

 **BOEING**  
COMPONENT  
MAINTENANCE MANUAL

TO: ALL HOLDERS OF SECTION 46 ENTRY/SERVICE DOORS OVERCENTER MECHANISM ASSEMBLY  
COMPONENT MAINTENANCE MANUAL 52-11-88

REVISION NO. 3 DATED OCT 01/92

HIGHLIGHTS

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

CHAPTER/SECTION

AND PAGE NO.

DESCRIPTION OF CHANGE

TITLE PAGE

Added Top Assembly 146T6125-23, -24, -27, -28 with new housing assemblies per PRR B12043.

1

TR & SB RECORD

1

301

REPAIR 1-1

601

REPAIR 3-1

601-602

REPAIR 4-1

601

701

1009-1018

TR & SB RECORD

Incorporate SB 52-0056 that changes bearings and adds bearing retainer.

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1012-1016

REPAIR 3-1

Changed sealant from Q3-0121 to BMS 5-95.

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HIGHLIGHTS

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SECTION 46 ENTRY/SERVICE DOORS  
OVERCENTER MECHANISM ASSEMBLY

PART NUMBERS 146T6125-15,-16,-19,-20,-23,  
-24,-27,-28

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
52-0056		PRR B12043	OCT 01/92 OCT 01/92

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TR & SB RECORD

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			*601	OCT 01/92	01.1
			602	BLANK	
TITLE PAGE			REPAIR 2-1		
*1	OCT 01/92	01.1	601	OCT 10/84	01
2	BLANK		602	BLANK	
REVISION RECORD			REPAIR 3-1		
1	OCT 10/84	01	*601	OCT 01/92	01.1
2	BLANK		*602	OCT 01/92	01.1
TR & SB RECORD			REPAIR 4-1		
*1	OCT 01/92	01.1	*601	OCT 01/92	01.1
2	BLANK		602	BLANK	
LIST OF EFFECTIVE PAGES			ASSEMBLY		
*1	OCT 01/92	01	*701	OCT 01/92	01.1
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CHECK			*1009	OCT 01/92	01.1
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502	BLANK		*1011	OCT 01/92	01.1
REPAIR-GENERAL			*1012	OCT 01/92	01.1
*601	OCT 01/92	01.101	*1013	OCT 01/92	01.1
602	BLANK		*1014	OCT 01/92	01.1
			*1015	OCT 01/92	01.1
			*1016	OCT 01/92	01.1
			*1017	OCT 01/92	01.1
			*1018	OCT 01/92	01.1

\* = 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.

Verification:

Disassembly  
Assembly

# 52-11-88

INTRODUCTION

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SECTION 46 ENTRY/SERVICE DOORS OVERCENTER MECHANISM ASSEMBLY

DESCRIPTION AND OPERATION

1. The overcenter mechanism assembly consists of two crank assemblies which pivot on a splined drive shaft and a pivot sleeve inside a housing assembly. A link connects the two crank assemblies together.
2. The overcenter mechanism assembly provides an overcenter condition when the door handle is moved to the door latched position. It also prevents any force acting inboard on either the door or the trolley from influencing door handle position.
3. Leading Particulars (Approximate)

Length -- 7 inches  
Width -- 4 inches  
Height -- 12 inches

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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

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

A. Nuts (35, 40, 45, 125, IPL Fig. 1)

2. Disassembly (IPL Fig. 1)

A. Remove lockwire and remove bolt (5), washer (20) and nuts (35).

B. Remove bolt (10), washer (25) and nut (40) securing link (85) and crank assembly (90). Separate link (85) from crank assembly (90).

C. Rotate crank assembly (60) to gain access to nut (45) and remove nut (45), washer (30) and bolt (15).

D. Remove shaft (50), spacer rings (55, 57) and crank assembly (60) from housing assembly (134, 135, 137).

E. Remove bolt (10), washer (25) and nut (40) and separate link (85) from crank assembly (60).

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

F. Remove nut (125), washers (120) and bolt (115) and remove crank assembly (90), spacer (55) and sleeve (130) from housing assembly (134, 135, 137 or 137A).

NOTE: Do not disassemble crank assembly (90) or housing assembly (134, 135, 137) 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 the following parts (IPL Fig. 1) per 20-20-01.
  - A. Drive shaft (50)
  - B. Crank (80, 110)
  - C. Sleeve (130)
3. Penetrant check the following parts (IPL Fig. 1) per 20-20-02.
  - A. Cap (155)
  - B. Housing (205, 225, 245)

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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>
141T6166	CRANK	1-1
141T6167	CRANK	2-1
141T6172	HOUSING	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  
 20-50-03 Bearing Installation and Retention

3. Materials

NOTE: Equivalent substitutes may be used.

