

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

TO: ALL HOLDERS OF THE MAIN DECK CARGO DOOR ASSEMBLY, 52-32-04

REVISION NO. 4 DATED NOV 01/03

HIGHLIGHTS

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

CHAPTER/SECTION

AND PAGE NO.

DESCRIPTION OF CHANGE

ALL PAGES

Added 143T6200 to header.

TITLE PAGE

Added the 143T62002-2, Main Deck Cargo Door Assembly.

1

308

501

REPAIR 1-1

612

713,715-717

820,825-826

1002-1050,1061-1074,

1080G-1080U,1082I-1082U,

1082W-1082X,1083-1084,

1084U-1086B,1086G-1086K,

1086O-1086P,1086U-1086W,

1087-1088A,1088E-1088H,

1088K-1088N,1088S-1088V,

1089-1090I,1090O-1090W,

1092C-1092D,1092M-1092N,

1092P-1094B,1094D-1096C

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HIGHLIGHTS

01.1

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MAIN DECK CARGO DOOR ASSEMBLY

PART NUMBERS 143T6200-1,-2

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

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TITLE PAGE

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01.1



REVISION RECORD

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

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

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REVISION RECORD

01.1

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
52-0072		PRR B12820 PRR B12818	DEC 01/96 MAR 01/03

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TR & SB RECORD

01.1

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PAGE	DATE	CODE	PAGE	DATE	CODE
52-32-04			CLEANING		
			*401	NOV 01/03	01.1
			402	BLANK	
TITLE PAGE			CHECK		
*1	NOV 01/03	01.1	*501	NOV 01/03	01.1
2	BLANK		*502	NOV 01/03	01.1
REVISION RECORD			REPAIR-GENERAL		
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2	BLANK		*602	NOV 01/03	01.1
TR & SB RECORD			*603	NOV 01/03	01.1
*1	NOV 01/03	01.1	604	BLANK	
2	BLANK		REPAIR 1-1		
LIST OF EFFECTIVE PAGES			*601	NOV 01/03	01.1
*1	NOV 01/03	01	*602	NOV 01/03	01.1
THRU LAST PAGE			*603	NOV 01/03	01.1
CONTENTS			*604	NOV 01/03	01.1
*1	NOV 01/03	01.1	*605	NOV 01/03	01.1
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INTRODUCTION			*607	NOV 01/03	01.1
*1	NOV 01/03	01.1	*608	NOV 01/03	01.1
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DESCRIPTION & OPERATION			*610	NOV 01/03	01.1
*1	NOV 01/03	01.1	*611	NOV 01/03	01.1
*2	NOV 01/03	01.1	*612	NOV 01/03	01.1
DISASSEMBLY			*613	NOV 01/03	01.1
*301	NOV 01/03	01.1	*614	NOV 01/03	01.1
*302	NOV 01/03	01.1	*615	NOV 01/03	01.1
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*304	NOV 01/03	01.1	*617	NOV 01/03	01.1
*305	NOV 01/03	01.1	*618	NOV 01/03	01.1
*306	NOV 01/03	01.1	*619	NOV 01/03	01.1
*307	NOV 01/03	01.1	*620	NOV 01/03	01.1
*308	NOV 01/03	01.1	REPAIR 2-1		
			*601	NOV 01/03	01.1
			*602	NOV 01/03	01.1

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PAGE	DATE	CODE	PAGE	DATE	CODE
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*604	NOV 01/03	01.1	REPAIR 8-1		
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			*601	NOV 01/03	01.1
REPAIR 5-2			602	BLANK	
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			*604	NOV 01/03	01.1

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PAGE	DATE	CODE	PAGE	DATE	CODE
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*602	NOV 01/03	01.1	*602	NOV 01/03	01.1
*603	NOV 01/03	01.1	*603	NOV 01/03	01.1
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REPAIR 14-2			REPAIR 18-2		
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REPAIR 15-1			REPAIR 19-1		
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REPAIR 15-2			REPAIR 19-2		
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*603	NOV 01/03	01.1	*603	NOV 01/03	01.1
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REPAIR 16-1			REPAIR 20-1		
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REPAIR 16-2			REPAIR 20-2		
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602	BLANK		*602	NOV 01/03	01.1

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PAGE	DATE	CODE	PAGE	DATE	CODE
REPAIR 22-1			REPAIR 26-2		CONT.
*601	NOV 01/03	01.1	*605	NOV 01/03	01.1
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REPAIR 22-2			ASSEMBLY		
*601	NOV 01/03	01.1	*701	NOV 01/03	01.1
*602	NOV 01/03	01.1	*702	NOV 01/03	01.1
*603	NOV 01/03	01.1	*703	NOV 01/03	01.1
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REPAIR 23-1			*705	NOV 01/03	01.1
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REPAIR 23-2			*708	NOV 01/03	01.1
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REPAIR 24-2			*716	NOV 01/03	01.1
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REPAIR 26-1			*724	NOV 01/03	01.1
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REPAIR 26-2			*727	NOV 01/03	01.1
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			*733	NOV 01/03	01.1
			*734	NOV 01/03	01.1
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			*736	NOV 01/03	01.1
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			*738	NOV 01/03	01.1

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PAGE	DATE	CODE	PAGE	DATE	CODE
ASSEMBLY		CONT.	ILLUSTRATED PARTS LIST		CONT.
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*740	NOV 01/03	01.1	*1010	NOV 01/03	01.1
*741	NOV 01/03	01.1	*1011	NOV 01/03	01.1
*742	NOV 01/03	01.1	*1012	NOV 01/03	01.1
			*1013	NOV 01/03	01.1
FITS AND CLEARANCES			*1014	NOV 01/03	01.1
*801	NOV 01/03	01.1	*1015	NOV 01/03	01.1
*802	NOV 01/03	01.1	*1016	NOV 01/03	01.1
*803	NOV 01/03	01.1	*1017	NOV 01/03	01.1
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*810	NOV 01/03	01.1	*1024	NOV 01/03	01.1
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*826	NOV 01/03	01.1	*1040	NOV 01/03	01.1
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			*1050	NOV 01/03	01.1

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PAGE	DATE	CODE	PAGE	DATE	CODE
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*1052	NOV 01/03	01.1	*1080N	NOV 01/03	01.1
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*1056	NOV 01/03	01.1	*1080R	NOV 01/03	01.1
*1057	NOV 01/03	01.1	*1080S	NOV 01/03	01.1
*1058	NOV 01/03	01.1	*1080T	NOV 01/03	01.1
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*1062	NOV 01/03	01.1	*1080X	NOV 01/03	01.1
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*1064	NOV 01/03	01.1	*1080Z	NOV 01/03	01.1
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*1066	NOV 01/03	01.1	*1082	NOV 01/03	01.1
*1067	NOV 01/03	01.1	*1082A	NOV 01/03	01.1
*1068	NOV 01/03	01.1	*1082B	NOV 01/03	01.1
*1069	NOV 01/03	01.1	*1082C	NOV 01/03	01.1
*1070	NOV 01/03	01.1	*1082D	NOV 01/03	01.1
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*1074	NOV 01/03	01.1	*1082H	NOV 01/03	01.1
*1075	NOV 01/03	01.1	*1082I	NOV 01/03	01.1
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*1080B	NOV 01/03	01.1	*1082P	NOV 01/03	01.1
*1080C	NOV 01/03	01.1	*1082Q	NOV 01/03	01.1
*1080D	NOV 01/03	01.1	*1082R	NOV 01/03	01.1
*1080E	NOV 01/03	01.1	*1082S	NOV 01/03	01.1
*1080F	NOV 01/03	01.1	*1082T	NOV 01/03	01.1
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*1080H	NOV 01/03	01.1	*1082V	NOV 01/03	01.1
*1080I	NOV 01/03	01.1	*1082W	NOV 01/03	01.1
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*1080L	NOV 01/03	01.1	*1082Z	NOV 01/03	01.1

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PAGE	DATE	CODE	PAGE	DATE	CODE
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*1084C	NOV 01/03	01.1	*1086Q	BLANK	
*1084D	NOV 01/03	01.1	*1086R	NOV 01/03	01.1
*1084E	NOV 01/03	01.1	*1086S	NOV 01/03	01.1
*1084F	NOV 01/03	01.1	*1086T	NOV 01/03	01.1
*1084G	NOV 01/03	01.1	*1086U	NOV 01/03	01.1
*1084H	NOV 01/03	01.1	*1086V	NOV 01/03	01.1
*1084I	NOV 01/03	01.1	*1086W	NOV 01/03	01.1
*1084J	NOV 01/03	01.1	*1086X	BLANK	
*1084K	NOV 01/03	01.1	*1086Y	NOV 01/03	01.1
*1084L	NOV 01/03	01.1	*1086Z	NOV 01/03	01.1
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*1084N	NOV 01/03	01.1	*1088	NOV 01/03	01.1
*1084O	NOV 01/03	01.1	*1088A	NOV 01/03	01.1
*1084P	NOV 01/03	01.1	1088B	BLANK	
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*1084R	NOV 01/03	01.1	*1088D	NOV 01/03	01.1
*1084S	NOV 01/03	01.1	*1088E	NOV 01/03	01.1
*1084T	NOV 01/03	01.1	*1088F	NOV 01/03	01.1
*1084U	NOV 01/03	01.1	*1088G	NOV 01/03	01.1
*1084V	NOV 01/03	01.1	*1088H	NOV 01/03	01.1
*1084W	NOV 01/03	01.1	*1088I	NOV 01/03	01.1
*1084X	NOV 01/03	01.1	*1088J	NOV 01/03	01.1
*1084Y	NOV 01/03	01.1	*1088K	NOV 01/03	01.1
*1084Z	NOV 01/03	01.1	*1088L	NOV 01/03	01.1
*1085	NOV 01/03	01.1	*1088M	NOV 01/03	01.1
*1086	NOV 01/03	01.1	*1088N	NOV 01/03	01.1
*1086A	NOV 01/03	01.1	*1088O	BLANK	
*1086B	NOV 01/03	01.1	*1088P	NOV 01/03	01.1
*1086C	NOV 01/03	01.1	*1088Q	NOV 01/03	01.1
*1086D	NOV 01/03	01.1	*1088R	NOV 01/03	01.1
*1086E	NOV 01/03	01.1	*1088S	NOV 01/03	01.1
*1086F	NOV 01/03	01.1	*1088T	NOV 01/03	01.1
*1086G	NOV 01/03	01.1	*1088U	NOV 01/03	01.1
*1086H	NOV 01/03	01.1	*1088V	NOV 01/03	01.1
*1086I	NOV 01/03	01.1	*1088W	NOV 01/03	01.1
*1086J	NOV 01/03	01.1	*1088X	NOV 01/03	01.1
*1086K	NOV 01/03	01.1	*1088Y	NOV 01/03	01.1
*1086L	BLANK		*1088Z	NOV 01/03	01.1

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PAGE	DATE	CODE	PAGE	DATE	CODE
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*1090	NOV 01/03	01.1	*1092N	NOV 01/03	01.1
*1090A	NOV 01/03	01.1	*1092O	BLANK	
*1090B	NOV 01/03	01.1	*1092P	NOV 01/03	01.1
*1090C	NOV 01/03	01.1	*1092Q	NOV 01/03	01.1
*1090D	NOV 01/03	01.1	*1092R	NOV 01/03	01.1
*1090E	NOV 01/03	01.1	*1092S	NOV 01/03	01.1
*1090F	NOV 01/03	01.1	*1092T	NOV 01/03	01.1
*1090G	NOV 01/03	01.1	*1092U	NOV 01/03	01.1
*1090H	NOV 01/03	01.1	*1092V	NOV 01/03	01.1
*1090I	NOV 01/03	01.1	*1092W	NOV 01/03	01.1
*1090J	NOV 01/03	01.1	*1092X	NOV 01/03	01.1
*1090K	NOV 01/03	01.1	*1092Y	NOV 01/03	01.1
*1090L	NOV 01/03	01.1	*1092Z	NOV 01/03	01.1
*1090M	NOV 01/03	01.1	*1093	NOV 01/03	01.1
*1090N	NOV 01/03	01.1	*1094	NOV 01/03	01.1
*1090O	NOV 01/03	01.1	*1094A	NOV 01/03	01.1
*1090P	NOV 01/03	01.1	*1094B	NOV 01/03	01.1
*1090Q	NOV 01/03	01.1	*1094C	BLANK	
*1090R	NOV 01/03	01.1	*1094D	NOV 01/03	01.1
*1090S	NOV 01/03	01.1	*1094E	NOV 01/03	01.1
*1090T	NOV 01/03	01.1	*1094F	NOV 01/03	01.1
*1090U	NOV 01/03	01.1	*1094G	NOV 01/03	01.1
*1090V	NOV 01/03	01.1	*1094H	NOV 01/03	01.1
*1090W	NOV 01/03	01.1	*1094I	NOV 01/03	01.1
*1090X	BLANK		*1094J	NOV 01/03	01.1
*1090Y	NOV 01/03	01.1	*1094K	NOV 01/03	01.1
*1090Z	NOV 01/03	01.1	*1094L	NOV 01/03	01.1
*1091	NOV 01/03	01.1	*1094M	NOV 01/03	01.1
*1092	NOV 01/03	01.1	*1094N	NOV 01/03	01.1
*1092A	NOV 01/03	01.1	*1094O	NOV 01/03	01.1
*1092B	NOV 01/03	01.1	*1094P	NOV 01/03	01.1
*1092C	NOV 01/03	01.1	*1094Q	NOV 01/03	01.1
*1092D	NOV 01/03	01.1	*1094R	NOV 01/03	01.1
*1092E	BLANK		*1094S	NOV 01/03	01.1
*1092F	NOV 01/03	01.1	*1094T	NOV 01/03	01.1
*1092G	NOV 01/03	01.1	*1094U	NOV 01/03	01.1
*1092H	NOV 01/03	01.1	*1094V	NOV 01/03	01.1
*1092I	NOV 01/03	01.1	*1094W	NOV 01/03	01.1
*1092J	NOV 01/03	01.1	*1094X	NOV 01/03	01.1
*1092K	NOV 01/03	01.1	*1094Y	NOV 01/03	01.1
*1092L	NOV 01/03	01.1	*1094Z	NOV 01/03	01.1

* = REVISED, ADDED OR DELETED

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*1096	NOV 01/03	01.1			
*1096A	NOV 01/03	01.1			
*1096B	NOV 01/03	01.1			
*1096C	NOV 01/03	01.1			
*1096D	BLANK				

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INTRODUCTION

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

This manual is divided into separate sections:

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

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

The beginning of the REPAIR section includes a list of the separate repairs, 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.

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MAIN DECK CARGO DOOR ASSEMBLYDESCRIPTION AND OPERATION1. Description

A. The main deck cargo door provides access to the main deck cargo compartment and is located on the forward left side of the fuselage. The door structural framework consists of beams, frames, intercostals, and skins fabricated from aluminum alloy sheet and extrusions. Door pressurization loads are transmitted to the fuselage by twelve door latches along the bottom edge, two midspan latches, and a piano-type hinge along the upper edge. Two door pull-in hooks are located on the fore and aft sides. A pressure seal attached around the door periphery prevents pressure losses and internal rain leakage when the door is closed. A rain seal, which extends across the hinge line, prevents rain leakage through the hinge line when the door is opened. Twelve viewing ports installed along the lower door edge (adjacent to each latch cam) allow outside verification that the door is securely latched. Two pressure vent doors (negative pressure relief doors), located in the central door surface, prevent pressurization if the door is not properly closed, latched or locked. The two pressure vent doors open and close as the latch lock tube rotates.

2. Operation

- A. The door opens outward.
- B. The normal door operation is electrical and is possible only from just inside the entry door. The door can be opened manually.
- C. The door operating mechanism consists of mechanical and electrical components located on the door. Torque tubes, bellcranks and pushrods connect electrically powered actuators to the locks and vent doors. A second electrically powered actuator operates the twelve rotary latches at the bottom of the door and the two midspan latches and two hooks on the forward and aft sides of the door.
- D. The door is opened and closed by an electrically powered lift actuator and mechanical rotary actuators mounted on the fuselage that are connected to the fittings on the door just below the hinge line.

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3. Leading Particulars (Approximations)

Height ---- 132 inches
Width ----- 140 inches
Depth ----- 6 inches
Weight ---- 1300 pounds

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DISASSEMBLY1. General

- A. This procedure contains the data necessary to disassemble the Main Deck Cargo Door Assembly.
- B. Disassemble this component only as necessary to sufficiently isolate the defect, do the necessary repairs, and put the component back to a serviceable condition.
- C. Permanently installed parts such as press-fit bearings or bushings, riveted components, threaded inserts, bonded components, etc., must not be removed unless repair or replacement is necessary.
- D. Support the door assembly in a suitable holding fixture.
- E. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM chapters identified in this procedure.
- F. Disassembly is divided generally (by IPL figure) into three different operations: removal of latch and hook installation (IPL Fig. 2), the latch lock installation (IPL Fig. 3), and the structure assembly (IPL Fig. 1 and 4 thru 7).

2. Disassemble the Main Deck Cargo Door Assembly (1, IPL Fig. 1)

- A. Remove the rain seal installation (190, IPL Fig. 1) components (195 thru 220).
- B. Remove the pressure seal (225, IPL Fig. 1).
- C. Remove and disassemble the latch lock installation components (10, IPL Fig. 1; 1, IPL Fig. 3). (The item numbers that follow are from Fig. 3 unless specified differently.)
 - (1) Put the latch and hook installation (1A, IPL Fig. 2) in the fully Unlatched position.
 - (2) Remove the spring (35) and fasteners (5 thru 30).
 - (3) Remove the pushrod assembly (415) and fasteners (390 thru 410).

NOTE: Do not disassemble pushrod assembly (415) unless necessary for repair or replacement.

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- (4) Remove the pushrod assemblies (85) and fasteners (40 thru 80).

NOTE: Do not disassemble pushrod assembly (85) unless necessary for repair or replacement.

- (5) Remove the pushrod assembly (355) and fasteners (250, 270, 285, 290 and 310).

NOTE: Do not disassemble pushrod assembly (355) unless necessary for repair or replacement.

CAUTION: ALL TORQUE TUBE ASSEMBLY (625A) COMPONENTS BUT THE FASTENERS COMPOSE A MATCHED SET. COMPONENTS MUST BE KEPT TOGETHER TO MAKE SURE THE ASSEMBLY OPERATES CORRECTLY.

- (6) Remove and disassemble the torque tube assembly (625A).

(a) Remove the fasteners (670 thru 685) from the vent door mechanism cams (690).

(b) Remove the fasteners (630 thru 645) from the bellcrank assembly (650).

(c) Remove the fasteners (450 thru 470) from the bearing supports (480) and remove the cover plate (475).

(d) Pull out the torque tube (695), stripping off cams (690), bearing components (480 thru 495) and bellcrank assembly (650). Note the thickness of shim (490) for reference during assembly.

NOTE: Do not disassemble bellcrank assembly (650) unless necessary for repair or replacement.

CAUTION: SECTOR SHAFT ASSEMBLY (770) COMPONENTS COMPRISE A MATCHED SET. EACH SECTOR (865) IS A MATCH TO ITS SEPCIFIC LOCATION. BELLCRANK ASSEMBLY (800), CONNECTOR (840), SECTORS (865), TORQUE TUBE (870), AND FASTENERS MUST BE KEPT TOGETHER TO MAKE SURE THE SECTOR SHAFT ASSEMBLY OPERATES CORRECTLY AFTER ASSEMBLY.

- (7) Remove and disassemble the sector shaft assembly (770).

(a) Remove the bellcrank assembly (800) and fasteners (780 thru 795).

NOTE: Do not disassemble the bellcrank assembly (800) unless necessary for repair or replacement.

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- (b) Remove fasteners (750 thru 765 and 820 thru 835) and remove connector (840).
- (c) Remove fasteners (845 thru 860) to disassemble torque tube (870) from sectors (865), bearings (730), bearing supports (715, 720) and washers (705). Note the number and location of washers (705) for reference during assembly.

CAUTION: SECTOR SHAFT ASSEMBLY (775) COMPONENTS COMPRISE A MATCHED SET. EACH SECTOR (865) IS A MATCH TO ITS SPECIFIC LOCATION. BELLCRANK ASSEMBLY (800), CONNECTOR (840), SECTORS (865), TORQUE TUBE (870) AND FASTENERS MUST BE KEPT TOGETHER TO MAKE SURE THE SECTOR SHAFT ASSEMBLY OPERATES CORRECTLY AFTER ASSEMBLY.

- (8) Remove and disassemble the sector shaft assembly (775).
 - (a) Remove the bellcrank assembly (800) and fasteners (780 thru 795).

NOTE: Do not disassemble the bellcrank assembly (800) unless necessary for repair or replacement.
 - (b) Remove fasteners (845 thru 860) to disassemble torque tube (870) from sectors (865), bearings (730), bearing supports (715, 720) and washers (705). Note the number and location of washers (705) for reference during assembly.
- (9) Remove fasteners (700, 710) and remove bearing supports (715, 720). Note the number and thickness of the shims (725) under the bearing supports (715, 720) for reference during assembly.

NOTE: Do not remove the bearing supports (715, 720) unless necessary for repair or replacement.

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(10) Remove fasteners (235, 245, 255, 265, 280, 290, 295, 300, 305) and remove power unit (315).

(11) Remove the idler assembly (320) and fasteners (240, 260, 275, 290).

NOTE: Do not disassemble the idler assembly (320) unless necessary for repair or replacement.

(12) Remove the vent door mechanism crank assembly (535) and fasteners (500, 510, 520, 530).

NOTE: Do not disassemble the crank assembly (535) unless necessary for repair or replacement.

(13) Remove the support fitting assembly (605) and fasteners (505, 515, 525, 530, 600). Note the number and location of shims (600) for reference during assembly.

NOTE: Do not disassemble the support fitting assembly (605) unless necessary for repair or replacement.

(14) Remove the vent door assembly (195) with fasteners (160 thru 190).

D. Remove and disassemble the latch and hook installation (5, IPL Fig. 1; 1A, IPL Fig. 2). (The item numbers that follow are from Fig. 2 unless specified differently.)

(1) If installed, make sure that the latch lock installation components (IPL Fig. 3) are in the Unlocked position: vent doors (535) must be open, and sectors (865) must be rotated into the door structure so that the latch cams (360, 363, IPL Fig. 2) are free to turn.

(2) Remove items (351 thru 357) and latch cams (360, 363).

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- (3) Remove fasteners (336 thru 345) and straps (348) to free the bellcrank assemblies (366, 369) from the door structure. Remove fasteners (273, 279, 282, 288, 291) and bellcrank assemblies (366, 369).

NOTE: Do not disassemble the bellcrank assemblies (366, 369) unless necessary for repair or replacement.

- (4) Remove fasteners (276, 279, 285, 288, 294) and pushrods (297).

- (5) Remove fasteners (228 thru 252) and pushrod assemblies (255).

NOTE: Do not disassemble the pushrod assemblies (255) unless necessary for repair or replacement.

- (6) Remove fasteners (300 thru 312) and idler assemblies (315, 318).

NOTE: Do not disassemble the idler assemblies (315, 318) unless necessary for repair or replacement.

- (7) Remove fasteners (141 thru 159) and pushrod assemblies (162).

NOTE: Do not disassemble the pushrod assemblies (162) unless necessary for repair or replacement.

- (8) Remove fasteners (3 thru 21) and pushrod assemblies (24).

NOTE: Do not disassemble the pushrod assemblies (24) unless necessary for repair or replacement.

- (9) Remove fasteners (186 thru 204) and idler assemblies (207, 210).

NOTE: Do not disassemble the idler assemblies (207, 210) unless necessary for repair or replacement.

CAUTION: CRANK FITTING ASSEMBLY (87, 90) COMPONENTS MAKE A MATCHED SET; LATCH FITTING (117) AND BELLCRANK ASSEMBLY (105) MUST BE KEPT TOGETHER TO MAKE SURE OF CORRECT OPERATION AFTER ASSEMBLY.

- (10) Disassemble and remove the crank fitting assemblies (87, 90).

(a) Remove fasteners (33 thru 42) and pull the collar (45) back on to the fitting (117).

(b) Remove fasteners (93 thru 102) and slide the latch fitting (117) out through the bearing (81).

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- (c) Slide the bellcrank assembly (105) out of bearing (120) and remove the washers (84). Note the number of washers (84) for reference during assembly.

NOTE: Do not disassemble the bellcrank assembly (105) unless necessary for repair or replacement.

- (11) Remove fasteners (126 thru 138) and remove the bearing housings (123) and bearings (120).

- (12) Remove fasteners (51 thru 60) and rigging plates (48); remove fasteners (66 thru 78) and bearing housings (63).

- (13) Remove items (384 thru 417).

NOTE: Do not separate the rod ends (414, 417) by loosening the jamnut (411) unless necessary for repair or replacement.

- (14) Remove fasteners (420 thru 429). Pull bellcrank assemblies (432) and pull-in hooks (444A, 447A) out. Note the number of the thrust rings (531 thru 537) for reference during assembly.

NOTE: Do not disassemble the bellcrank assemblies (432) unless necessary for repair or replacement.

- (15) Remove fasteners (480 thru 486). Remove retaining plates (474, 477) and bearings (489).

- (16) Remove and disassemble torque shaft (699, 702, 705) components.

- (a) Remove fasteners (660 thru 669, 756, 762, 765, 771); remove bearing housing (774, 777), thrust rings (672 thru 681), bearing (780), retaining plate (783), and bellcrank assembly (450, 453). Note the number of thrust rings (672 thru 681) for reference during assembly.

NOTE: Do not disassemble bellcrank assembly (450, 453) unless necessary for repair or replacement.

- (b) Remove fasteners (492 thru 513), bearing housing assembly (516, 519), bearings (540, 543) and retaining plate (546).

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- (c) Remove fasteners (633 thru 642, 660 thru 669, 687 thru 696, 756 thru 777), connectors (654, 657), housings (774, 777), plates (783), bearings (780), bellcrank assemblies (630), torque shafts (699, 702, 705) and stop lever (684).

NOTE: Do not disassemble bellcrank assembly (630) unless necessary for repair or replacement.

- (17) Remove the actuator (621) and associated components.

- (a) Remove fasteners (720 thru 729) and stop brackets (717).
- (b) Remove fasteners (732 thru 741); remove items (744 thru 753). Note the thickness of shims (744) for reference during assembly.
- (c) Remove jumper assembly (564) and fasteners (549 thru 561).
- (d) Lift the actuator (621) and attached mounting plate (627) gently straight out of the door. Remove connector (567). Remove mounting plate (627) and fasteners (612 thru 618).

NOTE: Do not disassemble actuator (621) unless necessary for repair or replacement.

- (e) Remove items (582 thru 609).

NOTE: Do not disassemble adapter assembly (585) unless necessary for repair or replacement.

- E. Remove and disassemble the structure assembly (230, IPL Fig. 1) components. (The item numbers that follow are for Fig. 1 unless specified differently.)

NOTE: Do not remove the seal support installation (500, 505, IPL Fig. 1; 1A, 5, IPL Fig. 7) components unless necessary for repair or replacement.

- (1) Remove the lift link fitting assemblies (1B, 5A, IPL Fig. 4).

NOTE: Do not remove the lift link fitting assemblies unless necessary for repair or replacement.

- (2) Remove fasteners (285 thru 300) and the centering roller ramp fittings (305, 310) and shims (315 thru 350).

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- (3) Remove fasteners (355 thru 375) to remove the bracket assembly (380) and shims (395, 400) for the latch lock idler support. Note the thickness of the shims (395, 400) for reference during assembly.
- (4) Remove fasteners (405 thru 425) to remove bearing plate assemblies (430, 435).
- (5) Remove fasteners (450 thru 465 and 475, 480) to remove the vent door torque tube support fittings (470, 485).
- (6) Remove the upper beam installation (495, IPL Fig. 1; 1A, IPL Fig. 6; 1A, IPL Fig. 19) components.

NOTE: Do not remove hinge fittings (190 thru 230, IPL Fig. 6; 185 thru 225, IPL Fig. 19) unless necessary for repair or replacement. If it is necessary to remove the hinge fittings, remove and install them one at a time to maintain the centerline of the hinges. Note the thickness of the shims (235 thru 270, IPL Fig. 6; 230 thru 265, IPL Fig. 19) for reference during assembly.

- (7) Remove the lower latch observation window installation (490, IPL Fig. 1; 1A, IPL Fig. 5) components.

NOTE: Do not remove the remainder of the structure assembly (510 thru 615) unless necessary for repair or replacement. If components are removed, note the thickness of all shims for reference during assembly.

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CLEANING

1. Use standard industry practices (Ref 20-30-03) to clean all parts but the bearings identified in par. 2.
2. Clean all sealed bearings as specified in the manufacturers instructions. Clean and lubricate all other bearings as specified in 20-30-01.

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CHECK

1. Use standard industry practices to do a check of all parts for defects.
2. Magnetic particle check as specified in 20-20-01:
 - A. IPL Fig. 1 -- Fitting (305, 310)
 - B. IPL Fig. 2 -- Collar (45), bellcrank (114), fitting (117), tube (270), strap (348), bolt (351), retainer (354), latch cam (360, 363), pull-in hook (444A, 447A), bellcrank (378, 381, 441, 468, 471), connector (567, 654, 657), thrust rings (531, 534, 537, 672, 675, 678, 681), stop lever (684), stop bracket (717).
 - C. IPL Fig. 3 -- Support (100, 135), spring retainer (115), keeper (120), insert (145), cam (690), torque tube (695, 870)
 - D. IPL Fig. 6 -- Hinge fittings (190 thru 230)
 - E. IPL Fig. 14 -- Fitting (125, 130)
 - F. IPL Fig. 15 -- Fitting (90, 95)
 - G. IPL Fig. 19 -- Hinge Fittings (185 thru 225)
3. Penetrant check as specified in 20-20-02:
 - A. IPL Fig. 1 -- Panel (90), bracket (390), plate (445)
 - B. IPL Fig. 2 -- Pushrod (30), rigging plate (48), idler (222, 225, 330, 333), housings (63, 525, 528), spring (357), adapter (591), mounting plate (627), bellcrank (651), bearing housing (123, 747, 774, 777)
 - C. IPL Fig. 3 -- Spring (35, 105), rod (155, 385, 445), door (230), idler (350), crank (595), fitting (620), bearing supports (715, 720), bellcrank (665, 815), connector (840), sector (865)
 - D. IPL Fig. 4 -- Fitting (60A, 65A)
 - E. IPL Fig. 7 -- Support block (40)
 - F. IPL Fig. 8 -- Clip (40, 45, 50), fitting (85,90)
 - G. IPL Fig. 9 -- Fitting (85, 90, 95, 135)
 - H. IPL Fig. 10 - Fitting (55 thru 70)
 - I. IPL Fig. 11 - Bushing (95), fitting (100, 105)

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- J. IPL Fig. 12 - Bushing (75), fitting (80, 85, 90)
 - K. IPL Fig. 13 - Clip (30, 35), fitting (80, 85, 120, 125), bushing (115)
 - L. IPL Fig. 14 - Fitting (190, 195)
 - M. IPL Fig. 15 - Fitting (125, 130), bushing (170), fitting (175)
 - N. IPL Fig. 16 - Clip (70), support (100)
4. Refer to Fits and Clearances for service wear limits.
 5. Check springs (35, IPL Fig. 3) for load limits as specified in Fig. 501.

Item Number	Test Length (inches)	Allowable Load Limit (pounds)
35 (IPL Fig. 3)	11.49 12.74	27 - 33 45 - 55
105A (IPL Fig. 3)	3.20 4.20	117 - 143 60 - 74

Spring Check
 Figure 501

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REPAIR – GENERAL1. Content

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

<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
--	MISCELLANEOUS PARTS	1-1
140T2993	VENT DOOR MECHANISM CRANK ASSEMBLY	2-1
143T6206	BEARING PLATE ASSEMBLY	3-1
143T6220	SHEAR FITTING ASSEMBLY	4-1
143T6221	FITTING ASSEMBLY	5-1
143T6229	FITTING ASSEMBLY	6-1
143T6231	LIFT LINK FITTING ASSEMBLY	7-1
143T6240	INTERCOSTAL INSTALLATION	8-1
143T6244	LATCH LOCK IDLER SUPPORT BRACKET ASSEMBLY	9-1
143T6255	LATCH FITTING ASSEMBLY	10-1
143T6260	FITTING ASSEMBLY	11-1
143T6295	MIDSPAN IDLER ASSEMBLY	12-1
143T6401	LATCH CAM	13-1
143T6402	BELLCRANK ASSEMBLY	14-1
143T6411	PULL-IN HOOK BELLCRANK ASSEMBLY	15-1
143T6414	LOWER LATCH IDLER ASSEMBLY	16-1
143T6418	MIDSPAN LATCH BELLCRANK ASSEMBLY	17-1
143T6446	LATCH LOCK DRIVE BELLCRANK ASSEMBLY	18-1
143T6492	LOWER LATCH BELLCRANK ASSY	19-1
143T6495	LATCH/HOOK BELLCRANK ASSY	20-1
143T6496	PULL-IN HOOK	21-1
143T6558	VENT DOOR EXTENSION SPRING SUPPORT ASSEMBLY	22-1
143T6583	SECTOR TORQUE TUBE BELLCRANK ASSEMBLY	23-1

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143T6593	LATCH LOCK IDLER ASSEMBLY	24-1
143T6597	VENT DOOR MECHANISM SUPPORT FITTING ASSEMBLY	25-1
143T6603	VENT DOOR ASSEMBLY	26-1

2. Standard Practices

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

20-10-01 - Repair and Refinish of High Strength Steel Parts
20-30-01 - Cleaning and Relubricating Antifriction Bearings
20-30-02 - Stripping of Protective Finishes
20-30-03 - General Cleaning Procedures
20-41-01 - Decoding Table for Boeing Finish Codes
20-41-05 - Application of Corrosion Inhibiting Compounds
20-42-03 - Hard Chrome Plating
20-42-05 - Bright Cadmium Plating
20-43-01 - Chromic Acid Anodizing
20-43-03 - Anodizing
20-44-02 - Temporary Protective Coatings
20-50-03 - Bearing Installation and Retention
20-50-07 - Lubrication
20-50-08 - Application of Dry Lubricant
20-50-09 - Installation of Protective Grommets
20-50-12 - Application of Adhesives
20-70-01 - Protection, Storage, and Handling of Airplane Components

3. Materials

NOTE: Equivalent substitutes can be used.

- A. Adhesives (Ref 20-50-12)

(1) Type 60
(2) Type 70
(3) Type 82

- B. Compound, corrosion inhibiting -- BMS 3-23, type 2 (Ref 20-60-04)

- C. Compound, corrosion preventive -- MIL-C-16173, Grade 3 (Ref 20-60-04)

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D. Enamel (Ref 20-60-02)

- (1) BMS 10-11, type 2, BAC101 red gloss
- (2) BMS 10-11, type 2, BAC702 white gloss
- (3) BMS 10-11, type 2, BAC4533 apple green gloss
- (4) BMS 10-60, BAC101 red gloss
- (5) BMS 10-60, type 2, BAC707 gray gloss

E. Grease (Ref 20-60-03)

- (1) BMS 3-24

F. Lubricant, dry film (Ref 20-60-03)

- (1) BMS 3-8
- (2) MIL-L-8937
- (3) MIL-L-46010

G. Primer (Ref 20-60-02)

- (1) BMS 10-11, type 1
- (2) BMS 10-79, type 2
- (3) BMS 10-79, type 3

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

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REPAIR-GENERAL

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MISCELLANEOUS PARTS - REPAIR 1-1

1. Repair of parts listed in Fig. 601 is only replacement of the original finish. Refer to REPAIR - GENERAL for a list of applicable standard practices.

2.

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 1</u>		
Panel (30,50)	Al alloy	Interior (convave) surface only: Chemically treat (color film); apply one coat BMS 10-11, type 1 primer (F-18.06). Overspray in holes is acceptable.
Panel (90)	Al alloy	Chromic acid anodize (F-17.02). Apply one coat of BMS 10-79, type 2 primer and BMS 10-60, type 2 enamel, color 707 gray gloss (F-19.40).
Panel (110)	Al alloy	Interior (concave) surface only: Chromic acid anodize; apply one coat of BMS 10-11, type 1 primer (F-18.13) plus one coat of BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over, but do not put primer or enamel in bolt holes.
Plate (185)	Al alloy	Exterior Surface: Clear chemical treat. Interior Surface: Chemical treat and apply one coat of BMS 10-11, type 1 primer (SRF-14.011).
Retainer Strip (200,205,210,215)	Al alloy	Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.17) all over.
Structure Assembly (230)	--	Touch-up painted areas with BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.17).

Figure 601 (Sheet 1)

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IPL FIG. & ITEM	MATERIAL	FINISH
Fitting (305,310)	15-5PH CRES 180-200 ksi	Apply solid film lubricant as specified in 20-50-08 all over but not in the fastener holes.
Shim (315 thru 340)	15-5PH CRES 180-200 ksi	Passivate (F-17.09).
Fitting (470,485)	Al alloy	Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04).
<u>Fig. 2</u>		
Pushrod Assembly (24)	--	Tube exterior only (after swaging): Chemically treat (colored film); apply one coat of BMS 10-11, type 1 primer (F-18.07). Apply one coat of BMS 10-11, type 2 enamel, BAC702 white gloss (SRF-14.905-702).
Pushrod (30,183)	Al alloy	Interior only: Chemically treat (colored film); apply one coat of BMS 10-11, type 1 primer (F-18.07). On all of the interior surface but the threads, apply BMS 3-23, type 2 corrosion inhibiting compound (F-19.26).

Figure 601 (Sheet 2)

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IPL FIG. & ITEM	MATERIAL	FINISH
Collar (45)	4130 steel 150-170 ksi	Cadmium plate as specified in 20-42-05, type 2, class 2 (F-15.06) to dimensions shown in Fig. 601. Apply one coat of BMS 10-11, type 1 primer (F-20-02) plus one coat of BMS 10-11, type 2 enamel, BAC702 white gloss (SRF-14.905-702) all over, but do not put primer and enamel in areas shown in Fig. 601.
Rigging Plate (48)	Al alloy	Chromic acid anodize (F-17.04): Apply one coat BMS 10-11, type 1 primer (F-20.02) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (SRF-14.905-702) all over, but do not put primer or enamel in the areas shown in Fig. 602.
Bearing Housing (63,123,747)	Al alloy	Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04). Do not put primer in bolt holes or bearing bore.
Washer (84)	301 CRES	Cadmium plate as specified in 20-42-05, type 2, class 2; apply one coat of BMS 10-11, type 1 primer (F-16.01) all over.
Latch Fitting (117)	15-5PH CRES 180-200 ksi	Passivate (F-17.09). Cadmium plate as specified in 20-42-05, type 2, class 2 (F-15.06) area shown in Fig. 603. Apply MIL-L-46010 solid film lubricant or BMS 3-8 solid film lubricant to areas shown in Fig. 603.

Figure 601 (Sheet 3)

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IPL FIG. & ITEM	MATERIAL	FINISH
Pushrod Assembly (162)	--	Tube exterior only (after swaging): Chemically treat (colored film); apply one coat of BMS 10-11, type 1 primer (F-18.01). Apply one coat of BMS 10-11, type 2 color BAC702 white gloss enamel to a thickness of 0.0005 to 0.0010 inch (F-21.15).
Sleeve (171)	304 CRES	Passivate (F-17.09). Apply dry film lubricant, BMS 3-8, to threads. Optional: apply dry film lubricant MIL-L-8937, to threads.
Tube (270), Connectors (567, 654,657), Stop Lever (684)	15-5PH CRES 180-200 ksi	Passivate (F-17.09).
Strap (348)	15-5PH CRES 180-200 ksi	Cadmium plate as specified in 20-42-05, type 2, class 2; apply one coat BMS 10-11, type 1 primer (F-16.01) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (SRF-14.905-702) all over.
Bolt (351)	15-5PH CRES 180-200 ksi	Cadmium plate (0.0002 to 0.0004 inch) as specified in 20-42-05 (F-15.02) as shown in Fig. 604.
Retainer (354)	15-5PH CRES 180-200 ksi	Passivate (F-17.09). Cadmium plate (0.0002 to 0.0004 inch) as specified in 20-42-05 (F-15.02) as shown in Fig. 604.
Spring (357)	302 CRES OPT: 17-7PH CRES CH900	Cadmium plate as specified in 20-42-05, type 2, class 2 (F-15.06).
Retainer Plates (474,477)	Al alloy	Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.17) all over.

Figure 601 (Sheet 4)

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IPL FIG. & ITEM	MATERIAL	FINISH
Housings (525,528)	Al alloy	Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.17) all over, but do not put primer or enamel in bolt holes or bearing bores.
Thrust Rings (531, 534, 537, 672, 675, 678, 681)	4130 steel 150-170 ksi	Cadmium plate as specified in 20-42-05, type 2, class 2 (F-15.06).
Adapter (591)	Al alloy	Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04). Apply BMS 10-60 Boeing color 707 gray gloss enamel (SRF-14.9813). Do not put primer or paint in the fastener holes or the groove.
Retainer (609)	Al alloy	Chemically treat (colored film); apply one coat BMS 10-11, type 1 primer (F-18.06) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over.
Mounting Plate (627), Bearing Retaining Plates (546, 753)	Al alloy	Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04).
Torque Shafts (699, 702, 705)	15-5PH CRES 180-200 ksi	Passivate (F-17.09). Cadmium plate as specified in 20-40-05, type 2, class 2 (F-15.06) the areas shown in Fig. 605.
Stop Bracket (717)	15-5PH CRES 180-200 ksi	Cadmium plate as specified in 20-42-05, type 2, class 2; apply one coat of BMS 10-11, type 1 primer (F-16.01) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over, but do not put primer and enamel in holes or on threads.

Figure 601 (Sheet 5)

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IPL FIG. & ITEM	MATERIAL	FINISH
Bearing Housing (774,777)	Al alloy	Chromic acid anodize (F-17.04); apply one coat BMS 10-11, type 1 primer (F-20.02) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (SRF-14.905-702) all over, but do not put primer or enamel in the bolt holes or bearing bore.
Bearing Retaining Plate (783)	Al alloy	Chemically treat (colored film); apply one coat BMS 10-11, type 1 primer (F-18.06) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (SRF-14.905-702) all over.
<u>Fig. 3</u>		
Support (100) ⁶	15-5PH CRES 150-170 ksi	Passivate (F-17.09). Apply one coat BMS 10-11, type 1 primer (F-20.02) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (SRF-14.905-702) all over but not in areas identified in Fig. 606. Apply MIL-L-46010 dry film lubricant as specified in 20-50-08, type 6, class 1, to areas identified in Fig. 606.
Retainer (115), Keeper (120)	15-5PH CRES 150-170 ksi	Passivate (F-17.09).
Support (135)	15-5PH CRES 180-200 ksi	Passivate (F-17.09). Apply MIL-L-46010 dry film lubricant as specified in 20-50-08, type 6, class 1, to areas identified in Fig. 606.
Rod Assembly (140)	--	Tube exterior only (after swaging): Apply one coat of BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.17).

Figure 601 (Sheet 6)

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IPL FIG. & ITEM	MATERIAL	FINISH
Insert (145,375,435)	17-4PH CRES or 15-5PH CRES 150-170 ksi	Passivate (F-17.09). Cadmium plate (0.0002 to 0.0004 inch) as specified in 20-42-05 (F-15.02) on outer diameter only.
Rod (155), Tube (385,445)	Al alloy	Chemically treat (colored film); apply one coat of BMS 10-11, type 1 primer (F-18.07). On all of the interior surface but the threads, apply BMS 3-23, type 2 corrosion inhibiting compound (F-19.26).
Rod Assembly (370,430)	--	Tube exterior only (after swaging): Apply one coat of BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.15) to a thickness of 0.0005 to 0.0010.
Cover Plate (475), Bearing Retainer (485)	Al alloy	Chemically treat (colored film); apply one coat (F-18.06) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.17) all over.
Bearing Support (480,715,720)	Al alloy	Chromic acid anodize; apply one coat of BMS 10-11, type 1 primer (F-18.13) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (SRF-14.905-702) all over, but do not put primer or enamel in the bolt holes or bearing bores.
Cam (690)	15-5PH CRES 180-200 ksi	Passivate (F-17.09).
Tube (695,870)	15-5PH CRES 180-200 ksi	Passivate (F-17.09). Cadmium plate as specified in 20-42-05, type 2, class 2 (F-15.06) to areas shown in Fig. 607.
Washer (705)	301 CRES	Cadmium plate as specified in 20-42-05, type 2, class 2; apply one coat of BMS 10-11, type 1 primer (F-16.01) all over.

Figure 601 (Sheet 7)

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IPL FIG. & ITEM	MATERIAL	FINISH
Stop Plate (745)	15-5PH CRES 180-200 ksi	Cadmium plate as specified in 20-42-05, type 2, class 2; apply one coat BMS 10-11, type 1 primer (F-16.01) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (SRF-14.905-702) all over.
Connector (840)	Al alloy	Chemically treat (colored film); apply one coat of BMS 10-11, type 1 primer (F-18.07) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.17) all over, but do not put enamel in the inner diameter of the part.
Sector (865)	Al alloy	Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.17) all over, but do not put enamel in the 1.57 inch diameter hole.
<u>Fig. 4</u>		
Nut Retainer (40)	CRES	Apply one coat BMS 10-11, type 1 primer (F-20.02) plus one coat of BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.17).
Plate (45)	301 CRES	Apply one coat of BMS 10-11, type 1 primer (F-16.01) plus one coat of BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.17).
<u>Fig. 5</u>		
Filler (30), Doublers (35)	Al alloy	Chemically treat (colored film); apply one coat BMS 10-11, type 1 primer (F-18.06) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over.

Figure 601 (Sheet 8)

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 MAINTENANCE MANUAL

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 6</u>		
Angle (25,45), Gusset (300,305)	Al alloy	Chemically treat (colored film); apply one coat BMS 10-11, type 1 primer (F-18.06).
Hinge Fitting (190 thru 230)	15-5PH CRES 180-200 ksi	Cadmium plate as specified in 20-42-05, type 2, class 2 (F-16.06). Apply one coat of BMS 10-79, type 3 primer (F-19.47) and BMS 10-60, type 2 gloss enamel (F-19.39-707). Do not put primer or enamel on the sides of all the lugs or the hinge pin holes. Primer and enamel is optional in the fastener holes. The surface finish in the hinge pin holes must be 63 Ra or better.
<u>Fig. 7</u>		
Retainer (30,35)	Al alloy	Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04). Apply one coat of BMS 10-11, type 2 color BAC702 white gloss enamel to a thickness of 0.0005 to 0.0010 inch (F-21.15). Apply BMS 10-60 red gloss enamel (SRF-14.9815-101) to the area shown in Fig. 608.
Support Block (40), Clip (135,140)	Al alloy	Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04). Apply one coat of BMS 10-11, type 2 color BAC702 white gloss enamel to a thickness of 0.0005 to 0.0010 inch (F-21.15).
Clip (50,55), Strap (65), Bracket (75, 80,100,105), Filler (145), Angle (160,165)	Al alloy	Chemically treat (colored film); apply one coat of BMS 10-11, type 1 primer (F-18.06). Apply one coat of BMS 10-11, type 2 color BAC702 white gloss enamel to a thickness of 0.0005 to 0.0010 inch (F-21.15).

Figure 601 (Sheet 9)

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IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 8</u> Clip (40 thru 50)	Al alloy	Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04).
<u>Fig. 9</u> Retainer (30)	Al alloy	Chemically treat (colored film); apply one coat BMS 10-11, type 1 primer (F-18.06).
<u>Fig. 11</u> Angle (55)	Al alloy	Chromic acid anodize; apply one coat of BMS 10-11, type 1 primer (F-18.13). Apply one coat of BMS 10-11, type 2 enamel, color 702 white gloss (F-21.03).
Bracket Assembly (60A)	--	Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04).
<u>Fig. 12</u> Angle (50)	Al alloy	Chromic acid anodize; apply one coat of BMS 10-11, type 1 primer (F-18.13). Apply one coat of BMS 10-11, type 2 enamel, color 702 white gloss (F-21.03).
<u>Fig. 13</u> Clip (30,35), Fitting (80,85)	Al alloy	Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04).

Figure 601 (Sheet 10)

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IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 14</u>		
Bracket (45,70,95)	Al alloy	Chemically treat (colored film); apply one coat BMS 10-11, type 1 primer (F-18.06).
Fitting (125,130)	15-5PH CRES 180-200 ksi	Cadmium plate and apply one coat of BMS 10-11, type 1 primer (F-16.01).
Fitting (190,195)	Al alloy	Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04) but do not put primer in lubrication fitting hole or 3.5000-3.5010 diameter hole.
<u>Fig. 15</u>		
Angle (25,45)	Al alloy	Chemically treat (colored film); apply one coat BMS 10-11, type 1 primer (F-18.06).
Fitting (90,95)	15-5PH CRES 180-200 ksi	Cadmium plate and apply one coat of BMS 10-11, type 1 primer (F-16.01).

Figure 601 (Sheet 11)

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IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 16</u>		
Gutter (30)	Al alloy	Chromic acid anodize (F-17.04) and apply one coat of BMS 10-79, type 2 primer (F-19.46) to area shown in Fig. 609.
Plate (45)	301 CRES	Cadmium plate and apply one coat of BMS 10-11, type 1 primer (F-16.01).
Clip (70)	Al alloy	Chemically treat (colored film or chromic acid anodize); apply one coat BMS 10-11, type 1 primer (F-18.05).
Doubler (75)	Al alloy	Chemically treat (colored film); apply one coat BMS 10-11, type 1 primer (F-18.06).
<u>Fig. 17</u>		
Bracket (25,35,40)	Al alloy	Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04).
<u>Fig. 19</u>		
Angle (25,45), Gusset (295,300)	Al alloy	Chemical treat and apply BMS 10-11, Type 1 primer (F-18.06).
Hinge Fitting (185 thru 225)	Al alloy	Cadmium plate (F-16.06). Apply BMS 10-79, Type 3 primer (F-19.47) and apply BMS 10-60 enamel (F-19.39-707). Do not put primer or enamel on the sides of all the lugs or hinge pin holes. Primer and enamel are optional in fastener holes. The surface finish in the hinge pin holes must be 63 Ra or better.

Figure 601 (Sheet 12)

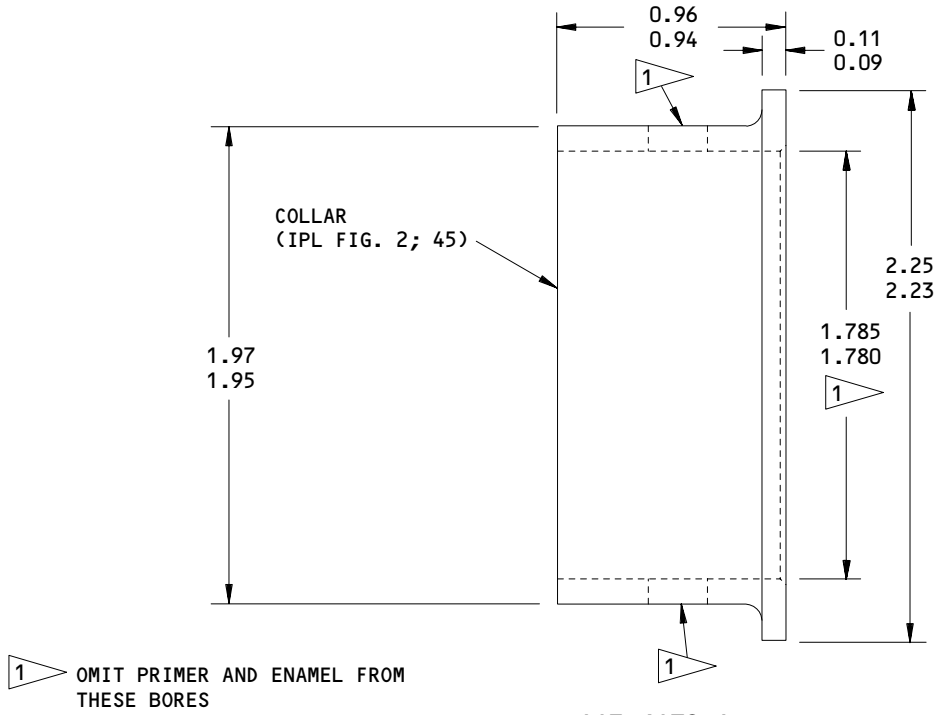
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REPAIR 1-1

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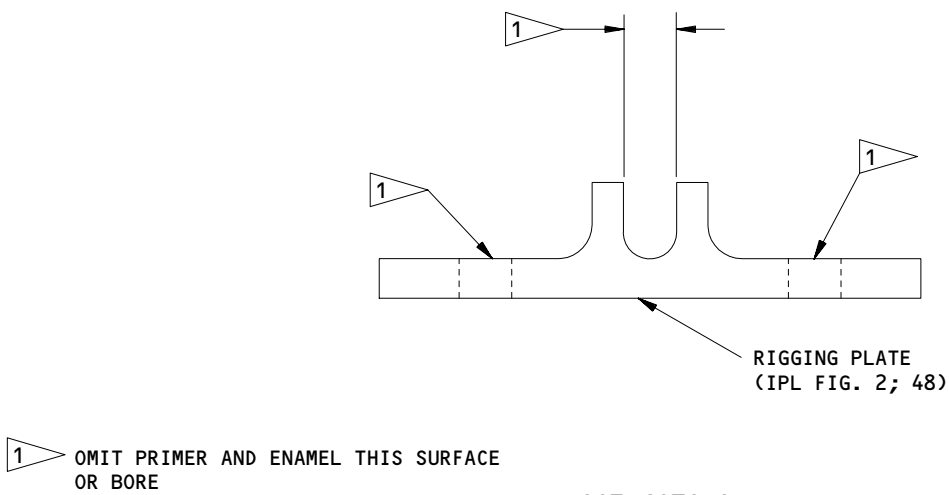
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143T6472-1
Collar Refinish
Figure 601

F23957



143T6471-1
Rigging Plate Refinish
Figure 602

F23959

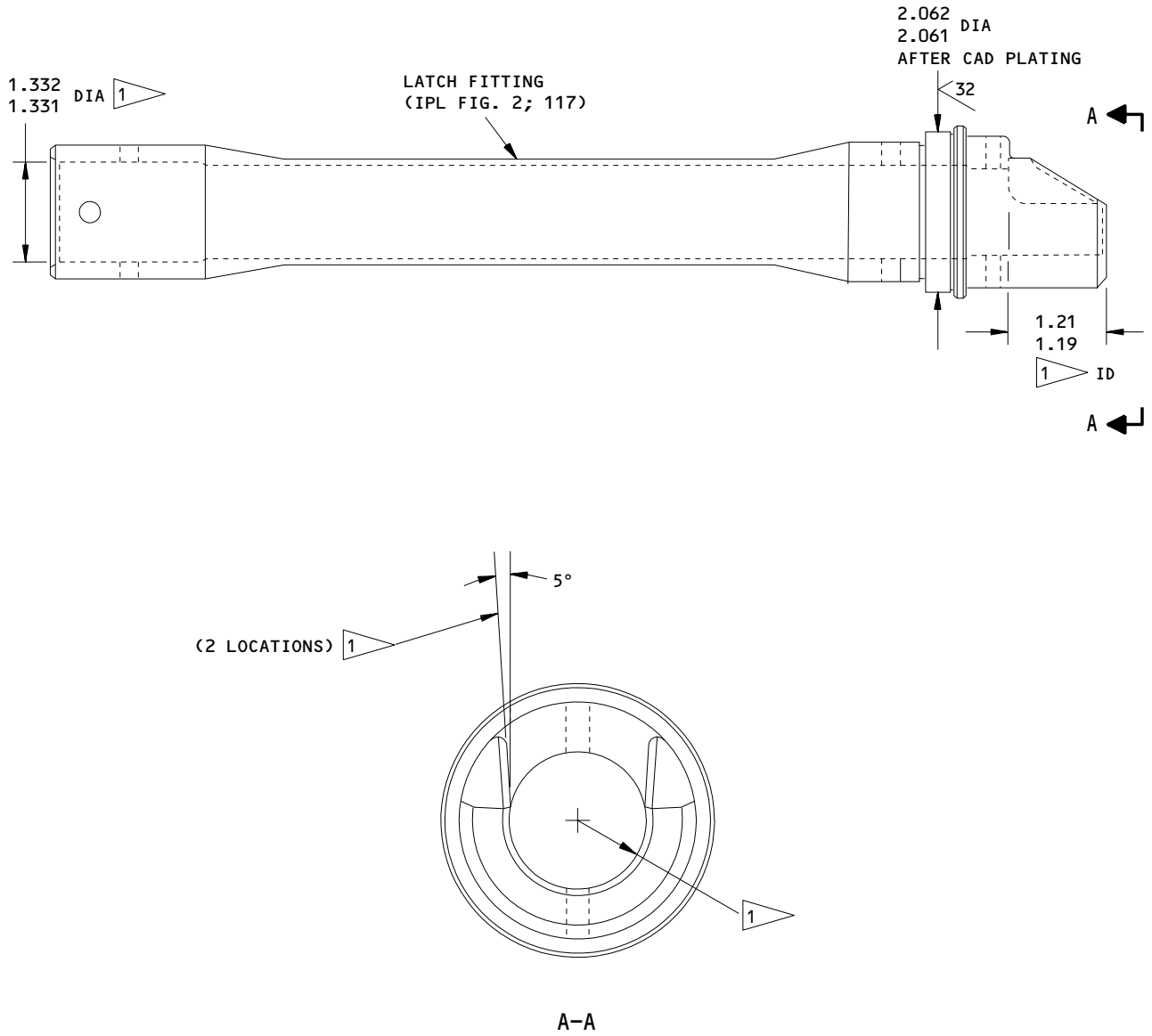
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1 APPLY MIL-L-46010 (OPT: BMS 3-8)
 DRY FILM LUBRICANT TO THE SURFACE
 SHOWN

ALL DIMENSIONS ARE IN INCHES

143T6417-4
 Latch Fitting Refinish
 Figure 603

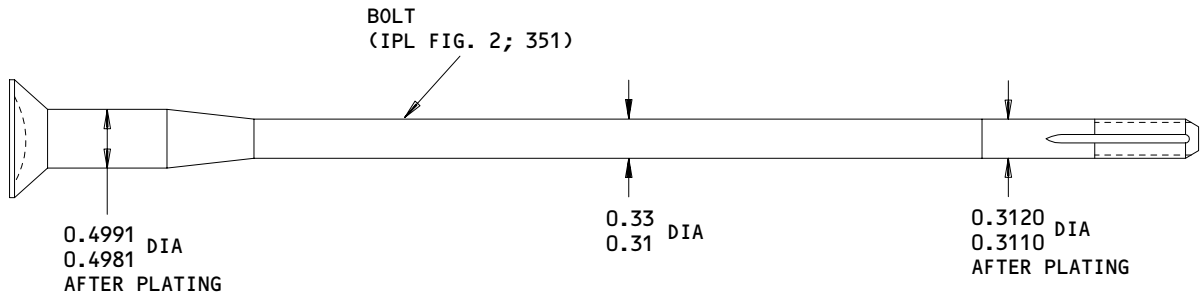
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REPAIR 1-1

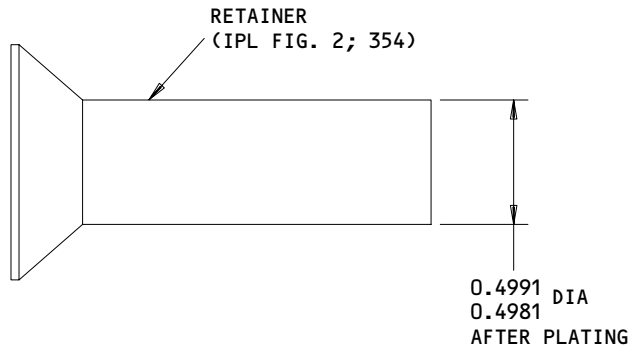
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143T6466-1



143T6467-1

ALL DIMENSIONS ARE IN INCHES

Bolt and Retainer Refinish
Figure 604

F23835

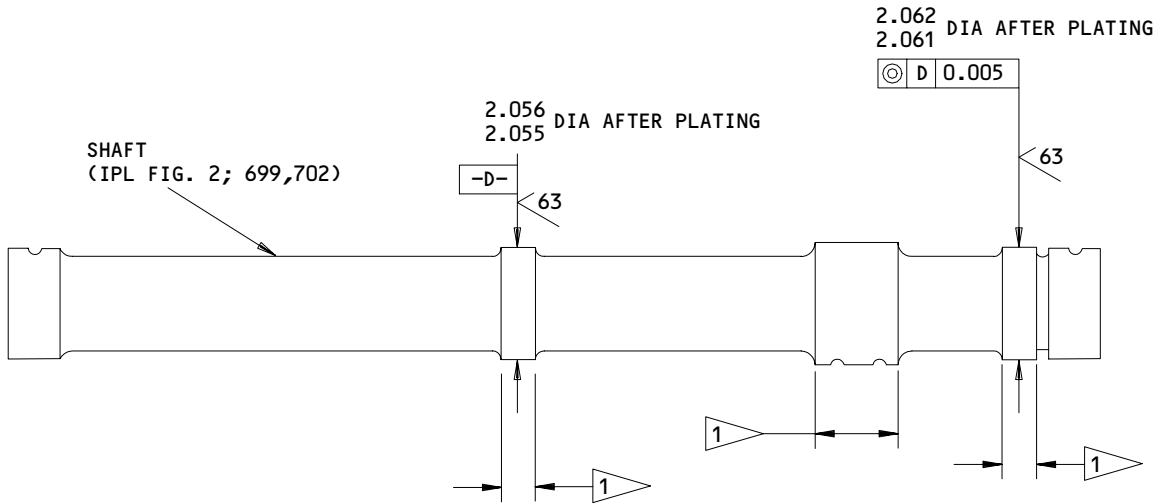
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REPAIR 1-1

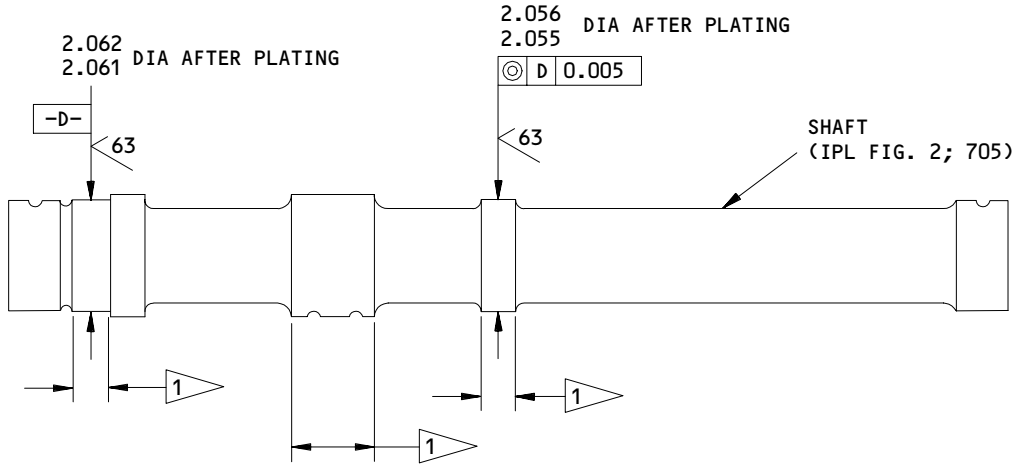
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143T6423-5,-6



143T6423-7

1 CAD PLATE THESE SURFACES ONLY

ALL DIMENSIONS ARE IN INCHES

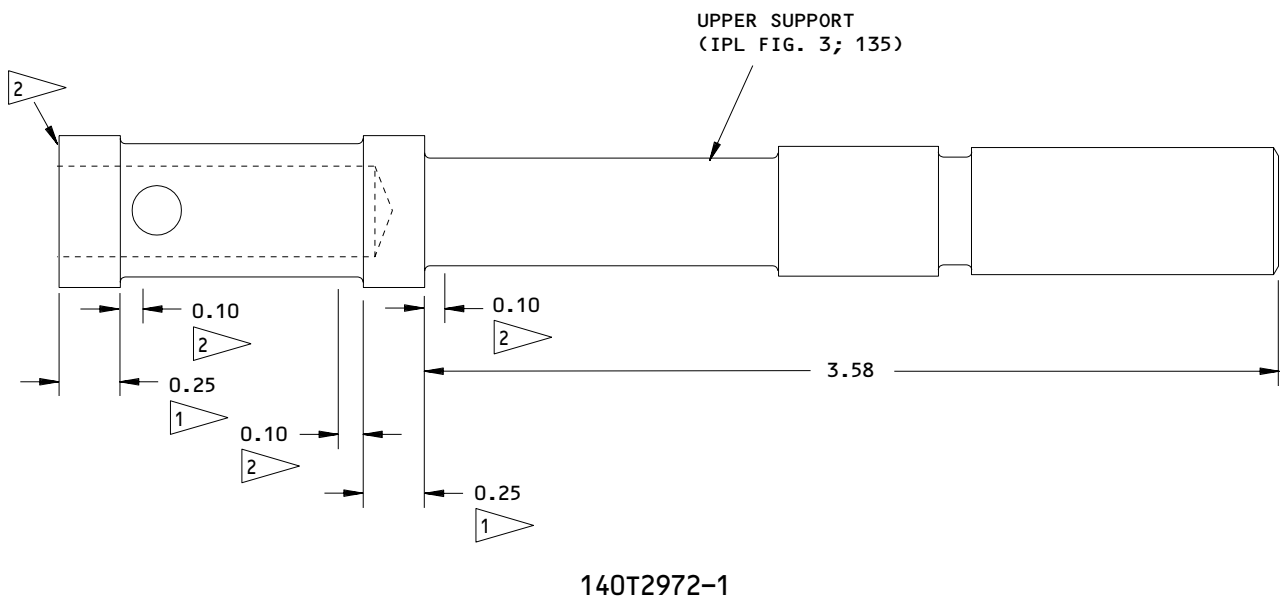
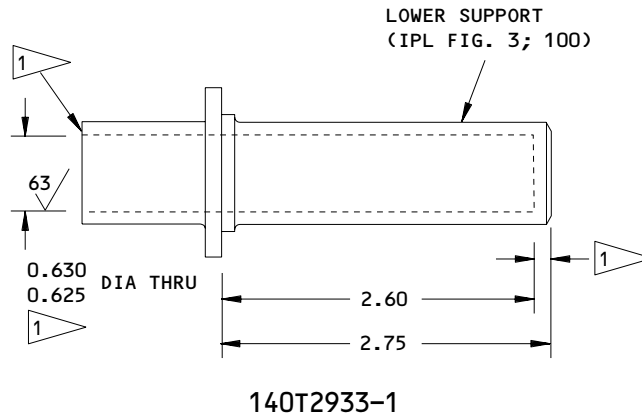
Shaft Refinish
 Figure 605

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REPAIR 1-1

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- 1 APPLY MIL-L-46010 DRY FILM LUBRICANT TO THESE AREAS
- 2 OPTIONAL RUN-OUT FOR 1 FINISH

Support Refinish
Figure 606

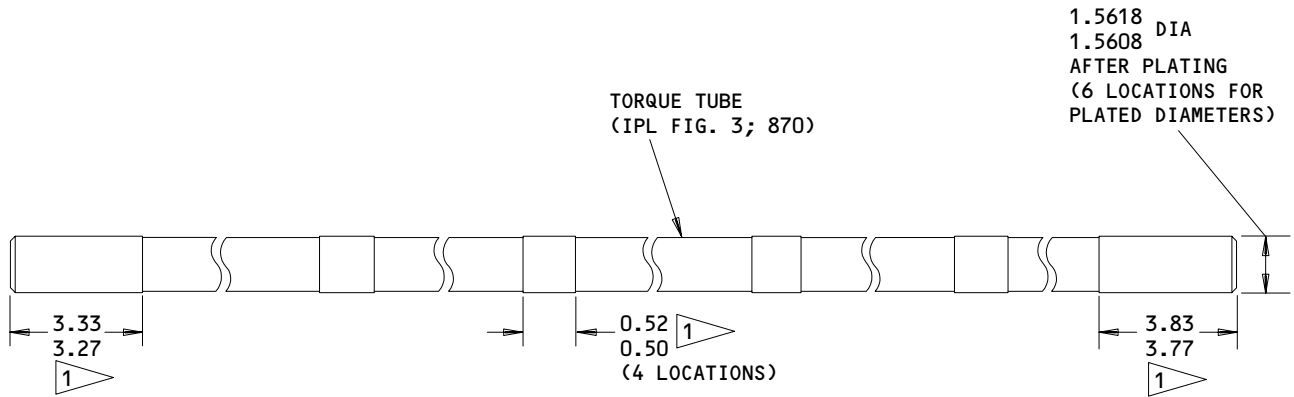
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REPAIR 1-1

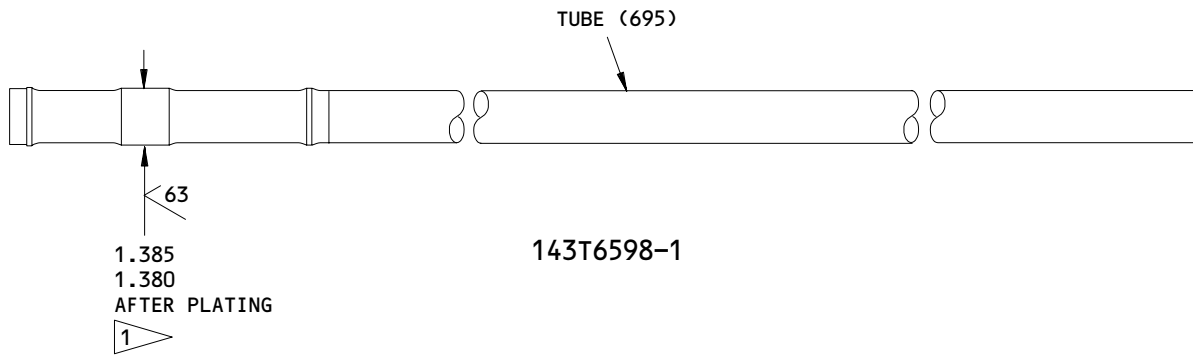
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143T6453-1



143T6598-1

1 APPLY CAD PLATE TO THIS AREA TO 63 RA OR BETTER

Torque Tube Refinish
 Figure 607

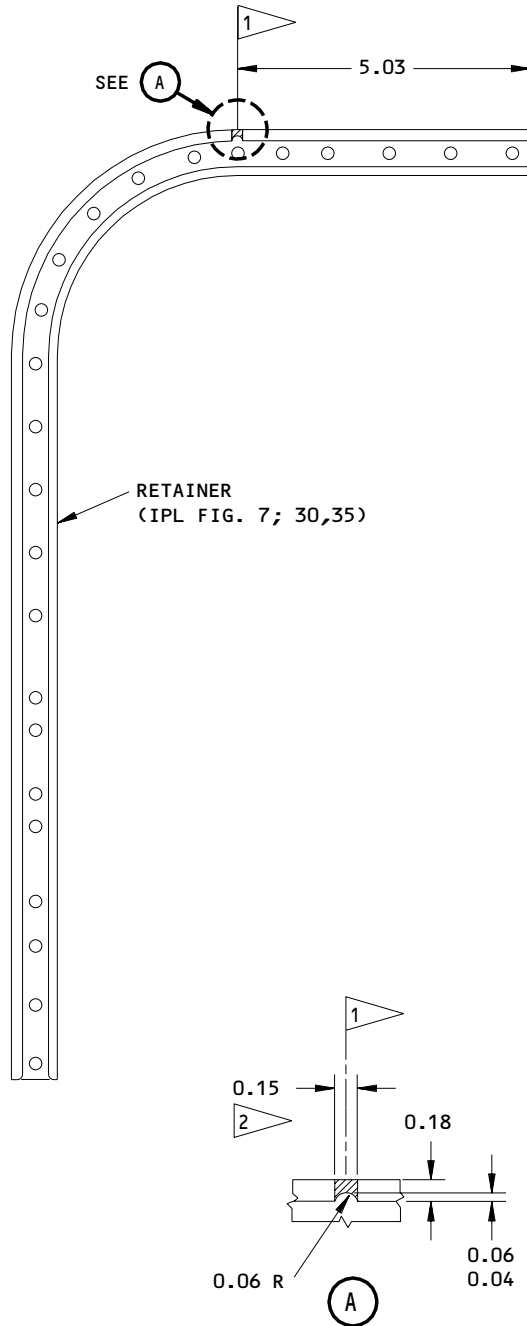
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- 1 CENTERLINE OF SEAL LOCATION INDICATOR
- 2 APPLY BMS 10-60 GLOSS ENAMEL (SRF-14.9815-101) TO THE AREA CENTERED ABOUT THE SEAL LOCATION INDICATOR

ALL DIMENSIONS ARE IN INCHES

143T6555-9,-10
 Retainer Refinish
 Figure 608

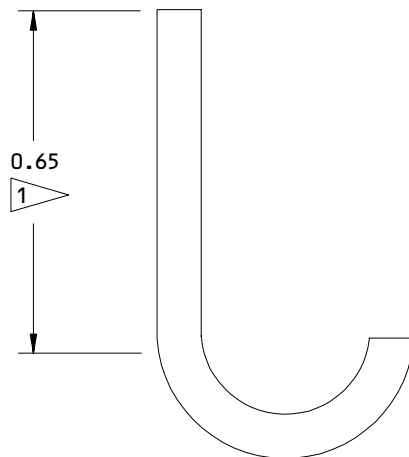
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1 APPLY ONE COAT OF BMS 10-79, TYPE 2
PRIMER (F-19.46)

ALL DIMENSIONS ARE IN INCHES

143T6286-1
Rain Gutter Refinish
Figure 609

F28053

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REPAIR 1-1

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VENT DOOR MECHANISM CRANK ASSEMBLY – REPAIR 2-1

140T2993-5

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (580, 585, 590, IPL Fig. 3)
 - A. Remove bushings.
 - B. Install bushings as specified in 20-50-03 with wet BMS 5-95 sealant.
 - C. Fillet seal around periphery of bushings with BMS 5-95 sealant in the areas shown in Fig. 601.

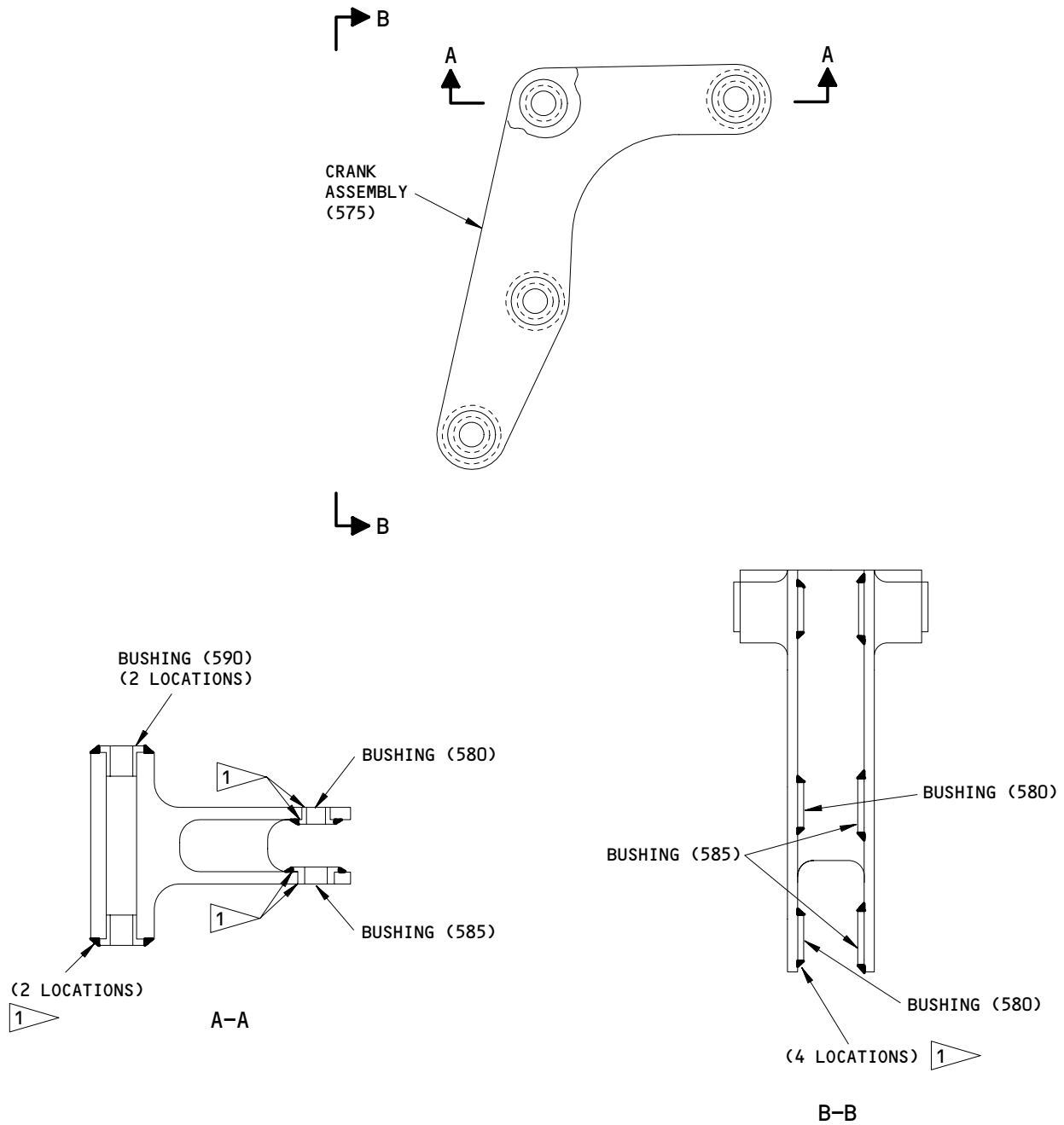
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
REPAIR 2-1

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 FILLET SEAL WITH BMS 5-95 SEALANT

Bushing Sealant Application
 Figure 601

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REPAIR 2-1

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CRANK - REPAIR 2-2

140T2993-4

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices, and to IPL Fig. 3 for item numbers. For the repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 2-1.

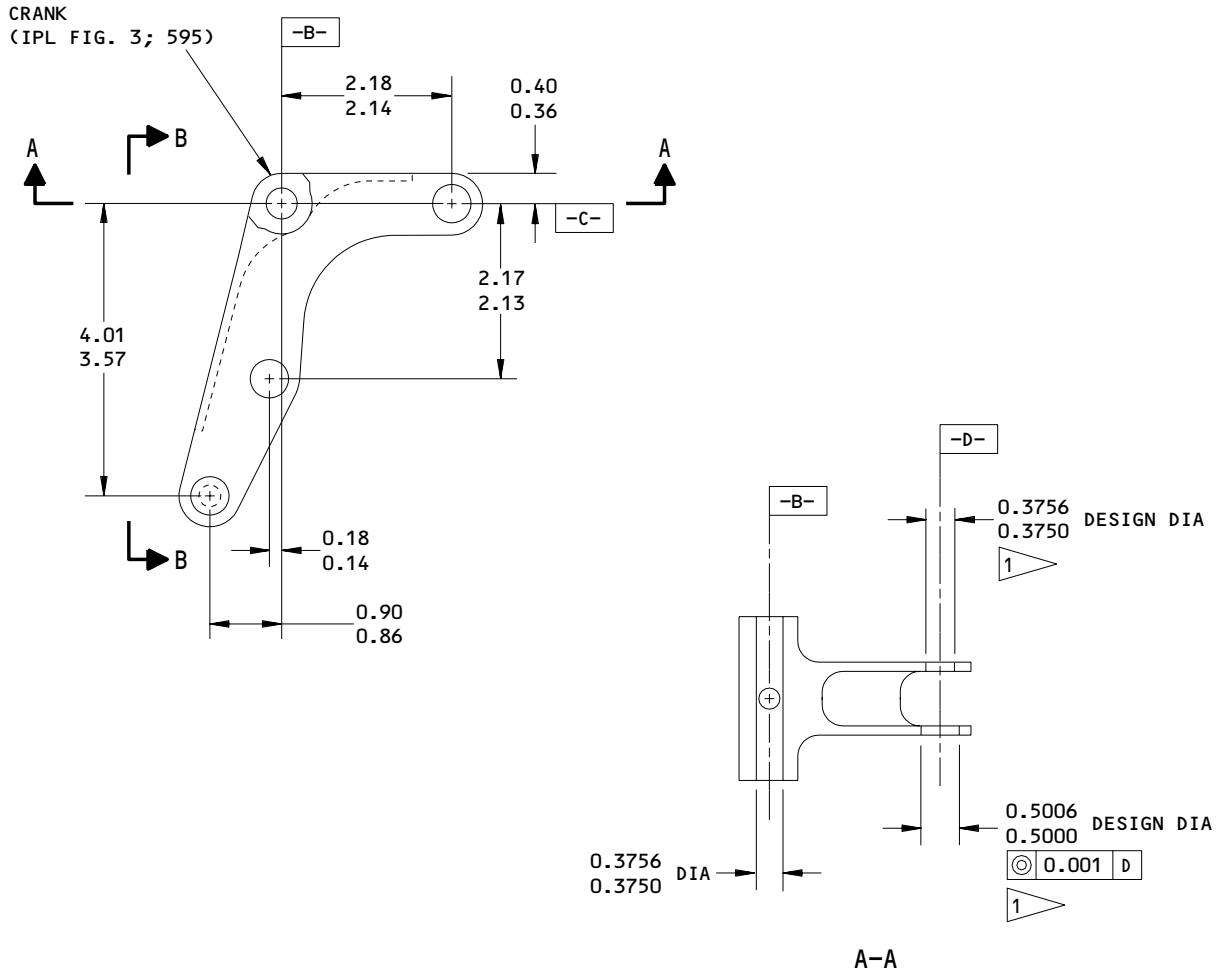
52-32-04

REPAIR 2-2

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REFINISH

CRANK (595) -- BORIC ACID - SULFURIC ACID ANODIZE OR CHROMIC ACID ANODIZE AT 22 VOLTS AS SPECIFIED IN 20-43-01, CLASS 3 OR 5 (F-17.31). APPLY TWO COATS OF BMS 10-11, TYPE 1 PRIMER (F-20.03) BUT NOT IN HOLES.



THE REPAIR LIMIT FOR THE INSTALLATION OF AN OVERSIZED BUSHING IS THE MAXIMUM DESIGN DIAMETER SHOWN PLUS 0.06 INCHES.

REPAIR

REF

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: ALUM ALLOY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

140T2993-4
 Crank - Bushed Hole Repair
 Figure 601 (Sheet 1)

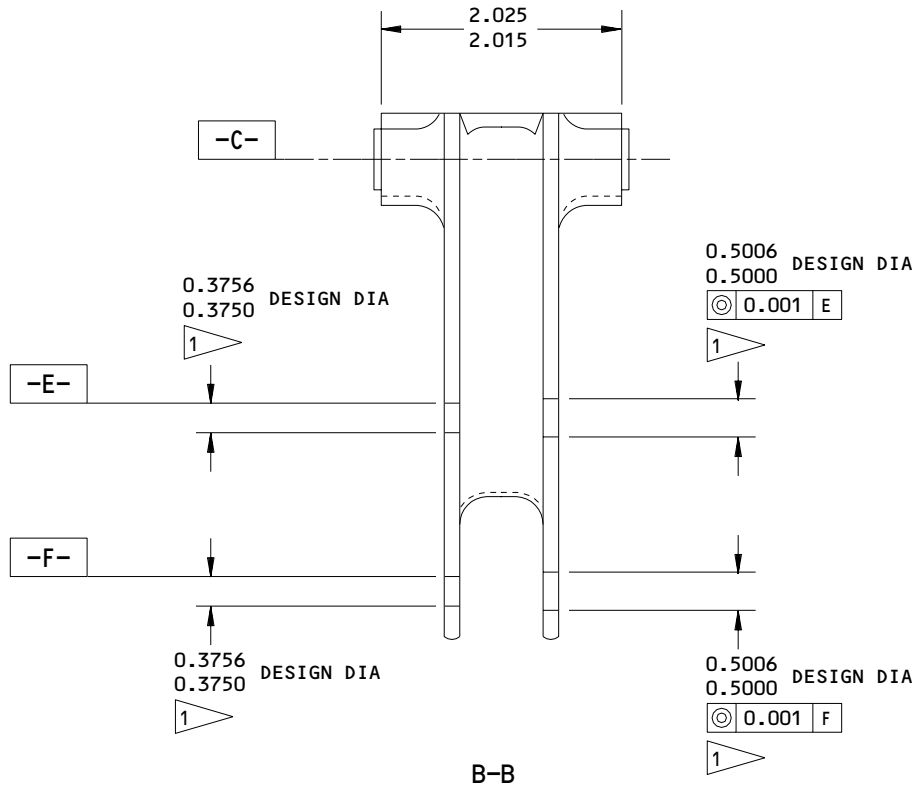
52-32-04

REPAIR 2-2

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140T2993-4
Crank - Bushed Hole Repair
Figure 601 (Sheet 2)

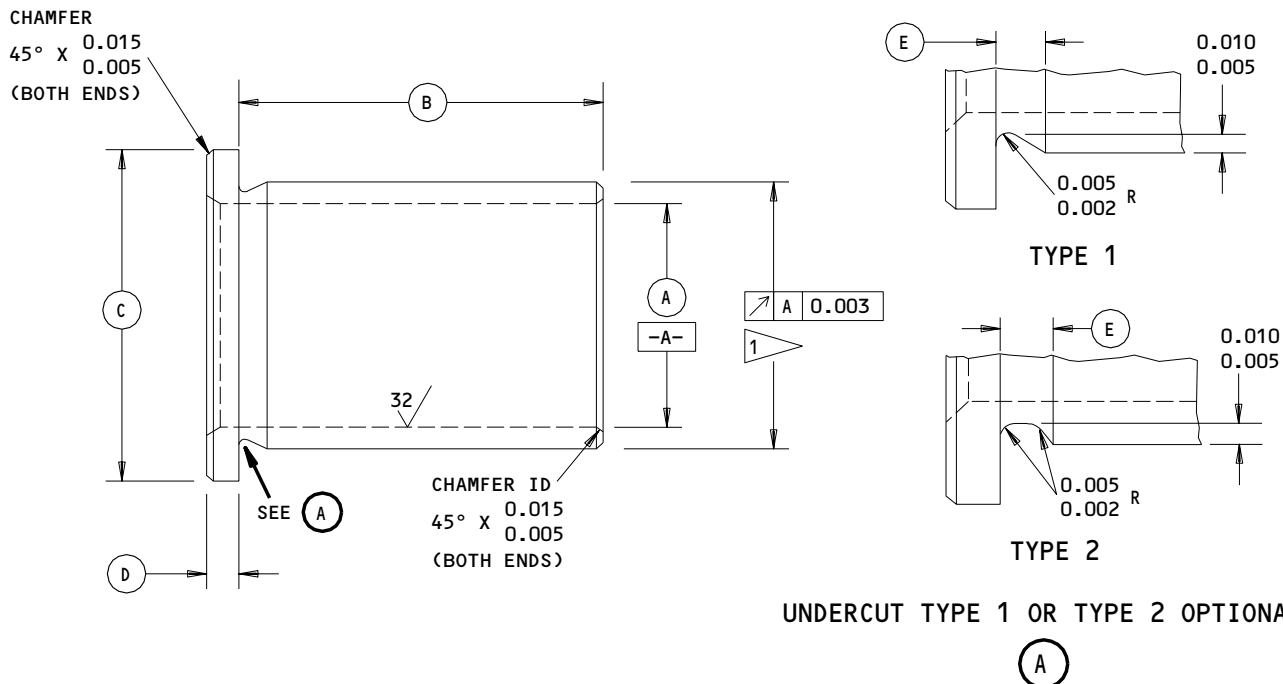
52-32-04

REPAIR 2-2

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ORIGINAL BUSHING (ITEM NUMBERS)	(A)	(B)	(C)	(D)	(E)	INTERFERENCE
580	0.2515 0.2500	0.100 0.095	0.510 0.500	0.062 0.057	0.030 0.015	0.0002-0.0013
585	0.3765 0.3650	0.100 0.095	0.635 0.625	0.062 0.057	0.030 0.015	0.0003-0.0016
590	0.2515 0.2500	0.250 0.245	0.510 0.500	0.062 0.057	0.060 0.030	0.0002-0.0013

REFINISH

ITEM NUMBERS 580,590: CADMIUM PLATE (F-15.06). CADMIUM PLATE IN BORE IS OPTIONAL.

ITEM NUMBER 585: CADMIUM PLATE (F-15.06) ALL BUT THE BUSHING BORE

FINAL BUSHING OUTSIDE DIAMETER EQUALS THE REPAIR DIAMETER OF THE CRANK PLUS THE INTERFERENCE.

DIMENSIONS TO BE MET AFTER PLATING

REPAIR

REF

ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: (ITEM NUMBERS 580,590) 17-4PH CRES, RHc 40-43
 (ITEM NUMBER 585) ALUMINUM-NICKEL-BRONZE

ANGULAR TOLERANCE, ±5 DEGREES

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 3

REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 3; 580,585,590)

140T2993-4
 Oversize Bushing Details
 Figure 602

52-32-04

REPAIR 2-2

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BEARING PLATE ASSEMBLY – REPAIR 3-1

143T6206-1, -2

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (440, IPL Fig. 1)

- A. Remove bushing.
- B. Install bushing as specified in 20-50-03 with wet BMS 5-95 sealant.
- C. Fillet seal around periphery of bushing flange with BMS 5-95 sealant.

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REPAIR 3-1

01.1

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BEARING PLATE – REPAIR 3-2

143T6206-3

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

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 3-1.

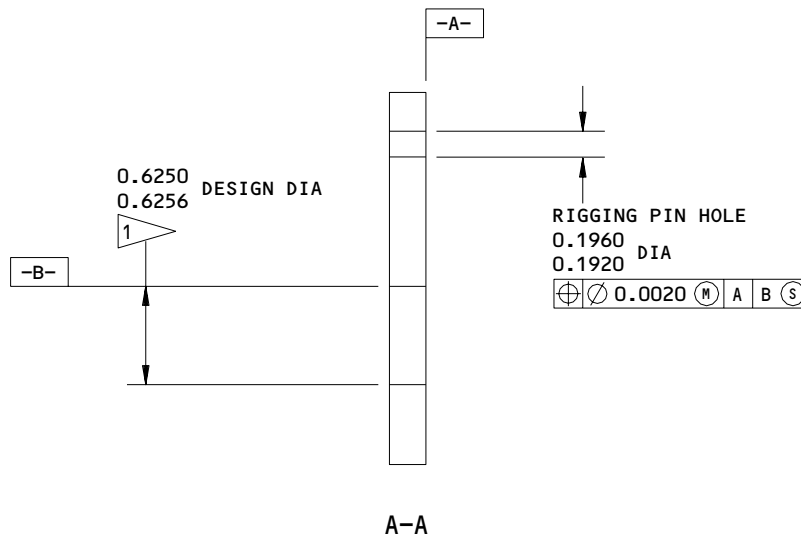
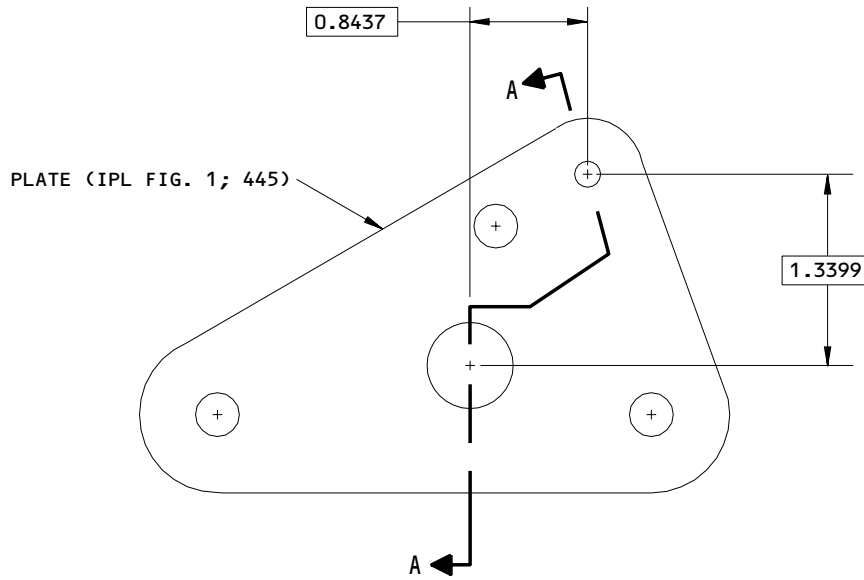
52-32-04

REPAIR 3-2

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REFINISH

PLATE (445) -- ANODIZE AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.04) ALL OVER, BUT DO NOT PUT PRIMER AND ENAMEL IN THE BUSHING BORE

1 THE REPAIR LIMIT FOR THE INSTALLATION OF AN OVERSIZED BUSHING IS THE MAXIMUM DESIGN DIAMETER SHOWN PLUS 0.06 INCHES.

REPAIR

REF 1

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: ALUM ALLOY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

143T6206-3
 Bearing Plate - Bushed Hole Repair
 Figure 601

52-32-04

REPAIR 3-2

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SHEAR FITTING ASSEMBLY – REPAIR 4-1

143T6220-1

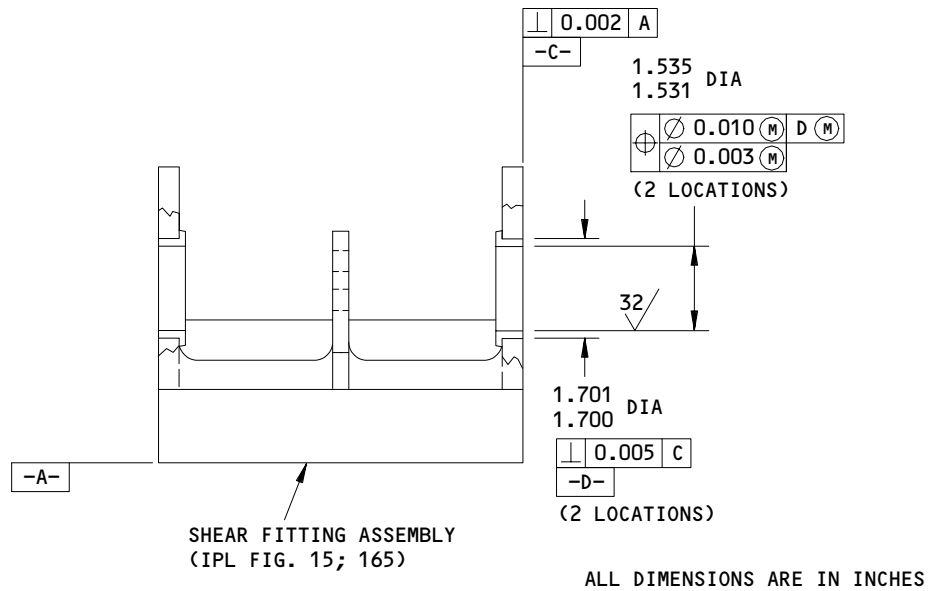
NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (170, IPL Fig. 15)

- A. Remove bushings.
- B. Install bushings as specified in 20-50-03 with wet BMS 5-95 sealant.
- C. Machine bores of bushings as shown in Fig. 601.

2. Refinish

- A. Shear fitting (175) -- Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04). Material: Alum alloy.
- B. Bushing (170) -- Cadmium plate (F-15.06). Material: A1-Ni-Br.



143T6220-1
 Bushing Replacement
 Figure 601

F27790

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REPAIR 4-1

01.1

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FITTING ASSEMBLY – REPAIR 5-1

143T6221-1, -2

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (110, 115, IPL Fig. 15)

- A. Remove bushing.
- B. Install bushing by shrink fit as specified in 20-50-03 with wet BMS 5-95 sealant.
- C. Fillet seal around periphery of bushing flange with BMS 5-95 sealant.

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REPAIR 5-1

01.1

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FITTING - REPAIR 5-2

143T6221-5, -6

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices, and to IPL Fig. 15 for item numbers. For the repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 5-1.

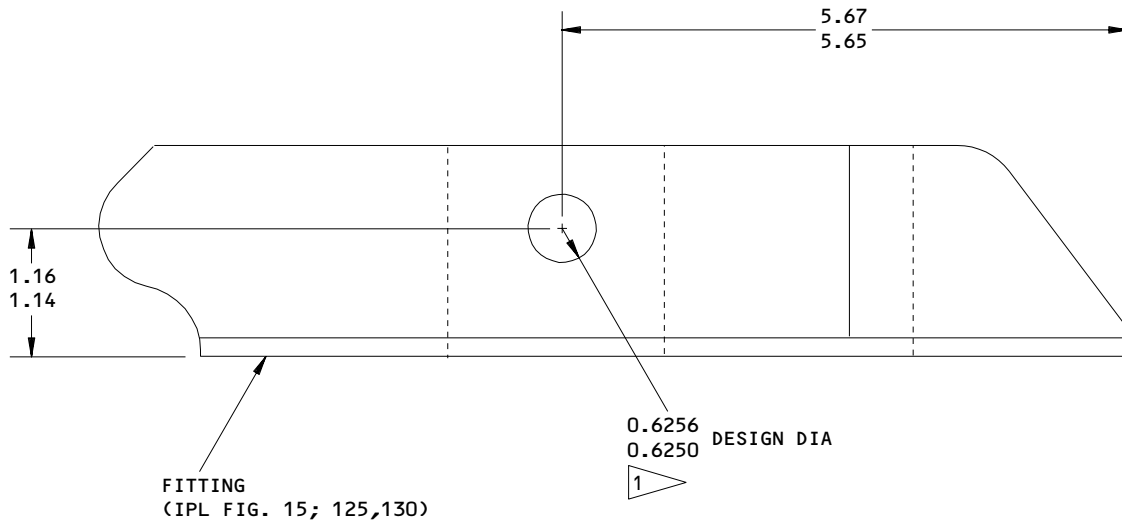
52-32-04

REPAIR 5-2

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REFINISH

FITTING (125,130) - - ANODIZE AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.04) BUT DO NOT PUT PRIMER IN BUSHING BORE.

1 THE REPAIR LIMIT FOR THE INSTALLATION OF AN OVERSIZED BUSHING IS THE MAXIMUM DESIGN DIAMETER PLUS 0.06 INCHES.

REPAIR

REF 1

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: ALUM ALLOY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 15

143T6221-5,-6
 Fitting - Bushed Hole Repair
 Figure 601

52-32-04

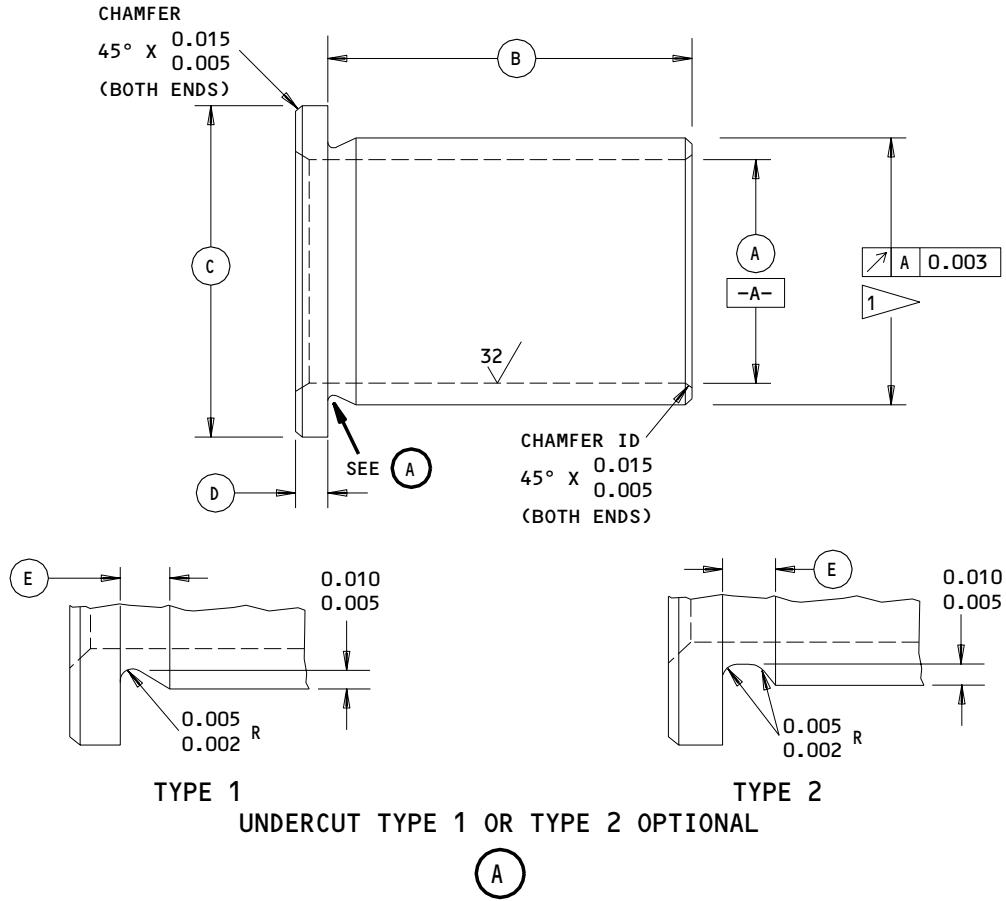
REPAIR 5-2

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BOEING
COMPONENT
MAINTENANCE MANUAL



ORIGINAL BUSHING (ITEM NUMBERS)	(A)	(B)	(C)	(D)	(E)	INTERFERENCE
120 ∇ 2	0.5015 0.5000	0.450 0.445	0.760 0.750	0.062 0.057	0.060 0.030	0.0003-0.0018

REFINISH

ITEM NUMBER 120: CADMIUM PLATE (F-15.06).
 CADMIUM PLATE IN BORE IS OPTIONAL.

- ∇ 1 FINAL BUSHING OUTSIDE DIAMETER EQUALS THE REPAIR DIAMETER OF THE FITTING PLUS THE INTERFERENCE.
- ∇ 2 DIMENSIONS TO BE MET AFTER PLATING

REPAIR

∇ 63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
 MATERIAL: 17-4PH CRES, Rhc 40-43
 ANGULAR TOLERANCE, \pm 5 DEGREES
 BREAK ALL SHARP EDGES
 ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG. 15

REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 15; 120)

143T6221-5,-6
 Oversize Bushing Details
 Figure 602

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REPAIR 5-2

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FITTING ASSEMBLY – REPAIR 6-1

143T6229-1

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (125, 130, IPL Fig. 9)

- A. Remove bushings.
- B. Install bushings as specified in 20-50-03.
- C. Fillet seal around periphery of bushing flanges with BMS 5-95 sealant.

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REPAIR 6-1

01.1

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FITTING - REPAIR 6-2

143T6229-2

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices, and to IPL Fig. 9 for item numbers. For the repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 6-1.

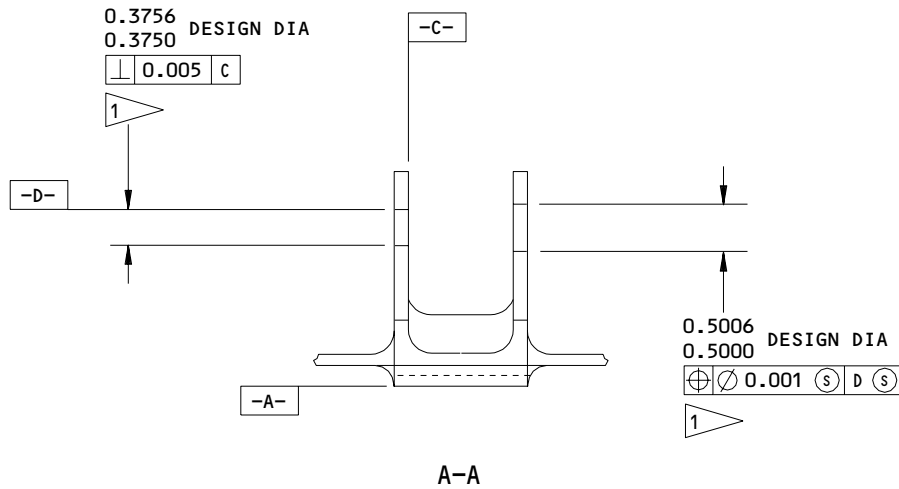
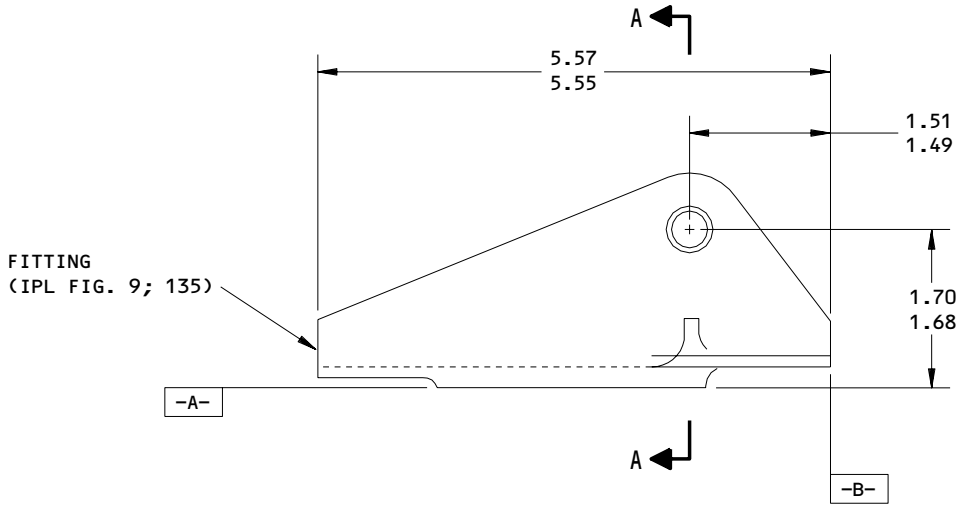
52-32-04

REPAIR 6-2

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REFINISH

FITTING (135) -- ANODIZE AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.04) BUT DO NOT PUT PRIMER IN BUSHING BORES.

1 THE REPAIR LIMIT FOR THE INSTALLATION OF AN OVERSIZED BUSHING IS THE MAXIMUM DESIGN DIAMETER SHOWN PLUS 0.06 INCHES.

REPAIR

REF 1
 125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: ALUM ALLOY
 BREAK ALL SHARP EDGES
 ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG. 9

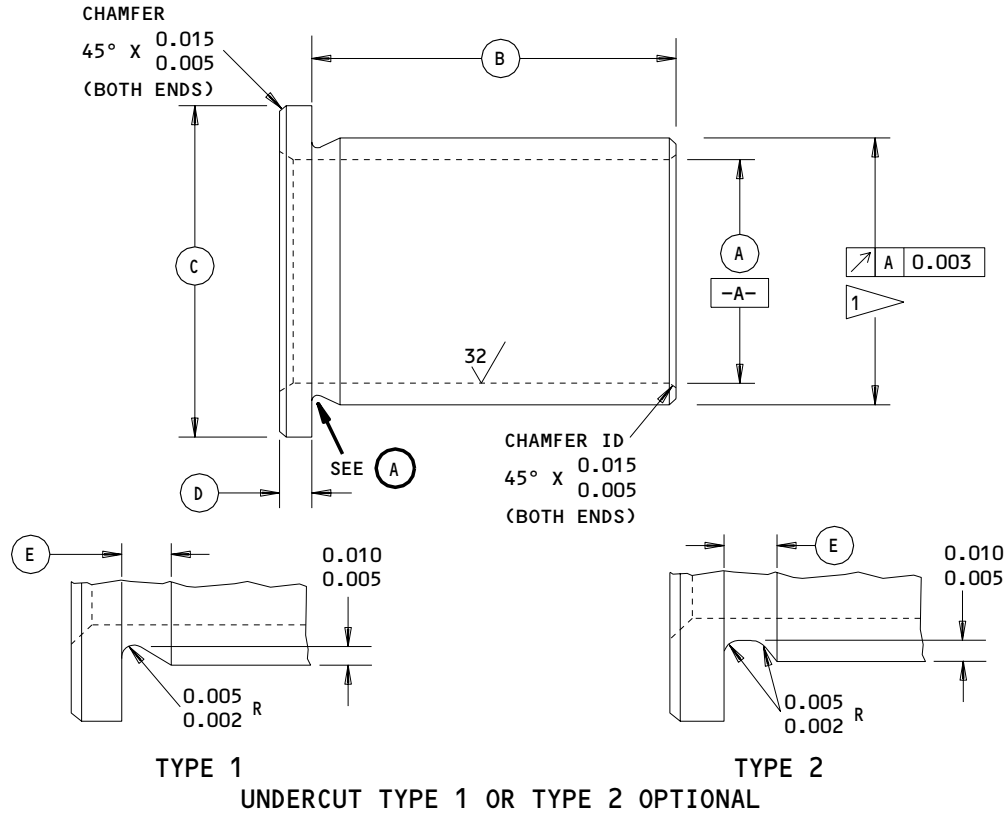
143T6229-2
 Fitting - Bushed Hole Repair
 Figure 601

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REPAIR 6-2
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BOEING
COMPONENT
MAINTENANCE MANUAL



(A)

ORIGINAL BUSHING (ITEM NUMBERS)	(A)	(B)	(C)	(D)	(E)	INTERFERENCE
125	0.2515 0.2500	0.120 0.115	0.510 0.500	0.062 0.057	0.030 0.015	0.0002-0.0013
130	0.3765 0.3750	0.120 0.115	0.635 0.625	0.062 0.057	0.030 0.015	0.0003-0.0016

REFINISH

ITEM NUMBER 125: CADMIUM PLATE (F-15.06).
 CADMIUM PLATE IN BORE IS OPTIONAL.

ITEM NUMBER 130: CADMIUM PLATE (F-15.06) ALL
 BUT THE BUSHING BORE.

FINAL BUSHING OUTSIDE DIAMETER EQUALS THE
 REPAIR DIAMETER OF THE FITTING PLUS THE
 INTERFERENCE.

DIMENSIONS TO BE MET AFTER PLATING.

REPAIR

ALL MACHINED SURFACES UNLESS SHOWN
 DIFFERENTLY

MATERIAL: (ITEM NUMBER 125) 17-4PH CRES,
 RHc 40-43
 (ITEM NUMBER 130) ALUMINUM-NICKEL-
 BRONZE

ANGULAR TOLERANCE, ±5 DEGREES

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 9

REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 9; 125,130)

143T6229-2
 Oversize Bushing Details
 Figure 602

52-32-04

REPAIR 6-2

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LIFT LINK FITTING ASSEMBLY – REPAIR 7-1

143T6231-5, -6

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (50, 55, IPL Fig. 4)

- A. Remove bushings.
- B. Install bushings as specified in 20-50-03 with wet BMS 5-95 sealant.
- C. Machine the bushing bores as specified in Fig. 601.

2. Refinish

- A. Fittings (60A, 65A) -- Anodize and apply one coat of BMS 10-11, type 1 primer (18.04) plus one coat of BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.17) all over, but do not put primer and enamel in the bushing bores. Material: Alum alloy.

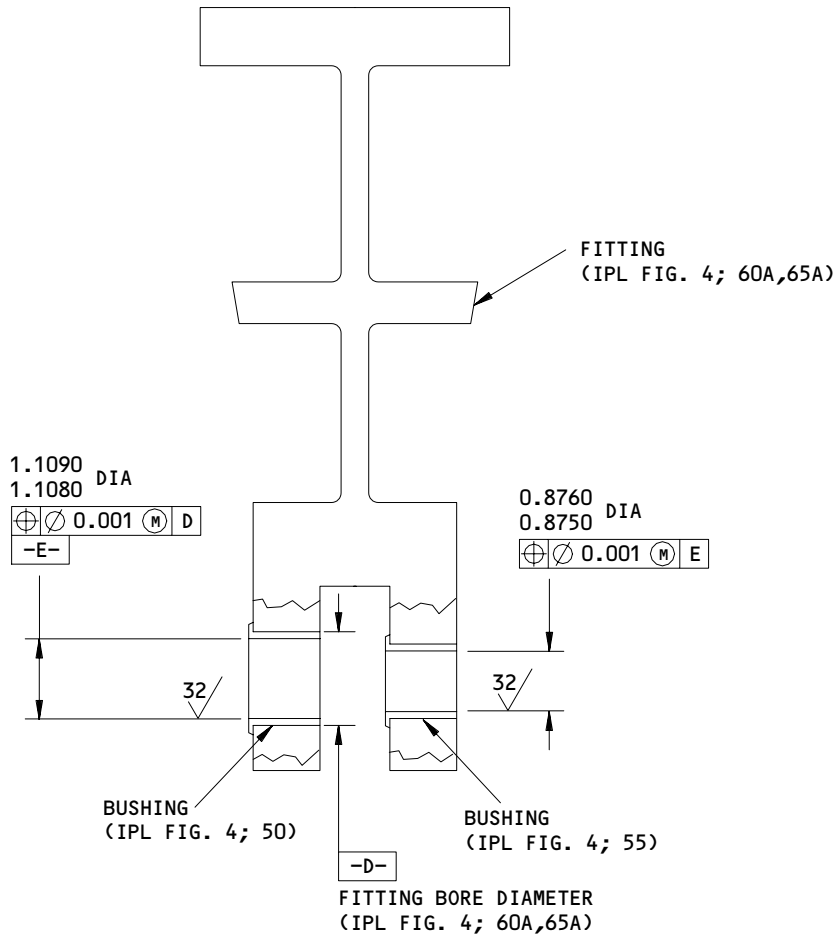
52-32-04

REPAIR 7-1

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FITTING ASSEMBLY

ALL DIMENSIONS ARE IN INCHES

143T6231-5,-6
 Bushing Replacement
 Figure 601

F28034

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REPAIR 7-1

01.1

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INTERCOSTAL INSTALLATION - REPAIR 8-1

143T6240-1

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

1. Grommet Replacement (105, IPL Fig. 9)

- A. Remove grommets.
- B. Install grommets; trim to fit. Bond as specified in 20-50-12, type 70 or type 82.

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REPAIR 8-1

01.1

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LATCH LOCK IDLER SUPPORT BRACKET ASSEMBLY – REPAIR 9-1

143T6244-1

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (385, IPL Fig. 1)

- A. Remove bushings.
- B. Install bushings by the shrink fit procedure of 20-50-03 with BMS 5-95 sealant.

2. Refinish

- A. Bracket (390) -- Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04) but do not put primer in the holes. Material: Alum alloy.

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REPAIR 9-1

01.1

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BRACKET - REPAIR 9-2

143T6244-2

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

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 9-1.

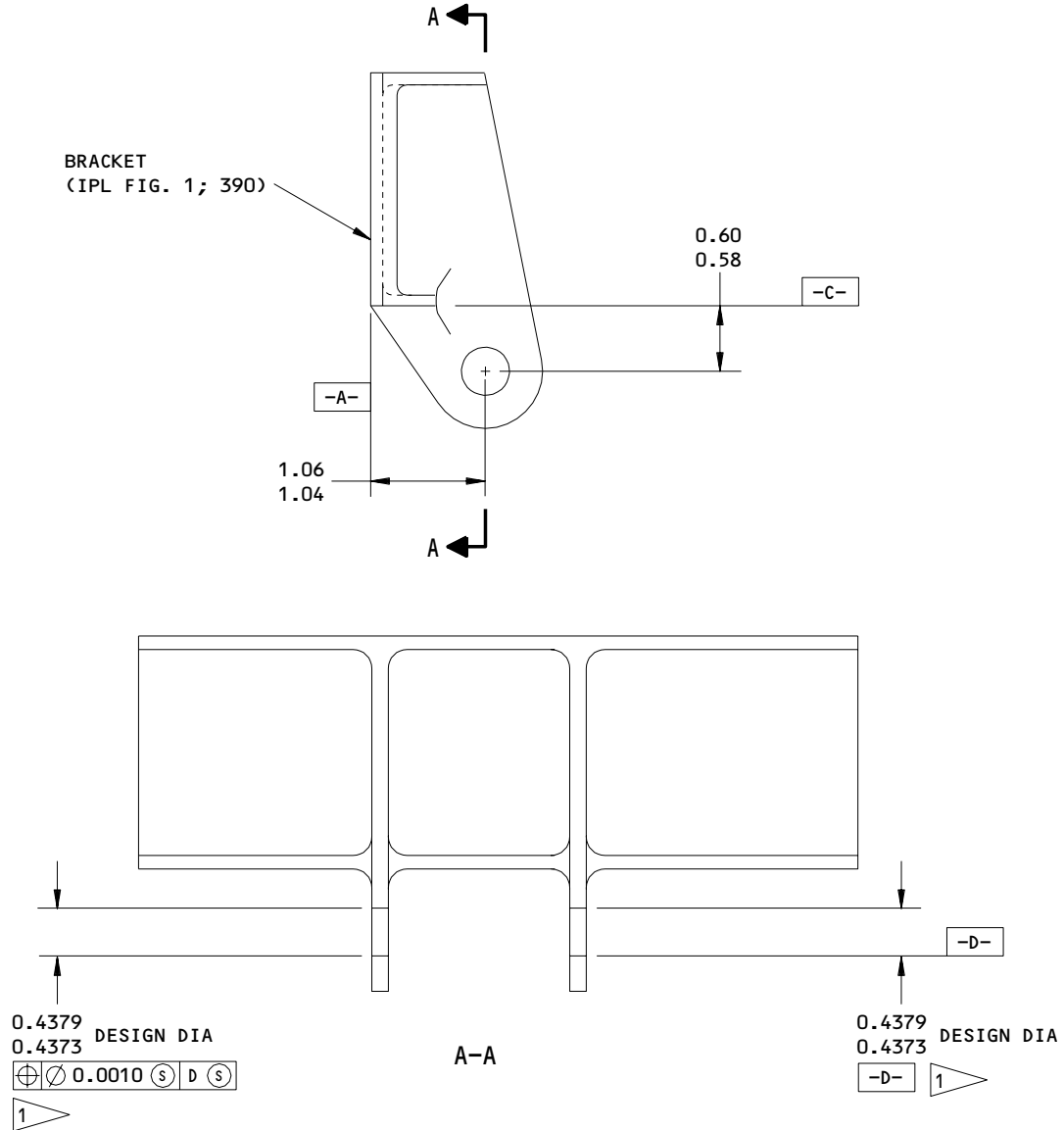
52-32-04

REPAIR 9-2

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REFINISH

BRACKET (390) -- ANODIZE AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.04) BUT DO NOT PUT PRIMER IN THE HOLES.

1 THE REPAIR LIMIT FOR THE INSTALLATION OF AN OVERSIZED BUSHING IS THE MAXIMUM DESIGN DIAMETER SHOWN PLUS 0.06 INCHES.

REPAIR

REF 1

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: ALUM ALLOY
 BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

143T6244-2
 Bracket - Bushed Hole Repair
 Figure 601

52-32-04

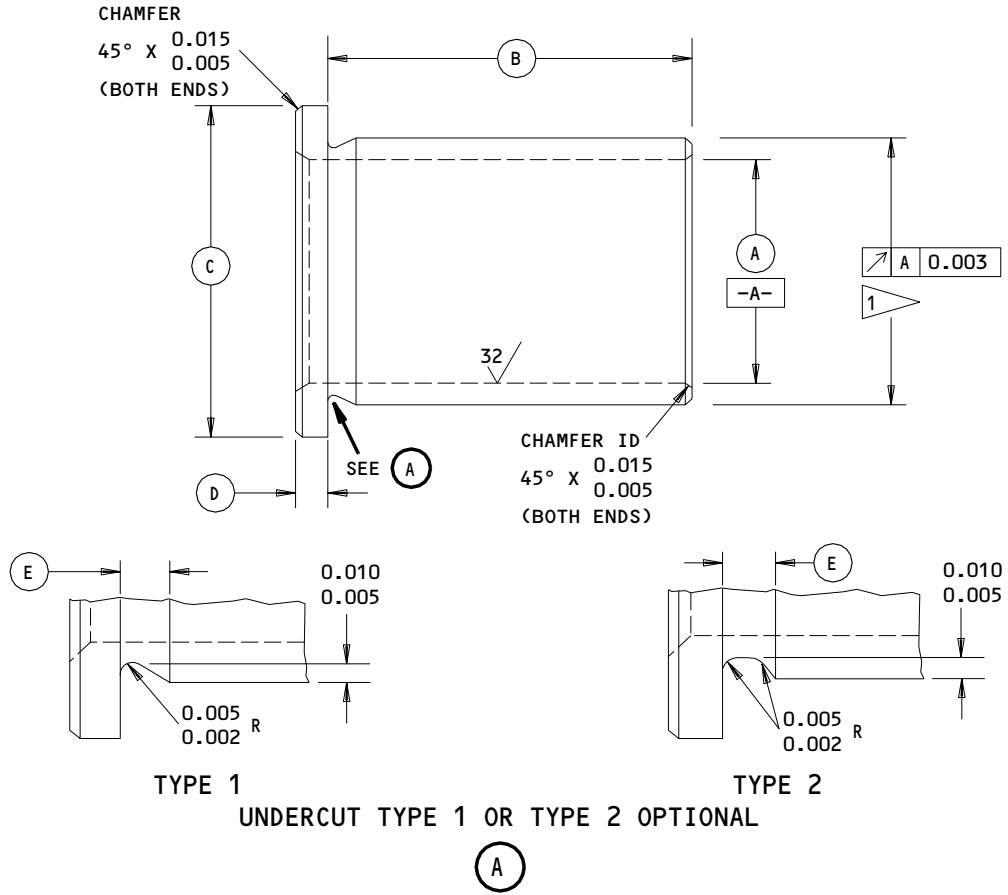
REPAIR 9-2

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01.1

BOEING
 COMPONENT
 MAINTENANCE MANUAL



ORIGINAL BUSHING (ITEM NUMBERS)	(A)	(B)	(C)	(D)	(E)	INTERFERENCE
385 ∇	0.3140 0.3125	0.100 0.095	0.572 0.562	0.062 0.057	0.030 0.015	0.0002-0.0013

REFINISH

ITEM NUMBERS 385: CADMIUM PLATE (F-15.06) ALL BUT THE BUSHING BORE.

- ∇ 1 FINAL BUSHING OUTSIDE DIAMETER EQUALS THE REPAIR DIAMETER OF THE BRACKET PLUS THE INTERFERENCE.
- ∇ 2 DIMENSIONS TO BE MET AFTER PLATING.

