TO: ALL HOLDERS OF EMERGENCY EXIT DOOR MECHANISM INSTALLATION COMPONENT MAINTENANCE MANUAL 52-22-21

REVISION NO. 6 DATED MAR 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
TITLE PAGE	Added top assemblies 146T6550-5, -6 in accord with current engineering.
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BOEING

COMPONENT
MAINTENANCE MANUAL

EMERGENCY EXIT DOOR MECHANISM INSTALLATION

PART NUMBERS 146T6550-1 THRU -6

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

684729

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

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602	BLANK	
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*1048	MAR 01/04	01.1
*1049	MAR 01/04	01.1
*1050	MAR 01/04	01.1
*1051	MAR 01/04	01.1
*1052	MAR 01/04	01.1
*1053	MAR 01/04	01.1
*1054	MAR 01/04	01.1
*1055	MAR 01/04	01.1
*1056	MAR 01/04	01.1
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*1062	MAR 01/04	01.1

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

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.

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.

EMERGENCY EXIT DOOR MECHANISM INSTALLATION

DESCRIPTION AND OPERATION

1. Description

   A. The door mechanism is installed in the door assembly structure. It contains:
      - An internal and external handle
      - A torque tube assembly with latching cranks and rollers
      - Snubbers with a release assembly
      - And the attaching linkage.

2. Operation

   A. Operation of either the inside handle or the outside handle moves the mechanism linkage. This causes the door assembly torque tube to turn. The pressure-relief door immediately opens. This will release the remaining pressure in the passenger cabin. The latch cranks on the forward and the aft ends of the torque tube turn. The rollers on the latch cranks are moved by the latch-cam fittings on the cutout structure frames. The door assembly is lifted 1.30 inches. The pawl-latch mechanisms then engage to hold the door in the lifted position. The two hydraulic snubbers control the rate at which the door is lowered so it will not hit the underside of the fuselage.

DISASSEMBLY

NOTE: Disassemble this component only as necessary to isolate defects, do necessary repairs, and put the component back in a serviceable condition.

1. Use standard industry practices to disassemble the door structure assembly (993 or 996, IPL Fig. 1) as necessary.

2. Disassemble the Emergency-Exit-Door-Mechanism Installation (1, IPL Fig. 1)

A. Remove the control rod assembly (162A) and items (107 thru 116, 137 thru 147).

NOTE: Do not disassemble the control rod assembly (162A) unless necessary for repair or replacement. Write the length of the control rod assembly if disassembly is necessary. Refer to it during assembly.

B. Remove the external handle shaft (33), external handle crank (119 or 122) and items (36 thru 48).

C. Remove the external handle crank assembly (51) and items (6, 12, 15 and 21).

NOTE: Do not disassemble the external handle crank assembly (51) unless necessary for repair or replacement.

D. Remove the tie-rod assembly (24) and items (3, 9, 15 and 18).

NOTE: Do not disassemble the tie-rod assembly (24) unless necessary for repair or replacement.

E. Remove the external handle assembly (125).

NOTE: Do not disassemble the external handle assembly (125) unless necessary for repair or replacement.

F. Remove items (86 thru 104).

G. Remove items (63 thru 72).

H. Remove the fasteners (137 thru 147) to disconnect the control rod assembly (165A) from the idler crank (207 or 210).

I. Remove the idler crank (207 or 210) and items (186 thru 204).

J. Remove the control rod assembly (165A) and items (150 thru 159).

NOTE: Do not disassemble the control rod assembly (165A) unless necessary for repair or replacement. Write the length of the control rod assembly if disassembly is necessary. Refer to it during assembly.

K. Remove the fasteners (276A thru 285). Write the number of spacers (279) used. Refer to it during assembly.

L. Remove the control rod assembly (303A).

NOTE: Do not disassemble the control rod assembly (303A) unless necessary for repair or replacement. Write the length of the control rod assembly if disassembly is necessary. Refer to it during assembly.

M. Remove items (243 thru 249) and the handle (270 or 273).

NOTE: Do not move apart the inner handle (270 or 273) and the crank (264 or 267). A 0.190 to 0.194 hole was drilled through the two during the initial assembly.

N. Remove items (213 thru 240).

O. Remove the idler crank assembly (252 or 255).

NOTE: Do not disassemble the idler crank assembly (252 or 255) unless necessary for repair or replacement.

Do not remove the bushings (234, 237) unless necessary for repair or replacement.

Do not move apart the inner handle (270 or 273) and the crank (264 or 267). A 0.190 to 0.194 hole was drilled through the two during the initial assembly.

P. Remove the fasteners (276A thru 285). Write the number of spacers (279) used. Refer to it during assembly.

Q. Disconnect the control rod assembly (300A) from the idler handle (354A).

R. Remove items (327 thru 342, 351) and the idler handle (354A).

NOTE: Do not remove the bushings (345, 348) unless necessary for repair or replacement.

S. Remove the fasteners (288 thru 297). Write the number of spacers (291) used. Refer to it during assembly.

T. Remove the control rod assembly (300A).

NOTE: Do not disassemble the control rod assembly (300A) unless necessary for repair or replacement. Write the length of the control rod assembly if disassembly is necessary. Refer to it during assembly.

U. Remove items (504 thru 528).

V. Remove and disassemble the torque tube assembly (531 or 534).

(1) Disengage the spring (579 or 585) from the spacer (597).

(2) Remove the fasteners (537 thru 543).

(3) Remove the cranks (546) and the spacers (558). Write the number and the location of the spacers (558) used. Refer to it during assembly.

(4) Remove the fasteners (564 thru 570).

(5) Remove the bearing housing (573 or 576) and the bearings (561).

(6) Remove the torque tube (555) through the aft edge of the door. Remove the cam (549), the washer (591), the spring (579 or 585), the torque tube sleeve (588), and the crank (552).

(7) Remove items (594 thru 603).

W. Remove the pressure relief door assembly (453 or 456).

(1) Remove items (357 thru 372), the fitting assemblies (375, 387), the washer (393) and the spring (396). Write the number of the washers (393) used. Refer to it during assembly.

NOTE: Do not disassemble the fitting assemblies (375 and 387) unless necessary for repair or replacement.

(2) Remove the fasteners (291, 399 thru 414) and the control rod assembly (417A). Write the number of spacers (291) used. Refer to it during assembly.

NOTE: Do not disassemble the control rod assembly (417A) unless necessary for repair or replacement. Write the length of the control rod assembly if disassembly is necessary. Refer to it during assembly.

(3) Remove items (438 thru 450).

(4) Remove the pressure relief door assembly (1, IPL Fig. 2).

NOTE: Do not disassemble the pressure relief door assembly (453 or 456) unless necessary for repair or replacement.

X. Remove items (486 thru 498).

Y. Remove items (459 thru 477) and the bearings (484). Write the number of washers (468 and 471) used. Refer to it during assembly.

NOTE: Do not remove the bushings (480 and 483) unless necessary for repair or replacement.

Z. Remove the idler crank (501).

AA. Remove items (606 thru 654).

NOTE: Do not remove the bushings (627 and 630) unless necessary for repair or replacement.

AB. Remove items (645L, 645Q, 645V, 646, 646L, 652, 655, 656).

NOTE: Do not remove the bushings (646Q) unless necessary for repair or replacement.

AC. Remove items (658 thru 670) and disconnect the spring (718).

AD. Remove items (709 thru 715) and disconnect the cable (721).

AE. Remove items (673 thru 694) and remove the pawl assembly (703, 706).

NOTE: Do not remove the cable (721) unless necessary for repair or replacement.

Do not remove the bushings (697, 700) unless necessary for repair or replacement.

AF. Disassemble the pawl assembly (703, 706).

(1) Remove the nut (724), the washer (727) and the adjusting screw (730) from the pawl (733, 736).

AG. Remove items (912 thru 921) and (930 thru 942). Write the number of washers (936) used. Refer to it during assembly.

AH. Remove the hinge end link assembly (945) and the hinge fitting assembly (963, 966).

NOTE: Do not remove the bushings (948) from the link (951) unless necessary for repair or replacement.

Do not disassemble the hinge fitting assembly (963, 966) unless necessary for repair or replacement.

AI. Remove the fasteners (894 thru 900) and the support walkway (909).

AJ. Remove items (870 thru 891) and the angle (903, 906).

AK. Remove items (807 thru 816, 822, 828) and the links (924 thru 927). Write the number of washers (810) used. Refer to it during assembly.

AL. Remove items (792 thru 804) and the center link assembly (954). Write the number of washers (798) used. Refer to it during assembly.

NOTE: Do not remove the bushings (957) from the link (960) unless necessary for repair or replacement.

AM. Remove the fasteners (819, 825, 840 thru 850) and the link assemblies (855, 858). Write the number of washers (848) used. Refer to it during assembly.

NOTE: Do not remove the bushings (861) from the link (864, 867) unless necessary for repair or replacement.

AN. Remove the snubber assembly (852) from the support assembly (831).

NOTE: Do not disassemble the snubber assembly (852) unless necessary for repair or replacement. Refer to the manufacturer's instructions if disassembly is necessary.

AO. Remove the fasteners (774 thru 780) and the bearings (783).

AP. Remove the support assembly (831).

AQ. Remove items (748 thru 766) and the lower idler (786, 789). Write the number of washers (759) used. Refer to it during assembly.

NOTE: Do not remove the bushings (768 and 771) unless necessary for repair or replacement.

AR. Remove the cotter pin (739), the washer (742) and the stop (745).

CHECK

1. Do a check of all parts for defects. Refer to standard industry practices.

2. Do a magnetic particle check of these parts as shown in 20-20-01.

   IPL Fig. 1

   A. Rod (30)
   B. Shaft (33)
   C. Crank (60, 119, 122, 207, 210, 264, 267, 546, 552)
   D. Cam (549)
   E. Torque Tube (555)
   F. Spring (579, 585)
   G. Screw (730)
   H. Link (924, 925, 927, 960)
   I. Lock (969, Material: 15-5 PH, 150-170 ksi)
   J. Fitting (981, 983)

3. Do a penetrant check of these parts as shown in 20-20-02.

   IPL Fig. 1

   A. Trigger (104)
   B. Handle (134, 270, 273, 354A)
   C. Pushrod (183B, 321A, 324A, 435A)
   D. Crank (501)
   E. Idler (654, 655, 656, 786, 789)
   F. Pawl (733, 736)
   G. Fitting (837)
   H. Link ((864, 867, 951)
   I. Lock (969 Material: Al alloy)

   IPL Fig. 2

   A. Door (90, 95)

IPL Fig. 4

A. Door (85, 90)

IPL Fig. 5

A. Door (105, 110)

4. Do a check on the splines for wear that is not equal.

5. Check torsion spring (396, IPL Fig. 1).

   A. Compress the spring to 4.40 inches.

   B. Make sure the load is 19.3 to 27.3 pounds.

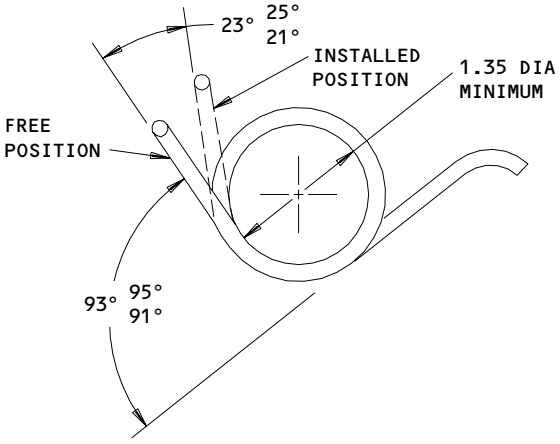
   C. Compress the spring to 3.36 inches.

   D. Make sure there is no permanent set.

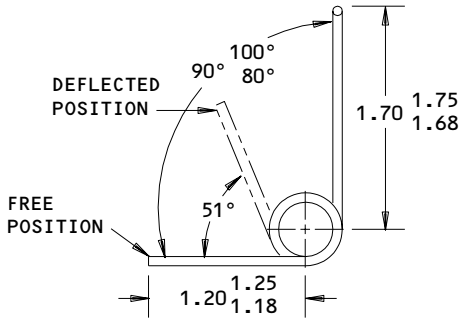
6. Check the torsion springs (98, 579, 585) for the load limits per Fig. 501.

7. Check the snubber assembly (852) per the manufacturer's instructions.

8. Check the assist spring (652) per the manufacturer's instructions.



TORSION SPRING (579,585)



TRIGGER SPRING (98)

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

Spring Check
Figure 501

684781

ITEM NUMBER IPL FIGURE 01	TEST DEFLECTION FROM FREE POSITION (DEGREES)	ALLOWABLE LOAD LIMITS (POUND - INCHES)
98	48-54	3.64 (3.26-4.30) *[1]
579,585	21-25	6.0 (5.0-7.0) *[2]
*[1] Maximum angular rotation without permanent set = 80 degrees. *[2] Maximum angular rotation without permanent set = 180 degrees.		

Torsion Spring Data
Figure 501

REPAIR - GENERAL

1. Content

A. Instructions for repair, refinish and replacement are divided into procedures as follows:

P/N	NAME	REPAIR
146N6328	PRESSURE RELIEF DOOR ASSY	1-1
146N6334	TIE ROD ASSEMBLY	2-1
146N6344	FITTING ASSEMBLY	3-1
146N6345	FITTING ASSEMBLY	4-1
146N6356	EXTERIOR HANDLE ASSEMBLY	5-1
146N6358	CRANK ASSEMBLY	6-1
146T6551	HINGE END LINK ASSEMBLY	7-1
146T6554	CENTER LINK ASSEMBLY	8-1
146T6555	HINGE FITTING ASSEMBLY	9-1
146T6556	SNUBBER SUPPORT ASSEMBLY	10-1
146T6558	PAWL ASSEMBLY	11-1
146T6561	SNUBBER LINK ASSEMBLY	12-1
- -	REPLACEMENT OF OTHER BUSHINGS	13-1
- -	REFINISH OF OTHER PARTS	14-1

2. Standard Practices

A. Refer to these standard practices for details of the procedures in the repairs.

20-30-02 Stripping of Protective Finishes
20-30-03 General Cleaning Procedures
20-41-01 Decoding Table for Boeing Finish Codes
20-42-02 Low Hydrogen Embrittlement Cadmium-Titanium Alloy Plating
20-42-03 Hard Chrome Plating
20-42-05 Bright Cadmium Plating
20-50-03 Bearing Installation and Retention
20-50-08 Application of Dry Lubricant
20-60-03 Lubricants

3. Materials

NOTE: Equivalent replacements can be used.

A. Compound, corrosion preventive - BMS 3-23, type 12 (Ref 20-60-04)

B. Enamel (Ref 20-60-02)

(1) BMS 10-60, type 2, BAC 707 grey gloss

(2) BMS 10-86, type 1 or 2, white

(3) BMS 10-11, type 2, BAC 702 white gloss

(4) BMS 10-11, type 2, epoxy black flat

(5) BMS 10-11, type 2, black gloss

C. Lubricant - BMS 3-8, class A (Ref 20-60-03)

D. Primer (Ref 20-60-02)

(1) BMS 10-11, type 1

(2) BMS 10-79, type 2

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

4. Dimensioning Symbols

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

—	STRAIGHTNESS
▱	FLATNESS
⊥	PERPENDICULARITY (OR SQUARENESS)
//	PARALLELISM
○	ROUNDNESS
⌭	CYLINDRICITY
⌒	PROFILE OF A LINE
⌓	PROFILE OF A SURFACE
◎	CONCENTRICITY
⌯	SYMMETRY
∠	ANGULARITY
↗	RUNOUT
⌰	TOTAL RUNOUT
⌴	COUNTERBORE OR SPOTFACE
	COUNTERSINK
⌖	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
∅	DIAMETER
S ∅	SPHERICAL DIAMETER
R	RADIUS
SR	SPHERICAL RADIUS
()	REFERENCE
BASIC (BSC) OR DIM	A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE FROM WHICH PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
-A-	DATUM
Ⓜ	MAXIMUM MATERIAL CONDITION (MMC)
Ⓛ	LEAST MATERIAL CONDITION (LMC)
Ⓢ	REGARDLESS OF FEATURE SIZE (RFS)
Ⓟ	PROJECTED TOLERANCE ZONE
FIM	FULL INDICATOR MOVEMENT

EXAMPLES

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

(NOTE THAT ⌓ A 0.020 MAY ALSO APPEAR AS ⌓ 0.020 A)

True Position Dimensioning Symbols
Figure 601

PRESSURE RELIEF DOOR ASSEMBLY - REPAIR 1-1

146N6328-9, -10, -21, -22, -25, -26

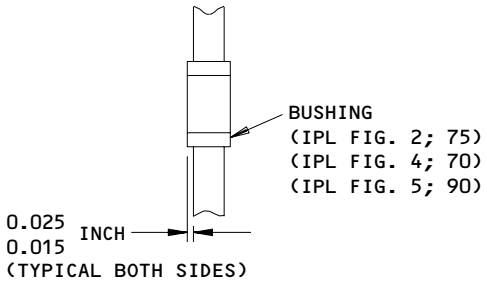
NOTE: Refer to REPAIR-GEN for list of applicable standard practices.

1. Bushing Replacement (75, 80, 85, IPL Fig. 2; 70, 75, 80, IPL Fig. 4; 90, 95, 100, IPL Fig. 5)

   A. Remove the bushings.

   B. Install the bushings (80, 85, IPL Fig. 2; 75, 80, IPL Fig. 4; 95, 100, IPL Fig. 5) per 20-50-03.

   C. Install the bushing (75, IPL Fig. 2; 70, IPL Fig. 4; 90, IPL Fig. 5) per 20-50-03 per Fig. 601.



146N6328-9,-10,-21,-22,-25,-26
Bushing Replacement
Figure 601

2. Bearing Replacement (70, IPL Fig. 2; 65, IPL Fig. 4; 10, IPL Fig. 5)

684735

   A. Remove the bearing.

   B. Install the bearing per 20-50-03.

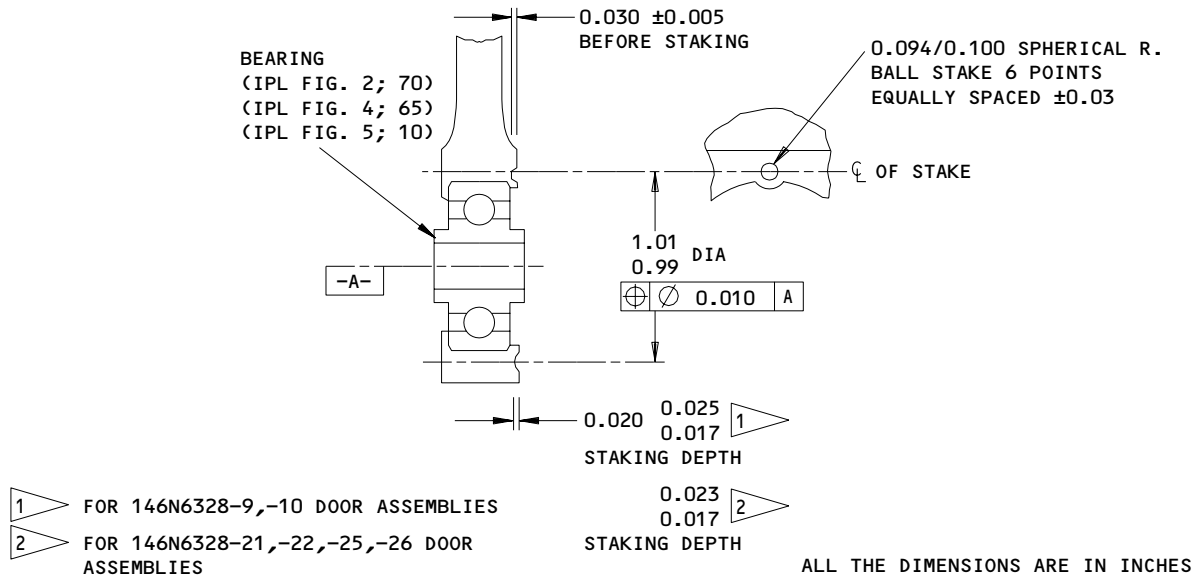
   C. Ball stake the bearing per Fig. 602.

3. Refinish

   A. For 146N6328-9, -10, -25, -26 Door Assemblies: Door (90, 95, IPL Fig. 2), splice plate (30, IPL Fig. 2; 35, IPL Fig. 4; 50, IPL Fig. 5), radius filler (40, IPL Fig. 2; 40, IPL Fig. 4; 95, IPL Fig. 5) -- Chromic acid anodize (F-17.02). Apply BMS 10-79, Type 2 primer. Then apply BMS 10-60, Type 2, enamel, Boeing color 707 grey gloss (F-19.40). Omit the primer and the enamel from the holes and from the area shown in Fig. 603. Sulphuric acid anodize (F-17.03) the area shown in Fig. 603. Material: Al alloy.

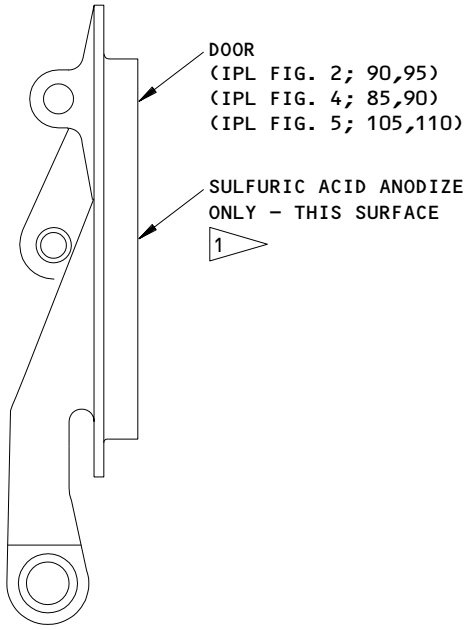
B. For 146N6328-21, -22 Door Assemblies: Door (85, 90, IPL Fig. 4): -- Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31). Apply BMS 10-79, Type 3 primer (F-19.66).

C. Radius filler (35, IPL Fig. 2; 45, IPL Fig. 4; 60, IPL Fig. 5), seal retainer (60, IPL Fig. 2; 55, IPL Fig. 4; 80, IPL Fig. 5) -- Chemical treat and apply BMS 10-11, Type 1 primer (F-18.06). Then apply BMS 10-11, Type 2 enamel, color BAC 702 white gloss (F-21.03). The enamel finish must be 0.0005 to 0.0010 inch thick on the radius filler. Material: Al alloy.



146N6328-9,-10,-21,-22,-25,-26
Bearing Replacement
Figure 602

684736



REFINISH

FOR 146N6328-21,-22 DOOR ASSEMBLIES:
CHEMICAL TREAT (F-17.10). APPLY BMS 10-79,
TYPE 3 PRIMER (F-19.66)

1 FOR 146N6328-9,-10,-25,-26 DOOR ASSEMBLIES

146N6328-9,-10,-21,-22,-25,-26
Door Refinish
Figure 603

684725

TIE ROD ASSEMBLY - REPAIR 2-1

146N6334-1

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

1. Bearing Replacement (27, IPL Fig. 1)

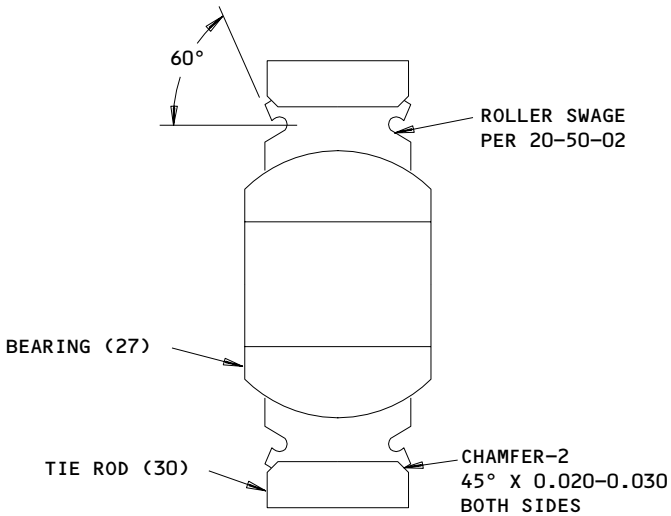
   A. Remove the bearings.

   B. Install the bearings per 20-50-03.

   C. Roller swage the bearings per Fig. 601.

2. Refinish

   A. Tie rod (30) -- cadmium plate (0.0002 to 0.0004 inch) per 20-42-05, type 2, class 3 (F-15.02) all over, except omit from bearing holes. Passivate (F-17.09) bearing holes. Material: 15-5PH CRES, 180-200 ksi.



Bearing Replacement
Figure 601

684742

FITTING ASSEMBLY - REPAIR 3-1

146N6344-4

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

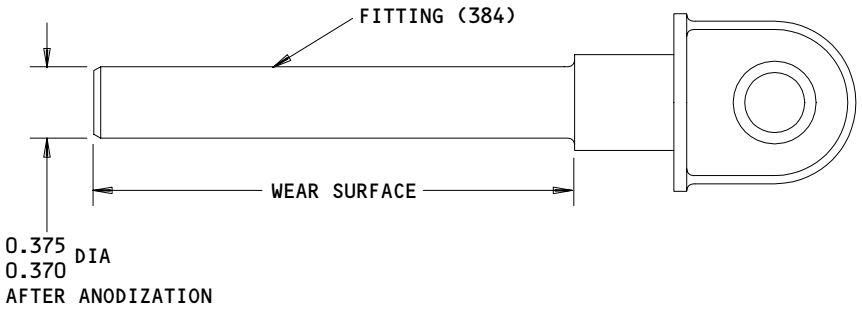
1. Bushing Replacement (378, 381, Fig. 1)

   A. Remove the bushings.

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

2. Refinish

   A. Fitting (384) -- Hard anodize (F-17.06) the wear surface (Fig. 601). Flash anodize the balance of the part 0.0002-0.0004 inch thick. Apply one layer of BMS 10-11, type 1 primer (F-20.02). Then apply one layer of BMS 10-11, type 2 enamel, color BAC 702 white gloss (F-21.03). Omit the primer and the enamel from the bushed holes and the wear surface (Fig. 601). Apply a layer of solid film lubricant BMS 3-8, class A, to the wear surface (Fig. 601) per 20-50-08, method 3. Material: Al alloy.



ALL THE DIMENSIONS ARE IN INCHES
ITEM NUMBERS REFER TO IPL FIG. 1

Fitting Refinish
Figure 601

684744

FITTING ASSEMBLY - REPAIR 4-1

146N6345-4

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

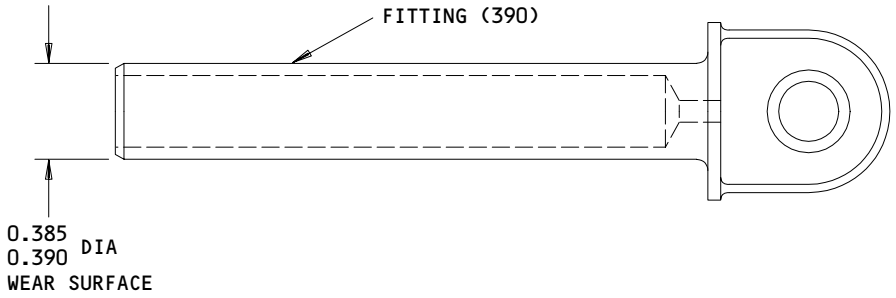
1. Bushing Replacement (389, Fig. 1)

   A. Remove the bushings.

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

2. Refinish

   A. Fitting (390) -- Hard anodize (F-17.06) the wear surface (Fig. 601). Flash anodize the balance of the part 0.0002-0.0004 inch thick. Apply one layer of BMS 10-11, type 1 primer (F-20.02). Then apply one layer of BMS 10-11, type 2 enamel, color BAC 702 white gloss (F-21.03). Omit the primer and the enamel from the bushed holes and the wear surface (Fig. 601). Apply a layer of solid film lubricant BMS 3-8, class A, to the wear surface (Fig. 601) per 20-50-08, method 3. Material: Al alloy.



ALL THE DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

Fitting Refinish
Figure 601

684746

EXTERIOR HANDLE ASSEMBLY - REPAIR 5-1

146N6356-6

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

1. Bushing Replacement (128, 131, IPL Fig. 1)

   A. Remove the bushings.

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

2. Refinish

   A. Handle (134) -- Chromic acid anodize (F-17.02). Apply one layer of BMS 10-79, type 2 primer. Then apply one layer of BMS 10-60, type 2, enamel, Boeing color 707 grey gloss (F-19.40). Material: Al alloy.

CRANK ASSEMBLY - REPAIR 6-1

146N6358-1

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

1. Bushing Replacement (54, 57, IPL Fig. 1)

   A. Remove the bushings.

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

2. Refinish

   A. Crank (60) -- Passivate (F-17.09). Material: 15-5PH or 17-4PH CRES, 180-200 ksi.

HINGE END LINK ASSEMBLY - REPAIR 7-1

146T6551-1

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

1. Bushing Replacement (948, IPL Fig. 1)

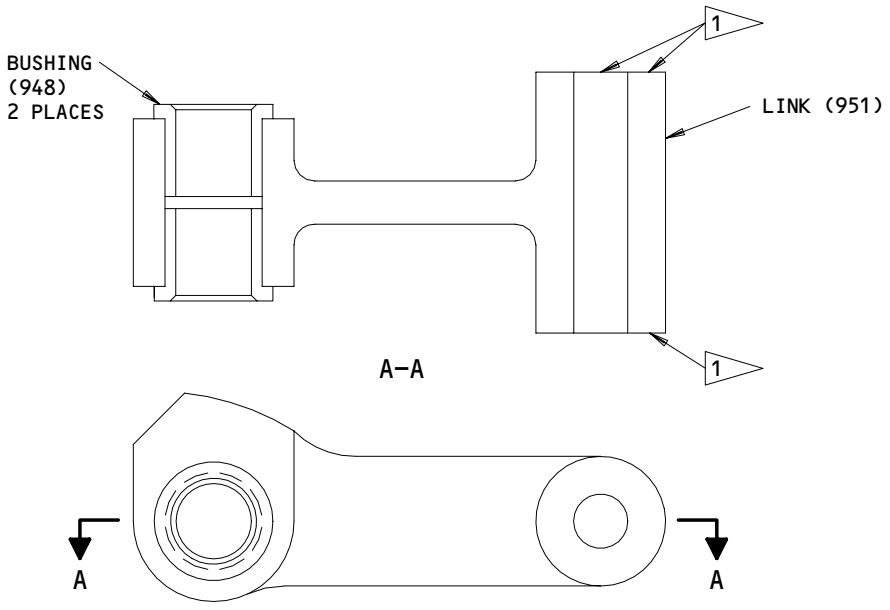
   A. Remove the bushings.

   B. Use BMS 5-95 sealant to install the bushings per 20-50-03.

   C. Use BMS 5-95 sealant to fillet seal the flanges and the gap between the bushings.

2. Refinish

   A. Link (951) -- Chromic acid anodize, type 1. Apply one layer of BMS 10-11, type 1 primer (F-18.13). Then apply one layer of BMS 10-11, type 2 enamel, color BAC 702 white gloss (F-21.03). Omit the primer and the enamel as shown in Fig. 601. Material: Al alloy.



Link Refinish
Figure 601

684783

CENTER LINK ASSEMBLY - REPAIR 8-1

146T6554-1

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

1. Bushing Replacement (957, IPL Fig. 1)

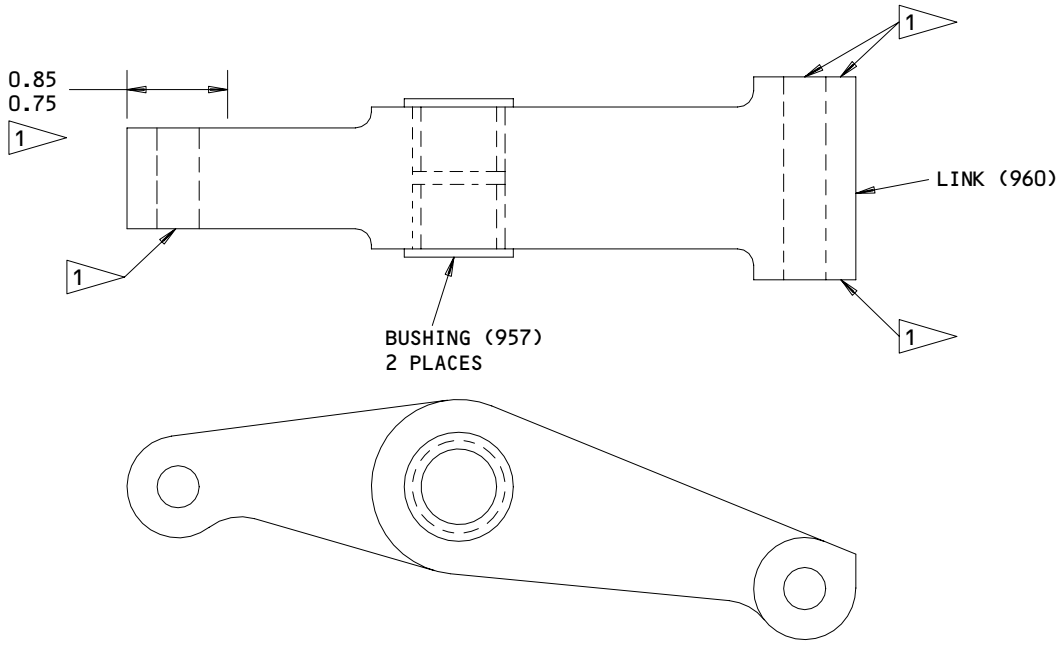
   A. Remove the bushings.