- A. Primer -- BMS 10-11, type 1 (Ref 20-60-02)  
 B. Sealant -- BMS 5-95 (Ref 20-60-04)  
 C. Grease -- MIL-G-23827 (Ref 20-60-03)

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REPAIR-GENERAL

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CRANK ASSEMBLY – REPAIR 1-1

141T6166-5, -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 instruction.

1. Bushing (105) Replacement

- A. Remove bushing.
- B. Install replacement bushing per 20-50-03.
- C. Fillet seal bushing flange with wet sealant BMS 5-95.

2. Bushings (95, 100) Replacement

- A. Remove bushings.
- B. Install bushing (100) per 20-50-03.
- C. Install bushing (95) inside bushing (100) using grease. Secure bushing (95) with masking tape for shipment and storage to prevent loss of bushing prior to installation.

3. Refinish

- A. Crank (110) -- Passivate (F-17.09) all over. Material: 17-4PH CRES (Opt: 15-5PH CRES), 180-200 ksi.

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CRANK ASSEMBLY – REPAIR 2-1

141T6167-3

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 instruction.

1. Bushings (65, 70) Replacement

- A. Remove bushings (65, 70).
- B. Install bushing (65) then install bushing (70) per 20-50-03.

2. Bushing (75) Replacement

- A. Remove bushing.
- B. Install replacement bushing per 20-50-03.
- C. Fillet seal bushing flange with wet sealant, BMS 5-95.

3. Refinish

- A. Crank (80) -- Passivate (F-17.09) all over. Material: 15-5PH CRES, 150-170 ksi.

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HOUSING ASSEMBLY – REPAIR 3-1

| 141T6172-21, -22, -27, -28, -41, -42, -45, -46

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 instruction.

1. Cap (155) Replacement

- A. Remove bolt (140), washer (145), nut (150) and cap (155).
- B. Apply wet sealant, BMS 5-95 to faying surfaces of cap (155) and housing (205, 225, 245).
- C. Install cap on housing and secure with bolt (140), washer (145) and nut (150).

2. Bearing (170) Replacement

- A. Remove ring (160) and bearing (170).
- B. Install replacement bearing and ring per 20-50-03.

3. Bearing (175) Replacement

- A. Remove bearing (175) and sleeve (165).

CAUTION: USE CARE WHEN HANDLING BEARING (175). BEARING CAN EASILY BE CONTAMINATED DURING HANDLING; THE SPHERICAL INNER RACE CAN BE ROTATED OUT OF POSITION, THEREBY EXPOSING THE ROLLER ELEMENTS.

- B. Install replacement bearing and sleeve per 20-50-03 using wet primer.
  - C. Check that gap in sleeve (165) is 0.062-inch maximum. Fill gap with sealant, BMS 5-95.
- |

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4. Bearing (175A, 175B) Replacement

- A. Remove bearings.
- B. Install replacement bearings per 20-50-03.
- C. Apply wet sealant, BMS 5-95 between the bearing and housing.
- D. Install retainer (177) with rivets (178).

5. Refinish

- A. Housing (205, 225, 245) -- Chromic acid anodize and apply one coat of primer (F-18.13) all over except omit primer in bores for bearing.  
Material: Al alloy.

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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>		
Shaft (50)	4330M steel, 220-240 ksi	Cadmium-titanium plate (F-15.01) on all exterior surfaces and apply 2 coats of primer (F-20.03) on all interior surfaces.
Ring (55, 57)	303 steel	Cadmium plate (F-15.02) all over.
Sleeve (130)	15-5PH CRES, 150-170 ksi	Cadmium plate (F-15.02) all over except in bore.
Cap (155)	15-5PH CRES, 150-170 ksi	Cadmium plate and apply 1 coat of primer (F-16.01) all over except omit primer on 0.5 by 0.5 inch exterior surface.

Refinish Details  
Figure 601

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REPAIR 4-1

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ASSEMBLY1. Equipment

NOTE: Equivalent substitutes may be used.