REPAIR

∇ 63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: ALUMINUM-NICKEL-BRONZE
 ANGULAR TOLERANCE, ± 5 DEGREES
 BREAK ALL SHARP EDGES
 ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG. 1

REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 1; 385)

143T6244-2
 Oversize Bushing Details
 Figure 602

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REPAIR 9-2

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LATCH FITTING ASSEMBLY – REPAIR 10-1

143T6255-1, -2, -6, -9, -10

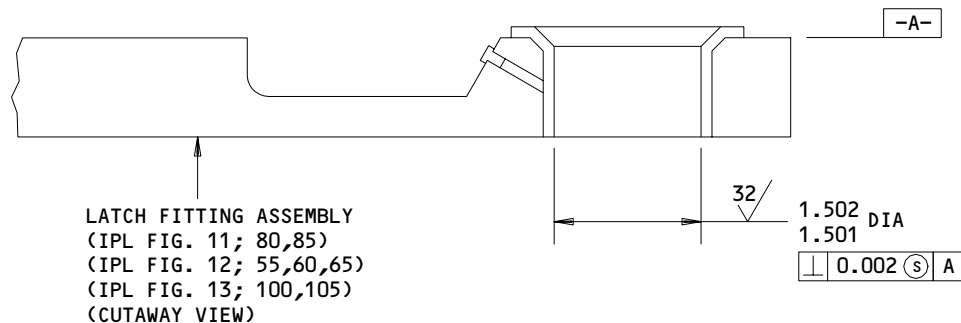
NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (95, IPL Fig. 11; 75, IPL Fig. 12; 115, IPL Fig. 13)

- A. Remove bushing.
- B. Install bushing as specified in 20-50-03 with BMS 3-24 grease.
- C. Machine bore of bushing as specified in Fig. 601.
- D. Fillet seal around periphery of bushing flange with BMS 5-95 sealant.

2. Refinish

- A. Latch fitting (100, 105, IPL Fig. 11; 80, 85, 90, IPL Fig. 12; 120, 125, IPL Fig. 13) -- Anodize and apply one coat of BMS 10-11, type 1 primer but not in bushing bore. Material: Alum alloy.
- B. Bushing (95, IPL Fig. 11; 75, IPL Fig. 12; 115, IPL, Fig. 13) -- Cadmium plate (F-15.06). Material: A1-Ni-Br



ALL DIMENSIONS ARE IN INCHES

143T6255-1,-2,-6,-9,-10
 Bushing Replacement
 Figure 601

52-32-04

REPAIR 10-1

01.1

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FITTING ASSEMBLY – REPAIR 11-1

143T6260-1, -2, -5, -6, -9, -13, -14, -15, -16

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (75, 80, IPL Fig. 8; 75, 80, IPL Fig. 9; 45, 50, IPL Fig. 10)
 - A. Remove bushings.
 - B. Install bushings as specified in 20-50-03.
 - C. Fillet seal around periphery of bushing flanges with BMS 5-95 sealant.

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REPAIR 11-1

01.1

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FITTING - REPAIR 11-2

143T6260-3, -4, -5, -6, -9, -11, -12, -17, -18

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

1. Bushing Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 11-1.

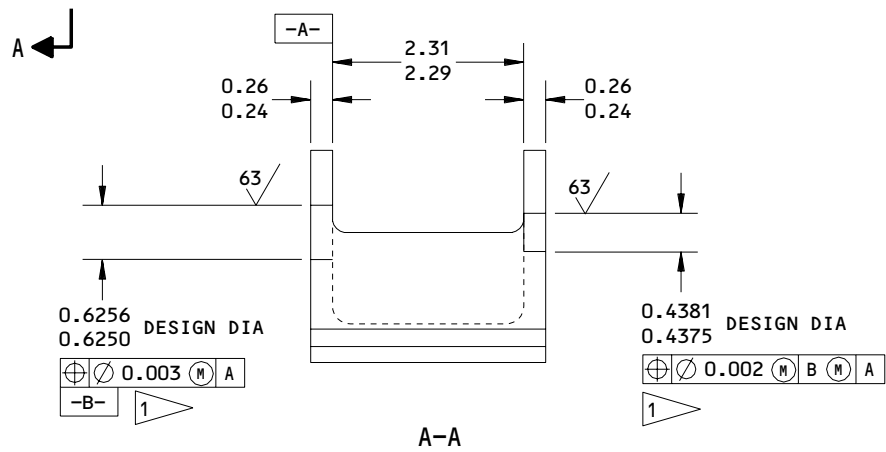
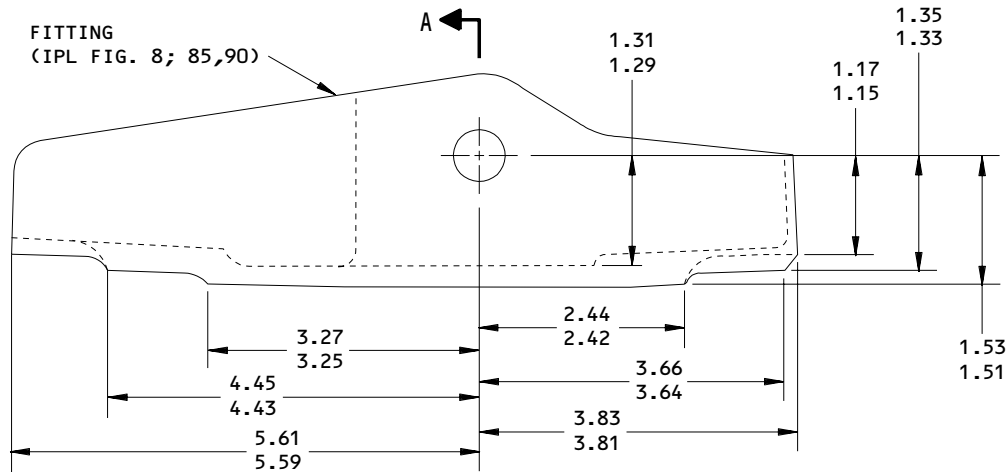
52-32-04

REPAIR 11-2

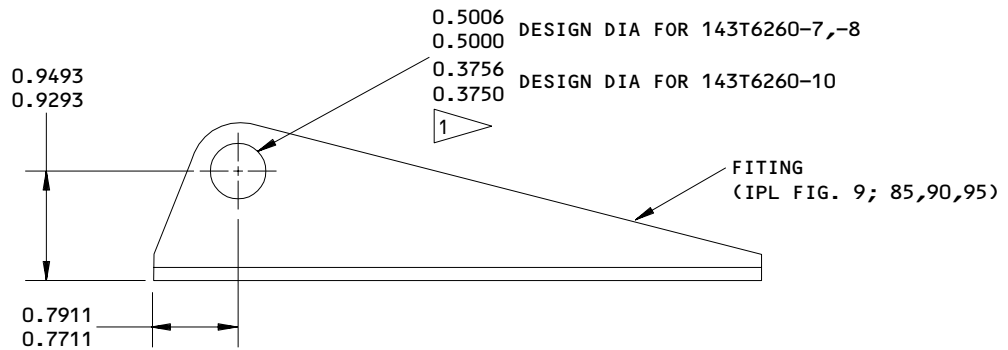
01.1

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143T6260-3 SHOWN
 143T6260-4 OPPOSITE



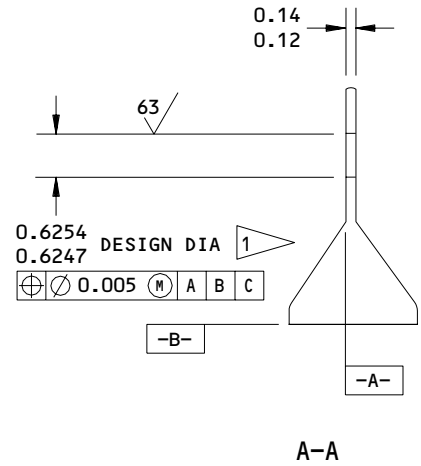
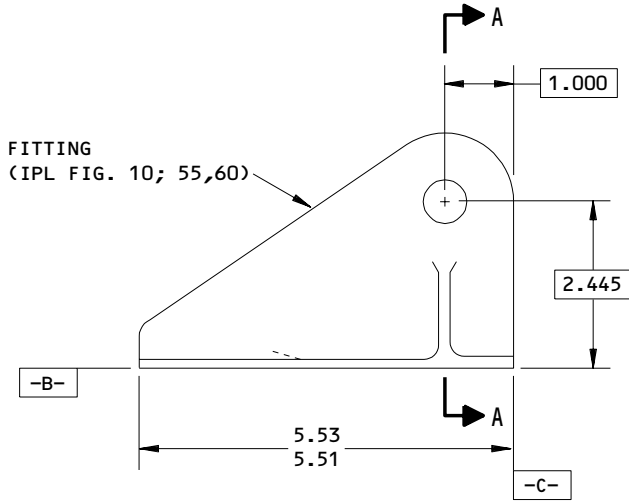
143T6260-7 SHOWN
 143T6260-8,-10 OPPOSITE EXCEPT AS SHOWN

143T6260-3,-4,-7,-8,-10,-11,-12,-17,-18
 Fittings - Bushed Hole Repair
 Figure 601 (Sheet 1)

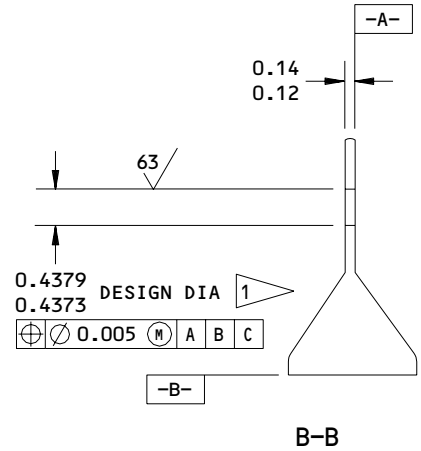
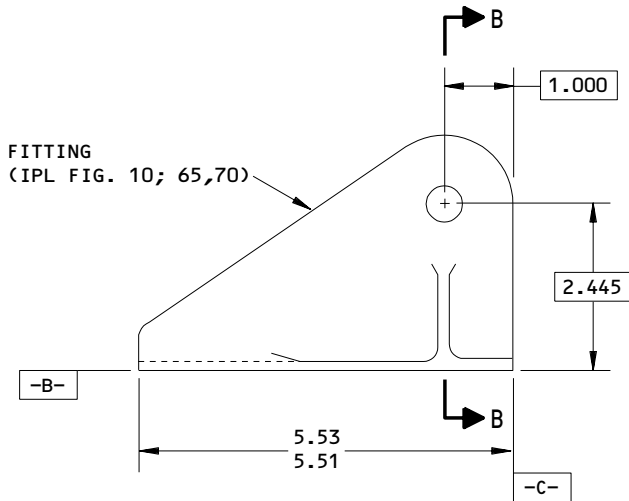
52-32-04

REPAIR 11-2
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01.1



143T6260-11 SHOWN
 143T6260-17 OPPOSITE



143T6260-12 SHOWN
 143T6260-18 OPPOSITE

REFINISH

FITTING (IPT FIG. 8; 85,90) (IPT FIG. 9; 85,90,95) (IPT FIG. 10; 55 THRU 70) -- ANODIZE AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.04) BUT DO NOT PUT PRIMER IN BUSHING BORES.

1 THE REPAIR LIMIT FOR THE INSTALLATION OF AN OVERSIZED BUSHING IS THE MAXIMUM DIAMETER SHOWN PLUS 0.06 INCHES.

REPAIR

REF 1

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: ALUM ALLOY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

143T6260-3,-4,-7,-8,-10,-11,-12,-17,-18
 Fittings - Bushed Hole Repair
 Figure 601 (Sheet 2)

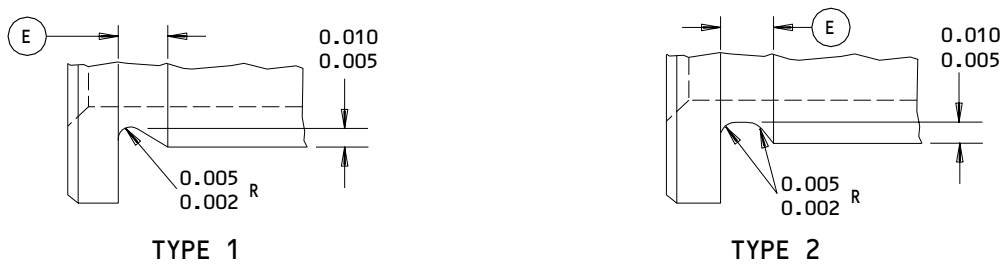
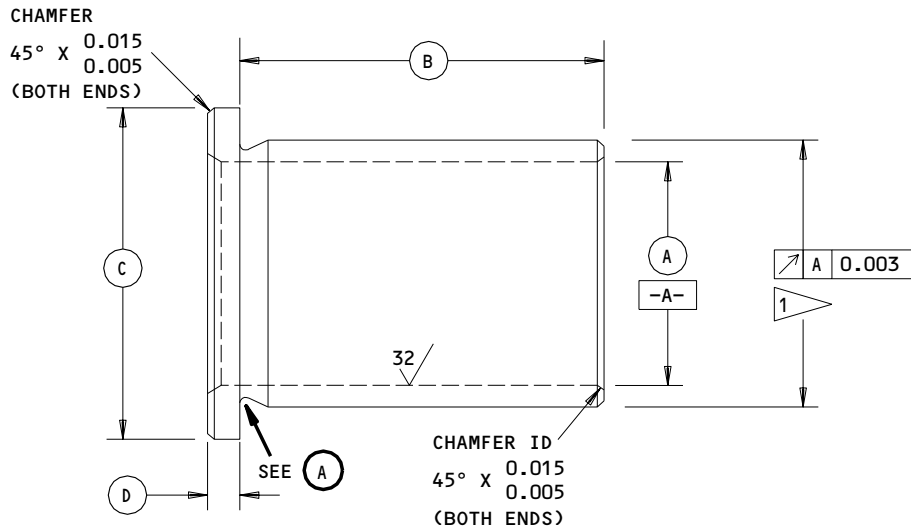
52-32-04

REPAIR 11-2

01.1

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UNDERCUT TYPE 1 OR TYPE 2 OPTIONAL



REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 8; 75,80)
 (IPL FIG. 9; 75,80) (IPL FIG. 10; 45,50)

143T6260-3,-4,-7,-8,-10,-11,-12,-17,-18
 Oversize Bushing Details
 Figure 602 (Sheet 1)

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 REPAIR 11-2
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01.1


BOEING
 COMPONENT
 MAINTENANCE MANUAL

ORIGINAL BUSHING (ITEM NUMBERS)	(A)	(B)	(C)	(D)	(E)	INTERFERENCE
IPL FIG. 8; 75 2	0.5015 0.5000	0.230 0.225	0.760 0.750	0.062 0.057	0.030 0.015	0.0003-0.0018
IPL FIG. 8; 80 2	0.3140 0.3125	0.230 0.225	0.572 0.562	0.062 0.057	0.030 0.015	0.0002-0.0013
IPL FIG. 9; 75 2	0.3765 0.3750	0.140 0.135	0.635 0.625	0.062 0.057	0.030 0.015	0.0003-0.0016
IPL FIG. 9; 80 2	0.2515 0.2500	0.140 0.135	0.510 0.500	0.062 0.057	0.030 0.015	0.0002-0.0013
IPL FIG. 10; 45 2	0.5015 0.5000	0.100 0.095	0.760 0.750	0.062 0.057	0.030 0.015	0.0003-0.0018
IPL FIG. 10; 50 2	0.3140 0.3125	0.100 0.095	0.572 0.562	0.062 0.057	0.030 0.015	0.0002-0.0013

REFINISH

ITEM NUMBERS (IPL FIG. 8; 80), (IPL FIG. 9; 80), (IPL FIG. 10; 50): CADMIUM PLATE (F-15.06). CADMIUM PLATE IN BORE IS OPTIONAL.

ITEM NUMBERS (IPL FIG. 9; 75), (IPL FIG. 10; 45): CADMIUM PLATE (F-15.06) ALL BUT THE BUSHING BORE.

1 FINAL BUSHING OUTSIDE DIAMETER EQUALS THE REPAIR DIAMETER OF THE FITTING PLUS THE INTERFERENCE.

2 DIMENSIONS TO BE MET AFTER PLATING.

REPAIR

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: ITEM NUMBERS (IPL FIG. 8; 80), (IPL FIG. 9; 80), (IPL FIG. 10; 50) 17-4PH CRES, RHc 40-43

ITEM NUMBERS (IPL FIG. 8; 75), (IPL FIG. 9; 75), (IPL FIG. 10; 45) ALUMINUM-NICKEL-BRONZE

ANGULAR TOLERANCE, ±5 DEGREES

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 8; 75,80), (IPL FIG. 9; 75,80), (IPL FIG. 10; 45,50)

143T6260-3,-4,-7,-8,-10,-11,-12,-17,-18
 Oversize Bushing Details
 Figure 602 (Sheet 2)

52-32-04

REPAIR 11-2

01.1

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MIDSPAN IDLER ASSEMBLY – REPAIR 12-1

143T6295-1, -3

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (213, 216, IPL Fig. 2)

- A. Remove bushings.
- B. Install bushings as specified in 20-50-03 with BMS 5-95 sealant.
- C. Fillet seal around periphery of bushing flanges with BMS 5-95 sealant.

2. Bearing Replacement (219)

- A. Remove bearings.
- B. Install bearings and roller swage housing over bearings as specified in 20-50-03.

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REPAIR 12-1

01.1

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IDLER - REPAIR 12-2

143T6295-2, -4

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices, and to IPL Fig. 2 for item numbers. For the repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 12-1.

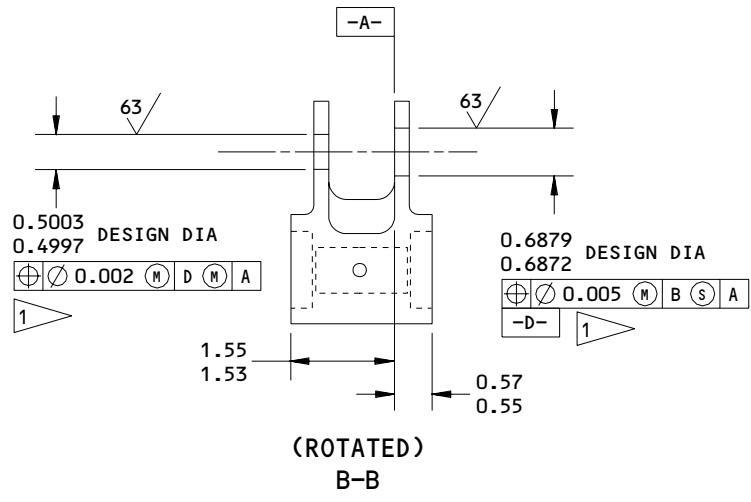
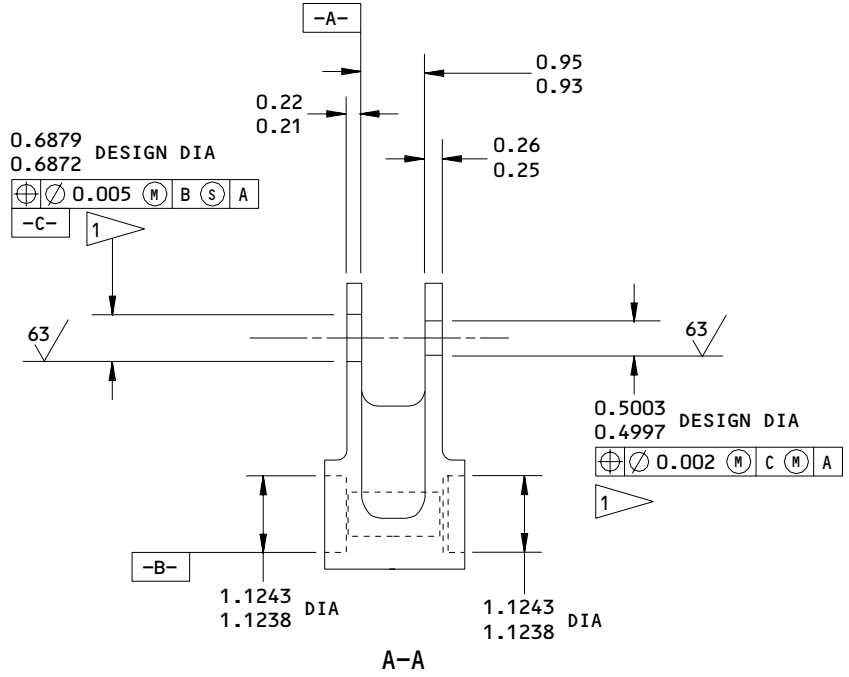
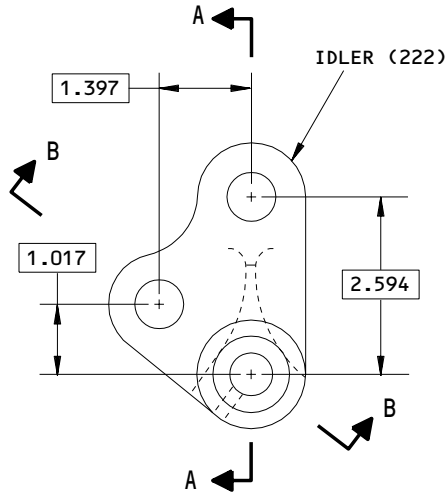
52-32-04

REPAIR 12-2

01.1

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143T6295-2

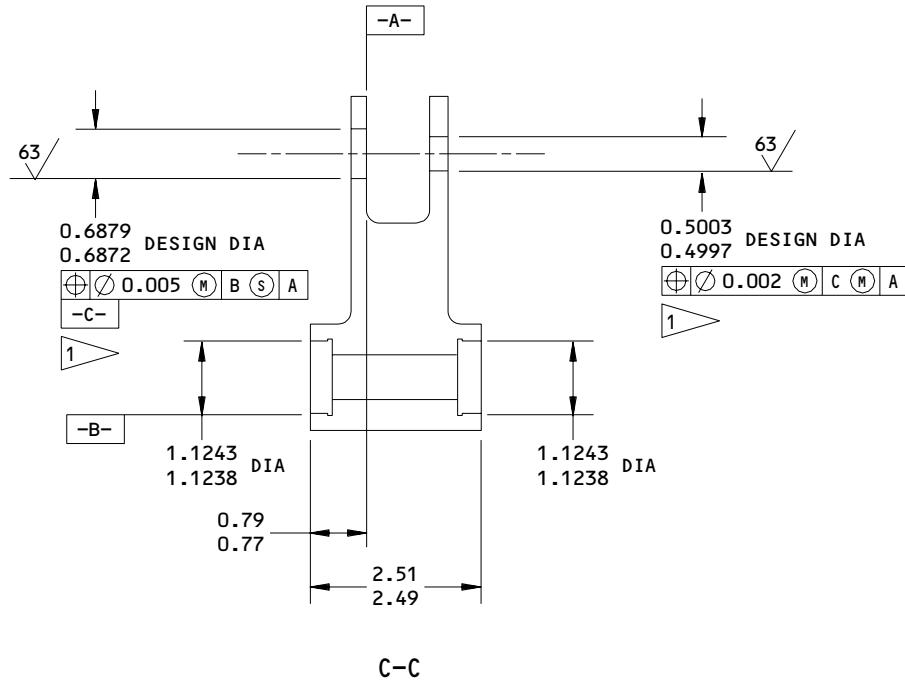
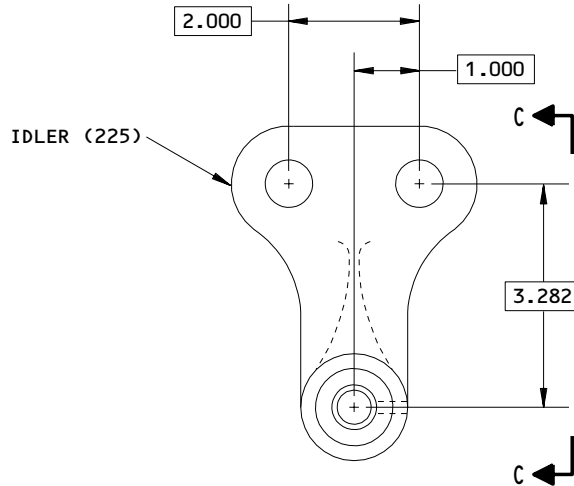
143T6295-2,-4
 Idler - Bushed Hole Repair
 Figure 601 (Sheet 1)

52-32-04

REPAIR 12-2
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01.1

BOEING
 COMPONENT
 MAINTENANCE MANUAL



143T6295-4

REFINISH

IDLER (222,225) -- ANODIZE AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.04) ALL OVER BUT DO NOT PUT PRIMER IN BUSHING BORES.

1 THE REPAIR LIMIT FOR THE INSTALLATION OF AN OVERSIZED BUSHING IS THE MAXIMUM DESIGN DIAMETER SHOWN PLUS 0.06 INCHES.

REPAIR

REF 1
 125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: ALUM ALLOY
 BREAK ALL SHARP EDGES
 ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG. 2

143T6295-2,-4
 Idler - Bushed Hole Repair
 Figure 601 (Sheet 2)

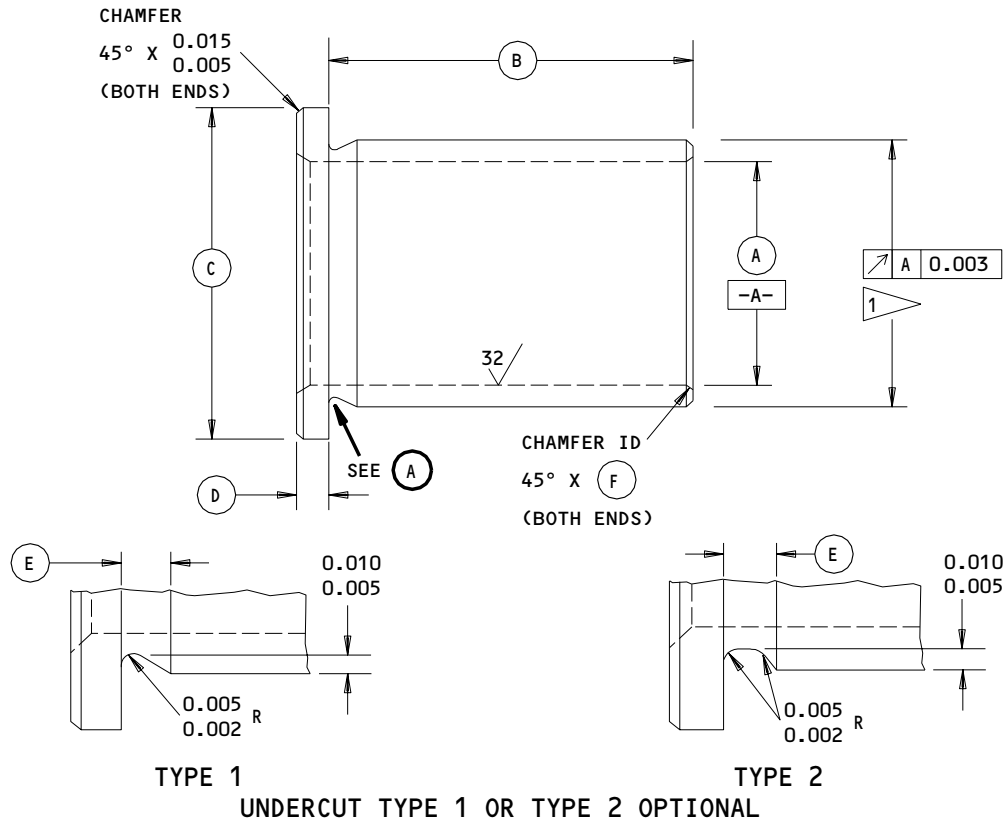
52-32-04

REPAIR 12-2

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01.1



(A)

ORIGINAL BUSHING (ITEM NUMBERS)	(A)	(B)	(C)	(D)	(E)	(F)	INTERFERENCE
213	0.5640 0.5625	0.200 0.195	0.822 0.812	0.062 0.057	0.030 0.015	0.020 0.010	0.0003-0.0020
216	0.3765 0.3750	0.240 0.235	0.635 0.625	0.062 0.057	0.030 0.015	0.015 0.005	0.0003-0.0016

REFINISH

ITEM NUMBER 213: CADMIUM PLATE (F-15.06)
 ALL BUT THE BUSHING BORE.

ITEM NUMBER 216: CADMIUM PLATE (F-15.06).
 CADMIUM PLATE IN BORE IS OPTIONAL.

FINAL BUSHING OUTSIDE DIAMETER EQUALS THE REPAIR DIAMETER OF THE IDLER PLUS THE INTERFERENCE.

DIMENSIONS TO BE MET AFTER PLATING.

REPAIR

ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: (ITEM NUMBER 213) ALUMIUM-NICKEL-BRONZE
 (ITEM NUMBER 216) 17-4PH CRES,
 R_{Hc} 40-43

ANGULAR TOLERANCE, ±5 DEGREES

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 2

REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 2; 213,216)

143T6295-2,-4
 Oversize Bushing Details
 Figure 602

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REPAIR 12-2

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01.1

LATCH CAM - REPAIR 13-1

143T6401-3, -4

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

1. Repair Damage to the 1.4985-1.4990 Inch Design Diameter of the Latch Cam (360, 363, IPL Fig. 2) as follows:

- A. Remove chrome plate from the 1.4985-1.4990 inch design diameter of the latch cam (see Fig. 601).
- B. Machine the 1.4985-1.4990 inch design diameter as specified in 20-10-01 as necessary to a minimum diameter of 1.4840 inch to remove damage. The latch cam is acceptable if the outside diameter is more than 1.4840 inch before plating.
- C. Magnetic particle check the repaired area as specified in 20-20-01, critical class A.
- D. Shot peen the repaired surfaces as specified in 20-10-03; shot number 170-390, intensity 0.016A, coverage 2.0.
- E. Apply chrome plate and final finishes as specified in Fig. 601.

2. Repair Damage to the Throat of the Latch Cam (360, 363, IPL Fig. 2) as follows:

- A. Remove chrome plate from the throat (1.22-1.23 inch design diameter) of the latch cam (Fig. 601).
- B. Machine the throat as specified in 20-10-01 as necessary to a maximum diameter of 1.2500 inch to remove damage. The latch cam is not repairable if the throat diameter is more than 1.2500 inch before plating.
- C. Magnetic particle check the repaired area as specified in 20-20-01, critical class A.
- D. Shot peen the repaired surfaces as specified in 20-10-03; shot number 170-390, intensity 0.016A, coverage 2.0.
- E. Apply chrome plate and final finishes as specified in Fig. 601.

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REPAIR 13-1

01.1

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3. Refinish

- A. Latch cam (360, 363) -- Refinish the latch cam as shown in Fig. 601.
Material: HP9NI-4C0-0.30C alloy steel, 220 ksi minimum.

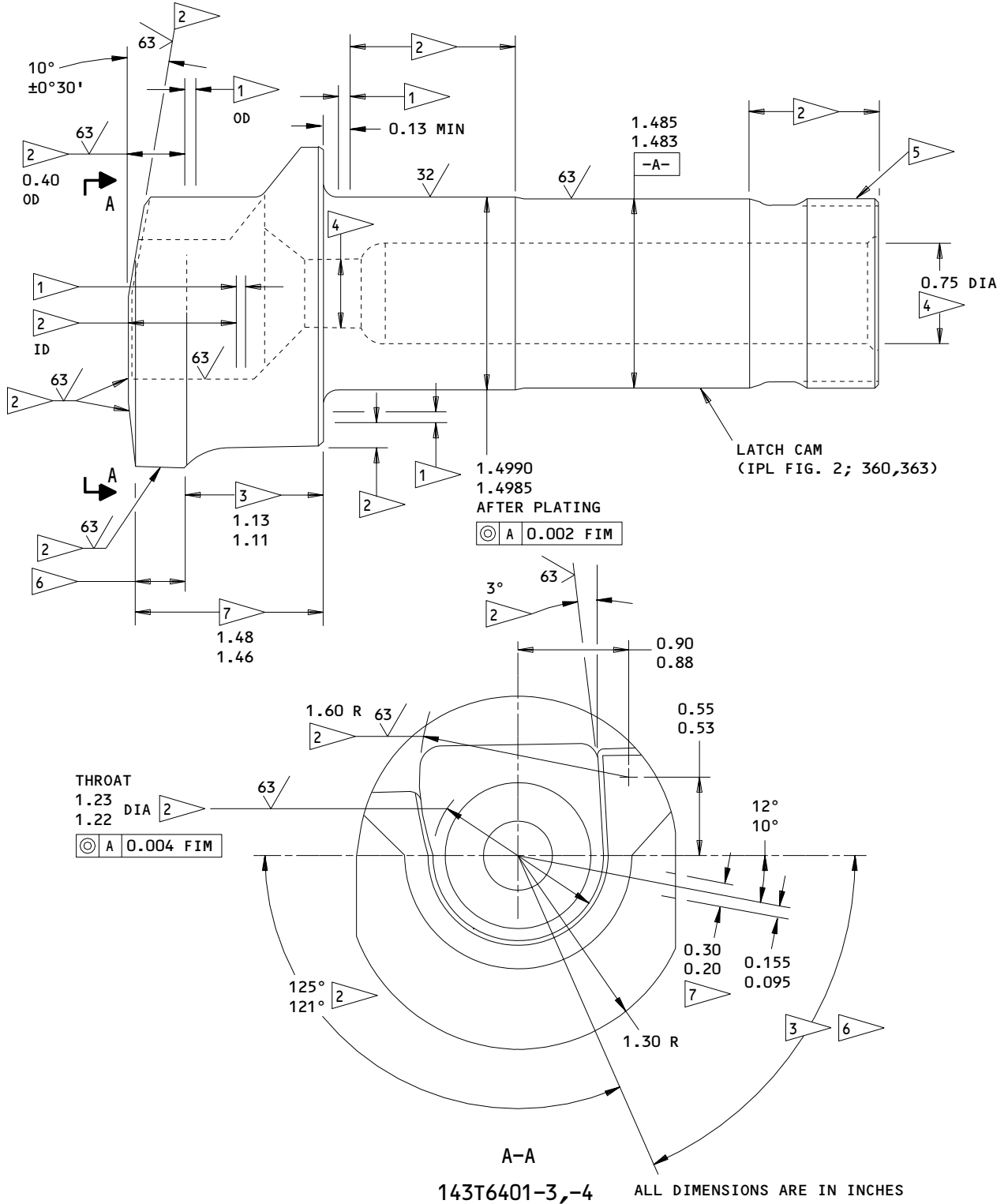
52-32-04

REPAIR 13-1

01.1

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Latch Cam Refinish
Figure 601 (Sheet 1)

52-32-04








REPAIR 13-1




01.1





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REFINISH

CADMIUM-TITANIUM ALLOY PLATE, BAKE 12 HOURS MINIMUM AT 350-400°F, AND APPLY POST-PLATE TREATMENT AS SPECIFIED IN SOPM 20-42-02 (F-15.01); APPLY TWO COATS BMS 10-11, TYPE 1 PRIMER (F-20.03) UNLESS SPECIFIED DIFFERENTLY IN , , , , ,  AND 

-  0.00-0.08 CHROMIUM PLATE RUNOUT AREA
-  CHROME PLATE AND BAKE AS SPECIFIED IN SOPM 20-42-03 (F-15.04); SINGLE PLATE THICKNESS TO BE 0.003 MINIMUM, 0.005 MAXIMUM, AFTER GRINDING AS SPECIFIED IN SOPM 20-10-04. APPLY SOLID FILM LUBRICANT BMS 3-8 AS SPECIFIED IN SOPM 20-50-08
-  CADMIUM-TITANIUM ALLOY PLATE, BAKE 12 HOURS MINIMUM AT 350-400°F, AND APPLY POST-PLATE TREATMENT AS SPECIFIED IN SOPM 20-42-02 (F-15.01); APPLY TWO COATS BMS 10-11, TYPE 1 PRIMER (F-20.03) PLUS ONE COAT BMS 10-11, TYPE 2 ENAMEL, BAC702 WHITE GLOSS (F-21.03)

-  CADMIUM-TITANIUM ALLOY PLATE AND BAKE 12 HOURS MINIMUM AT 350 TO 400°F AS SPECIFIED SOPM 20-42-02, EXCEPT APPLY PHOSPHATE TREATMENT (F-16.05). APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER (F-20.02). FILL AND DRAIN USING MIL-C-16173, GRADE 3, CORROSION PREVENTIVE COMPOUND
-  OMIT PRIMER FROM SPLINES
-  OMIT SOLID FILM LUBRICANT FROM THIS AREA OF OUTSIDE DIAMETER (1.30R)
-  APPLY ONE COAT BMS 10-11, TYPE 2 ENAMEL, BAC4533 APPLE GREEN GLOSS, TO THE LENGTH AND WIDTH SHOWN (SRF-14.905-4533).

Latch Cam Refinish
Figure 601 (Sheet 2)

F23942

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REPAIR 13-1

01.1

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BELLCRANK ASSEMBLY – REPAIR 14-1

143T6402-1

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (645, 648, IPL Fig. 2)

- A. Remove bushings.
- B. Install bushings as specified in 20-50-03 with BMS 5-95 sealant.
- C. Fillet seal around periphery of bushing flanges with BMS 5-95 sealant.

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REPAIR 14-1

01.1

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BELLCRANK – REPAIR 14-2

143T6402-2

NOTE: Refer to REPAIR – GENERAL for a list of applicable standard practices, and to IPL Fig. 2 for item numbers. For the repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 14-1.

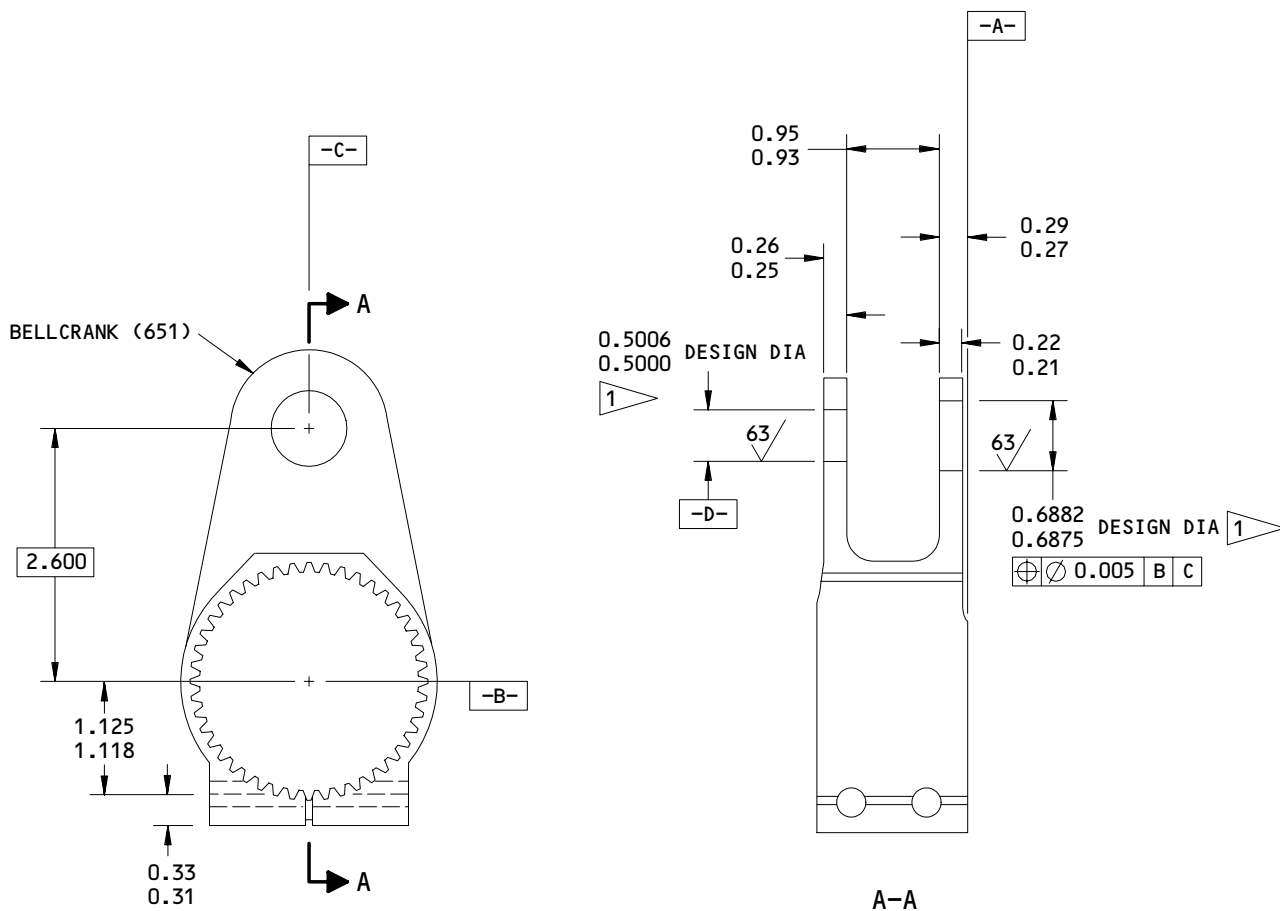
52-32-04

REPAIR 14-2

01.1

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REFINISH

BELLCRANK (651) -- CHROMIC ACID ANODIZE;
 APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER
 (F-18.13). APPLY ONE COAT OF BMS 10-11, TYPE 2
 ENAMEL, BAC 702 WHITE GLOSS (SRF-14.905.702)
 ALL OVER, BUT DO NOT PUT PRIMER OR ENAMEL ON
 SPLINES, BOLT HOLES, AND BUSHING BORES

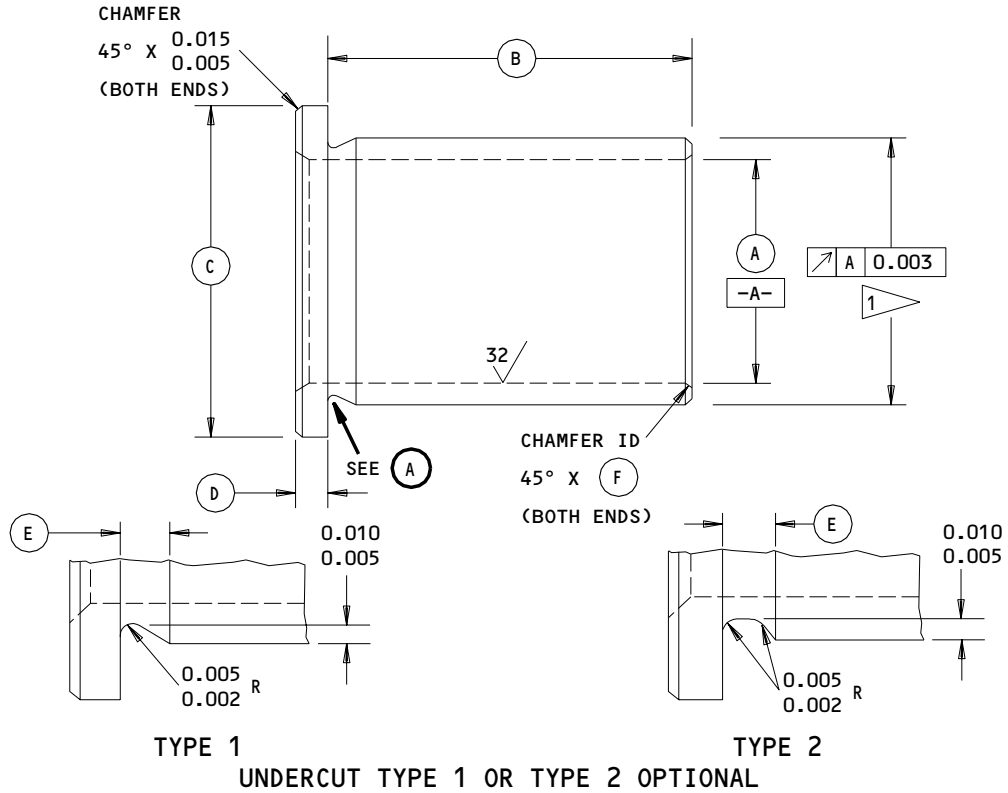
REF 1 THE REPAIR LIMITS FOR THE INSTALLATION OF
 OVERSIZED BUSHINGS ARE THE MAXIMUM
 DESIGN DIAMETERS SHOWN PLUS 0.06 INCH.

REPAIR

REF 1
 125 ALL MACHINED SURFACES UNLESS SHOWN
 DIFFERENTLY
 MATERIAL: ALUMINUM ALLOY
 BREAK ALL SHARP EDGES
 ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG. 2

143T6402-2
 Bellcrank - Bushed Hole Repair
 Figure 601

BOEING
COMPONENT
MAINTENANCE MANUAL



(A)

ORIGINAL BUSHING (ITEM NUMBERS)	(A)	(B)	(C)	(D)	(E)	(F)	INTERFERENCE
645 ∇ 2	0.3765 0.3750	0.240 0.235	0.635 0.625	0.062 0.057	0.030 0.015	0.015 0.005	0.0003-0.0016
648 ∇ 2	0.5640 0.5625	0.200 0.195	0.822 0.812	0.062 0.057	0.030 0.015	0.020 0.010	0.0003-0.0020

REFINISH

ITEM NUMBER 645: CADMIUM PLATE (F-15.06).
 CADMIUM PLATE IN BORE IS OPTIONAL

ITEM NUMBER 648: CADMIUM PLATE (F-15-06) ALL
 BUT THE BUSHING BORE

1 ∇ FINAL BUSHING OUTSIDE DIAMETER EQUALS THE
 REPAIR DIAMETER OF THE BELLCRANK PLUS THE
 INTERFERENCE.

2 ∇ DIMENSIONS TO BE MET AFTER PLATING

REPAIR

63 ∇ ALL MACHINED SURFACES UNLESS SHOWN
 DIFFERENTLY

MATERIAL: (ITEM NUMBER 645) 17-4 PH CRES,
 RHc 40-43

(ITEM NUMBER 648) ALUMINUM-NICKEL-
 BRONZE

ANGULAR TOLERANCE, ±5 DEGREES

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 2

REPLACEMENT BUSHINGS FOR BUSHINGS (645,648, IPL FIG. 2)

143T6402-2
 Oversize Bushing Details
 Figure 602

52-32-04

REPAIR 14-2

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01.1



PULL-IN HOOK BELLCRANK ASSEMBLY – REPAIR 15-1

143T6411-3

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (435, 438, IPL Fig. 2)

- A. Remove bushings.
- B. Install bushings as specified in 20-50-03 with wet BMS 3-24 grease.

52-32-04

REPAIR 15-1

01.1

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BELLCRANK – REPAIR 15-2

143T6411-4

NOTE: Refer to REPAIR – GENERAL for the list of applicable standard practices, and to IPL Fig. 2 for the item numbers. For the repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 15-1.

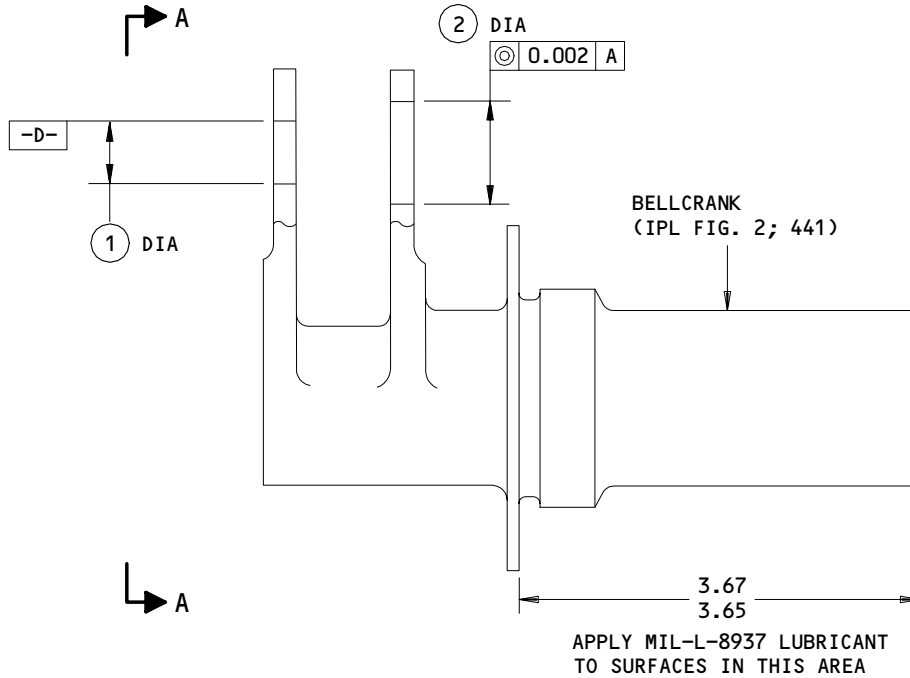
52-32-04


REPAIR 15-2

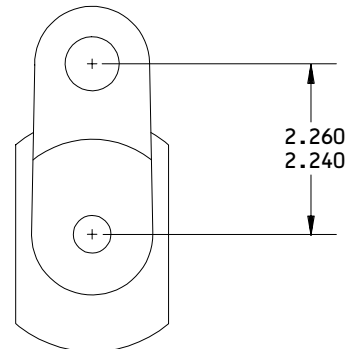
01.1

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
	①	②
DESIGN DIMENSION	0.6256 0.6250	0.8757 0.9357
REPAIR LIMIT 	0.6856	0.9357




A-A

REFINISH

PASSIVATE (F-17.09). APPLY MIL-L-8937 DRY FILM LUBRICANT AS SPECIFIED IN 20-50-08, TYPE 6, TO THE AREA SHOWN.

 REPAIR LIMIT FOR INSTALLATION OF OVERSIZED BUSHINGS

REPAIR

REF 

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: 15-5PH STAINLESS STEEL;
180-200 KSI

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

143T6411-4
 Bellcrank - Bushed Hole Repair
 Figure 601

52-32-04

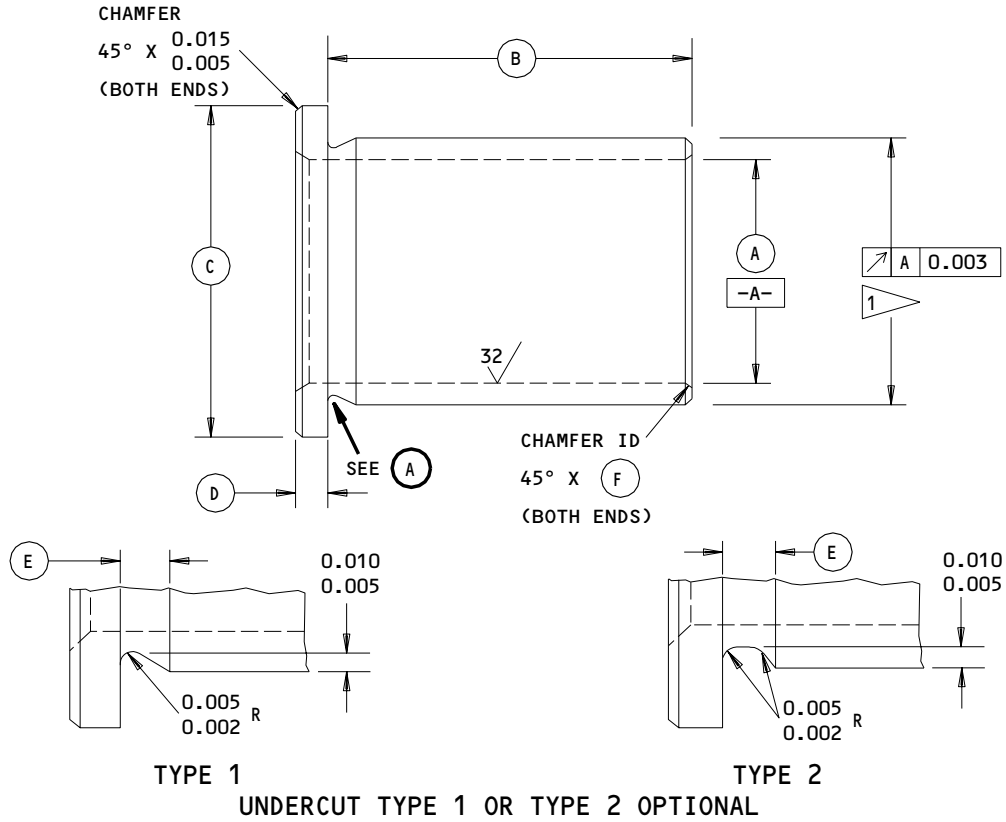
REPAIR 15-2

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01.1

BOEING
COMPONENT
MAINTENANCE MANUAL



(A)

ORIGINAL BUSHING (ITEM NUMBERS)	(A)	(B)	(C)	(D)	(E)	(F)	INTERFERENCE
435 ∇	0.5015 0.5000	0.190 0.185	0.760 0.750	0.062 0.057	0.030 0.015	0.015 0.005	0.0002-0.0017
438 ∇	0.6890 0.6875	0.190 0.185	1.072 1.062	0.062 0.057	0.030 0.015	0.020 0.010	0.0002-0.0020

REFINISH

ITEM NUMBER 435: CADMIUM PLATE (F-15.06).
 CADMIUM PLATE IN BORE IS OPTIONAL.

ITEM NUMBER 438: CADMIUM PLATE (F-15.06)
 ALL BUT THE BUSHING BORE.

∇ FINAL BUSHING OUTSIDE DIAMETER EQUALS THE
 REPAIR DIAMETER OF THE IDLER PLUS THE
 INTERFERENCE.

∇ DIMENSIONS TO BE MET AFTER PLATING.

REPAIR

∇ ALL MACHINED SURFACES UNLESS SHOWN
 DIFFERENTLY

MATERIAL: (ITEM NUMBER 435) 17-4PH CRES,
 RHc 40-43
 (ITEM NUMBER 438) ALUMIUM-NICKEL-
 BRONZE

ANGULAR TOLERANCE, ± 5 DEGREES

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 2

REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 2; 435,438)

143T6411-4
 Oversize Bushing Details
 Figure 602

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REPAIR 15-2

01.1

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LOWER LATCH IDLER ASSEMBLY – REPAIR 16-1

143T6414-11, -12

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (324, 327, IPL Fig. 2)

- A. Remove bushings.
- B. Install bushings as specified in 20-50-03 with wet BMS 10-11 primer.
- C. Fillet seal around the periphery of the bushing flanges with BMS 5-95 sealant.

2. Bearing Replacement (321)

- A. Remove bearings.
- B. Install bearings and roller swage housing over bearings as specified in 20-50-03. Roller groove depth: 0.005/0.009.

3. Refinish

- A. Idlers (330, 333) -- Chromic acid anodize; apply one coat BMS 10-11, type 1 primer (F-18.13) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (SRF-14.905-702) all over but do not put primer and enamel in bushing and bearing bores. Material: Alum alloy.

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REPAIR 16-1

01.1

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IDLER - REPAIR 16-2

143T6414-3, -4, -9, -10

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices, and to IPL Fig. 2 for the item numbers. For the repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 16-1.

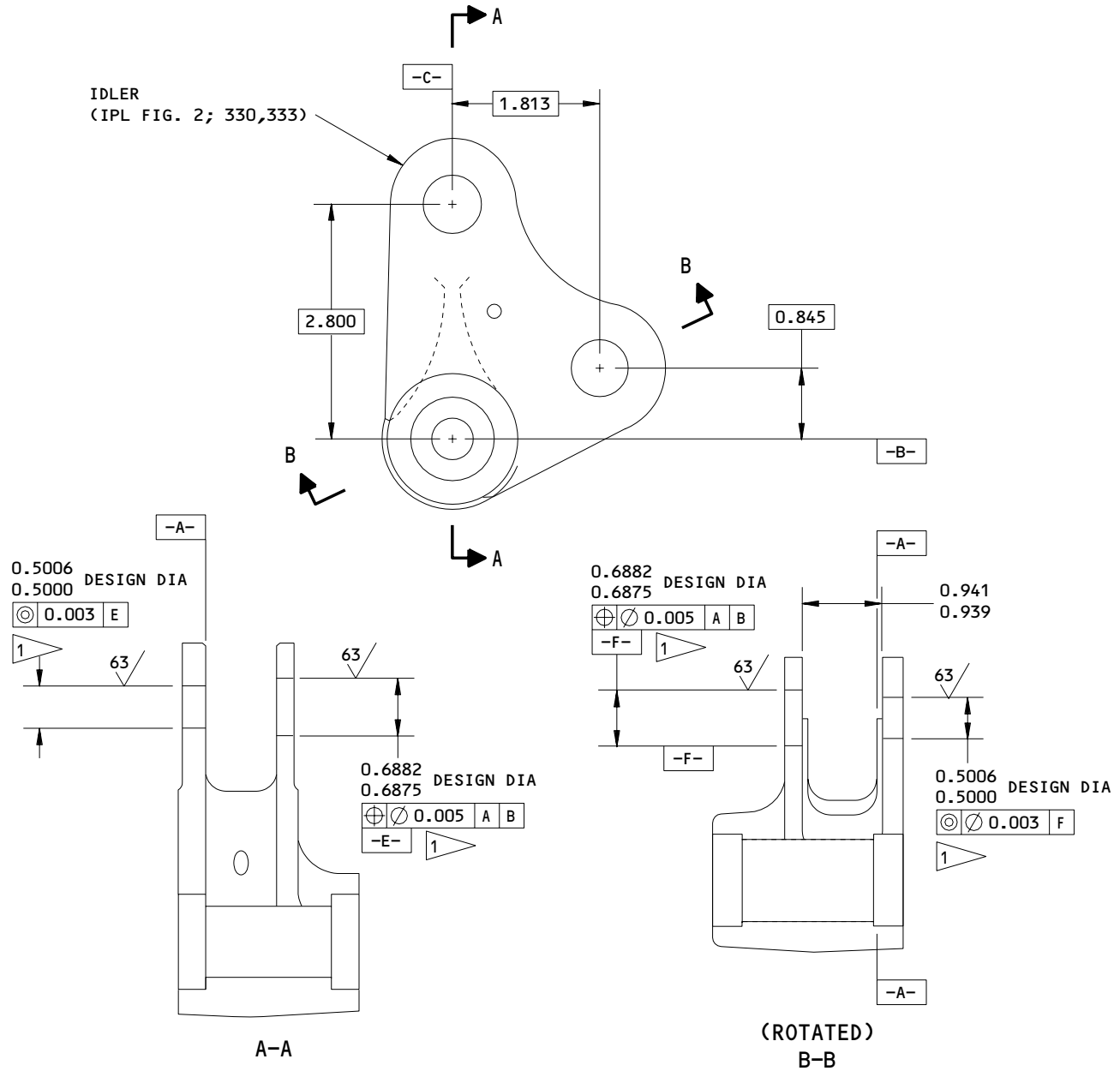
52-32-04

REPAIR 16-2

01.1

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REFINISH

IDLER (330,333) -- CHROMIC ACID ANODIZE;
 APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER
 (F-18.13) PLUS ONE COAT BMS 10-11, TYPE 2
 ENAMEL, BAC702 WHITE GLOSS (SRF-14.905-702)
 ALL OVER, BUT DO NOT PUT PRIMER AND ENAMEL
 IN BUSHING AND BEARING BORES.

1 THE REPAIR LIMIT FOR THE INSTALLATION
 OF OVERSIZED BUSHINGS IS THE MAXIMUM
 DESIGN DIAMETER SHOWN PLUS 0.06 INCHES.

REPAIR

REF 1
 125 ALL MACHINED SURFACES UNLESS SHOWN
 DIFFERENTLY
 MATERIAL: ALUM ALLOY
 BREAK ALL SHARP EDGES
 ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG. 2

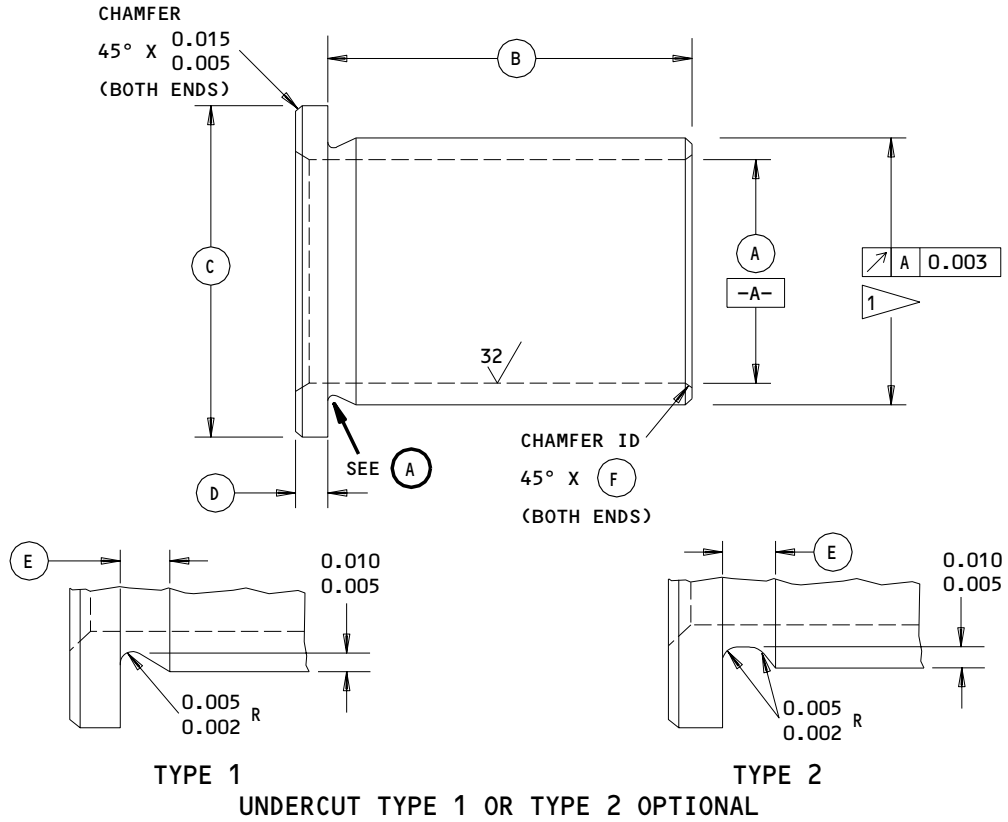
143T6414-3,-4,-9,-10
 Idler - Bushed Hole Repair
 Figure 601

52-32-04

REPAIR 16-2
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01.1

BOEING
COMPONENT
MAINTENANCE MANUAL



ORIGINAL BUSHING (ITEM NUMBERS)	A	B	C	D	E	F	INTERFERENCE
324	0.3765 0.3750	0.240 0.235	0.635 0.625	0.062 0.057	0.030 0.015	0.015 0.005	0.0002-0.0015
327	0.5640 0.5625	0.200 0.195	0.822 0.812	0.062 0.057	0.030 0.015	0.020 0.010	0.0002-0.0019

REFINISH

ITEM NUMBER 324: CADMIUM PLATE (F-15.06).
 CADMIUM PLATE IN BORE IS OPTIONAL.

ITEM NUMBER 327: CADMIUM PLATE (F-15.06)
 ALL BUT THE BUSHING BORE.

FINAL BUSHING OUTSIDE DIAMETER EQUALS THE REPAIR DIAMETER OF THE IDLER PLUS THE INTERFERENCE.

DIMENSIONS TO BE MET AFTER PLATING.

REPAIR

ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: (ITEM NUMBER 324) 17-4PH CRES,
 RHc 40-43
 (ITEM NUMBER 327) ALUMIUM-NICKEL-BRONZE

ANGULAR TOLERANCE, ±5 DEGREES

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 2

REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 2; 324,327)

143T6414-3,-4,-9,-10
 Oversize Bushing Details
 Figure 602

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REPAIR 16-2

01.1

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MIDSPAN LATCH BELLCRANK ASSMEBLY - REPAIR 17-1

143T6418-16

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

1. Bushing Replacement (108, 111, IPL Fig. 2)

- A. Remove bushings.
- B. Install bushings as specified in 20-50-03 with wet BMS 10-11, type 1 primer.

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REPAIR 17-1

01.1

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BELLCRANK - REPAIR 17-2

143T6418-18

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices, and to IPL Fig. 2 for item numbers. For the repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 17-1.

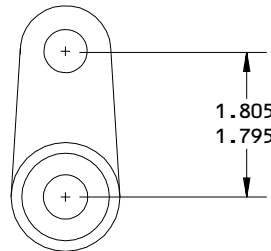
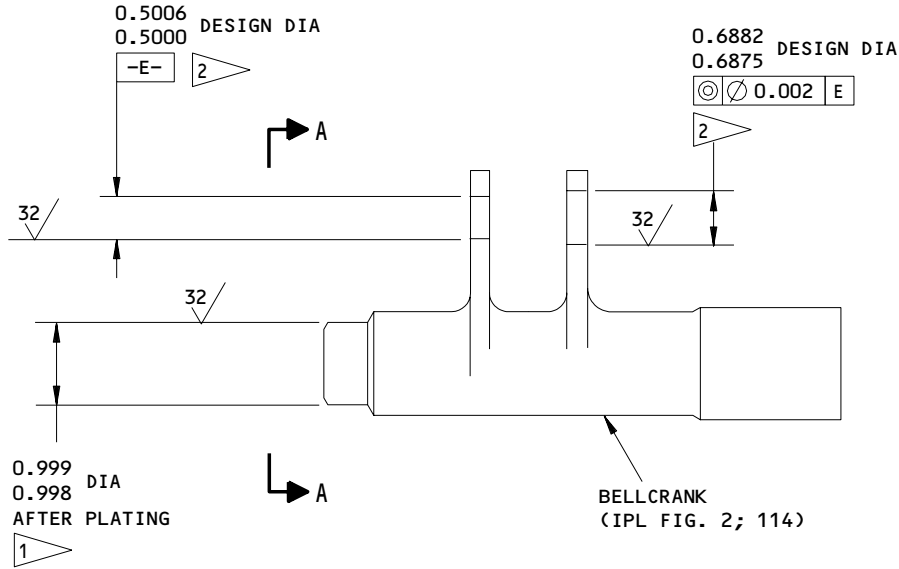
52-32-04

REPAIR 17-2

01.1

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A-A

REFINISH

BELLCRANK (114) - - PASSIVATE (F-17.09).
 CADMIUM PLATE AS SPECIFIED IN 20-42-05,
 TYPE 2, CLASS 2 (F-15.06) THE AREA SHOWN.

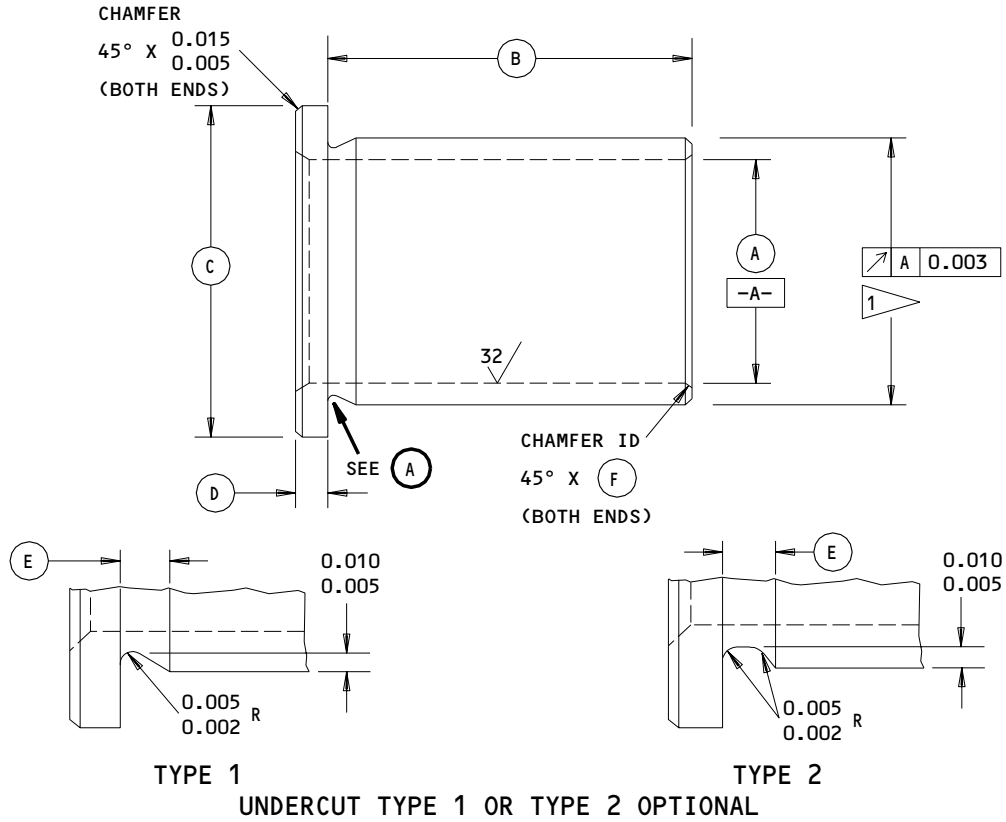
- 1 CADMIUM PLATE THIS DIAMETER
- 2 THE REPAIR LIMIT FOR THE INSTALLATION OF OVERSIZED BUSHINGS IS THE MAXIMUM DESIGN DIAMETER SHOWN PLUS 0.06 INCHES.

REPAIR

REF 1 2
 125 ALL MACHINED SURFACES UNLESS SHOWN
 DIFFERENTLY
 MATERIAL: 15-5PH CRES, 180-200 KSI
 BREAK ALL SHARP EDGES
 ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG. 2

143T6418-18
 Bellcrank - Bushed Hole Repair
 Figure 601

BOEING
COMPONENT
MAINTENANCE MANUAL



(A)

ORIGINAL BUSHING (ITEM NUMBERS)	(A)	(B)	(C)	(D)	(E)	(F)	INTERFERENCE
108	0.3765 0.3750	0.240 0.235	0.635 0.625	0.062 0.057	0.030 0.015	0.015 0.005	0.0003-0.0016
111	0.5640 0.5625	0.240 0.235	0.822 0.812	0.062 0.057	0.030 0.015	0.020 0.010	0.0003-0.0020

REFINISH

ITEM NUMBER 108: CADMIUM PLATE (F-15.06). CADMIUM PLATE IN BORE IS OPTIONAL.

ITEM NUMBER 111: CADMIUM PLATE (F-15.06) ALL BUT THE BUSHING BORE.

FINAL BUSHING OUTSIDE DIAMETER EQUALS THE REPAIR DIAMETER OF THE BELLCRANK PLUS THE INTERFERENCE.

DIMENSIONS TO BE MET AFTER PLATING.

REPAIR

ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: (ITEM NUMBER 108) 17-4PH CRES, RHc 40-43
 (ITEM NUMBER 111) ALUMIUM-NICKEL-BRONZE

ANGULAR TOLERANCE, ±5 DEGREES

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 2

REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 2; 108,111)

143T6418-18
 Oversize Bushing Details
 Figure 602

52-32-04

REPAIR 17-2

01.1

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LATCH LOCK DRIVE BELLCRANK ASSEMBLY – REPAIR 18-1

143T6446-1

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (655, 660, IPL Fig. 3)

- A. Remove bushings.
- B. Install bushings as specified in 20-50-03 with wet BMS 5-95 sealant.
- C. Fillet seal around periphery of bushing flanges with BMS 5-95 sealant.

52-32-04

REPAIR 18-1

01.1

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BELLCRANK – REPAIR 18-2

143T6446-2

NOTE: Refer to REPAIR – GENERAL for a list of applicable standard practices, and to IPL Fig. 3 for item numbers. For the repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 18-1.

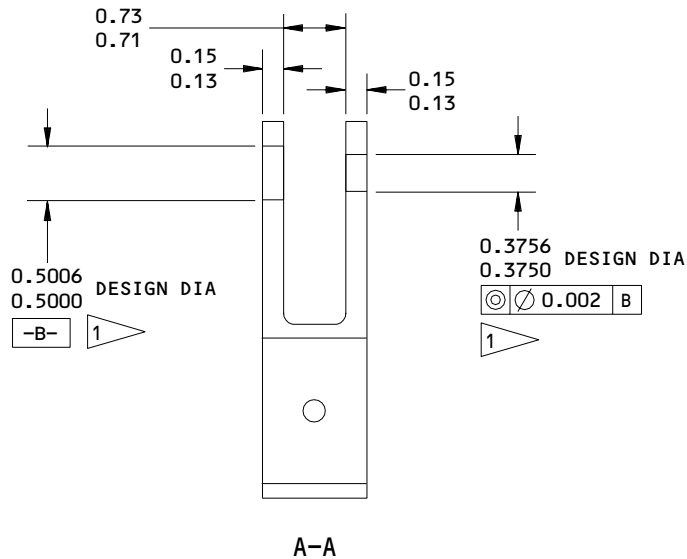
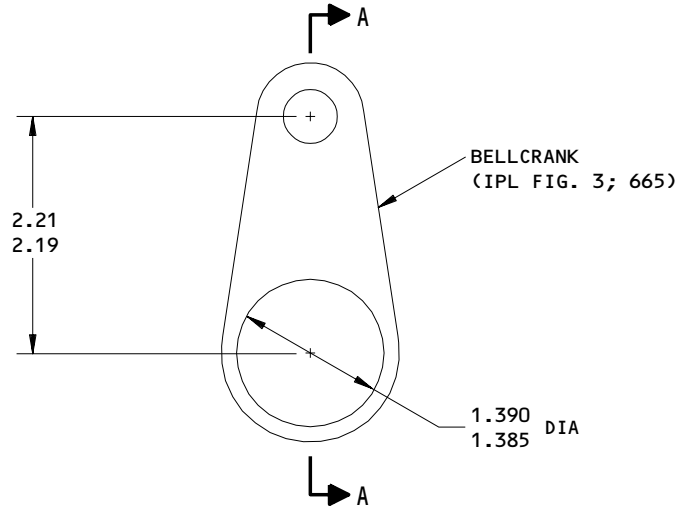
52-32-04

REPAIR 18-2

01.1

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REFINISH

BELLCRANKS (665) -- CHROMIC ACID ANODIZE (F-17.04). APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER (F-20.02) PLUS ONE COAT BMS-10-11, TYPE 2 ENAMEL, BAC702 WHITE GLOSS (SRF-14.905-702) ALL OVER, BUT DO NOT PUT PRIMER AND ENAMEL IN BUSHING BORES. ALSO, DO NOT PUT ENAMEL IN THE 1.39 INCH DIAMETER HOLE.

1 THE REPAIR LIMIT FOR THE INSTALLATION OF AN OVERSIZED BUSHING IS THE MAXIMUM DESIGN DIAMETER SHOWN PLUS 0.06 INCHES.

REPAIR

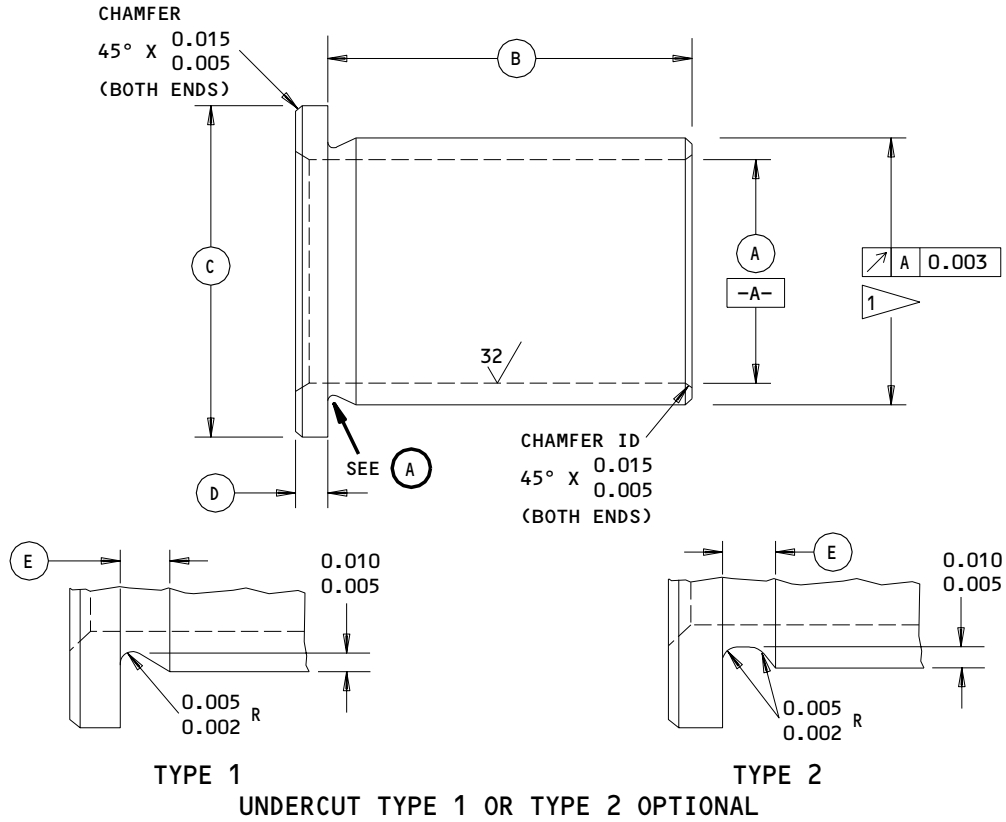
REF 1
 125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: ALUM ALLOY
 BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG. 3

143T6446-2
 Bellcrank - Bushed Hole Repair
 Figure 601

BOEING
COMPONENT
MAINTENANCE MANUAL



(A)

ORIGINAL BUSHING (ITEM NUMBERS)	(A)	(B)	(C)	(D)	(E)	INTERFERENCE
655	0.3765 0.3750	0.120 0.115	0.635 0.625	0.062 0.057	0.030 0.015	0.0003-0.0016
660	0.2515 0.2500	0.120 0.115	0.510 0.500	0.062 0.057	0.030 0.015	0.0002-0.0013

REFINISH

ITEM NUMBER 655: CADMIUM PLATE (F-15.06)
 ALL BUT THE BUSHING BORE

ITEM NUMBER 660: CADMIUM PLATE (F-15.06).
 CADMIUM PLATE IN BORE IS OPTIONAL.

FINAL BUSHING OUTSIDE DIAMETER EQUALS THE REPAIR DIAMETER OF THE BELLCRANK PLUS THE INTERFERENCE.

DIMENSIONS TO BE MET AFTER PLATING.

REPAIR

ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: (ITEM NUMBER 660) 17-4PH CRES, RHc 40-43
 (ITEM NUMBER 655) ALUMIUM-NICKEL-BRONZE

ANGULAR TOLERANCE, ±5 DEGREES

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 3

REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 3; 655,660)

143T6446-2
 Oversize Bushing Details
 Figure 602

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REPAIR 18-2

01.1

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LOWER LATCH BELLCRANK ASSEMBLY – REPAIR 19-1

143T6492-1, -2

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (372, 375, IPL Fig. 2)

- A. Remove bushings.
- B. Install bushings by shrink fit as specified in 20-50-03 with BMS 5-95 sealant.

52-32-04

REPAIR 19-1

01.1

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BELLCRANK - REPAIR 19-2

143T6492-3, -4

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices, and to IPL Fig. 2 for item numbers. For the repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 19-1.

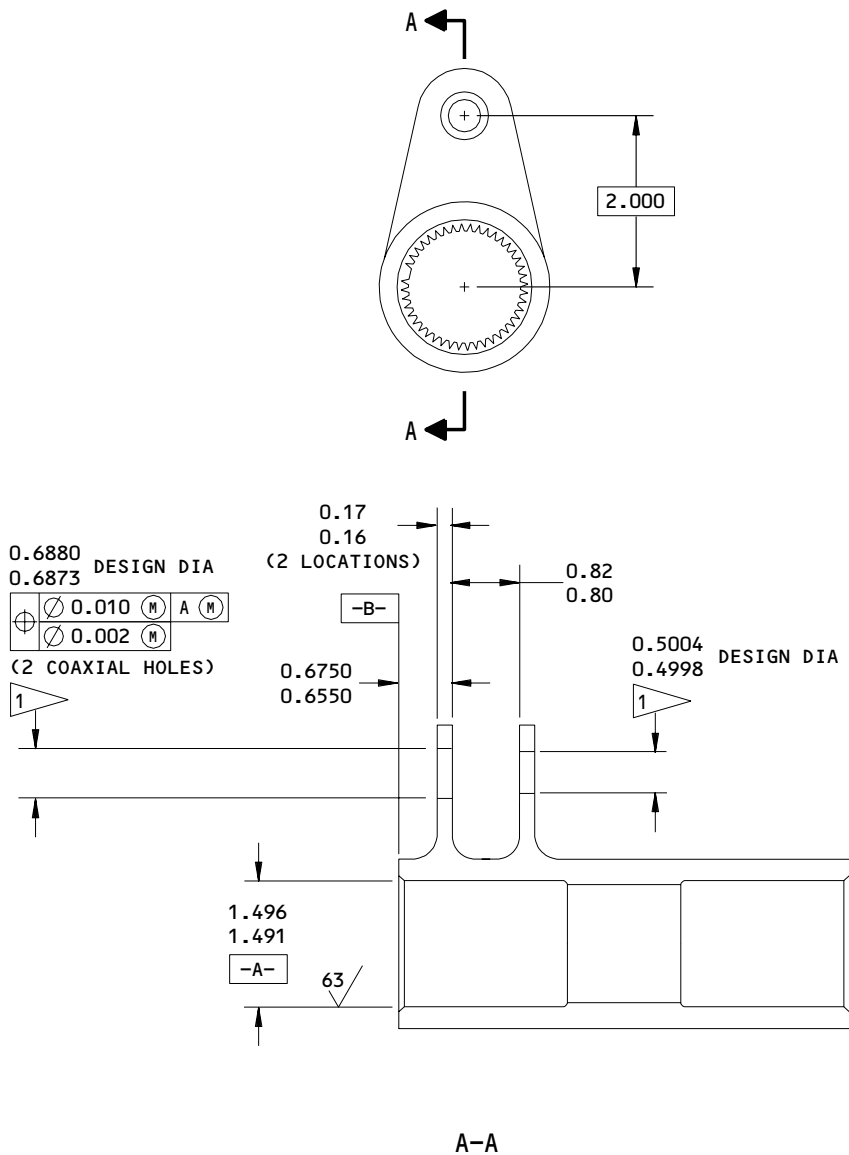
52-32-04

REPAIR 19-2

01.1

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REFINISH

BELLCRANK (378,381) -- PASSIVATE (F-17.09)

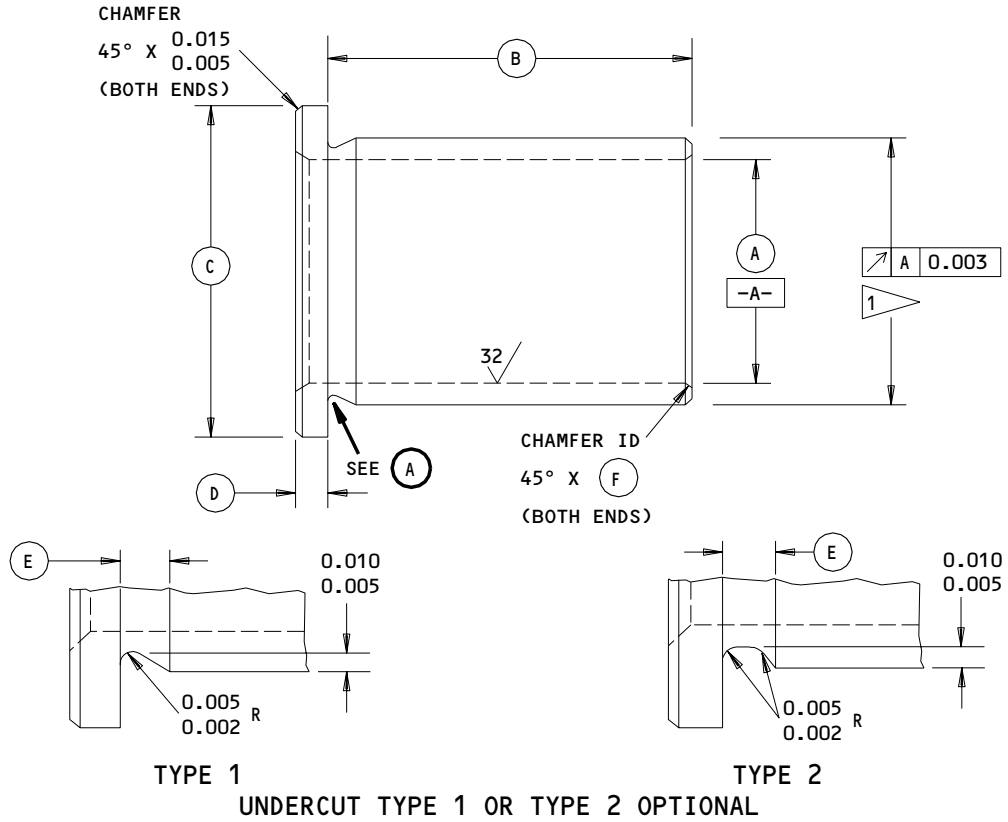
1 THE REPAIR LIMIT FOR THE INSTALLATION OF OVERSIZED BUSHINGS IS THE MAXIMUM DESIGN DIAMETER SHOWN PLUS 0.06 INCHES

REPAIR

REF 1
 125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
 MATERIAL: 15-5PH CRES, 180-200 KSI
 BREAK ALL SHARP EDGES
 ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG. 2

143T6492-3,-4
 Bellcrank - Bushed Hole Repair
 Figure 601

BOEING
COMPONENT
MAINTENANCE MANUAL



(A)

ORIGINAL BUSHING (ITEM NUMBERS)	(A)	(B)	(C)	(D)	(E)	(F)	INTERFERENCE
372	0.3765 0.3750	0.150 0.145	0.635 0.625	0.062 0.057	0.030 0.015	0.015 0.005	0.0002-0.0015
375	0.5640 0.5625	0.150 0.145	0.822 0.812	0.062 0.057	0.030 0.015	0.020 0.010	0.0002-0.0019

REFINISH

ITEM NUMBER 372: CADMIUM PLATE (F-15.06).
 CADMIUM PLATE IN BORE IS OPTIONAL.

ITEM NUMBER 375: CADMIUM PLATE (F-15.06)
 ALL BUT THE BUSHING BORE.

FINAL BUSHING OUTSIDE DIAMETER EQUALS THE REPAIR DIAMETER OF THE BELLCRANK PLUS THE INTERFERENCE.

DIMENSIONS TO BE MET AFTER PLATING.

REPAIR

ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: (ITEM NUMBER 372) 17-4PH CRES,
 RHc 40-43
 (ITEM NUMBER 375) ALUMIUM-NICKEL-BRONZE

ANGULAR TOLERANCE, ±5 DEGREES

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 2

REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 2; 372,375)

143T6492-3,-4
 Oversize Bushing Details
 Figure 602

52-32-04

REPAIR 19-2

01.1

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LATCH/HOOK BELLCRANK ASSEMBLY – REPAIR 20-1

143T6495-1, -2

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (456, 459, 462, 465, IPL Fig. 2)

- A. Remove bushings.
- B. Install bushings by shrink fit as specified in 20-50-03 with wet BMS 5-95 sealant.

52-32-04

REPAIR 20-1

01.1

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BELLCRANK - REPAIR 20-2

143T6495-3, -4

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices, and to IPL Fig. 2 for the item numbers. For the repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 20-1.

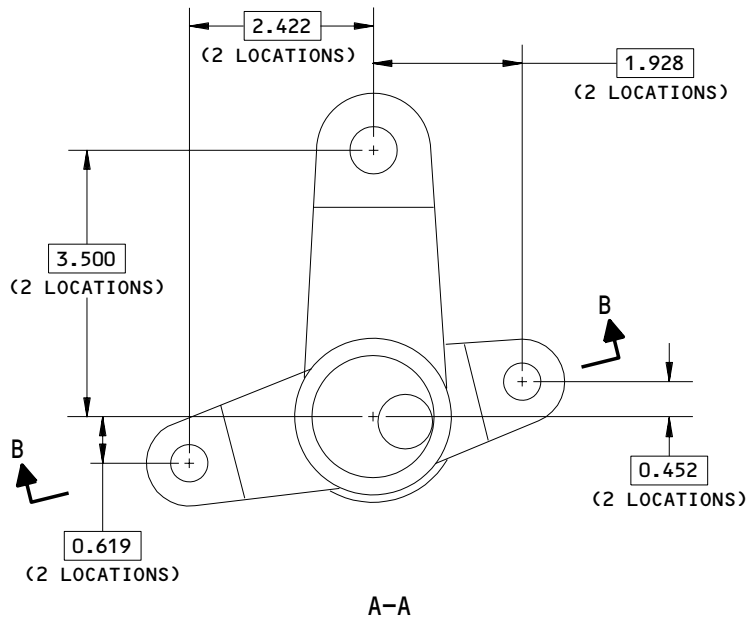
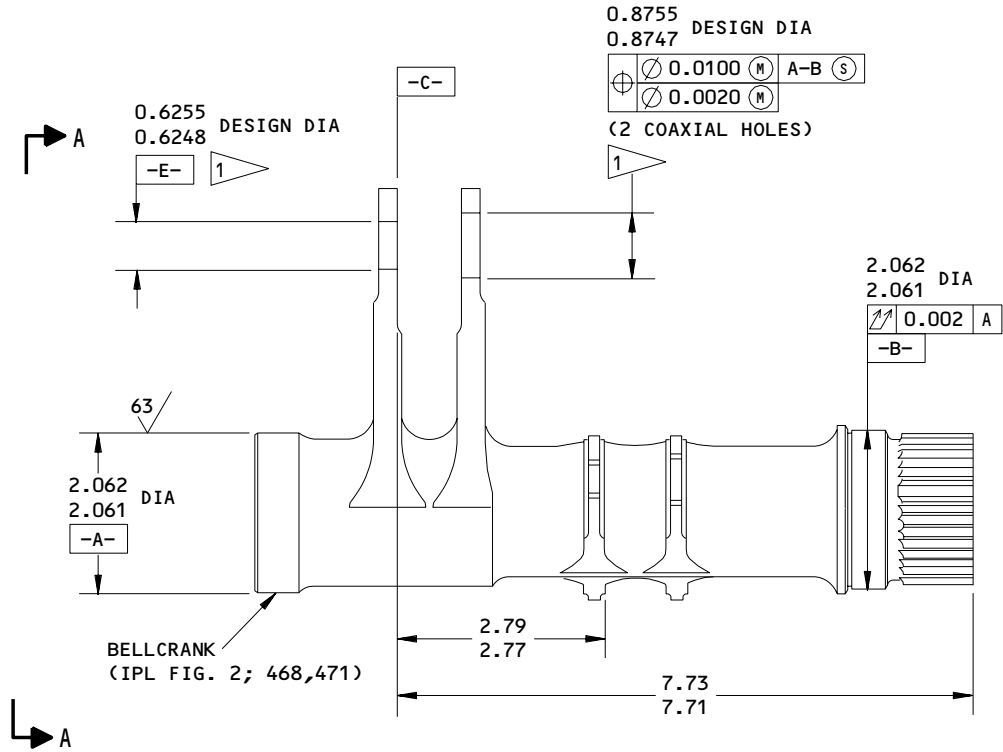
52-32-04

REPAIR 20-2

01.1

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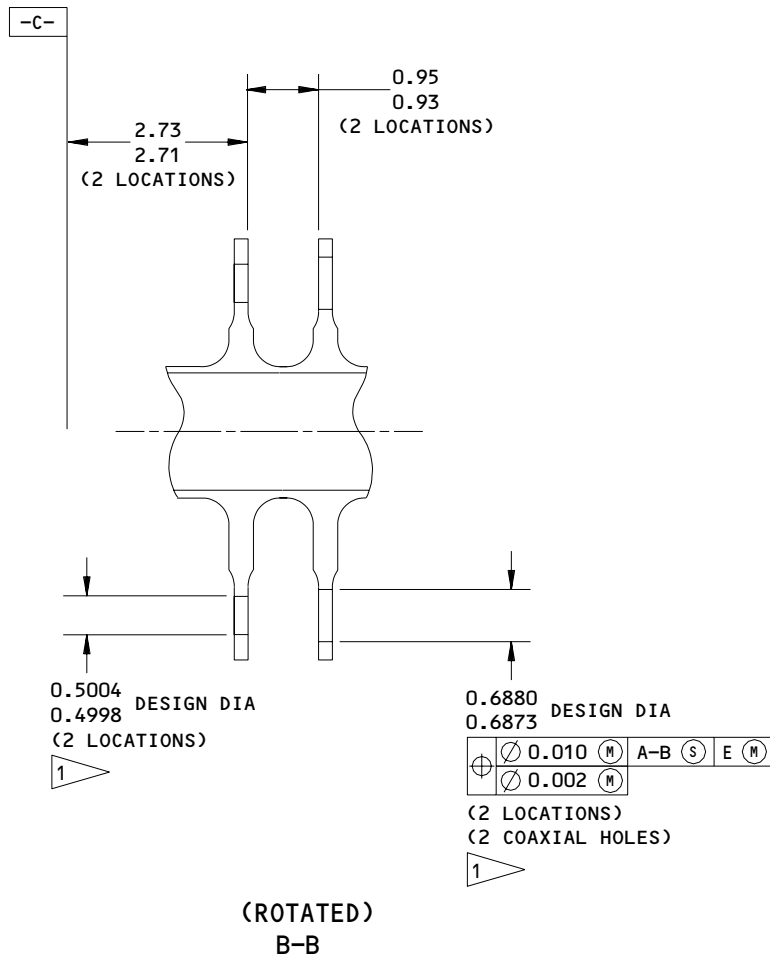


143T6495-3,-4
 Bellcrank - Bushed Hole Repair
 Figure 601 (Sheet 1)

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REPAIR 20-2
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01.1



REFINISH

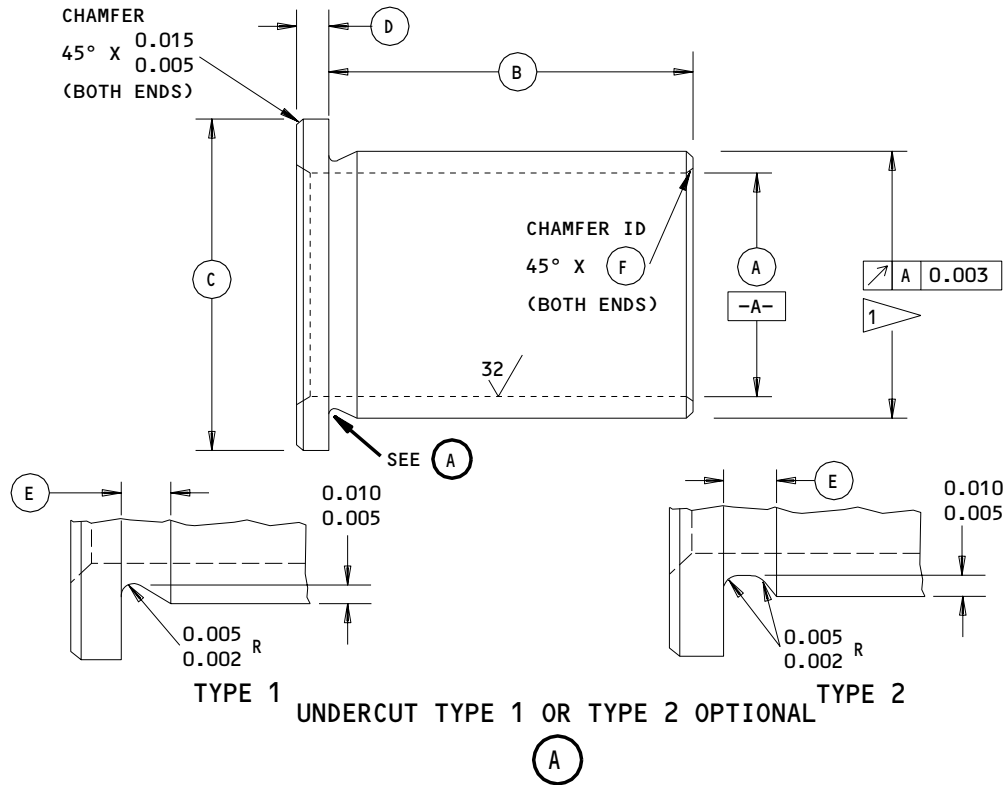
BELLCRANK (468,471) -- PASSIVATE (F-17.09).

1 THE REPAIR LIMIT FOR THE INSTALLATION OF OVERSIZED BUSHINGS IS THE MAXIMUM DESIGN DIAMETER SHOWN PLUS 0.06 INCHES.

REPAIR

REF 1
 125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
 MATERIAL: 15-5PH CRES, 180-200 KSI
 BREAK ALL SHARP EDGES
 ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG. 2

143T6495-3,-4
 Bellcrank - Bushed Hole Repair
 Figure 601 (Sheet 2)



ORIGINAL BUSHING (ITEM NUMBERS)	A	B	C	D	E	F	INTERFERENCE
456	0.5015 0.5000	0.240 0.235	0.760 0.750	0.062 0.057	0.030 0.015	0.015 0.005	0.0002-0.0017
459	0.6890 0.6875	0.240 0.235	1.072 1.062	0.062 0.057	0.030 0.015	0.020 0.010	0.0002-0.0020
462	0.5640 0.5625	0.160 0.155	0.822 0.812	0.062 0.057	0.030 0.015	0.020 0.010	0.0002-0.0019
465	0.3765 0.3750	0.160 0.155	0.635 0.625	0.062 0.057	0.030 0.015	0.015 0.005	0.0002-0.0015

REFINISH

ITEM NUMBERS 456,465: CADMIUM PLATE (F-15.06).
 CADMIUM PLATE IN BORE IS OPTIONAL.

ITEM NUMBERS 459,462: CADMIUM PLATE (F-15.06)
 ALL BUT THE BUSHING BORE.

FINAL BUSHING OUTSIDE DIAMETER EQUALS
 THE REPAIR DIAMETER OF THE BELLCRANK
 PLUS THE INTERFERENCE.

DIMENSIONS TO BE MET AFTER PLATING.

REPAIR

ALL MACHINED SURFACES UNLESS SHOWN
 DIFFERENTLY

MATERIAL: (ITEM NUMBERS 456,465) 17-4PH CRES,
 Rhc 40-43
 (ITEM NUMBERS 459,462) ALUMIUM-
 NICKEL-BRONZE

ANGULAR TOLERANCE, ±5 DEGREES

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 2

REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 2; 456,459,462,465)

143T6495-3,-4
 Oversize Bushing Details
 Figure 602

52-32-04

REPAIR 20-2

01.1

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PULL-IN HOOK - REPAIR 21-1

143T6496-3, -4

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

1. Repair Damage to the Throat of the Pull-In Hook (444A, 447A, IPL Fig. 2) as follows:
 - A. Remove chrome plate from the throat of the pull-in hook (Fig. 601).
 - B. Machine the throat as specified in 20-10-01 as necessary to remove damage. The pull-in hook is not repairable if the surface of the throat changes by more than 0.02 inch of its design surface.
 - C. Magnetic particle check the repaired area as specified in 20-20-01, critical class A.
 - D. Shot peen the repaired surfaces as specified in 20-10-03; intensity 0.010A, coverage 2.0.
 - E. Apply chrome plate and final finishes as specified in Fig. 601.
2. Refinish
 - A. Hook (444A, 447A) -- Passivate (F-17.09). Chrome plate (F-15.03) to 0.0010 to 0.0020 thick and apply BMS 3-8 dry film lubricant to areas shown in Fig. 601. Material: 15-5PH CRES, 180-200 ksi.

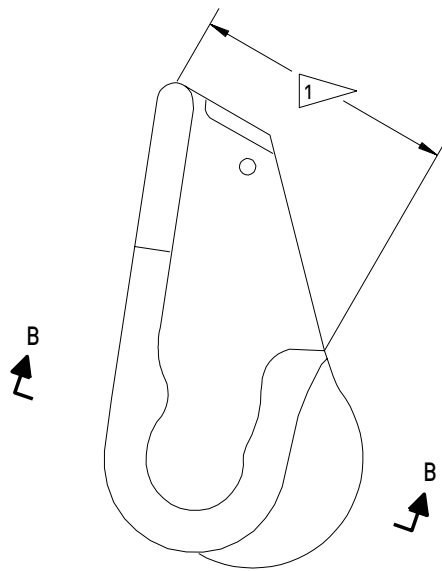
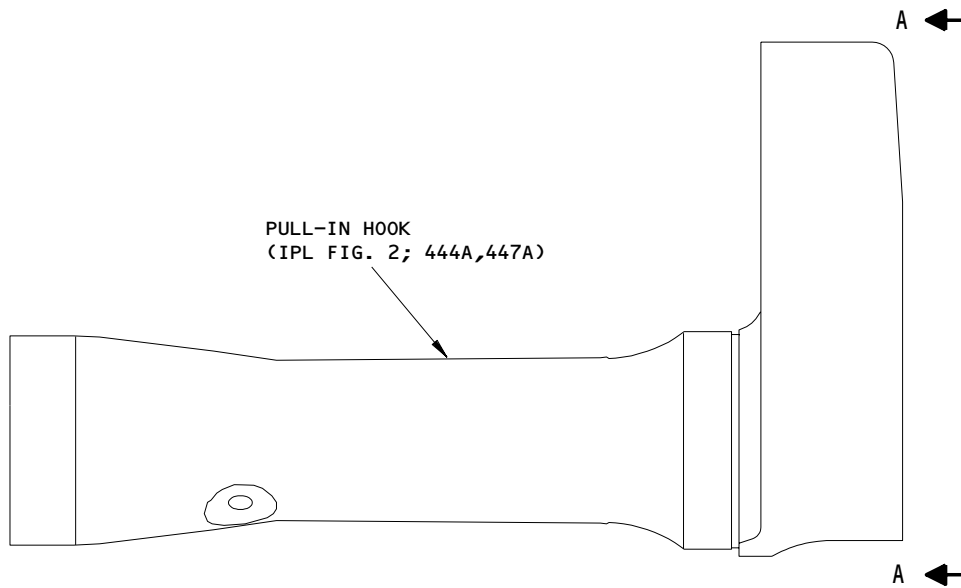
52-32-04

REPAIR 21-1

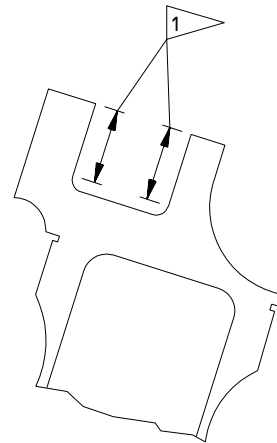
01.1

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A-A



B-B

1 THROAT OF THE PULL-IN HOOK -- CHROME PLATE (F-15.03) 0.0010-0.0020 THICK; APPLY DRY FILM LUBRICANT BMS 3-8 TO THIS SURFACE AS SPECIFIED IN SOPM 20-50-08, TYPE 8

143T6496-3,-4
 Pull-In Hook Refinish
 Figure 601

52-32-04

REPAIR 21-1

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01.1



VENT DOOR EXTENSION SPRING SUPPORT ASSEMBLY - REPAIR 22-1

143T6558-1

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

1. Bushing Replacement (95, IPL Fig. 16)

- A. Remove bushing.
- B. Install bushing by shrink fit as specified in 20-50-03 with BMS 5-95 sealant.

52-32-04

REPAIR 22-1

01.1

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SUPPORT – REPAIR 22-2

143T6558-2

NOTE: Refer to REPAIR – GENERAL for a list of applicable standard practices, and to IPL Fig. 16 for item numbers. For the repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 22-1.

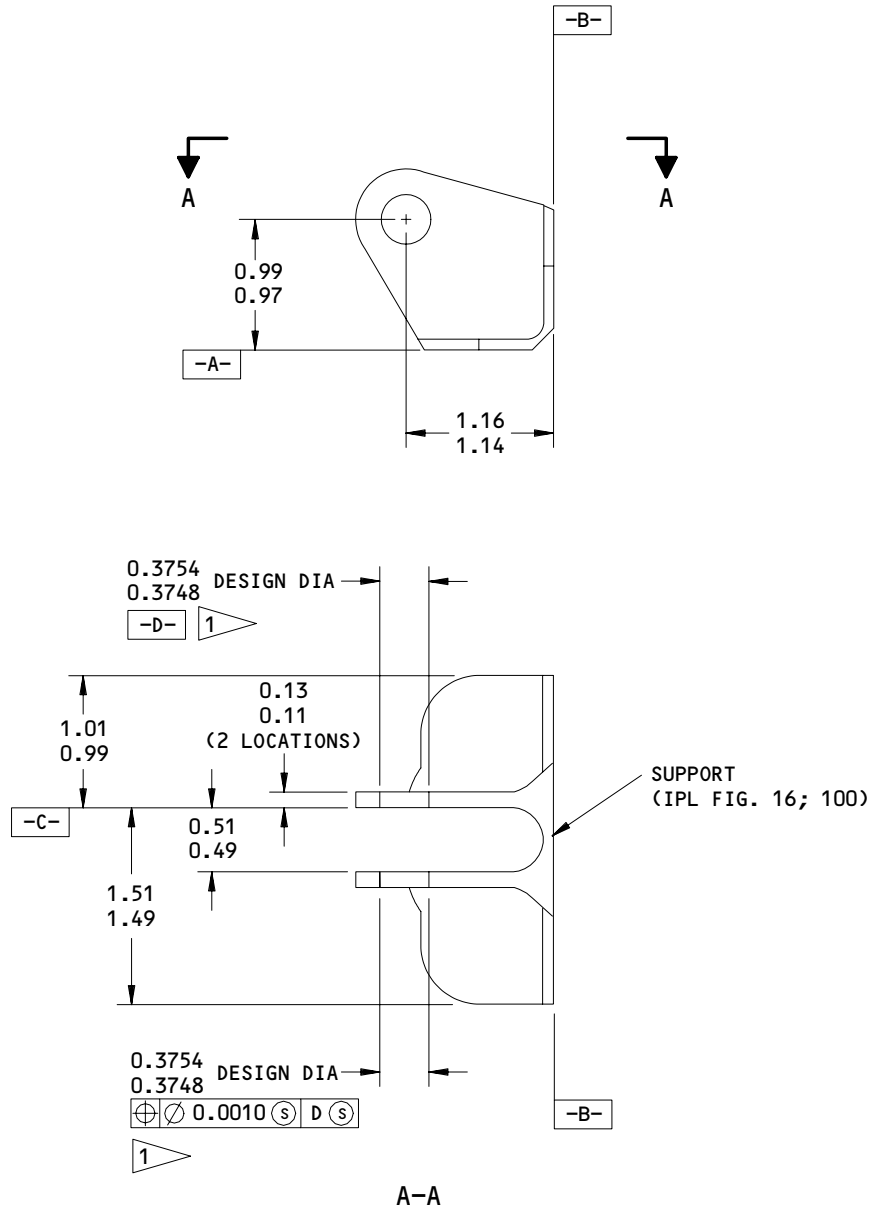
52-32-04

REPAIR 22-2

01.1

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REFINISH

SUPPORT (100) -- ANODIZE AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.04) BUT DO NOT PUT PRIMER IN HOLES.

1 THE REPAIR LIMIT FOR THE INSTALLATION OF AN OVERSIZED BUSHING IS THE MAXIMUM DESIGN DIAMETER SHOWN PLUS 0.06 INCHES.

REPAIR

REF 1
 125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
 MATERIAL: ALUM ALLOY
 BREAK ALL SHARP EDGES
 ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG. 16

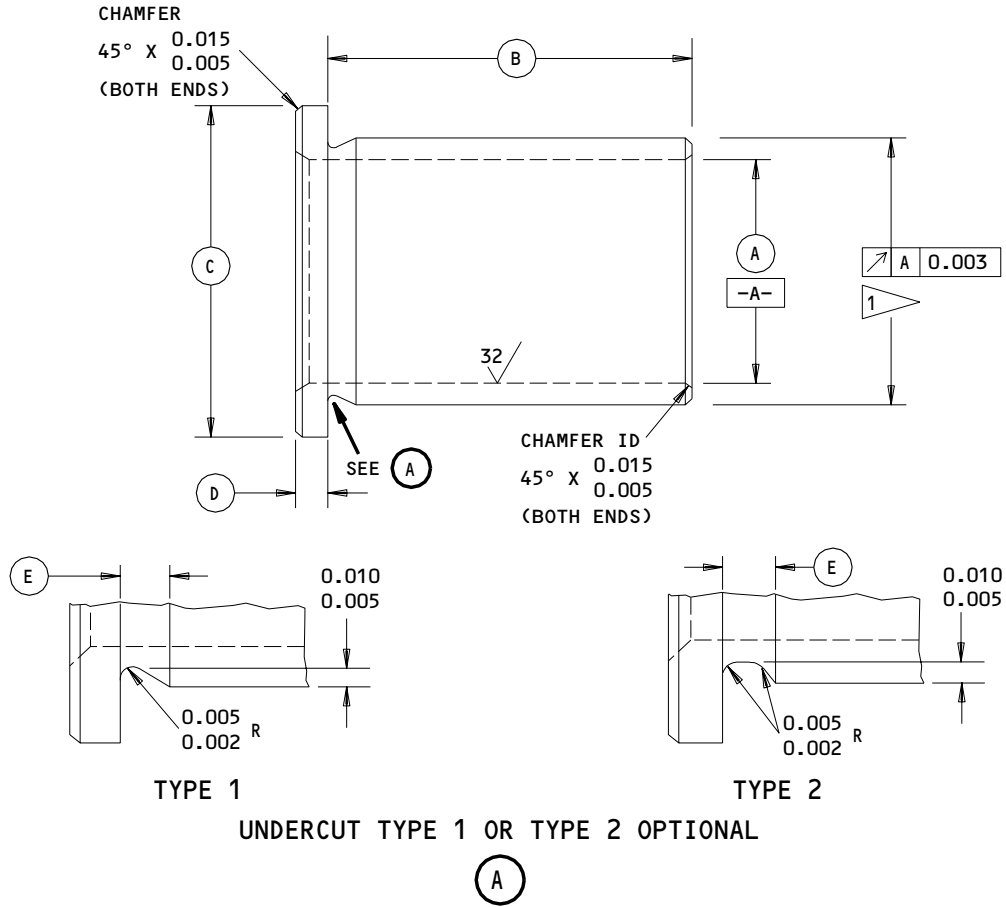
143T6558-2
 Support - Bushed Hole Repair
 Figure 601

52-32-04

REPAIR 22-2
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01.1

BOEING
 COMPONENT
 MAINTENANCE MANUAL



ORIGINAL BUSHING (ITEM NUMBERS)	(A)	(B)	(C)	(D)	(E)	INTERFERENCE
95 ∇	0.2515 0.2500	0.100 0.095	0.510 0.500	0.062 0.057	0.030 0.015	0.0002-0.0013

REFINISH

ITEM NUMBER 95: CADMIUM PLATE (F-15.06)
 ALL BUT THE BUSHING BORE

- ∇ 1 FINAL BUSHING OUTSIDE DIAMETER EQUALS THE REPAIR DIAMETER OF THE SUPPORT PLUS THE INTERFERENCE.
- ∇ 2 DIMENSIONS TO BE MET AFTER PLATING.

REPAIR

∇ 63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
 MATERIAL: ALUMINUM-NICKEL-BRONZE
 ANGULAR TOLERANCE, ± 5 DEGREES
 BREAK ALL SHARP EDGES
 ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG. 16

REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 16; 95)

143T6558-2
 Oversize Bushing Details
 Figure 602

52-32-04
 REPAIR 22-2
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SECTOR TORQUE TUBE BELLCRANK ASSEMBLY – REPAIR 23-1

143T6583-1

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (805, 810, IPL Fig. 3)

- A. Remove bushings.
- B. Install bushings as specified in 20-50-03.
- C. Fillet seal around periphery of bushing flanges with BMS 5-95 sealant.

52-32-04

REPAIR 23-1

01.1

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BELLCRANK – REPAIR 23-2

143T6583-2

NOTE: Refer to REPAIR – GENERAL for a list of applicable standard practices, and to IPL Fig. 3 for item numbers. For the repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 23-1.

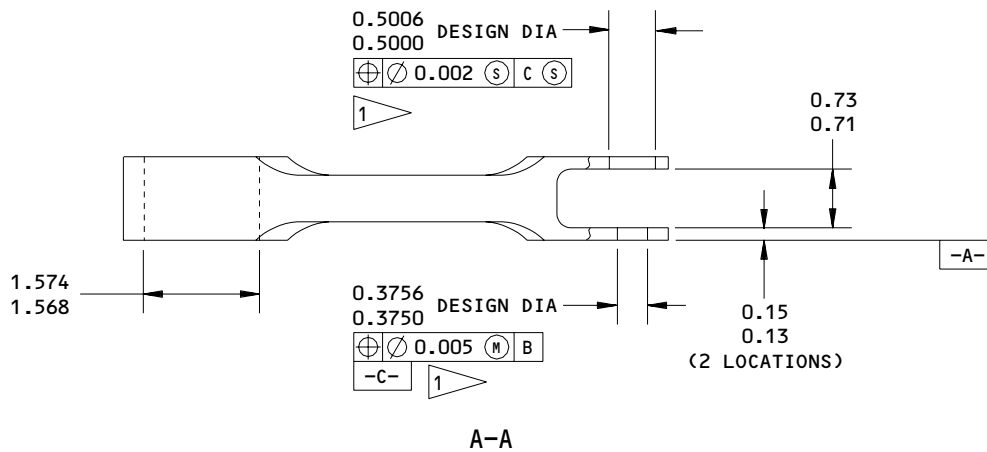
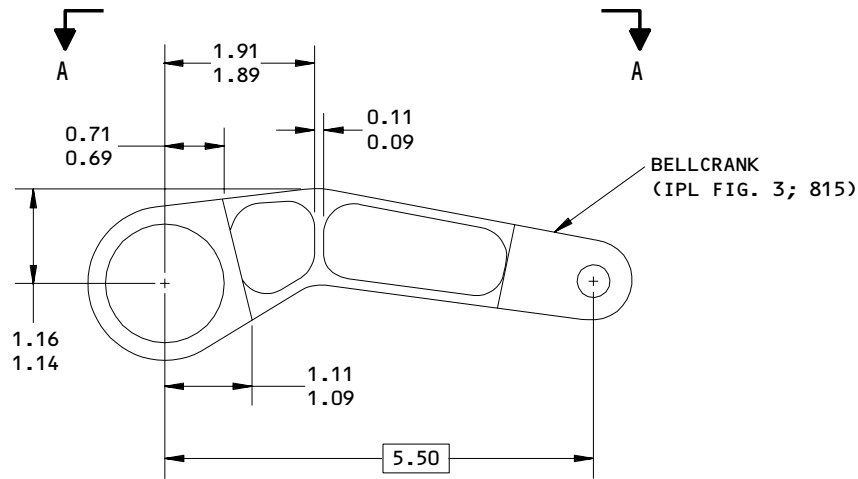
52-32-04

REPAIR 23-2

01.1

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REFINISH

BELLCRANK (815) -- ANODIZE AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.04) PLUS ONE COAT OF BMS 10-11, TYPE 2 ENAMEL, BAC702 WHITE GLOSS (F-21.17) ALL OVER, BUT DO NOT PUT PRIMER AND ENAMEL IN BUSHING BORES AND DO NOT PUT ENAMEL IN THE 1.57 INCH DIAMETER HOLE.

1 THE REPAIR LIMIT FOR THE INSTALLATION OF AN OVERSIZED BUSHING IS THE MAXIMUM DESIGN DIAMETER SHOWN PLUS 0.06 INCHES.

REPAIR

REF 1
 125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: ALUM ALLOY
 BREAK ALL SHARP EDGES
 ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG. 3

143T6583-2
 Bellcrank - Bushed Hole Repair
 Figure 601

52-32-04

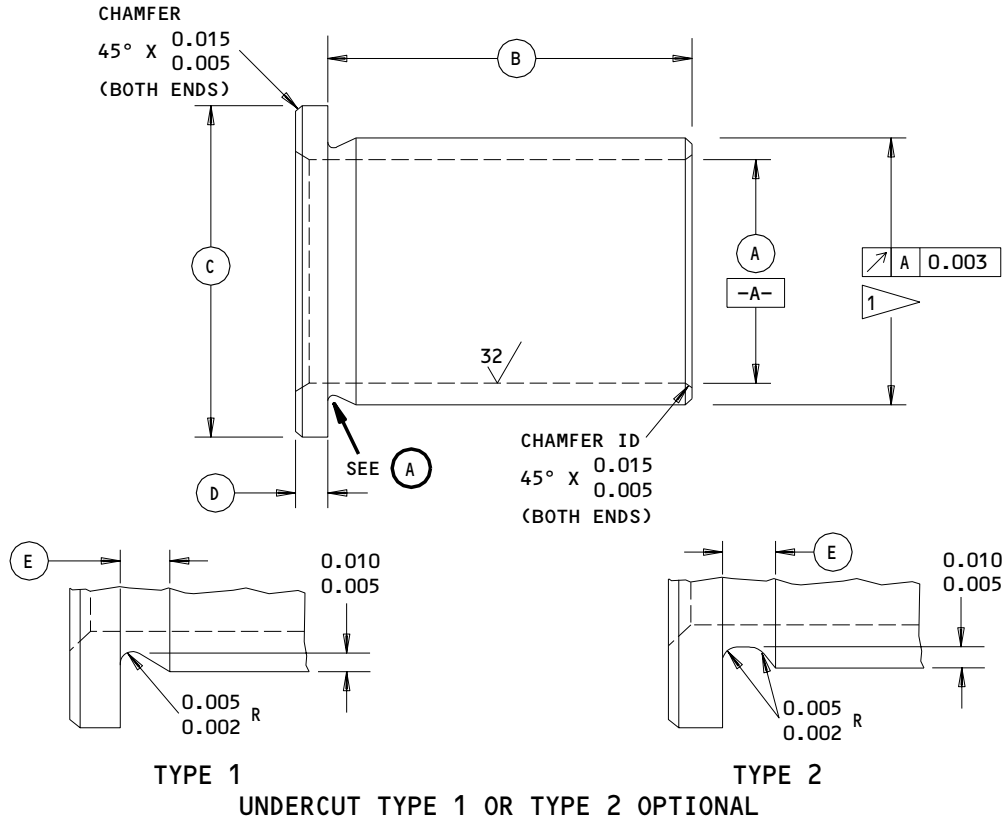
REPAIR 23-2

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01.1

BOEING
COMPONENT
MAINTENANCE MANUAL



(A)

ORIGINAL BUSHING (ITEM NUMBERS)	(A)	(B)	(C)	(D)	(E)	INTERFERENCE
805	0.3765 0.3750	0.120 0.115	0.635 0.625	0.062 0.057	0.030 0.015	0.0003-0.0016
810	0.2515 0.2500	0.120 0.115	0.510 0.500	0.062 0.057	0.030 0.015	0.0002-0.0013

REFINISH

ITEM NUMBER 805: CADMIUM PLATE (F-15.06)
 ALL BUT THE BUSHING BORE

ITEM NUMBER 810: CADMIUM PLATE (F-15.06).
 CADMIUM PLATE IN BORE IS OPTIONAL

FINAL BUSHING OUTSIDE DIAMETER EQUALS THE REPAIR DIAMETER OF THE BELLCRANK PLUS THE INTERFERENCE.

DIMENSIONS TO BE MET AFTER PLATING.

REPAIR

ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: (ITEM NUMBER 810) 17-4PH CRES, RHC 40-43
 (ITEM NUMBER 805) ALUMIUM-NICKEL-BRONZE

ANGULAR TOLERANCE, ±5 DEGREES

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 3

REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 3; 805,810)

143T6583-2
 Oversize Bushing Details
 Figure 602

52-32-04

REPAIR 23-2

01.1

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LATCH LOCK IDLER ASSEMBLY – REPAIR 24-1

143T6593-1

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bearing Replacement (325, IPL Fig. 3)
 - A. Remove bearings.
 - B. Install bearings as specified in 20-50-03.
2. Bushing Replacement (330, 335, 340, 345)
 - A. Remove bushings.
 - B. Install bushings as specified in 20-50-03 with wet BMS 5-95 sealant.
 - C. Fillet seal around periphery of bushing flanges with BMS 5-95 sealant.

52-32-04

REPAIR 24-1

01.1

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IDLER - REPAIR 24-2

143T6593-2

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices, and to IPL Fig. 3 for item numbers. For the repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 24-1.

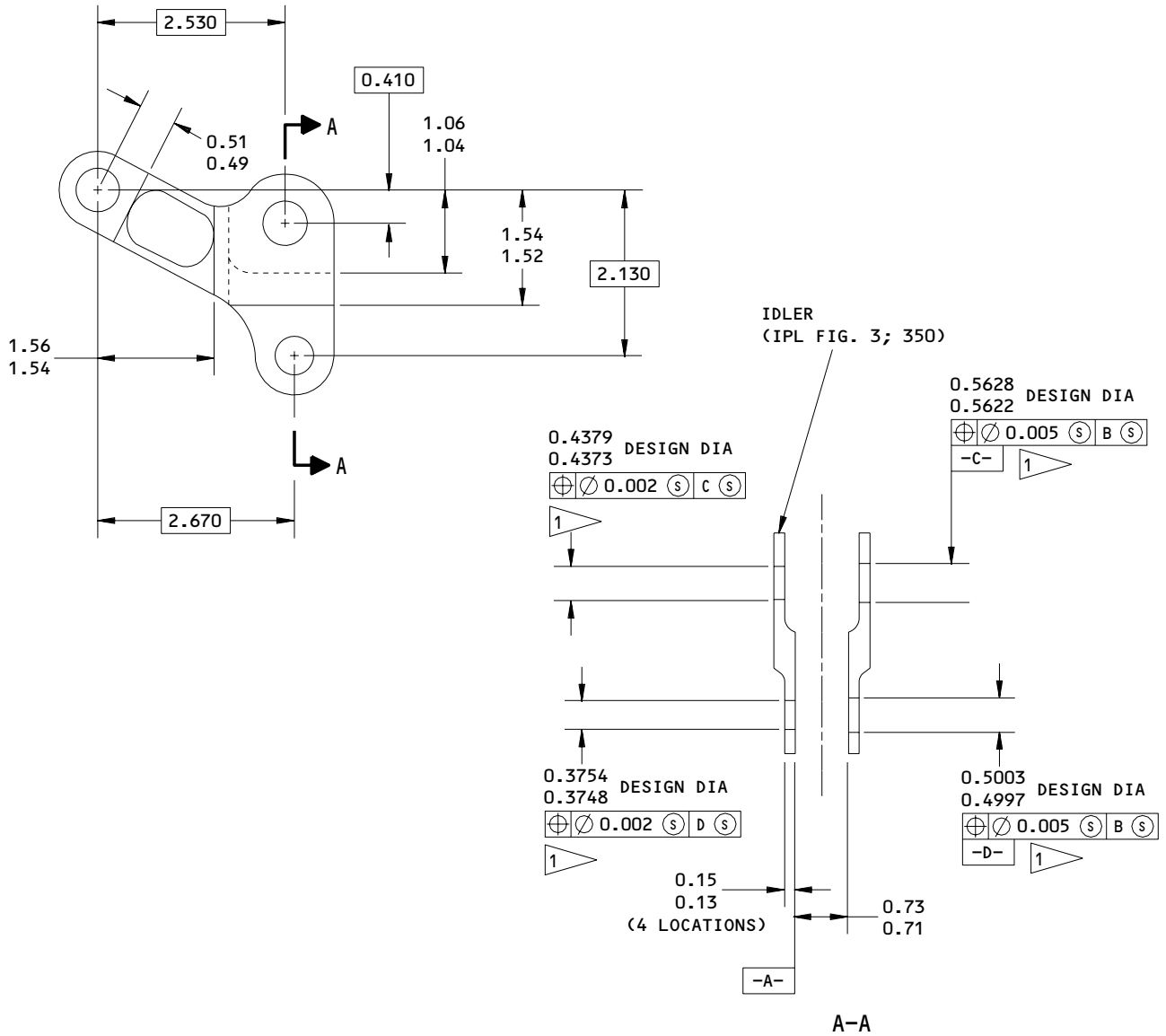
52-32-04

REPAIR 24-2

01.1

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REFINISH

IDLER (350) -- ANODIZE AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.04) ALL OVER, BUT DO NOT PUT PRIMER IN BUSHING AND BEARING BORES.

