

 **BOEING**  
COMPONENT  
MAINTENANCE MANUAL

TO: ALL HOLDERS OF ENTRY AND SERVICE DOOR UPLATCH ASSEMBLY  
COMPONENT MAINTENANCE MANUAL 52-11-87

REVISION NO. 2 DATED OCT 01/91

HIGHLIGHTS

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

CHAPTER/SECTION

AND PAGE NO.

701

1004,1008

DESCRIPTION OF CHANGE

Updated IPL to reflect latest released engineering.

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HIGHLIGHTS

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# ENTRY AND SERVICE DOOR UPLATCH ASSEMBLY

PART NUMBER 141T6583-25,-28,-29,-30

COMPONENT MAINTENANCE MANUAL  
WITH  
ILLUSTRATED PARTS LIST

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TITLE PAGE

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REVISION RECORD

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

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



TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL

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TR & SB RECORD

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 COMPONENT  
 MAINTENANCE MANUAL

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2	BLANK		602	OCT 10/84	01
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*1	OCT 01/91	01	*701	OCT 01/91	01.1
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1	APR 10/86	01.1	*1004	OCT 01/91	01.1
2	BLANK		1005	OCT 10/84	01
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1	APR 10/86	01.1	1007	OCT 10/84	01
2	BLANK		*1008	OCT 01/91	01.1
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302	BLANK				
CHECK					
501	OCT 10/84	01			
502	BLANK				
REPAIR-GENERAL					
601	OCT 10/84	01			
602	BLANK				

\* = REVISED, ADDED OR DELETED

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\* [1] Special instructions not required. Use standard industry practices.

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## INTRODUCTION

The instructions in this manual provide the information necessary to perform maintenance functions ranging from simple checks and replacement to complete shop-type repair.

This manual is divided into separate sections:

- |  |                              |
|--|------------------------------|
| 1. Title Page                                      | 4. List of Effective Pages   |
| 2. Record of Revisions                             | 5. Table of Contents         |
| 3. Temporary Revision &<br>Service Bulletin Record | 6. Introduction              |
|  | 7. Procedures & IPL Sections |

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

The beginning of the REPAIR section includes a list of the separate repairs and a list of applicable standard Boeing practices.

An explanation of the use of the Illustrated Parts List is provided in the Introduction to that section.

All weights and measurements used in the manual are in English units, unless otherwise stated. When metric equivalents are given they will be in parentheses following the English units.

Design changes, optional parts, configuration differences and Service Bulletin modifications create alternate part numbers. These are identified in the Illustrated Parts List (IPL) by adding an alphabetical character to the basic item number. The resulting item number is called an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless otherwise indicated.

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INTRODUCTION

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ENTRY AND SERVICE DOOR UPLATCH ASSEMBLY

DESCRIPTION AND OPERATION

1. The entry and service door uplatch assembly consists of a spring-loaded lever attached to a catch assembly. Both lever and catch assembly pivot on a fitting assembly.
2. Pressing the uplatch button mounted on the lever while lifting the door will release the door from "up" position and allow the door to be lowered and closed. On a motor-assisted door, the lever is also attached to a solenoid which activates releasing of the uplatch assembly electrically.
3. Leading Particulars (Approximate)

Length -- 11 inches

Width -- 3 inches

Height -- 2 inches

Weight -- 1 pound

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DESCRIPTION & OPERATION

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### 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 (IPL Fig. 1)

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

A. Nuts (30, 70)

B. Rivet (85)

#### 2. Disassemble the uplatch assembly using standard industry practices.

NOTE: Do not disassemble catch assembly (35) or fitting assembly (105) unless necessary for repair or replacement.

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DISASSEMBLY

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CHECK

1. Check all parts for obvious defects in accordance with standard industry practices.
2. Magnetic particle check spring (80) per 20-20-01.
3. Penetrant check the following parts (Ref IPL Fig. 1) per 20-20-02.
  - A. Catch (55)
  - B. Lever (100)
  - C. Fitting (120)
4. Check torsion spring (80, IPL Fig. 1).
  - A. Compress spring 40 degrees from free position and check that moment is at least 2.4 pound-inches.
  - B. Check that there is no permanent set after 40 degree deflection.