   B. Use BMS 5-95 sealant to install the bushings per 20-50-03.

   C. Use BMS 5-95 sealant to fillet seal the flanges and the gap between the bushings.

2. Refinish

   A. Link (960) -- Cadmium plate 0.0002 to 0.0004 inch thickness (F-15.02). Apply one layer of BMS 10-11, type 1 primer (F-20.02). Then apply one layer of BMS 10-11, type 2 enamel, color BAC 702 white gloss (F-21.03). Omit the primer and the enamel as shown in Fig. 601. Material: 15-5PH, 170-190 ksi.



1 OMIT THE PRIMER AND THE ENAMEL FROM THIS SURFACE

ALL THE DIMENSIONS ARE IN INCHES
ITEM NUMBERS REFER TO IPL FIG. 1

Link Refinish
Figure 601

HINGE FITTING ASSEMBLY - REPAIR 9-1

146T6555-1, -2, -9, -10

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

A. Remove the bushing.

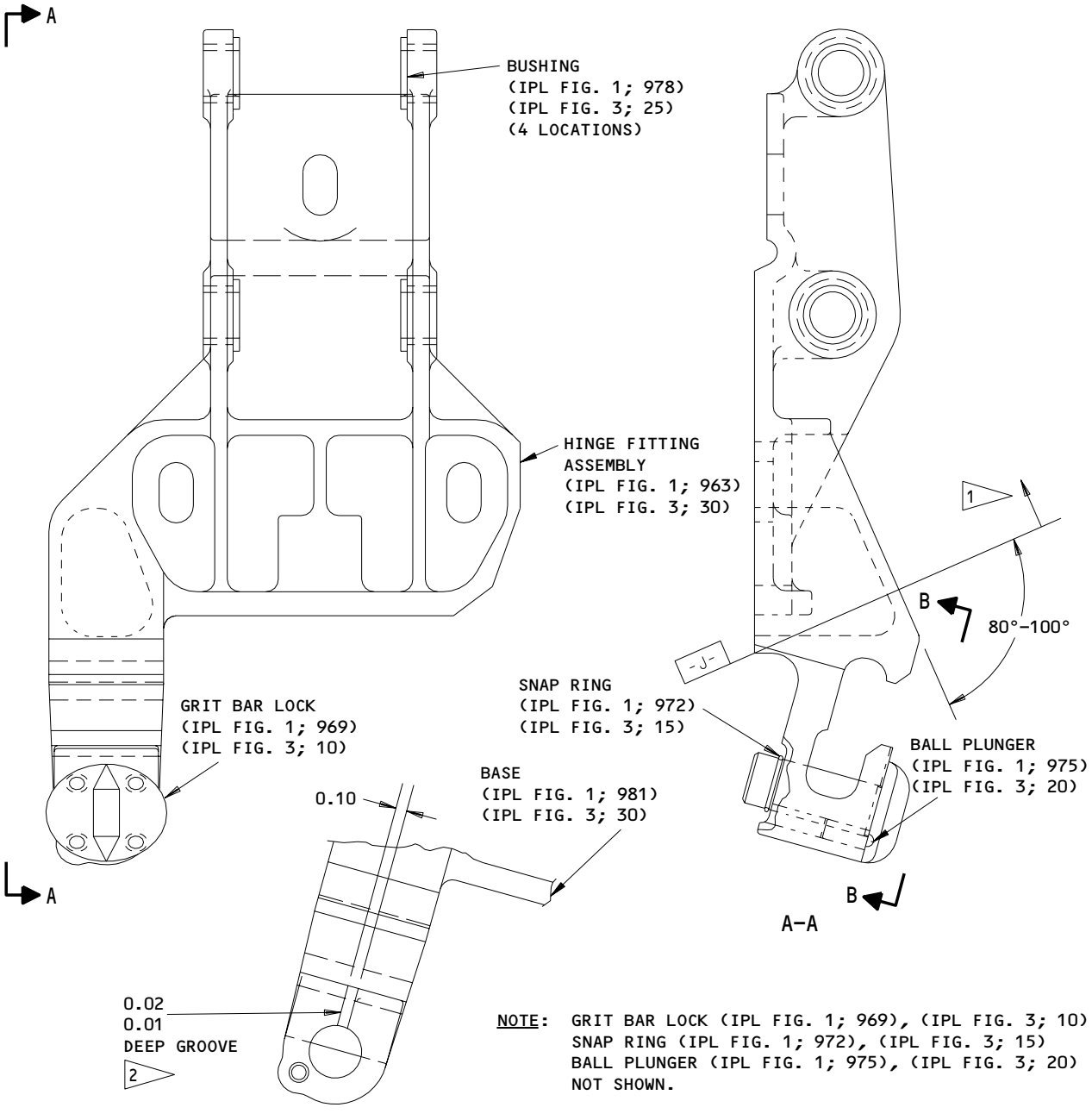
B. Install the bushing per 20-50-03.

1. Refinish

A. Base (981, IPL Fig. 1; 30, IPL Fig. 3; 983, IPL FIG. 1; 35, IPL Fig. 3) -- Cadmium plate 0.0002 to 0.0004 inch thick (F-15.02). Apply one layer of BMS 10-11, type 1, primer (F-20.02). Then apply one layer of BMS 10-11, type 2 enamel, color BAC 702 white gloss. Apply the enamel in the direction shown above the datum plane -J- per Fig. 601. Omit the primer and the enamel from the holes and the serrations. Material: 17-4 PH, 180 ksi (146T6555-3, -4 only), 15-5PH 180-200 ksi (146T6565-7, -8 only).

B. Girt bar lock (969, IPL Fig. 1; 10, IPL Fig. 3) -- Passivate (F-17.09). Add the detail finish per Fig. 602. Apply vitrolube 1220 per 20-50-08. Omit the vitrolube from the interior. Material: 15-5PH, 150-170 ksi.

C. Apply no finish (F-25.01) except for the detail finish per Fig. 602. Material: Al alloy.

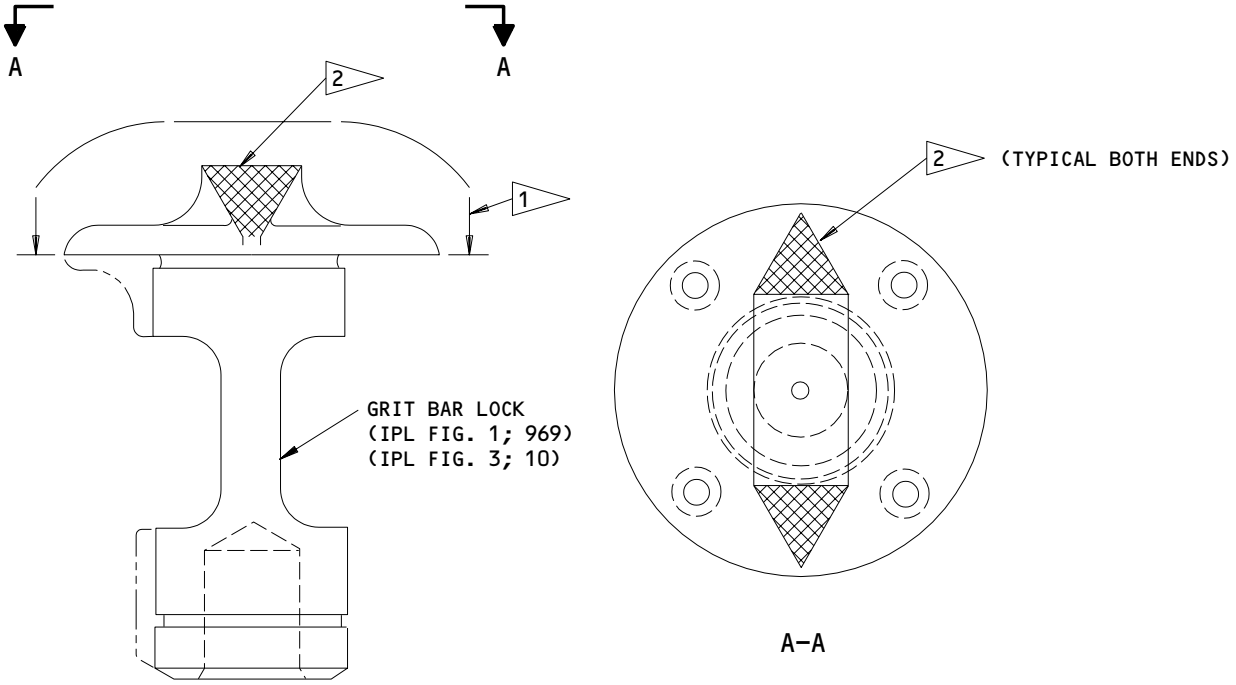


1 APPLY THE FINISH IN THIS DIRECTION

2 PREPARE THE SURFACE PER 20-30-03. APPLY ONE LAYER OF BMS 10-11, TYPE 1, PRIMER (F-18.12). THEN APPLY ONE LAYER OF BMS 10-11, TYPE 2, EPOXY BLACK ENAMEL FLAT (SRF 14.903-701)

ALL THE DIMENSIONS ARE IN INCHES

146T6555-1,-9 SHOWN
146T6555-2,-10 OPPOSITE
Hinge Fitting Assembly Refinish
Figure 601



1 APPLY ONE LAYER OF BMS 10-11, TYPE 1, PRIMER (F-20.02). APPLY ONE LAYER OF BMS 10-11, TYPE 2 WHITE-ENAMEL GLOSS (SRF 14.905-702)

2 APPLY ONE LAYER OF BMS 10-11, TYPE 1, PRIMER (F-20.02). APPLY ONE LAYER OF BMS 10-11, TYPE 2 BLACK-ENAMEL GLOSS (SRF 14.905-701). FOLLOW THE NATURAL-ARROW SHAPE

141T6632-1
Grit Bar Lock Refinish
Figure 602

SNUBBER SUPPORT ASSEMBLY - REPAIR 10-1

146T6556-1, -2

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

1. Bushing Replacement (834, IPL Fig. 1)

   A. Remove the bushings.

   B. Use BMS 5-95 sealant to install the bushings per 20-50-03.

   C. Use BMS 5-95 sealant to fillet seal the flanges.

2. Refinish

   A. Support fitting (837) -- Chromic acid anodize, type 1. Apply one layer of BMS 10-11, type 1 primer (F-18.13). Then apply one layer of BMS 10-11, type 2 enamel, color BAC 702 white gloss (F-21.03). Omit the primer and the enamel from all the holes.

PAWL ASSEMBLY - REPAIR 11-1

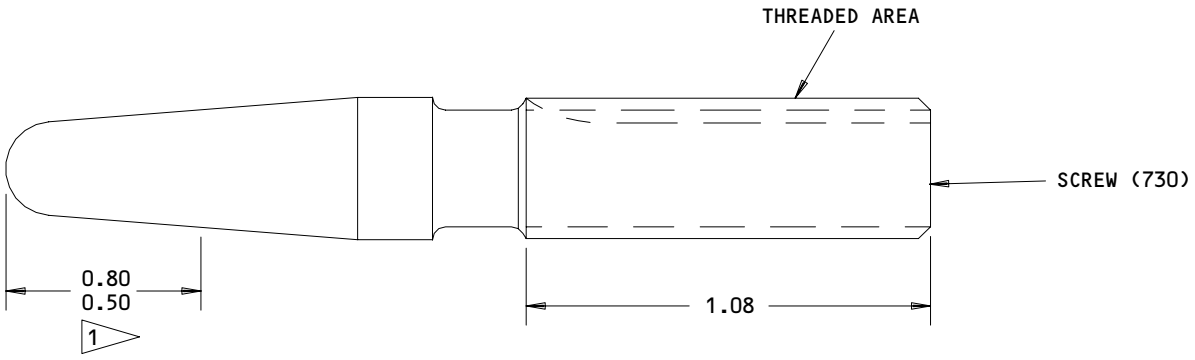
146T6558-1, -2

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

1. Refinish

   A. Pawl (733, 736) -- Chromic acid anodize. Apply one layer of BMS 10-11, type 1 primer (F-18.13). Then apply one layer of BMS 10-11, type 2 enamel, color BAC 702 white gloss (F-21.03). Omit the primer and the enamel from the 0.75 inch and 0.19 inch diameter holes or threads. Material: Al alloy.

   B. Screw (730) -- Cadmium plate 0.0002 to 0.0004 inch thick (F-15.02). Apply one layer of BMS 10-11, type 1 primer (F-20.02). Omit the primer from the threaded area. Apply one layer of BMS 10-86, type 1 or 2 color white (SRF-14.9624) to the area shown in Fig. 601. Material: 4340 steel, 125-145 ksi.



1 APPLY ONE LAYER OF BMS 10-86, TYPE 1 OR 2 COLOR WHITE (SRF-14.9624)

ALL THE DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

Adjusting Screw Refinish
Figure 601

684812

SNUBBER LINK ASSEMBLY - REPAIR 12-1

146T6561-1, -2

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

1. Bushing Replacement (861, IPL Fig. 1)

   A. Remove the bushing.

   B. Use BMS 5-95 sealant to install the bushing per 20-50-03.

   C. Use BMS 5-95 sealant to fillet seal the flanges.

2. Refinish

   A. Link (864, 867) -- Chromic acid anodize, type 1. Apply one layer of BMS 10-11, type 1 primer (F-18.13). Then apply one layer of BMS 10-11, type 2 enamel, color BAC 702 white gloss (F-21.03). Omit the primer and the enamel from the holes. Material: Al alloy.

REPLACEMENT OF OTHER BUSHINGS - REPAIR 13-1

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

Bushing Replacement (234, 345, 348, 480, 483, 627, 630, 646Q, 697, 700, 768, 771, IPL Fig. 1)

A. Remove the bushings.

B. Use BMS 5-95 sealant to install the bushings per 20-50-03.

C. Use BMS 5-95 sealant to fillet seal the flanges.

REFINISH OF OTHER PARTS - REPAIR 14-1

1. Instructions given in Fig. 601 are to repair the finishes of the items.

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1:		
Shaft (33)	15-5PH CRES 180-200 ksi	Cadmium plate per 20-42-05, type 2, class 2 (F-15.06) to the dimensions shown (Fig. 602).
Collar (42), filler (83), angle (903,906), walkway (909)	Al alloy	Chromic acid anodize. Apply one layer of BMS 10-11, type 1 primer (F-18.13). Then apply one layer of BMS 10-11, type 2 enamel, color BAC 702 white gloss (F-21.03) all over.
Spring (98)	17-7PH CRES CH900	Cadmium plate per 20-42-05, type 2, class 2 (F-15.06).
Trigger (104)	Al alloy	Chromic acid anodize (F-17.02).
Crank (119,122)	17-4PH CRES 180-200 ksi	Cadmium plate (0.0002 to 0.0004 inch) per 20-42-05, type 1, class 3 (F-15.05). Apply two layers of BMS 10-11, type 1 primer (F-20.03) all over.
Rod (183B,184,435A)	Al alloy	Chemical treat. Apply one layer of BMS 10-11, type 1 primer (F-18.06) all over. Omit the primer from the threads. Then apply one layer of BMS 10-11, type 2 enamel, color BAC 702 white gloss (F-21.03) to the external surface only.
Crank (207,210)	15-5PH stainless 180-200 ksi	Passivate (F-17.09).
Handle (270,273)	Al alloy	Apply coarse-grain-buff-satin finish. Sulfuric acid anodize all over (F-14.29). The brush direction is the same as the length of the handle. Handle this part carefully. The decorative surface finish can be seen from the cabin interior. The surface must be clean of scratches.

Refinish Details
Figure 601 (Sheet 1)

IPL FIG. & ITEM	MATERIAL	FINISH
Crank (264,267)	15-5PH CRES 180-200 ksi	Cadmium plate per 20-42-05, type 2, class 2, to the dimensions shown (Fig. 604). Apply one layer of BMS 10-11, type 1 primer (F-16.01) all over. Omit the primer from the holes.
Spacer (279)	301 CRES	Cadmium plate per 20-42-05, type 3, class 2 (F-16.04).
Rod (321A,324A)	15-5PH 150-170 ksi	Passivate (F-17.09).
Handle (354A)	Al alloy	Chromic acid anodize. Apply one layer of BMS 10-11, type 1 primer (F-18.13) aLL over. Then apply one layer of BMS 10-11, type 2 enamel, color BAC 702 white gloss F-21.03 to the external side of the handle. Omit the primer and the enamel from the 0.75 inch and the 0.25 inch diameter holes. Material: Al alloy.
Crank (501), idler (786,789)	Al alloy	Chromic acid anodize. Apply one layer of BMS 10-11, type 1 primer (F-18.13). Then apply one layer of BMS 10-11, type 2 enamel, color BAC 702 white gloss (F-21.03). Omit the primer and the enamel from the holes.
Target (525,528)	4130 steel	Cadmium plate (F-15.06). Apply one layer of BMS 10-11, type 1 primer (F-20.02). Then apply one layer of BMS 10-11, type 2 enamel, BAC 702 white gloss (F-21.03) all over.

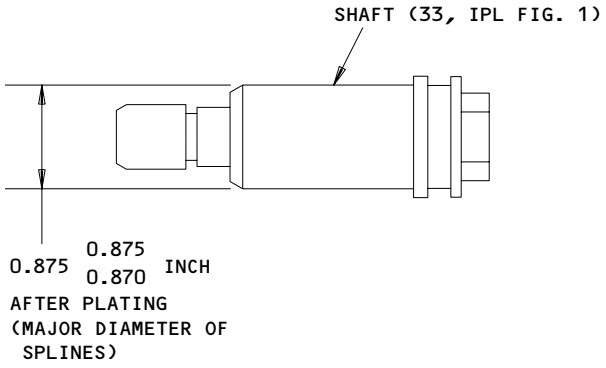
Refinish Details
Figure 601 (Sheet 2)

IPL FIG. & ITEM	MATERIAL	FINISH
Crank (546)	17-4PH CRES 180-200 ksi	Cadmium plate (F-15.06) per Fig. 604. Apply one layer of BMS 10-11, type 1 primer (F-20.02). Then apply one layer of BMS 10-11, type 2 enamel, BAC 702 white gloss (F-21.03) per Fig. 605.
Cam (549), Crank (552)	4340 steel 150-180 ksi	Cadmium plate (0.003 inch thick). Post-plate chromate treat per 20-42-05. Bake a minimum of three hours at 350° to 400°F (see Fig. 605). Apply one layer of BMS 10-11, type 1 primer (SRF-1.285) all over. Omit the primer from the holes and the surfaces shown (Fig. 606).
Torque tube (555)	4130 steel 180-200 ksi	Cadmium plate. Apply one layer of BMS 10-11, type 1 primer (F-16.01) all over. Omit the primer from the surfaces shown (Fig. 603).
Spacer (558)	301 CRES	Passivate (F-17.09).
Housing (573,576)	Al alloy	Chromic acid anodize. Apply one layer of BMS 10-11, type 1 primer (F-18.13). Then apply one layer of BMS 10-11, type 2 enamel, color BAC 702 white gloss (F-21.03). Omit the primer and the enamel from the 1.9375 inch diameter surface.
Spring (579,585)	17-7PH CRES	Cadmium plate. Apply one layer of BMS 10-11, type 1 primer (F-16.03).

Refinish Details
Figure 601 (Sheet 3)

IPL FIG. & ITEM	MATERIAL	FINISH
Idler (654)	Al alloy	Chromic acid anodize. Apply one layer of BMS 10-11, type 1 primer (F-18.13). Then apply one layer of BMS 10-11, type 2 enamel, color BAC 702 white gloss (F-21.03). Omit the primer and the enamel from the 0.75-inch and the 0.88-inch diameter holes.
Idler (655,656)	Al alloy	Chromic acid anodize. Apply one layer of BMS 10-11, type 1 primer (F-18.13). Then apply one layer of BMS 10-11, type 2 enamel, color BAC 702 white gloss (F-21.17). Omit primer and enamel from the 0.75-inch and the 0.88-inch diameter holes. No enamel between the 0.75-inch diameter bores or in the 0.250 and 0.375-inch diameter holes.
Stop (745)	4130 steel 150-170 ksi	External: Cadmium plate (F-15.06). Apply two layers of BMS 10-11, type 1, primer (F-20.03). Then apply one coat of BMS 10-11, type 2 enamel, color BAC 702 white gloss (F-21.03). Internal: Cadmium plate (optional) (F-15.06). Apply two layers of BMS 10-11, type 1, primer (F-20.03). Then apply water-displacing corrosion-preventive compound BMS 3-23, type 2 (F-19.26).
Link (924,925,927)	15-5PH 180-200 ksi	Cadmium plate 0.0002 to 0.0004 inch thick (F-15.02).

Refinish Details
Figure 601 (Sheet 4)

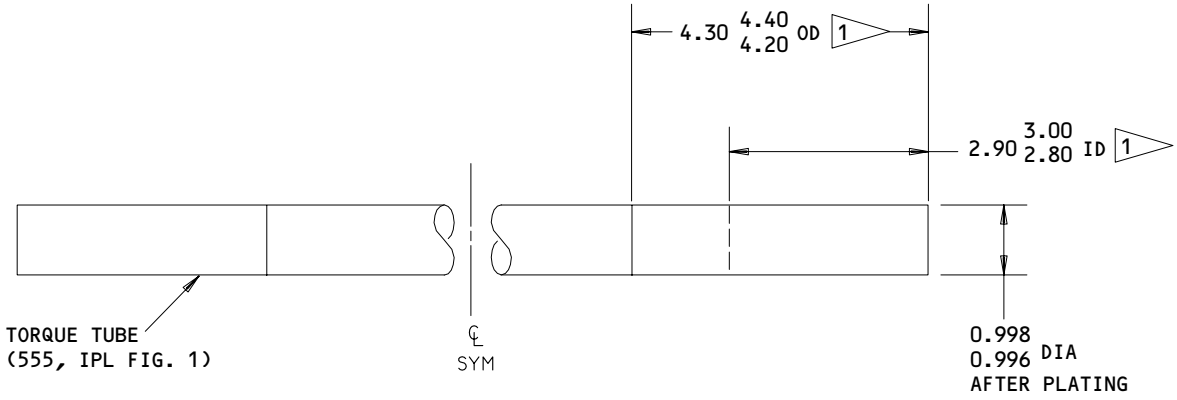


ALL THE DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

146N6324-1
Shaft Refinish
Figure 602

684749



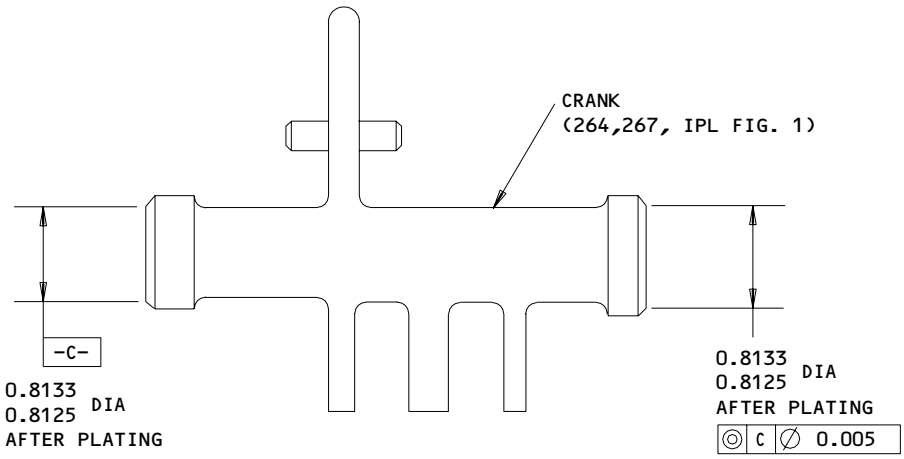
ALL THE DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

1 OMIT PRIMER THIS AREA

69-49936-2
Torque Tube Refinish
Figure 603

684751

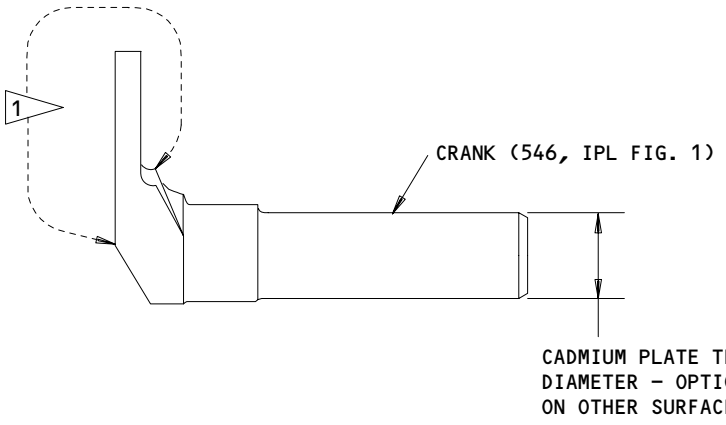


ALL THE DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

146N6339-9,-10
Crank Refinish
Figure 604

684721



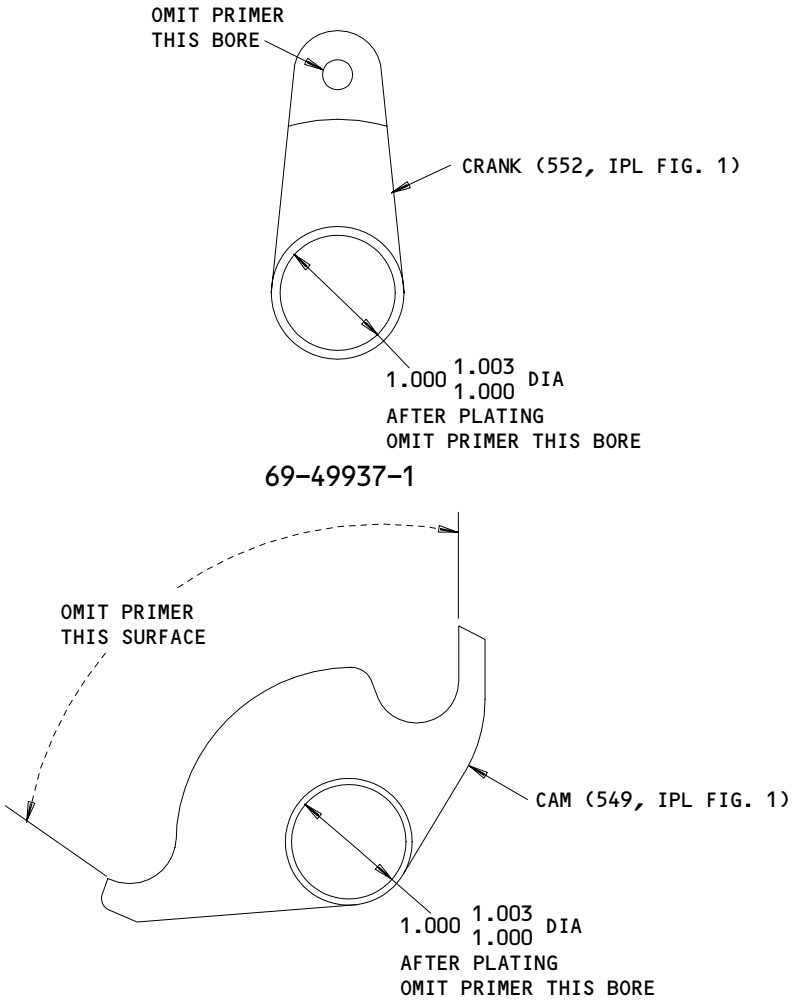
ALL THE DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

1 APPLY PRIMER AND ENAMEL TO THESE SURFACES

146N6333-2
Crank Refinish
Figure 605

684752



Torque Tube Assembly Components Refinish
Figure 606

684756

ASSEMBLY

1. General

   A. Install all the bolts and the nuts per 20-50-01. Tighten to the approved torque values. Tighten the bolts and the nuts shown in Fig. 801 to the values shown.

   B. Install all the lockwire and the cotter pins per 20-50-02.

2. Materials

   NOTE: Equivalent replacements can be used.

   A. Grease (Ref 20-60-03)

      (1) BMS 3-24

      (2) MIL-G-23827

   B. Lockwire -- MS20995NC20

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

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

3. Assembly (IPL Fig. 1)

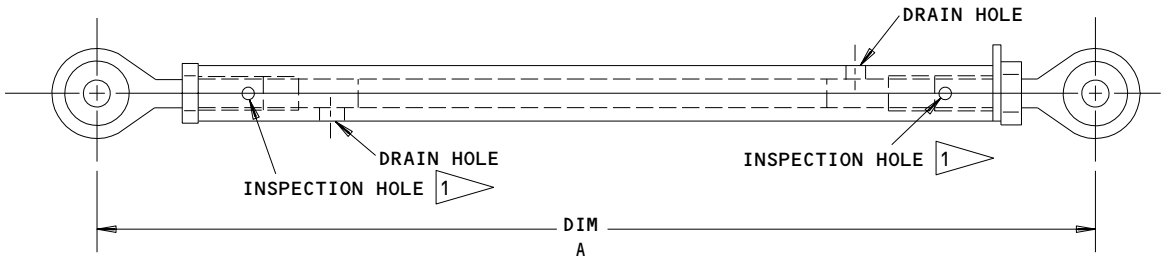
   A. Preassemble the rod assemblies (162A, 165A, 300A, 303A, 417A, IPL Fig. 1).

      (1) Install the rod end bearings with BMS 3-24 grease on all surfaces (F-19.16).

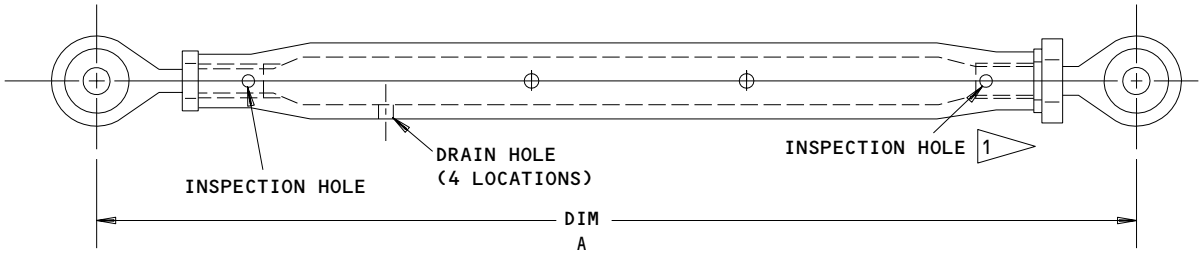
      (2) Assemble the rod assemblies to the dimensions shown in Fig. 701.

      (3) One end of the rod assembly is made for adjustment after installation. Tighten the nut on the opposite end from the adjustment nut. Make sure the rod end is seen through the inspection hole.

      (4) Put a tag on the nut that is to be adjusted. Write on the tag "The nut is not tightened. Tighten the nut to the approved values after the door installation and the adjustment in the airplane. Make sure the rod end is seen through the inspection hole. Lockwire per 20-50-02 (double-twist method) after the last adjustment. Use MS20995NC20.".



TYPE A



IPL NO. IPL FIG. 1	DIM. A (INCHES)
162A	8.38-8.40
165A	8.89-8.91
300A	7.24-7.26
303A	5.27-5.31
417A	18.51-18.53

1 LOOK IN THE INSPECTION HOLE. THE ROD END MUST BE SEEN. THIS IS THE MINIMUM LENGTH FOR THE ROD END TO BE ENGAGED

ALL DIMENSIONS ARE IN INCHES

Control Rod Assembly Diagram
Figure 701

684817

B. Install the pressure relief door assembly (1, IPL Fig. 2) with items (438 thru 450, IPL FIg. 1).

(1) Apply a layer of BMS 3-24 grease to the internal diameter of the pressure relief door, the bushings and the external diameter of the bearings and the bolt before installation.

(2) Tighten the nuts (444) to 50-75 pound-inches.

C. Install the male and the female fitting assembly (375, 387, IPL Fig. 1) with items (357 thru 372).

(1) Apply a layer of BMS 3-24 grease to the external diameter of the bolts and the internal diameter of the bushings.

(2) Point the nuts (366) to the centerline of the door.

(3) Omit the washer (393) and the spring (396). The washer and the spring will be installed in the last adjustment of the door assembly.