1 THE REPAIR LIMIT FOR THE INSTALLATION OF AN OVERSIZED BUSHING IS THE MAXIMUM DESIGN DIAMETER SHOWN PLUS 0.06 INCHES.

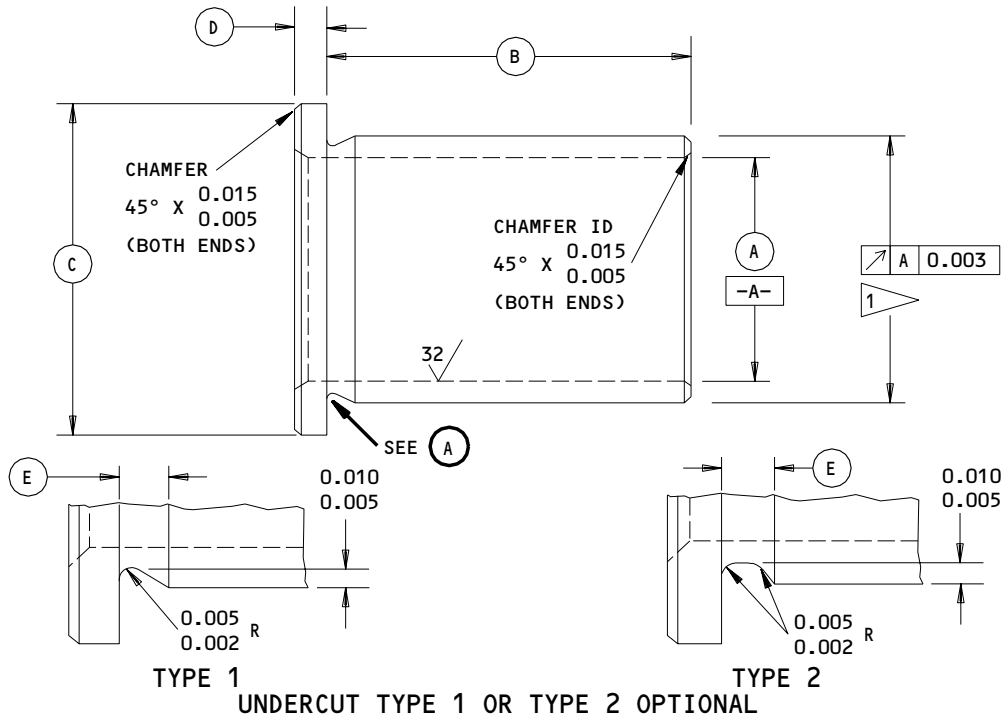
REPAIR

REF 1
 125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: ALUM ALLOY
 BREAK ALL SHARP EDGES
 ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG. 3

143T6593-2
 Idler - Bushed Hole Repair
 Figure 601

BOEING
 COMPONENT
 MAINTENANCE MANUAL



(A)

ORIGINAL BUSHING (ITEM NUMBERS)	(A)	(B)	(C)	(D)	(E)	INTERFERENCE
330	0.3140 0.3125	0.120 0.115	0.572 0.562	0.062 0.057	0.030 0.015	0.0002-0.0013
335	0.2515 0.2500	0.120 0.115	0.510 0.500	0.062 0.057	0.030 0.015	0.0002-0.0013
340	0.4390 0.4375	0.120 0.115	0.697 0.687	0.062 0.057	0.030 0.015	0.0003-0.0016
345	0.3765 0.3750	0.120 0.115	0.635 0.625	0.062 0.057	0.030 0.015	0.0003-0.0016

REFINISH

ITEM NUMBERS 330,335: CADMIUM PLATE (F-15.06). CADMIUM PLATE IN BORE IS OPTIONAL.

ITEM NUMBERS 340,345: CADMIUM PLATE (F-15.06) ALL BUT THE BUSHING BORES.

FINAL BUSHING OUTSIDE DIAMETER EQUALS THE REPAIR DIAMETER OF THE IDLER PLUS THE INTERFERENCE.

DIMENSIONS TO BE MET AFTER PLATING.

REPAIR

ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: (ITEM NUMBERS 330,335) 17.4PH CRES, Rhc 40-43
 (ITEM NUMBERS 340,345) ALUMIUM-NICKEL-BRONZE

ANGULAR TOLERANCE, ±5 DEGREES

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 3

REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 3; 330,335,340,345)

143T6593-2
 Oversize Bushing Details
 Figure 602

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REPAIR 24-2

01.1

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VENT DOOR MECHANISM SUPPORT FITTING ASSEMBLY - REPAIR 25-1

143T6597-1

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

1. Bearing Replacement (610, 615, IPL Fig. 3)

- A. Remove bearings.
- B. Install bearings (610) as specified in 20-50-03.
- C. Install and roller swage bearings (615) as specified in 20-50-03.

2. Refinish

- A. Fitting (620) -- Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04) but do not put primer in bearing counter bores. Material: Alum alloy.

52-32-04

REPAIR 25-1

01.1

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VENT DOOR ASSEMBLY – REPAIR 26-1

143T6603-1

NOTE: Refer to REPAIR – GENERAL for list of applicable standard practices.

1. Bushing Replacement (215, 220, 225, IPL Fig. 3)
 - A. Remove bushings.
 - B. Install bushings by shrink fit procedure as specified in 20-50-03 with BMS 5-95 sealant.
2. Bearing Replacement (210, IPL Fig. 3)
 - A. Remove bearings.
 - B. Install bearings by ball stake procedure as specified in 20-50-03 with wet BMS 5-95 sealant.
3. Pressure Seal Replacement (200, IPL Fig. 3)
 - A. Remove pressure seal.
 - B. Bond the pressure seal (200) to the door assembly (205) with adhesive as specified in 20-50-12, type 60. Apply the adhesive around the full periphery of the door assembly. Make sure not to cover the two breather holes in the pressure seal with adhesive during installation.

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REPAIR 26-1

01.1

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DOOR - REPAIR 26-2

143T6603-3

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices, and to IPL Fig. 3 for item numbers. For the repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushed Hole Repair (Fig. 601)

- A. Remove bushing.
- B. Machine the hole as necessary to remove corrosion and/or repair the damaged areas as specified in Fig. 601.
- C. Make an oversized bushing as specified in Fig. 602 to make allowance for the material removed in step 1.B.
- D. Install the bushing as specified in REPAIR 26-1.

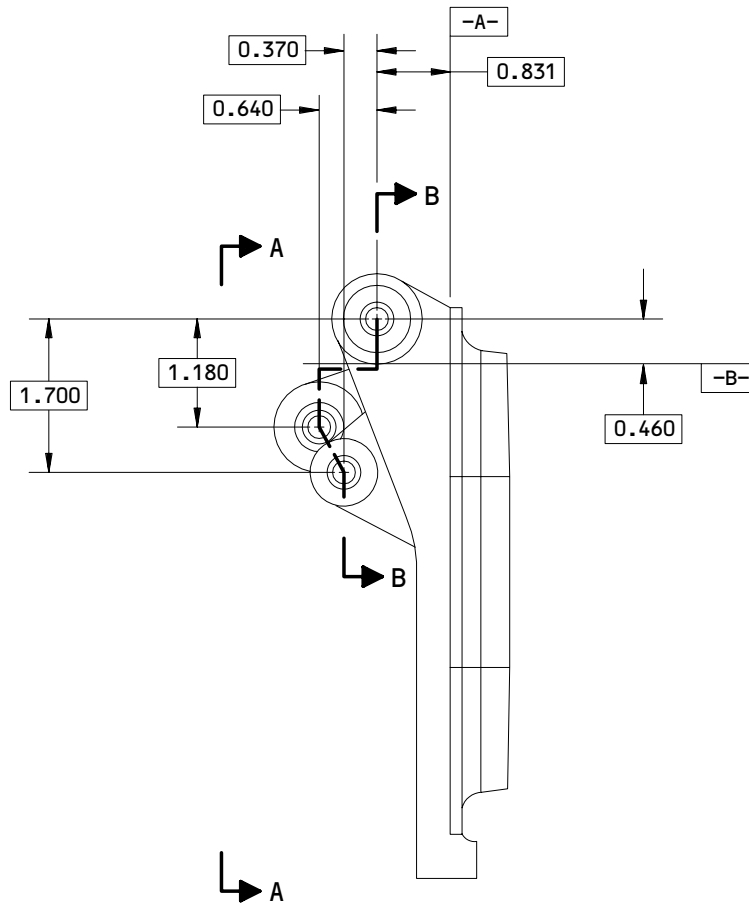
52-32-04

REPAIR 26-2

01.1

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REFINISH

DOOR (230) - - FINISH THE DOOR AS SHOWN IN FIGURE 601, SHEET 3.

1 THE REPAIR LIMIT FOR THE INSTALLATION OF AN OVERSIZED BUSHING IS THE MAXIMUM DESIGN DIAMETER SHOWN PLUS 0.06 INCHES.

REPAIR

REF 1

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: A357.0-T6 HIGH STRENGTH CASTING PER MIL-A-21180, CLASS 10

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 3

143T6603-3
 Door - Bushed Hole Repair
 Figure 601 (Sheet 1)

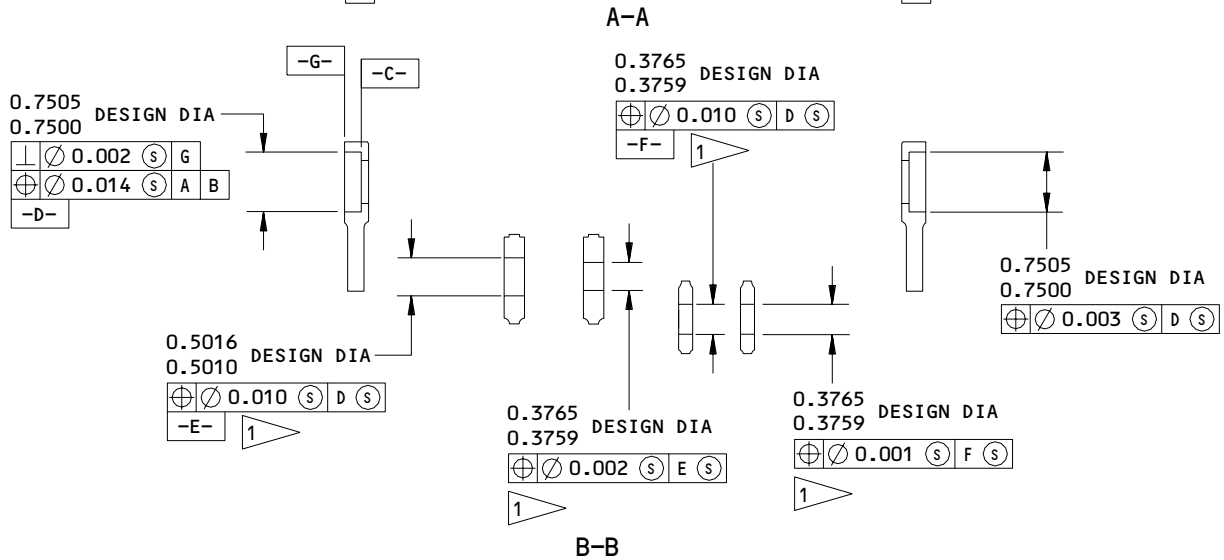
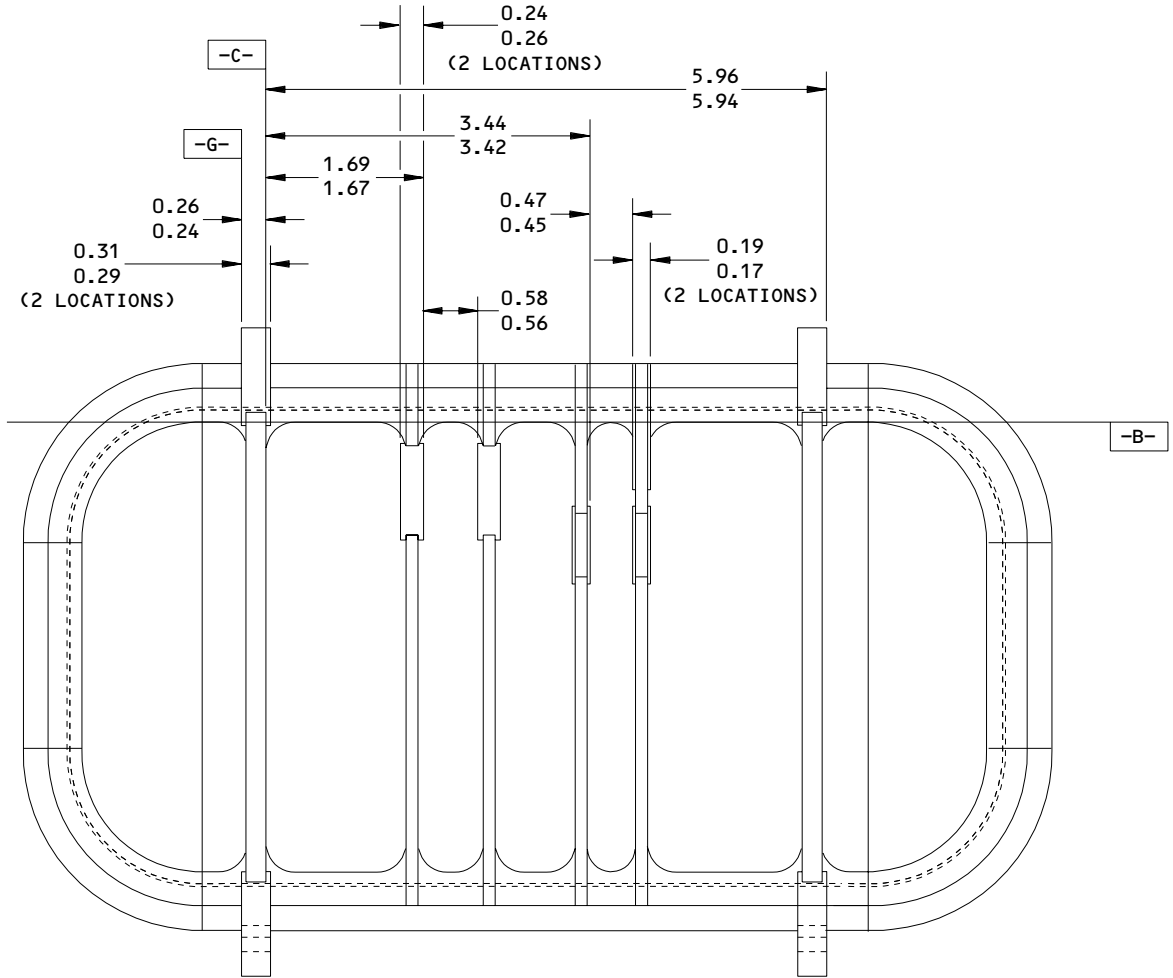
52-32-04

REPAIR 26-2

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143T6603-3
 Door - Bushed Hole Repair
 Figure 601 (Sheet 2)

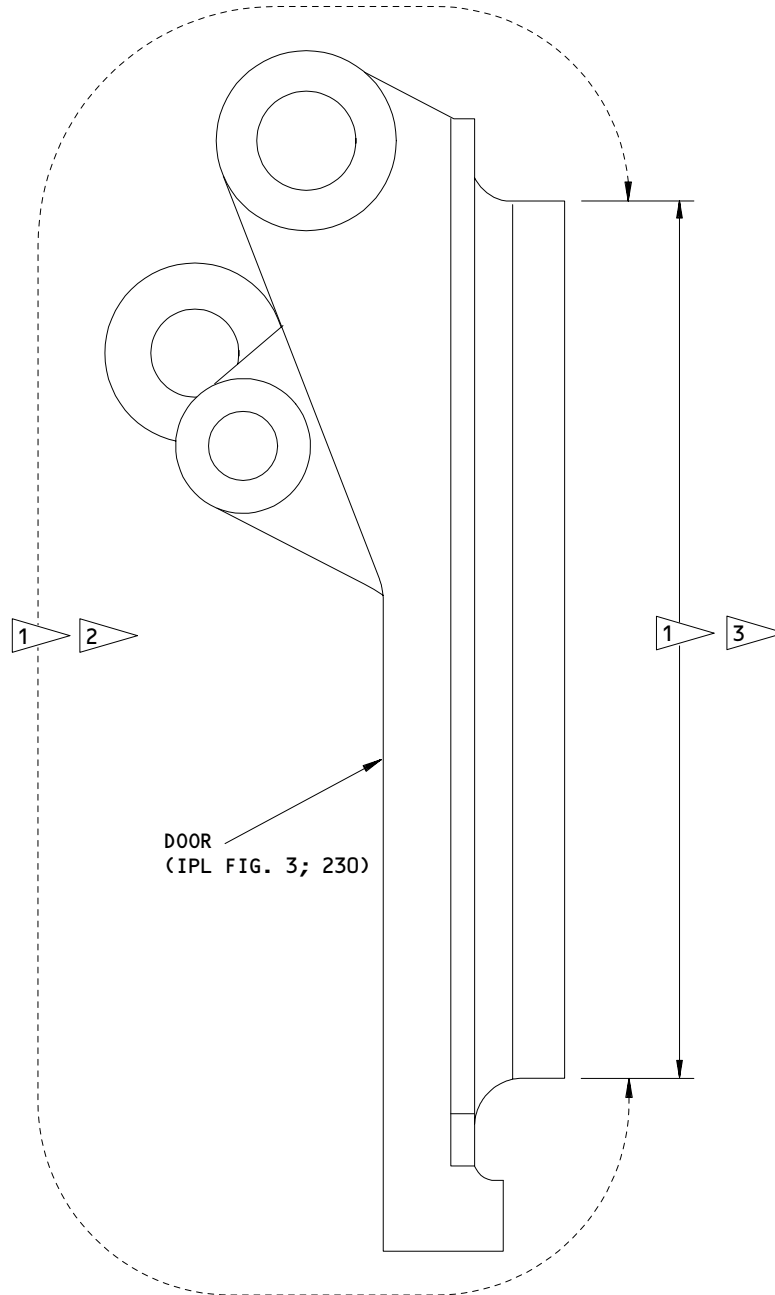
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REPAIR 26-2

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143T6603-3



1 ANODIZE (F-17.05)
 2 APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02) AND ONE COAT OF BMS 10-11, TYPE 2, COLOR BAC702 WHITE GLOSS ENAMEL (F-21.17) BUT DO NOT PUT PRIMER OR ENAMEL IN BUSHING OR BEARING HOLES



3 APPLY ONE COAT OF BMS 10-79, TYPE 2 PRIMER AND APPLY BMS10-60, TYPE 2 ENAMEL, COLOR 707 GREY GLOSS (F-19.40)

Door Refinish
 Figure 601 (Sheet 3)

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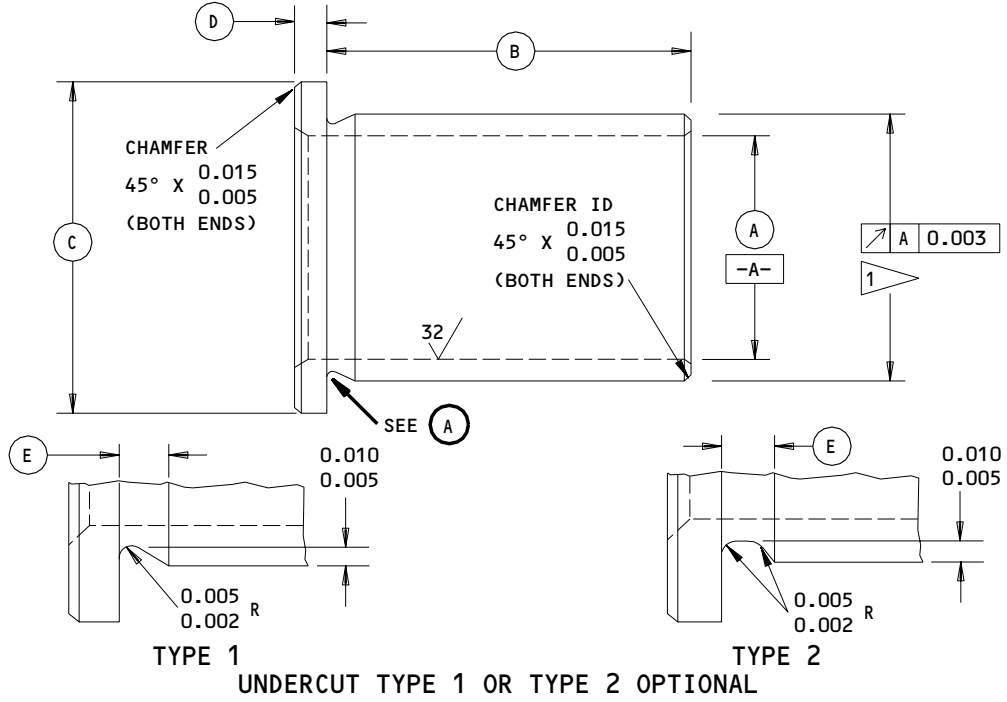
REPAIR 26-2

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BOEING
 COMPONENT
 MAINTENANCE MANUAL



A

ORIGINAL BUSHING (ITEM NUMBERS)	A	B	C	D	E	INTERFERENCE
215	0.3765 0.3750	0.230 0.225	0.635 0.625	0.062 0.057	0.030 0.015	
220	0.2515 0.2500	0.230 0.225	0.510 0.500	0.062 0.057	0.030 0.015	
225	0.2515 0.2500	0.160 0.155	0.510 0.500	0.062 0.057	0.030 0.015	

REFINISH

ITEM NUMBER 220: CADMIUM PLATE (F-15.06).
 CADMIUM PLATE IN BORE IS OPTIONAL.
 ITEM NUMBERS 215,225: CADMIUM PLATE (F-15.06)
 ALL BUT THE BUSHING BORE.

- FINAL BUSHING OUTSIDE DIAMETER EQUALS THE REPAIR DIAMETER OF THE DOOR PLUS THE INTERFERENCE.
- DIMENSIONS TO BE MET AFTER PLATING.
- BUSHING TO BE INSTALLED WITH 0.0010 CLEARANCE TO 0.0003 INTERFERENCE.
- BUSHING TO BE INSTALLED WITH 0.0009 CLEARANCE TO 0.0002 INTERFERENCE.

REPAIR

ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: (ITEM NUMBER 220) 17.4PH CRES, RHC 40-43
 (ITEM NUMBERS 215,225) ALUMIUM-NICKEL-BRONZE

ANGULAR TOLERANCE, ±5 DEGREES
 BREAK ALL SHARP EDGES
 ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG. 3

REPLACEMENT BUSHINGS FOR BUSHINGS (IPL FIG. 3; 215,220,225)

143T6603-3
 Oversize Bushing Details
 Figure 602

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REPAIR 26-2
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ASSEMBLY1. General

- A. Assembly is generally divided into three main categories; the door structure components (IPL Fig. 1 and 4 thru 17), the latch and hook installation (IPL Fig. 2) and the latch lock installation (IPL Fig. 3). Additional paragraphs contain pushrod preassembly, general sealing and door rigging information.
- B. Install all bolts and nuts except those indicated in Fig. 707 and Fig. 802 as specified in 20-50-01 and tighten to the standard torque values.
- C. Install all lockwire and cotter pins as specified in 20-50-02.

2. Materials

NOTE: Equivalent substitutes can be used.

- A. Adhesives (Ref 20-50-12)
 - (1) Type 60
 - (2) Type 68
 - (3) Type 70
 - (4) Type 82
 - (5) Type 93
- B. Adhesives (Ref 20-60-04)
 - (1) Metalset A-4
- C. Compound, corrosion preventive (Ref 20-60-04)
 - (1) MIL-C-16173, type 2
- D. Compound, potting (Ref 20-60-04)
 - (1) BMS 5-28, type 6 or type 4

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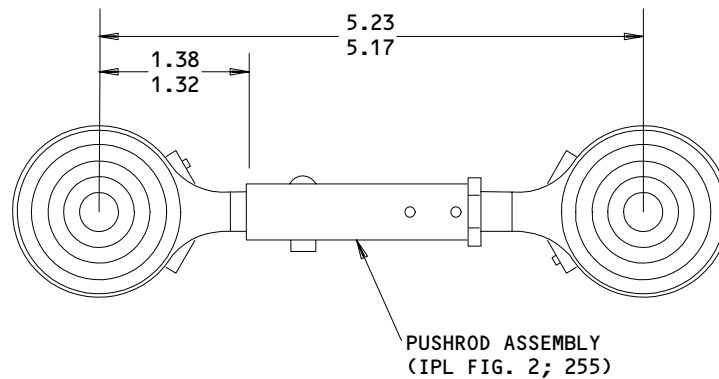
- E. Enamel (Ref 20-60-02)
 - (1) BMS 10-11, type 2 BAC701 black gloss or BAC706 black semigloss
- F. Grease (Ref 20-60-03)
 - (1) BMS 3-24
 - (2) MIL-G-23827
- G. Lockwire -- MS20995NC032, MS20995C032, any convenient source
- H. Lubricant -- Liquid soap, any convenient source
- I. Primer (Ref 20-60-02)
 - (1) BMS 10-11, type 1
- J. Sealant (Ref 20-60-04)
 - (1) BMS 5-79
 - (2) BMS 5-95
 - (3) BMS 5-142

3. Preassemble Pushrod Assemblies (255, IPL Fig. 2) as follows:

- A. Apply corrosion preventive compound, MIL-C-16173, grade 2, on the internal and external mating threads of the pushrod assembly components before assembly.
- B. Assemble the pushrod assemblies to the dimensions given in Fig. 701. Use standard shop practices.
- C. Lubricate the bearings through the lube fittings with MIL-G-23827 grease.
- D. Tag the nut used to adjust the rod length as follows: "tighten nut to standard torque value after final rigging adjustment".

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ALL DIMENSIONS ARE IN INCHES

Pushrod Assembly
 Figure 701

F28565

4. Preassemble Pushrod Assemblies (24, 162, IPL Fig. 2; 355, 415, IPL Fig. 3) as follows:

- A. Install inserts (177, IPL Fig. 2; 375, 435, IPL Fig. 3) as specified in 20-50-12, type 70 (opt: Metalset A-4).
- B. Install rod ends (27, 180, IPL Fig. 2; 380, 440, IPL Fig. 3) as specified in 20-50-12, type 70 (opt: Metalset A-4) to the dimensions shown in Fig. 702.
- C. Swage each end of the rod before curing of the bonding agent.

NOTE: Swage appropriate rods over inserts (177, IPL Fig. 2; 375, 435, IPL Fig. 3) and cure bonding agent before installation of adjustable rod end.

- D. Verify that the inserts and rod ends withstand the torques specified in Fig. 703 after swaging and curing of bonding agent.

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ASSEMBLY
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- E. Install rod end (174, IPL Fig. 2; 365, 425, IPL Fig. 3) by applying corrosion preventive compound, MIL-C-16173, type 2, on the internal and external mating threads before assembly. Install the rod ends to get the pushrod assembly dimensions shown in Fig. 702.
- F. Tighten the indicated nuts as specified in Fig. 703.
- G. Lubricate the bearings through the lube fittings with MIL-G-23827 grease.
- H. Tag the nut left loose for rod length adjustment as follows: "Tighten nut to (insert Fig. 801 value) after final rigging adjustment".

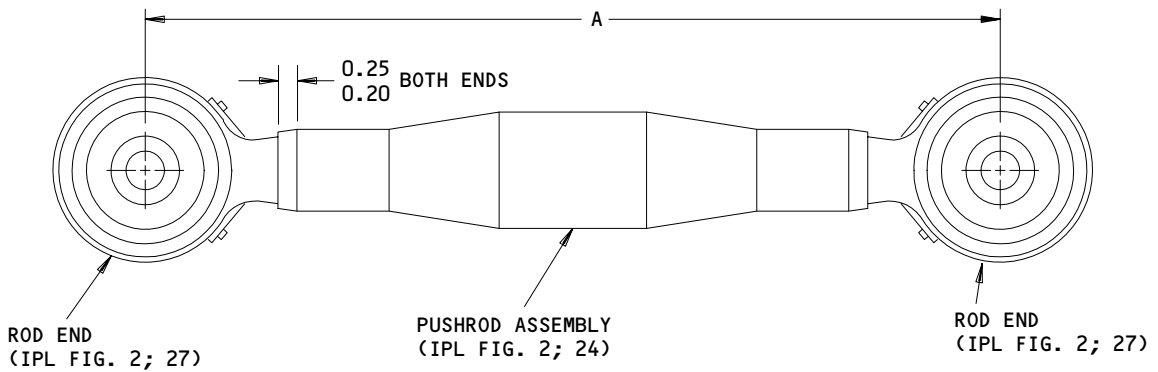
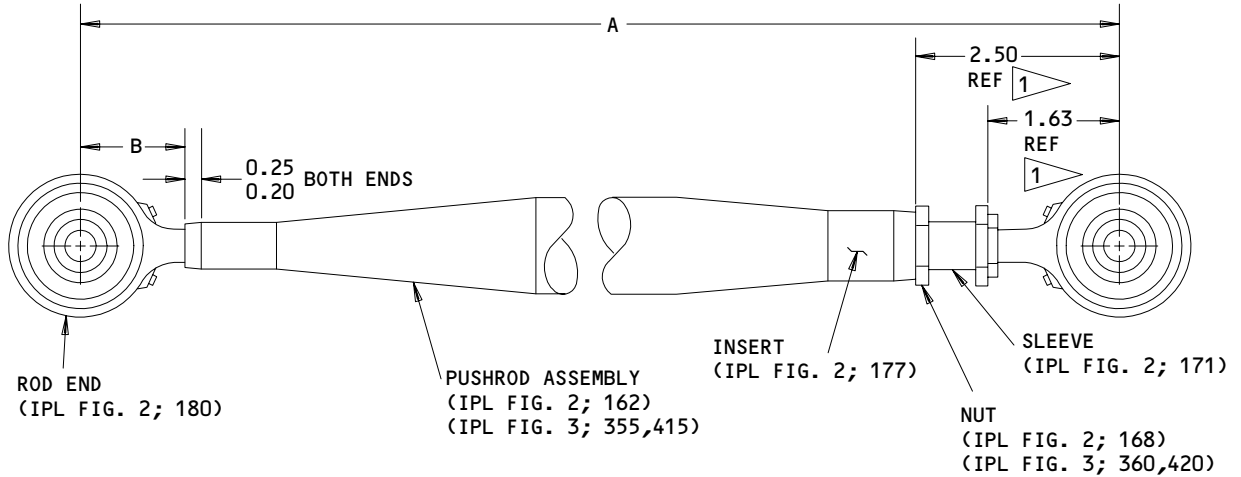
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ASSEMBLY

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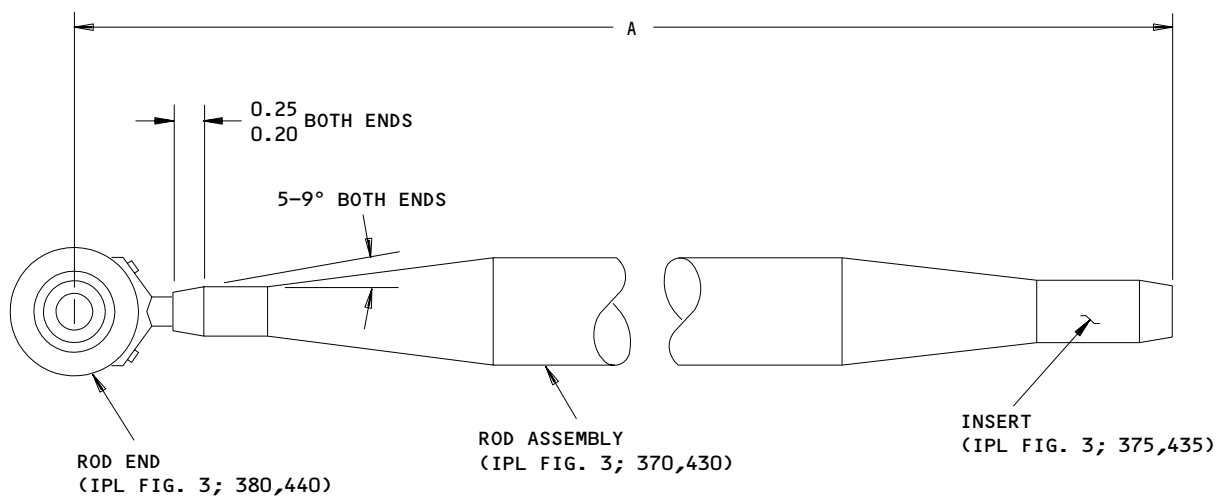
1 PUSHROD ASSEMBLY (IPL FIG. 2; 162) ONLY

ALL DIMENSIONS ARE IN INCHES

Rod Assembly Dimensions
 Figure 702 (Sheet 1)

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ASSEMBLY
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ALL DIMENSIONS ARE IN INCHES

Rod Assembly Dimensions
 Figure 702 (Sheet 2)

IPL FIG & ITEM	DIMENSION "A" (INCHES)	DIMENSION "B" (INCHES)
2 - 24	8.23 - 8.27	-
2 - 162	18.68 - 18.72	1.25 - 1.27
3 - 140	4.46 - 4.52	-
3 - 355	18.48 - 18.52	-
3 - 370	17.39 - 17.43	-
3 - 415	20.36 - 20.40	-
3 - 430	19.27 - 19.31	-

ROD ASSEMBLY DIMENSIONS
 Figure 702 (Sheet 2)

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ASSEMBLY
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01.1

IPL FIG & ITEM	NAME	TORQUE (LB-INCHES)
2 - 27	Rod end	800 maximum
2 - 168	Nut	150-200
2 - 177	Insert	800 maximum
2 - 180	Rod end	200 maximum
3 - 360	Nut	20-30
3 - 375,435	Insert	100 maximum
3 - 380	Rod end	90 maximum
3 - 420	Nut	20-30

ROD ASSEMBLY COMPONENT TORQUE TABLE
 Figure 703

5. Preassemble Pushrod Assemblies (85A, IPL Fig. 3) as follows:

- A. Install insert (145) with BMS 5-95 sealant or Metalset A-4.
- B. Install bearing (150) with BMS 5-95 sealant or Metalset A-4 to the dimensions shown in Fig. 704.
- C. Swage each end of rod (155) so that the bearing and the insert can withstand 200 inch-pounds (maximum) torque.
- D. Assemble pushrod assembly (85A) items 90 thru 140 dimensions shown in Fig. 704.

NOTE: The lower support (100) and the upper support (135) have dry film lubricated surfaces which must be kept clean and protected from mechanical damage during assembly.

- (1) Fill the hollow shank of bearing (95) with BMS 5-28, type 6 or type 4, and allow to harden.
 - (2) Make sure that the two drain holes in the lower support (100) are clear.
- E. Do an operation check of the pushrod assembly (85A) as follows:
- (1) Slowly compress the assembly. The breakout force must be 56 to 78 pounds.

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- (2) Continue to compress the assembly until it bottoms out. The compressed (or bottomed out) force shall be 132 to 172 pounds.
- (3) Make sure the assembly can be compressed a minimum of 1.23 inches.
- (4) Slowly allow the assembly to extend. Make sure the assembly can compress and extend smoothly and there is no indication of binding or scraping of parts.

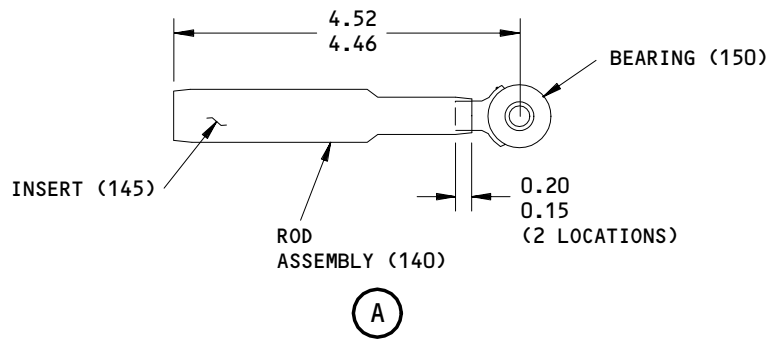
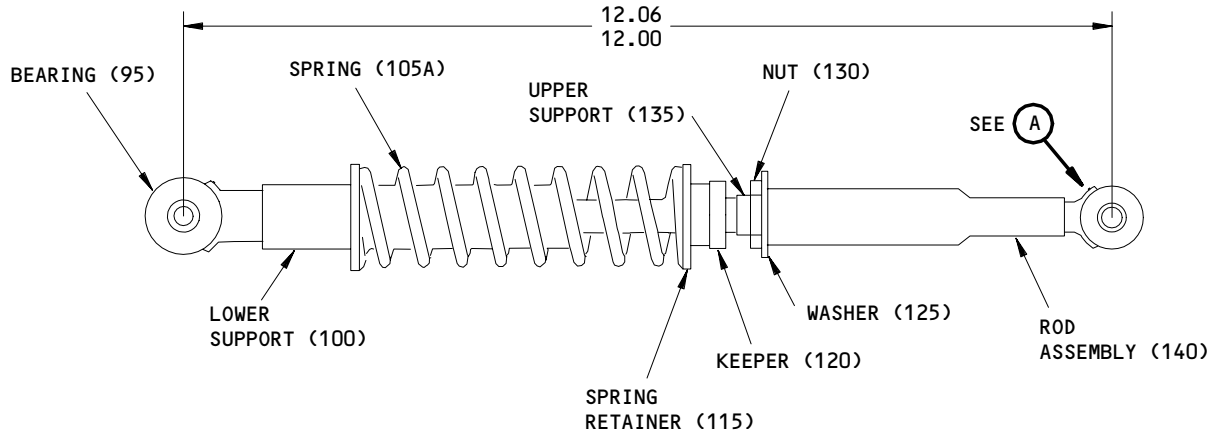
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ITEM NUMBERS REFER TO IPL FIG. 3

Rod Assembly Dimensions
 Figure 704

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6. Install Door Structure Assembly (230, IPL Fig. 1) Components

- A. Assemble and install the lift link fitting assemblies (1B, 5A, IPL Fig. 4).
- (1) Use BMS 5-95 sealant as specified in 20-50-03 to fay surface seal the retainer plate assembly (20) to the fitting (60A, 65A). Temporarily install a 7/8-inch diameter bolt to make sure the nut (25) is aligned correctly before sealing. Attach the retainer plate assembly to the fitting with bolts (10) and nuts (15).
 - (2) Install the lift link fitting assemblies (1B, 5A) with fasteners (235 thru 270, IPL Fig. 1) as shown in Fig. 705.

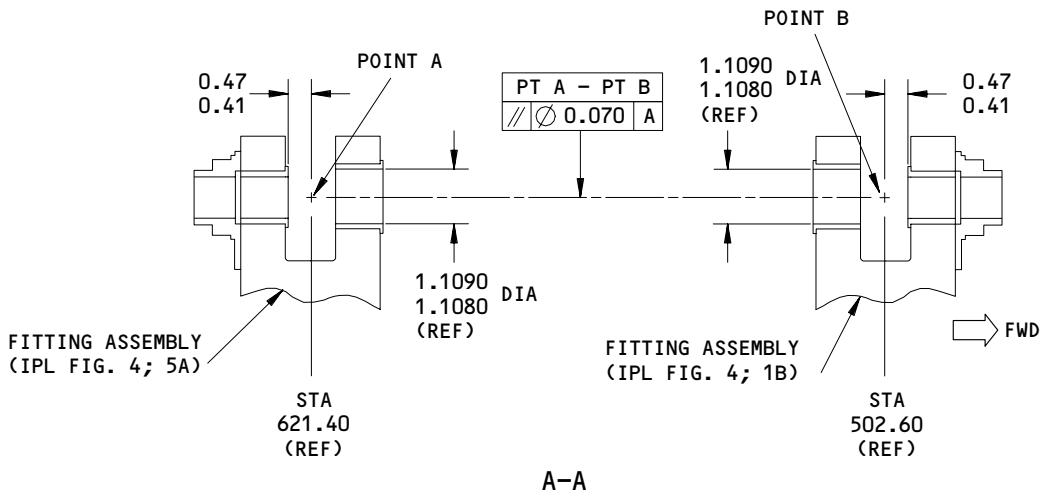
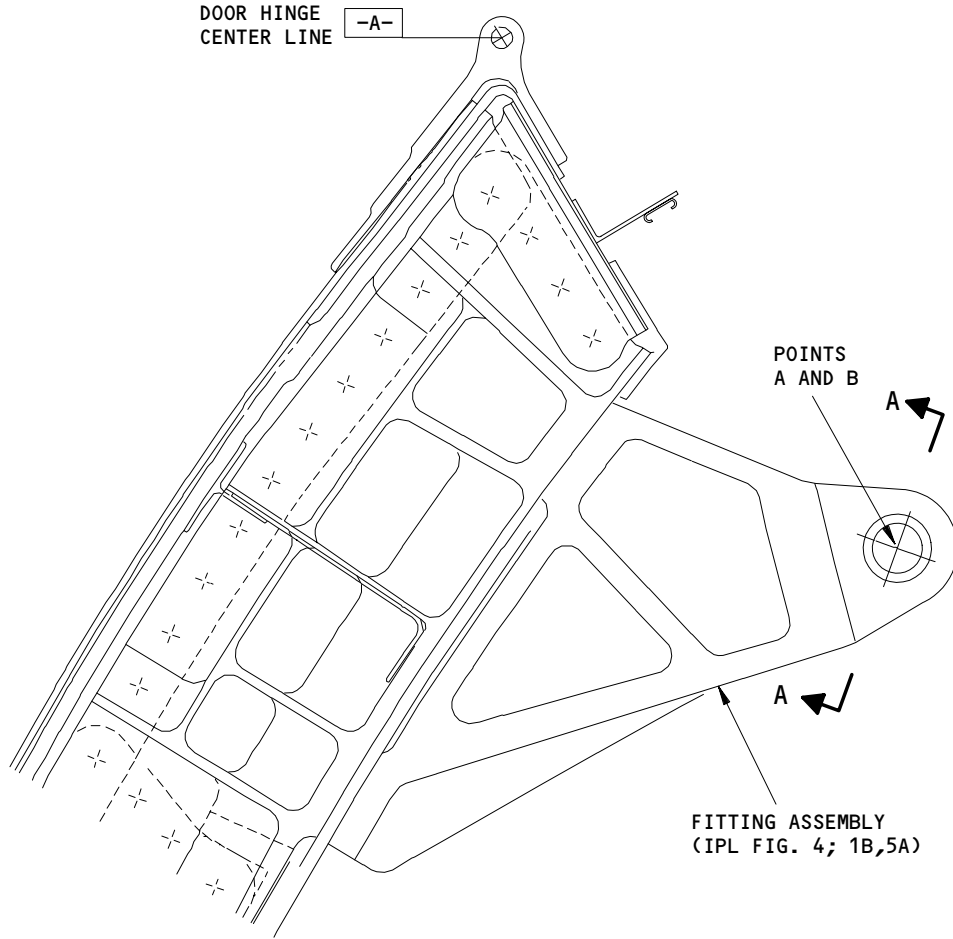
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Lift Link Fitting Assembly Installation
Figure 705

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- B. Install the centering roller ramp fittings (305, 310) and shims (315 thru 350) with fasteners (285A thru 300). Torque the nuts (300) only enough to overcome the self-locking feature. The final torque is given during rigging.
- C. Install the bracket assembly (380) for the latch lock idler support and shims (395, 400) with fasteners (355 thru 375) and BMS 5-95 faying surface seal for corrosion protection. The maximum allowable gap between the bracket assembly and any mating parts is 0.010-inch after shimming. Install the shims with wet BMS 10-11, type 1 primer after delamination.
- D. Install the bearing plate assemblies (430, 435) with fasteners (405 thru 425). Make sure the rigging pin hole in the bearing plate assembly is aligned with the hole in the frame.
- E. Install the vent door torque tube support fittings (470, 485) with fasteners (450 thru 465 and 475, 480). Position support fittings (485) so that the up standing flanges are aligned within 0.010-inch of the up standing flanges of support fittings (470).
- F. Install the lower latch observation window installation (490, IPL Fig. 1; 1A, IPL Fig. 5) components. (The item numbers that follow are from Fig. 5).
- (1) Install bolts (5) with BMS 5-95 sealant.
 - (2) Apply BMS 5-95 faying surface sealant between the doubler (35) and the filler (30), and between the filler (30) and the door exterior skin.
 - (3) Apply BMS 5-142 sealant as shown in Fig. 706. Fillet seal with BMS 5-142 sealant as shown in Fig. 706.

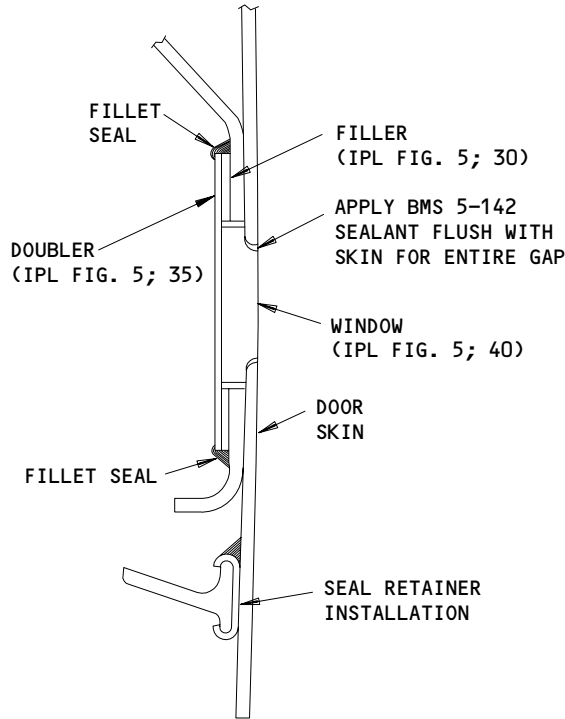
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Observation Window Sealant Application
 Figure 706

F27644

- G. Install upper beam installation (495, IPL Fig. 1; 1A, IPL Fig. 6; 1A, IPL Fig. 19) components (the item numbers that follow are from Fig. 6 and Fig. 19).
- (1) Install hinge fittings (190 thru 230, IPL Fig. 6; 185 thru 225, IPL Fig. 19).
 - (a) Install a pin through the hinge fitting to be installed and the adjacent hinge fittings to maintain the centerline of the hinges.
 - (b) Remove the 0.003-inch laminations from the shims (235 thru 270, IPL Fig. 6; 230 thru 265, IPL Fig. 19) as necessary to align the hinge fitting centerlines. The maximum shim thickness is 0.080-inch. The maximum allowable gap after delamination is 0.004-inch. After delamination, finish the shim with wet or dry BMS 10-11, type 1 primer. Use BMS 5-95 to fay surface seal between the door and the shim and the shim and the hinge fitting.

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- (c) Apply BMS 5-95 sealant to all bolts (85 thru 145) and their related nuts that go through the outer skin. Torque the nuts as shown in Fig. 707. Retorque the nuts as shown in Fig. 707 after the sealant has stopped squeezing out. For bolts (60 thru 80), install the washers (150, 155) under the nuts (165, 170) only.

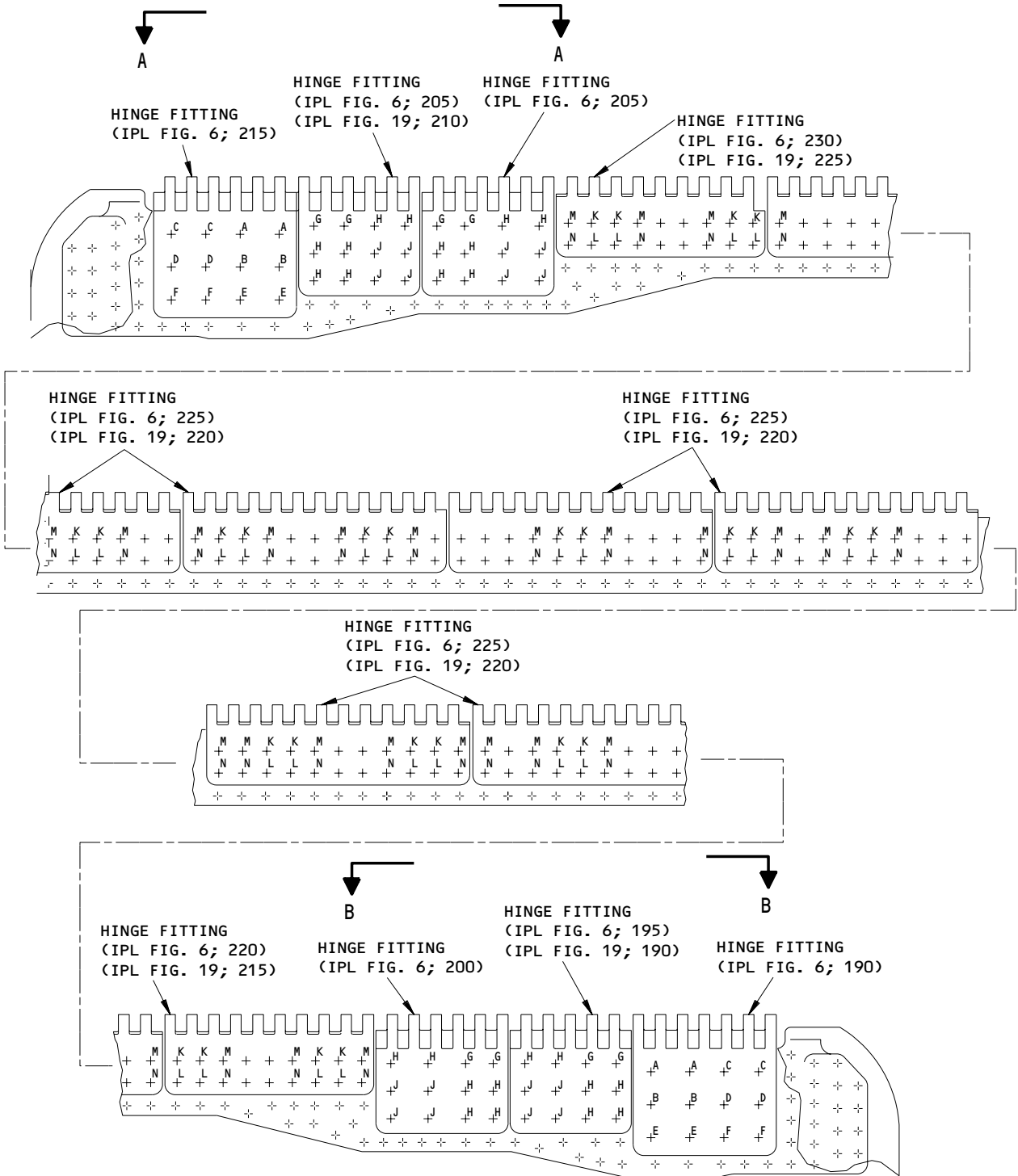
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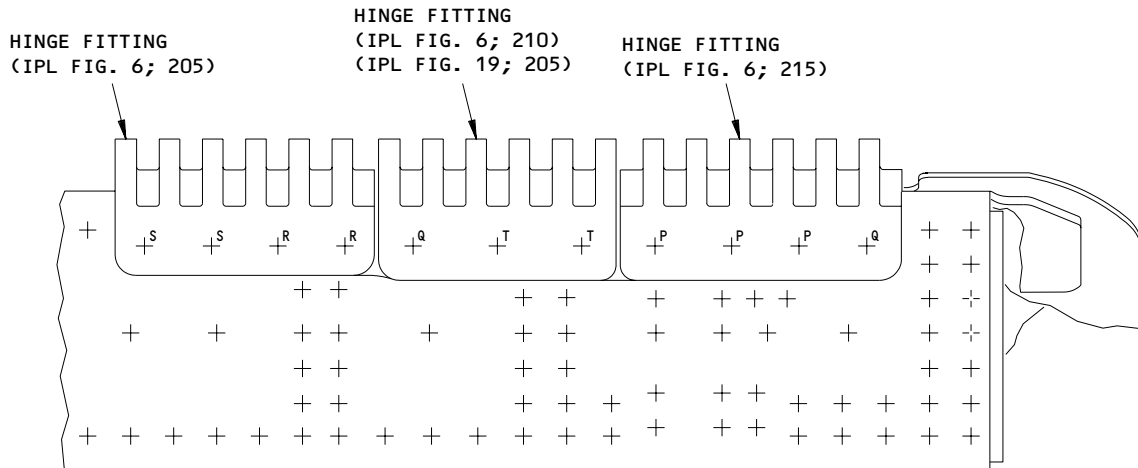


Upper Hinge Fitting Installation
Figure 707 (Sheet 1)

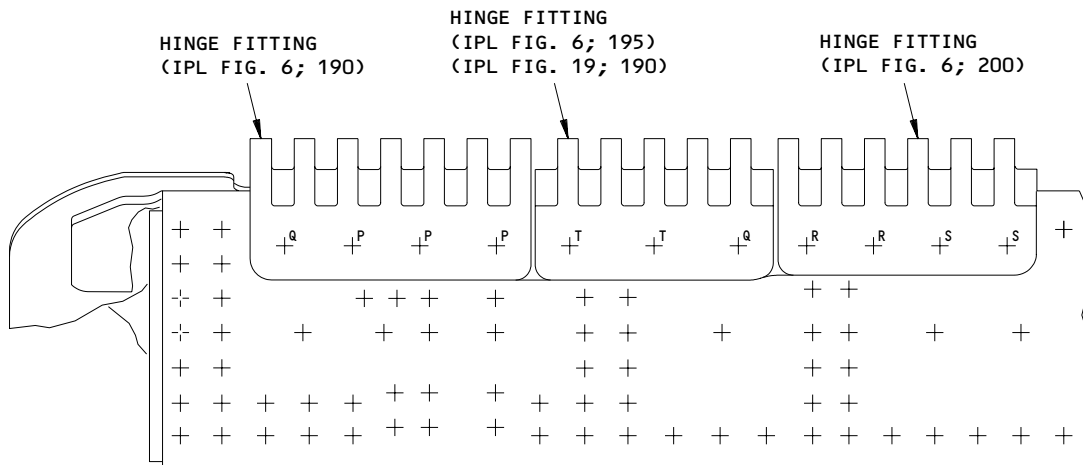
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A-A



B-B



Upper Hinge Fitting Installation
 Figure 707 (Sheet 2)

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DOOR HINGE FASTENERS			
CODE	BOLT ITEM NUMBERS	NUT TORQUE 	NUT RETORQUE 
A	85	300-410 IN-LBS	370-450 IN-LBS
B	95		
C	90		
D	100		
E	105	200-240	220-265
F	110	200-240	220-265
G	115	150-200	180-220
H	120		
J	125		
K	130	75-100	90-110
L	135		
M	140		
N	145		
P	65	300-360	325-395
Q	60	300-360	325-395
R	75	150-200	180-220
S	80	150-200	180-220
T	70	300-360	325-395



 INITIAL TORQUE

 TORQUE AFTER SEALANT HAS SQUEEZED-OUT

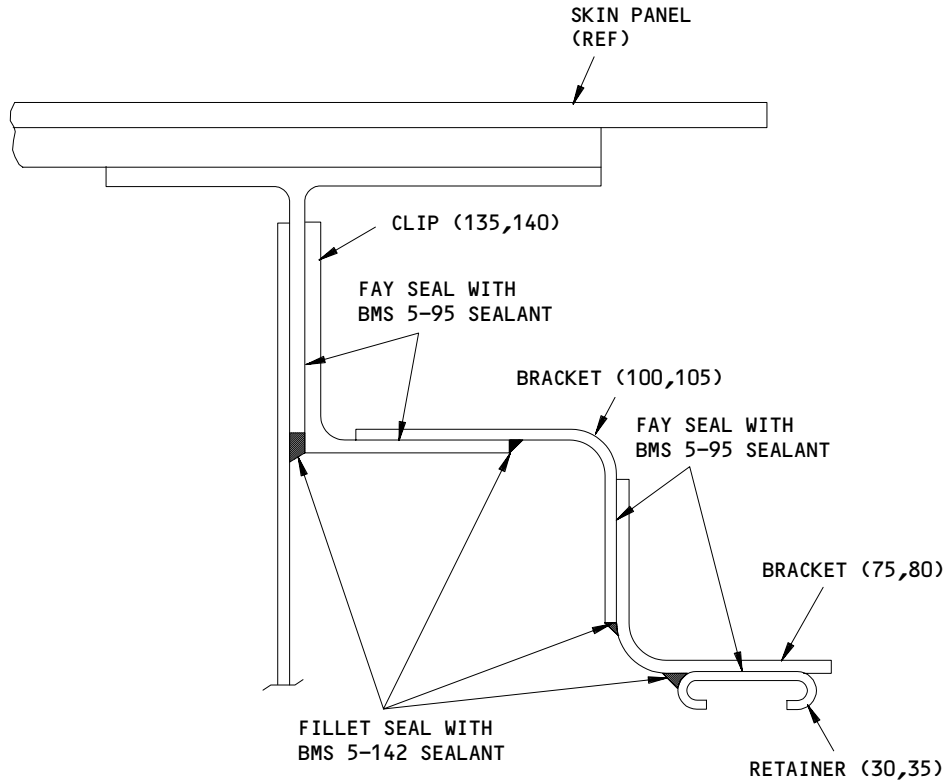
Upper Hinge Fitting Installation
 Figure 707 (Sheet 3)

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- H. Install the seal support installation (500, 505, IPL Fig. 1; 1A, 5, IPL Fig. 7) components with BMS 5-95 sealant on faying surfaces as shown in Fig. 708. Fillet seal areas shown in Fig. 708 with BMS 5-142.



ITEM NUMBERS REFER TO IPL FIG. 3

Seal Support Installation Sealant Application
Figure 708

F28301

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- I. Install the Number 8 midspan idler support intercostal installation (510, 515, IPL Fig. 1; 1A, 5, IPL Fig. 8) components with BMS 5-95 sealant on faying surface of fitting assembly (65, 70, IPL Fig. 8) and skin. Use a maximum of one shim (35) at each location. Apply wet or dry BMS 10-11, type 1 primer to the delaminated surface before shim installation. The maximum allowable gap after shimming is 0.010-inch.
- J. Install the Number 9 intercostal installation (520, IPL Fig. 1; 1A, IPL Fig. 9) components.
- (1) Install a maximum of one shim (100, 140, 145) at each location. Install the shim to get a shim edge margin equal to or greater than two times the diameter of the fastener that penetrates the shim. Remove laminations as necessary and apply wet or dry BMS 10-11, type 1 primer to the delaminated surface before shim installation. The maximum gap after shim installation is 0.010-inch.
 - (2) Fay surface seal the interface between the rain seal (35) and the door web with BMS 5-95 sealant.
 - (3) Bond grommets (105) as specified in 20-50-12, type 70 or 82.
- K. Install the station 495.5 and 628.5 frame installation (595, 600, IPL Fig. 1; 1A, 5, IPL Fig. 14) components. (The item numbers that follow are from Fig. 14.)
- (1) Make sure the maximum gap between the ramp support fitting (125, 130) and the pull-in hook support fitting assembly (175, 180) does not exceed 0.005-inch before you tighten the fasteners. Use shim (140) if and as necessary to remove the gap. Remove the 0.003-inch laminations from the shim to adjust the thickness and taper. Apply two coats of BMS 10-11, type 1 primer to the delaminated shim before installation.
 - (2) Fill the gap between the ramp support fitting (125, 130) and the door structure to within 0.004 inch with shim (135) before you tighten the fasteners. Remove the 0.003 laminations as necessary and apply wet or dry BMS 10-11, type 1 primer to the delaminated surface before shim installation.

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- L. Install the lower beam installation (605, IPL Fig. 1; 1A, IPL Fig. 15) components. (The item numbers that follow are from Fig. 15 unless specified differently.)
- (1) Install the latch shear fitting assemblies (165).
 - (a) Remove 0.003 inch laminations from shims (155, 160) as necessary to position the centerline of the shear fittings within 0.010 inch of the centerline of the bushings in the frame fittings (80, 85, IPL Fig. 11; 55, 60, 65, IPL Fig. 12; 100, 105, IPL Fig. 13). Install shims (155, 160) with wet or dry BMS 10-11, type 1 primer applied to the delaminated surface.
 - (b) Corrosion fay seal the shear fitting assemblies and shims (160) to the outer skin installation (610, IPL Fig. 1) with BMS 5-95 sealant.
- M. Install the outer skin installation (610, IPL Fig. 1; 1A, IPL Fig. 16) components. (The item numbers that follow are from Fig. 16.)
- (1) Install the rain gutter (30), bearing plate (45), and doubler (75) with BMS 5-95 sealant on the faying surfaces.
 - (2) Install all non-aluminum fasteners that go through the outer skin with BMS 5-95 sealant.
7. Assemble and install the latch and hook installation (5, IPL Fig. 1; 1A, IPL Fig. 2) components. (The item numbers that follow are from Fig. 2 unless specified differently.)
- A. Assemble adapter assembly (585) by bonding seal (588) to adapter (591) as specified in 20-50-12, type 93.
 - B. Lubricate packing (594) with MIL-G-23827 grease and put it in the adapter assembly (585) groove.
 - C. Assemble the retainer assembly (597) by bonding seal (606) to retainer (609) as specified in 20-50-12, type 60.
 - D. Install the retainer assembly (597) loosely in place.
 - E. Install actuator (621).
 - (1) Attach the mounting plate (627) to the actuator (621) with fasteners (621 thru 618).

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- (2) Slide the stop lever (684) into position on the torque shaft (705); thoroughly lubricate splines with BMS 3-24 grease before installation.

NOTE: Avoid excessive torque of tangent bolts (687) by applying only the minimum torque necessary to lock nut (696) and clamp splines snugly.
 - (3) Slide the bellcrank assembly (630) with associated fasteners (633 thru 642) into position on the torque shaft (705).
 - (4) Install the torque shaft (705) and attached parts in the door.
 - (5) Put the bearing housing (747), bearing (750) and bearing retaining plate (753) on the torque shaft (705). Install the bearing (750) with BMS 3-24 grease.
 - (6) Lubricate the splines of connector (657) with BMS 3-24 grease and attach to the actuator (621) end of the torque shaft (705) with fasteners (660 thru 669).
 - (7) Install the actuator (621) and attached mounting plate (627) with bolts (732), washers (735, 738), shims (744) and nuts (741). Remove 0.003 inch laminations from shims (744) as necessary to align the actuator (621) shaft with the connector (657). After delaminating, install shims (744) with wet or dry BMS 10-11 primer (F-20.05).
 - (8) Install jumper assembly (564) with fasteners (549 thru 561).
- F. Install the adapter assembly (585) with bolts (582).
- G. Install items (708 thru 729).
- H. Install bearing housing assemblies (516, 519), bearings (540, 543), and retaining plates (546) with fasteners (492 thru 513). Install bearings (540, 543) with BMS 3-24 grease. Lubricate bearing housing assemblies (516, 519) with BMS 3-24 grease after assembly.
- I. Install torque shafts (699, 702) and associated components (567 thru 579, 630 thru 669 and 756 thru 783). Install bearings (780) with BMS 3-24 grease. Coat splines on connectors (567, 654) thoroughly with BMS 3-24 grease before installation.

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- J. Install bellcrank assemblies (450, 453), thrust rings (672 thru 681), bearing housings (774, 777), bearing retaining plate (783) and bearings (780) with bolts (756), washers (762, 765) and nuts (771). Install bearings (780) with BMS 3-24 grease. Use thrust rings (672 thru 681) as necessary to adjust the end play to 0.010 to 0.030 inch.
- K. Install items (420 thru 447 and 474 thru 489). Install bearings (489) with BMS 3-24 grease. Use thrust rings (531 thru 537) as necessary to limit end play to 0.010 to 0.030 inch. Lubricate splines of bellcrank assembly (432) with BMS 3-24 grease before installation.

CAUTION: DO NOT INSTALL A LONGER BOLT THAN THAT SPECIFIED FOR BOLT (387). A LONGER BOLT CAN CAUSE INTERFERENCE WITH BEARING HOUSING (516, 519).

- L. Install adjustable tie rod components (384 thru 417). Install bolts (384, 387) with BMS 3-24 grease.

CAUTION: CRANK FITTING ASSEMBLY (87, 90) COMPONENTS MAKE A MATCHED SET AND MUST BE KEPT TOGETHER TO MAKE SURE OF CORRECT OPERATION AFTER ASSEMBLY.

- M. Install crank fitting assemblies (87, 90) and associated components (33 thru 138).
- (1) Install bearing housing (63), rigging plate (48), and fasteners (51 thru 60, 66 thru 78).
 - (2) Install bearing housing (123) and fasteners (126 thru 138).
 - (3) Slide collar (45) and bearing (81) onto latch fitting (117); assemble crank fitting assemblies (87, 90) and position in door. Install bearings (81, 120) with BMS 3-24 grease. Install fasteners (33 thru 42).
 - (4) Add shim washers (84) as necessary to give 0.010 to 0.030 inch gap between bearing (120) and bellcrank (105) (Fig. 709).

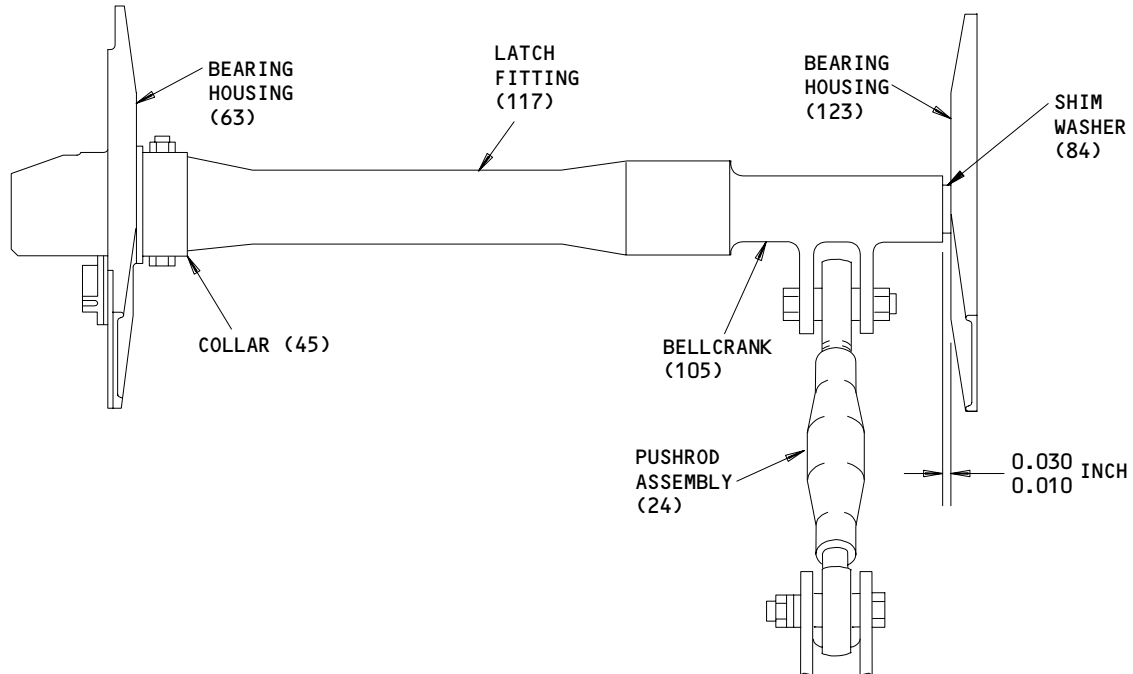
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ITEM NUMBERS REFER TO IPL FIG. 2

Bellcrank Clearance
 Figure 709

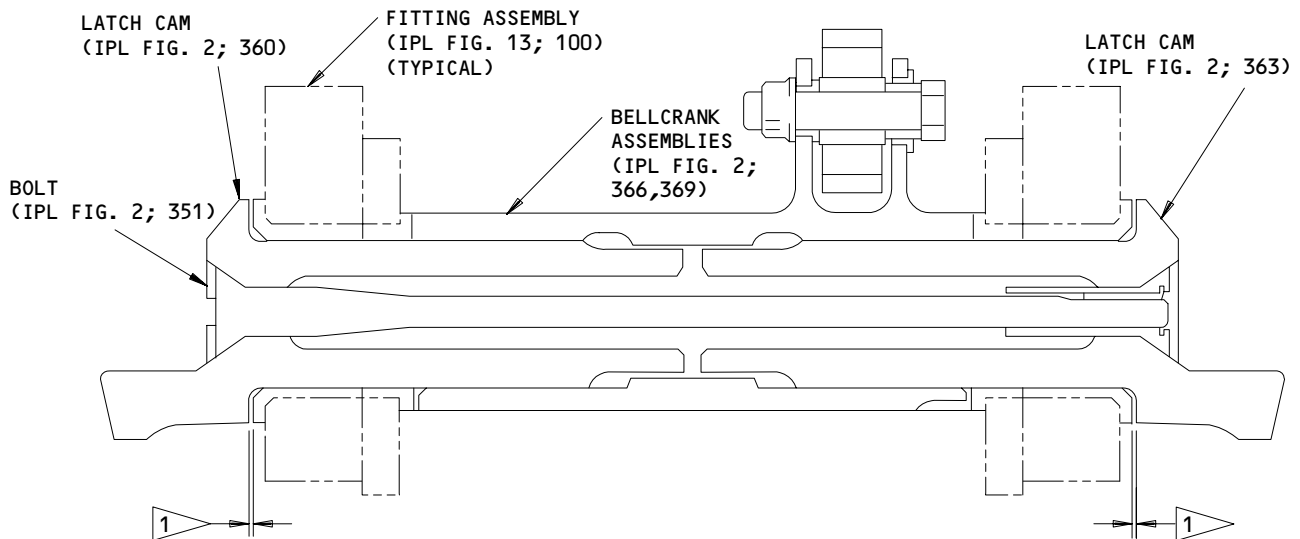
- N. Install idler assemblies (207, 210) with fasteners (186 thru 204). Install bolts (186, 189) with BMS 3-24 grease. The bolt (186, 189) heads at Sta 508 must be on the forward side of the idler assembly (207) and the aft side of the idler assembly (207) at Sta 615.
- O. Install pushrod assemblies (24, 162) and attaching parts (3 thru 21 and 141 thru 159). Install bolts (3, 141, 144) with BMS 3-24 grease. Lubricate pushrod assemblies (24, 162) with BMS 3-24 grease after installation. Make sure the bolts (3, 141, 144) used to connect the pushrod assemblies (24, 162) to the idler assemblies (207, 210) are installed with the bolt heads on the forward side of the idler assembly at Sta 508 and the aft side of the idler assembly at Sta 615.
- P. Install idler assemblies (315, 318) and attaching parts (300 thru 312). Install bolts (300) with BMS 3-24 grease.

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- Q. Install pushrod assemblies (255) and attaching parts (228 thru 252). Install bolts (228, 231, 234) with BMS 3-24 grease. The bolt heads must be on the forward side for all pushrod installations but the aft (Sta 615) one. The longer bolt (234) and two washers (240) are installed at Sta 595 for the attachment of the pushrod assembly (255) to the idler assembly (315). The extra washer (240) installed at Sta 595 will be removed during the sensor installation.
- R. Install items (273 thru 297 and 336 thru 381).
- (1) Prepack interior of bellcranks (378, 381) with BMS 3-24 grease before installation.
 - (2) Lubricate splines and coat surfaces of latch cams (360, 363) with BMS 3-24 grease before installation.
 - (3) Install bellcrank assemblies (366, 369).
 - (4) Install latch cams (360, 363) and fasteners (351 thru 357). The total gap at one end of the cams is to be 0.005 to 0.015 inch when the gap at the other end of the cam pair is zero (Fig. 710).
 - (5) Install straps (348), and pushrods (297).



1 TOTAL GAP AT ONE END IS TO BE 0.005-0.015 INCH WHEN GAP AT OTHER END OF CAM PAIR IS ZERO

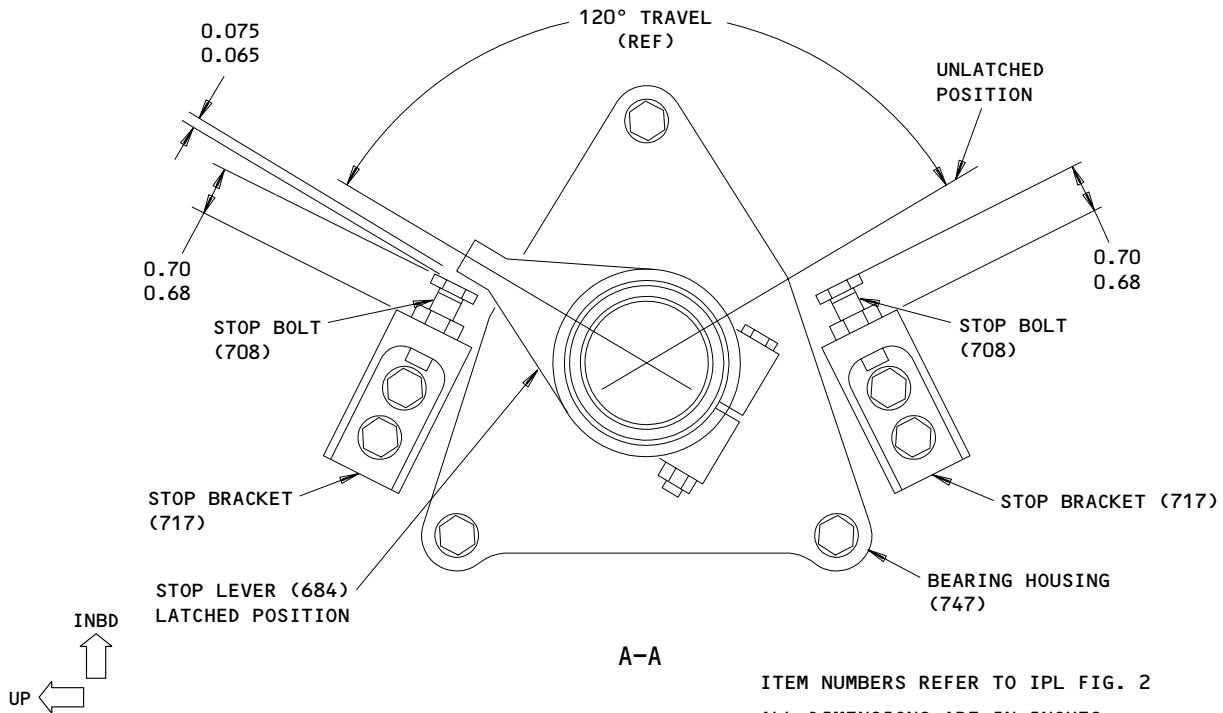
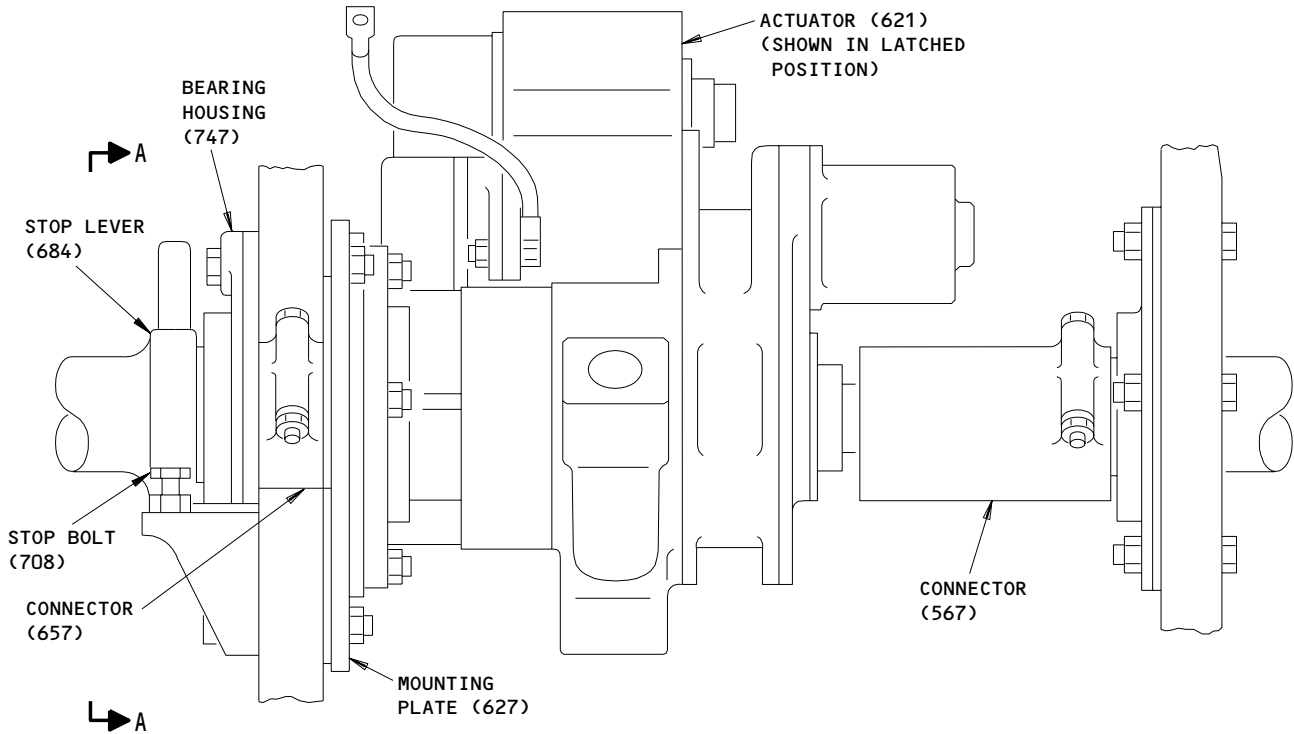
Latch Cam Clearance
 Figure 710

8. Rig Latch and Hook Installation (1, IPL Fig. 2)
 - A. If installed, set the latch lock installation (1, IPL Fig. 3) in the Unlocked position (vent doors open).
 - B. Set the actuator stop bolts (708, IPL Fig. 2) to the dimensions shown (Fig. 711).
 - C. Using the manual drive port on the outside of the door, rotate the stop lever (684) to the Latched position as shown in Fig. 711.

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**COMPONENT
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**Actuator Rigging
Figure 711**

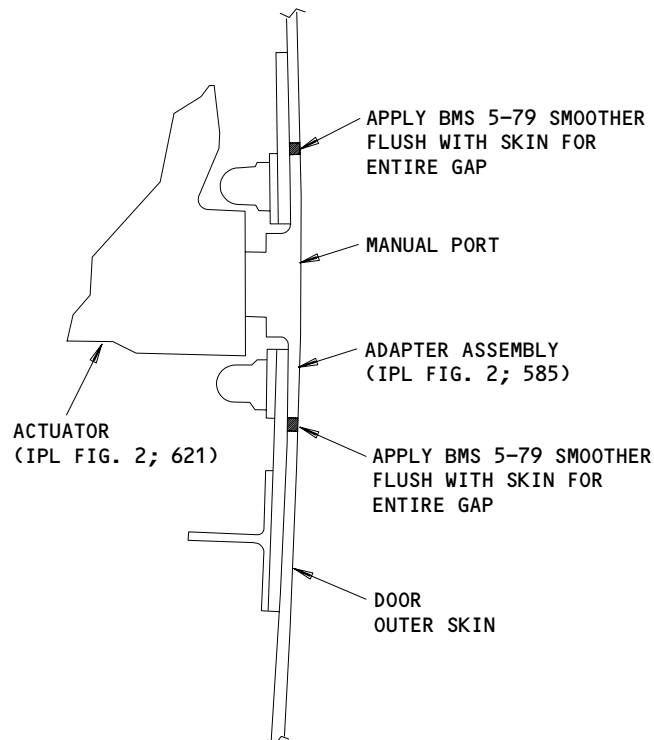
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- D. Adjust the six pushrod assemblies (255), the upper two pushrod assemblies (162), and two rod ends (414, 417) until 0.18- to 0.19-inch diameter rig pins can be inserted through the six idler assemblies (315, 318), two midspan latch fittings (87, 90), and two pull-in hooks (444A, 447A) into rig pin holes and fittings.
- E. Make sure that the two lower pushrod assemblies (162) are set to a length of 18.70 inch.
- F. Manually rotate the stop lever from Latched to Unlatched to verify that the mechanism operates smoothly and no interferences occur.
- G. Lockwire the pushrod assemblies (255, 162), rod ends (414, 417) and stop bolts (708) as specified in 20-50-02. Use the double-twist method.
- H. Lubricate pushrod assemblies (24, 162, 255), rod ends (414, 417) with BMS 3-24 grease.
- I. Apply aerodynamic smoother BMS 5-79 around the manual port as shown in Fig. 712.



Actuator Sealing
Figure 712

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9. Assemble and Install the Latch Lock Installation (10, IPL Fig. 1; 1, IPL Fig. 3)

NOTE: Pushrod assemblies (85, 355, 415) are installed during the rigging procedure of the latch lock installation (10, IPL Fig. 1; 1, IPL Fig. 3)

- A. Install the vent door assembly (195) with fasteners (160 thru 190). Install the fasteners with BMS 3-24 grease on all surfaces.
- B. Install the support fitting assembly (605) with bolts (505), washers (515, 525), shims (600), and nuts (530). Remove the laminations from the shims (600) as necessary to fill the gap between the support fitting assembly and the structure. Apply wet or dry BMS 10-11, type 1 primer to the delaminated surface before shim installation.
- C. Assemble and install the vent door mechanism crank assembly (535).
 - (1) Assemble items (540 thru 575). Coat all surfaces of bushings (565) with a light film of MIL-G-23827 grease as specified in 20-50-07 before installation. Install bearings (570) as specified in 20-50-03. Make sure the bearings (570) turn smoothly after assembly.
 - (2) Install the vent door mechanism crank assembly (535) with bolt (500), washers (510, 520) and nut (530). Install the fasteners with BMS 3-24 grease on all surfaces.
- D. Install the spring (35) with fasteners (5 thru 30). Install the fasteners with BMS 3-24 grease on all surfaces.
- E. Install the power unit (315).
 - (1) Install idler assembly (320) with bolt (240), washers (260, 275) and nut (290). Install the fasteners with BMS 3-24 grease on all surfaces.
 - (2) Install power unit (315) with bolts (235, 245), washers (255, 265, 280), bushings (300, 305) and nuts (290, 295). Install the fasteners with BMS 3-24 grease on all surfaces.

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CAUTION: SECTOR SHAFT ASSEMBLIES (770, 775) ARE EACH MATCHED SETS. EACH SECTOR (865) IS A MATCH TO ITS SPECIFIC LOCATION. COMPONENTS MUST BE KEPT TOGETHER TO MAKE SURE THE SHAFT ASSEMBLIES OPERATE CORRECTLY AFTER ASSEMBLY.

F. Install the sector shaft assemblies (770, 775).

- (1) Temporarily install bearing supports (715, 720), bearings (730), washers (705), tubes (870) and shims (725). Remove 0.003 inch laminations from shims as necessary (Fig. 713).

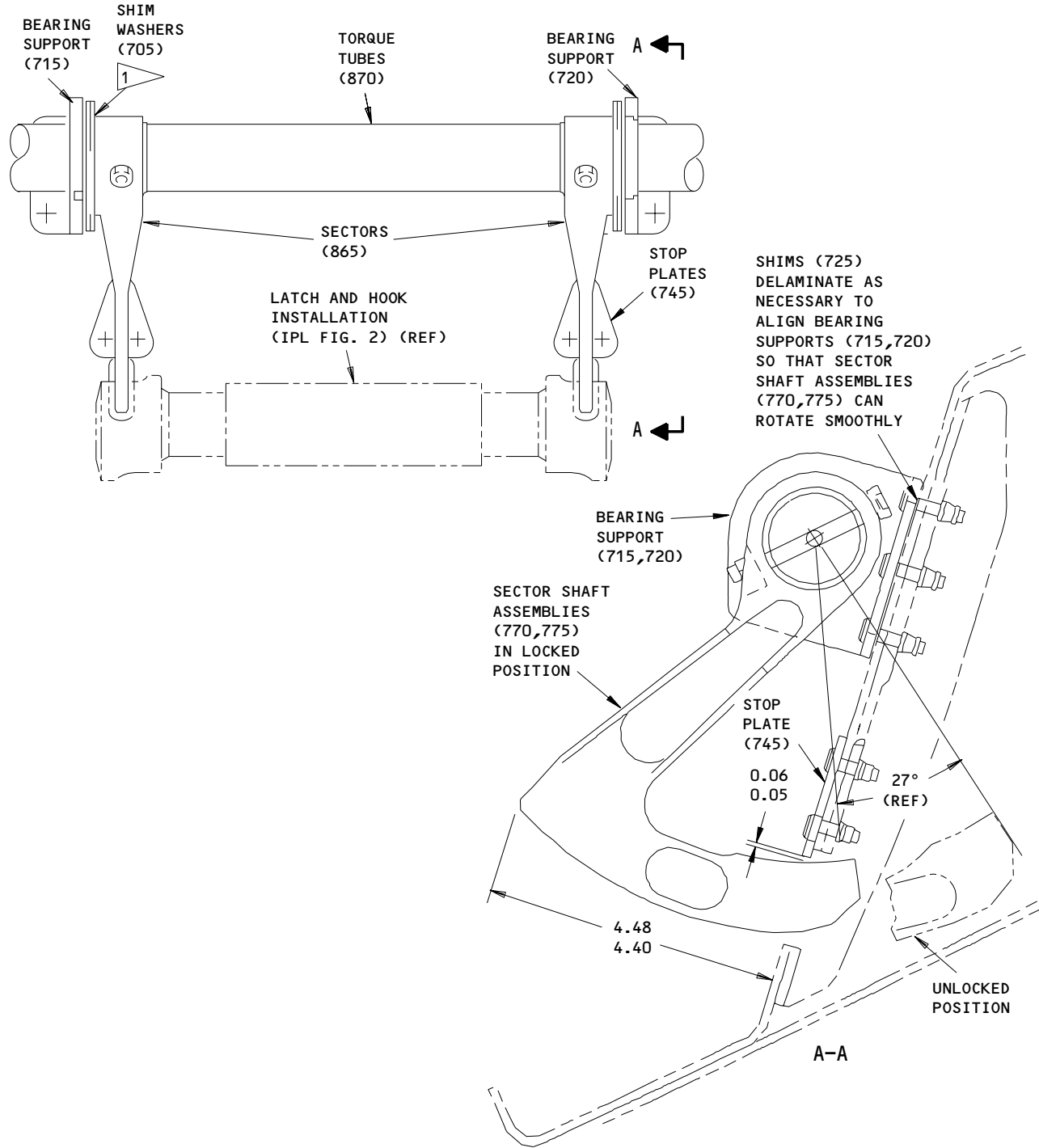
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SHIMS (725)
 DELAMINATE AS
 NECESSARY TO
 ALIGN BEARING
 SUPPORTS (715,720)
 SO THAT SECTOR
 SHAFT ASSEMBLIES
 (770,775) CAN
 ROTATE SMOOTHLY

1 REMOVE OR ADD WASHERS (705) AS REQUIRED TO KEEP A 0.015-0.035 GAP BETWEEN THE BEARINGS (730), SHIM WASHERS (705), AND SECTORS (865)

ITEM NUMBERS REFER TO IPL FIG. 3 UNLESS SHOWN DIFFERENTLY
 ALL DIMENSIONS ARE IN INCHES

**Sector Shaft Assembly Installation
 Figure 713**

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- (2) Install items (700 thru 870) (Fig. 713).
 - (a) Install bearings (730) as specified in 20-50-03 with BMS 5-95 sealant.
 - (b) Remove or add washers (705) as necessary to keep a 0.015 to 0.035 inch gap between the bearing (730), shim washers (705) and sectors (865). Two washers (705) are required at Sta 568.6 and 555.4.
 - (c) Connect the two torque tubes (870) to give a 0.005 to 0.015 inch combined gap between the sectors (865), washers (705) and bearings (730) at Sta 555.4 and 568.6. Remove or add washers (705) as necessary to adjust the gaps at the other 10 locations. After connection of the two torque tubes, all twelve lock sectors (865) must be in alignment within 1 degree.
 - (d) Tighten nuts (765, 795, 835, 860) to 40-50 pound-inches.
 - (e) Install stop plates (745).

CAUTION: ALL TORQUE TUBE ASSEMBLY (625A) COMPONENTS BUT THE FASTENERS COMPOSE A MATCHED SET. COMPONENTS MUST BE KEPT TOGETHER TO MAKE SURE THE ASSEMBLY OPERATES CORRECTLY.

G. Assemble and install items (450 thru 495 and 625A thru 695).

- (1) Put torque tube (695) in position and temporarily install items (450 thru 495).
- (2) Remove 0.003 inch laminations from shim (490) to get zero gap between the shoulder on the torque tube (695) and the bearing (495) at Sta 502.60 and a gap of 0.005 to 0.015 inch between the shoulder on the torque tube (695) and the bearing (495) at Sta 495.50 (Fig. 714).
- (3) Install items (450 thru 495 and 625A thru 695). Install bearings (495) with wet BMS 5-95 sealant as specified in 20-50-03. Apply wet or dry BMS 10-11, type 1 primer to the delaminated surface before shim (490) installation.
- (4) Tighten nut (645) to 40-50 pound-inches.

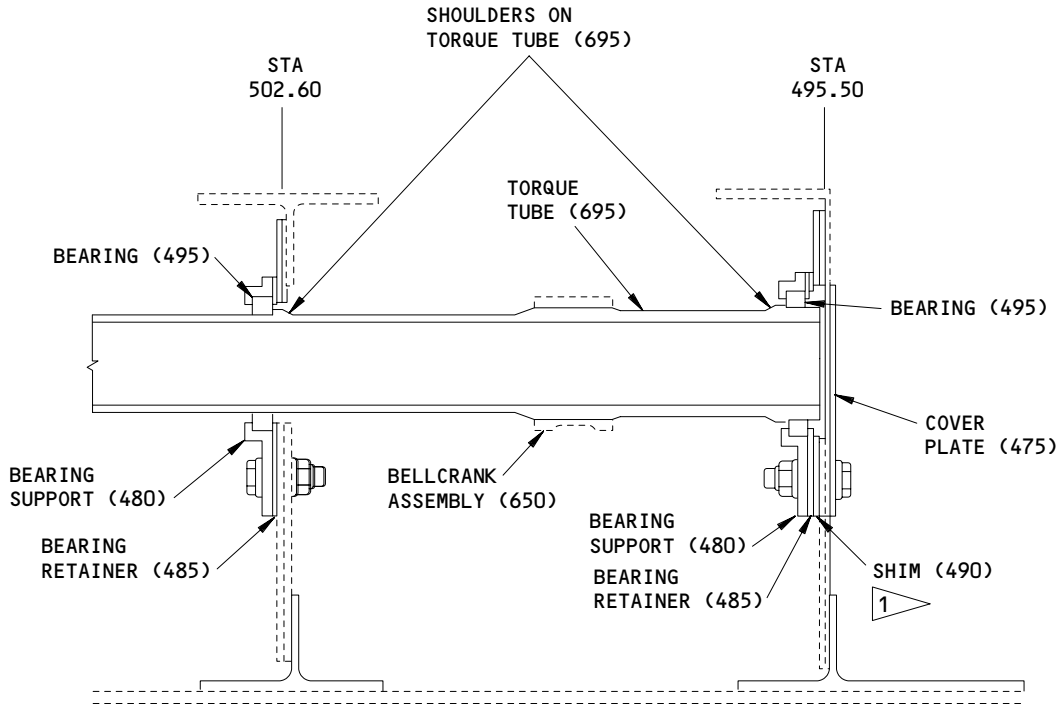
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1 DELAMINATE AS NECESSARY TO GET ZERO GAP BETWEEN TORQUE TUBE SHOULDER AND BEARING AT STATION 495.50, AND 0.005-0.015 INCH GAP BETWEEN TORQUE TUBE SHOULDER AND BEARING AT STATION 502.60

Torque Tube Assembly Placement
 Figure 714

F24773

10. Rig the Latch Lock Installation (1, IPL Fig. 3)

CAUTION: DO NOT EXCEED 15 INCH-POUNDS OF TORQUE AND 500 RPM WHEN YOU OPERATE THE MANUAL DRIVE OF THE POWER UNIT (315).

- A. Turn the manual drive of the power unit (315) clockwise (the actuator will retract) until the actuator stop is contacted.

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**BOEING**
COMPONENT
MAINTENANCE MANUAL

- B. Turn the manual drive of the power unit (315) counterclockwise 2.5 turns (this is the unlocked position for electrical operation).
- C. Adjust the length of the aft pushrod assembly (355) to get the lock sector dimension of 1.81 to 1.85 as shown in Fig. 715. After adjustment, tighten locknut (360) as specified in 20-50-01.

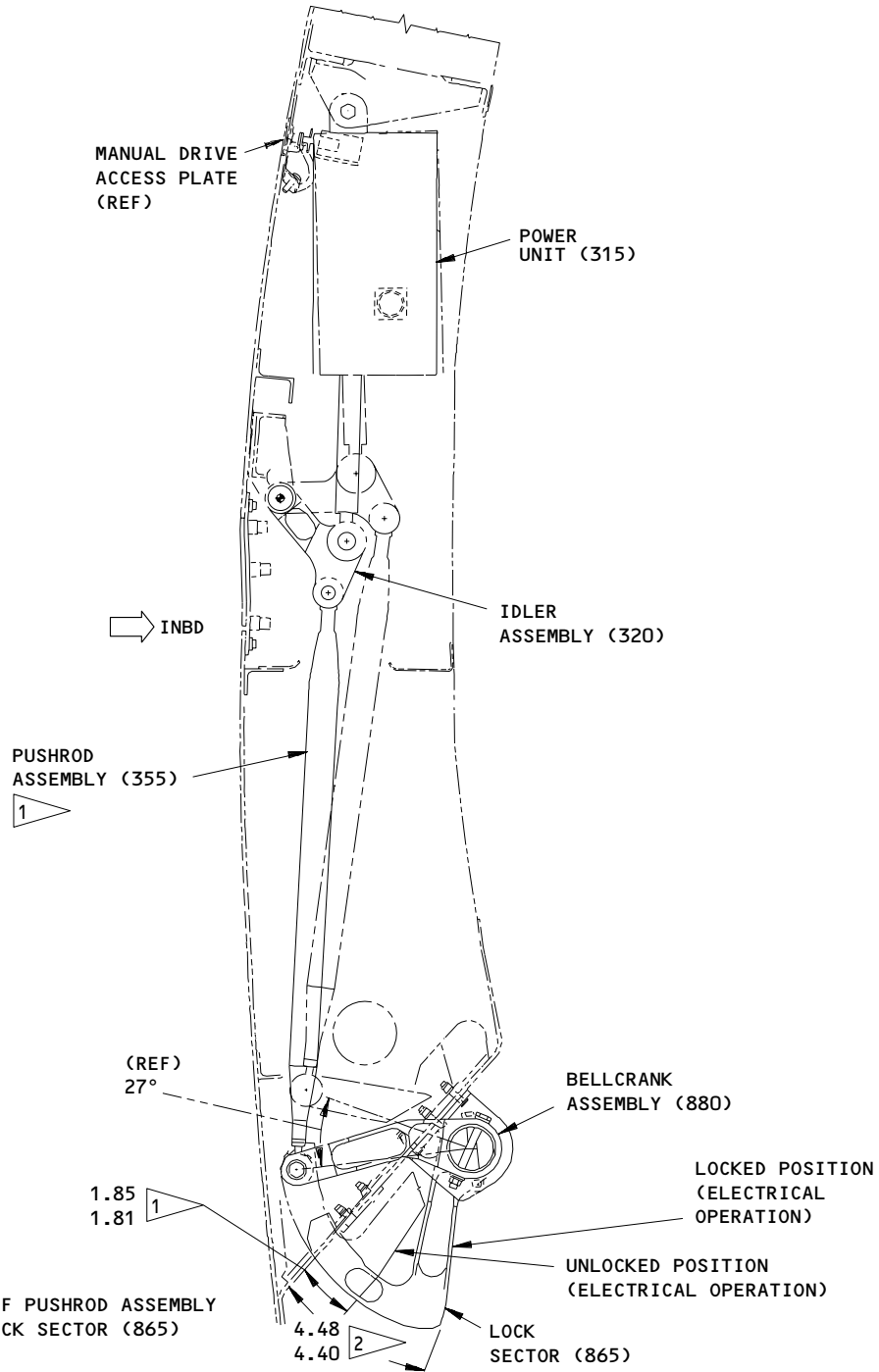
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1 ADJUST THE LENGTH OF PUSHROD ASSEMBLY (355) TO GET THE LOCK SECTOR (865) DIMENSION SHOWN

2 DURING LOCK INSTALLATION CHECK, MAKE SURE THE AFT LOCK SECTOR (865) MEETS THE 4.40 TO 4.48 DIMENSION WHEN THE LOCK INSTALLATION IS IN THE LOCKED POSITION

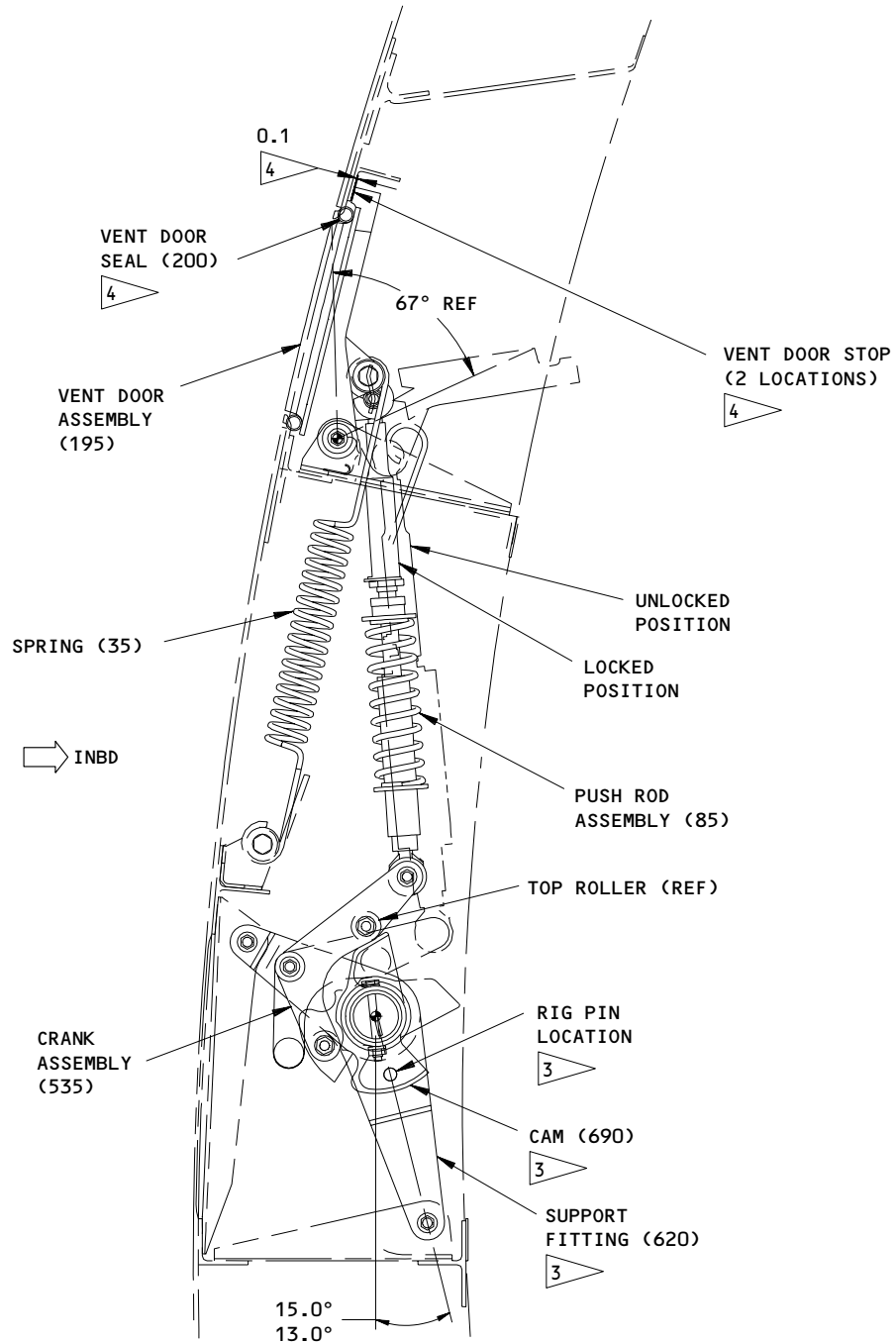
ITEM NUMBERS REFER TO IPL FIG. 3 UNLESS SHOWN DIFFERENTLY
 ALL DIMENSIONS ARE IN INCHES

Latch Lock Installation Rigging and Check
 Figure 715 (Sheet 1)

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- 3 INSERT RIG PIN THROUGH SUPPORT FITTING (620) AND CAM (690)
- 4 ADJUST PUSHROD ASSEMBLIES (85) SO STOPS OF VENT DOOR ASSEMBLY (195) ARE WITHIN 0.1 INCH OF CONTACTING DOOR STRUCTURE

Latch Lock Installation Rigging and Check
 Figure 715 (Sheet 2)

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- D. Examine the adjustable rod end (365) of the pushrod assembly (355) to make sure there is sufficient thread engagement. The rod end (365) must cover at least 50 percent of the tube (385) inspection hole.
- E. Install the aft pushrod assembly (355) so that the inspection hole is inboard with bolts (250), washers (270, 285), bushings (310) and nuts (290). Install the fasteners with BMS 3-24 grease on all surfaces.
- F. Turn the torque tube assembly (625A) until a rig pin can be inserted through each support fitting (620) and vent door mechanism cam (690). Insert a 0.313-inch diameter by 3-inch long rig pin at each location as shown in Fig. 715.
- G. Install and adjust the two pushrod assemblies (85) to cause each vent door assembly (195) to close as far as possible without causing the pushrods to be compressed. The vent doors must be within 0.1 inch of contacting the closed stops at the top of the vent door cut-out. Apply BMS 3-24 grease on all surfaces of the fasteners (40 thru 80). (Fig. 715).
- H. Remove the two rig pins.
- I. Turn the manual drive of the power unit (315) counterclockwise (the actuator will extend) until the actuator stop is contacted. Turn the manual drive clockwise 2.5 turns (this is the locked position for electrical operation).
- J. Without applying any hand pressure to the vent door assemblies (195), adjust the forward pushrod assembly (415) to a length so that the two rig pins can be easily inserted through the support fittings (620) and the cams (690).
- K. Examine the adjustable rod end (425) of the pushrod assembly (415) to make sure there is sufficient thread engagement. The rod end (425) must cover at least 50 percent of the tube (445) inspection hole.
- L. Install the pushrod assembly (415) so that the inspection hole is inboard with fasteners (390 thru 410). Install the fasteners with BMS 3-24 grease on all surfaces.
- M. Make sure that the vent door stops are within 0.10 inch of contacting the structure (Fig. 715).

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- N. Do a check for correct system operation and adjustment.
- (1) Turn the manual drive of the power unit (315) clockwise (the actuator will retract) until the actuator stop is contacted (this is the unlocked position for manual operation).
 - (2) Do a check to make sure that each lock sector (865) does not contact the stop plate (745).
 - (3) Turn the manual drive of the power unit (315) counterclockwise 2.5 turns (this is the unlocked position for electrical operation).
 - (4) Put the latch and hook installation (1A, IPL Fig. 2) in the fully Unlatched position.
 - (5) Make sure that the smallest distance between the lock sector (865) and the latch cam (360, 363, IPL Fig. 2) at all 12 locations is not less than 0.35 inch (Fig. 716).

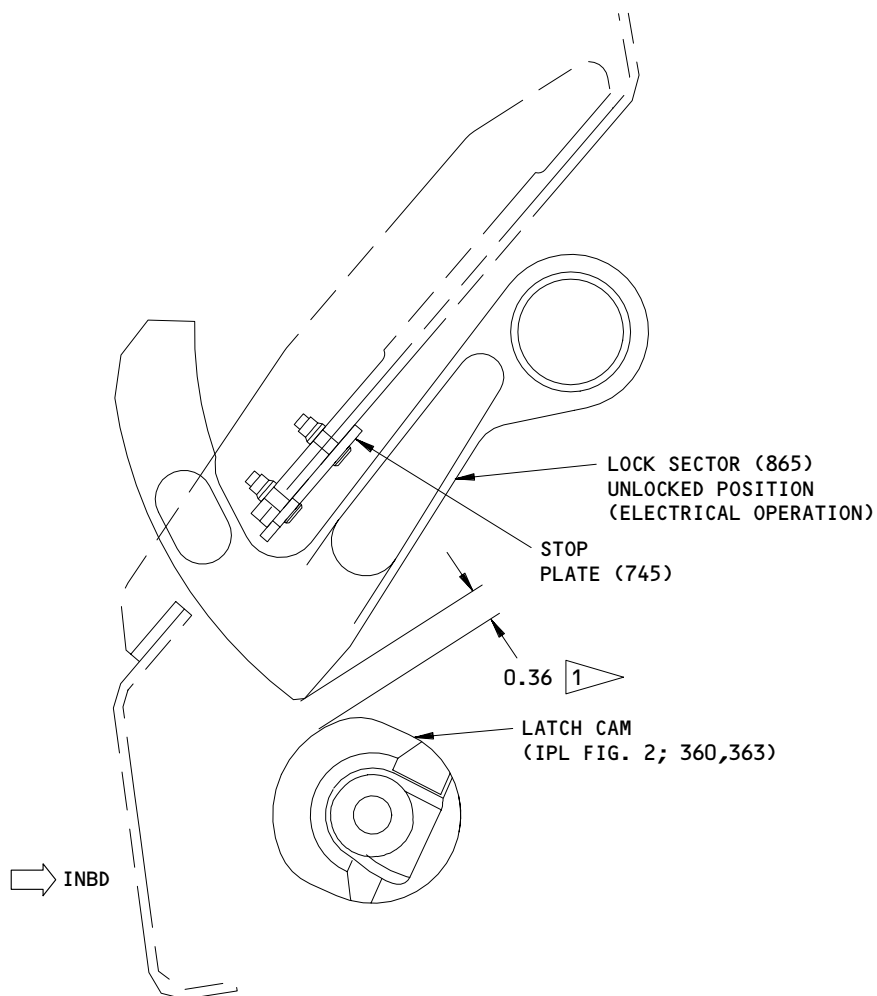
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FOR SYSTEM CHECK ONLY

1 SMALLEST ALLOWABLE DISTANCE BETWEEN THE LOCK SECTORS (865) AND THE LATCH CAMS (IPL FIG. 2; 360,363). THE LOCK INSTALLATION (IPL FIG. 3; 1) IS IN THE UNLOCKED POSITION FOR ELECTRICAL OPERATION AND THE LATCH AND HOOK INSTALLATION (IPL FIG. 2; 1A) IS IN THE FULLY UNLATCHED POSITION. (12 LOCATIONS)

Latch Lock Installation Check
Figure 716

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01.1

- (6) Turn the manual drive of the power unit (315) counterclockwise (the actuator will extend) until the actuator stop is contacted.
 - (7) Turn the manual drive of the power unit (315) clockwise 2.5 turns (this is the locked position for electrical operation).
 - (8) Make sure that the aft lock sector (865) meets the 4.40 to 4.48 dimension as shown in Fig. 715 for the locked position.
 - (9) Make sure that the two rig pins can be easily inserted through each support fitting (620) and vent door mechanism cam (690).
 - (10) Remove the rig pins.
 - (11) Make sure that the vent door assembly (195) stops are within 0.10 inch of contacting the structure (Fig. 715).
- O. Lockwire the pushrod assemblies (85) as specified in 20-50-02. Use the double-twist method.
- P. Lubricate pushrod assemblies (85, 355, 415) and power unit (315) with BMS 3-24 grease.
11. Install the Rain Seal Installation (190, IPL Fig. 1) Components
- A. Bond the rain seal (220) to the upper beam installation (495) angle and the support brackets (75, 80, IPL Fig. 7) of the pressure seal upper corner support installation (505, IPL Fig. 1; 1A, 5, IPL Fig. 7) for the full length of the rain seal as specified in 20-50-12, type 60.
 - B. Install strip retainers (210, 215) with bolts (195).
 - C. For the edge of the rain seal that attaches to the body sill structure, attach the strip retainers (200, 205) to the rain seal (220) with bolts (195) and temporary nuts.
12. Install the Pressure Seal (225, IPL Fig. 1)
- NOTE: Liquid soap lubricants can be used.
- A. Position each corner of the pressure seal at the seal retainer corners.
 - B. Fit the inboard edge of the seal under the inner lip of the retainer for a distance of 1 to 2 inches either side of the corner midpoint.

- C. Using a smooth round-edged tool, push the outboard edge of the seal under the outer lip of the retainer.

NOTE: Push square to seal edge to avoid bunching.

- D. Install the remainder of the seal in the above manner starting at the approximate centerline of the four sides and working towards the corners.
- E. Refit as necessary to remove any stretch or bunching that can occur.

13. Install the Structural Components of the Door Assembly (IPL Fig. 1)

- A. Assemble panel assemblies (20, 40, 60) by bonding seals (25, 45, 65) in position as specified in 20-50-12, type 93.
- B. Assemble panel assemblies (100) by bonding seals (105) in position as specified in 20-50-12, type 60.
- C. Assemble cover plate installation (115, IPL Fig. 1) components.
 - (1) Bond gasket (180) to plate (185) as specified in 20-50-12, type 68.
- D. Install items (15 thru 185).
- E. Mark panel assemblies (20, 40, 60, 100) as follows:
 - (1) Stencil the indicated identification (ID) number on the inside surface of the panel assemblies, as centrally located as possible (Fig. 717).
 - (2) Apply stencils as specified in 20-50-10. The letters are to be 0.50 inch tall. Use BMS 10-11, type 2 enamel, BAC701 black gloss (optional: BAC706 black semigloss).

