TO: ALL HOLDERS OF AFT ENTRY/SERVICE DOOR HANDLE MECHANISM ASSEMBLY COMPONENT MAINTENANCE MANUAL 52-11-42

REVISION NO. 8 DATED NOV 01/04

HIGHLIGHTS

Pages which have been added or revised are outlined below together with the highlights of the revision. Remove and insert the affected pages as listed and enter Revision No. and date on the Record of Revision Sheet.

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
REPAIR-GEN	Added clarifications and updated callouts.
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BOEING

COMPONENT
MAINTENANCE MANUAL

AFT ENTRY/SERVICE DOOR
HANDLE MECHANISM ASSEMBLY

PART NUMBERS 146T6140-7,-8,-11,-12,-17,-18,-37, -38,-41,-42,-45,-46, -49 THRU -54,-57,-58

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

60580

REVISION RECORD

- Retain this record in front of manual. On receipt of revision, insert revised pages in the manual, and enter revision number, date inserted and initial.

REVISION NUMBER	REVISION DATE	DATE FILED	BY	REVISION NUMBER	REVISION DATE	DATE FILED	BY

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR B10014-1	OCT 10/82
		PRR B10370	OCT 10/82
		PRR B10500-11	OCT 10/82
		PRR B10558	OCT 10/82
		PRR B10642	OCT 10/82
		PRR B11462	OCT 10/86
		PRR B12121	OCT 01/91
		PRR B11910	OCT 01/91
52A0057			OCT 01/91
52-58			OCT 01/93
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1080C	JUL 01/03	01.1
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TABLE OF CONTENTS

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.

Verification:

Disassembly	Mar 4/83
Assembly	Mar 4/83

AFT 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, cam assembly, arming handle assembly and 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 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 when operated from the interior.

2. Operation

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

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

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

      (2) Rotate inside handle assembly upward to open the door. The external handle assembly will 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 lift 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)

A. Height -- 30 inches

B. Width -- 15 inches

C. Depth -- 8 inches

D. Weight -- 31 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. Lockwire

B. Cotter pin (471, IPL Fig. 1)

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

WARNING: RESTRAIN INSIDE HANDLE ASSEMBLY (139P OR 141) AND OUTSIDE HANDLE ASSEMBLY (945) TO PREVENT PERSONNEL INJURY FROM INADVERENT HANDLE TRAVEL.

A. Disconnect and remove handle assembly (139P or 141) and shaft assembly (175).

(1) Remove parts (6 thru 15) and separate lug assembly (30) from shaft assembly (176).

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

(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 (81), washer (84) and remove adapter assembly (75) from shaft assembly (175).

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

(5) Remove parts (102 thru 114) and separate lever assembly (99) and cap (129) from shaft assembly (175).

(6) For handle assemblies without clutch mechanism –

(a) Loosen nuts (138, 156). Back off screw (165) and remove adapter (162). Remove screw (165 or 176C), washer (168) and nut (171) from adapter (162). Remove parts (132, 135, 138, 150, 153, 156) and remove handle assembly (141) and spacer (159, 160).

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

(7) For handle assemblies with clutch mechanisms –

(a) Loosen nuts (139B, 156). Back off screw (176C) and remove bearings (161), spacer (161N), clutch assembly (138M) and adapter (176J). Remove screw (176C), washer (176E), and nut (176G) from adapter (176J). Remove parts (150, 153, 156) and remove handle assembly (139) and spacer (157).

(b) Disassemble handle assembly (139P) by removing pins (139T, 139U), spring (139V), washers (139W), and pawl assembly (140A).

NOTE: Do not disassemble handle assembly (139P) further unless repair or replacement is necessary.

(8) Remove shaft assembly (175), bearings (186), washers (177, 180) and spring (183) from support assembly (984).

NOTE: Do not disassemble shaft assembly (175) unless necessary for repair or replacement.

B. Remove lever assembly (201).

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

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

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

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

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

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

CAUTION: DELETED

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

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

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

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

H. Remove ring (369), bolt (372), washer (375) and remove handle assembly (378) and lever assembly (387A). Remove nut (390) and retainer (393) from lever (396A).

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

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

J. Remove parts (411 thru 417).

K. Remove bolt (432A), washer (435).

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

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

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

O. Remove parts (536N thru 558) and separate support assembly (531) from handle support assembly (984).

P. 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 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 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.

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

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

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

(5) Push cam assembly (645) inward to release handle assembly (945). Move handle assembly (945) 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 (723), cam assembly (645), crank (693), spacers (705 thru 711), washers (714), spring (717) and bearing (720) from support assembly (984).

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

Q. Remove parts (732 thru 765) and stop assembly (726).

R. Remove shaft assembly (924) and handle assembly (945).

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

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

(3) With handle assembly (945) 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 (924) and separate handle assembly from support assembly (984).

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

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

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

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

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

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

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

W. Separate levers (834, 837) and remove rod end assembly (870). Keep levers (834, 837) together as a matched set.

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

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

NOTE: Do not remove nutplates or bushings from support 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 (93 or 96, 162, 148, 176J)

      (3) Levers (126, 318, 396A, 429, 633, 834 or 837)

      (4) Cap (129)

      (5) Clutch (139F)

      (6) Fitting (139H)

      (7) Pin (139U)

      (8) Pawl (140H)

      (9) Spacer (157, 158, 159, 160, 906)

      (10) Spring (342, 861)

      (11) Handle (384)

      (12) Sector (453A)

      (13) Shafts (456, 723, 858, 936 or 939)

(14) Bracket (469)

(15) Cam (660 or 663)

(16) Crank (693)

(17) Stop (762 or 765)

(18) Bushing (777)

(19) Rollers (786, 822)

(20) Support (801)

(21) Lever (834, 837)

(22) Pin (849)

(23) Rod end (876)

(24) Spring (961)

B. IPL Fig. 2

(1) Housing (45)

(2) Shaft (50)

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

A. IPL Fig. 1

(1) Handle (140V, 140W, 147)

(2) Levers (219 or 222)

(3) Links (255, 297)

(4) Housings (140Q, 339, 612)

(5) Piston (366)

(6) Support (555 or 558)

(7) Guide (582)

(8) Base (960A)

(9) Pawl (962)

B. IPL Fig. 3

(1) Lever (30)

C. IPL Fig. 4

(1) Cap (50)

(2) Handle (55 or 60)

D. IPL Fig. 5

(1) Plate (65)

(2) Bracket (70)

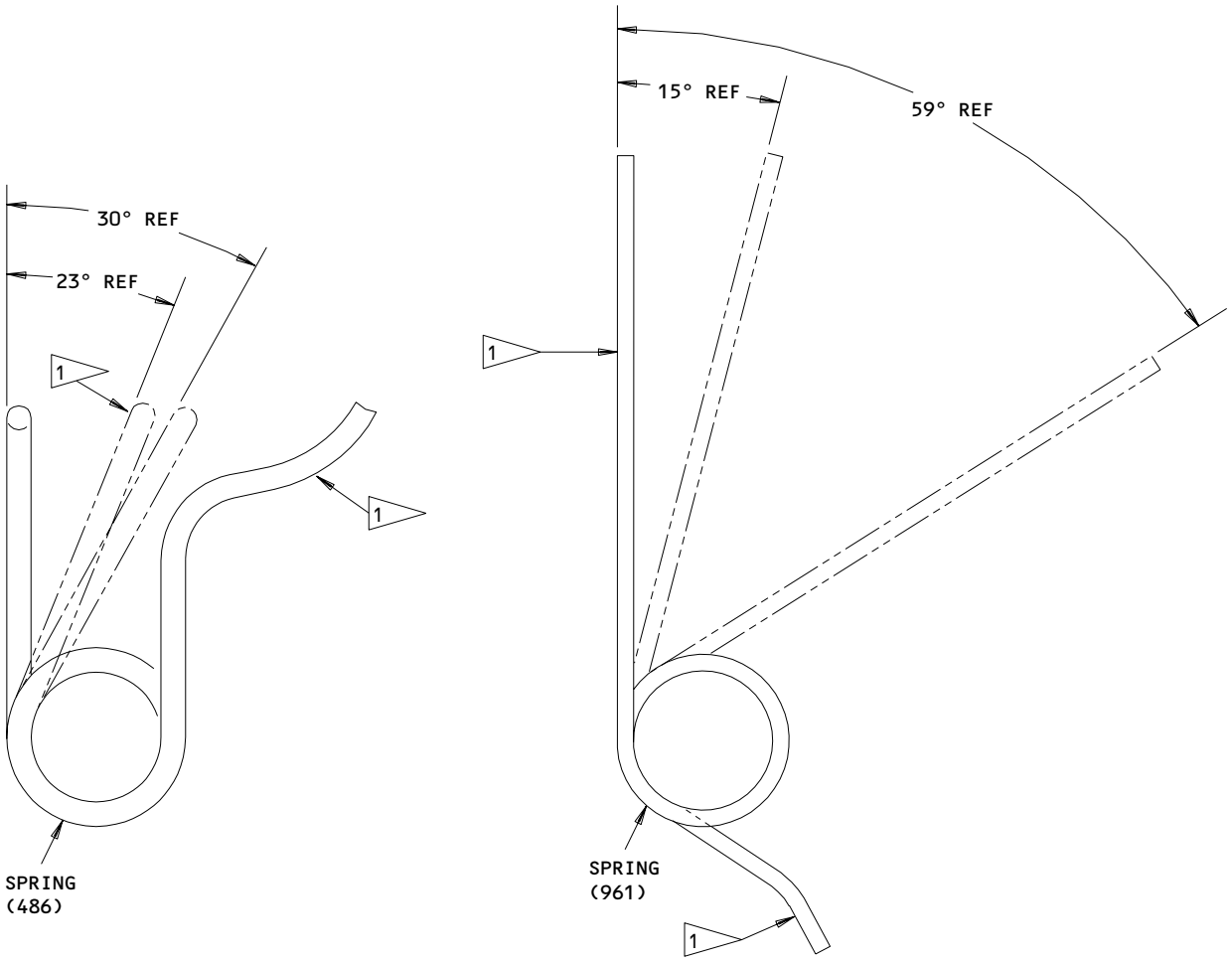
(3) Support (130 or 135)

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.



1 POINT AND DIRECTION OF LOAD APPLICATION

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

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
141T6194	LEVER, GIRT DRIVE	6-1
141T6195	CAM	7-1
141T6196	LUG	8-1
141T6197	LUG	8-1
141T6200	HANDLE, CAM	9-1
141T6202	ADAPTER	10-1
141T6205	LEVER, SPRING OVERCENTER	11-1
141T6207	LEVER, CARRIER DRIVE	12-1
141T6221	SHAFT, PIVOT	13-1
141T6226	BUSHING, ADJUSTABLE	14-1
141T6227	LEVER	15-1
141T6228	SHAFT, PIVOT	16-1
141T6249	HANDLE	17-1
141T6271	LEVER, ARMING FLAG	18-1

P/N	NAME	REPAIR
141T6274	GUIDE, SPRING	19-1
141T6277	LINK	20-1
141T6287-3, -4	ROLLER	21-1
141T6287-5	ROD END	22-1
141T6651	LEVER, LOCKOUT	23-1
141T6652	SECTOR, LOCKOUT	24-1
69B13060	PISTON	25-1
69B13067	HOUSING	26-1
---	MISCELLANEOUS PARTS REFINISH	27-1
141T6538	BUTTON	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.

20-00-00 Introduction
20-30-02 Stripping of Protective Finishes
20-30-03 General Cleaning Procedures
20-41-01 Decoding Table for Boeing Finish Codes
20-41-02 Application of Chemical and Solvent Resistant Finishes
20-42-01 Low Hydrogen Embrittlement Cadmium Plating
20-42-03 Hard Chrome Plating
20-44-01 Application of Abrasion Resistant Finishes
20-43-01 Chromic Acid Anodizing
20-43-03 Chemical Conversion Coatings for Aluminum
20-50-03 Bearing and Bushing Replacement
20-50-05 Application of Aluminum Foil and Other Markers
20-50-06 Installation of O-Rings and Teflon Seals
20-50-08 Application of Bonded Solid Film Lubricant
20-50-19 General Sealing
20-60-02 Finishing Materials
20-60-03 Lubricants
20-60-04 Miscellaneous Materials

3. Materials

NOTE: Equivalent substitutes can be used.

A. Primer (SOPM 20-60-02)

(1) BMS 10-11, Type 1

(2) BMS 10-79, Type 2

B. Coating, abrasion-resistant teflon -- BMS 10-86, Type 1 (SOPM 20-44-01, Type 27)

C. Coating, clear -- BAC 5755, Type 11 (Replaces BMS 10-70) (SOPM 20-60-02)

D. Enamel (SOPM 20-60-02)

(1) BMS 10-60, Type 2

(2) BMS 10-83, Type 2

E. Grease (SOPM 20-60-03)

(1) BMS 3-24

(2) BMS 3-33

(3) MIL-G-23827

F. Lubricant -- Vitrolube NPI-1220 (SOPM 20-60-03)

G. Potting Compound (SOPM 20-60-04)

(1) BMS 5-28, Type 18, 19, or 20 (Replaces Type 5)

(2) BMS 5-28, Type 6

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

4. Dimensioning Symbols

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

HANDLE SUPPORT ASSY - REPAIR 1-1

141T6133-51, -52, -55, -56, -61, -62, -81 thru -84

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.

1. Bushing 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 (35) Replacement

   A. Remove bolts (40), collars (45) and bracket assembly (35).

   B. Install bracket assembly (35) with sealant and secure with bolts (40) and collars (45).

3. Nutplates (15, 20, 30) Replacement

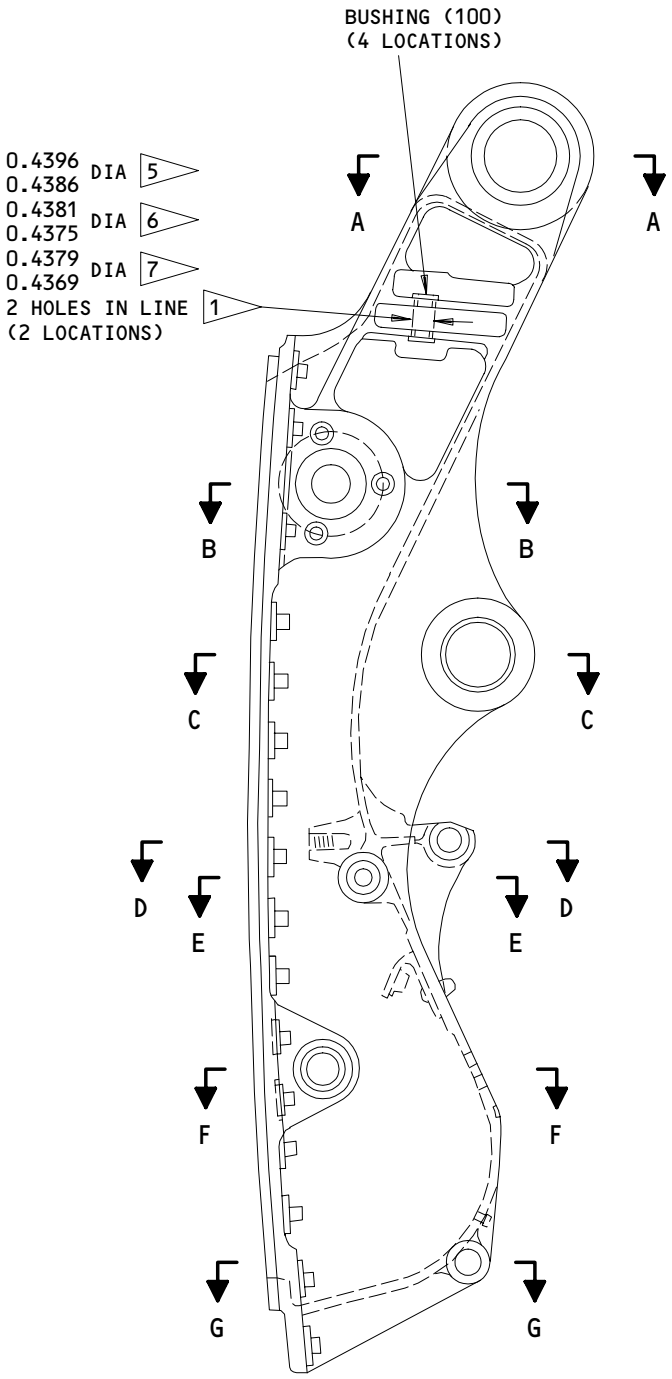
   A. Remove rivets (10) and damaged nutplates.

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

4. Seals (115, 120, 125) 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.

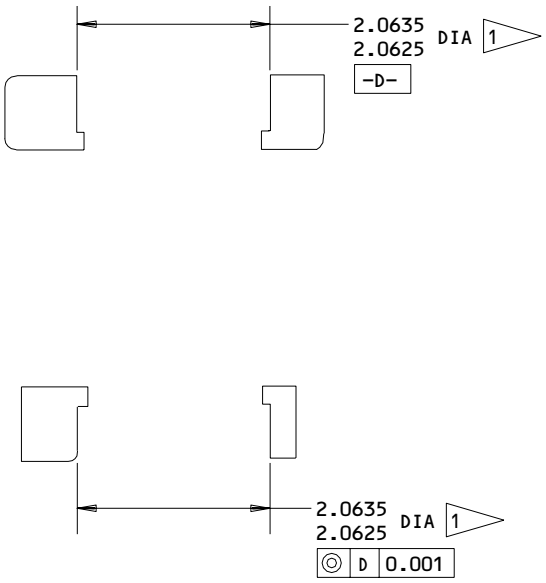


141T6133-51,-52,-55,-56,-61,-62,-81 THRU -84

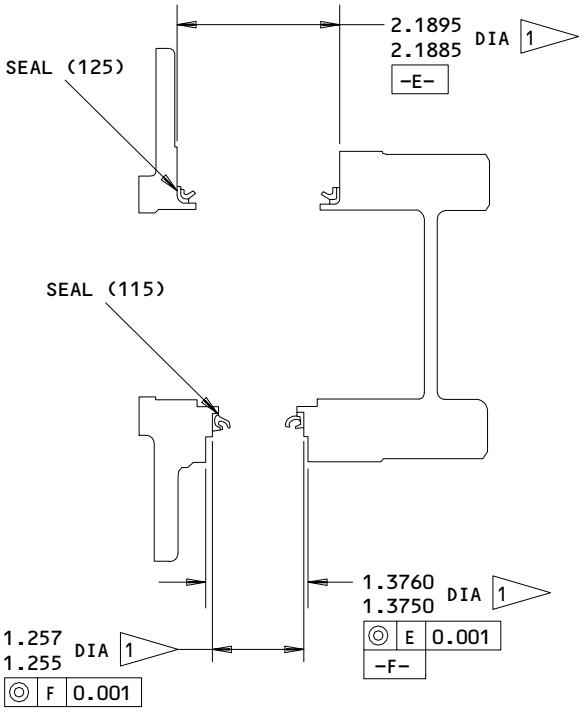
ALL DIMENSIONS ARE IN INCHES

Support Repair and Refinish
Figure 601 (Sheet 1)

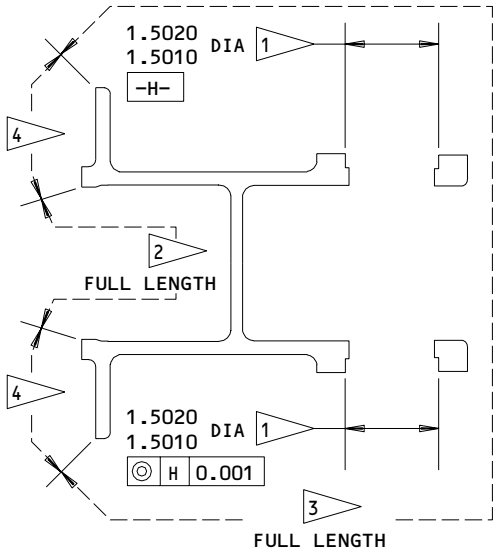
60478



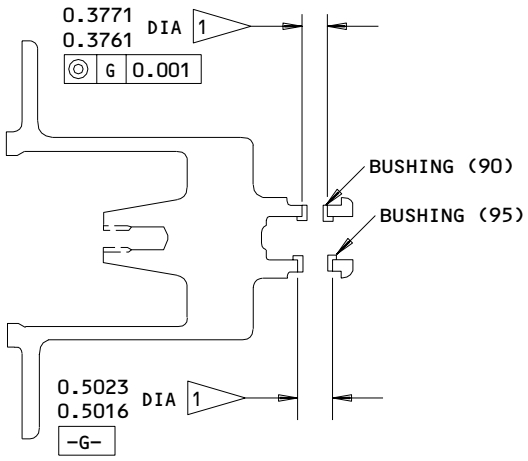
A-A



B-B



C-C



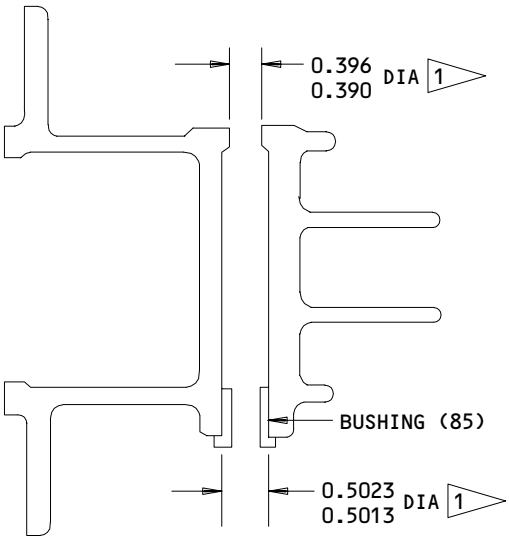
D-D

ITEM NUMBERS REFER TO IPL FIG. 5

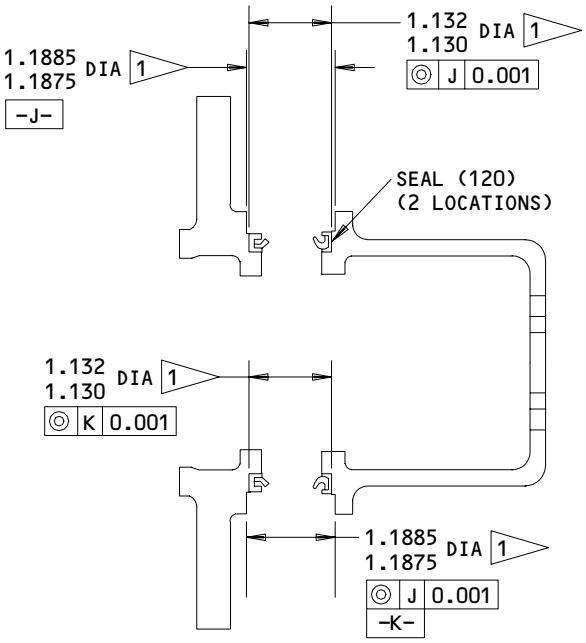
ALL DIMENSIONS ARE IN INCHES

141T6133-51,-52,-55,-58,-61,-62,-81 THRU -84

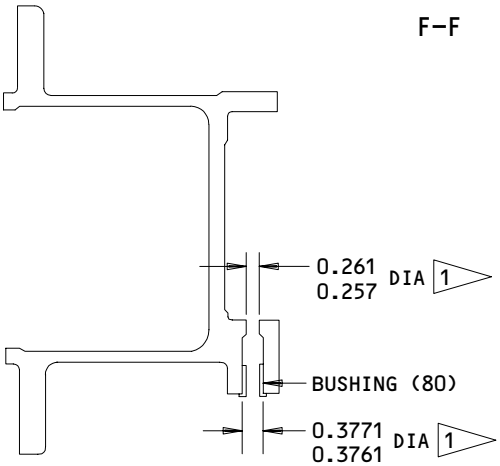
Support Repair and Refinish
Figure 601 (Sheet 2)



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-1939-702)

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 141T6133-51,-52,-55,-56

6 141T6133-81,-82

7 141T6133-61,-62,-83,-84

141T6133-51,-52,-55,-56,-61,-62,-81 THRU -84

Support Repair and Refinish
Figure 601 (Sheet 3)

EXTERNAL HANDLE ASSEMBLY - REPAIR 2-1

141T6159-13, -14

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 maximum from bearing bore in handle (Ref Fig. 601).

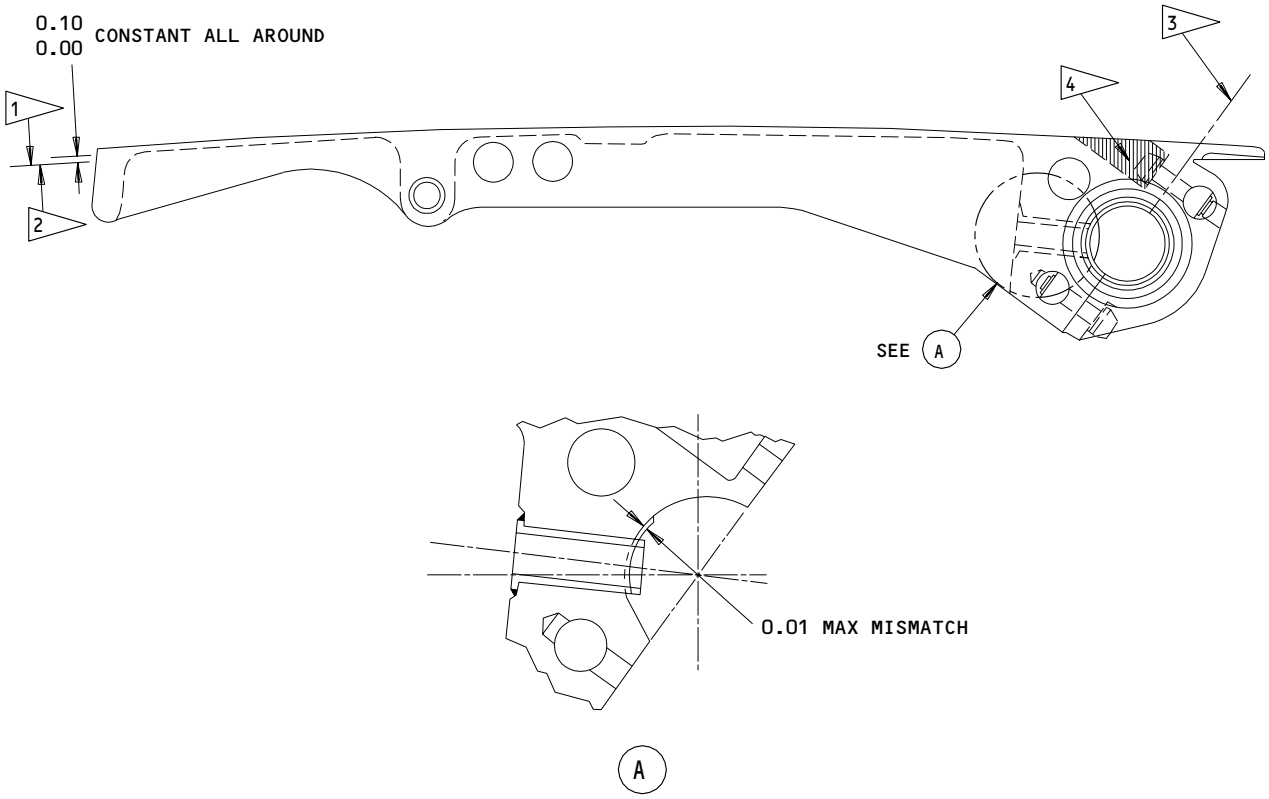
   D. Fillet seal bushings with sealant.

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 (55) when removing potting compound.

   B. 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.

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



REFINISH

CAP (50) AND HANDLE (55) -- 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.

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

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

2 APPLY 1 COAT OF GLOSS ENAMEL, BMS 10-60, TYPE 2 COLOR WHITE (BAC702)(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 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 SURFACE. CHEMICAL TREAT (F-17.10) AS REQUIRED.

141T6159-13,-14

Parts Replacement and Handle Refinish
Figure 601

HANDLE ASSEMBLY, INSIDE LATCH - REPAIR 3-1

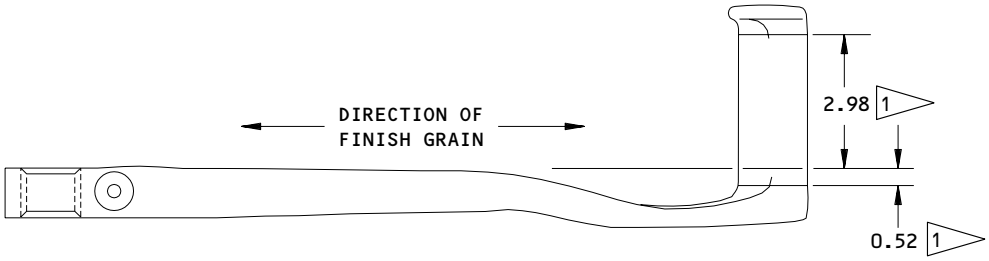
141T6160-1, -5, -6

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers. For repair of surfaces which is only replacement of the original finish, refer to Refinish instructions, Fig. 601 or 602.

1. Filler (144) Replacement

   A. Remove the old potting compound and filler (144) from the handle (147).

   B. Install a replacement filler with potting compound, BMS 5-28, Type 18, 19, or 20 (for 141T6160-1) or BMS 5-28, Type 6 (for 141T6160-5, -6). Fill the cavity with potting compound and trim it flush to 0.10 inch below the handle surface.



REFINISH

APPLY SATIN FINISH WITH GRAIN AS SHOWN AND TYPE 11 CLEAR COATING (F-14.231) ON OUTSIDE SURFACES BUT NOT IN HOLES OR AREA SHOWN BY 1 CHROMIC ACID ANODIZE (F-17.04) IN HOLES, SLOT AND ON SPLINES.

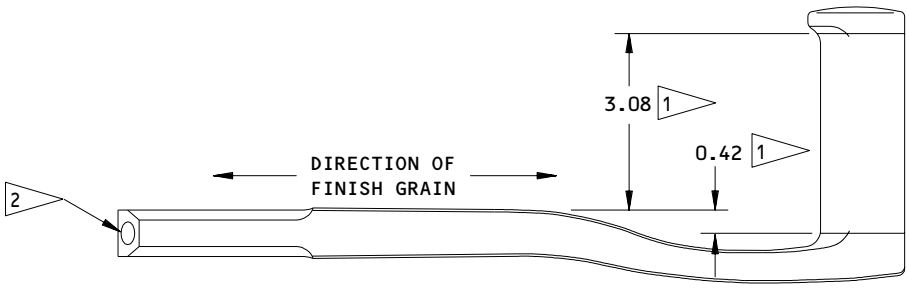
1 CHEMICAL TREAT AND APPLY BMS 10-11 TYPE 1 PRIMER (F-18.01). APPLY RED ENAMEL BMS 10-83, TYPE 2 (F-22.06-101) AROUND HANDLE GRIP

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

141T6160-2,-11
Handle Refinish
Figure 601

471228



REFINISH

APPLY SATIN FINISH WITH GRAIN AS SHOWN AND TYPE 11 CLEAR COATING (F-14.231) ON OUTSIDE SURFACES BUT NOT IN HOLES OR AS SHOWN BY 1 2.

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

1 CHEMICAL TREAT AND APPLY BMS 10-11 TYPE 1 PRIMER (F-18.01). APPLY BMS 10-83 TYPE 2 RED ENAMEL (F-22.06-101) AROUND HANDLE GRIP

2 CHEMICAL TREAT (F-17.10) THIS HOLE

141T6160-7 THRU -10
Handle Refinish
Figure 602

471276

STOP ASSEMBLY - REPAIR 4-1

141T6188-3 thru -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 (759) Replacement

   A. Remove bearing (759) and ring (756).

   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 (762 or 765) -- 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.

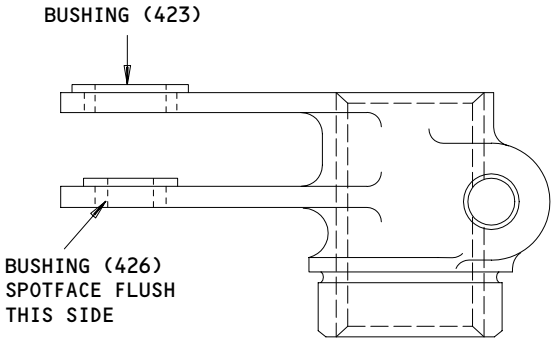
Item numbers refer to IPL Fig. 1.

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-17.09)

MATERIAL: 17-4PH CRES, 150 KSI MIN

Bushing Replacement and Lever Refinish
Figure 601

60481

GIRT DRIVE LEVER ASSEMBLY - REPAIR 6-1

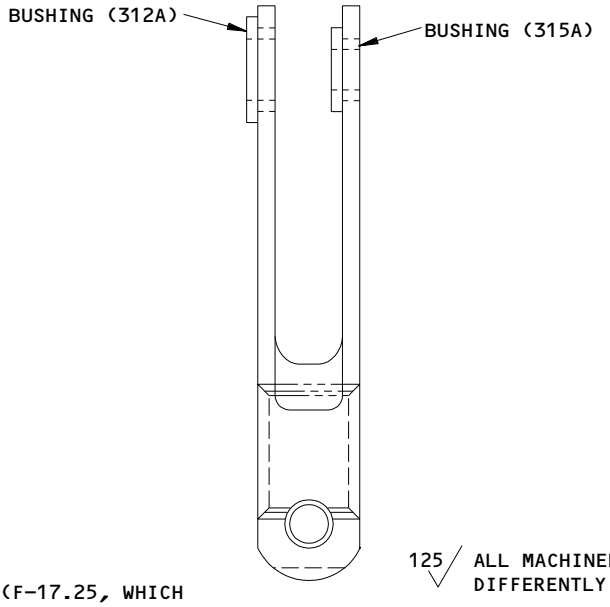
141T6194-1

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers. For repair of surfaces, which is only replacement of the original finish, refer to Refinish instructions, Fig. 601.

1. Bushings (312, 315A) Replacement

   A. Remove the old bushings.

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



REFINISH

LEVER (318) -- PASSIVATE (F-17.25, WHICH REPLACES F-17.09)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: 17-4PH CRES, 150 KSI MIN

ITEM NUMBERS REFER TO IPL FIG. 1

141T6194-1
Bushing Replacement and Lever Refinish
Figure 601

60482

CAM ASSEMBLY - REPAIR 7-1

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.