A. Rigging pin -- 0.310 inch diameter

2. Assembly

A. Attach link (85) to crank assembly (60) using bolt (10), washer (25) and nut (40).

CAUTION: USE CARE WHEN HANDLING HOUSING ASSEMBLY (134, 135, 137 OR 137A). BEARING (175) IN HOUSING ASSEMBLY CAN EASILY BE CONTAMINATED DURING HANDLING; THE SPHERICAL INNER RACE CAN BE ROTATED OUT OF POSITION, THEREBY EXPOSING THE ROLLER ELEMENTS.

B. Position crank assembly (60) and two spacer rings (55) in housing assembly (134, 135, 137) and install shaft (50). Locate spacer rings (55, 57) and nut (40) on the spline teeth side of shaft (50).

C. Secure crank assembly (60) to shaft (50) with bolt (15), washer (30) and nut (45). Locate fasteners so that bolthead is facing inside of the housing assembly (134, 135, 137).

D. Position crank assembly (90) and spacer ring (55, 57) in housing assembly (134, 135, 137) with spacer ring on the same side as spline teeth of shaft (50). Install sleeve (130) to secure crank assembly (90) in housing assembly (134, 135, 137).

E. Secure crank assembly (90) to sleeve (130) with bolt (115), washers (120) and nut (125). Check that sleeve (130) is centered in housing assembly (134, 135, 137) within 0.03 inch. Remove fasteners and reverse direction of sleeve if required.

F. Attach link (85) to crank assembly (90) using bolt (10), washers (25) and nut (40) with nut on the spline teeth side of shaft (50).

G. Install bolt (5), washer (20) and nuts (35) on crank assembly (90).

H. Install rigging pin thru holes in crank assembly (90) and housing assembly (134, 135, 137) and adjust bolt (5) until bolthead just contacts cap (155) on housing assembly (134, 135, 137). Tighten nuts (35) to secure bolt (5).

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- I. Remove rigging pin and lockwire nuts (35) using MS20995 CRES lockwire 0.03 inch diameter per 20-50-02.
3. Store this component using standard industry practices and information contained in 20-44-02.

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

NOTE: Equivalent substitutes may be used.

1. Rigging pin -- 0.310 inch diameter

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SPECIAL TOOLS

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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