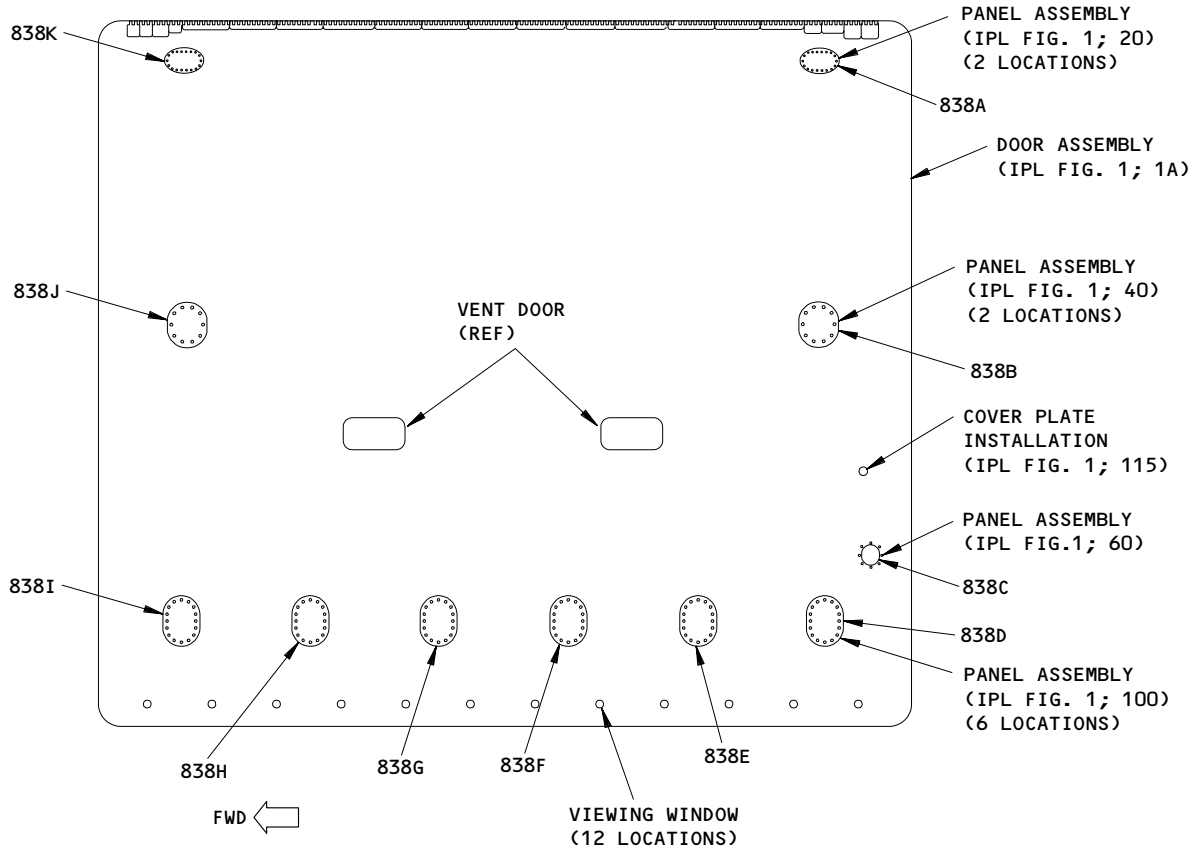
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Panel ID Number Callouts
 Figure 717

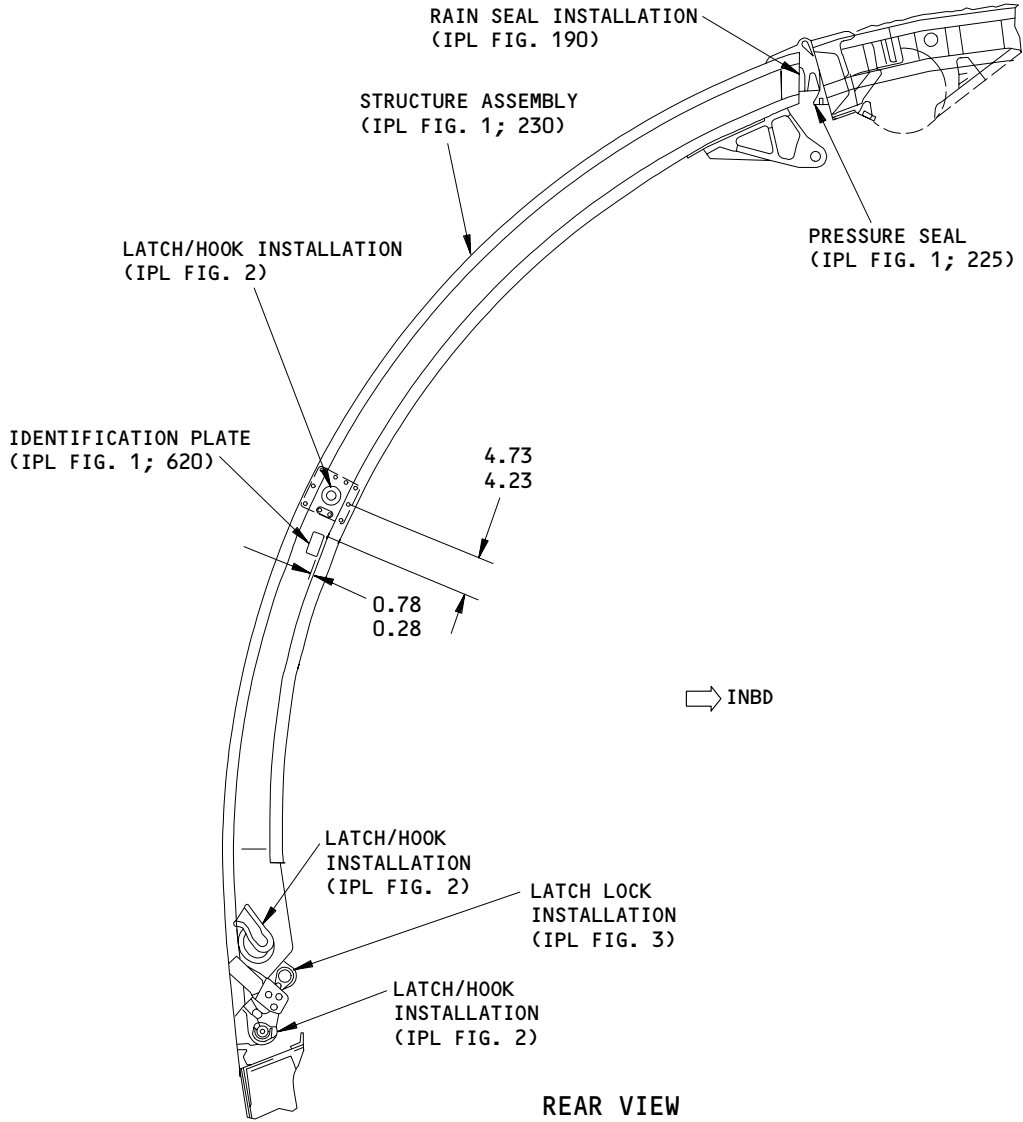
14. Install Identification Plate (620) to Location Shown in Fig. 718

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**Identification Plate Location
Figure 718**

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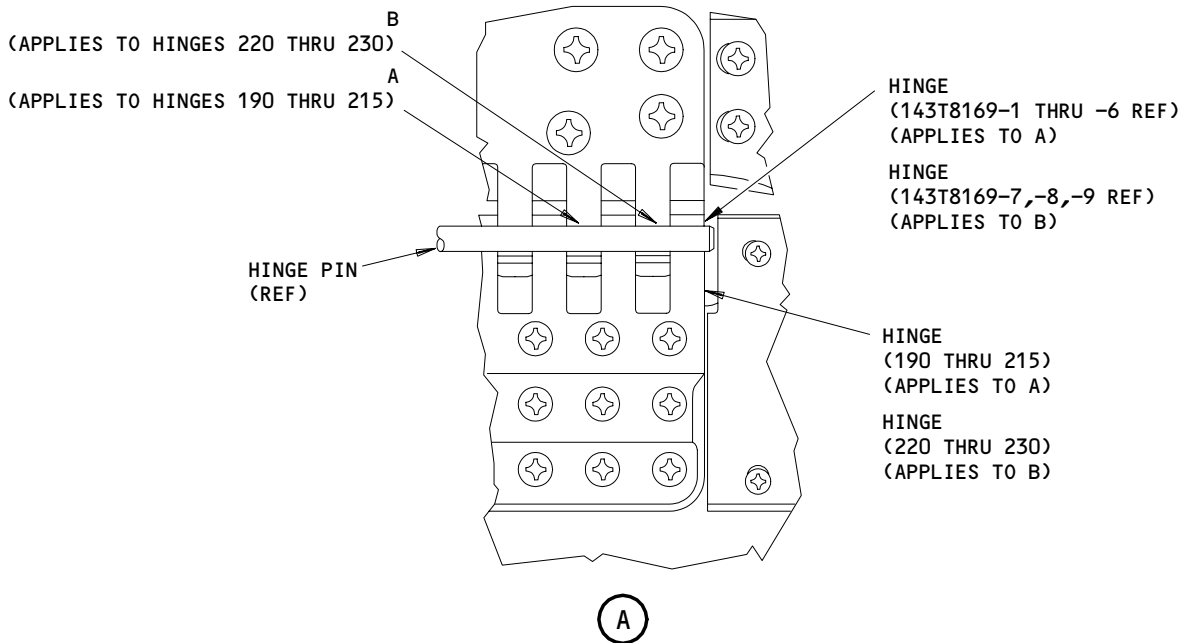
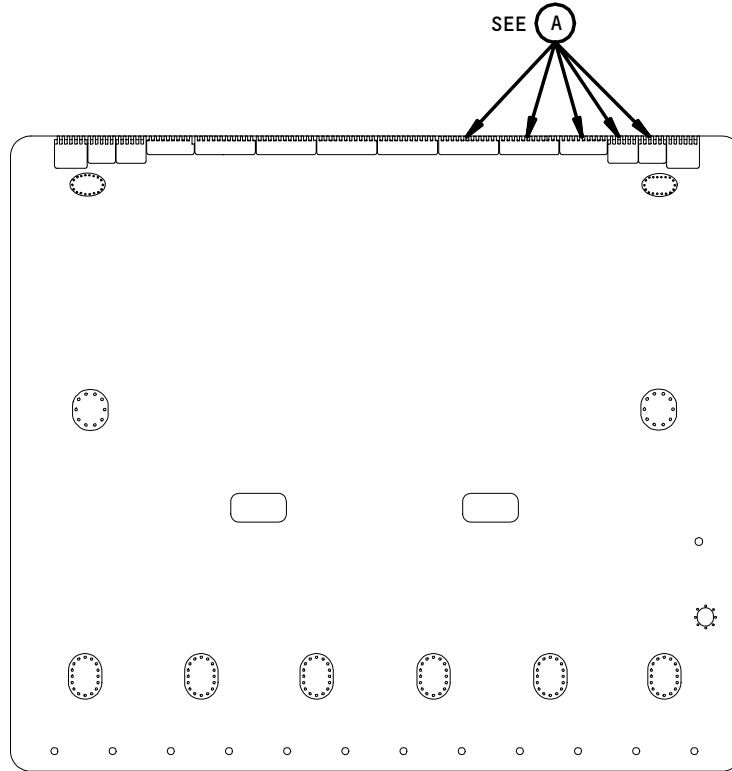
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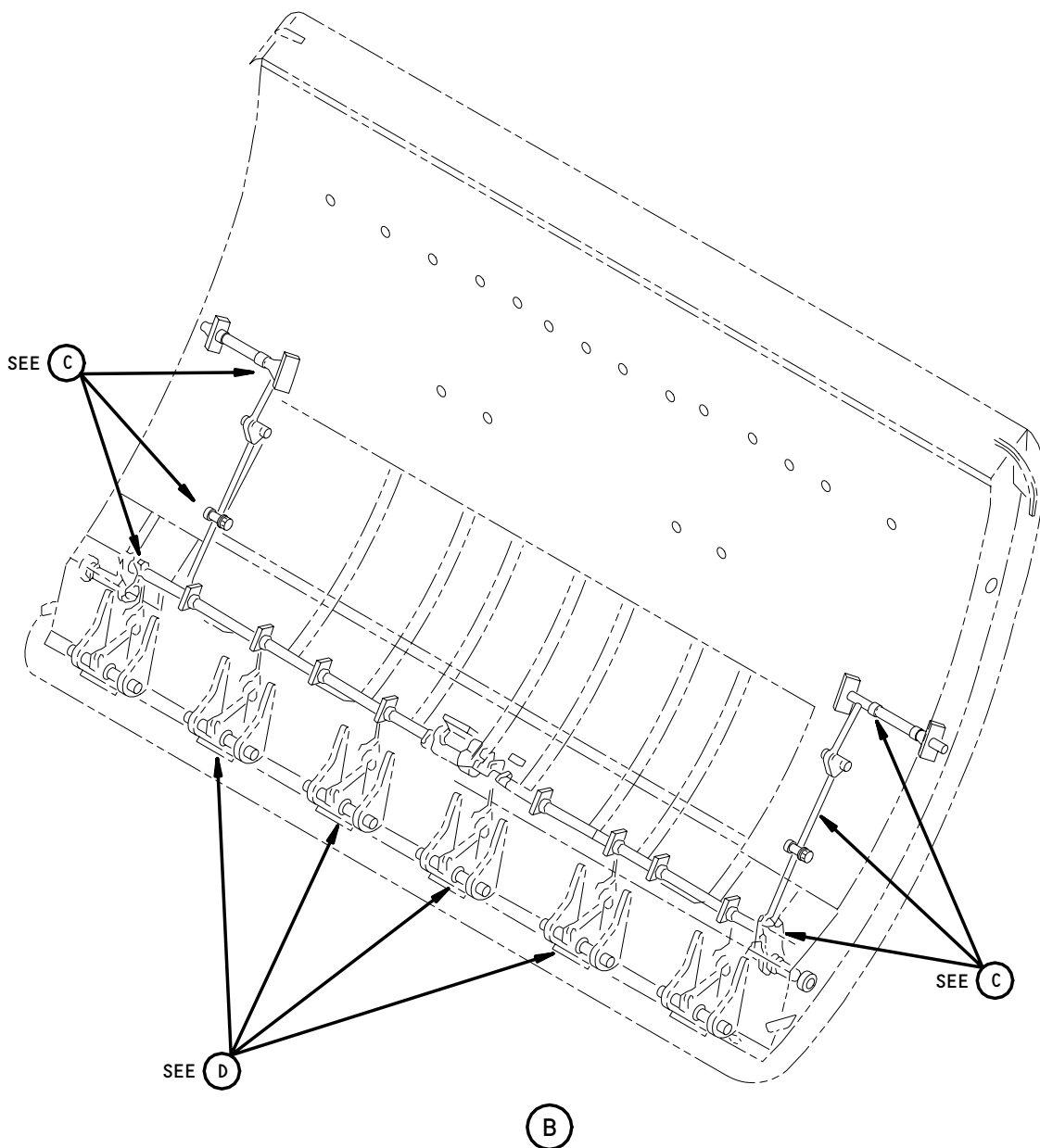
FITS AND CLEARANCES



Fits and Clearances
 Figure 801 (Sheet 1)

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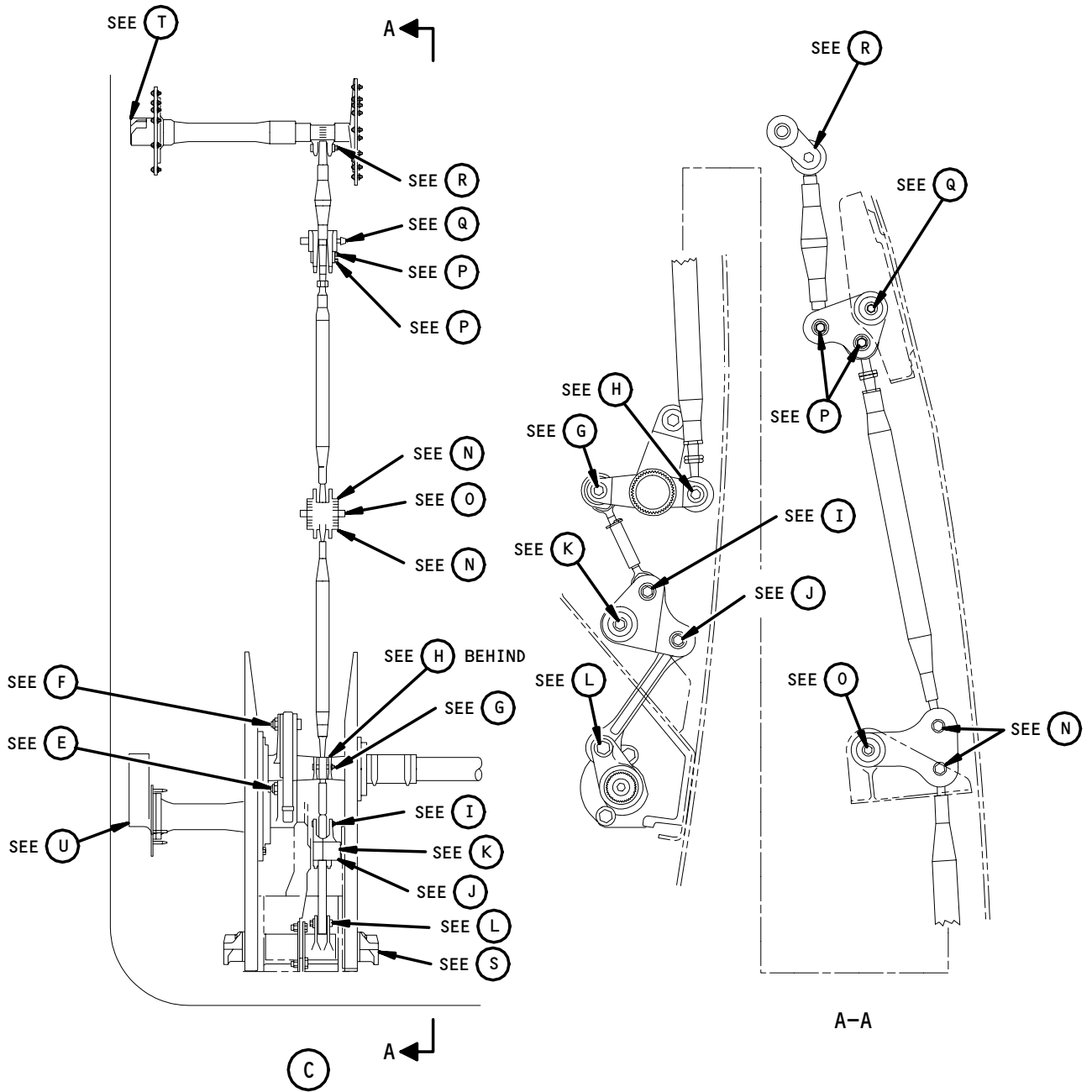


ITEM NUMBERS REFER TO IPL FIG. 2
UNLESS SPECIFIED DIFFERENTLY

Fits and Clearances
Figure 801 (Sheet 2)

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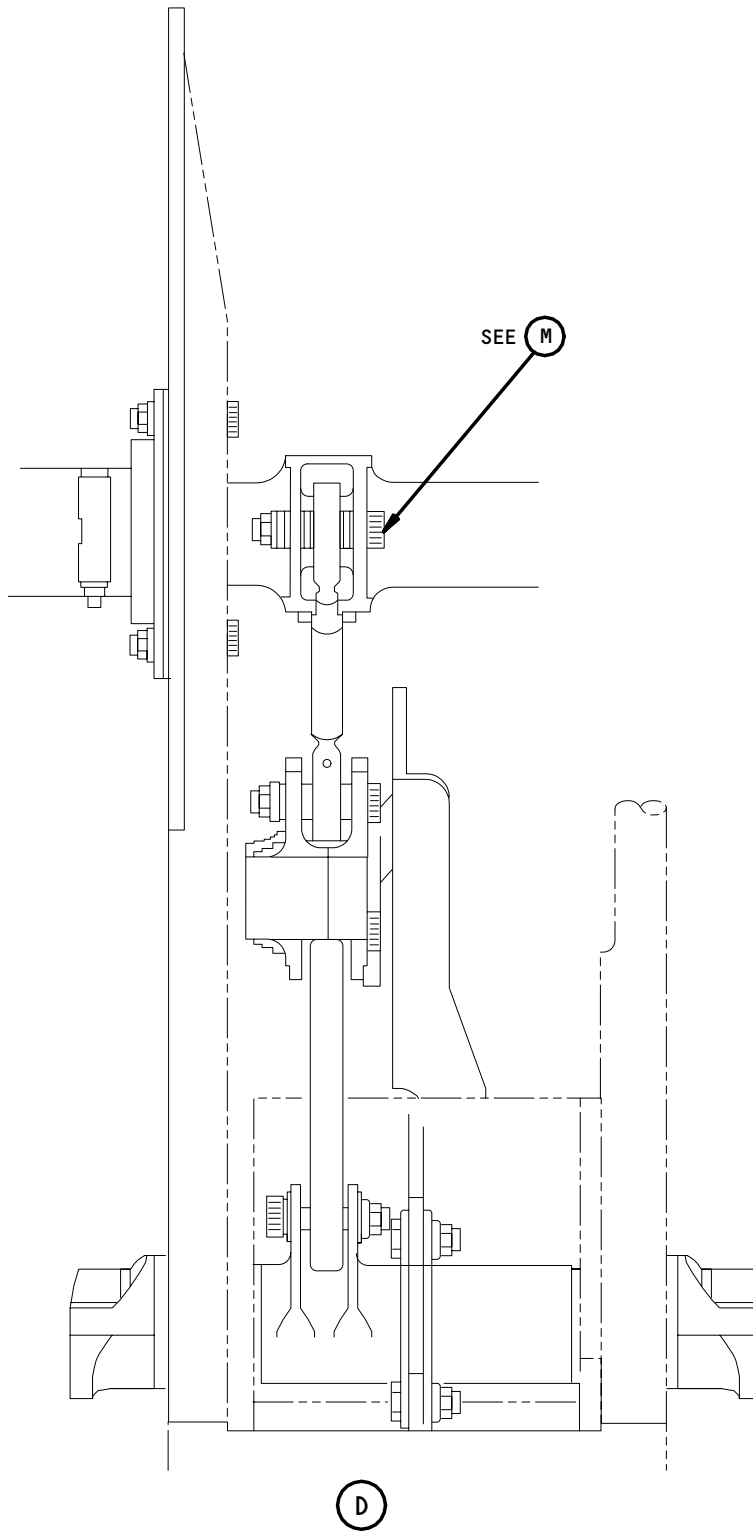
FITS AND CLEARANCES
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Fits and Clearances
 Figure 801 (Sheet 3)

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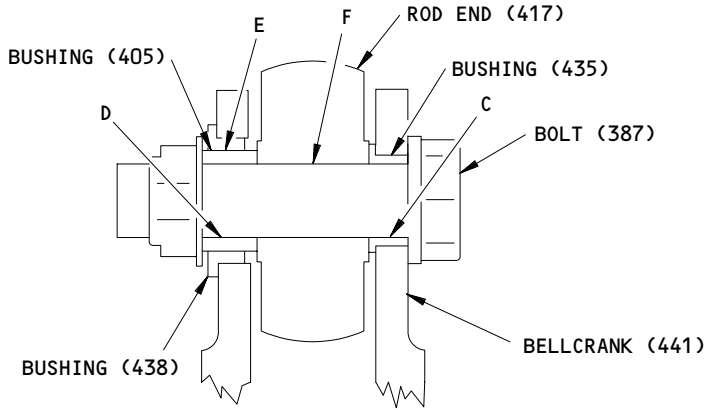
FITS AND CLEARANCES
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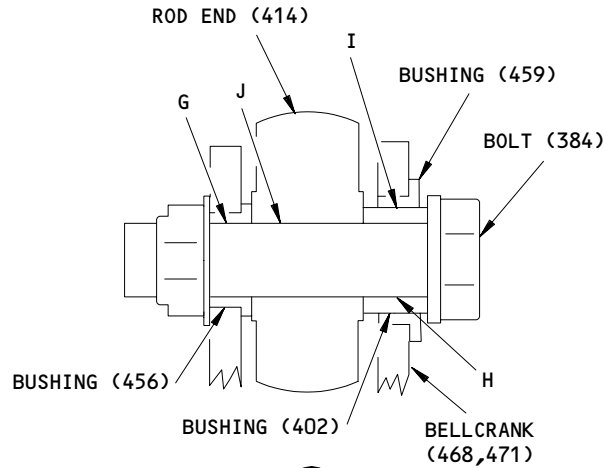
Fits and Clearances
Figure 801 (Sheet 4)

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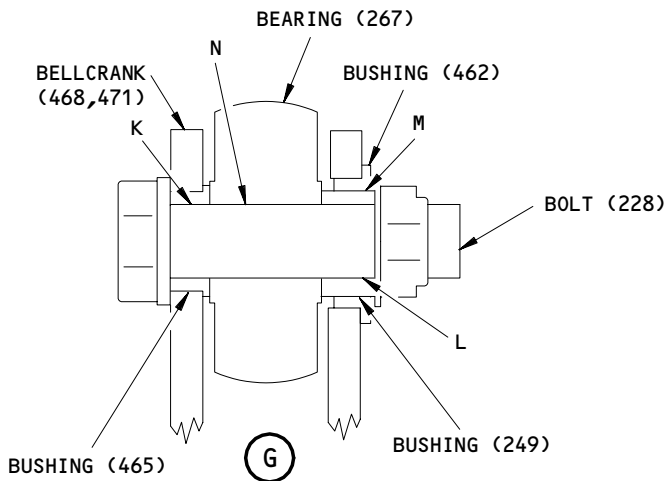
FITS AND CLEARANCES
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(E)



(F)

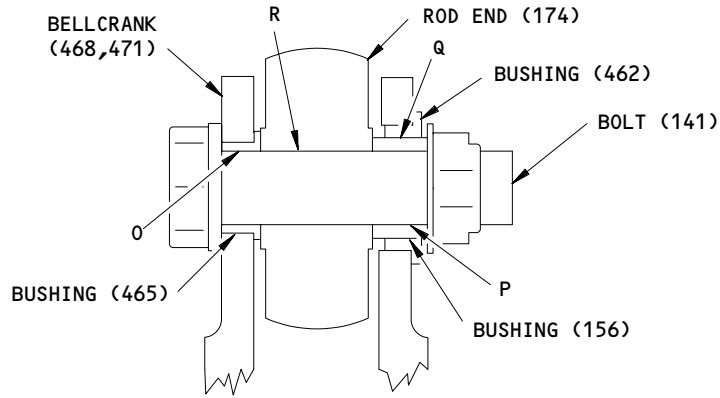


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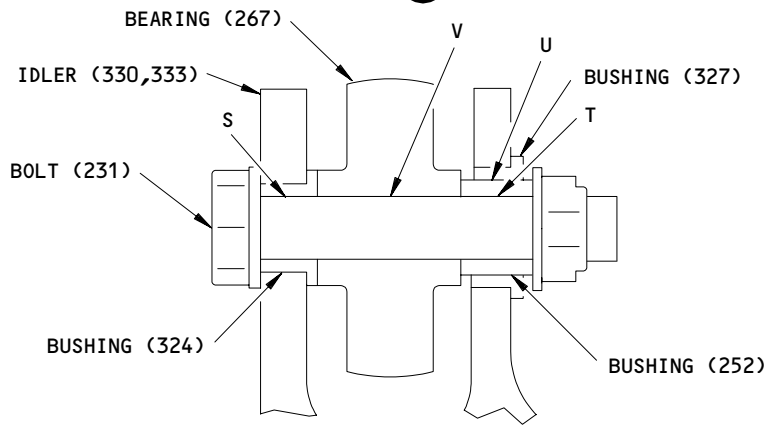
Fits and Clearances
 Figure 801 (Sheet 5)

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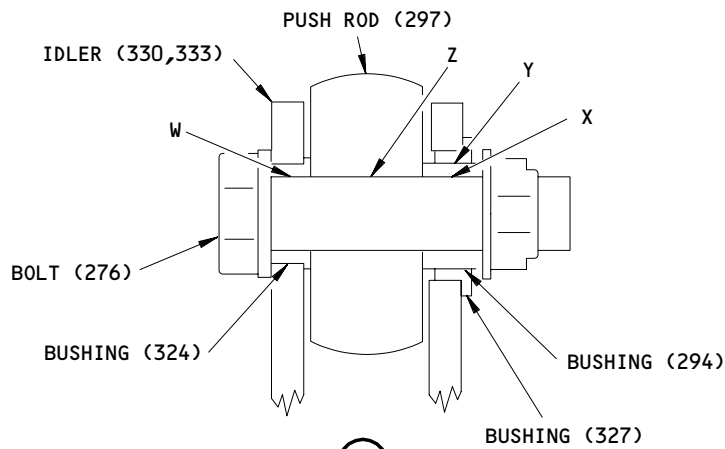
FITS AND CLEARANCES
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(H)



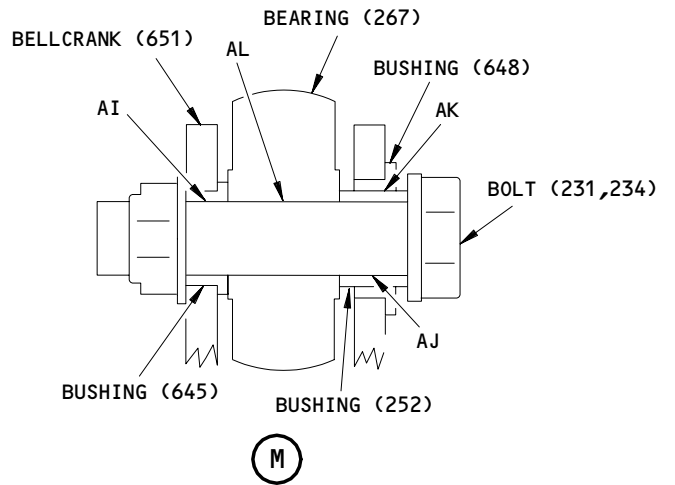
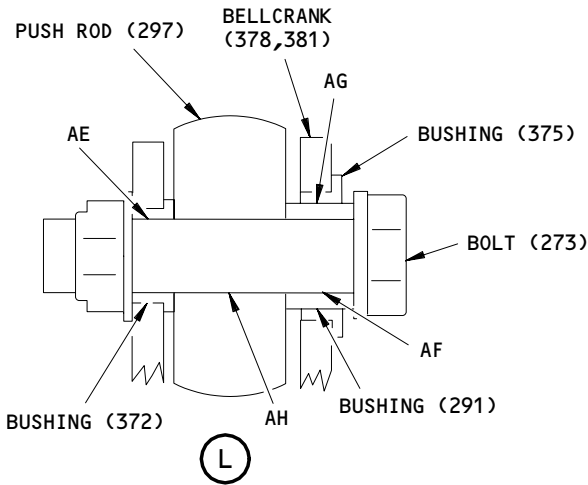
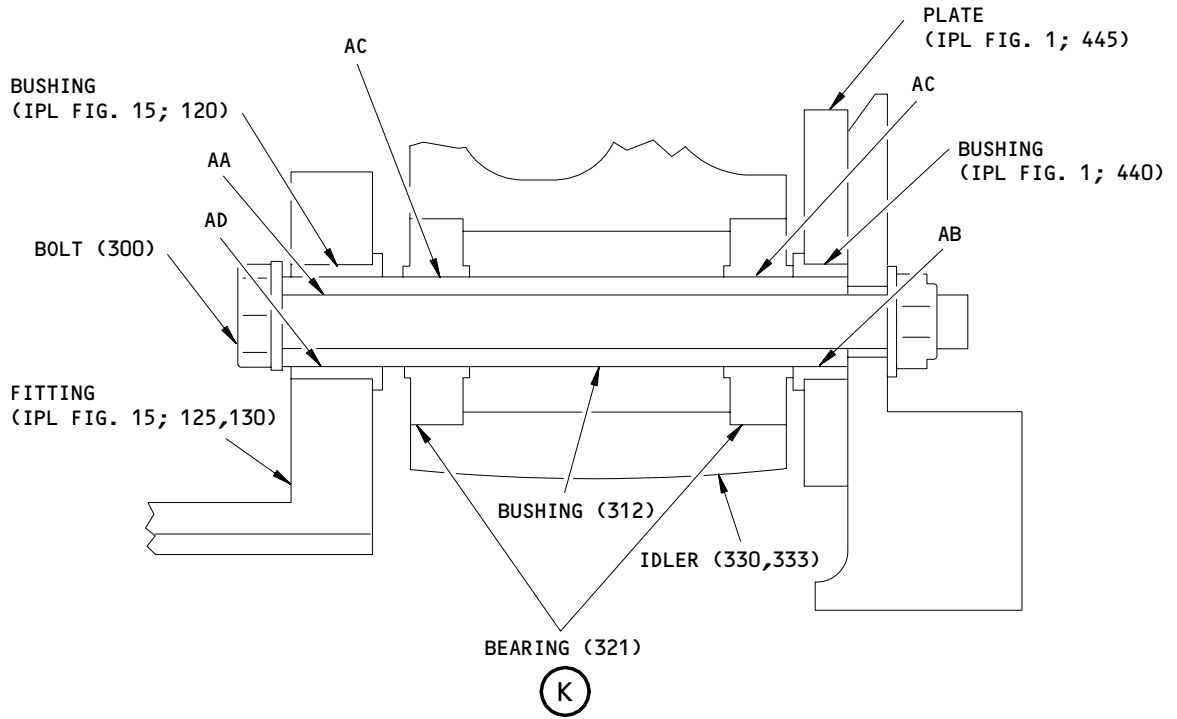
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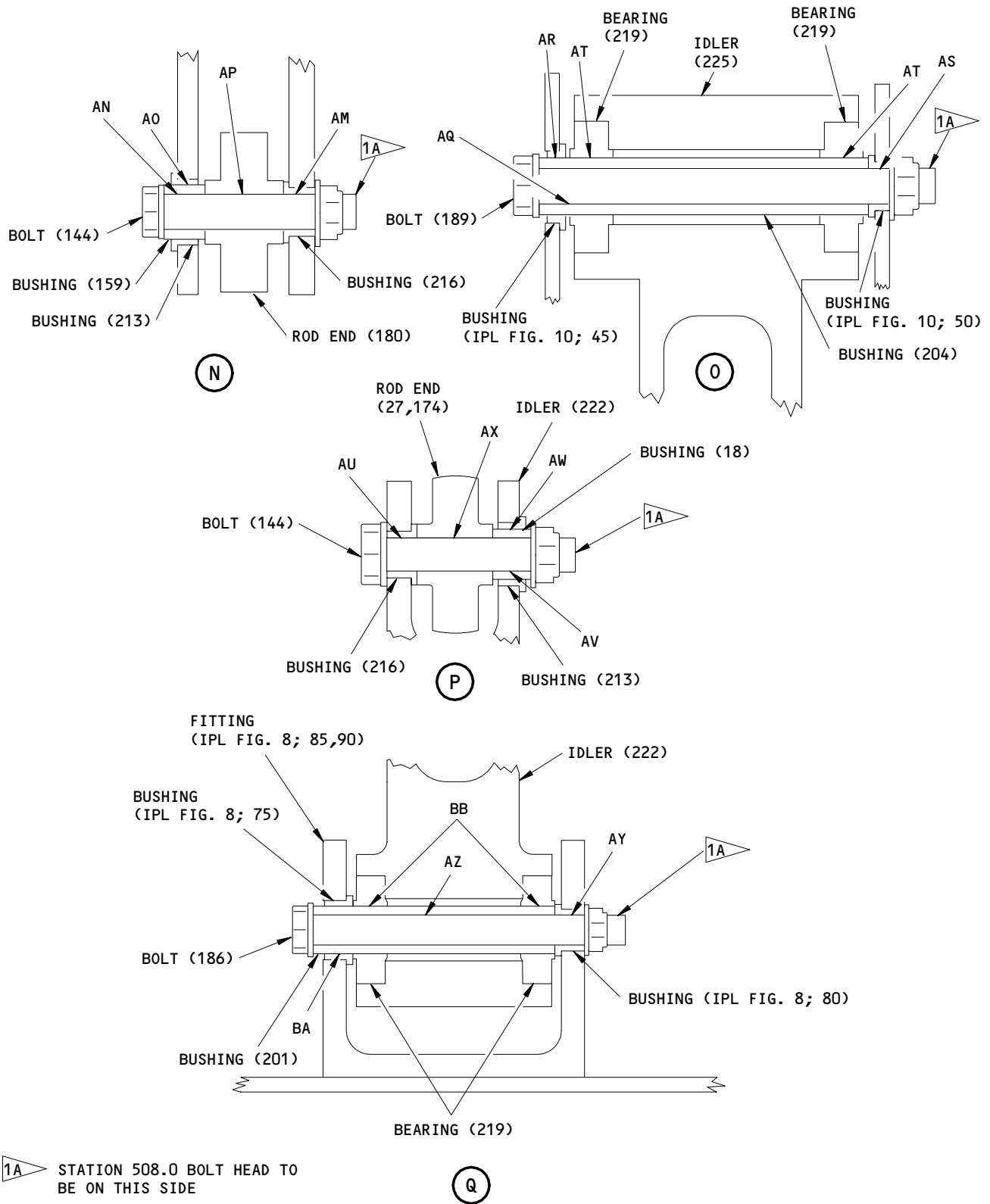
Fits and Clearances
 Figure 801 (Sheet 6)

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Fits and Clearances
 Figure 801 (Sheet 7)

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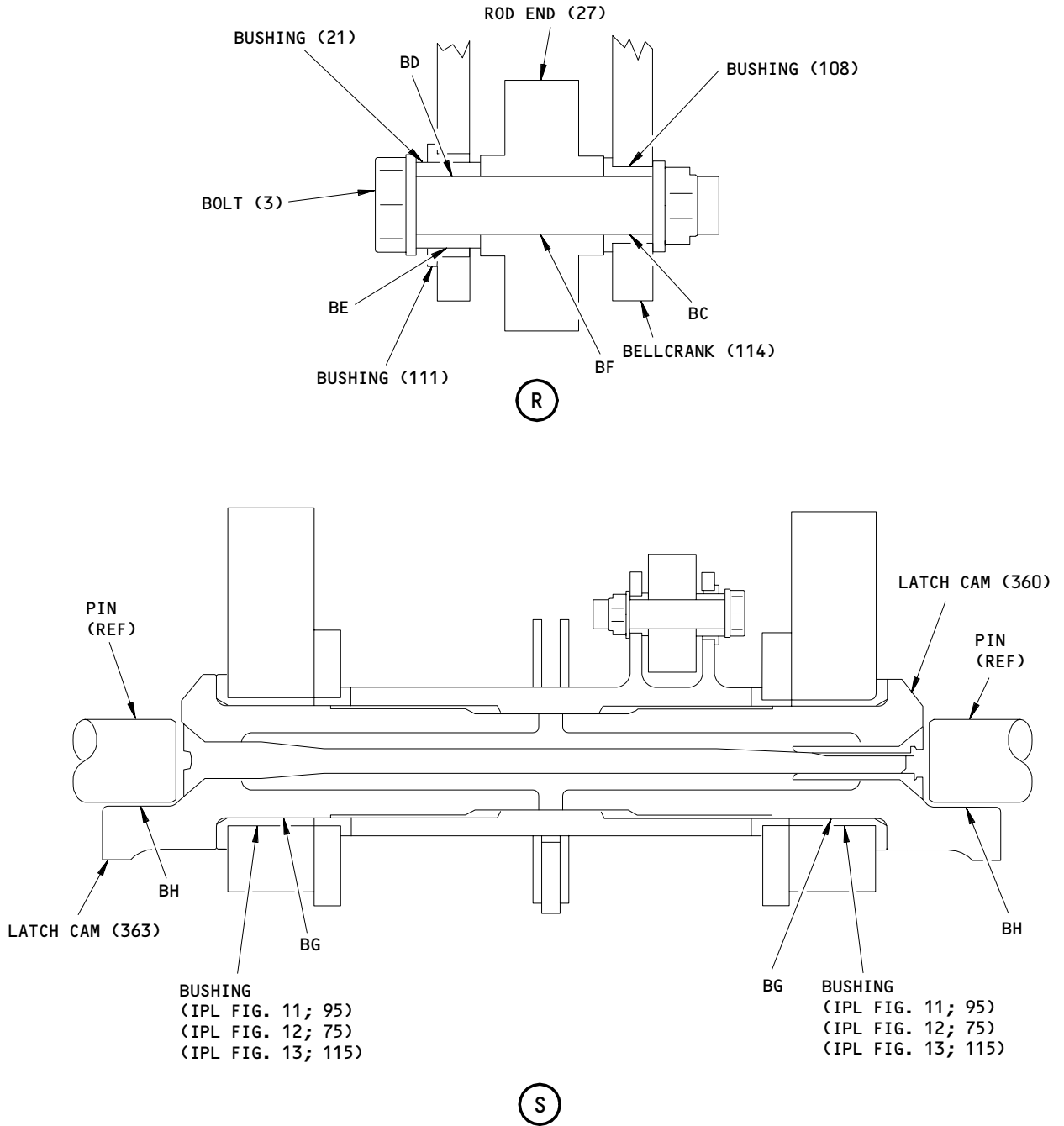


1A STATION 508.0 BOLT HEAD TO BE ON THIS SIDE

Q
 Fits and Clearances
 Figure 801 (Sheet 8)

52-32-04

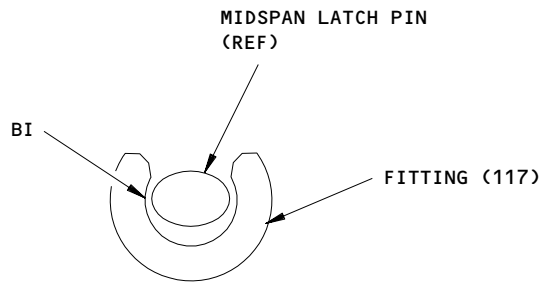
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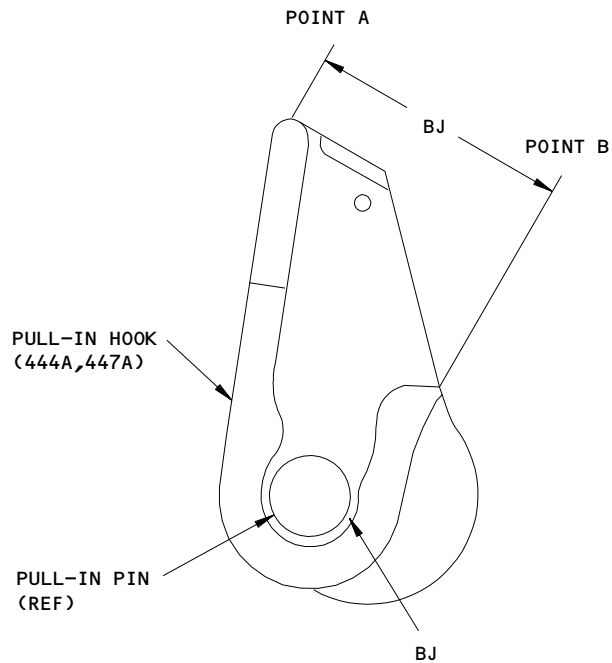
Fits and Clearances
 Figure 801 (Sheet 9)

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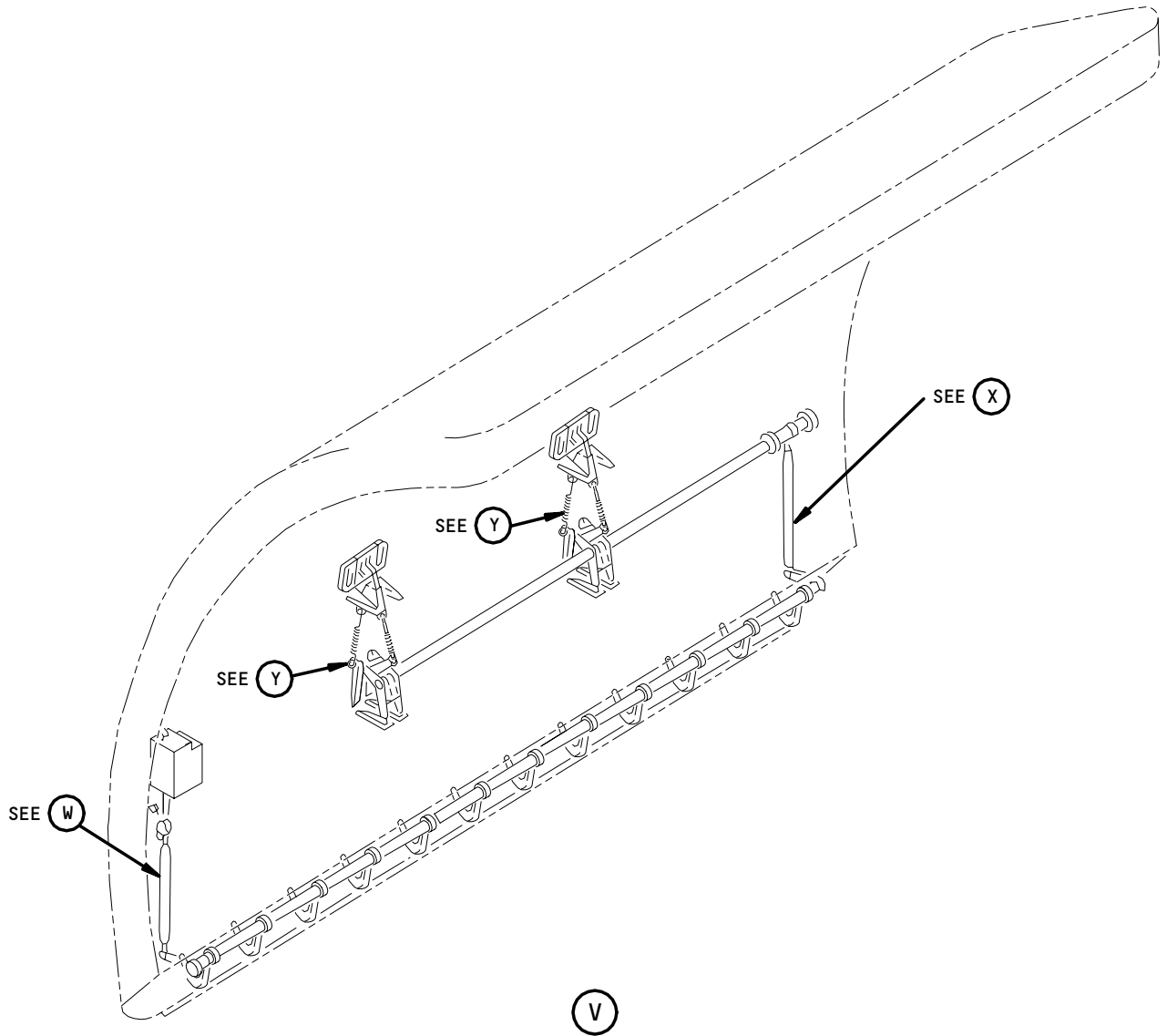


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Fits and Clearances
Figure 801 (Sheet 10)

52-32-04

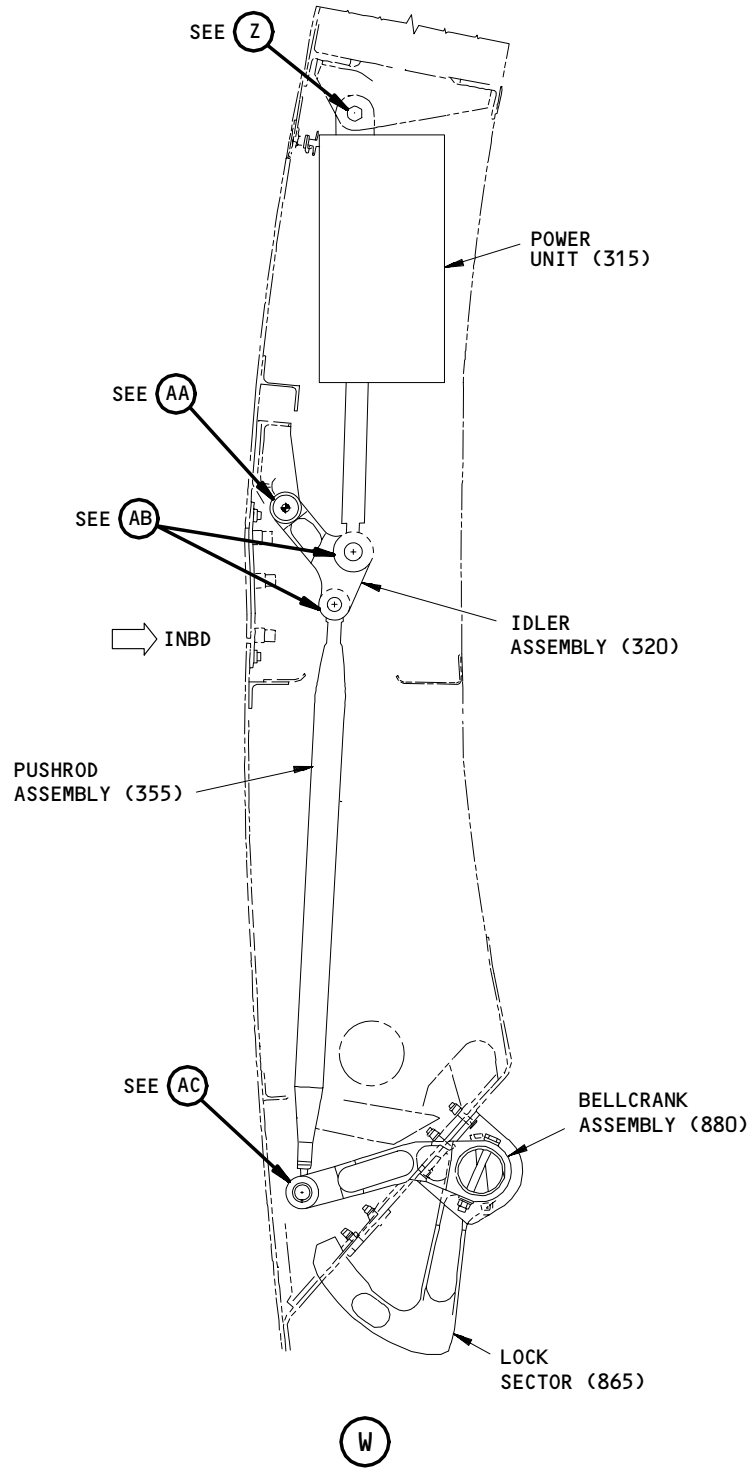
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Fits and Clearances
Figure 801 (Sheet 11)

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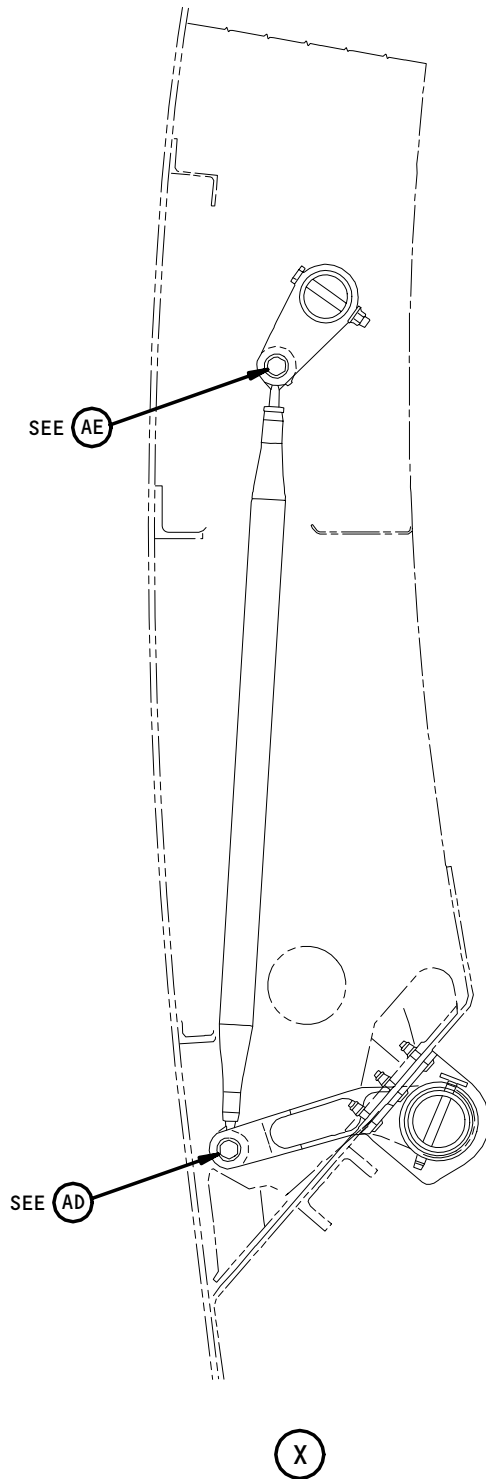


ITEM NUMBERS REFER TO IPL FIG. 3
UNLESS SPECIFIED DIFFERENTLY

Fits and Clearances
Figure 801 (Sheet 12)

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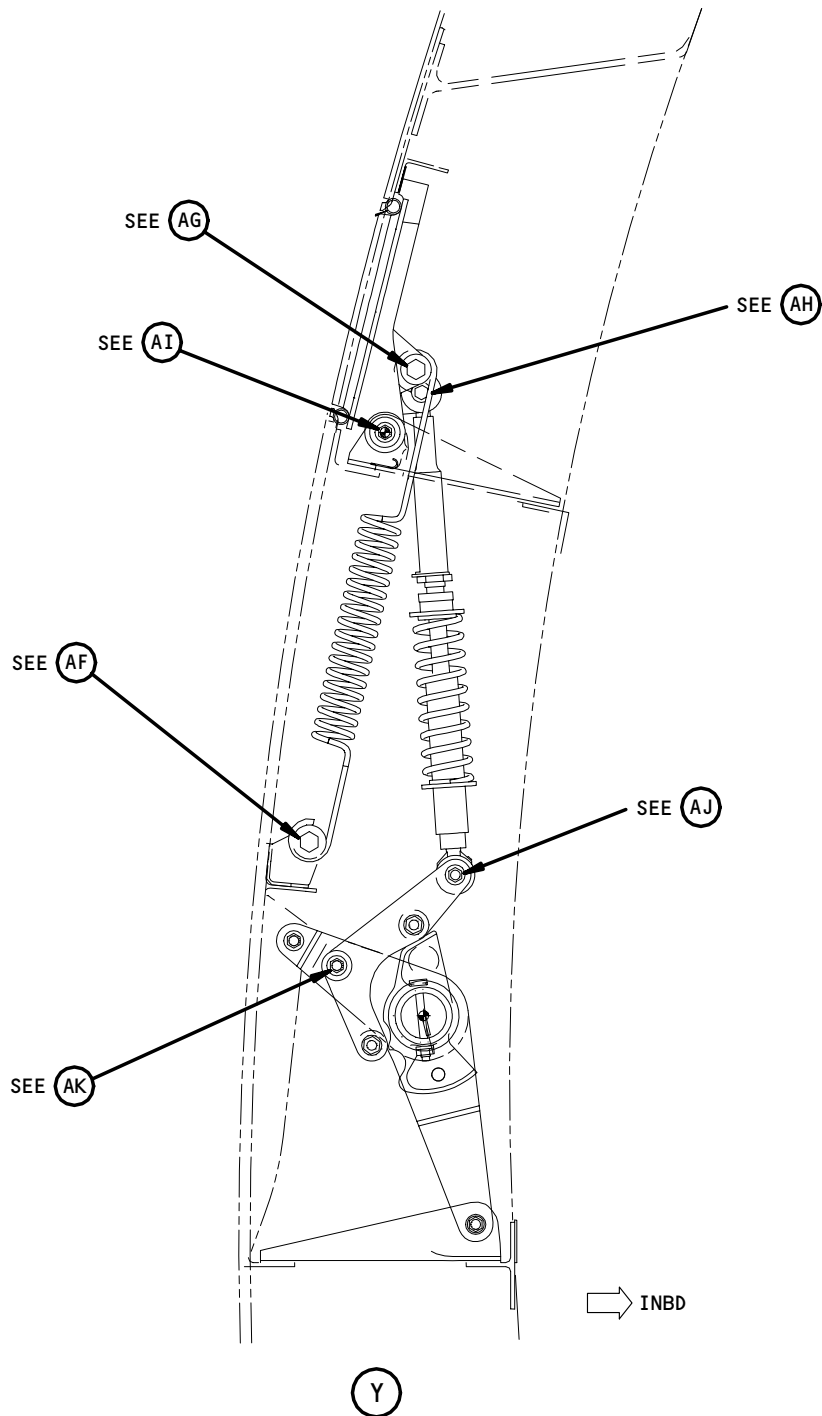
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Fits and Clearances
Figure 801 (Sheet 13)

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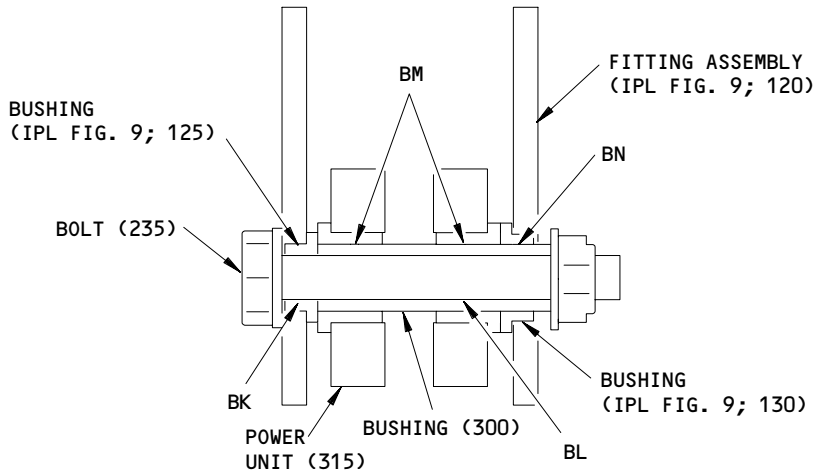
FITS AND CLEARANCES
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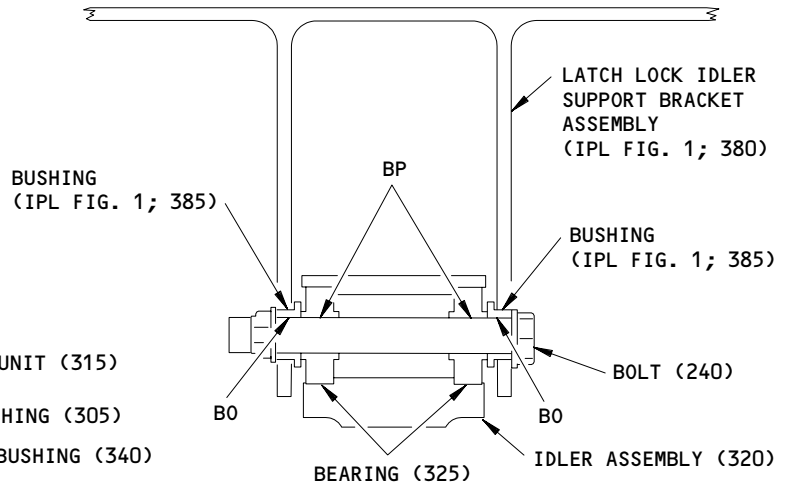
Fits and Clearances
Figure 801 (Sheet 14)

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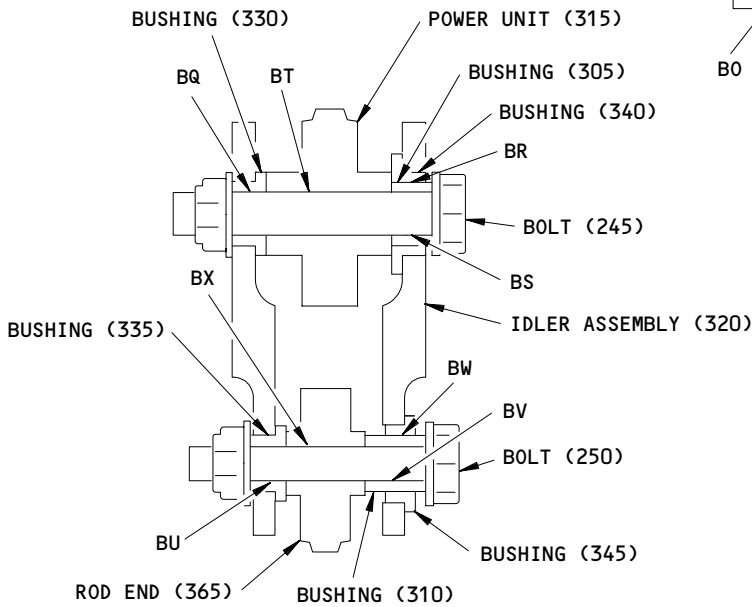
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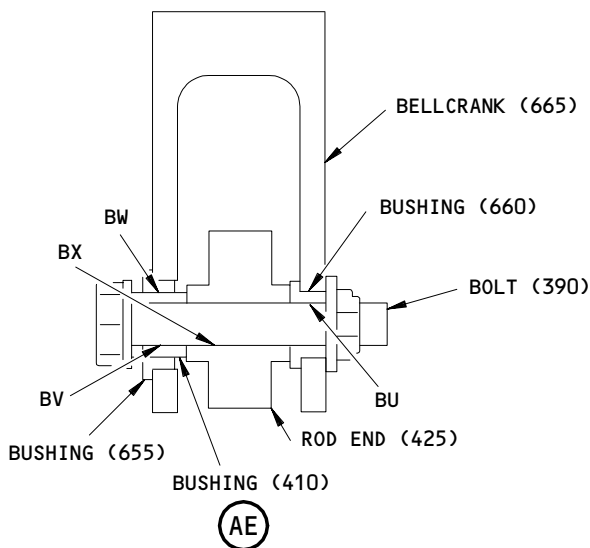
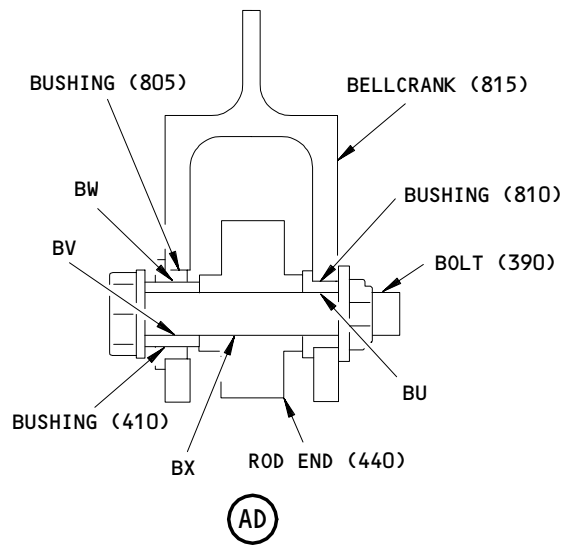
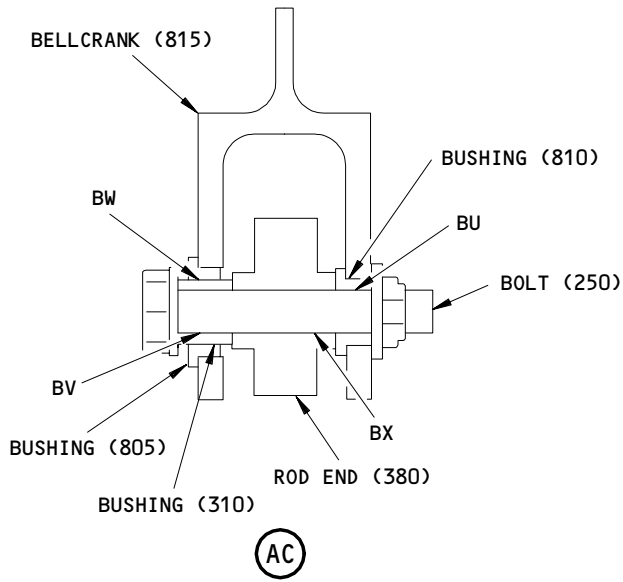
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ITEM NUMBERS REFER TO IPL FIG. 3
 UNLESS SPECIFIED DIFFERENTLY

Fits and Clearances
 Figure 801 (Sheet 15)

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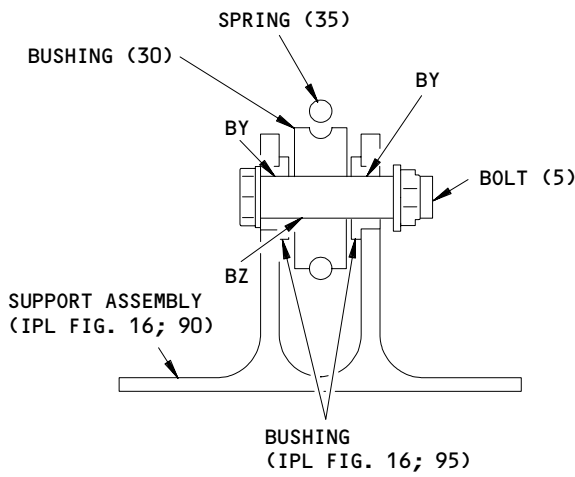
FITS AND CLEARANCES
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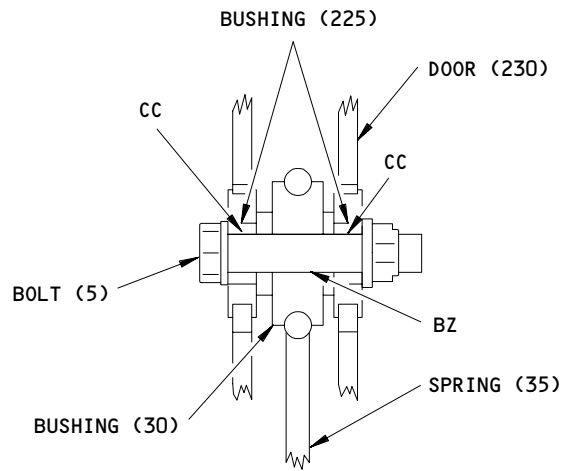
Fits and Clearances
 Figure 801 (Sheet 16)

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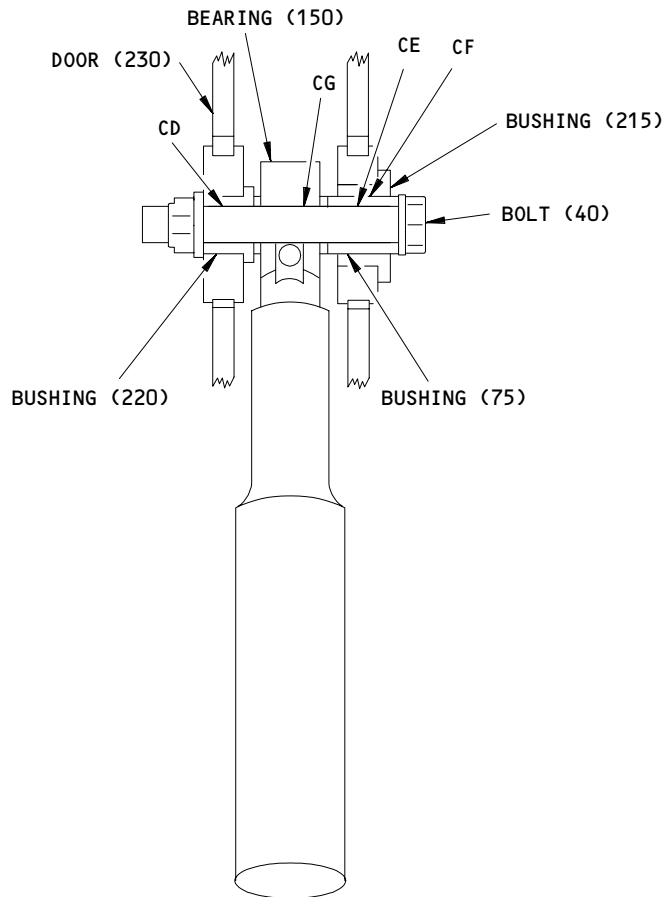
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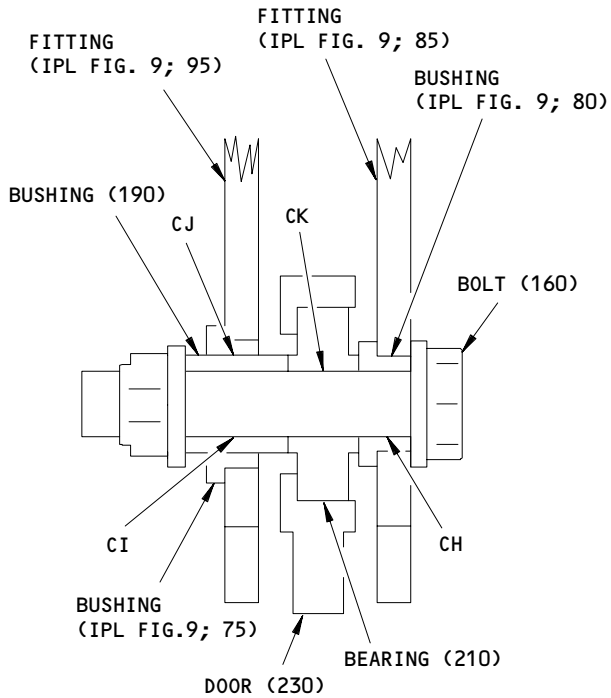


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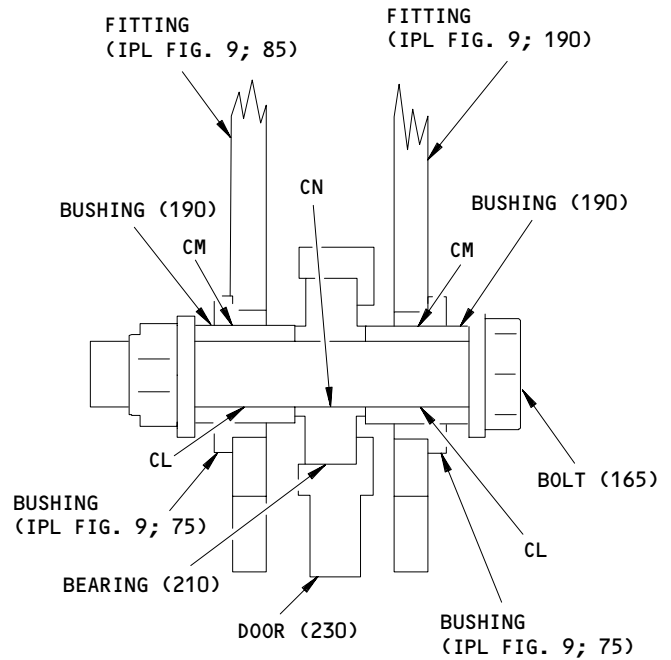
Fits and Clearances
Figure 801 (Sheet 17)

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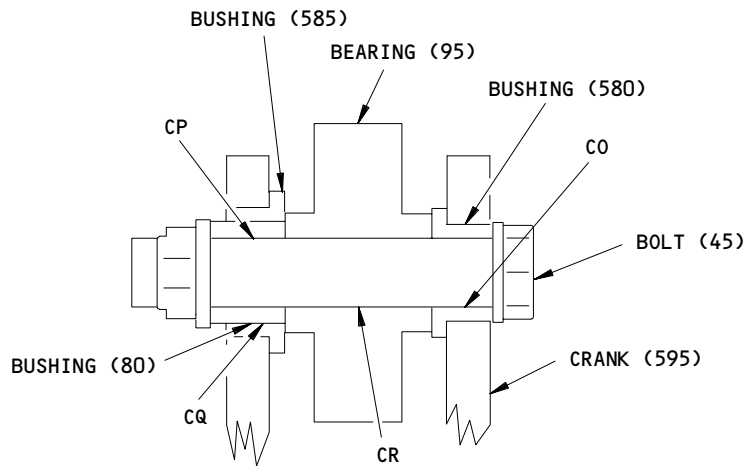
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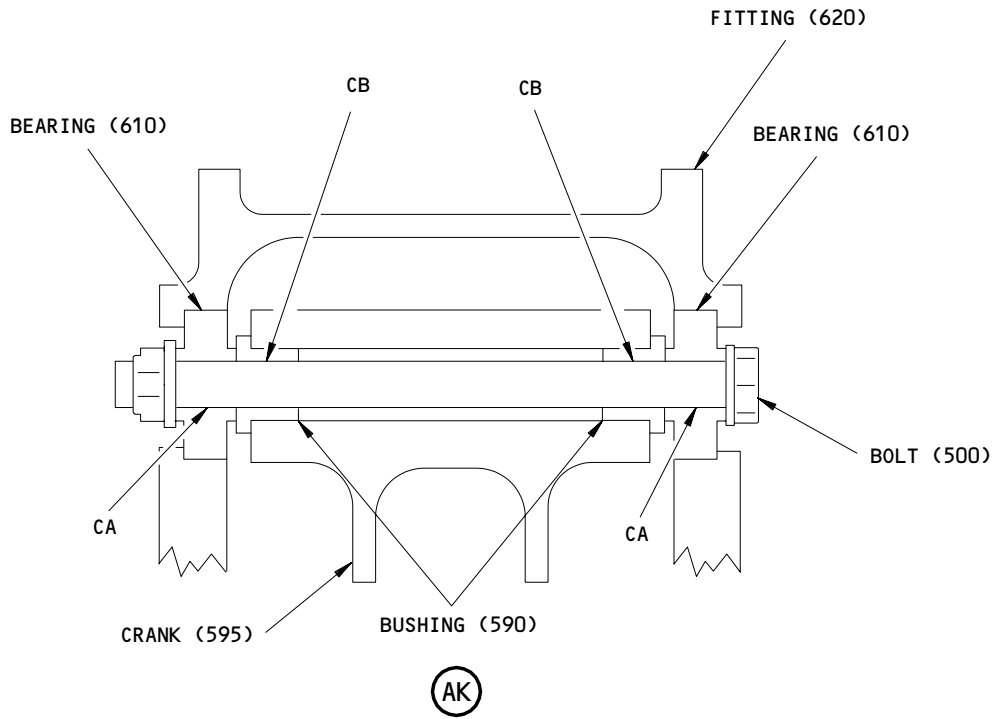


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Fits and Clearances
 Figure 801 (Sheet 18)

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Fits and Clearances
Figure 801 (Sheet 19)

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**COMPONENT
MAINTENANCE MANUAL**

REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
A		ID 1 OD 2	0.4375 0.4260	0.4405 0.4280	0.0095	0.0145	0.4210	0.4450	0.017
B		ID 3 OD 4	0.2520 0.2400	0.2570 0.2420	0.0100	0.0170	0.2350	0.2620	0.020
C	2	ID 435 OD 387	0.5000 0.4985	0.5015 0.4995	0.0005	0.0030	0.4950	0.5045	0.0050
D	2	ID 405 OD 387	0.5000 0.4985	0.5005 0.4995	0.0005	0.0020	0.4950	0.5045	0.0050
E	2	ID 438 OD 405	0.6875 0.6860	0.6890 0.6865	0.0010	0.0030	0.6821	0.6919	0.0054
F	2	ID 417 OD 387	0.4995 0.4985	0.5000 0.4995	0.0000	0.0015	0.4945	0.5045	0.0050
G	2	ID 456 OD 384	0.5000 0.4985	0.5015 0.4995	0.0005	0.0030	0.4950	0.5045	0.0050
H	2	ID 402 OD 384	0.5000 0.4985	0.5005 0.4995	0.0005	0.0020	0.4950	0.5045	0.0050
I	2	ID 459 OD 402	0.6875 0.6860	0.6890 0.6865	0.0010	0.0030	0.6821	0.6919	0.0054
J	2	ID 414 OD 384	0.4995 0.4985	0.5000 0.4995	0.0000	0.0015	0.4945	0.5045	0.0050
K	2	ID 465 OD 228	0.3750 0.3735	0.3765 0.3745	0.0005	0.0030	0.3700	0.3795	0.0050
L	2	ID 249 OD 228	0.3750 0.3735	0.3755 0.3745	0.0005	0.0020	0.3700	0.3795	0.0050
M	2	ID 462 OD 249	0.5625 0.5610	0.5640 0.5615	0.0010	0.0030	0.5575	0.5665	0.0050
N	2	ID 267 OD 228	0.3745 0.3735	0.3750 0.3745	0.0000	0.0015	0.3695	0.3795	0.0050
O	2	ID 465 OD 141	0.3750 0.3735	0.3765 0.3745	0.0005	0.0030	0.3700	0.3795	0.0050
P	2	ID 156 OD 141	0.3750 0.3735	0.3755 0.3745	0.0005	0.0020	0.3700	0.3795	0.0050
Q	2	ID 462 OD 156	0.5625 0.5610	0.5640 0.5615	0.0010	0.0030	0.5575	0.5665	0.0050
R	2	ID 174 OD 141	0.3745 0.3735	0.3750 0.3745	0.0000	0.0015	0.3695	0.3795	0.0050

* ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 20)

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BOEING
 COMPONENT
 MAINTENANCE MANUAL

REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
S	2	ID 324 OD 231	0.3750 0.3735	0.3765 0.3745	0.0005	0.0030	0.3700	0.3795	0.0050
T	2	ID 252 OD 231	0.3750 0.3735	0.3755 0.3745	0.0005	0.0020	0.3700	0.3795	0.0050
U	2	ID 327 OD 252	0.5625 0.5610	0.5640 0.5615	0.0010	0.0030	0.5575	0.5665	0.0050
V	2	ID 267 OD 231	0.3745 0.3735	0.3750 0.3745	0.0000	0.0015	0.3695	0.3795	0.0050
W	2	ID 324 OD 276	0.3750 0.3735	0.3765 0.3745	0.0005	0.0030	0.3700	0.3795	0.0050
X	2	ID 294 OD 276	0.3750 0.3735	0.3755 0.3745	0.0005	0.0020	0.3700	0.3795	0.0050
Y	2	ID 327 OD 294	0.5625 0.5610	0.5640 0.5615	0.0010	0.0030	0.5575	0.5665	0.0050
Z	2	ID 297 OD 276	0.3745 0.3735	0.3750 0.3745	0.0000	0.0015	0.3695	0.3795	0.0050
AA	2	ID 312 OD 300	0.3120 0.3110	0.3135 0.3120	0.0000	0.0025	0.3070	0.3170	0.0050
AB	1 2	ID 440 OD 312	0.5000 0.4970	0.5015 0.4980	0.0020	0.0045	0.4940	0.5040	0.0060
AC	2	ID 321 OD 312	0.4997 0.4970	0.5000 0.4980	0.0017	0.0030	0.4945	0.5030	0.0050
AD	15 2	ID 120 OD 312	0.5000 0.4970	0.5015 0.4980	0.0020	0.0045	0.4940	0.5040	0.0060
AE	2	ID 372 OD 273	0.3750 0.3735	0.3765 0.3745	0.0005	0.0030	0.3700	0.3795	0.0050
AF	2	ID 291 OD 273	0.3750 0.3735	0.3755 0.3745	0.0005	0.0020	0.3700	0.3795	0.0050
AG	2	ID 375 OD 291	0.5625 0.5610	0.5640 0.5615	0.0010	0.0030	0.5575	0.5665	0.0050
AH	2	ID 297 OD 273	0.3745 0.3735	0.3750 0.3745	0.0000	0.0015	0.3695	0.3795	0.0050
AI	2	ID 645 OD 231,234	0.3750 0.3735	0.3765 0.3745	0.0005	0.0030	0.3700	0.3795	0.0050
AJ	2	ID 252 OD 231,234	0.3750 0.3735	0.3755 0.3745	0.0005	0.0020	0.3700	0.3795	0.0050
AK	2	ID 648 OD 252	0.5625 0.5610	0.5640 0.5615	0.0010	0.0030	0.5575	0.5665	0.0050
AL	2	ID 267 OD 231,234	0.3745 0.3735	0.3750 0.3745	0.0000	0.0015	0.3695	0.3795	0.0050

* ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
 Figure 801 (Sheet 21)

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**COMPONENT
MAINTENANCE MANUAL**

REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
AM	2	ID 216 OD 144	0.3750 0.3735	0.3765 0.3745	0.0005	0.0030	0.3700	0.3795	0.0050
AN	2	ID 159 OD 144	0.3750 0.3735	0.3755 0.3745	0.0005	0.0020	0.3700	0.3795	0.0050
AO	2	ID 213 OD 159	0.5625 0.5610	0.5640 0.5615	0.0010	0.0030	0.5575	0.5665	0.0050
AP	2	ID 180 OD 144	0.3745 0.3735	0.3750 0.3745	0.0000	0.0015	0.3695	0.3795	0.0050
AQ	2	ID 204 OD 189	0.3120 0.3110	0.3135 0.3120	0.0000	0.0025	0.3070	0.3170	0.0050
AR	10 2	ID 45 OD 204	0.5000 0.4970	0.5015 0.4980	0.0020	0.0045	0.4940	0.5040	0.0060
AS	10 2	ID 50 OD 189	0.3125 0.3110	0.3140 0.3120	0.0005	0.0030	0.3075	0.3170	0.0050
AT	2	ID 219 OD 204	0.4997 0.4970	0.5000 0.4980	0.0017	0.0030	0.4947	0.5030	0.0050
AU	2	ID 216 OD 144	0.3750 0.3735	0.3765 0.3745	0.0005	0.0030	0.3700	0.3795	0.0050
AV	2	ID 18 OD 144	0.3750 0.3735	0.3755 0.3745	0.0005	0.0020	0.3700	0.3795	0.0050
AW	2	ID 213 OD 18	0.5625 0.5610	0.5640 0.5615	0.0010	0.0030	0.5575	0.5665	0.0050
AX	2	ID 27,174 OD 144	0.3745 0.3735	0.3750 0.3745	0.0000	0.0015	0.3695	0.3795	0.0050
AY	8 2	ID 80 OD 186	0.3125 0.3110	0.3140 0.3120	0.0005	0.0030	0.3075	0.3170	0.0050
AZ	2	ID 201 OD 186	0.3120 0.3110	0.3135 0.3120	0.0000	0.0025	0.3070	0.3170	0.0050
BA	8 2	ID 75 OD 201	0.5000 0.4970	0.5015 0.4980	0.0020	0.0045	0.4940	0.5040	0.0060
BB	2	ID 219 OD 201	0.4997 0.4970	0.5000 0.4980	0.0017	0.0030	0.4947	0.5030	0.0050
BC	2	ID 108 OD 3	0.3750 0.3735	0.3765 0.3745	0.0005	0.0030	0.3700	0.3795	0.0050
BD	2	ID 21 OD 3	0.3750 0.3735	0.3755 0.3745	0.0005	0.0020	0.3700	0.3795	0.0050
BE	2	ID 111 OD 21	0.5625 0.5610	0.5640 0.5615	0.0010	0.0030	0.5575	0.5665	0.0050
BF	2	ID 27 OD 3	0.3745 0.3735	0.3750 0.3745	0.0000	0.0015	0.3695	0.3795	0.0050










* ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 22)

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BOEING
 COMPONENT
 MAINTENANCE MANUAL

REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
BG	11 2	ID 95 OD 360,363	1.5010 1.4985	1.5020 1.4990	0.0020	0.0035		1.5110	0.0120
BG	12 2	ID 75 OD 360,363	1.5010 1.4985	1.5020 1.4990	0.0020	0.0035		1.5110	0.0120
BG	13 2	ID 115 OD 360,363	1.5010 1.4985	1.5020 1.4990	0.0020	0.0035		1.5110	0.0120
BH	2	ID 360,363 OD 	1.2200 1.1760	1.2300 1.1771	0.0429	0.0540	1.156		0.0750
BI	2	ID 117 OD 	1.09 0.98	1.10 1.02	0.070	0.120		1.12	
BJ	2	 444A,447A OD 	1.1217	1.1237			1.0917		
BK	9 3	ID 125 OD 235	0.2500 0.2485	0.2515 0.2495	0.0005	0.0030	0.2450	0.2545	0.0050
BL	3	ID 300 OD 235	0.2500 0.2485	0.2505 0.2495	0.0005	0.0020	0.2450	0.2545	0.0050
BM	3	ID 315 OD 300	0.3750 0.3740	0.3765 0.3745	0.0005	0.0025	0.3700	0.3795	0.0050
BN	9 3	ID 130 OD 300	0.3750 0.3740	0.3765 0.3745	0.0005	0.0025	0.3700	0.3795	0.0050
BO	1 3	ID 385 OD 240	0.3125 0.3110	0.3140 0.3120	0.0005	0.0030	0.3075	0.3170	0.0050
BP	3	ID 325 OD 240	0.3122 0.3110	0.3125 0.3120	0.0002	0.0015	0.3072	0.3170	0.0050
BQ	3	ID 330 OD 245	0.3125 0.3110	0.3140 0.3120	0.0005	0.0030	0.3075	0.3170	0.0050
BR	3	ID 340 OD 305	0.4375 0.4365	0.4390 0.4370	0.0005	0.0025	0.4325	0.4420	0.0050
BS	3	ID 305 OD 245	0.3125 0.3110	0.3130 0.3120	0.0005	0.0020	0.3075	0.3170	0.0050
BT	3	ID 315 OD 245	0.3120 0.3110	0.3125 0.3120	0.0000	0.0015	0.3070	0.3170	0.0050
BU	3	ID 335,660, 810 OD 250,390	0.2500 0.2485	0.2515 0.2495	0.0005	0.0030	0.2450	0.2545	0.0050
BV	3	ID 310,410 OD 250,390	0.2500 0.2485	0.2505 0.2495	0.0005	0.0020	0.2450	0.2545	0.0050
BW	3	ID 345,655, 805 OD 310,410	0.3750 0.3740	0.3765 0.3745	0.0005	0.0025	0.3700	0.3795	0.0050
BX	3	ID 365,380, 425,440 OD 250,390	0.2495 0.2485	0.2500 0.2495	0.0000	0.0015	0.2445	0.2545	0.0050

* ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 23)

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REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
BY	16 3	ID 95 OD 5	0.2500 0.2485	0.2515 0.2495	0.0005	0.0030	0.2450	0.2545	0.0050
BZ	3	ID 30 OD 5	0.2550 0.2485	0.2600 0.2495	0.0055	0.0115	0.2450	0.2670	0.0175
CA	3	ID 610 OD 500	0.2497 0.2485	0.2500 0.2495	0.0002	0.0015	0.2447	0.2540	0.0050
CB	3	ID 590 OD 500	0.2500 0.2485	0.2515 0.2495	0.0005	0.0030	0.2450	0.2545	0.0050
CC	3	ID 225 OD 5	0.2500 0.2485	0.2515 0.2495	0.0005	0.0030	0.2450	0.2545	0.0050
CD	3	ID 220 OD 40	0.2500 0.2485	0.2515 0.2495	0.0005	0.0030	0.2450	0.2545	0.0050
CE	3	ID 75 OD 40	0.2500 0.2485	0.2505 0.2495	0.0005	0.0020	0.2450	0.2545	0.0050
CF	3	ID 215 OD 75	0.3750 0.3740	0.3765 0.3745	0.0005	0.0025	0.3700	0.3795	0.0050
CG	3	ID 150 OD 40	0.2495 0.2485	0.2500 0.2495	0.0000	0.0015	0.2445	0.2545	0.0050
CH	9 3	ID 80 OD 160	0.2500 0.2485	0.2515 0.2495	0.0005	0.0030	0.2450	0.2545	0.0050
CI	3	ID 190 OD 160	0.2500 0.2485	0.2505 0.2495	0.0005	0.0020	0.2450	0.2545	0.0050
CJ	9 3	ID 75 OD 190	0.3750 0.3740	0.3765 0.3745	0.0005	0.0025	0.3700	0.3795	0.0050
CK	3	ID 210 OD 160	0.2497 0.2485	0.2500 0.2495	0.0002	0.0015	0.2447	0.2545	0.0050
CL	3	ID 190 OD 165	0.2500 0.2485	0.2505 0.2495	0.0005	0.0020	0.2450	0.2545	0.0050
CM	9 3	ID 75 OD 190	0.3750 0.3740	0.3765 0.3745	0.0005	0.0025	0.3700	0.3795	0.0050
CN	3	ID 210 OD 165	0.2497 0.2485	0.2500 0.2495	0.0002	0.0015	0.2447	0.2545	0.0050
CO	3	ID 580 OD 45	0.2500 0.2485	0.2515 0.2495	0.0005	0.0030	0.2450	0.2545	0.0050
CP	3	ID 80 OD 45	0.2500 0.2485	0.2505 0.2495	0.0005	0.0020	0.2450	0.2545	0.0050
CQ	3	ID 585 OD 80	0.3750 0.3740	0.3765 0.3745	0.0005	0.0025	0.3700	0.3795	0.0050
CR	3	ID 95 OD 45	0.2495 0.2485	0.2500 0.2495	0.0000	0.0015	0.2445	0.2545	0.0050

* ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 24)

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- 1 HINGE (IPL FIG. 6; 190 THRU 215)
(IPL FIG. 19; 185 THRU 210)
- 2 HINGE PIN, 143T6688-1 (REF)
- 3 HINGE (IPL FIG. 6; 220 THRU 230)
(IPL FIG. 19; 215 THRU 225)
- 4 HINGE PIN, 143T6688-2,-3 (REF)
- 5 LATCH CAMS (IPL FIG. 2; 360,363) MUST
NOT WEAR THROUGH CHROME PLATING
- 6 PIN, 143T8258-2 (REF)
- 7 MIDSPAN LATCH PIN, 143T8385-() (REF)
- 8 PULL-IN PIN, 143T8420-() (REF)
- 9 SURFACE PROFILE FROM POINT A TO POINT B
AS SHOWN IN VIEW U

Fits and Clearances
Figure 801 (Sheet 25)

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FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01		
IPL FIG & ITEM	NAME	TORQUE (POUND-INCHES)
<u>IPL Fig. 2</u>		
27	Rod End	800 maximum *[1]
168	Nut	150-200
177	Insert	800 maximum *[1]
180	Rod End	200 maximum *[1]
<u>IPL Fig. 3</u>		
145	Insert	200 maximum *[1]
150	Bearing	200 maximum *[1]
360,420	Nut	20-30
375,435	Insert	100 maximum *[1]
380	Rod End	90 maximum *[1]
645,765,795,835,860	Nuts	40-50
<u>IPL Fig. 6 and Fig. 19</u>		
60,65,70	Bolt *[2]	300-360 *[3], 325-395 *[4]
75,80	Bolt *[2]	150-200 *[3], 180-220 *[4]
85,90,95,100	Bolt *[2]	300-410 *[3], 370-450 *[4]
105,110	Bolt *[2]	200-240 *[3], 220-265 *[4]
115,120,125	Bolt *[2]	150-200 *[3], 180-220 *[4]
130,135,140,145	Bolt *[2]	75-100 *[3], 90-110 *[4]
*[1] Item must be able to withstand this torque value *[2] Apply the torque to the nut of the specified bolt *[3] Initial torque *[4] Torque after sealant has squeezed out		

Torque Table
 Figure 802

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ILLUSTRATED PARTS LIST

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

2. Indentures show parts relationships as follows:

Assembly

Detail Parts for Assembly

Subassembly

Attaching Parts for Subassembly

Detail Parts for Subassembly

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

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

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

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

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

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

6. Parts Interchangeability

Optional
(OPT)

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

Supersedes, Superseded By
(SUPSDS, SUPSD BY)

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

Replaces, Replaced By
(REPLS, REPLD BY)

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

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ILLUSTRATED PARTS LIST

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VENDORS

K1406 DUNLOP LTD PRECISION RUBBER DIV
ASHBY ROAD
SHEPshed LOUGHBOROUGH LEICS LE12 9EQ ENGLAND

S0352 NIPPON MINIATURE BEARING CO LTD
TOKYO, JAPAN

OPTK6 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV
5195 W 4700 SPO BOX 18459
KEARNS, UTAH 84118

04169 WESTERN SKY INDUSTRIES A DIVISION OF ATLAS CORPORATION
1280 SAN LUIS OBISPO STREET
HAYWARD, CALIFORNIA 94544-7916
FORMERLY WESTERN SKY IND VB0008

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.

06950 SCREWCORP VSI AEROSPACE PRODUCTS DIV FAIRCHILD IND DIV
13001 EAST TEMPLE AVENUE PO BOX 730
CITY OF INDUSTRY, CALIFORNIA 91746-1417
FORMERLY VB0096 AND VSI CORP SCREWCORP DIV
FORMERLY IN CULVER CITY, CALIFORNIA

08524 DEUTSCH FASTENER CORP SEE CODE V97928

1GK47 R AND B ELECTRONICS INC
2374 NW DALLAS STREET
GRAND PRAIRIE, TEXAS 75050

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

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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
- 16258 SPACE-LOK INC
 13306 HALLDALE AVE
 GARDENA, CALIFORNIA 90249-2204
 FORMERLY V05704 ALAC INC
 FORMERLY IN BURBANK, CA
- 17446 HUCK INTL INC AEROSPACE FASTENER DIV
 900 WATSON CENTER ROAD
 CARSON, CALIFORNIA 90745-4201
 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
- 17472 EATON AEROSPACE LLC DIV ELECTRO-MECHANICAL SYSTEMS
 3675 PATTERSON SE
 GRAND RAPIDS, MICHIGAN 49512-4022
 FORMERLY CONDUCTRON CORP & MCDONNELL DOUGLAS ELECT
 FORMERLY VICKERS ELECTROMECH
- 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
- 27238 BRISTOL INDUSTRIES
 630 EAST LAMBERT ROAD PO BOX 630
 BREA, CALIFORNIA 92621-4119
- 39317 MC GILL MANUFACTURING COMPANY, INC.
 1002 NORTH CAMPBELL
 VALPARAISO, INDIANA 46383-4210
- 40920 MPB MINIATURE PRECISION BEARING DIV
 PRECISION PARK PO BOX 547
 KEENE, NEW HAMPSHIRE 03431
 FORMERLY MPB CORP AND MINIATURE BRG DIV MPB CORP

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VENDORS

5M902 FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV
3016 W LOMITA BLVD
TORRANCE, CALIFORNIA 90505-5103
FMLY IN REDONDO BEACH, CALIF

52825 HOFFMAN CAMERA CORP
19 GRAND AVENUE
FARMINGTON, NEW YORK 11735-6315

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

53551 ALLFAST FASTENING SYSTEMS INC
15200 EAST DON JULIAN ROAD PO BOX 3166
CITY OF INDUSTRY, CALIFORNIA 91745-1001
FORMERLY V0736B
FORMERLY ALLFAST INC V5K545

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

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

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

72962 HARVARD INDUSTRIES INC
3 WERNER WAY SUITE 210
LEBANON, NEW JERSEY 08833
FORMERLY AMERACE CORP ESNA DIV
FORMERLY ELASTIC STOP NUT IN UNION, NJ

73197 HI-SHEAR TECHNOLOGY CORP
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509

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VENDORS

75345 KIRKHILL RUBBER CO
 300 EAST CYPRESS STREET
 BREA, CALIFORNIA 92621-4007
 FORMERLY L.A. STANDARD RUBBER CO V84914

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

80539 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV
 2701 SOUTH HARBOR BOULEVARD PO BOX 1259
 SANTA ANA, CALIFORNIA 92702-1259
 FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539
 AND STANDARD PRESSED STEEL WESTERN DIV V17279

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

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

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

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ACMB542DDP818LY		3	495	2
		3	615	4
ACMB543DDP818LY		3	730	12
ACMKP16B005M		2	120	2
ACMKP33BP28LY19		2	81	2
		2	543	2
		2	750	1
		2	780	9
ACMKP33BP612LY1		2	81	2
		2	543	2
		2	750	1
		2	780	9
ACMKP33P28LY198		2	81	2
		2	543	2
		2	750	1
		2	780	9
ACMKP33P612LY19		2	81	2
		2	543	2
		2	750	1
		2	780	9
ACMKP4AP510LY19		3	210	4
		3	610	4
ACMKP5AP510LY19		3	325	2
ACMKP8AP510LY19		2	219	8
		2	321	12
AF3253-6-2B		17	30B	4
AF3553P6-5B		17	15A	4
AN960C416		3	550	4
AN960C416L		3	555	4
AN960PD416L		3	545	4
ARM5126		1	225A	1
ARR6M30A		2	267	12
BACB10DE6-06		2	267	12
BACB10FR16		2	120	2
BACB10FR33		2	81	2
		2	543	2
		2	750	1
		2	780	9
BACB10FS4		3	210	4
		3	610	4
BACB10FS5		3	325	2
BACB10FS8		2	219	8
		2	321	12

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BOEING
 COMPONENT
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB10FU21		3	495	2
BACB10FU21		3	615	4
BACB10FU25		3	730	12
BACB28AK04-023		3	80	2
		3	565	4
BACB28AK04-032		3	310	2
		3	410	2
BACB28AK04-042		3	75	2
		3	190	6
BACB28AK04-128		3	300	1
BACB28AK05-025		3	305	1
BACB28AK06-037		2	156	2
		2	249	2
		2	291	6
BACB28AK06-039		2	18	2
		2	159	6
BACB28AK06-042		2	21	2
		2	252	10
		2	294	6
BACB28AK08-038		2	405	2
BACB28AK08-042		2	402	2
BACB28W14C091		4	55	2
BACB28W18C093		4	50	2
BACB28X11M019		2	438	2
BACB28X11M024		2	459	2
BACB28X4C010		3	580	6
BACB28X4C012		3	335	1
		3	660	1
		3	810	2
		9	125	1
BACB28X4C014		9	80	2
BACB28X4C023		3	220	2
BACB28X4C025		3	590	4
BACB28X4M010		16	95	4
BACB28X4M016		3	225	4
BACB28X5C010		10	50	2
BACB28X5C012		3	330	1
BACB28X5C023		8	80	2
BACB28X5M010		1	385	2
		18	150	2
BACB28X6C015		2	372	6
BACB28X6C016		2	465	4
BACB28X6C024		2	108	2
		2	216	8
		2	324	12
		2	645	4

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB28X6M010		3	585	6
BACB28X6M012		3	345	1
		3	655	1
		3	805	2
		9	130	1
BACB28X6M014		9	75	6
BACB28X6M023		3	215	2
BACB28X7M012		3	340	1
BACB28X8C019		2	435	2
BACB28X8C024		2	456	2
BACB28X8C045		15	120	6
BACB28X8M010		10	45	2
BACB28X8M023		8	75	2
BACB28X8M024		1	440	6
		18	205	6
BACB28X9M015		2	375	6
BACB28X9M016		2	462	4
BACB28X9M020		2	213	8
		2	327	12
		2	648	4
BACB28X9M024		2	111	2
BACB30LH3-4		1	57	2
BACB30LH3-5		1	55B	6
BACB30LH3-6		1	95	72
		5	5	48
BACB30LH3K14		2	480	8
BACB30LH3K6		2	582	4
BACB30LH6		1	285A	6
		18	55	6
BACB30NM3K25		3	670	4
BACB30NM3K48		4	10	4
BACB30NN4K10		6	140	58
		19	140	58
BACB30NN4K11		6	135	26
		19	135	26
BACB30NN4K12		6	130	26
		19	130	26
BACB30NN4K9		6	145	58
		19	145	58
BACB30NN5K11		6	120	24
		19	120	24
BACB30NN5K13		6	115	8
		19	115	8
BACB30NN5K9		6	125	16
		19	125	16
BACB30NN6K10		6	100	4
		19	100	4

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BOEING
 COMPONENT
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30NN6K12		6	90	4
		19	90	4
BACB30NN6K14		6	95	4
		19	95	4
BACB30NN6K15		6	85	4
		19	85	4
BACB30NR4K16		3	160	2
		3	540	4
BACB30NR4K17		3	45	2
BACB30NR4K19		3	165	2
		3	250	2
		3	390	2
BACB30NR4K20		3	40	2
BACB30NR4K21		2	756	34
BACB30NR4K23		2	759	2
BACB30NR4K25		3	235	1
BACB30NR4K28		3	630	1
BACB30NR4K30		2	570	1
		2	660	9
BACB30NR4K32		3	750	2
		3	780	2
		3	820	2
BACB30NR4K33		2	33	2
		3	845	12
BACB30NR4K34		2	420	2
BACB30NR4K36		2	633	8
BACB30NR4K45		3	500	2
BACB30NR4K6		3	505	8
BACB30NR4K7		3	450	3
BACB30NR4K9		3	455	3
BACB30NR5K10		2	612	4
BACB30NR5K22		3	245	1
BACB30NR5K23		2	492	8
BACB30NR5K32		2	732	3
BACB30NR5K47		2	186	2
BACB30NR5K50		2	189	2
BACB30NR5K56		2	300	6
BACB30NR6K10		2	336	12
BACB30NR6K11		2	504	2
BACB30NT3K4		1	195	66
BACB30NT3K5		9	15	4
BACB30NT6K13		6	105	4
		19	105	4

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30NT6K9		6	110	4
		19	110	4
BACB30NX10K4		14	110	2
BACB30NX10K6		14	105	2
BACB30NX10K7		6	80	4
		19	80	4
BACB30NX10K8		15	50	6
BACB30NX10K9		6	75	4
		19	75	4
BACB30NX12K10		6	65	6
		19	65	6
BACB30NX12K7		6	60	4
		19	60	4
BACB30NX12K9		6	70	4
		19	70	4
BACB30NX6K4		1	450	4
		10	15	4
		14	160	16
		15	65	8
BACB30NX6K5		18	215	4
		1	455	8
		18	220	8
BACB30NX6K6		10	10	8
		3	735	36
BACB30NX6K7		15	70	4
		3	700	72
BACB30NX6K9		7	120	4
		14	155	4
		15	60	4
BACB30NX8K4		6	275	2
		11	30	8
		12	20	3
		14	145	16
BACB30NX8K5		19	270	2
		7	122	4
		12	25	1
BACB30NX8K6		14	150	8
		15	55	4
		14	10	2
BACB30NX8K7		14	100	4
		4	30	4
		3	5	4
BACB30NY5K4		3	240	1
BACB30PW4-14		1	240	4
BACB30PW5P32		18	10	4

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BOEING
 COMPONENT
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30US9K23		1	235	4
		18	5	4
BACB30UU4K29		2	93	4
BACB30UU4K33		2	687	1
BACB30UU5K21		2	720	4
BACB30UU6K22		2	273	6
BACB30UU6K24		2	141	2
		2	228	2
BACB30UU6K26		2	276	6
		2	3	4
		2	144	6
		2	231	9
BACB30UU6K28		2	234	1
BACB30UU8K22		2	387	2
BACB30UU8K25		2	384	2
BACB30VF3-6		1	35	20
BACB30VF3K6		1	35A	20
BACB30VF3K7		1	15A	24
BACB30VF4K6		16	5	8
BACB30VF4K7		16	7	8
BACB30VT10K10		13	45	16
BACB30VT10K12		13	50	4
BACB30VT10K7		13	10	6
BACB30VT10K8		13	40	2
BACB30VT12K11		13	15	2
BACB30VT12K17		13	55	8
BACB30VT6K3		6	285	4
		8	20	4
BACB30VT6K4		19	280	4
		6	280	4
		8	10	8
		9	45	8
BACB30VT6K5		19	275	4
		8	55	4
		9	40	8
		15	100	48

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30VT6K6		8	15	4
		9	110	4
BACB30VT6K8		1	415	6
		18	180	6
BACB30VT8K10		15	140	12
BACB30VT8K23		1	410	6
		18	175	6
BACB30VT8K25		1	405	6
		18	170	6
BACB30VT8K7		13	60	12
		15	135	48
BACB30VT8K8		15	145	12
BACB30VU6K4		1	365	2
		18	130	2
BACB30VU6K5		1	475	16
		16	80	4
		18	265	16
BACB30VU6K6		1	360	4
		7	90	4
		16	35	8
		18	125	4
BACB30VU6K8		7	85	4
BACB30VU8K6		1	355	4
		18	120	4
BACC30BL10		13	20	6
		13	65	22
BACC30BL12		13	25	2
		13	70	8
BACC30BL6		1	375	6
		1	425	6
		6	295	8
		8	30	16
		8	60	4
		9	55	16
		9	115	4
		15	105	48
		16	40	8
		16	85	4
		18	140	6
		18	190	6
		19	290	8

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BOEING
 COMPONENT
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ	
BACC30BL8		1	370	4	
		1	420	12	
		13	75	12	
		15	150	72	
		18	135	4	
		18	185	12	
BACC30BQ6		1	480	16	
		7	95	8	
		18	270	16	
BACC30X10		14	120	4	
		15	75	6	
		4	35	4	
BACC30X5		4	35	4	
BACC30X6		1	465	12	
BACC30X6		3	710	72	
		3	740	36	
		10	17	12	
		14	170	16	
		15	85	12	
		18	230	12	
	BACC30X8		6	290	2
			7	130	8
			11	35	8
			12	30	4
		14	15	2	
		14	115	4	
		14	165	28	
		15	80	8	
		19	285	2	
BACF3H08RC027HS			17	45A	2
BACF3T02F8G8		7	45	2	
BACG20AD0707		9	105A	6	
BACJ40A20-7		2	564	1	
BACJ40K5A5A4		1	175	1	

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACN10GH3-10		1	468	1
		18	245	1
BACN10HR8CD		1	270	4
		18	40	4
BACN10HR9CD		1	265	4
		18	35	4
BACN10JB3		5	25	24
BACN10JC3CD		3	685	4
		4	15	4
		9	25	4
BACN10JC4		3	560	4
BACN10JC4CD		3	645	1
BACN10JC4CM		2	102	4
BACN10JC8CD		2	399	4
BACN10JP3ACD		1	155	1
BACN10JP3ACM		16	65A	1
BACN10JP3B		11	50	2
		11	70	1
		12	45	2
BACN10JR3CD		14	40	12
		14	65	14
		14	90	14
BACN10JR3CFD		6	20	9
		6	40	10
		15	20	11
BACN10JR3CFD		15	40	12
		19	20	9
		19	40	10
BACN10JR3F		1	80	2
BACN10JZ3A2		1	85	6
		2	603	4
BACN10JZ3A4CDM		6	55	52
		19	55	52

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BOEING
 COMPONENT
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACN10JZ4A2CDM		16	20	16
BACN10KA3AR		5	25A	24
BACN10KA3CR		5	20A	24
BACN10KB3		11	50A	2
		12	45A	2
BACN10KB3F		5	20	24
BACN10KE3B2		16	15	16
BACN10KE3B2CD		9	10	8
BACN10KE3B3CD		17	10	24
BACN10KH3CD		7	115	4
BACN10YR3CD		2	60	4
		2	78	16
		2	138	20
		2	486	8
		2	561	2
		3	25	4
BACN10YR4CD		2	42	2
		2	429	2
		2	579	1
		2	642	8
		2	669	9
		2	696	1
		2	771	36
		3	70	4
		3	185	4
		3	290	4
		3	405	2
		3	470	6
		3	530	10
		3	765	2
		3	795	2
		3	835	2
		3	860	12
BACN10YR5CD		2	198	4
		2	309	6
		2	501	8
		2	618	4
BACN10YR5CD		2	729	4
		3	295	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ	
BACN10YR6CD		1	300	6	
		2	15	4	
		2	153	8	
		2	246	12	
		2	288	12	
		2	345	12	
		2	513	2	
		6	180	8	
		18	65	6	
		19	180	8	
	BACR15BA3AD		2	600	8
			5	15	96
			6	15	18
		6	35	20	
		11	45	4	
		11	65	2	
		12	40	4	
		14	35	24	
		14	60	28	
		14	85	28	
		15	15	22	
		15	35	24	
		19	15	18	
		19	35	20	
BACR15BA4B			1	507	244
		7	25	10	
		18	305	244	
BACR15BA5AD		15	5	19	
BACR15BB8AD		6	315	2	
		19	310	2	
BACR15CE3AD		1	75	16	
		6	50	104	
		7	110	8	
		9	5	16	
		16	10	64	
		17	5	48	
		19	50	104	

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BOEING
 COMPONENT
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ	
BACR15CE3D		1	130	1	
		1	150	2	
		1	467A	2	
		16	60	2	
		18	240A	2	
	BACR15CE4AD		7	10	32
			7	73A	4
	BACR15CE6AD		7	73A	4
	BACR15FR6E2R		17	30B	4
	BACR15FR6E5R		17	30A	4
	BACR15FR6MP5R		17	15A	4
	BACR15FT4KE		7	60	8
	BACR15FT6KE		1	460	16
			6	5	27
			7	70	12
			7	125	12
			7	155	4
			8	25	14
		9	50	24	
		10	20	16	
		14	20	26	
		18	225	16	
		19	5	27	
BACR15FV5KE		16	25	8	
BACR15FV6KE		7	20	4	
		7	150	4	
		16	50	7	
BACS12CK3-8		1	165	1	
BACS40R008B010F		8	35	8	
BACS40R008B020F		8	105	6	
BACS40R009B010F		3	600	8	
BACS40R009B020F		8	110	4	
BACS40R010B014F		9	140	1	

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACS4OR010B033F		9	145	1
BACS4OR010C010F		2	744	3
BACS4OR010F054F		9	100	8
BACS4OR011C021F		1	395	2
		18	160	2
BACS4OR011F025F		14	135	2
BACS4OR016C061F		13	95	2
BACS4OR016C069F		13	90	4
BACS4OR019B028F		3	725	24
BACS4OR021C036F		15	155	6
BACS4OR021C040F		1	400	1
		18	165	1
BACS4OR032C065F		15	160	6
BACS53B1EA1		6	310	2
		19	305	2
BACW10BN3AC		2	54	4
		2	72	16
		2	132	20
		2	555	2
BACW10BN4AC		2	636	8
		3	55	2
		3	170	2
		3	255	1
		3	460	6
		3	515	8
		3	755	2
		3	785	2
		3	825	2
		3	850	12
BACW10BP4ACU		2	36	2
		2	96	4
		2	423	2
		2	573	1
		2	663	9
		3	50	2
		3	175	2
		3	270	2
		3	395	2
		3	510	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACW10BP4CD		2	690	1
		2	762	36
BACW10BP4DP		6	160	168
		19	160	168
BACW10BP5ACU		2	192	4
		2	303	6
		3	265	1
BACW10BP5CD		2	495	8
		2	723	4
		2	735	3
BACW10BP5DP		6	155	56
		19	155	56
BACW10BP6ACU		2	339	12
BACW10BP6CD		2	6	4
		2	147	8
		2	237	12
		2	279	12
		2	507	2
BACW10BP6DP		6	150	38
		19	150	38
BACW10BP8CD		1	250	4
		2	390	4
		18	20	4
BACW10BP8DP		1	260	4
		18	30	4
BACW10BP9CD		1	245	4
		18	15	4
BACW10BP9DP		1	255	4
		18	25	4
BH00303CM8		1	270	4
		18	40	4
BH00303CM9		1	265	4
		18	35	4
BMN10HRCWD3-8		1	270	4
		18	40	4
BMN10HRCWD3-9		1	265	4
		18	35	4
BMN4122CPD8-8		2	399	4
BMN5024CWD3-8		1	270	4
		18	40	4
BMN5024CWD3-9		1	265	4
		18	35	4
BMN5024CWD38		1	270	4
		18	40	4
BMN5024CWD39		1	265	4
		18	35	4

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BRFR220A3-2		16	15	16
BRFR220C3-2D		9	10	8
BRFR220C3-3D		17	10	24
BRF100A3		5	20	24
BRF200A3		1	80	2
BRF200C3D		6	20	9
		6	40	10
		15	20	11
		15	40	12
		19	20	9
		19	40	10
BRF210A3		5	25	24
BRH10A4		3	560	4
BRH10C3D		3	685	4
		4	15	4
		9	25	4
BRH10C4D		3	645	1
BRH10C4M		2	102	4
BRM100A3		11	50	2
		11	70	1
		12	45	2
BRM200C3M		16	65A	1
BR1000A3		11	50A	2
		12	45A	2
BR2000C3D		14	40	12
		14	65	14
		14	90	14
CA4T6V		1	175A	1
CR3253-6-2		17	30B	4
CR3253-6-5		17	30A	4
CR3553P6-5		17	15A	4
CR60308		1	270	4
		18	40	4

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
CR60309		1	265	4
		18	35	4
CYR3-4SCP		3	570A	4
DDR6-96A1-501		2	297	6
D2070-11		2	621	1
FS1651-3		7	115	4
F171-3		5	25	24
F1968-3BAC		1	85	6
		2	603	4
F2000-3		5	20	24
F5000-3BAC		1	80	2
F51643-4BAC		16	20	16
F51645-3BAC		6	55	52
		19	55	52
F51747-3-2CD		9	10	8
F51747-3-3CD		17	10	24
F51750-3-2		16	15	16
HL1012AZ10-4		14	110	2
HL1012AZ10-6		14	105	2
HL1012AZ10-7		6	80	4
		19	80	4
HL1012AZ10-8		15	50	6
HL1012AZ10-9		6	75	4
		19	75	4
HL1012AZ12-10		6	65	6
		19	65	6
HL1012AZ12-7		6	60	4
		19	60	4
HL1012AZ12-9		6	70	4
		19	70	4
HL1012AZ6-4		1	450	4
		10	15	4
		14	160	16
		15	65	8
		18	215	4

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL1012AZ6-5		1	455	8
		18	220	8
HL1012AZ6-6		10	10	8
HL1012AZ6-7		3	735	36
		15	70	4
HL1012AZ6-9		3	700	72
HL1012AZ8-4		7	120	4
		14	155	4
		15	60	4
HL1012AZ8-5		6	275	2
		11	30	8
		12	20	3
HL1012AZ8-5		14	145	16
		19	270	2
HL1012AZ8-6		7	122	4
		12	25	1
		14	150	8
		15	55	4
		14	10	2
HL1012AZ8-7		14	100	4
		14	120	4
		15	75	6
HL1187-10		4	35	4
HL1187-5		1	465	12
		3	710	72
HL1187-6		3	740	36
		10	17	12
		14	170	16
		15	85	12
		18	230	12
		6	290	2
		7	130	8
		11	35	8
HL1187-8		12	30	4
		14	15	2
		14	115	4
		14	165	28
		15	80	8
		19	285	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL12VAZ10-4		14	110	2
HL12VAZ10-6		14	105	2
HL12VAZ10-7		6	80	4
		19	80	4
HL12VAZ10-8		15	50	6
HL12VAZ10-9		6	75	4
		19	75	4
HL12VAZ12-10		6	65	6
		19	65	6
HL12VAZ12-7		6	60	4
HL12VAZ12-7		19	60	4
HL12VAZ12-9		6	70	4
		19	70	4
HL12VAZ6-4		1	450	4
		10	15	4
		14	160	16
		15	65	8
		18	215	4
HL12VAZ6-5		1	455	8
		18	220	8
HL12VAZ6-6		10	10	8
HL12VAZ6-7		3	735	36
		15	70	4
HL12VAZ6-9		3	700	72
HL12VAZ8-4		7	120	4
		14	155	4
		15	60	4
HL12VAZ8-5		6	275	2
		11	30	8
		12	20	3
		14	145	16
		19	270	2
HL12VAZ8-6		7	122	4
		12	25	1
		14	150	8
		15	55	4
HL12VAZ8-7		14	10	2
		14	100	4

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL13VAZ5-4		4	30	4
HL86PB5		4	35	4
HL87-10		14	120	4
		15	75	6
HL87-5		4	35	4
HL87-6		1	465	12
		3	710	72
		3	740	36
		10	17	12
		14	170	16
		15	85	12
		18	230	12
HL87-8		6	290	2
		7	130	8
		11	35	8
		12	30	4
		14	15	2
		14	115	4
		14	165	28
		15	80	8
		19	285	2
HST10AG10-10		13	45	16
HST10AG10-12		13	50	4
HST10AG10-7		13	10	6
HST10AG10-8		13	40	2
HST10AG12-11		13	15	2
HST10AG12-17		13	55	8
HST10AG6-3		6	285	4
		8	20	4
		19	280	4
HST10AG6-4		6	280	4
		8	10	8
		9	45	8
		19	275	4
HST10AG6-5		8	55	4
		9	40	8
		15	100	48
HST10AG6-6		8	15	4
		9	110	4
HST10AG6-8		1	415	6
		18	180	6
HST10AG8-10		15	140	12
HST10AG8-23		1	410	6
		18	175	6

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HST10AG8-25		1	405	6
		18	170	6
HST10AG8-7		13	60	12
		15	135	48
		15	145	12
HST10AG8-8		15	145	12
HST11AG6-4		1	365	2
		18	130	2
HST11AG6-5		1	475	16
		16	80	4
		18	265	16
HST11AG6-6		1	360	4
HST11AG6-6		7	90	4
		16	35	8
		18	125	4
HST11AG6-8		7	85	4
HST11AG8-6		1	355	4
		18	120	4
HST79-10		13	20	6
		13	65	22
HST79-12		13	25	2
		13	70	8
HST79-6		1	375	6
		1	425	6
		6	295	8
HST79-6		8	30	16
		8	60	4
		9	55	16
		9	115	4
		15	105	48
		16	40	8
		16	85	4
		18	140	6
		18	190	6
19	290	8		

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ		
HST79-8		1	370	4		
		1	420	12		
		13	75	12		
		15	150	72		
		18	135	4		
HST79-8		18	185	12		
HST79CY10		13	20	6		
		13	65	22		
HST79CY12		13	25	2		
		13	70	8		
HST79CY6		1	375	6		
		1	425	6		
		6	295	8		
		8	30	16		
		8	60	4		
		9	55	16		
		9	115	4		
		15	105	48		
		16	40	8		
		16	85	4		
		18	140	6		
		18	190	6		
		19	290	8		
		HST79CY8		1	370	4
				1	420	12
13	75			12		
15	150			72		
18	135			4		
HST82CY6APBW		18	185	12		
		1	480	16		
		7	95	8		
HST826AW		18	270	16		
		1	480	16		
		7	95	8		
		18	270	16		

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
H01-4BAC		2	102	4
H10-4BAC		3	560	4
H51560		1	265	4
		1	270	4
H51560		18	35	4
		18	40	4
H51560-8		1	270	4
		18	40	4
H51560-9		1	265	4
		18	35	4
H51650-3BAC		3	685	4
		4	15	4
		9	25	4
H51650-4BAC		3	645	1
H51650-8BAC		2	399	4
H52732-3CD		2	60	4
		2	78	16
		2	138	20
		2	486	8
		2	561	2
		3	25	4
H52732-4CD		2	42	2
		2	429	2
		2	579	1
		2	642	8
		2	669	9
		2	696	1
		2	771	36
		3	70	4
		3	185	4
		3	290	4
		3	405	2
		3	470	6
		3	530	10
		3	765	2
		3	795	2
		3	835	2
		3	860	12

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
H52732-5CD		2	198	4
		2	309	6
		2	501	8
		2	618	4
		2	729	4
		3	295	1
H52732-6CD		1	300	6
		2	15	4
		2	153	8
		2	246	12
		2	288	12
H52732-6CD		2	345	12
		2	513	2
		6	180	8
		18	65	6
		19	180	8
		11	50A	2
K2000-3		12	45A	2
K51601-3BAC		14	40	12
		14	65	14
		14	90	14
K51602-3BAC		6	20	9
		6	40	10
		15	20	11
		15	40	12
		19	20	9
		19	40	10
L801-5K4		4	30	4
L802-10K4		14	110	2
L802-10K6		14	105	2
L802-10K7		6	80	4
		19	80	4

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
L802-10K8		15	50	6
L802-10K9		6	75	4
		19	75	4
L802-12K10		6	65	6
		19	65	6
L802-12K7		6	60	4
		19	60	4
L802-12K9		6	70	4
		19	70	4
L802-6K4		1	450	4
		10	15	4
		14	160	16
		15	65	8
		18	215	4
L802-6K5		1	455	8
		18	220	8
L802-6K6		10	10	8
L802-6K7		3	735	36
		15	70	4
L802-6K9		3	700	72
L802-8K4		7	120	4
		14	155	4
L802-8K4		15	60	4
L802-8K5		6	275	2
		11	30	8
		12	20	3
		14	145	16
		19	270	2
L802-8K6		7	122	4
		12	25	1
		14	150	8
		15	55	4
L802-8K7		14	10	2
		14	100	4
MK1001-3BAC		16	65A	1
MK2000-3BAC		11	50	2
		11	70	1
		12	45	2
MS20615-4M		2	264	6
		3	90	4
MS24665-86		1	120	1
MS27253F2		1	620	1
MS29513-210		2	594	1
MS39086-143		3	110	2
NAS1149C0332B		3	20	4

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NAS1149C0416R		2	576	1
		2	666	9
NAS1149C0432B		3	65	2
		3	180	4
		3	275	2
		3	520	2
NAS1149C0432R		2	99	4
		2	693	1
NAS1149C0463R		2	426	2
NAS1149C0632R		1	295A	6
		2	711	2
		18	60	6
NAS1149C0663R		2	12	2
		2	243	2
		2	282	6
		2	342	12
NAS1149C0832R		2	396	2
NAS1149C0863R		2	393	2
NAS1149D0316H		2	483	8
NAS1149D0332J		3	675	4
NAS1149D0363J		1	135	1
		1	170	1
NAS1149D0363J		2	57	4
		2	75	16
		2	135	20
		2	558	4
		3	680	4
NAS1149D0416J		2	765	36
		3	635	1
NAS1149D0432J		2	639	8
		3	10	2
		3	60	2
		3	285	2
		3	400	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NAS1149D0463J		2	768	4
		3	15	2
		3	465	6
		3	525	8
		3	640	1
		3	760	2
		3	790	2
		3	830	2
		3	855	12
	NAS1149D0532J		3	280
NAS1149D0563J		2	195	4
		2	306	6
		2	498	8
NAS1149D0663J		3	260	1
		2	9	2
		2	150	6
		2	240	11
		2	285	6
		2	510	2
NAS1149D0663R		2	151	2
NAS1149F0363P		9	20	8
NAS1149F0463P		2	39	2
NAS1149F0532P		2	615	4
		2	738	3
NAS1149F0563P		2	726	4
NAS1399B4-2		7	15	8
NAS1423-4		3	360	1
		3	420	1
NAS1423-6		2	165	4
		2	258	6
NAS1423-8		2	168	4
		2	411	2
		3	130	2
NAS1801-3-15		2	549	1
NAS1804-4		6	175	168
		19	175	168

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NAS1804-5		6	170	56
		19	170	56
NAS1804-6		6	165	30
		19	165	30
NAS1805-14L		4	25	2
NAS1805-5L		2	741	3
NAS42DD3-28FC		1	140A	1
NAS428-6-11		2	708	2
NAS509-6		2	714	2
NAS513-6		2	261	6
NAS513-8		2	408	2
		3	125	2
NAS516-1A		2	522	2
		11	90	6
		12	70	4
		13	110	2
		14	185	2
NAS6703-5		2	66	4
NAS6703-6		2	69	12
		2	126	12
		2	552	1
NAS6703-7		2	51	4
		2	129	8
NAS72-5E209		2	201	2
NAS72-5E214		2	204	2
NAS72-5E303		2	312	6
NS103191-02-2		16	15	16
NS103197SE02		16	65A	1
NS103198-02		11	50	2
		11	70	1
		12	45	2
NS103203-02		1	80	2
NS103224-02		1	85	6
		2	603	4

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NS103226-02BC		5	25A	24
NS103228-02BC		5	20A	24
NS202101-048		3	560	4
NS202439-02		14	40	12
		14	65	14
		14	90	14
NS202476-02		6	20	9
		6	40	10
NS202476-02		15	20	11
		15	40	12
		19	20	9
		19	40	10
NS202486-02		3	685	4
		4	15	4
		9	25	4
NS202486-048		3	645	1
NS202492-048		16	20	16
NS202492A02		6	55	52
		19	55	52
NS202493-02-2		9	10	8
NS202493-02-3		17	10	24
NS202496-02		7	115	4
PACMB542DDA3908		3	495	2
		3	615	4
PACMB542DDFS428		3	495	2
		3	615	4
PACMB543DDA3908		3	730	12
PACMKP16BA3908		2	120	2
PACMKP16BFS428		2	120	2
PACMKP33BA3908		2	81	2
		2	543	2
		2	750	1
		2	780	9
PACMKP33BFS428		2	81	2
		2	543	2
		2	750	1
		2	780	9
PACMKP4AA3908		3	210	4
		3	610	4
PACMKP4AFS428		3	210	4
		3	610	4
PACMKP5AA3908		3	325	2
PACMKP8AA3908		2	219	8
		2	321	12

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
PACMKP8AFS428		2	219	8
		2	321	12
PLH53CD		2	60	4
		2	78	16
		2	138	20
		2	486	8
		2	561	2
PLH53CD		3	25	4
PLH54CD		2	42	2
		2	429	2
		2	579	1
		2	642	8
		2	669	9
		2	696	1
		2	771	36
		3	70	4
		3	185	4
		3	290	4
		3	405	2
		3	470	6
		3	530	10
		3	765	2
		3	795	2
		3	835	2
		3	860	12
PLH55CD		2	198	4
		2	309	6
		2	501	8
		2	618	4
		2	729	4
		3	295	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ	
PLH56CD		1	300	6	
		2	15	4	
		2	153	8	
		2	246	12	
		2	288	12	
		2	345	12	
		2	513	2	
		6	180	8	
		18	65	6	
		19	180	8	
	RBEJ40K5A5A4 RMA9207-3		1	175	1
			11	50	2
			11	70	1
RMF9201-3 RMF9207-3 RMF9213-2-3 RMF9219-3		12	45	2	
		1	80	2	
		5	20	24	
		16	15	16	
		1	85	6	
RMLH9075-4W SAT42-56B1-502		2	603	4	
		3	560	4	
		2	489	2	
		2	540	2	
SE98A3		1	85	6	
		2	603	4	
SFP8-8A1-501 SL7108C8		2	417	2	
		1	270	4	
		18	40	4	
SL7108C9		1	265	4	
		18	35	4	
SM4-4J20		3	365	1	
		3	425	1	

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
SM4-6AW1-501		3	150	2
SM6-6C23		2	267	12
SM8-8C1-501		2	414	2
SPH4-10B4		3	95	2
SSMB542DDSD705		3	495	2
		3	615	4
SSMB543DDSD705		3	730	12
SSMKP16BSD702		2	120	2
SSMKP33BSD702		2	81	2
		2	543	2
		2	750	1
		2	780	9
SSMKP4AP		3	210	4
		3	610	4
SSMKP4ASD705		3	210	4
		3	610	4
SSMKP5AP		3	325	2
SSMKP8AP		2	219	8
		2	321	12
SSMKP8ASD705		2	219	8
		2	321	12
S012T236-104		2	414	2
S012T236-105		2	417	2
S012T236-203		2	297	6
S012T236-530		2	174	4
S012T236-600		2	489	2
		2	540	2
S012T236-657		3	150	2
S140T260-5		3	315	1
S140T263-143		1	225A	1
S18234-143		1	225A	1
T6C1032JCD		3	685	4
T6C1032JCD		4	15	4
		9	25	4
T6C428JCD		3	645	1
T6C428JM		2	102	4
T6S428J		3	560	4
T8077S1032		11	50	2
		11	70	1
		12	45	2
T8080C1032		16	65A	1
T8091S1032		1	80	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
T8092C1032CD		6	20	9
		6	40	10
		15	20	11
		15	40	12
		19	20	9
		19	40	10
T8097S1032BCK		5	25A	24
T8101S3SBCK		5	20A	24
T8109S1032		11	50A	2
		12	45A	2
T8114S1032S		5	20	24
VCU0005D9		1	265	4
		18	35	4
VNS1924CA1-8		6	310	2
		19	305	2
VNS1924CA3-1-8		6	310	2
		19	305	2
VN101A1-02		11	50A	2
		12	45A	2
VN151A1-02		5	20	24
VN152A1-02		1	80	2
VN201A1-02		11	50	2
		11	70	1
		12	45	2
VN202D1-02		16	65A	1
VN303A048		3	560	4
VN303D048		2	102	4
WSI332-10		1	468	1
		18	245	1
YCRS12CP		3	570	4
012T2400-29		15	170	12
10106-658		2	489	2
		2	540	2
10106-731		3	150	2
102A9201-3		14	40	12
102A9201-3		14	65	14
		14	90	14
102A9213-2-3		9	10	8
102A9213-3-3		17	10	24
102F9201-3		6	20	9
		6	40	10
		15	20	11
		15	40	12
		19	20	9
		19	40	10

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
102F9209M3		7	115	4
102F9219-4		16	20	16
102F9221-3		6	55	52
		19	55	52
102LH9031-8		1	270	4
		18	40	4
102LH9031-9		1	265	4
		18	35	4
102LH9074-8		2	399	4
102LH9075-3W		3	685	4
		4	15	4
		9	25	4
102LH9075-4W		3	645	1
109A9201M3		16	65A	1
109LH9075-4W		2	102	4
140T2933-1		3	100	2
140T2972-2		3	135	2
140T2973-1		3	115	2
140T2974-1		3	105A	2
140T2975-3		3	535	2
140T2976-1		3	120	2
140T2993-4		3	595	2
140T2993-5		3	575	2
141T6165-1		2	171	4
141T6171-10		3	375	1
		3	435	1
141T6171-5		2	177	4
		3	145	2
143T6200-1		1	1A	RF
143T6203-1		1	230	1
143T6203-2		1	230A	1
		18	1A	RF
143T6203-5001		1	616	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
143T6205-1		1	5	1
		2	1A	RF
143T6206-1		1	430	5
		18	195	5
143T6206-2		1	435	1
		18	200	1
143T6206-3		1	445	6
		18	210	6
143T6207-1		1	10	1
		3	1A	RF
143T6208-1		1	190	1
143T6208-2		1	220	1
143T6208-3		1	215	1
143T6208-4		1	210	1
143T6208-5		1	205	1
143T6208-6		1	200	1
143T6218-1		1	605	1
		15	1A	RF
		18	430	1
143T6220-1		15	165	6
143T6220-3		15	175	6
143T6221-1		15	110	5
143T6221-2		15	115	1
143T6221-5		15	125	5
143T6221-6		15	130	1
143T6223-1		15	95	1
143T6223-2		15	90	1
143T6224-1		1	595	1
		14	1A	RF
		18	420	1
143T6224-13		14	140	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
143T6224-2		1	600	1
		14	5	RF
		18	425	1
143T6225-1		14	125	1
143T6225-2		14	130	1
143T6226-1		1	350	1
		18	115	1
143T6226-2		1	345	1
		18	110	1
143T6226-3		1	340	1
		18	105	1
143T6226-4		1	335	1
		18	100	1
143T6226-5		1	330	1
		18	95	1
143T6226-6		1	325	1
		18	90	1
143T6226-7		1	320	1
		18	85	1
143T6226-8		1	315	1
		18	80	1
143T6228-1		14	175	1
143T6228-2		14	180	1
143T6228-3		14	190	1
143T6228-4		14	195	1
143T6229-1		9	120	1
143T6229-2		9	135	1
143T6230-1		1	585	1
		13	1A	RF
		18	410	1
143T6230-2		1	590	1
		13	5	RF
		18	415	1
143T6231-5		1	275A	1
		4	1B	RF
		18	45	1
143T6231-6		1	280A	1
		4	5A	RF
		18	50	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
143T6231-7		4	60A	1
143T6231-8		4	65A	1
143T6232-1		1	535	1
		11	1A	RF
		18	360	1
143T6232-2		1	540	1
		11	5	RF
		18	365	1
143T6232-3		1	545	1
		11	10	RF
		18	370	1
143T6232-4		1	550	1
		11	15	RF
		18	375	1
143T6233-1		1	555	1
		12	1A	RF
		18	380	1
143T6233-16		1	617A	1
		12	15A	RF
		18	395	1
143T6233-2		1	560	1
		12	5	RF
		18	385	1
143T6233-3		1	565	1
		12	10	RF
		18	390	1
143T6233-4		1	617	1
		12	15	RF
143T6234-1		1	575	1
		11	20	RF
		18	400	1
143T6234-2		1	580	1
		11	25	RF
		18	405	1
143T6240-1		1	520	1
		9	1A	RF
		18	345	1
143T6240-7		9	30	2
143T6240-8		9	35	2
143T6244-1		1	380	1
		18	145	1
143T6244-2		1	390	1
		18	155	1
143T6246-1		1	310	1
		18	75	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
143T6246-2		1	305	1
		18	70	1
143T6249-1		13	80	1
143T6249-2		13	85	1
143T6250-1		1	515	1
		8	1A	RF
		18	340	1
143T6250-2		1	510	1
		8	5	RF
		18	335	1
143T6254-19		8	95	1
143T6254-20		8	100	1
143T6255-1		11	80	3
		12	55	1
143T6255-10		13	105	1
143T6255-2		11	85	3
		12	60	2
143T6255-3		11	100	3
		12	80	1
143T6255-4		11	105	3
143T6255-4		12	85	2
143T6255-5		12	90	1
143T6255-6		12	65	1
143T6255-7		13	120	1
143T6255-8		13	125	1
143T6255-9		13	100	1
143T6256-1		11	95	6
		12	75	4
		13	115	2
143T6258-1		1	495	1
		6	1A	RF
143T6258-20		6	250	2
		19	245	2
143T6258-21		6	255	2
		19	250	2
143T6258-22		6	260	2
		19	255	2
143T6258-23		6	265	2
		19	260	2
143T6258-24		6	270	6
		19	265	6
143T6258-25		6	235	2
		19	230	2
143T6258-26		6	240	2
		19	235	2
143T6258-27		6	245	2
		19	240	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
143T6258-40		18	285	1
		19	1A	RF
143T6258-5001		6	185	1
143T6259-1		1	530	1
		10	1A	RF
		18	355	1
143T6259-2		1	525	1
		10	5	RF
		18	350	1
143T6260-1		8	65	1
143T6260-10		9	95	2
143T6260-11		10	60	1
143T6260-12		10	70	1
143T6260-13		10	30	1
143T6260-14		10	40	1
143T6260-15		10	25	1
143T6260-16		10	35	1
143T6260-17		10	55	1
143T6260-18		10	65	1
143T6260-2		8	70	1
143T6260-3		8	85	1
143T6260-4		8	90	1
143T6260-5		9	60	4
143T6260-6		9	65	2
143T6260-7		9	85	4
143T6260-8		9	90	2
143T6260-9		9	70	2
143T6261-1		6	305	1
		19	300	1
143T6261-2		6	300	1
		19	295	1
143T6262-1		6	230	1
		19	225	1
143T6262-2		6	225	6
		19	220	6
143T6262-3		6	220	1
		19	215	1
143T6263-1		6	215	1
143T6263-10		6	190A	1
		19	185	1
143T6263-2		6	210	1
		19	205	1
143T6263-3		6	205	1
143T6263-4		6	195	1
		19	190	1
143T6263-5		6	190	1
143T6263-6		6	200	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
143T6263-7		6	200A	1
		19	195	1
143T6263-8		6	215A	1
		19	210	1
143T6263-9		6	205A	1
		19	200	1
143T6267-1		13	30	1
143T6267-2		13	35	1
143T6271-15		8	50	2
143T6271-16		8	45	2
143T6271-17		8	40	2
143T6272-1		1	610	1
		16	1A	RF
		18	435	1
143T6276-2		16	75	1
143T6276-3		16	45	4
143T6281-1		1	490	6
		5	1A	RF
		18	280	6
143T6283-1		1	618	1
		17	1A	RF
143T6283-2		1	618A	1
		17	1B	RF
		18	440	1
143T6286-1		16	30	2
143T6288-1		1	70	1
143T6288-2		1	90	1
143T6291-1		1	45	2
143T6293-1		2	63	2
143T6294-1		2	123	2
143T6295-1		2	207	2
143T6295-2		2	222	2
143T6295-3		2	210	2
143T6295-4		2	225	2
143T6296-1		2	87	1
143T6296-2		2	90	1
143T6332-1		1	110	6
143T6339-3		2	591	1
143T6339-4		2	585	1
143T6346-1		5	40	12
143T6347-2		5	10	12
143T6347-3		5	35	12
143T6347-4		5	30	12
143T6366-2		1	100	6
143T6376-2		1	105	6
143T6376-4		2	588	1
		2	606	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
143T6401-3		2	360	6
143T6401-4		2	363	6
143T6402-1		2	630	4
143T6402-2		2	651	4
143T6405-7		2	774	5
143T6405-8		2	777	4
143T6407-3		2	783	9
143T6411-3		2	432	2
143T6411-4		2	441	2
143T6412-1		2	654	4
143T6412-7		2	657	1
143T6412-8		2	657A	1
143T6414-10		2	333A	1
143T6414-11		2	315	5
143T6414-12		2	318	1
143T6414-3		2	330	5
143T6414-4		2	333	1
143T6414-9		2	330A	5
143T6417-4		2	117	2
143T6418-16		2	105	2
143T6418-18		2	114	2
143T6419-1		2	717	2
143T6423-5		2	699	2
143T6423-6		2	702	1
143T6423-7		2	705	1
143T6424-1		3	715	6
143T6424-2		3	720	6
143T6424-5		3	715A	6
143T6424-6		3	720A	6
143T6426-4		3	480	2
143T6426-5		3	480A	2
143T6432-2		2	183	4
143T6433-4		2	162	4
143T6433-5		2	180	4
143T6446-1		3	650	1
143T6446-2		3	665	1
143T6453-1		3	870	2
143T6455-5		3	380	1
		3	440	1
143T6455-6		3	415	1
143T6455-7		3	430	1
143T6455-8		3	355	1
143T6455-9		3	370	1
143T6456-4		3	445	1
143T6456-5		3	385	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
143T6457-4		3	490	1
143T6458-1		3	745	12
143T6459-2		3	485	2
143T6459-4		3	475	1
143T6466-1		2	351	6
143T6467-1		2	354	6
143T6468-1		2	255	6
143T6468-2		2	270	6
143T6469-1		2	24	2
143T6469-2		2	30	2
143T6469-3		2	27	4
143T6469-4		2	27A	4
143T6470-1		2	348	12
143T6471-1		2	48	2
143T6472-1		2	45	2
143T6473-1		2	672	2
143T6473-2		2	675	2
143T6473-3		2	678	2
143T6473-4		2	681	2
143T6474-1		2	531	2
143T6474-2		2	534	2
143T6474-3		2	537	2
143T6478-1		3	705	24
143T6478-2		2	84	2
143T6481-1		2	597	1
143T6481-2		2	609	1
143T6490-1		2	516	1
143T6490-2		2	519	1
143T6490-3		2	525	1
143T6490-4		2	528	1
143T6491-1		2	546	2
143T6492-1		2	366	1
143T6492-2		2	369	5
143T6492-3		2	378	1
143T6492-4		2	381	5