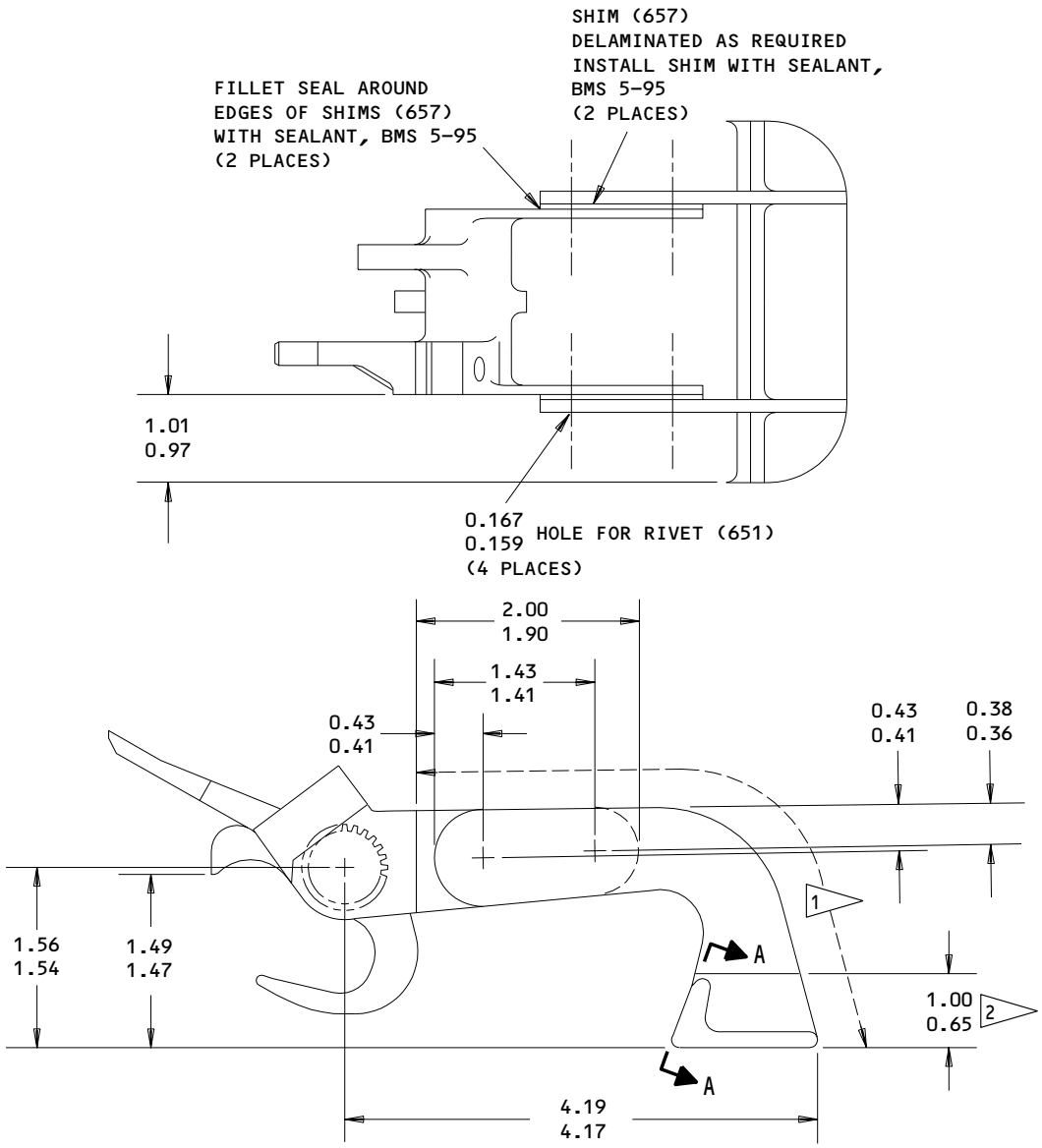
   C. Assemble parts (654 thru 660) and secure with rivet (651). Install shims (657) with wet sealant, BMS 5-95 on faying surfaces. Install rivets (651) with wet sealant, BMS 5-95 and squeeze drive. Fillet seal edges of shims (657) with sealant, BMS 5-95.

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

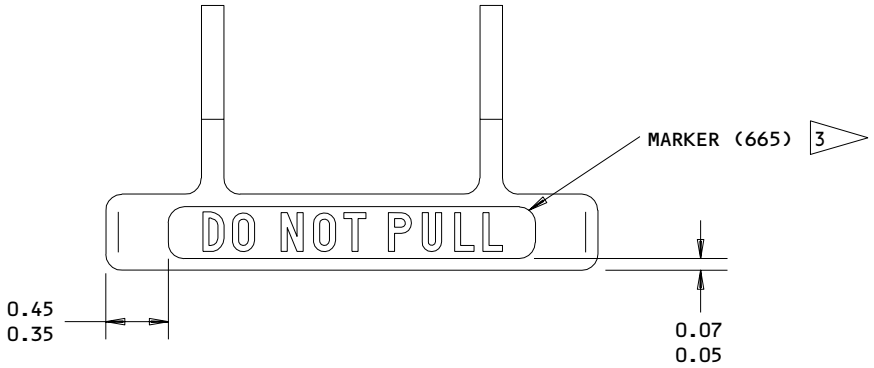
1 APPLY 1 COAT BMS 10-79, TYPE 2 PRIMER AND BMS 10-60 TYPE 2 GLOSS ENAMEL, COLOR WHITE (BAC702)(F-19.41-702) AREA INDICATED

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

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

141T6195-1,-2

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

232757

LUG ASSEMBLY - REPAIR 8-1

141T6196-3, -5
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 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

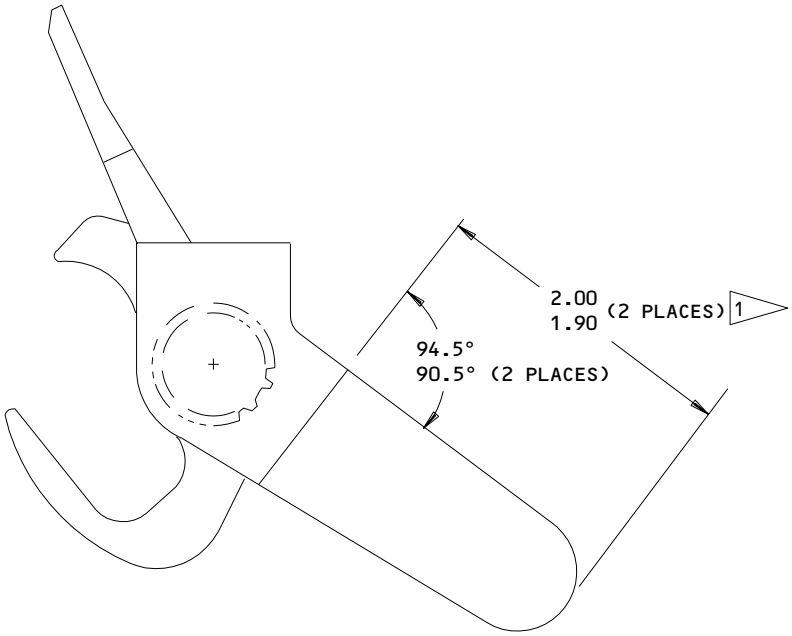
   A. Lug (39, 72) -- Passivate (F-17.09) all over. Material: 15-5PH CRES, 180-200 ksi.

CAM - REPAIR 9-1

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

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

ALL DIMENSIONS ARE IN INCHES

Cam Refinish
Figure 601

60483

ADAPTER ASSEMBLY - REPAIR 10-1

141T6202-1, -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.

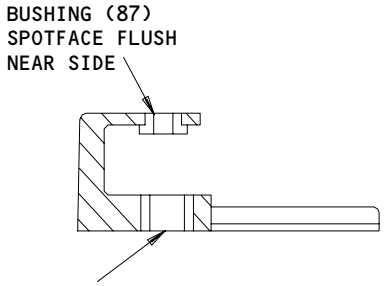
Item numbers refer to IPL Fig. 1.

1. Bushing Replacement (Fig. 1)

   A. Remove bushings.

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

   C. Spot face bushings as indicated.



REFINISH

PASSIVATE (F-17.09)

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

Bushing Replacement and Adapter Refinish
Figure 601

60484

LEVER ASSEMBLY - REPAIR 11-1

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.

Item numbers refer to IPL Fig. 1.

1. Bushing Replacement

   A. Remove bushings.

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

2. Refinish

   A. Lever (633) -- Passivate (F-17.09) all over. Material: 17-4PH CRES, 150 ksi min. (opt 15-5PH CRES 150-170 ksi).

CARRIER DRIVE LEVER ASSEMBLY - REPAIR 12-1

141T6207-6

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

Item numbers refer to IPL Fig. 3.

1. Bearing Replacement

   A. Remove bearings (15).

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

2. Bushing Replacement

   A. Remove bushings (5, 10).

   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.

PIVOT SHAFT ASSEMBLY - REPAIR 13-1

141T6221-1, -3

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 Replacement (Fig. 601)

   A. Remove bushings.

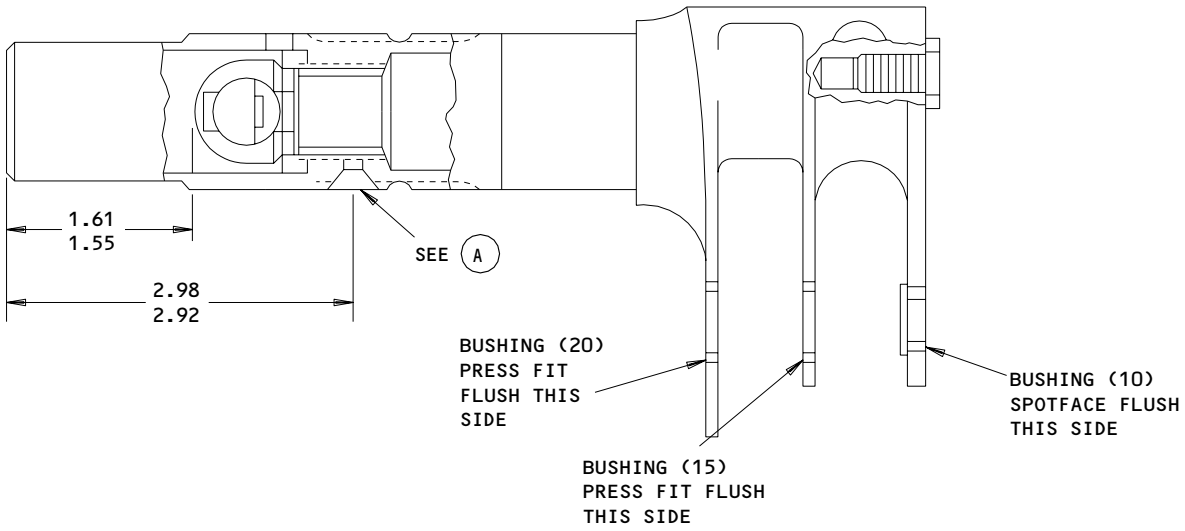
   B. Install replacement bushing per 20-50-03 and spot face as indicated.

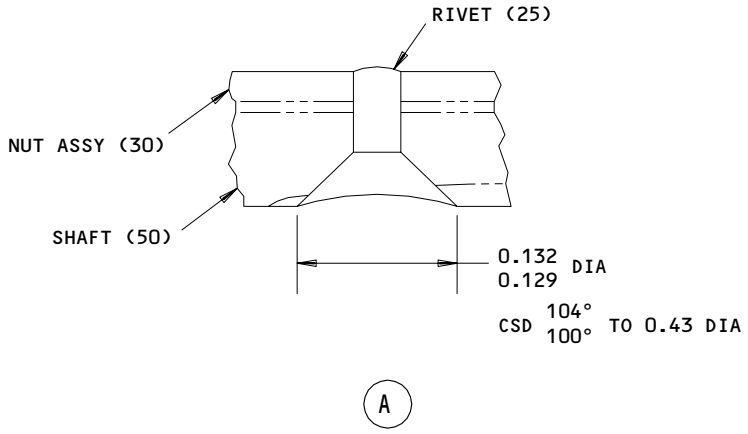
2. Nut Assembly (30) Replacement (Fig. 601)

   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 dia. thru 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

ALL DIMENSIONS ARE IN INCHES

141T6221-1,-3

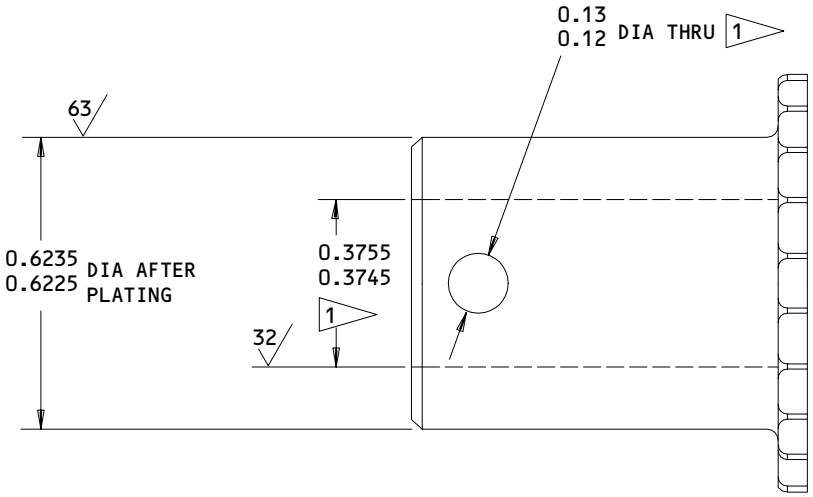
Parts Replacement and Shaft Refinish
Figure 601

ADJUSTABLE BUSHING - REPAIR 14-1

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

ALL DIMENSIONS ARE IN INCHES

Bushing Refinish
Figure 601

60536

LEVER ASSEMBLY - REPAIR 15-1

141T6227-1

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers. For repair of surfaces, which is only replacement of the original finish, refer to Refinish instructions, Fig. 601.

1. Bushing Replacement (Fig. 601)

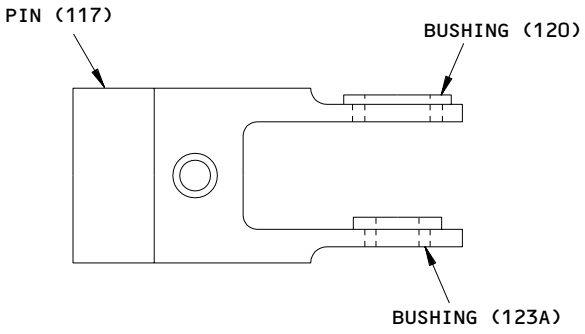
   A. Remove the old bushings.

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

2. Pin Replacement (Fig. 601)

   A. Remove the old pin (117).

   B. Install a replacement pin with wet BMS 5-95 sealant.



REFINISH

LEVER (126) -- PASSIVATE (F-17.25, WHICH REPLACES F-17.09)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

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

ITEM NUMBERS REFER TO IPL FIG. 1

141T6227-1
Parts Replacement and Lever Refinish
Figure 601

60537

PIVOT SHAFT ASSEMBLY - REPAIR 16-1

141T6228-1, -2, -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. Bushing Replacement

   A. Remove bushings (930, 933).

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

2. Refinish

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

HANDLE ASSEMBLY - REPAIR 17-1

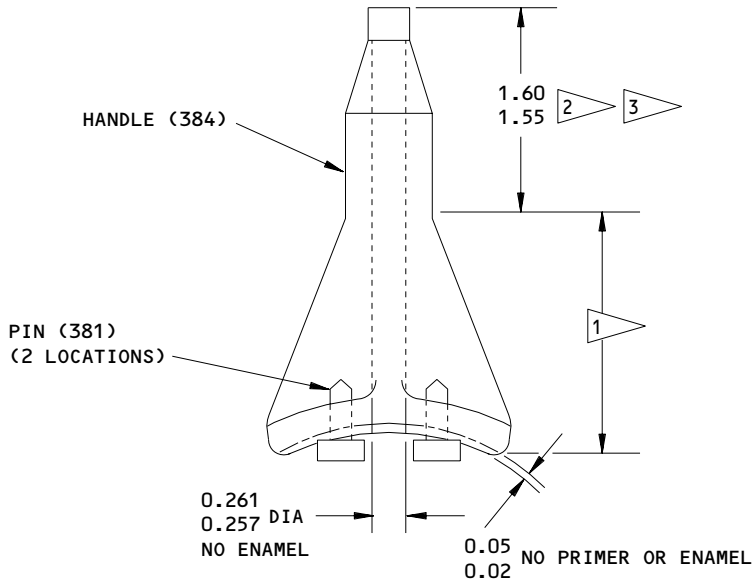
141T6249-1, -6

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers. For repair, which is only replacement of the original finish, refer to Refinish instructions, Fig. 601.

1. Pin Replacement

A. Remove the old pins (381).

B. Install replacement pins with BMS 5-95 sealant (SOPM 20-50-19).



REFINISH

PINS (381) -- NO FINISH
HANDLE (384) -- PASSIVATE (F-17.25, WHICH REPLACES F-17.09).
HANDLE ASSEMBLY (378) -- APPLY PROTECTIVE COATING IN AREA INDICATED BY 1. APPLY BMS 10-83, TYPE 2 ENAMEL IN AREA INDICATED BY 2 AND 3.

1 APPLY TYPE 31 COATING (F-21.04)

2 141T6249-1: APPLY BMS 10-83 TYPE 2 GREEN ENAMEL (F-22.06-4533)

3 141T6249-6: APPLY BMS 10-83 TYPE 2 YELLOW ENAMEL (F-22.06-302)

MATERIAL: HANDLE (384):
17-4PH CRES, 180-200 KSI
PINS (381):
15-5PH CRES, 180-200 KSI

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

142T6249-1,-6
Handle Repair and Refinish
Figure 601

60650

LEVER ASSEMBLY - REPAIR 18-1

141T6271-1, -2, -11, -12, -17, -18, -25, -26, -31 thru -34

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.

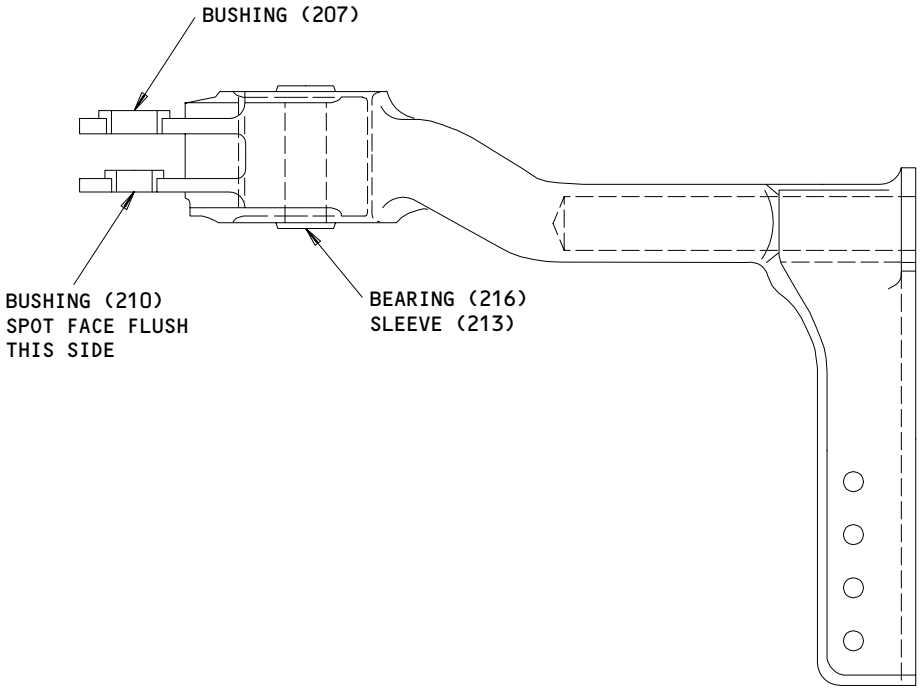
   C. Spot face bushing (210) as indicated.

   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 maximum gap in sleeve after roller swage is 0.062 inch maximum.



REFINISH

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

MATERIAL: AL ALLOY

141T6271-1,-2,-11,-12,-17,-18,-25,-26,-31 THRU -34
Bushing Replacement Lever Refinish
Figure 601

60651

SPRING GUIDE - REPAIR 19-1

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, Fig. 601.

Item numbers refer to IPL Fig. 1.

1. Bearing Replacement

A. Remove bearing and sleeve.

B. Install replacement bearing and sleeve and roller swage per 20-50-03 except use wet sealant, BMS 5-95. Maximum permissible gap in sleeve shall be 0.062 inch. 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 20-1

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 Replacement

   A. Remove bearing and sleeve.

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

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 21-1

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 Replacement

A. Remove bushings.

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

2. Refinish

A. Roller (786) -- Chrome plate (F-15.03) on O.D. and ends. Passivate (F-17.09) on I.D. O.D. 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 O.D. and ends. Passivate (F-17.09) on I.D. O.D. 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 22-1

141T6287-5

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers. For repair of surfaces, which is only replacement of the original finish, refer to Refinish instructions, Fig. 601.

1. Bushing Replacement

   A. Remove the old bushings (873).

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

2. Refinish

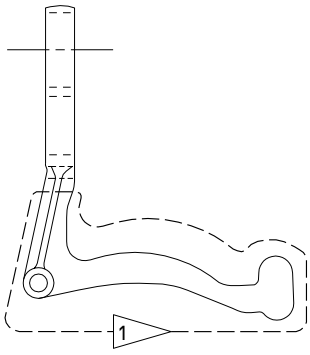
   A. Rod end (876) -- Passivate (F-17.09) all over. Material: 15-5PH CRES, 180-200 ksi.

LOCKOUT LEVER - REPAIR 23-1

141T6651-1

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

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 AREA INDICATED BY 1 EXCEPT NO VITROLUBE PERMITTED IN 0.250 INCH HOLE

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

Lever Refinish
Figure 601

60652

LOCKOUT SECTOR ASSEMBLY - REPAIR 24-1

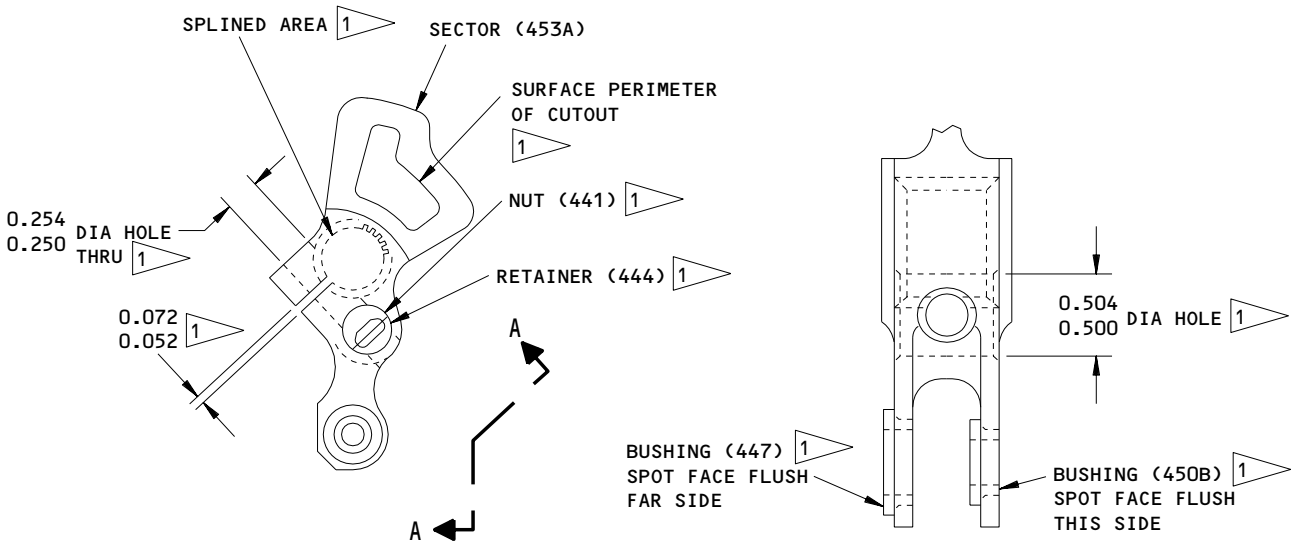
141T6652-1, -10

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers. For repair of surfaces which is only replacement of the original finish, refer to Refinish instructions, Fig. 601.

1. Bushing Replacement (Fig. 601)

A. Remove the old bushings (447, 450B).

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



141T6652-1 SHOWN

A-A

REFINISH

SECTOR (453A) -- PASSIVATE (F-17.25, WHICH REPLACES F-17.09)
ON 141T6652-1 ASSEMBLY ONLY, APPLY BMS 10-60, YELLOW GLOSS ENAMEL (F-14.9815, WHICH REPLACES SRF-14.9815-302) ALL OVER BUT NO ENAMEL ON AREAS SHOWN BY 1.
DO NOT APPLY ENAMEL ON 141T6652-10 ASSEMBLY.

1 NO ENAMEL IN THIS AREA

REPAIR

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

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

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

141T6652-1,-10
Bushing Replacement and Sector Refinish
Figure 601

60598

PISTON ASSEMBLY - REPAIR 25-1

69B13060-7

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices.
Refer to IPL Fig. 1 for item numbers.

1. Bearing Replacement

A. Remove the old bearing (363).

B. Install a replacement bearing and ball stake the housing (SOPM 20-50-03) at 4 locations equally spaced.

HOUSING ASSEMBLY - REPAIR 26-1

69B13067-7

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers. For repair of surfaces which is only replacement of the original finish, refer to Refinish instructions, par. 2.

1. Bushing Replacement

   A. Remove the old bushings (336).

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

2. Refinish

   A. Housing (339) -- Apply BMS 3-8 solid film lubricant (F-19.10) all over. Material: AISI 303 CRES, Condition A.

MISCELLANEOUS PARTS REFINISH - REPAIR 27-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Cap (129), clutch (138F), fitting (138H), pawl (140H), adapter (162,176J), lever (396A,834 or 837), shafts (456,723, 858), pin (849), spacer (906)	15-5PH CRES, 180-200 ksi	Passivate (F-17.25, which replaces F-17.09).
Spring (342,861, 961)	17-7PH CRES	Passivate (F-17.25, which replaces F-17.09).
Spacer (157,158, 159,160), adapter (408), crank (693)	17-4PH CRES, 150 ksi minimum (optional 15-5PH CRES, 150-170 ksi)	Passivate (F-17.25, which replaces F-17.09).
Support (555 or 558)	Al alloy	Anodize (F-17.05) and apply BMS 10-11, Type 1 primer (F-20.02) all over.
Support (801)	17-4PH CRES, 180 ksi minimum (Optional 15-5PH CRES, 180-200 ksi)	Passivate (F-17.25, which replaces F-17.09).
Clip (831U, 833)	302 or 304 annealed CRES sheet	Passivate (F-17.25, which replaces F-17.09).

Refinish Details
Figure 601 (Sheet 1)

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1 (Cont)		
Base (960A), pawl (962)	Al alloy	Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13) all over. Apply BMS 10-86, Type 1 or 2 white Teflon coating (F-14.9624, which replaces SRF-14.9624), 0.01 inch maximum thickness. No Teflon coating in holes.
Fig. 2		
Housing (45)	15-5PH CRES, 180-200 ksi	Passivate (F-17.25, which replaces F-17.09).
Fig. 5		
Plate (65), bracket (70, 70A)	Al alloy	Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13) all over.

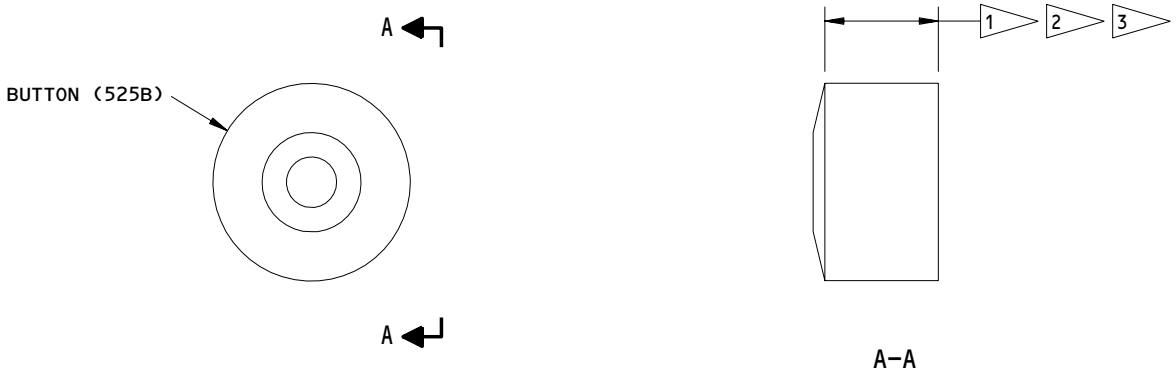
Refinish Details
Figure 601 (Sheet 2)

BUTTON - REPAIR 28-1

141T6538-7, -8, -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 (525B) -- APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER (F-20.02) PLUS APPLY BMS 10-83, TYPE 2 ENAMEL (F-22.06-XXX) TO CIRCUMFERENTIAL SURFACE NOTED

1 APPLY PRIMER AND ENAMEL TO THIS SURFACE ONLY

2 141T6538-7,-8 : APPLY BAC4533 GREEN ENAMEL

3 141T6538-10 : APPLY BAC302 YELLOW ENAMEL

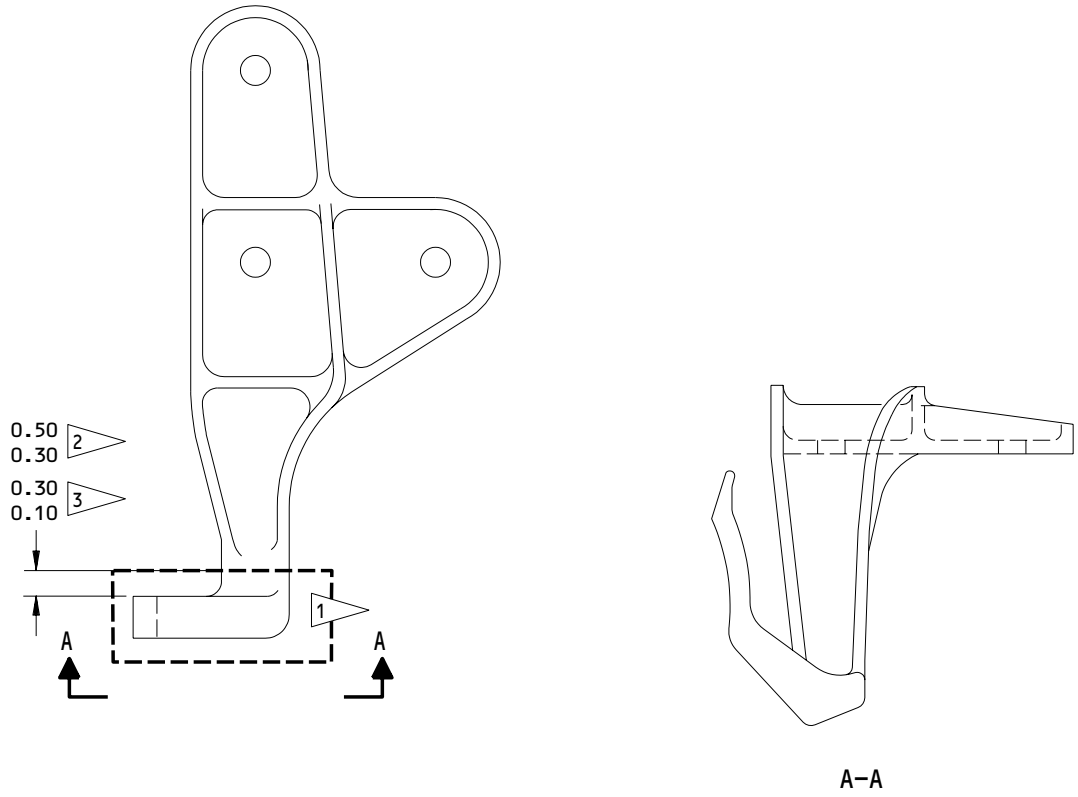
141T6538-7,-8,-10
Button Refinish
Figure 601

CAM BRACKET - REPAIR 29-1

143T6156-7, -8, -11 thru -14, -17, -18

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

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

1 NO PRIMER IN THIS AREA

2 143T6156-7,-8,-11,-12 ONLY

3 143T6156-13,-14,-17,-18 ONLY

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

ALL DIMENSIONS ARE IN INCHES

Cam Bracket Assembly Refinish
Figure 601

969119

ASSEMBLY

1. Materials

NOTE: Equivalent substitutes can be used.

A. Grease (SOPM 20-60-03)

(1) BMS 3-24

(2) BMS 3-33

(3) MIL-G-23827

B. Lockwire -- MS20995NC32 (SOPM 20-60-04)

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

2. Assembly

NOTE: Unless shown differently, tighten fasteners to standard torque (SOPM 20-50-01).

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

(1) Assemble adapter assembly (75) to shaft assembly (175).

(a) Apply a thin layer of grease to faying surfaces of adapter assembly (75) and shaft assembly (175). Wipe surfaces with dry cloth to remove grease. Do not use a solvent.

(b) Assemble adapter assembly (75) to shaft assembly (175) with wet BMS 5-95 sealant.

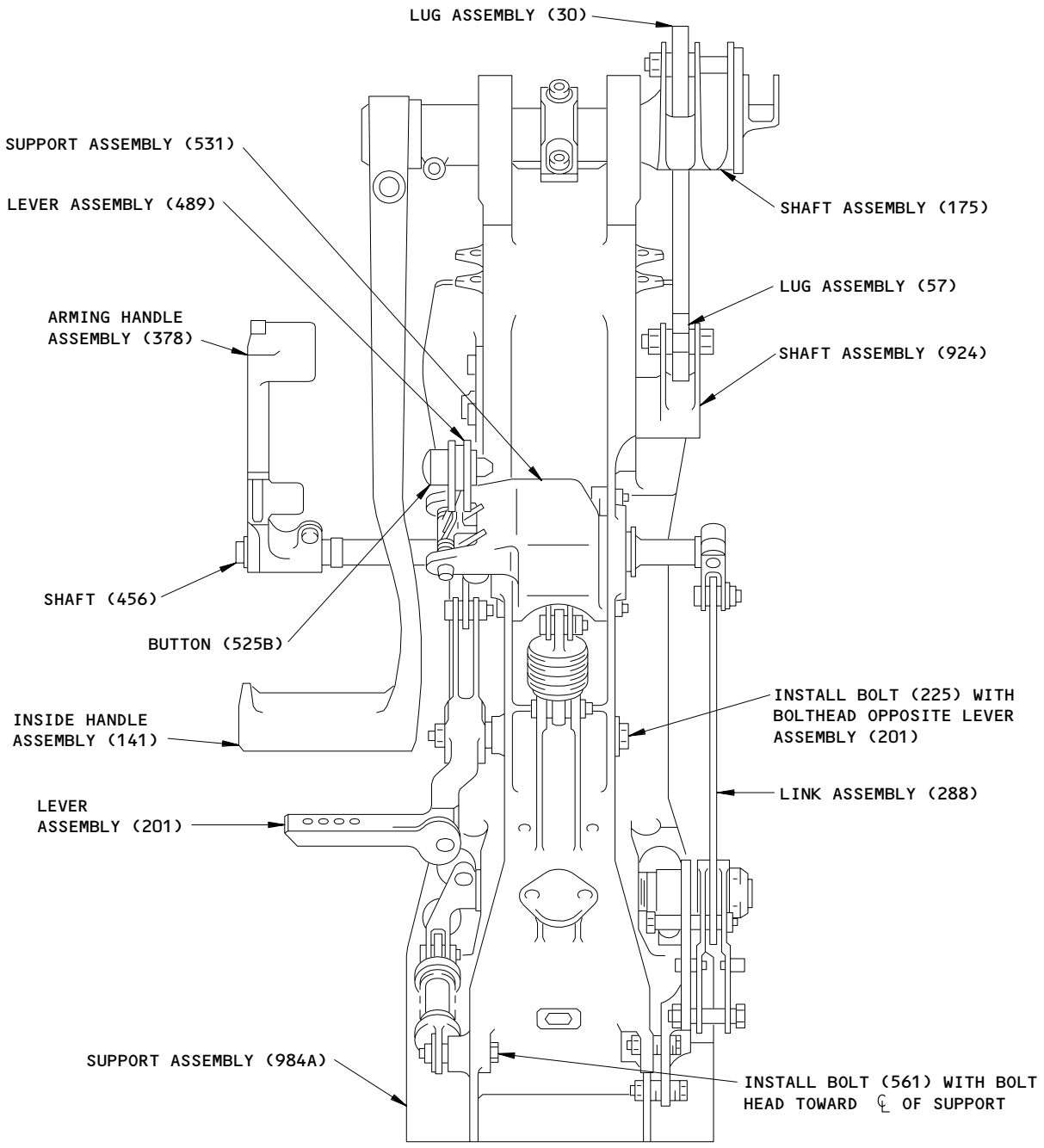
(2) Assemble handle assembly (378), lever assembly (387A) and adapter (408).

(a) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to faying surfaces of lever assembly (387A) and to serrated area of handle assembly (378) and adapter (408).

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

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

(a) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease, to serrated surfaces of lug assemblies (30, 57).