08073 MAMCO MANUFACTURING CO INC  
1411 NORTHWEST 50TH  
SEATTLE, WASHINGTON 98107

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

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

11815 TOWNSEND DIV OF TEXTRON INC CHERRY FASTENER UNIT  
BOX 2157 1224 EAST WARNER AVENUE  
SANTA ANA, CALIFORNIA 92707

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

15805 FABRICATORS, INC DIV OF THE FLUOROCARBON CO  
3711 SOUTH HUDSON STREET PO BOX 18319  
SEATTLE, WASHINGTON 98118

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

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

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VENDORS

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

30163 DAYRON CORP  
333 MAGUIRE BLVD PO BOX 20394  
ORLANDO, FLORIDA 32814

38443 TRW INC BEARING DIV  
402 CHANDLER STREET  
JAMESTOWN, NEW YORK 14701

43991 FAG BEARING INCORPORATED  
HAMILTON AVENUE  
STAMFORD, CONNECTICUT 06904

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

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

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

77896 REXNORD INC BEARING OPERATION  
2400 CURTIS STREET  
DOWNERS GROVE, ILLINOIS 60515

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

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VENDORS

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

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN960-516		1	20	1
AN960C10L		1	30	1
AN960XC10L		1	145	1
BACB10BW16		1	170	2
		1	175A	2
		1	175B	2
BACB28AK06-027		1	70	1
BACB28AK08-021		1	100	2
BACB28X6E020		1	75	1
		1	105	2
BACB28Y6E027		1	95	2
BACB28Y9E021		1	65	1
BACB30LT3U7		1	140	1
BACB30LT6U20		1	10	2
BACB30MY6K20		1	15	1
BACB30NM3K20		1	115	1
BACB30NM3K7		1	140A	1
BACN10JC3CM		1	45	1
		1	125	1
		1	150	1
BACN10JC6CM		1	40	2
BACN10JP3A		1	195	2
		1	215	2
		1	235	2
BACN10JP3C		1	200	3
		1	220	2
		1	240	2
BACN10JP4C		1	185	8
BACN10YR3CM		1	150A	1
BACR12Y49		1	160	2
BACR15BB6AD7		1	178	6
BACR15DR3D		1	180	16
		1	190	10
		1	210	8