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
143T6493-1		2	567	1
143T6494-1		2	684	1
143T6495-1		2	450	1
143T6495-2		2	453	1
143T6495-3		2	468	1
143T6495-4		2	471	1
143T6496-3		2	444A	1
143T6496-4		2	447A	1
143T6497-1		2	747	1
143T6498-1		2	753	1
143T6499-1		2	474	1
143T6499-2		2	477	1
143T6542-1		2	627	1
143T6544-1		4	20	2
143T6544-2		4	45	2
143T6544-3		4	40	2
143T6545-1		1	50	2
143T6545-2		1	30	2
143T6554-1		7	100	1
143T6554-2		7	105	1
143T6554-3		7	75	1
143T6554-4		7	80	1
143T6555-1		7	160	1
143T6555-10		7	35	1
143T6555-11		7	135	1
143T6555-12		7	140	1
143T6555-2		7	165	1
143T6555-3		7	50	1
143T6555-4		7	55	1
143T6555-5		7	65	2
143T6555-7		7	145	2
143T6555-9		7	30	1
143T6556-1		1	470	4
		18	260	4
143T6556-2		1	485	4
		18	275	4

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
143T6557-10		1	125A	1
143T6557-11		1	145A	1
143T6557-12		1	160A	1
143T6557-13		1	163	1
143T6557-7		1	115A	1
143T6557-8		1	180A	1
143T6557-9		1	185A	1
143T6558-1		16	90	2
143T6558-2		16	100	2
143T6560-1		1	25	2
143T6561-1		1	65	1
143T6562-1		1	60	1
143T6562-2		1	40	2
143T6562-3		1	20	2
143T6580-1		3	770	1
143T6580-2		3	775	1
143T6583-1		3	800	2
143T6583-2		3	815	2
143T6584-1		3	840	1
143T6593-1		3	320	1
143T6593-2		3	350	1
143T6596-1		3	690	2
143T6597-1		3	605	2
143T6597-2		3	620	2
143T6598-1		3	695	1
143T6599-1		3	625A	1
143T6601-2		3	85A	2
143T6603-1		3	195	2
143T6603-2		3	205	2
143T6603-3		3	230	2
143T6607-1		3	35	2
143T6610-1		3	200	2
143T6615-1		3	30	4
143T6616-1		3	140	2
143T6616-2		3	155	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
143T6617-1		3	865	12
143T6628-1		1	500	1
		7	1A	RF
		18	290	1
143T6628-2		1	505	1
		7	5	RF
		18	295	1
143T6629-1		1	506	1
		18	300	1
143T6629-2		1	507L	2
		18	310	2
143T6629-3		1	508L	1
		18	320	1
143T6629-4		1	508	1
		18	315	1
143T6629-5		1	509L	1
		18	330	1
143T6629-6		1	509	1
		18	325	1
143T6630-1		7	40	2
287T0013-112		17	25A	2
287T0013-96		11	75B	1
287T0013-97		11	60B	1
287T0014-649		1	469	1
		18	250	1
287T0014-664		1	466A	1
		18	235A	1
287T0015-381		1	472	1
		18	255	1
287T0020-161		12	35	2
287T0020-162		11	40	2
287T0020-163		12	50	2
287T0020-164		11	55	2
287T3030-58		17	40	1
287T3030-59		17	35	1
43600-02		5	25	24
453T7034-43		6	30	1
		19	30	1
453T7034-44		6	45	1
		19	45	1
453T7034-51		6	10	1
		19	10	1
453T7034-52		6	25	1
		19	25	1
453T7034-53		15	30	1

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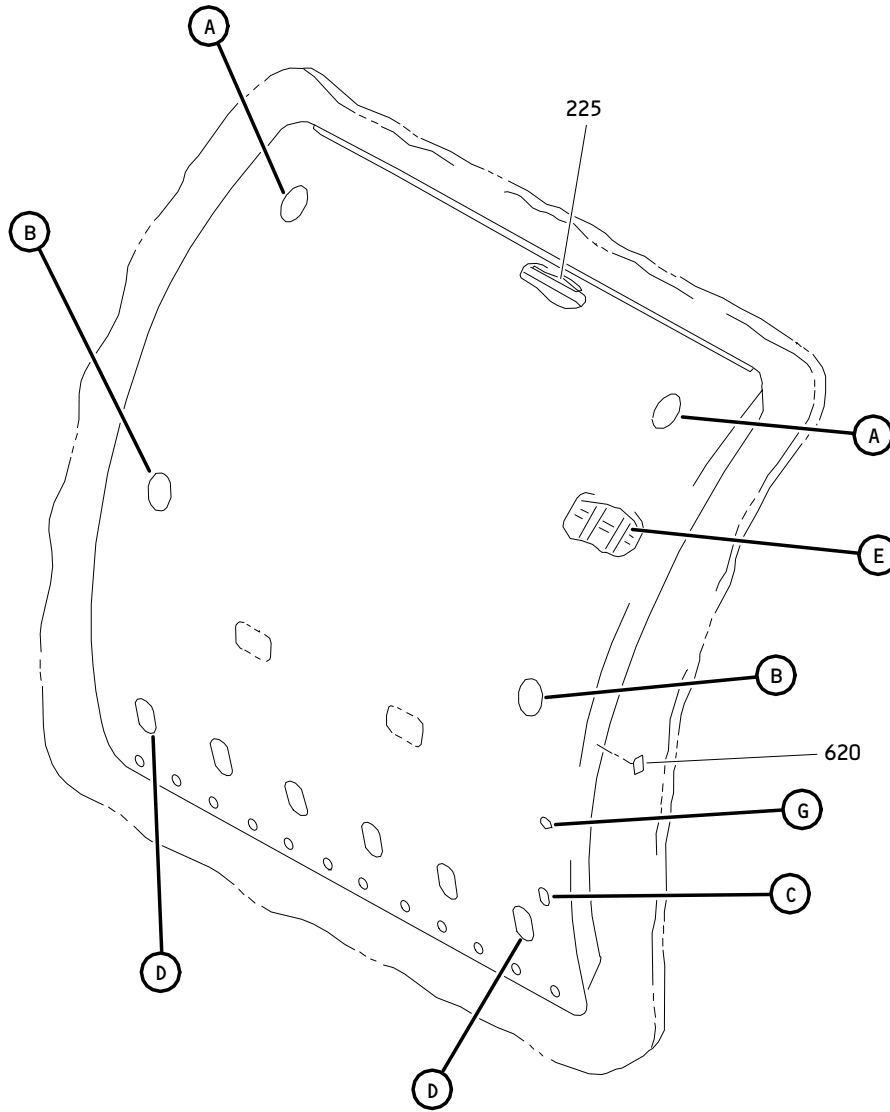
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
453T7034-54		15	45	1
453T7034-55		15	10	1
453T7034-56		15	25	1
453T7036-1		14	75	1
453T7036-2		14	80	1
453T7036-3		14	95	2
453T7036-4		14	70	2
453T7036-5		14	50	1
453T7036-6		14	55	1
453T7036-7		14	25	1
453T7036-8		14	30	1
453T7036-9		14	45	2
60B00304-6		2	621	1
67832CD820		1	270	4
		18	40	4
67832CD918		1	265	4
		18	35	4
69B16419-1		16	55	1
69B16419-2		16	70	1
69B17196-1		2	357	6
69235-820CD		2	399	4
9NS202101SE048		2	102	4
96-048		3	560	4
97E48		2	102	4

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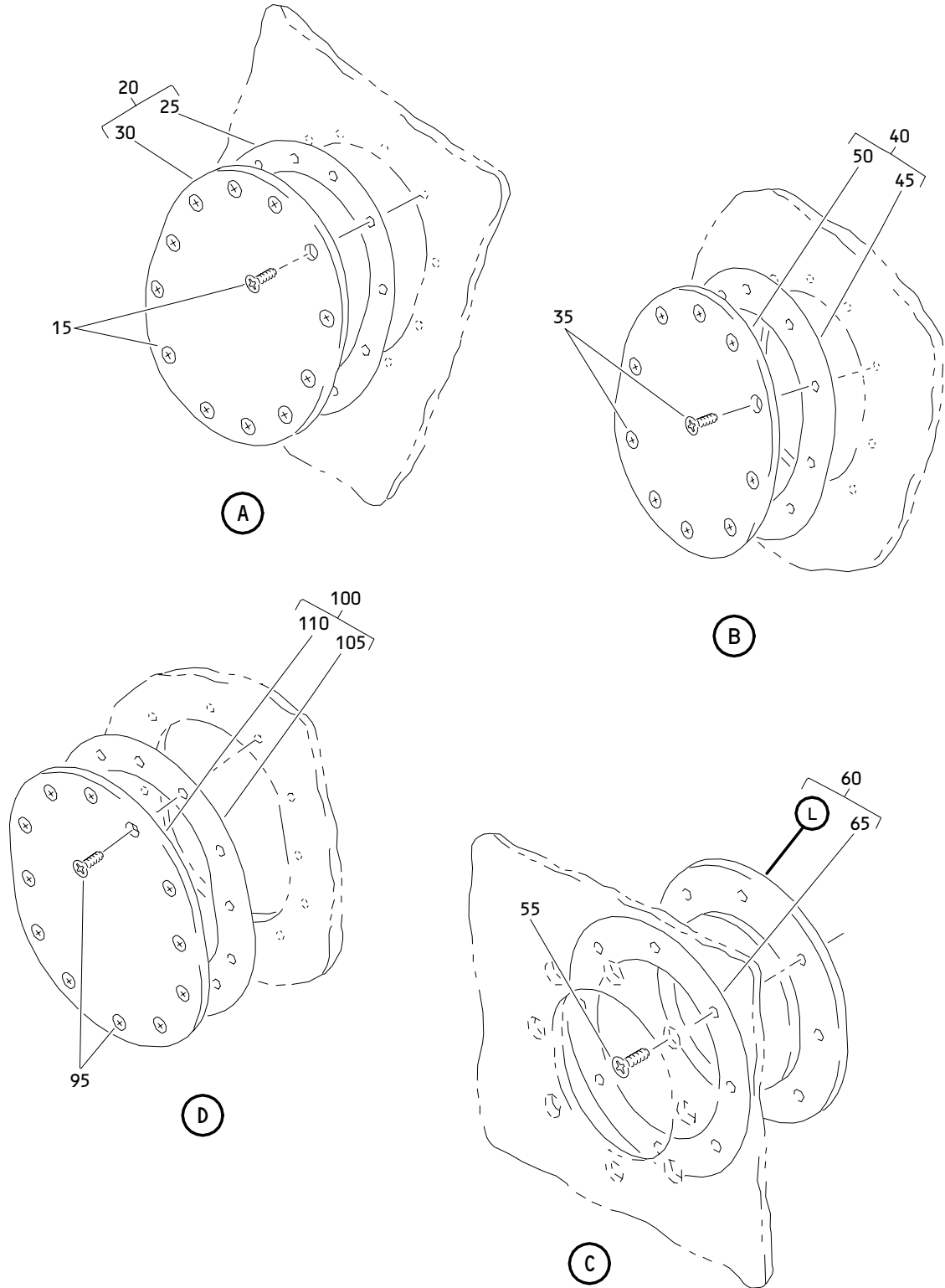
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Main Deck Cargo Door Assembly
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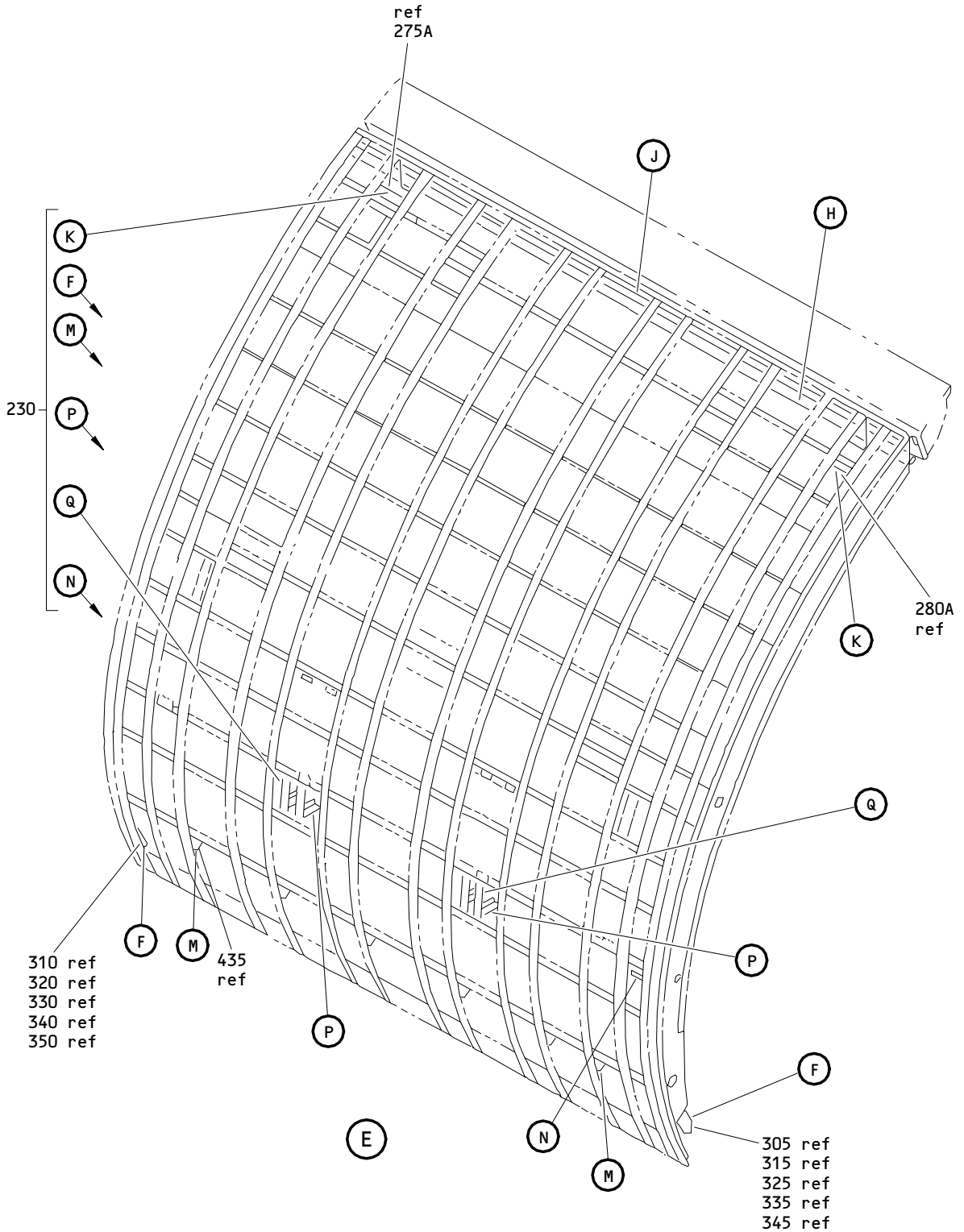
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Main Deck Cargo Door Assembly
Figure 1 (Sheet 2)

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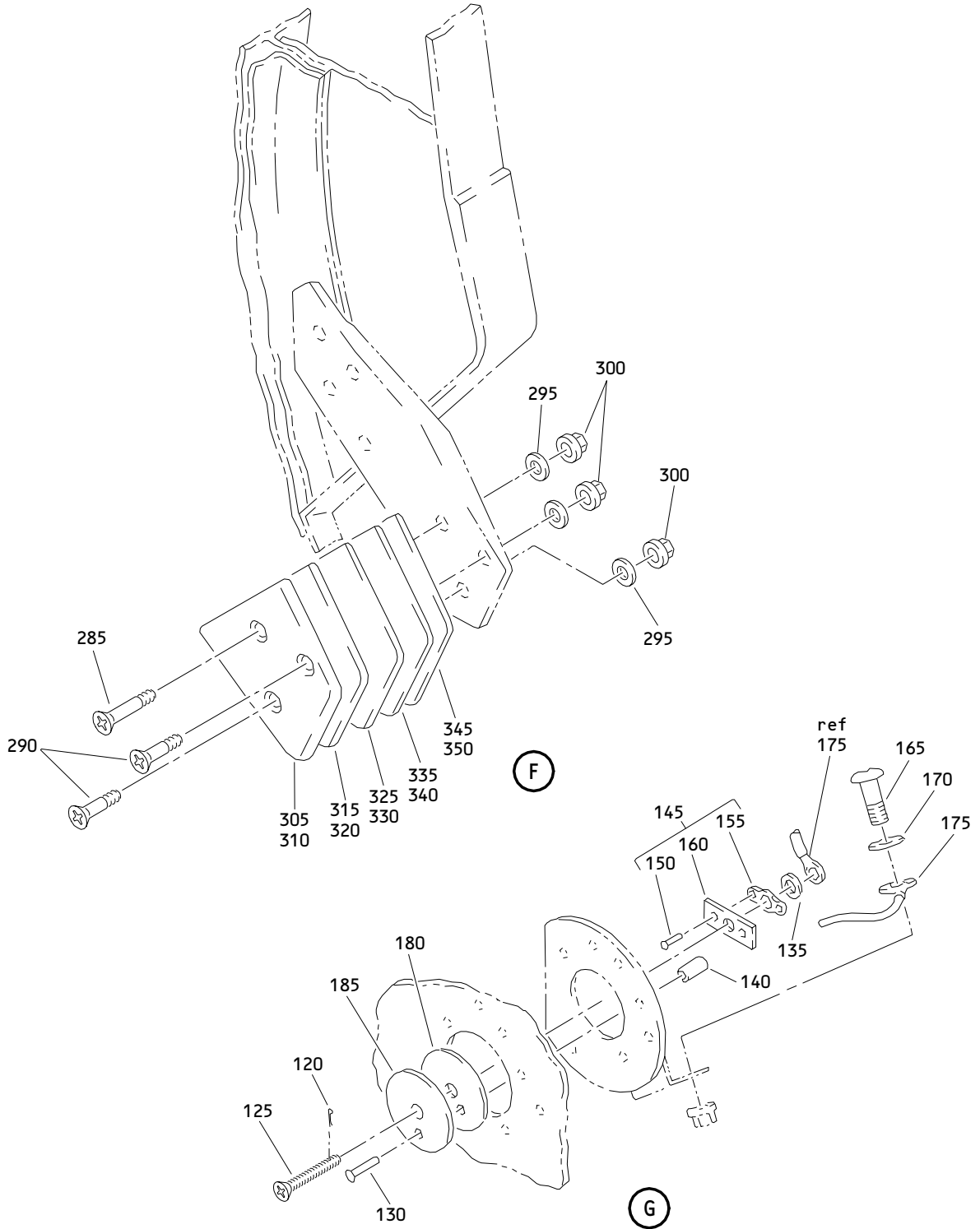
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**Main Deck Cargo Door Assembly
 Figure 1 (Sheet 3)**

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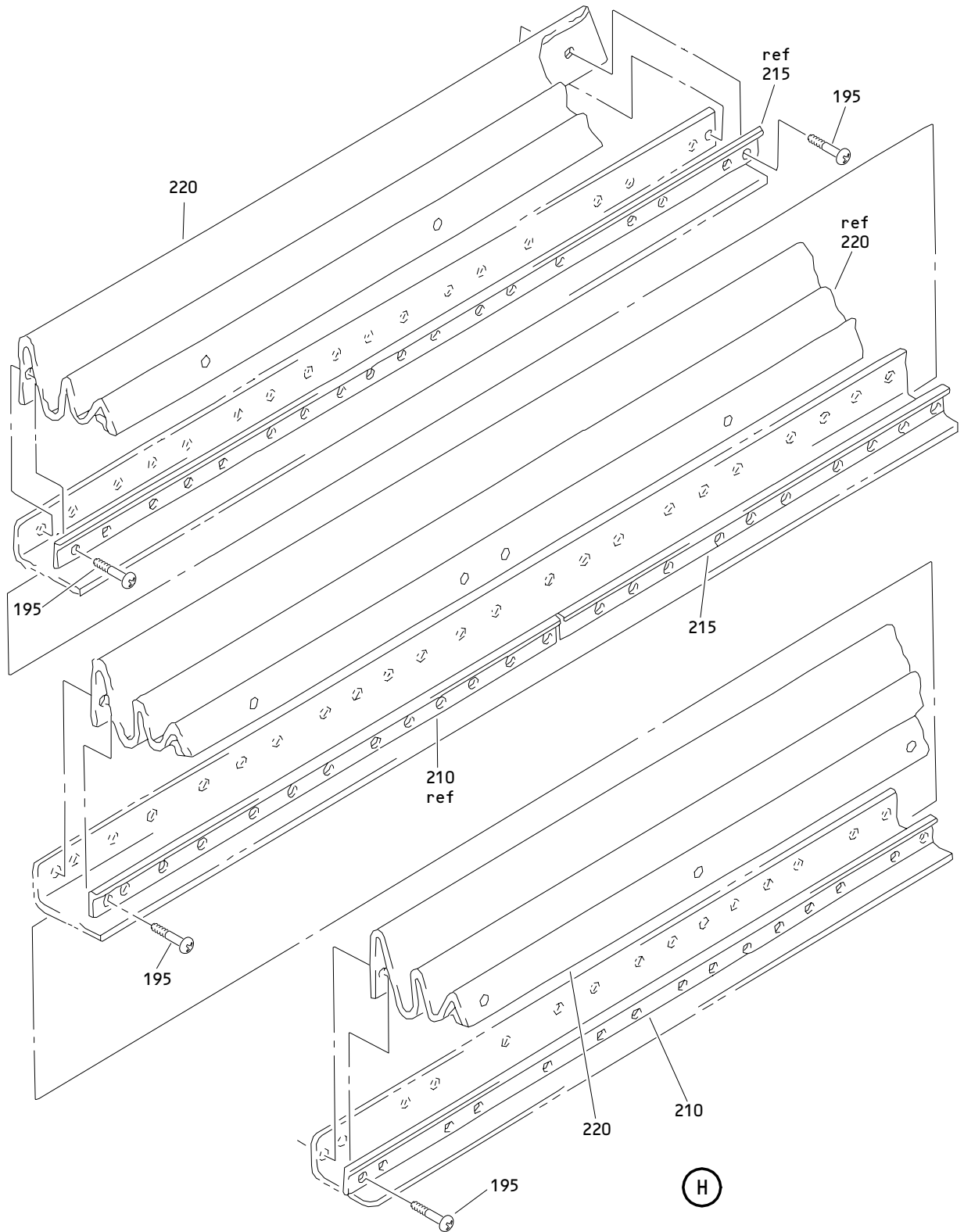
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Main Deck Cargo Door Assembly
Figure 1 (Sheet 4)

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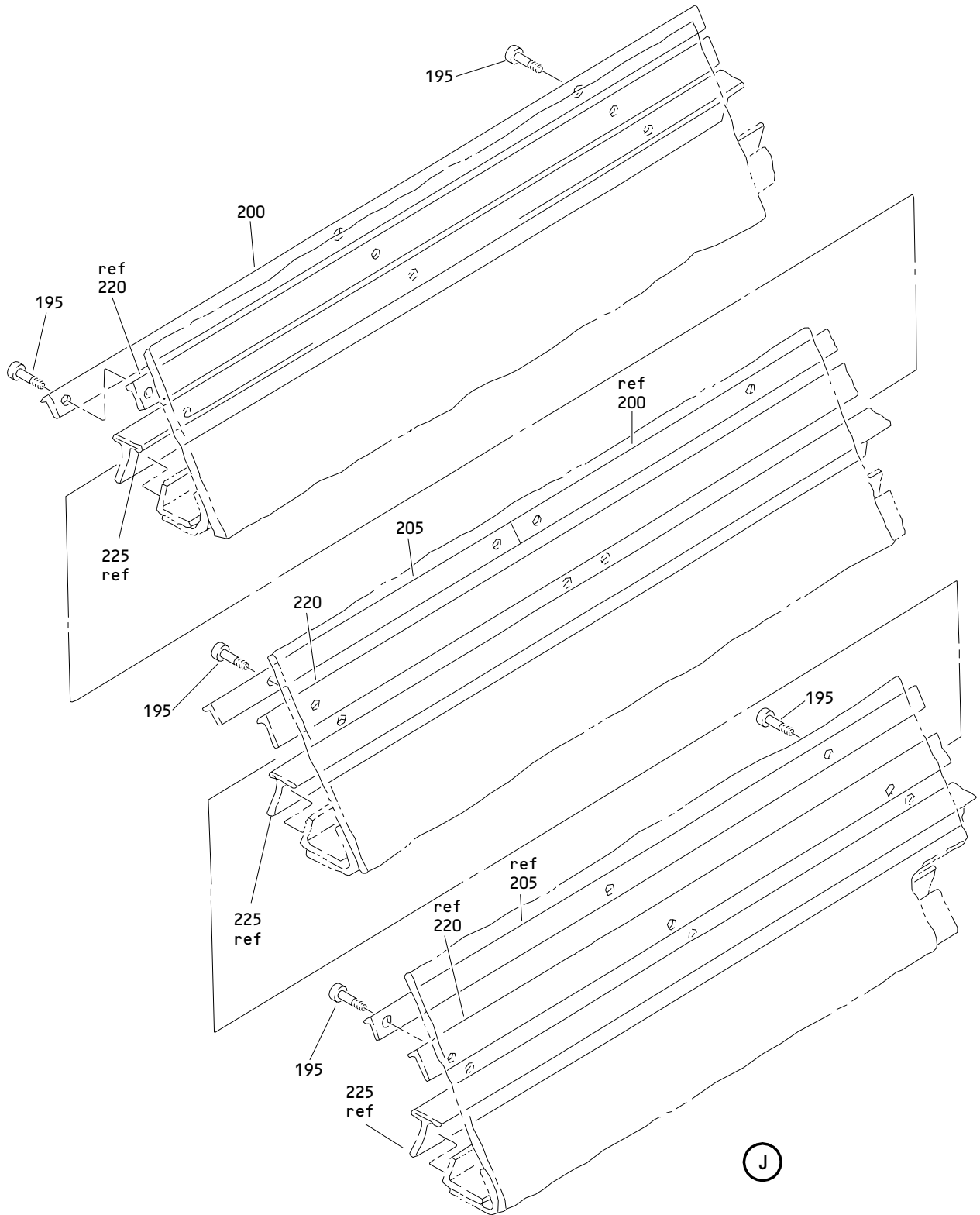
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Main Deck Cargo Door Assembly
Figure 1 (Sheet 5)

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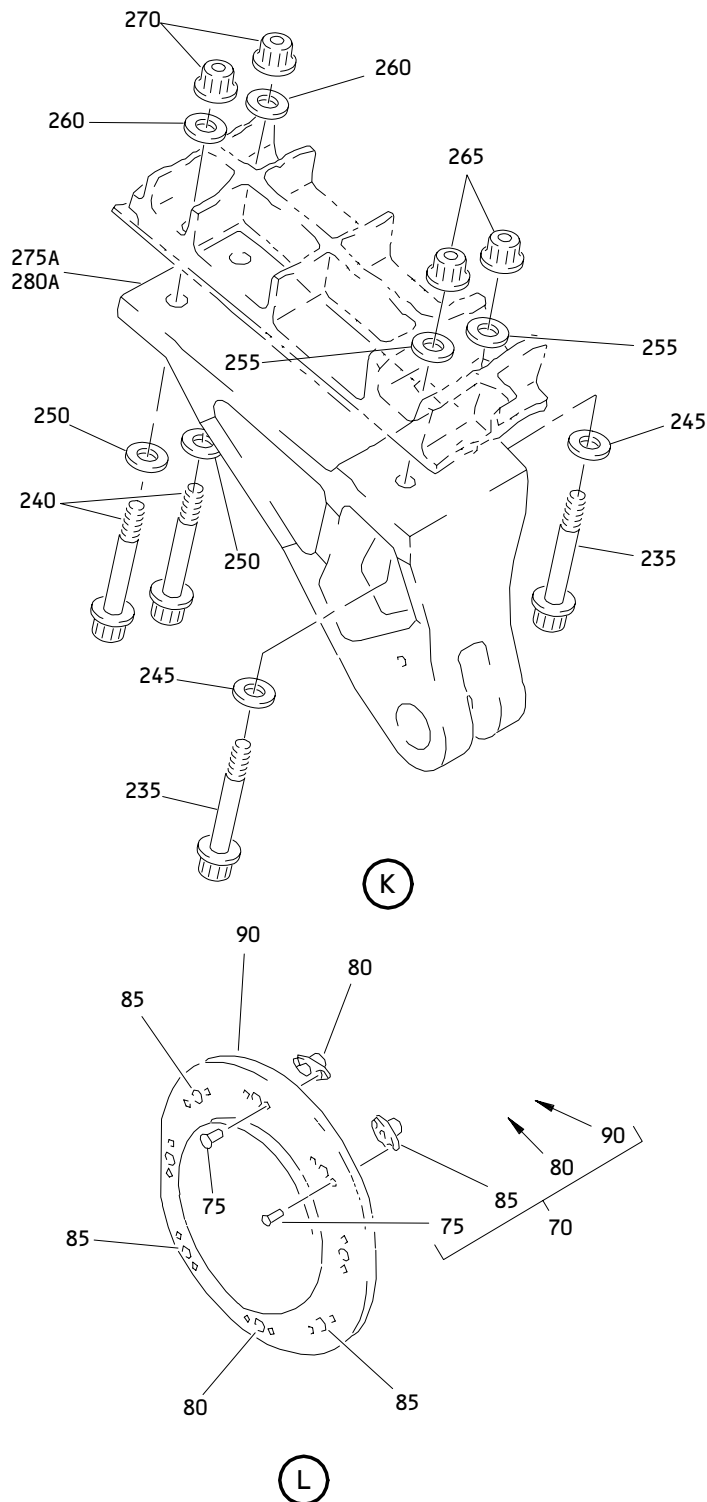
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Main Deck Cargo Door Assembly
Figure 1 (Sheet 6)

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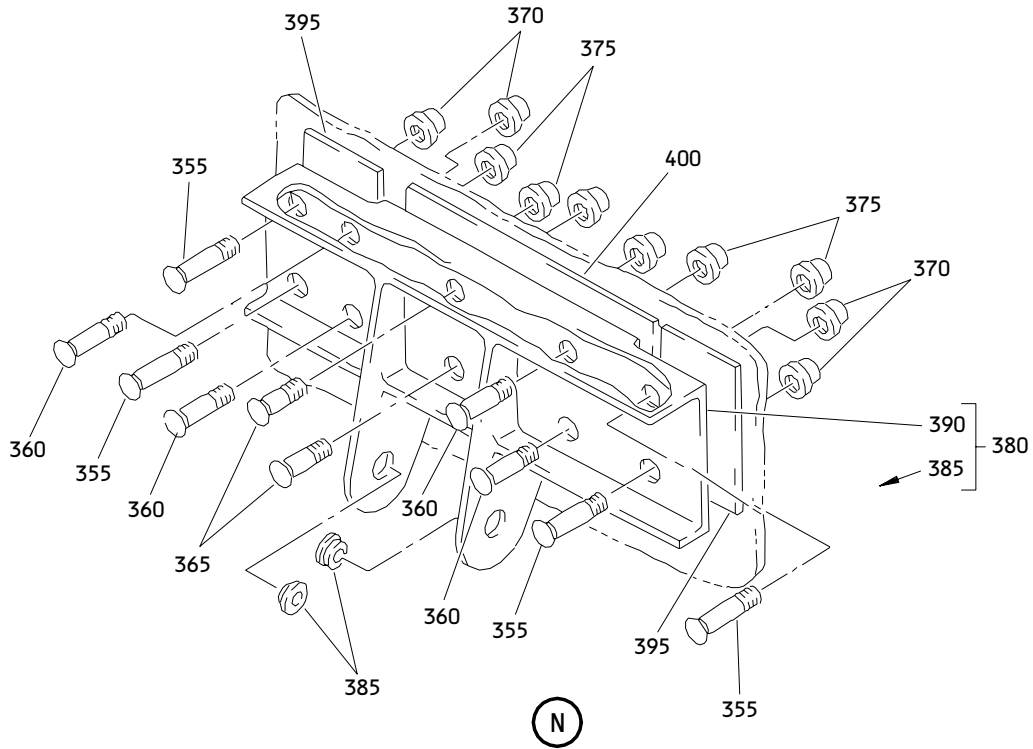
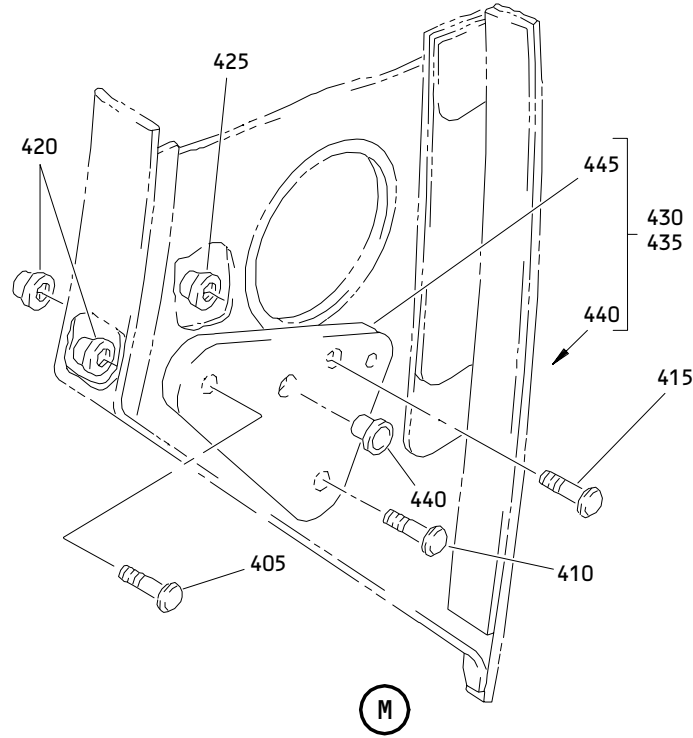
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**Main Deck Cargo Door Assembly
 Figure 1 (Sheet 7)**

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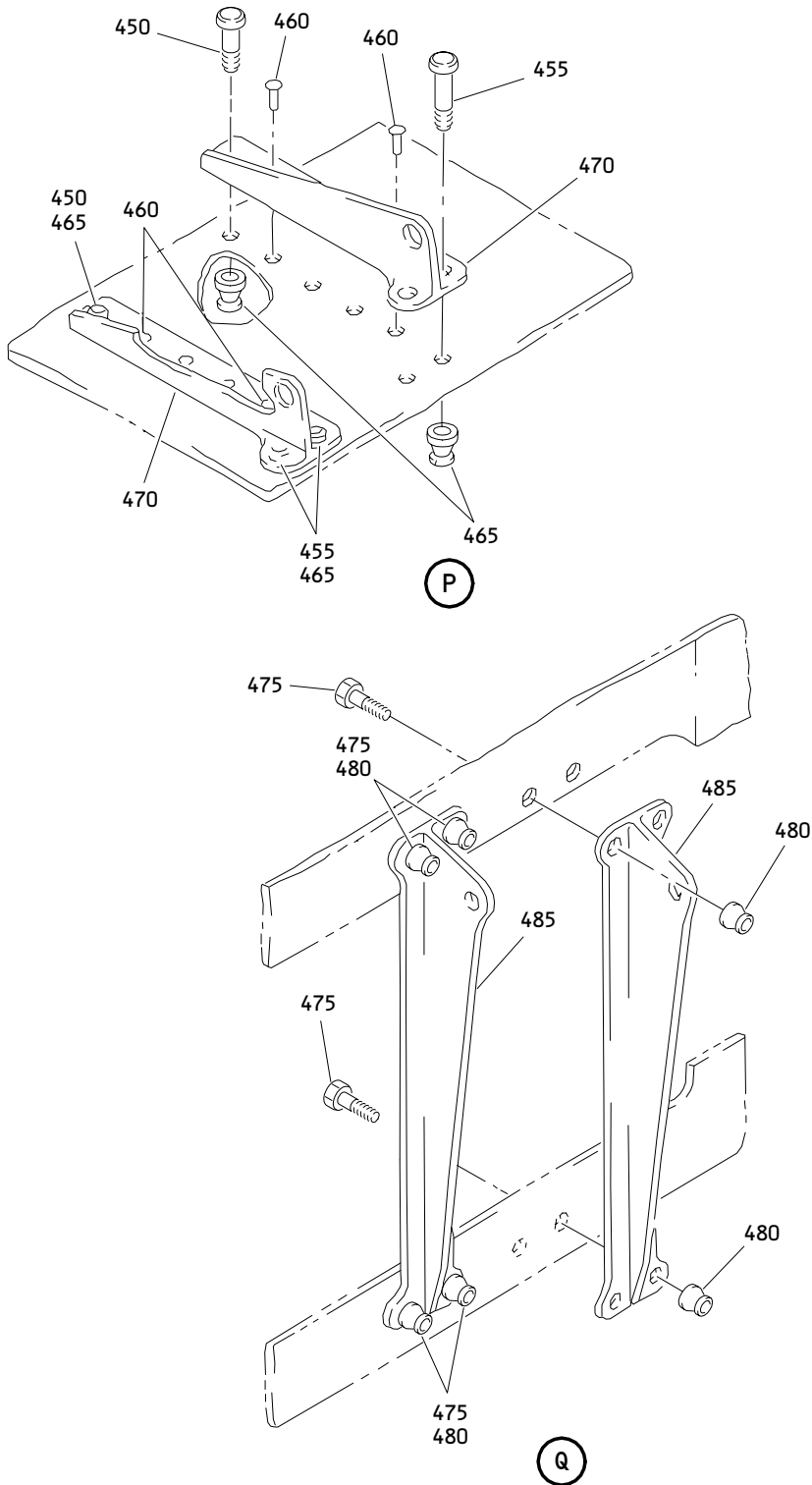
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Main Deck Cargo Door Assembly
 Figure 1 (Sheet 8)

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**Main Deck Cargo Door Assembly
 Figure 1 (Sheet 9)**

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01- -1A	143T6200-1		DOOR ASSY-MAIN DECK CARGO DOOR	A	RF
R -1B	143T6200-2		DOOR ASSY-MAIN DECK CARGO DOOR	B	RF
R -5	143T6205-1		.LATCH AND HOOK INSTL- (FOR DETAILS SEE FIG. 2)		1
R -10	143T6207-1		.LOCK INSTL-LATCH (FOR DETAILS SEE FIG. 3)		1
R 15	BACB30VF3-9		DELETED		
R 15A	BACB30VF3K7		.BOLT		24
R 20	143T6562-3		.PANEL ASSY-ACCESS.		2
R 25	143T6560-1		..SEAL		1
R 30	143T6545-2		..PANEL		1
R 35	BACB30VF3-6		.BOLT	A	20
R -35A	BACB30VF3K6		.BOLT	B	20
R 40	143T6562-2		.PANEL ASSY-ACCESS.		2
R 45	143T6291-1		..SEAL		1
R 50	143T6545-1		..PANEL		1
R 55	BACB30LH3-6		DELETED		
R 55A	BACB30LH3-4		DELETED		
R 55B	BACB30LH3-5		.BOLT		6
R 57	BACB30LH3-4		.BOLT		2
R 60	143T6562-1		.PANEL ASSY-ACCESS.		1
R 65	143T6561-1		..SEAL		1
R 70	143T6288-1		..PANEL ASSY		1
R 75	BACR15CE3AD		...RIVET- (SIZE DETERMINE ON INST)		16
R 80	F5000-3BAC		...NUTPLATE- (V15653) (SPEC BACN10JR3F) (OPT NS103203-02 (V80539)) (OPT RMF9201-3 (V72962)) (OPT T8091S1032 (V11815)) (OPT VN152A1-02 (V92215)) (OPT BRF200A3 (V52828))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-85	F1968-3BAC		...NUTPLATE- (V15653) (SPEC BACN10JZ3A2) (OPT NS103224-02 (V80539)) (OPT RMF9219-3 (V72962)) (OPT SE98A3 (V62554))		6
R 90	143T6288-2		...PANEL		1
R 95	BACB30LH3-6		.BOLT		72
R 100	143T6366-2		.PANEL ASSY-ACCESS.		6
R 105	143T6376-2		..SEAL		1
R 110	143T6332-1		..PANEL		1
-115	143T6557-1		DELETED		
R -115A	143T6557-7		.PLATE INSTL-COVER		1
R 120	MS24665-86		..PIN-COTTER		1
125	143T6557-4		DELETED		
R 125A	143T6557-10		..SCREW		1
R 130	BACR15CE3D		..RIVET- (SIZE DETERMINE ON INST)		1
R 135	NAS1149D0363J		..WASHER		1
140	NAS42DD3-22FC		DELETED		
R 140A	NAS42DD3-28FC		..SPACER		1
145	143T6557-5		DELETED		
R 145A	143T6557-11		..RETAINER ASSY		1
R 150	BACR15CE3D		...RIVET- (SIZE DETERMINE ON INST)		2
R 155	BACN10JP3ACD		...NUTPLATE		1
160	143T6557-6		DELETED		
R 160A	143T6557-12		...RETAINER		1
R 163	143T6557-13		...SPACER-PLATE		1
R 165	BACS12CK3-8		..SCREW		1
165A	143T6557-9		DELETED		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
R 170	NAS1149D0363J		..WASHER		1
R 175	RBEJ40K5A5A4		..JUMPER- (V1GK47) (SPEC BACJ40K5A5A4) (OPT ITEM 175A)		1
R -175A	CA4T6V		..CABLE ASSY- (V16258) (OPT ITEM 175)		1
180	143T6557-2		DELETED		
R 180A	143T6557-8		..GASKET		1
185	143T6557-3		DELETED		
R 185A	143T6557-9		..PLATE		1
R -190	143T6208-1		..SEAL INSTL-RAIN		1
R 195	BACB30NT3K4		..BOLT		66
R 200	143T6208-6		..STRIP-RTNR		1
R 205	143T6208-5		..STRIP-RTNR		1
R 210	143T6208-4		..STRIP-RTNR		1
R 215	143T6208-3		..STRIP-RTNR		1
R 220	143T6208-2		..SEAL		1
225	S140T263-143		DELETED		
R 225A	ARM5126		..SEAL-PRESSURE (VK1406) (SPEC S140T263-143) (OPT S18234-143 (V75345))		1
R 230	143T6203-1		..STRUCTURE ASSY	A	1
R -230A	143T6203-2		..STRUCTURE ASSY- (FOR DETAILS SEE FIG. 18)	B	1
R 235	BACB30US9K23		..BOLT	A	4
R 240	BACB30US8K25		..BOLT	A	4
R 245	BACW10BP9CD		..WASHER	A	4
R 250	BACW10BP8CD		..WASHER	A	4
R 255	BACW10BP9DP		..WASHER	A	4
R 260	BACW10BP8DP		..WASHER	A	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-265	H51560-9		..NUT- (V15653) (SPEC BACN10HR9CD) (OPT 67832CD918 (V56878)) (OPT BMN5024CWD3-9 (V97928)) (OPT 102LH9031-9 (V72962)) (OPT BH00303CM9 (V27238)) (OPT BMN10HRCWD3-9 (V97928)) (OPT BMN5024CWD39 (V97928)) (OPT CR60309 (V62554)) (OPT H51560 (V15653)) (OPT SL7108C9 (V11815)) (OPT VCU0005D9 (V06710))	A	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-270	H51560-8		..NUT- (V15653) (SPEC BACN10HR8CD) (OPT 67832CD820 (V56878)) (OPT BMN5024CWD3-8 (V97928)) (OPT 102LH9031-8 (V72962)) (OPT BH00303CM8 (V27238)) (OPT BMN10HRCWD3-8 (V97928)) (OPT BH00303CM8 (V27238)) (OPT BMN5024CWD38 (V97928)) (OPT CR60308 (V62554)) (OPT H51560 (V15653)) (OPT SL7108C8 (V11815))	A	4
R 275	143T6231-1		DELETED		
R 275A	143T6231-5		..FITTING ASSY-LIFT LINK (FOR DETAILS SEE FIG. 4)	A	1
R 280	143T6231-2		DELETED		
R 280A	143T6231-6		..FITTING ASSY-LIFT LINK (FOR DETAILS SEE FIG. 4)	A	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-285	BACB30NN6K23		DELETED		
R 285A	BACB30LH6		..BOLT- (SIZE DETERMINE ON INST)	A	6
R 290	BACB30NN6K20		DELETED		
R 295	NAS1149F0632P		DELETED		
R 295A	NAS1149C0632R		..WASHER	A	6
R 300	H52732-6CD		..NUT- (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))	A	6
R 305	143T6246-2		..FITTING-CENTERING ROLLER RAMP	A	1
R 310	143T6246-1		..FITTING-CENTERING ROLLER RAMP	A	1
R 315	143T6226-8		..SHIM-CENTERING ROLLER RAMP	A	1
R 320	143T6226-7		..SHIM-CENTERING ROLLER RAMP	A	1
R 325	143T6226-6		..SHIM-CENTERING ROLLER RAMP	A	1
R 330	143T6226-5		..SHIM-CENTERING ROLLER RAMP	A	1
R 335	143T6226-4		..SHIM-CENTERING ROLLER RAMP	A	1
R 340	143T6226-3		..SHIM-CENTERING ROLLER RAMP	A	1
R 345	143T6226-2		..SHIM-CENTERING ROLLER RAMP	A	1
R 350	143T6226-1		..SHIM-CENTERING ROLLER RAMP	A	1
R 355	HST11AG8-6		..BOLT- (VOPTK6) (SPEC BACB30VU8K6) (OPT HST11AG8-6 (V73197)) (OPT HST11AG8-6 (V56878)) (OPT HST11AG8-6 (V06725))	A	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-360	HST11AG6-6		..BOLT- (V06725) (SPEC BACB30VU6K6) (OPT HST11AG6-6 (V73197)) (OPT HST11AG6-6 (V56878)) (OPT HST11AG6-6 (VOPTK6))	A	4
R 365	HST11AG6-4		..BOLT- (V06725) (SPEC BACB30VU6K4) (OPT HST11AG6-4 (V73197)) (OPT HST11AG6-4 (V56878)) (OPT HST11AG6-4 (VOPTK6))	A	2
R 370	HST79CY8		..COLLAR- (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))	A	4
R 375	HST79CY6		..COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))	A	6
R 380	143T6244-1		..BRACKET ASSY-LATCH LOCK IDLER SPRT	A	1
R 385	BACB28X5M010		...BUSHING	A	2
R 390	143T6244-2		...BRACKET	A	1
R 395	BACS40R011C021F		..SHIM	A	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-400	BACS40R021C040F		..SHIM	A	1
R 405	HST10AG8-25		..BOLT- (VOPTK6) (SPEC BACB30VT8K25) (OPT HST10AG8-25 (V06725)) (OPT HST10AG8-25 (V56878)) (OPT HST10AG8-25 (V73197))	A	6
R 410	HST10AG8-23		..BOLT- (VOPTK6) (SPEC BACB30VT8K23) (OPT HST10AG8-23 (V06725)) (OPT HST10AG8-23 (V56878)) (OPT HST10AG8-23 (V73197))	A	6
R 415	HST10AG6-8		..BOLT- (VOPTK6) (SPEC BACB30VT6K8) (OPT HST10AG6-8 (V06725)) (OPT HST10AG6-8 (V56878)) (OPT HST10AG6-8 (V73197))	A	6
R 420	HST79CY8		..COLLAR- (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))	A	12

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-425	HST79CY6		..COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))	A	6
R 430	143T6206-1		..PLATE ASSY-BRG	A	5
R 435	143T6206-2		..PLATE ASSY-BRG	A	1
R 440	BACB28X8M024		...BUSHING	A	1
R 445	143T6206-3		...PLATE	A	1
R 450	HL1012AZ6-4		..BOLT- (V97928) (SPEC BACB30NX6K4) (OPT HL12VAZ6-4 (V73197)) (OPT HL12VAZ6-4 (V92215)) (OPT HL12VAZ6-4 (V97928)) (OPT L802-6K4 (V06725)) (OPT HL12VAZ6-4 (V56878)) (OPT HL1012AZ6-4 (V0PTK6)) (OPT HL1012AZ6-4 (V06725)) (OPT HL1012AZ6-4 (V06950)) (OPT HL1012AZ6-4 (V17446)) (OPT HL1012AZ6-4 (V56878)) (OPT HL1012AZ6-4 (V60516)) (OPT HL1012AZ6-4 (V73197))	A	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-455	HL1012AZ6-5		..BOLT- (V97928) (SPEC BACB30NX6K5) (OPT HL12VAZ6-5 (V73197)) (OPT HL12VAZ6-5 (V92215)) (OPT HL12VAZ6-5 (V97928)) (OPT L802-6K5 (V06725)) (OPT HL12VAZ6-5 (V56878)) (OPT HL1012AZ6-5 (V0PTK6)) (OPT HL1012AZ6-5 (V06725)) (OPT HL1012AZ6-5 (V06950)) (OPT HL1012AZ6-5 (V17446)) (OPT HL1012AZ6-5 (V56878)) (OPT HL1012AZ6-5 (V60516)) (OPT HL1012AZ6-5 (V73197))	A	8
R 460	BACR15FT6KE		..RIVET- (SIZE DETERMINE ON INST)	A	16
R 465	HL1187-6		..COLLAR- (V5M902) (SPEC BACC30X6) (OPT HL87-6 (V73197)) (OPT HL87-6 (V92215)) (OPT HL1187-6 (V56878)) (OPT HL1187-6 (V92215)) (OPT HL87-6 (V56878)) (OPT HL1187-6 (V73197))	A	12
466	287T0014-648		DELETED		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-466A	287T0014-664		..ANGLE ASSY	A	1
R 467	BACR15BB3D		DELETED		
R 467A	BACR15CE3D		...RIVET- (SIZE DETERMINE ON INST)	A	2
R 468	WSI332-10		...NUTPLATE- (V04169) (SPEC BACN10GH3-10)	A	1
R 469	287T0014-649		...ANGLE	A	1
R 470	143T6556-1		..FITTING-VENT DOOR TORQUE TUBE SPRT	A	4
R 472	287T0015-381		..FILLER	A	1
R 475	HST11AG6-5		..BOLT- (V06725) (SPEC BACB30VU6K5) (OPT HST11AG6-5 (V73197)) (OPT HST11AG6-5 (V56878)) (OPT HST11AG6-5 (V0PTK6))	A	16
R 480	HST826AW		..COLLAR- (V5M902) (SPEC BACC30BQ6) (OPT HST826AW (V56878)) (OPT HST826AW (V73197)) (OPT HST82CY6APBW (V73197)) (OPT HST82CY6APBW (V56878))	A	16
R 485	143T6556-2		..FITTING-VENT DOOR TORQUE TUBE SPRT	A	4
R -490	143T6281-1		..WINDOW INSTL-LWR LATCH OBSERVATION (FOR DETAILS SEE FIG. 5)	A	6
R -495	143T6258-1		..BEAM INSTL-UPR (FOR DETAILS SEE FIG. 6)	A	1
R -500	143T6628-1		..SUPPORT INSTL-UPR CORNER PRESSURE SEAL (FOR DETAILS SEE FIG. 7)	A	1
R -505	143T6628-2		..SUPPORT INSTL-UPR CORNER PRESSURE SEAL (FOR DETAILS SEE FIG. 7)	A	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-506	143T6629-1		..RETAINER INSTL-PRESSURE SEAL	A	1
R 507	BACR15BA4B		...RIVET- (SIZE DETERMINE ON INST)	A	244
R 507L	143T6629-2		...RETAINER	A	2
R 508	143T6629-4		...RETAINER	A	1
R 508L	143T6629-3		...RETAINER	A	1
R 509	143T6629-6		...RETAINER	A	1
R 509L	143T6629-5		...RETAINER	A	1
R -510	143T6250-2		..INTERCOSTAL INSTL-NO. 8 MIDSPAN IDLER SPRT (FOR DETAILS SEE FIG. 8)	A	1
R -515	143T6250-1		..INTERCOSTAL INSTL-NO. 8 MIDSPAN IDLER SPRT (FOR DETAILS SEE FIG. 8)	A	1
R -520	143T6240-1		..INTERCOSTAL INSTL-NO. 9 (FOR DETAILS SEE FIG. 9)	A	1
R -525	143T6259-2		..INTERCOSTAL INSTL-NO. 10 MIDSPAN SPRT (FOR DETAILS SEE FIG. 10)	A	1
R -530	143T6259-1		..INTERCOSTAL INSTL-NO. 10 MIDSPAN SPRT (FOR DETAILS SEE FIG. 10)	A	1
R -535	143T6232-1		..FRAME INSTL-STA 546.6 (FOR DETAILS SEE FIG. 11)	A	1
R -540	143T6232-2		..FRAME INSTL-STA 577.4 (FOR DETAILS SEE FIG. 11)	A	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-545	143T6232-3		..FRAME INSTL-ST A 590.6 (FOR DETAILS SEE FIG. 11)	A	1
R -550	143T6232-4		..FRAME INSTL-ST A 533.4 (FOR DETAILS SEE FIG. 11)	A	1
R -555	143T6233-1		..FRAME INSTL-ST A 524.6 (FOR DETAILS SEE FIG. 12)	A	1
R -560	143T6233-2		..FRAME INSTL-ST A 555.4 (FOR DETAILS SEE FIG. 12)	A	1
R -565	143T6233-3		..FRAME INSTL-ST A 568.6 (FOR DETAILS SEE FIG. 12)	A	1
R -570	143T6233-4		DELETED		
R -575	143T6234-1		..FRAME INSTL-ST A 511.4 (FOR DETAILS SEE FIG. 11)	A	1
R -580	143T6234-2		..FRAME INSTL-ST A 612.6 (FOR DETAILS SEE FIG. 11)	A	1
R -585	143T6230-1		..FRAME INSTL-ST A 502.6 (FOR DETAILS SEE FIG. 13)	A	1
R -590	143T6230-2		..FRAME INSTL-ST A 621.4 (FOR DETAILS SEE FIG. 13)	A	1
R -595	143T6224-1		..FRAME INSTL-ST A 495.5 (FOR DETAILS SEE FIG. 14)	A	1

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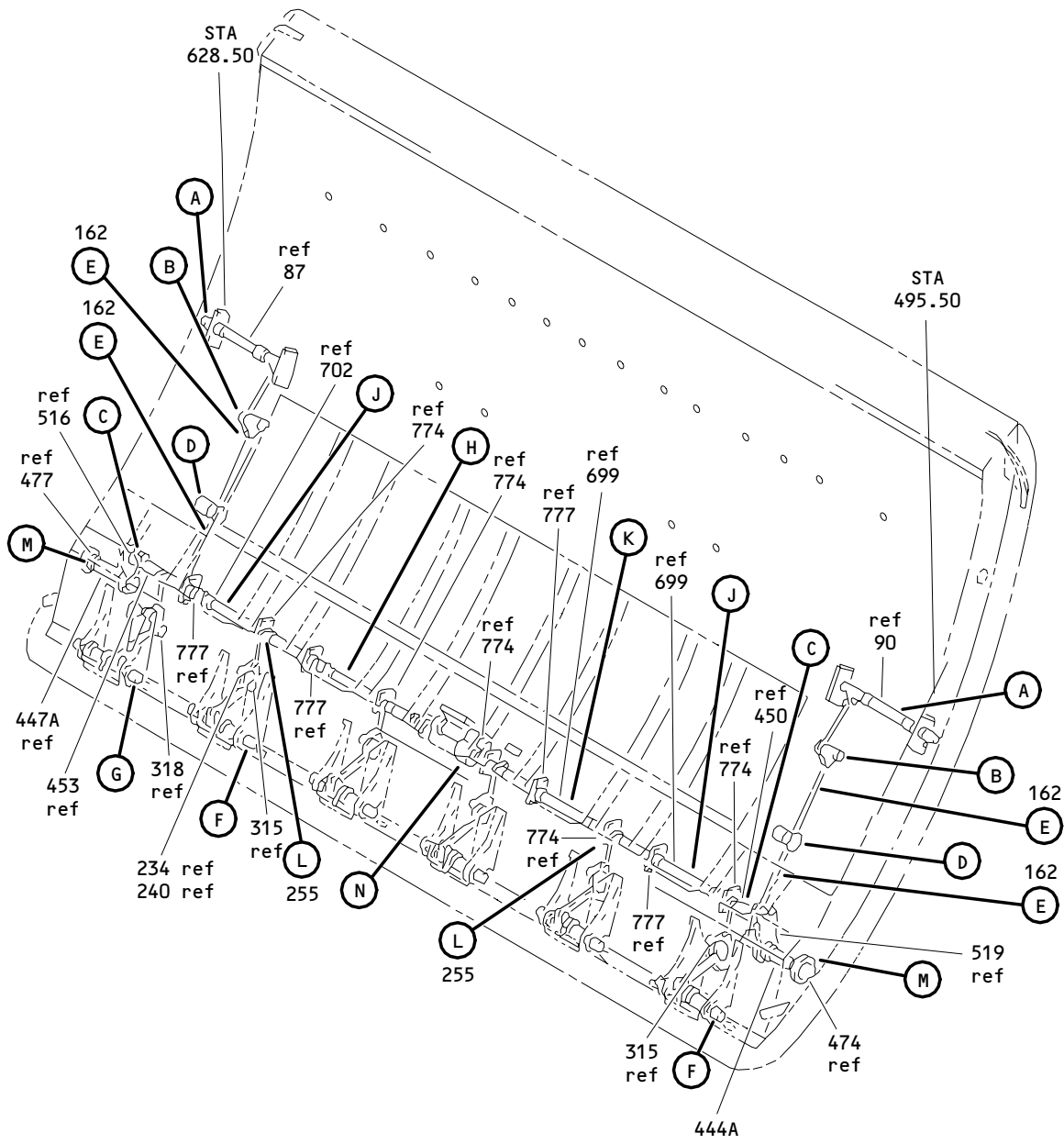
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-600	143T6224-2		..FRAME INSTL-ST A 628.5 (FOR DETAILS SEE FIG. 14)	A	1
R -605	143T6218-1		..BEAM INSTL-LWR (FOR DETAILS SEE FIG. 15)	A	1
R -610	143T6272-1		..SKIN INSTL-OUTER (FOR DETAILS SEE FIG. 16)	A	1
R -615	143T6283-1		DELETED		
R -616	143T6203-5001		..COLLECTOR-LIMITED PART	A	1
R -616A	143T6203-5002		..COLLECTOR-LIMITED PART	A	1
R -617	143T6233-4		...FRAME INSTL-ST A 599.4 (USED ON ITEM 616) (FOR DETAILS SEE FIG. 12)	A	1
R -617A	143T6233-16		...FRAME INSTL-ST A 599.4 (USED ON ITEM 616A) (FOR DETAILS SEE FIG. 12)	A	1
R -618	143T6283-1		...SKIN INSTL-INNER (USED ON ITEM 616) (FOR DETAILS SEE FIG. 17)	A	1
R -618A	143T6283-2		...SKIN INSTL-INNER (USED ON ITEM 616A) (FOR DETAILS SEE FIG. 17)	A	1
R 620	MS27253F2		.PLATE-IDENT		1

- Item Not Illustrated

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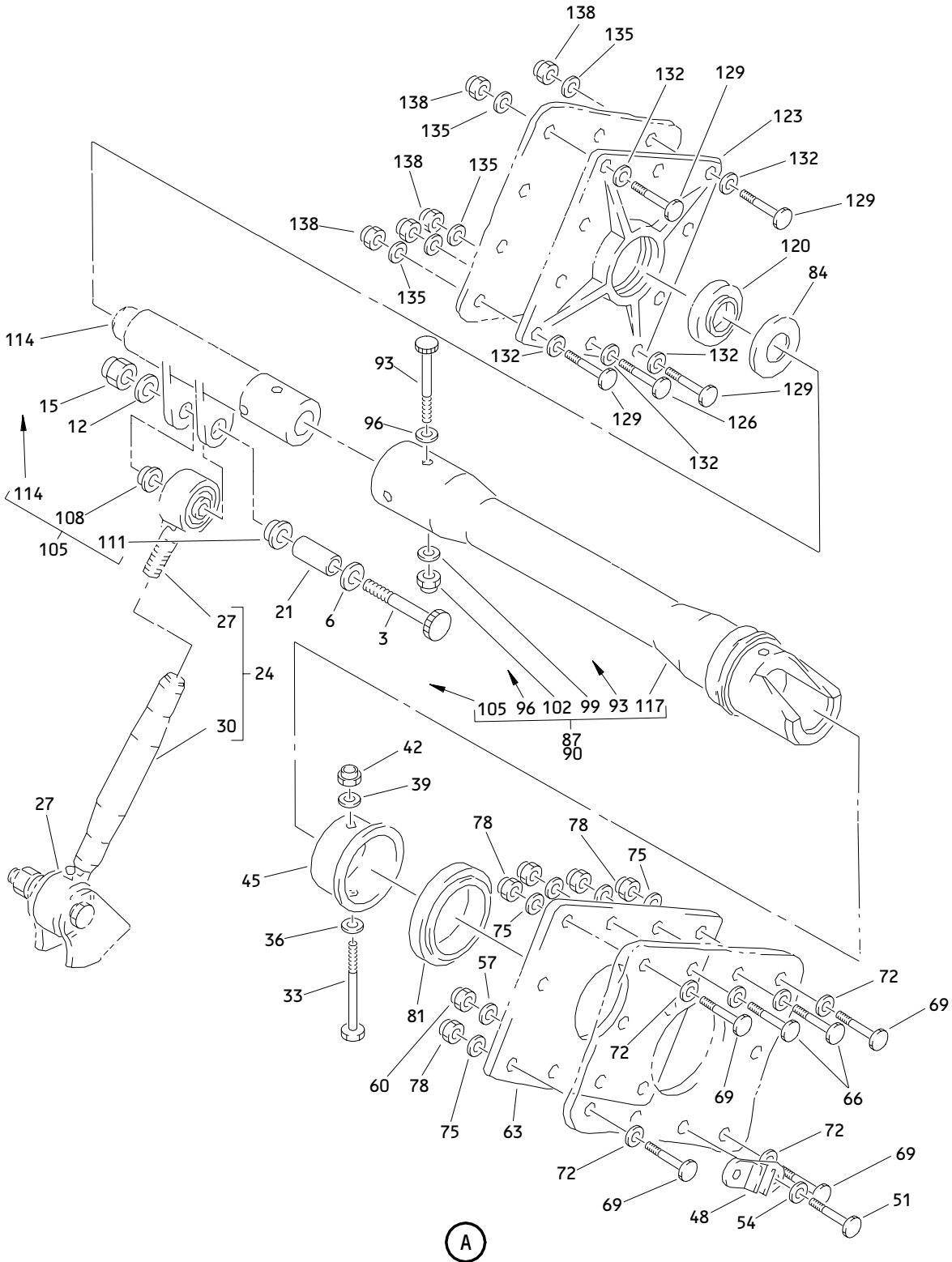
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Main Deck Cargo Door Latch and Hook Installation
Figure 2 (Sheet 1)

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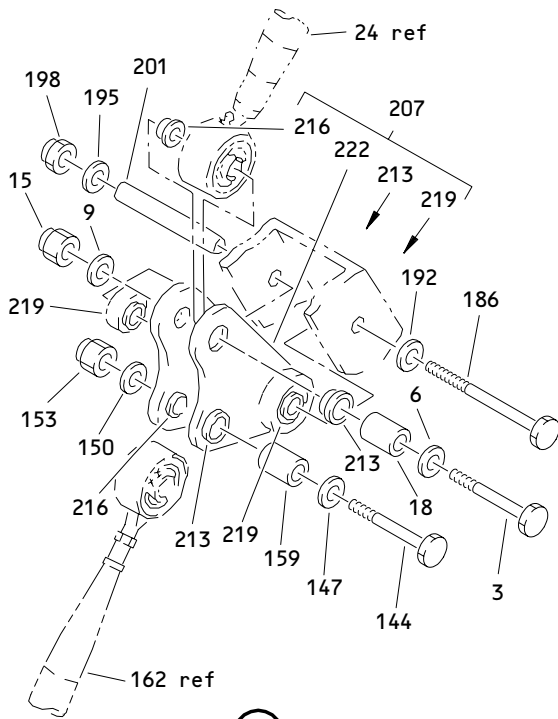
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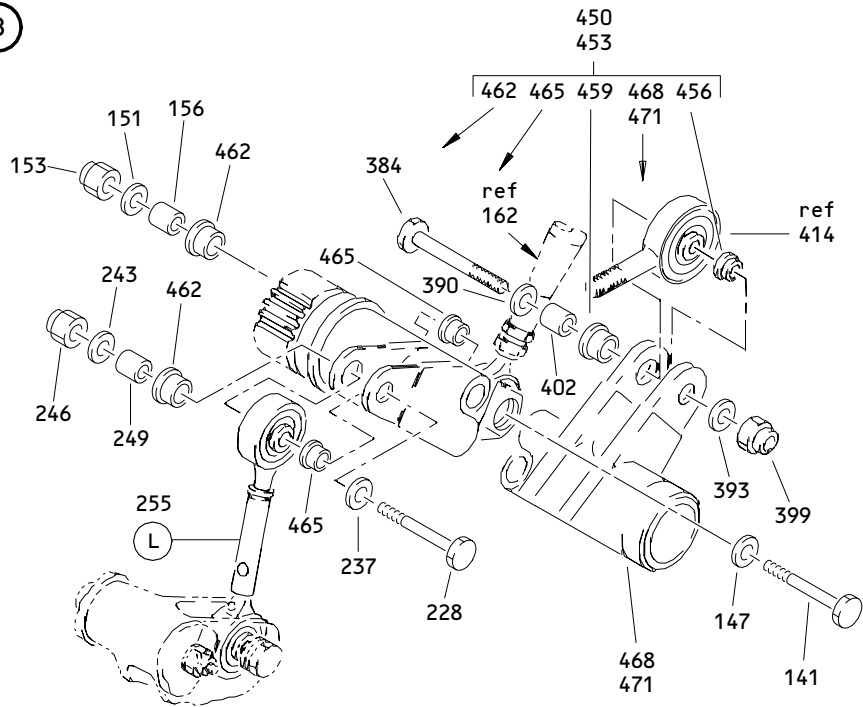
Main Deck Cargo Door Latch and Hook Installation
Figure 2 (Sheet 2)

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(B)

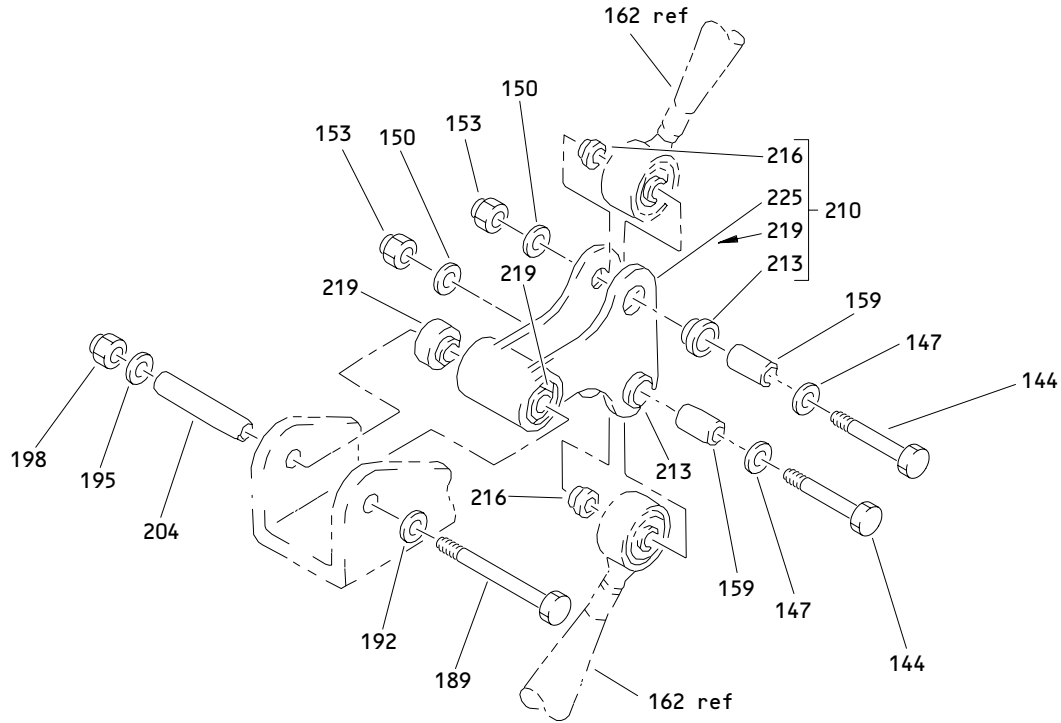


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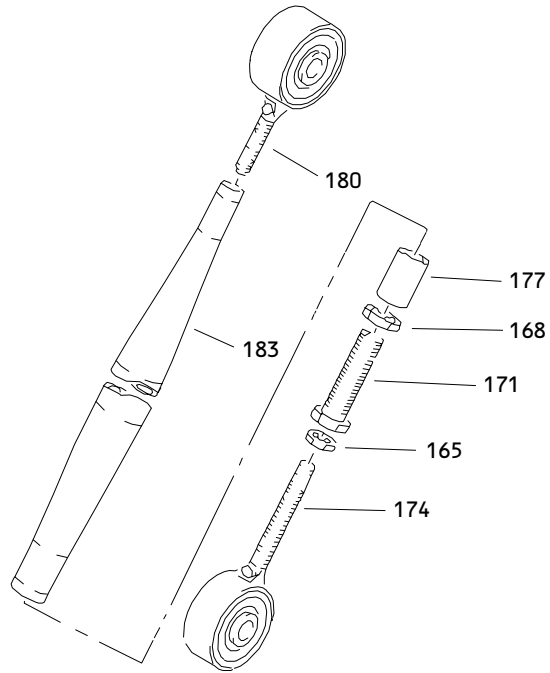
Main Deck Cargo Door Latch and Hook Installation
 Figure 2 (Sheet 3)

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(D)



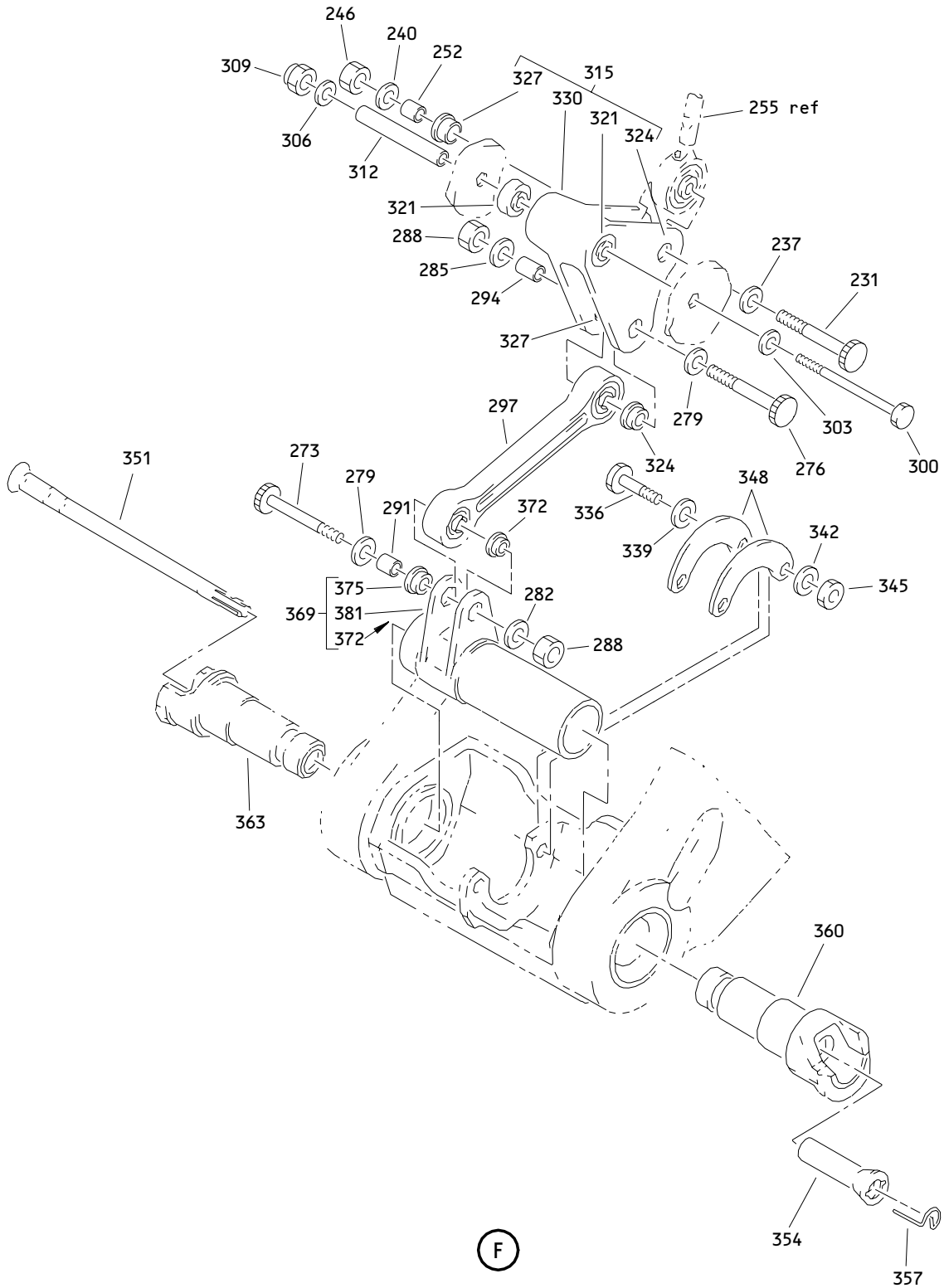
(E)

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Main Deck Cargo Door Latch and Hook Installation
Figure 2 (Sheet 4)

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Main Deck Cargo Door Latch and Hook Installation
 Figure 2 (Sheet 5)

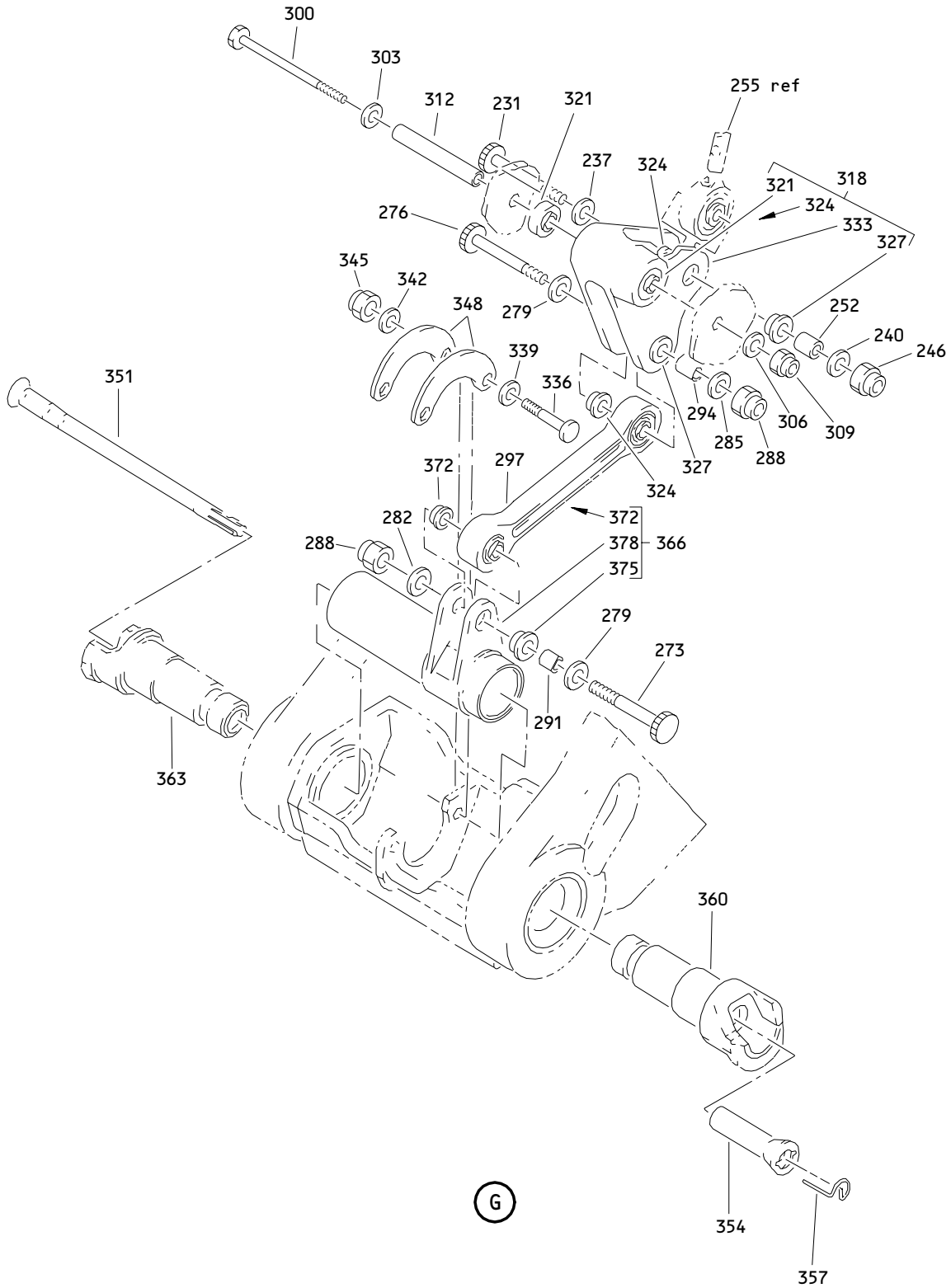
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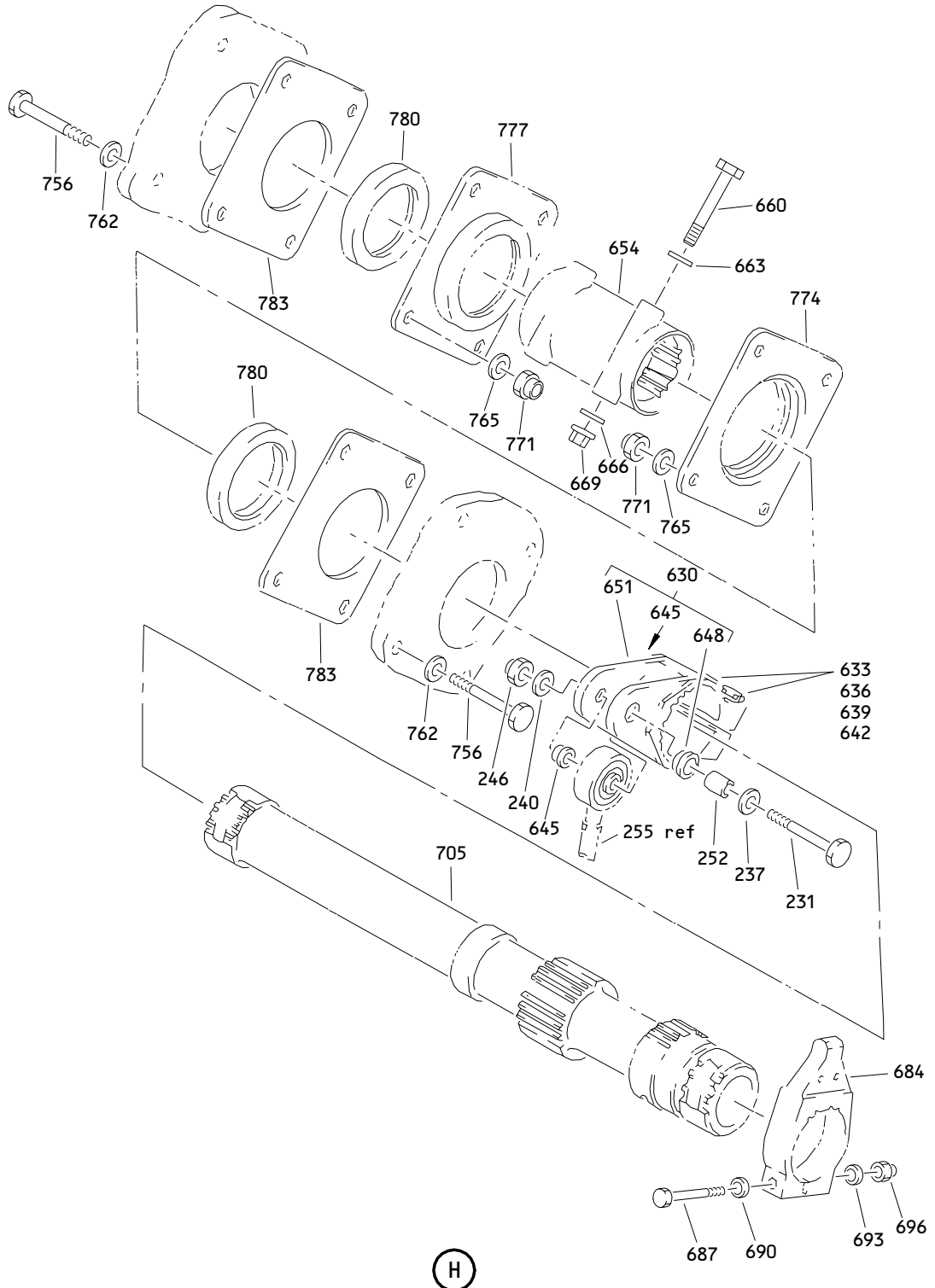
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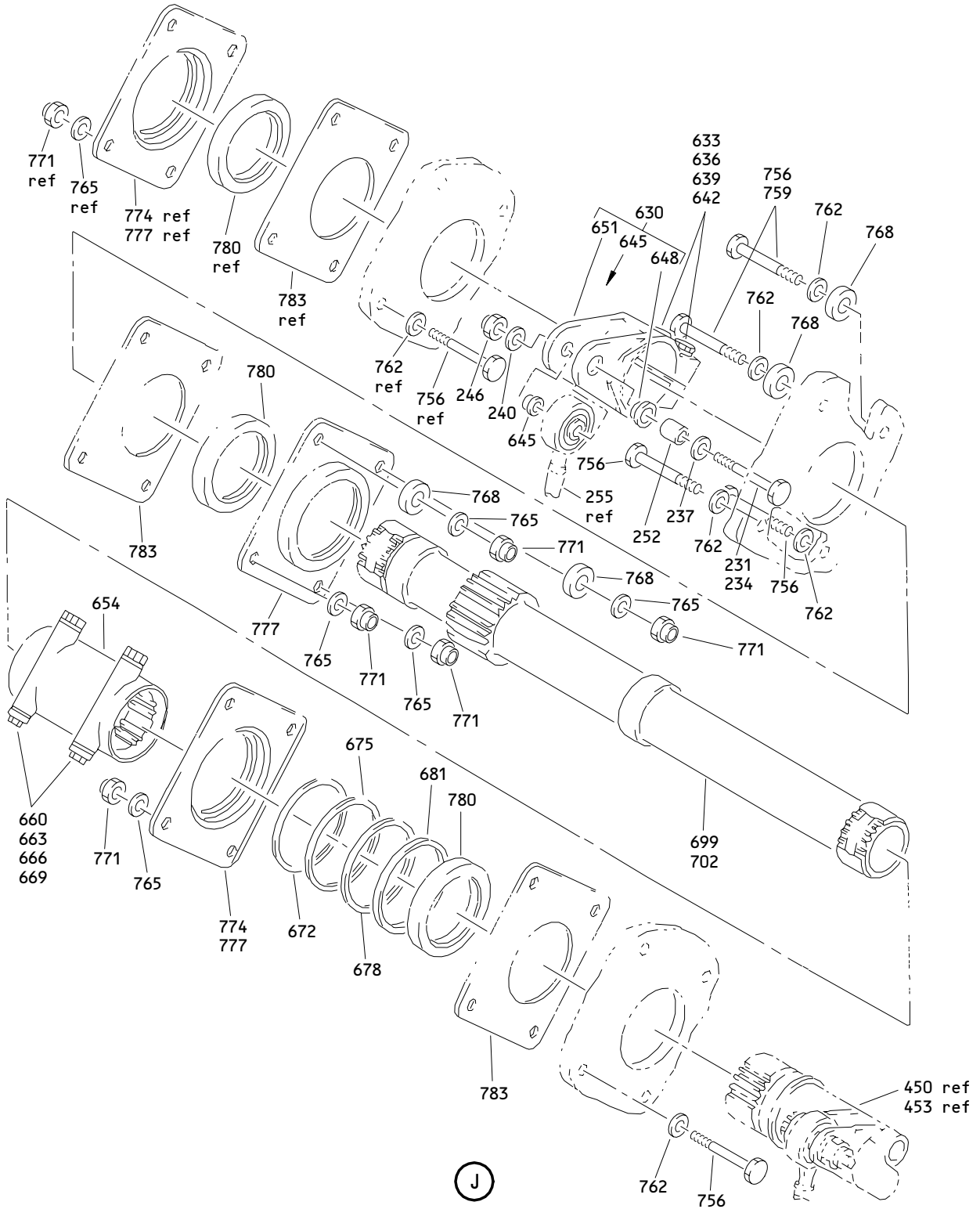
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Main Deck Cargo Door Latch and Hook Installation
 Figure 2 (Sheet 7)

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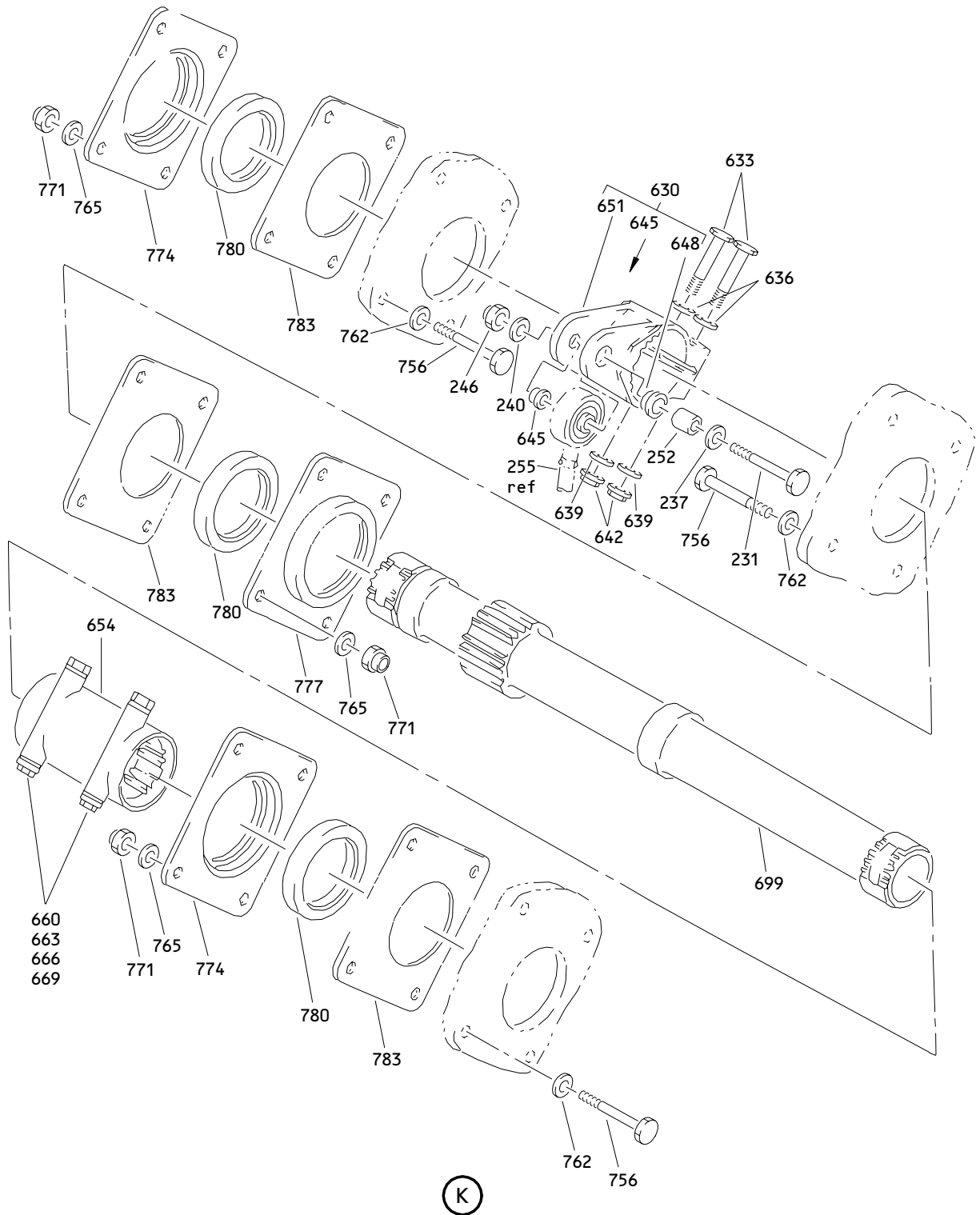
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Main Deck Cargo Door Latch and Hook Installation
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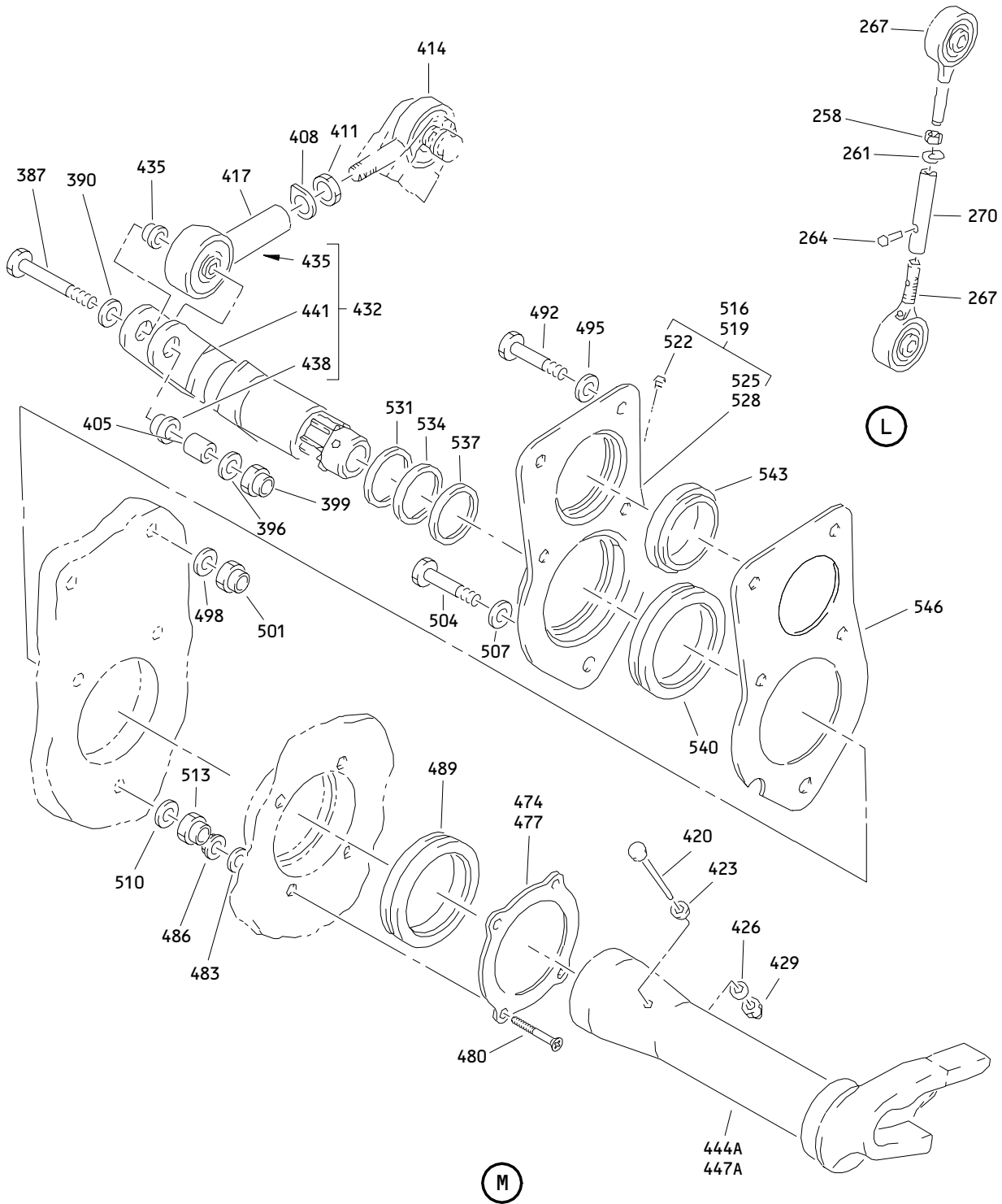
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Main Deck Cargo Door Latch and Hook Installation
 Figure 2 (Sheet 9)

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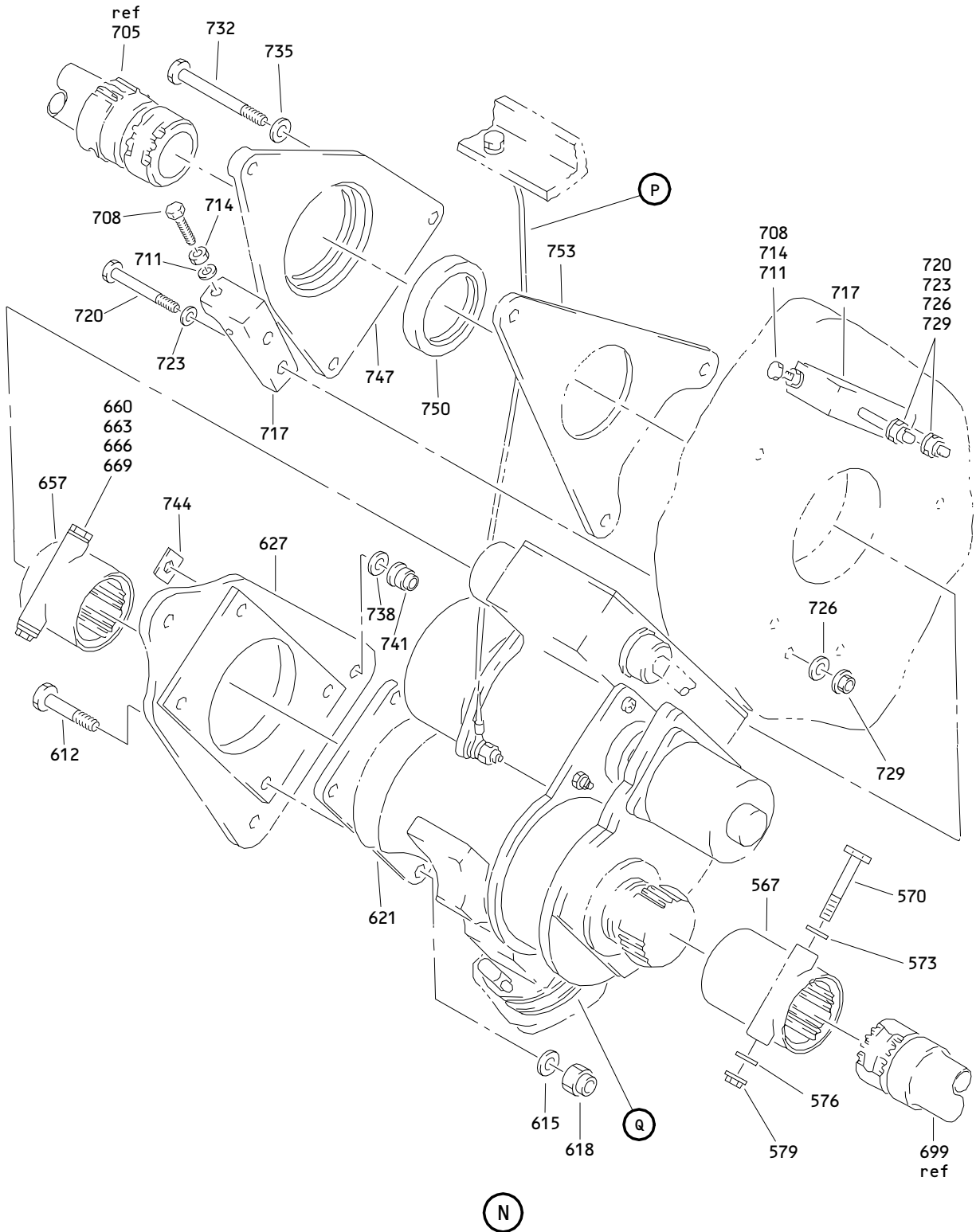
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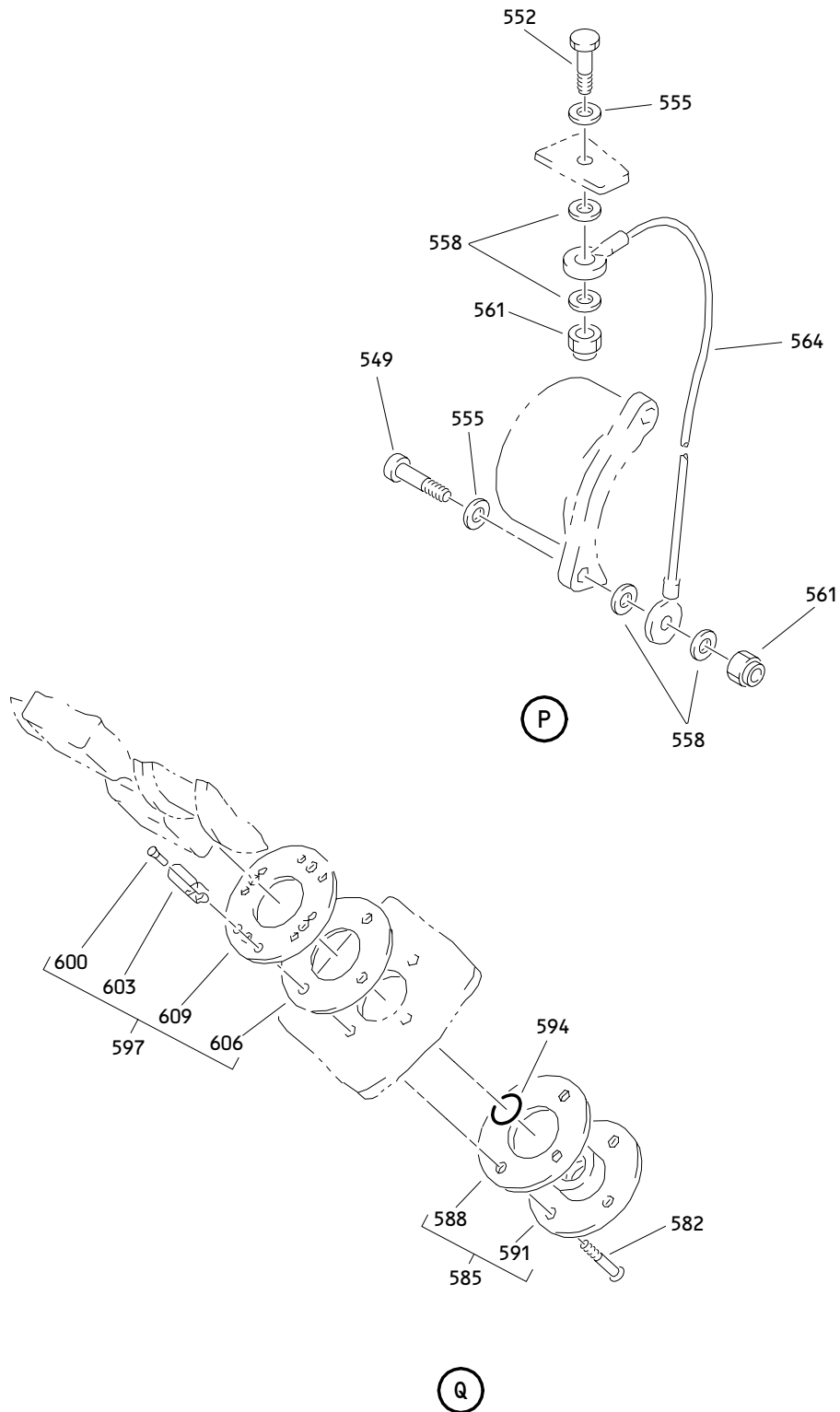
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Main Deck Cargo Door Latch and Hook Installation
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Main Deck Cargo Door Latch and Hook Installation
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02-					
R -1A	143T6205-1		LATCH AND HOOK INSTL		RF
R 3	BACB30UU6K26		.BOLT		4
R 6	BACW10BP6CD		.WASHER		4
R 9	NAS1149D0663J		.WASHER		2
R 12	NAS1149C0663R		.WASHER		2
R 15	H52732-6CD		.NUT- (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))		4
R 18	BACB28AK06-039		.BUSHING		2
R 21	BACB28AK06-042		.BUSHING		2
R 24	143T6469-1		.ROD ASSY-PUSH		2
R 27	143T6469-3		..ROD END- (OPT ITEM 27A)		2
R -27A	143T6469-4		..ROD END- (OPT ITEM 27)		2
R 30	143T6469-2		..PUSHROD		1
R 33	BACB30NR4K33		.BOLT		2
R 36	BACW10BP4ACU		.WASHER		2
R 39	NAS1149F0463P		.WASHER		2
R 42	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		2
R 45	143T6472-1		.COLLAR		2
R 48	143T6471-1		.PLATE-RIGGING ATTACHING PARTS		2
R 51	NAS6703-7		.BOLT		4
R 54	BACW10BN3AC		.WASHER		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02-57	NAS1149D0363J		.WASHER		4
R 60	H52732-3CD		.NUT- (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554)) -----*-----		4
R 63	143T6293-1		.HOUSING-BRG ATTACHING PARTS		2
R 66	NAS6703-5		.BOLT		4
R 69	NAS6703-6		.BOLT		12
R 72	BACW10BN3AC		.WASHER		16
R 75	NAS1149D0363J		.WASHER		16
R 78	H52732-3CD		.NUT- (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554)) -----*-----		16
R 81	SSMKP33BSD702		.BEARING- (V83086) (SPEC BACB10FR33) (OPT ACMKP33P28LY198 (V40920)) (OPT ACMKP33BP28LY198 (V40920)) (OPT ACMKP33BP612LY198 (V40920)) (OPT ACMKP33P612LY198 (V40920)) (OPT PACMKP33BA3908 (V21335)) (OPT PACMKP33BFS428 (V21335))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02-84	143T6478-2		.WASHER		AR
R 87	143T6296-1		.CRANK AND FITTING ASSY- MIDSPAN LATCH		1
R 90	143T6296-2		.CRANK AND FITTING ASSY- MIDSPAN LATCH		1
R 93	BACB30UU4K29		..BOLT		2
R 96	BACW10BP4ACU		..WASHER		2
R 99	NAS1149C0432R		..WASHER		2
R 102	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))		2
R 105	143T6418-16		..BELLCRANK ASSY		1
R 108	BACB28X6C024		...BUSHING		1
R 111	BACB28X9M024		...BUSHING		1
R 114	143T6418-18		...BELLCRANK		1
R 117	143T6417-4		..FITTING		1
R 120	PACMKP16BFS428		.BEARING- (V21335) (SPEC BACB10FR16) (OPT ACMKP16B005M (V40920)) (OPT SSMKP16BSD702 (V83086)) (OPT PACMKP16BA3908 (V21335))		2
R 123	143T6294-1		.HOUSING-BRG ATTACHING PARTS		2
R 126	NAS6703-6		.BOLT		12
R 129	NAS6703-7		.BOLT		8
R 132	BACW10BN3AC		.WASHER		20

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02-135	NAS1149D0363J		.WASHER		20
R 138	H52732-3CD		.NUT- (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554)) -----*		20
R 141	BACB30UU6K24		.BOLT		2
R 144	BACB30UU6K26		.BOLT		6
R 147	BACW10BP6CD		.WASHER		8
R 150	NAS1149D0663J		.WASHER		6
R 151	NAS1149D0663R		.WASHER		2
R 153	H52732-6CD		.NUT- (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))		8
R 156	BACB28AK06-037		.BUSHING		2
R 159	BACB28AK06-039		.BUSHING		6
R 162	143T6433-4		.ROD ASSY-PUSH		4
R 165	NAS1423-6		..NUT		1
R 168	NAS1423-8		..NUT		1
R 171	141T6165-1		..SLEEVE-VERNIER		1
R 174	S012T236-530		..ROD-END		1
R 177	141T6171-5		..INSERT		1
R 180	143T6433-5		..ROD END		1
R 183	143T6432-2		..PUSHROD		1
R 186	BACB30NR5K47		.BOLT		2
R 189	BACB30NR5K50		.BOLT		2
R 192	BACW10BP5ACU		.WASHER		4
R 195	NAS1149D0563J		.WASHER		4
R 198	H52732-5CD		.NUT- (V15653) (SPEC BACN10YR5CD) (OPT PLH55CD (V62554))		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R	02- 201	NAS72-5E209	.BUSHING		2
R	204	NAS72-5E214	.BUSHING		2
R	207	143T6295-1	.IDLER ASSY		2
R	210	143T6295-3	.IDLER ASSY		2
R	213	BACB28X9M020	..BUSHING		2
R	216	BACB28X6C024	..BUSHING		2
R	219	SSMKP8ASD705	..BEARING- (V83086) (SPEC BACB10FS8) (OPT PACMKP8AA3908 (V21335)) (OPT ACMKP8AP510LY19 (V40920)) (OPT PACMKP8AFS428 (V21335)) (OPT SSMKP8AP (V21760))		2
R	222	143T6295-2	..IDLER- (USED ON ITEM 207)		1
R	225	143T6295-4	..IDLER- (USED ON ITEM 210)		1
R	228	BACB30UU6K24	.BOLT		2
R	231	BACB30UU6K26	.BOLT		9
R	234	BACB30UU6K28	.BOLT		1
R	237	BACW10BP6CD	.WASHER		12
R	240	NAS1149D0663J	.WASHER		11
R	243	NAS1149C0663R	.WASHER		2
R	246	H52732-6CD	.NUT- (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))		12

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-				
R	249	BACB28AK06-037	.BUSHING		2
R	252	BACB28AK06-042	.BUSHING		10
R	255	143T6468-1	.ROD ASSY-PUSH		6
R	258	NAS1423-6	..NUT		1
R	261	NAS513-6	..WASHER		1
R	264	MS20615-4M	..RIVET- (SIZE DETERMINE ON INST)		1
R	267	SM6-6C23	..BEARING- (V77896) (SPEC BACB10DE6-06) (OPT ARR6M30A (VS0352))		2
R	270	143T6468-2	..TUBE		1
R	273	BACB30UU6K22	.BOLT		6
R	276	BACB30UU6K24	.BOLT		6
R	279	BACW10BP6CD	.WASHER		12
R	282	NAS1149C0663R	.WASHER		6
R	285	NAS1149D0663J	.WASHER		6
R	288	H52732-6CD	.NUT- (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))		12
R	291	BACB28AK06-037	.BUSHING		6
R	294	BACB28AK06-042	.BUSHING		6
R	297	DDR6-96A1-501	.ROD-PUSH (V77896) (SPEC S012T236-203)		6
R	300	BACB30NR5K56	.BOLT		6
R	303	BACW10BP5ACU	.WASHER		6
R	306	NAS1149D0563J	.WASHER		6
R	309	H52732-5CD	.NUT- (V15653) (SPEC BACN10YR5CD) (OPT PLH55CD (V62554))		6
R	312	NAS72-5E303	.BUSHING		6
R	315	143T6414-11	.IDLER ASSY-LWR LATCH		5
R	318	143T6414-12	.IDLER ASSY-LWR LATCH		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02-321	SSMKP8ASD705		..BEARING- (V83086) (SPEC BACB10FS8) (OPT PACMKP8AA3908 (V21335)) (OPT ACMKP8AP510LY19 (V40920)) (OPT PACMKP8AFS428 (V21335)) (OPT SSMKP8AP (V21760))		2
R 324	BACB28X6C024		..BUSHING		2
R 327	BACB28X9M020		..BUSHING		2
R 330	143T6414-3		..IDLER- (OPT ITEM 330A) (USED ON ITEM 315)		1
R -330A	143T6414-9		..IDLER- (OPT ITEM 330) (USED ON ITEM 315)		1
R 333	143T6414-4		..IDLER- (OPT ITEM 333A) (USED ON ITEM 318)		1
R -333A	143T6414-10		..IDLER- (OPT ITEM 333) (USED ON ITEM 318)		1
R 336	BACB30NR6K10		.BOLT		12
R 339	BACW10BP6ACU		.WASHER		12
R 342	NAS1149C0663R		.WASHER		12
R 345	H52732-6CD		.NUT- (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))		12
R 348	143T6470-1		.STRAP-SHEAR FTG		12
R 351	143T6466-1		.BOLT		6
R 354	143T6467-1		.RETAINER		6
R 357	69B17196-1		.SPRING		6
R 360	143T6401-3		.CAM-LATCH		6
R 363	143T6401-4		.CAM-LATCH		6
R 366	143T6492-1		.BELLCRANK ASSY		1
R 369	143T6492-2		.BELLCRANK ASSY		5
R 372	BACB28X6C015		..BUSHING		1
R 375	BACB28X9M015		..BUSHING		1
R 378	143T6492-3		..BELLCRANK- (USED ON ITEM 366)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02-381	143T6492-4		..BELLCRANK- (USED ON ITEM 369)		1
R 384	BACB30UU8K25		.BOLT		2
R 387	BACB30UU8K22		.BOLT		2
R 390	BACW10BP8CD		.WASHER		4
R 393	NAS1149C0863R		.WASHER		2
R 396	NAS1149C0832R		.WASHER		2
R 399	H51650-8BAC		.NUT- (V15653) (SPEC BACN10JC8CD) (OPT 102LH9074-8 (V72962)) (OPT 69235-820CD (V92215)) (OPT BMN4122CPD8-8 (V97928))		4
R 402	BACB28AK08-042		.BUSHING		2
R 405	BACB28AK08-038		.BUSHING		2
R 408	NAS513-8		.WASHER		2
R 411	NAS1423-8		.NUT		2
R 414	SM8-8C1-501		.ROD END- (V77896) (SPEC S012T236-104)		2
R 417	SFP8-8A1-501		.ROD END- (V77896) (SPEC S012T236-105)		2
R 420	BACB30NR4K34		.BOLT		2
R 423	BACW10BP4ACU		.WASHER		2
R 426	NAS1149C0463R		.WASHER		2
R 429	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-				
R	432	143T6411-3	.BELLCRANK ASSY		2
R	435	BACB28X8C019	..BUSHING		1
R	438	BACB28X11M019	..BUSHING		1
R	441	143T6411-4	..BELLCRANK		1
	444	143T6496-1	DELETED		
R	444A	143T6496-3	.HOOK-PULL-IN		1
	447	143T6496-2	DELETED		
R	447A	143T6496-4	.HOOK-PULL-IN		1
R	450	143T6495-1	.BELLCRANK ASSY		1
R	453	143T6495-2	.BELLCRANK ASSY		1
R	456	BACB28X8C024	..BUSHING		1
R	459	BACB28X11M024	..BUSHING		1
R	462	BACB28X9M016	..BUSHING		2
R	465	BACB28X6C016	..BUSHING		2
R	468	143T6495-3	..BELLCRANK- (USED ON ITEM 450)		1
R	471	143T6495-4	..BELLCRANK- (USED ON ITEM 453)		1
R	474	143T6499-1	.PLATE-RTNR		1
R	477	143T6499-2	.PLATE-RTNR		1
			ATTACHING PARTS		
R	480	BACB30LH3K14	.BOLT		8
R	483	NAS1149D0316H	.WASHER		8
R	486	H52732-3CD	.NUT- (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554)) -----*		8

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02-489	10106-658		.BEARING- (V77896) (SPEC S012T236-600) (OPT SAT42-56B1-502 (V77896))		2
R 492	BACB30NR5K23		.BOLT		8
R 495	BACW10BP5CD		.WASHER		8
R 498	NAS1149D0563J		.WASHER		8
R 501	H52732-5CD		.NUT- (V15653) (SPEC BACN10YR5CD) (OPT PLH55CD (V62554))		8
R 504	BACB30NR6K11		.BOLT		2
R 507	BACW10BP6CD		.WASHER		2
R 510	NAS1149D0663J		.WASHER		2
R 513	H52732-6CD		.NUT- (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))		2
R 516	143T6490-1		.HOUSING ASSY-BRG		1
R 519	143T6490-2		.HOUSING ASSY-BRG		1
R 522	NAS516-1A		..FITTING		1
R 525	143T6490-3		..HOUSING- (USED ON ITEM 516)		1
R 528	143T6490-4		..HOUSING- (USED ON ITEM 519)		1
R 531	143T6474-1		.RING-THRUST		AR
R 534	143T6474-2		.RING-THRUST		AR
R 537	143T6474-3		.RING-THRUST		AR
R 540	10106-658		.BEARING- (V77896) (SPEC S012T236-600) (OPT SAT42-56B1-502 (V77896))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02-543	SSMKP33BSD702		.BEARING- (V83086) (SPEC BACB10FR33) (OPT ACMKP33P28LY198 (V40920)) (OPT ACMKP33BP28LY198 (V40920)) (OPT ACMKP33BP612LY198 (V40920)) (OPT ACMKP33P612LY198 (V40920)) (OPT PACMKP33BA3908 (V21335)) (OPT PACMKP33BFS428 (V21335))		2
R 546	143T6491-1		.PLATE-BRG RETAINING		2
R 549	NAS1801-3-15		.SCREW		1
R 552	NAS6703-6		.BOLT		1
R 555	BACW10BN3AC		.WASHER		2
R 558	NAS1149D0363J		.WASHER		4
R 561	H52732-3CD		.NUT- (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		2
R 564	BACJ40A20-7		.JUMPER ASSY		1
R 567	143T6493-1		.CONNECTOR-TORQUE TUBE ATTACHING PARTS		1
R 570	BACB30NR4K30		.BOLT		1
R 573	BACW10BP4ACU		.WASHER		1
R 576	NAS1149C0416R		.WASHER		1
R 579	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554)) -----*		1
R 582	BACB30LH3K6		.BOLT		4
R 585	143T6339-4		.ADAPTER ASSY		1
R 588	143T6376-4		..SEAL		1
R 591	143T6339-3		..ADAPTER		1
R 594	MS29513-210		.PACKING		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-				
R	597	143T6481-1	.RETAINER PLATE ASSY-RTNR		1
R	600	BACR15BA3AD	..RIVET- (SIZE DETERMINE ON INST)		8
R	603	F1968-3BAC	..NUTPLATE- (V15653) (SPEC BACN10JZ3A2) (OPT NS103224-02 (V80539)) (OPT RMF9219-3 (V72962)) (OPT SE98A3 (V62554))		4
R	606	143T6376-4	..SEAL		1
R	609	143T6481-2	..RETAINER		1
R	612	BACB30NR5K10	.BOLT		4
R	615	NAS1149F0532P	.WASHER		4
R	618	H52732-5CD	.NUT- (V15653) (SPEC BACN10YR5CD) (OPT PLH55CD (V62554))		4
R	621	D2070-11	.ACTUATOR- (V17472) (SPEC 60B00304-6)		1
	624	PACMKP33BA3908	DELETED		
R	627	143T6542-1	.PLATE-MTG		1
R	630	143T6402-1	.BELLCRANK ASSY ATTACHING PARTS		4
R	633	BACB30NR4K36	.BOLT		8
R	636	BACW10BN4AC	.WASHER		8
R	639	NAS1149D0432J	.WASHER		8
R	642	H52732-4CD	.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554)) -----*		8
R	645	BACB28X6C024	..BUSHING		1
R	648	BACB28X9M020	..BUSHING		1
R	651	143T6402-2	..BELLCRANK		1
R	654	143T6412-1	.CONNECTOR		4
R	657	143T6412-7	.CONNECTOR- (OPT ITEM 657A)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02- -657A	143T6412-8		.CONNECTOR- (OPT ITEM 657) ATTACHING PARTS		1
R 660	BACB30NR4K30		.BOLT		9
R 663	BACW10BP4ACU		.WASHER		9
R 666	NAS1149C0416R		.WASHER		9
R 669	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554)) -----*-----		9
R 672	143T6473-1		.RING-THRUST		AR
R 675	143T6473-2		.RING-THRUST		AR
R 678	143T6473-3		.RING-THRUST		AR
R 681	143T6473-4		.RING-THRUST		AR
R 684	143T6494-1		.LEVER-STOP ATTACHING PARTS		1
R 687	BACB30UU4K33		.BOLT		1
R 690	BACW10BP4CD		.WASHER		1
R 693	NAS1149C0432R		.WASHER		1
R 696	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554)) -----*-----		1
R 699	143T6423-5		.SHAFT-TORQUE		2
R 702	143T6423-6		.SHAFT-TORQUE		1
R 705	143T6423-7		.SHAFT-TORQUE		1
R 708	NAS428-6-11		.BOLT		2
R 711	NAS1149C0632R		.WASHER		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-				
R	714	NAS509-6	.NUT		2
R	717	143T6419-1	.BRACKET-STOP ATTACHING PARTS		2
R	720	BACB30UU5K21	.BOLT		4
R	723	BACW10BP5CD	.WASHER		4
R	726	NAS1149F0563P	.WASHER		4
R	729	H52732-5CD	.NUT- (V15653) (SPEC BACN10YR5CD) (OPT PLH55CD (V62554)) -----*		4
R	732	BACB30NR5K32	.BOLT		3
R	735	BACW10BP5CD	.WASHER		3
R	738	NAS1149F0532P	.WASHER		3
R	741	NAS1805-5L	.NUT		3
R	744	BACS40R010C010F	.SHIM		3
R	747	143T6497-1	.HOUSING-BRG		1
R	750	SSMKP33BSD702	.BEARING- (V83086) (SPEC BACB10FR33) (OPT ACMKP33P28LY198 (V40920)) (OPT ACMKP33BP28LY198 (V40920)) (OPT ACMKP33BP612LY198 (V40920)) (OPT ACMKP33P612LY198 (V40920)) (OPT PACMKP33BA3908 (V21335)) (OPT PACMKP33BFS428 (V21335))		1