146T6140-11,-17,-41,-51 ASSEMBLIES SHOWN
146T6140-8,-38,-46,-50,-54,-58 ASSEMBLIES SIMILAR
146T6140-7,-12,-18,-37,-42,-45,-49,-52,-53,-57 ASSEMBLIES OPPOSITE
(VIEW IN THE OUTBOARD DIRECTION)

ITEM NUMBERS REFER TO IPL FIG. 1

Handle Mechanism Assembly
Figure 701

(b) Assemble lug assemblies (30, 57) and attach with bolts (42, 48) and washers (45, 51, 54). Tighten the fasteners only to hold the lug assemblies.

(4) Assemble roller assembly (816), levers (834, 837), clip (833) and rod end assembly (870).

WARNING: MAKE SURE LEVERS (834, 837) ARE INSTALLED AS SHOWN IN FIG. 705. BACKWARDS INSTALLATION OF LEVERS (834, 837) WILL NOT OPEN THE DOOR DURING EMERGENCY EXIT.

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

(a) Assemble levers (834, 837) and rod end assembly (870) and install bushing (813) inside roller assembly (816). Install clip (833), as necessary, around middle shaft between levers (834, 837).

(b) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to threads and shank of bolt (804). Put roller assembly (816) between levers (834, 837) and install bolt (804), washer (807) and nut (810). Be sure to put the head of bolt (804) in the correct direction for the left hand or right hand handle assembly (945).

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

(6) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to threads and shank of bolt (696) and install bolt (696), washers (699) and nut (702) on adapter (693). Install 13 washers under bolt and 1 washer under nut. Tighten the nut finger tight.

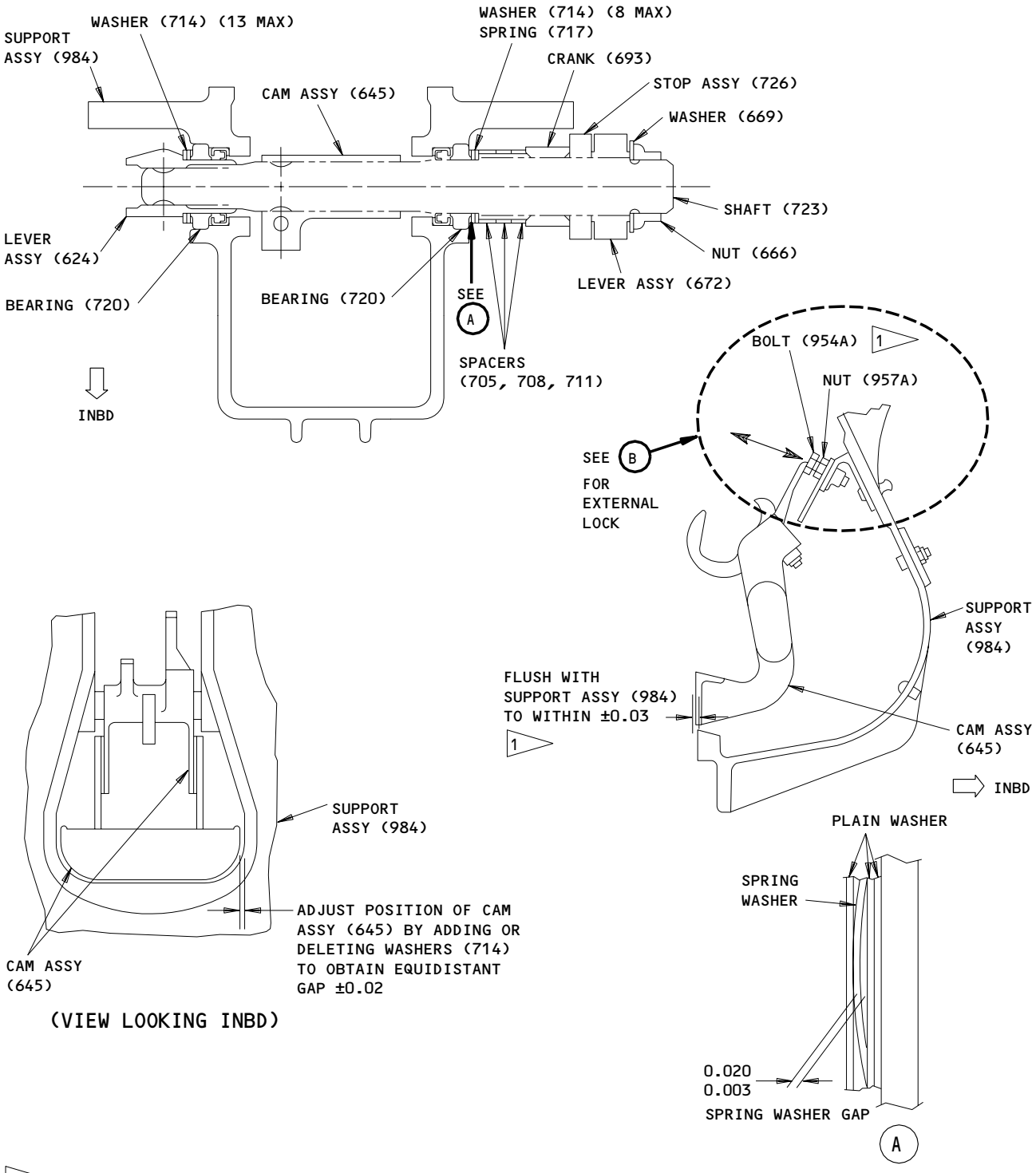
(7) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to O.D. of bearings (186, 468, 720) and install in support assembly (984).

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

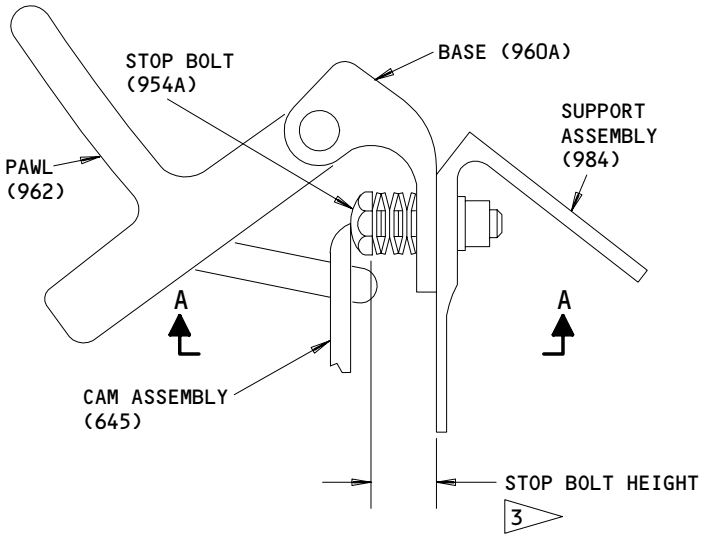
(1) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to splined areas of shaft (723), cam assembly (645), washers (714), spring (717) and to splines and bearing flat of lever assembly (624). Install 2 washers (714) and 1 spring (717) on shaft (723) up against the large splined end of shaft.

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

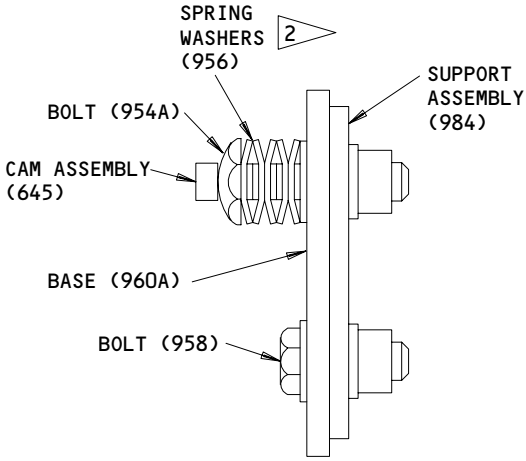
(3) Apply a thin layer of BMS 3-33 or MIL-G-23827 to the shank and threads of bolt (636) and install bolt (636) thru cam assembly (645).



Assembly Details – Cam Assembly
Figure 702 (Sheet 1)



ARMING SYSTEM EXTERNAL LOCK
B



A-A

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 (954A) HEIGHT AFTER INSTALLING WASHERS (956) AND TIGHTEN BOLT TO 35-40 IN. -LBS TORQUE

Assembly Details - Cam Assembly
Figure 702 (Sheet 2)

(4) Make sure cam assembly (645) is centered in the support assembly to within ±0.02 inch. Remove parts and add washers (714) as necessary. You can use a maximum of 8 washers to put the cam assembly in the center.

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

(6) Adjust cam assembly (645) external flushness as follows:

(a) For those assemblies without the arming system external lock (961, 962), install bolt (954A), nut (957A) and washer (955) on support assembly (984). Adjust bolt height to make cam assembly (645) be flush with the contour of support assembly to within 0.03 inch over surface of cam assembly in the closed position. Tighten nut (957A) to hold the bolt in position.

(b) For those assemblies with the arming system external lock, assemble items (959H thru 962). Apply grease to pin (959H) and mating surfaces. Install base (960A) and attached items on support assembly (984) with bolts (954A, 958). Adjust bolt (954A) height to make cam assembly (645) be flush with the support assembly to within 0.03 inch over surface of cam assembly in the closed position. Measure the stop bolt (954A) height, then remove the bolt and install the necessary number of spring washers (956) per Fig. 702.

(7) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to bearing bore and mating surfaces of guide assemblies (573, 600). Assemble spring (585) and guide assemblies (573, 600).

(8) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to the 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 (924) and external handle assembly (945).

(1) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to the shank and threads of bolts (789) and install bolts in handle assembly (945).

(2) Install plug (942) in shaft assembly (924) with sealant and fillet seal the plug to 0.18 inch minimum with BMS 5-95 sealant.

(3) Apply a thin layer of BMS-33 or MIL-G-23827 grease to seal (912), and install the seal in seal ring (915).

(4) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to washers (885, 903, 909, 918), faying surfaces of shaft assembly (924), spacer (906), seal ring (915) and bearings (900, 921) and I.D. of bearings in handle assembly (945).

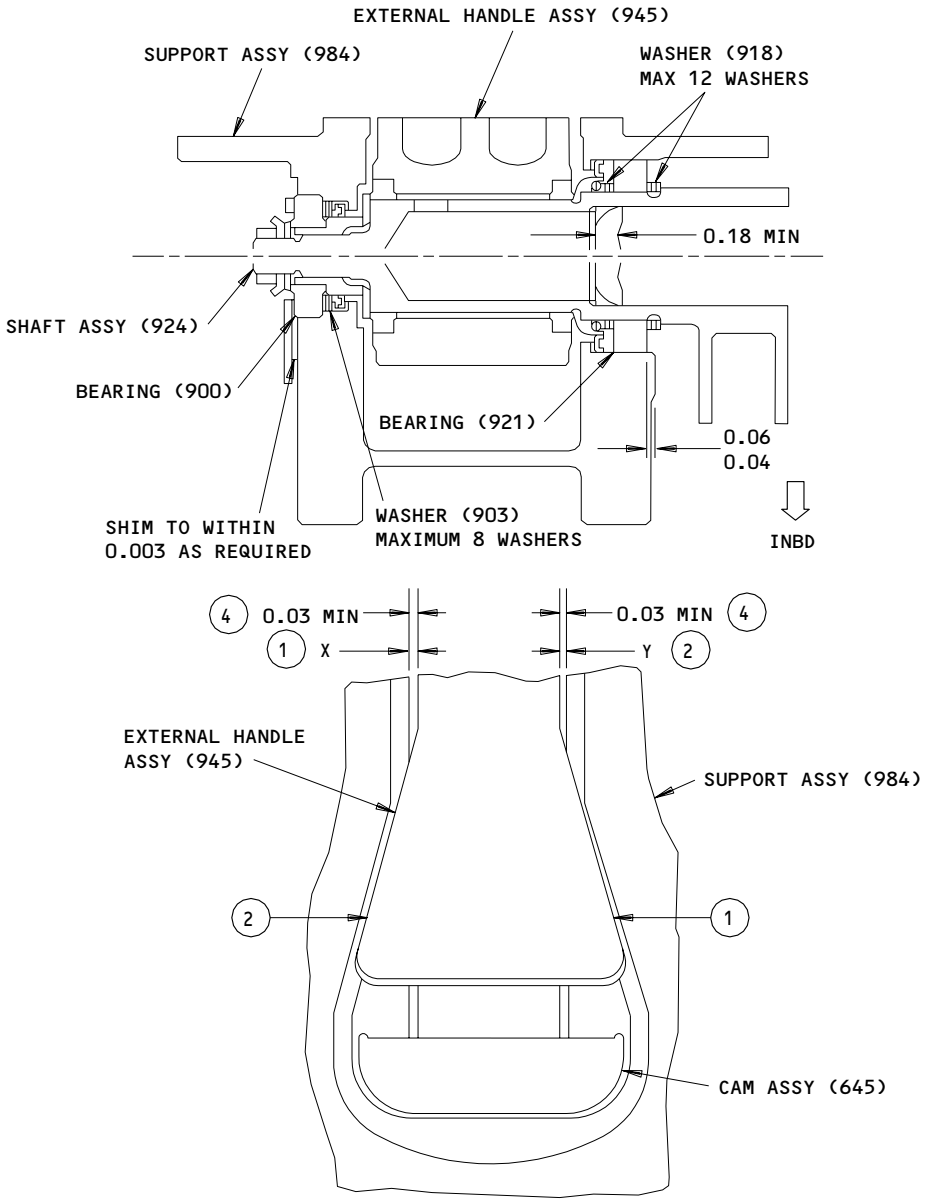
(5) Install bearing (921) with 5 washers (918) on each side on shaft assembly (924). Install seal ring (915), spacer (906) on support assembly (984). Be careful not to damage seal in support assembly (984) when you install seal ring (915).

(6) Put external handle assembly (945) and washer (909) in the cavity of support assembly (984) and install shaft assembly (924) with attached parts. Install 7 washers (903), bearing (900) on shaft assembly (924). Install washers (882, 885) and nut (879). Tighten nut (879) finger tight to remove free play from bearing (900). Install retainer (894) with bolts (888) and washers (891). Tighten bolts (888) finger tight to hold the bearing (900) in position.

(7) Install bolt (951A), nut (952), washer (953). Close external handle assembly (945) and note the height of the handle assembly. Adjust the height of bolt (951A) to make external handle assembly (945) be flush with the contour of support assembly (984).

(8) Apply a 20-50-pound force to the external handle assembly (945) to one side and measure gap between handle assembly and support assembly (984). Do this procedure with the same force ±5 pounds on the other side. Find the center location of the handle assembly (945). To adjust the position of the handle, add or remove washers (903) behind bearing (900). You can use a maximum of 8 washers here.

(9) Close handle assembly (945) and make sure there is a 0.030 inch minimum gap all around the handle assembly. If necessary, to move the position of the handle assembly, add or remove or change location of washers (918) between bearing (921). You can use a maximum of 12 washers (918). Adjust the quantity of washers (918) between shaft assembly (924) and bearing (921) as necessary to put the outer race of the bearing 0.04-0.06 inch below the surface of support assembly (984) (Fig. 701).



(VIEW LOOKING INBD)

(1) APPLY 20-50 LBS ON HANDLE ASSY (945) 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 the notch in pin (849) and put the pin into bushing hole in handle assembly (945). Turn shaft assembly (924) as necessary to engage pin in slot in shaft assembly.

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

(a) Turn shaft assembly (924) until slot in shaft assembly touches pin (849). Hold this position.

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

(c) Turn bushing (855) and/or retainer (852) until free play in shaft assembly (924) is a minimum, and shaft (858) can be easily removed and installed. (Fig. 704).

(d) Make sure the free play at the tip of the handle assembly (945) is 0.25 inch maximum.

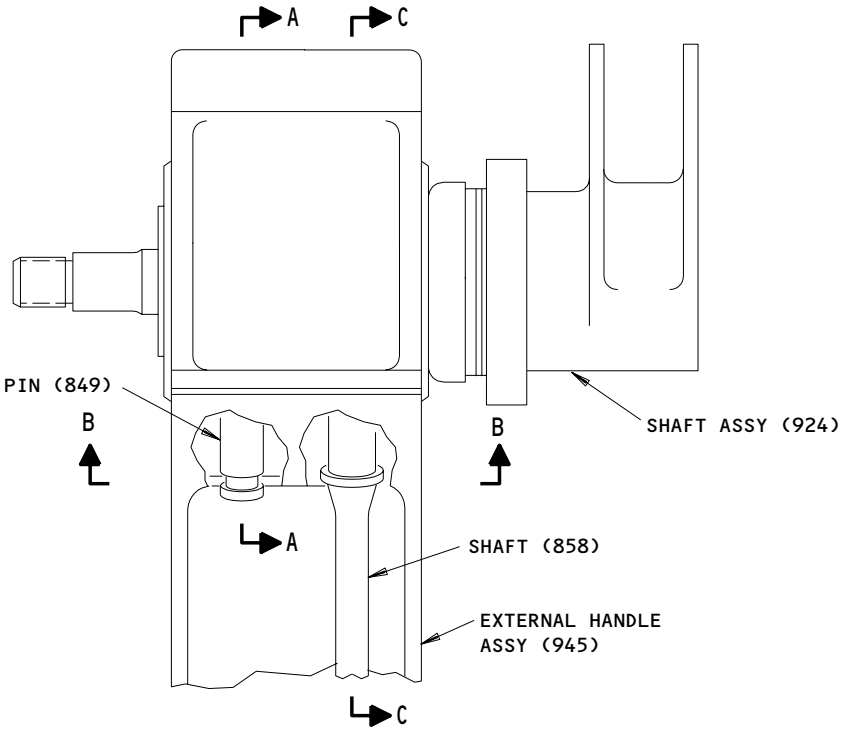
(e) Mark the position of bushing (855), retainer (852) and shaft (858).

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

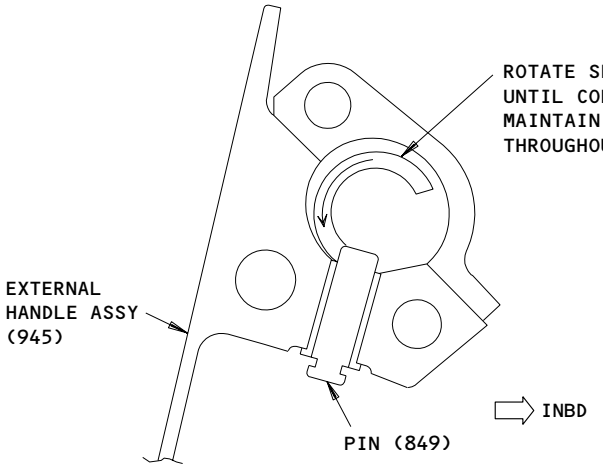
(12) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to the mating surfaces of pin (849) and to all surfaces of bushing (855).

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

(14) Install pin (849) in handle assembly (945). Install retainer (852) on bushing (855) and install the parts in the handle assembly as marked. Install spring (861), shaft (858) and support (846) and attach the support with bolt (840) and washers (843). Install shaft (858) as marked. Turn the keyway on shaft (858) inboard or outboard for shaft (858) alignment. If safety clip (833) is installed, turn the keyway inboard. Install spring (861) with the small diameter side toward shaft assembly (924).



VIEW LOOKING OUTBD
(SUPPORT ASSY (984) OMITTED FOR CLARITY)

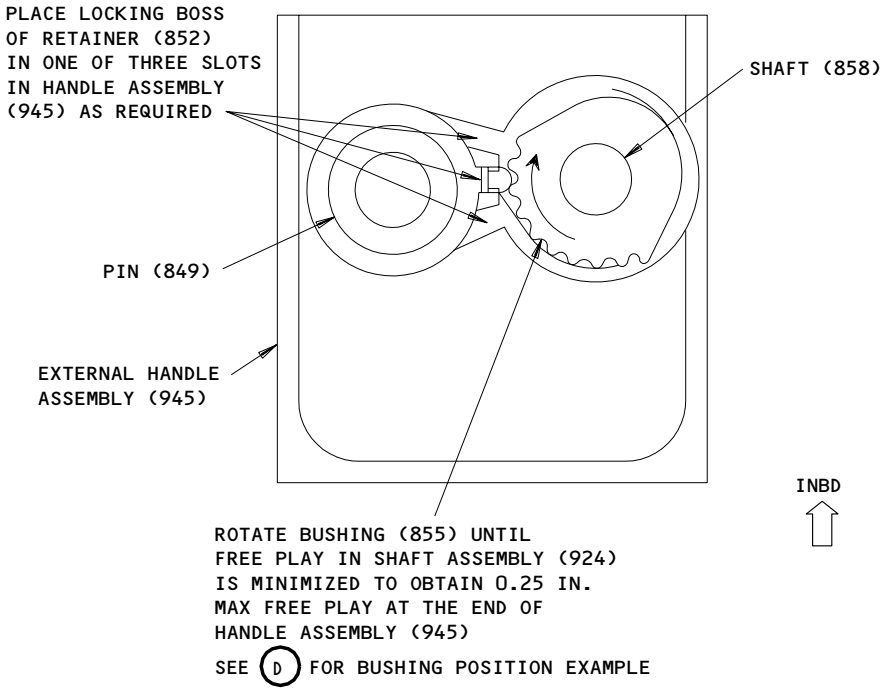


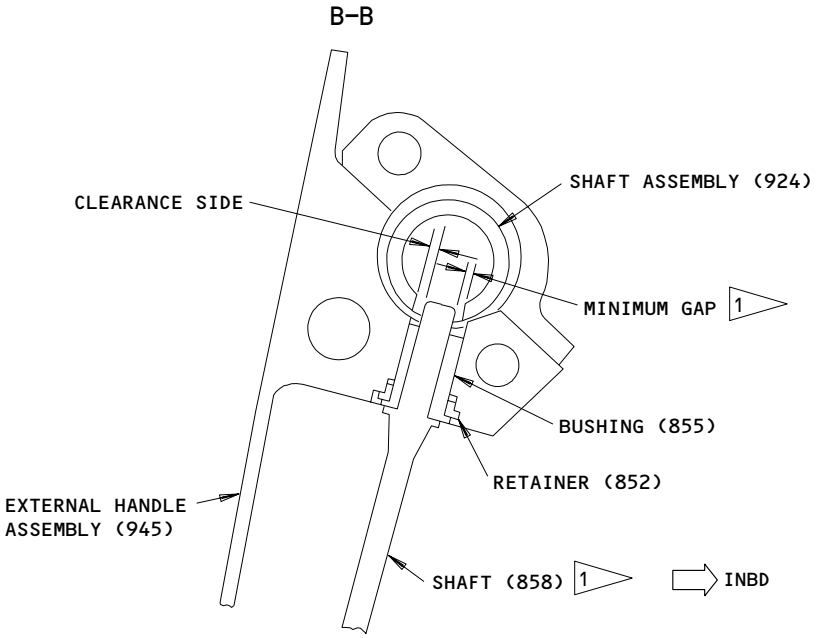
A-A

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

External Handle Assembly Rigging Details
Figure 704 (Sheet 1)



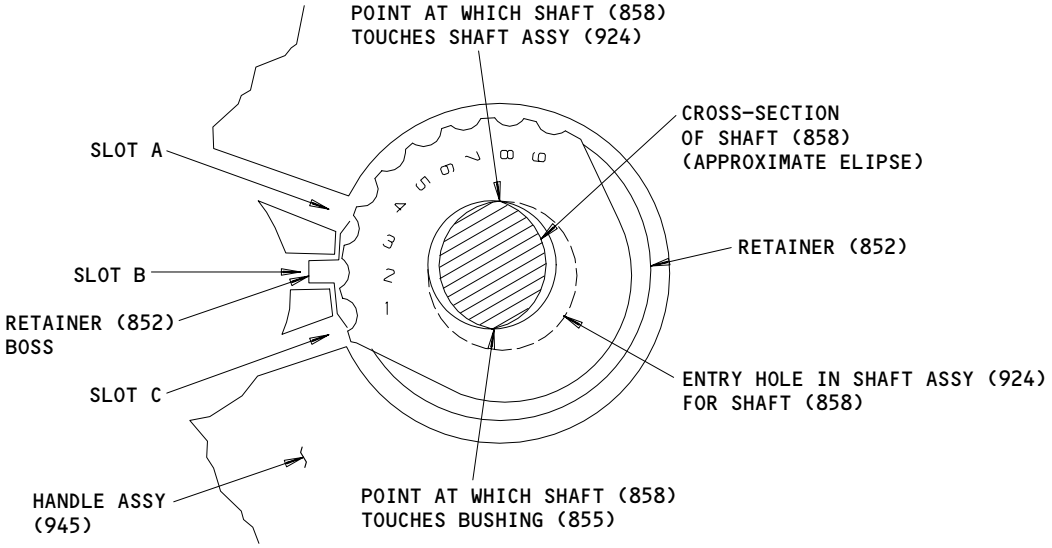


1 SHAFT (858) MUST BE FREE TO MOVE THRU BUSHING (855) AND SHAFT ASSEMBLY (924) WITHOUT INTERFERENCE. MAXIMUM FREEPLAY AT GRIP END OF EXTERNAL HANDLE ASSEMBLY (945) IS 0.25 INCH. ADJUST BUSHING (855) AS NEEDED.

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

External Handle Assembly Rigging Details
Figure 704 (Sheet 2)



D

EXAMPLE OF ADJUSTMENT OF BUSHING POSITION

NOTE: THE SLOTS IN THE HANDLE ASSY (945) 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 (924), 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.

External Handle Assembly Rigging Details
Figure 704 (Sheet 3)

(15) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to the threads and shank of bolt (825). Attach preassembled levers (834, 837) 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 (945) and look at the position of handle assembly relative to support assembly (984). Adjust the length of shaft (858) in full turns as necessary until roller assembly (816) touches contact cam assembly (645) and shaft (858) disconnects from shaft assembly (924) when the handle assembly (945) is closed. Turn shaft (858) 2 full turns into rod end assembly (870). Make sure that there is no torque in spring (861), then tighten nut (864).

NOTE: Adjust shaft (858) in full turns to keep the position of shaft you made in step (11).

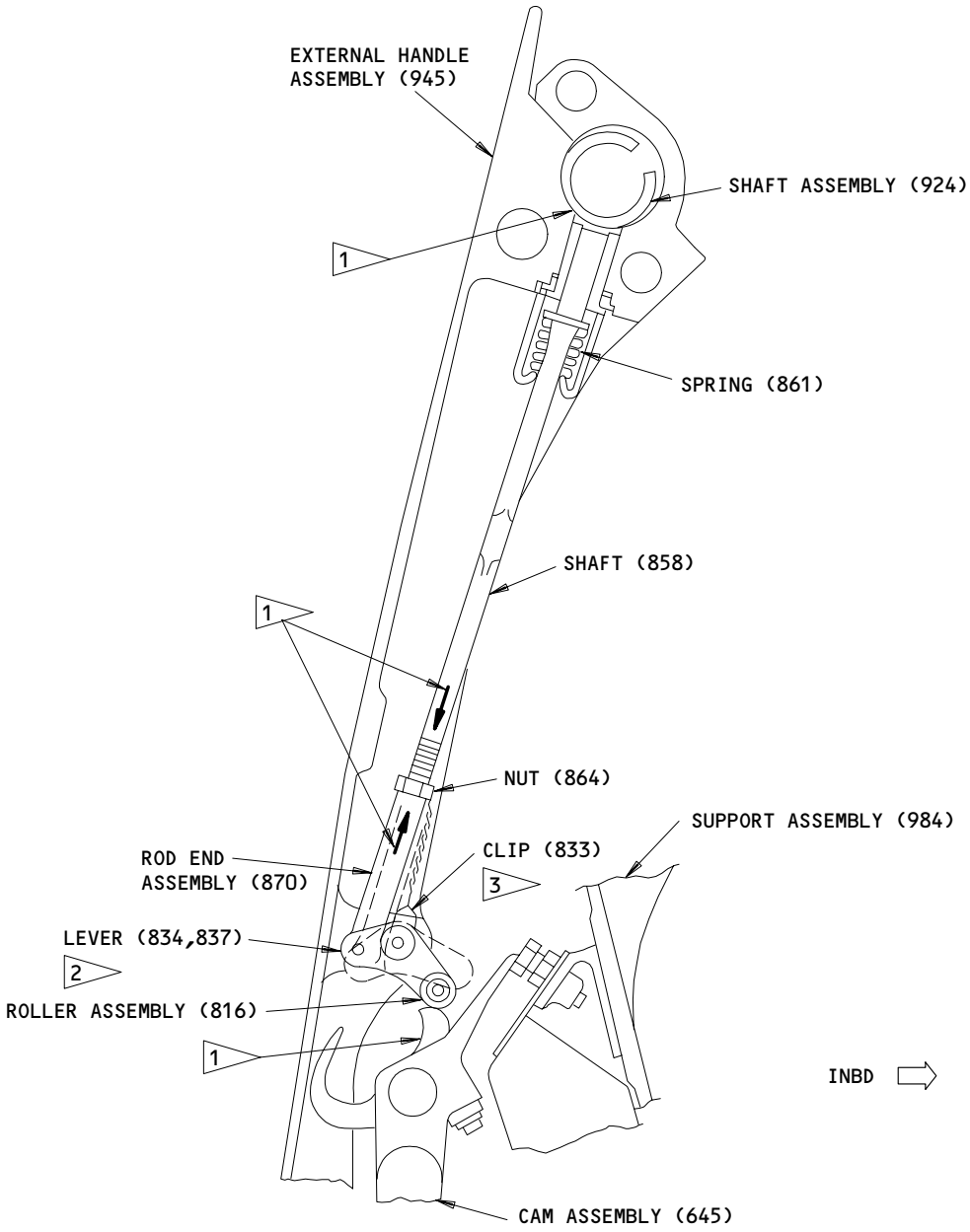
(17) Attach clip (833, 833), as applicable, to shaft (858) with lockwire. Install lockwire by the double-twist method through washer (867) and nut (864). Make sure that the clip has free play and does not prevent the full movement of the shaft.

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

(19) Apply a thin layer of grease to the mating surfaces of handle assembly (945) 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 (945) with sealant on faying surfaces and secure with washers (792) and nuts (795). Apply a bead of sealant to threads of bolts (789) before you install washers (792) and nut (795). Wipe off unwanted sealant.

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

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



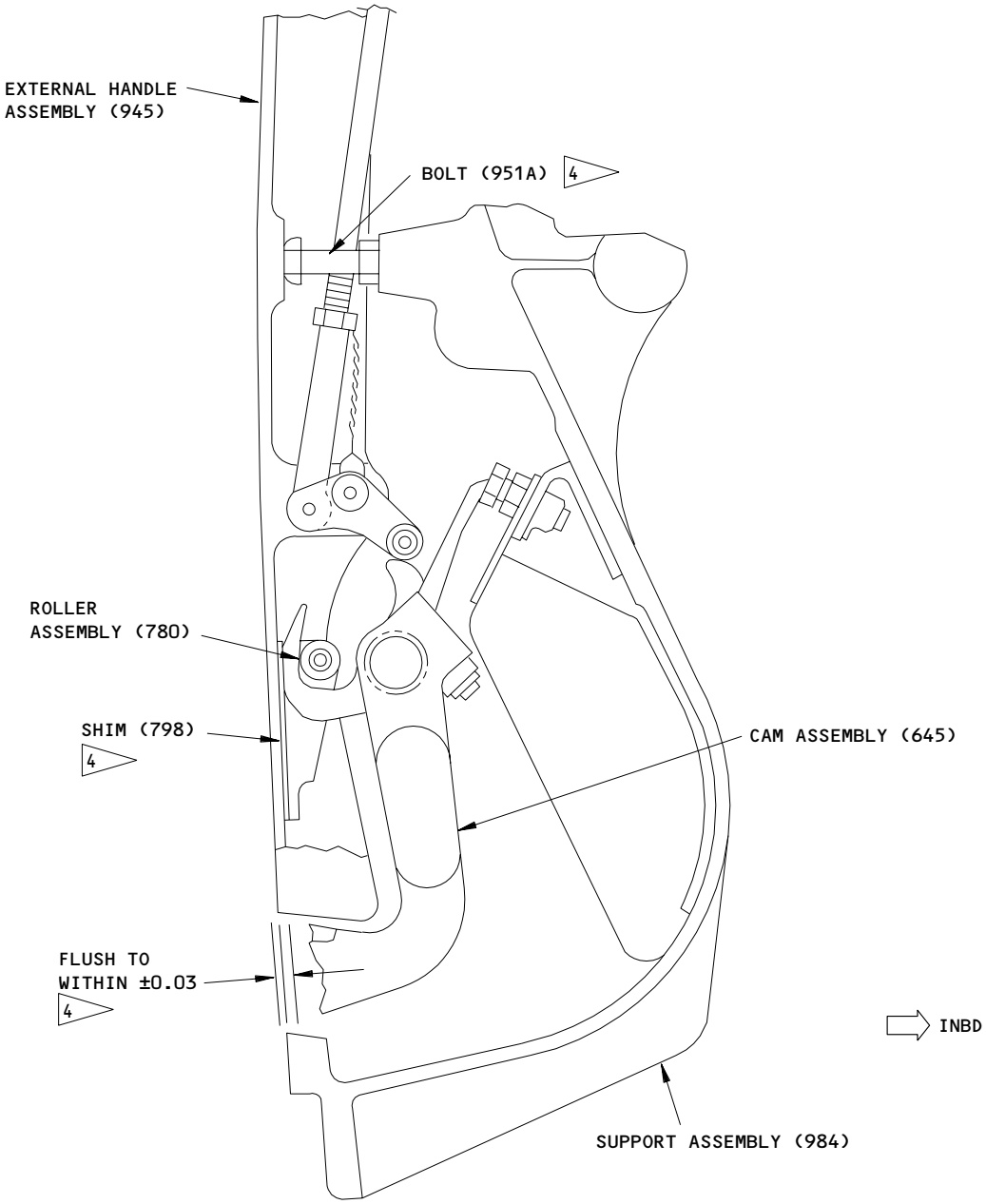
1 WITH SHAFT (858) DISENGAGED FROM SHAFT ASSEMBLY (924), ROTATE SHAFT IN FULL TURNS INTO ROD END ASSEMBLY (870) UNTIL ROLLER ASSEMBLY (816) CONTACTS CAM ASSEMBLY (645). CHECK THAT THERE IS NO STORED TORQUE IN SPRING (861). TURN SHAFT (858) 2 ADDITIONAL TURNS INTO ROD END ASSEMBLY (870) AND TIGHTEN NUT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

2 INSTALL LEVERS (834,837) AS SHOWN

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

ITEM NUMBERS REFER TO IPL FIG. 1

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



4 ADJUST BOLT (951A) AND SHIM (798) SO THAT ROLLER ASSEMBLY (780) CONTACTS CAM ASSEMBLY (645) WHEN THE HANDLE ASSEMBLY (945) 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 2)

(22) Apply a thin layer of grease to the mating surfaces of retainer (894) and support assembly (984). Wipe off the 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 related components (Fig. 706).

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

(a) Apply a thin layer of BMS 3-33 or BMS 3-24 grease to OD of bushings (555) and install bushings in support assembly (984).

(b) Apply a thin layer of BMS 3-33 or BMS 3-24 grease to shank and threads of bolts (537).

(c) Apply a thin layer of BMS 3-33 or BMS 3-24 grease to OD of bushings (536N) and install bushings in support assembly (531).

NOTE: A loose fit of the bushing after it is installed is satisfactory.

(d) Put support assembly (531) on handle support assembly (984) and install bolts (537), washers (539, 540), bushing (558) and nuts (543). Tighten nuts (543) finger-tight.