(4) Do not tighten the nuts (366). Put a tag on the nuts. Write on the tag "The nut (NAS1805-3L) is not tightened. Tighten the nut to 20-25 pound-inches after the door installation and adjustment in the airplane.".

D. Install the torque tube assembly (531 or 534, IPL FIg. 1).

(1) Move the torque tube (555) through the holes in the door structure assembly (993 or 996). Put the bearings (561), the bearing housing (573 or 576), the crank (552), the washer (591), the torque tube sleeve (588), the spring (579 or 585) and the cam (549) on the torque tube. Install the fasteners (537 thru 543). Do not put a load on the spring (579 or 585). The spring will be adjusted during the last adjustment.

NOTE: Apply a layer of BMS 10-11, type 1 primer to the mating surfaces of the cam (549), the crank (552) and the torque tube (555). Install wet or dry.

(2) Do not tighten the nuts (543). The torque tube assembly (531 or 534) will be adjusted during the last adjustment on the airplane. Put a tag on the nuts (543). Write on the tag "The nut (BACN10JC4CD) is not tightened. Tighten the nut to the approved value after the door installation and adjustment in the airplane.".

(3) Install the bearings (561) and the bearing housing (573 or 576) with the fasteners (564 thru 570).

(4) Assemble items (504 thru 528) on the cranks (546). Apply MIL-G-23827 grease to the cam roller (504). Tighten the nut (513) to 50-75 pound-inches. Install the screw (519) on the forward side of the door. Use BMS 5-95 sealant (F-19.48). Tighten the screw (519) to 20-25 pound-inches.

(5) Install the cranks (546). Apply a layer of BMS 10-11, type 1 primer to the mating surface of the crank (546) and the torque tube (555). Install wet or dry. Add the spacers (558) equally (plus or minus one spacer) to limit the torque tube end float to 0.01 to 0.03 inch.

(6) Install items (594 thru 603).

E. Install the external handle assembly (125, IPL FIg. 1) and the related linkage.

(1) Assemble the idler-crank assembly (252 or 255). Install items (258, 261) on the crank (264 or 267).

(2) Install the idler handle (354A) with items (327 thru 342, 351) and the idler crank assembly (252 or 255) with items (213 thru 231, 240).

(a) Apply a layer of BMS 3-24 grease to the internal diameter of the handle and the crank, the bushings and the external diameter of the bearings and the bolts before the installation.

(b) Point the bolthead (213, 327) to the centerline of the door.

(c) Do not tighten the nut (228A). The crank (252 or 255) position will be adjusted during the last adjustment. Put a tag on the nut. Write on the tag "The nut (BACN10JC5CM) is not tightened. Tighten the nut to 90-125 pound-inches after the door installation and the adjustment in the airplane.".

(d) Do not tighten the nut (339). The idler handle (354A) position will be adjusted during the last adjustment. Put a tag on the nut. Write on the tag "The nut (BACN10JC4CM) is not tightened. Tighten the nut to 50-75 pound-inches after the door installation and the adjustment in the airplane.".

(3) Install the corner crank (207 or 210) with items (186 thru 204).

(a) Apply a layer of BMS 3-24 grease to the internal diameter of the crank, the spacer, the bushing and the external diameter of the bearings, the bolt and the spacer before installation.

(b) Tighten the nut (198) to 50-75 pound-inches.

(4) Install the control rod assembly (300A) with items (276A thru 285, 288 thru 297).

(a) Apply MIL-B-23827 grease to the fasteners.

(b) Add spacers (279 and 291) as necessary. The maximum permitted pull-up is 0.01 inch.

(c) Do not tighten the nuts (285 and 297). The control-rod assembly (300A) will be adjusted during the last adjustment on the airplane. Put a tag on the nuts (285 and 297). Write on the tag "The nut (BACN10JC4CM) is not tightened. Tighten the nut to 50-75 pound-inches after the door installation and adjustment in the airplane.".

(5) Install the control rod assemblies (165A and 303A) with items (137 thru 147, 150 thru 159, 276A thru 285).

(a) Apply a layer of BMS 3-24 grease to the internal diameter of the cranks and the outside diameter of the bushings and the bolts before installation.

(b) Add spacers (279) as necessary to the bolt (276A). The maximum permitted pull-up is 0.01 inch.

(c) Do not tighten the nuts (143, 153, 285). The control-rod assemblies (165A and 303A) will be adjusted during the last adjustment on the airplane. Put a tag on the nuts (143, 153, 285). Write on the tag "The nut (BACN10JC4CM) is not tightened. Tighten the nut to 50-75 pound-inches after the door installation and adjustment in the airplane.".

(6) Install the filler assembly (72) and the bumper (69) with items (63, 66).

(a) Do not tighten the bolts (63). The bumper (69) position will be adjusted during the last adjustment. Put a tag on the bolts. Write on the tag "The bolt (NA6603-7) is not tightened. Tighten the bolt to 20-30 pound-inches after the door installation and adjustment in the airplane.".

(7) Install the trigger (104) and the spring (98) with items (86 thru 95) and the bearings (101).

(a) Apply a layer of BMS 3-24 grease to the internal diameter of the trigger, the spacers, the bearings and the external diameter of the bolt, the spacers and the bearings before installation.

(b) Tighten the nut (95) to 50-75 pound-inches.

(8) Install the exterior handle crank (119 or 122), the exterior handle crank assembly (51), the exterior handle shaft (33), the handle assembly (125) and items (36 thru 48).

(a) Apply BMS 3-24 grease to the external diameters of the shafts, the bearings and the internal diameter of the bearings.

(b) Install the seals (45) with the open end away from the handle assembly (125) centerline.

(c) Tighten the nut (39) to 290-510 pound-inches.

(9) Install the tie-rod assembly (24) with items (3 thru 21).

(a) Apply a layer of BMS 3-24 grease to the external diameter of the bolts and the internal diameter of the bushings before installation.

(b) Tighten the nuts (15) to 50-75 pound-inches.

(10) Install the control rod assembly (162A) with items (107 thru 116, 137 thru 147).

(a) Apply a layer of BMS 3-24 grease to the internal diameter of the cranks, the bushings and the external diameter of the bolts before installation.

(b) Do not tighten the nuts (113, 143). The control rod assembly (162A) will be adjusted during the last adjustment on the airplane. Put a tag on the nuts. Write on the tag "The nut (BACN10JC4CM) is not tightened. Tighten the nut to 50-75 pound-inches after the door installation and the adjustment in the airplane.".

F. Install the handle (270 or 273, IPL Fig. 1) with items (243 thru 249).

G. Install items (486 thru 498) on the idler crank (501).

H. Install the idler crank (501) with item (459 thru 477) and the bearings (484).

I. Install the control rod assembly (417A) with item (291, 399 thru 414).

(1) Apply a layer of BMS 3-24 grease to the internal diameter of the bushing and the external diameter of the bolt before installation.

(2) Install the spacers (291) between the bearing of the control rod assembly (417A) and the clevis as needed. The maximum pull-up is 0.01 inch.

(3) Tighten the nut (411) to 50-75 pound-inches.

J. Install the stop (745, IPL Fig. 1) with items (739, 742).

(1) Add the washers (742) as necessary for a tight fit of the stop (745) in the door structure assembly (993 or 996). A minimum of one washer is necessary.

K. Install the lower idler (786, 789, IPL Fig. 1) with items (748 thru 771).

(1) Apply a layer of BMS 3-24 grease to the internal diameter of the door structure assembly, the bushings and the external diameter of the bolt, the bearing and the spacer before installation.

(2) Set the bolthead (748) to the centerline of the door in the forward and the aft positions.

(3) Do not tighten the nut (762). The lower idler (786, 789) will be adjusted during the last adjustment on the airplane. Put a tag on the nut (762). Write on the tag "The nut (BACN10JC5CM) is not tightened. Tighten the nut to 50-75 pound-inches after the door installation and adjustment in the airplane.".

L. Attach the support assembly (831, IPL Fig. 1) to the lower idler (786, IPL Fig. 1) with the fasteners (774 thru 780) and the bearings (783).

(1) Apply a layer of BMS 3-24 grease to the internal diameter of the lower idler, the support assembly and the outside diameter of the bearing and the bolt before installation.

(2) Tighten the nut (780) to 50-75 pound-inches.

M. Set the snubber assembly (852, IPL Fig. 1) in the support assembly (831, IPL Fig. 1).

N. Attach the link assemblies (855, 858, IPL Fig. 1) to the snubber assembly (852, IPL Fig. 1) and the support assembly (831, IPL Fig.1) with items (819, 825, 840 thru 850).

(1) Apply BMS 324 grease to the internal diameter of the bushings (825, 842) and the external diameter of the bolt (841) before installation.

(2) Install the washers (819) as necessary. The maximum clearance is 0.01 inch and the maximum catch is 0.007 inch before the nut (850) is tightened.

(3) Set the bolthead (841) to the centerline of the door in the forward and the aft position.

(4) Tighten the nut (849) to 160-240 pound-inches.

(5) Do not tighten the nut (850). The link assemblies (855, 858) will be adjusted during the last adjustment on the airplane. Put a tag on the nut (850). Write on the tag "The nut (NAS1805-5L) is not tightened. Tighten the nut to 100-150 pound-inches after the door installation and the adjustment in the airplane.".

O. Attach the center link assembly (954, IPL Fig. 1) with items (792 thru 804).

(1) Apply a layer BMS 3-24 grease to the internal diameter of the bushings and the external diameter of the bolt and the bushings before installation.

(2) Point the bolthead (792) to the centerline of the door in the forward and the aft position.

(3) Do not tighten the nut (801). The center link assembly (954) will be adjusted during the last adjustment on the airplane. Put a tag on the nut (801). Write on the tag "The nut (NAS1805-5L) is not tightened. Tighten the nut 90-125 pound-inches after the door installation and adjustment in the airplane.".

P. Assemble the links (924 thru 927, IPL Fig. 1) and the angles (903, 906, IPL Fig. 1) with items (807 thru 816, 822, 828, 870 thru 891).

(1) Apply a layer of BMS 3-24 grease to the internal diameter of the bushings and the external diameter of the bushings and the bolts before installation.

(2) Point the bolthead (807, 870) to the centerline of the door in the forward and the aft position.

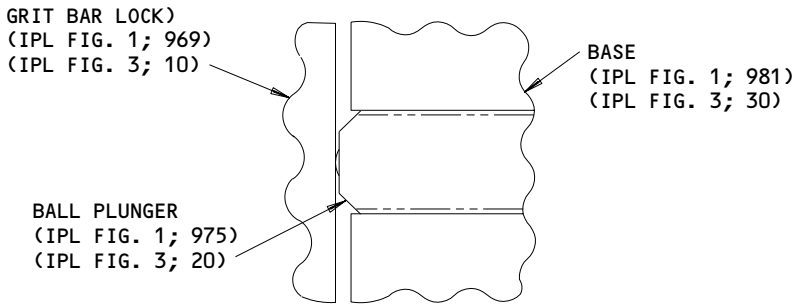
(3) Apply BMS 5-95 surface sealant to the surfaces of the angles (903, 906) and the links (924 thru 927) that touch.

(4) Tighten the nut (879) to 150-200 pound-inches.

(5) Do not tighten the nut (816). The links (924 thru 927) will be adjusted during the last adjustment on the airplane. Put a tag on the nut (816). Write on the tag "The nut (NAS1805-5L) is not tightened. Tighten the nut to 90-125 pound-inches after the door installation and adjustment in the airplane.".

Q. Install the support walkway (909, IPL Fig. 1) with the fasteners (894 thru 900).

R. Install ball plunger (975) with Loctite 242 retaining compound into base (981). Thread the ball plunger in until the plunger body contacts the back of the girt bar lock (969). Now thread the ball plunger out so that the girt bar lock can be rotated freely between detent positions and so that the ball plunger provides a positive holding force on the girt bar lock when it is in a detent position.



Assembly Details - Ball Plunger
Figure 701A

966468

S. Install the hinge end link assembly (945, IPL Fig. 1) and the hinge fitting assembly (963, 966, IPL Fig. 1) with items (912 thru 921, 930 thru 942).

(1) Apply BMS 3-24 grease to the internal diameter of the bushings and external diameter of the bolts and the bushings.

(2) Point the bolthead (912, 930) to the centerline of the door in the forward and the aft position.

(3) Do not tighten the nut (918, 939). The hinge-end-link assembly (945) and the hinge fitting assembly (963, 966) will be adjusted during the last adjustment on the airplane. Put a tag on the nut (918, 939). Write on the tag "The nut (NAS1805-5L) is not tightened. Tighten the nut to 90-125 pound-inches after the door installation and adjustment in the airplane.".

T. Assemble the pawl assembly (703, 706), IPL Fig. 1).

(1) Install items (709 thru 718, 724 thru 730) on the pawl (733, 736).

(2) Set the length of the adjusting screw (730) as shown in Fig. 708. The adjusting screw will be adjusted during the last adjustment on the airplane. Put a tag on the nut (724). Write on the tag "The nut (NAS1423-6) is not tightened. Tighten the nut to an approved torque value and lockwire after the door installation and the adjustment in the airplane.".

U. Install the pawl assembly (703, 706, IPL Fig. 1) with items (673 thru 694).

(1) Apply a layer of BMS 3-24 grease to the internal diameter of the bushings, the pawl assembly and the external diameter of the bearings, the spacer, the bushings and the bolt before installation.

(2) Set the bolthead (673) to the centerline of the door in the forward and the aft position.

(3) Do not tighten the nut (688). The pawl assembly (703, 706) will be adjusted during the last adjustment on the airplane. Put a tag on the nut (688). Write on the tag "The nut (BACN10JC4CM) is not tightened. Tighten the nut to 50-75 pound-inches after the door installation and the adjustment in the airplane.".

V. Install the cable (721, IPL Fig. 1).

(1) Attach the cable (721) to the pawl assembly.

(2) Put the cable (721) around the side frame and through the guide of the door structure assembly (993 or 996). Make a loop and install a BACF22U3 ferrule.

W. Attach the spring (718, IPL Fig. 1) with items (658 thru 670).

X. Install the upper idler (654, 655, 656 IPL Fig. 1) with items (606 thru 624, 633).

(1) Apply a layer of BMS 3-24 grease to the internal diameter of the bushings, the sleeve, the upper idler and the external diameter of the bearings, the sleeve, the bushings and the bolt before installation.

(2) Set the bolthead (606) to the centerline of the door in the forward and the aft position.

(3) Do not tighten the nut (621). The upper idler (654, 655, 656) will be adjusted during the last adjustment on the airplane. Put a tag on the nut (621). Write on the tag "The nut (BACN10JC4CM) is not tightened. Tighten the nut to 50-75 pound-inches after the door installation and the adjustment in the airplane.".

Y. Install the upper idler (654, 655, 656, IPL Fig. 1) with items (645Q, 645V, 646, 646L, 652).

(1) Apply a layer of BMS 3-24 grease to the internal diameter of the bushing (646Q), the upper idler (655, 656) and the external diameter of bolt (645Q) before installation.

(2) Set end of assist spring (652) in upper idler (655, 656).

(3) Set the bolthead (645Q) to the centerline of the door in the forward and aft position.

(4) Do not tighten the nut (646L). The upper idler (654, 655, 656) will be adjusted during the last adjustment on the airplane. Put a tag on the nut (646L). Write on tag "The nut (BACN10YR4CD) is not tightened. Tighten the nut to 50-75 pound-inches after the door installation and the adjustment in the airplane".

Z. Assemble the snubber assembly (852, IPL Fig. 1), the support assembly (831, IPL Fig. 1) and the upper idler (654, IPL Fig. 1) with items (636 thru 651).

(1) Apply a layer of BMS 3-24 grease to the internal diameter of the bushing, the fitting assembly, the snubber assembly, the upper idler and the external diameter of the bearings, the bushing and the bolt.

(2) Set the bolthead (636) to the centerline of the door in the forward and the aft position.

(3) Do not tighten the nut (645). Items (654, 831, 852) will be adjusted during the last adjustment on the airplane. Put a tag on the nut (645). Write on the tag "The nut (BACN10JC6M) is not tightened. Tighten the nut to 160-240 pound-inches after the door installation and the adjustment in the airplane.".

AA. Assemble the assist spring (652), the support assembly (831), and the upper idler (655, 656) with items (645L, 645V, 646, 646L).

(1) Apply a layer of BMS 3-24 grease to the internal diameter of bushing (646Q), the support assembly (831) and the external diameter of bolt (645L).

(2) Set the end of the assist spring (652) in support assembly (831).

(3) Set the bolthead (645L) to the centerline of the door in the forward and aft position.

(4) Do not tighten the nut (646L). Items (655, 656, 831, 652) will be adjusted during the last adjustment on the airplane. Put a tag on the nut (646L). Write on the tag "The nut (BACN10YR4CD) is not tightened. Tighten the nut to 160-240 pound-inches after the door installation and the adjustment in the airplane.".

AB. Adjustment instructions

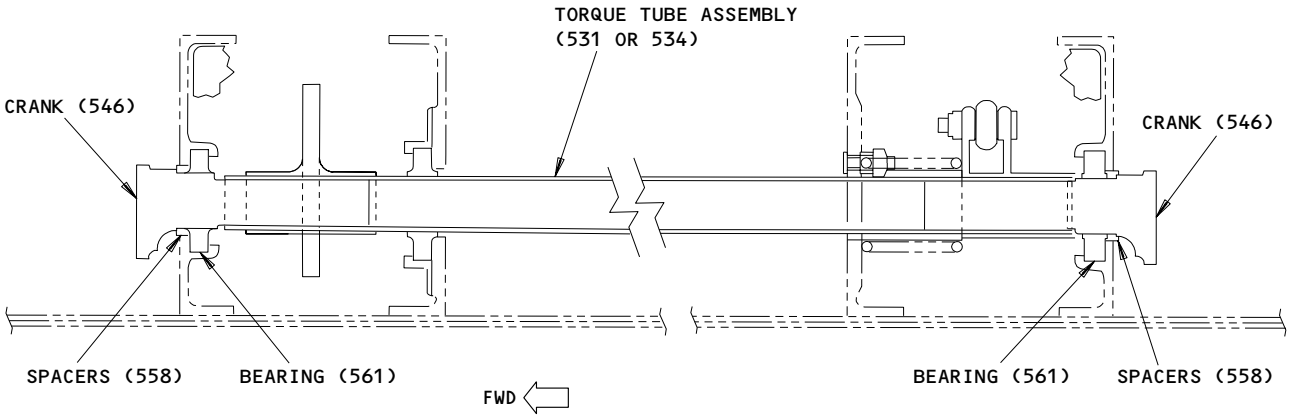
NOTE: All of the adjustments are to be made after the mechanism has been installed but not tightened and before the lockwire is installed. Unless not shown, all the mechanism adjustments are in the door CLOSED position.

(1) Adjust the forward and the aft position of the torque-tube assembly (531 or 534).

(a) Install the spacers (558) as necessary between the crank (546) and the bearing (561). Use the same number of spacers (558) initially at the forward and the aft end of the torque tube (531 or 534) (Fig. 702).

(b) The total end movement of the torque tube should be a minimum of 0.01-0.03 inch.

NOTE: Do not tighten the nuts (543). The torque tube position will be examined after the door installation.



ITEM NUMBERS REFER TO IPL FIG. 1

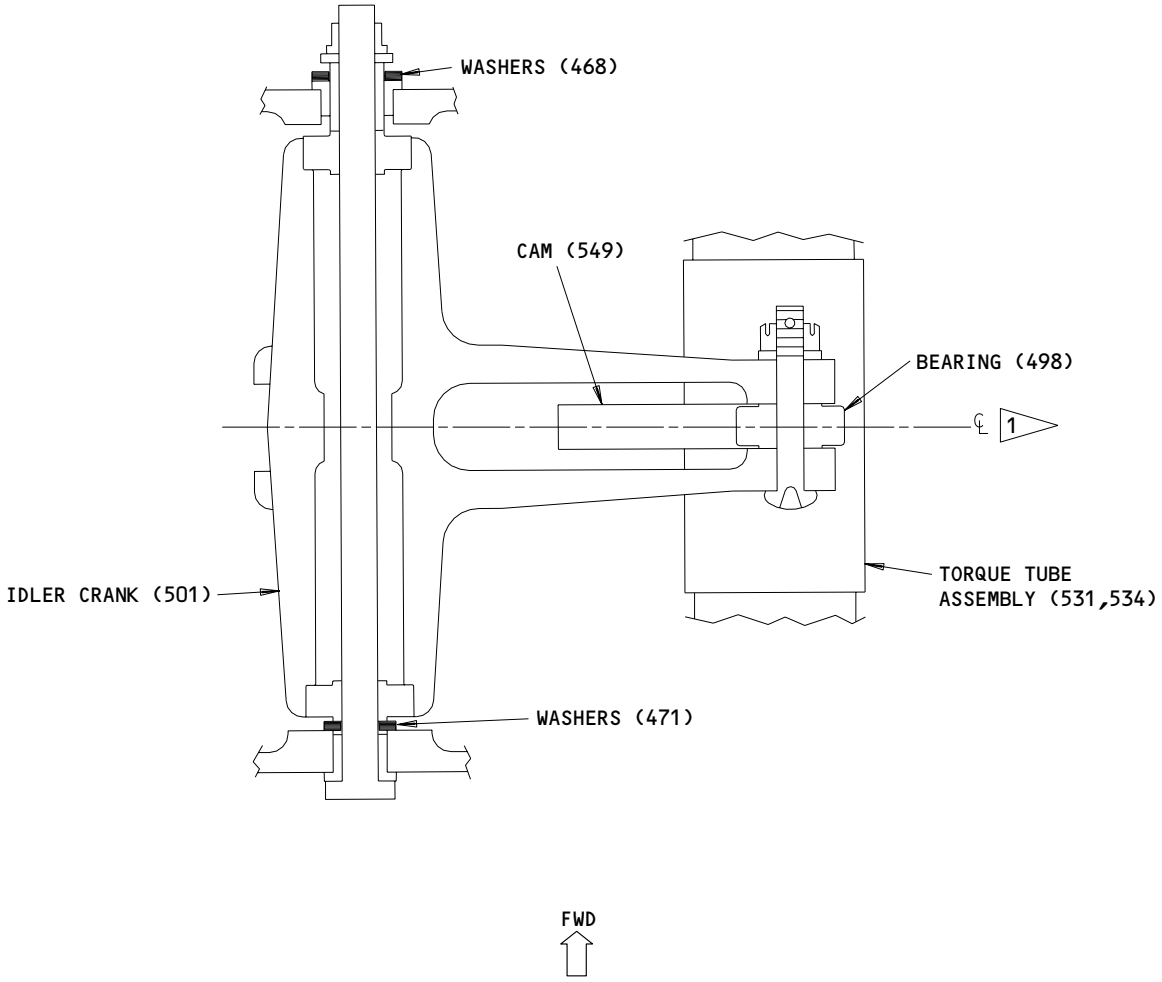
Torque Tube Assembly Adjustment
Figure 702

684818

(2) Adjust the forward and the aft position of the pressure-relief door idler crank (501).

(a) Set the washers (471) at the aft end of the idler crank (501) so that the bearing (498) is in the center of the cam (549). The centerline of the cam (549) and the bearing (498) will be in 0.10 inch of each other per Fig. 703.

NOTE: Do not tighten the nut (474). The idler crank position will be examined after the door installation.



1 THE CENTERLINE OF THE BEARING (498) AND THE CAM (549) WILL BE IN 0.10 INCH OF EACH OTHER

ITEM NUMBERS REFER TO IPL FIG. 1

Pressure-Relief-Door-Idler-Crank Adjustment
Figure 703

684821

(3) Adjust the torque tube rotational index.

(a) Turn the torque tube until the bearing (498) on the idler crank (501) is in the recess on the cam (549). This sets the torque tube at the door CLOSED position for subsequent adjustments.

(4) Adjust the pressure-relief door (453 or 456).

(a) Close the pressure-relief door (453 or 456) until it is in contact with the aft flange on the door frame (Fig. 712).

(b) Hold the torque tube assembly (531 or 534) in the door CLOSED position. Adjust the control rod assembly (417A) to hold the pressure-relief door assembly (453 or 456) closed (Fig. 709).

(c) Install the spring (396). Omit all the washers (393). More adjustment will occur in Assembly V.8. and the last adjustment on the airplane.

(5) Adjust the handle linkage.

(a) Make sure the torque tube (531 or 534) is set per Assembly V.3.

(b) Disconnect the control rod (165A) from the idler crank (252 or 255).

(c) Make sure the length of the control rod (303A) is 5.27-5.31 inches per Fig. 701.

(d) Adjust the control rod (300A) so the interior handle (270 or 273) is set per Fig. 704.

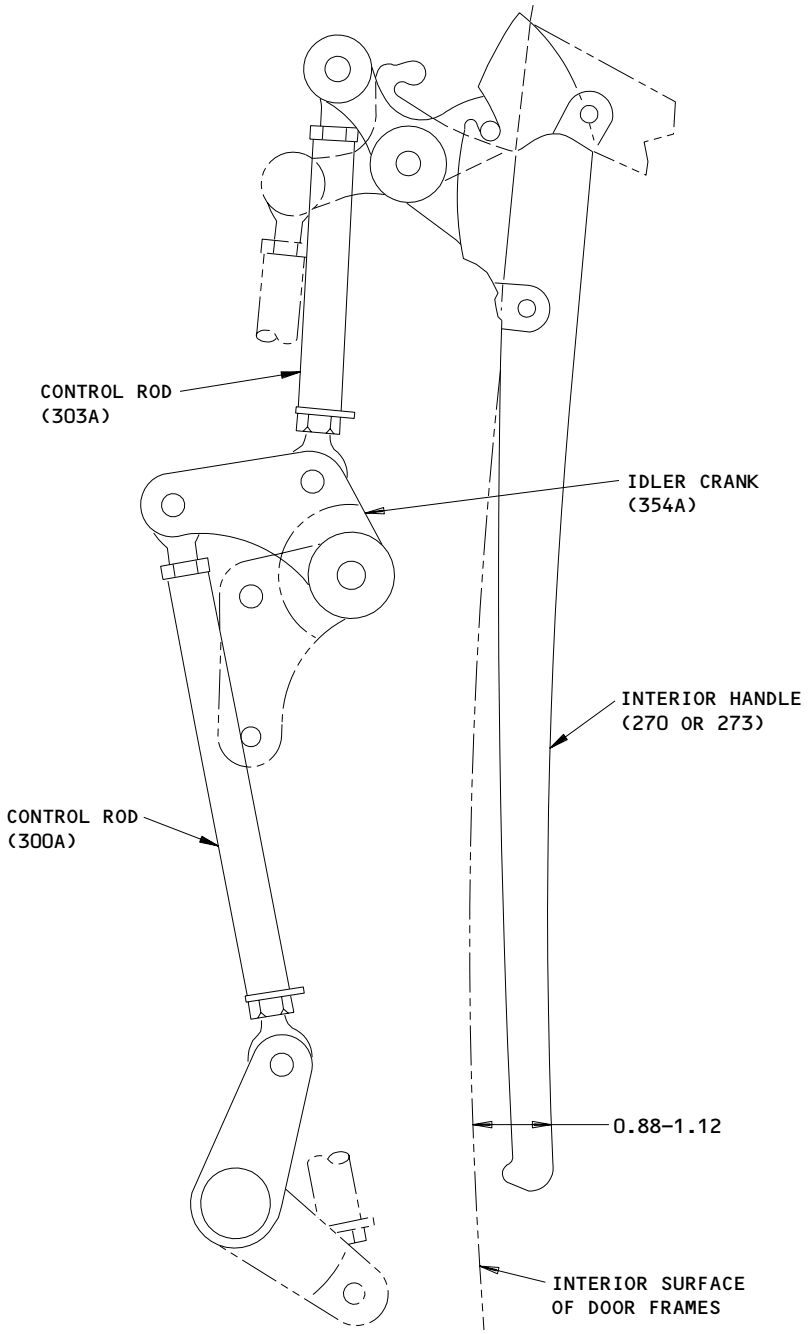
(e) Remove the bumper (69) temporarily (Fig. 705).

(f) Set the idler crank (252 or 255) so that the interior handle (270 or 273) is in the CLOSED position.

(g) Install the control rod (165A). Adjust the control rod (165A) length as necessary to set the exterior handle assembly (125) aligned with the exterior skin of the door. Keep a 0.17 inch minimum clearance between the control rod (162A) and the crank (207 or 210) per Fig. 706.

NOTE: Adjust the control rod (162A) as necessary to keep the minimum 0.17-inch clearance.

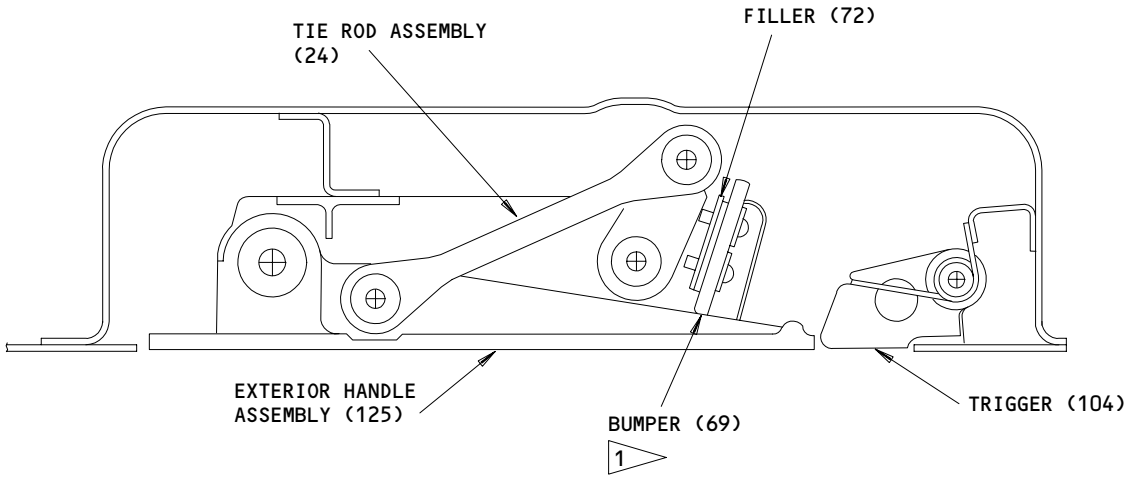
(h) Install the bumper (69). Adjust the bumper (69) to touch the exterior handle assembly (125) (Fig. 705).



ALL THE DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

Adjustment of the Handle Linkage
Figure 704

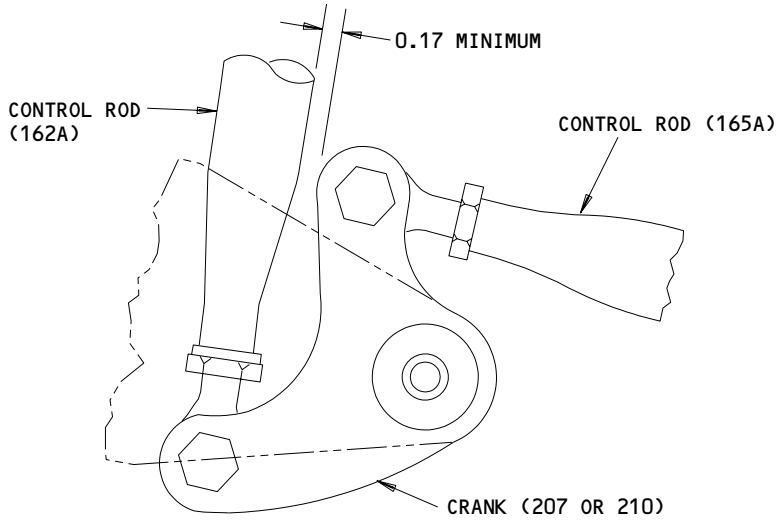


1 ADJUST THE BUMPER (69) TO TOUCH THE EXTERIOR HANDLE ASSEMBLY (125)

ITEM NUMBERS REFER TO IPL FIG. 1

Exterior Handle Bumper Adjustment
Figure 705

684826



ALL THE DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

Exterior Handle Control Rod Adjustment
Figure 706

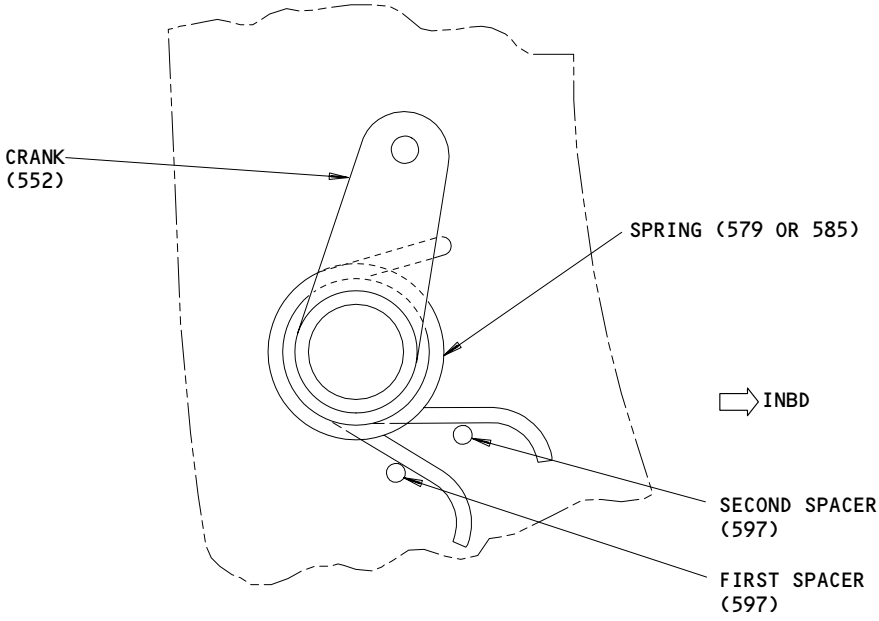
684830

(6) Adjust the spring (579 or 585) on the torque tube assembly (531 or 534).