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CHECK  
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REPAIR – GENERAL1. Content

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

<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
141T6539	FITTING	1-1
141T6540	LEVER	2-1
141T6541	CATCH	3-1
- - -	MISC PARTS REFINISH	4-1

2. Standard Practices

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

20-30-02 Stripping of Protective Finishes  
 20-30-03 General Cleaning Procedures  
 20-41-01 Decoding Table for Boeing Finish Codes  
 20-41-02 Application of Chemical and Solvent Resistant Finishes  
 20-43-01 Chromic Acid Anodizing

3. Materials

NOTE: Equivalent substitutes may be used.

- A. Primer -- BMS 10-11, type 1 (Ref 20-60-02)  
 B. Enamel -- BMS 10-11, type 2, color BAC702 white gloss (Ref 20-60-02)  
 C. Coating -- Teflon-filled, BMS 10-86, type 1, color white (Ref 20-60-02)  
 D. Sealant -- BMS 5-95 (Ref 20-60-04)

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REPAIR-GENERAL

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FITTING ASSEMBLY - REPAIR 1-1

141T6539-5, -7

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

1. Bushing Replacement (IPL Fig. 1)

- A. Remove bushing (115).
- B. Install replacement bushing per 20-50-03, using wet sealant, BMS 5-95.
- C. Fillet seal bushing flanges with sealant.

2. Refinish (IPL Fig. 1)

- A. Fitting (120) -- Chromic acid anodize and apply one coat primer, BMS 10-11, type 1 (F-18.13). Apply one coat enamel, BMS 10-11, type 2, color BAC702 white gloss (F-21.03). Omit primer and enamel in holes.  
Material: Aluminum alloy.

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REPAIR 1-1

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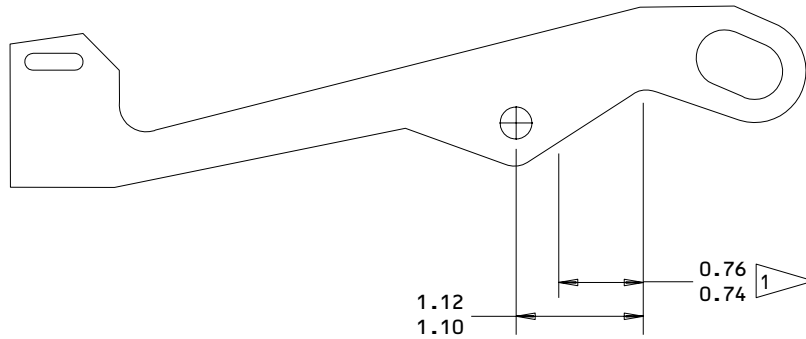
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LEVER - REPAIR 2-1


141T6540-2, -3

1. Plating Repair

**NOTE:** Repair consists of stripping and restoration of original finish. Refer to Refinish instruction in Fig. 601 and to REPAIR-GEN for List of applicable standard practices.




REFINISH

CHROMIC ACID ANODIZE AND APPLY ONE COAT PRIMER, BMS 10-11, TYPE 1 (F-18.13) EXCEPT OMIT PRIMER IN SLOTS AND HOLE. APPLY WHITE TEFLON-FILLED COATING, BMS 10-86, TYPE 1 (SRF-14.9624) ON SPRING CONTACT AREA PER 

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

 APPLY TEFLON-FILLED COATING TO EDGE OF LEVER THIS AREA ONLY

Lever Refinish  
 Figure 601

144453

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REPAIR 2-1

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CATCH ASSEMBLY – REPAIR 3-1

141T6541-5, -7, -9

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require stripping and restoration of original finish, refer to REFINISH instructions, Fig. 601 and Repair 4-1.

1. Bushing Replacement (IPL Fig. 1)

- A. Remove bushing (40).
- B. Install replacement bushing per 20-50-03, using wet sealant, BMS 5-95.
- C. Fillet seal bushing flanges with sealant.

2. Target Replacement (IPL Fig. 1)

- A. Remove rivets (45) to release target (50) from catch assembly.
- B. Position replacement target per Fig. 601 and drill 0.098-0.103 inch diameter holes for rivets using existing holes in catch (55) as pattern.
- C. Fay surface seal target and catch with sealant, BMS 5-95, and attach target with rivets.