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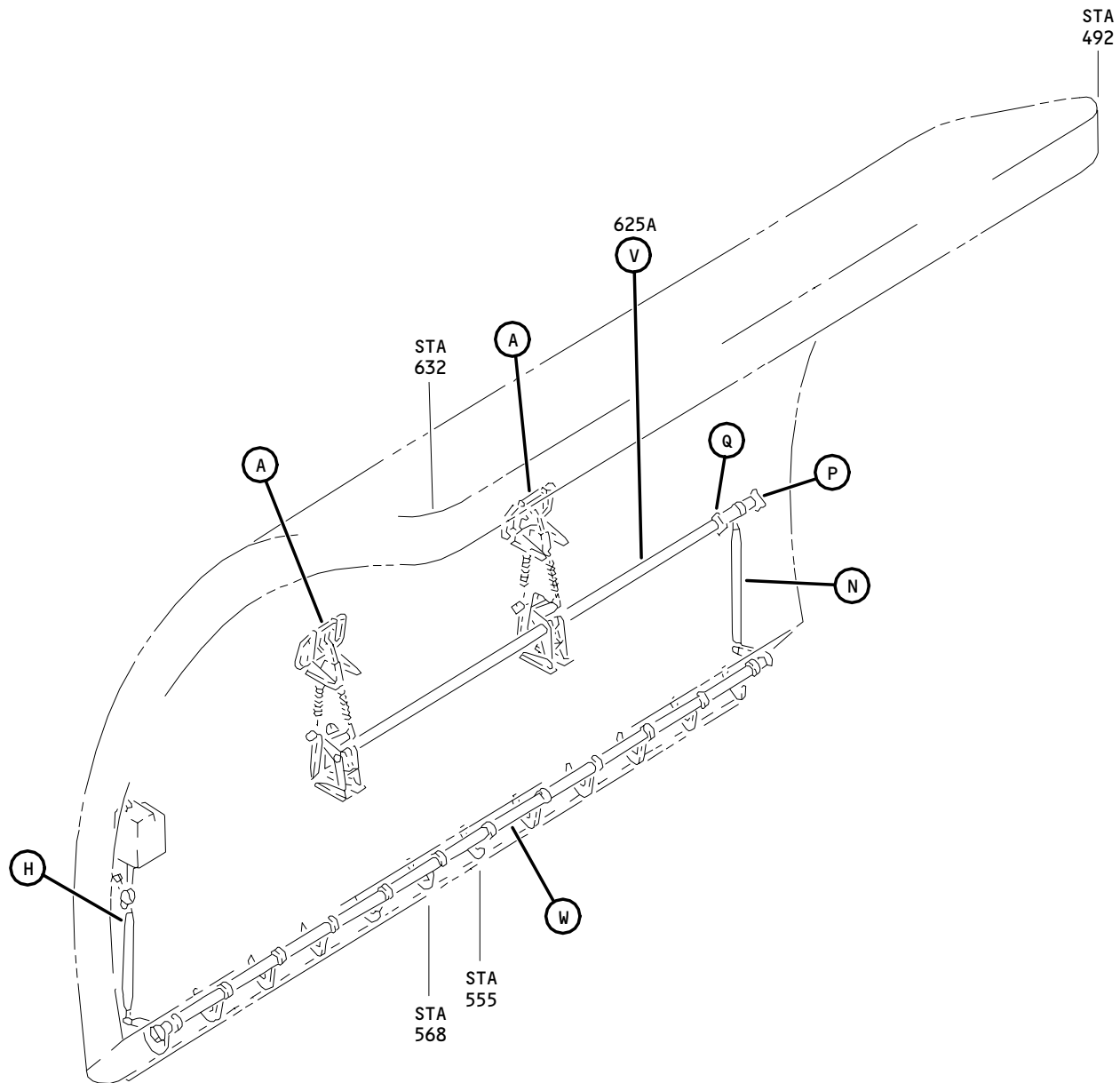

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
R 753	143T6498-1		.PLATE-BRG RETAINING		1
R 756	BACB30NR4K21		.BOLT		34
R 759	BACB30NR4K23		.BOLT		2
R 762	BACW10BP4CD		.WASHER		36
R 765	NAS1149D0416J		.WASHER		36
R 768	NAS1149D0463J		.WASHER		4
R 771	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		36
R 774	143T6405-7		.HOUSING-BRG		5
R 777	143T6405-8		.HOUSING-BRG		4
R 780	SSMKP33BSD702		.BEARING- (V83086) (SPEC BACB10FR33) (OPT ACMKP33P28LY198 (V40920)) (OPT ACMKP33BP28LY198 (V40920)) (OPT ACMKP33BP612LY198 (V40920)) (OPT ACMKP33P612LY198 (V40920)) (OPT PACMKP33BA3908 (V21335)) (OPT PACMKP33BFS428 (V21335))		9
R 783	143T6407-3		.PLATE-BRG RETAINING		9

- Item Not Illustrated

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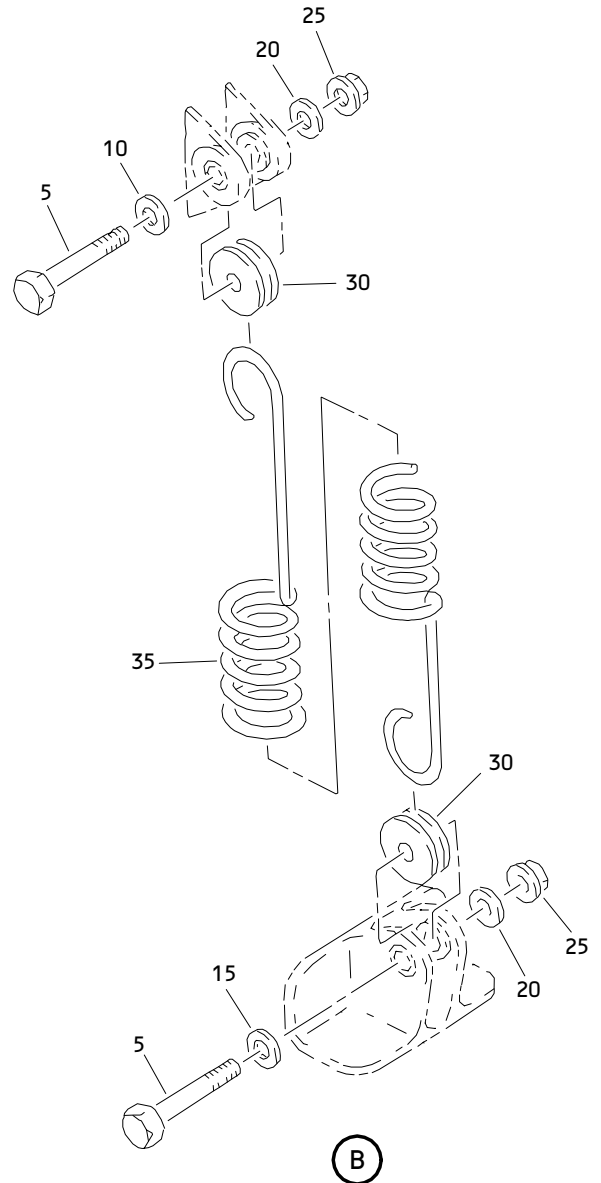
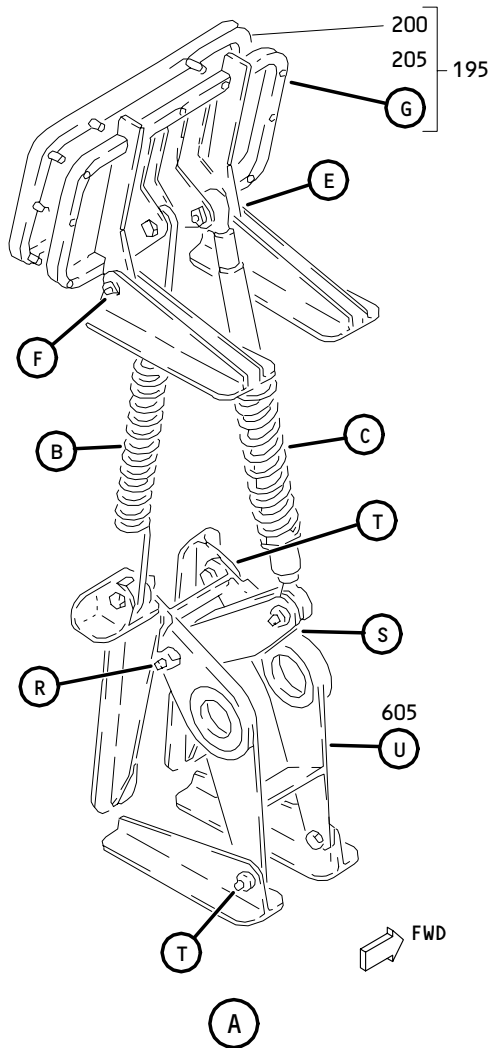
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Main Deck Cargo Door Latch Lock Installation
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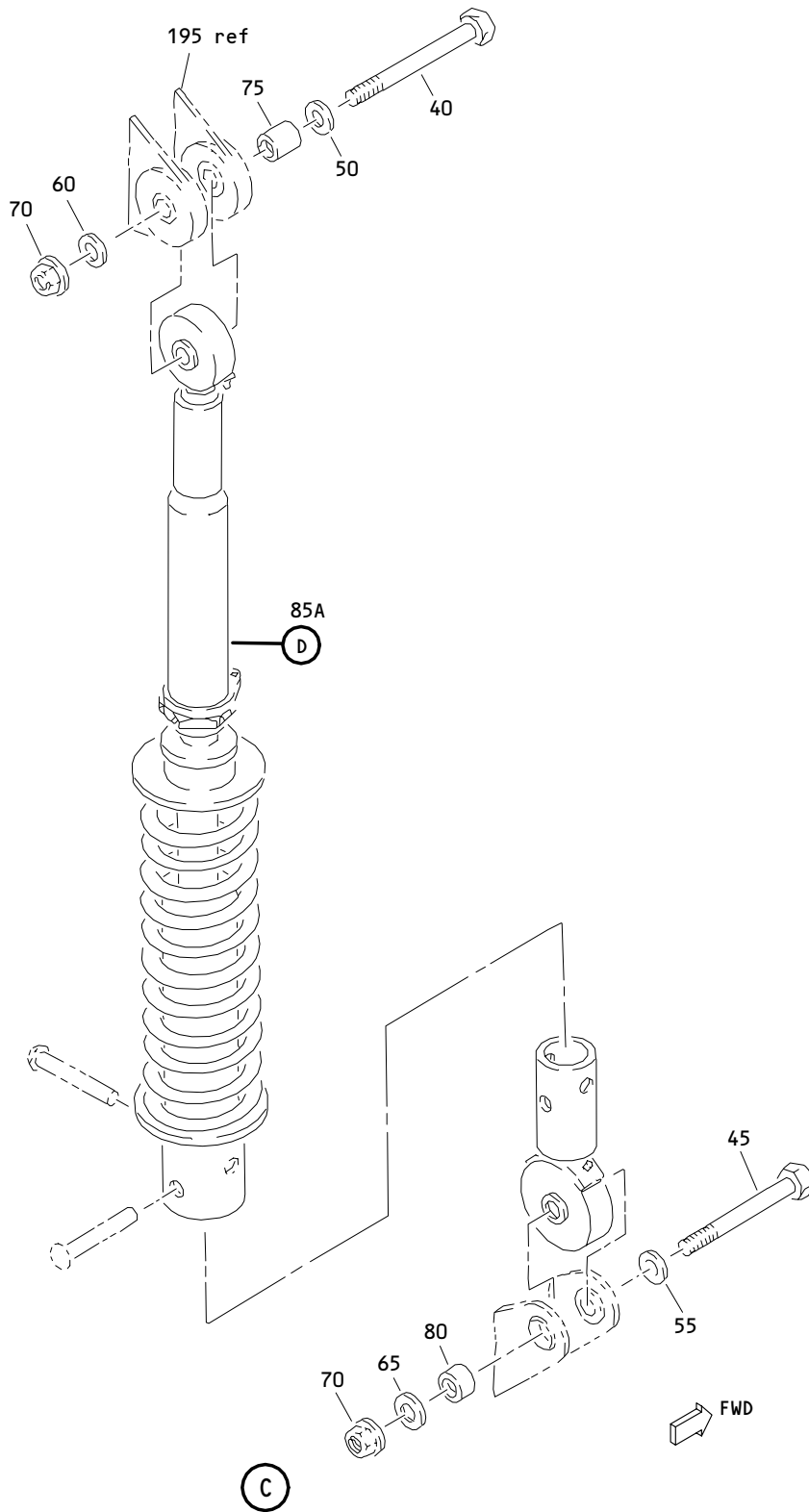
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Main Deck Cargo Door Latch Lock Installation
 Figure 3 (Sheet 2)

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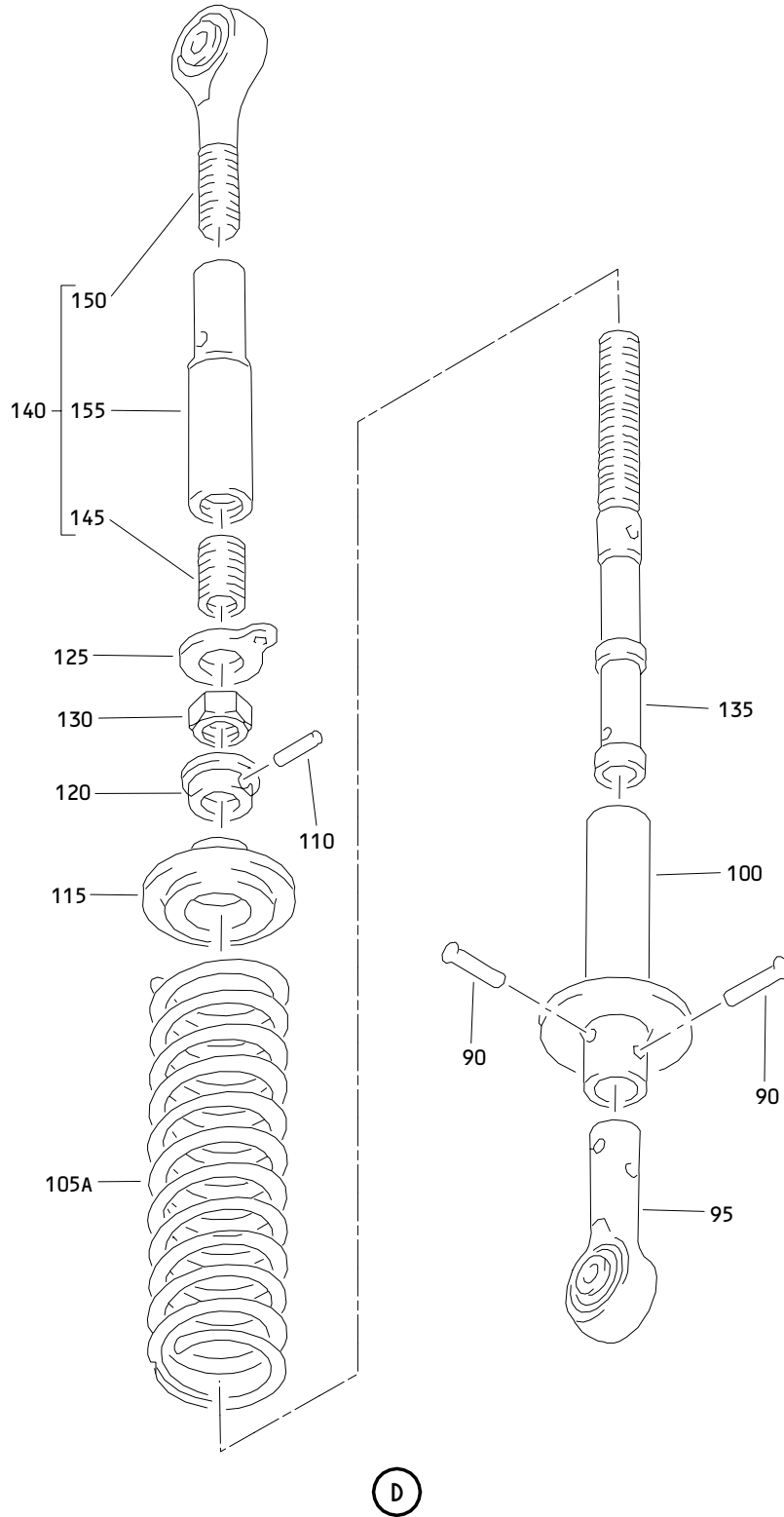
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Main Deck Cargo Door Latch Lock Installation
 Figure 3 (Sheet 3)

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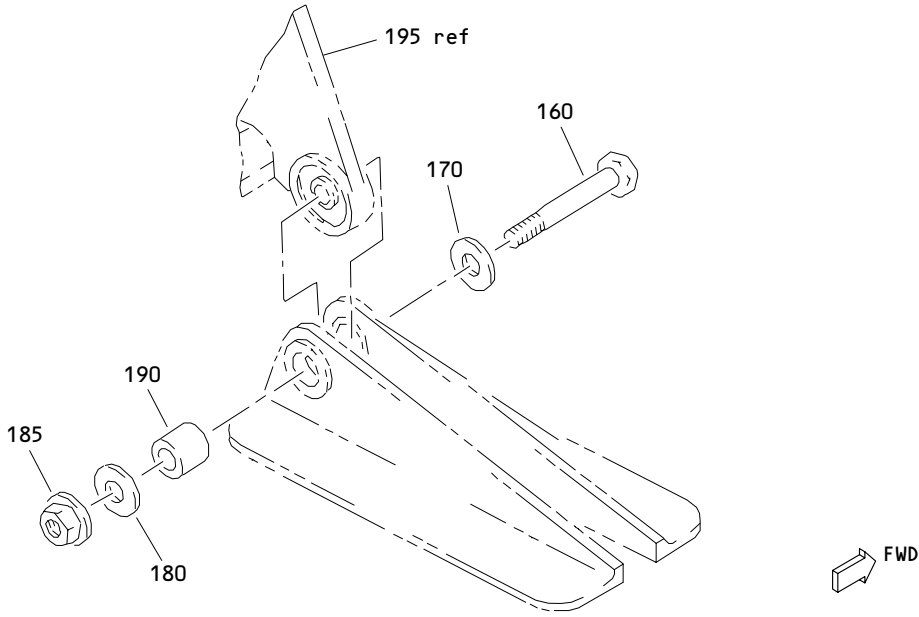
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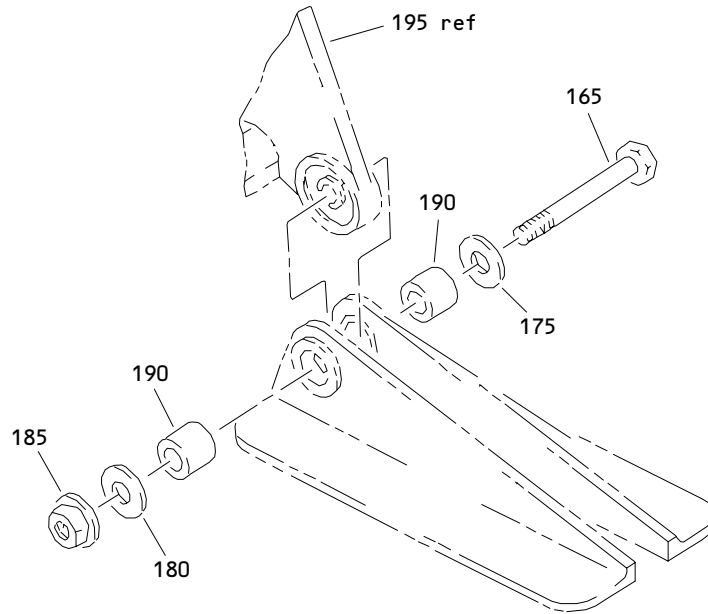
Main Deck Cargo Door Latch Lock Installation
Figure 3 (Sheet 4)

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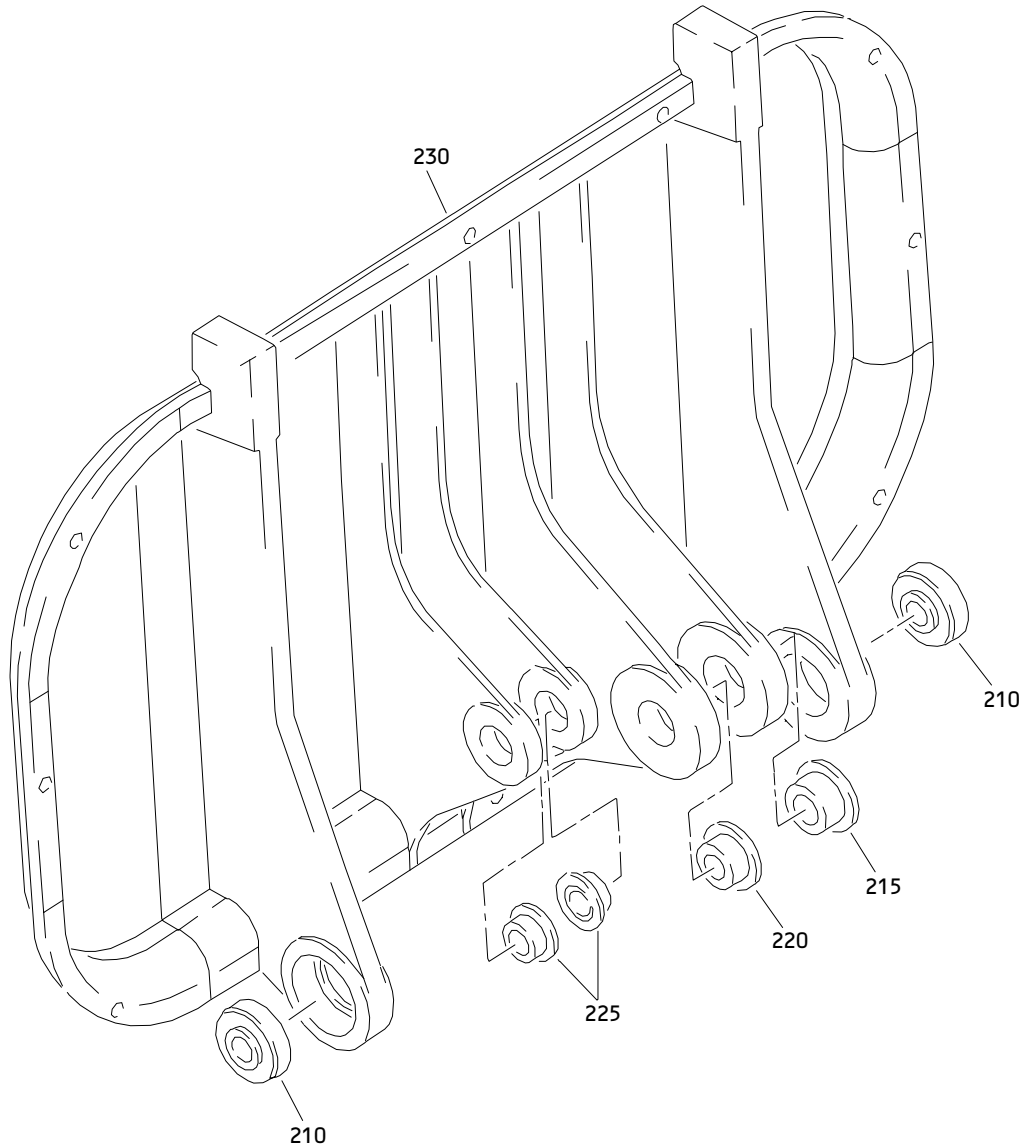


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Figure 3 (Sheet 5)

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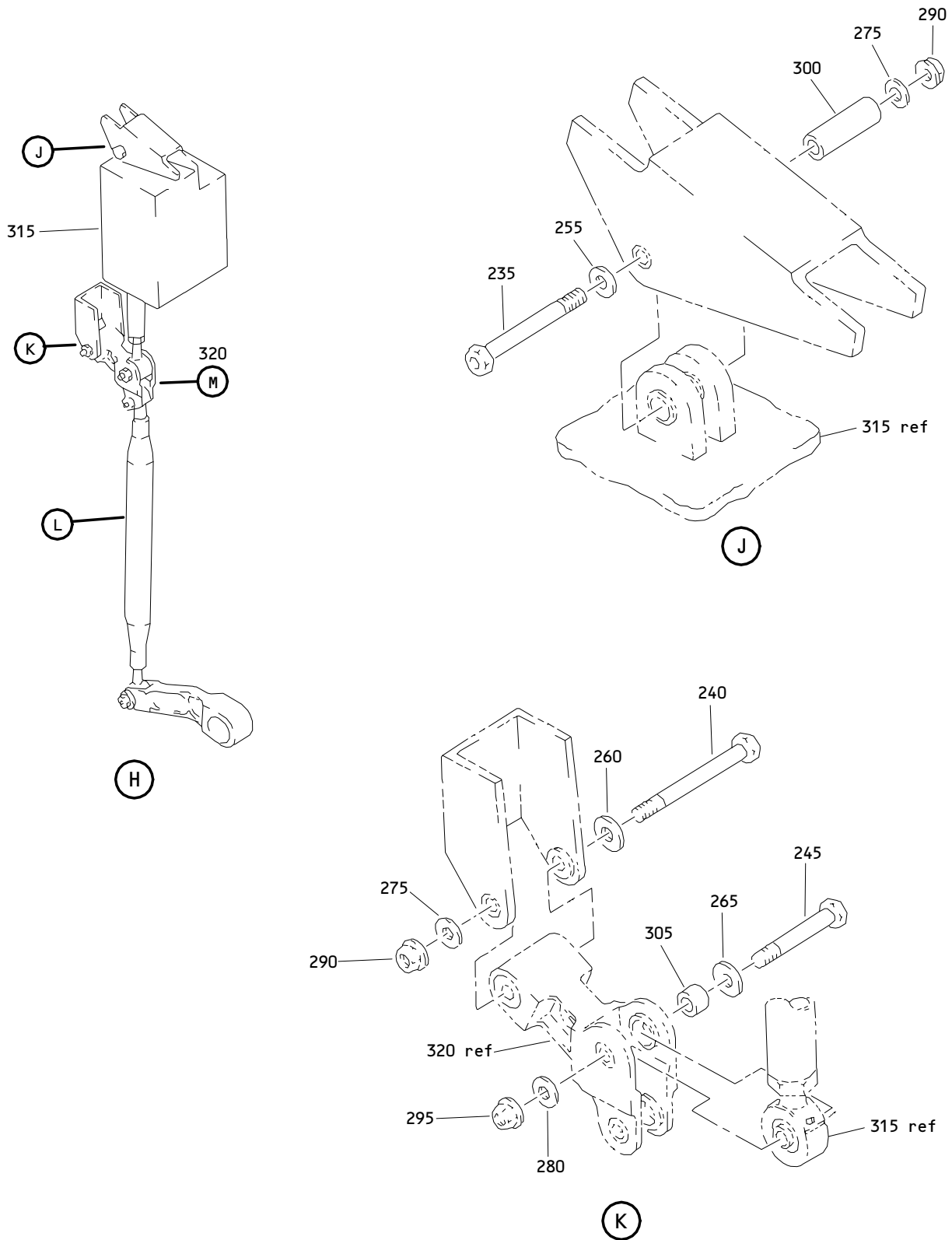


(G)

Main Deck Cargo Door Latch Lock Installation
Figure 3 (Sheet 6)

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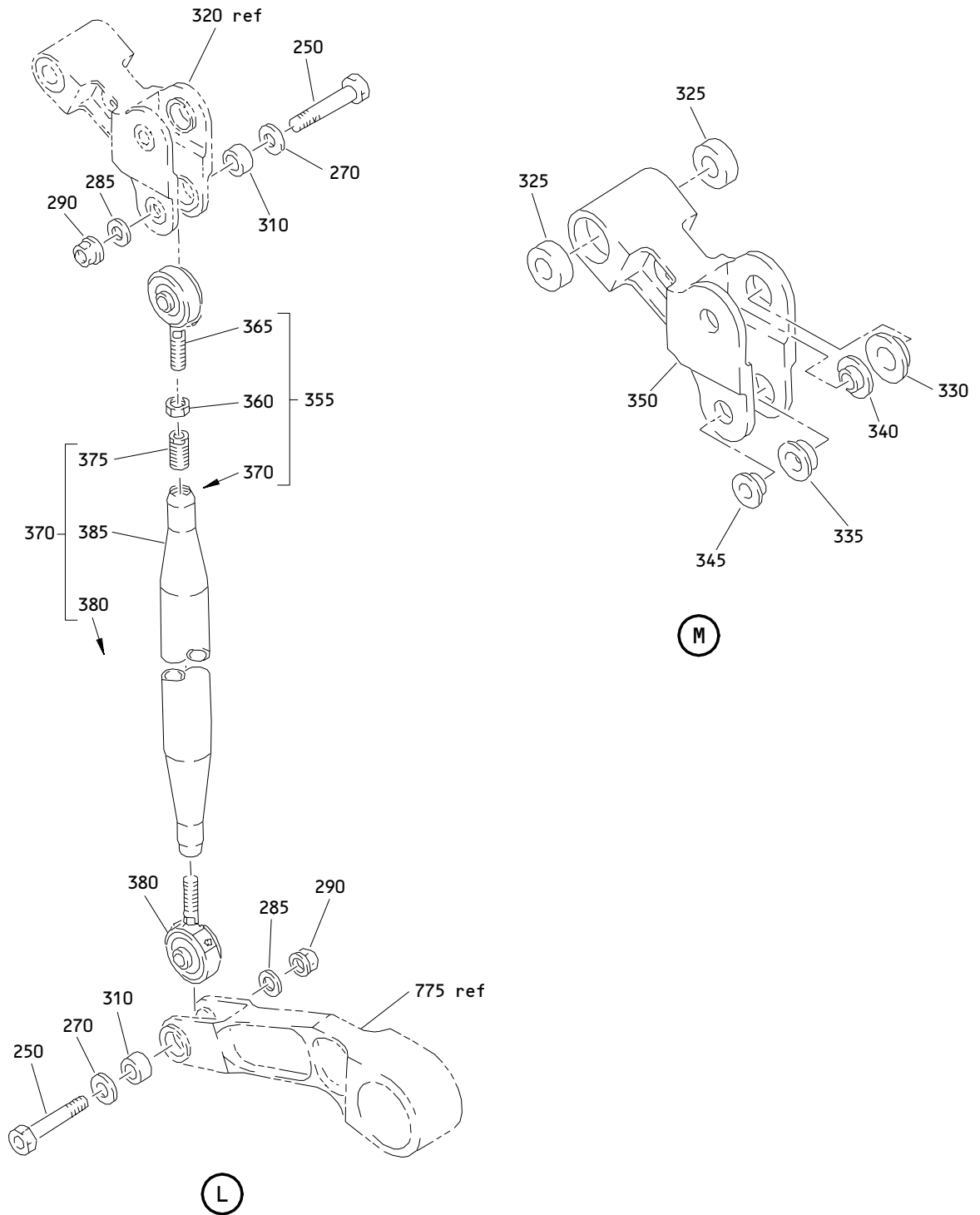
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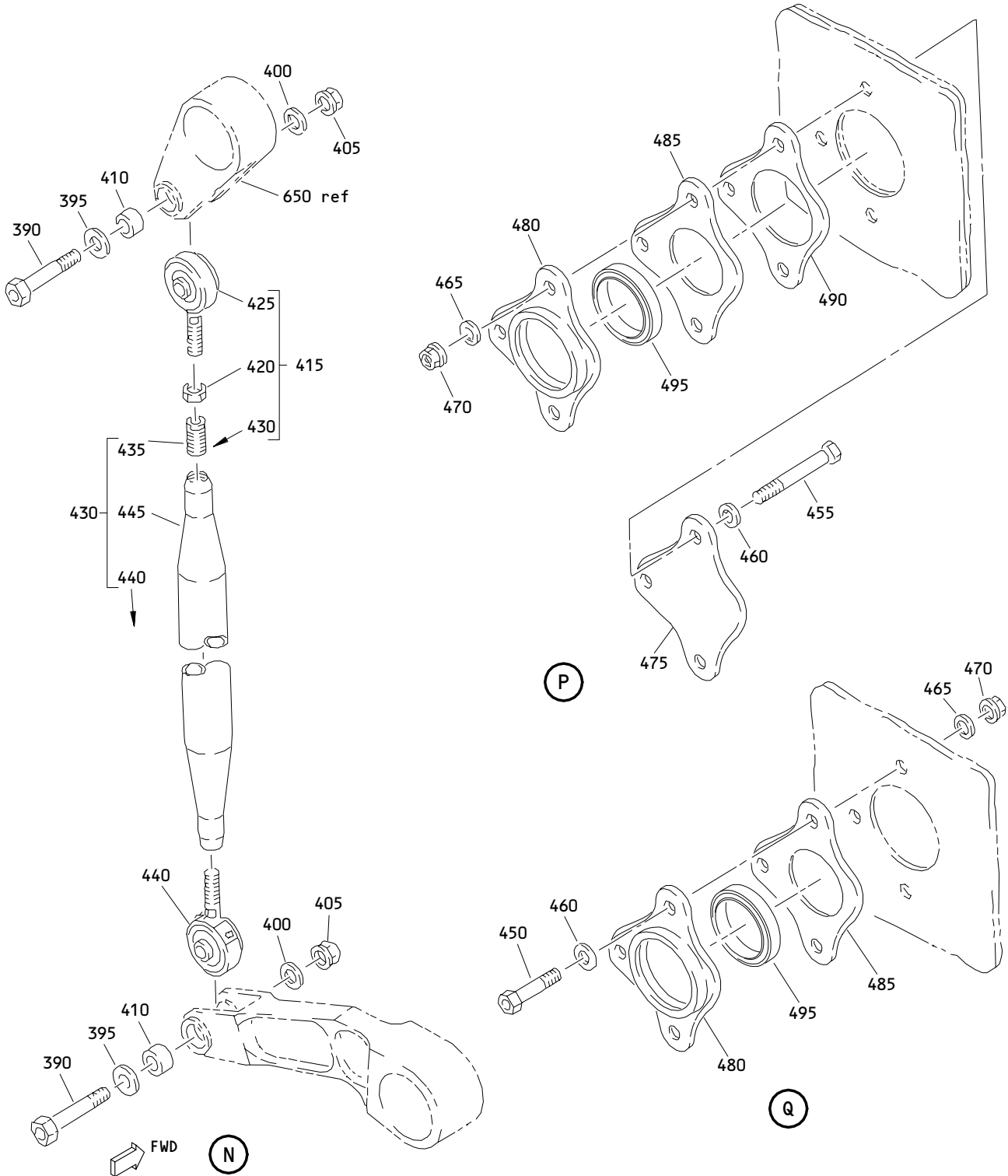
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Main Deck Cargo Door Latch Lock Installation
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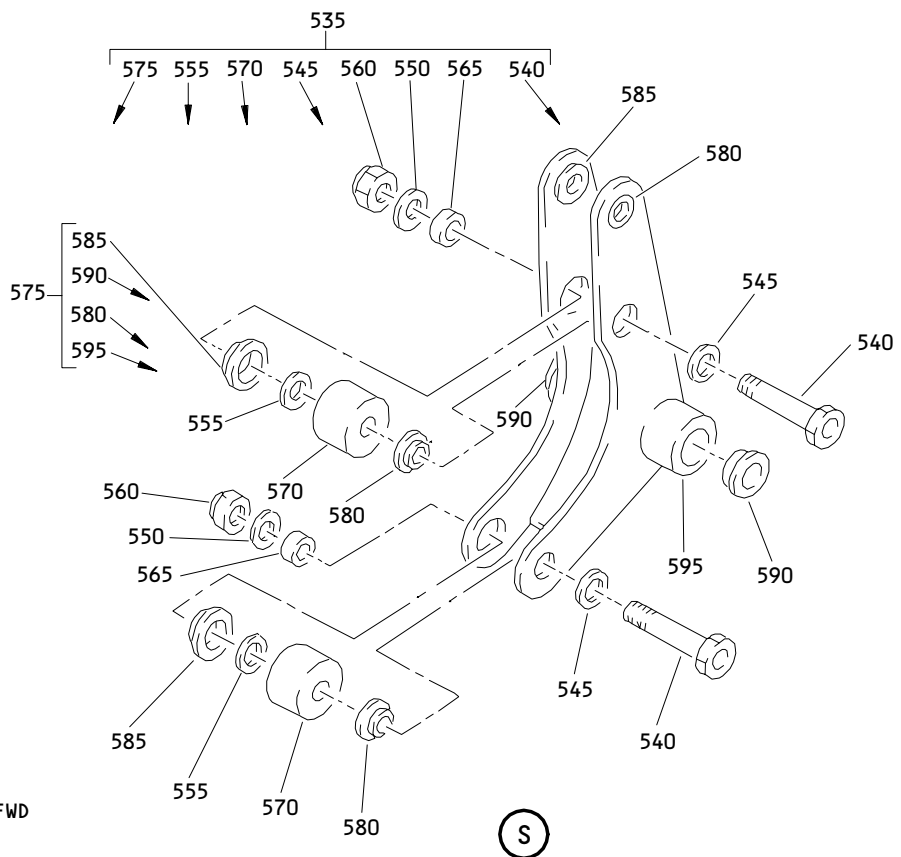
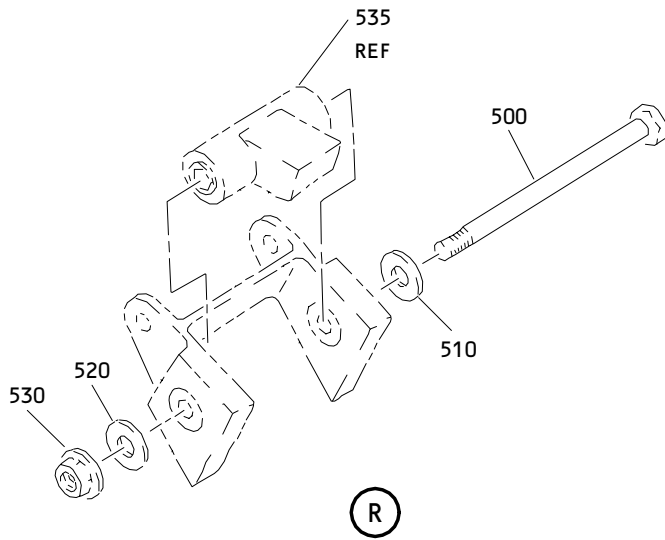
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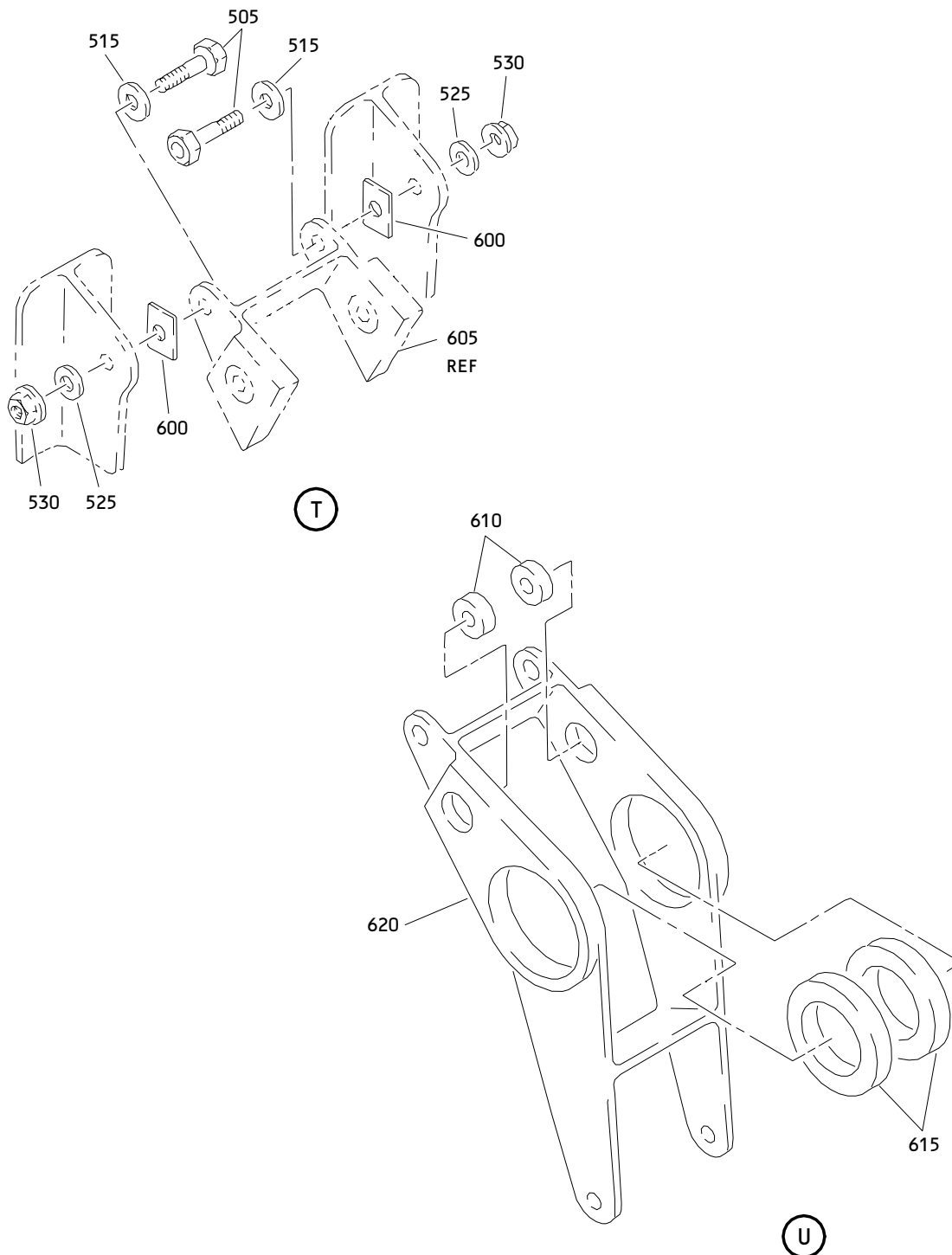
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Main Deck Cargo Door Latch Lock Installation
 Figure 3 (Sheet 10)

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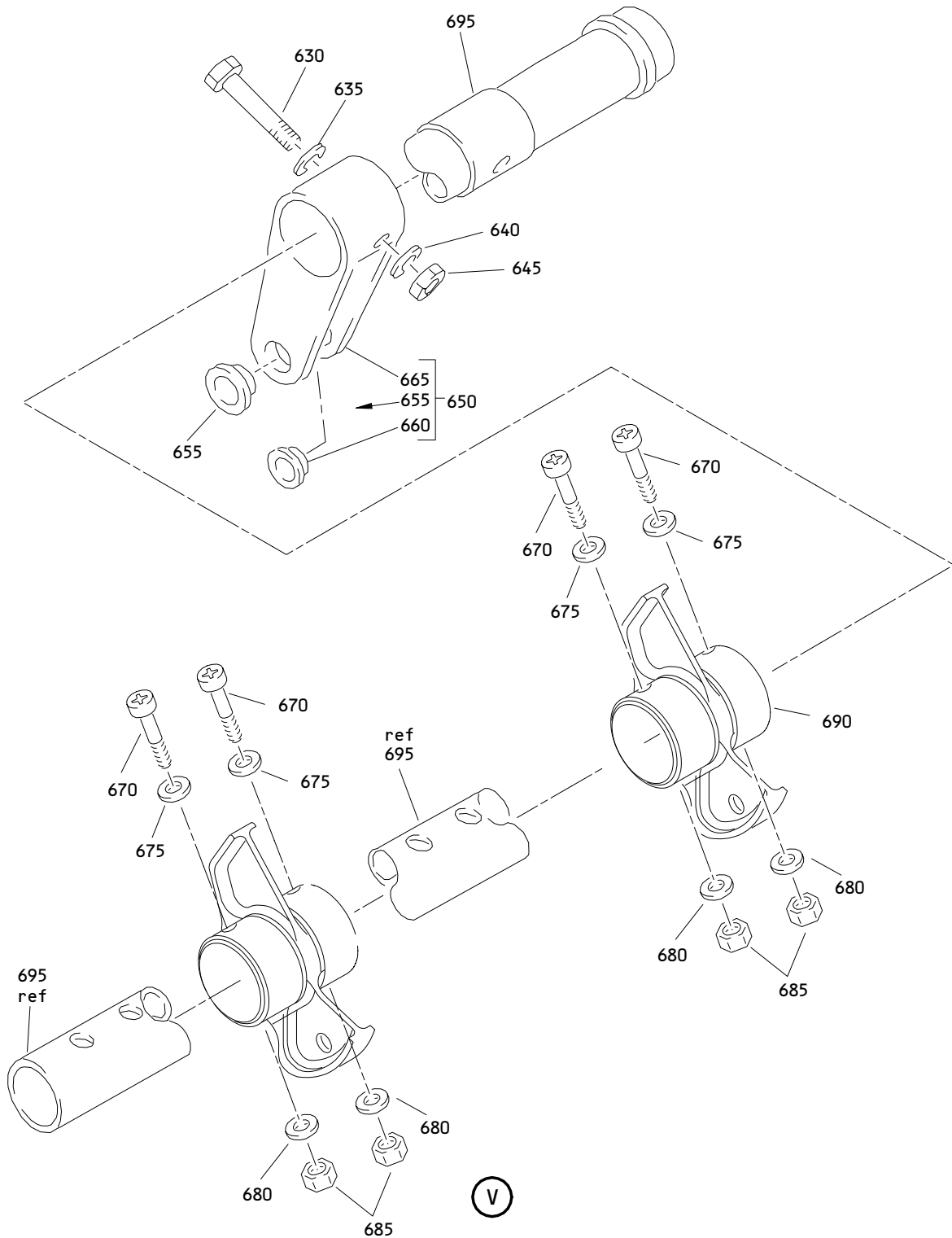
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Main Deck Cargo Door Latch Lock Installation
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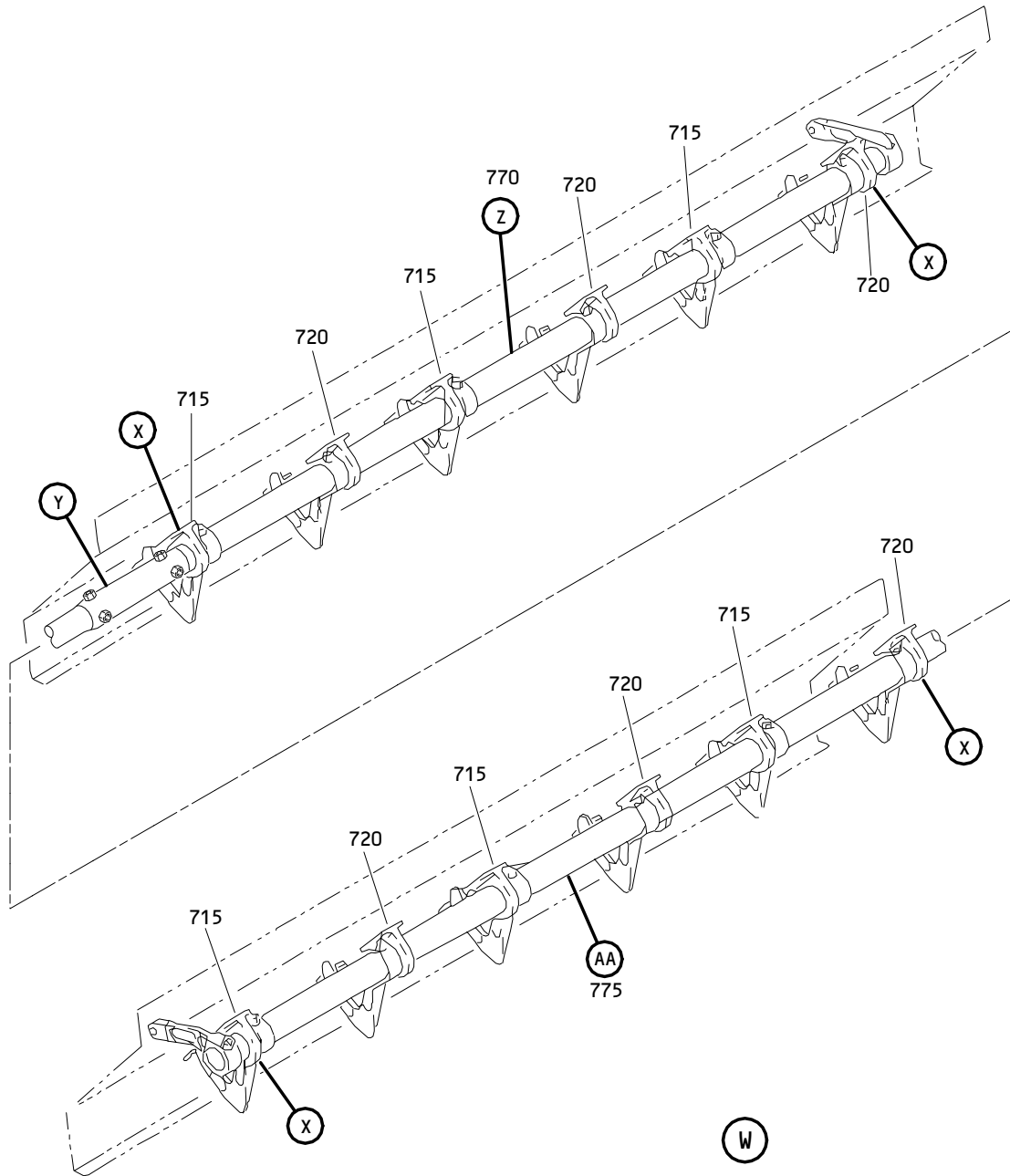
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Figure 3 (Sheet 12)

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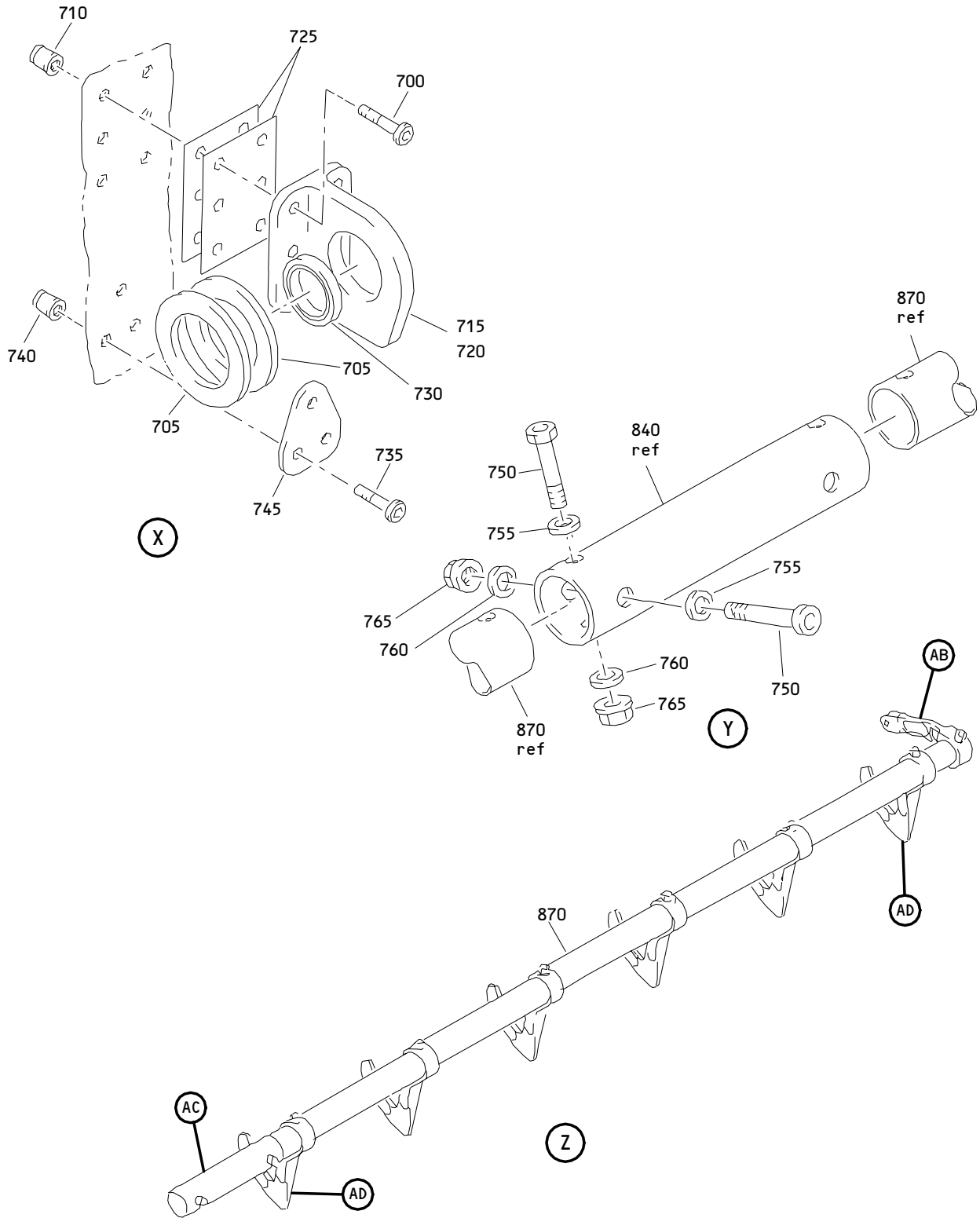
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Figure 3 (Sheet 13)

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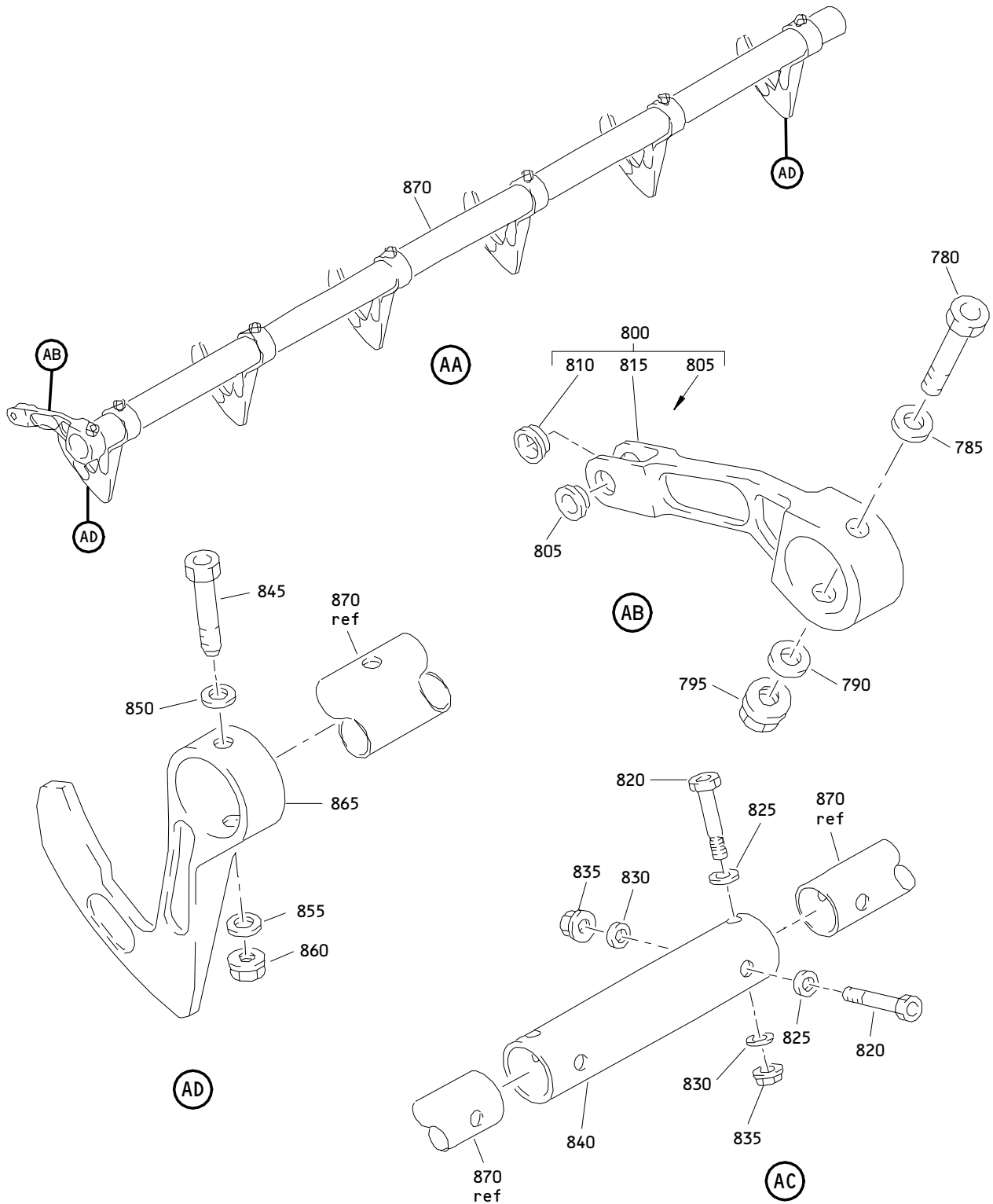
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Main Deck Cargo Door Latch Lock Installation
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Main Deck Cargo Door Latch Lock Installation
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 03-					
R -1A	143T6207-1		LOCK INSTL-LATCH		RF
R 5	BACB30PW4-14		.BOLT		4
R 10	NAS1149D0432J		.WASHER		2
R 15	NAS1149D0463J		.WASHER		2
R 20	NAS1149C0332B		.WASHER		4
R 25	H52732-3CD		.NUT- (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		4
R 30	143T6615-1		.BUSHING-SPR		4
R 35	143T6607-1		.SPRING-HELICAL EXTENSION		2
R 40	BACB30NR4K20		.BOLT		2
R 45	BACB30NR4K17		.BOLT		2
R 50	BACW10BP4ACU		.WASHER		2
R 55	BACW10BN4AC		.WASHER		2
R 60	NAS1149D0432J		.WASHER		2
R 65	NAS1149C0432B		.WASHER		2
R 70	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		4
R 75	BACB28AK04-042		.BUSHING		2
R 80	BACB28AK04-023		.BUSHING		2
R 85	143T6601-1		DELETED		
R 85A	143T6601-2		.ROD ASSY-PUSH		2
R 90	MS20615-4M		..RIVET- (SIZE DETERMINE ON INST)		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 03-95	SPH4-10B4		..BEARING- (V77896)		1
R 100	140T2933-1		..SUPPORT-LWR		1
105	143T6606-1		DELETED		
R 105A	140T2974-1		..SPRING-HELICAL CPRSN		1
R 110	MS39086-143		..PIN-SPR		1
R 115	140T2973-1		..RETAINER-SPR		1
R 120	140T2976-1		..KEEPER		1
R 125	NAS513-8		..WASHER		1
R 130	NAS1423-8		..NUT		1
R 135	140T2972-2		..SUPPORT-UPR		1
R 140	143T6616-1		..ROD ASSY		1
R 145	141T6171-5		...INSERT		1
R 150	10106-731		...BEARING- (V77896) (SPEC S012T236-657) (OPT SM4-6AW1-501 (V77896))		1
R 155	143T6616-2		...ROD		1
R 160	BACB30NR4K16		.BOLT		2
R 165	BACB30NR4K19		.BOLT		2
R 170	BACW10BN4AC		.WASHER		2
R 175	BACW10BP4ACU		.WASHER		2
R 180	NAS1149C0432B		.WASHER		4
R 185	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	03-				
R	190	BACB28AK04-042	.BUSHING		6
R	195	143T6603-1	.DOOR ASSY-VENT		2
R	200	143T6610-1	..SEAL-PRESSURE		1
R	205	143T6603-2	..DOOR ASSY		1
R	210	SSMKP4ASD705	...BEARING- (V83086) (SPEC BACB10FS4) (OPT PACMKP4AA3908 (V21335)) (OPT ACMKP4AP510LY19 (V40920)) (OPT PACMKP4AFS428 (V21335)) (OPT SSMKP4AP (V21760))		2
R	215	BACB28X6M023	...BUSHING		1
R	220	BACB28X4C023	...BUSHING		1
R	225	BACB28X4M016	...BUSHING		2
R	230	143T6603-3	...DOOR		1
R	235	BACB30NR4K25	.BOLT		1
R	240	BACB30PW5P32	.BOLT		1
R	245	BACB30NR5K22	.BOLT		1
R	250	BACB30NR4K19	.BOLT		2
R	255	BACW10BN4AC	.WASHER		1
R	260	NAS1149D0563J	.WASHER		1
R	265	BACW10BP5ACU	.WASHER		1
R	270	BACW10BP4ACU	.WASHER		2
R	275	NAS1149C0432B	.WASHER		2
R	280	NAS1149D0532J	.WASHER		1
R	285	NAS1149D0432J	.WASHER		2
R	290	H52732-4CD	.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		4
R	295	H52732-5CD	.NUT- (V15653) (SPEC BACN10YR5CD) (OPT PLH55CD (V62554))		1
R	300	BACB28AK04-128	.BUSHING		1
R	305	BACB28AK05-025	.BUSHING		1
R	310	BACB28AK04-032	.BUSHING		2
R	315	S140T260-5	.UNIT-PWR		1
R	320	143T6593-1	.IDLER ASSY		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 03-325	SSMKP5ASD705		..BEARING- (V83086) (SPEC BACB10FS5) (OPT ACMKP5AP510LY19 (V40920)) (OPT PACMKP5AA3908 (V21335)) (OPT PACMKP5AFS428 (V21335)) (OPT SSMKP5AP (V21760))		2
R 330	BACB28X5C012		..BUSHING		1
R 335	BACB28X4C012		..BUSHING		1
R 340	BACB28X7M012		..BUSHING		1
R 345	BACB28X6M012		..BUSHING		1
R 350	143T6593-2		..IDLER		1
R 355	143T6455-8		.ROD ASSY		1
R 360	NAS1423-4		..NUT		1
R 365	SM4-4J20		..ROD END- (V77896)		1
R 370	143T6455-9		..ROD ASSY		1
R 375	141T6171-10		...INSERT		1
R 380	143T6455-5		...END-ROD		1
R 385	143T6456-5		...TUBE		1
R 390	BACB30NR4K19		.BOLT		2
R 395	BACW10BP4ACU		.WASHER		2
R 400	NAS1149D0432J		.WASHER		2
R 405	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		2
R 410	BACB28AK04-032		.BUSHING		2
R 415	143T6455-6		.ROD ASSY		1
R 420	NAS1423-4		..NUT		1
R 425	SM4-4J20		..ROD END- (V77896)		1
R 430	143T6455-7		..ROD ASSY		1
R 435	141T6171-10		...INSERT		1
R 440	143T6455-5		...END-ROD		1
R 445	143T6456-4		...TUBE		1
R 450	BACB30NR4K7		.BOLT		3

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 03-					
R 455	BACB30NR4K9		.BOLT		3
R 460	BACW10BN4AC		.WASHER		6
R 465	NAS1149D0463J		.WASHER		6
R 470	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		6
R 475	143T6459-4		.PLATE-COVER		1
R 480	143T6426-4		.SUPPORT-BRG (OPT ITEM 480A)		2
R -480A	143T6426-5		.SUPPORT-BRG (OPT ITEM 480)		2
R 485	143T6459-2		.RETAINER-BRG		2
R 490	143T6457-4		.SHIM		1
R 495	PACMB542DDFS428		.BEARING- (V21335) (SPEC BACB10FU21) (OPT SSMB542DDSD705 (V83086)) (OPT PACMB542DDA3908 (V21335)) (OPT ACMB542DDP818LY (V40920))		2
R 500	BACB30NR4K45		.BOLT		2
R 505	BACB30NR4K6		.BOLT		8
R 510	BACW10BP4ACU		.WASHER		2
R 515	BACW10BN4AC		.WASHER		8
R 520	NAS1149C0432B		.WASHER		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 03- 525	NAS1149D0463J		.WASHER		8
R 530	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		10
R 535	140T2975-3		.CRANK ASSY-VENT DOOR MECH		2
R 540	BACB30NR4K16		..BOLT		2
R 545	AN960PD416L		..WASHER		2
R 550	AN960C416		..WASHER		2
R 555	AN960C416L		..WASHER		2
R 560	BRH10A4		..NUT- (V52828) (SPEC BACN10JC4) (OPT T6S428J (V11815)) (OPT 96-048 (V80539)) (OPT VN303A048 (V92215)) (OPT RMLH9075-4W (V72962)) (OPT NS202101-048 (V80539)) (OPT H10-4BAC (V15653))		2
R 565	BACB28AK04-023		..BUSHING		2
R 570	YCRS12CP		..BEARING- (V60380) (OPT ITEM 570A)		2
R -570A	CYR3-4SCP		..BEARING- (V39317) (OPT ITEM 570)		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	03-				
R	575	140T2993-5	..CRANK ASSY		1
R	580	BACB28X4C010	...BUSHING		3
R	585	BACB28X6M010	...BUSHING		3
R	590	BACB28X4C025	...BUSHING		2
R	595	140T2993-4	...CRANK		1
R	600	BACS40R009B010F	.SHIM		8
R	605	143T6597-1	.FITTING ASSY-SPRT		2
R	610	SSMKP4ASD705	..BEARING- (V83086) (SPEC BACB10FS4) (OPT PACMKP4AA3908 (V21335)) (OPT ACMKP4AP510LY19 (V40920)) (OPT PACMKP4AFS428 (V21335)) (OPT SSMKP4AP (V21760))		2
R	615	PACMB542DDFS428	..BEARING- (V21335) (SPEC BACB10FU21) (OPT SSMB542DDSD705 (V83086)) (OPT PACMB542DDA3908 (V21335)) (OPT ACMB542DDP818LY (V40920))		2
R	620	143T6597-2	..FITTING		1
	625	143T6559-1	DELETED		
R	625A	143T6599-1	.TUBE ASSY-TORQUE		1
R	630	BACB30NR4K28	..BOLT		1
R	635	NAS1149D0416J	..WASHER		1
R	640	NAS1149D0463J	..WASHER		1
R	645	BRH10C4D	..NUT- (V52828) (SPEC BACN10JC4CD) (OPT T6C428JCD (V11815)) (OPT NS202486-048 (V80539)) (OPT 102LH9075-4W (V72962)) (OPT H51650-4BAC (V15653))		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 03-					
R 650	143T6446-1		..BELLCRANK ASSY		1
R 655	BACB28X6M012		...BUSHING		1
R 660	BACB28X4C012		...BUSHING		1
R 665	143T6446-2		...BELLCRANK		1
R 670	BACB30NM3K25		..BOLT		4
R 675	NAS1149D0332J		..WASHER		4
R 680	NAS1149D0363J		..WASHER		4
R 685	BRH10C3D		..NUT- (V52828) (SPEC BACN10JC3CD) (OPT T6C1032JCD (V11815)) (OPT NS202486-02 (V80539)) (OPT 102LH9075-3W (V72962)) (OPT H51650-3BAC (V15653))		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 03-690	143T6596-1		..CAM-VENT DOOR MECH		2
R 695	143T6598-1		..TUBE		1
R 700	HL1012AZ6-9		.BOLT- (V97928) (SPEC BACB30NX6K9) (OPT HL12VAZ6-9 (V73197)) (OPT HL12VAZ6-9 (V92215)) (OPT HL12VAZ6-9 (V97928)) (OPT L802-6K9 (V06725)) (OPT HL12VAZ6-9 (V56878)) (OPT HL1012AZ6-9 (V0PTK6)) (OPT HL1012AZ6-9 (V06725)) (OPT HL1012AZ6-9 (V06950)) (OPT HL1012AZ6-9 (V17446)) (OPT HL1012AZ6-9 (V56878)) (OPT HL1012AZ6-9 (V60516)) (OPT HL1012AZ6-9 (V73197))		72
R 705	143T6478-1		.WASHER		AR

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 03-710	HL1187-6		.COLLAR- (V5M902) (SPEC BACC30X6) (OPT HL87-6 (V73197)) (OPT HL87-6 (V92215)) (OPT HL1187-6 (V56878)) (OPT HL1187-6 (V92215)) (OPT HL87-6 (V56878)) (OPT HL1187-6 (V73197))		72
R 715	143T6424-1		.SUPPORT-BRG (OPT ITEM 715A)		6
R -715A	143T6424-5		.SUPPORT-BRG (OPT ITEM 715)		6
R 720	143T6424-2		.SUPPORT-BRG (OPT ITEM 720A)		6
R -720A	143T6424-6		.SUPPORT-BRG (OPT ITEM 720)		6
R 725	BACS40R019B028F		.SHIM		24
R 730	PACMB543DDFS428		.BEARING- (V21335) (SPEC BACB10FU25) (OPT SSMB543DDSD705 (V83086)) (OPT PACMB543DDA3908 (V21335)) (OPT ACMB543DDP818LY (V40920))		12

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 03-735	HL1012AZ6-7		.BOLT- (V97928) (SPEC BACB30NX6K7) (OPT HL12VAZ6-7 (V73197)) (OPT HL12VAZ6-7 (V92215)) (OPT HL12VAZ6-7 (V97928)) (OPT L802-6K7 (V06725)) (OPT HL12VAZ6-7 (V56878)) (OPT HL1012AZ6-7 (V0PTK6)) (OPT HL1012AZ6-7 (V06725)) (OPT HL1012AZ6-7 (V06950)) (OPT HL1012AZ6-7 (V17446)) (OPT HL1012AZ6-7 (V56878)) (OPT HL1012AZ6-7 (V60516)) (OPT HL1012AZ6-7 (V73197))		36
R 740	HL1187-6		.COLLAR- (V5M902) (SPEC BACC30X6) (OPT HL87-6 (V73197)) (OPT HL87-6 (V92215)) (OPT HL1187-6 (V56878)) (OPT HL1187-6 (V92215)) (OPT HL87-6 (V56878)) (OPT HL1187-6 (V73197))		36
R 745	143T6458-1		.PLATE-STOP		12
R 750	BACB30NR4K32		.BOLT		2
R 755	BACW10BN4AC		.WASHER		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	03-				
R	760	NAS1149D0463J	.WASHER		2
R	765	H52732-4CD	.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		2
R	770	143T6580-1	.SHAFT ASSY-SECTOR		1
R	775	143T6580-2	.SHAFT ASSY-SECTOR		1
R	780	BACB30NR4K32	..BOLT		1
R	785	BACW10BN4AC	..WASHER		1
R	790	NAS1149D0463J	..WASHER		1
R	795	H52732-4CD	..NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		1
R	800	143T6583-1	..BELLCRANK ASSY		1
R	805	BACB28X6M012	...BUSHING		1
R	810	BACB28X4C012	...BUSHING		1
R	815	143T6583-2	...BELLCRANK		1
R	820	BACB30NR4K32	..BOLT- (USED ON ITEM 770)		2
R	825	BACW10BN4AC	..WASHER- (USED ON ITEM 770)		2
R	830	NAS1149D0463J	..WASHER- (USED ON ITEM 770)		2
R	835	H52732-4CD	..NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554)) (USED ON ITEM 770)		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 03-840	143T6584-1		..CONNECTOR- (USED ON ITEM 770)		1
R 845	BACB30NR4K33		..BOLT		6
R 850	BACW10BN4AC		..WASHER		6
R 855	NAS1149D0463J		..WASHER		6
R 860	H52732-4CD		..NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		6
R 865	143T6617-1		..SECTOR-LATCH LOCK		6
R 870	143T6453-1		..TUBE-TORQUE		1

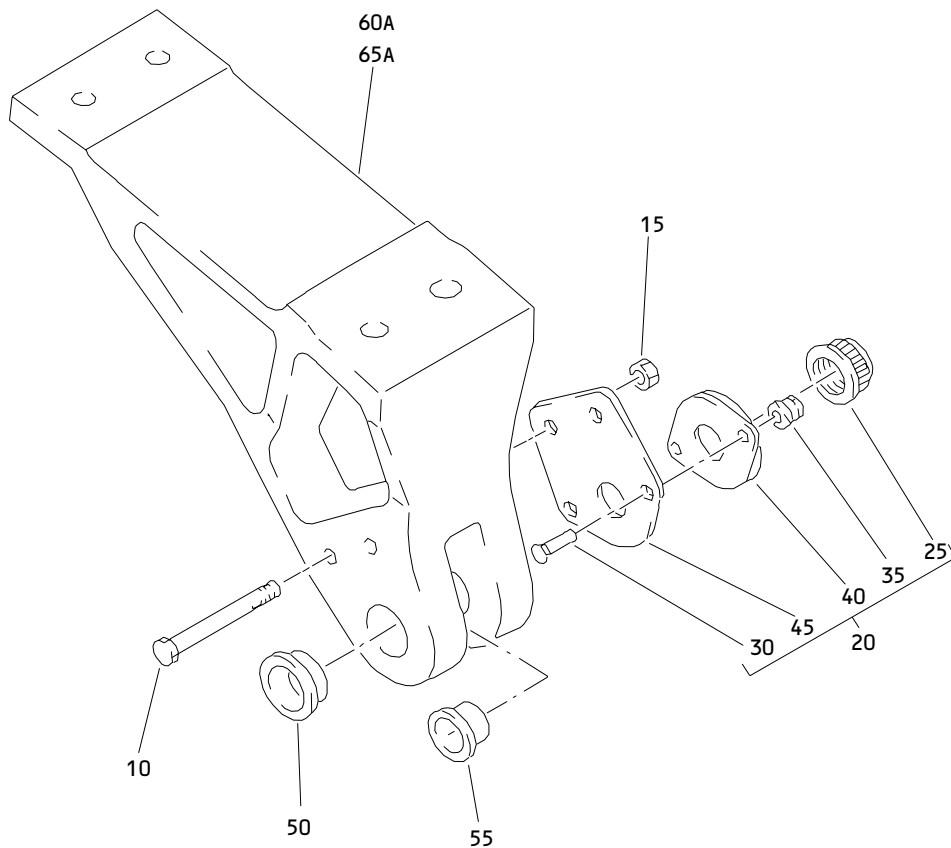
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Main Deck Cargo Door Lift Link Fitting Assembly
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
R -1A	143T6231-1		DELETED		
R -1B	143T6231-5		FITTING ASSY-LIFT LINK		RF
-5	143T6231-2		DELETED		
R -5A	143T6231-6		FITTING ASSY-LIFT LINK		RF
R 10	BACB30NM3K48		.BOLT		2
R 15	BRH10C3D		.NUT- (V52828) (SPEC BACN10JC3CD) (OPT T6C1032JCD (V11815)) (OPT NS202486-02 (V80539)) (OPT 102LH9075-3W (V72962)) (OPT H51650-3BAC (V15653))		2
R 20	143T6544-1		.PLATE ASSY-RTNR		1
R 25	NAS1805-14L		..NUT		1
R 30	HL13VAZ5-4		..BOLT- (V56878) (SPEC BACB30NY5K4) (OPT HL13VAZ5-4 (V73197)) (OPT HL13VAZ5-4 (V92215)) (OPT HL13VAZ5-4 (V97928)) (OPT L801-5K4 (V06725)) (OPT HL13VAZ5-4 (V08524)) (OPT HL13V4 (V06725)) (OPT HL13VAZ5-4 (V17446))		2

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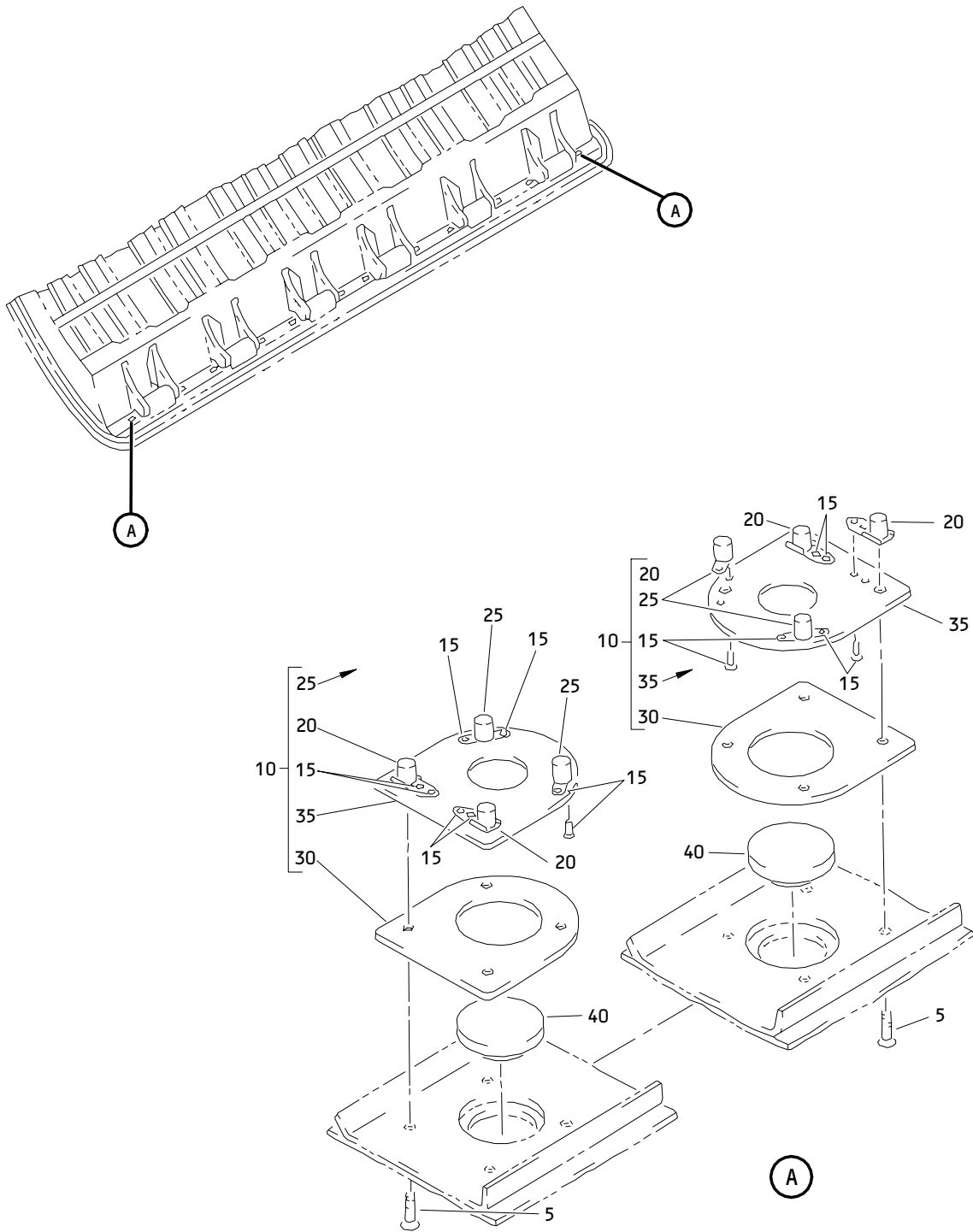
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 04-35	HL1187-5		..COLLAR- (V5M902) (SPEC BACC30X5) (OPT HL87-5 (V73197)) (OPT HL87-5 (V92215)) (OPT HL86PB5 (V73197)) (OPT HL86PB5 (V56878)) (OPT HL86PB5 (V92215)) (OPT HL1187-5 (V56878)) (OPT HL1187-5 (V92215)) (OPT HL87-5 (V56878)) (OPT HL1187-5 (V73197))		2
R 40	143T6544-3		..RETAINER-NUT		1
R 45	143T6544-2		..PLATE		1
R 50	BACB28W18C093		.BUSHING		1
R 55	BACB28W14C091		.BUSHING		1
60	143T6231-3		DELETED		
R 60A	143T6231-7		.FITTING- (USED ON ITEM 1B)		1
65	143T6231-4		DELETED		
R 65A	143T6231-8		.FITTING- (USED ON ITEM 5A)		1

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Main Deck Cargo Door Lower Latch Window Installation
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 05- -1A	143T6281-1		WINDOW INSTL-LWR LATCH OBSERVATION		RF
R 5	BACB30LH3-6		.BOLT		8
R 10	143T6347-2		.DOUBLER ASSY		2
R 15	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		8
R 20	BRF100A3		..NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT F2000-3 (V15653)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653)) (OPT ITEM 20A)		2
R -20A	T8101S3SBCK		..NUTPLATE- (V11815) (SPEC BACN10KA3CR) (OPT NS103228-02BC (V80539)) (OPT ITEM 20)		2
R 25	F171-3		..NUTPLATE- (V72962) (SPEC BACN10JB3) (OPT 43600-02 (V80539)) (OPT BRF210A3 (V52828)) (OPT BRF270A3 (V52828)) (OPT ITEM 25A)		2
R -25A	T8097S1032BCK		..NUTPLATE- (V11815) (SPEC BACN10KA3AR) (OPT NS103226-02BC (V80539)) (OPT ITEM 25)		2

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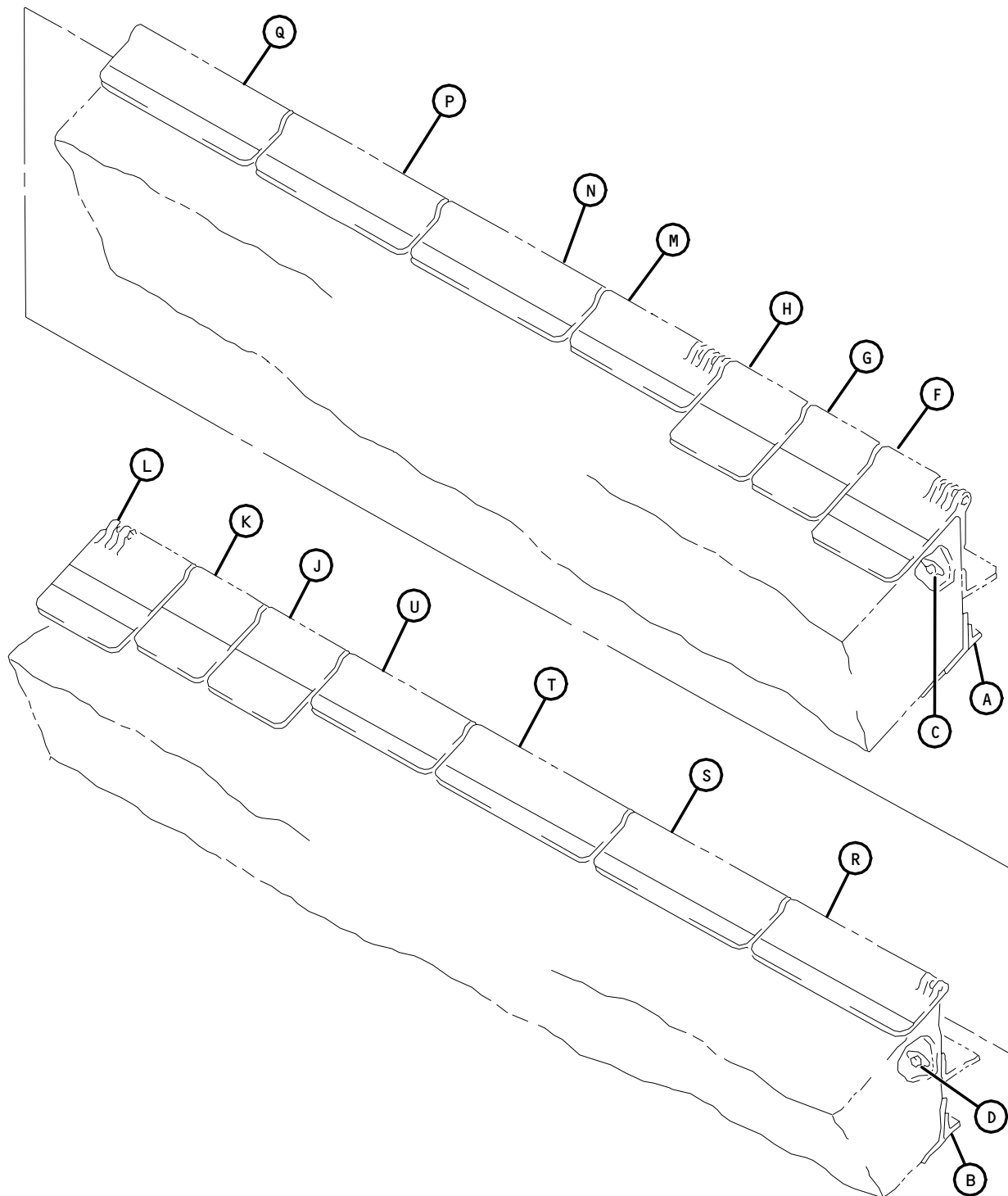
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
R R R	05- 30 35 40	143T6347-4 143T6347-3 143T6346-1	..FILLER ..DOUBLER .WINDOW		1 1 2

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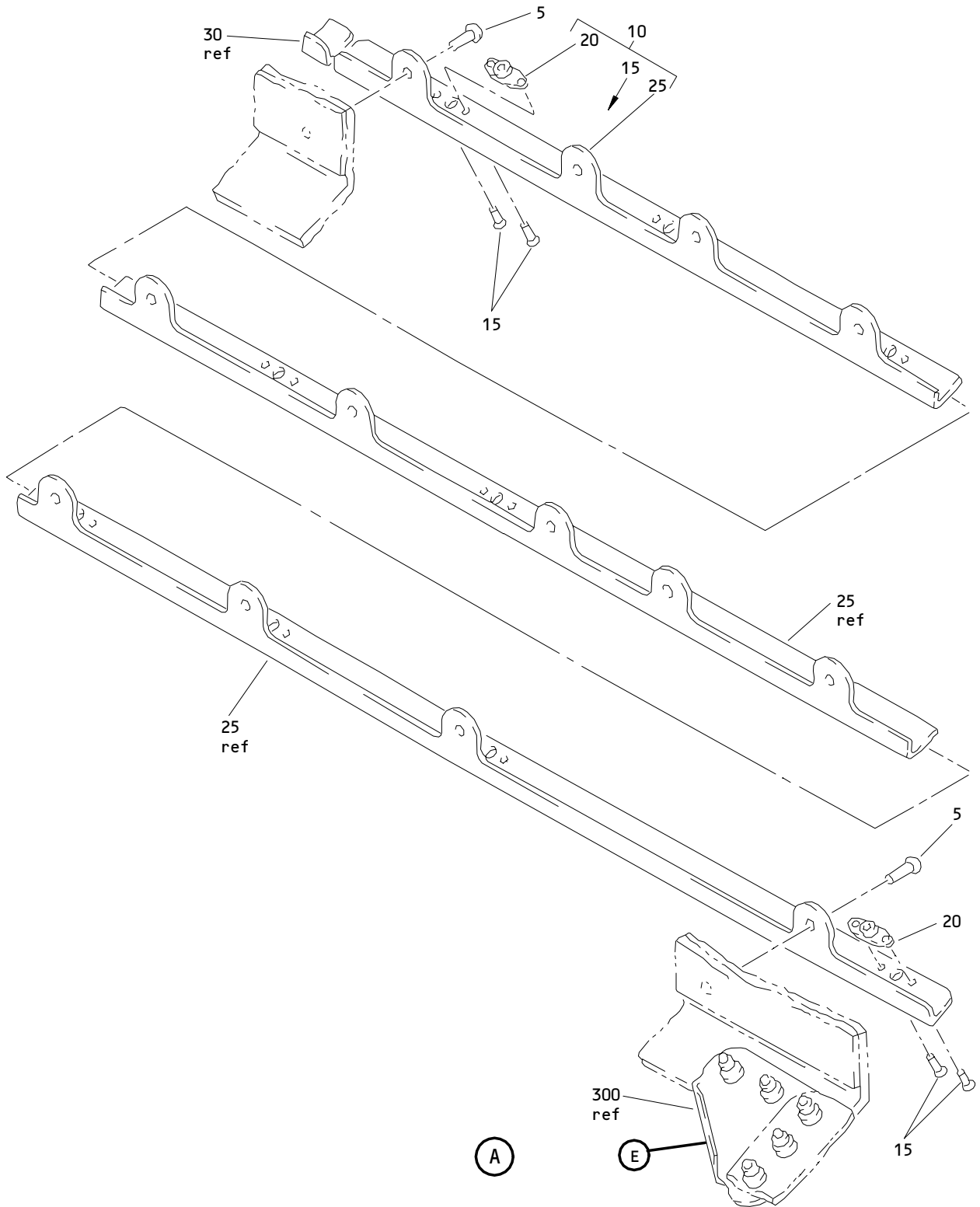
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 1)

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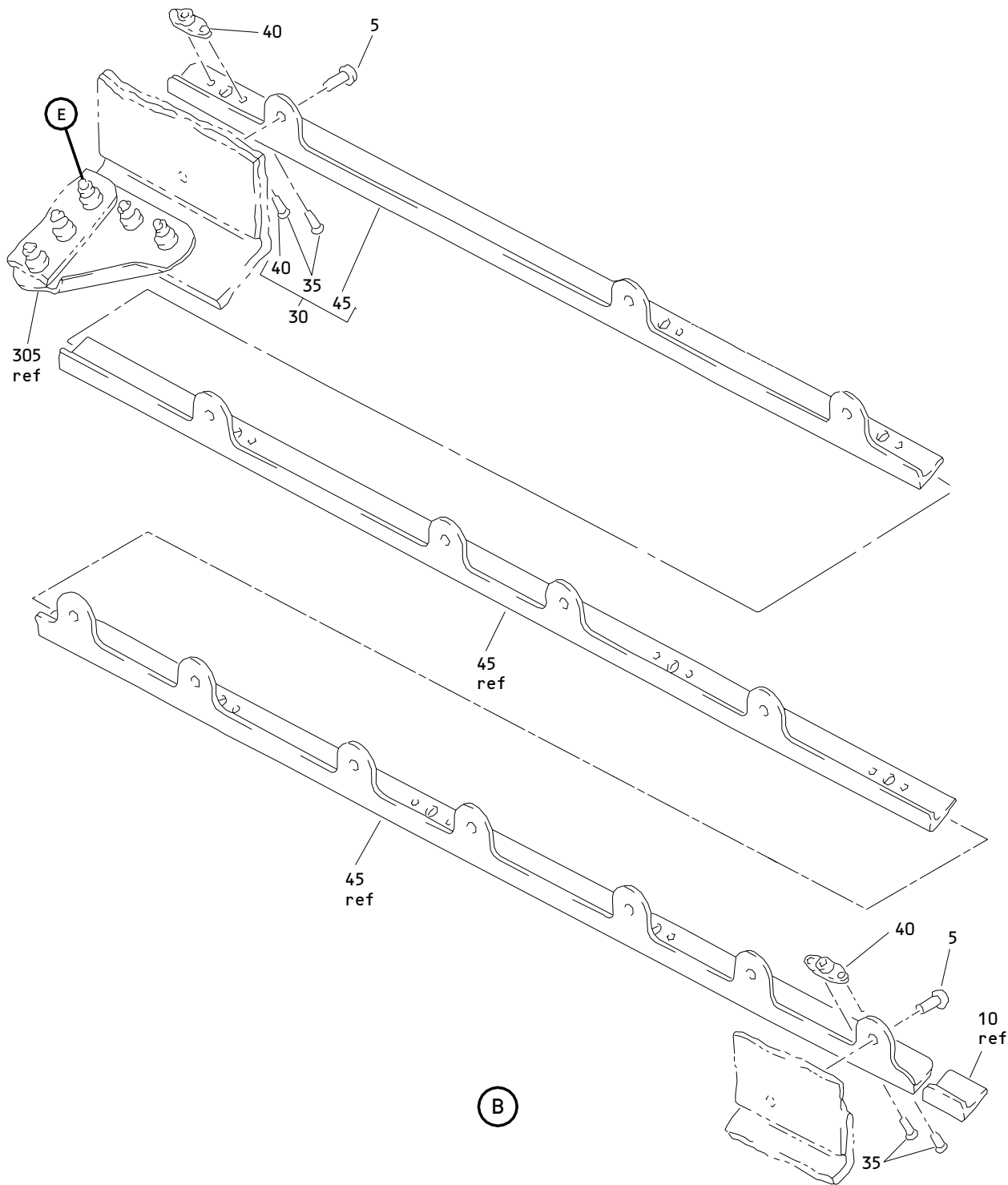
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 2)

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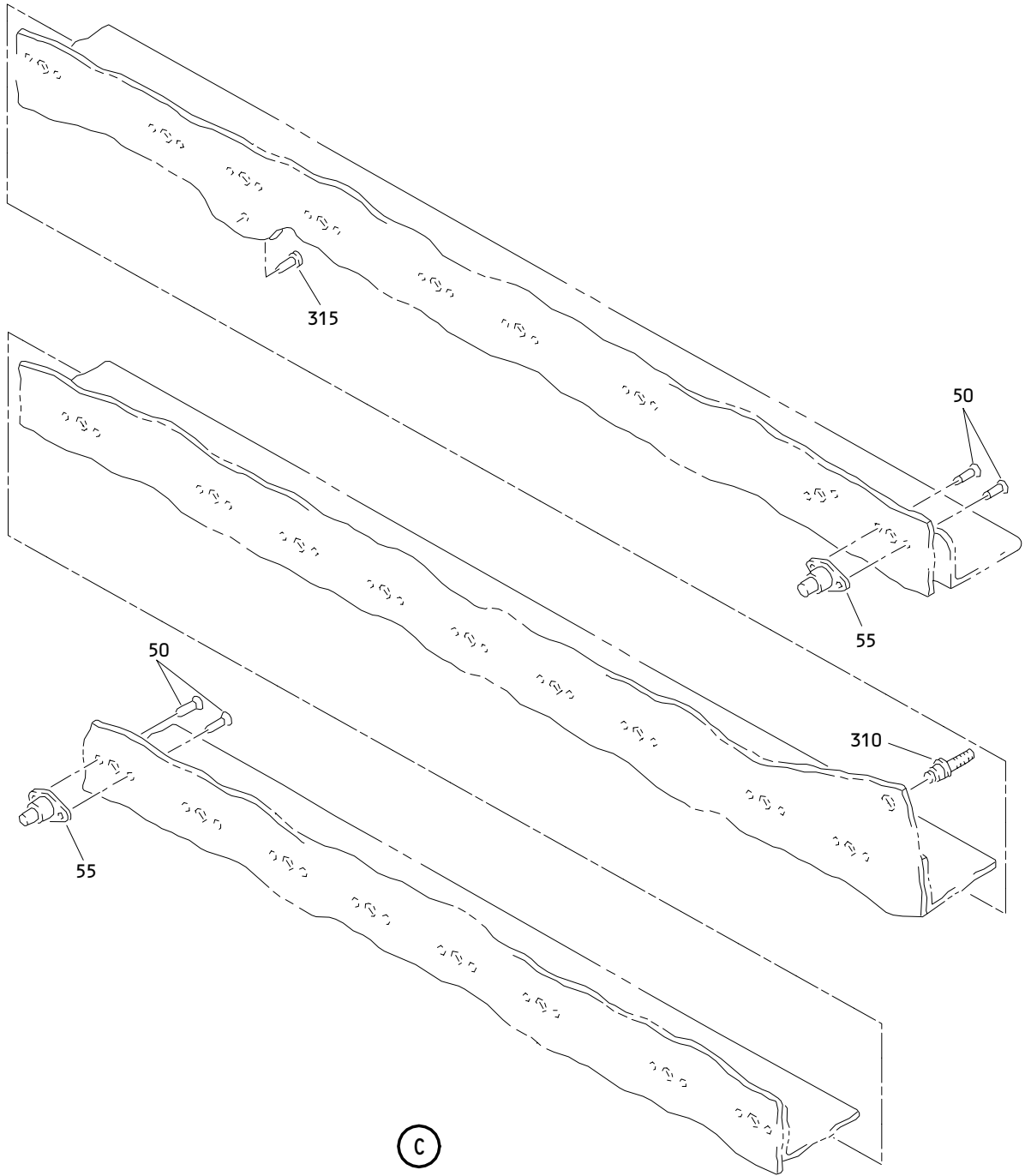
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 3)

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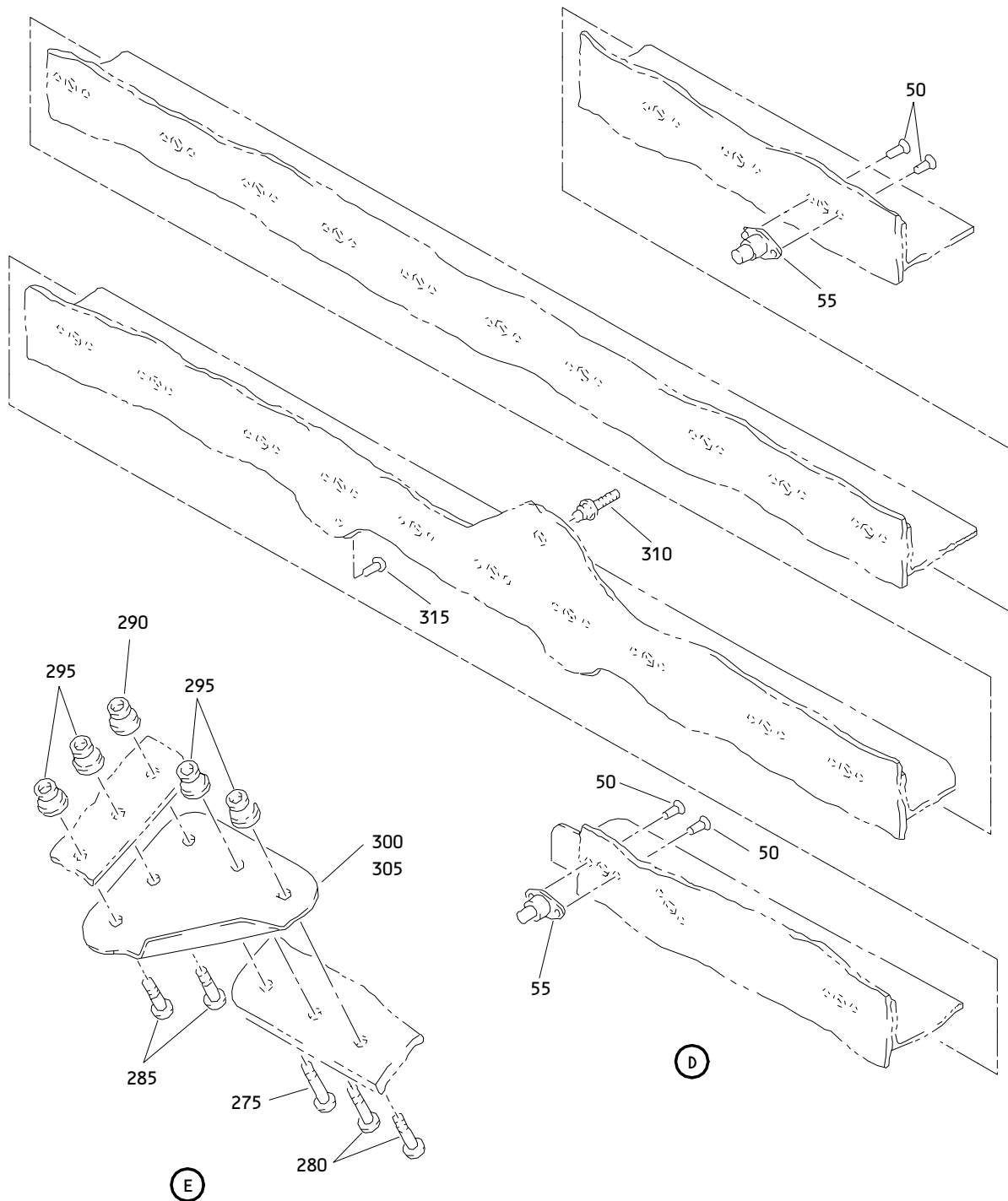
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 4)

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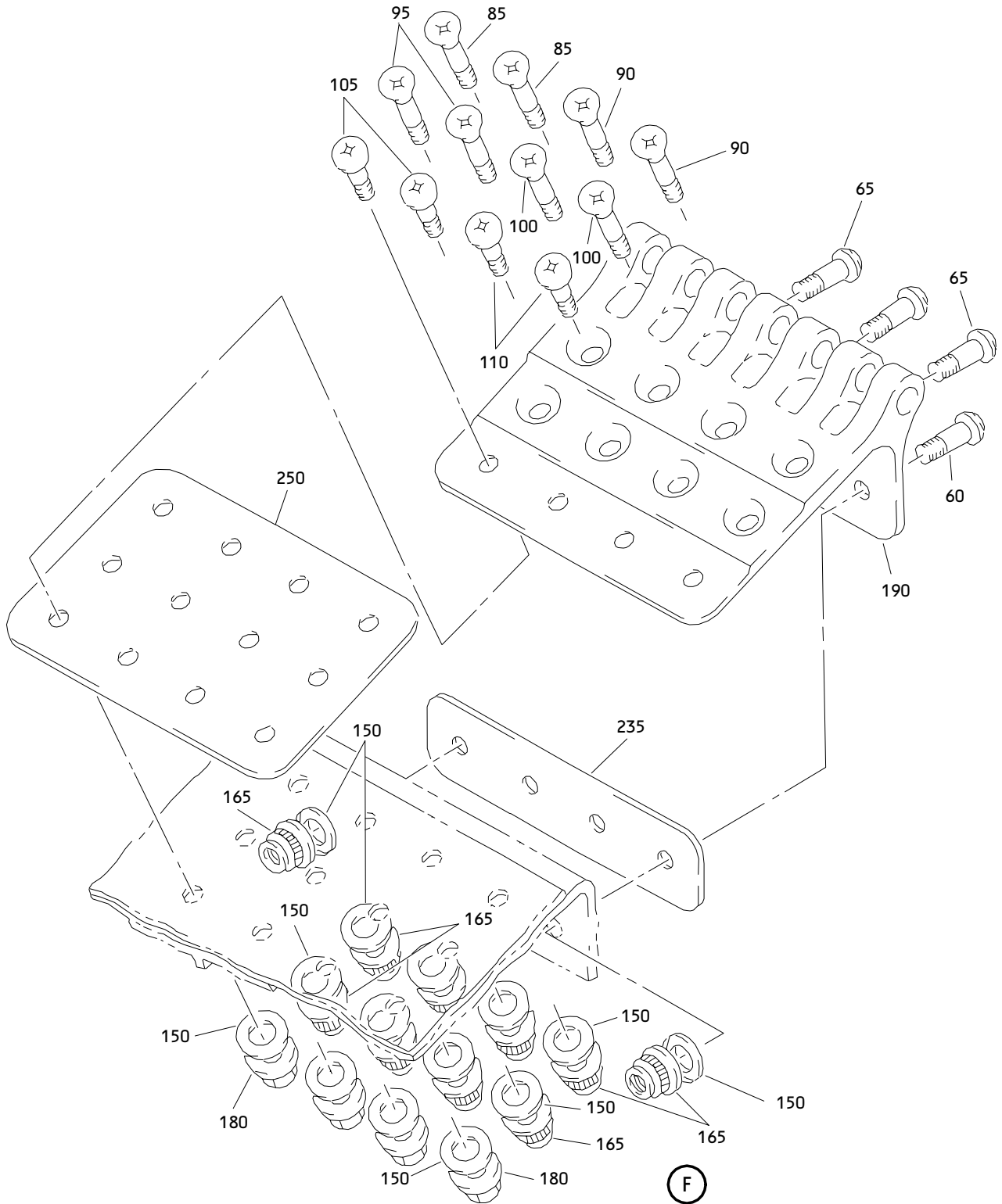
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Main Deck Cargo Door Upper Beam Installation
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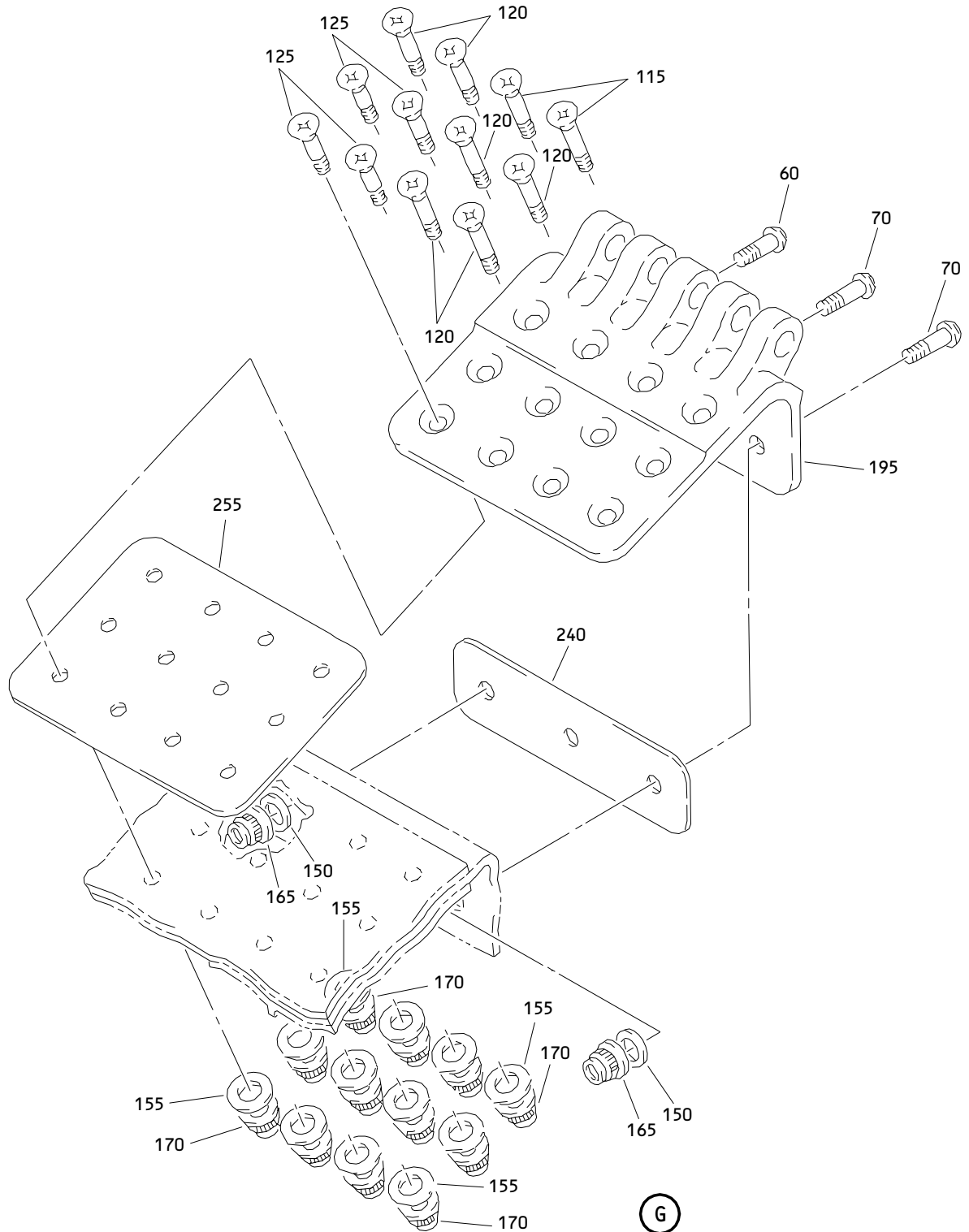
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 6)

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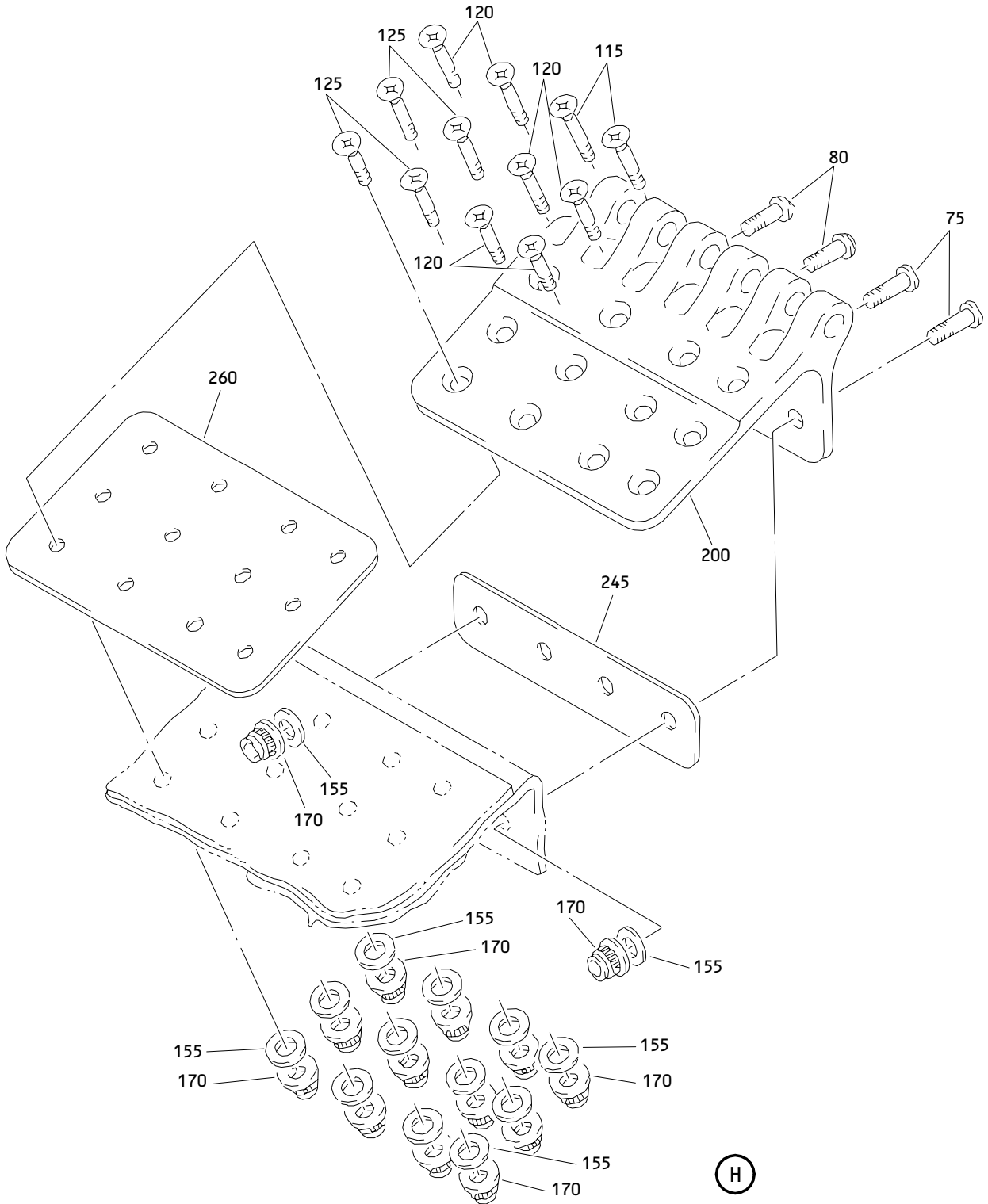
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 7)

52-32-04

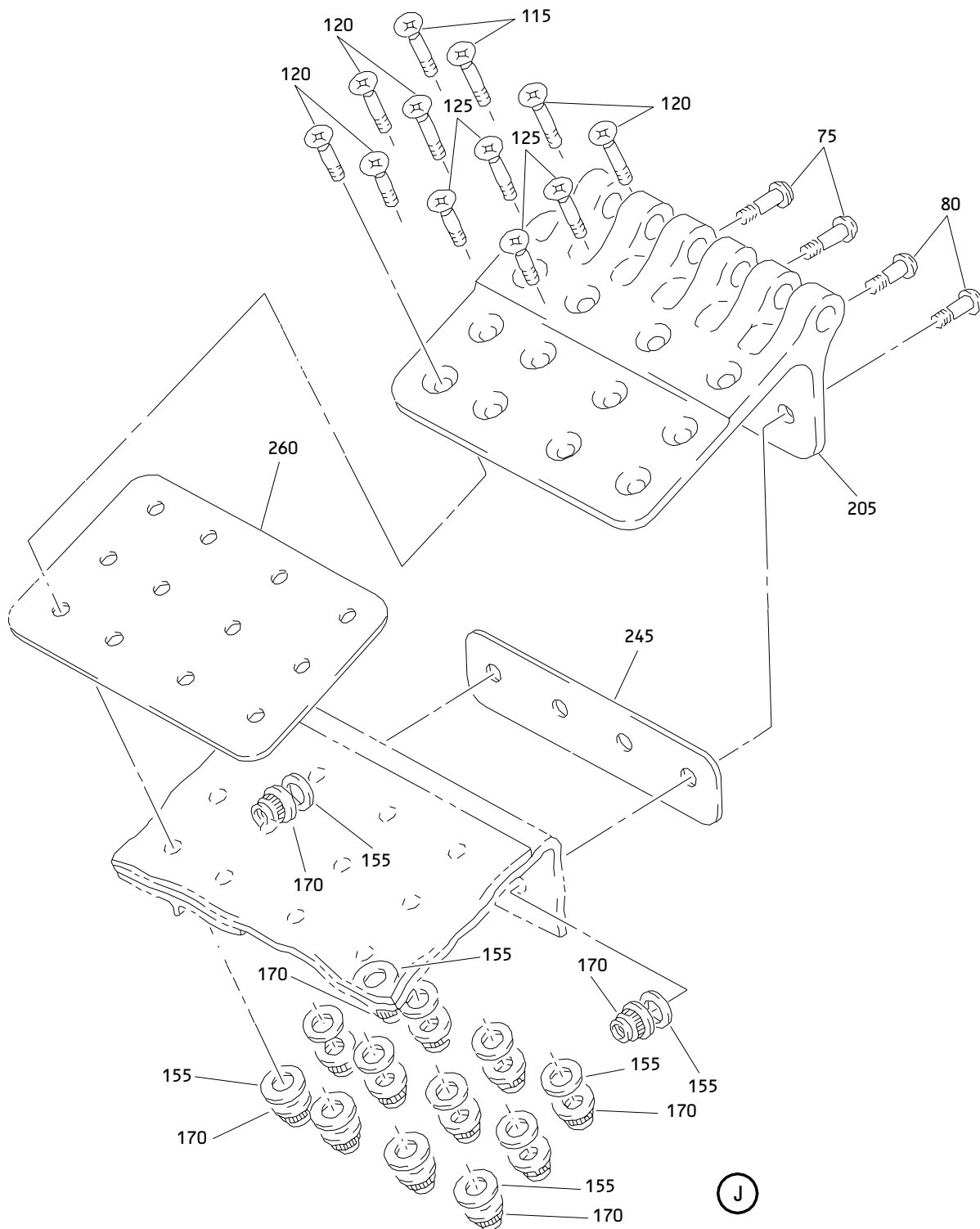
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 8)

52-32-04

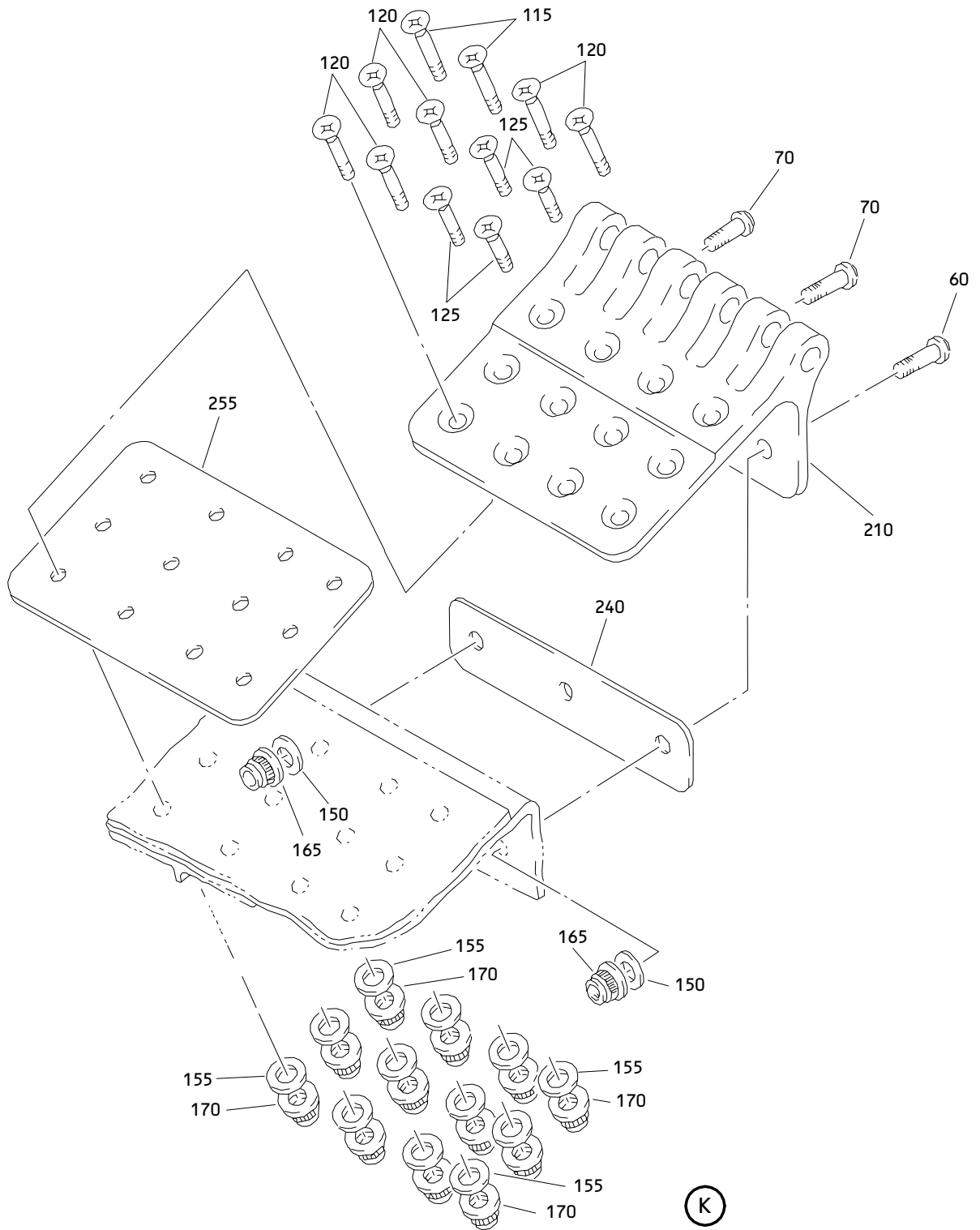
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 9)

52-32-04

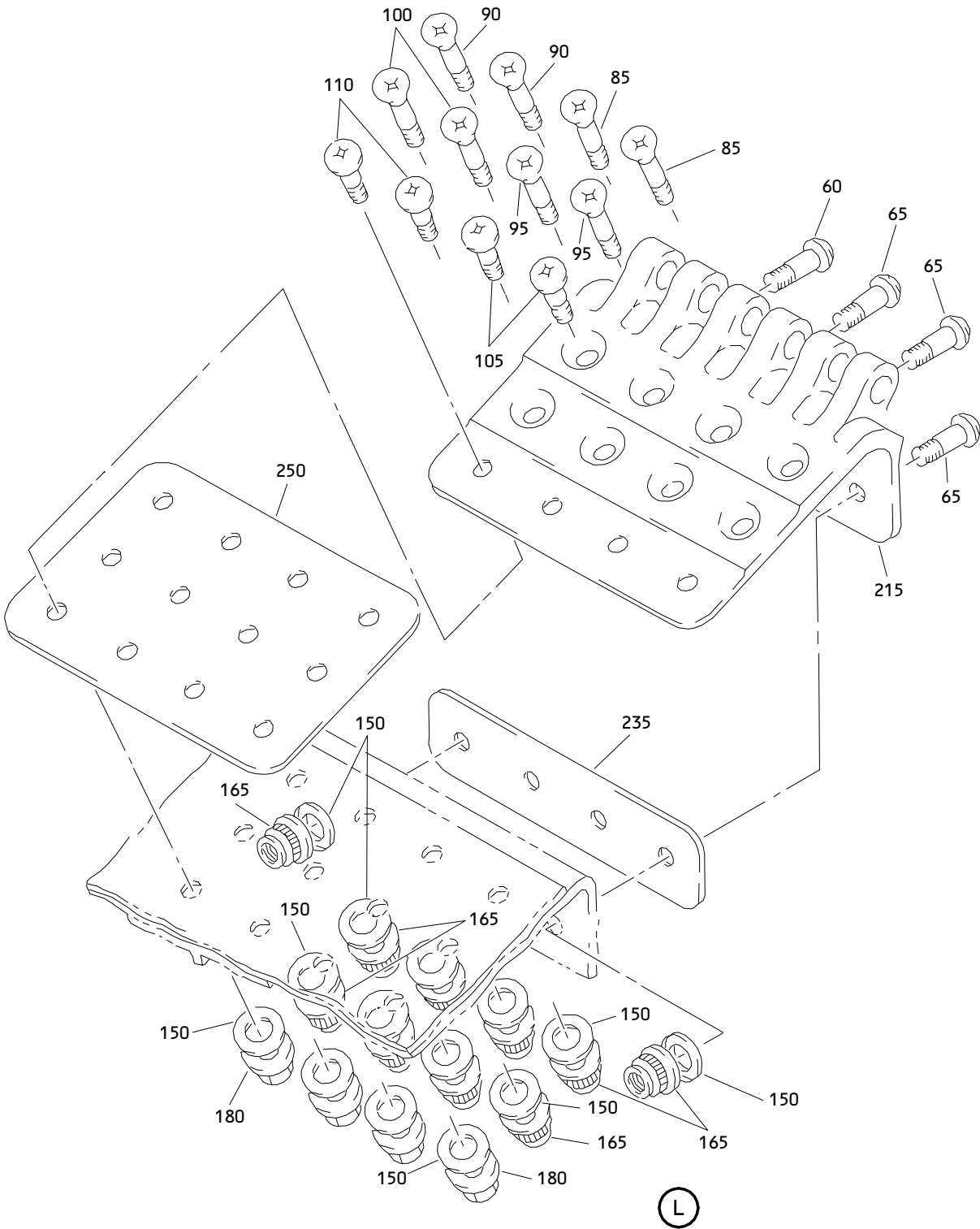
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 10)