(a) Put the torsion spring (579 or 585) over the crank (552). Attach the spring over the first spacer (597) on the aft intermediate frame per Fig. 707.

(b) Turn the interior handle (270 or 273) or the exterior handle (125) to the door OPEN position. Release the handle. Make sure the spring (579 or 585) will send the handles to the CLOSED position.

(c) Turn the spring (579 or 585) up approximately 42 degrees if the handle does not go back to the CLOSED position. Attach the spring to the second spacer (597) per Fig. 707.

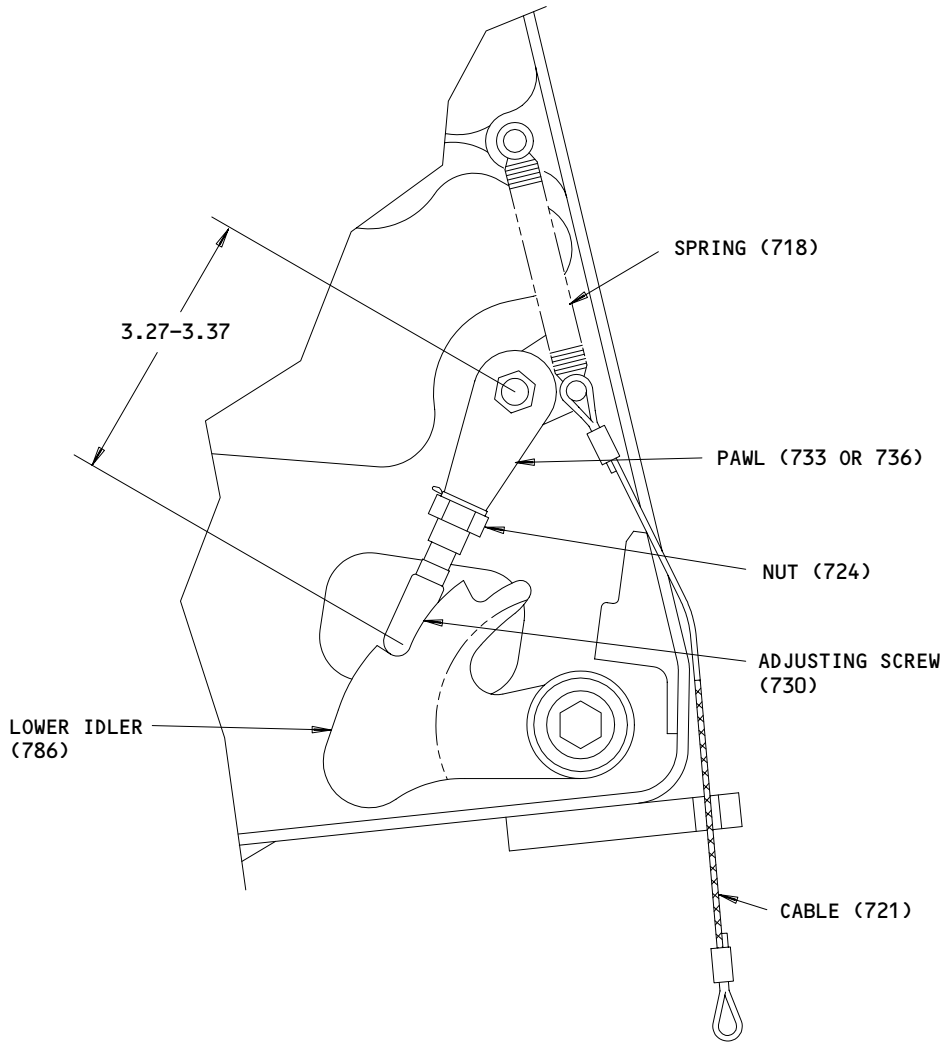


ITEM NUMBERS REFER TO IPL FIG. 1

Torsion Spring Position
Figure 707

684831

(7) Make sure the adjusting screw (730) is set on the pawl assembly (703, 706) as shown in Fig. 708.



Adjustment of the Pawl Assembly
Figure 708

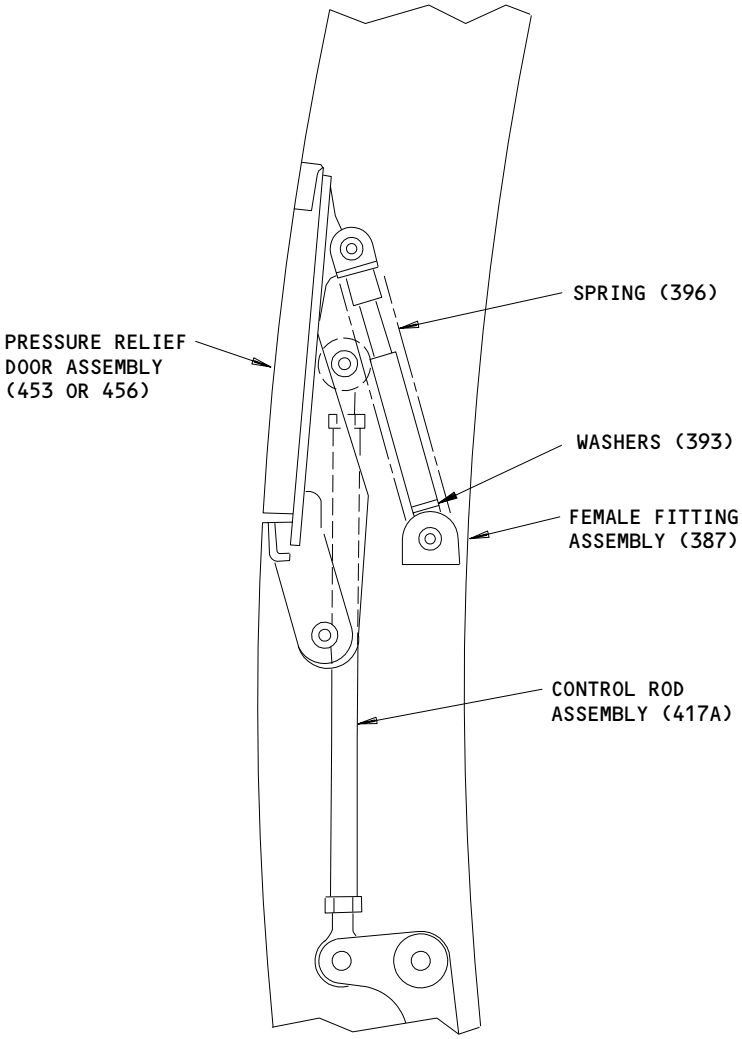
685133

(8) Examine the interior door handle (270 or 273) initial load.

(a) Make sure the load necessary to rotate the interior handle (270 or 273) is 40-50 pounds. The door will be in the CLOSED position.

NOTE: The handle load may be changed by the weight of the escape slide or the installation of the pressure seal and the linings.

(b) Add or remove the washers (393) between the spring (396) and the base of the fitting assembly (387) to adjust the handle load (Fig. 709). Make sure that the relief door (453, 456) is still properly seated.



(SIDE VIEW)

ITEM NUMBERS REFER TO IPL FIG. 1

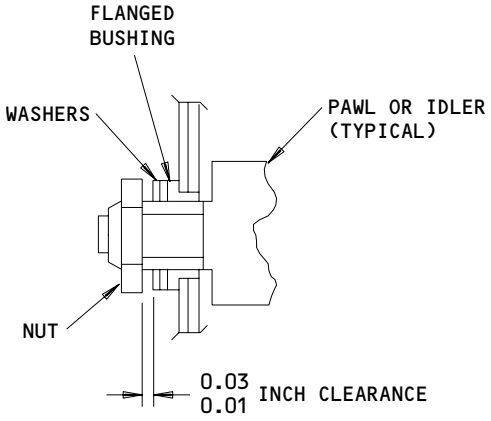
Inside Door Handle Initial Load Check
Figure 709

684738

(9) Adjust the clearance between the bushing and the idler and the pawl.

(a) The adjustment is necessary at 4 locations on the door forward frame and at 5 locations on the door aft frame.

(b) Add or remove the washers as necessary to change the clearance between the washers and the nut as shown in Fig. 710.



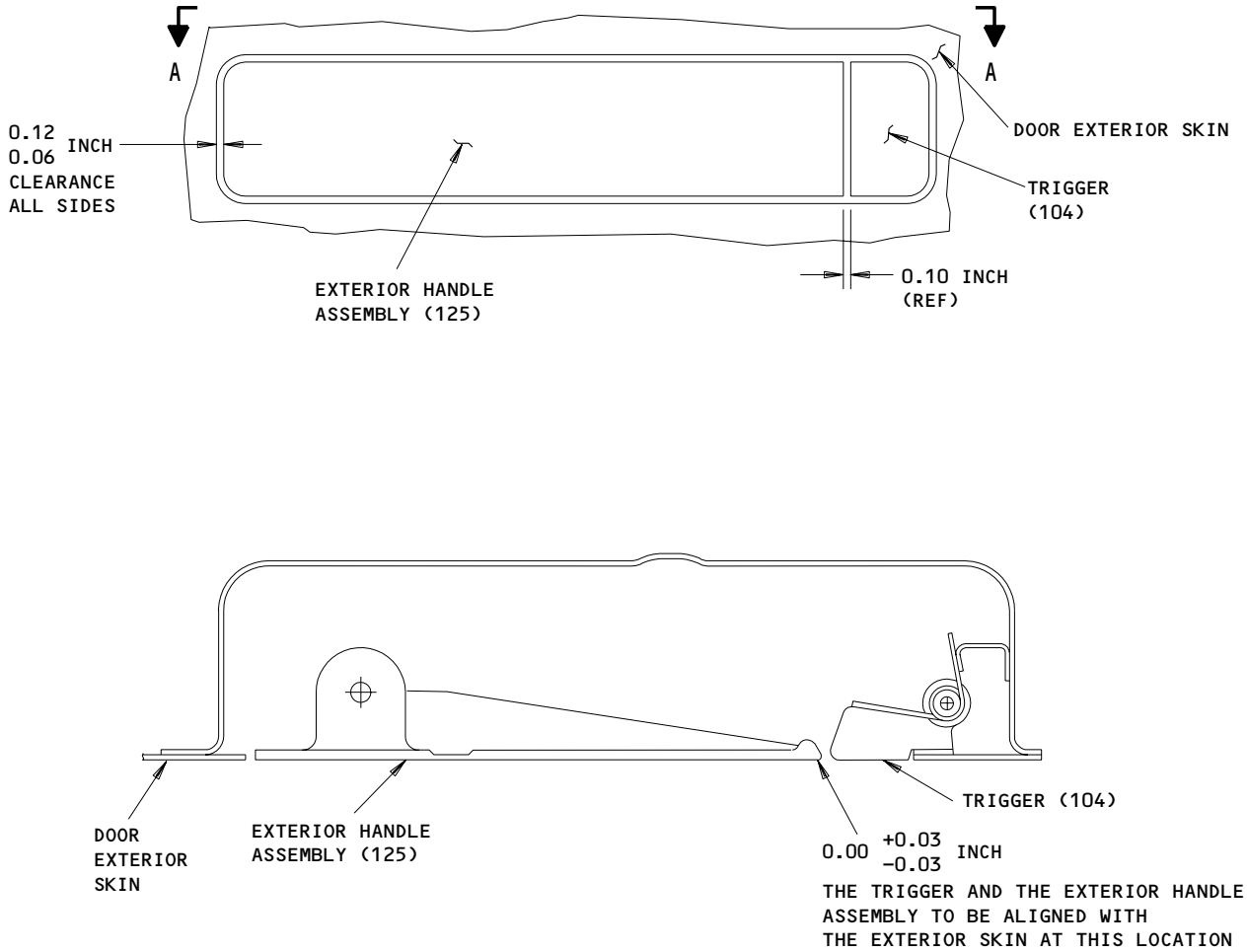
Idler/Pawl-Bushing Clearance Adjustment (Typical)
Figure 710

684740

(10) Alignment of the exterior-handle assembly (125), the pressure-relief door (453 or 456) and the door structure assembly (993 or 996).

(a) Make sure the clearance between the door skin and the exterior handle assembly (125) is as shown in Fig. 711.

(b) Make sure the clearance between the face of the exterior handle assembly (125) and the door skin is no more than 0.03 inch to one side or the other (Fig. 711).



EXTERIOR HANDLE ALIGNMENT

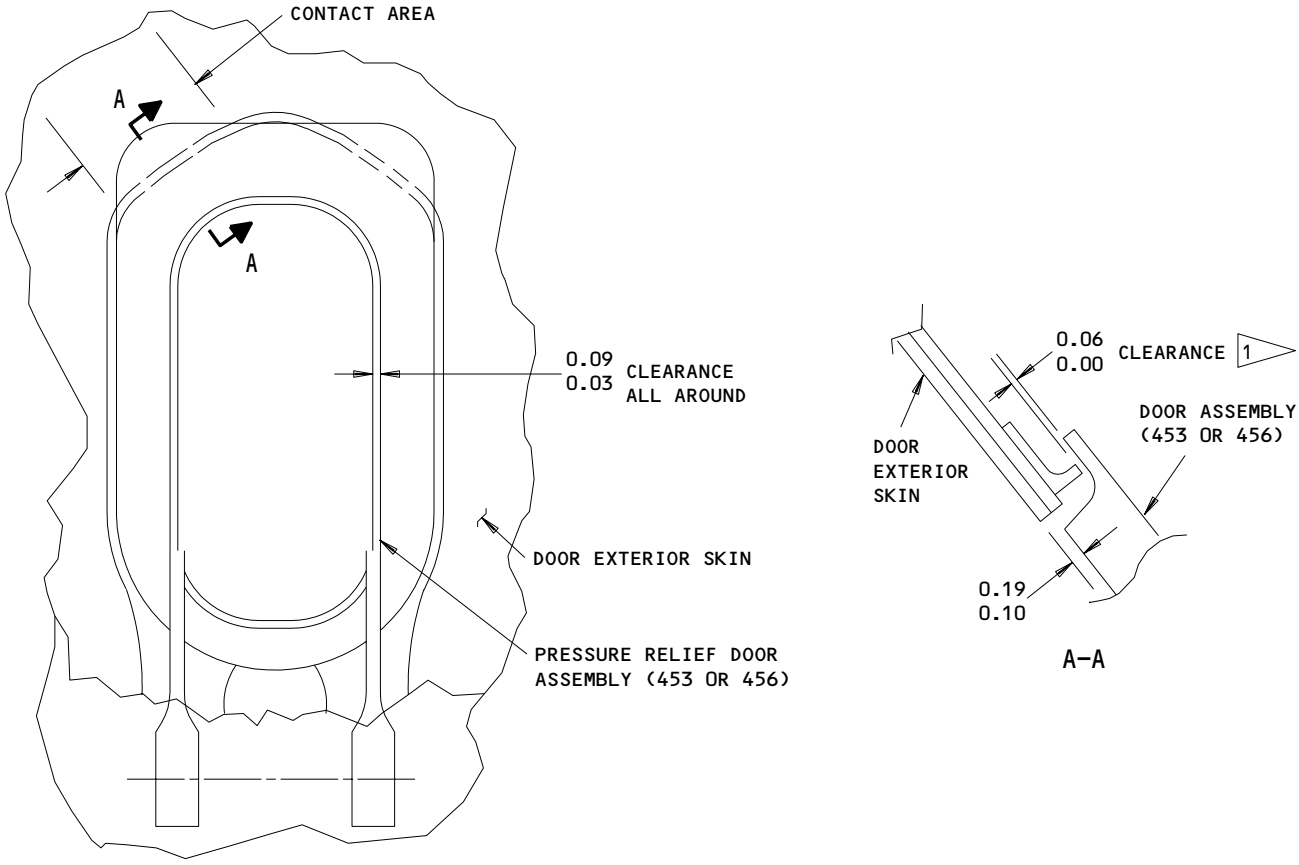
A-A

ITEM NUMBERS REFER TO IPL FIG. 1

Exterior Handle-to-Door Skin Clearance
Figure 711

685136

(c) Make sure the clearance between the pressure-relief-door assembly (453 or 456) and the door skin is as shown in Fig. 712.



1 USE 0.06 INCHES MORE IF THE RELIEF DOOR CAN BE CLOSED WITH LIGHT FINGER PRESSURE APPLIED TO THE INBOARD SIDE (OPTIONAL)

ITEM NUMBERS REFER TO IPL FIG. 1

ALL THE DIMENSIONS ARE IN INCHES

Pressure Relief Door–to–Door Skin Clearance and Alignment
Figure 712

685143

FITS AND CLEARANCES

FOR TORQUE VALUES OF STANDARD FASTENERS. REFER TO 20-50-01			
ITEM NO.	NAME	TORQUE	
		POUND-INCHES	POUND-FEET
IPL Fig. 1			
366	Nut	20-25	
15,95,113, 143,153,198, 285,297,339, 444,513,621, 688,762,780	Nut	50-75	
228A,801,816 816,918,939	Nut	90-125	
850	Nut	100-150	
879	Nut	150-200	
645,849	Nut	160-240	
39	Nut	290-510	
519	Screw	20-25	
63	Bolt	20-30	

Torque Table
Figure 801

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

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
RANCHO DOMINGUEZ, CALIFORNIA 90221
FORMERLY IN COMPTON, CALIFORNIA

06710 LAMSON AND SESSIONS CO THE VALLEY-TODECO
12975 BRADLEY AVENUE
SYLMAR, CALIFORNIA 91342-3830
FORMERLY VALLEY BOLT CORP VB0097 IN NORTH HOLLYWOOD, CA

06725 AIR INDUSTRIES CORPORATION
12570 KNOTT STREET
GARDEN GROVE, CALIFORNIA 92641-3932
FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.

07484 ACCURATE BUSHING CO INC
443 NORTH AVENUE
GARWOOD, NEW JERSEY 07027-1014
FORMERLY V83132 SMITH BRG DIV OF ACCURATE BUSHING CO

09790 EATON CORP VALVE AND ACTUATOR DIV
2338 ALASKA AVENUE
EL SEGUNDO, CALIFORNIA 90245-4896
FORMERLY CONSOLIDATED CONTROLS CORPORATION

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

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

21760 SCHATZ MANUFACTURING CO
FAIRVIEW AVENUE PO BOX 1191
POUGHKEEPSIE, NEW YORK 12601
FORMERLY FEDERAL BRG CO AND SCHATZ MFG CO V53268
FORMERLY SCHATZ MFG CO

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

50294 NEW HAMPSHIRE BALL BEARINGS, INC PRECISION DIVISION
9700 INDEPENDENCE AVENUE
CHATSWORTH, CALIFORNIA 91311
FORMERLY NIPPON MINATURE BEARING CORP V23589 AND NMB
AMERICA INC AND NMB INC

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
301 HIGHLAND AVE
JENKINTOWN, PENNSYLVANIA 19046
FORMERLY STANDARD PRESSED STEEL

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

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

64422 AMERICAN VARISEAL CORP
510 BURBANK STREET PO BOX 840
BROOMFIELD, COLORADO 80020-1604
FORMERLY V0751B IN DENVER, COLORADO V9S158

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

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 BEARING, INC HITECH DIVISION
172 JAFFREY ROAD
PETERBOROUGH, NEW HAMPSHIRE 03458

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

92563 MCGILL MFG CO INC BEARINGS DIV
909 LAFAYETTE STREET
VALPARAISO, INDIANA 46383-4210

VENDORS

97415 SMITHS AEROSPACE ACTUATION SYSTEMS-YAKIMA
2720 W WASHINGTON AVE
YAKIMA, WASHINGTON 98909-0907
FORMERLY DECOTO AIRCRAFT AND DOWTY DECOTO; FORMERLY DOWTY AEROSPACE YAKIMA
DECOTO AIRCRAFT INC SEE DOWTY DECOTO INC

97928 SEE V17446 HUCK INTL
SEE V17446 HUCK INTL
HUCK INTL SEE V17446 HUCK INTL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ACMKP04JAP510LY		1	101A	2
		1	342A	2
		1	484A	2
		1	624A	4
		1	691A	4
		1	783A	4
ACMKP04JP510LY1		1	201A	2
		1	447A	1
		4	65	1
		5	10	1
ACMKP05JAP510LY		1	231A	2
		1	764A	4
ACMKP06JAP510LY		1	643	4
ACMKP3AFS428		1	101A	2
		1	342A	2
		1	484A	2
		1	624A	4
		1	691A	4
		1	783A	4
AHRSC3CFR6		1	504A	2
AMB540DDNJC		1	48A	4
AMKP16BSNJC		1	561A	3
AN316-5L		1	180	2
		1	318	2
		1	429	1
AN960C1616L		1	591	1
AN960C416		1	140	2
		1	294	1
		1	338A	1
		1	465	1
		1	618	2
		1	682	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN960C416L		1	12	1
		1	110	1
AN960C516		1	222	1
		1	510	2
		1	753	2
		1	795	4
		1	813	4
		1	915	4
		1	933	8
AN960C616LL		1	336	1
		1	468	1
		1	612	2
AN960C616LL		1	685	2
AN960JD10		1	363	2
		1	489	1
		1	567	4
AN960JD10L		1	246	2
		1	600	4
		1	667	2
		1	888	2
		1	897	6
AN960JD10LL		2	10	4
		5	30	4
AN960JD416		1	92	2
		1	192	1
		1	282	2
		1	333	1
		1	405	1
		1	408	1
		1	615	2
		1	679	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN960JD416L		1	9	1
		1	441	2
		1	471	1
		1	777	4
AN960JD516		1	219	1
		1	756	2
AN960JD516L		1	819	1
AN960JD616		1	642	2
		1	843	2
AN960JD616L		1	846	2
AN960JD716L		1	798	4
		1	810	4
AN960JD816		1	393	2
AN960JD816L		1	36	2
		1	742	1
AN960XC716LL		1	225	1
		1	759	2
		1	936	8
ATF3		1	498	1
AVP3088		1	45	4
BACB10AF5F6HS		1	504	2
BACB10BX4		1	101	2
		1	342	2
		1	484	2
		1	624	4
BACB10BX4		1	691	4
		1	783	4
BACB10BX5		1	231	2
		1	764	4
BACB10BX6		1	648	2
BACB10BY4		1	201	2
		1	447	1
		2	70	1
BACB10CF14PP		1	48	4
BACB10ET03		1	498	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB10EX16		1	561	3
BACB10E04GC		1	27	2
BACB10FS04J		1	101A	2
		1	342A	2
		1	484A	2
		1	624A	4
		1	691A	4
		1	783A	4
BACB10FS05J		1	231A	2
		1	764A	4
BACB10FS06J		1	643	4
BACB10FT04J		1	201A	2
		1	447A	1
		4	65	1
		5	10	1
BACB10FU14J		1	48A	4
BACB10FV16J		1	561A	3
BACB10GS05FJ6		1	504A	2
BACB10HH03		1	498A	1
BACB28AK03-046		1	369	1
BACB28AK03-070		1	372	1
BACB28AK04-014		1	116	1
BACB28AK04-018		1	646Q	4
BACB28AK04-021		1	147	2
BACB28AK04-023		1	159	1
BACB28AK04-026		1	450	2
BACB28AK04-030		1	156	1
BACB28AK04-031		1	694	2
BACB28AK04-032		1	21	1
		1	633	2
BACB28AK04-040		1	18	1
BACB28AK04-041		1	414	1
BACB28AK04-047		1	351	1
		1	477	1
BACB28AK05-031		1	240	1
BACB28AK05-033		1	765	2
BACB28AK05-042		1	942	8
BACB28AK05-045		1	804	4
BACB28AK05-055		1	822	4
BACB28AK05-089		1	825	2
BACB28AK05-120		1	828	2
		1	921	2
BACB28AK06-120		1	882	2
BACB28X3C007		1	381	1
BACB28X4C007		2	80	1
		4	75	1
		5	95	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB28X4C014		1	54	1
BACB28X4C016		1	345	1
		1	630	2
		1	697	2
BACB28X4C022		1	128	1
BACB28X4C027		1	483	1
BACB28X5C010		1	237	1
BACB28X5C016		1	771	2
BACB28X5M007		1	378	1
BACB28X6M007		2	85	1
		4	80	1
		5	100	1
BACB28X6M014		1	348	1
		1	627	2
		1	700	2
BACB28X6M015		1	57	1
BACB28X6M018		1	480	1
BACB28X6M022		1	131	1
BACB28X7M014		1	234	1
		1	768	2
BACB28X7M027		1	978	8
		3	25	8
BACB28X7M029		1	861	4
BACB28X7M033		1	834	8
BACB28X7M045		1	948	4
BACB28X9M048		1	957	4
BACB28Y5M021		2	75	1
		4	70	1
		5	90	1
BACB28Y5M044		1	388	2
BACB30LH4-9		1	774	4
BACB30LJ4-14		1	137	2
BACB30LJ4-14		1	288	1
BACB30LJ4-16		1	6	1
BACB30LJ4-17		1	276A	2
BACB30LJ4-29		1	150	1
BACB30LM3-6		4	10	4
BACB30NE3-7		1	63A	2
BACB30NM3K11		1	357	1
BACB30NM3K15		1	360	1
BACB30NM3K5		1	564	4
BACB30NM3K8		1	594	2
BACB30NM4K16		1	402	1
BACB30NM4K17		1	399	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30NM5K27		1	912	2
BACB30NM5K28		1	792	2
BACB30NM5K39		1	930	4
BACB30NM5K44		1	807	2
BACB30NN3K4		1	894	6
BACB30NN3K5		1	885	2
BACB30NR4K12		1	645L	2
BACB30NR4K13		1	645Q	2
BACB30NR4K14		1	438	2
BACB30NR4K18		1	3	1
BACB30NR4K20		1	537A	4
BACB30NR4K43		1	86	1
BACB30NR4K72		1	606	2
BACB30NR4K80		1	327	1
		1	673	2
BACB30NR4K81		1	459	1
BACB30NR5K76		1	748	2
BACB30NR5K80		1	213	1
BACB30NR6K17		1	840	2
BACB30NT3DK15		1	486	1
BACB30US4K45		1	186	1
BACB30US6K29		1	870	2
BACB30VT12K42		1	636	2
BACB30VT8K12		1	107	1
BACC13Y3B90		1	721	2
BACN10JC3CM		1	603	2
BACN10JC4CD		1	543	4
BACN10JC4CM		1	15	2
		1	95	1
		1	113	1
		1	143	2
		1	153	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACN10JC4CM		1	198	1
		1	285	2
		1	297	1
		1	339	1
		1	444	2
		1	474	1
		1	621	2
		1	688	2
		1	780	4
BACN10JC5CM		1	228A	1
		1	762	2
BACN10JC6CM		1	849	2
BACN10JC6M		1	645	2
BACN10JC8CD		1	39	2
BACN10JD105CD		1	513	2
BACN10JD3CD		1	492	1
BACN10JN3		2	25	4
		4	30	4
		5	45	4
BACN10JP3DCD		1	80A	2
BACN10YR3CM		1	603A	2
BACN10YR4CD		1	646L	4
BACN10YR4CM		1	15A	2
		1	95A	1
		1	113A	1
		1	143A	2
		1	153A	1
		1	198A	1
		1	285A	2
		1	297A	1
		1	339A	1
		1	621A	2
		1	688A	2
		1	780A	4

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACN10YR5CM		1	228B	1
		1	762A	2
BACN10YR6CM		1	645B	2
		1	849A	2
BACN10YR6M		1	645A	2
BACN10YR8CD		1	39A	2
BACP18BC02A06P		1	243A	1
		1	516A	2
		1	658A	2
BACP18BC03A10P		1	739A	2
BACR15BA3AD		1	75	4
BACR15BA3AD		2	15	8
		2	55	12
		4	20	8
		4	50	12
		5	35	8
		5	75	12
BACR15BB4AD		2	20	1
		4	25	1
		5	40	1
BACS12BP08P5		1	519	2
BACW10BN4AC		1	645V	4
BACW10BP4CD		1	195	1
BACW10BP6CD		1	873	2
BACW10BP6DP		1	876	2
BACW10CT12J		1	639	2
BACW10EG12J		1	639A	2
BACW10P24OL		1	507	2
BMN4122CPD8-8		1	39	2
BRFM20A3		2	25	4
		4	30	4
		5	45	4

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BRH10C3M		1	603	2
BRH10C4D		1	543	4
BRH10C4M		1	15	2
		1	95	1
		1	113	1
		1	143	2
		1	153	1
		1	198	1
		1	285	2
		1	297	1
		1	339	1
		1	444	2
		1	474	1
		1	621	2
		1	688	2
		1	780	4
BRH10C5M		1	228A	1
		1	762	2
BRH10C6M		1	849	2
B540-2TS		1	48	4
B540DD		1	48	4
B540DDFS101		1	48	4
B540DDFS428		1	48	4
B540DDNJC		1	48	4
B540DDP		1	48	4
B540FS101		1	48	4
B540SSG27		1	48	4
CS204E		1	101	2
		1	342	2
		1	484	2
		1	624	4
		1	691	4
		1	783	4
CS205E		1	231	2
		1	764	4
CS206E		1	648	2
HRS3CFR6		1	504	2
HST10AG12-42		1	636	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HST10AG8-12		1	107	1
HO1-3BAC		1	603	2
HO1-4BAC		1	15	2
		1	95	1
		1	113	1
		1	143	2
		1	153	1
		1	198	1
		1	285	2
		1	297	1
		1	339	1
		1	444	2
		1	474	1
		1	621	2
		1	688	2
		1	780	4
HO1-5BAC		1	228A	1
		1	762	2
HO1-6BAC		1	849	2
H51650-4BAC		1	543	4
H51650-8BAC		1	39	2
H52732-3CM		1	603A	2
H52732-4CD		1	646L	4
H52732-4CM		1	15A	2
		1	95A	1
		1	113A	1
		1	143A	2
		1	153A	1
		1	198A	1
		1	285A	2
		1	297A	1
		1	339A	1
		1	621A	2
		1	688A	2
		1	780A	4
H52732-5CM		1	228B	1
		1	762A	2
H52732-6CM		1	645B	2
		1	849A	2
H52732-6M		1	645A	2
H52732-8CD		1	39A	2
KP16BS		1	561	3
KP16BSFS428		1	561	3
KP16BSLY196		1	561	3
KP16BSNJC		1	561	3

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
KP16BSSD610		1	561	3
KP4		1	201	2
		1	447	1
		2	70	1
KP4A		1	101	2
		1	342	2
		1	484	2
		1	624	4
		1	691	4
		1	783	4
KP4AFS428		1	101	2
		1	342	2
		1	484	2
		1	624	4
		1	691	4
		1	783	4
KP4AG27		1	101	2
KP4AG27		1	342	2
		1	484	2
		1	624	4
		1	691	4
		1	783	4
KP4ALY196		1	101	2
		1	342	2
		1	484	2
		1	624	4
		1	691	4
		1	783	4
KP4ANJC		1	101	2
		1	342	2
		1	484	2
		1	624	4
		1	691	4
		1	783	4
KP4ASD610		1	101	2
		1	342	2
		1	484	2
		1	624	4
		1	691	4
		1	783	4
KP4A2TS		1	101	2
		1	342	2
		1	484	2
		1	624	4
		1	691	4
		1	783	4

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
KP4FS428		1	201	2
		1	447	1
		2	70	1
KP4G27		1	201	2
		1	447	1
		2	70	1
KP4SD610		1	201	2
		1	447	1
		2	70	1
KP4TT		1	201	2
		1	447	1
		2	70	1
KP5A		1	231	2
		1	764	4
KP5AFS428		1	231	2
		1	764	4
KP5AG27		1	231	2
		1	764	4
KP5ALY196		1	231	2
		1	764	4
KP5ANJC		1	231	2
		1	764	4
KP5ASD610		1	231	2
		1	764	4
KP5A2TS		1	231	2
		1	764	4
KP6A		1	648	2
LLKP4		1	201	2
		1	447	1
		2	70	1
LLKP4A		1	101	2
		1	342	2
		1	484	2
		1	624	4
		1	691	4
		1	783	4
LLKP5A		1	231	2
		1	764	4
LLKP6A		1	648	2
MF1000-3BAC		2	25	4
		4	30	4
		5	45	4