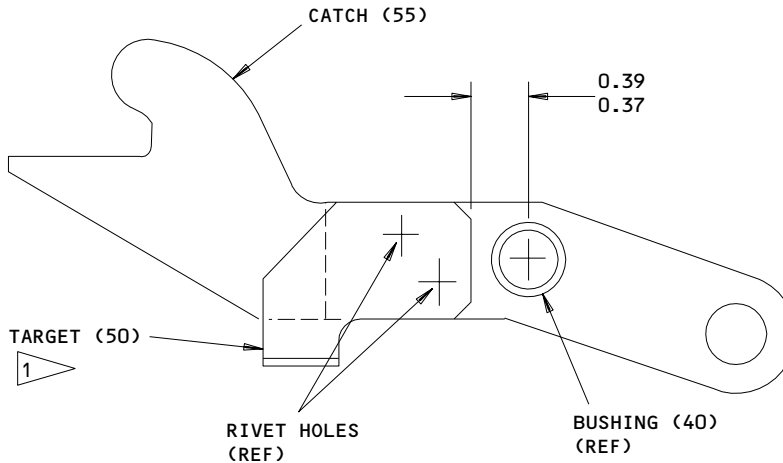
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REPAIR 3-1

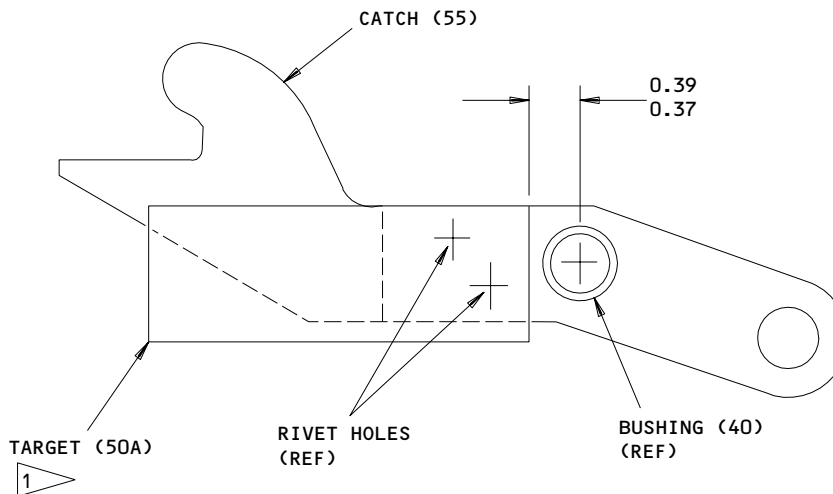
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**CATCH ASSEMBLY (35)**  
**141T6541-9**



**CATCH ASSEMBLY (35B)**  
**141T6541-7**

**REFINISH**

CATCH (55) -- CHROMIC ACID ANODIZE AND APPLY ONE COAT PRIMER, BMS 10-11, TYPE 1 (F-18.13), PLUS ONE COAT ENAMEL, BMS 10-11, TYPE 2, COLOR BAC702 WHITE GLOSS. OMIT PRIMER AND ENAMEL IN HOLES

MATERIAL: CATCH (55) -- AL ALLOY

ALL DIMENSIONS ARE IN INCHES

1 FAY SURFACE SEAL WITH SEALANT, BMS 5-95

**141T6541-5,-7,-9**  
**Catch Assembly - Parts Replacement and Refinish**  
**Figure 601**

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REPAIR 3-1

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MISCELLANEOUS PARTS REFINISH – REPAIR 4-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 1</u>		
Target (50)	4130 Steel	Cadmium plate and apply one coat primer, BMS 10-11, type 1 (F-16.01)
Target (50A)	4130 Steel	Cadmium plate and apply one coat primer, BMS 10-11, type 1 (F-16.01 plus one coat enamel, BMS 10-11, type 2, color BAC702 white gloss (F-21.03)
Spring (80)	17-7PH CRES	Passivate (F-17.09)
Spacer (92)	Al alloy	Chromic acid anodize and apply one coat primer, BMS 10-11, type 1 (F-18.13) except omit primer in bore.

Refinish Details  
Figure 601

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REPAIR 4-1

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ASSEMBLY1. Material

NOTE: Equivalent substitutes may be used.

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

2. Lubrication

A. Apply grease to O.D. of bolts (5, 60) and O.D. of bushings (15, 20, 25, 75A) as parts are assembled.

3. Assembly (IPL Fig. 1)

A. Position button (95) on lever (100) and install spacers (92), washers (90). Secure button to lever with rivet (85).

B. Assemble lever (85), spring (80), bushings (75A) on fitting assembly (105) and secure with bolt (60), washer (65) and nut (70).