		1	230	8
BACW10BN6UC		1	25	2
BRM200A3		1	195	2
		1	215	2
		1	235	2
BRM300A3		1	200	3
		1	220	2
		1	240	2
BRM300A4		1	185	8
BR1110C3M		1	45	1
		1	125	1
		1	150	1
BR1110C6M		1	40	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
DDR6-85A1-501		1	85	1
H01-3BAC		1	45	1
H01-6BAC		1	40	2
KP16B		1	170	2
KP16BG27		1	170	2
KP16B2TS		1	170	2
LLKP16B		1	170	2
MK1000-3BAC		1	195	2
MK3000-3BAC		1	200	3
MK3000-4BAC		1	185	8
NAS509-5		1	35	2
NAS565-31		1	5	1
NAS620A10L		1	120	2
NS103197-02		1	195	2
NS103199-02		1	200	3
NS103199-048		1	185	8
NS202101SE02		1	45	1
RMA9201M3		1	195	2
RMA9205M3		1	200	3
RMA9205M4		1	185	8
SAT16-24A1-501		1	175	2
SAT16-24B1-501		1	175	2
S012T236-201		1	85	1
T6C1032JM		1	45	1
T8076S1032		1	195	2
T8078S1032		1	200	3
T8078S428		1	185	8
VN202A1-02		1	195	2
VN203A1-02		1	200	3
VN203A1-048		1	185	8
VN303D02		1	45	1
102LH9075-6		1	40	2
109LH9075-3W		1	45	1
141T6163-2		1	50	1
141T6164-2		1	130	1
141T6164-3		1	130A	1
		1	130B	1
141T6166-5		1	90	1
141T6166-6		1	110	1
141T6166-7		1	90A	1
		1	90B	1
141T6166-8		1	110A	1
141T6167-3		1	60	1
141T6167-4		1	80	1
141T6172-21		1	135	1
141T6172-22		1	137	1
141T6172-23		1	205	1

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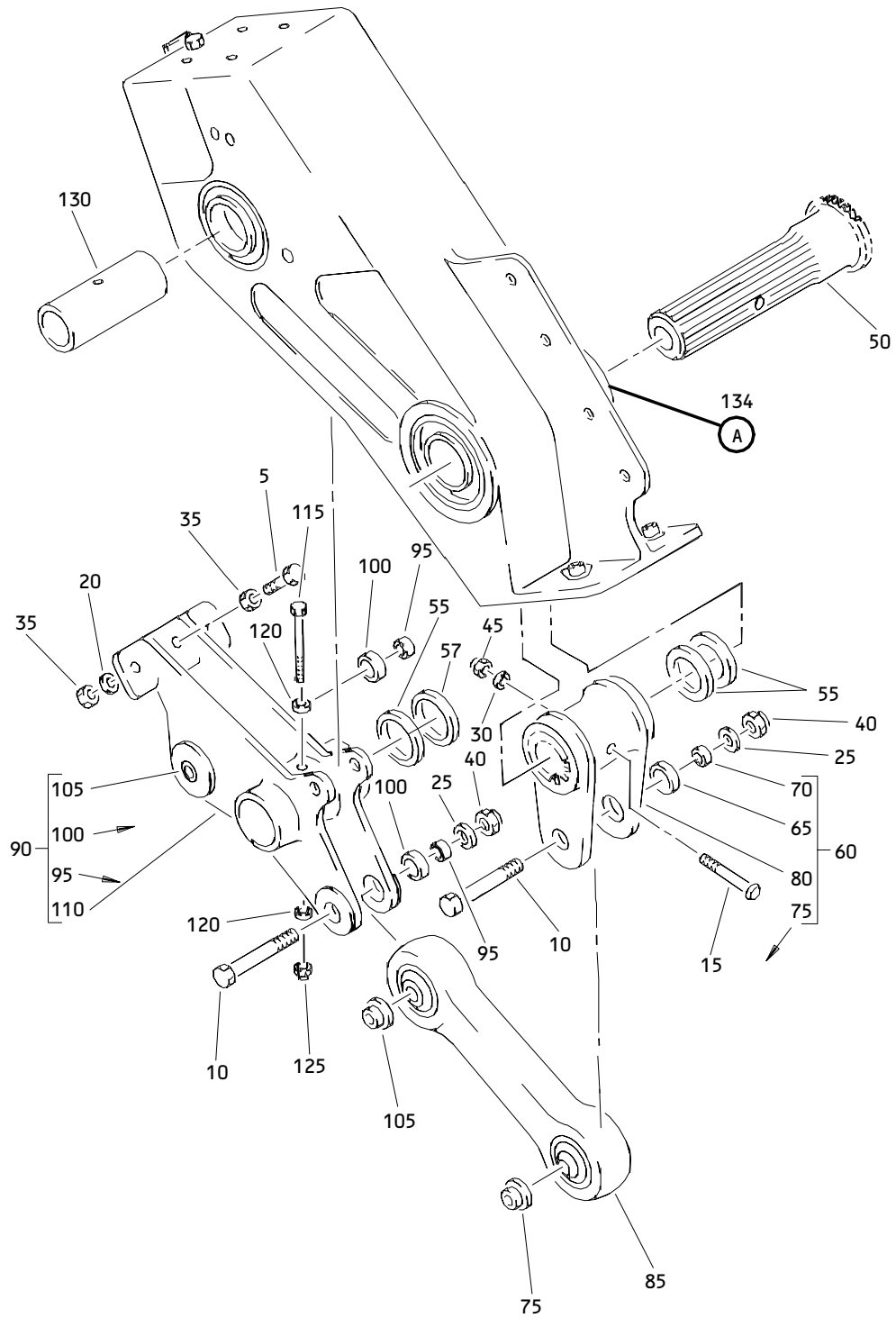
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T6172-24		1	225B	1
141T6172-25		1	205A	1
141T6172-26		1	225C	1
141T6172-27		1	134	1
141T6172-28		1	137A	1
141T6172-41		1	135F	1
		1	135G	1
141T6172-42		1	137B	1
		1	137C	1
141T6172-43		1	205B	1
141T6172-44		1	225D	1
141T6172-45		1	135H	1
		1	135J	1
141T6172-46		1	137D	1
		1	137E	1
141T6172-47		1	205C	1
141T6172-48		1	225E	1
141T6172-5		1	225	1
141T6172-6		1	245	1
141T6172-7		1	225A	1
141T6172-8		1	245A	1
141T6178-1		1	55	3
		1	57	1
		1	57A	1
141T6218-1		1	155	1
141T6989-1		1	177	2
146T6125-15		1	1	RF
146T6125-16		1	2	RF
146T6125-19		1	1A	RF
146T6125-20		1	2A	RF
146T6125-23		1	1F	RF
146T6125-24		1	2B	RF
146T6125-27		1	1G	RF
146T6125-28		1	2C	RF
146T6153-9		1	165	2
60B00178-200		1	175	2
97E02		1	45	1
97E064		1	40	2