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
MF53049-3		2	25	4
		4	30	4
		5	45	4
MILB81935-104K		1	171	2
		1	309	2
		1	423	1
MILB81935-104L		1	168	2
		1	306	2
		1	420	1
MS16562-216		1	258	2
MS16624-4050		1	972	2
		3	15	2
MS20392-2A27		1	249	1
MS20392-2A35		1	670	2
MS20392-2C23		1	715	2
MS24586-634		1	718	2
MS24665-132		1	709	2
MS24665-153		1	243	1
		1	495	1
		1	516	2
		1	658	2
MS24665-304		1	739	2
NAS1149C0432R		1	12A	1
NAS1149C0463R		1	140A	2
		1	294A	1
		1	338B	1
		1	618A	2
		1	682A	2
NAS1149C0563R		1	222A	1
		1	510A	2
		1	753A	2
		1	795A	4
		1	813A	4
		1	915A	4
		1	933A	8

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NAS1149C0616R		1	336A	1
		1	612A	2
		1	685A	2
NAS1149C0716B		1	225A	1
		1	759A	2
		1	936A	8
NAS1149C1632R		1	591A	1
NAS1149D0316J		4	15	4
NAS1149D0332J		1	246A	2
		1	600A	4
		1	667A	2
		1	888A	2
		1	897A	6
NAS1149D0363J		1	567A	4
NAS1149D0416J		1	9A	1
		1	110A	1
		1	777A	4
NAS1149D0463J		1	92A	2
		1	192A	1
NAS1149D0463J		1	282A	2
		1	333A	1
		1	540A	8
		1	615A	2
		1	646	4
		1	679A	2
NAS1149D0516J		1	819A	1
NAS1149D0563J		1	219A	1
		1	756A	2
NAS1149D0616J		1	846A	2
NAS1149D0663J		1	642A	2
		1	843A	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NAS1149D0716J		1	798A	4
		1	810A	4
NAS1149D0816J		1	36A	2
		1	742A	1
NAS1149D0863J		1	393A	2
NAS1423-5		1	177	2
		1	315	2
		1	432	1
NAS1423-6		1	724	2
NAS1805-3L		1	366	2
		1	570	4
		1	891	2
		1	900	6
NAS1805-4L		1	411	2
NAS1805-5L		1	801	2
		1	816	2
		1	918	2
		1	939	4
NAS1805-6L		1	879	2
NAS43DD3-1N		1	712	2
NAS43DD3-12		1	664	2
NAS43DD3-12FC		1	664A	2
NAS43DD3-16		1	597	2
NAS43DD3-16FC		1	597A	2
NAS43DD3-5		1	661	2
NAS43DD3-5FC		1	661A	2
NAS43DD4-060		1	189	1
NAS43DD4-060FC		1	189A	1
NAS43DD4-210		1	609	2
NAS43DD4-210FC		1	609A	2
NAS43DD4-227		1	462	1
NAS43DD4-227FC		1	462A	1
NAS43DD4-230		1	330	1
NAS43DD4-230FC		1	330A	1
NAS43DD4-240		1	676	2
NAS43DD4-240FC		1	676A	2
NAS43DD4-58		1	89	2
NAS43DD4-58FC		1	89A	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NAS43DD5-220		1	751	2
NAS43DD5-220FC		1	751A	2
NAS43DD5-242		1	216	1
NAS43DD5-242FC		1	216A	1
NAS513-5		1	174	2
		1	312	2
		1	426	1
NAS513-6		1	727	2
NAS6603-7		1	63	2
NAS6703-6		2	5	4
		5	25	4
NAS74A4E007P		1	204	1
NAS74A6E009P		1	651	2
NS103218-02		2	25	4
		4	30	4
		5	45	4
NS202101SE02		1	603	2
NS202486-048		1	543	4
PACMB540DDFS428		1	48A	4
PACMKP04JAA3908		1	101A	2
		1	342A	2
		1	484A	2
		1	624A	4
		1	691A	4
		1	783A	4
PACMKP04JAFS428		1	101A	2
		1	342A	2
		1	484A	2
		1	624A	4
		1	691A	4
		1	783A	4
PACMKP04JA3908		1	201A	2
		1	447A	1
		4	65	1
		5	10	1
PACMKP05JAA3908		1	231A	2
		1	764A	4
PACMKP06JAA3908		1	643	4
PACMKP16BSFS428		1	561A	3
PACMKP4FS428		1	201A	2
		1	447A	1
		4	65	1
		5	10	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
PACMKP5AFS428		1	231A	2
		1	764A	4
PACMKP6AFS428		1	643	4
PLH53CM		1	603A	2
PLH54CD		1	646L	4
PLH54CM		1	15A	2
		1	95A	1
		1	113A	1
		1	143A	2
		1	153A	1
		1	198A	1
		1	285A	2
		1	297A	1
		1	339A	1
		1	621A	2
		1	688A	2
		1	780A	4
PLH55CM		1	228B	1
		1	762A	2
PLH56CM		1	645B	2
		1	849A	2
PLH56M		1	645A	2
PLH58CD		1	39A	2
RMF9201M3		2	25	4
		4	30	4
		5	45	4
SSB52P		1	975B	2
		3	20	2
SSMB540DDSD624		1	48A	4
SSMKP04AP		1	101A	2
		1	342A	2
		1	484A	2
		1	624A	4
		1	691A	4
		1	783A	4

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
SSMKP04JASD705		1	101A	2
		1	342A	2
		1	484A	2
SSMKP04JASD705		1	624A	4
		1	691A	4
		1	783A	4
SSMKP04JP510LY8		1	201A	2
		1	447A	1
		4	65	1
		5	10	1
SSMKP04JSD705		1	201A	2
		1	447A	1
		4	65	1
		5	10	1
SSMKP05AP		1	231A	2
		1	764A	4
SSMKP05JAP		1	231A	2
		1	764A	4
SSMKP05JASD705		1	231A	2
		1	764A	4
SSMKP06AP		1	643	4
SSMKP4ASD524		1	101A	2
		1	342A	2
		1	484A	2
		1	624A	4
		1	691A	4
		1	783A	4
SSMKP5ASD524		1	231A	2
		1	764A	4
SSMKP6ASD524		1	643	4
T340E		1	48	4
T6C1032JM		1	603	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
T6C428JCD		1	543	4
T6C428JM		1	15	2
		1	95	1
		1	113	1
		1	143	2
		1	153	1
		1	198	1
		1	285	2
		1	297	1
		1	339	1
T6C428JM		1	444	2
		1	474	1
		1	621	2
		1	688	2
		1	780	4
T6C524JM		1	228A	1
		1	762	2
T8124S3S		4	30	4
		5	45	4
VN252A02		2	25	4
		4	30	4
		5	45	4
VN303D02		1	603	2
VN303D048		1	15	2
		1	95	1
		1	113	1
		1	143	2
		1	153	1
		1	198	1
		1	285	2
		1	297	1
		1	339	1
		1	444	2
		1	474	1
		1	621	2
		1	688	2
		1	780	4

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
YAF03B		1	498	1
102LH9074-8		1	39	2
102LH9075-4W		1	543	4
102LH9075-6		1	849	2
109LH9075-3W		1	603	2
109LH9075-4W		1	15	2
		1	95	1
		1	113	1
		1	143	2
		1	153	1
		1	198	1
		1	285	2
		1	297	1
		1	339	1
		1	444	2
		1	474	1
		1	621	2
109LH9075-4W		1	688	2
		1	780	4
109LH9075-5W		1	228A	1
		1	762	2
141T6632-1		1	969	2
		3	10	2
146N6314-3		1	588	1
146N6324-1		1	33	1
146N6328-10		1	453	1
		2	1	RF
		5	15	1
146N6328-11		2	30	2
		4	35	2
		5	50	2
146N6328-12		2	35	1
		4	45	1
		5	60	1
146N6328-13		2	40	1
		4	40	1
		5	55	1
146N6328-21		1	456A	1
		4	5	RF
146N6328-22		1	453A	1
		4	1A	RF
146N6328-23		4	85	1
146N6328-24		4	90	1
146N6328-25		1	456B	1
		5	5	RF

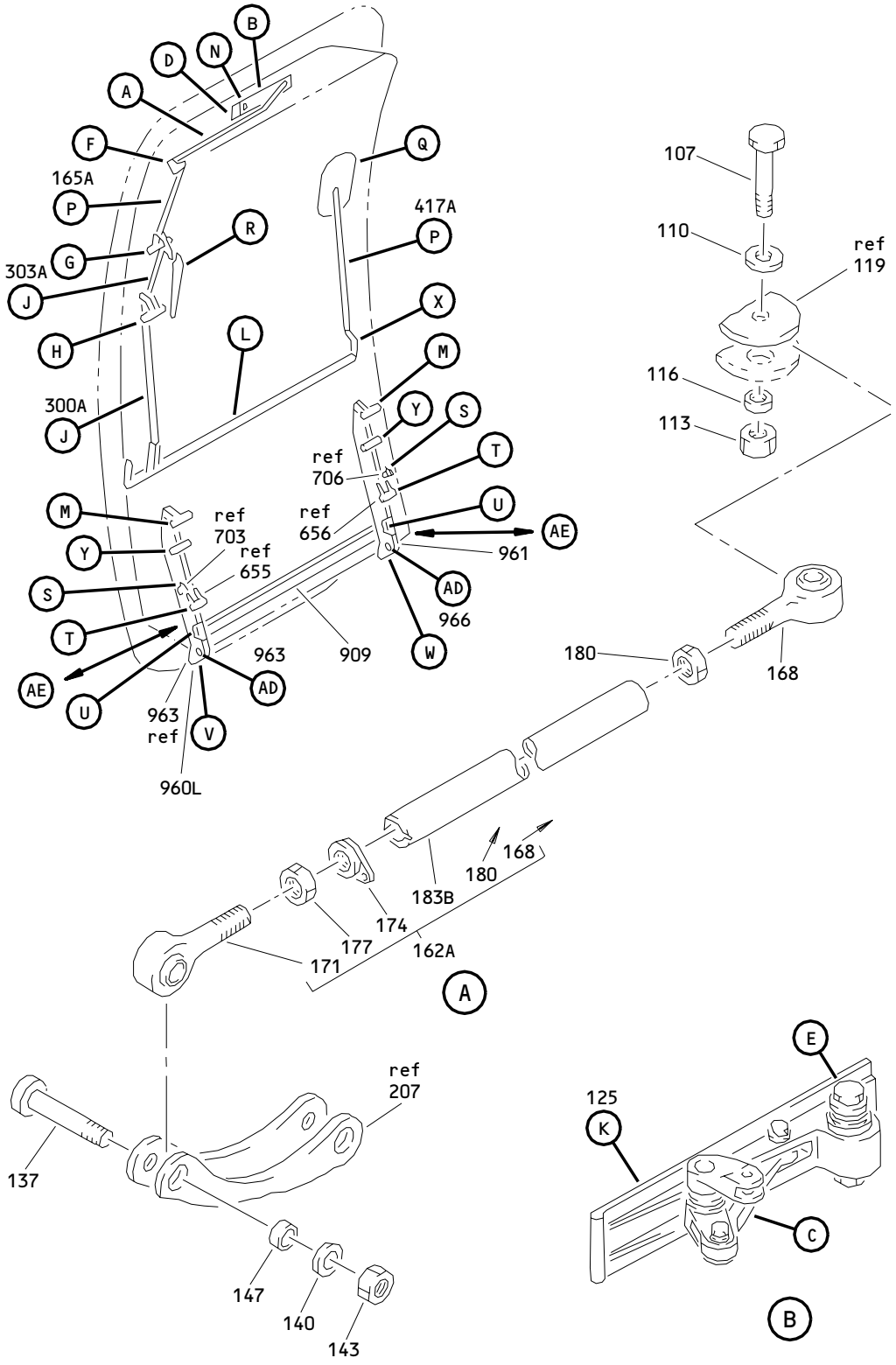
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
146N6328-26		1	453B	1
		5	1A	RF
146N6328-5		2	50	1
		5	70	1
146N6328-6		2	45	1
		5	65	1
146N6328-7		2	90	1
		5	110	1
146N6328-8		2	95	1
		5	105	1
146N6328-9		1	456	1
		2	3	RF
		5	20	1
146N6332-11		1	531	1
146N6332-12		1	534	1
146N6333-2		1	546	2
146N6334-1		1	24	1
146N6334-2		1	30	1
146N6339-10		1	267	1
146N6339-5		1	261	1
146N6339-7		1	252	1
146N6339-8		1	255	1
146N6339-9		1	264	1
146N6342-7		1	573	1
146N6342-8		1	576	1
146N6344-4		1	375	1
146N6344-5		1	384	1
146N6345-4		1	387	1
146N6345-5		1	390	1
146N6352-1		1	279	1
		1	291	1
146N6356-6		1	125	1
146N6356-7		1	134	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
146N6357-1		1	207	1
146N6357-2		1	210	1
146N6358-1		1	51	1
146N6358-2		1	60	1
146N6359-1		1	122	1
146N6359-2		1	119	1
146N6363-3		1	104	1
146N6370-1		1	69	1
146N6371-3		1	72	1
146N6371-4		1	83	1
146N6371-501		1	66A	1
146N6381-3		1	501	1
146T6505-1		1	993	1
		1	996	1
146T6505-7		1	993A	1
		1	996A	1
146T6550-1		1	1	RF
146T6550-2		1	2	RF
146T6550-3		1	1B	RF
146T6550-4		1	2A	RF
146T6550-5		1	1D	RF
146T6550-5001		1	962	1
146T6550-5002		1	962A	1
146T6550-6		1	2B	RF
146T6551-1		1	945	2
146T6551-2		1	951	2
146T6552-1		1	786	1
146T6552-2		1	789	1
146T6553-1		1	925	1
146T6553-2		1	924	1
146T6553-3		1	927	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
146T6554-1		1	954	2
146T6554-2		1	960	2
146T6555-1		1	963	1
146T6555-10		1	961	1
		1	966A	1
		3	5	RF
146T6555-11		1	981B	1
		3	30	1
146T6555-12		1	983B	1
		3	35	1
146T6555-13		1	981C	1
		3	30A	1
146T6555-14		1	983C	1
		3	35A	1
146T6555-2		1	966	1
146T6555-3		1	981	1
146T6555-4		1	983	1
146T6555-7		1	981A	1
146T6555-8		1	983A	1
146T6555-9		1	960L	1
		1	963A	1
		3	1A	RF
146T6556-1		1	831	2
146T6556-3		1	837	2
146T6556-4		1	837A	2
146T6557-3		1	354A	1
146T6558-1		1	706	1
146T6558-2		1	703	1
146T6558-3		1	736	1
146T6558-4		1	733	1
146T6558-7		1	736A	1
146T6558-8		1	733A	1
146T6559-1		1	745	2
146T6561-1		1	855	2
146T6561-2		1	858	2
146T6561-3		1	864	2
146T6561-4		1	867	2

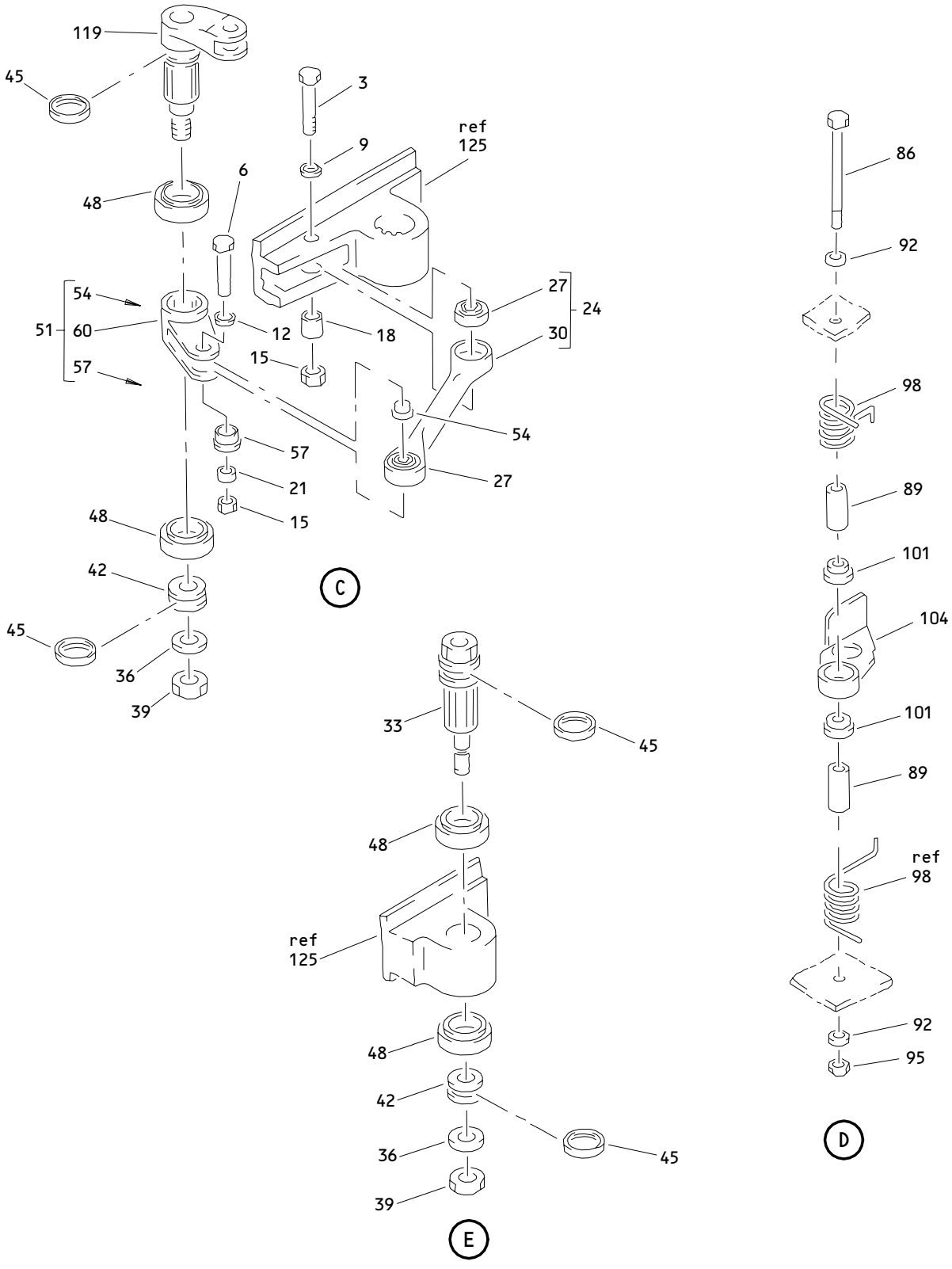
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
146T6564-13		1	162A	1
146T6564-14		1	417A	1
146T6564-15		1	165A	1
146T6564-16		1	300A	1
146T6564-17		1	303A	1
146T6564-18		1	183B	1
146T6564-19		1	435A	1
146T6564-20		1	184	1
146T6564-21		1	321A	1
146T6564-22		1	324A	1
146T6566-1		1	270	1
146T6566-2		1	273	1
146T6566-5		1	270A	1
146T6566-6		1	273A	1
146T6567-1		1	579	1
146T6567-2		1	585	1
146T6568-1		1	654	2
146T6568-3		1	655	1
146T6568-4		1	656	1
146T6569-1		1	730	2
146T6570-1		1	903	1
146T6570-2		1	906	1
146T6571-1		1	909	1
2-541501-1A		1	852	2
284N1750-5		1	528	1
284N1750-6		1	525	1
3-94319		1	396	1
3AFC512		1	498	1
66-15332-1		1	558	1
69-49936-2		1	555	1
69-49936-3		1	555A	1
69-49937-1		1	552	1
69-49939-2		1	42	2
69-52651-2		1	98	1
69-53400-501		1	501A	1
69-53401-3		1	549	1
69-53461-1		2	65	1
		4	60	1
		5	85	1
69-53462-501		2	60	1
		4	55	1
		5	80	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
69235-820CD		1	39	2
87570-1		1	652	2
9NS202101SE048		1	15	2
		1	95	1
		1	113	1
		1	143	2
		1	153	1
		1	198	1
9NS202101SE048		1	285	2
		1	297	1
		1	339	1
		1	444	2
		1	474	1
		1	621	2
		1	688	2
		1	780	4
97E02		1	603	2
97E054		1	228A	1
		1	762	2
97E064		1	849	2
97E48		1	15	2
		1	95	1
		1	113	1
		1	143	2
		1	153	1
		1	198	1
		1	285	2
		1	297	1
		1	339	1
		1	444	2
		1	474	1
		1	621	2
		1	688	2
		1	780	4

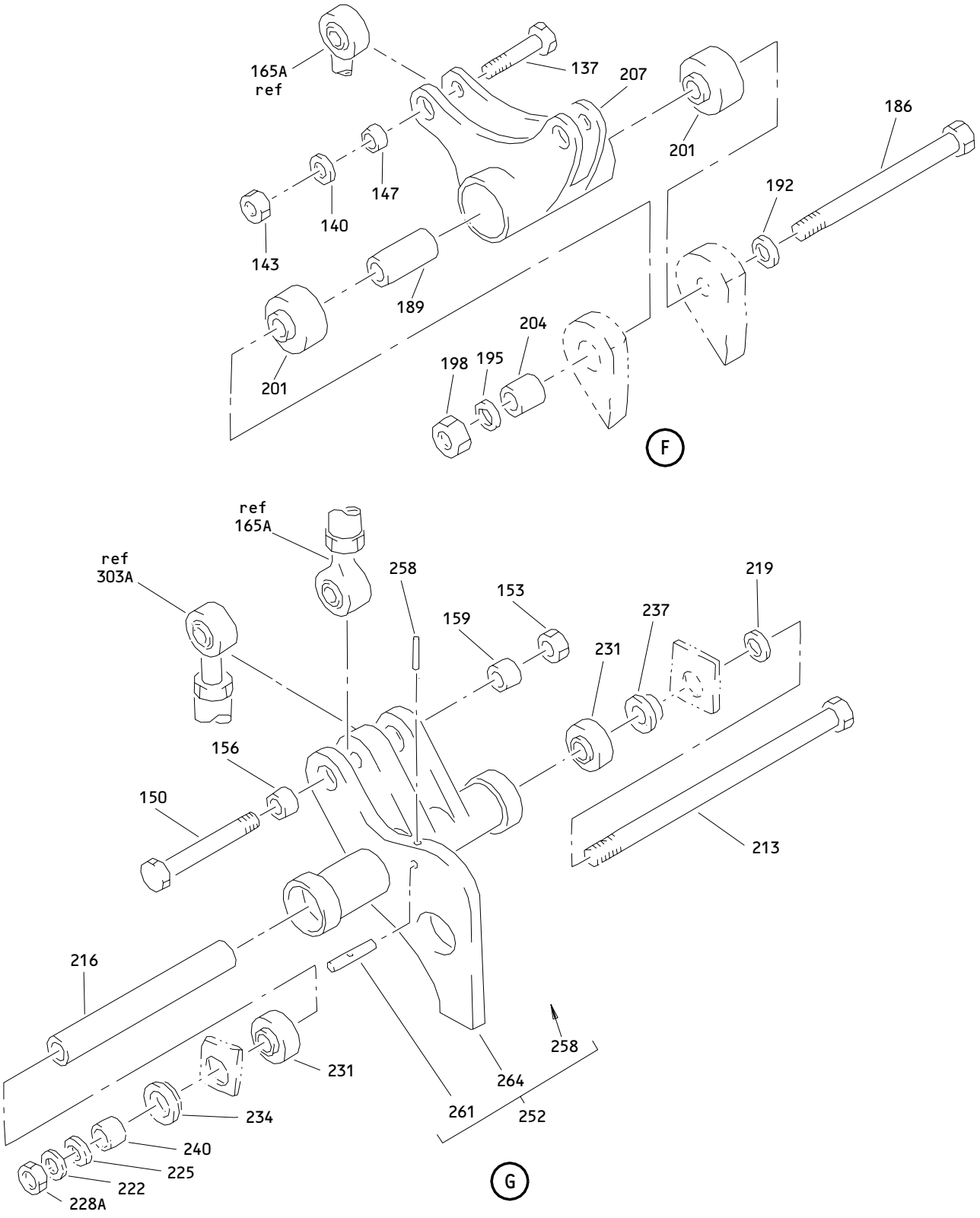


Emergency Exit Mechanism Installation
Figure 1 (Sheet 1)

685197

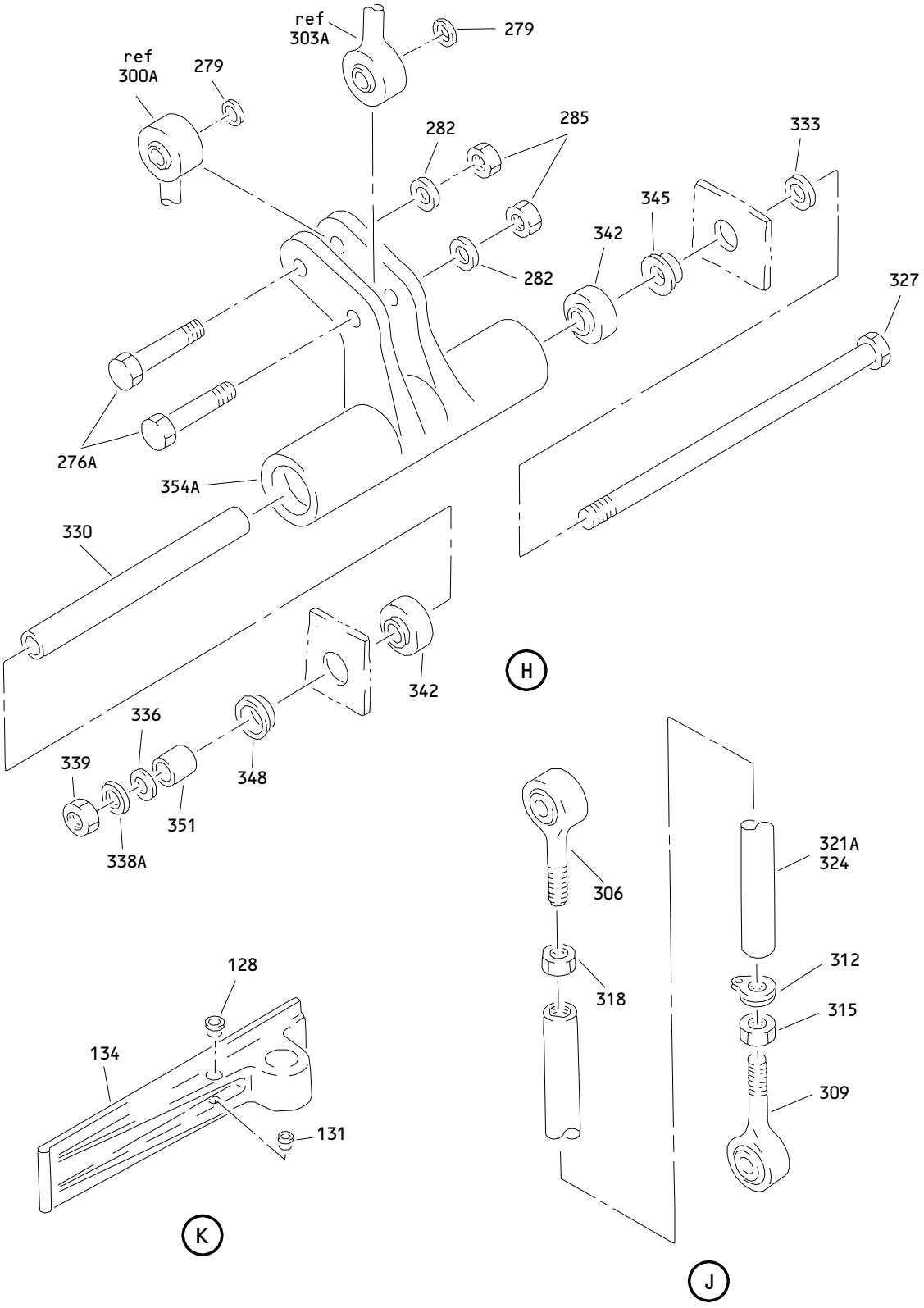


Emergency Exit Mechanism Installation
Figure 1 (Sheet 2)

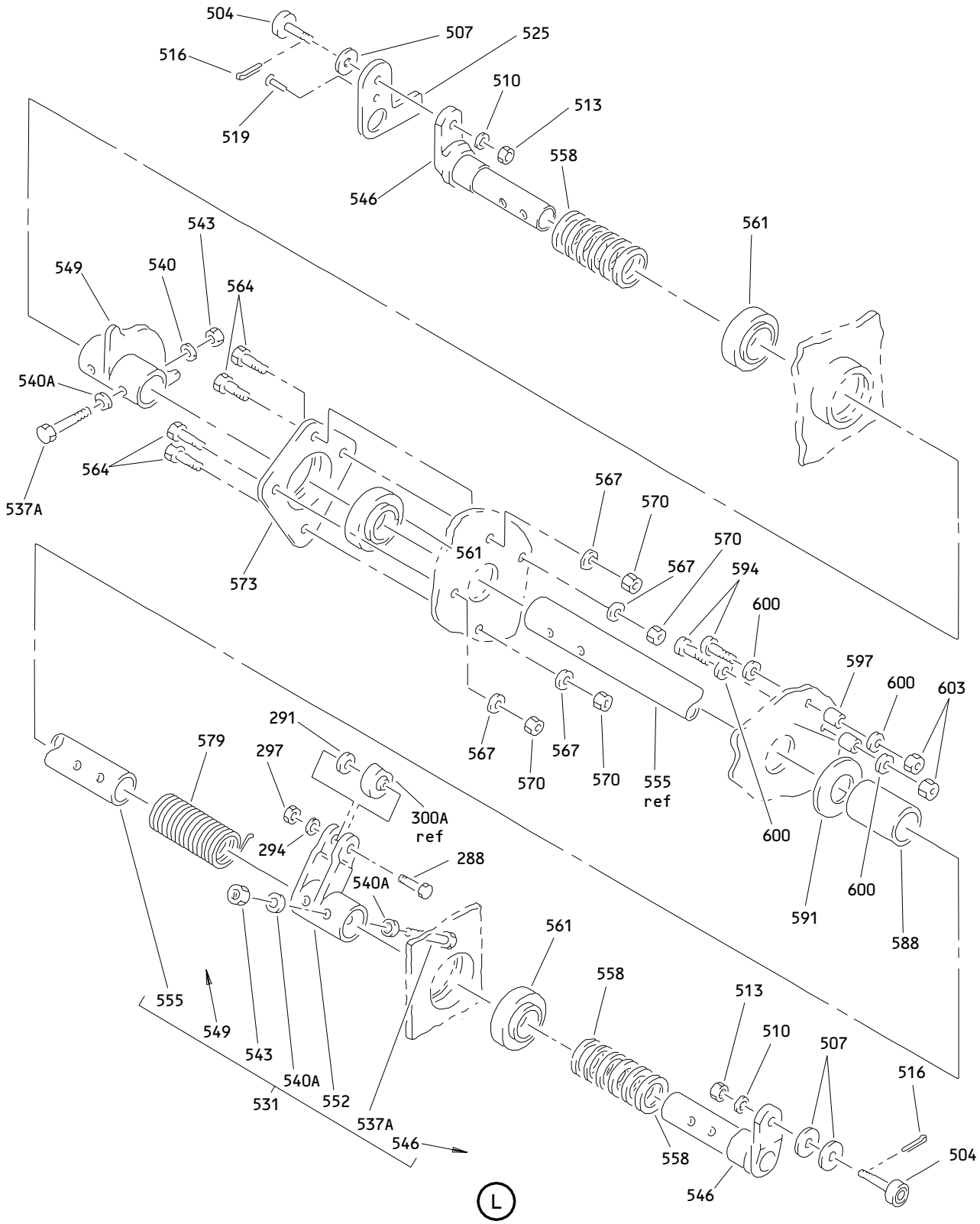


Emergency Exit Mechanism Installation
Figure 1 (Sheet 3)