C. Position catch assembly (35) on fitting assembly (105) and secure with bolt (5), washer (10), bushings (15) and nut (30).

D. Install bushing (20) in slot of lever (100). Align slot of lever (100) and bolt holes in catch assembly (35) then install bushing (25), bolt (5), washer (10) and nut (30).

4. Store this component using standard industry practices and information contained in 20-44-02.

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ASSEMBLY

01.1

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ILLUSTRATED PARTS LIST

1. This section lists and illustrates replaceable or repairable component parts. The Illustrated Parts Catalog contains a complete explanation of the Boeing part numbering system.

2. Indentures show parts relationships as follows:

Assembly

Detail Parts for Assembly

Subassembly

Attaching Parts for Subassembly

Detail Parts for Subassembly

Detail Installation Parts (Included only if installation parts may be returned to shop as part of assembly)

3. One use code letter (A, B, C, etc.) is assigned in the EFF CODE column for each variation of top assembly. All listed parts are used on all top assemblies except when limitations are shown by use code letter opposite individual part entries.

4. Letter suffixes (alpha-variants) are added to item numbers for optional parts, Service Bulletin modification parts, configuration differences (Except left- and right-hand parts), product improvement parts, and parts added between two sequential item numbers. The alpha-variant is not shown on illustrations when appearance and location of all variants of the part is the same.

5. Service Bulletin modifications are shown by the notations PRE SB XXXX and POST SB XXXX.

A. When a new top assembly part number is assigned by Service Bulletin, the notations appear at the top assembly level only. The configuration differences at detail part level are then shown by use code letter.

B. When the top assembly part number is not changed by the Service Bulletin, the notations appear at the detail part level.

6. Parts Interchangeability

Optional  
(OPT)

The parts are optional to and interchangeable with other parts having the same item number.

Supersedes, Superseded By  
(SUPSDS, SUPSD BY)

The part supersedes and is not interchangeable with the original part.

Replaces, Replaced By  
(REPLS, REPLD BY)

The part replaces and is interchangeable with, or is an alternate to, the original part.

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ILLUSTRATED PARTS LIST

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VENDORS

06710 VALLEY-TODECO INCORPORATED  
12975 BRADLEY AVENUE  
SYLMAR, CALIFORNIA 91342

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

06950 SCREWCORP VSI CORP AEROSPACE PRODUCTS DIV FAIRCHILD IND INC  
13001 EAST TEMPLE AVENUE  
CITY OF INDUSTRY, CALIFORNIA 91746

08524 DEUTSCH CO FASTENER DIV  
PO BOX 92925 7001 WEST IMPERIAL HIGHWAY  
LOS ANGELES, CALIFORNIA 90045

15653 MICRODOT AEROSPACE FASTENING SYS DIV OF MICRODOT INC  
800 SOUTH COLLEGE BLVD PO BOX 3001  
FULLERTON, CALIFORNIA 92634

23294 AVALON MACHINE PRODUCTS INC  
15337 ALLEN STREET  
PARAMOUNT, CALIFORNIA 90723

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

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

56878 SPS TECHNOLOGIES INC  
HIGHLAND AVENUE  
JENKINTOWN, PENNSYLVANIA 19046

70265 ALL POWER MANUFACTURING COMPANY  
13141 MOLETTE STREET  
SANTE FE SPRINGS, CALIFORNIA 90670

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

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**BOEING**  
COMPONENT  
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72962 AMERACE CORP ESNA DIV  
2330 VAUXHALL ROAD  
UNION, NEW JERSEY 07083