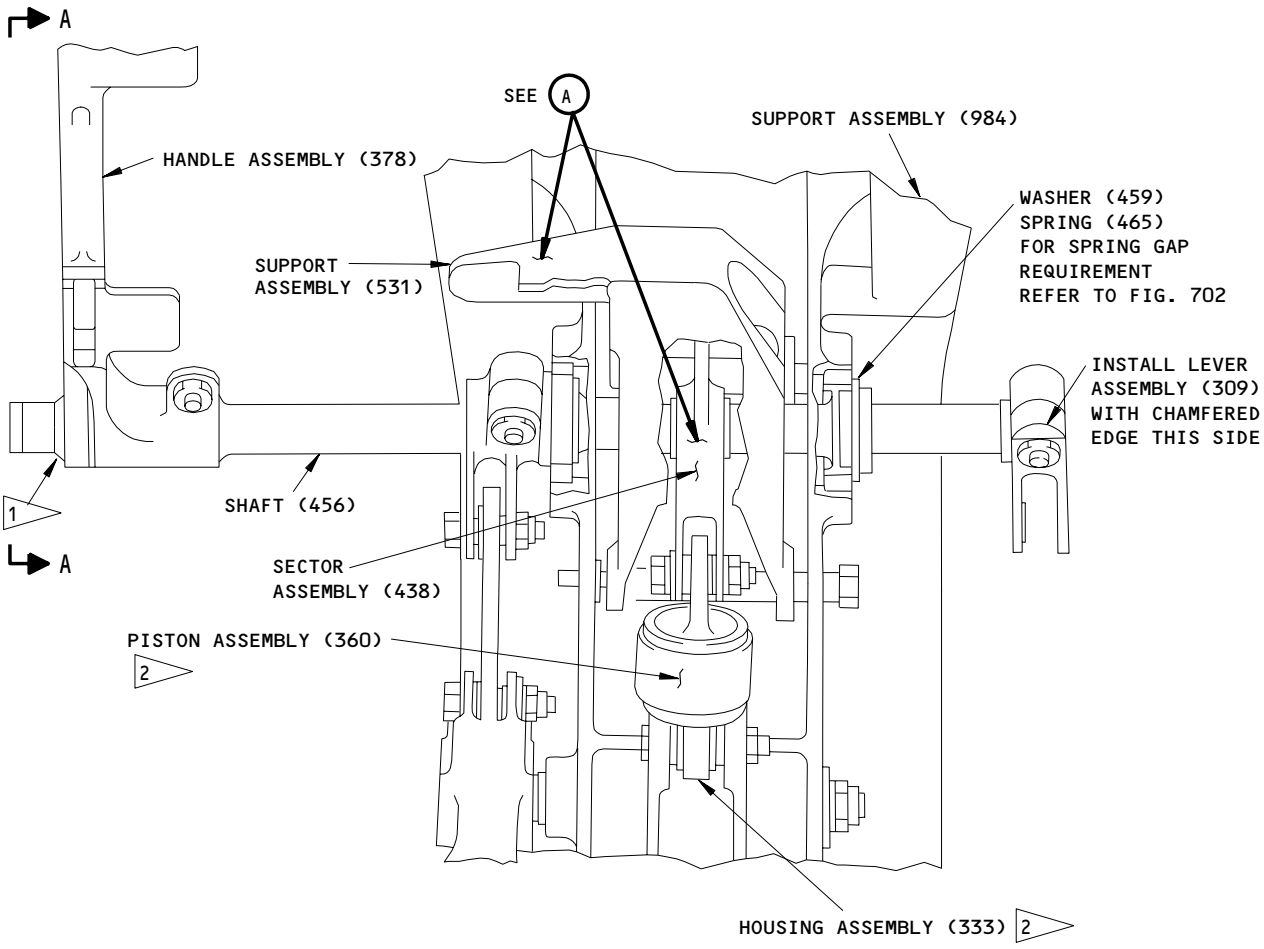
(e) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to the splines of shaft (456) and lever assembly (420) and to washers (459, 462) and spring (465). Install washer (462) and spring (465) on shaft (456).

(f) Put sector assembly (531) in position and install shaft (456) thru support assemblies (531, 984). Install washer (459) and lever assembly (420) on shaft (456) with the split line in the lever assembly aligned with the missing tooth in the shaft. Apply a thin layer of grease to the shank and threads of bolt (411) and install bolt (411), washer (414) and nut (417).

(g) Apply a thin layer of BMS 3-33 or BMS 3-24 grease to the shank and threads of bolt (432). Attach sector assembly (438) with bolt (432A), washer (435). Tighten bolt (432) only to remove play between sector assembly and shaft (456).

(h) Make a check of the distance between sector assembly (438) and support assembly (531) and add or remove washers (540) between bushing (555) and support assembly (531) to get the dimension shown (Fig. 701).

(i) Tighten nuts (543) and measure the distance between nut (543) and end of bolt (537). Then add washers (540) under nut as necessary to get a 0.17 inch maximum distance.



(VIEW IN THE OUTBOARD DIRECTION)

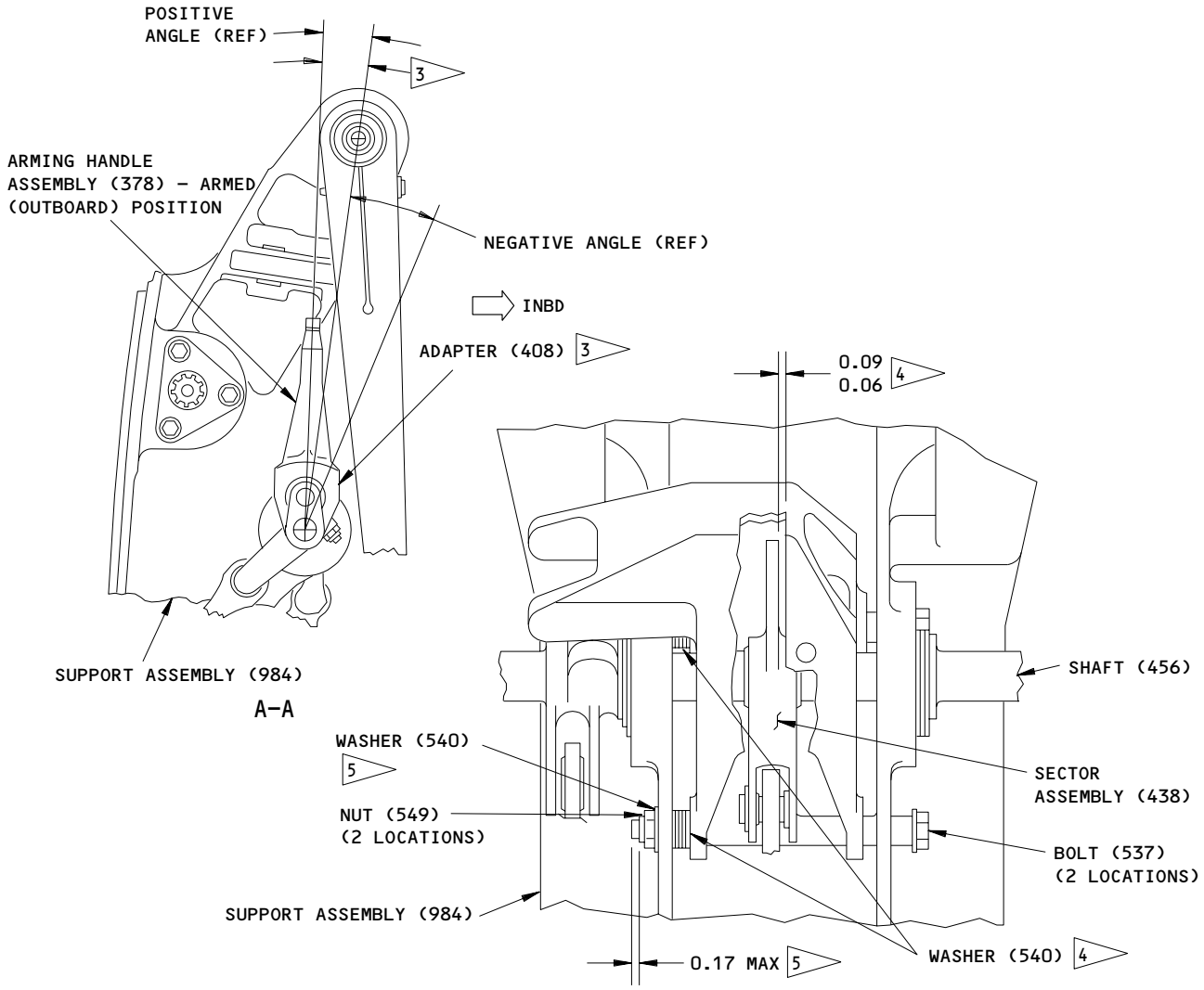
1 ON 146T6140-7,-8,-37,-38,-45,-46,-49,-50, -53,-54,-57,-58 ASSEMBLIES, INSTALL PRE-ASSEMBLED HANDLE ASSEMBLY (378) SUCH THAT SNAP RING (369) CAN BE INSTALLED ON THE SECOND GROOVE OF SHAFT (456)

ON 146T6140-11,-12,-17,-18,-41,-42,-51, -52 ASSEMBLIES, INSTALL HANDLE ASSEMBLY SUCH THAT SNAP RING CAN BE INSTALLED ON THE FIRST GROOVE OF SHAFT

2 TO ALIGN PISTON ASSEMBLY (360) AND HOUSING ASSEMBLY (333) ADJUST THE QUANTITY OF WASHER (459) ON SHAFT (456)

ITEM NUMBERS REFER TO IPL FIG. 1

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



(VIEW IN THE OUTBOARD DIRECTION)

A

NOTE: WASHER (540) THICKNESS = 0.016.

3 WITH ARMING LINKAGE IN ARMED (OUTBOARD) POSITION, POSITION ADAPTER (408) AS FOLLOWS: 146T6140–7,–8,–37,–38,–45,–46,–49,–50,–53,–54,–57,–58 ASSEMBLIES: –10° ±2°
146T6140–11,–12,–17,–18,–41,–42,–51,–52 ASSEMBLIES: 0° ±2°

4 ADJUST NUMBERS OF WASHERS (540) AS NECESSARY TO GET THIS DIMENSION (2 LOCATIONS)

5 ADD WASHERS (540) AS NECESSARY TO GET THIS DIMENSION (2 LOCATIONS)

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

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

109313

(2) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to the shank and threads of bolt (348A). Install piston assembly (360) on sector assembly (438) and secure with bolt (348A), washer (351), bushing (354) and nut (357).

(3) Install 5 washers (345) and spring (342) in housing assembly (333).

(4) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to the shank and threads of bolt (321). Put piston assembly (360) and housing assembly (333) together and attach the housing assembly to the support assembly with parts (321 thru 330).

(5) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to the splines of adapter (408). Install adapter with preassembled handle assembly (378) on shaft (456) at dimension indicated per Fig. 706.

(6) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to the shank and threads of bolt (399) and install parts (399 thru 405). Install snap ring (369).

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

(7) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to the shank and threads of bolt (225). Install lever assembly (201) with parts (225 thru 231). Install bolt (225) with bolt head away from lever assembly and washer (228) under bolt head.

(8) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to the shank and threads of bolts (189, 234). Position link assembly (246) and attach with parts (189 thru 198, 234 thru 243).

(9) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to the shank and threads of bolt (300) and to the splines of lever assembly (309).

(10) Install lever assembly (309) on shaft (456) with the chamfered edge of lever assembly facing inboard. Attach lever assembly with parts (300 thru 306).

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

(1) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease on spacers (705, 708, 711) and install 2 spacers (708), 1 spacer (711) and 1 spacer (705) on shaft (723).

(2) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease on the splines of crank (693) and install crank on shaft (723) approximately 15 degrees inboard to the vertical line of the support assembly (984) with bolt head inboard.

(3) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease on the shank and threads of bolt (675A) and install parts (675A thru 690) on lever assembly (672). Refer to IPL Fig. 1 for location of washer (684) and bushing (687) in LH or RH assembly.

NOTE: You can use a 0.437 inch long bushing or spacer between the lugs of lever assembly (672) to help.

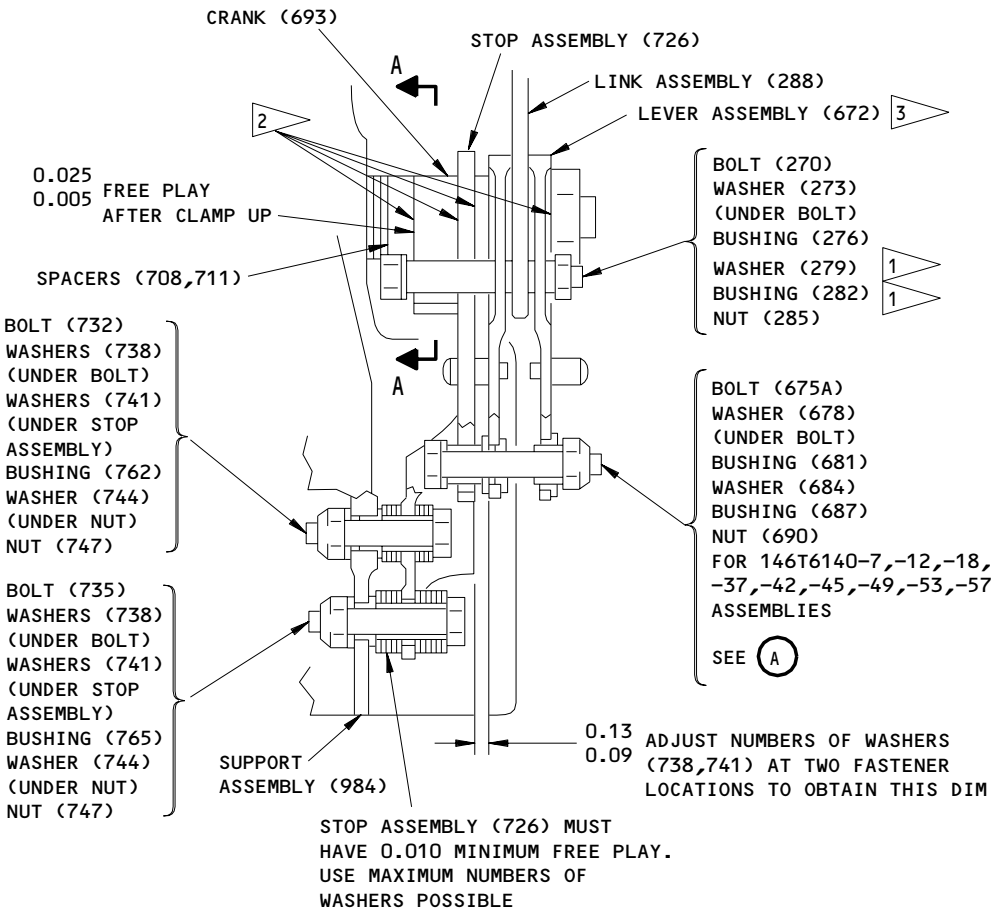
(4) Apply a light coat of BMS 3-33 or MIL-G-23827 grease to the shank and threads of bolt (270) and attach link assembly (288) to lever assembly (672) with parts (270 thru 285). Note the different locations of washer (279) and bushing (282) for LH and RH assembly.

(5) Install stop assembly (726).

(a) Attach stop assembly (726) and lever assembly (672) on shaft (723).

(b) Attach stop assembly (726) to support assembly (984) with parts (732 thru 765) as follows:

1) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to the shank and threads of bolts (732, 735).



1 ON 146T6140-7,-12,-18,-37,-42,-45,-49, -53,-57 ASSEMBLIES, REVERSE POSITION OF BUSHING (282) AND WASHER (279)

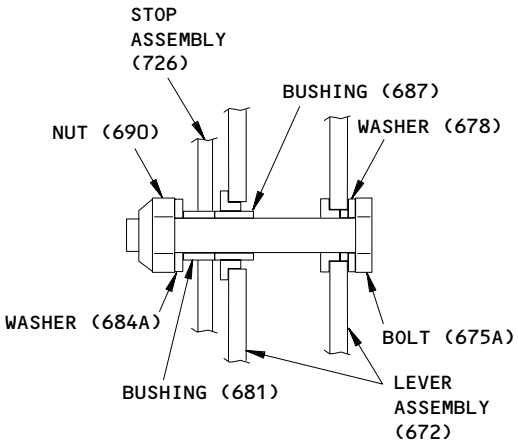
2 ADJUST QUANTITY OF SPACERS (708,711) AS REQUIRED TO PRODUCE 0.015-0.055 AXIAL FREE PLAY PRIOR TO CLAMP UP AT THESE FOUR LOCATIONS

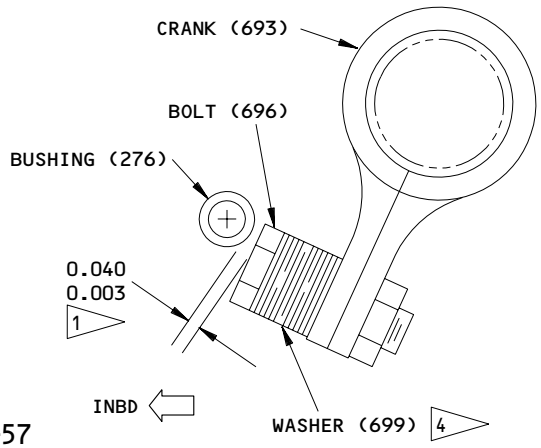
3 AFTER CLAMP UP, 0.01-0.03 AXIAL FLOAT IS NECESSARY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Assembly Details - Stop Assembly
Figure 707 (Sheet 1)

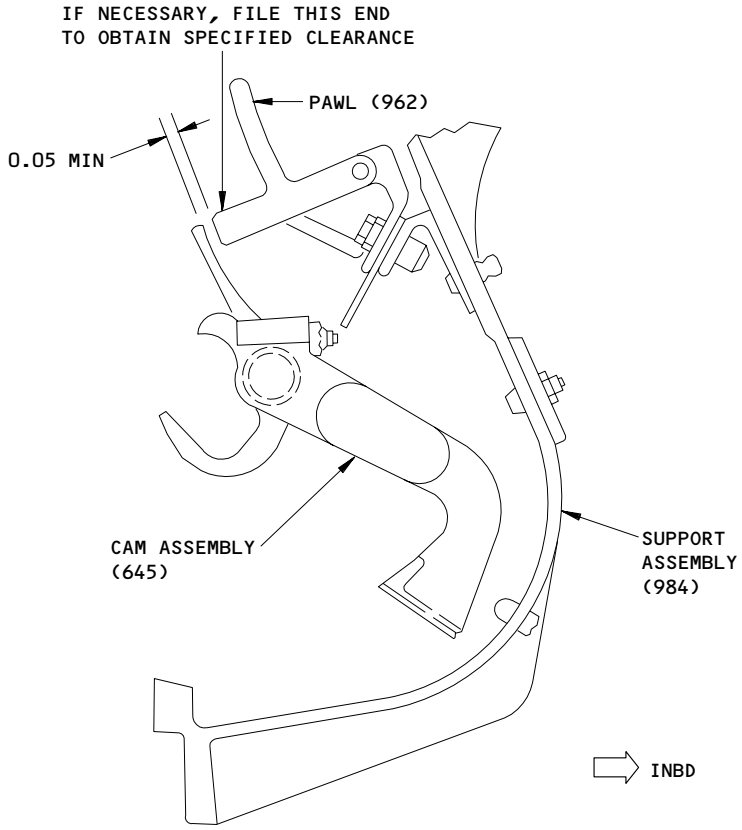




146T6140-7,-12,-18,-37,-42,-45,-49,-52,-53,-57
ASSEMBLIES

A

A-A



4 ADD OR REMOVE WASHERS (699) TO GET THIS DIMENSION (WASHER THICKNESS 0.032 INCH). YOU CAN USE A MAXIMUM OF 14 WASHERS

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Assembly Details - Cam Assembly
Figure 707 (Sheet 2)

232877

2) Install bolt (732), bushing (744), 2 washers (738) between bolt head and stop assembly (726), 15 washers (741) between the stop assembly and support assembly (984), 2 washers (750) and nut (753).

3) Install bolt (735), bushing (747), 3 washers (738) between the bolt head and stop assembly (726), 20 washers (741) between the stop assembly and support assembly (984), 2 washers (750) and nut (753).

4) Make sure the distance between stop assembly (726) and lever assembly (672) is 0.09-0.13 inch and there is no preload of the stop assembly against crank (693) or lever assembly (672). Adjust the number of washers (738, 741) as necessary. The stack of washers (741) must have 0.010 minimum freeplay at both fastener locations.

(c) Before clamp up, make sure the free play at the following four locations is 0.015-0.055 inch. Adjust the quantity of spacers (708, 711) as necessary.

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

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

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

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

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

(e) Install washer (669A), nut (666B). Tighten nut only to clamp lever assembly (672). After clamp up, make sure the lever assembly (672) axial float is 0.01-0.03 inch.

(6) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to the 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 the armed position (handle moved outboard), make sure there is 0.003-0.040 inch clearance between bolt (696) head and bushing (276). Adjust as follows to get this dimension.

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

1) Remove parts (258 thru 267) and disconnect link assembly (288) from lever assembly (309).

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

3) Remove stop assembly (726) with parts (732 thru 753). Make a note of the numbers of washers (738, 741) at each fastener location.

4) Remove crank (693) and turn it one tooth at a time in the direction to get (approximately) the necessary dimension.

5) Install the parts you removed in steps 1), 2) and 3).

(b) For fine adjustment, move washers (699) from under bolt (696) head to under nut (702) as necessary. Tighten nut (702) after the adjustment is completed. Do not remove more than 6 washers (699) from under bolt (696) head, or bolt (696) will hit bushing (276) off-center.

(8) Turn nut (666) and make sure the run-on torque is 90-400 lb.-in. If not, remove this nut and try a different nut. Then tighten the nut to 1700-2150 lb.-in.

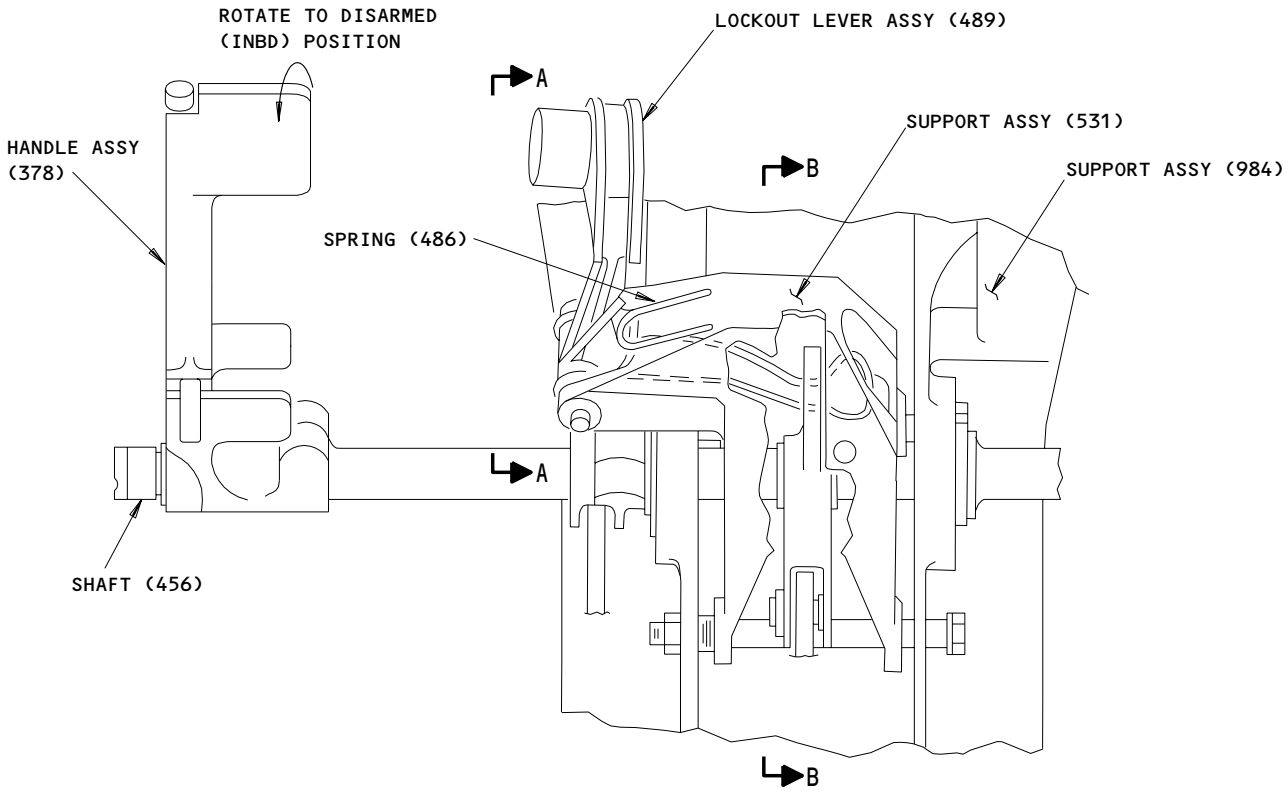
(9) On assemblies with the arming system external lock (961, 962), make sure the clearance between pawl (962) and cam assembly (645) after rigging disconnect crank (693) is a minimum of 0.05 inch. If necessary, file the end of pawl (962) to get the clearance (Fig. 707).

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

(1) Turn handle assembly (378) inboard (to the disarmed position) and keep it in this position while you do 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.

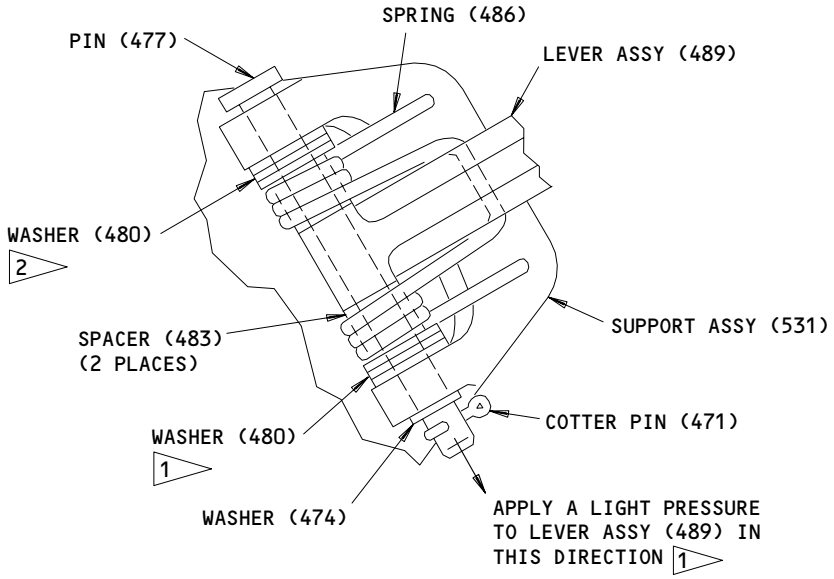
(b) Apply a light pressure at the pivot point of lever assembly (489) in the direction that will decrease the gap between lever assembly (489) and sector assembly (438). Make a note of the size of the gap.



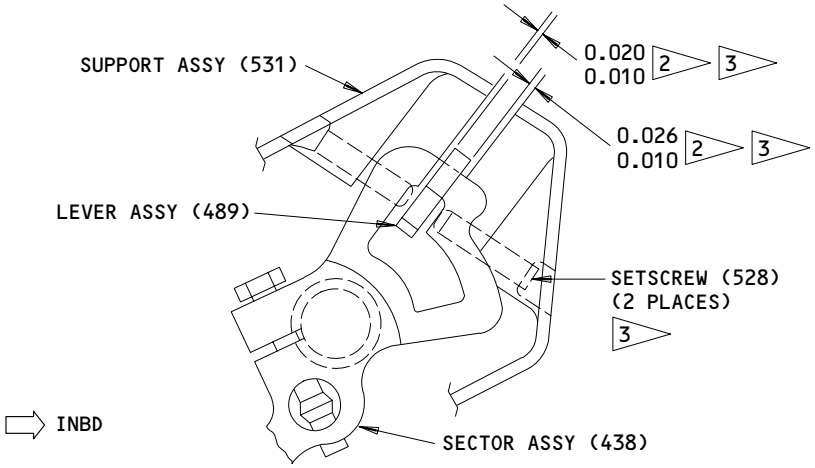
(VIEW LOOKING OUTBD)

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)

(c) Add washers (480) between support assembly (531) and spacer (483) as necessary to get the dimension shown between lever assembly (489) and sector assembly (438).

(d) Add washers (480) on the cotter pin side to fill the gap between spacer (483) and support assembly (531). Do not use too many washers (480) or the lever will not move easily.

(e) Make a note of the quantity of washers (480) at each location, then remove the parts you installed in step (a).

(f) Wipe spacer (483) with BMS 10-11, Type 1 primer (F-19.45 in SOPM 20-41-01). Then apply a thin layer of BMS 3-33 or BMS 3-34 grease to O.D. of spacers (483).

(g) Install lever assembly (489), spring (486), spacers (483), the quantity of washers (480) you used in step (e), and pin (477).

(h) Make a new check of the dimensions and adjust as necessary. Then install washer (474) and cotter pin (471) (SOPM 20-50-02).

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

G. Push lever assembly (489) toward center line of support assembly (984) and turn handle assembly (378) from one position to the other and back. Make sure spring (342) is preloaded in both positions. Add washers (345) as necessary until 7-11 pounds of force is necessary to move handle assembly from one position to the other. Also make sure there is no free play at each extreme position (with lever assembly (672) against stop assembly (726)).

H. Assemble shaft assembly (175) and inside handle assembly (139P or 141).

(1) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to shank and threads of bolt (81) and install bolts (81) and washer (84).

(2) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to washers (177, 180), spring (183), and the mating surfaces and splines of shaft assembly (175). Install washer (177), then install 3 washers (180) and 1 spring (183) with the spring between washers (180) on shaft assembly (175).

(3) Install shaft assembly (175) on support assembly (984) and turn it to the approximate angle 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 (162). Do not tighten nut (171) up against adapter (162).

(b) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to splines of handle assembly (141), spacer (159, 160) and adapter (162).

(c) Install spacer (159, 160), handle assembly (141) and adapter (162) on shaft assembly (175). Tighten screw (165).

NOTE: Final adjustments will be made during installation on the airplane.

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

(a) Install screw (176C), washer (176E), and nut (176G) on adapter (176J). Do not tighten nut (176G) up against adapter (176J).

(b) To assemble handle assembly (139P), install pawl assembly (140A) with washers (139W) in the housing (140Q) with pin (139U). Lock the pawl assembly (140A) on the pin (139U) with pin (139T). Install pin (139T) with a thin layer of BMS 3-33 or MIL-G-23827 grease.

(c) Install spring (139V) with BMS 3-33 or BMS 3-24 grease and adjust spring (139V) to get the dimension shown in Fig. 712.

(d) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to splines of handle assembly (139P), spacer (157), clutch assembly (138M) and adapter (176J).

(e) Install clutch assembly (138M), spacer (161N), bearings (161), spacer (157), handle assembly (139P), and adapter (176J) on shaft assembly (175). Tighten screw (176C).

NOTE: Final adjustments will be made during installation on the airplane.

(6) Make sure there is a 0.003-0.020 inch clearance between waves of spring (183) and washers (180). Remove parts and adjust the number of washers (180) as necessary.

(7) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease 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 (157, 159, 160). Tighten nuts (138, 156) only finger-tight, because these nuts will be tightened when the unit is installed on the airplane.

(8) Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to the mating surfaces of lever assembly (99). Put lever assembly (99) and cap (120) on shaft assembly (175) and install parts (102 thru 114). Tighten nut (114) only finger-tight, because lever assembly (99) will be adjusted when it is installed on the airplane.

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

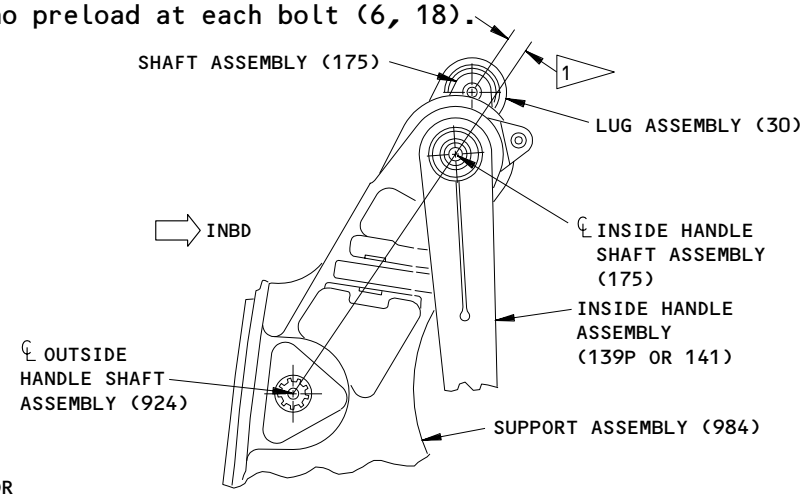
(1) With external handle assembly (945) closed and latched (cam assembly (645) flush with support assembly (984)), turn shaft assembly (174) to the dimension shown and turn shaft assembly (924) to the hard-over position toward external handle assembly closed.

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

(3) Adjust the serrated area between lug assemblies (30, 57) to remove the preload at each bolt (6, 18). Tighten bolts (42, 48).

(4) Remove parts (6 thru 27), then install them with BMS 5-95 sealant.

(5) Make sure there is no preload at each bolt (6, 18).



1 TURN SHAFT ASSEMBLY (175) TO THE FOLLOWING SPECIFIED DIMENSIONS FOR INSTALLATION AND ADJUSTMENT OF LUG ASSEMBLIES (30,57)
46T6140-7,-37,-45,-49,-53,-57:
1.00-1.04 (PREF), 0.91-1.04 (ACCEPTABLE)
146T6140-8,-38,-46,-50,-54,-58:
1.03-1.07 (PREF), 0.95,-1.07 (ACCEPTABLE)
146T6140-11,-12,-17,-18,-41,-42,-51,-52:
0.47-0.51

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Assembly Details - Lug Assemblies
Figure 709

109323

J. Install button (525B) with screw (516B), washer (519) and washer (522). Use washers (522) as necessary to get the distance shown between the tip of button (525B) and handle assembly (139P or 141) (Fig. 710).

K. Install cam bracket (469) on handle support assembly (984) with bolts (469Q) and washers (469R). Install fasteners with BMS 5-95 sealant (SOPM 20-50-19).

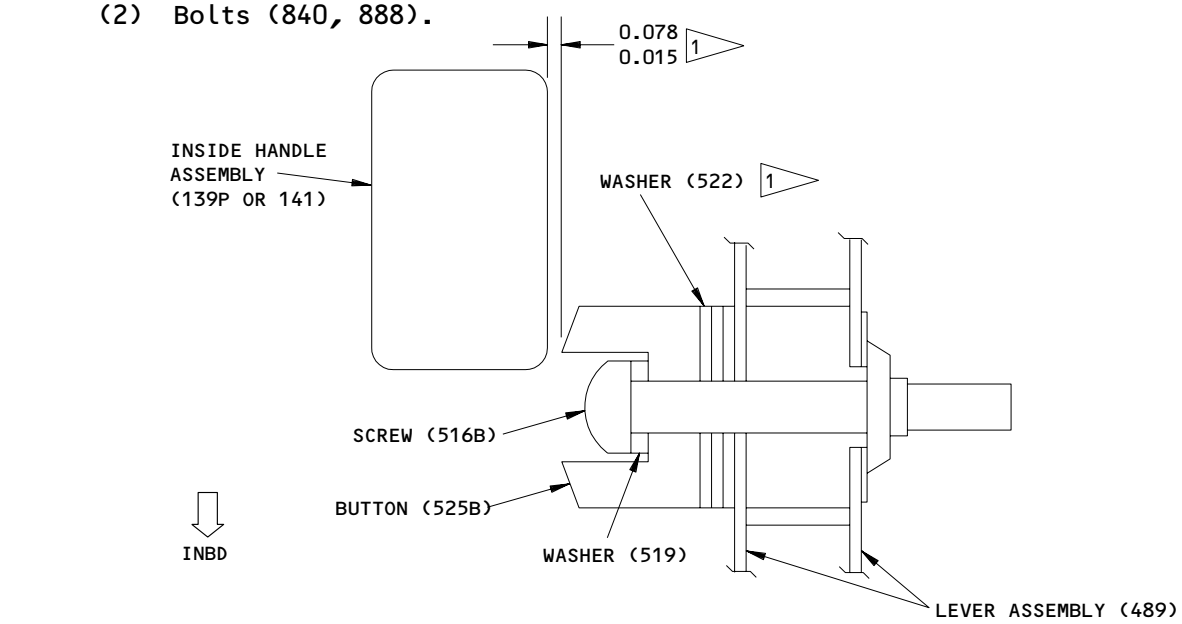
L. Make sure the handle mechanism operates smoothly.