685671

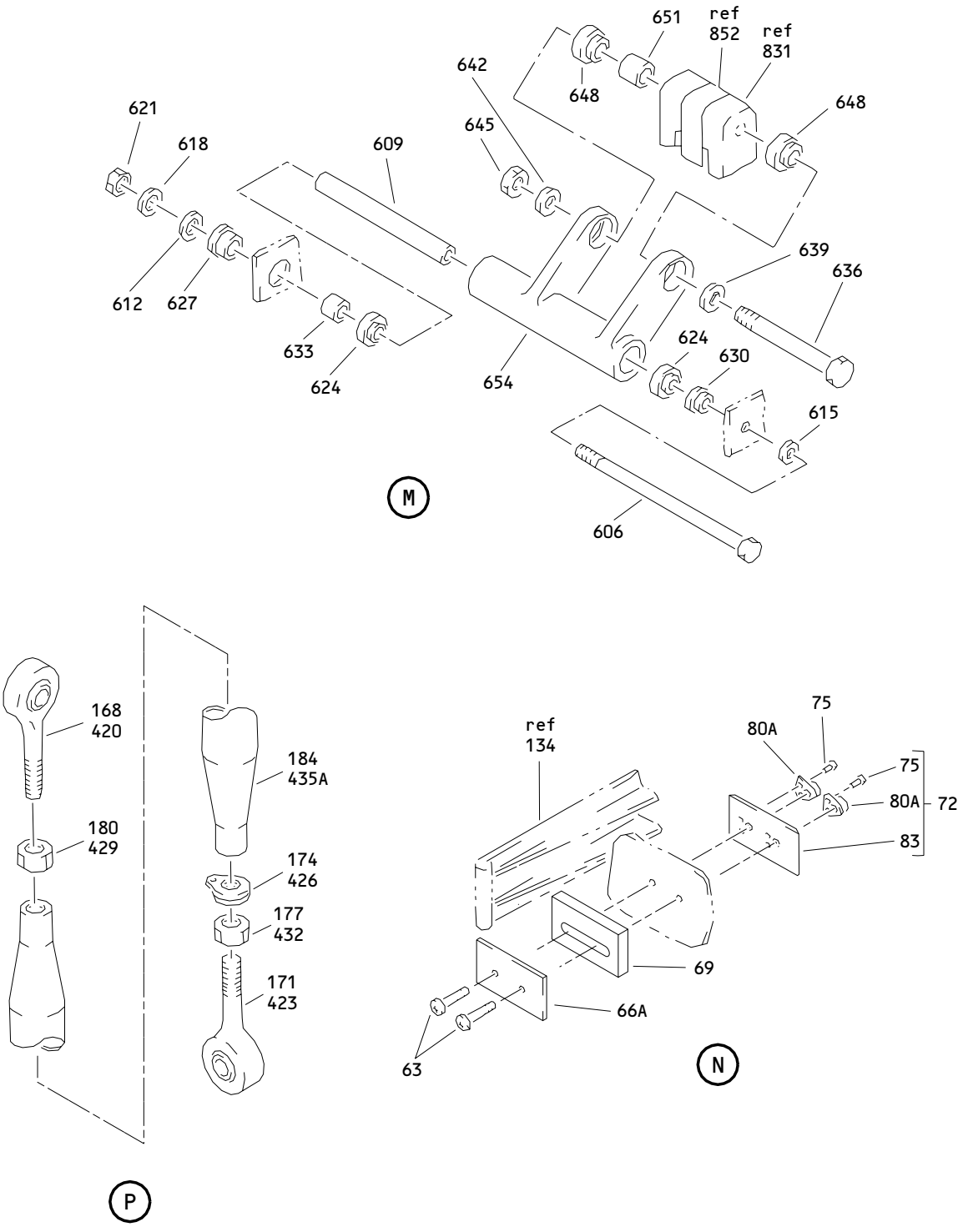


Emergency Exit Mechanism Installation
Figure 1 (Sheet 4)

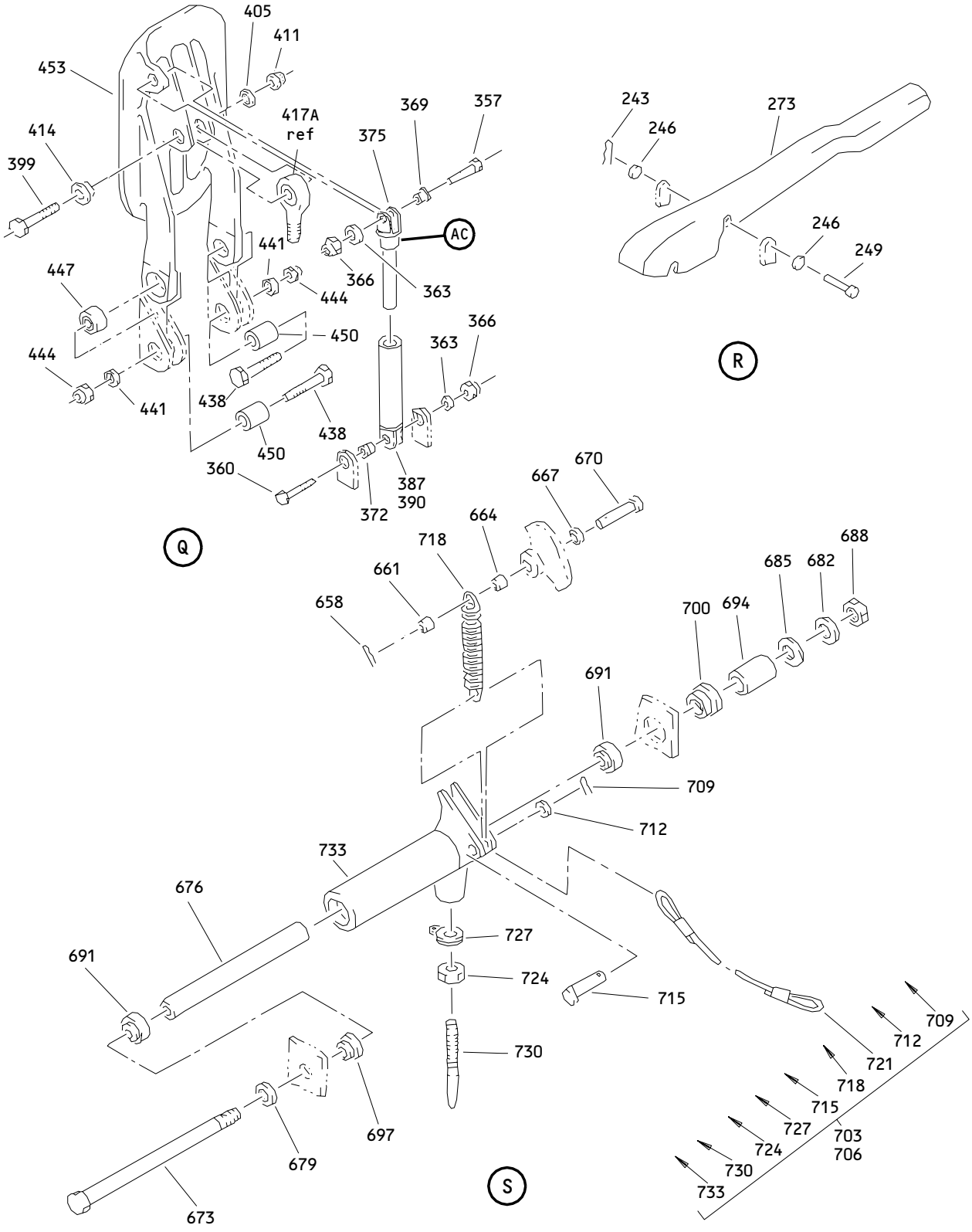


Emergency Exit Mechanism Installation
Figure 1 (Sheet 5)

685669

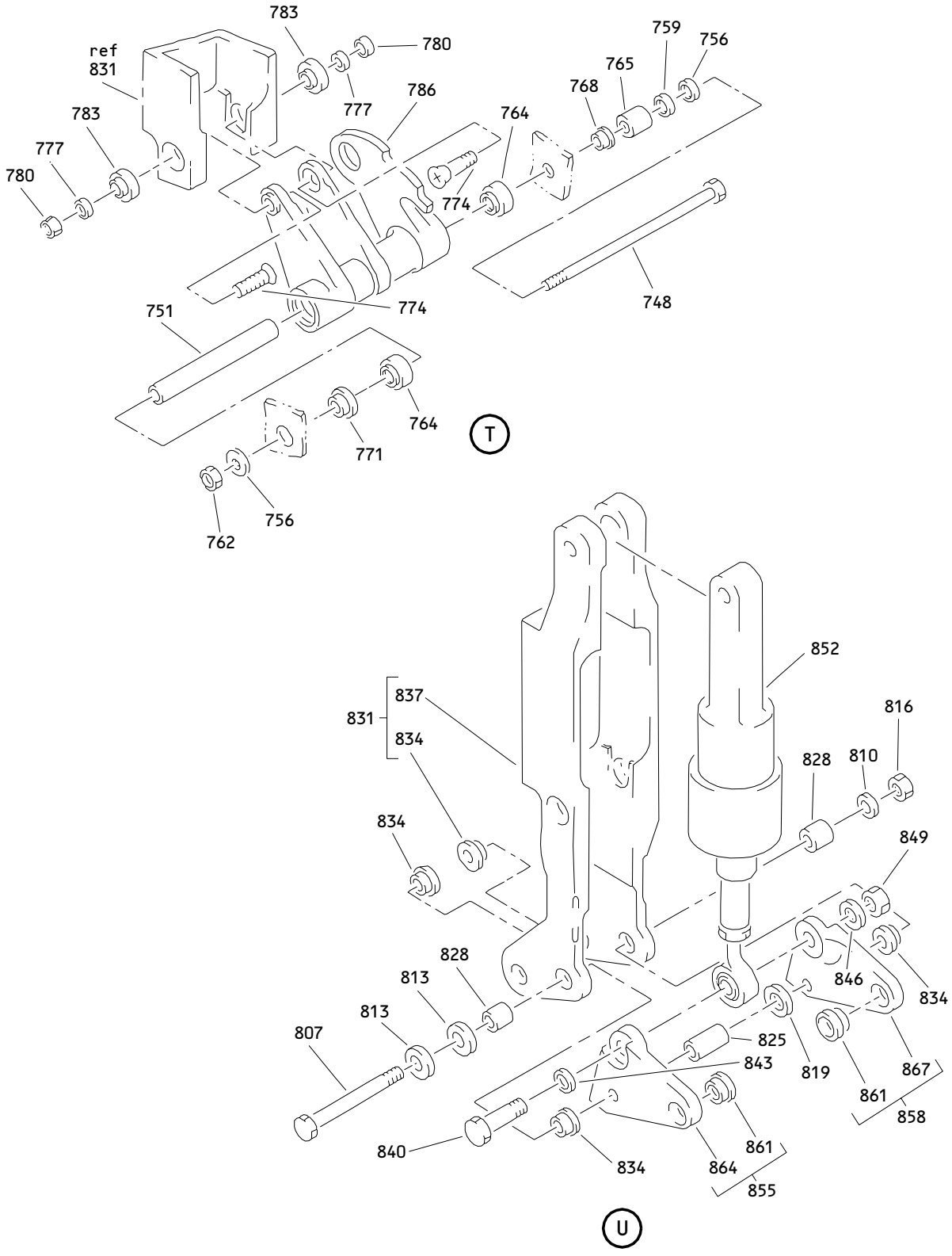


Emergency Exit Mechanism Installation
Figure 1 (Sheet 6)

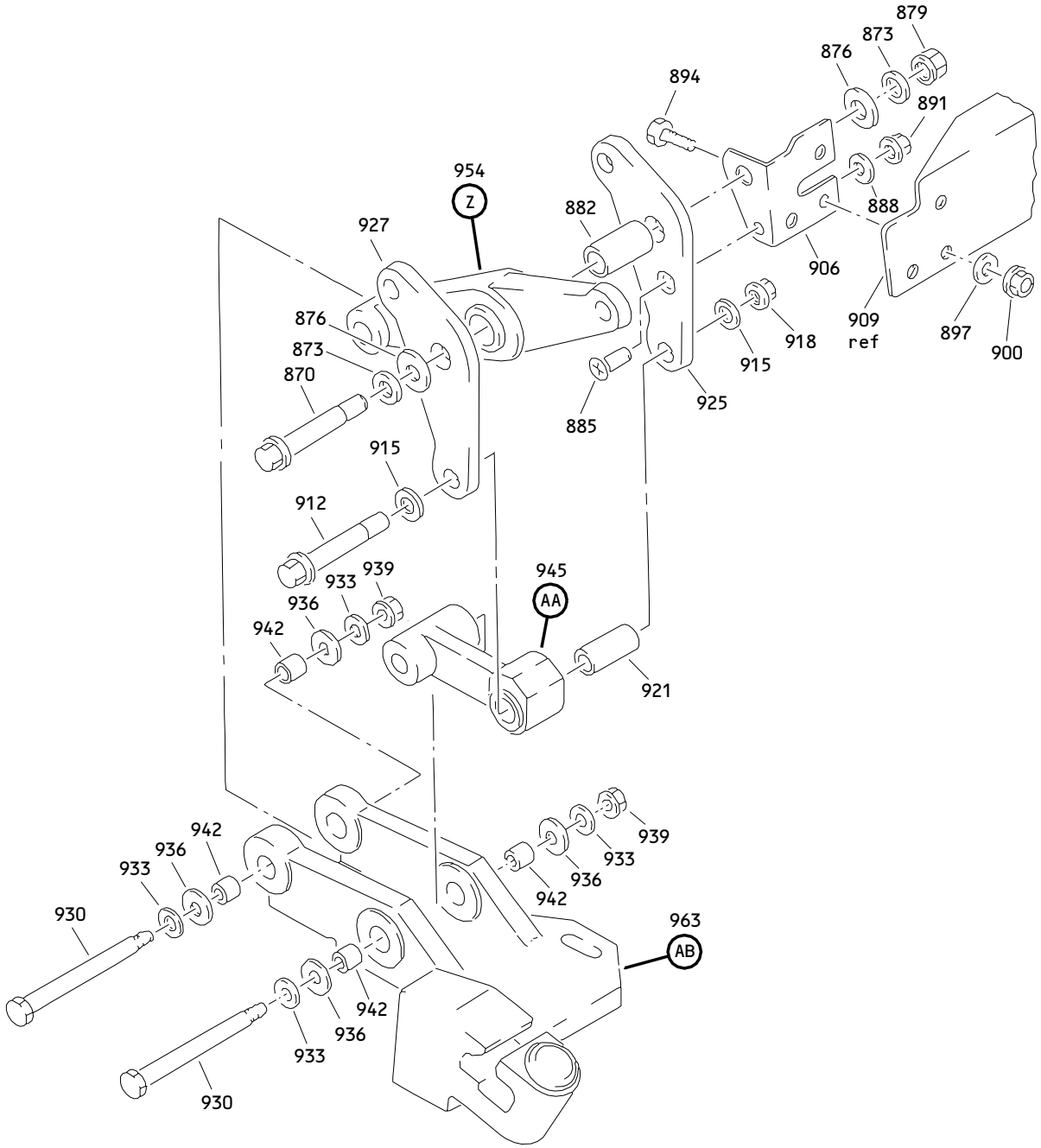


Emergency Exit Mechanism Installation
Figure 1 (Sheet 7)

685673

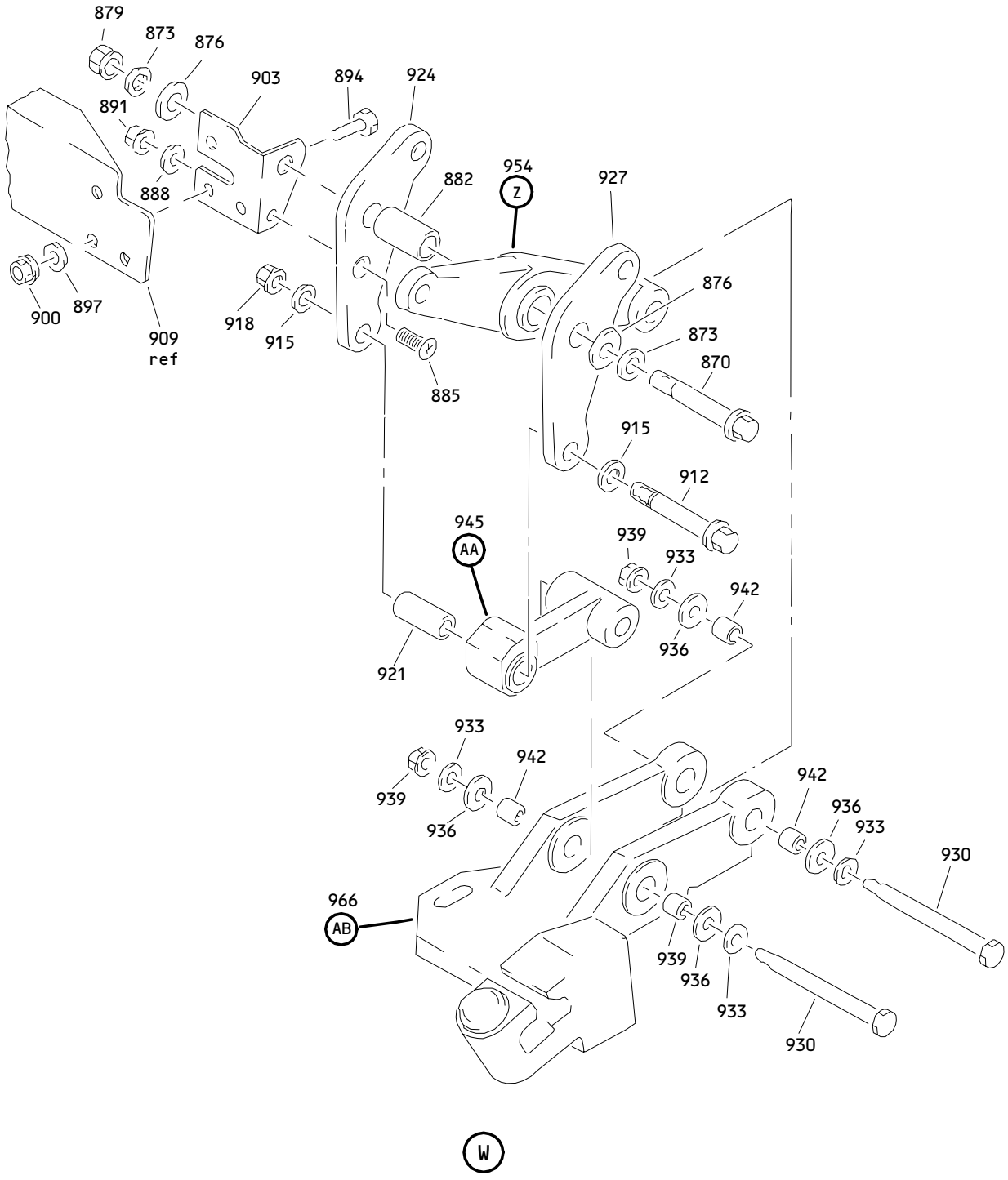


Emergency Exit Mechanism Installation
Figure 1 (Sheet 8)



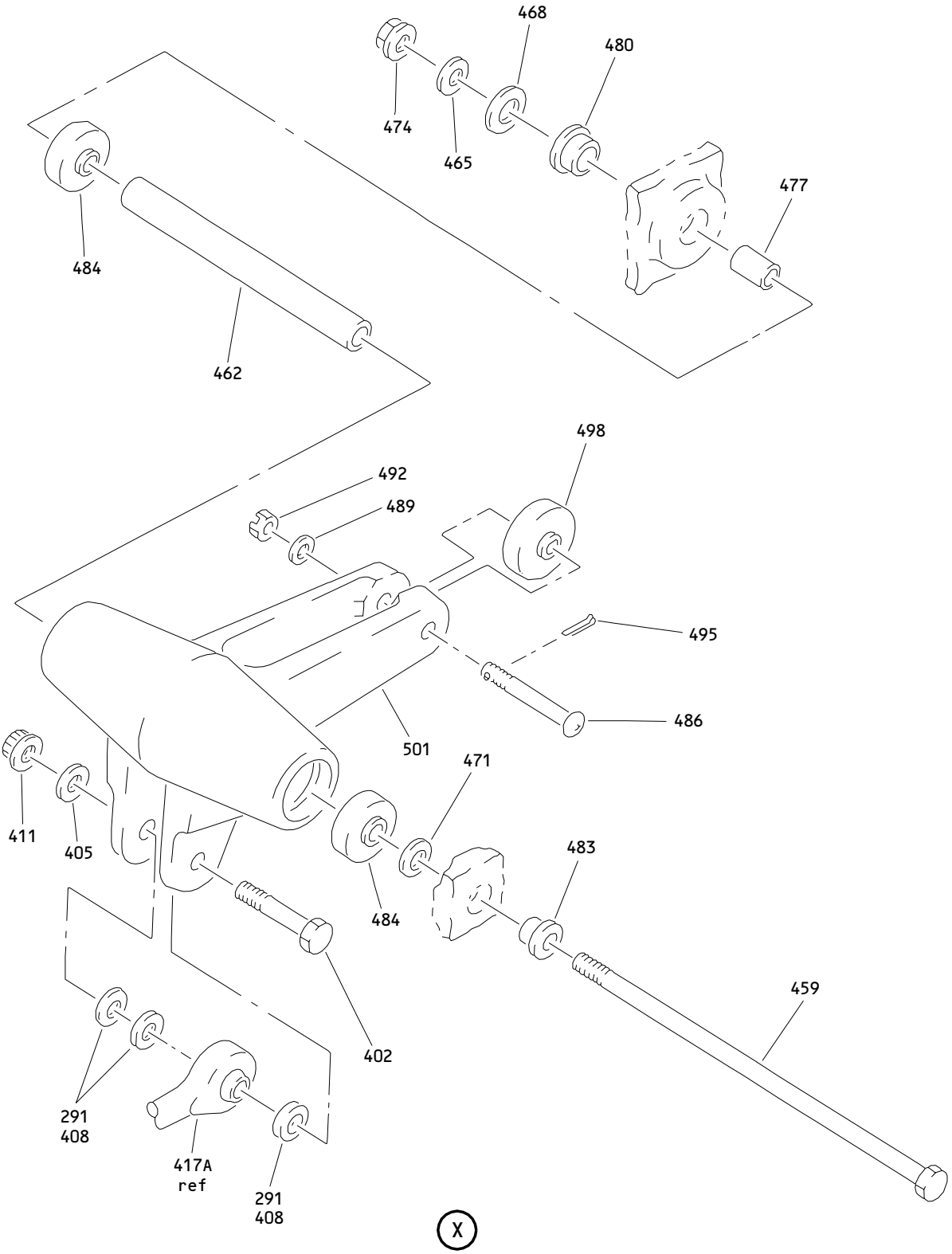
Emergency Exit Mechanism Installation
Figure 1 (Sheet 9)

685664



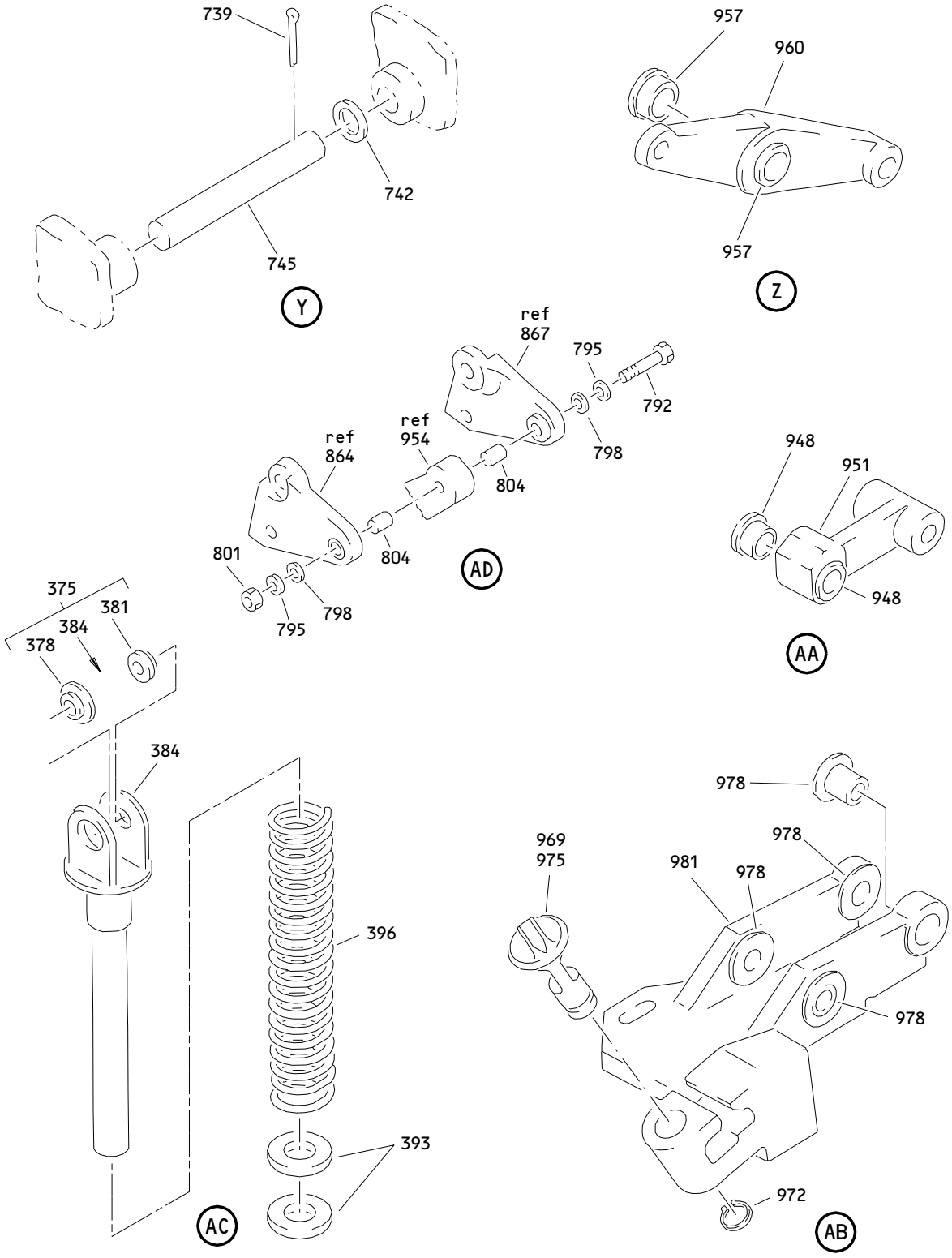
Emergency Exit Door Mechanism Installation
Figure 1 (Sheet 10)

688557

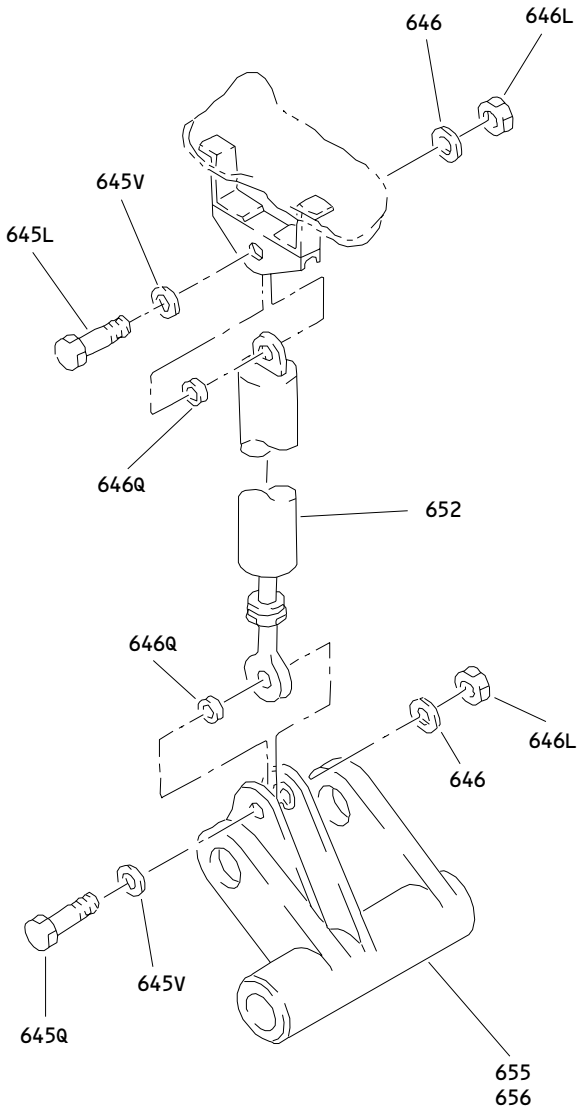


Emergency Exit Mechanism Installation
Figure 1 (Sheet 11)

685663



Emergency Exit Door Mechanism Installation
Figure 1 (Sheet 12)



Emergency Exit Mechanism Installation
Figure 1 (Sheet 13)

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-1	146T6550-1		MECHANISM INSTL-SECT. 46, EMER EXIT, LH DOOR (PRE SB 767-52-0068)	A	RF
	-1A	146T6550-2		DELETED		
	-1B	146T6550-3		MECHANISM INSTL-SECT. 46, EMER EXIT, LH DOOR (POST SB 767-52-0068)	C	RF
	-1C	146T6550-4		DELETED		
R	-1D	146T6550-5		MECHANISM INSTL-SECT. 46, EMER EXIT, LH DOOR	E	RF
R	-2	146T6550-2		MECHANISM INSTL-SECT. 46, EMER EXIT, RH DOOR (PRE SB 767-52-0068)	B	RF
R	-2A	146T6550-4		MECHANISM INSTL-SECT. 46, EMER EXIT, RH DOOR (POST SB 767-52-0068)	D	RF
R	-2B	146T6550-6		MECHANISM INSTL-SECT. 46, EMER EXIT, RH DOOR	F	RF
	3	BACB30NR4K18		.BOLT		1
	6	BACB30LJ4-16		.BOLT		1
	9	AN960JD416L		.WASHER	A,B	1
	-9A	NAS1149D0416J		.WASHER	C-F	1
	12	AN960C416L		.WASHER	A,B	1
	-12A	NAS1149C0432R		.WASHER	C-F	1
	15	BRH10C4M		.NUT- (V52828) (SPEC BACN10JC4CM) (OPT T6C428JM (V11815)) (OPT 97E48 (V80539)) (OPT 109LH9075-4W (V72962)) (OPT VN303D048 (V92215)) (OPT 9NS202101SE048 (VA8053)) (OPT H01-4BAC (V15653))	A,B	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-15A	H52732-4CM		.NUT-	C-F	2
			(V15653)		
			(SPEC BACN10YR4CM)		
			(OPT PLH54CM		
			(V62554))		
18	BACB28AK04-040		.BUSHING		1
21	BACB28AK04-032		.BUSHING		1
24	146N6334-1		.ROD ASSY-TIE		1
27	BACB10E04GC		..BEARING		2
30	146N6334-2		..ROD		1
33	146N6324-1		.SHAFT-EXT HANDLE		1
36	AN960JD816L		.WASHER	A,B	2
-36A	NAS1149D0816J		.WASHER	C-F	2
39	H51650-8BAC		.NUT-	A,B	2
			(V15653)		
			(SPEC BACN10JC8CD)		
			(OPT 102LH9074-8		
			(V72962))		
			(OPT 69235-820CD		
			(V92215))		
			(OPT BMN4122CPD8-8		
			(V97928))		
-39A	H52732-8CD		.NUT-	C-F	2
			(V15653)		
			(SPEC BACN10YR8CD)		
			(OPT PLH58CD		
			(V62554))		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
42	69-49939-2		.COLLAR		2
45	AVP3088		.SEAL- (V64422)		4
48	B54ODDNJC		.BEARING- (VO6144) (SPEC BACB1OCF14PP) (OPT B54O-2TS (V43991)) (OPT B54ODDFS428 (V21335)) (OPT B54OSSG27 (V3O163)) (OPT T34OE (VK8455)) (OPT B54ODDFS1O1 (VO6144)) (OPT B54ODD (V38443)) (OPT B54OFS1O1 (VO6144)) (OPT B54ODDP (V2176O))	A-D	4
R -48A	SSMB54ODDSD624		.BEARING- (V83O86) (SPEC BACB1OFU14J) (OPT PACMB54ODDFS428 (V21335)) (OPT AMB54ODDNJC (VO6144))	E,F	4
51	146N6358-1		.CRANK ASSY-EXT HANDLE		1
54	BACB28X4CO14		..BUSHING		1
57	BACB28X6MO15		..BUSHING		1
60	146N6358-2		..CRANK		1
63	NAS6603-7		.BOLT	A-D	2
R -63A	BACB3ONE3-7		.BOLT	E,F	2
66	AN96OJD1OL		DELETED		
66A	146N6371-5O1		.PLATE		1
69	146N637O-1		.BUMPER		1
72	146N6371-3		.FILLER ASSY		1
75	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		4
80	BACN1OJP3CCD		DELETED		
80A	BACN1OJP3DCD		..NUTPLATE		2
83	146N6371-4		..FILLER		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
86	BACB30NR4K43		.BOLT		1
89	NAS43DD4-58		.SPACER	A,B	2
-89A	NAS43DD4-58FC		.SPACER	C-F	2
92	AN960JD416		.WASHER	A,B	2
-92A	NAS1149D0463J		.WASHER	C-F	2
95	BRH10C4M		.NUT-	A,B	1
			(V52828)		
			(SPEC BACN10JC4CM)		
			(OPT T6C428JM		
			(V11815))		
			(OPT 97E48		
			(V80539))		
			(OPT 109LH9075-4W		
			(V72962))		
			(OPT VN303D048		
			(V92215))		
			(OPT 9NS202101SE048		
			(VA8053))		
			(OPT H01-4BAC		
			(V15653))		
-95A	H52732-4CM		.NUT-	C-F	1
			(V15653)		
			(SPEC BACN10YR4CM)		
			(OPT PLH54CM		
			(V62554))		