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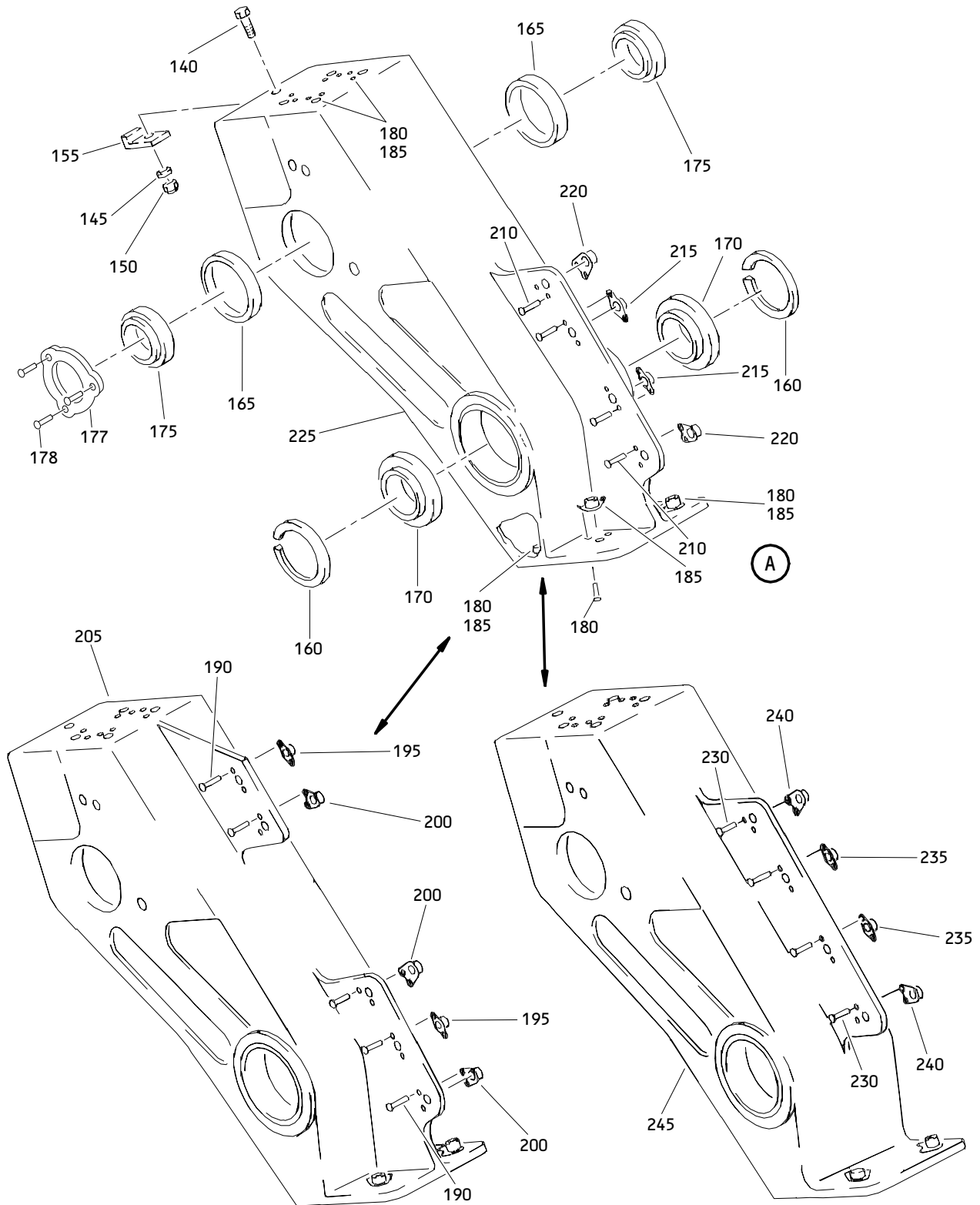
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Section 46 Entry/Service Doors Overcenter Mechanism Assembly  
 Figure 1 (Sheet 1)