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

N. Lockwire between these parts by the double twist method (SOPM 20-50-02) with MS20995NC32 lockwire.

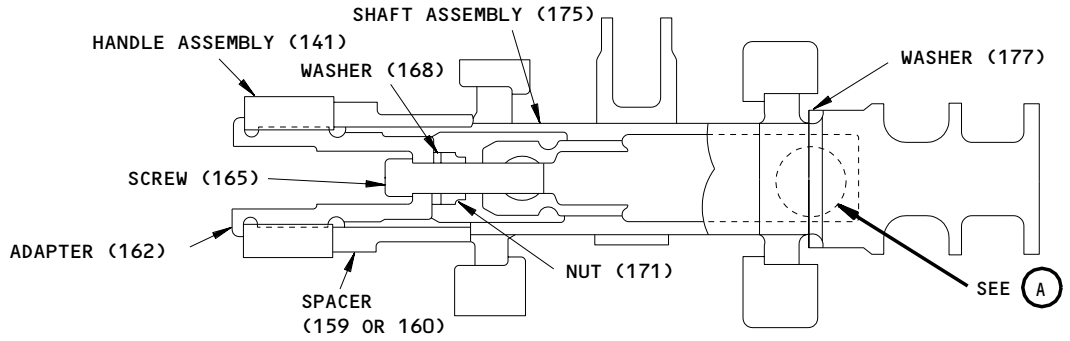
(1) Nut (864) and washer (867).

(2) Bolts (840, 888).

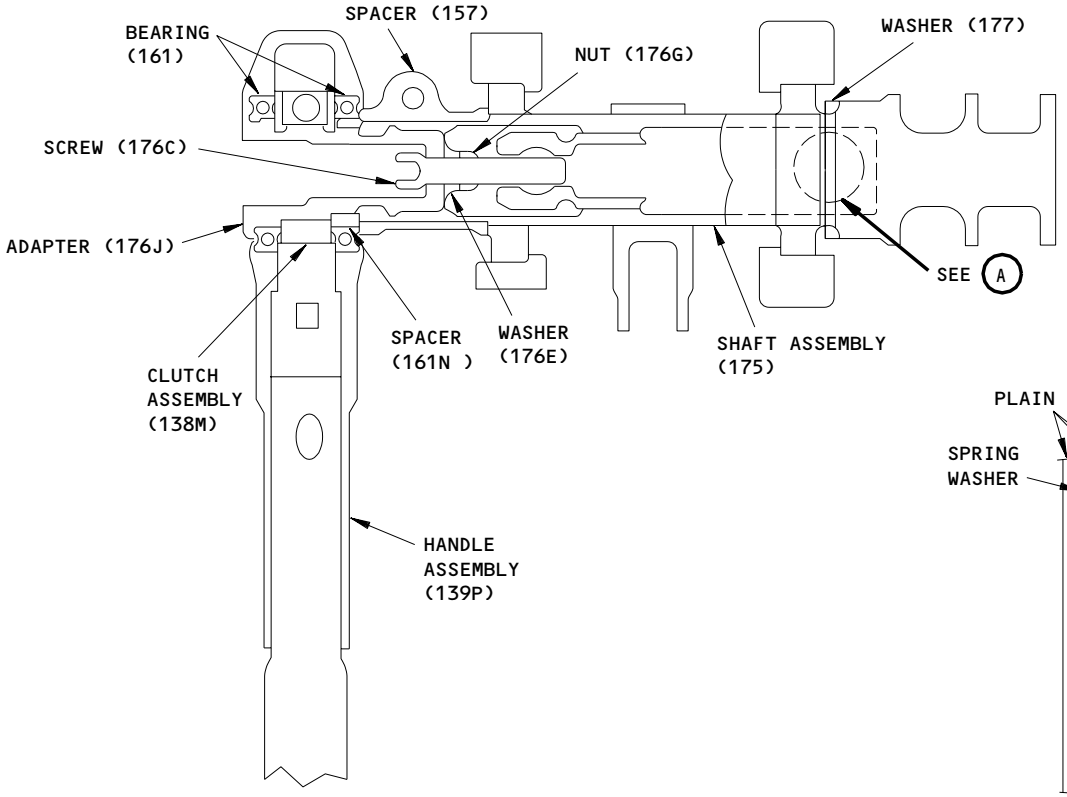


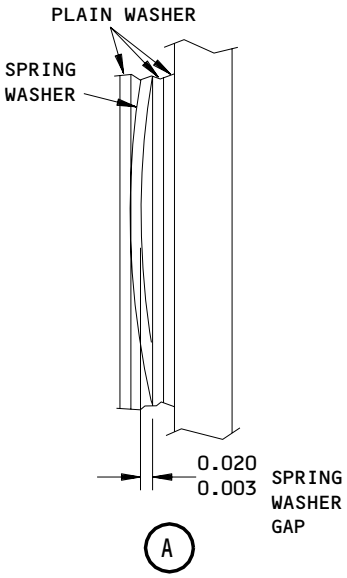
Button Installation
Figure 710

109325



HANDLE INSTALLATION WITHOUT CLUTCH MECHANISM



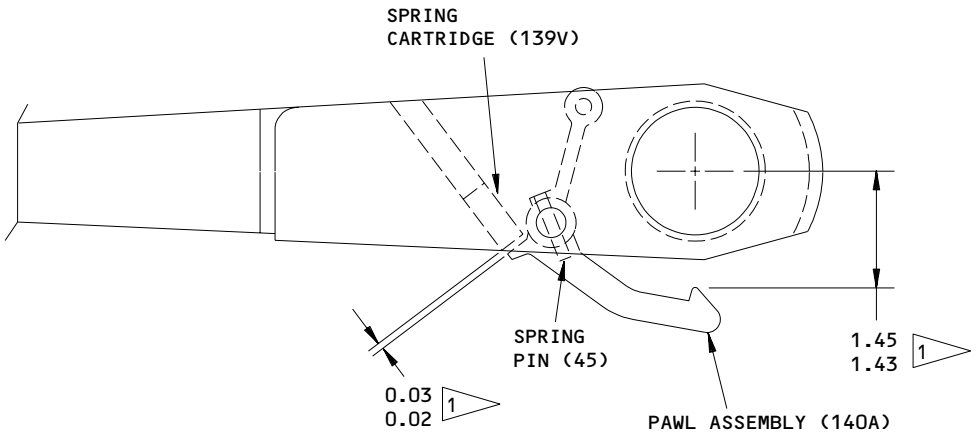


HANDLE INSTALLATION WITH CLUTCH MECHANISM

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 CARTRIDGE (139V) TO DIMENSION SHOWN WHEN PAWL ASSEMBLY IS AT FULL OPEN POSITION

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Inside Handle Assembly Adjustment
Figure 712

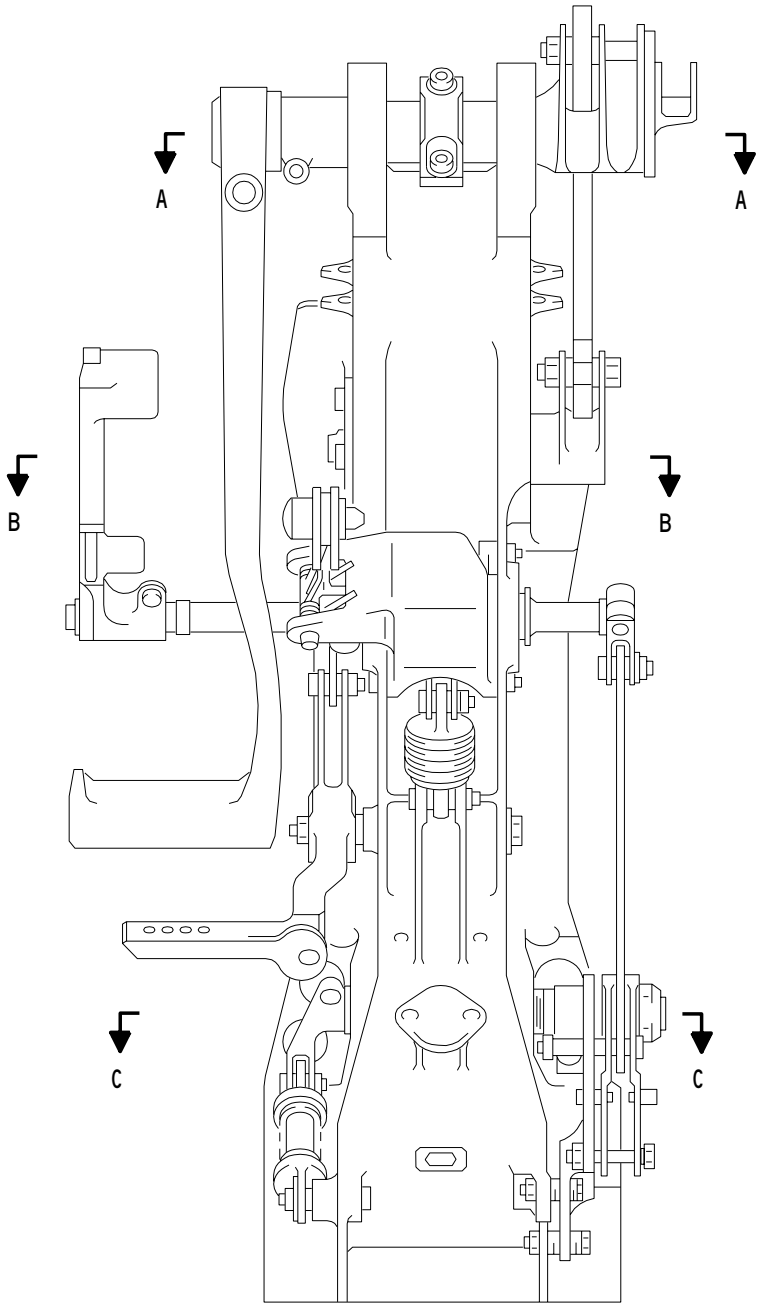
969036

3. Storage

CAUTION: HANDLE ASSEMBLY (139 OR 141) IS FREE TO TURN AND MUST BE HELD IN POSITION TO PREVENT DAMAGE TO PARTS OR INJURY TO PERSONNEL.

A. Temporarily attach handle assembly (139P or 141) to shaft (456) with tape or something equivalent.

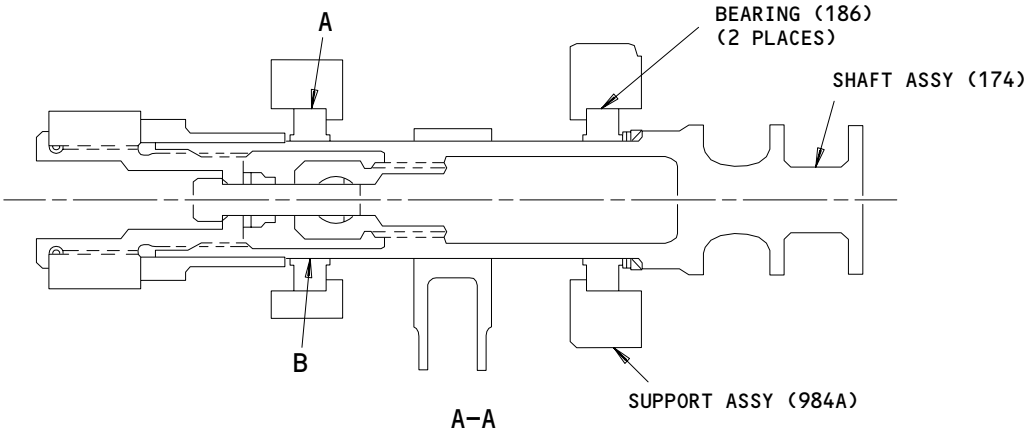
B. Give protection to the unit and put it away by standard industry practices and the instructions in SOPM 20-44-02 and 20-70-01.



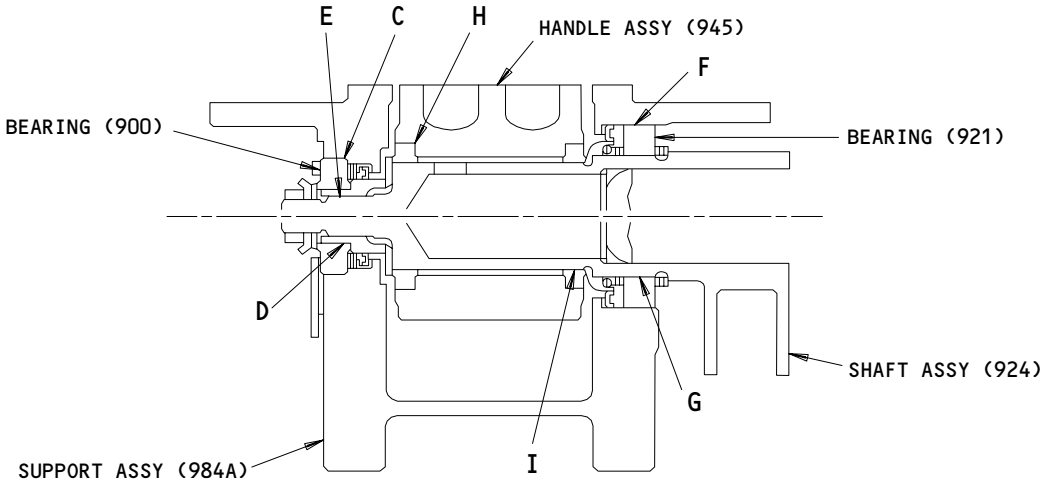
146T6140-11 SHOWN

Fits and Clearances
Figure 801 (Sheet 1)

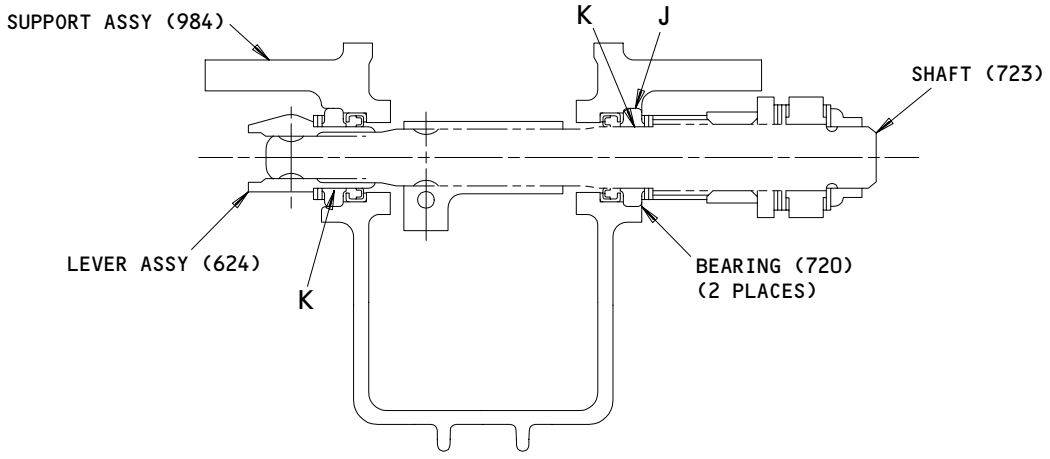
60525



A–A



B–B



C–C

ITEM NUMBERS REFER TO IPL FIG. 1

Fits and Clearances
Figure 801 (Sheet 2)

60542

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 924	0.501 0.495	0.504 0.500	0.001	0.009			0.0100
F	ID 984 OD 921	2.1885 2.1865	2.1895 2.1875	0.0010	0.0030			0.0040
G	ID 921 OD 924	1.4370 1.4365	1.4380 1.4375	-0.0005	0.0015			0.0025
H	ID 50,55 *[2] OD 40 *[2]	1.7500 1.7490	1.7510 1.7500	0.0000	0.0020			0.0030
I	ID 40 *[2] OD 924	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 624,723	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)

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

Torque Table
Figure 802

60579

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

08524 DEUTSCH FASTENER CORP SEE CODE V97928

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

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

VENDORS

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

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

VENDORS

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

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

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

VENDORS

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
AN315C4R		1	957A	1
		1	957B	1
AN316C4R		1	952	1
AN960-1216L		1	669A	1
AN960-416		1	153	1
		1	261A	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	539	3
		1	540	1
		1	639	1
		1	678	1
		1	699	14
AN960-516		1	168	1
		1	176E	1
AN960-616		1	9	1
		1	21	1
		1	45	1
		1	738	11

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN960-716		1	885	1
AN960C10		1	807	1
AN960C10L		1	771	1
AN960C416		1	792	3
AN960C416L		1	469R	3
AN960KD416		1	192A	1
		1	324A	1
		1	351A	1
		1	956A	5
AN960KD416L		1	953	1
		1	955	1
		1	956B	5
AN960KD416L		1	959	1
AN960KD616		1	228A	1
AN960KD8		1	981A	1
AN960KD8L		1	978A	1
AN960PD10L		1	966A	2
AN960PD416		1	744	2
AN960PD416L		1	684	1
AN970-4		1	564	1
ASR6-30		1	36	1
		1	69	1
AS46-4		1	111	2
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		1	140E	1
BACB10CF12PP		1	720	2
BACB10CF14PP		1	753	1
		3	15	2
BACB10CF21PP		1	161	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

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB28AK04-027		1	195A	1
		1	282	1
BACB28AK04-028		1	687	1
BACB28AK04-053		1	762	1
BACB28AK04-070		1	765	1
BACB28AK04-075		1	327B	1
BACB28AK04-238		1	558C	1
BACB28AK04-248		1	558B	1
BACB28AK04-258		1	558	1
BACB28AK06-021		1	12	2
BACB28AK06-028		1	24	1
BACB28X4C009		5	105	1
BACB28X4C010		1	123A	1
		1	630A	1
		3	5	2
BACB28X4C011		1	315A	1
		1	450B	1
BACB28X4C012		1	426	1
BACB28X4C015		1	210	1
BACB28X4C024		1	536N	2
		5	110	1
BACB28X4E015		1	87	1
BACB28X4M010		1	555	1
BACB28X4M016		5	90	1
BACB28X4M050		5	80	1
BACB28X5M016		5	100	4
BACB28X5M024		5	100A	4
BACB28X6C010		1	930	1
BACB28X6C016		2	10	1
BACB28X6M010		1	120	1
		1	312A	1
		1	423	1
		1	627	1
BACB28X6M012		1	207	1
		1	447	1
		3	10	2
BACB28X6M016		5	95	1
BACB28X6M050		5	85	1
BACB28X6M109		4	30	1
BACB28X9M010		1	933	1
BACB28Y4C037		1	681A	1
BACB28Y4C089		1	276	1
BACB28Y6E036		1	90	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB28Y9M013		2	20	1
BACB28Y9M015		2	15	1
BACB30LE6U25		1	48B	1
BACB30LK3-13		1	825	1
BACB30LL6-34		1	6F	1
BACB30LT6-18		1	18B	1
BACB30MR4K10		4	10	4
BACB30MT6K25		1	48	1
BACB30MY5K5		5	40	2
BACB30NF4-1		1	81	1
BACB30NF4-4		1	958	1
BACB30NJ6K18		1	18	1
BACB30NM3K12		1	768A	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
		1	411	1
		1	432A	1
BACB30NM4K25		1	561	1
BACB30NM4K50		1	537	2
BACB30NM4K6		1	469Q	3
BACB30NM6K12		1	42	1
BACB30NM6K70		1	225	1
BACB30NN4K14		1	636	1
BACB30NR4K10		1	588	1
BACB30NR4K11		1	234	1
		1	258	1
		1	348A	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30NR4K12		1	189	1
BACB30NR4K15		1	732	1
BACB30NR4K16		1	321	1
		1	735	1
BACB30NR4K22		1	675A	1
BACB30NR4K26		1	270	1
BACB30NT2K3		1	975	1
BACB30NT3K3		1	963	2
BACB30NW8K5		1	789	3
BACB30NX8K28		1	132	1
BACB30RF6P34		1	6D	1
BACC30M5		5	45	2
BACN10HC4		1	139B	1
		1	390	1
		1	441	1
BACN10HC5		2	35A	1
BACN10HC6		1	60	2
BACN10JC3		1	969	2
BACN10JC3CM		1	774	1
		1	810	1
BACN10JC4		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
		1	642	1
		1	690	1
		1	702	1
		1	747	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACN10JC4CM		1	795	3
BACN10JC5		1	171	1
BACN10JC6		1	27	1
		1	231	1
BACN10JD112CD		1	666B	1
BACN10JP08A		5	25	1
BACN10JP08C		1	218	4
		1	218G	2
BACN10JP4DCM		5	55	2
BACN10JQ42		5	15	22
		5	20	14
BACN10JQ43		5	20A	14
BACN10JR4CM		1	501	1
BACN10MT4		1	114	2
BACN10YF42		5	15A	22
BACN10YF43		5	20B	14
BACP18T4K72		1	477	1
BACR10V4		1	393	1
		1	444	1
BACR10V5		2	40	1
BACR10V6		1	63	2
BACR15BA3AD		1	217	8
		1	217G	4
		1	498	2
		5	10	74
		5	50	4
BACR15BA5D		1	139S	5
BACR15BB4AD		5	60	1
BACR15BB4AD10		3	20	2
BACR15BB4B		1	492	2
BACR15CE5M		1	651	4

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACR15DR3F4		5	8	44
BACR15DR3F6		5	7	24
BACR15DR3F8		5	12	4
BACR15GA6		1	140C	1
BACS18G50B		1	504	1
BACS40U4N2		1	473	1
BACS45A26S		1	972	1
BACW10AU4		1	111	2
BACW10BN4AC		4	15	4
BACW10CA104CCU		1	105	2
BACW10CA104CVU		1	108	2
BACW10CA6CCS		1	51	1
BACW10CA6CVS		1	54	1
BACW10P115S		1	84	1
BACW10P121C		1	345	4
		1	346	1
BACW10P129AM		1	522	1
BACW10P221S		1	741	10
BACW10P274G		1	139W	4
BACW10P321S		1	480	1
BAC27TBY0033		1	664	1
BCREF5231		5	120	2
BCREF5232		5	115	1
BCREF5355		5	125	1
BRH10A3		1	969	2
BRM200A08		5	25	1
BRM300A08		1	218	4
		1	218G	2
BR2000C4M		1	501	1
BO500-038S		1	956	5
B30MY5K5		5	40	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

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
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	161	2
		4	40	2
B542DD		1	161	2
		4	40	2
B542DDFSS428		1	161	2
		4	40	2
B542DDFS101		1	161	2
B542DDFS101		4	40	2
B542FS101		1	161	2
		4	40	2
B542SSG27		1	161	2
		4	40	2
DELETED		1	873	2
DW6-1		1	216	1
GDW6FS428		1	216	1
GDW6SD610		1	216	1
GDW6TT		1	216	1
HHKSP4A		1	252	2
		1	294	2
		1	363	1
		1	579	1
		1	606	1
HL10VAZ5-5		5	40	2
HL1012AZ8-28		1	132	1
HL11VAZ8-5		1	789	3
HL12VAZ8-28		1	132	1
HL70-5		5	45	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL79-5		5	45	2
H10-3BAC		1	969	2
H19700P4		1	114	2
KP10AFS428		1	900	1
KP10A2TS		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
KSP4AFS428		1	252	2
		1	294	2
		1	363	1
		1	579	1
		1	606	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
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
K19701P4		1	111	2
K29646-104NF		1	108	2
K29646-6S		1	54	1
K29913-104NF		1	105	2
K29913-6S		1	51	1
LH8065-048		1	139B	1
		1	390	1
LH8065-048		1	441	1
LH8065-054		2	35A	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	15A	22
MF19058-4-3BAC		5	20B	14
MK1000-08BAC		5	25	1
MK3000-08BAC		1	218	4
		1	218G	2
MK4001-4BAC		5	55	2
MS16562-252		1	117	1
MS16562-37		1	139T	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	959H	1
MS21042L3		1	774B	1
		1	810B	1
		1	969B	2
MS21042L4		1	156B	1
		1	198B	1
		1	243B	1
		1	267B	1
		1	285B	1
		1	306B	1
		1	330B	1
		1	357B	1
		1	405B	1
MS21042L4		1	417B	1
		1	543B	2
		1	570B	1
		1	597B	1
		1	621B	1
		1	642B	1
		1	690B	1
		1	702B	1
		1	747B	2
		1	774C	2
		1	795B	3
MS21042L5		1	171B	1
		1	176G	1
MS21042L6		1	27B	1
		1	231B	1
MS21209F4-15P		1	546	2
MS24665-134		1	471	1
MS24665-376		1	665H	1
MS28775-127		1	912	1
MS51023-122		1	528A	2
NAS1149C0432R		1	131	3
NAS1329H4K200L		1	472A	3
NAS1330H4K211L		1	472	3
NAS1351-4-76P		1	372	1
NAS1351-5-24P		1	165	1
		1	176C	1
NAS1351C4-24P		1	138U	1
NAS1394C4L		2	5A	1
		4	35	2
		5	75	4
NAS1399MW4-5		2	25	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NAS1801-4-16		1	130A	3
NAS1805-3		1	828	1
NAS1805-4N		1	138	1
NAS1805-6		1	15	1
NAS42DD4-24		3	25	2
NAS42DD4-24FC		1	495B	2
NAS42E4-24		1	495A	2
NAS428-4-10		1	696	1
NAS428-4-12		1	951A	1
NAS428-4-7		1	954A	1
NAS43HT4-4		1	139A	1
		1	375	1
		1	519	1
NAS509-4C		1	864	1
NAS513-4		1	867B	1
NAS513-5		1	867A	1
NAS577-4A		4	20	4
NAS578-4		4	25	4
NAS604-24P		1	516B	1
NAS604-32P		1	516C	1
NAS6604-17		1	102	2
NAS6604-50		1	537A	2
NAS72-4E005		1	483	2
NNS57N003		1	139V	1
NS103197-82		5	25	1
NS103199-82		1	218	4
		1	218G	2
NS103200SE048		5	55	2
NS103202SE048		1	501	1
NS202101-02		1	969	2
PN3A		1	140E	1
PN3ALT		1	140E	1
RMA9205M82		1	218	4
		1	218G	2
RMLH9075-3W		1	969	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
SAT1624A1501		1	468	2
SLR4027-4		1	393	1
		1	444	1
SLR4027-5		2	40	1
SLR4027-6		1	63	2
SL414-4		1	139B	1
		1	390	1
		1	441	1
SL414-5		2	35A	1
SL414-6		1	60	2
TLN1020-4N		1	114	2
TLN1020L4W		1	111	2
TN11251212ALCAS		5	120	2
TN12501212ALCAS		5	115	1
TN21881214ALCAS		5	125	1
T339E		1	720	2
T340E		1	753	1
		3	15	2
T342E		1	161	2
		4	40	2
T6S1032J		1	969	2
T8076S832		5	25	1
T8078S832		1	218	4
		1	218G	2
T8083C428		5	55	2
T8089C428		1	501	1
VN102D1-048		1	501	1
VN202A1-82		5	25	1
VN203A1-82		1	218	4
		1	218G	2
VN204D1-048		5	55	2
VN303A02		1	969	2
109A9201-4		1	501	1
109A9209M4		5	55	2
141N6271-19		1	223A	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T6103-1		1	831U	1
		1	833	1
141T6133-51		1	984A	1
		5	1A	RF
141T6133-52		1	987A	1
		5	5A	RF
141T6133-55		1	984B	1
		5	1B	RF
141T6133-56		1	987B	1
		5	5B	RF
141T6133-61		1	984	1
		5	1	RF
141T6133-62		1	987	1
		5	5	RF
141T6133-65		5	130A	1
141T6133-66		5	135A	1
141T6133-69		5	130B	1
141T6133-70		5	135B	1
141T6133-73		5	130	1
141T6133-74		5	135	1
141T6133-81		1	984C	1
		5	1C	RF
141T6133-82		1	987C	1
		5	5C	RF
141T6133-83		1	984D	1
		5	1D	RF
141T6133-84		1	987D	1
		5	5D	RF
141T6133-89		5	130C	1
141T6133-90		5	135C	1
141T6133-91		5	130D	1
141T6133-92		5	135D	1
141T6159-13		1	945	1
		4	5	RF

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T6159-14		1	948	1
		4	1	RF
141T6159-17		4	60	1
141T6159-18		4	55	1
141T6159-7		4	50	1
141T6160-1		1	141	1
141T6160-2		1	147	1
141T6160-3		1	140U	1
		1	144	1
141T6160-5		1	140S	1
141T6188-11		1	756	1
141T6188-12		1	759	1
141T6188-13		1	759A	1
141T6188-14		1	759B	1
141T6188-3		1	726	1
141T6188-4		1	729	1
141T6188-5		1	729A	1
141T6188-6		1	729B	1
141T6193-1		1	420	1
141T6193-3		1	429	1
141T6194-1		1	309	1
141T6194-2		1	318	1
141T6195-1		1	645	1
141T6195-2		1	648	1
141T6195-3		1	657	2
141T6196-2		1	39	1
141T6196-3		1	30	1
141T6196-4		1	39A	1
141T6196-5		1	30A	1
141T6197-1		1	57	1
141T6197-2		1	72	1
141T6198-1		1	456	1
141T6199-2		1	723A	1
141T6200-1		1	660	1
141T6200-2		1	663	1
141T6201-3		1	705	1
141T6201-4		1	708	1
141T6201-5		1	711	1
141T6202-1		1	75	1
141T6202-2		1	78	1
141T6202-3		1	93	1
141T6202-4		1	96	1
141T6203-1		1	180	3
141T6203-2		1	183	1
141T6203-3		1	714	21

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
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
141T6206-1		5	35	1
141T6206-2		5	70	1
141T6206-3		5	35A	1
141T6206-4		5	70A	1
141T6206-5		5	65	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
		1	160A	1
141T6215-2		1	159A	1
		1	160	1
141T6215-3		1	159B	1
		1	160B	1
141T6215-4		1	157	1
		1	158	1
141T6219-1		1	861	1
141T6220-1		1	408	1
141T6220-3		1	408A	1
141T6221-1		1	174	1
		2	1	RF

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T6221-2		2	50	1
141T6221-3		1	175	1
		2	1A	RF
141T6221-4		2	50A	1
141T6222-1		1	129	1
141T6223-1		1	162	1
141T6223-2		1	176	1
141T6223-3		1	176J	1
141T6224-1		2	45	1
141T6224-3		2	30	1
141T6225-1		1	177	1
141T6226-1		1	855	1
141T6227-1		1	99	1
141T6227-2		1	126	1
141T6228-1		1	924	1
141T6228-2		1	927	1
141T6228-3		1	936	1
141T6228-4		1	939	1
141T6228-5		1	927C	1
141T6228-6		1	927D	1
141T6228-7		1	939A	1
141T6228-8		1	939B	1
141T6229-1		1	906	1
141T6231-1		1	849	1
141T6231-2		1	477A	1
141T6232-1		1	852	1
141T6248-3		1	387A	1
141T6248-4		1	396A	1
141T6248-5		1	387B	1
141T6248-6		1	396B	1
141T6249-1		1	378	1
141T6249-3		1	384	1
141T6249-4		1	381	2
141T6249-6		1	378B	1
141T6251-1		1	66	1

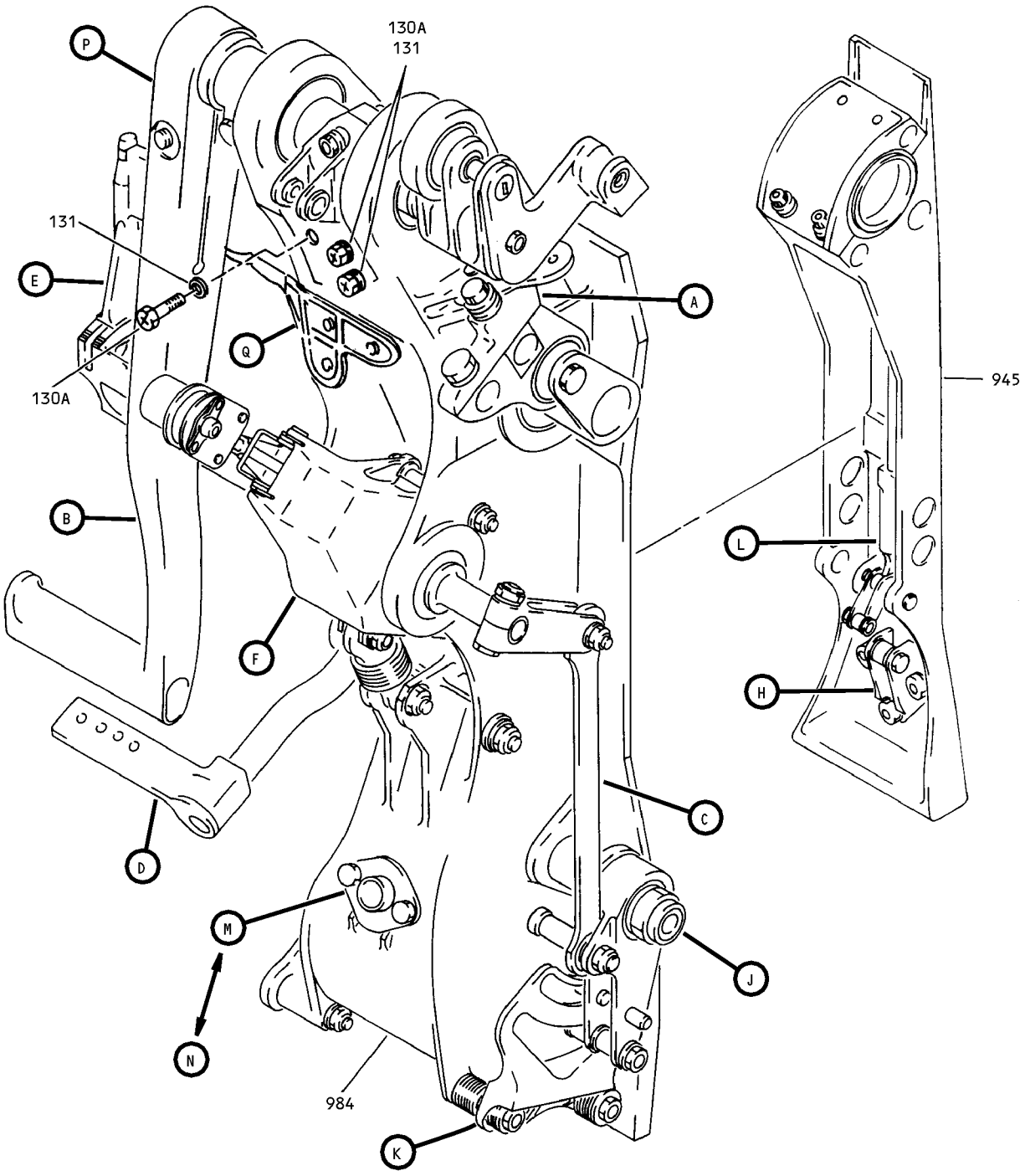
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T6258-3		1	585	1
141T6271-1		1	201	1
141T6271-11		1	205	1
141T6271-12		1	206	1
141T6271-13		1	223	1
141T6271-14		1	224	1
141T6271-17		1	205A	1
141T6271-18		1	206A	1
141T6271-2		1	204	1
141T6271-20		1	224A	1
141T6271-25		1	201A	1
141T6271-26		1	204A	1
141T6271-27		1	219A	1
141T6271-28		1	222A	1
141T6271-3		1	219	1
141T6271-31		1	201B	1
141T6271-32		1	204B	1
141T6271-33		1	205B	1
141T6271-34		1	206B	1
141T6271-4		1	222	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	832	1
		1	834	1
141T6280-2		1	832L	1
		1	837	1
141T6280-3		1	832M	1
		1	837B	1
141T6282-1		1	894	1
141T6284-1		1	801	1
141T6286-1		1	798	1
141T6286-2		1	897	1
141T6287-1		1	831	2
141T6287-10		1	876	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T6287-14		1	783	2
		1	819	1
		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
141T6521-3		1	213	1
141T6521-6		1	750	1
141T6538-10		1	525H	1
141T6538-7		1	525B	1
141T6538-8		1	525C	1
141T6649-1		1	531	1
141T6649-2		1	534	1
141T6649-3		1	549	1
141T6649-4		1	552	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
141T6652-1		1	438	1
141T6652-10		1	439A	1
141T6652-4		1	453A	1
141T6652-9		1	453B	1
141T6653-10		1	552C	1
141T6653-7		1	535A	1
141T6653-8		1	536A	1
141T6653-9		1	552D	1
141T6661-1		1	960A	1
141T6662-1		1	962	1
141T6662-2		1	962A	1
141T6663-1		1	961	1
143T6150-1		1	139P	1
143T6150-2		1	139Q	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
143T6151-1		1	140Q	1
143T6151-3		1	140R	1
143T6152-1		1	139U	1
143T6152-2		1	140N	1
143T6154-5		1	140A	1
143T6154-6		1	140H	1
143T6155-1		1	138M	1
143T6155-2		1	139F	1
143T6155-4		1	139H	1
143T6155-5		1	138N	1
143T6155-6		1	139K	1
143T6155-7		1	139M	1
143T6156-11		1	469A	1
143T6156-12		1	469C	1
143T6156-13		1	469F	1
143T6156-14		1	469D	1
143T6156-17		1	469G	1
143T6156-18		1	469E	1
143T6156-7		1	469	1
143T6156-8		1	469B	1
143T6157-1		1	161N	1
146T6140-11		1	1A	RF
146T6140-12		1	3A	RF
146T6140-17		1	1B	RF
146T6140-18		1	3B	RF
146T6140-37		1	1D	RF
146T6140-38		1	3D	RF
146T6140-41		1	1E	RF
146T6140-42		1	3E	RF
146T6140-45		1	1F	RF
146T6140-46		1	3F	RF
146T6140-49		1	1G	RF
146T6140-50		1	3G	RF
146T6140-51		1	1H	RF
146T6140-52		1	3H	RF