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-98	69-52651-2		.SPRING		1
	101	KP4ANJC		.BEARING- (V06144) (SPEC BACB10BX4) (OPT KP4AFS428 (V21335)) (OPT KP4A2TS (V43991)) (OPT LLKP4A (V38443)) (OPT KP4AG27 (V30163)) (OPT KP4A (V38443)) (OPT KP4ALY196 (V40920)) (OPT KP4ASD610 (V83086)) (OPT CS204E (VK8455)) (OPT KP4A (V21760))	A-D	2
R	-101A	ACMKP3AFS428		.BEARING- (V21335) (SPEC BACB10FS04J) (OPT PACMKP04JAA3908 (V21335)) (OPT SSMKP04JASD705 (V83086)) (OPT SSMKP4ASD524 (V50294)) (OPT SSMKP04AP (V21760)) (OPT PACMKP04JAFS428 (V21335)) (OPT ACMKP04JAP510LY (V40920))	E,F	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
104	146N6363-3		.TRIGGER		1
107	HST10AG8-12		.BOLT-		1
			(V0PTK6)		
			(SPEC BACB30VT8K12)		
			(OPT HST10AG8-12		
			(V06725))		
			(OPT HST10AG8-12		
			(V56878))		
			(OPT HST10AG8-12		
			(V73197))		
110	AN960C416L		.WASHER	A,B	1
-110A	NAS1149D0416J		.WASHER	C-F	1
113	BRH10C4M		.NUT-	A,B	1
			(V52828)		
			(SPEC BACN10JC4CM)		
			(OPT T6C428JM		
			(V11815))		
			(OPT 97E48		
			(V80539))		
			(OPT 109LH9075-4W		
			(V72962))		
			(OPT VN303D048		
			(V92215))		
			(OPT 9NS202101SE048		
			(VA8053))		
			(OPT H01-4BAC		
			(V15653))		
-113A	H52732-4CM		.NUT-	C-F	1
			(V15653)		
			(SPEC BACN10YR4CM)		
			(OPT PLH54CM		
			(V62554))		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
116	BACB28AK04-014		.BUSHING		1
119	146N6359-2		.CRANK-EXT HANDLE	A,C,E	1
-122	146N6359-1		.CRANK-EXT HANDLE	B,D,F	1
125	146N6356-6		.HANDLE ASSY		1
128	BACB28X4C022		..BUSHING		1
131	BACB28X6M022		..BUSHING		1
134	146N6356-7		..HANDLE		1
137	BACB30LJ4-14		.BOLT		2
140	AN960C416		.WASHER	A,B	2
-140A	NAS1149C0463R		.WASHER	C-F	2
143	BRH10C4M		.NUT- (V52828) (SPEC BACN10JC4CM) (OPT T6C428JM (V11815)) (OPT 97E48 (V80539)) (OPT 109LH9075-4W (V72962)) (OPT VN303D048 (V92215)) (OPT 9NS202101SE048 (VA8053)) (OPT H01-4BAC (V15653))	A,B	2
-143A	H52732-4CM		.NUT- (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))	C-F	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
147	BACB28AK04-021		.BUSHING		2
150	BACB30LJ4-29		.BOLT		1
153	BRH10C4M		.NUT-	A,B	1
			(V52828)		
			(SPEC BACN10JC4CM)		
			(OPT T6C428JM		
			(V11815))		
			(OPT 97E48		
			(V80539))		
			(OPT 109LH9075-4W		
			(V72962))		
			(OPT VN303D048		
			(V92215))		
			(OPT 9NS202101SE048		
			(VA8053))		
			(OPT H01-4BAC		
			(V15653))		
-153A	H52732-4CM		.NUT-	C-F	1
			(V15653)		
			(SPEC BACN10YR4CM)		
			(OPT PLH54CM		
			(V62554))		
156	BACB28AK04-030		.BUSHING		1
159	BACB28AK04-023		.BUSHING		1
162	146T6564-1		DELETED		
162A	146T6564-13		.PUSH ROD ASSY-CONTROL		1
165	146T6564-3		DELETED		
165A	146T6564-15		.PUSH ROD ASSY-CONTROL		1
168	MILB81935-104L		..BEARING		1
171	MILB81935-104K		..BEARING		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	174	NAS513-5		..WASHER		1
	177	NAS1423-5		..NUT		1
	180	AN316-5L		..NUT		1
	183	146T6564-6		DELETED		
	183A	146T6564-8		DELETED		
	183B	146T6564-18		..ROD- (USED ON ITEM 162A)		1
	184	146T6564-20		..ROD- (USED ON ITEM 165A)		1
	186	BACB30US4K45		.BOLT		1
	189	NAS43DD4-060		.SPACER	A,B	1
R	-189A	NAS43DD4-060FC		.SPACER	C-F	1
	192	AN960JD416		.WASHER	A,B	1
	-192A	NAS1149D0463J		.WASHER	C-F	1
	195	BACW10BP4CD		.WASHER		1
	198	BRH10C4M		.NUT- (V52828) (SPEC BACN10JC4CM) (OPT T6C428JM (V11815)) (OPT 97E48 (V80539)) (OPT 109LH9075-4W (V72962)) (OPT VN303D048 (V92215)) (OPT 9NS202101SE048 (VA8053)) (OPT H01-4BAC (V15653))	A,B	1
	-198A	H52732-4CM		.NUT- (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))	C-F	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-201	KP4FS428		.BEARING- (V21335) (SPEC BACB10BY4) (OPT KP4TT (V43991)) (OPT LLKP4 (V38443)) (OPT KP4SD610 (V83086)) (OPT KP4G27 (V30163)) (OPT KP4 (V21760))	A-D	2
R	-201A	PACMKP4FS428		.BEARING- (V21335) (SPEC BACB10FT04J) (OPT SSMKP04JSD705 (V83086)) (OPT PACMKP04JA3908 (V21335)) (OPT ACMKP04JP510LY1 (V40920)) (OPT SSMKP04JP510LY8 (V83086))	E,F	2
	204	NAS74A4E007P		.BUSHING		1
	207	146N6357-1		.CRANK-CORNER	A,C,E	1
	-210	146N6357-2		.CRANK-CORNER	B,D,F	1
	213	BACB30NR5K80		.BOLT		1
	216	NAS43DD5-242		.SPACER	A,B	1
	-216A	NAS43DD5-242FC		.SPACER	C-F	1
	219	AN960JD516		.WASHER	A,B	1
	-219A	NAS1149D0563J		.WASHER	C-F	1
	222	AN960C516		.WASHER	A,B	1
	-222A	NAS1149C0563R		.WASHER	C-F	1
	225	AN960XC716LL		.WASHER	A,B	1
	-225A	NAS1149C0716B		.WASHER	C-F	1
	228	BACNJ10JC5CM		DELETED		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
228A	BRH10C5M		.NUT- (V52828) (SPEC BACN10JC5CM) (OPT T6C524JM (V11815)) (OPT 97E054 (V80539)) (OPT 109LH9075-5W (V72962)) (OPT H01-5BAC (V15653))	A,B	1
-228B	H52732-5CM		.NUT- (V15653) (SPEC BACN10YR5CM) (OPT PLH55CM (V62554))	C-F	1
231	KP5ANJC		.BEARING- (V06144) (SPEC BACB10BX5) (OPT KP5AFS428 (V21335)) (OPT KP5A2TS (V43991)) (OPT LLKP5A (V38443)) (OPT KP5AG27 (V30163)) (OPT KP5A (V38443)) (OPT KP5ALY196 (V40920)) (OPT KP5ASD610 (V83086)) (OPT CS205E (VK8455)) (OPT KP5A (V21760))	A-D	2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-231A	SSMKP5ASD524		.BEARING- (V50294) (SPEC BACB10FS05J) (OPT PACMKP05JAA3908 (V21335)) (OPT SSMKP05JASD705 (V83086)) (OPT PACMKP5AFS428 (V21335)) (OPT ACMKP05JAP510LY (V40920)) (OPT SSMKP05JAP (V21760)) (OPT SSMKP05AP (V21760))	E,F	2
	234	BACB28X7M014		.BUSHING		1
	237	BACB28X5C010		.BUSHING		1
	240	BACB28AK05-031		.BUSHING		1
	243	MS24665-153		.PIN-COTTER	A,B	1
	-243A	BACP18BC02A06P		.PIN-COTTER	C-F	1
	246	AN960JD10L		.WASHER	A,B	2
	-246A	NAS1149D0332J		.WASHER	C-F	2
	249	MS20392-2A27		.PIN		1
	252	146N6339-7		.CRANK ASSY-IDLER	A,C,E	1
	-255	146N6339-8		.CRANK ASSY-IDLER	B,D,F	1
	258	MS16562-216		..PIN-SPR		1
	261	146N6339-5		..PIN		1
	264	146N6339-9		..CRANK	A,C,E	1
	-267	146N6339-10		..CRANK	B,D,F	1
	-270	146T6566-1		.HANDLE- (OPT ITEM 270A)	B,D,F	1
	-270A	146T6566-5		.HANDLE- (OPT ITEM 270)	B,D,F	1
	273	146T6566-2		.HANDLE- (OPT ITEM 273A)	A,C,E	1
	-273A	146T6566-6		.HANDLE- (OPT ITEM 273)	A,C,E	1
	276	BACB302LJ4-17		DELETED		
	276A	BACB30LJ4-17		.BOLT		2
	279	146N6352-1		.SPACER		AR
	282	AN960JD416		.WASHER	A,B	2
	-282A	NAS1149D0463J		.WASHER	C-F	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
285	BRH10C4M		.NUT- (V52828) (SPEC BACN10JC4CM) (OPT T6C428JM (V11815)) (OPT 97E48 (V80539)) (OPT 109LH9075-4W (V72962)) (OPT VN303D048 (V92215)) (OPT 9NS202101SE048 (VA8053)) (OPT H01-4BAC (V15653))	A,B	2
-285A	H52732-4CM		.NUT- (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))	C-F	2
288	BACB30LJ4-14		.BOLT		1
291	146N6352-1		.SPACER		AR
294	AN960C416		.WASHER	A,B	1
-294A	NAS1149C0463R		.WASHER	C-F	1
297	BRH10C4M		.NUT- (V52828) (SPEC BACN10JC4CM) (OPT T6C428JM (V11815)) (OPT 97E48 (V80539)) (OPT 109LH9075-4W (V72962)) (OPT VN303D048 (V92215)) (OPT 9NS202101SE048 (VA8053)) (OPT H01-4BAC (V15653))	A,B	1
-297A	H52732-4CM		.NUT- (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))	C-F	1
300	146T6564-4		DELETED		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
300A	146T6564-16		.ROD ASSY-PUSH		1
303	146T6564-5		DELETED		
303A	146T6564-17		.ROD ASSY-PUSH		1
306	MILB81935-104L		..BEARING		1
309	MILB81935-104K		..BEARING		1
312	NAS513-5		..WASHER		1
315	NAS1423-5		..NUT		1
318	AN316-5L		..NUT		1
321	146T6564-9		DELETED		
321A	146T6564-21		..ROD- (USED ON ITEM 300A)		1
324	146T6564-10		DELETED		
324A	146T6564-22		..ROD- (USED ON ITEM 303A)		1
327	BACB30NR4K80		.BOLT		1
330	NAS43DD4-230		.SPACER	A,B	1
-330A	NAS43DD4-230FC		.SPACER	C-F	1
333	AN960JD416		.WASHER	A,B	1
-333A	NAS1149D0463J		.WASHER	C-F	1
336	AN960C616LL		.WASHER	A,B	1
-336A	NAS1149C0616R		.WASHER	C-F	1
338	AN960C516		DELETED		
338A	AN960C416		.WASHER	A,B	1
-338B	NAS1149C0463R		.WASHER	C-F	1
339	BRH10C4M		.NUT- (V52828) (SPEC BACN10JC4CM) (OPT T6C428JM (V11815)) (OPT 97E48 (V80539)) (OPT 109LH9075-4W (V72962)) (OPT VN303D048 (V92215)) (OPT 9NS202101SE048 (VA8053)) (OPT H01-4BAC (V15653))	A,B	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01- -339A	H52732-4CM		.NUT- (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))	C-F	1
	342	KP4ANJC		.BEARING- (V06144) (SPEC BACB10BX4) (OPT KP4AFS428 (V21335)) (OPT KP4A2TS (V43991)) (OPT LLKP4A (V38443)) (OPT KP4AG27 (V30163)) (OPT KP4A (V38443)) (OPT KP4ALY196 (V40920)) (OPT KP4ASD610 (V83086)) (OPT CS204E (VK8455)) (OPT KP4A (V21760))	A-D	2
R	-342A	ACMKP3AFS428		.BEARING- (V21335) (SPEC BACB10FS04J) (OPT PACMKP04JAA3908 (V21335)) (OPT SSMKP04JASD705 (V83086)) (OPT SSMKP4ASD524 (V50294)) (OPT SSMKP04AP (V21760)) (OPT PACMKP04JAFS428 (V21335)) (OPT ACMKP04JAP510LY (V40920))	E,F	2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	345	BACB28X4C016		.BUSHING		1
	348	BACB28X6M014		.BUSHING	A-F	1
	-348A	BACB28X6M024		DELETED		
	351	BACB28AK04-047		.BUSHING		1
	354	146T6557-1		DELETED		
	354A	146T6557-3		.HANDLE-IDLER		1
	357	BACB30NM3K11		.BOLT- (V06710) (SPEC BACB30NM3K11)		1
	360	BACB30NM3K15		.BOLT		1
	363	AN960JD10		.WASHER		2
	366	NAS1805-3L		.NUT		2
	369	BACB28AK03-046		.BUSHING		1
	372	BACB28AK03-070		.BUSHING		1
	375	146N6344-4		.FITTING ASSY-MALE		1
	378	BACB28X5M007		..BUSHING		1
	381	BACB28X3C007		..BUSHING		1
	384	146N6344-5		..FITTING		1
	387	146N6345-4		.FITTING ASSY-FEMALE		1
R	388	BACB28Y5M044		..BUSHING		2
	390	146N6345-5		..FITTING		1
R	393	AN960JD816		.WASHER	A,B	2
R	-393A	NAS1149D0863J		.WASHER	C-F	2
	396	3-94319		.SPRING		1
	399	BACB30NM4K17		.BOLT		1
	402	BACB30NM4K16		.BOLT		1
	405	AN960JD416		.WASHER		1
	408	AN960JD416		.WASHER- (ANY COMBINATION OF AN960JD416, AN960JD416L, AND/OR 146N6352-1 AS REQ'D)		AR

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
411	NAS1805-4L		.NUT		2
414	BACB28AK04-041		.BUSHING		1
417	146T6564-2		DELETED		
417A	146T6564-14		.ROD ASSY-PUSH		1
420	MILB81935-104L		..BEARING		1
423	MILB81935-104K		..BEARING		1
426	NAS513-5		..WASHER		1
429	AN316-5L		..NUT		1
432	NAS1423-5		..NUT		1
435	146T6564-7		DELETED		
435A	146T6564-19		..ROD		1
438	BACB30NR4K14		.BOLT		2
441	AN960JD416L		.WASHER		2
444	BRH10C4M		.NUT-		2
			(V52828)		
			(SPEC BACN10JC4CM)		
			(OPT T6C428JM		
			(V11815))		
			(OPT 97E48		
			(V80539))		
			(OPT 109LH9075-4W		
			(V72962))		
			(OPT VN303D048		
			(V92215))		
			(OPT 9NS202101SE048		
			(VA8053))		
			(OPT H01-4BAC		
			(V15653))		
447	KP4FS428		.BEARING-	A-D	1
			(V21335)		
			(SPEC BACB10BY4)		
			(OPT KP4TT		
			(V43991))		
			(OPT LLKP4		
			(V38443))		
			(OPT KP4SD610		
			(V83086))		
			(OPT KP4G27		
			(V30163))		
			(OPT KP4		
			(V21760))		

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-447A	PACMKP4FS428		.BEARING- (V21335) (SPEC BACB10FT04J) (OPT SSMKP04JSD705 (V83086)) (OPT PACMKP04JA3908 (V21335)) (OPT ACMKP04JP510LY1 (V40920)) (OPT SSMKP04JP510LY8 (V83086))	E,F	1
	450	BACB28AK04-026		.BUSHING		2
	453	146N6328-10		.DOOR ASSY- (FOR DETAILS SEE FIG. 2)	A,C	1
R	-453A	146N6328-22		.DOOR ASSY- (FOR DETAILS SEE FIG. 4) (OPT ITEM 453B)	E	1
R	-453B	146N6328-26		.DOOR ASSY- (FOR DETAILS SEE FIG. 5) (OPT ITEM 453A)	E	1
	-456	146N6328-9		.DOOR ASSY- (FOR DETAILS SEE FIG. 2)	B,D	1
R	-456A	146N6328-21		.DOOR ASSY- (FOR DETAILS SEE FIG. 4) (OPT ITEM 456B)	F	1
R	-456B	146N6328-25		.DOOR ASSY- (FOR DETAILS SEE FIG. 5) (OPT ITEM 456A)	F	1
	459	BACB30NR4K81		.BOLT		1
	462	NAS43DD4-227		.SPACER	A,B	1
	-462A	NAS43DD4-227FC		.SPACER	C-F	1
	465	AN960C416		.WASHER		1
	468	AN960C616LL		.WASHER		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
471	AN960JD416L		.WASHER		1
474	BRH10C4M		.NUT-		1
			(V52828)		
			(SPEC BACN10JC4CM)		
			(OPT T6C428JM		
			(V11815))		
			(OPT 97E48		
			(V80539))		
			(OPT 109LH9075-4W		
			(V72962))		
			(OPT VN303D048		
			(V92215))		
			(OPT 9NS202101SE048		
			(VA8053))		
			(OPT H01-4BAC		
			(V15653))		
477	BACB28AK04-047		.BUSHING		1
480	BACB28X6M018		.BUSHING		1
483	BACB28X4C027		.BUSHING		1
484	KP4ANJC		.BEARING-	A-D	2
			(V06144)		
			(SPEC BACB10BX4)		
			(OPT KP4AFS428		
			(V21335))		
			(OPT KP4A2TS		
			(V43991))		
			(OPT LLKP4A		
			(V38443))		
			(OPT KP4AG27		
			(V30163))		
			(OPT KP4A		
			(V38443))		
			(OPT KP4ALY196		
			(V40920))		
			(OPT KP4ASD610		
			(V83086))		
			(OPT CS204E		
			(VK8455))		
			(OPT KP4A		
			(V21760))		

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R	01- -484A	ACMKP3AFS428		.BEARING- (V21335) (SPEC BACB10FS04J) (OPT PACMKP04JAA3908 (V21335)) (OPT SSMKP04JASD705 (V83086)) (OPT SSMKP4ASD524 (V50294)) (OPT SSMKP04AP (V21760)) (OPT PACMKP04JAFS428 (V21335)) (OPT ACMKP04JAP510LY (V40920))	E,F	2
	486	BACB30NT3DK15		.BOLT		1
	489	AN960JD10		.WASHER		1
	492	BACN10JD3CD		.NUT		1
	495	MS24665-153		.PIN-COTTER		1
	498	ATF3		.BEARING- (V60380) (SPEC BACB10ET03) (OPT 3AFC512 (V92563)) (OPT YAF03B (V07484))	A-D	1
R	-498A	ATF3T8		.BEARING- (V60380) (SPEC BACB10HH03) (OPT YAF03XD (V07484))	E,F	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	501	146N6381-3		.CRANK-IDLER (OPT ITEM 501A)		1
	-501A	69-53400-501		.CRANK-IDLER (OPT ITEM 501)		1
	504	HRS3CFR6		.CAM FOLLOWER- (V07484) (SPEC BACB10AF5F6HS) (OPT HRS3CFR6 (V92563)) (OPT HRS3CFR6 (V60380))	A-D	2
R	-504A	AHRSC3CFR6		.BEARING- (V60380) (SPEC BACB10GS05FJ6)	E,F	2
	507	BACW10P240L		.WASHER		2
	510	AN960C516		.WASHER	A,B	2
	-510A	NAS1149C0563R		.WASHER	C-F	2
	513	BACN10JD105CD		.NUT		2
	516	MS24665-153		.PIN-COTTER	A,B	2
	-516A	BACP18BC02A06P		.PIN-COTTER	C-F	2
	519	BACS12BP08P5		.SCREW		2
	522	BACW10P240L		DELETED		
	525	284N1750-6		.TARGET	A,C,E	1
	-528	284N1750-5		.TARGET	B,D,F	1
	531	146N6332-11		.TUBE ASSY-TORQUE	A,C,E	1
	-534	146N6332-12		.TUBE ASSY-TORQUE	B,D,F	1
	537	BACB30NR4K18		DELETED		
R	537A	BACB30NR4K20		..BOLT		4
	540	AN960PD416		DELETED		
R	540A	NAS1149D0463J		..WASHER		8

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	543	BRH10C4D		..NUT-		4
				(V52828)		
				(SPEC BACN10JC4CD)		
				(OPT T6C428JCD		
				(V11815))		
				(OPT NS202486-048		
				(V80539))		
				(OPT 102LH9075-4W		
				(V72962))		
				(OPT H51650-4BAC		
				(V15653))		
R	546	146N6333-2		..CRANK		2
R	549	69-53401-3		..CAM		1
R	552	69-49937-1		..CRANK		1
R	555	69-49936-2		..TUBE-TORQUE		1
				(OPT ITEM 555A)		
R	-555A	69-49936-3		..TUBE-TORQUE		1
				(OPT ITEM 555)		
	558	66-15332-1		.SPACER		AR
	561	KP16BSNJC		.BEARING-	A-D	3
				(V06144)		
				(SPEC BACB10EX16)		
				(OPT KP16BSSD610		
				(V83086))		
				(OPT KP16BS		
				(V06144))		
				(OPT KP16BSFS428		
				(V21335))		
				(OPT KP16BSLY196		
				(V40920))		
R	-561A	PACMKP16BSFS428		.BEARING-	E,F	3
				(V21335)		
				(SPEC BACB10FV16J)		
				(OPT AMKP16BSNJC		
				(V06144))		
	564	BACB30NM3K5		.BOLT		4
	567	AN960JD10		.WASHER	A,B	4
	-567A	NAS1149D0363J		.WASHER	C-F	4
	570	NAS1805-3L		.NUT		4
	573	146N6342-7		.HOUSING-BRG	A,C,E	1
	-576	146N6342-8		.HOUSING-BRG	B,D,F	1
	579	146T6567-1		.SPRING-TORSION	A,C,E	1
	582	146T6567-1		DELETED		
	-585	146T6567-2		.SPRING-TORSION	B,D,F	1
	588	146N6314-3		.SLEEVE-TORQUE TUBE		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	591	AN960C1616L		.WASHER	A,B	1
	-591A	NAS1149C1632R		.WASHER	C-F	1
	594	BACB30NM3K8		.BOLT		2
	597	NAS43DD3-16		.SPACER	A,B	2
	-597A	NAS43DD3-16FC		.SPACER	C-F	2
	600	AN960JD10L		.WASHER	A,B	4
	-600A	NAS1149D0332J		.WASHER	C-F	4
	603	BRH10C3M		.NUT- (V52828) (SPEC BACN10JC3CM) (OPT T6C1032JM (V11815)) (OPT 97E02 (V80539)) (OPT 109LH9075-3W (V72962)) (OPT VN303D02 (V92215)) (OPT NS202101SE02 (V80539)) (OPT H01-3BAC (V15653))	A,B	2
	-603A	H52732-3CM		.NUT- (V15653) (SPEC BACN10YR3CM) (OPT PLH53CM (V62554))	C-F	2
R	606	BACB30NR4K72		.BOLT		1
R	609	NAS43DD4-210		.SPACER	A,B	1
R	-609A	NAS43DD4-210FC		.SPACER	C-F	1
R	612	AN960C616LL		.WASHER	A,B	1
R	-612A	NAS1149C0616R		.WASHER	C-F	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	615	AN960JD416		.WASHER	A,B	1
R	-615A	NAS1149D0463J		.WASHER	C-F	1
R	618	AN960C416		.WASHER	A,B	1
R	-618A	NAS1149C0463R		.WASHER	C-F	1
R	621	BRH10C4M		.NUT- (V52828) (SPEC BACN10JC4CM) (OPT T6C428JM (V11815)) (OPT 97E48 (V80539)) (OPT 109LH9075-4W (V72962)) (OPT VN303D048 (V92215)) (OPT 9NS202101SE048 (VA8053)) (OPT H01-4BAC (V15653))	A,B	1
R	-621A	H52732-4CM		.NUT- (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))	C-F	1
R	624	KP4ANJC		.BEARING- (V06144) (SPEC BACB10BX4) (OPT KP4AFS428 (V21335)) (OPT KP4A2TS (V43991)) (OPT LLKP4A (V38443)) (OPT KP4AG27 (V30163)) (OPT KP4A (V38443)) (OPT KP4ALY196 (V40920)) (OPT KP4ASD610 (V83086)) (OPT CS204E (VK8455)) (OPT KP4A (V21760))	A-D	2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-624A	ACMKP3AFS428		.BEARING- (V21335) (SPEC BACB10FS04J) (OPT PACMKP04JAA3908 (V21335)) (OPT SSMKP04JASD705 (V83086)) (OPT SSMKP4ASD524 (V50294)) (OPT SSMKP04AP (V21760)) (OPT PACMKP04JAFS428 (V21335)) (OPT ACMKP04JAP510LY (V40920))	E,F	2
R	627	BACB28X6M014		.BUSHING		1
R	630	BACB28X4C016		.BUSHING		1
R	633	BACB28AK04-032		.BUSHING		1
R	636	HST10AG12-42		.BOLT- (V73197) (SPEC BACB30VT12K42) (OPT HST10AG12-42 (V56878)) (OPT HST10AG12-42 (V06725)) (OPT HST10AG12-42 (V0PTK6))		1
R	639	BACW10CT12J		.WASHER	A-D	1
R	-639A	BACW10EG12J		.WASHER	E,F	1
R	642	AN960JD616		.WASHER	A,B	1
R	-642A	NAS1149D0663J		.WASHER	C-F	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	643	SSMKP6ASD524		.BEARING- (V50294) (SPEC BACB10FS06J) (OPT PACMKP06JAA3908 (V21335)) (OPT SSMKP06JASD705 (V83086)) (OPT PACMKP6AFS428 (V21335)) (OPT ACMKP06JAP510LY (V40920)) (OPT PACMKP06JAFS428 (V21335)) (OPT SSMKP06JAP (V21760)) (OPT SSMKP06AP (V21760))	E,F	2
R	-643A	SSMKP6ASD524		.BEARING- (V50294) (SPEC BACB10FS06J) (OPT PACMKP06JAA3908 (V21335)) (OPT SSMKP06JASD705 (V83086)) (OPT PACMKP6AFS428 (V21335)) (OPT ACMKP06JAP510LY (V40920)) (OPT PACMKP06JAFS428 (V21335)) (OPT SSMKP06JAP (V21760)) (OPT SSMKP06AP (V21760))	A-D	2
R	645	BACN10JC6M		.NUT	A,B	1
R	-645A	PLH56M		.NUT- (V62554) (SPEC BACN10YR6M) (OPT H52732-6M (V15653))	C,D	1
R	-645B	H52732-6CM		.NUT- (V15653) (SPEC BACN10YR6CM) (OPT PLH56CM (V62554))	E,F	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	645L	BACB30NR4K12		.BOLT	C-F	2
	645Q	BACB30NR4K13		.BOLT	C-F	2
	645V	BACW10BN4AC		.WASHER	C-F	4
	646	NAS1149D0463J		.WASHER	C-F	4
	646L	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	C-F	4
	646Q	BACB28AK04-018		.BUSHING	C-F	4
	648	KP6ANJC		.BEARING- (V06144) (SPEC BACB10BX6) (OPT KP6AFS428 (V21335)) (OPT KP6A2TS (V43991)) (OPT LLKP6A (V38443)) (OPT KP6AG27 (V30163)) (OPT KP6A (V38443)) (OPT KP6BLY196 (V40920)) (OPT KP6BSD610 (V83086)) (OPT CS206E (VK8455)) (OPT KP6A (V21760))		2
R	651	NAS74A6E009P		.BUSHING		1
	652	87570-1		.SPRING-ASSIST (V09790)	C-F	2
	654	146T6568-1		.IDLER-UPR	A,B	2
	655	146T6568-3		.IDLER-UPR	C-F	1
	656	146T6568-4		.IDLER-UPR	C-F	1
	658	MS24665-153		.PIN-COTTER	A,B	2
	-658A	BACP18BC02A06P		.PIN-COTTER	C-F	2
	661	NAS43DD3-5		.SPACER	A,B	2
	-661A	NAS43DD3-5FC		.SPACER	C-F	2
	664	NAS43DD3-12		.SPACER	A,B	2
	-664A	NAS43DD3-12FC		.SPACER	C-F	2
	667	AN960JD10L		.WASHER	A,B	2
	-667A	NAS1149D0332J		.WASHER	C-F	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
670	MS20392-2A35		.PIN	A-D	2
673	BACB30NR4K80		.BOLT		2
676	NAS43DD4-240		.SPACER	A,B	2
-676A	NAS43DD4-240FC		.SPACER	C-F	2
679	AN960JD416		.WASHER	A,B	2
-679A	NAS1149D0463J		.WASHER	C-F	2
682	AN960C416		.WASHER	A,B	2
-682A	NAS1149C0463R		.WASHER	C-F	2
685	AN960C616LL		.WASHER	A,B	2
-685A	NAS1149C0616R		.WASHER	C-F	2
688	BRH10C4M		.NUT- (V52828) (SPEC BACN10JC4CM) (OPT T6C428JM (V11815)) (OPT 97E48 (V80539)) (OPT 109LH9075-4W (V72962)) (OPT VN303D048 (V92215)) (OPT 9NS202101SE048 (VA8053)) (OPT H01-4BAC (V15653))	A,B	2
-688A	H52732-4CM		.NUT- (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))	C-F	2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-691	KP4ANJC		.BEARING- (V06144) (SPEC BACB10BX4) (OPT KP4AFS428 (V21335)) (OPT KP4A2TS (V43991)) (OPT LLKP4A (V38443)) (OPT KP4AG27 (V30163)) (OPT KP4A (V38443)) (OPT KP4ALY196 (V40920)) (OPT KP4ASD610 (V83086)) (OPT CS204E (VK8455)) (OPT KP4A (V21760))	A-D	4
R	-691A	ACMKP3AFS428		.BEARING- (V21335) (SPEC BACB10FS04J) (OPT PACMKP04JAA3908 (V21335)) (OPT SSMKP04JASD705 (V83086)) (OPT SSMKP4ASD524 (V50294)) (OPT SSMKP04AP (V21760)) (OPT PACMKP04JAFS428 (V21335)) (OPT ACMKP04JAP510LY (V40920))	E,F	4
	694	BACB28AK04-031		.BUSHING		2
	697	BACB28X4C016		.BUSHING		2
	700	BACB28X6M014		.BUSHING		2
	703	146T6558-2		.PAWL ASSY		1
	706	146T6558-1		.PAWL ASSY		1
	709	MS24665-132		..PIN-COTTER		1
	712	NAS43DD3-1N		..SPACER		1
	715	MS20392-2C23		..PIN		1
	718	MS24586-634		..SPRING		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
721	BACC13Y3B90		..CABLE		1
724	NAS1423-6		..NUT		1
727	NAS513-6		..WASHER		1
730	146T6569-1		..SCREW-ADJUSTING		1
733	146T6558-4		..PAWL- (OPT ITEM 733A) (USED ON ITEM 703)		1
-733A	146T6558-8		..PAWL- (OPT ITEM 733) (USED ON ITEM 703)		1
-736	146T6558-3		..PAWL- (OPT ITEM 736A) (USED ON ITEM 706)		1
-736A	146T6558-7		..PAWL- (OPT ITEM 736) (USED ON ITEM 706)		1
739	MS24665-304		.PIN-COTTER	A,B	2
-739A	BACP18BC03A10P		.PIN-COTTER	C-F	2
742	AN960JD816L		.WASHER	A,B	AR
-742A	NAS1149D0816J		.WASHER	C-F	AR
745	146T6559-1		.STOP		2
748	BACB30NR5K76		.BOLT		2
751	NAS43DD5-220		.SPACER	A,B	2
-751A	NAS43DD5-220FC		.SPACER	C-F	2
753	AN960C516		.WASHER	A,B	2
-753A	NAS1149C0563R		.WASHER	C-F	2
756	AN960JD516		.WASHER	A,B	2
-756A	NAS1149D0563J		.WASHER	C-F	2
759	AN960XC716LL		.WASHER	A,B	2
-759A	NAS1149C0716B		.WASHER	C-F	2
762	BRH10C5M		.NUT- (V52828) (SPEC BACN10JC5CM) (OPT T6C524JM (V11815)) (OPT 97E054 (V80539)) (OPT 109LH9075-5W (V72962)) (OPT H01-5BAC (V15653))	A,B	2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01- -762A	H52732-5CM		.NUT- (V15653) (SPEC BACN10YR5CM) (OPT PLH55CM (V62554))	C-F	2
	764	KP5ANJC		.BEARING- (V06144) (SPEC BACB10BX5) (OPT KP5AFS428 (V21335)) (OPT KP5A2TS (V43991)) (OPT LLKP5A (V38443)) (OPT KP5AG27 (V30163)) (OPT KP5A (V38443)) (OPT KP5ALY196 (V40920)) (OPT KP5ASD610 (V83086)) (OPT CS205E (VK8455)) (OPT KP5A (V21760))	A-D	2
R	-764A	SSMKP5ASD524		.BEARING- (V50294) (SPEC BACB10FS05J) (OPT PACMKP05JAA3908 (V21335)) (OPT SSMKP05JASD705 (V83086)) (OPT PACMKP5AFS428 (V21335)) (OPT ACMKP05JAP510LY (V40920)) (OPT SSMKP05JAP (V21760)) (OPT SSMKP05AP (V21760))	E,F	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
765	BACB28AK05-033		.BUSHING		2
768	BACB28X7M014		.BUSHING		2
771	BACB28X5C016		.BUSHING		2
774	BACB30LH4-9		.BOLT		4
777	AN960JD416L		.WASHER	A,B	4
-777A	NAS1149D0416J		.WASHER	C-F	4
780	BRH10C4M		.NUT- (V52828) (SPEC BACN10JC4CM) (OPT T6C428JM (V11815)) (OPT 97E48 (V80539)) (OPT 109LH9075-4W (V72962)) (OPT VN303D048 (V92215)) (OPT 9NS202101SE048 (VA8053)) (OPT H01-4BAC (V15653))	A,B	4
-780A	H52732-4CM		.NUT- (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))	C-F	4