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Section 46 Entry/Service Doors Overcenter Mechanism Assembly  
 Figure 1 (Sheet 2)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -1	146T6125-15		MECHANISM ASSY-SECT. 46 ENTRY/SVCE DOORS OVERCTR	A	RF
-1A	146T6125-19		MECHANISM ASSY-SECT. 46 ENTRY/SVCE DOORS OVERCTR	B	RF
-1F	146T6125-23		MECHANISM ASSY-SECT. 46 ENTRY/SVCE DOORS OVERCTR	E	RF
-1G	146T6125-27		MECHANISM ASSY-SECT. 46 ENTRY/SVCE DOORS OVERCTR	F	RF
-2	146T6125-16		MECHANISM ASSY-SECT. 46 ENTRY/SVCE DOORS OVERCTR	C	RF
-2A	146T6125-20		MECHANISM ASSY-SECT. 46 ENTRY/SVCE DOORS OVERCTR	D	RF
-2B	146T6125-24		MECHANISM ASSY-SECT. 46 ENTRY/SVCE DOORS OVERCTR	G	RF
-2C	146T6125-28		MECHANISM ASSY-SECT. 46 ENTRY/SVCE DOORS OVERCTR	H	RF
5	NAS565-31		.BOLT		1
10	BACB30LT6U20		.BOLT- (V06710) (SPEC BACB30LT6U20) (OPT BACB30LT6U20 (V06725)) (OPT BACB30LT6U20 (V17943)) (OPT BACB30LT6U20 (V27624)) (OPT BACB30LT6U20 (V80539)) (OPT BACB30LT6U20 (V92215)) (OPT BACB30LT6U20 (V93907)) (OPT BACB30LT6U20 (V97928))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-15	BACB30MY6K20		.BOLT		1
20	AN960-516		.WASHER		1
25	BACW10BN6UC		.WASHER- (V10630) (SPEC BACW10BN6UC)		2
30	AN960C10L		.WASHER		1
35	NAS509-5		.NUT		2
40	BR1110C6M		.NUT- (V52828) (SPEC BACN10JC6CM) (OPT H01-6BAC (V15653)) (OPT 102LH9075-6 (V72962)) (OPT 97E064 (V80539))		2
45	BR1110C3M		.NUT- (V52828) (SPEC BACN10JC3CM) (OPT H01-3BAC (V15653)) (OPT NS202101SE02 (V80539)) (OPT T6C1032JM (V11815)) (OPT VN303D02 (V92215)) (OPT 109LH9075-3W (V72962)) (OPT 97E02 (V80539))		1
50	141T6163-2		.SHAFT-DRIVE		1
55	141T6178-1		.RING-SPACER		3
57	141T6178-1		.RING-SPACER	E-H	1
-57A	141T6178-1		.RING-SPACER (POST SB 52-0056)	A-D	1
60	141T6167-3		.CRANK ASSY-DRIVE SHAFT		1
65	BACB28Y9E021		..BUSHING- (V23294) (SPEC BACB28Y9E021) (OPT BACB28Y9E021 (V70265)) (OPT BACB28Y9E021 (V94892))		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-70	BACB28AK06-027		..BUSHING- (V23294) (SPEC BACB28AK06-027) (OPT BACB28AK06-027 (V70265)) (OPT BACB28AK06-027 (V94892))		1
75	BACB28X6E020		..BUSHING- (V23294) (SPEC BACB28X6E020) (OPT BACB28X6E020 (V70265)) (OPT BACB28X6E020 (V94892))		1
80	141T6167-4		..CRANK		1
85	DDR6-85A1-501		.LINK (V77896) (SPEC S012T236-201)		1
90	141T6166-5		.CRANK ASSY (PRE SB 52-0056)	A-D	1
90A	141T6166-7		.CRANK ASSY	E-H	1
90B	141T6166-7		.CRANK ASSY (POST SB 52-0056)	A-D	1
95	BACB28Y6E027		..BUSHING- (V23294) (SPEC BACB28Y6E027) (OPT BACB28Y6E027 (V70265)) (OPT BACB28Y6E027 (V94892))		2
100	BACB28AK08-021		..BUSHING- (V23294) (SPEC BACB28AK08-021) (OPT BACB28AK08-021 (V70265)) (OPT BACB28AK08-021 (V94892))		2
105	BACB28X6E020		..BUSHING- (V23294) (SPEC BACB28X6E020) (OPT BACB28X6E020 (V70265)) (OPT BACB28X6E020 (V94892))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-110	141T6166-6		..CRANK (USED ON ITEM 90)		1
110A	141T6166-8		..CRANK (USED ON ITEM 90A)	E-H	1
115	BACB30NM3K20		.BOLT- (V06710) (SPEC BACB30NM3K20) (OPT BACB30NM3K20 (V06725)) (OPT BACB30NM3K20 (V06950)) (OPT BACB30NM3K20 (V08524)) (OPT BACB30NM3K20 (V27624)) (OPT BACB30NM3K20 (V56878)) (OPT BACB30NM3K20 (V73197)) (OPT BACB30NM3K20 (V80539)) (OPT BACB30NM3K20 (V92215)) (OPT BACB30NM3K20 (V93907)) (OPT BACB30NM3K20 (V97928))		1
120	NAS620A10L		.WASHER		2
125	BR1110C3M		.NUT- (V52828) (SPEC BACN10JC3CM) (REFER TO ITEM 45 FOR OPT PARTS)		1
130	141T6164-2		.SLEEVE-PIVOT (PRE SB 52-0056)	A-D	1
130A	141T6164-3		.SLEEVE-PIVOT	E-H	1
130B	141T6164-3		.SLEEVE-PIVOT (POST SB 52-0056)	A-D	1
134	141T6172-27		.HOUSING ASSY-LH (PRE SB 52-0056)	B	1
-135	141T6172-21		.HOUSING ASSY-LH (PRE SB 52-0056)	A	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
135F	141T6172-41		.HOUSING ASSY-LH	E	1
135G	141T6172-41		.HOUSING ASSY-LH (POST SB 52-0056)	A	1
135H	141T6172-45		.HOUSING ASSY-LH	F	1
135J	141T6172-45		.HOUSING ASSY-LH (POST SB 52-0056)	B	1
-137	141T6172-22		.HOUSING ASSY-RH (PRE SB 52-0056)	C	1
-137A	141T6172-28		.HOUSING ASSY-RH (PRE SB 52-0056)	D	1
137B	141T6172-42		.HOUSING ASSY-RH	G	1
137C	141T6172-42		.HOUSING ASSY-RH (POST SB 52-0056)	C	1
137D	141T6172-46		.HOUSING ASSY-RH	H	1
137E	141T6172-46		.HOUSING ASSY-RH (POST SB 52-0056)	D	1
140	BACB30LT3U7		..BOLT- (V06710) (SPEC BACB30LT3U7) (OPT BACB30LT3U7 (V06725)) (OPT BACB30LT3U7 (V17943)) (OPT BACB30LT3U7 (V27624)) (OPT BACB30LT3U7 (V80539)) (OPT BACB30LT3U7 (V92215)) (OPT BACB30LT3U7 (V93907)) (OPT BACB30LT3U7 (V97928))	A-D	1
140A	BACB30NM3K7		..BOLT	E-H	1
145	AN960XC10L		..WASHER		1
150	BR1110C3M		..NUT- (V52828) (SPEC BACN10JC3CM) (REFER TO ITEM 45 FOR OPT PARTS)	A-D	1
150A	BACN10YR3CM		..NUT	E-H	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
155	141T6218-1		..CAP		1
160	BACR12Y49		..RING- (V08073) (SPEC BACR12Y49) (OPT BACR12Y49 (V15805))	A-D	2
165	146T6153-9		..SLEEVE (PRE SB 52-0056)	A-D	2
170	KP16B		..BEARING- (V38443) (SPEC BACB10BW16) (OPT KP16B2TS (V43991)) (OPT LLKP16B (V38443)) (OPT KP16BG27 (V30163))		2
175	SAT16-24A1-501		..BEARING- (PRE SB 52-0056) (V77896) (SPEC 60B00178-200) (OPT SAT16-24B1-501 (V77896))	A-D	2
175A	BACB10BW16		..BEARING	E-H	2
175B	BACB10BW16		..BEARING (POST SB 52-0056)	A-D	2
177	141T6989-1		..RETAINER-BEARING (POST SB 52-0056)	A-D	2
178	BACR15BB6AD7		..RIVETS (POST SB 52-0056)	A-D	6
180	BACR15DR3D		..RIVET		16
185	BRM300A4		..NUTPLATE- (V52828) (SPEC BACN10JP4C) (OPT MK3000-4BAC (V15653)) (OPT NS103199-048 (V80539)) (OPT RMA9205M4 (V72962)) (OPT T8078S428 (V11815)) (OPT VN203A1-048 (V92215))		8