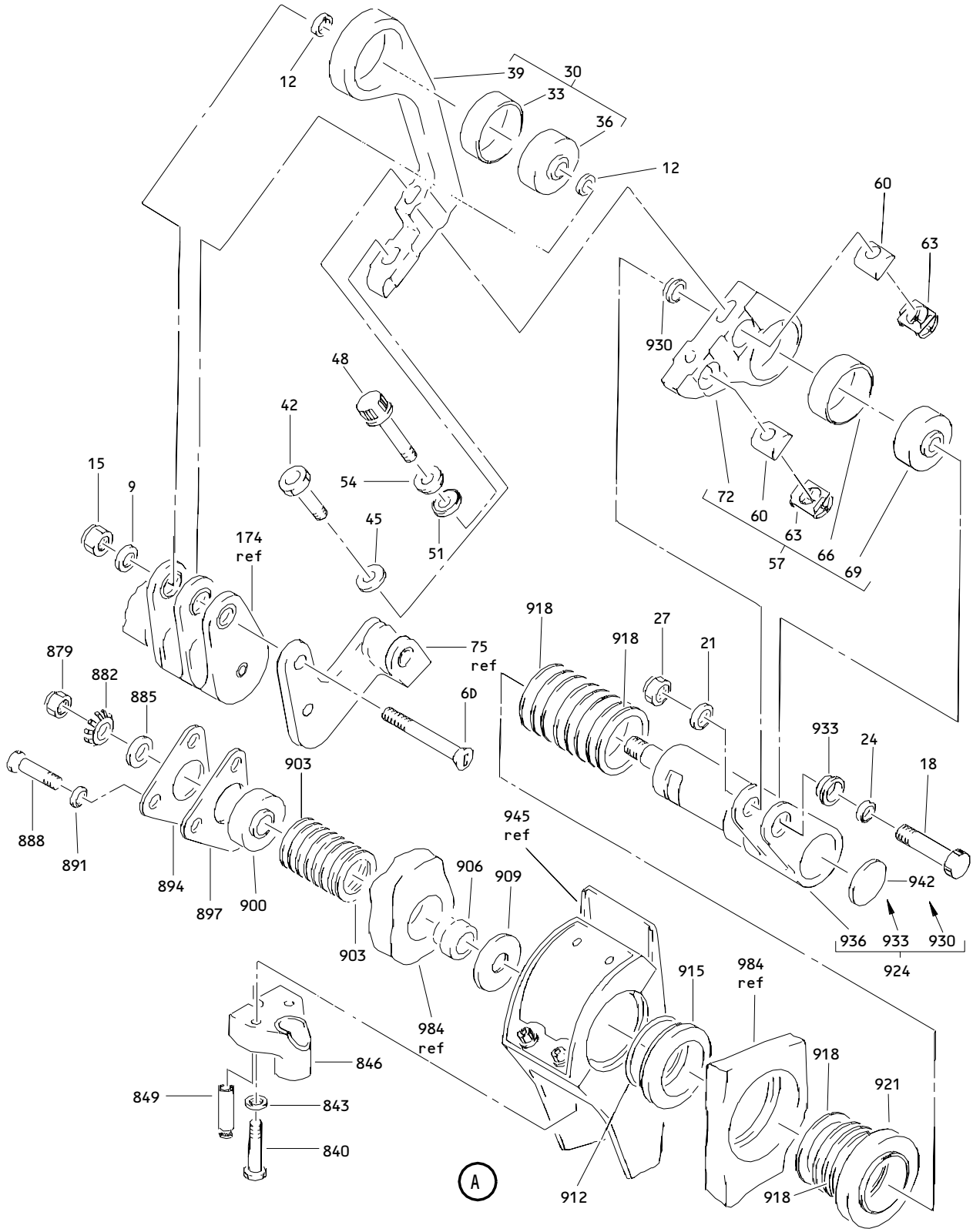
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
146T6140-53		1	1J	RF
146T6140-54		1	3J	RF
146T6140-57		1	1K	RF
146T6140-58		1	3K	RF
146T6140-63		1	831G	1
146T6140-64		1	831N	1
146T6140-7		1	1	RF
146T6140-8		1	3	RF
2452-048RET		1	393	1
		1	444	1
2452-054RET		2	40	1
2452-064RET		1	63	2
295927-50		1	504	1
4AFS428		1	252	2
		1	294	2
		1	363	1
		1	579	1
		1	606	1
52LH6073-048		1	114	2
53488W428		1	111	2
6073-04		1	111	2
66014-5		5	45	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

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
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
70188-104U		1	108	2
70189-6S		1	51	1
70191-104U		1	105	2
922005-6		1	54	1
922006-6		1	51	1
922009-4		1	108	2
922010-4		1	105	2
942005-6		1	54	1
942006-6		1	51	1
942009-4		1	108	2
942010-4		1	105	2
94263-428		1	139B	1
		1	390	1
		1	441	1
94263-524		2	35A	1
94263-624		1	60	2
96-02		1	969	2



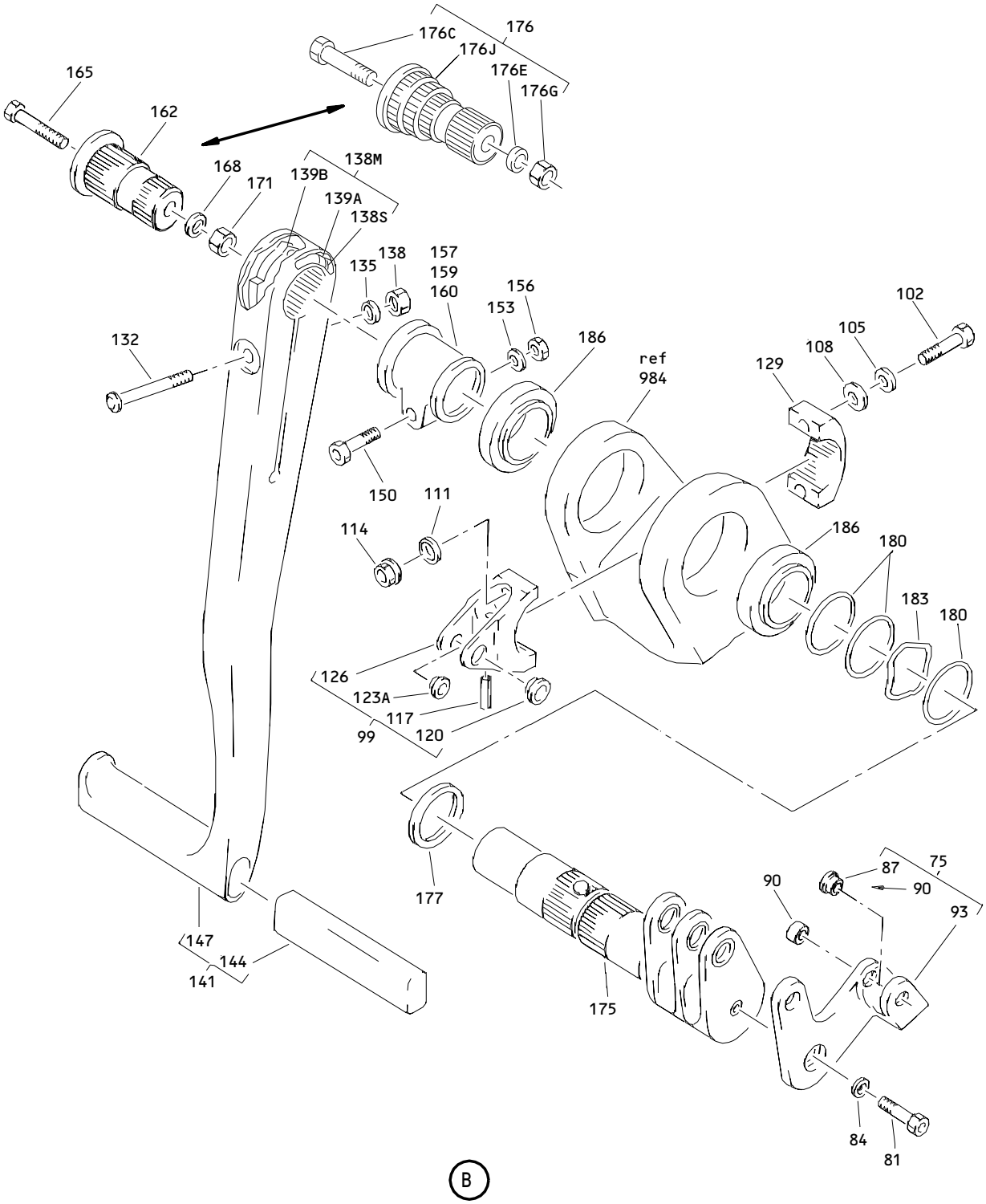
Aft Entry/Service Door Handle Mechanism Assembly
Figure 1 (Sheet 1)

T65138

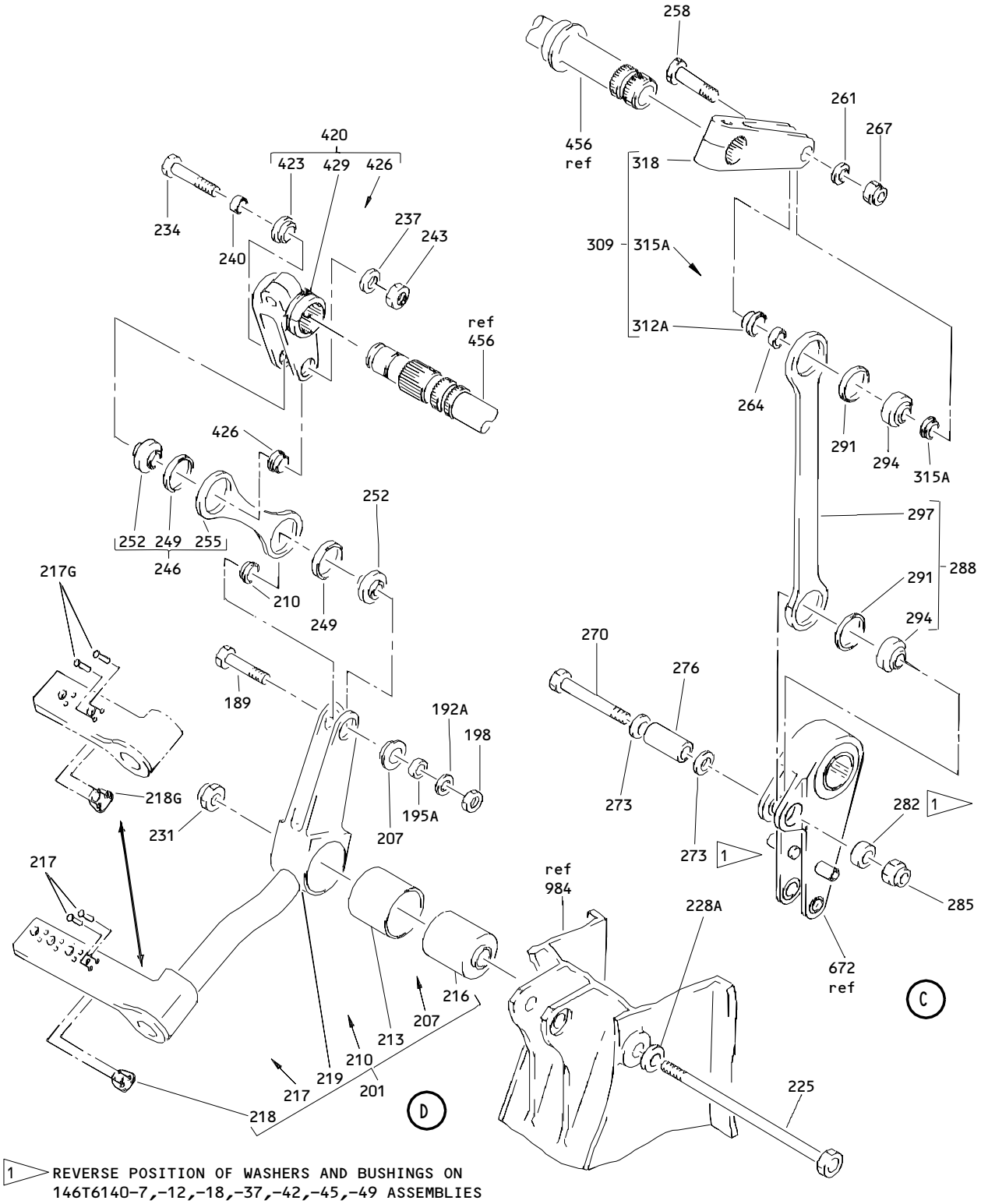


Aft Entry/Service Door Handle Mechanism Assembly
Figure 1 (Sheet 2)

T65139



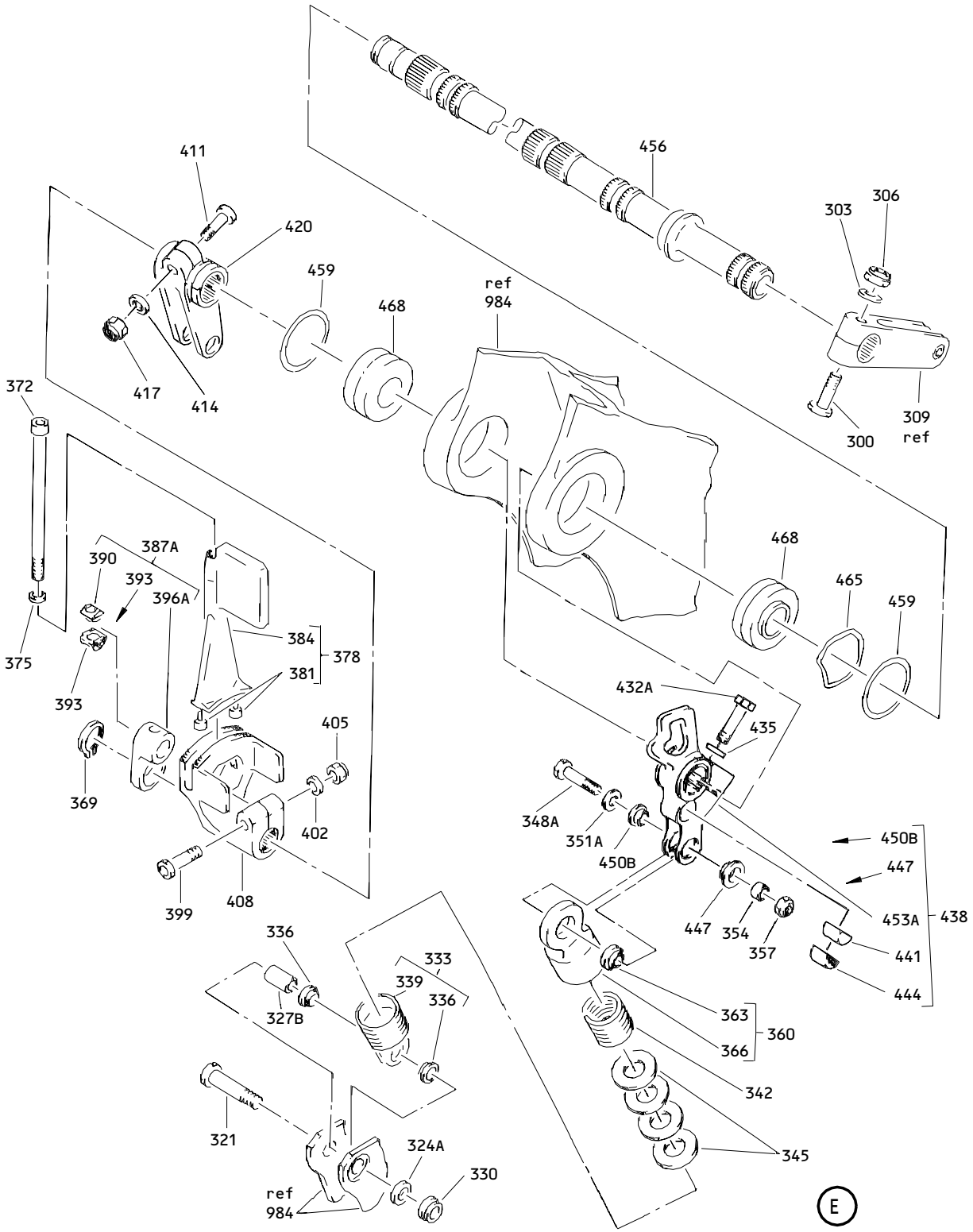
Aft Entry/Service Door Handle Mechanism Assembly
Figure 1 (Sheet 3)



1 REVERSE POSITION OF WASHERS AND BUSHINGS ON 146T6140-7,-12,-18,-37,-42,-45,-49 ASSEMBLIES

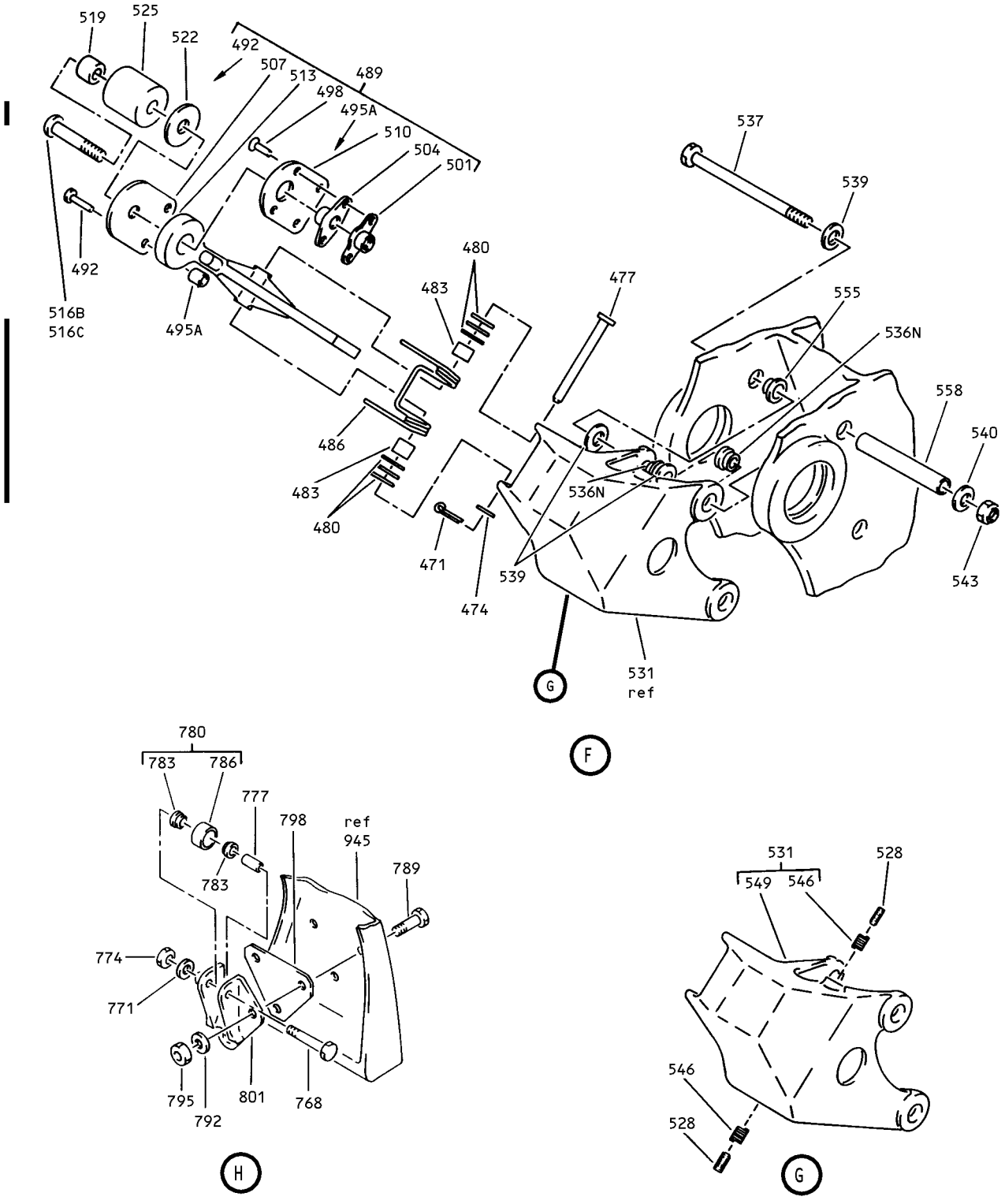
Aft Entry/Service Door Handle Mechanism Assembly
Figure 1 (Sheet 4)

T65141



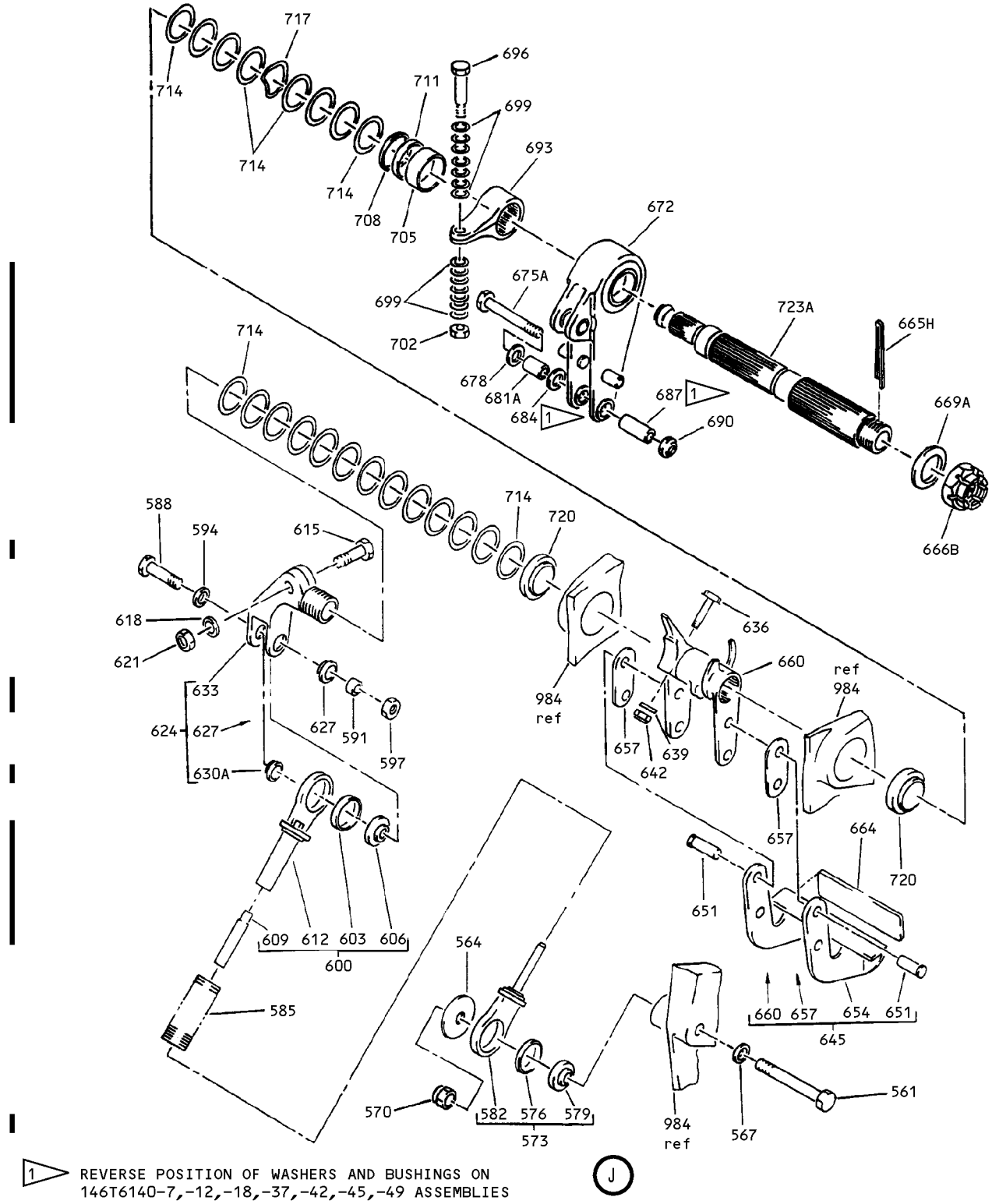
Aft Entry/Service Door Handle Mechanism Assembly
Figure 1 (Sheet 5)

T65142



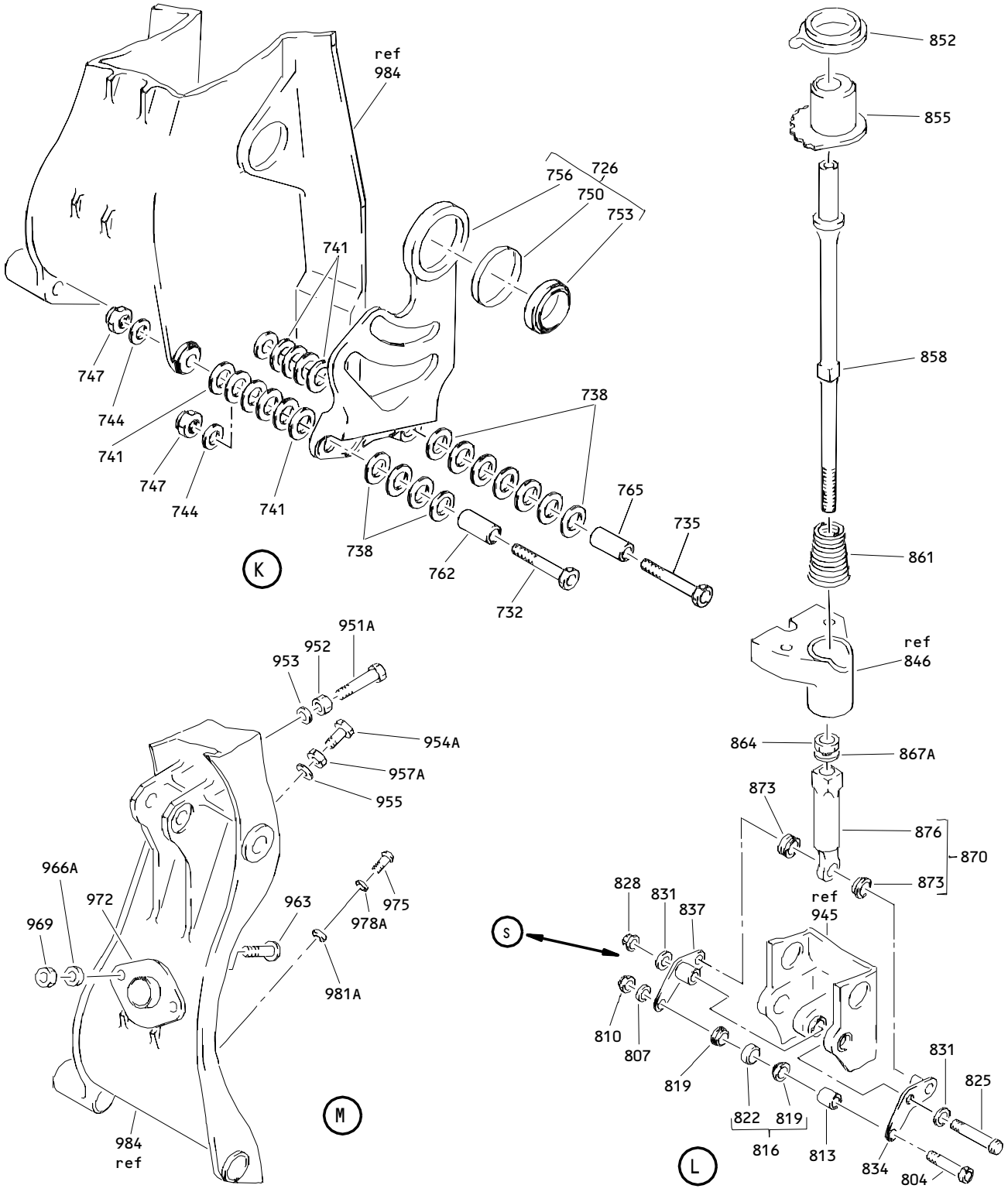
Aft Entry/Service Door Handle Mechanism Assembly
Figure 1 (Sheet 6)

T65143



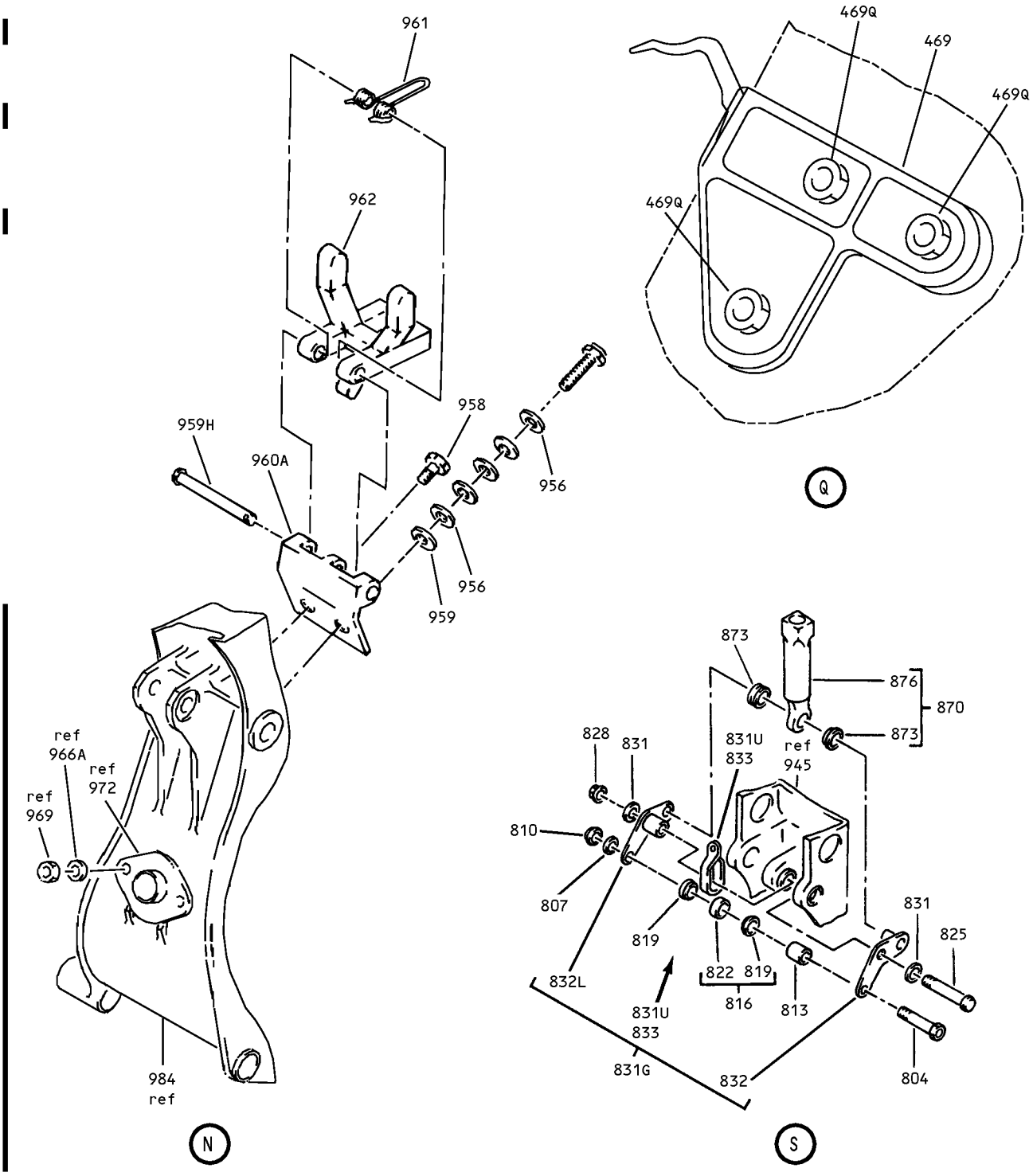
Aft Entry/Service Door Handle Mechanism Assembly
Figure 1 (Sheet 7)