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-783	KP4ANJC		.BEARING- (V06144) (SPEC BACB10BX4) (OPT KP4AFS428 (V21335)) (OPT KP4A2TS (V43991)) (OPT LLKP4A (V38443)) (OPT KP4AG27 (V30163)) (OPT KP4A (V38443)) (OPT KP4ALY196 (V40920)) (OPT KP4ASD610 (V83086)) (OPT CS204E (VK8455)) (OPT KP4A (V21760))	A-D	4
R	-783A	ACMKP3AFS428		.BEARING- (V21335) (SPEC BACB10FS04J) (OPT PACMKP04JAA3908 (V21335)) (OPT SSMKP04JASD705 (V83086)) (OPT SSMKP4ASD524 (V50294)) (OPT SSMKP04AP (V21760)) (OPT PACMKP04JAFS428 (V21335)) (OPT ACMKP04JAP510LY (V40920))	E,F	4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
786	146T6552-1		.IDLER-LWR		1
789	146T6552-2		.IDLER-LWR		1
792	BACB30NM5K28		.BOLT		2
795	AN960C516		.WASHER	A,B	4
-795A	NAS1149C0563R		.WASHER	C-F	4
798	AN960JD716L		.WASHER	A,B	4
-798A	NAS1149D0716J		.WASHER	C-F	4
801	NAS1805-5L		.NUT		2
804	BACB28AK05-045		.BUSHING		4
807	BACB30NM5K44		.BOLT		2
810	AN960JD716L		.WASHER	A,B	4
-810A	NAS1149D0716J		.WASHER	C-F	4
813	AN960C516		.WASHER	A,B	4
-813A	NAS1149C0563R		.WASHER	C-F	4
816	NAS1805-5L		.NUT		2
819	AN960JD516L		.WASHER	A,B	AR
-819A	NAS1149D0516J		.WASHER	C-F	AR
822	BACB28AK05-055		.BUSHING		4
825	BACB28AK05-089		.BUSHING		2
828	BACB28AK05-120		.BUSHING		2
831	146T6556-1		.SUPPORT ASSY- (OPT ITEM 831A)		2
-831A	146T6556-2		.SUPPORT ASSY- (OPT ITEM 831)		2
834	BACB28X7M033		..BUSHING		4
837	146T6556-3		..SUPPORT- (USED ON ITEM 831)		1
-837A	146T6556-4		..SUPPORT- (USED ON ITEM 831A)		1
840	BACB30NR6K17		.BOLT		2

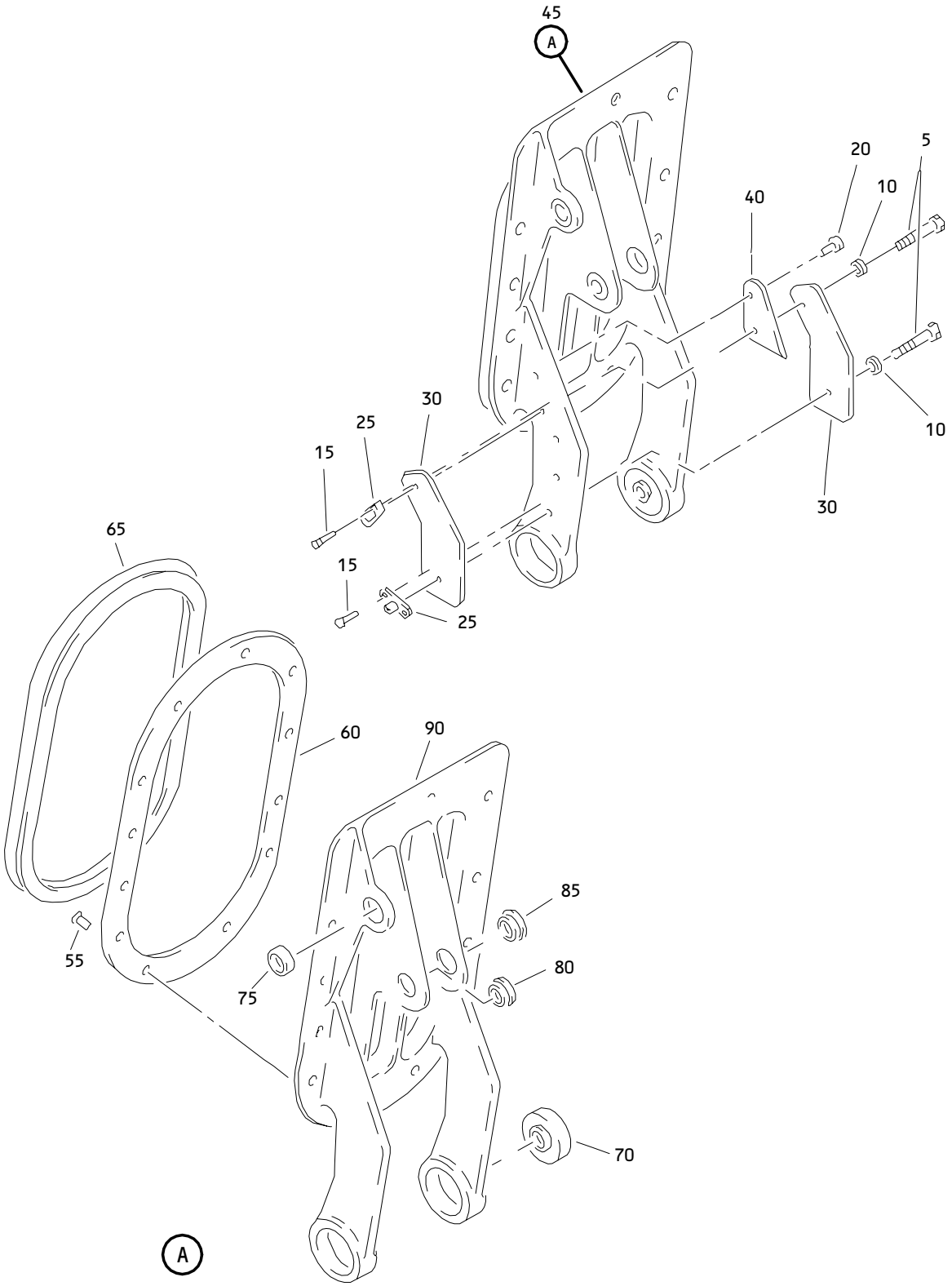
FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
843	AN960JD616		.WASHER	A,B	2
-843A	NAS1149D0663J		.WASHER	C,D	2
846	AN960JD616L		.WASHER	A,B	2
-846A	NAS1149D0616J		.WASHER	C,D	2
849	BRH10C6M		.NUT- (V52828) (SPEC BACN10JC6CM) (OPT 97E064 (V80539)) (OPT 102LH9075-6 (V72962)) (OPT H01-6BAC (V15653))	A,B	2
-849A	H52732-6CM		.NUT- (V15653) (SPEC BACN10YR6CM) (OPT PLH56CM (V62554))	C,D	2
852	2-541501-1A		.SNUBBER ASSY- (V97415)		2
855	146T6561-1		.LINK ASSY		2
-858	146T6561-2		.LINK ASSY		2
861	BACB28X7M029		..BUSHING		1
864	146T6561-3		..LINK- (USED ON ITEM 855)		1
-867	146T6561-4		..LINK- (USED ON ITEM 858)		1
870	BACB30US6K29		.BOLT		2
873	BACW10BP6CD		.WASHER		2
876	BACW10BP6DP		.WASHER		2
879	NAS1805-6L		.NUT		2
882	BACB28AK06-120		.BUSHING		2
885	BACB30NN3K5		.BOLT		2
888	AN960JD10L		.WASHER	A,B	2
-888A	NAS1149D0332J		.WASHER	C-F	2
891	NAS1805-3L		.NUT		2
894	BACB30NN3K4		.BOLT		6
897	AN960JD10L		.WASHER	A,B	6
-897A	NAS1149D0332J		.WASHER	C-F	6
900	NAS1805-3L		.NUT		6
903	146T6570-1		.ANGLE		1
906	146T6570-2		.ANGLE		1
909	146T6571-1		.SUPPORT-WALKWAY		1
912	BACB30NM5K27		.BOLT		2
915	AN960C516		.WASHER	A,B	4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-915A	NAS1149C0563R		.WASHER	C-F	4
918	NAS1805-5L		.NUT		2
921	BACB28AK05-120		.BUSHING		2
924	146T6553-2		.LINK		1
925	146T6553-1		.LINK		1
927	146T6553-3		.LINK		2
930	BACB30NM5K39		.BOLT		4
933	AN960C516		.WASHER	A,B	8
-933A	NAS1149C0563R		.WASHER	C-F	8
936	AN960XC716LL		.WASHER	A,B	8
-936A	NAS1149C0716B		.WASHER	C-F	8
939	NAS1805-5L		.NUT		4
942	BACB28AK05-042		.BUSHING		8
945	146T6551-1		.END LINK ASSY-HINGE		2
948	BACB28X7M045		..BUSHING		2
951	146T6551-2		..LINK		1
954	146T6554-1		.CENTER LINK ASSY		2
957	BACB28X9M048		..BUSHING		2
960	146T6554-2		..LINK		1
960L	146T6555-9		.FITTING ASSY-HINGE (FOR DETAILS SEE FIG. 3)	C-F	1
961	146T6555-10		.FITTING ASSY-HINGE (FOR DETAILS SEE FIG. 3)	C-F	1
-962	146T6550-5001		.COLLECTOR-LIMITED PART	A,B	1
-962A	146T6550-5002		.COLLECTOR-LIMITED PART	A,B	1
963	146T6555-1		..FITTING ASSY-HINGE (USED ON ITEM 962)	A,B	1
-963A	146T6555-9		..FITTING ASSY-HINGE (USED ON ITEM 962A)	A,B	1
966	146T6555-2		..FITTING ASSY-HINGE (USED ON ITEM 962)	A,B	1
-966A	146T6555-10		..FITTING ASSY-HINGE (USED ON ITEM 962A)	A,B	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	969	141T6632-1		...LOCK-GIRT BAR	A,B	1
	972	MS16624-4050		...RING-SNAP	A,B	1
	975	SSB52N		DELETED		
	-975A	SSB52P		DELETED		
R	975B	SSB52P		...PLUNGER-BALL (V01226)	A,B	1
	978	BACB28X7M027		...BUSHING	A,B	4
	981	146T6555-3		...BASE- (OPT ITEM 981A) (USED ON ITEM 963)	A,B	1
	-981A	146T6555-7		...BASE- (OPT ITEM 981) (USED ON ITEM 963)	A,B	1
	-981B	146T6555-11		...BASE- (OPT ITEM 981C) (USED ON ITEM 963A)	A,B	1
	-981C	146T6555-13		...BASE- (OPT ITEM 981B) (USED ON ITEM 963A)	A,B	1
	983	146T6555-4		...BASE- (OPT ITEM 983A) (USED ON ITEM 966)	A,B	1
	-983A	146T6555-8		...BASE- (OPT ITEM 983) (USED ON ITEM 966)	A,B	1
	-983B	146T6555-12		...BASE- (OPT ITEM 983C) (USED ON ITEM 966A)	A,B	1
	-983C	146T6555-14		...BASE- (OPT ITEM 983B) (USED ON ITEM 966A)	A,B	1
				INSTALLATION PARTS		

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-993	146T6505-1		DOOR STRUCTURE ASSY- SECT. 46, EMER EXIT (PRE SB 767-52-0068)		1
R	-993A	146T6505-7		DOOR STRUCTURE ASSY- SECT. 46, EMER EXIT (POST SB 767-52-0068)		1
	-996	146T6505-1		DOOR STRUCTURE ASSY- SECT. 46, EMER EXIT (PRE SB 767-52-0068)		1
R	-996A	146T6505-7		DOOR STRUCTURE ASSY- SECT. 46, EMER EXIT (POST SB 767-52-0068)		1

- Item Not Illustrated



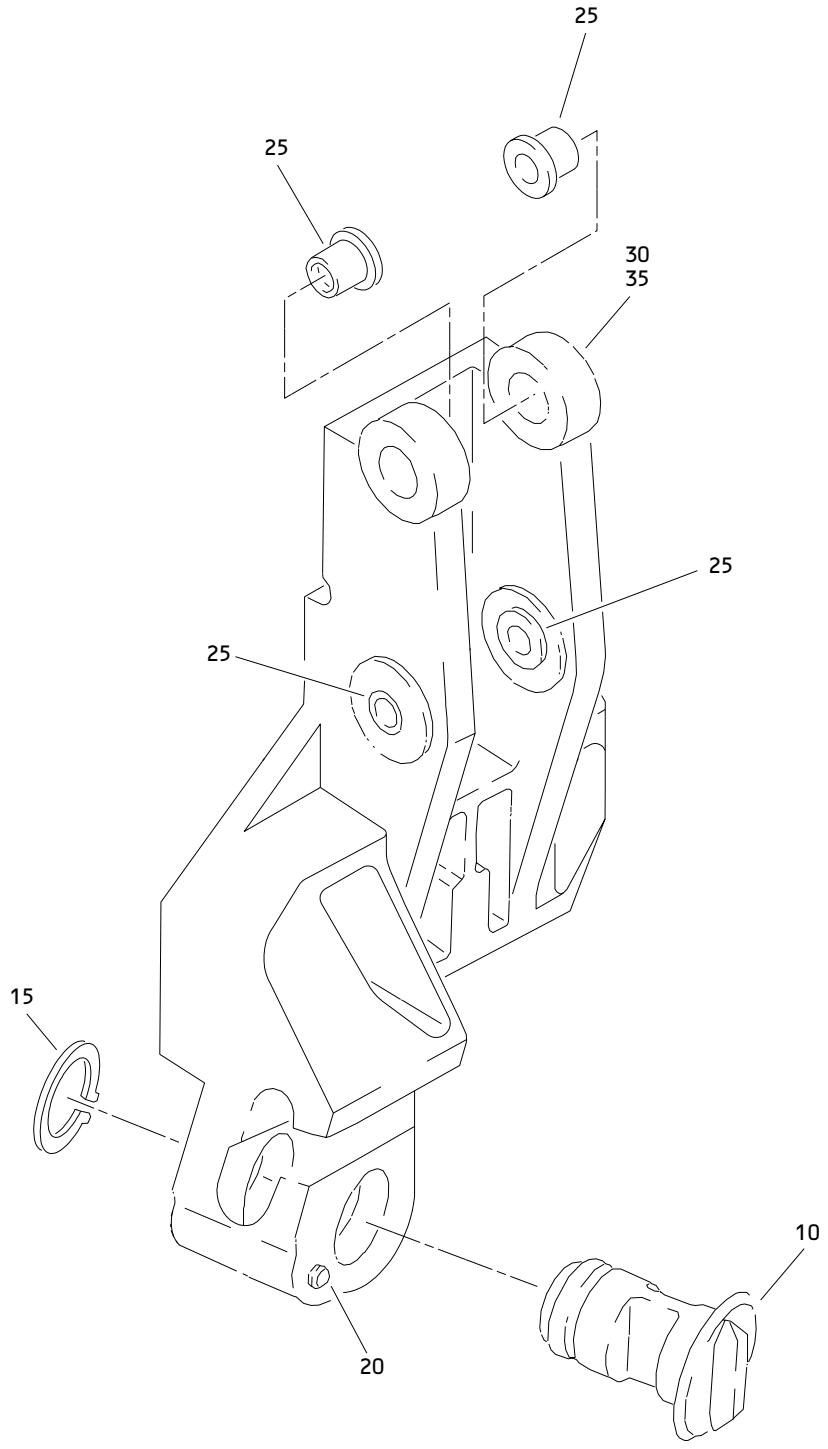
Emergency Exit Pressure Relief Door Assembly
Figure 2

688556

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-					
	-1	146N6328-10		DOOR ASSY-PRESSURE RELIEF EMERGENCY EXIT	A,C	RF
	-1A	146N6328-9		DELETED		
R	-3	146N6328-9		DOOR ASSY-PRESSURE RELIEF EMERGENCY EXIT		RF
	5	NAS6703-6		.BOLT	A-D	4
	10	AN960JD10LL		.WASHER	A-D	4
	15	BACR15BA3AD		.RIVET- (SIZE DETERMINE ON INST)	A-D	8
	20	BACR15BB4AD		.RIVET- (SIZE DETERMINE ON INST)	A-D	1
	25	BRFM20A3		.NUTPLATE- (V52828) (SPEC BACN10JN3) (OPT MF1000-3BAC (V15653)) (OPT NS103218-02 (V80539)) (OPT RMF9201M3 (V72962)) (OPT VN252A02 (V92215)) (OPT MF1000-3BAC (V15653)) (OPT MF53049-3 (V15653))	A-D	4
	30	146N6328-11		.PLATE	A-D	2
	-35	146N6328-12		.FILLER	B,D	1
	40	146N6328-13		.FILLER	A,C	1
	45	146N6328-6		.DOOR ASSY	A,C	1
	-50	146N6328-5		.DOOR ASSY	B,D	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
55	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	A-D	12
60	69-53462-501		..SEAL-RETAINER	A-D	1
65	69-53461-1		..SEAL	A-D	1
70	KP4FS428		..BEARING- (V21335) (SPEC BACB10BY4) (OPT KP4TT (V43991)) (OPT LLKP4 (V38443)) (OPT KP4SD610 (V83086)) (OPT KP4G27 (V30163)) (OPT KP4 (V21760))	A-D	1
75	BACB28Y5M021		..BUSHING	A-D	1
80	BACB28X4C007		..BUSHING	A-D	1
85	BACB28X6M007		..BUSHING	A-D	1
90	146N6328-7		..DOOR	B,D	1
-95	146N6328-8		..DOOR	A,C	1

- Item Not Illustrated

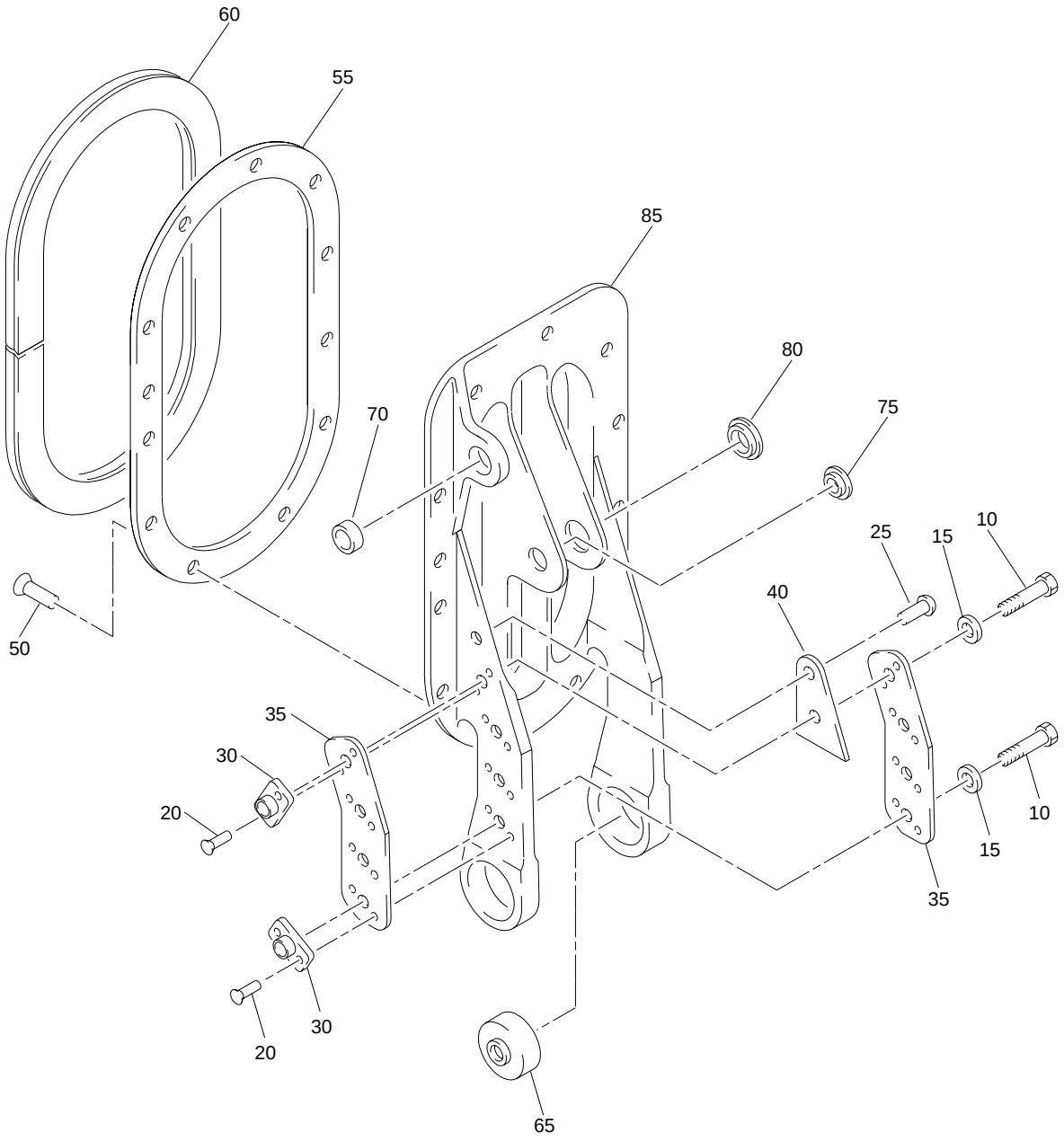


Hinge Fitting Assembly
Figure 3

G16265

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
-1A	146T6555-9		FITTING ASSY-HINGE	C-F	RF
-5	146T6555-10		FITTING ASSY-HINGE	C-F	RF
10	141T6632-1		.LOCK-GIRT BAR	C-F	1
15	MS16624-4050		.RING-SNAP	C-F	1
20	SSB52P		.PLUNGER-BALL (V01226)	C-F	1
25	BACB28X7M027		.BUSHING	C-F	4
30	146T6555-11		.BASE- (OPT ITEM 30A) (USED ON ITEM 1A)	C-F	1
-30A	146T6555-13		.BASE- (OPT ITEM 30) (USED ON ITEM 1A)	C-F	1
35	146T6555-12		.BASE- (OPT ITEM 35A) (USED ON ITEM 5)	C-F	1
-35A	146T6555-14		.BASE- (OPT ITEM 35) (USED ON ITEM 5)	C-F	1

- Item Not Illustrated



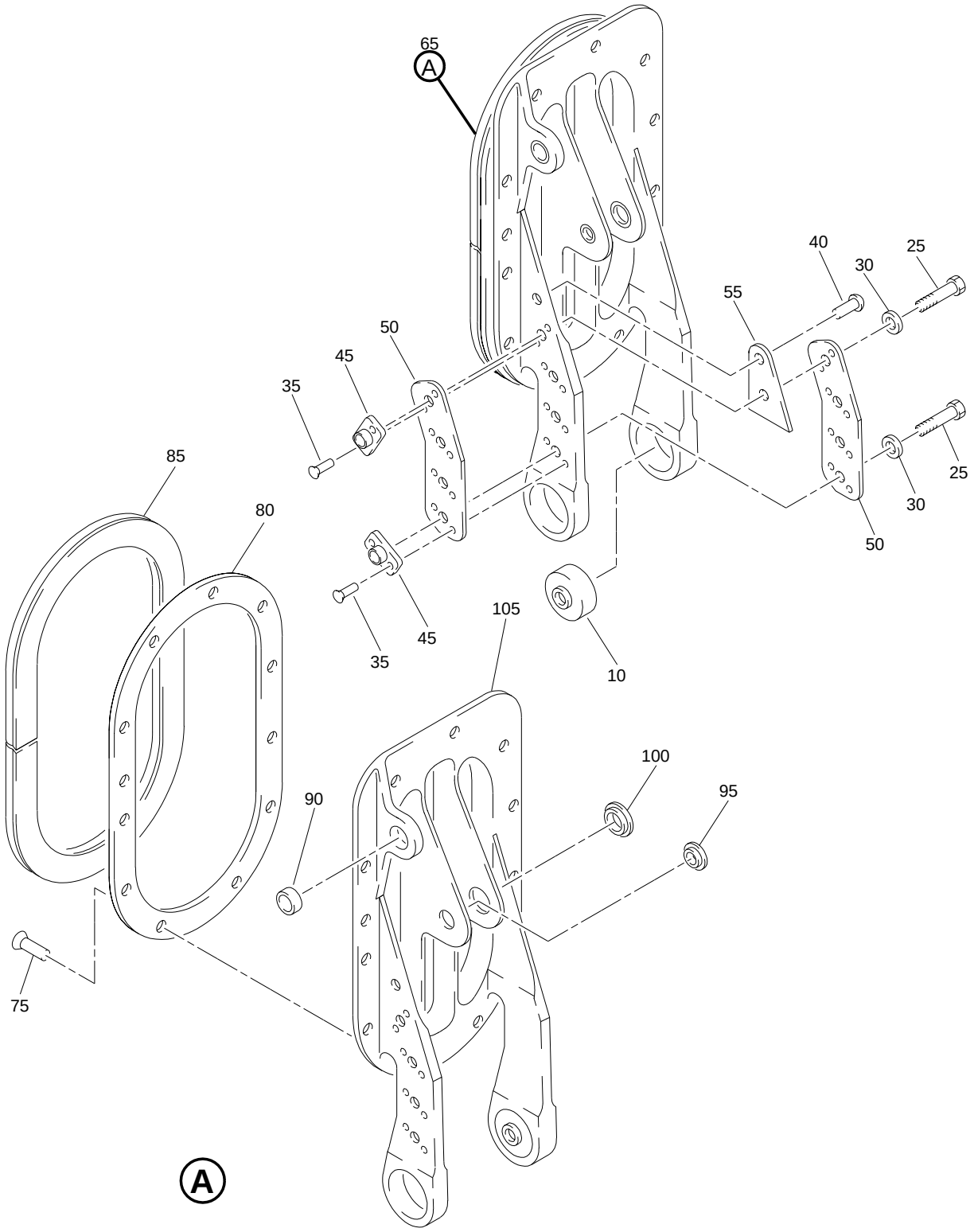
Emergency Exit Pressure Relief Door Assembly
Figure 4

W79129

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	04-					
R	-1A	146N6328-22		DOOR ASSY	E	RF
R	-5	146N6328-21		DOOR ASSY	F	RF
R	10	BACB30LM3-6		.BOLT	E,F	4
R	15	NAS1149D0316J		.WASHER	E,F	4
R	20	BACR15BA3AD		.RIVET- (SIZE DETERMINE ON INST)	E,F	8
R	25	BACR15BB4AD		.RIVET- (SIZE DETERMINE ON INST)	E,F	1
R	30	BRFM20A3		.NUTPLATE- (V52828) (SPEC BACN10JN3) (OPT MF1000-3BAC (V15653)) (OPT NS103218-02 (V80539)) (OPT RMF9201M3 (V72962)) (OPT VN252A02 (V92215)) (OPT MF53049-3 (V15653)) (OPT T8124S3S (V11815))	E,F	4
R	35	146N6328-11		.PLATE	E,F	2
R	40	146N6328-13		.FILLER	E	1
R	-45	146N6328-12		.FILLER	F	1
R	50	BACR15BA3AD		.RIVET- (SIZE DETERMINE ON INST)	E,F	12
R	55	69-53462-501		.SEAL-RETAINER	E,F	1
R	60	69-53461-1		.SEAL	E,F	1
R	65	PACMKP4FS428		.BEARING- (V21335) (SPEC BACB10FT04J) (OPT SSMKP04JSD705 (V83086)) (OPT PACMKP04JA3908 (V21335)) (OPT ACMKP04JP510LY1 (V40920)) (OPT SSMKP04JP510LY8 (V83086))	E,F	1
R	70	BACB28Y5M021		.BUSHING	E,F	1
R	75	BACB28X4C007		.BUSHING	E,F	1
R	80	BACB28X6M007		.BUSHING	E,F	1
R	85	146N6328-23		.DOOR ASSY	E	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R	04- -90	146N6328-24		.DOOR ASSY	F	1

- Item Not Illustrated



Emergency Exit Pressure Relief Door Assembly
Figure 5

W79143

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	05-					
R	-1A	146N6328-26		DOOR ASSY	E	RF
R	-5	146N6328-25		DOOR ASSY	F	RF
R	10	PACMKP4FS428		.BEARING- (V21335) (SPEC BACB10FT04J) (OPT SSMKP04JSD705 (V83086)) (OPT PACMKP04JA3908 (V21335)) (OPT ACMKP04JP510LY1 (V40920)) (OPT SSMKP04JP510LY8 (V83086))	E,F	1
R	-15	146N6328-10		.DOOR ASSY-PRESSURE RELIEF EMERGENCY EXIT	E	1
R	-20	146N6328-9		.DOOR ASSY-PRESSURE RELIEF EMERGENCY EXIT	F	1
R	25	NAS6703-6		..BOLT	E,F	4
R	30	AN960JD10LL		..WASHER	E,F	4
R	35	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	E,F	8
R	40	BACR15BB4AD		..RIVET- (SIZE DETERMINE ON INST)	E,F	1
R	45	BRFM20A3		..NUTPLATE- (V52828) (SPEC BACN10JN3) (OPT MF1000-3BAC (V15653)) (OPT NS103218-02 (V80539)) (OPT RMF9201M3 (V72962)) (OPT VN252A02 (V92215)) (OPT MF53049-3 (V15653)) (OPT T8124S3S (V11815))	E,F	4
R	50	146N6328-11		..PLATE	E,F	2
R	55	146N6328-13		..FILLER	E	1
R	-60	146N6328-12		..FILLER	F	1
R	65	146N6328-6		..DOOR ASSY	E	1
R	-70	146N6328-5		..DOOR ASSY	F	1
R	75	BACR15BA3AD		...RIVET- (SIZE DETERMINE ON INST)	E,F	12

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	05-					
R	80	69-53462-501		...SEAL-RETAINER	E,F	1
R	85	69-53461-1		...SEAL	E,F	1
R	90	BACB28Y5M021		...BUSHING	E,F	1
R	95	BACB28X4C007		...BUSHING	E,F	1
R	100	BACB28X6M007		...BUSHING	E,F	1
R	105	146N6328-8		...DOOR	E	1
R	-110	146N6328-7		...DOOR	F	1

- Item Not Illustrated