73197 HI-SHEAR CORPORATION  
2600 SKYPARK DRIVE  
TORRANCE, CALIFORNIA 90509

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

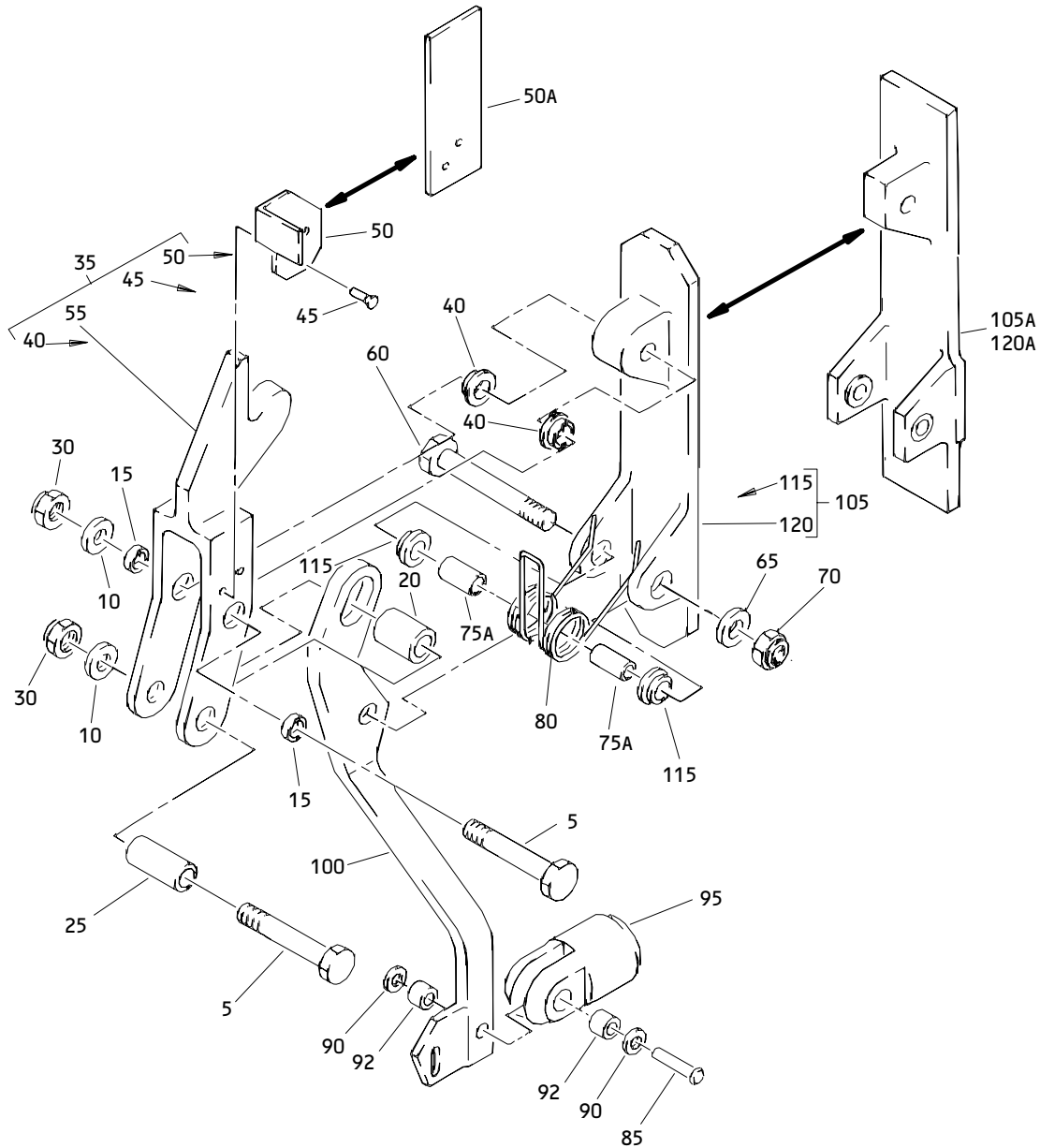
92215 VOI-SHAN DIV OF VSI CORP SUB OF FAIRCHILD INDUSTRIAL INC  
8463 HIGUERA STREET  
CULVER CITY, CALIFORNIA 90230