52-32-04

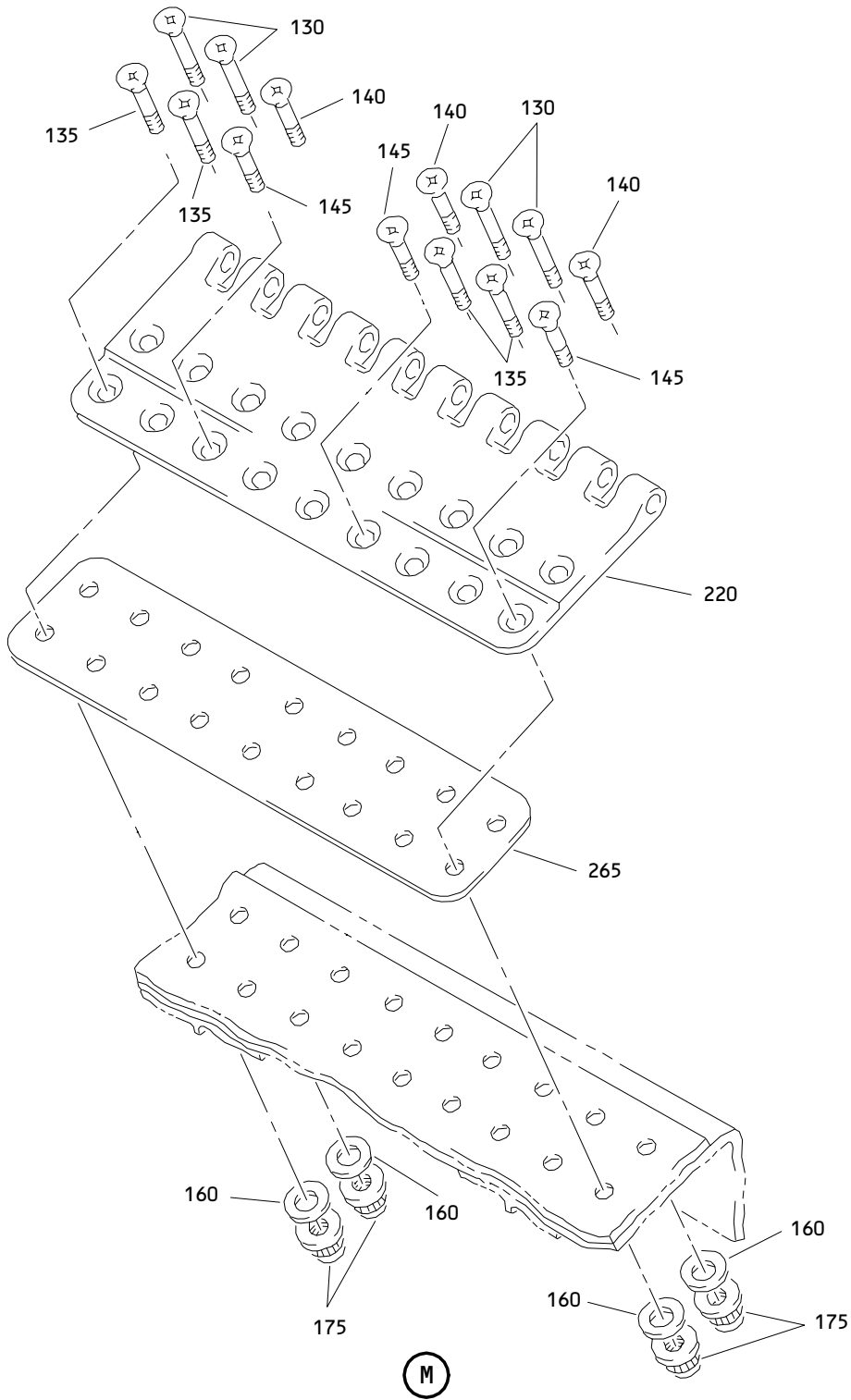
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 11)

52-32-04

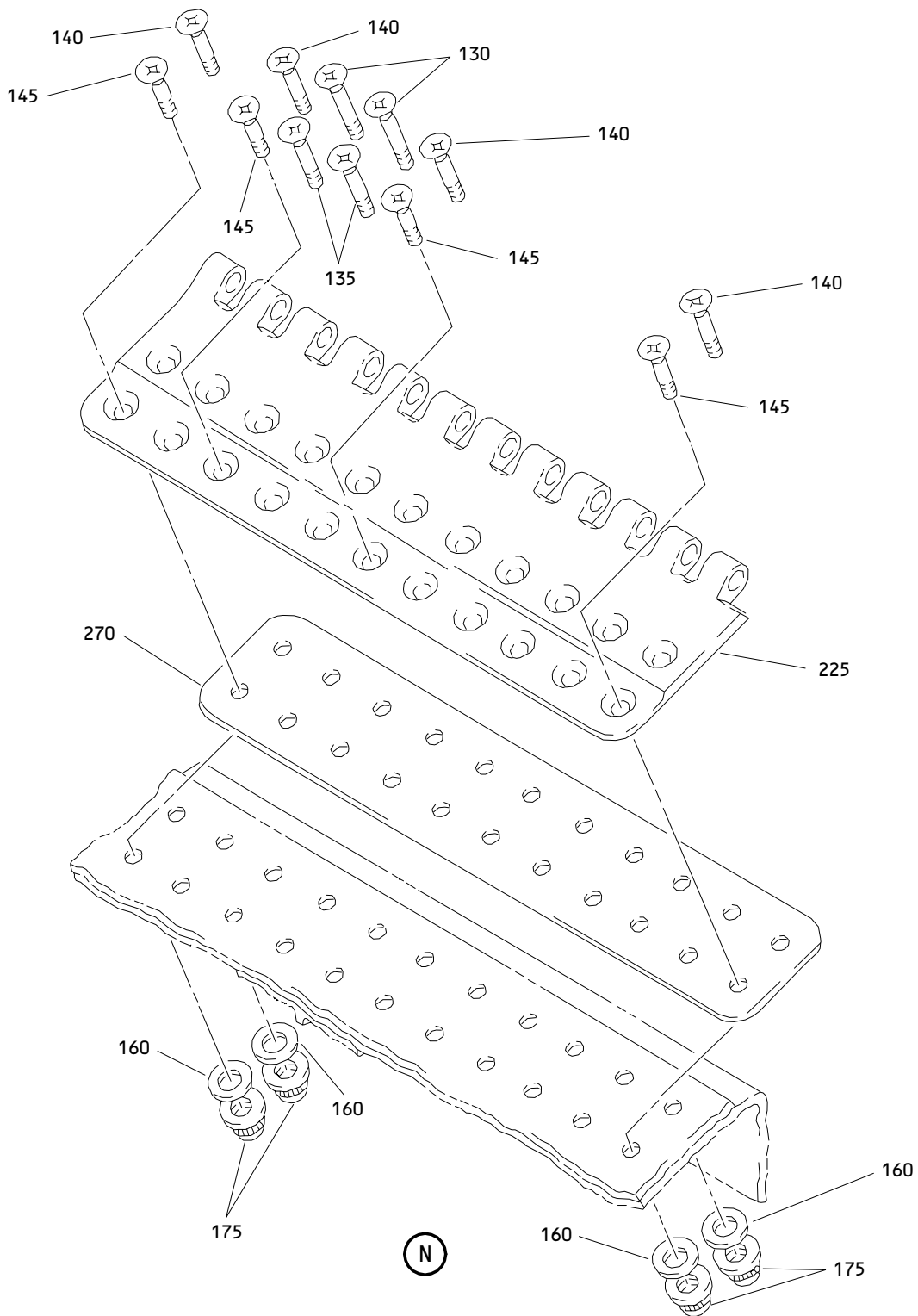
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 12)

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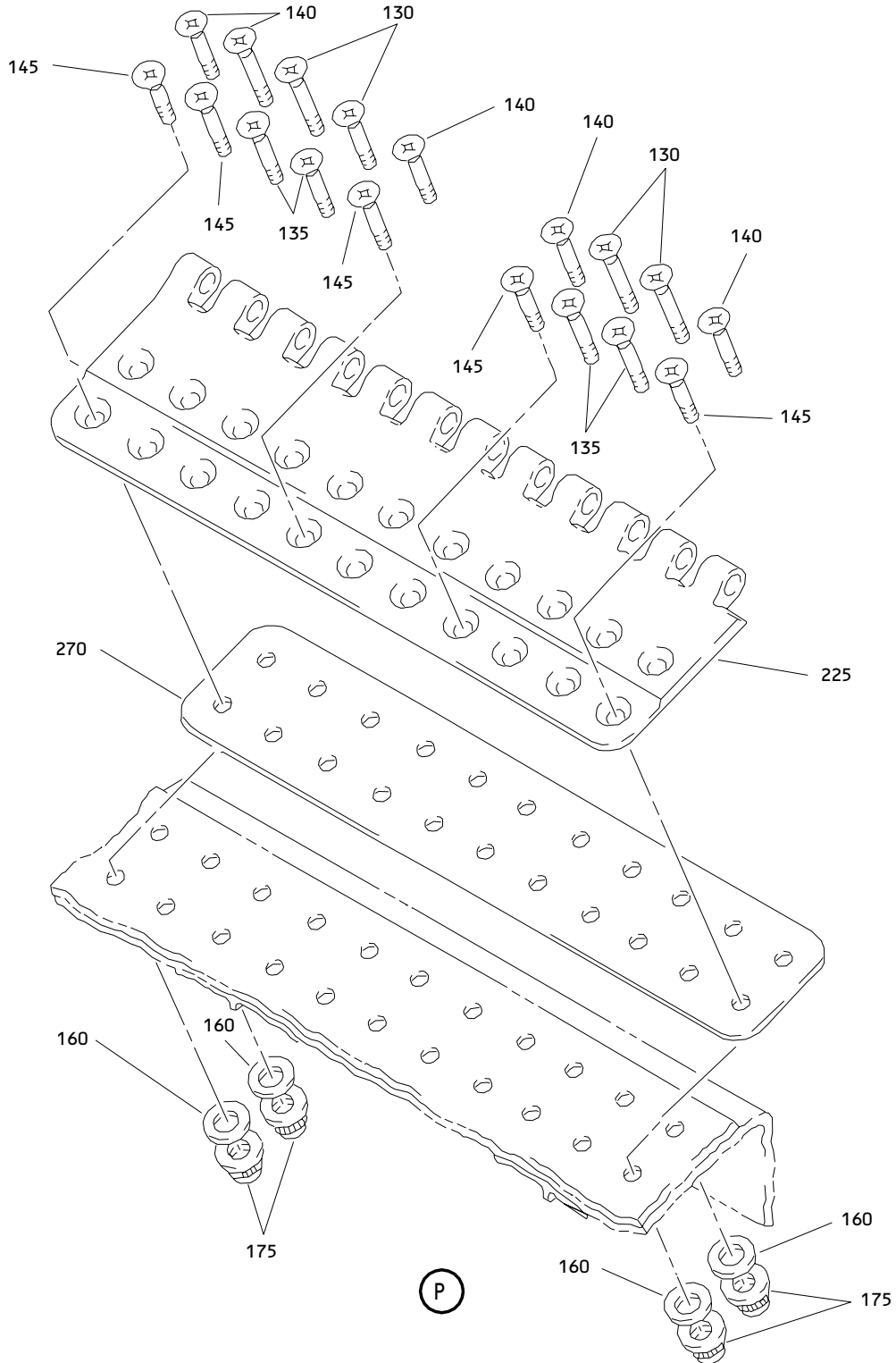
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 13)

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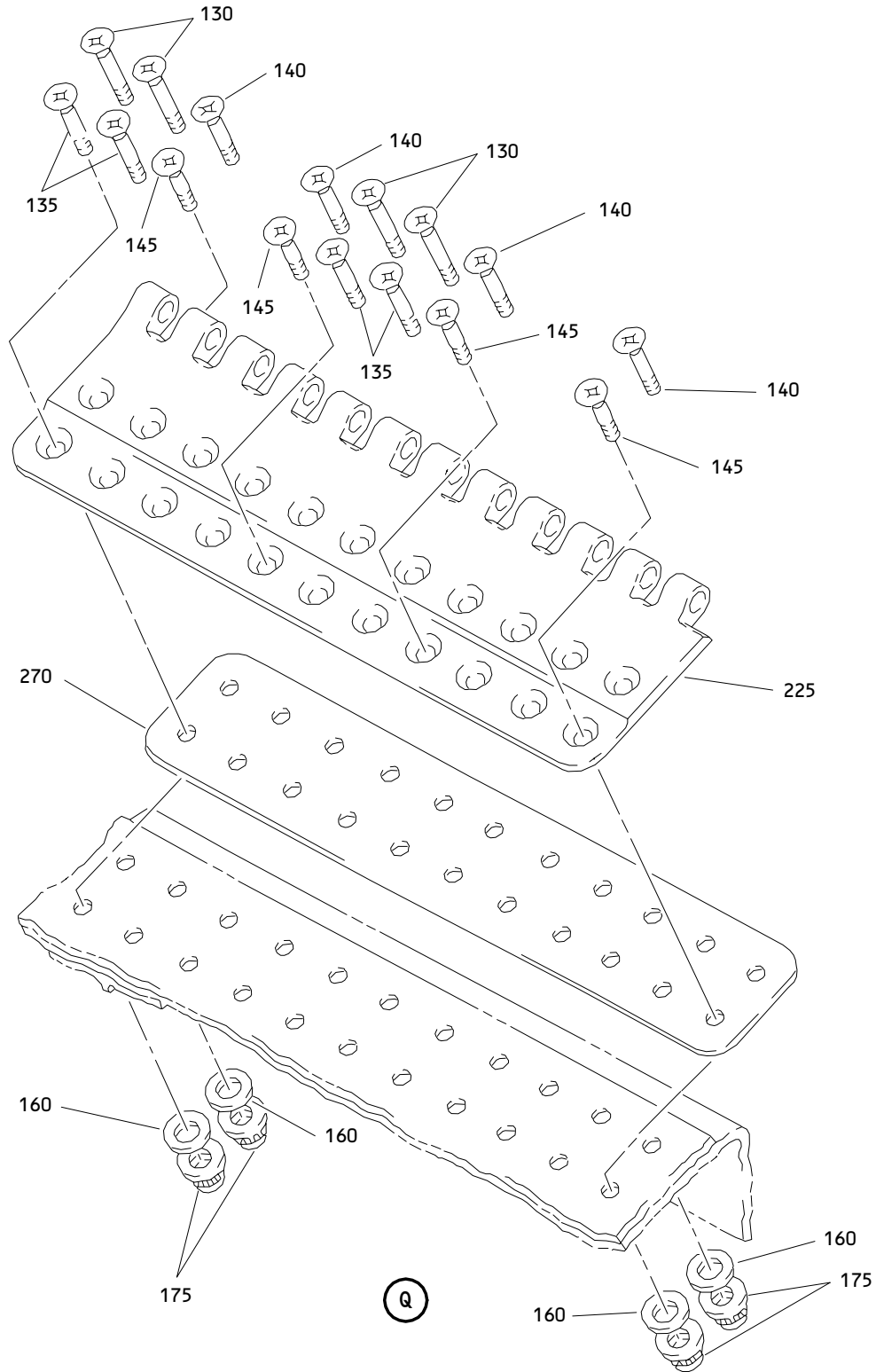
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 14)

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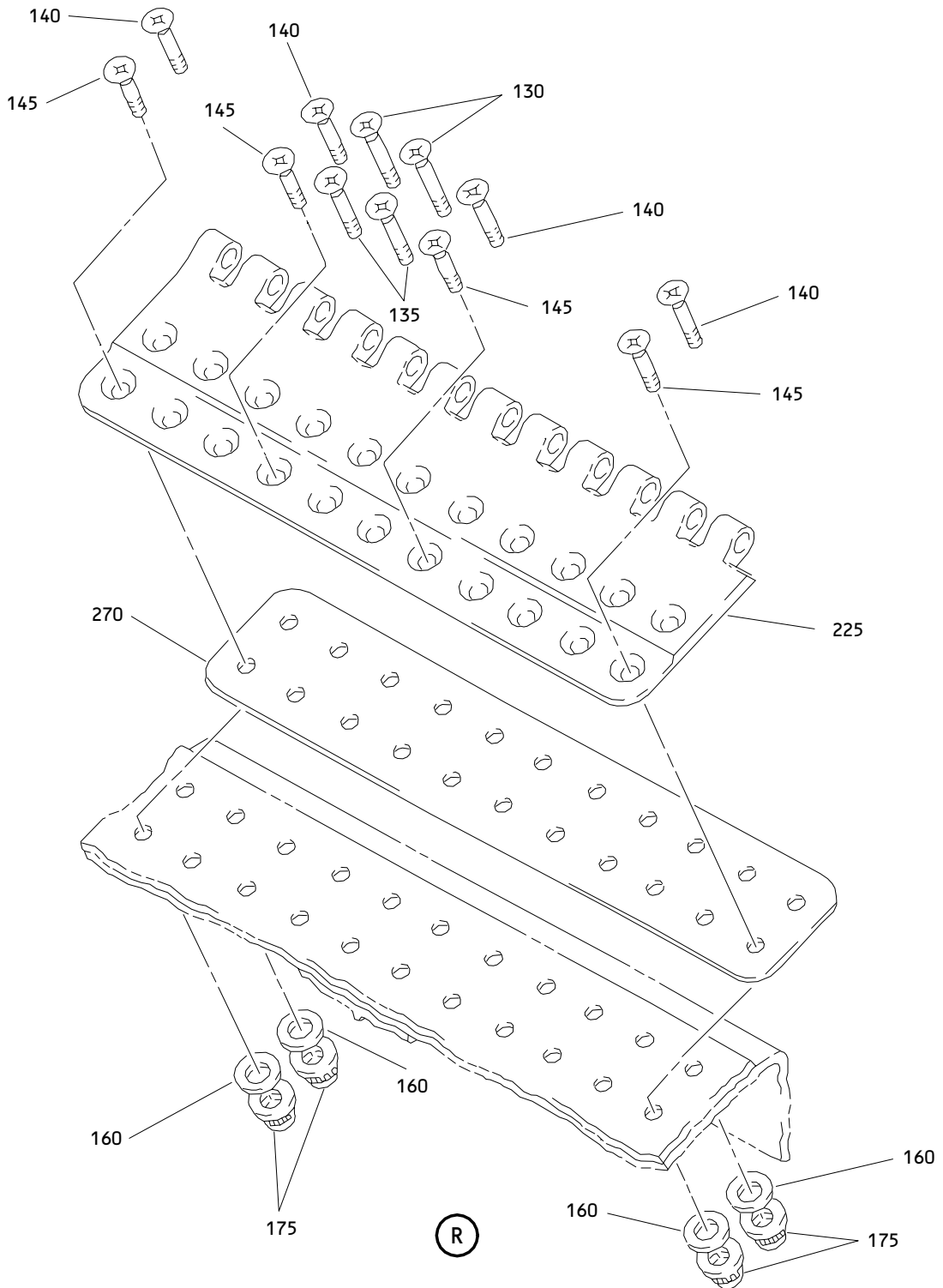
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 15)

52-32-04

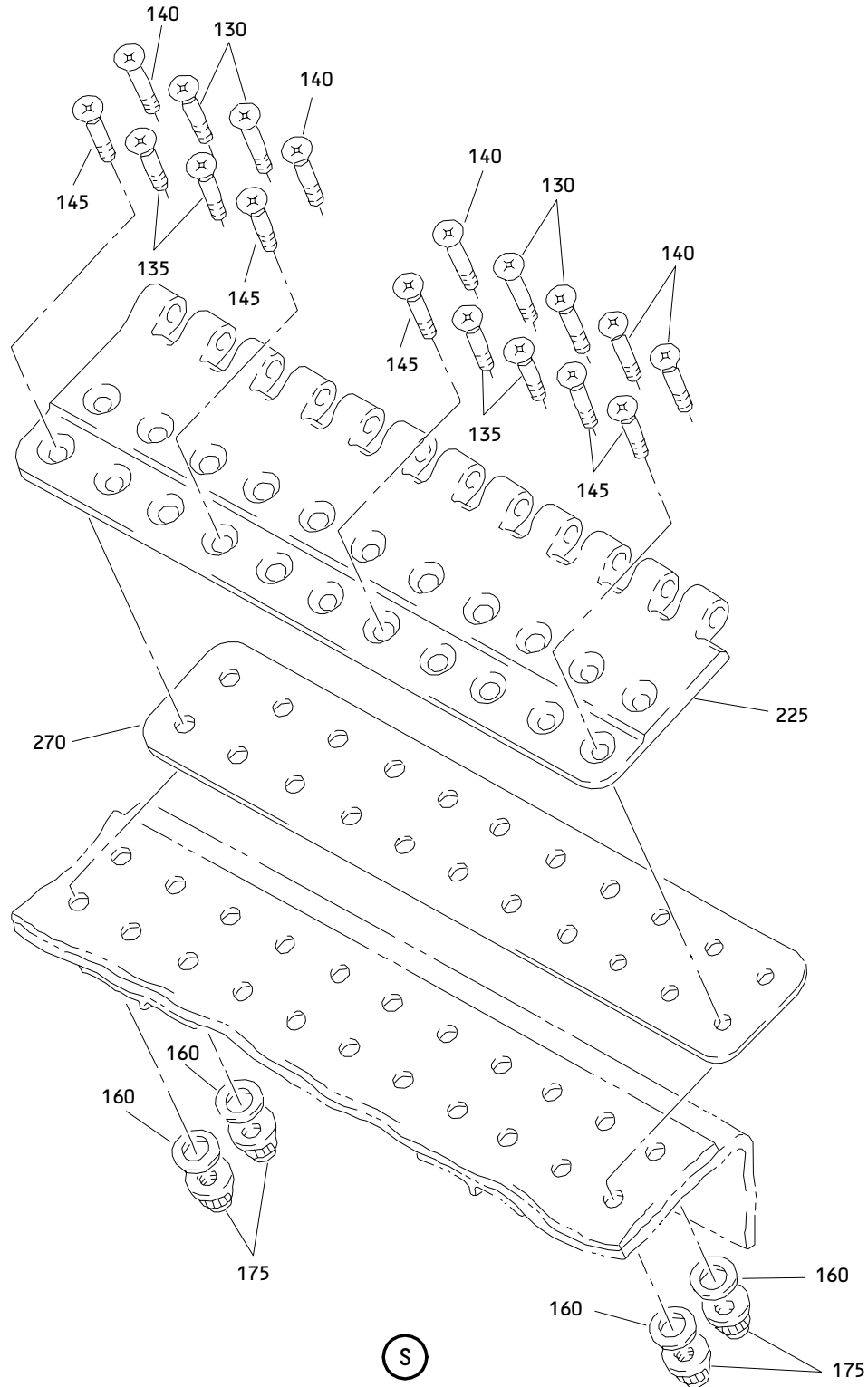
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 16)

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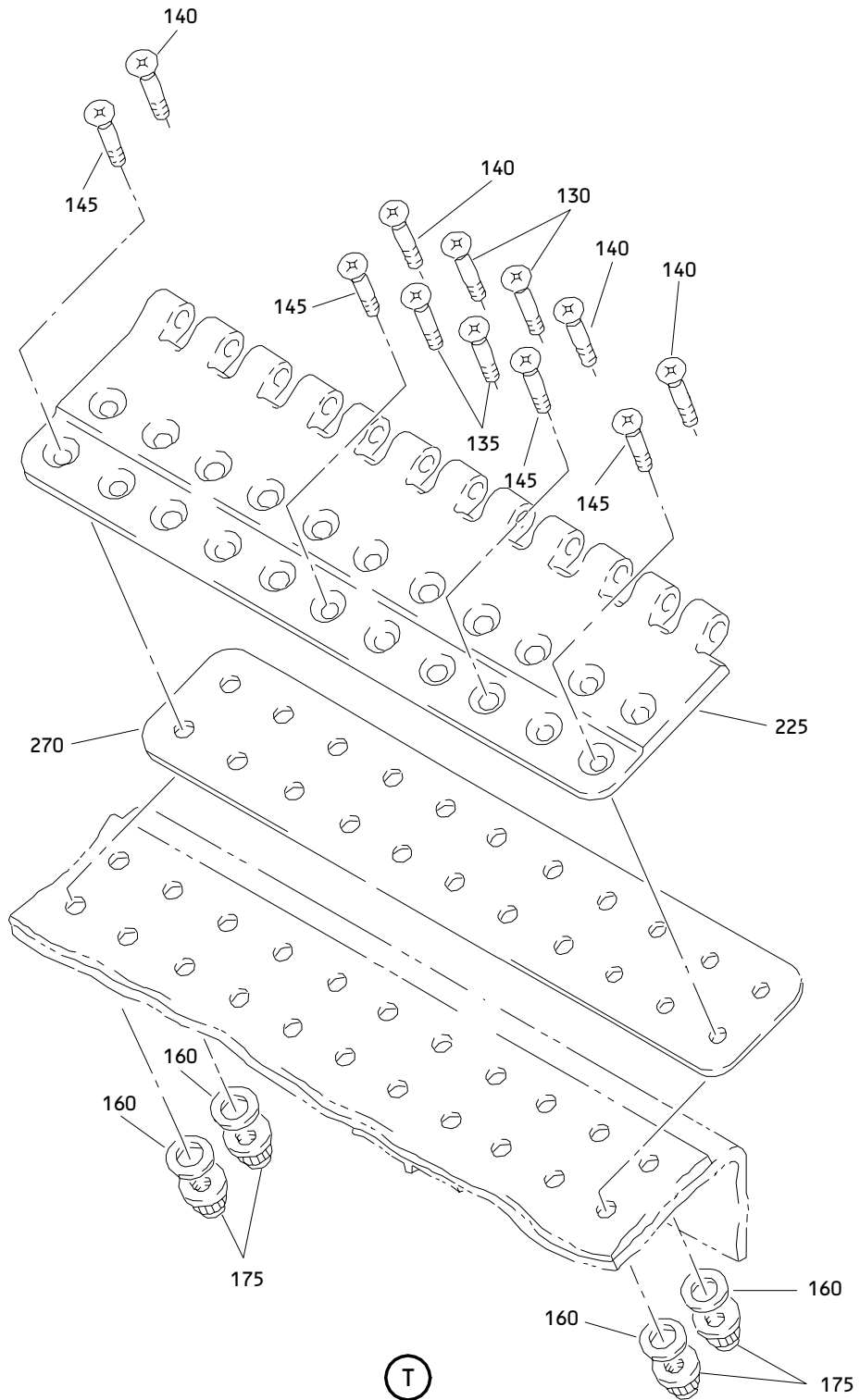
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 17)

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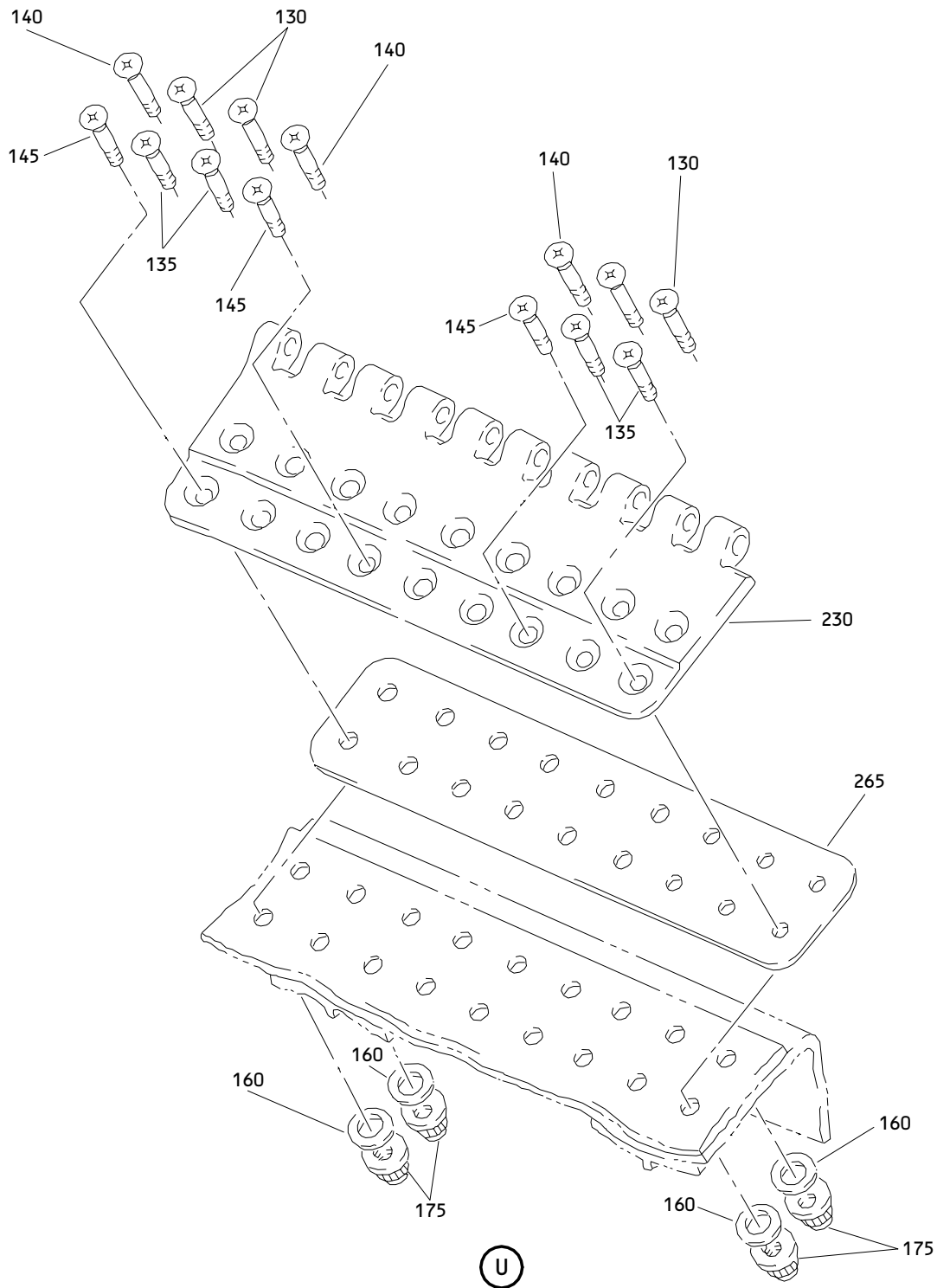
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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 18)

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Main Deck Cargo Door Upper Beam Installation
Figure 6 (Sheet 19)

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 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 06-					
R -1A	143T6258-1		BEAM INSTL-UPR	A	RF
R 5	BACR15FT6KE		.RIVET-	A	27
			(SIZE DETERMINE ON INST)		
R 10	453T7034-51		.SUPPORT ASSY-SIDEWALL	A	1
R 15	BACR15BA3AD		..RIVET-	A	18
			(SIZE DETERMINE ON INST)		
R 20	BRF200C3D		..NUTPLATE-	A	9
			(V52828)		
			(SPEC BACN10JR3CFD)		
			(OPT K51602-3BAC		
			(V15653))		
			(OPT NS202476-02		
			(V80539))		
			(OPT 102F9201-3		
			(V72962))		
			(OPT T8092C1032CD		
			(V11815))		
R 25	453T7034-52		..ANGLE	A	1
R 30	453T7034-43		.SUPPORT ASSY-SIDEWALL	A	1
R 35	BACR15BA3AD		..RIVET-	A	20
			(SIZE DETERMINE ON INST)		
R 40	BRF200C3D		..NUTPLATE-	A	10
			(V52828)		
			(SPEC BACN10JR3CFD)		
			(OPT K51602-3BAC		
			(V15653))		
			(OPT NS202476-02		
			(V80539))		
			(OPT 102F9201-3		
			(V72962))		
			(OPT T8092C1032CD		
			(V11815))		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 06-45	453T7034-44		. . ANGLE	A	1
R 50	BACR15CE3AD		. RIVET- (SIZE DETERMINE ON INST)	A	104
R 55	F51645-3BAC		. NUTPLATE- (V15653) (SPEC BACN10JZ3A4CDM) (OPT 102F9221-3 (V72962)) (OPT NS202492A02 (V80539))	A	52
R 60	HL1012AZ12-7		. BOLT- (VOPTK6) (SPEC BACB30NX12K7) (OPT HL12VAZ12-7 (V73197)) (OPT HL12VAZ12-7 (V92215)) (OPT HL12VAZ12-7 (V97928)) (OPT L802-12K7 (V06725)) (OPT HL12VAZ12-7 (V56878)) (OPT HL1012AZ12-7 (V06725)) (OPT HL1012AZ12-7 (V06950)) (OPT HL1012AZ12-7 (V17446)) (OPT HL1012AZ12-7 (V56878)) (OPT HL1012AZ12-7 (V60516)) (OPT HL1012AZ12-7 (V73197)) (OPT HL1012AZ12-7 (V97928))	A	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 06-65	HL1012AZ12-10		.BOLT- (VOPTK6) (SPEC BACB30NX12K10) (OPT HL12VAZ12-10 (V73197)) (OPT HL12VAZ12-10 (V92215)) (OPT HL12VAZ12-10 (V97928)) (OPT L802-12K10 (V06725)) (OPT HL12VAZ12-10 (V56878)) (OPT HL1012AZ12-10 (V06725)) (OPT HL1012AZ12-10 (V06950)) (OPT HL1012AZ12-10 (V17446)) (OPT HL1012AZ12-10 (V56878)) (OPT HL1012AZ12-10 (V60516)) (OPT HL1012AZ12-10 (V73197)) (OPT HL1012AZ12-10 (V97928))	A	6

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 06-70	HL1012AZ12-9		.BOLT- (VOPTK6) (SPEC BACB30NX12K9) (OPT HL12VAZ12-9 (V73197)) (OPT HL12VAZ12-9 (V92215)) (OPT HL12VAZ12-9 (V97928)) (OPT L802-12K9 (V06725)) (OPT HL12VAZ12-9 (V56878)) (OPT HL1012AZ12-9 (V06725)) (OPT HL1012AZ12-9 (V06950)) (OPT HL1012AZ12-9 (V17446)) (OPT HL1012AZ12-9 (V56878)) (OPT HL1012AZ12-9 (V60516)) (OPT HL1012AZ12-9 (V73197)) (OPT HL1012AZ12-9 (V97928))	A	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
R 06-75	HL1012AZ10-9		1234567 .BOLT- (VOPTK6) (SPEC BACB30NX10K9) (OPT HL12VAZ10-9 (V73197)) (OPT HL12VAZ10-9 (V92215)) (OPT HL12VAZ10-9 (V97928)) (OPT L802-10K9 (V06725)) (OPT HL12VAZ10-9 (V56878)) (OPT HL1012AZ10-9 (V06725)) (OPT HL1012AZ10-9 (V06950)) (OPT HL1012AZ10-9 (V17446)) (OPT HL1012AZ10-9 (V56878)) (OPT HL1012AZ10-9 (V60516)) (OPT HL1012AZ10-9 (V73197)) (OPT HL1012AZ10-9 (V97928))	A	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 06-80	HL1012AZ10-7		.BOLT- (VOPTK6) (SPEC BACB30NX10K7) (OPT HL12VAZ10-7 (V73197)) (OPT HL12VAZ10-7 (V92215)) (OPT HL12VAZ10-7 (V97928)) (OPT L802-10K7 (V06725)) (OPT HL12VAZ10-7 (V56878)) (OPT HL1012AZ10-7 (V06725)) (OPT HL1012AZ10-7 (V06950)) (OPT HL1012AZ10-7 (V17446)) (OPT HL1012AZ10-7 (V56878)) (OPT HL1012AZ10-7 (V60516)) (OPT HL1012AZ10-7 (V73197)) (OPT HL1012AZ10-7 (V97928))	A	4
R 85	BACB30NN6K15		.BOLT	A	4
R 90	BACB30NN6K12		.BOLT	A	4
R 95	BACB30NN6K14		.BOLT	A	4
R 100	BACB30NN6K10		.BOLT	A	4
R 105	BACB30NT6K13		.BOLT	A	4
R 110	BACB30NT6K9		.BOLT	A	4
R 115	BACB30NN5K13		.BOLT	A	8
R 120	BACB30NN5K11		.BOLT	A	24
R 125	BACB30NN5K9		.BOLT	A	16
R 130	BACB30NN4K12		.BOLT	A	26
R 135	BACB30NN4K11		.BOLT	A	26
R 140	BACB30NN4K10		.BOLT	A	58
R 145	BACB30NN4K9		.BOLT	A	58
R 150	BACW10BP6DP		.WASHER	A	38
R 155	BACW10BP5DP		.WASHER	A	56
R 160	BACW10BP4DP		.WASHER	A	168
R 165	NAS1804-6		.NUT	A	30
R 170	NAS1804-5		.NUT	A	56

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 06-175	NAS1804-4		.NUT	A	168
R 180	H52732-6CD		.NUT- (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))	A	8
R -185	143T6258-5001		.COLLECTOR INSTL- (LIMITED)	A	1
R -185A	143T6258-5002		.COLLECTOR INSTL- (LIMITED)	A	1
R 190	143T6263-5		..FITTING-HINGE (USED ON ITEM 185)	A	1
R -190A	143T6263-10		..FITTING-HINGE (USED ON ITEM 185A)	A	1
R 195	143T6263-4		..FITTING-HINGE	A	1
R 200	143T6263-6		..FITTING-HINGE (USED ON ITEM 185)	A	1
R -200A	143T6263-7		..FITTING-HINGE (USED ON ITEM 185A)	A	1
R 205	143T6263-3		..FITTING-HINGE (USED ON ITEM 185)	A	1
R -205A	143T6263-9		..FITTING-HINGE (USED ON ITEM 185A)	A	1
R 210	143T6263-2		..FITTING-HINGE	A	1
R 215	143T6263-1		..FITTING-HINGE (USED ON ITEM 185)	A	1
R -215A	143T6263-8		..FITTING-HINGE (USED ON ITEM 185A)	A	1
R 220	143T6262-3		.FITTING-HINGE	A	1
R 225	143T6262-2		.FITTING-HINGE	A	6
R 230	143T6262-1		.FITTING-HINGE	A	1
R 235	143T6258-25		.SHIM-LAMINATED	A	2
R 240	143T6258-26		.SHIM-LAMINATED	A	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 06-245	143T6258-27		.SHIM-LAMINATED	A	2
R 250	143T6258-20		.SHIM-LAMINATED	A	2
R 255	143T6258-21		.SHIM-LAMINATED	A	2
R 260	143T6258-22		.SHIM-LAMINATED	A	2
R 265	143T6258-23		.SHIM-LAMINATED	A	2
R 270	143T6258-24		.SHIM-LAMINATED	A	6
R 275	HL1012AZ8-5		.BOLT- (VOPTK6) (SPEC BACB30NX8K5) (OPT HL12VAZ8-5 (V73197)) (OPT HL12VAZ8-5 (V92215)) (OPT HL12VAZ8-5 (V97928)) (OPT L802-8K5 (V06725)) (OPT HL12VAZ8-5 (V56878)) (OPT HL1012AZ8-5 (V06725)) (OPT HL1012AZ8-5 (V06950)) (OPT HL1012AZ8-5 (V17446)) (OPT HL1012AZ8-5 (V56878)) (OPT HL1012AZ8-5 (V60516)) (OPT HL1012AZ8-5 (V73197)) (OPT HL1012AZ8-5 (V97928))	A	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 06-280	HST10AG6-4		.BOLT- (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (VOPTK6))	A	4
R 285	HST10AG6-3		.BOLT- (VOPTK6) (SPEC BACB30VT6K3) (OPT HST10AG6-3 (V06725)) (OPT HST10AG6-3 (V56878)) (OPT HST10AG6-3 (V73197))	A	4
R 290	HL1187-8		.COLLAR- (V5M902) (SPEC BACC30X8) (OPT HL87-8 (V73197)) (OPT HL87-8 (V92215)) (OPT HL1187-8 (V56878)) (OPT HL1187-8 (V92215)) (OPT HL87-8 (V56878)) (OPT HL1187-8 (V73197))	A	2

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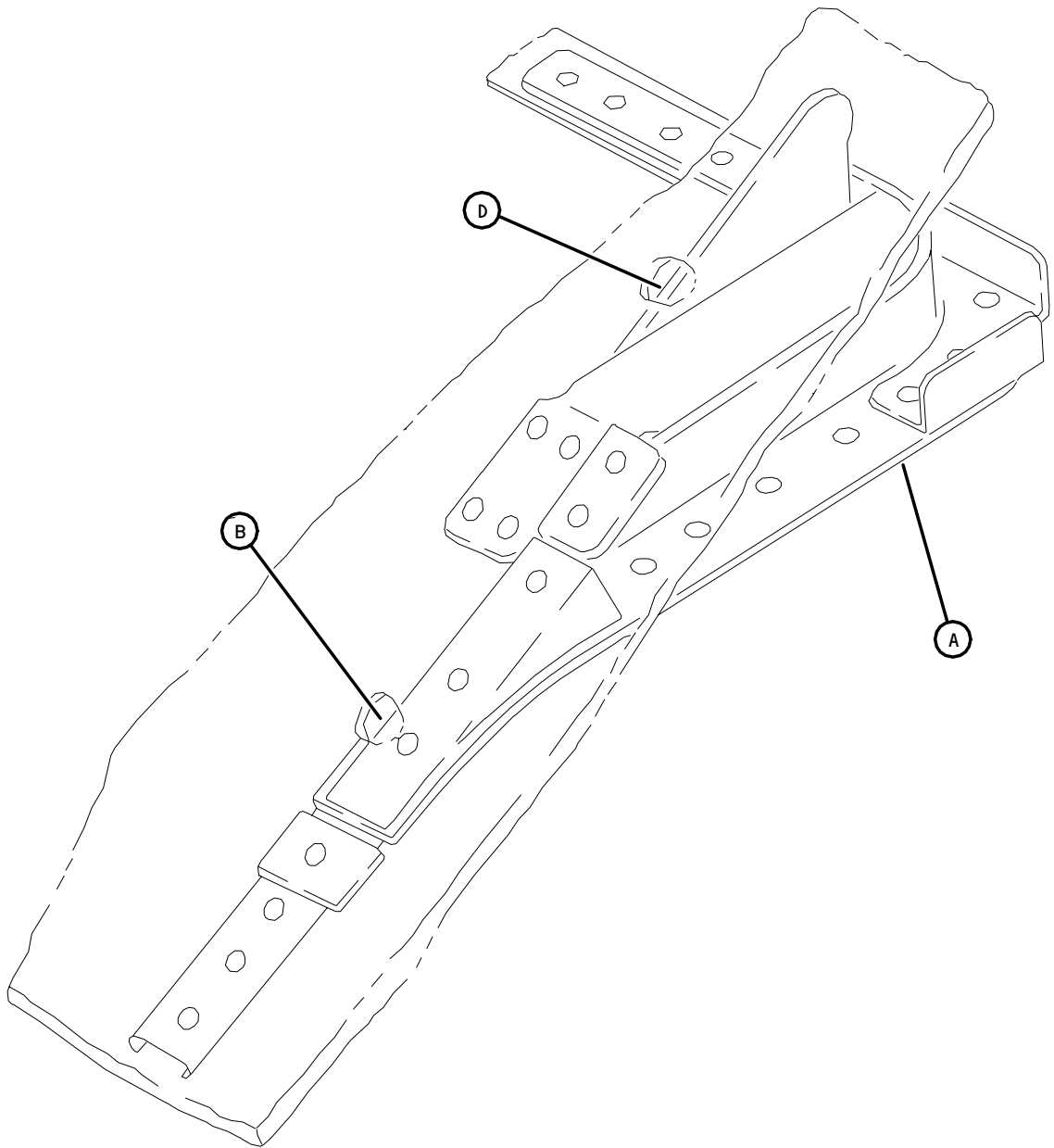
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 06-295	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))	A	8
R 300	143T6261-2		.GUSSET	A	1
R 305	143T6261-1		.GUSSET	A	1
R 310	VNS1924CA1-8		.STUD- (V5M902) (SPEC BACS53B1EA1) (OPT VNS1924CA3-1-8 (V92215))	A	2
R 315	BACR15BB8AD		.RIVET- (SIZE DETERMINE ON INST)	A	2

- Item Not Illustrated

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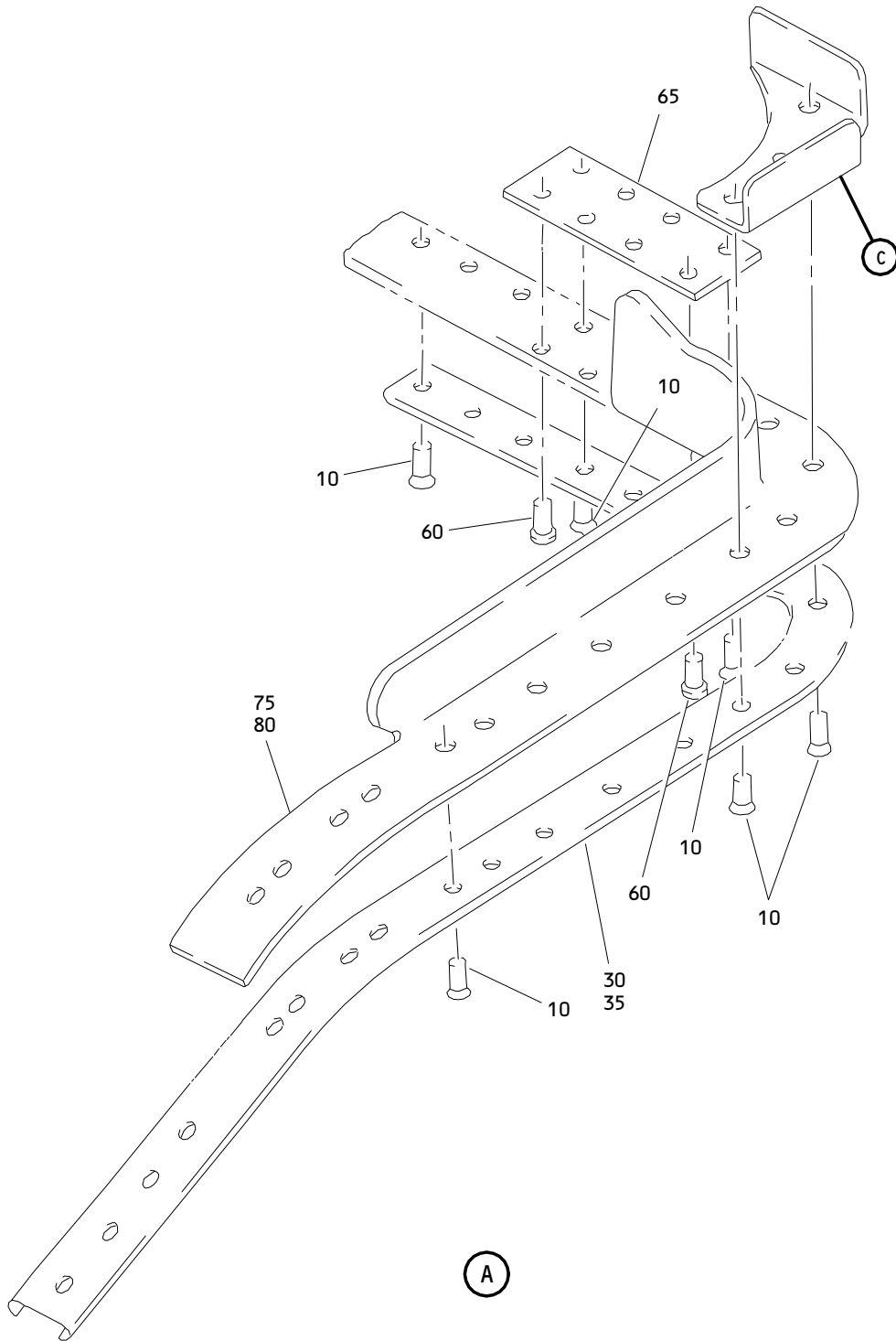
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Main Deck Cargo Door Upper Corner Pressure Seal Support Installation
Figure 7 (Sheet 1)

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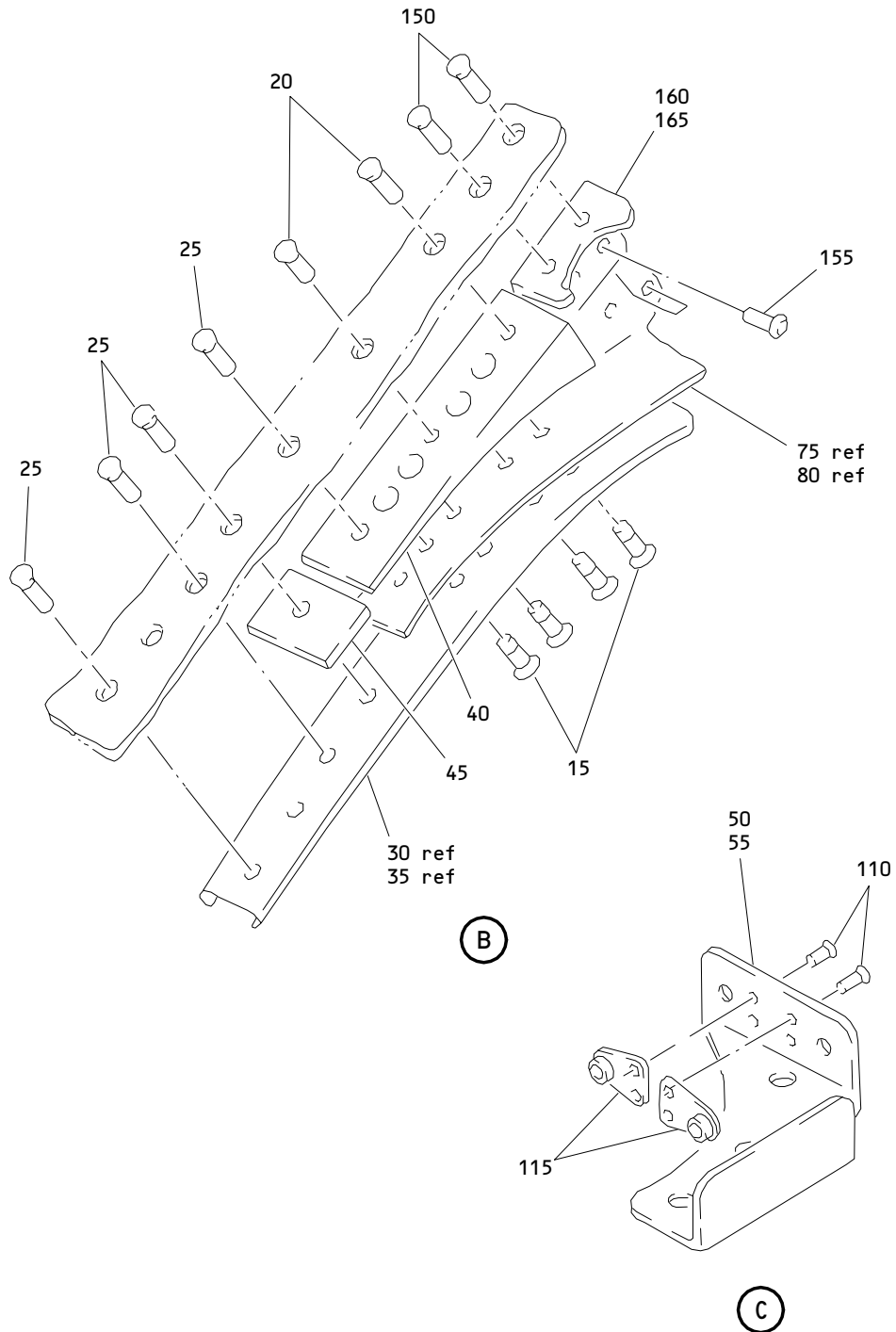
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Main Deck Cargo Door Upper Corner Pressure Seal Support Installation
Figure 7 (Sheet 2)

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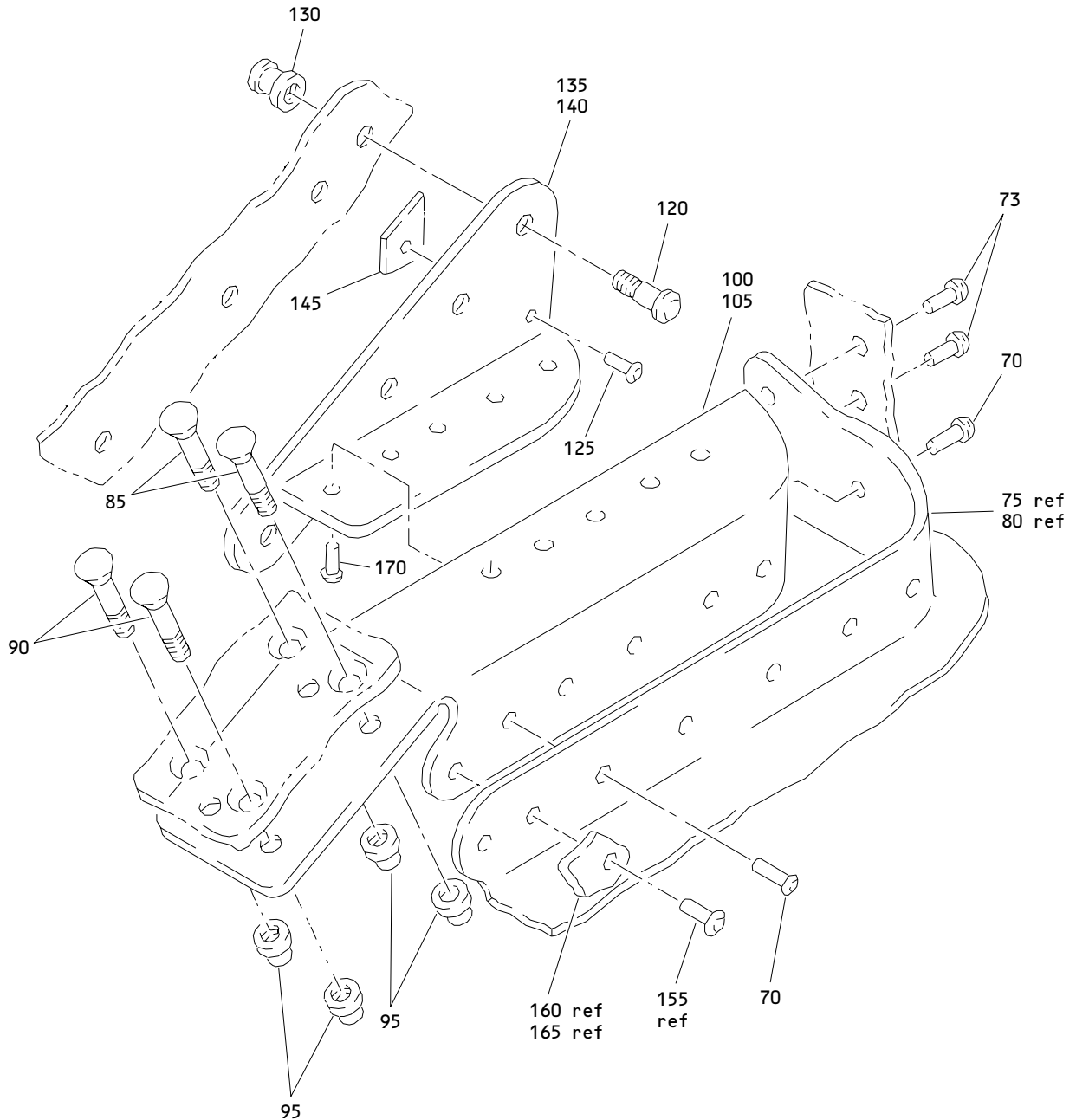
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Main Deck Cargo Door Upper Corner Pressure Seal Support Installation
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Main Deck Cargo Door Upper Corner Pressure Seal Support Installation
Figure 7 (Sheet 4)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 07-1A	143T6628-1		SUPPORT INSTL-UPR CORNER PRESSURE SEAL		RF
R -5	143T6628-2		SUPPORT INSTL-UPR CORNER PRESSURE SEAL		RF
R 10	BACR15CE4AD		.RIVET- (SIZE DETERMINE ON INST)		16
R 15	NAS1399B4-2		.RIVET		4
R 20	BACR15FV6KE		.RIVET- (SIZE DETERMINE ON INST)		2
R 25	BACR15BA4B		.RIVET- (SIZE DETERMINE ON INST)		5
R 30	143T6555-9		.RETAINER- (USED ON ITEM 1A)		1
R 35	143T6555-10		.RETAINER- (USED ON ITEM 5)		1
R 40	143T6630-1		.BLOCK-SPRT		1
R 45	BACF3T02F8G8		.SHIM		1
R 50	143T6555-3		.CLIP- (USED ON ITEM 1A)		1
R 55	143T6555-4		.CLIP- (USED ON ITEM 5)		1
R 60	BACR15FT4KE		.RIVET- (SIZE DETERMINE ON INST)		4
R 65	143T6555-5		.STRAP-SPLICE		1
R 70	BACR15FT6KE		.RIVET- (SIZE DETERMINE ON INST)		6
R 73A	BACR15CE6AD		.RIVET- (SIZE DETERMINE ON INST)		2
R 75	143T6554-3		.BRACKET- (USED ON ITEM 1A)		1
R 80	143T6554-4		.BRACKET- (USED ON ITEM 5)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 07-85	HST11AG6-8		.BOLT- (V06725) (SPEC BACB30VU6K8) (OPT HST11AG6-8 (V73197)) (OPT HST11AG6-8 (V56878)) (OPT HST11AG6-8 (VOPTK6))		2
R 90	HST11AG6-6		.BOLT- (V06725) (SPEC BACB30VU6K6) (OPT HST11AG6-6 (V73197)) (OPT HST11AG6-6 (V56878)) (OPT HST11AG6-6 (VOPTK6))		2
R 95	HST826AW		.COLLAR- (V5M902) (SPEC BACC30BQ6) (OPT HST826AW (V56878)) (OPT HST826AW (V73197)) (OPT HST82CY6APBW (V73197)) (OPT HST82CY6APBW (V56878))		4
R 100	143T6554-1		.BRACKET- (USED ON ITEM 1A)		1
R 105	143T6554-2		.BRACKET- (USED ON ITEM 5)		1
R 110	BACR15CE3AD		.RIVET- (SIZE DETERMINE ON INST)		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 07-115	102F9209M3		.NUTPLATE- (V72962) (SPEC BACN10KH3CD) (OPT FS1651-3 (V15653)) (OPT NS202496-02 (V80539))		2
R 120	HL1012AZ8-4		.BOLT- (V0PTK6) (SPEC BACB30NX8K4) (OPT HL12VAZ8-4 (V73197)) (OPT HL12VAZ8-4 (V92215)) (OPT HL12VAZ8-4 (V97928)) (OPT L802-8K4 (V06725)) (OPT HL12VAZ8-4 (V56878)) (OPT HL1012AZ8-4 (V06725)) (OPT HL1012AZ8-4 (V06950)) (OPT HL1012AZ8-4 (V17446)) (OPT HL1012AZ8-4 (V56878)) (OPT HL1012AZ8-4 (V60516)) (OPT HL1012AZ8-4 (V73197)) (OPT HL1012AZ8-4 (V97928))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 07-122	HL1012AZ8-6		.BOLT- (VOPTK6) (SPEC BACB30NX8K6) (OPT HL12VAZ8-6 (V73197)) (OPT HL12VAZ8-6 (V92215)) (OPT HL12VAZ8-6 (V97928)) (OPT L802-8K6 (V06725)) (OPT HL12VAZ8-6 (V56878)) (OPT HL1012AZ8-6 (V06725)) (OPT HL1012AZ8-6 (V06950)) (OPT HL1012AZ8-6 (V17446)) (OPT HL1012AZ8-6 (V56878)) (OPT HL1012AZ8-6 (V60516)) (OPT HL1012AZ8-6 (V73197)) (OPT HL1012AZ8-6 (V97928))		2
R 125	BACR15FT6KE		.RIVET- (SIZE DETERMINE ON INST)		6
R 130	HL1187-8		.COLLAR- (V5M902) (SPEC BACC30X8) (OPT HL87-8 (V73197)) (OPT HL87-8 (V92215)) (OPT HL1187-8 (V56878)) (OPT HL1187-8 (V92215)) (OPT HL87-8 (V56878)) (OPT HL1187-8 (V73197))		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 07- 135	143T6555-11		.CLIP- (USED ON ITEM 1A)		1
R 140	143T6555-12		.CLIP- (USED ON ITEM 5)		1
R 145	143T6555-7		.FILLER		1
R 150	BACR15FV6KE		.RIVET- (SIZE DETERMINE ON INST)		2
R 155	BACR15FT6KE		.RIVET- (SIZE DETERMINE ON INST)		2
R 160	143T6555-1		.ANGLE- (USED ON ITEM 1A)		1
R 165	143T6555-2		.ANGLE- (USED ON ITEM 5)		1

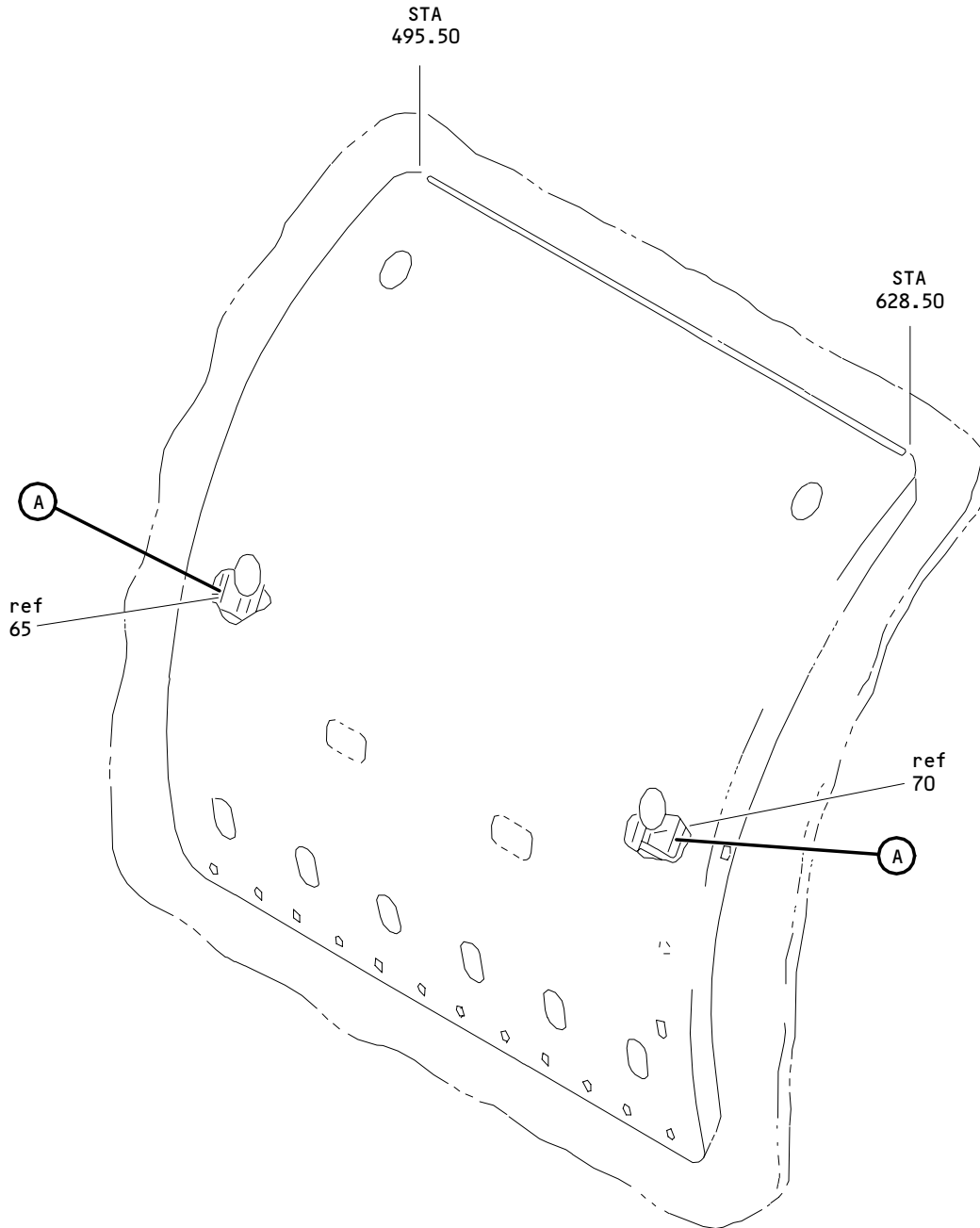
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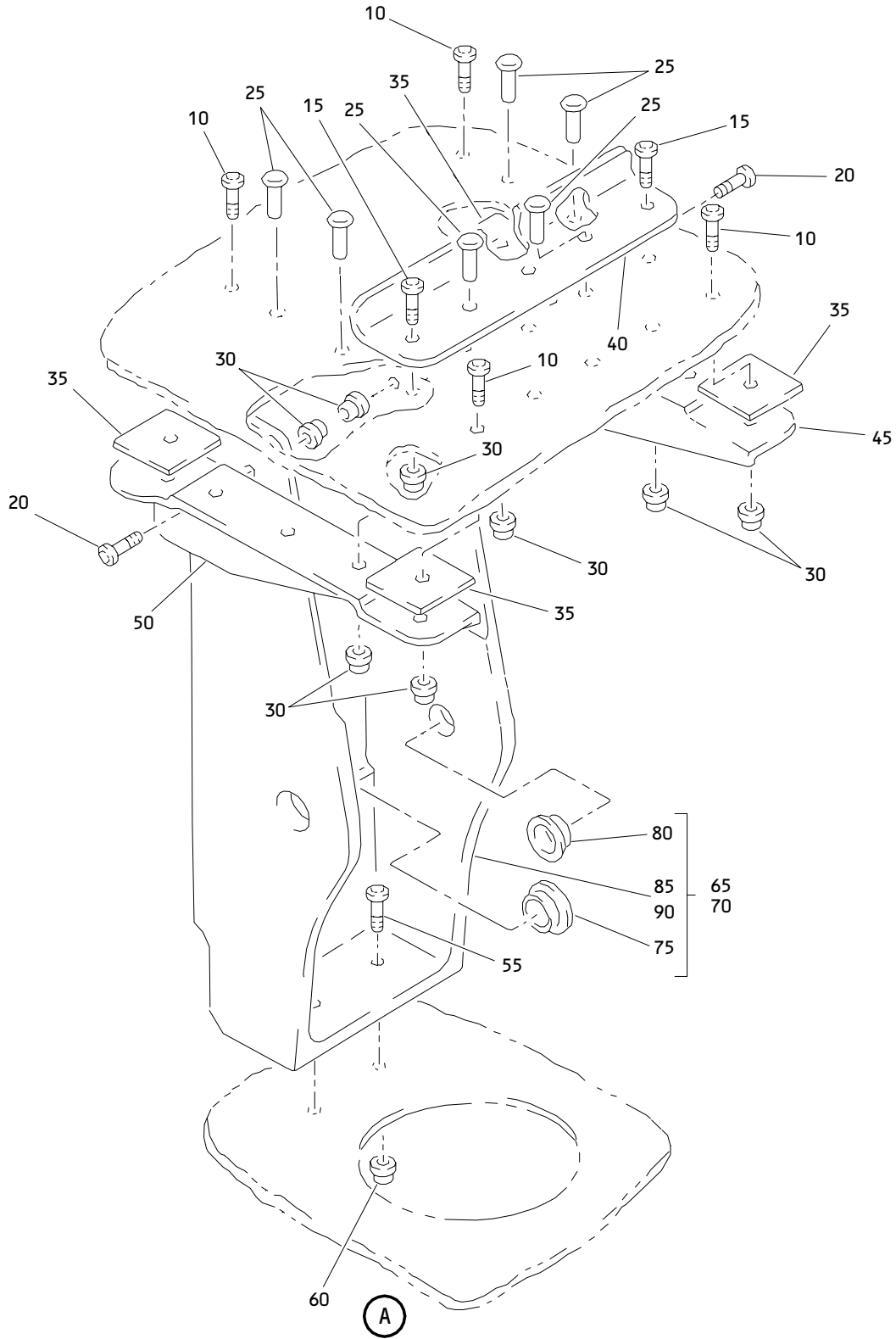
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Main Deck Cargo Door No. 8 Midspan Idler Support Intercostal Installation
Figure 8 (Sheet 1)

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Main Deck Cargo Door No. 8 Midspan Idler Support Intercostal Installation
Figure 8 (Sheet 2)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 08-1A	143T6250-1		INTERCOSTAL INSTL-NO. 8 MIDSPAN IDLER SPRT		RF
R -5	143T6250-2		INTERCOSTAL INSTL-NO. 8 MIDSPAN IDLER SPRT		RF
R 10	HST10AG6-4		.BOLT- (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (VOPTK6))		4
R 15	HST10AG6-6		.BOLT- (VOPTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))		2
R 20	HST10AG6-3		.BOLT- (VOPTK6) (SPEC BACB30VT6K3) (OPT HST10AG6-3 (V06725)) (OPT HST10AG6-3 (V56878)) (OPT HST10AG6-3 (V73197))		2
R 25	BACR15FT6KE		.RIVET- (SIZE DETERMINE ON INST)		7
R 30	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))		8

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 08-35	BACS40R008B010F		.SHIM		4
R 40	143T6271-17		.CLIP		1
R 45	143T6271-16		.CLIP		1
R 50	143T6271-15		.CLIP		1
R 55	HST10AG6-5		.BOLT- (VOPTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197))		2
R 60	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))		2
R 65	143T6260-1		.FITTING ASSY- (USED ON ITEM 1A)		1
R 70	143T6260-2		.FITTING ASSY- (USED ON ITEM 5)		1
R 75	BACB28X8M023		..BUSHING		1
R 80	BACB28X5C023		..BUSHING		1
R 85	143T6260-3		..FITTING- (USED ON ITEM 65)		1
R 90	143T6260-4		..FITTING- (USED ON ITEM 70)		1
R 95	143T6254-19		.CHORD- (USED ON ITEM 1A)		1
R 100	143T6254-20		.CHORD- (USED ON ITEM 5)		1
R 105	BACS40R008B020F		.SHIM		3
R 110	BACS40R009B020F		.SHIM		2

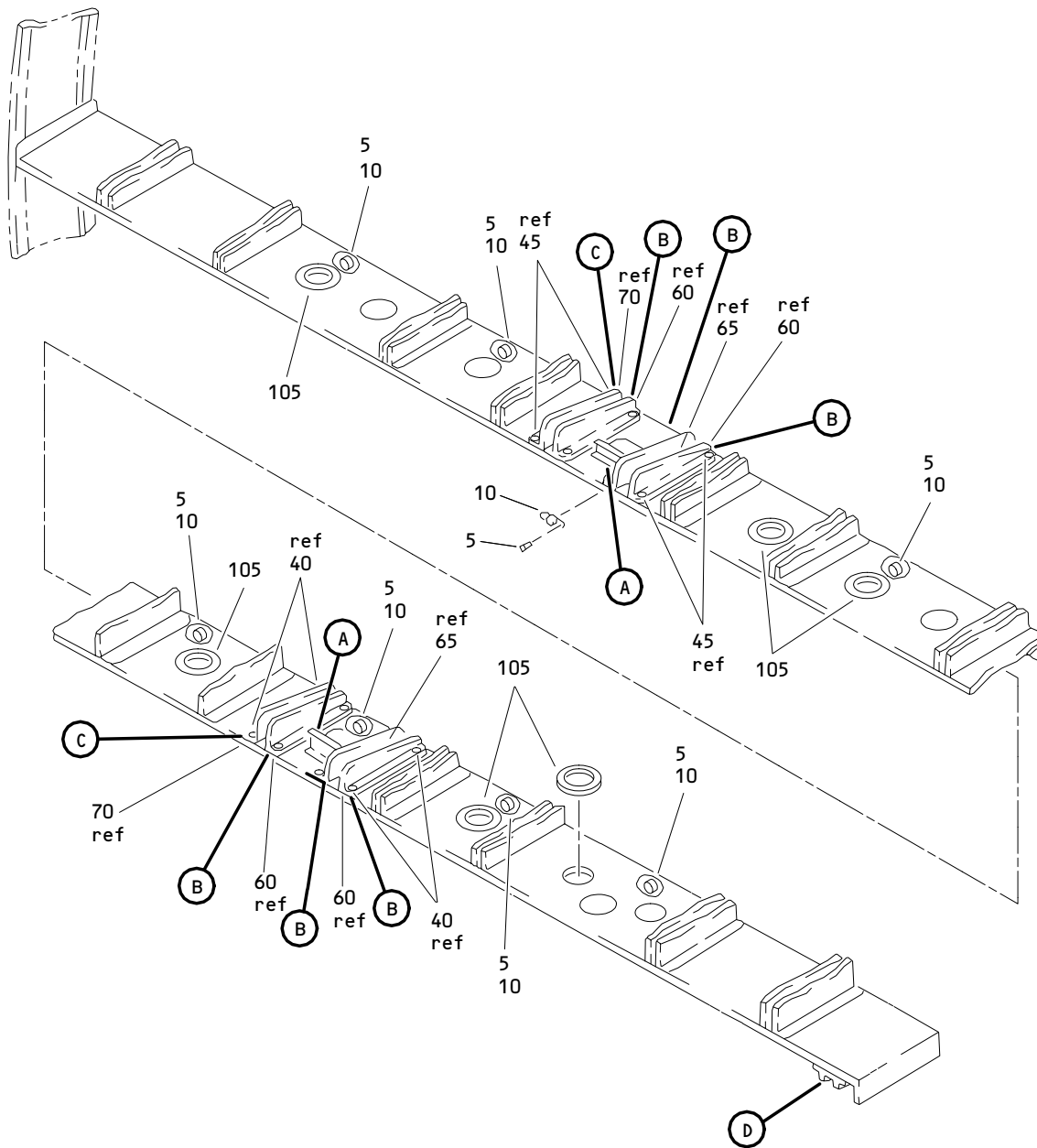
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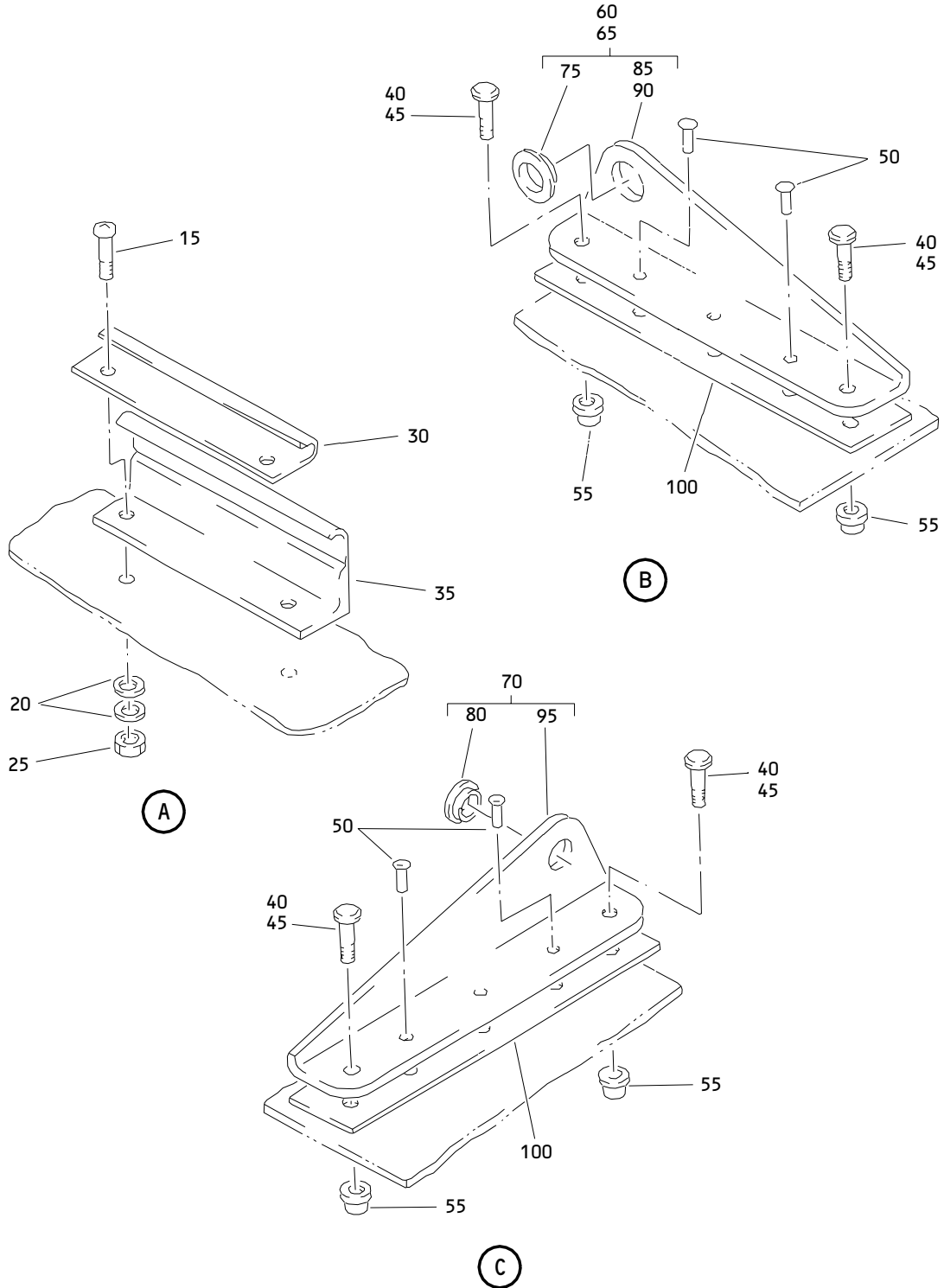
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Main Deck Cargo Door Assembly No. 9 Intercostal Installation
 Figure 9 (Sheet 1)

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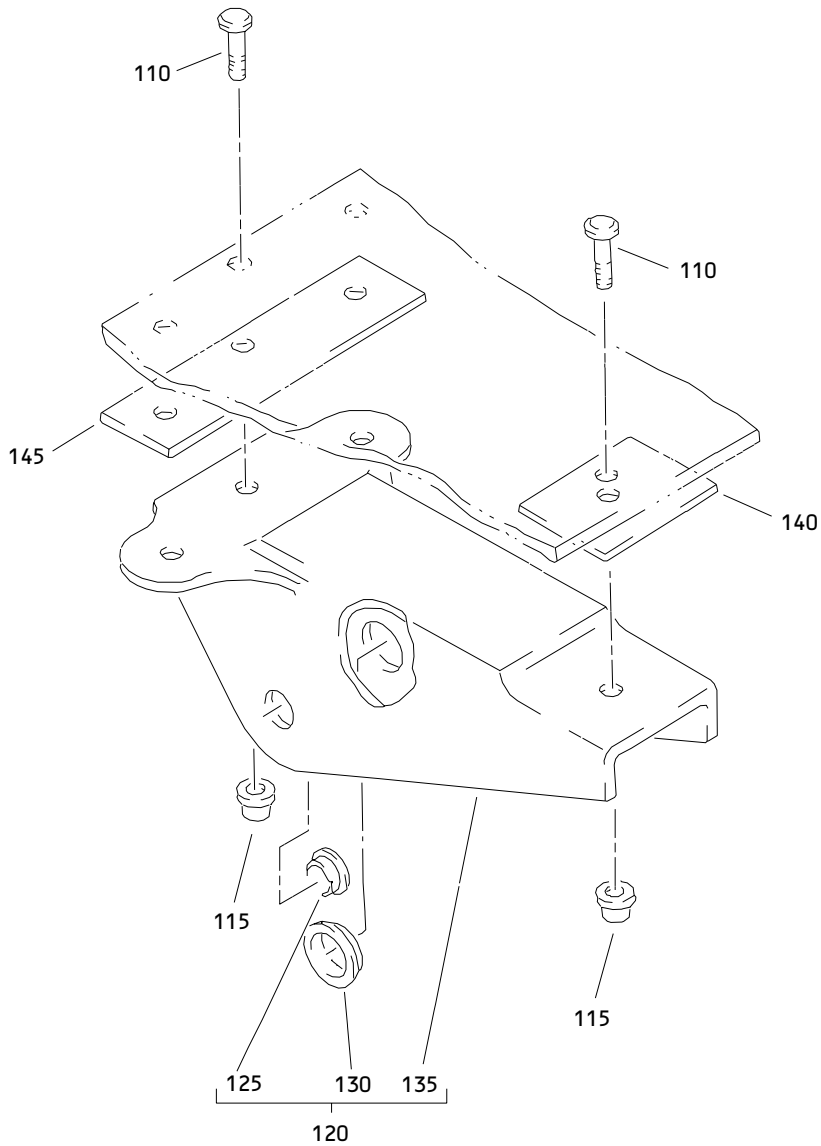
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Main Deck Cargo Door Assembly No. 9 Intercostal Installation
 Figure 9 (Sheet 2)

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Main Deck Cargo Door Assembly No. 9 Intercostal Installation
Figure 9 (Sheet 3)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 09- R -1A R 5	143T6240-1 BACR15CE3AD		INTERCOSTAL INSTL-NO. 9 .RIVET- (SIZE DETERMINE ON INST)		RF 16
R 10	NS202493-02-2		.NUTPLATE- (V80539) (SPEC BACN10KE3B2CD) (OPT BRFR220C3-2D (V52828)) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962))		8
R 15 R 20 R 25	BACB30NT3K5 NAS1149F0363P BRH10C3D		.BOLT .WASHER .NUT- (V52828) (SPEC BACN10JC3CD) (OPT T6C1032JCD (V11815)) (OPT NS202486-02 (V80539)) (OPT 102LH9075-3W (V72962)) (OPT H51650-3BAC (V15653))		4 8 4
R 30 R 35	143T6240-7 143T6240-8		.RETAINER-SEAL .SEAL-RAIN (MFD FROM BAC1521-870-746 X 3.50)		2 2
R 40	HST10AG6-5		.BOLT- (VOPTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197))		8

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 09-45	HST10AG6-4		.BOLT- (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (VOPTK6))		8
R 50	BACR15FT6KE		.RIVET- (SIZE DETERMINE ON INST)		24
R 55	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))		16
R 60	143T6260-5		.FITTING ASSY		4
R 65	143T6260-6		.FITTING ASSY		2
R 70	143T6260-9		.FITTING ASSY		2
R 75	BACB28X6M014		..BUSHING- (USED ON ITEMS 60, 65)		1
R 80	BACB28X4C014		..BUSHING- (USED ON ITEM 70)		1
R 85	143T6260-7		..FITTING- (USED ON ITEM 60)		1
R 90	143T6260-8		..FITTING- (USED ON ITEM 65)		1

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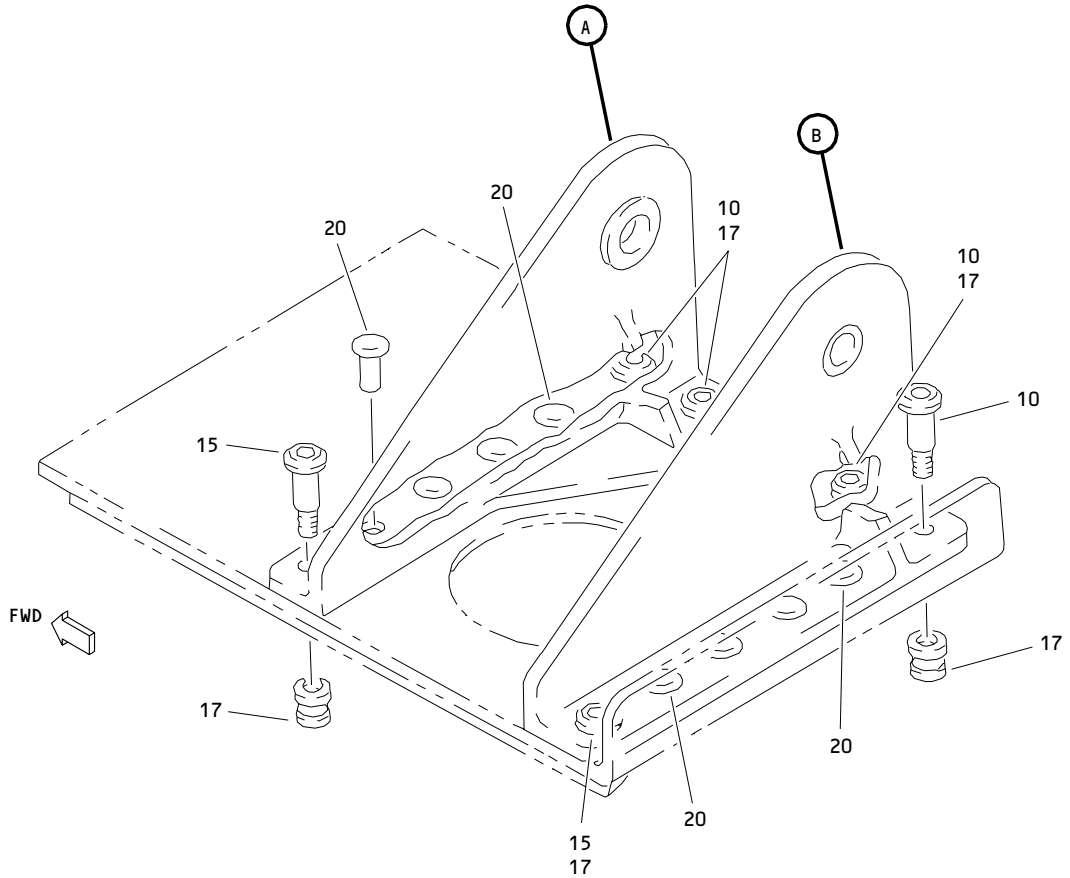

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 09-95	143T6260-10		..FITTING- (USED ON ITEM 70)		1
R 100	BACS4OR010F054F		.SHIM		8
R 105	BACG20AD0613		DELETED		
R 105A	BACG20AD0707		.GROMMET		6
R 110	HST10AG6-6		.BOLT- (VOPTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))		4
R 115	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))		4
R 120	143T6229-1		.FITTING ASSY-ACTR LATCH LOCK		1
R 125	BACB28X4C012		..BUSHING		1
R 130	BACB28X6M012		..BUSHING		1
R 135	143T6229-2		..FITTING		1
R 140	BACS4OR010B014F		.SHIM		1
R 145	BACS4OR010B033F		.SHIM		1

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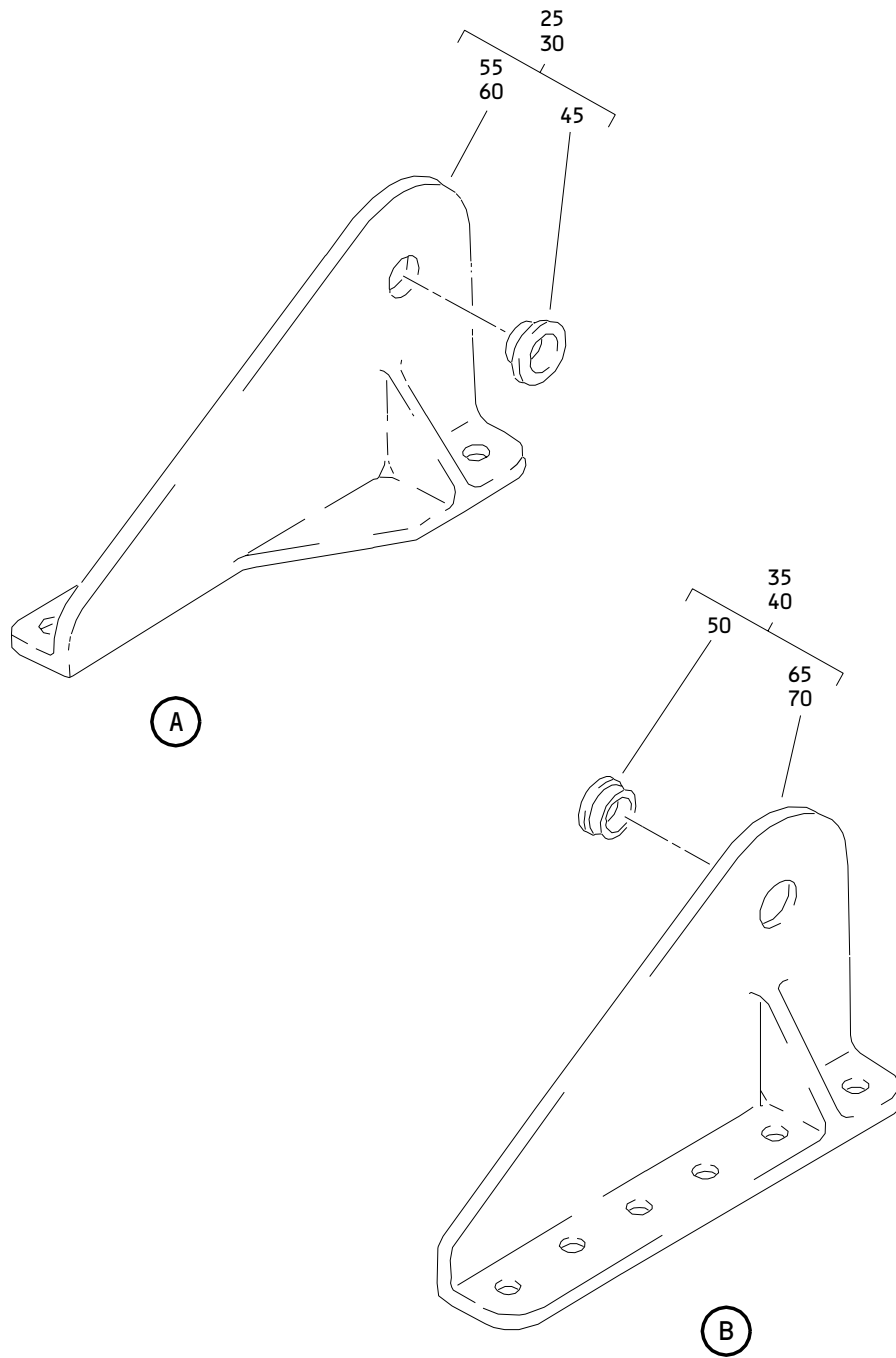
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Main Deck Cargo Door No. 10 Midspan Support Intercostal Installation
Figure 10 (Sheet 1)

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Main Deck Cargo Door No. 10 Midspan Support Intercostal Installation
Figure 10 (Sheet 2)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 10- -1A	143T6259-1		INTERCOSTAL INSTL-NO. 10 MIDSPAN SPRT		RF
R -5	143T6259-2		INTERCOSTAL INSTL-NO. 10 MIDSPAN SPRT		RF
R 10	HL1012AZ6-6		.BOLT- (V97928) (SPEC BACB30NX6K6) (OPT HL12VAZ6-6 (V73197)) (OPT HL12VAZ6-6 (V92215)) (OPT HL12VAZ6-6 (V97928)) (OPT L802-6K6 (V06725)) (OPT HL12VAZ6-6 (V56878)) (OPT HL1012AZ6-6 (V0PTK6)) (OPT HL1012AZ6-6 (V06725)) (OPT HL1012AZ6-6 (V06950)) (OPT HL1012AZ6-6 (V17446)) (OPT HL1012AZ6-6 (V56878)) (OPT HL1012AZ6-6 (V60516)) (OPT HL1012AZ6-6 (V73197))		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 10-15	HL1012AZ6-4		.BOLT- (V97928) (SPEC BACB30NX6K4) (OPT HL12VAZ6-4 (V73197)) (OPT HL12VAZ6-4 (V92215)) (OPT HL12VAZ6-4 (V97928)) (OPT L802-6K4 (V06725)) (OPT HL12VAZ6-4 (V56878)) (OPT HL1012AZ6-4 (V0PTK6)) (OPT HL1012AZ6-4 (V06725)) (OPT HL1012AZ6-4 (V06950)) (OPT HL1012AZ6-4 (V17446)) (OPT HL1012AZ6-4 (V56878)) (OPT HL1012AZ6-4 (V60516)) (OPT HL1012AZ6-4 (V73197))		2
R 17	HL1187-6		.COLLAR- (V5M902) (SPEC BACC30X6) (OPT HL87-6 (V73197)) (OPT HL87-6 (V92215)) (OPT HL1187-6 (V56878)) (OPT HL1187-6 (V92215)) (OPT HL87-6 (V56878)) (OPT HL1187-6 (V73197))		6
R 20	BACR15FT6KE		.RIVET- (SIZE DETERMINE ON INST)		8

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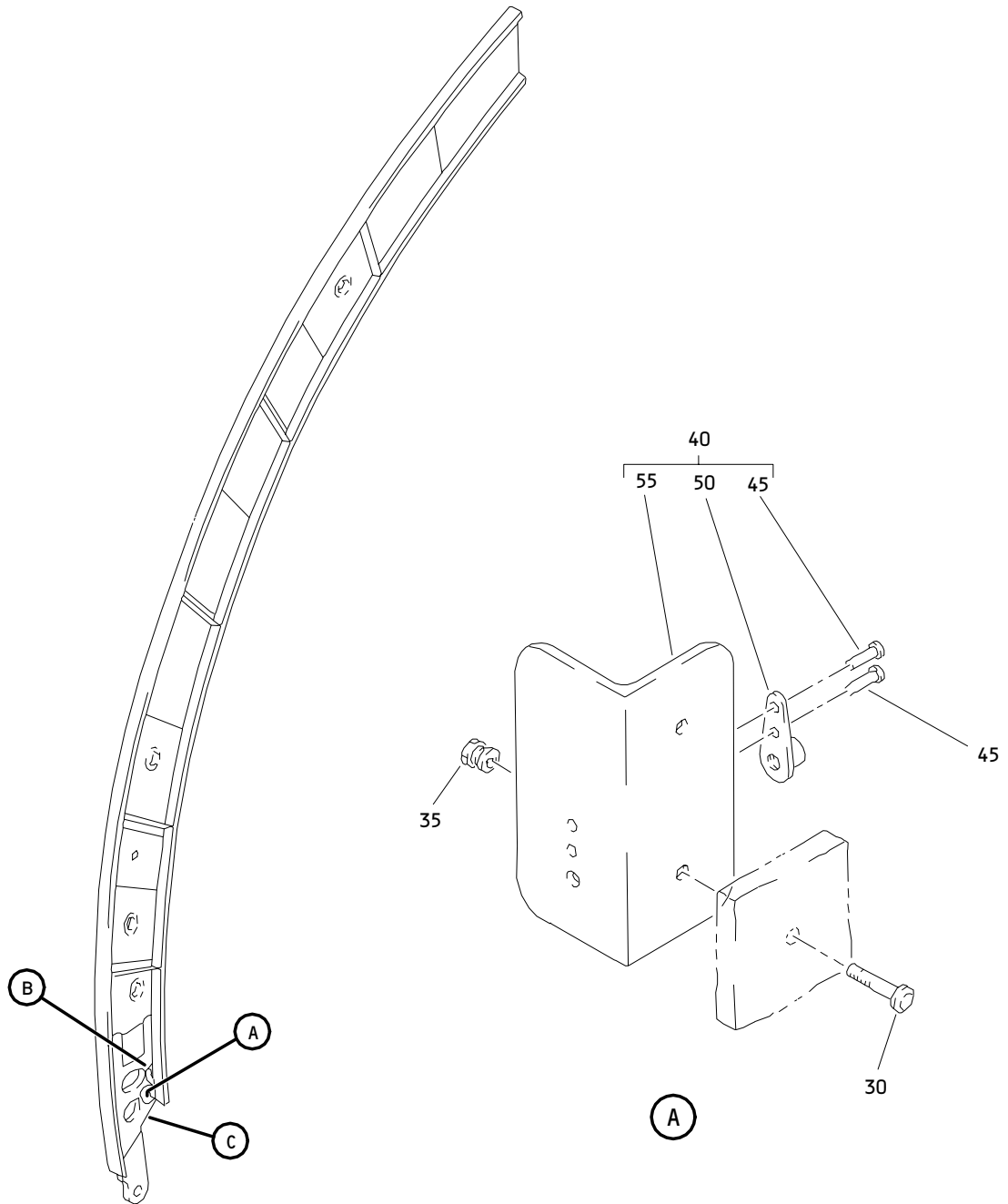

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 10-25	143T6260-15		.FITTING- (USED ON ITEM 1A)		1
R -30	143T6260-13		.FITTING- (USED ON ITEM 5)		1
R 35	143T6260-16		.FITTING- (USED ON ITEM 1A)		1
R 40	143T6260-14		.FITTING- (USED ON ITEM 5)		1
R 45	BACB28X8M010		..BUSHING- (USED ON ITEMS 25, 30)		1
R 50	BACB28X5C010		..BUSHING- (USED ON ITEMS 35, 40)		1
R 55	143T6260-17		..FITTING- (USED ON ITEM 25)		1
R 60	143T6260-11		..FITTING- (USED ON ITEM 30)		1
R 65	143T6260-18		..FITTING- (USED ON ITEM 35)		1
R 70	143T6260-12		..FITTING- (USED ON ITEM 40)		1

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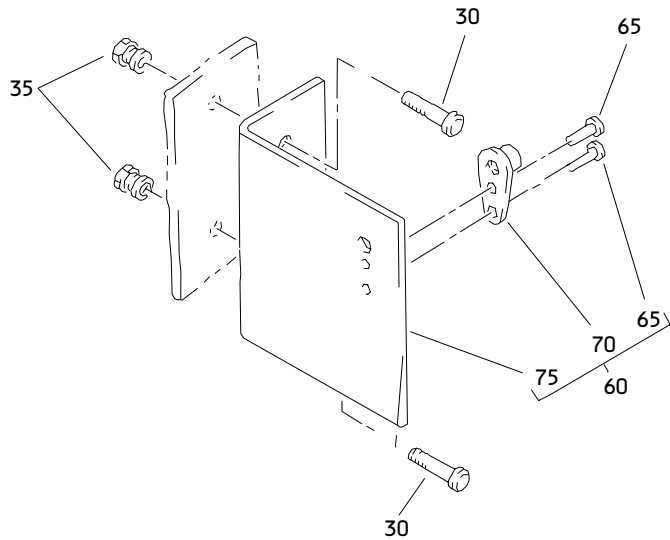
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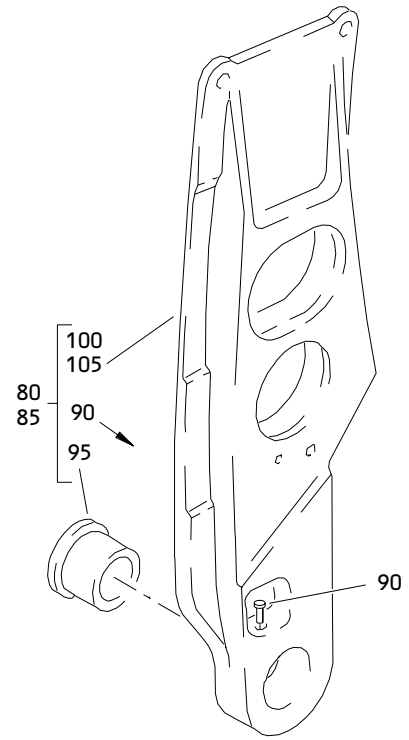
Main Deck Cargo Door STA 546.6 Frame Installation
Figure 11 (Sheet 1)

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(B)



(C)

Main Deck Cargo Door STA 524.6 Frame Installation
 Figure 11 (Sheet 2)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 11-					
R -1A	143T6232-1		FRAME INSTL-STA 546.6		RF
R -5	143T6232-2		FRAME INSTL-STA 577.4		RF
R -10	143T6232-3		FRAME INSTL-STA 590.6		RF
R -15	143T6232-4		FRAME INSTL-STA 533.4		RF
R -20	143T6234-1		FRAME INSTL-STA 511.4		RF
R -25	143T6234-2		FRAME INSTL-STA 612.6		RF
R 30	HL1012AZ8-5		.BOLT- (V0PTK6) (SPEC BACB30NX8K5) (OPT HL12VAZ8-5 (V73197)) (OPT HL12VAZ8-5 (V92215)) (OPT HL12VAZ8-5 (V97928)) (OPT L802-8K5 (V06725)) (OPT HL12VAZ8-5 (V56878)) (OPT HL1012AZ8-5 (V06725)) (OPT HL1012AZ8-5 (V06950)) (OPT HL1012AZ8-5 (V17446)) (OPT HL1012AZ8-5 (V56878)) (OPT HL1012AZ8-5 (V60516)) (OPT HL1012AZ8-5 (V73197)) (OPT HL1012AZ8-5 (V97928)) (USED ON ITEMS 5, 20)		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 11-35	HL1187-8		.COLLAR- (V5M902) (SPEC BACC30X8) (OPT HL87-8 (V73197)) (OPT HL87-8 (V92215)) (OPT HL1187-8 (V56878)) (OPT HL1187-8 (V92215)) (OPT HL87-8 (V56878)) (OPT HL1187-8 (V73197)) (USED ON ITEMS 5, 20)		4
R 40	287T0020-162		.SUPPORT ASSY-WIRE (USED ON ITEMS 5, 20)		1
R 45	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		2
R 50	BRM100A3		..NUTPLATE- (V52828) (SPEC BACN10JP3B) (OPT MK2000-3BAC (V15653)) (OPT NS103198-02 (V80539)) (OPT RMA9207-3 (V72962)) (OPT T8077S1032 (V11815)) (OPT VN201A1-02 (V92215)) (OPT ITEM 50A)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 11-50A	BR1000A3		..NUTPLATE- (V52828) (SPEC BACN10KB3) (OPT K2000-3 (V15653)) (OPT RMA9207-3 (V72962)) (OPT T8109S1032 (V11815)) (OPT VN101A1-02 (V92215)) (OPT K2000-3 (V15653)) (OPT ITEM 50)		1
R 55	287T0020-164		..ANGLE		1
60	287T0013-26		DELETED		
60A	287T0013-90		DELETED		
R 60B	287T0013-97		.BRACKET ASSY- (USED ON ITEM 5)		1
R 65	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		2
R 70	BRM100A3		..NUTPLATE- (V52828) (SPEC BACN10JP3B) (OPT MK2000-3BAC (V15653)) (OPT NS103198-02 (V80539)) (OPT RMA9207-3 (V72962)) (OPT T8077S1032 (V11815)) (OPT VN201A1-02 (V92215))		1

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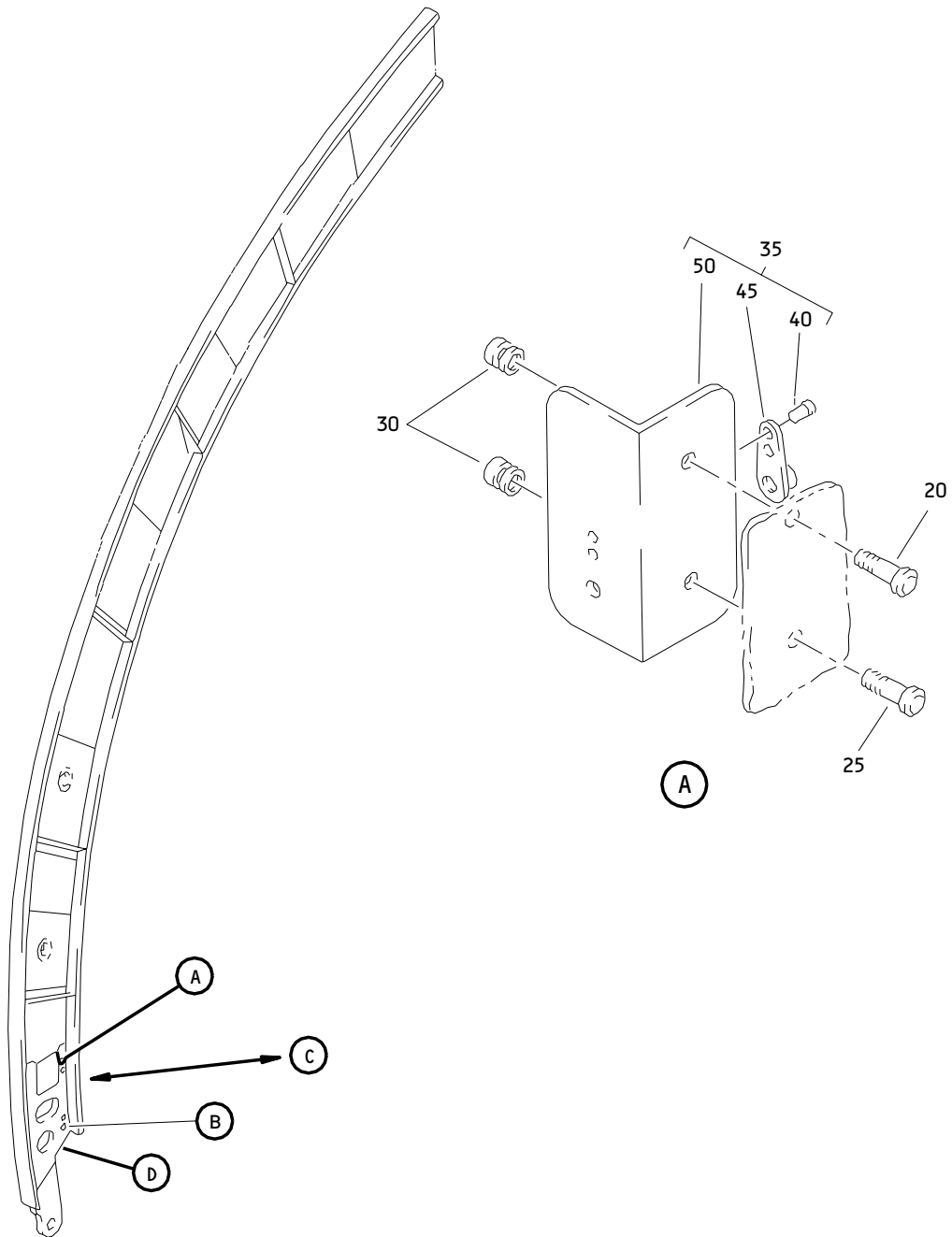
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
11-					
75	287T0013-12		DELETED		
75A	287T0013-89		DELETED		
R 75B	287T0013-96		..BRACKET		1
R 80	143T6255-1		.FITTING ASSY-LATCH (USED ON ITEMS 1A, 10, 25)		1
R 85	143T6255-2		.FITTING ASSY-LATCH (USED ON ITEMS 5, 15, 20)		1
R 90	NAS516-1A		..FITTING		1
R 95	143T6256-1		..BUSHING		1
R 100	143T6255-3		..FITTING- (USED ON ITEM 80)		1
R 105	143T6255-4		..FITTING- (USED ON ITEM 85)		1

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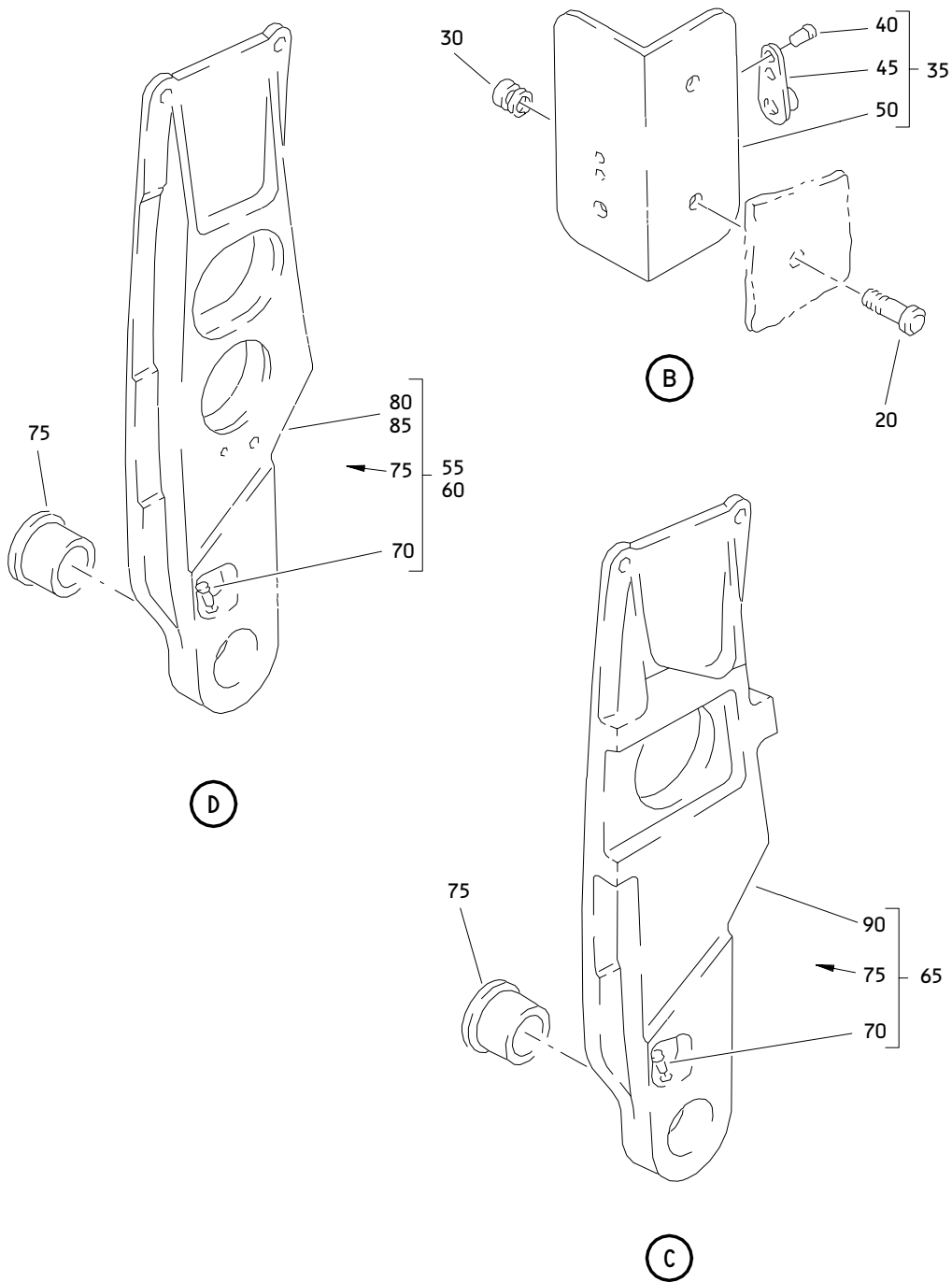
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Main Deck Cargo Door Assembly STA 524.6 Frame Installation
Figure 12 (Sheet 1)

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Main Deck Cargo Door Assembly STA 524.6 Frame Installation
 Figure 12 (Sheet 2)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 12-					
R -1A	143T6233-1		FRAME INSTL-ST A 524.6		RF
R -5	143T6233-2		FRAME INSTL-ST A 555.4		RF
R -10	143T6233-3		FRAME INSTL-ST A 568.6		RF
R -15	143T6233-4		FRAME INSTL-ST A 599.4	A	RF
R -15A	143T6233-16		FRAME INSTL-ST A 599.4		RF
R 20	HL1012AZ8-5		.BOLT- (V0PTK6) (SPEC BACB30NX8K5) (OPT HL12VAZ8-5 (V73197)) (OPT HL12VAZ8-5 (V92215)) (OPT HL12VAZ8-5 (V97928)) (OPT L802-8K5 (V06725)) (OPT HL12VAZ8-5 (V56878)) (OPT HL1012AZ8-5 (V06725)) (OPT HL1012AZ8-5 (V06950)) (OPT HL1012AZ8-5 (V17446)) (OPT HL1012AZ8-5 (V56878)) (OPT HL1012AZ8-5 (V60516)) (OPT HL1012AZ8-5 (V73197)) (OPT HL1012AZ8-5 (V97928)) (USED ON ITEM 5)		3

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 12-25	HL1012AZ8-6		.BOLT- (VOPTK6) (SPEC BACB30NX8K6) (OPT HL12VAZ8-6 (V73197)) (OPT HL12VAZ8-6 (V92215)) (OPT HL12VAZ8-6 (V97928)) (OPT L802-8K6 (V06725)) (OPT HL12VAZ8-6 (V56878)) (OPT HL1012AZ8-6 (V06725)) (OPT HL1012AZ8-6 (V06950)) (OPT HL1012AZ8-6 (V17446)) (OPT HL1012AZ8-6 (V56878)) (OPT HL1012AZ8-6 (V60516)) (OPT HL1012AZ8-6 (V73197)) (OPT HL1012AZ8-6 (V97928)) (USED ON ITEM 5)		1
R 30	HL1187-8		.COLLAR- (V5M902) (SPEC BACC30X8) (OPT HL87-8 (V73197)) (OPT HL87-8 (V92215)) (OPT HL1187-8 (V56878)) (OPT HL1187-8 (V92215)) (OPT HL87-8 (V56878)) (OPT HL1187-8 (V73197)) (USED ON ITEM 5)		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 12-35	287T0020-161		.SUPPORT ASSY-WIRE (USED ON ITEM 5)		2
R 40	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		2
R 45	BRM100A3		..NUTPLATE- (V52828) (SPEC BACN10JP3B) (OPT MK2000-3BAC (V15653)) (OPT NS103198-02 (V80539)) (OPT RMA9207-3 (V72962)) (OPT T8077S1032 (V11815)) (OPT VN201A1-02 (V92215)) (OPT ITEM 45A)		1
R -45A	BR1000A3		..NUTPLATE- (V52828) (SPEC BACN10KB3) (OPT K2000-3 (V15653)) (OPT RMA9207-3 (V72962)) (OPT T8109S1032 (V11815)) (OPT VN101A1-02 (V92215)) (OPT K2000-3 (V15653)) (OPT ITEM 45)		1
R 50	287T0020-163		..ANGLE		1
R 55	143T6255-1		.FITTING ASSY-LATCH (USED ON ITEM 1A)		1
R 60	143T6255-2		.FITTING ASSY-LATCH (USED ON ITEMS 5, 15, 15A)		1
R 65	143T6255-6		.FITTING ASSY-LATCH (USED ON ITEM 10)		1
R 70	NAS516-1A		..FITTING		1
R 75	143T6256-1		..BUSHING		1
R 80	143T6255-3		..FITTING- (USED ON ITEM 55)		1

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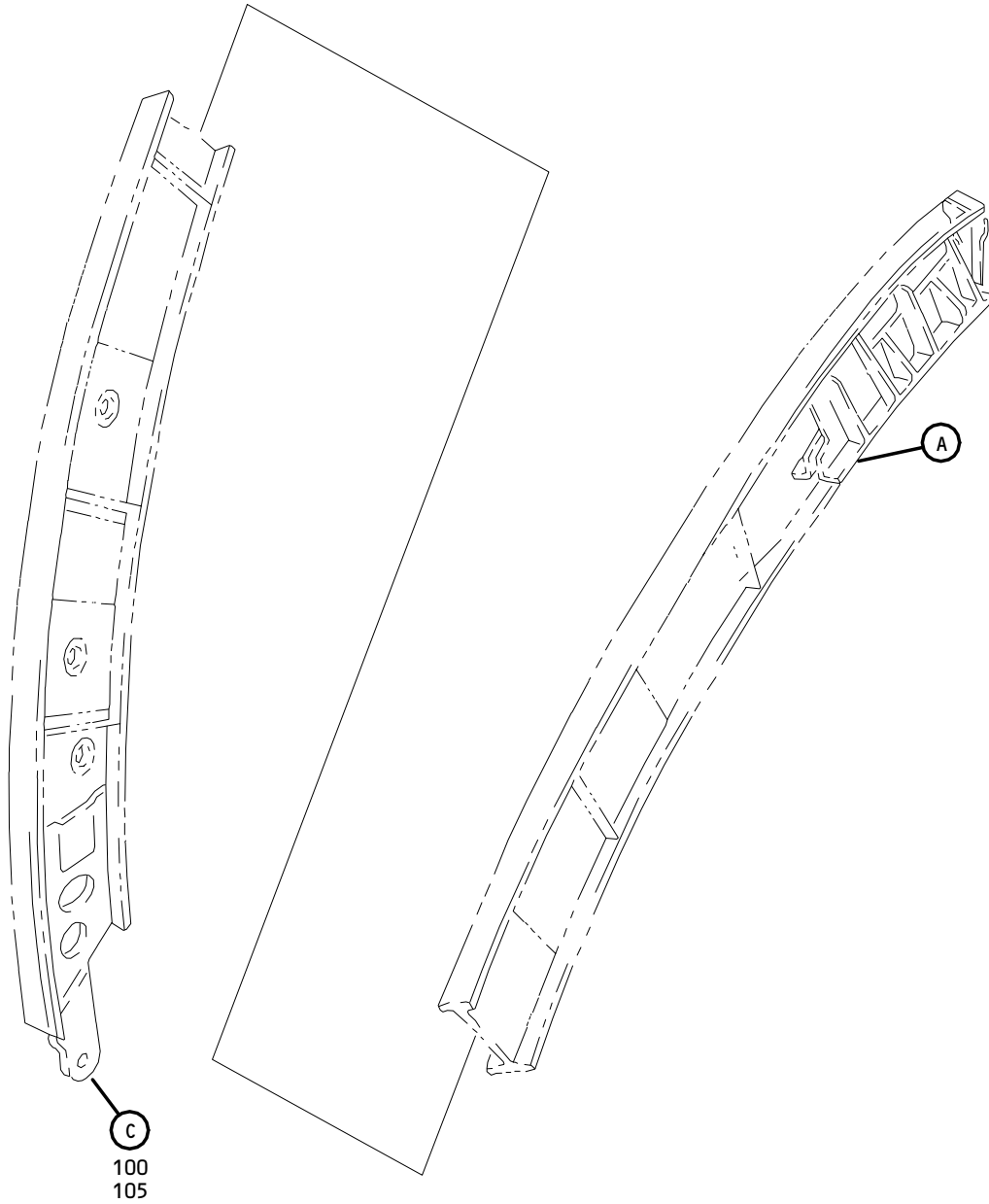
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
R 12-85	143T6255-4		..FITTING- (USED ON ITEM 60)		1
R 90	143T6255-5		..FITTING- (USED ON ITEM 65)		1

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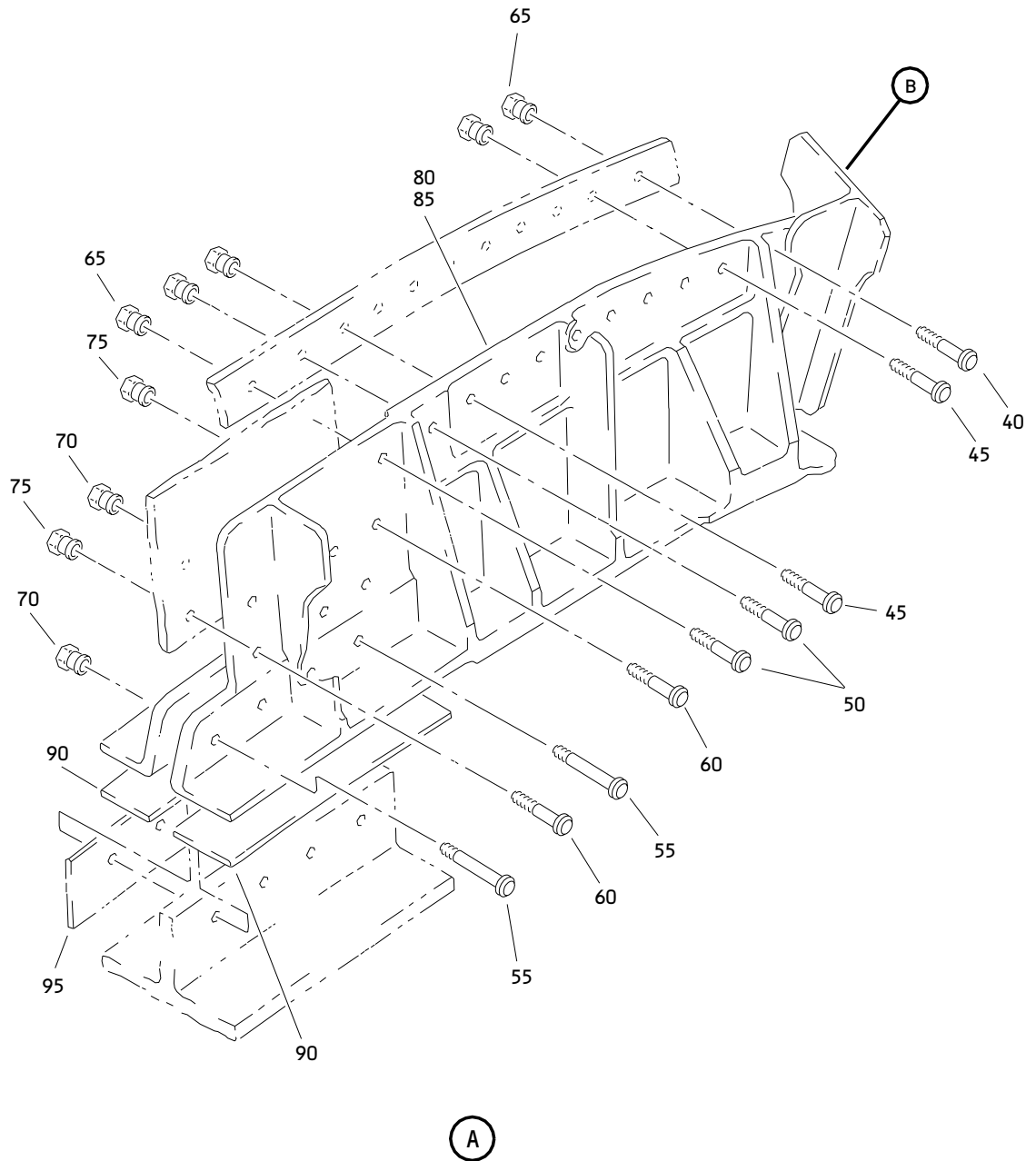
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Main Deck Cargo Door STA 502.6 Frame Installation
Figure 13 (Sheet 1)