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 190 195	BACR15DR3D BRM200A3		..RIVET ..NUTPLATE- (V52828) (SPEC BACN10JP3A) (OPT MK1000-3BAC (V15653)) (OPT NS103197-02 (V80539)) (OPT RMA9201M3 (V72962)) (OPT T8076S1032 (V11815)) (OPT VN202A1-02 (V92215))	A A	10 2
200	BRM300A3		..NUTPLATE- (V52828) (SPEC BACN10JP3C) (OPT MK3000-3BAC (V15653)) (OPT NS103199-02 (V80539)) (OPT RMA9205M3 (V72962)) (OPT T8078S1032 (V11815)) (OPT VN203A1-02 (V92215))	AE	3
205	141T6172-23		..HOUSING-LH (OPT ITEM 205A)	A	1
-205A	141T6172-25		..HOUSING-LH (OPT ITEM 205)	A	1
-205B	141T6172-43		..HOUSING-LH	E	1
-205C	141T6172-47		..HOUSING-LH	F	1
210	BACR15DR3D		..RIVET	BCGF	8
215	BRM200A3		..NUTPLATE- (V52828) (SPEC BACN10JP3A) (REFER TO ITEM 195 FOR OPT PARTS)	BCGF	2
220	BRM300A3		..NUTPLATE- (V52828) (SPEC BACN10JP3C) (REFER TO ITEM 200 FOR OPT PARTS)	BC	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-225	141T6172-5		..HOUSING-LH (OPT ITEM 225A)	B	1
-225A	141T6172-7		..HOUSING-LH (OPT ITEM 225)	B	1
-225B	141T6172-24		..HOUSING-RH (OPT ITEM 225C)	C	1
-225C	141T6172-26		..HOUSING-RH (OPT ITEM 225B)	C	1
-225D	141T6172-44		..HOUSING-RH	G	1
-225E	141T6172-48		..HOUSING-RH	H	1
230	BACR15DR3D		..RIVET	DH	8
235	BRM200A3		..NUTPLATE- (V52828) (SPEC BACN10JP3A) (REFER TO ITEM 195 FOR OPT PARTS)	DH	2
240	BRM300A3		..NUTPLATE- (V52828) (SPEC BACN10JP3C) (REFER TO ITEM 200 FOR OPT PARTS)	DH	2
245	141T6172-6		..HOUSING-RH (OPT ITEM 245A)	D	1
-245A	141T6172-8		..HOUSING-RH (OPT ITEM 245)	D	1

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