T65144



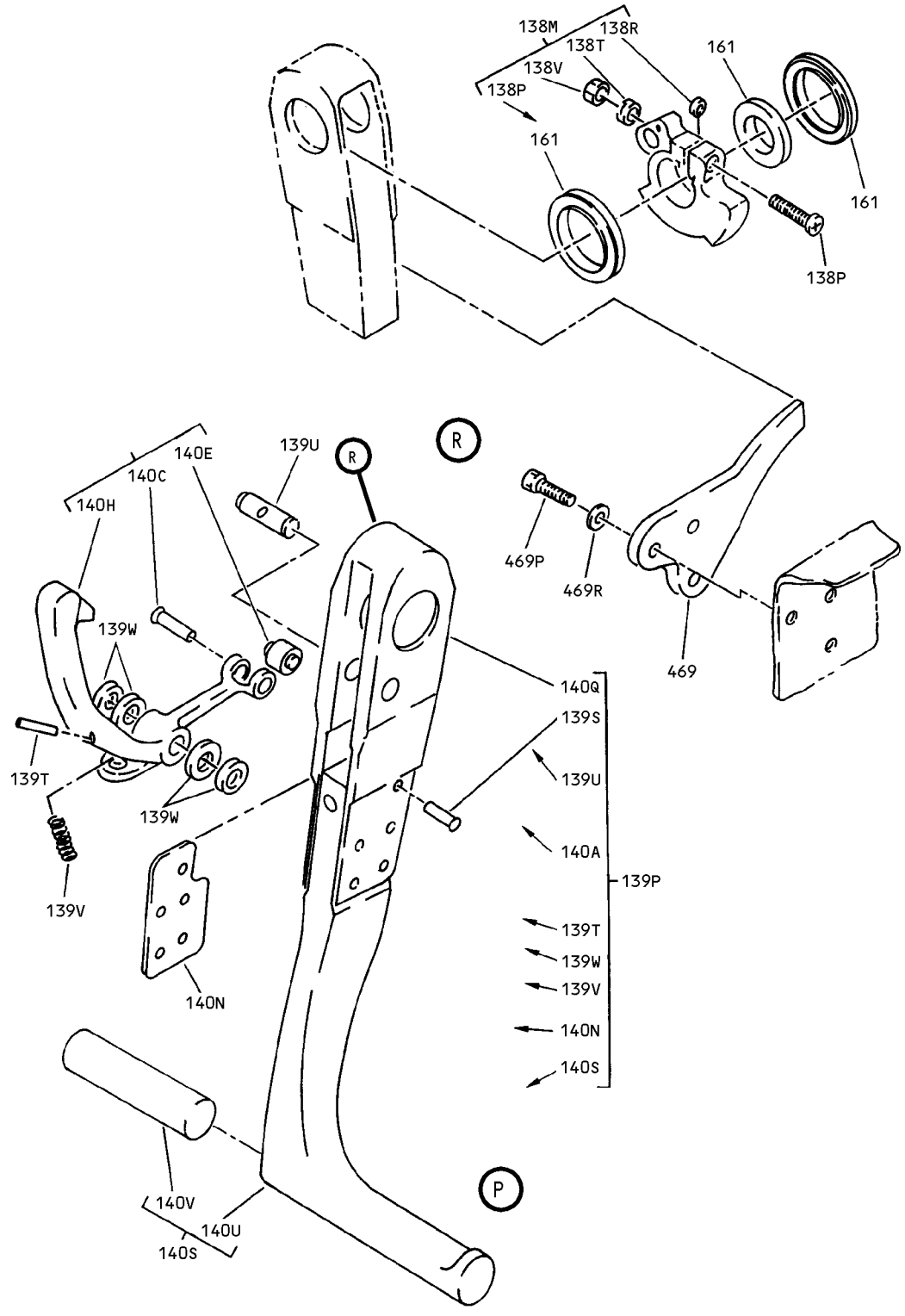
Aft Entry/Service Door Handle Mechanism Assembly
Figure 1 (Sheet 8)

T65145



Aft Entry/Service Door Handle Mechanism Assembly
Figure 1 (Sheet 9)

U11355



Aft Entry/Service Door Handle Mechanism Assembly
Figure 1 (Sheet 10)

967741

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-1	146T6140-7		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (LH) (PRE SB 767-52-0058)	A	RF
R	-1A	146T6140-11		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (LH) (PRE SB 767-52-0058)	B	RF
R	-1B	146T6140-17		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (LH) (PRE SB 767-52-0058)	C	RF
	-1C	146T6140-33		DELETED		
R	-1D	146T6140-37		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (LH) (PRE SB 767-52-0058)	G	RF
	-1E	146T6140-41		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (LH) (POST SB 767-52-0058)	J	RF
	-1F	146T6140-45		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (LH) (POST SB 767-52-0058)	L	RF
	-1G	146T6140-49		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (LH)	N	RF
R	-1H	146T6140-51		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (LH)	Q	RF
R	-1J	146T6140-53		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (LH)	R	RF
R	-1K	146T6140-57		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (LH)	U	RF
R	-3	146T6140-8		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (RH) (PRE SB 767-52-0058)	D	RF
R	-3A	146T6140-12		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (RH) (PRE SB 767-52-0058)	E	RF
R	-3B	146T6140-18		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (RH) (PRE SB 767-52-0058)	F	RF
	-3C	146T6140-34		DELETED		
R	-3D	146T6140-38		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (RH) (PRE SB 767-52-0058)	H	RF
	-3E	146T6140-42		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (RH) (POST SB 767-52-0058)	K	RF

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-3F	146T6140-46		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (RH) (POST SB 767-52-0058)	M	RF
	-3G	146T6140-50		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (RH)	P	RF
R	-3H	146T6140-52		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (RH)	S	RF
R	-3J	146T6140-54		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (RH)	T	RF
R	-3K	146T6140-58		MECHANISM ASSY-AFT ENTRY AND SVCE DOOR HANDLE (RH)	V	RF
	6	BACB30RF6P33		DELETED		
	-6A	BACB30RF6P33		DELETED		
	-6B	BACB30LL6-33		DELETED		
	-6C	BACB30LL6-33		DELETED		
	6D	BACB30RF6P34		.BOLT	B,E	1
	-6E	BACB30RF6P34		.BOLT-*(3) (LIMITED)	A,C,D ,F-H	1
	-6F	BACB30LL6-34		.BOLT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-6G	BACB30LL6-34		.BOLT	J-V	1
R	9	AN960-616		.WASHER		1
R	12	BACB28AK06-021		.BUSHING		2
R	15	NAS1805-6		.NUT		1
R	18	BACB30NJ6K18		.BOLT	B,E	1
	-18A	BACB30NJ6K18		.BOLT-*(3) (LIMITED)	A,C,D ,F-H	1
	-18B	BACB30LT6-18		.BOLT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-18C	BACB30LT6-18		.BOLT	J-V	1
R	21	AN960-616		.WASHER		1
R	24	BACB28AK06-028		.BUSHING		1
R	27	BACN10JC6		.NUT	B,E	1
	-27A	BACN10JC6		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1
	-27B	MS21042L6		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-27C	MS21042L6		.NUT	J-V	1
R	30	141T6196-3		.LUG ASSY- (OPT ITEM 30A)	A-P	1
R	-30A	141T6196-5		.LUG ASSY- (OPT ITEM 30)	A-P	1
R	-30B	141T6196-3		.LUG ASSY	Q-V	1
	33	141T6521-1		..RING-SWAGE		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	36	ASR6-30		..BEARING- (VS0352) (SPEC BACB10CK6)		1
	39	141T6196-2		..LUG- (USED ON ITEMS 30, 30B)		1
	-39A	141T6196-4		..LUG- (USED ON ITEM 30A)	A-P	1
R	42	BACB30NM6K12		.BOLT		1
R	45	AN960-616		.WASHER		1
R	48	BACB30MT6K25		.BOLT	B,E	1
	-48A	BACB30MT6K25		.BOLT-*(3) (LIMITED)	A,C,D ,F-H	1
	-48B	BACB30LE6U25		.BOLT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-48C	BACB30LE6U25		.BOLT	J-V	1
R	51	K29913-6S		.WASHER- (V15653) (SPEC BACW10CA6CCS) (OPT 70189-6S (V56878)) (OPT 922006-6 (V60119)) (OPT 942006-6 (V60119))		1
R	54	K29646-6S		.WASHER- (V15653) (SPEC BACW10CA6CVS) (OPT 70186-6S (V56878)) (OPT 922005-6 (V60119)) (OPT 942005-6 (V60119))		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	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	141T6251-1		..RING-SWAGE		1
R	69	ASR6-30		..BEARING- (VSO352) (SPEC BACB10CK6)		1
	72	141T6197-2		..LUG		1
R	75	141T6202-1		.ADAPTER ASSY	B,C,D,H,J,M,P,Q,T,V	1
R	-78	141T6202-2		.ADAPTER ASSY	A,E,F,G,K,L,N,R,S,U	1
				ATTACHING PARTS		
R	81	BACB30NF4-1		.BOLT		1
R	84	BACW10P115S		.WASHER		1
				-------*-------		
R	87	BACB28X4E015		..BUSHING		1
R	90	BACB28Y6E036		..BUSHING		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	93	141T6202-3		..ADAPTER	B,C,D ,H,J, M,P,Q ,T,V	1
R	-96	141T6202-4		..ADAPTER	A,E,F ,G,K, L,N,R ,S,U	1
R	99	141T6227-1		.LEVER ASSY		1
				ATTACHING PARTS		
R	102	NAS6604-17		.BOLT		2
R	105	K29913-104NF		.WASHER- (V15653) (SPEC BACW10CA104CCU) (OPT 70191-104U (V56878)) (OPT 922010-4 (V60119)) (OPT 942010-4 (V60119))		2
R	108	K29646-104NF		.WASHER- (V15653) (SPEC BACW10CA104CVU) (OPT 70188-104U (V56878)) (OPT 922009-4 (V60119)) (OPT 942009-4 (V60119))		2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	111	AS46-4		.WASHER- (V10630) (SPEC BACW10AU4) (OPT K19701P4 (V15653)) (OPT 53488W428 (V56878)) (OPT 6073-04 (V72962)) (OPT TLN1020L4W (V08524))		2
R	114	H19700P4		.NUT- (V15653) (SPEC BACN10MT4) (OPT TLN1020-4N (V08524)) (OPT 52LH6073-048 (V72962)) (OPT 53488-428 (V56878)) -------*-------		2
R	117	MS16562-252		..PIN-SPR		1
R	120	BACB28X6M010		..BUSHING		1
	123	BACB28X4C014		DELETED		
R	123A	BACB28X4C010		..BUSHING		1
R	126	141T6227-2		..LEVER		1
R	129	141T6222-1		.CAP		1
	130	NAS1801-4-5		DELETED		
R	130A	NAS1801-4-16		.BOLT	N,P	3
R	131	NAS1149C0432R		.WASHER	N,P	3

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	132	HL1012AZ8-28		.BOLT- (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))	A-H,N,P	1
R	135	AN960-416L		.WASHER	A-H,N,P	1
R	138	NAS1805-4N		.NUT	A-H,N,P	1
R	138M	143T6155-1		.CLUTCH ASSY-*(7)	J-M	1
R	-138N	143T6155-5		.CLUTCH ASSY-*(7)	Q-V	1
	138P	NAS1352C4-24P		DELETED		
	-138Q	NAS1352N4-24P		DELETED		
	138R	NAS43HT4-4		DELETED		
R	138S	NAS1351N4-24P		..SCREW- (OPT ITEM 138U)	J-M, Q-V	1
	138T	SLR4027-4		DELETED		
R	-138U	NAS1351C4-24P		..SCREW- (OPT ITEM 138S)	J-M, Q-V	1
	138V	LH8065-048		DELETED		
	-138W	143T6155-2		DELETED		
	-138X	143T6155-4		DELETED		
	-138Y	143T6155-6		DELETED		

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-138Z	143T6155-7		DELETED		
	139	143T6150-1		DELETED		
R	139A	NAS43HT4-4		..SPACER	J-M, Q-V	1
R	139B	LH8065-048		..NUT- (V72962) (SPEC BACN10HC4) (OPT SL414-4 (V97393)) (OPT 94263-428 (V56878))	J-M, Q-V	1
	-139C	143T6150-2		DELETED		
	139D	BACR15BA5D		DELETED		
	139E	MS16562-37		DELETED		
R	-139F	143T6155-2		..CLUTCH- (OPT ITEM 139H)	J-M	1
	139G	143T6152-1		DELETED		
R	-139H	143T6155-4		..FITTING- (OPT ITEM 139F)	J-M	1
	139J	NNS57N003		DELETED		
R	-139K	143T6155-6		..CLUTCH-*(7) (OPT ITEM 139M)	Q-V	1
	139L	BACW10P274G		DELETED		
R	-139M	143T6155-7		..CLUTCH-*(7) (OPT ITEM 139K)	Q-V	1
R	139P	143T6150-1		.HANDLE ASSY	K,L,S,T,U	1
R	-139Q	143T6150-2		.HANDLE ASSY	J,M,Q,R,V	1
R	139S	BACR15BA5D		..RIVET- (SIZE DETERMINE ON INST)	J-M, Q-V	5
R	139T	MS16562-37		..PIN-SPR	J-M, Q-V	1
R	139U	143T6152-1		..PIN	J-M, Q-V	1
R	139V	NNS57N003		..SPRING- (V01226)	J-M, Q-V	1
R	139W	BACW10P274G		..WASHER	J-M, Q-V	4
	140	143T6154-1		DELETED		
R	140A	143T6154-5		..PAWL ASSY	J-M, Q-V	1
R	140C	BACR15GA6		...RIVET- (SIZE DETERMINE ON INST)	J-M, Q-V	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	140E	PN3A		...BEARING- (V60380) (SPEC BACB10B79LT) (OPT PN3ALT (V60380))	J-M, Q-V	1
	140G	143T6154-2		DELETED		
R	140H	143T6154-6		...PAWL	J-M, Q-V	1
R	140N	143T6152-2		..SHIM	J-M, Q-V	1
R	140Q	143T6151-1		..HOUSING- (OPT ITEM 140R)	J-M, Q-V	1
R	-140R	143T6151-3		..HOUSING- (OPT ITEM 140Q)	J-M, Q-V	1
R	140S	141T6160-5		..HANDLE ASSY	K,L,S ,T,U	1
R	-140T	141T6160-6		..HANDLE ASSY	J,M,Q ,R,V	1
R	140U	141T6160-3		...FILLER	J-M, Q-V	1
R	140V	141T6160-7		...HANDLE	K,L,S ,T,U	1
R	-140W	141T6160-8		...HANDLE	J,M,Q ,R,V	1
R	141	141T6160-1		.HANDLE ASSY	A-H,N ,P	1
	141C	141T6160-5		DELETED		
	-141D	141T6160-6		DELETED		
R	144	141T6160-3		..FILLER	A-H,N ,P	1
R	147	141T6160-2		..HANDLE	A-H,N ,P	1
	147C	141T6160-7		DELETED		
	-147E	141T6160-8		DELETED		
R	150	BACB30NM4K14		.BOLT		1
R	153	AN960-416		.WASHER		1
R	156	BACN10JC4		.NUT	B,E	1
	-156A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1
	-156B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-156C	MS21042L4		.NUT	J-V	1
	157	141T6215-4		.SPACER	J,Q	1
	-158	141T6215-4		.SPACER	K,S	1
R	159	141T6215-1		.SPACER	A,G,N	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-159A	141T6215-2		.SPACER	E,F	1
	-159B	141T6215-3		.SPACER	L,R,U	1
R	160	141T6215-2		.SPACER	B,C	1
	-160A	141T6215-1		.SPACER	D,H,P	1
	-160B	141T6215-3		.SPACER	M,T,V	1
	161	B542DDFSS428		.BEARING- (V21335) (SPEC BACB10CF21PP) (OPT B542-2TS (V43991)) (OPT B542SSG27 (V30163)) (OPT T342E (VK8455)) (OPT B542DDFS101 (V06144)) (OPT B542DD (V38443)) (OPT B542FS101 (V06144))	J-M, Q-V	2
	161N	143T6157-1		.SPACER	J-M, Q-V	1
R	162	141T6223-1		.ADAPTER	A-H,N ,P	1
R	165	NAS1351-5-24P		.SCREW	A-H,N ,P	1
R	168	AN960-516		.WASHER	A-H,N ,P	1
R	171	BACN10JC5		.NUT	B,E	1
	-171A	BACN10JC5		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1
	-171B	MS21042L5		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
R	-171C	MS21042L5		.NUT	N,P	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	174	141T6221-1		.SHAFT ASSY- (FOR DETAILS SEE FIG. 2)	A,D,G,H,L-P,R,T-V	1
R	-175	141T6221-3		.SHAFT ASSY- (FOR DETAILS SEE FIG. 2)	B,C,E,F,J,K,Q,S	1
	176	141T6223-2		.ADAPTER ASSY	J-M,Q-V	1
	176C	NAS1351-5-24P		..SCREW	J-M,Q-V	1
	176E	AN960-516		..WASHER	J-M,Q-V	1
	176G	MS21042L5		..NUT	J-M,Q-V	1
	176J	141T6223-3		..ADAPTER	J-M,Q-V	1
R	177	141T6225-1		.WASHER		1
R	180	141T6203-1		.WASHER		3
R	183	141T6203-2		.SPRING		1
R	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

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	189	BACB30NR4K12		.BOLT		1
	192	AN960PD416		DELETED		
	192A	AN960KD416		.WASHER		1
	195	BACB28AK04-030		DELETED		
R	195A	BACB28AK04-027		.BUSHING		1
R	198	BACN10JC4		.NUT	B,E	1
	-198A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1
	-198B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-198C	MS21042L4		.NUT	J-V	1
R	201	141T6271-1		.LEVER ASSY- (OPT ITEMS 201A, 201B)	B,C,J	1
R	-201A	141T6271-25		.LEVER ASSY- (OPT ITEMS 201, 201B)	B,C,J	1
R	-201B	141T6271-31		.LEVER ASSY- (OPT ITEMS 201, 201A)	B,C,J	1
R	-201C	141T6271-31		.LEVER ASSY	Q	1
R	-204	141T6271-2		.LEVER ASSY- (OPT ITEMS 204A, 204B)	E,F,K	1
R	-204A	141T6271-26		.LEVER ASSY- (OPT ITEMS 204, 204B)	E,F,K	1
R	-204B	141T6271-32		.LEVER ASSY- (OPT ITEMS 204, 204A)	E,F,K	1
R	-204C	141T6271-32		.LEVER ASSY	S	1
R	-205	141T6271-11		.LEVER ASSY- (OPT ITEMS 205A, 205B)	A,G,L ,N	1
R	-205A	141T6271-17		.LEVER ASSY- (OPT ITEMS 205, 205B)	A,G,L ,N	1
R	-205B	141T6271-33		.LEVER ASSY- (OPT ITEMS 205, 205A)	A,G,L ,N	1
R	-205C	141T6271-33		.LEVER ASSY	R,U	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-206	141T6271-12		.LEVER ASSY- (OPT ITEMS 206A, 206B)	D,H,M ,P	1
R	-206A	141T6271-18		.LEVER ASSY- (OPT ITEMS 206, 206B)	D,H,M ,P	1
R	-206B	141T6271-34		.LEVER ASSY- (OPT ITEMS 206, 206A)	D,H,M ,P	1
R	-206C	141T6271-34		.LEVER ASSY	T,V	1
R	207	BACB28X6M012		..BUSHING		1
R	210	BACB28X4C015		..BUSHING		1
R	213	141T6521-3		..SLEEVE		1
R	216	GDW6SD610		..BEARING- (V83086) (SPEC BACB10CG6) (OPT GDW6TT (V43991)) (OPT DW6-1 (V38443)) (OPT GDW6FS428 (V21335))		1
	217	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	B,C,E ,F,J, K,Q,S	8
	217G	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	A,D,G ,H, L-P,R ,T-V	4

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-218	BRM300A08		..NUTPLATE- (V52828) (SPEC BACN10JP08C) (OPT MK3000-08BAC (V15653)) (OPT NS103199-82 (V80539)) (OPT RMA9205M82 (V72962)) (OPT T8078S832 (V11815)) (OPT VN203A1-82 (V92215))	B,C,E,F,J,K,Q,S	4
R	218G	BRM300A08		..NUTPLATE- (V52828) (SPEC BACN10JP08C) (OPT MK3000-08BAC (V15653)) (OPT NS103199-82 (V80539)) (OPT RMA9205M82 (V72962)) (OPT T8078S832 (V11815)) (OPT VN203A1-82 (V92215))	A,D,G,H,L-P,R,T-V	2
	219	141T6271-3		..LEVER- (USED ON ITEMS 201, 201B, 201C)	B,C,J,Q	1
	-219A	141T6271-27		..LEVER- (USED ON ITEM 201A)	B,C,J	1
	-222	141T6271-4		..LEVER- (USED ON ITEMS 204, 204B, 204C)	E,F,K,S	1
	-222A	141T6271-28		..LEVER- (USED ON ITEM 204A)	E,F,K	1
R	-223	141T6271-13		..LEVER- (USED ON ITEMS 205, 205B, 205C)	A,G,L,N,R,U	1
R	-223A	141N6271-19		..LEVER- (USED ON ITEM 205A)	A,G,L,N	1
R	-224	141T6271-14		..LEVER- (USED ON ITEMS 206, 206B, 206C)	D,H,M,P,T,V	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-224A	141T6271-20		..LEVER- (USED ON ITEM 206A)	D,H,M,P	1
R	225	BACB30NM6K70		.BOLT		1
	228	AN960PD616		DELETED		
	228A	AN960KD616		.WASHER		1
R	231	BACN10JC6		.NUT	B,E	1
	-231A	BACN10JC6		.NUT-*(3) (LIMITED)	A,C,D,F-H	1
	-231B	MS21042L6		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D,F-H	1
	-231C	MS21042L6		.NUT	J-V	1
R	234	BACB30NR4K11		.BOLT		1
R	237	AN960-416L		.WASHER		1
R	240	BACB28AK04-026		.BUSHING		1
R	243	BACN10JC4		.NUT	B,E	1
	-243A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D,F-H	1
	-243B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D,F-H	1
	-243C	MS21042L4		.NUT	J-V	1
R	246	141T6277-2		.LINK ASSY		1
	249	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 249A)		2
R	-249A	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 249)		2

	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
R	258	BACB30NR4K11		.BOLT		1
R	261	AN960-416L		.WASHER	A-K	1
	-261A	AN960-416		.WASHER	L-P	1
R	264	BACB28AK04-026		.BUSHING		1
R	267	BACN10JC4		.NUT	B,E	1
	-267A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1
	-267B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-267C	MS21042L4		.NUT	J-V	1
R	270	BACB30NR4K26		.BOLT		1
R	273	AN960-416L		.WASHER		2
R	276	BACB28Y4C089		.BUSHING		1
	279	AN960PD416L		DELETED		
R	282	BACB28AK04-027		.BUSHING		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	285	BACN10JC4		.NUT	B,E	1
	-285A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1
	-285B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-285C	MS21042L4		.NUT	J-V	1
R	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 .374IN) (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
	294	KSP4A		..BEARING- (V38443) (SPEC BACB10AC4A) (OPT HHKSP4A (V38443)) (OPT KSP4AE9440A (V21335)) (OPT KSP4AFS428 (V21335)) (OPT KSP4A2TS (V43991)) (OPT KSP4AG27 (V30163)) (OPT 4AFS428 (V21335))		2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	297	141T6277-3		..LINK		1
R	300	BACB30NM4K14		.BOLT		1
R	303	AN960-416L		.WASHER		1
R	306	BACN10JC4		.NUT	B,E	1
	-306A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1
	-306B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-306C	MS21042L4		.NUT	J-V	1
R	309	141T6194-1		.LEVER ASSY		1
	312	BACB28Y6M010		DELETED		
	312A	BACB28X6M010		..BUSHING		1
	315	BACB28X4C012		DELETED		
R	315A	BACB28X4C011		..BUSHING		1
R	318	141T6194-2		..LEVER		1
R	321	BACB30NR4K16		.BOLT		1
	324	AN960PD416		DELETED		
	324A	AN960KD416		.WASHER		1
	327	BACB28AK04-70		DELETED		
	327A	BACB28AK04-070		DELETED		
	327B	BACB28AK04-075		.BUSHING		1
R	330	BACN10JC4		.NUT	B,E	1
	-330A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1
	-330B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-330C	MS21042L4		.NUT	J-V	1
R	333	69B13067-7		.HOUSING ASSY		1
R	336	141T6287-15		..BUSHING		2
R	339	69B13067-6		..HOUSING		1
R	342	69B14846-2		.SPRING		1
R	345	BACW10P121C		.WASHER	A-Q,S	4

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-346	BACW10P121C		.WASHER	R,T-V	AR
	348	BACB30NR4K16		DELETED		
	348A	BACB30NR4K11		.BOLT		1
	351	AN960PD416		DELETED		
	351A	AN960KD416		.WASHER		1
R	354	BACB28AK04-026		.BUSHING		1
R	357	BACN10JC4		.NUT	B,E	1
	-357A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1
	-357B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-357C	MS21042L4		.NUT	J-V	1
R	360	69B13060-7		.PISTON ASSY		1
R	363	KSP4A		..BEARING- (V38443) (SPEC BACB10AC4A) (OPT HHKSP4A (V38443)) (OPT KSP4AE944OA (V21335)) (OPT KSP4AFS428 (V21335)) (OPT KSP4A2TS (V43991)) (OPT KSP4AG27 (V30163)) (OPT 4AFS428 (V21335))		1
R	366	69B13060-8		..PISTON		1
R	369	MS16624-1062		.RING		1
R	372	NAS1351-4-76P		.SCREW		1
R	375	NAS43HT4-4		.SPACER		1
R	378	141T6249-1		.HANDLE ASSY	A-F, J-M, Q-T	1
	-378A	141T6249-5		DELETED		
R	-378B	141T6249-6		.HANDLE ASSY	G,H,N ,P,U, V	1
R	381	141T6249-4		..PIN		2
R	384	141T6249-3		..HANDLE		1
	387	141T6248-1		DELETED		
R	387A	141T6248-3		.LEVER ASSY	B,E	1
	-387B	141T6248-5		.LEVER ASSY-*(1)*(2)*(4) *(5)*(6)(LIMITED)	A,C,D ,F-H	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-387C	141T6248-3		.LEVER ASSY-*(3) (LIMITED)	A,C,D ,F-H	1
	-387D	141T6248-5		.LEVER ASSY	J-V	1
R	390	LH8065-048		..NUT- (V72962) (SPEC BACN10HC4) (OPT SL414-4 (V97393)) (OPT 94263-428 (V56878)) (USED ON ITEMS 387A, 387C)	A-H	1
R	393	SLR4027-4		..RETAINER- (V97393) (SPEC BACR10V4) (OPT 2452-048RET (V72962)) (USED ON ITEMS 387A, 387C)	A-H	1
	396	141T6248-2		DELETED		
R	396A	141T6248-4		..LEVER- (USED ON ITEMS 387A, 387C)	A-H	1
	-396B	141T6248-6		..LEVER- (USED ON ITEMS 387B, 387D)	A,C,D ,F-V	1
R	399	BACB30NM4K14		.BOLT		1
R	402	AN960-416L		.WASHER		1
R	405	BACN10JC4		.NUT	B,E	1
	-405A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1
	-405B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-405C	MS21042L4		.NUT	J-V	1
R	408	141T6220-1		.ADAPTER	B,E	1
	-408A	141T6220-3		.ADAPTER-*(1)*(2)*(4)*(5) *(6)(LIMITED)	A,C,D ,F-H	1
	-408B	141T6220-1		.ADAPTER-*(3) (LIMITED)	A,C,D ,F-H	1
	-408C	141T6220-3		.ADAPTER	J-V	1
R	411	BACB30NM4K14		.BOLT		1
R	414	AN960-416L		.WASHER		1
R	417	BACN10JC4		.NUT	B,E	1
	-417A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-417B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-417C	MS21042L4		.NUT	J-V	1
R	420	141T6193-1		.LEVER ASSY		1
R	423	BACB28X6M010		..BUSHING		1
R	426	BACB28X4C012		..BUSHING		1
R	429	141T6193-3		..LEVER		1
	432	BACB30NM4K18		DELETED		
	432A	BACB30NM4K14		.BOLT		1
R	435	AN960-416L		.WASHER		1
R	438	141T6652-1		.SECTOR ASSY	B,C,E ,F,J, K,Q,S	1
	-439	141T6652-3		DELETED		
R	-439A	141T6652-10		.SECTOR ASSY	A,D,G ,H, L-P,R ,T-V	1
R	441	LH8065-048		..NUT- (V72962) (SPEC BACN10HC4) (OPT SL414-4 (V97393)) (OPT 94263-428 (V56878))		1
R	444	SLR4027-4		..RETAINER- (V97393) (SPEC BACR10V4) (OPT 2452-048RET (V72962))		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	447	BACB28X6M012		..BUSHING		1
	450	BACB20X4C012		DELETED		
	450A	BACB28X4C012		DELETED		
R	450B	BACB28X4C011		..BUSHING		1
	453	141T6652-5		DELETED		
R	453A	141T6652-4		..SECTOR	B,C,E,F,J,K,Q,S	1
R	-453B	141T6652-9		..SECTOR	A,D,G,H,L-P,R,T-V	1
R	456	141T6198-1		.SHAFT		1
R	459	141T6203-5		.WASHER		2
R	465	141T6203-6		.SPRING		1
R	468	SAT1624A1501		.BEARING- (V77896)		2
	469	143T6156-7		.CAM BRACKET- (OPT ITEM 469A)	J,Q	1
	-469A	143T6156-11		.CAM BRACKET- (OPT ITEM 469)	J,Q	1
	-469B	143T6156-8		.CAM BRACKET- (OPT ITEM 469C)	K,S	1
	-469C	143T6156-12		.CAM BRACKET- (OPT ITEM 469B)	K,S	1
	-469D	143T6156-14		.CAM BRACKET- (OPT ITEM 469E)	L,R,U	1
	-469E	143T6156-18		.CAM BRACKET- (OPT ITEM 469D)	L,R,U	1
	-469F	143T6156-13		.CAM BRACKET- (OPT ITEM 469G)	M,T,V	1
	-469G	143T6156-17		.CAM BRACKET- (OPT ITEM 469F)	M,T,V	1
				ATTACHING PARTS		
	469P	BACB30NM4K12		DELETED		
	469Q	BACB30NM4K6		.BOLT	J-M,Q-V	3
	469R	AN960C416L		.WASHER	J-M,Q-V	3
				-------*-------		

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	471	MS24665-134		.PIN-COTTER		1
R	-472	NAS1330H4K211L		.NUT-*(8) (LIMITED)	J-M	3
R	-472A	NAS1329H4K200L		.NUT-*(8) (LIMITED)	J-M	3
R	-473	BACS40U4N2		.SHIM-*(8) (LIMITED)	J-M	AR
R	474	AN960-416L		.WASHER		1
R	477	BACP18T4K72		.PIN-FLATHEAD (OPT ITEM 477A)	A-P	1
R	-477A	141T6231-2		.PIN- (OPT ITEM 477)	A-P	1
R	-477B	BACP18T4K72		.PIN-FLATHEAD	Q-V	1
R	480	BACW10P321S		.WASHER		AR
R	483	NAS72-4E005		.SPACER		2
R	486	141T6650-1		.SPRING		1
R	489	141T6651-1		.LEVER ASSY		1
R	492	BACR15BB4B		..RIVET- (SIZE DETERMINE ON INST)		2
	495	NAS42D4-24		DELETED		
R	495A	NAS42E4-24		..SPACER- (OPT ITEM 495B)		2
R	-495B	NAS42DD4-24FC		..SPACER- (OPT ITEM 495A)		2
R	498	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		2
R	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

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	504	295927-50		..SPACER- (V60119) (SPEC BACS18G50B)		1
R	507	141T6651-4		..PLATE		1
R	510	141T6651-5		..PLATE		1
R	513	141T6651-2		..LEVER		1
	516	NAS1351C4-24P		DELETED		
	-516A	141T6231-3		DELETED		
R	516B	NAS604-24P		.SCREW	A,D,G,H,L-P,R,T-V	1
R	516C	NAS604-32P		.SCREW	B,C,E,F,J,K,Q,S	1
R	519	NAS43HT4-4		.SPACER		1
R	522	BACW10P129AM		.WASHER		AR
	525	141T6538-5		DELETED		
	-525A	141T6538-6		DELETED		
R	525B	141T6538-7		.BUTTON	A,D,L,M,R,T	1
R	-525C	141T6538-8		.BUTTON	B,C,E,F,J,K,Q,S	1
	-525G	141T6538-9		DELETED		
R	-525H	141T6538-10		.BUTTON	G,H,N,P,U,V	1
R	528	MS18066-69		.SETSCREW- (OPT ITEM 528A)		2
R	-528A	MS51023-122		.SETSCREW- (OPT ITEM 528)		2
	-528B	MS18066-69		DELETED		

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	531	141T6649-1		.SUPPORT ASSY	B,C,J,Q	1
R	-534	141T6649-2		.SUPPORT ASSY	E,F,K,S	1
	-535	141T6653-1		DELETED		
R	-535A	141T6653-7		.SUPPORT ASSY	D,H,M,P,T,V	1
	-536	141T6653-2		DELETED		
R	-536A	141T6653-8		.SUPPORT ASSY	A,G,L,N,R,U	1
	536N	BACB28X4C024		.BUSHING	A,D,G,H,L-P,R,T-V	2
				ATTACHING PARTS		
R	537	BACB30NM4K50		.BOLT- (OPT ITEM 537A)	A-P	2
R	-537A	NAS6604-50		.BOLT- (OPT ITEM 537)	A-P	2
				-------*-------		
R	-537B	BACB30NM4K50		.BOLT	Q-V	2
				ATTACHING PARTS		
	539	AN960-416L		.WASHER		3
R	540	AN960-416L		.WASHER		AR
R	543	BACN10JC4		.NUT	B,E	2
	-543A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D,F-H	2
	-543B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D,F-H	2
	-543C	MS21042L4		.NUT	J-V	2
				-------*-------		
R	546	MS21209F4-15P		..INSERT		2
R	549	141T6649-3		..SUPPORT	B,C,J,Q	1
R	-552	141T6649-4		..SUPPORT	E,F,K,S	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-552A	141T6653-4		DELETED		
	-552B	141T6653-3		DELETED		
R	-552C	141T6653-10		..SUPPORT	A,G,L,N,T,V	1
R	-552D	141T6653-9		..SUPPORT	D,H,M,P,R,U	1
R	555	BACB28X4M010		.BUSHING		1
R	558	BACB28AK04-258		.BUSHING	B,C,E,F,J,K,Q,S	1
	-558A	BACB28AK04-258		DELETED		
R	-558B	BACB28AK04-248		.BUSHING	A,D,G,H	1
R	-558C	BACB28AK04-238		.BUSHING	L-P,R,T-V	1
R	561	BACB30NM4K25		.BOLT		1
R	564	AN970-4		.WASHER		1
R	567	AN960-416		.WASHER		1
R	570	BACN10JC4		.NUT	B,E	1
	-570A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D,F-H	1
	-570B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D,F-H	1
	-570C	MS21042L4		.NUT	J-V	1
R	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

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R	01- -576A	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 576)		1
	579	KSP4A		..BEARING- (V38443) (SPEC BACB10AC4A) (OPT HHKSP4A (V38443)) (OPT KSP4AE9440A (V21335)) (OPT KSP4AFS428 (V21335)) (OPT KSP4A2TS (V43991)) (OPT KSP4AG27 (V30163)) (OPT 4AFS428 (V21335))		1
	582	141T6274-4		..GUIDE		1
R	585	141T6258-3		.SPRING		1
R	588	BACB30NR4K10		.BOLT		1
R	591	BACB28AK04-026		.BUSHING		1
R	594	AN960-416		.WASHER		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	597	BACN10JC4		.NUT	B,E	1
	-597A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1
	-597B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-597C	MS21042L4		.NUT	J-V	1
R	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
R	-603A	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 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
R	609	141T6274-5		..BUSHING		1
	612	141T6274-3		..HOUSING		1
R	615	BACB30NM4K12		.BOLT		1
R	618	AN960-416		.WASHER		1
R	621	BACN10JC4		.NUT	B,E	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-621A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1
	-621B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-621C	MS21042L4		.NUT	J-V	1
R	624	141T6205-1		.LEVER ASSY		1
R	627	BACB28X6M010		..BUSHING		1
	630	BACB28X4C013		DELETED		
R	630A	BACB28X4C010		..BUSHING		1
R	633	141T6205-2		..LEVER		1
R	636	BACB30NN4K14		.BOLT		1
R	639	AN960-416L		.WASHER		1
R	642	BACN10JC4		.NUT	B,E	1
	-642A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1
	-642B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-642C	MS21042L4		.NUT	J-V	1
R	645	141T6195-1		.CAM ASSY	B,C,D ,H,J, M,P,Q ,T,V	1
R	-648	141T6195-2		.CAM ASSY	A,E,F ,G,K, L,N,R ,S,U	1
R	651	BACR15CE5M		..RIVET- (SIZE DETERMINE ON INST)		4
R	654	141T6210-1		..LEVER		1
R	657	141T6195-3		..SHIM		2
R	660	141T6200-1		..CAM	B,C,D ,H,J, M,P,Q ,T,V	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-663	141T6200-2		..CAM	A,E,F,G,K,L,N,R,S,U	1
	664	BAC27TBY0033		..MARKER-ALUMINUM FOIL		1
R	665H	MS24665-376		.PIN-COTTER		1
	666	BMN4122C1D2-12		DELETED		
	666A	BACN10JD12CD		DELETED		
R	666B	BACN10JD112CD		.NUT		1
	669	AN960-126L		DELETED		
R	669A	AN960-1216L		.WASHER		1
R	672	141T6207-6		.LEVER ASSY- (FOR DETAILS SEE FIG. 3)		1
	675	BACB30NR4K20		DELETED		
R	675A	BACB30NR4K22		.BOLT		1
R	678	AN960-416L		.WASHER		1
	681	BACB28Y4C025		DELETED		
R	681A	BACB28Y4C037		.BUSHING		1
R	684	AN960PD416L		.WASHER		1
R	687	BACB28AK04-028		.BUSHING		1
R	690	BACN10JC4		.NUT	B,E	1
	-690A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D,F-H	1
	-690B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D,F-H	1
	-690C	MS21042L4		.NUT	J-V	1
R	693	141T6214-1		.CRANK		1
R	696	NAS428-4-10		.BOLT		1
R	699	AN960-416L		.WASHER		14
R	702	BACN10JC4		.NUT	B,E	1
	-702A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D,F-H	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-702B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-702C	MS21042L4		.NUT	J-V	1
R	705	141T6201-3		.SPACER		1
R	708	141T6201-4		.SPACER		1
R	711	141T6201-5		.SPACER		1
R	714	141T6203-3		.WASHER		21
R	717	141T6203-4		.SPRING		1
R	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		
R	723A	141T6199-2		.SHAFT		1
R	726	141T6188-3		.STOP ASSY	D,H,M ,P,T, V	1
R	-729	141T6188-4		.STOP ASSY	A,G,L ,N,R, U	1
R	-729A	141T6188-5		.STOP ASSY	E,F,K ,S	1
R	-729B	141T6188-6		.STOP ASSY	B,C,J ,Q	1
				ATTACHING PARTS		
R	732	BACB30NR4K15		.BOLT -------*-------		1
	-734C	141T6280-1		DELETED		