93907 TEXTRON INC CAMCAR DIV  
600 18TH AVENUE  
ROCKFORD, ILLINOIS 61101

94892 MASTER MACHINE PRODUCTS CORPORATION  
1551 SOUTH PRIMROSE AVE  
MONROVIA, CALIFORNIA 91016

97928 LITTON FASTENING SYSTEMS DIV OF LITTON SYSTEMS INC  
3969 PARAMONT BOULEVARD  
LAKEWOOD, CALIFORNIA 90712

**52-11-87**ILLUSTRATED PARTS LIST  
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Entry and Service Door - Uplatch Assembly  
 Figure 1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -1	141T6583-25		UPLATCH ASSY-ENTRY AND SVCE DOOR	A	RF
-1A	141T6583-28		UPLATCH ASSY-ENTRY AND SVCE DOOR	B	RF
-1B	141T6583-29		UPLATCH ASSY-ENTRY AND SVCE DOOR	C	RF
-1C	141T6583-30		UPLATCH ASSY-ENTRY AND SVCE DOOR	D	RF
5	BACB30NR4K15		.BOLT- (V06710) (SPEC BACB30NR4K15) (OPT BACB30NR4K15 (V06725)) (OPT BACB30NR4K15 (V06950)) (OPT BACB30NR4K15 (V08524)) (OPT BACB30NR4K15 (V27624)) (OPT BACB30NR4K15 (V56878)) (OPT BACB30NR4K15 (V73197)) (OPT BACB30NR4K15 (V80539)) (OPT BACB30NR4K15 (V92215)) (OPT BACB30NR4K15 (V93907)) (OPT BACB30NR4K15 (V97928))		2
10	AN960PD416L		.WASHER		2
15	BACB28AK04-027		.BUSHING- (V23294) (SPEC BACB28AK04-027) (OPT BACB28AK04-027 (V70265)) (OPT BACB28AK04-027 (V94892))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-20	BACB28AK06-053		.BUSHING- (V23294) (SPEC BACB28AK06-053) (OPT BACB28AK06-053 (V70265)) (OPT BACB28AK06-053 (V94892))		1
25	BACB28AK04-095		.BUSHING- (V23294) (SPEC BACB28AK04-095) (OPT BACB28AK04-095 (V70265)) (OPT BACB28AK04-095 (V94892))		1
30	H10-4BAC		.NUT- (V15653) (SPEC BACN10JC4) (OPT NS202101-048 (V80539)) (OPT RMLH9075-4W (V72962)) (OPT T6S428J (V71087)) (OPT VN303A048 (V92215)) (OPT 96-048 (V80539)) (OPT BRH10A4 (V52828))		2
35	141T6541-9		.CATCH ASSY	A	1
35A	141T6541-5		.CATCH ASSY	BD	1
35B	141T6541-7		.CATCH ASSY	C	1
40	BACB28X6M015		..BUSHING- (V23294) (SPEC BACB28X6M015) (OPT BACB28X6M015 (V70265)) (OPT BACB28X6M015 (V94892))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-45	BACR15BB3AD		..RIVET- (SIZE DETERMINE ON INST)	AC	2
50	284T0861-1		..TARGET	A	1
50A	284T0459-1		..TARGET	C	1
55	141T6541-6		..CATCH		1
60	BACB30NR4K24		.BOLT- (V06710) (SPEC BACB30NR4K24) (OPT BACB30NR4K24 (V06725)) (OPT BACB30NR4K24 (V06950)) (OPT BACB30NR4K24 (V08524)) (OPT BACB30NR4K24 (V27624)) (OPT BACB30NR4K24 (V56878)) (OPT BACB30NR4K24 (V73197)) (OPT BACB30NR4K24 (V80539)) (OPT BACB30NR4K24 (V92215)) (OPT BACB30NR4K24 (V93907)) (OPT BACB30NR4K24 (V97928))		1
65	AN960PD416L		.WASHER		1
70	H10-4BAC		.NUT- (V15653) (SPEC BACN10JC4) (REFER TO ITEM 30 FOR OPT PARTS)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-75	BACB28AK04-062		DELETED		
75A	BACB28AK04-058		.BUSHING (V23294)		2
80	141T6502-3		.SPRING-TORSION		1
85	BACR15FT5KE		.RIVET		1
90	AN960PD8L		.WASHER		2
92	141T6583-15		.SPACER		2
95	141T6538-3		.BUTTON		1
100	141T6540-2		.LEVER	A-C	1
-100A	141T6540-3		.LEVER	D	1
105	141T6539-7		.FITTING ASSY- (OPT ITEM 105A)		1
105A	141T6539-5		.FITTING ASSY- (OPT ITEM 105)		1
115	BACB28X6M015		..BUSHING- (V23294) (SPEC BACB28X6M015) (OPT BACB28X6M015 (V70265)) (OPT BACB28X6M015 (V94892))		2
120	141T6539-8		..FITTING- (USED ON ITEM 105)		1
120A	141T6539-6		..FITTING- (USED ON ITEM 105A)		1

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