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-			ATTACHING PARTS		
R	735	BACB30NR4K16		.BOLT		1
R	738	AN960-616		.WASHER		11
R	741	BACW10P221S		.WASHER		10
R	744	AN960PD416		.WASHER		2
R	747	BACN10JC4		.NUT	B,E	2
R	-747A	BACN10JC4		.NUT-*(3) (LIMITED)	A,C,D,F-H	2
R	-747B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D,F-H	2
R	-747C	MS21042L4		.NUT -------*-------	J-V	2
R	750	141T6521-6		..RING		1
R	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
R	756	141T6188-11		..STOP	D,H,M,P,T,V	1
R	-759	141T6188-12		..STOP	A,G,L,N,R,U	1
R	-759A	141T6188-13		..STOP	E,F,K,S	1
R	-759B	141T6188-14		..STOP	B,C,J,Q	1
R	762	BACB28AK04-053		.BUSHING		1
R	765	BACB28AK04-070		.BUSHING		1
	768	BACB30LK3-12		DELETED		
R	768A	BACB30NM3K12		.BOLT		1
R	771	AN960C10L		.WASHER		1
R	774	BACN10JC3CM		.NUT	B,E	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-774A	BACN10JC3CM		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1
	-774B	MS21042L3		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-774C	MS21042L4		.NUT	J-V	2
R	777	141T6287-9		.BUSHING		1
R	780	141T6287-4		.ROLLER ASSY		1
	783	141T6287-14		..BUSHING		2
	786	141T6287-8		..ROLLER		1
R	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
R	792	AN960C416		.WASHER		3
R	795	BACN10JC4CM		.NUT	B,E	3
	-795A	BACN10JC4CM		.NUT-*(3) (LIMITED)	A,C,D ,F-H	3
	-795B	MS21042L4		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	3

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-795C	MS21042L4		.NUT	J-V	3
R	798	141T6286-1		.SHIM		1
R	801	141T6284-1		.SUPPORT		1
R	804	BACB30NM3K8		.BOLT		1
R	807	AN960C10		.WASHER		1
R	810	BACN10JC3CM		.NUT	B,E	1
	-810A	BACN10JC3CM		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1
	-810B	MS21042L3		.NUT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-810C	MS21042L3		.NUT	J-V	1
R	813	141T6287-2		.BUSHING		1
R	816	141T6287-3		.ROLLER ASSY		1
	819	141T6287-14		..BUSHING		1
	822	141T6287-7		..ROLLER		1
R	825	BACB30LK3-13		.BOLT		1
R	828	NAS1805-3		.NUT		1
R	831	141T6287-1		.BUSHING		2
R	831G	146T6140-63		.KIT ASSY-SUB (OPT ITEM 831N)	N-T	1
R	-831N	146T6140-64		.KIT ASSY-SUB (OPT ITEM 831G)	N-T	1
R	831U	141T6103-1		..CLIP- (USED ON ITEM 831G)	N-T	1
R	832	141T6280-1		..LEVER-(MATCHED SET) (USED ON ITEMS 831G, 831N)	N-T	1
R	832L	141T6280-2		..LEVER-(MATCHED SET) (USED ON ITEM 831G)	N-T	1
R	-832M	141T6280-3		..LEVER-(MATCHED SET) (USED ON ITEM 831N)	N-T	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01- 833	141T6103-1		.CLIP-*(4)*(5)*(6) (ITEM 833 WITH ITEM 834A AND ITEM 837A IS OPT TO THE MATCHED SET OF ITEM 834A AND ITEM 837B) (POST SB 767-52A0057)	A,D,G,H	1
	-833A	141T6103-1		.CLIP- (ITEM 833A WITH ITEM 834B AND ITEM 837C IS OPT TO THE MATCHED SET OF ITEM 834B AND ITEM 837D) (POST SB 767-52A0057)	J-M	1
R	834	141T6280-1		.LEVER-(MATCHED PART)	B,E	1
	-834A	141T6280-1		.LEVER-*(4)*(5)*(6) (MATCHED PART) (ITEM 833 WITH ITEM 834A AND ITEM 837A IS OPT TO THE MATCHED SET OF ITEM 834A AND ITEM 837B)	A,D,G,H	1
	-834B	141T6280-1		.LEVER- (MATCHED PART) (ITEM 833A WITH ITEM 834B AND ITEM 837C IS OPT TO THE MATCHED SET OF ITEM 834B AND ITEM 837D)	J-M	1
R	-834C	141T6280-1		.LEVER-(MATCHED PART)*(3)	A,C,D,F-H,U,V	1
R	837	141T6280-2		.LEVER-(MATCHED PART)	B,E	1
	-837A	141T6280-2		.LEVER-*(4)*(5)*(6) (MATCHED PART) (ITEM 833 WITH ITEM 834A AND ITEM 837A IS OPT TO THE MATCHED SET OF ITEM 834A AND ITEM 837B)	A,D,G,H	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-837B	141T6280-3		.LEVER-*(4)*(5)*(6) (MATCHED PART) (ITEM 833 WITH ITEM 834A AND ITEM 837A IS OPT TO THE MATCHED SET OF ITEM 834A AND ITEM 837B)	A,D,G,H	1
	-837C	141T6280-2		.LEVER- (MATCHED PART) (ITEM 833A WITH ITEM 834B AND ITEM 837C IS OPT TO THE MATCHED SET OF ITEM 834B AND ITEM 837D)	J-M	1
	-837D	141T6280-3		.LEVER- (MATCHED PART) (ITEM 833A WITH ITEM 834B AND ITEM 837C IS OPT TO THE MATCHED SET OF ITEM 834B AND ITEM 837D)	J-M	1
	-837E	141T6280-2		.LEVER-(MATCHED PART)*(3)	A,C,D,F-H	1
R	-837F	141T6280-3		.LEVER	U,V	1
R	840	BACB30NM4HK10		.BOLT		2
R	843	AN960-416		.WASHER		2
R	846	141T6288-1		.RETAINER		1
R	849	141T6231-1		.PIN		1
R	852	141T6232-1		.RETAINER		1
R	855	141T6226-1		.BUSHING		1
R	858	141T6287-17		.SHAFT		1
R	861	141T6219-1		.SPRING		1
R	864	NAS509-4C		.NUT		1
	867	NAS513-4		DELETED		
R	867A	NAS513-5		.WASHER	A-H	1
	-867B	NAS513-4		.WASHER	J-P	1
R	870	141T6287-5		.END ASSY-ROD		1
	873	141T6287-14		..BUSHING		2
	876	141T6287-10		..END		1
R	879	MS19068-002		.NUT		1
R	882	MS19070-002		.WASHER		1
R	885	AN960-716		.WASHER		1
R	888	BACB30NM4HK2		.BOLT		3
R	891	AN960-416		.WASHER		3
R	894	141T6282-1		.RETAINER		1
R	897	141T6286-2		.SHIM		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	900	KP10AFS428		.BEARING- (V21335) (SPEC BACB10BX10) (OPT KP10A2TS (V43991)) (OPT LLKP10A (V38443))		1
R	903	141T6203-7		.WASHER		8
R	906	141T6229-1		.SPACER		1
R	909	141T6500-1		.WASHER		1
R	912	MS28775-127		.PACKING		1
R	915	141T6208-1		.RING-SEAL		1
R	918	141T6203-8		.WASHER		12
R	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
R	924	141T6228-1		.SHAFT ASSY	B,C,J,Q	1
R	-927	141T6228-2		.SHAFT ASSY	E,F,K,S	1
	-927A	141N6228-5		DELETED		
	-927B	141N6228-6		DELETED		
	-927C	141T6228-5		.SHAFT ASSY	D,H,M,P,T,V	1
	-927D	141T6228-6		.SHAFT ASSY	A,G,L,N,R,U	1
R	930	BACB28X6C010		..BUSHING		1
R	933	BACB28X9M010		..BUSHING		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	936	141T6228-3		..SHAFT	B,C,J,Q	1
R	-939	141T6228-4		..SHAFT	E,F,J,S	1
R	-939A	141T6228-7		..SHAFT	D,H,M,P,T,V	1
R	-939B	141T6228-8		..SHAFT	A,G,L,N,R,U	1
R	942	141T6500-2		.PLUG		1
R	945	141T6159-13		.HANDLE ASSY- (FOR DETAILS SEE FIG. 4)	B,C,D,H,J,M,P,Q,T,V	1
R	-948	141T6159-14		.HANDLE ASSY- (FOR DETAILS SEE FIG. 4)	A,E,F,G,K,L,N,R,S,U	1
	951	NAS428H4-12		DELETED		
R	951A	NAS428-4-12		.BOLT		1
	952	AN316C4R		.NUT		1
	953	AN960KD416L		.WASHER		1
	954	NAS428H4-7		DELETED		
R	954A	NAS428-4-7		.BOLT		1
	955	AN960KD416L		.WASHER		1
	956	B0500-038S		.WASHER-*(1)*(2)*(4)*(5) *(6)(LIMITED) (V83553) (OPT ITEMS 956A, 956B)	A,C,D,F-H	AR

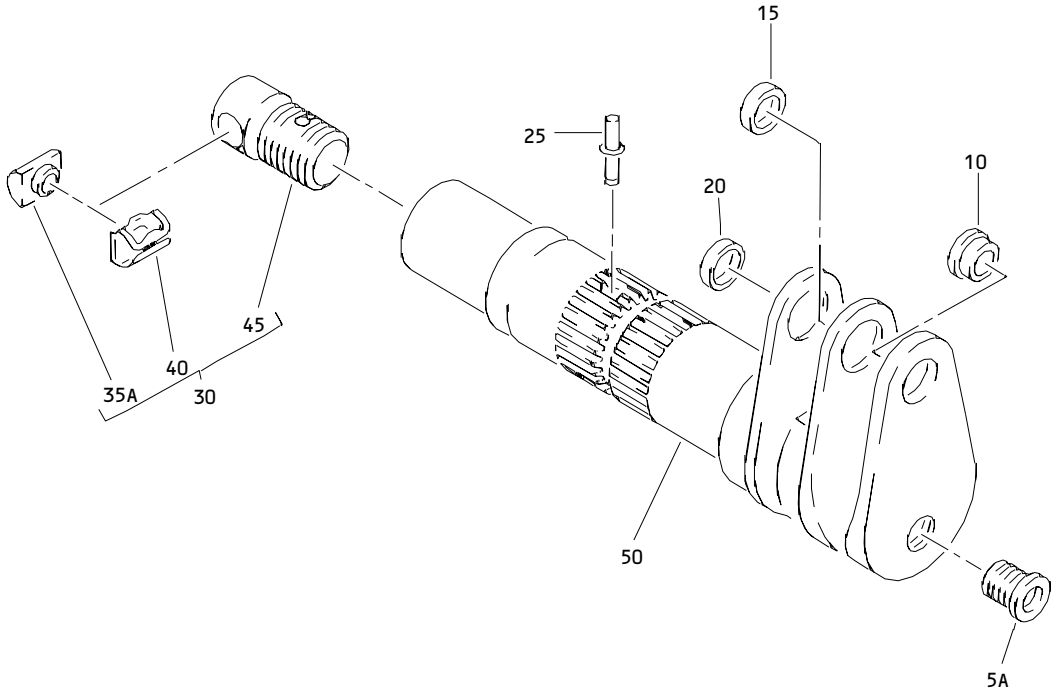
	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-956A	AN960KD416		.WASHER-*(1)*(2)*(4)*(5) *(6)(LIMITED) (OPT ITEMS 956, 956B)	A,C,D ,F-H	AR
	-956B	AN960KD416L		.WASHER-*(1)*(2)*(4)*(5) *(6)(LIMITED) (OPT ITEMS 956, 956A)	A,C,D ,F-H	AR
	-956C	B0500-038S		.WASHER- (V83553) (OPT ITEMS 956D, 956E)	J-V	AR
R	-956D	AN960KD416		.WASHER- (OPT ITEMS 956C, 956E)	J-V	AR
	-956E	AN960KD416L		.WASHER- (OPT ITEMS 956C, 956D)	J-V	AR
	957	NAS509-4		DELETED		
R	957A	AN315C4R		.NUT	B,E	1
	-957B	AN315C4R		.NUT-*(3) (LIMITED)	A,C,D ,F-H	1
	958	BACB30NF4-4		.BOLT-*(1)*(2)*(4)*(5)*(6) (LIMITED)	A,C,D ,F-H	1
	-958A	BACB30NF4-4		.BOLT	J-V	1
	959	AN960KD416L		.WASHER-*(1)*(2)*(4)*(5) *(6)(LIMITED)	A,C,D ,F-H	1
	-959A	AN960KD416L		.WASHER	J-V	1
	959G	141T6136-25		DELETED		
	959H	MS20392-3C69		.PIN-*(1)*(2)*(4)*(5)*(6) DRILLED SHANK (LIMITED) (V96906)	A,C,D ,F-H	1
	-959J	MS20392-3C69		.PIN-DRILLED SHANK (V96906)	J,K, Q-V	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-960	AN960PD416L		DELETED		
	960A	141T6661-1		.BASE-*(1)*(2)*(4)*(5)*(6) ARMING SYS EXTERNAL LOCK (LIMITED)	A,C,D,F-H	1
	-960B	141T6661-1		.BASE-ARMING SYS EXTERNAL LOCK	J-V	1
	961	141T6663-1		.SPRING-*(1)*(2)*(4)*(5)*(6) ARMING SYS EXTERNAL LOCK TORSION (LIMITED)	A,C,D,F-H	1
	-961A	141T6663-1		.SPRING-ARMING SYS EXTERNAL LOCK TORSION	J-V	1
	962	141T6662-1		.PAWL-*(1)*(5) ARMING SYS EXTERNAL LOCK (LIMITED)	A,F,G	1
	-962A	141T6662-2		.PAWL-*(2)*(6) ARMING SYS EXTERNAL LOCK (LIMITED)	C,D,H	1
	-962B	141T6662-1		.PAWL-EXTERNAL LOCK	J,M,P,Q,T,V	1
	-962C	141T6662-2		.PAWL-ARMING SYS EXTERNAL LOCK	K,L,N,R,S,U	1
R	963	BACB30NT3K3		.BOLT		2
	966	AN960D10L		DELETED		
	966A	AN960PD10L		.WASHER		2
R	969	H10-3BAC		.NUT- (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828))	B,E	2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-969A	H10-3BAC		.NUT-*(3) (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828)) (LIMITED)	A,C,D ,F-H	2
	-969B	MS21042L3		.NUT-*(1)*(2)*(3)*(4)*(5) *(6)(LIMITED)	A,C,D ,F-H	2
	-969C	MS21042L3		.NUT	J-V	2
R	972	BACS45A26S		.SEAL		1
R	975	BACB30NT2K3		.BOLT		1
	978	AN960PD8L		DELETED		
	978A	AN960KD8L		.WASHER		1
	981	AN960PD8		DELETED		
	981A	AN960KD8		.WASHER		1
R	984	141T6133-61		.SUPPORT ASSY-HANDLE (FOR DETAILS SEE FIG. 5)	A,G	1
R	-984A	141T6133-51		.SUPPORT ASSY-HANDLE (FOR DETAILS SEE FIG. 5)	B	1
R	-984B	141T6133-55		.SUPPORT ASSY-HANDLE (FOR DETAILS SEE FIG. 5)	C	1
	-984C	141T6133-81		.SUPPORT ASSY-HANDLE (FOR DETAILS SEE FIG. 5)	J,Q	1
	-984D	141T6133-83		.SUPPORT ASSY-HANDLE (FOR DETAILS SEE FIG. 5)	L,N,R ,U	1
R	-987	141T6133-62		.SUPPORT ASSY-HANDLE (FOR DETAILS SEE FIG. 5)	D,H	1
R	-987A	141T6133-52		.SUPPORT ASSY-HANDLE (FOR DETAILS SEE FIG. 5)	E	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R	01- -987B	141T6133-56		.SUPPORT ASSY-HANDLE (FOR DETAILS SEE FIG. 5)	F	1
	-987C	141T6133-82		.SUPPORT ASSY-HANDLE (FOR DETAILS SEE FIG. 5)	K,S	1
	-987D	141T6133-84		.SUPPORT ASSY-HANDLE (FOR DETAILS SEE FIG. 5)	M,P,T ,V	1

- Item Not Illustrated
*(1) PART OF COLLECTOR ASSY 141T6140-5001
*(2) PART OF COLLECTOR ASSY 141T6140-5002
*(3) PART OF COLLECTOR ASSY 141T6140-5003
*(4) PART OF COLLECTOR ASSY 141T6140-5004
*(5) PART OF COLLECTOR ASSY 141T6140-5005
*(6) PART OF COLLECTOR ASSY 141T6140-5006
*(7) TOP ASSEMBLIES 146T6140-41, -42, -45 AND -46 PRODUCTION UNITS USE 143T6155-1 CLUTCH ASSEMBLY TOP ASSEMBLIES 146T6140-11 AND -17, -12 AND -18, -7 AND -37, AND -8 AND -38 THAT WERE REWORKED TO 146T6140-41, -42, -45 AND -46 RESPECTIVELY PER SERVICE BULLETIN 767-52-0058 USE CLUTCH ASSEMBLY 143T6155-5
*(8) THESE COMPONENTS ARE BONDED TO MECHANISM ASSEMBLY AFT ENTRY AND SERVICE DOOR HANDLE THAT WERE REWORKED FROM 146T6140-11 AND -17, -12 AND -18, -7 AND -37, AND -8 AND -38 TO 146T6140-41, -42, -45 AND -46 RESPECTIVELY PER SERVICE BULLETIN 767-52-0058



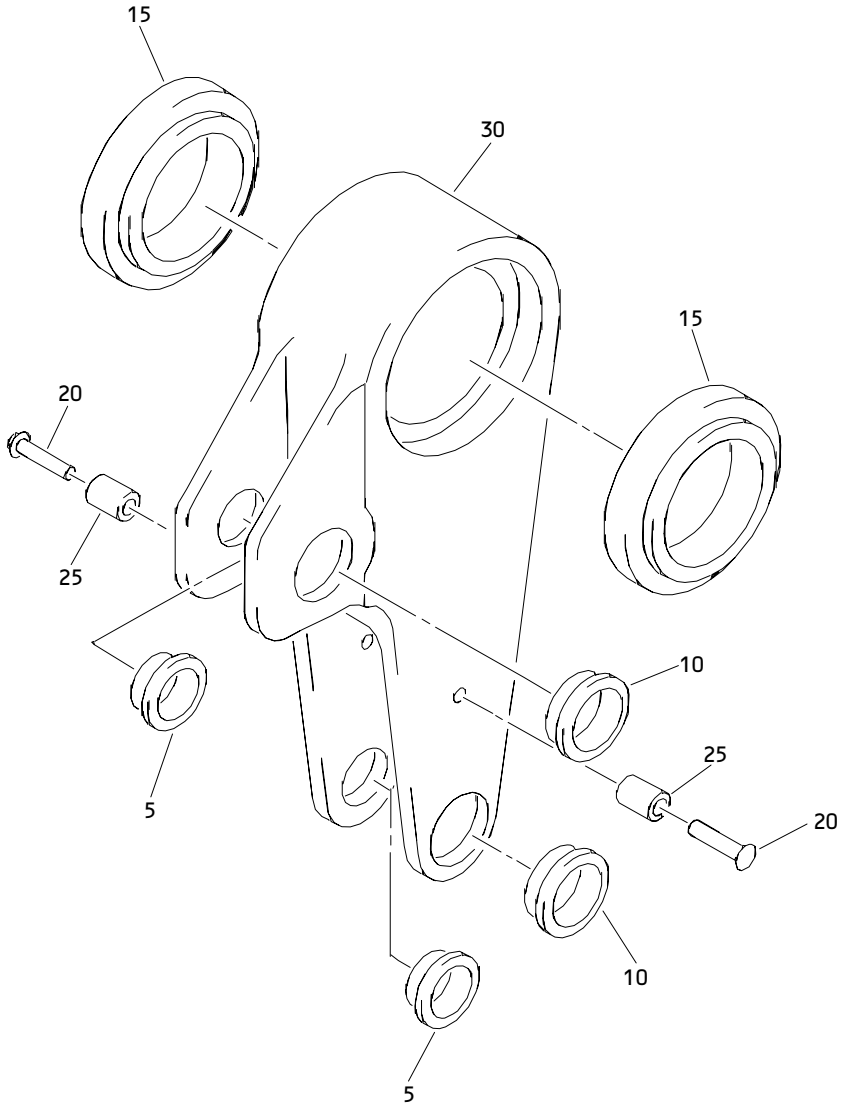
Inside Handle Pivot Shaft Assembly
Figure 2

T65146

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02- -1	141T6221-1		SHAFT ASSY-INSIDE HANDLE PIVOT	A,D,G,H,L-P,R,T-V	RF
R	-1A	141T6221-3		SHAFT ASSY-INSIDE HANDLE PIVOT	B,C,E,F,J,K,Q,S	RF
	5	NAS1394CAL		DELETED		
R	5A	NAS1394C4L		.INSERT		1
R	10	BACB28X6C016		.BUSHING		1
R	15	BACB28Y9M015		.BUSHING		1
R	20	BACB28Y9M013		.BUSHING		1
R	25	NAS1399MW4-5		.RIVET		1
R	30	141T6224-3		.NUT ASSY		1
	35	BRH10-5		DELETED		
	35A	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	141T6221-2		.SHAFT-PIVOT	A,D,G,H,L-P,R,T-V	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R	02- -50A	141T6221-4		.SHAFT-PIVOT	B,C,E ,F,J, K,Q,S	1

- Item Not Illustrated

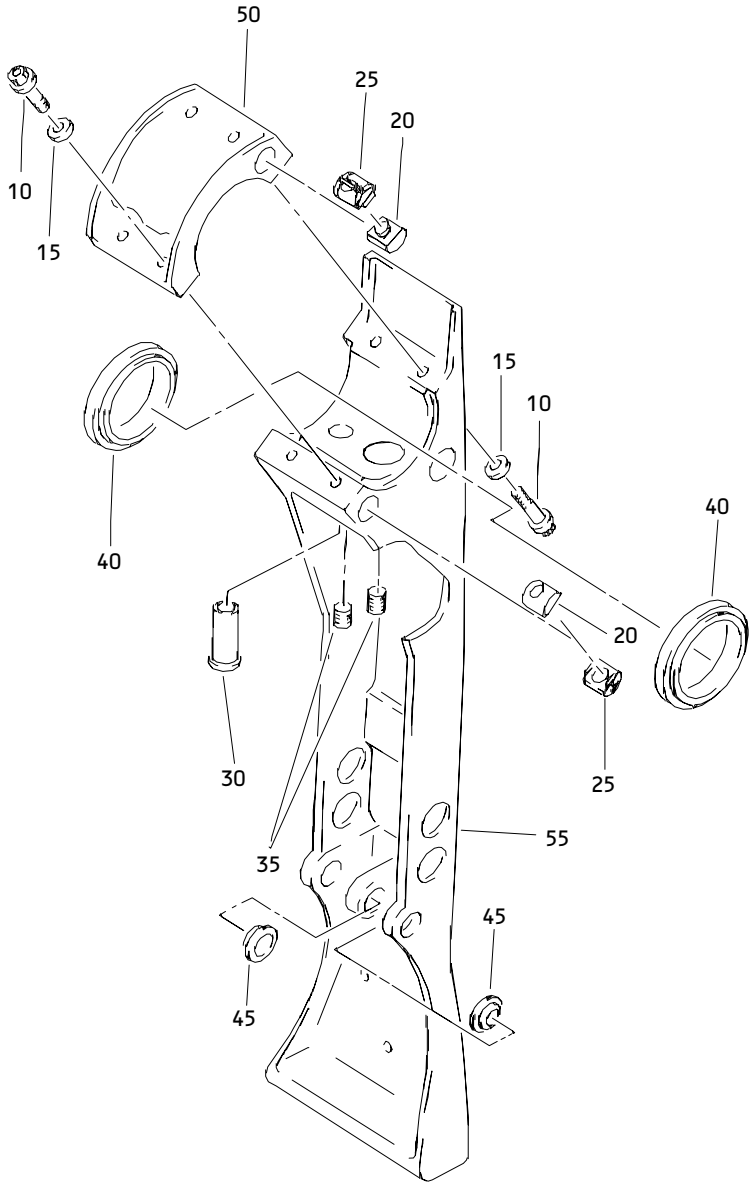


Carrier Drive Lever Assembly
Figure 3

T65147

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	03-					
R	-1	141T6207-6		LEVER ASSY-CARRIER DRIVE		RF
R	5	BACB28X4C010		.BUSHING		2
R	10	BACB28X6M012		.BUSHING		2
R	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
R	20	BACR15BB4AD10		.RIVET		2
R	25	NAS42DD4-24		.SPACER		2
R	30	141T6207-8		.LEVER		1

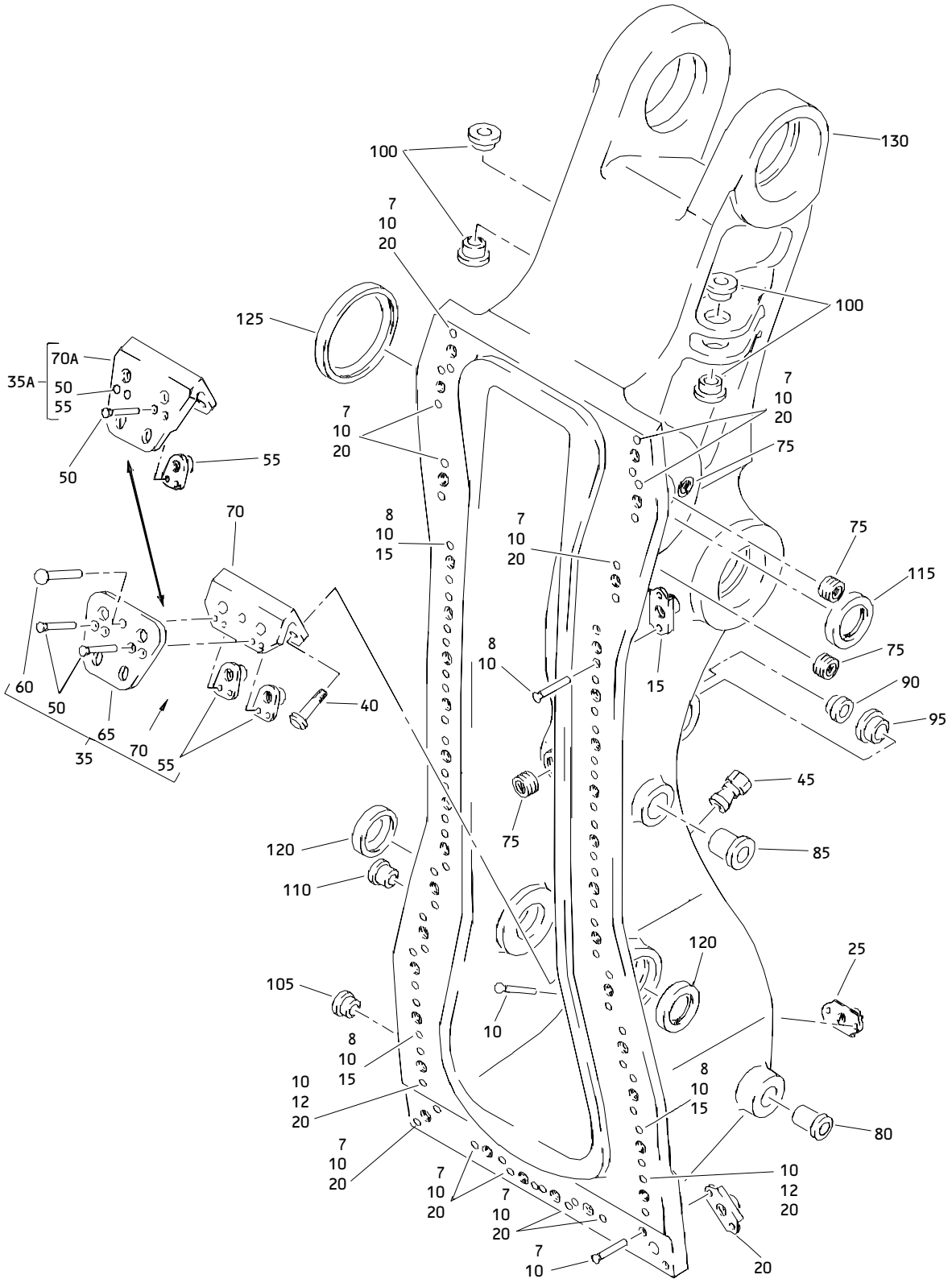
- Item Not Illustrated



External Handle Assembly
Figure 4

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	04-					
R	-1	141T6159-14		HANDLE ASSY-EXT	A,E-G,K,L,N,R,S,U	RF
R	-5	141T6159-13		HANDLE ASSY-EXT	B-D,H,J,M,P,Q,T,V	RF
R	10	BACB30MR4K10		.BOLT		4
R	15	BACW10BN4AC		.WASHER		4
R	20	NAS577-4A		.NUT		4
R	25	NAS578-4		.RETAINER		4
R	30	BACB28X6M109		.BUSHING		1
R	35	NAS1394C4L		.INSERT		2
R	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
R	45	141T6287-16		.BUSHING		2
R	50	141T6159-7		.CAP-(MATCHED PART)		1
R	55	141T6159-18		.HANDLE-(MATCHED PART)	A,E-G,K,L,N,R,S,U	1
R	-60	141T6159-17		.HANDLE-(MATCHED PART)	B-D,H,J,M,P,Q,T,V	1

- Item Not Illustrated



Handle Support Assembly
Figure 5

T65149

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	05-					
R	-1	141T6133-61		SUPPORT ASSY-HANDLE	A,G	RF
R	-1A	141T6133-51		SUPPORT ASSY-HANDLE	B	RF
R	-1B	141T6133-55		SUPPORT ASSY-HANDLE	C	RF
	-1C	141T6133-81		SUPPORT ASSY-HANDLE	J,Q	RF
	-1D	141T6133-83		SUPPORT ASSY-HANDLE	L,N,R,U	RF
R	-5	141T6133-62		SUPPORT ASSY-HANDLE	D,H	RF
R	-5A	141T6133-52		SUPPORT ASSY-HANDLE	E	RF
R	-5B	141T6133-56		SUPPORT ASSY-HANDLE	F	RF
	-5C	141T6133-82		SUPPORT ASSY-HANDLE	K,S	RF
	-5D	141T6133-84		SUPPORT ASSY-HANDLE	M,P,T,V	RF
	7	BACR15DR3F6		.RIVET	J-V	24
	8	BACR15DR3F4		.RIVET	J-V	44
R	10	BACR15BA3AD		.RIVET- (SIZE DETERMINE ON INST)	A-H	74
	12	BACR15DR3F8		.RIVET	J-V	4
R	15	BACN10JQ42		.NUTPLATE	A-H	22
	-15A	MF19058-4-2BAC		.NUTPLATE- (V15653) (SPEC BACN10YF42)	J,K,Q,S	22
R	20	BACN10JQ42		.NUTPLATE	B,E	14
R	-20A	BACN10JQ43		.NUTPLATE	A,C,D,F,G,H	14
	-20B	MF19058-4-3BAC		.NUTPLATE- (V15653) (SPEC BACN10YF43)	J-V	14
R	25	BRM200A08		.NUTPLATE- (V52828) (SPEC BACN10JP08A) (OPT MK1000-08BAC (V15653)) (OPT NS103197-82 (V80539)) (OPT T8076S832 (V71087)) (OPT T8076S832 (V11815)) (OPT VN202A1-82 (V92215))		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	05-					
R	35	141T6206-1		.BRACKET ASSY-STOP BOLT (OPT ITEM 35A)	A-H	1
R	35A	141T6206-3		.BRACKET ASSY-STOP BOLT (OPT ITEM 35)	A-H	1
	-35B	141T6206-3		.BRACKET ASSY-STOP BOLT ATTACHING PARTS	J-V	1
R	40	HL10VAZ5-5		.BOLT- (V60516) (SPEC BACB30MY5K5) (OPT B30MY5K5 (V97928))		2
R	45	HL70-5		.COLLAR- (V56878) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878)) (OPT HL79-5 (V5M902)) -------*-------		2
R	50	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		4
R	55	MK4001-4BAC		..NUTPLATE- (V15653) (SPEC BACN10JP4DCM) (OPT NS103200SE048 (V80539)) (OPT T8083C428 (V11815)) (OPT VN204D1-048 (V92215)) (OPT 109A9209M4 (V72962))		2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	05-					
R	60	BACR15BB4AD		..RIVET- (SIZE DETERMINE ON INST) (USED ON ITEM 35)		1
R	65	141T6206-5		..PLATE- (USED ON ITEM 35)		1
R	70	141T6206-2		..BRACKET- (USED ON ITEM 35)		1
R	70A	141T6206-4		..BRACKET- (USED ON ITEM 35A)		1
R	75	NAS1394C4L		.INSERT		4
R	80	BACB28X4M050		.BUSHING		1
R	85	BACB28X6M050		.BUSHING		1
R	90	BACB28X4M016		.BUSHING		1
R	95	BACB28X6M016		.BUSHING		1
R	100	BACB28X5M016		.BUSHING	B,E	4
R	-100A	BACB28X5M024		.BUSHING	C,F, J-V	4
R	105	BACB28X4C009		.BUSHING		1
R	110	BACB28X4C024		.BUSHING		1
R	115	BCREF5232		.SEAL- (V75165) (TN12501212ALCASTEFBU)		1
R	120	BCREF5231		.SEAL- (V75165) (TN11251212ALCASTEFBU)		2
R	125	BCREF5355		.SEAL- (V75165) (TN21881214ALCASTEFBU)		1
R	130	141T6133-73		.SUPPORT	A,G	1
R	-130A	141T6133-65		.SUPPORT	B	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	05-					
R	-130B	141T6133-69		.SUPPORT	C	1
	-130C	141T6133-89		.SUPPORT	J,Q	1
	-130D	141T6133-91		.SUPPORT	L,N,R ,U	1
R	-135	141T6133-74		.SUPPORT	D,H	1
R	-135A	141T6133-66		.SUPPORT	E	1
R	-135B	141T6133-70		.SUPPORT	F	1
	-135C	141T6133-90		.SUPPORT	K,S	1
	-135D	141T6133-92		.SUPPORT	M,P,T ,V	1

- Item Not Illustrated