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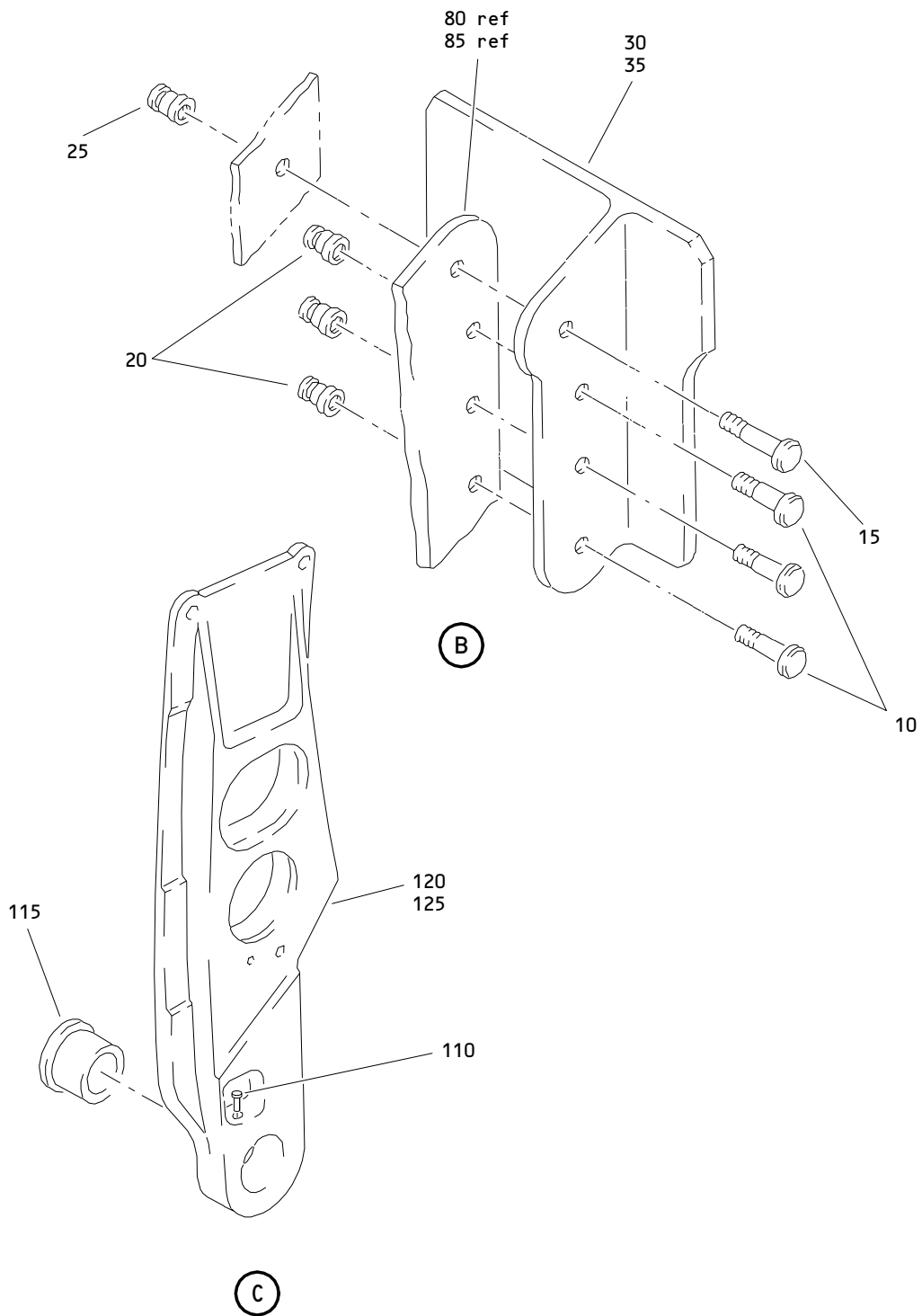
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Main Deck Cargo Door STA 502.6 Frame Installation
 Figure 13 (Sheet 2)

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Main Deck Cargo Door STA 502.6 Frame Installation
Figure 13 (Sheet 3)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 13-					
R -1A	143T6230-1		FRAME INSTL-STA 502.6		RF
R -5	143T6230-2		FRAME INSTL-STA 621.4		RF
R 10	HST10AG10-7		.BOLT- (VOPTK6) (SPEC BACB30VT10K7) (OPT HST10AG10-7 (V06725)) (OPT HST10AG10-7 (V56878)) (OPT HST10AG10-7 (V73197))		3
R 15	HST10AG12-11		.BOLT- (VOPTK6) (SPEC BACB30VT12K11) (OPT HST10AG12-11 (V06725)) (OPT HST10AG12-11 (V56878)) (OPT HST10AG12-11 (V73197))		1
R 20	HST79CY10		.COLLAR- (V73197) (SPEC BACC30BL10) (OPT HST79-10 (V92215)) (OPT HST79-10 (V56878)) (OPT HST79-10 (V5M902))		3
R 25	HST79CY12		.COLLAR- (V73197) (SPEC BACC30BL12) (OPT HST79-12 (V92215)) (OPT HST79-12 (V56878)) (OPT HST79-12 (V5M902))		1
R 30	143T6267-1		.CLIP-TEE (USED ON ITEM 1A)		1
R 35	143T6267-2		.CLIP-TEE (USED ON ITEM 5)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 13-40	HST10AG10-8		.BOLT- (VOPTK6) (SPEC BACB30VT10K8) (OPT HST10AG10-8 (V06725)) (OPT HST10AG10-8 (V56878)) (OPT HST10AG10-8 (V73197))		1
R 45	HST10AG10-10		.BOLT- (VOPTK6) (SPEC BACB30VT10K10) (OPT HST10AG10-10 (V06725)) (OPT HST10AG10-10 (V56878)) (OPT HST10AG10-10 (V73197))		8
R 50	HST10AG10-12		.BOLT- (VOPTK6) (SPEC BACB30VT10K12) (OPT HST10AG10-12 (V06725)) (OPT HST10AG10-12 (V56878)) (OPT HST10AG10-12 (V73197))		2
R 55	HST10AG12-17		.BOLT- (VOPTK6) (SPEC BACB30VT12K17) (OPT HST10AG12-17 (V06725)) (OPT HST10AG12-17 (V56878)) (OPT HST10AG12-17 (V73197))		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 13-60	HST10AG8-7		.BOLT- (V0PTK6) (SPEC BACB30VT8K7) (OPT HST10AG8-7 (V06725)) (OPT HST10AG8-7 (V56878)) (OPT HST10AG8-7 (V73197))		6
R 65	HST79CY10		.COLLAR- (V73197) (SPEC BACC30BL10) (OPT HST79-10 (V92215)) (OPT HST79-10 (V56878)) (OPT HST79-10 (V5M902))		11
R 70	HST79CY12		.COLLAR- (V73197) (SPEC BACC30BL12) (OPT HST79-12 (V92215)) (OPT HST79-12 (V56878)) (OPT HST79-12 (V5M902))		4
R 75	HST79CY8		.COLLAR- (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))		6

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 13- 80	143T6249-1		.FITTING-LIFT LINK SPRT (USED ON ITEM 1A)		1
R 85	143T6249-2		.FITTING-LIFT LINK SPRT (USED ON ITEM 5)		1
R 90	BACS4OR016C069F		.SHIM		2
R 95	BACS4OR016C061F		.SHIM		1
R 100	143T6255-9		.FITTING ASSY-LATCH (USED ON ITEM 1A)		1
R 105	143T6255-10		.FITTING ASSY-LATCH (USED ON ITEM 5)		1
R 110	NAS516-1A		..FITTING		1
R 115	143T6256-1		..BUSHING		1
R 120	143T6255-7		..FITTING- (USED ON ITEM 100)		1
R 125	143T6255-8		..FITTING- (USED ON ITEM 105)		1

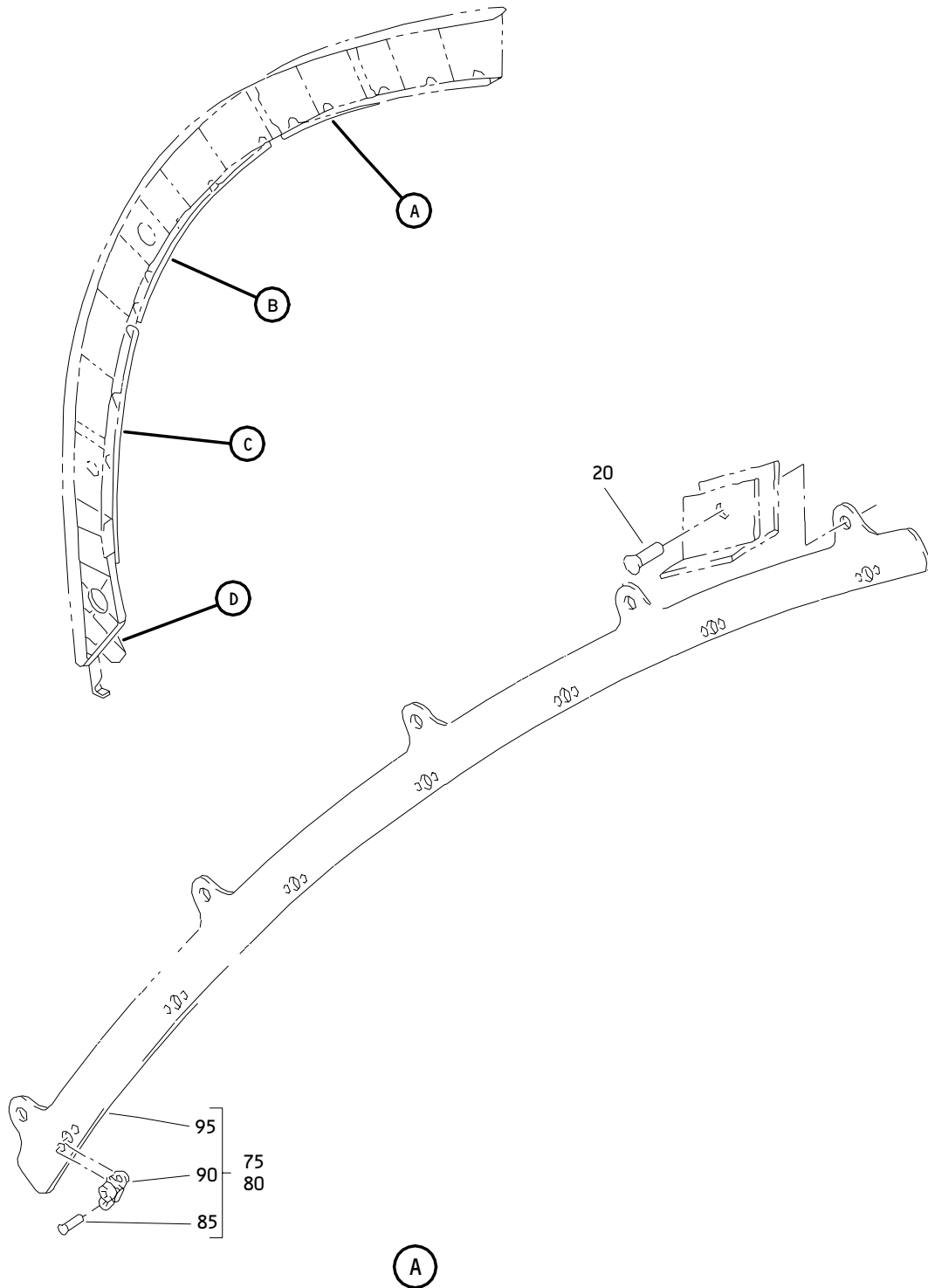
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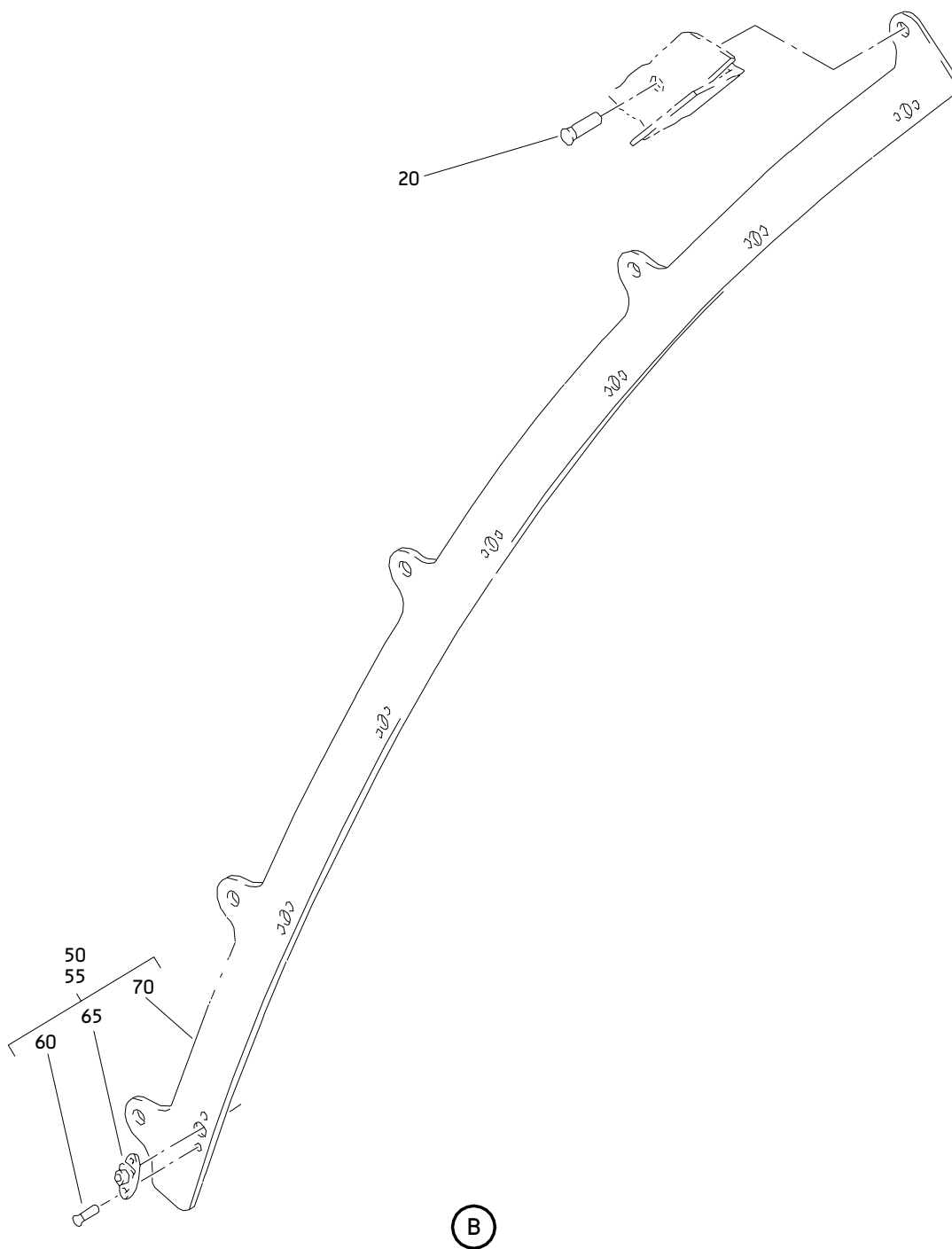
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Main Deck Cargo Door STA 495.5 Frame Installation
Figure 14 (Sheet 1)

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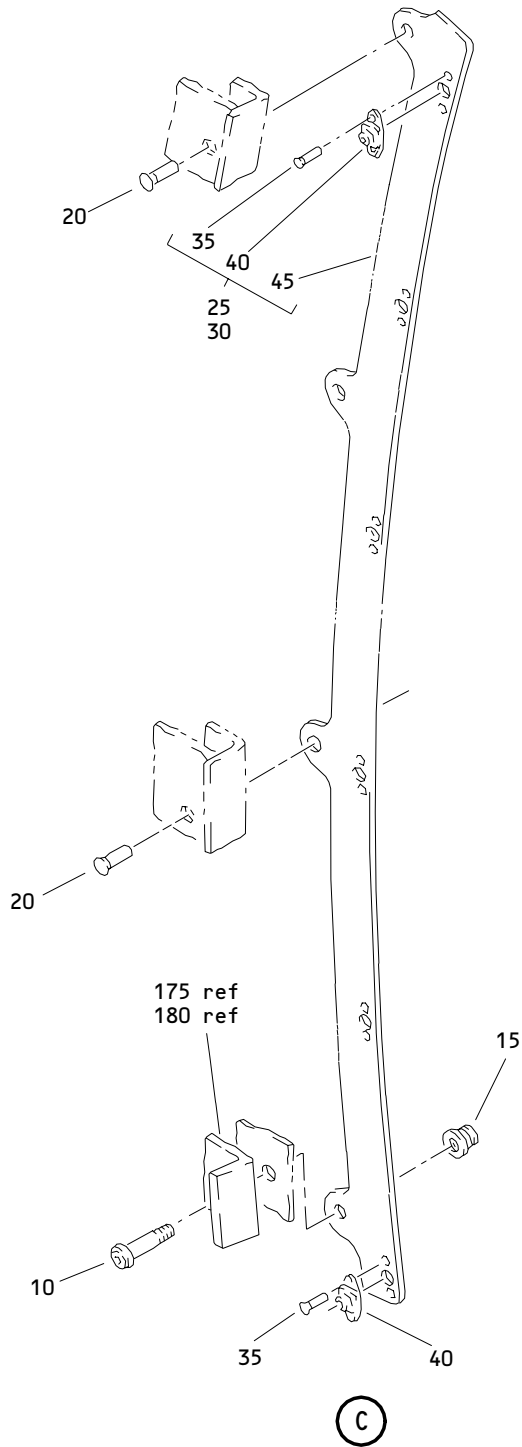
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Main Deck Cargo Door STA 495.5 Frame Installation
Figure 14 (Sheet 2)

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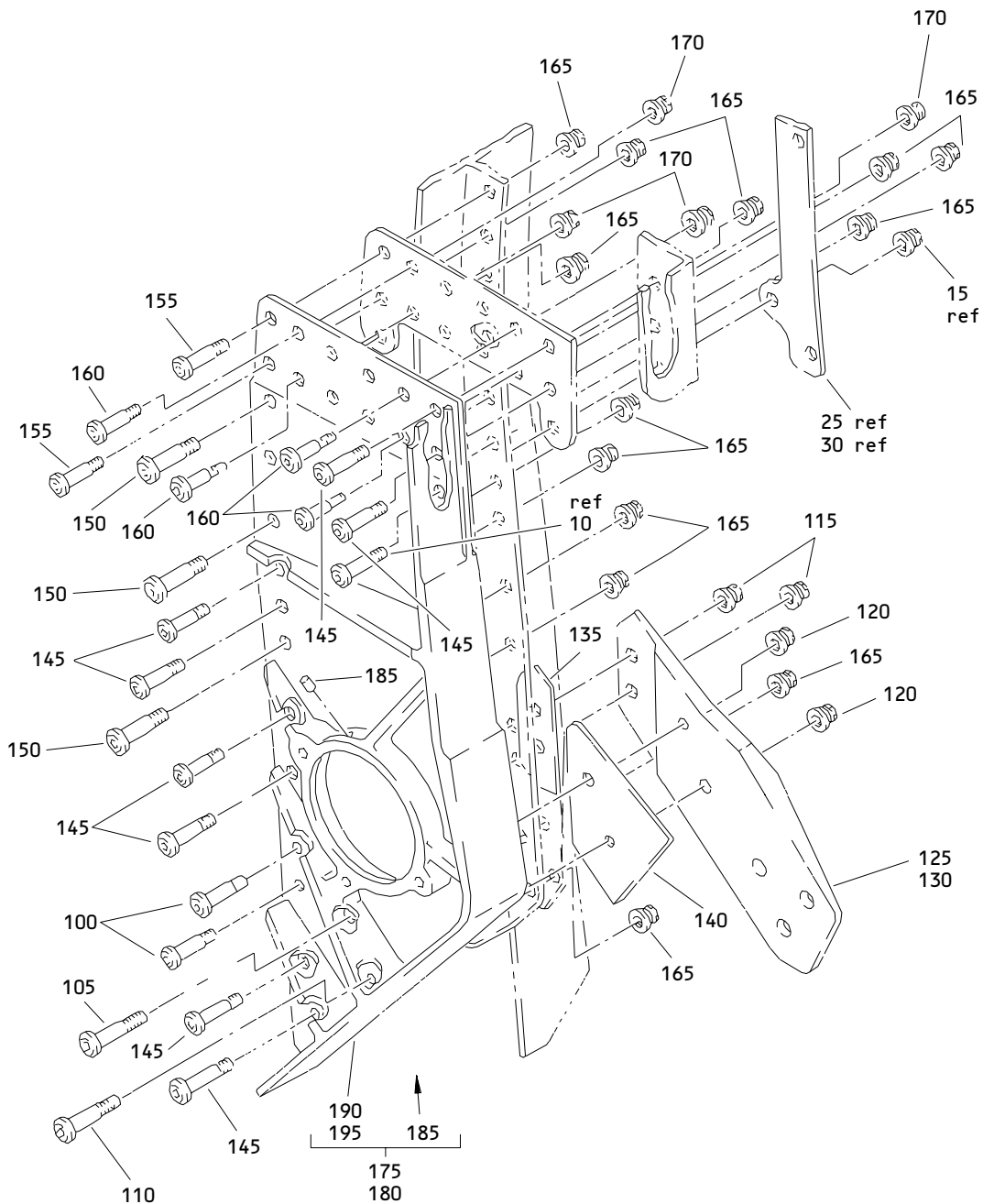
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Main Deck Cargo Door ATA 495.5 Frame Installation
Figure 14 (Sheet 3)

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Main Deck Cargo Door STA 495.5 Frame Installation
 Figure 14 (Sheet 4)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 14-					
R -1A	143T6224-1		FRAME INSTL-STA 495.5		RF
R -5	143T6224-2		FRAME INSTL-STA 628.5		RF
R 10	HL1012AZ8-7		.BOLT- (VOPTK6) (SPEC BACB30NX8K7) (OPT HL12VAZ8-7 (V73197)) (OPT HL12VAZ8-7 (V92215)) (OPT HL12VAZ8-7 (V97928)) (OPT L802-8K7 (V06725)) (OPT HL12VAZ8-7 (V56878)) (OPT HL1012AZ8-7 (V06725)) (OPT HL1012AZ8-7 (V06950)) (OPT HL1012AZ8-7 (V17446)) (OPT HL1012AZ8-7 (V56878)) (OPT HL1012AZ8-7 (V60516)) (OPT HL1012AZ8-7 (V73197)) (OPT HL1012AZ8-7 (V97928))		1
R 15	HL1187-8		.COLLAR- (V5M902) (SPEC BACC30X8) (OPT HL87-8 (V73197)) (OPT HL87-8 (V92215)) (OPT HL1187-8 (V56878)) (OPT HL1187-8 (V92215)) (OPT HL87-8 (V56878)) (OPT HL1187-8 (V73197))		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 14-20	BACR15FT6KE		.RIVET- (SIZE DETERMINE ON INST)		13
R 25	453T7036-7		.SUPPORT ASSY-SIDEWALL (USED ON ITEM 1A)		1
R 30	453T7036-8		.SUPPORT ASSY-SIDEWALL (USED ON ITEM 5)		1
R 35	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		12
R 40	BR2000C3D		..NUTPLATE- (V52828) (SPEC BACN10JR3CD) (OPT K51601-3BAC (V15653)) (OPT NS202439-02 (V80539)) (OPT 102A9201-3 (V72962))		6
R 45	453T7036-9		..BRACKET-SPRT		1
R 50	453T7036-5		.SUPPORT ASSY-SIDEWALL (USED ON ITEM 1A)		1
R 55	453T7036-6		.SUPPORT ASSY-SIDEWALL (USED ON ITEM 5)		1
R 60	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		14
R 65	BR2000C3D		..NUTPLATE- (V52828) (SPEC BACN10JR3CD) (OPT K51601-3BAC (V15653)) (OPT NS202439-02 (V80539)) (OPT 102A9201-3 (V72962))		7

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 14-70	453T7036-4		..BRACKET-SPRT		1
R 75	453T7036-1		.SUPPORT ASSY-SIDEWALL (USED ON ITEM 1A)		1
R 80	453T7036-2		.SUPPORT ASSY-SIDEWALL (USED ON ITEM 5)		1
R 85	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		14
R 90	BR2000C3D		..NUTPLATE- (V52828) (SPEC BACN10JR3CD) (OPT K51601-3BAC (V15653)) (OPT NS202439-02 (V80539)) (OPT 102A9201-3 (V72962))		7
R 95	453T7036-3		..BRACKET-SPRT		1
R 100	HL1012AZ8-7		.BOLT- (VOPTK6) (SPEC BACB30NX8K7) (OPT HL12VAZ8-7 (V73197)) (OPT HL12VAZ8-7 (V92215)) (OPT HL12VAZ8-7 (V97928)) (OPT L802-8K7 (V06725)) (OPT HL12VAZ8-7 (V56878)) (OPT HL1012AZ8-7 (V06725)) (OPT HL1012AZ8-7 (V06950)) (OPT HL1012AZ8-7 (V17446)) (OPT HL1012AZ8-7 (V56878)) (OPT HL1012AZ8-7 (V60516)) (OPT HL1012AZ8-7 (V73197)) (OPT HL1012AZ8-7 (V97928))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 14-105	HL1012AZ10-6		.BOLT- (VOPTK6) (SPEC BACB30NX10K6) (OPT HL12VAZ10-6 (V73197)) (OPT HL12VAZ10-6 (V92215)) (OPT HL12VAZ10-6 (V97928)) (OPT L802-10K6 (V06725)) (OPT HL12VAZ10-6 (V56878)) (OPT HL1012AZ10-6 (V06725)) (OPT HL1012AZ10-6 (V06950)) (OPT HL1012AZ10-6 (V17446)) (OPT HL1012AZ10-6 (V56878)) (OPT HL1012AZ10-6 (V60516)) (OPT HL1012AZ10-6 (V73197)) (OPT HL1012AZ10-6 (V97928))		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 14-110	HL1012AZ10-4		.BOLT- (V0PTK6) (SPEC BACB30NX10K4) (OPT HL12VAZ10-4 (V73197)) (OPT HL12VAZ10-4 (V92215)) (OPT HL12VAZ10-4 (V97928)) (OPT L802-10K4 (V06725)) (OPT HL12VAZ10-4 (V56878)) (OPT HL1012AZ10-4 (V06725)) (OPT HL1012AZ10-4 (V06950)) (OPT HL1012AZ10-4 (V17446)) (OPT HL1012AZ10-4 (V56878)) (OPT HL1012AZ10-4 (V60516)) (OPT HL1012AZ10-4 (V73197)) (OPT HL1012AZ10-4 (V97928))		1
R 115	HL1187-8		.COLLAR- (V5M902) (SPEC BACC30X8) (OPT HL87-8 (V73197)) (OPT HL87-8 (V92215)) (OPT HL1187-8 (V56878)) (OPT HL1187-8 (V92215)) (OPT HL87-8 (V56878)) (OPT HL1187-8 (V73197))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 14-120	HL1187-10		.COLLAR- (V5M902) (SPEC BACC30X10) (OPT HL87-10 (V73197)) (OPT HL87-10 (V92215)) (OPT HL1187-10 (V56878)) (OPT HL1187-10 (V92215)) (OPT HL87-10 (V56878)) (OPT HL1187-10 (V73197))		2
R 125	143T6225-1		.FITTING-RAMP SPRT (USED ON ITEM 1A)		1
R 130	143T6225-2		.FITTING-RAMP SPRT (USED ON ITEM 5)		1
R 135	BACS40R011F025F		.SHIM		1
R 140	143T6224-13		.SHIM		AR

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
R 14-145	HL1012AZ8-5		1234567 .BOLT- (V0PTK6) (SPEC BACB30NX8K5) (OPT HL12VAZ8-5 (V73197)) (OPT HL12VAZ8-5 (V92215)) (OPT HL12VAZ8-5 (V97928)) (OPT L802-8K5 (V06725)) (OPT HL12VAZ8-5 (V56878)) (OPT HL1012AZ8-5 (V06725)) (OPT HL1012AZ8-5 (V06950)) (OPT HL1012AZ8-5 (V17446)) (OPT HL1012AZ8-5 (V56878)) (OPT HL1012AZ8-5 (V60516)) (OPT HL1012AZ8-5 (V73197)) (OPT HL1012AZ8-5 (V97928))		8

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 14-150	HL1012AZ8-6		.BOLT- (VOPTK6) (SPEC BACB30NX8K6) (OPT HL12VAZ8-6 (V73197)) (OPT HL12VAZ8-6 (V92215)) (OPT HL12VAZ8-6 (V97928)) (OPT L802-8K6 (V06725)) (OPT HL12VAZ8-6 (V56878)) (OPT HL1012AZ8-6 (V06725)) (OPT HL1012AZ8-6 (V06950)) (OPT HL1012AZ8-6 (V17446)) (OPT HL1012AZ8-6 (V56878)) (OPT HL1012AZ8-6 (V60516)) (OPT HL1012AZ8-6 (V73197)) (OPT HL1012AZ8-6 (V97928))		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
R 14-155	HL1012AZ8-4		1234567 .BOLT- (VOPTK6) (SPEC BACB30NX8K4) (OPT HL12VAZ8-4 (V73197)) (OPT HL12VAZ8-4 (V92215)) (OPT HL12VAZ8-4 (V97928)) (OPT L802-8K4 (V06725)) (OPT HL12VAZ8-4 (V56878)) (OPT HL1012AZ8-4 (V06725)) (OPT HL1012AZ8-4 (V06950)) (OPT HL1012AZ8-4 (V17446)) (OPT HL1012AZ8-4 (V56878)) (OPT HL1012AZ8-4 (V60516)) (OPT HL1012AZ8-4 (V73197)) (OPT HL1012AZ8-4 (V97928))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 14-160	HL1012AZ6-4		.BOLT- (V97928) (SPEC BACB30NX6K4) (OPT HL12VAZ6-4 (V73197)) (OPT HL12VAZ6-4 (V92215)) (OPT HL12VAZ6-4 (V97928)) (OPT L802-6K4 (V06725)) (OPT HL12VAZ6-4 (V56878)) (OPT HL1012AZ6-4 (V0PTK6)) (OPT HL1012AZ6-4 (V06725)) (OPT HL1012AZ6-4 (V06950)) (OPT HL1012AZ6-4 (V17446)) (OPT HL1012AZ6-4 (V56878)) (OPT HL1012AZ6-4 (V60516)) (OPT HL1012AZ6-4 (V73197))		8
R 165	HL1187-8		.COLLAR- (V5M902) (SPEC BACC30X8) (OPT HL87-8 (V73197)) (OPT HL87-8 (V92215)) (OPT HL1187-8 (V56878)) (OPT HL1187-8 (V92215)) (OPT HL87-8 (V56878)) (OPT HL1187-8 (V73197))		14

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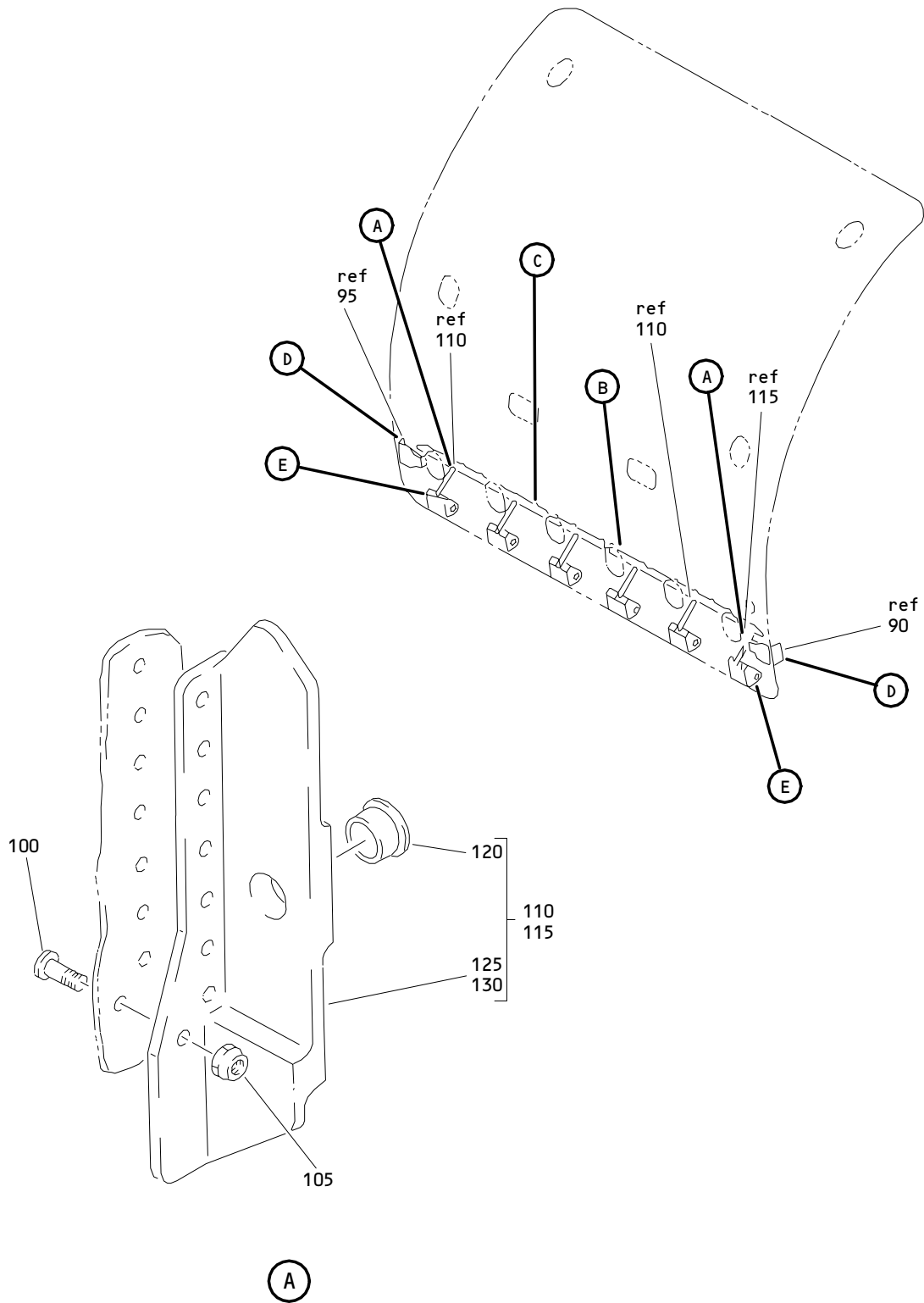

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 14-170	HL1187-6		.COLLAR- (V5M902) (SPEC BACC30X6) (OPT HL87-6 (V73197)) (OPT HL87-6 (V92215)) (OPT HL1187-6 (V56878)) (OPT HL1187-6 (V92215)) (OPT HL87-6 (V56878)) (OPT HL1187-6 (V73197))		8
R 175	143T6228-1		.FITTING ASSY-PULL-IN HOOK SPRT (USED ON ITEM 1A)		1
R 180	143T6228-2		.FITTING ASSY-PULL-IN HOOK SPRT (USED ON ITEM 5)		1
R 185	NAS516-1A		..FITTING		1
R 190	143T6228-3		..FITTING- (USED ON ITEM 175)		1
R 195	143T6228-4		..FITTING- (USED ON ITEM 180)		1

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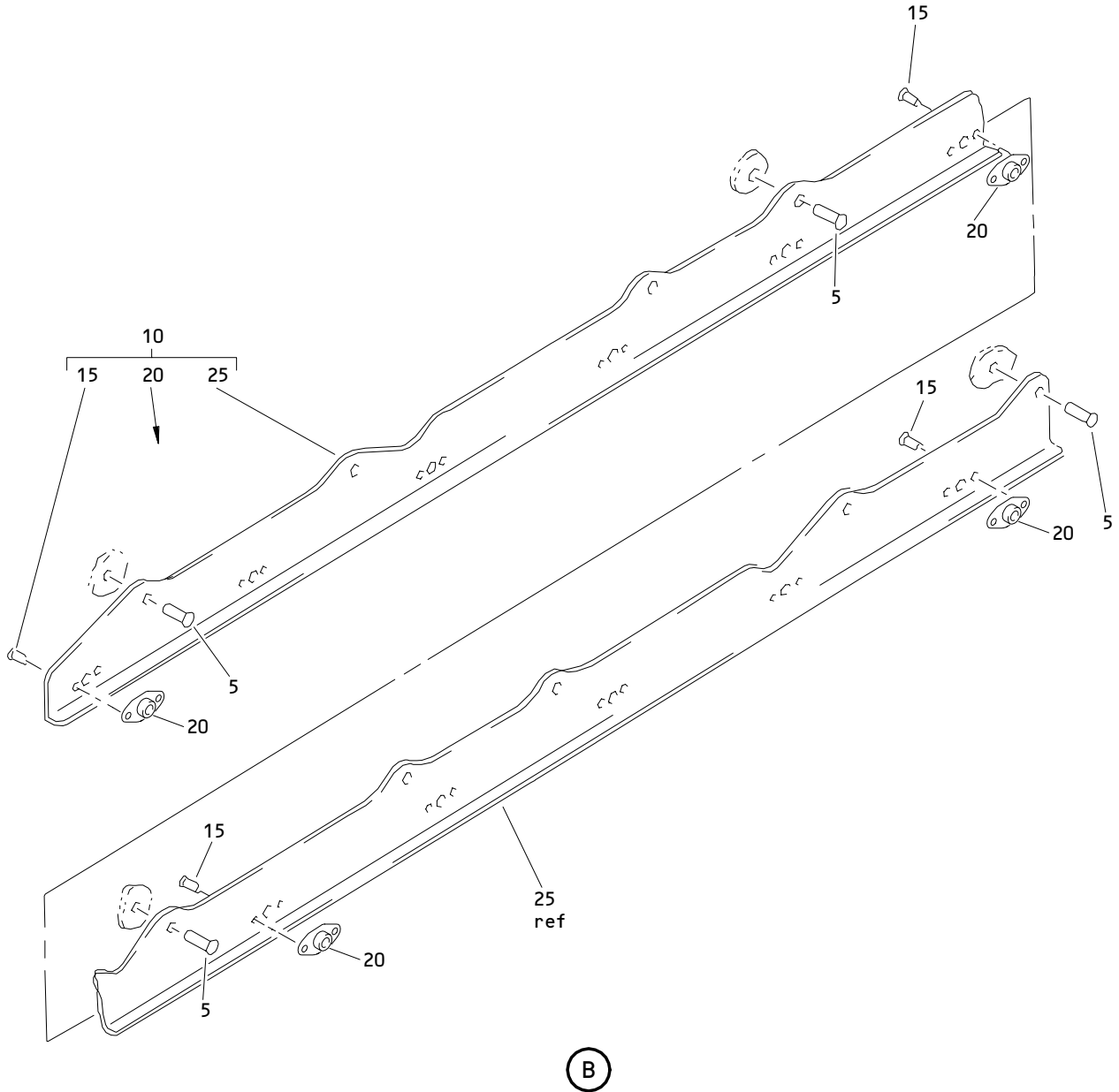
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Main Deck Cargo Door Lower Beam Installation
 Figure 15 (Sheet 1)

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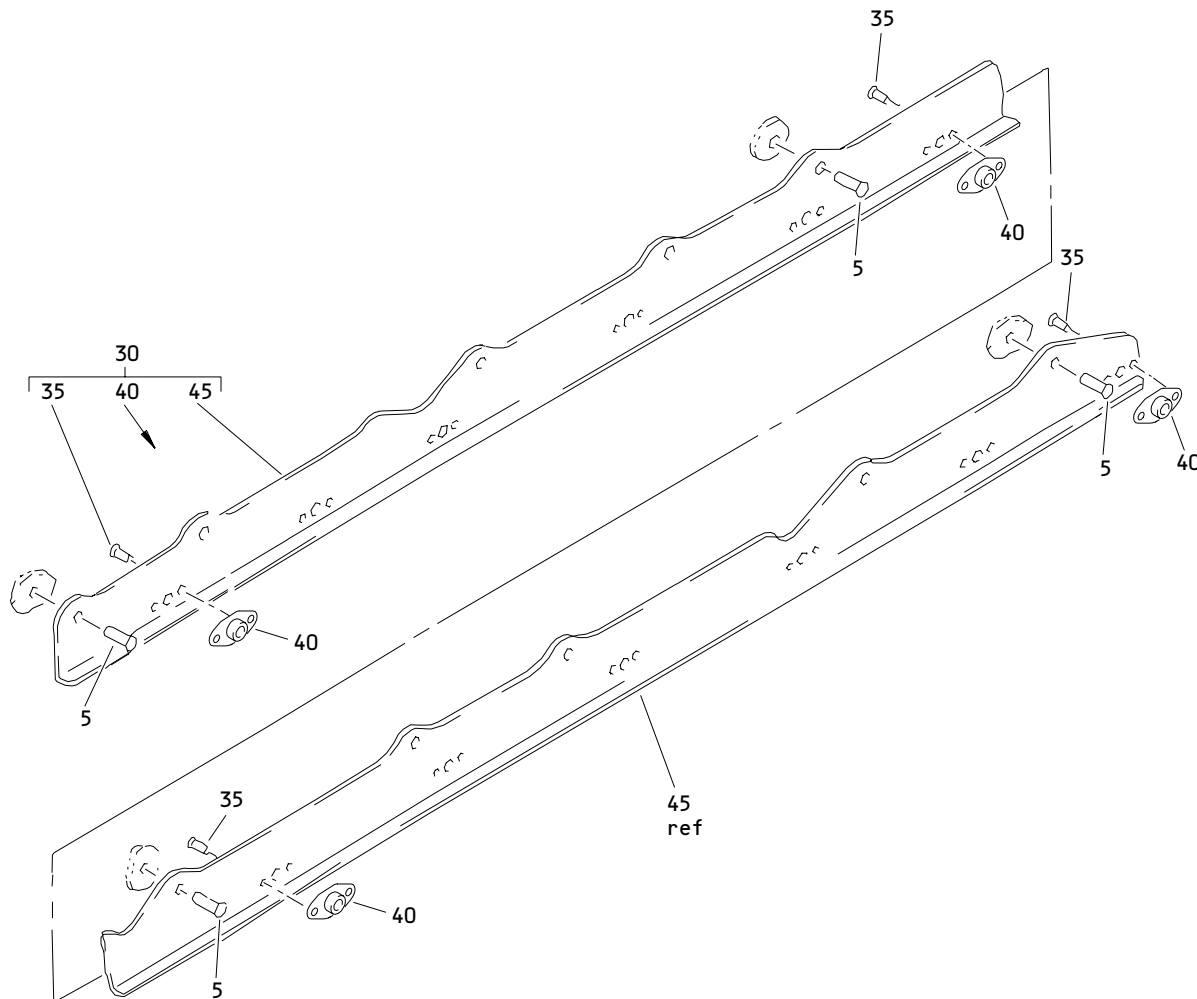
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Main Deck Cargo Door Lower Beam Installation
Figure 15 (Sheet 2)

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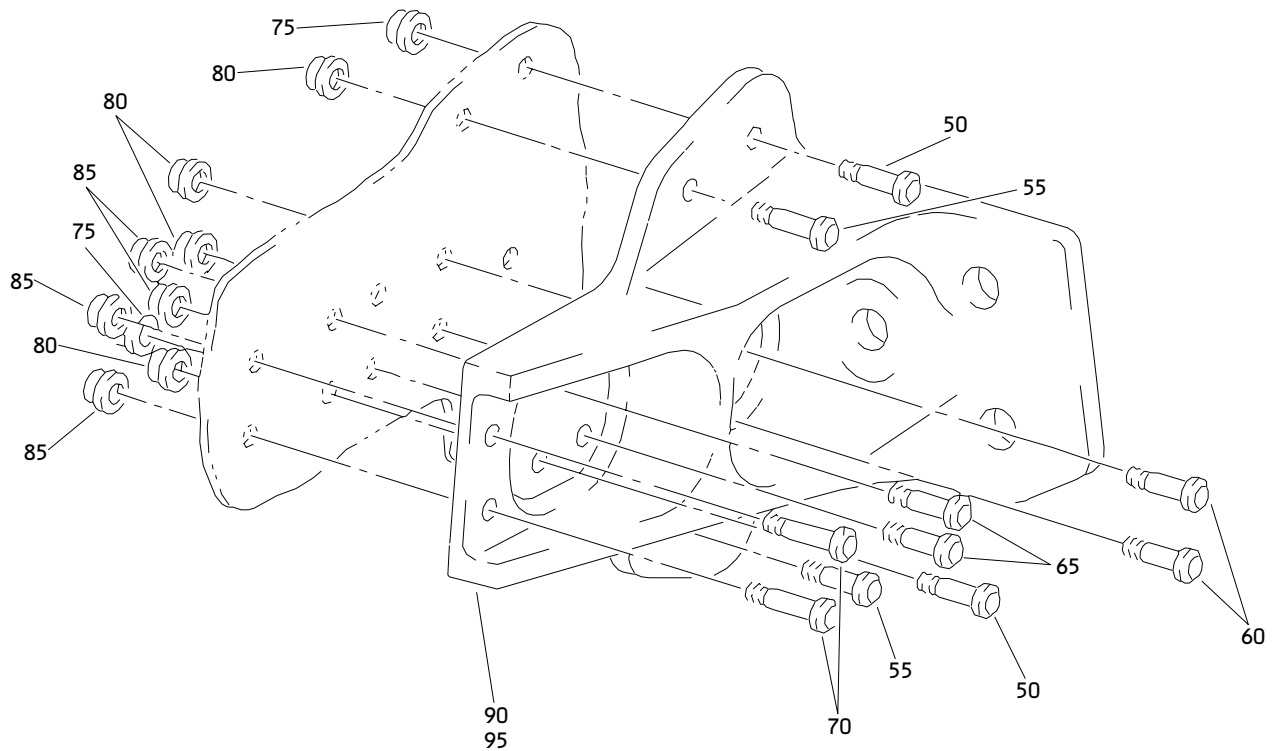


(C)

Main Deck Cargo Door Lower Beam Installation
Figure 15 (Sheet 3)

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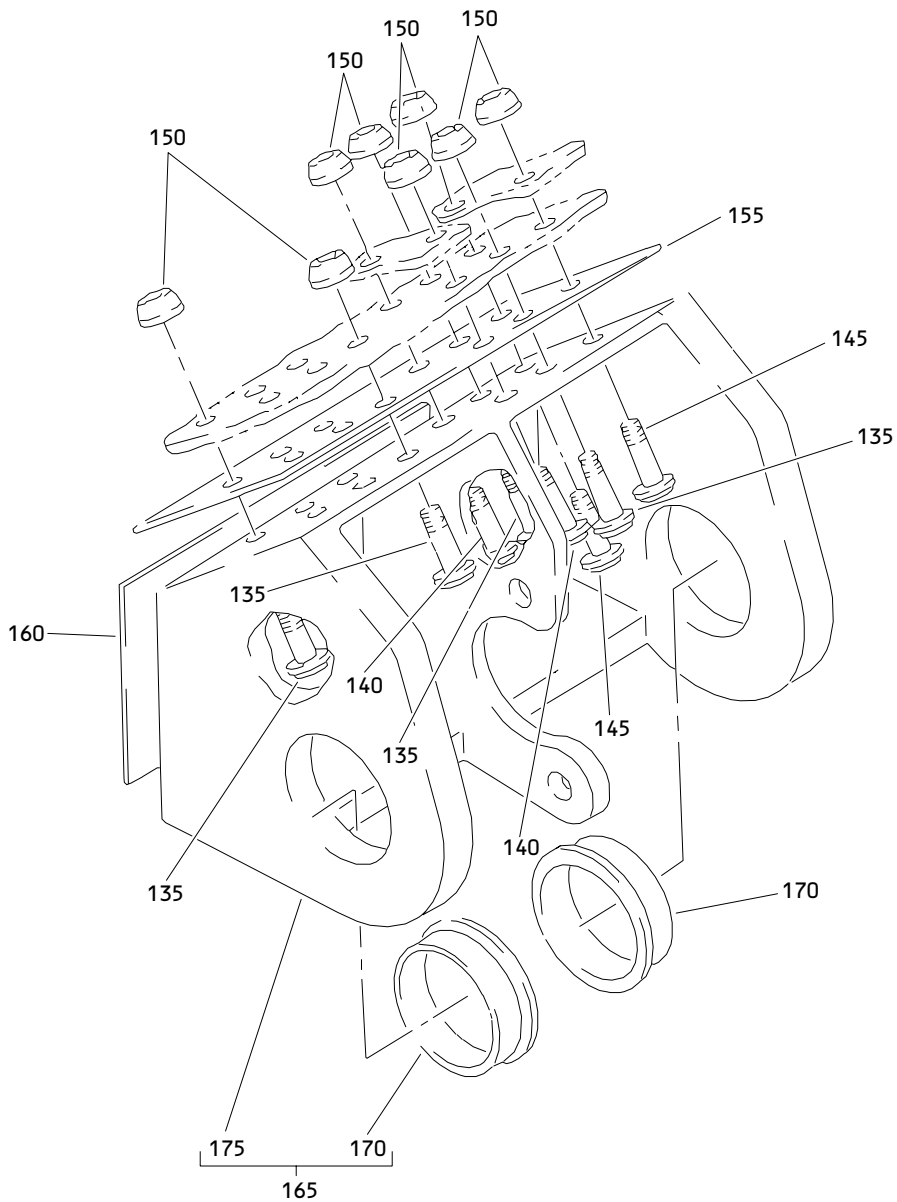


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Main Deck Cargo Door Lower Beam Installation
Figure 15 (Sheet 4)

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(E)

Main Deck Cargo Door Lower Beam Installation
Figure 15 (Sheet 5)

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 COMPONENT
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 15-					
R -1A	143T6218-1		BEAM INSTL-LWR		RF
R 5	BACR15BA5AD		.RIVET-		19
			(SIZE DETERMINE ON INST)		
R 10	453T7034-55		.SUPPORT ASSY-SIDEWALL		1
R 15	BACR15BA3AD		..RIVET-		22
			(SIZE DETERMINE ON INST)		
R 20	BRF200C3D		..NUTPLATE-		11
			(V52828)		
			(SPEC BACN10JR3CFD)		
			(OPT K51602-3BAC		
			(V15653))		
			(OPT NS202476-02		
			(V80539))		
			(OPT 102F9201-3		
			(V72962))		
			(OPT T8092C1032CD		
			(V11815))		
R 25	453T7034-56		..ANGLE		1
R 30	453T7034-53		.SUPPORT ASSY-SIDEWALL		1
R 35	BACR15BA3AD		..RIVET-		24
			(SIZE DETERMINE ON INST)		
R 40	BRF200C3D		..NUTPLATE-		12
			(V52828)		
			(SPEC BACN10JR3CFD)		
			(OPT K51602-3BAC		
			(V15653))		
			(OPT NS202476-02		
			(V80539))		
			(OPT 102F9201-3		
			(V72962))		
			(OPT T8092C1032CD		
			(V11815))		
R 45	453T7034-54		..ANGLE		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 15-50	HL1012AZ10-8		.BOLT- (VOPTK6) (SPEC BACB30NX10K8) (OPT HL12VAZ10-8 (V73197)) (OPT HL12VAZ10-8 (V92215)) (OPT HL12VAZ10-8 (V97928)) (OPT L802-10K8 (V06725)) (OPT HL12VAZ10-8 (V56878)) (OPT HL1012AZ10-8 (V06725)) (OPT HL1012AZ10-8 (V06950)) (OPT HL1012AZ10-8 (V17446)) (OPT HL1012AZ10-8 (V56878)) (OPT HL1012AZ10-8 (V60516)) (OPT HL1012AZ10-8 (V73197)) (OPT HL1012AZ10-8 (V97928))		6

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 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 15-55	HL1012AZ8-6		.BOLT- (V0PTK6) (SPEC BACB30NX8K6) (OPT HL12VAZ8-6 (V73197)) (OPT HL12VAZ8-6 (V92215)) (OPT HL12VAZ8-6 (V97928)) (OPT L802-8K6 (V06725)) (OPT HL12VAZ8-6 (V56878)) (OPT HL1012AZ8-6 (V06725)) (OPT HL1012AZ8-6 (V06950)) (OPT HL1012AZ8-6 (V17446)) (OPT HL1012AZ8-6 (V56878)) (OPT HL1012AZ8-6 (V60516)) (OPT HL1012AZ8-6 (V73197)) (OPT HL1012AZ8-6 (V97928))		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 15-60	HL1012AZ8-4		.BOLT- (VOPTK6) (SPEC BACB30NX8K4) (OPT HL12VAZ8-4 (V73197)) (OPT HL12VAZ8-4 (V92215)) (OPT HL12VAZ8-4 (V97928)) (OPT L802-8K4 (V06725)) (OPT HL12VAZ8-4 (V56878)) (OPT HL1012AZ8-4 (V06725)) (OPT HL1012AZ8-4 (V06950)) (OPT HL1012AZ8-4 (V17446)) (OPT HL1012AZ8-4 (V56878)) (OPT HL1012AZ8-4 (V60516)) (OPT HL1012AZ8-4 (V73197)) (OPT HL1012AZ8-4 (V97928))		4

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**COMPONENT
 MAINTENANCE MANUAL**

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 15-65	HL1012AZ6-4		.BOLT- (V97928) (SPEC BACB30NX6K4) (OPT HL12VAZ6-4 (V73197)) (OPT HL12VAZ6-4 (V92215)) (OPT HL12VAZ6-4 (V97928)) (OPT L802-6K4 (V06725)) (OPT HL12VAZ6-4 (V56878)) (OPT HL1012AZ6-4 (V0PTK6)) (OPT HL1012AZ6-4 (V06725)) (OPT HL1012AZ6-4 (V06950)) (OPT HL1012AZ6-4 (V17446)) (OPT HL1012AZ6-4 (V56878)) (OPT HL1012AZ6-4 (V60516)) (OPT HL1012AZ6-4 (V73197))		8

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 15-70	HL1012AZ6-7		.BOLT- (V97928) (SPEC BACB30NX6K7) (OPT HL12VAZ6-7 (V73197)) (OPT HL12VAZ6-7 (V92215)) (OPT HL12VAZ6-7 (V97928)) (OPT L802-6K7 (V06725)) (OPT HL12VAZ6-7 (V56878)) (OPT HL1012AZ6-7 (V0PTK6)) (OPT HL1012AZ6-7 (V06725)) (OPT HL1012AZ6-7 (V06950)) (OPT HL1012AZ6-7 (V17446)) (OPT HL1012AZ6-7 (V56878)) (OPT HL1012AZ6-7 (V60516)) (OPT HL1012AZ6-7 (V73197))		4
R 75	HL1187-10		.COLLAR- (V5M902) (SPEC BACC30X10) (OPT HL87-10 (V73197)) (OPT HL87-10 (V92215)) (OPT HL1187-10 (V56878)) (OPT HL1187-10 (V92215)) (OPT HL87-10 (V56878)) (OPT HL1187-10 (V73197))		6

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 15-80	HL1187-8		.COLLAR- (V5M902) (SPEC BACC30X8) (OPT HL87-8 (V73197)) (OPT HL87-8 (V92215)) (OPT HL1187-8 (V56878)) (OPT HL1187-8 (V92215)) (OPT HL87-8 (V56878)) (OPT HL1187-8 (V73197))		8
R 85	HL1187-6		.COLLAR- (V5M902) (SPEC BACC30X6) (OPT HL87-6 (V73197)) (OPT HL87-6 (V92215)) (OPT HL1187-6 (V56878)) (OPT HL1187-6 (V92215)) (OPT HL87-6 (V56878)) (OPT HL1187-6 (V73197))		12
R 90	143T6223-2		.FITTING-BACKUP		1
R 95	143T6223-1		.FITTING-BACKUP		1
R 100	HST10AG6-5		.BOLT- (VOPTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197))		48

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 15-105	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))		48
R 110	143T6221-1		.FITTING ASSY		5
R 115	143T6221-2		.FITTING ASSY		1
R 120	BACB28X8C045		..BUSHING		1
R 125	143T6221-5		..FITTING- (USED ON ITEM 110)		1
R 130	143T6221-6		..FITTING- (USED ON ITEM 115)		1
R 135	HST10AG8-7		.BOLT- (VOPTK6) (SPEC BACB30VT8K7) (OPT HST10AG8-7 (V06725)) (OPT HST10AG8-7 (V56878)) (OPT HST10AG8-7 (V73197))		48
R 140	HST10AG8-10		.BOLT- (VOPTK6) (SPEC BACB30VT8K10) (OPT HST10AG8-10 (V06725)) (OPT HST10AG8-10 (V56878)) (OPT HST10AG8-10 (V73197))		12
R 145	HST10AG8-8		.BOLT- (VOPTK6) (SPEC BACB30VT8K8) (OPT HST10AG8-8 (V06725)) (OPT HST10AG8-8 (V56878)) (OPT HST10AG8-8 (V73197))		12

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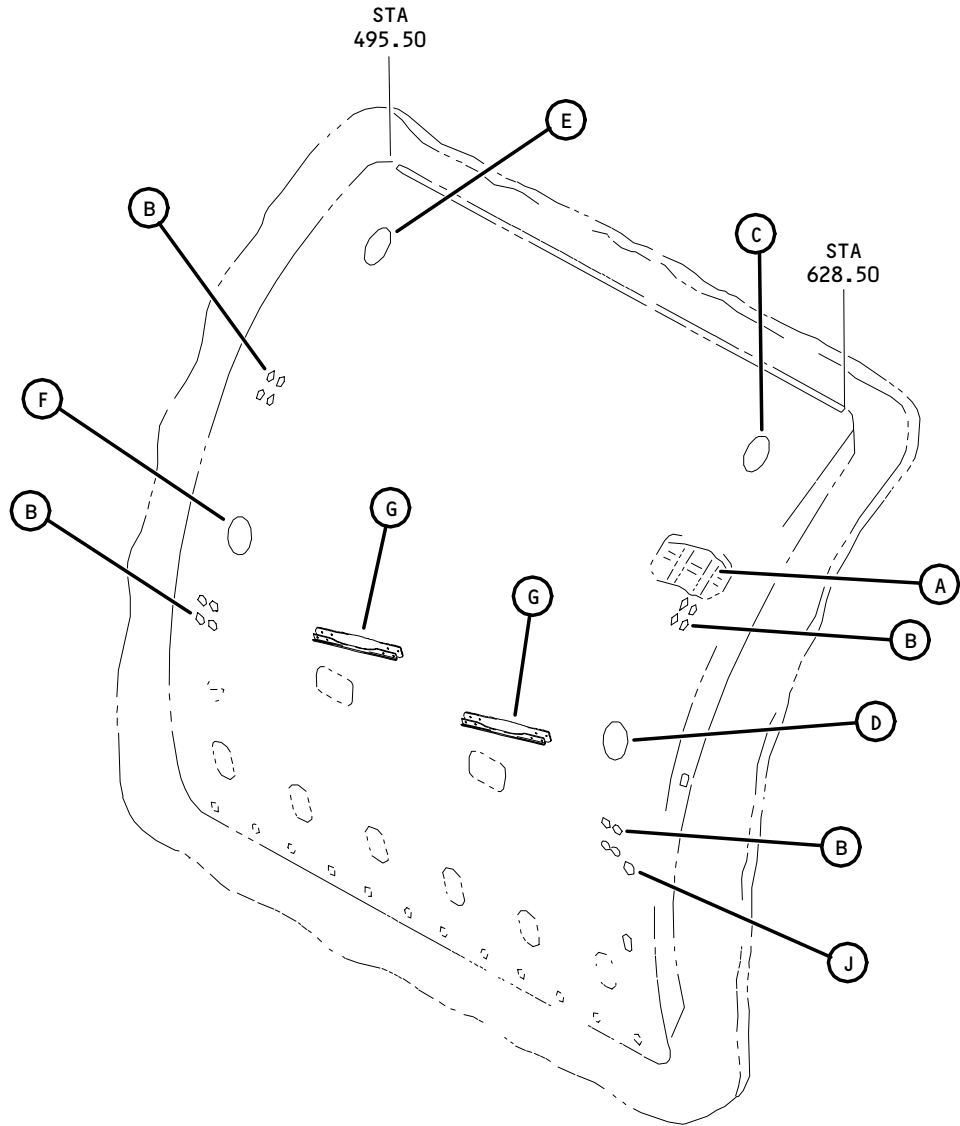

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 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 15- 150	HST79CY8		.COLLAR- (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))		72
R 155	BACS40R021C036F		.SHIM		6
R 160	BACS40R032C065F		.SHIM		6
R 165	143T6220-1		.FITTING ASSY-SHEAR		6
R 170	012T2400-29		..BUSHING		2
R 175	143T6220-3		..FITTING		1

- Item Not Illustrated

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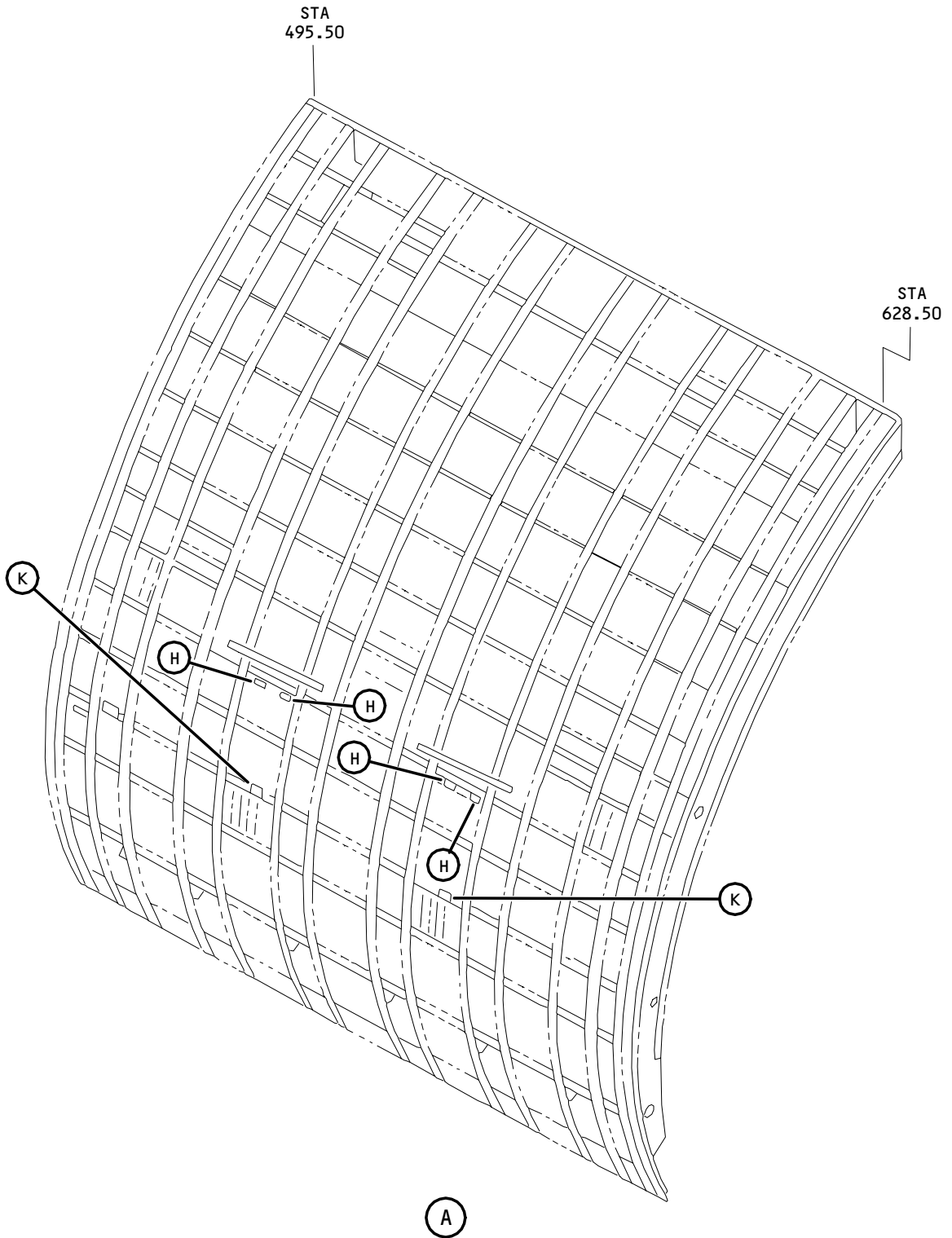
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Main Deck Cargo Door Outer Skin Installation
Figure 16 (Sheet 1)

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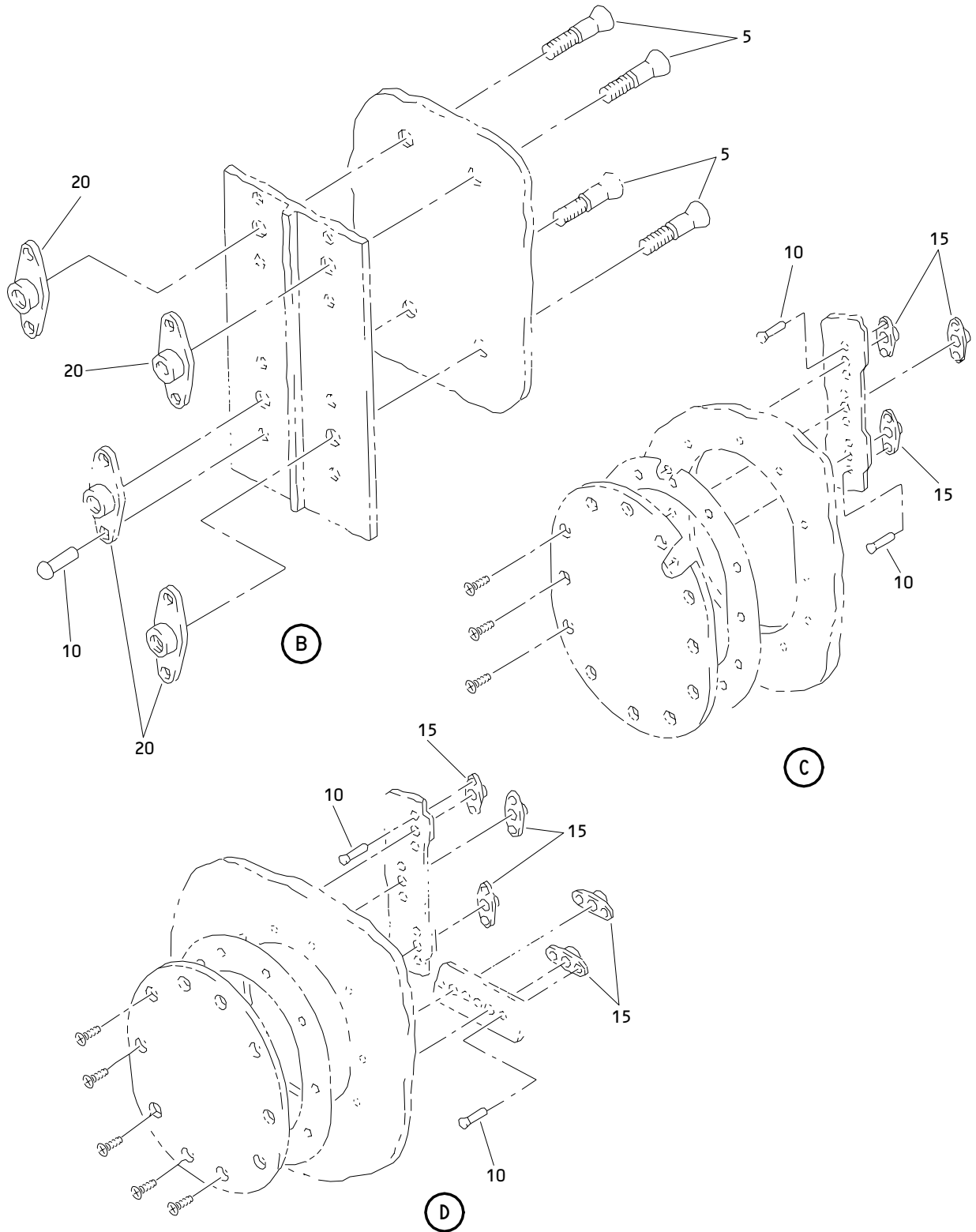
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Main Deck Cargo Door Outer Skin Installation
Figure 16 (Sheet 2)

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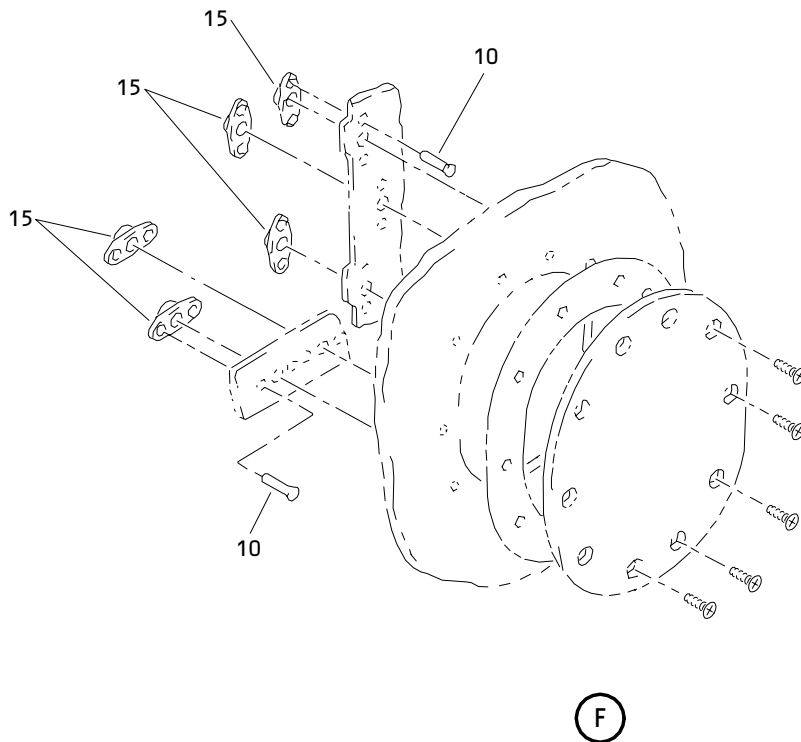
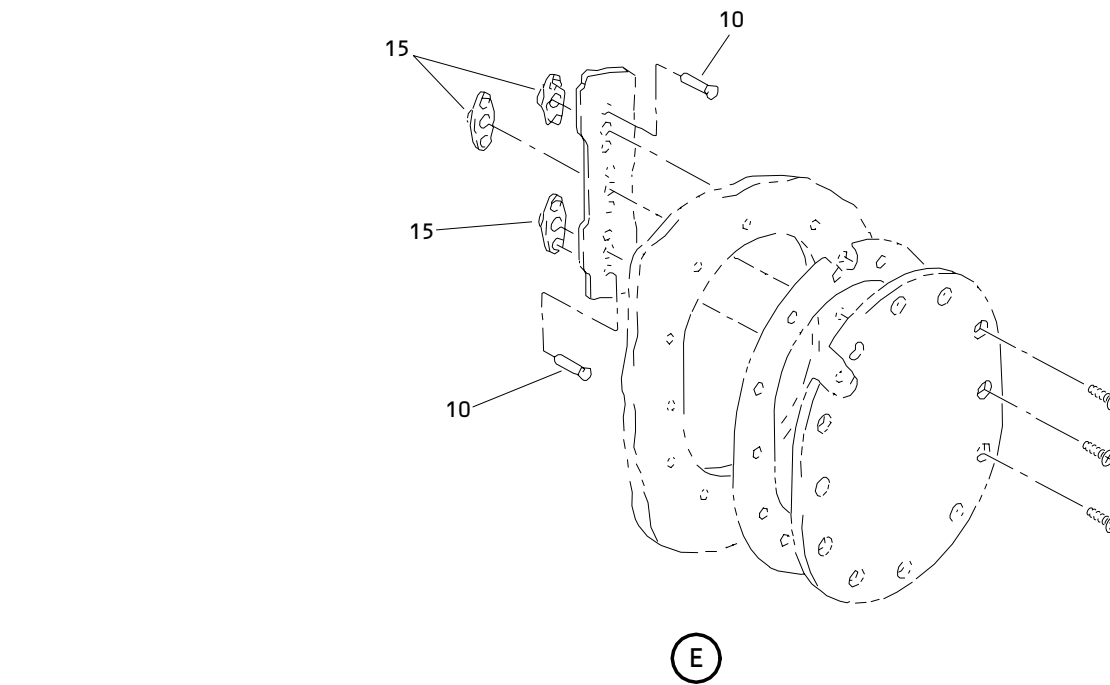
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Main Deck Cargo Door Outer Skin Installation
Figure 16 (Sheet 3)

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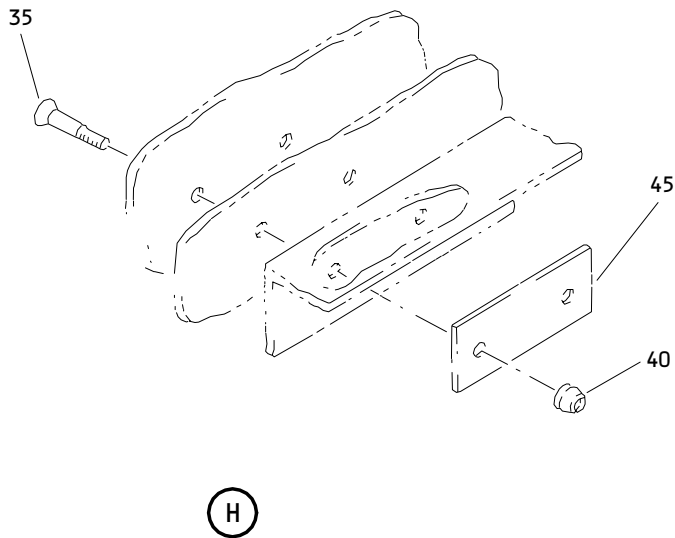
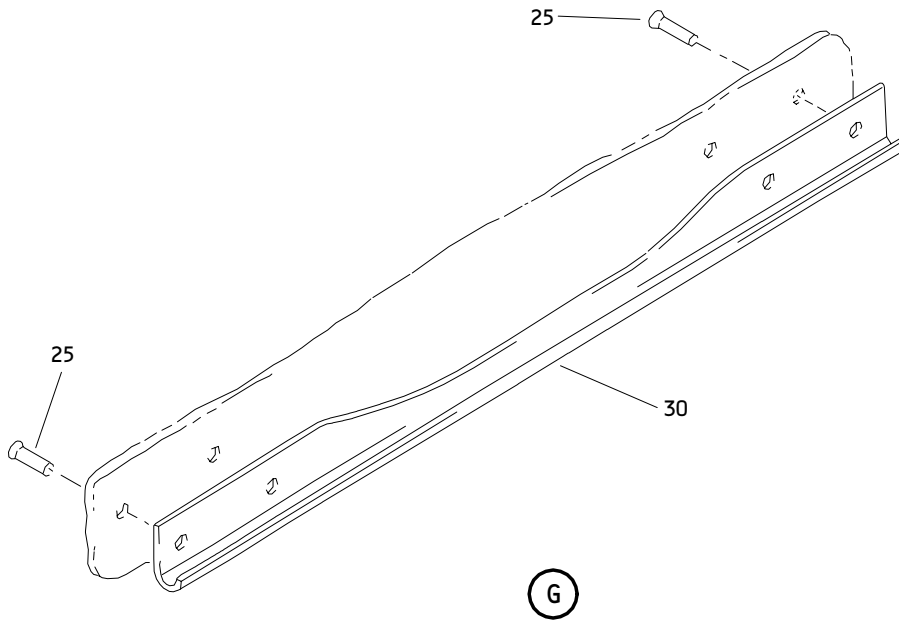
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Main Deck Cargo Door Outer Skin Installation
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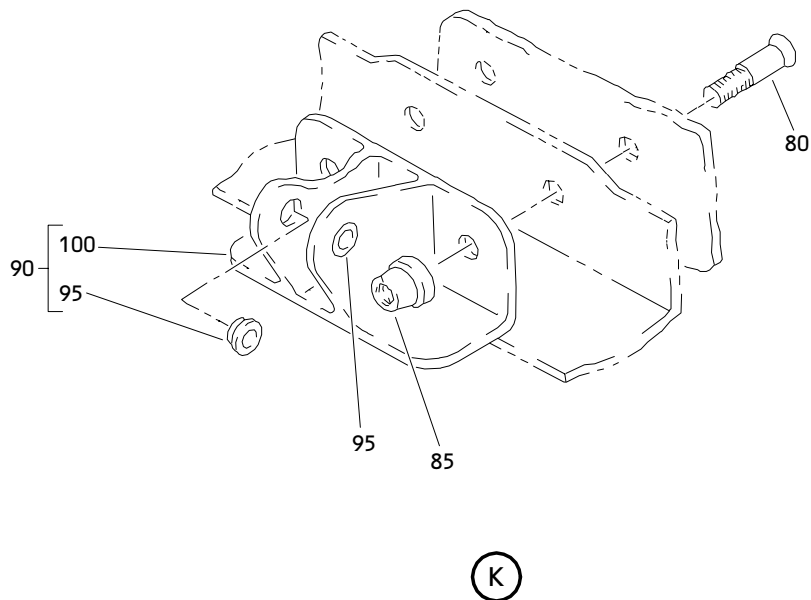
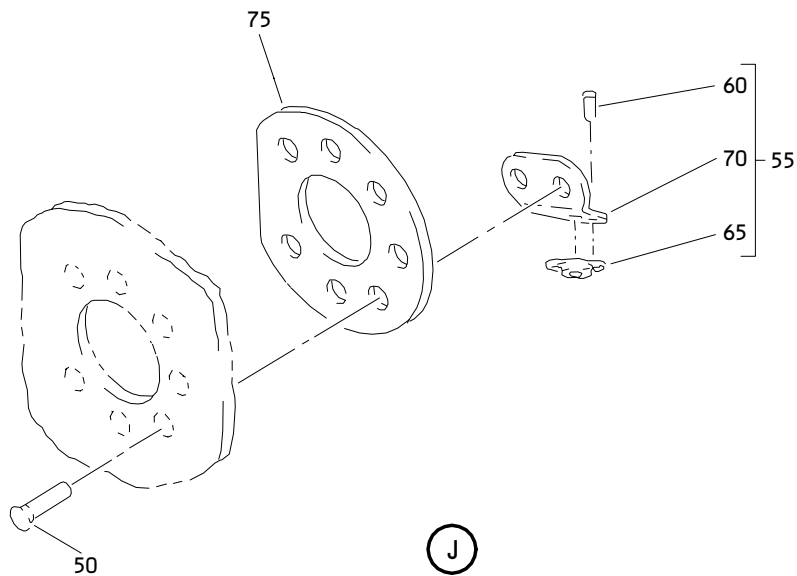
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Main Deck Cargo Door Outer Skin Installation
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Main Deck Cargo Door Outer Skin Installation
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 16-					
R -1A	143T6272-1		SKIN INSTL-OUTER		RF
R 5	BACB30VF4K6		.BOLT		8
R 7	BACB30VF4K7		.BOLT		8
R 10	BACR15CE3AD		.RIVET-		64
			(SIZE DETERMINE ON INST)		
R 15	NS103191-02-2		.NUTPLATE-		16
			(V80539)		
			(SPEC BACN10KE3B2)		
			(OPT F51750-3-2		
			(V15653))		
			(OPT RMF9213-2-3		
			(V72962))		
			(OPT BRFR220A3-2		
			(V52825))		
R 20	F51643-4BAC		.NUTPLATE-		16
			(V15653)		
			(SPEC BACN10JZ4A2CDM)		
			(OPT 102F9219-4		
			(V72962))		
			(OPT NS202492-048		
			(V80539))		
R 25	BACR15FV5KE		.RIVET-		8
			(SIZE DETERMINE ON INST)		
R 30	143T6286-1		.GUTTER-RAIN		2
R 35	HST11AG6-6		.BOLT-		8
			(V06725)		
			(SPEC BACB30VU6K6)		
			(OPT HST11AG6-6		
			(V73197))		
			(OPT HST11AG6-6		
			(V56878))		
			(OPT HST11AG6-6		
			(VOPTK6))		
R 40	HST79CY6		.COLLAR-		8
			(V73197)		
			(SPEC BACC30BL6)		
			(OPT HST79-6		
			(V56878))		
			(OPT HST79-6		
			(V92215))		
			(OPT HST79-6		
			(V5M902))		
R 45	143T6276-3		.PLATE-BRG		4
R 50	BACR15FV6KE		.RIVET-		7
			(SIZE DETERMINE ON INST)		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 16-55	69B16419-1		.CLIP ASSY		1
R 60	BACR15CE3D		..RIVET- (SIZE DETERMINE ON INST)		2
R 65	BRM200C3MK		DELETED		
R 65A	BRM200C3M		..NUTPLATE- (V52828) (SPEC BACN10JP3ACM) (OPT MK1001-3BAC (V15653)) (OPT NS103197SE02 (V80539)) (OPT T8080C1032 (V11815)) (OPT VN202D1-02 (V92215)) (OPT 109A9201M3 (V72962))		1
R 70	69B16419-2		..CLIP		1
R 75	143T6276-2		.DOUBLER		1
R 80	HST11AG6-5		.BOLT- (V06725) (SPEC BACB30VU6K5) (OPT HST11AG6-5 (V73197)) (OPT HST11AG6-5 (V56878)) (OPT HST11AG6-5 (VOPTK6))		4
R 85	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))		4
R 90	143T6558-1		.SUPPORT ASSY-VENT DOOR EXTENSION SPR		2
R 95	BACB28X4M010		..BUSHING		2
R 100	143T6558-2		..SUPPORT		1

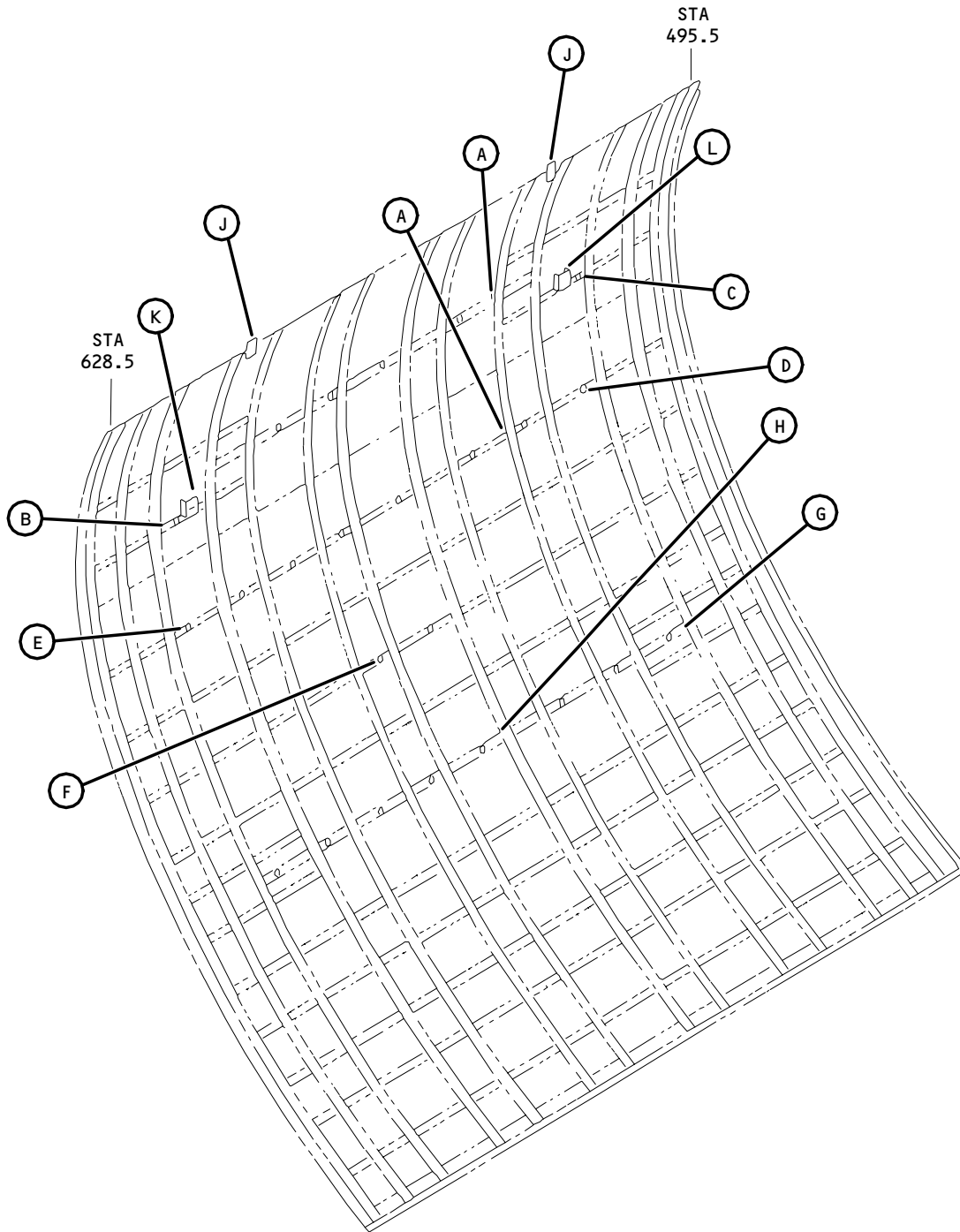
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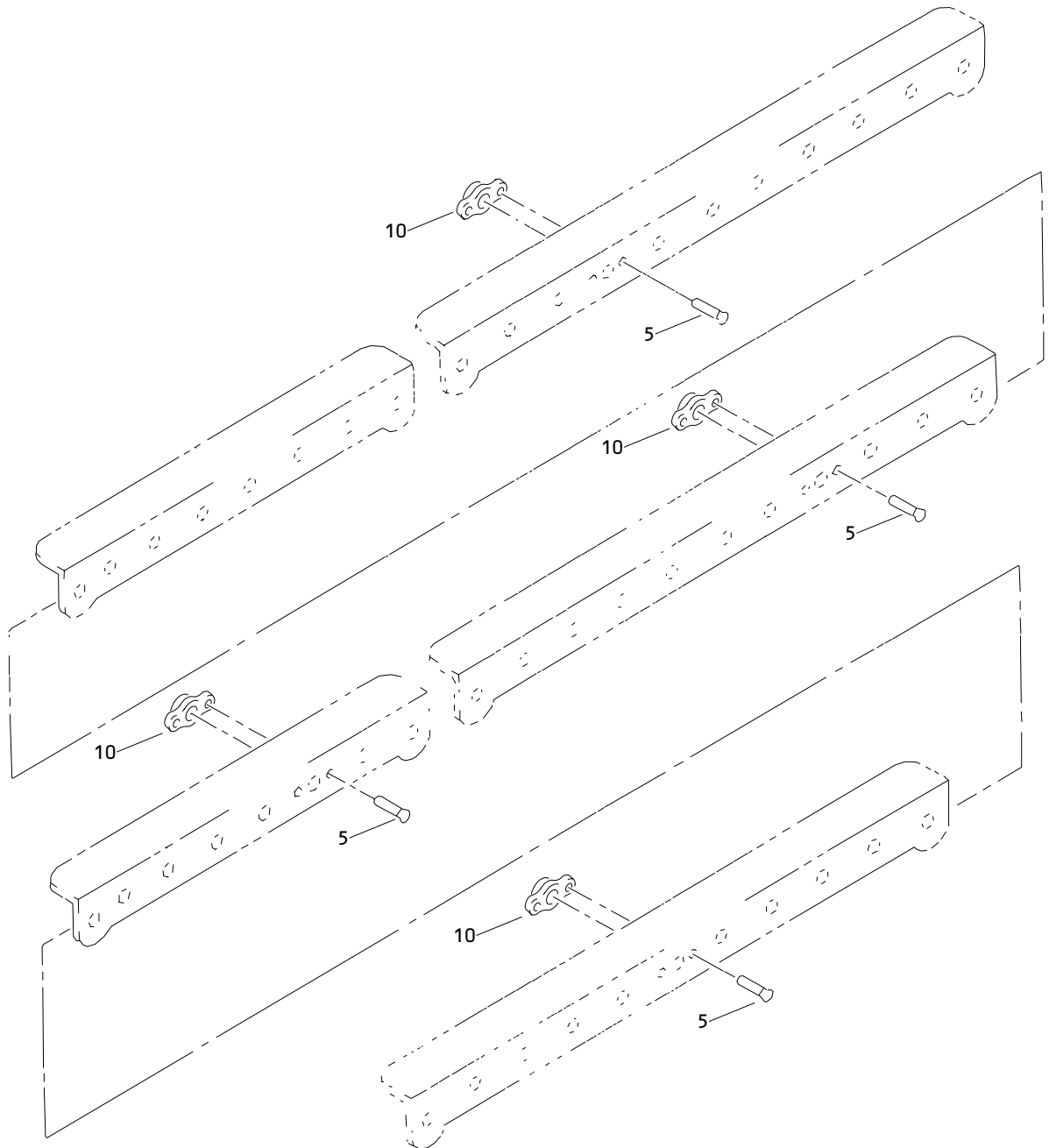
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Main Deck Cargo Door Inner Skin Installation
Figure 17 (Sheet 1)

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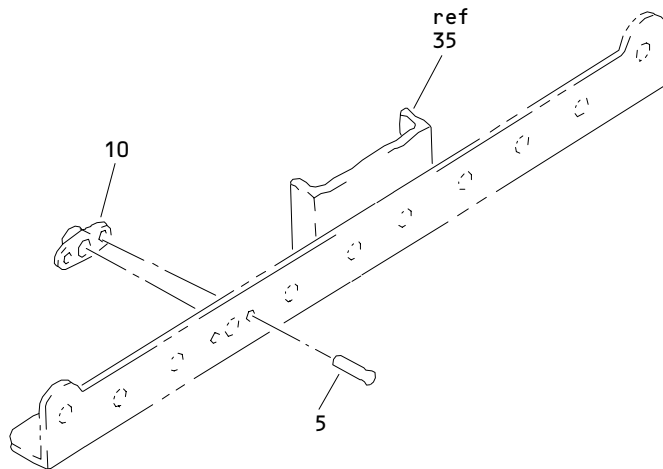


(A)

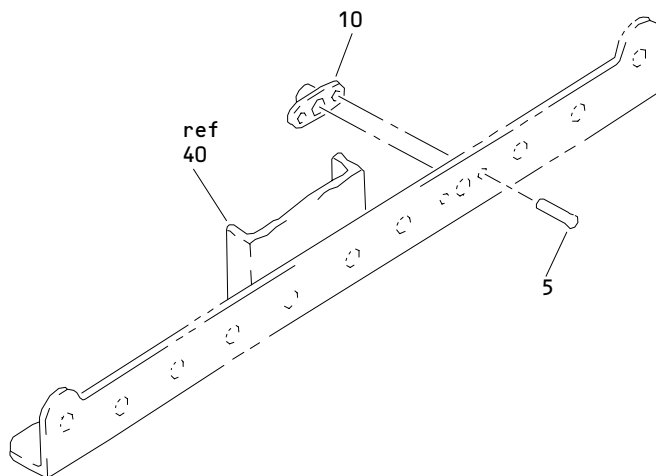
Main Deck Cargo Door Inner Skin Installation
Figure 17 (Sheet 2)

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(B)

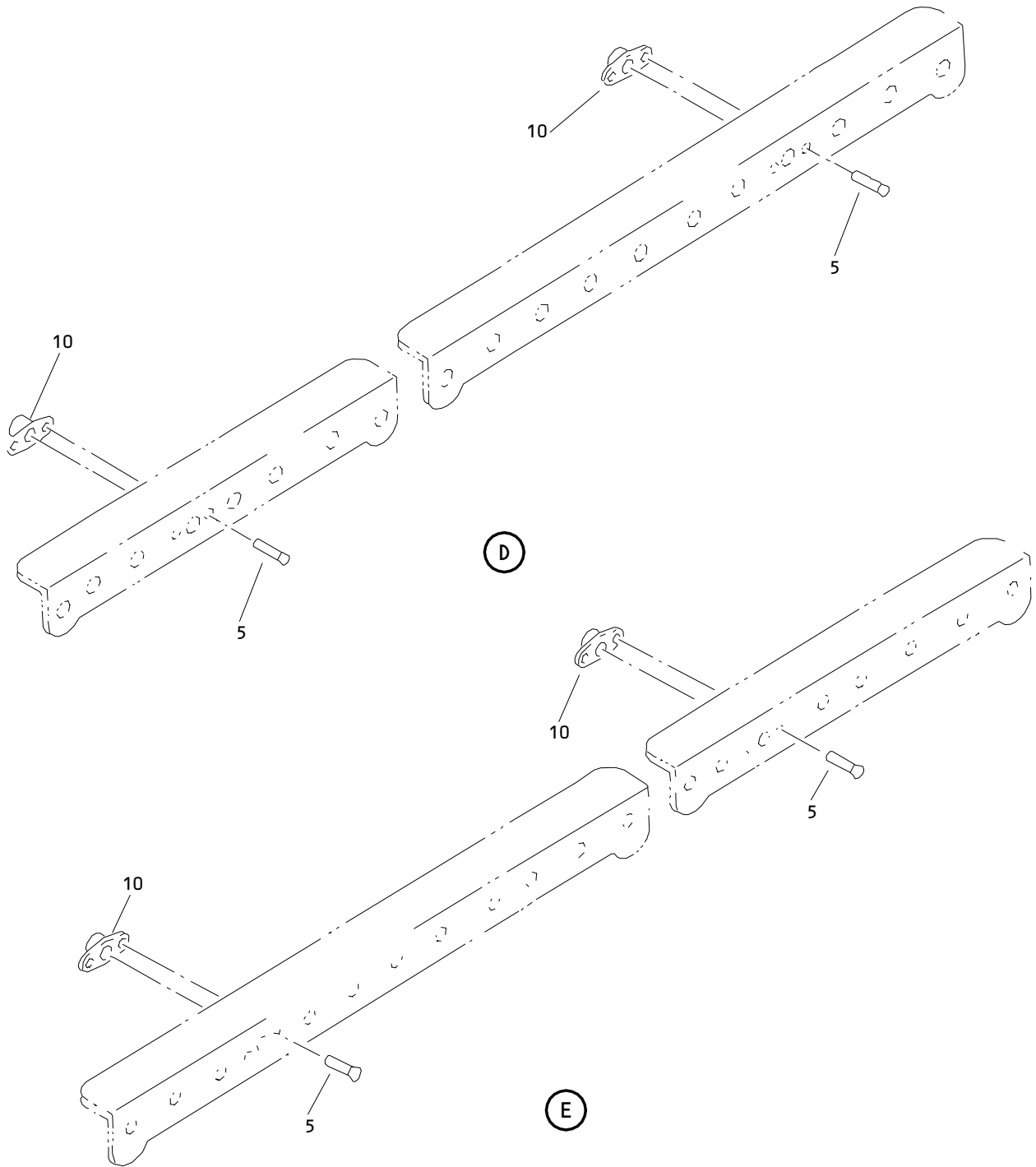


(C)

Main Deck Cargo Door Inner Skin Installation
Figure 17 (Sheet 3)

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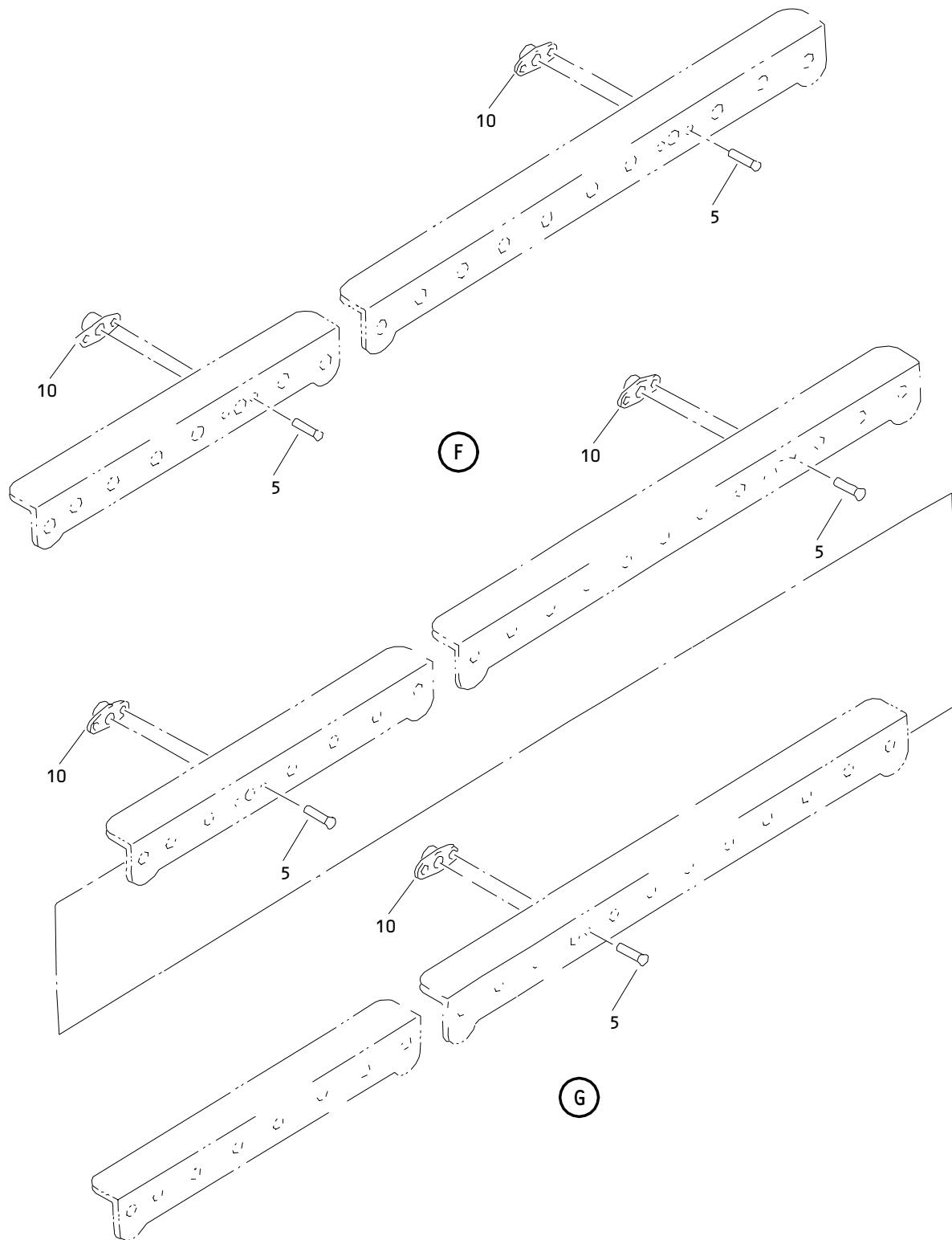
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Main Deck Cargo Door Inner Skin Installation
Figure 17 (Sheet 4)

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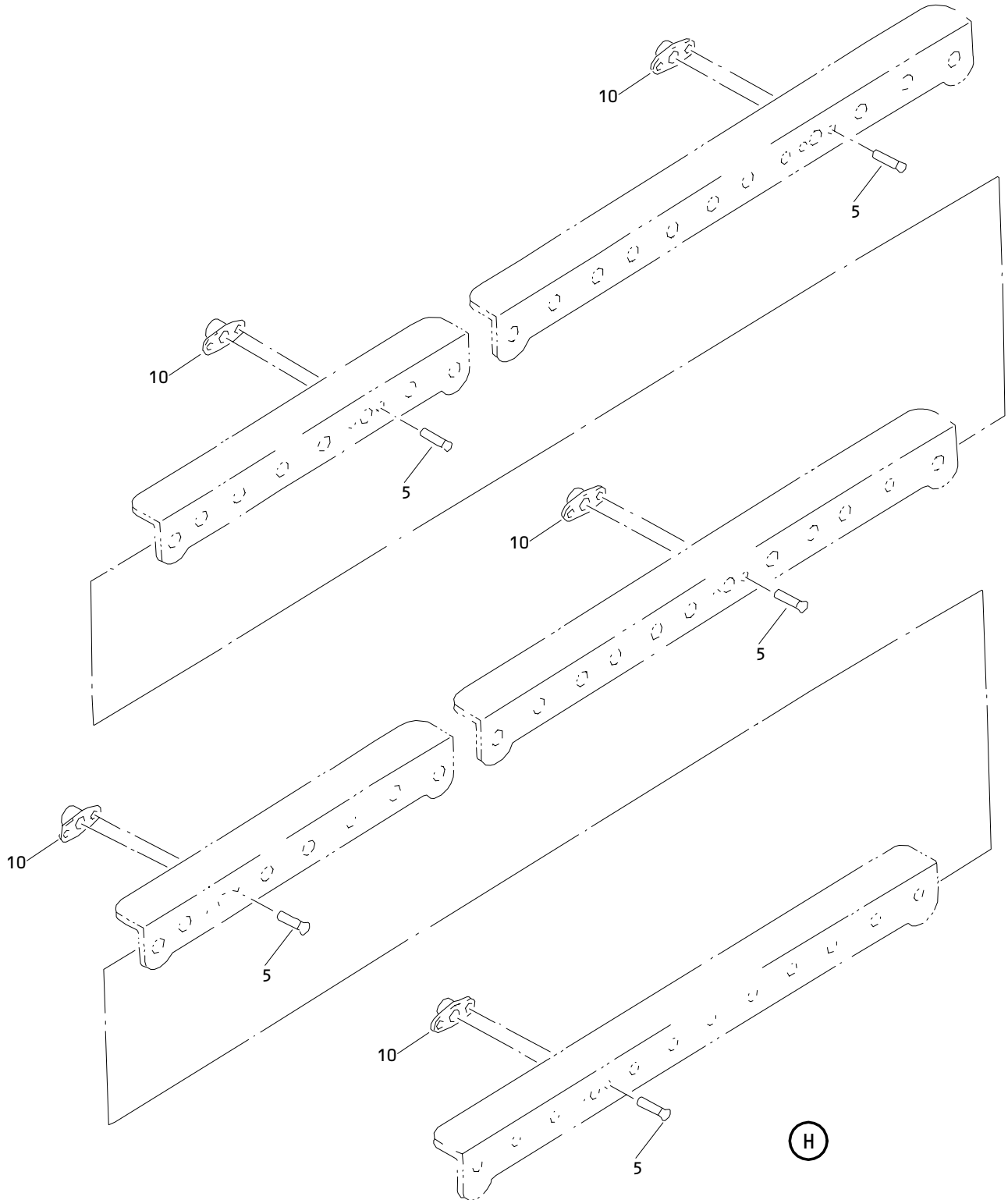
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Main Deck Cargo Door Inner Skin Installation
Figure 17 (Sheet 5)

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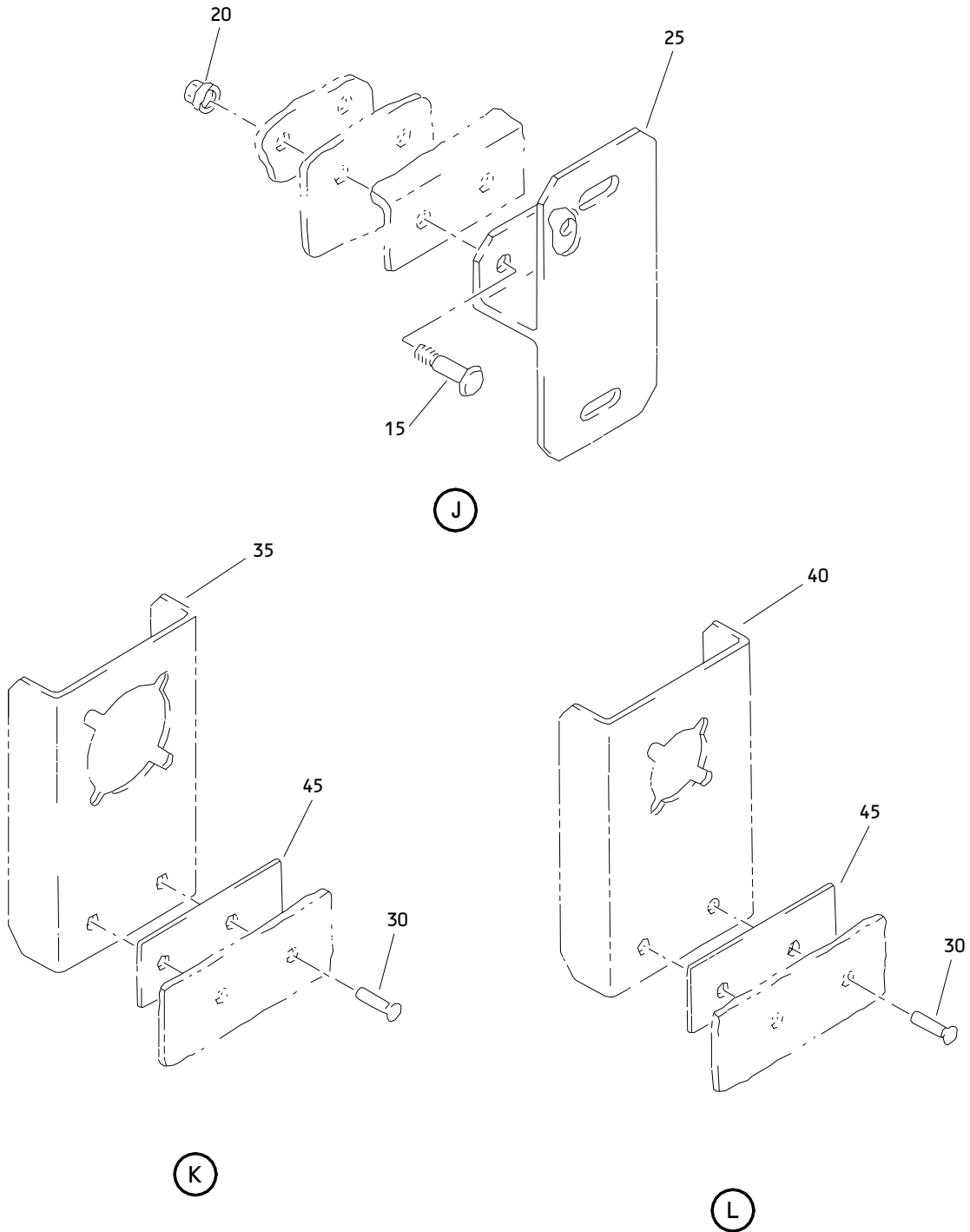
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Main Deck Cargo Door Inner Skin Installation
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Main Deck Cargo Door Inner Skin Installation
Figure 17 (Sheet 7)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 17-					
R -1A	143T6283-1		SKIN INSTL-INNER	A	RF
R -1B	143T6283-2		SKIN INSTL-INNER		RF
R 5	BACR15CE3AD		.RIVET- (SIZE DETERMINE ON INST)		48
R 10	NS202493-02-3		.NUTPLATE- (V80539) (SPEC BACN10KE3B3CD) (OPT 102A9213-3-3 (V72962)) (OPT F51747-3-3CD (V15653)) (OPT BRFR220C3-3D (V52828))		24
R 15	HST10AG6-5		DELETED		
R 15A	AF3553P6-5B		.RIVET- (V53551) (SPEC BACR15FR6MP5R) (OPT CR3553P6-5 (V11815))		4
	20	HST79CY6	DELETED		
	25	287T0013-45	DELETED		
R 25A	287T0013-112		.BRACKET		2
	30	AF3253-6-3B	DELETED		
R 30A	AF3253-6-5B		.RIVET- (V53551) (SPEC BACR15FR6E5R) (OPT CR3253-6-5 (V11815)) (USED ON ITEM 1A)	A	4
R -30B	AF3253-6-2B		.RIVET- (V53551) (SPEC BACR15FR6E2R) (OPT CR3253-6-2 (V11815)) (USED ON ITEM 1B)		4
R 35	287T3030-59		.BRACKET-DISCONNECT (USED ON ITEM 1A) (PRE SB 767-57-0072)	A	1
R 40	287T3030-58		.BRACKET-DISCONNECT (USED ON ITEM 1A) (PRE SB 767-52-0072)	A	1

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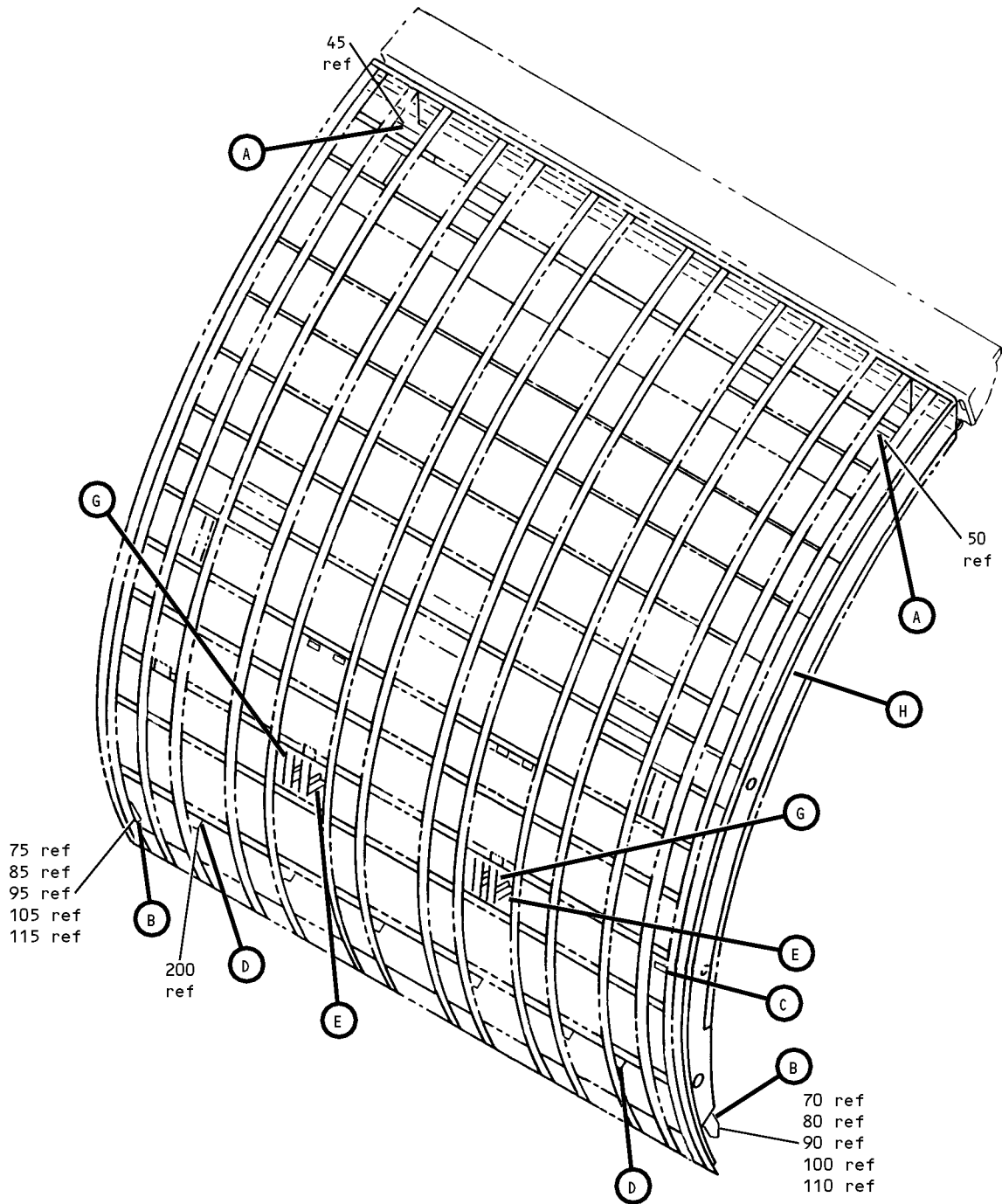
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
17- 45 R 45A	BACF3H08LC027HS BACF3H08RC027HS		DELETED .FILLER- (USED ON ITEM 1A)	A	2

- Item Not Illustrated

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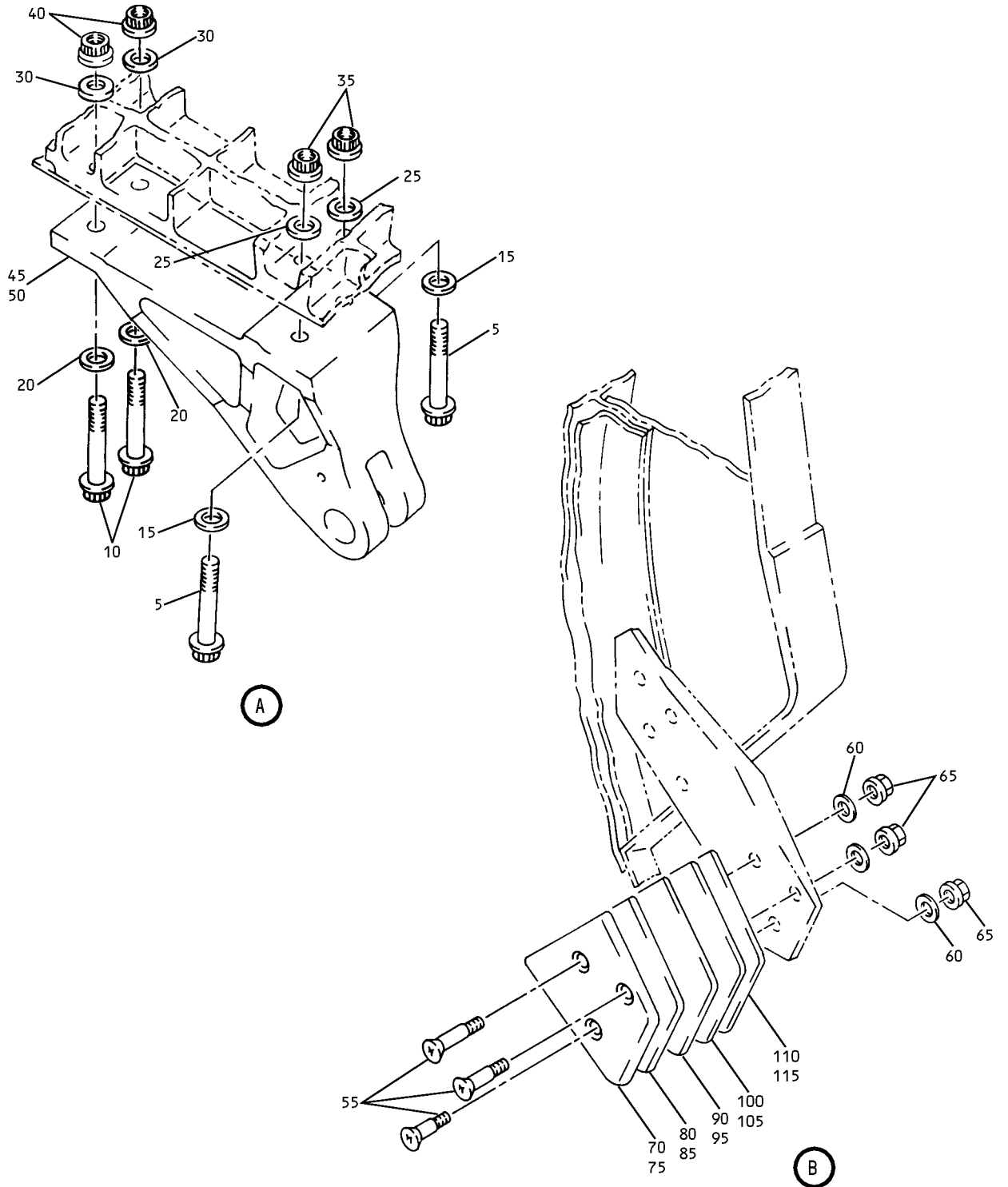


Main Deck Cargo Door Structural Assembly
 Figure 18 (Sheet 1)

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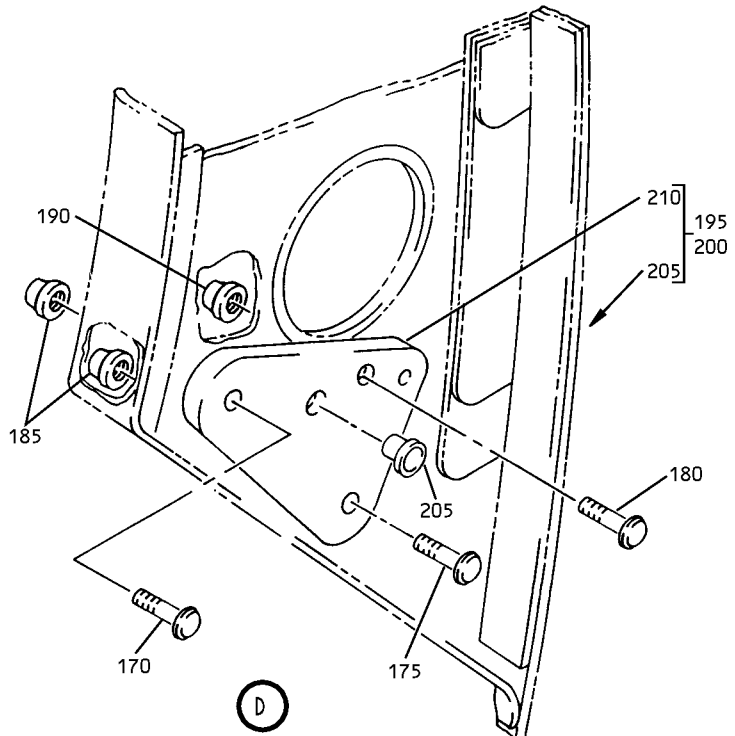
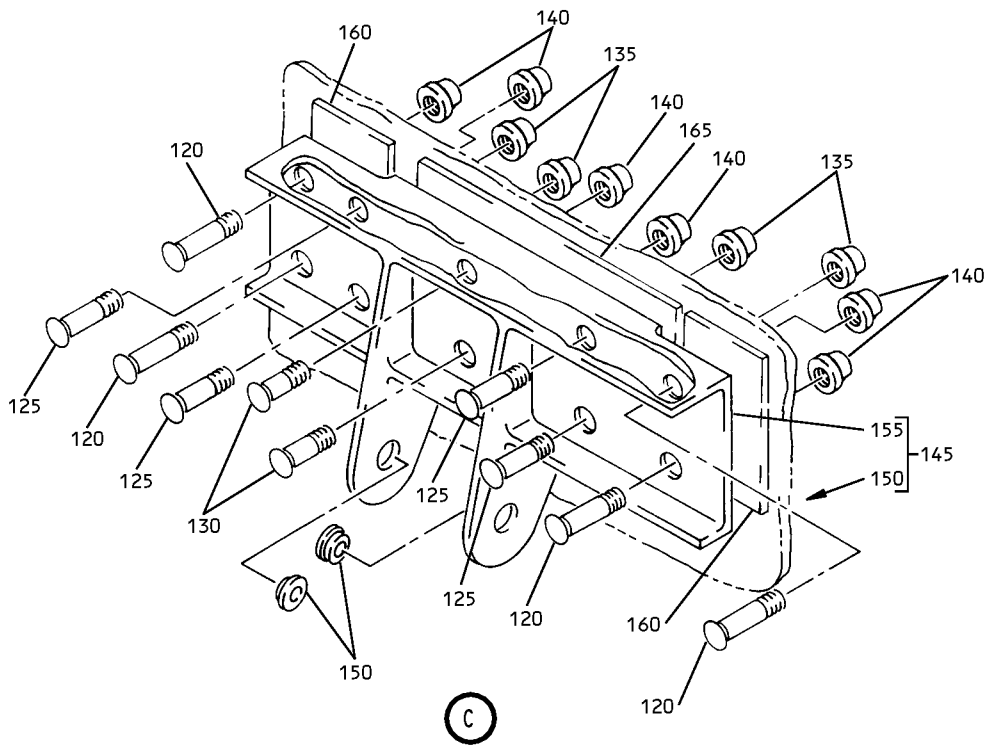
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Main Deck Cargo Door Structural Assembly
Figure 18 (Sheet 2)

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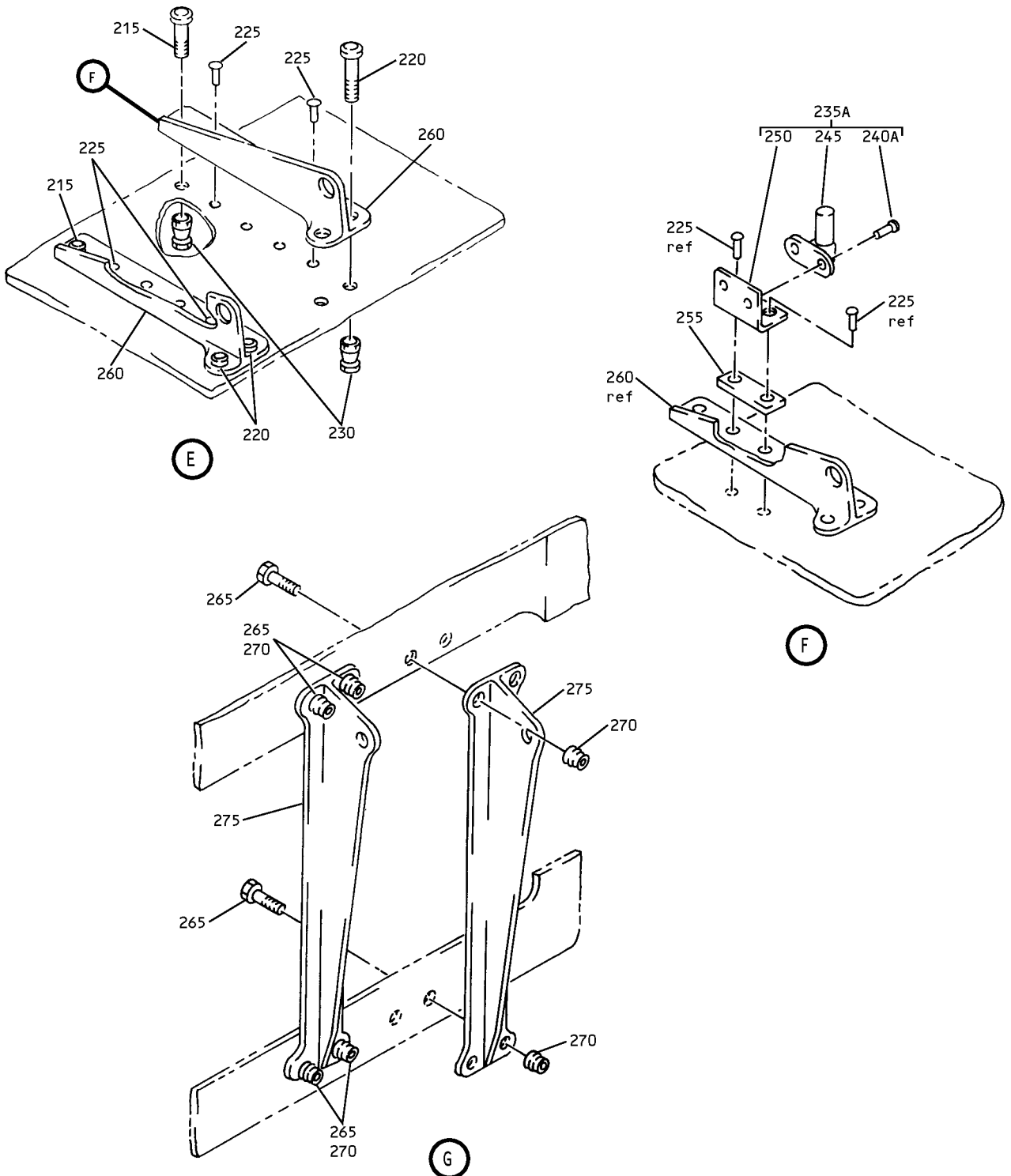
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Main Deck Cargo Door Structural Assembly
 Figure 18 (Sheet 3)

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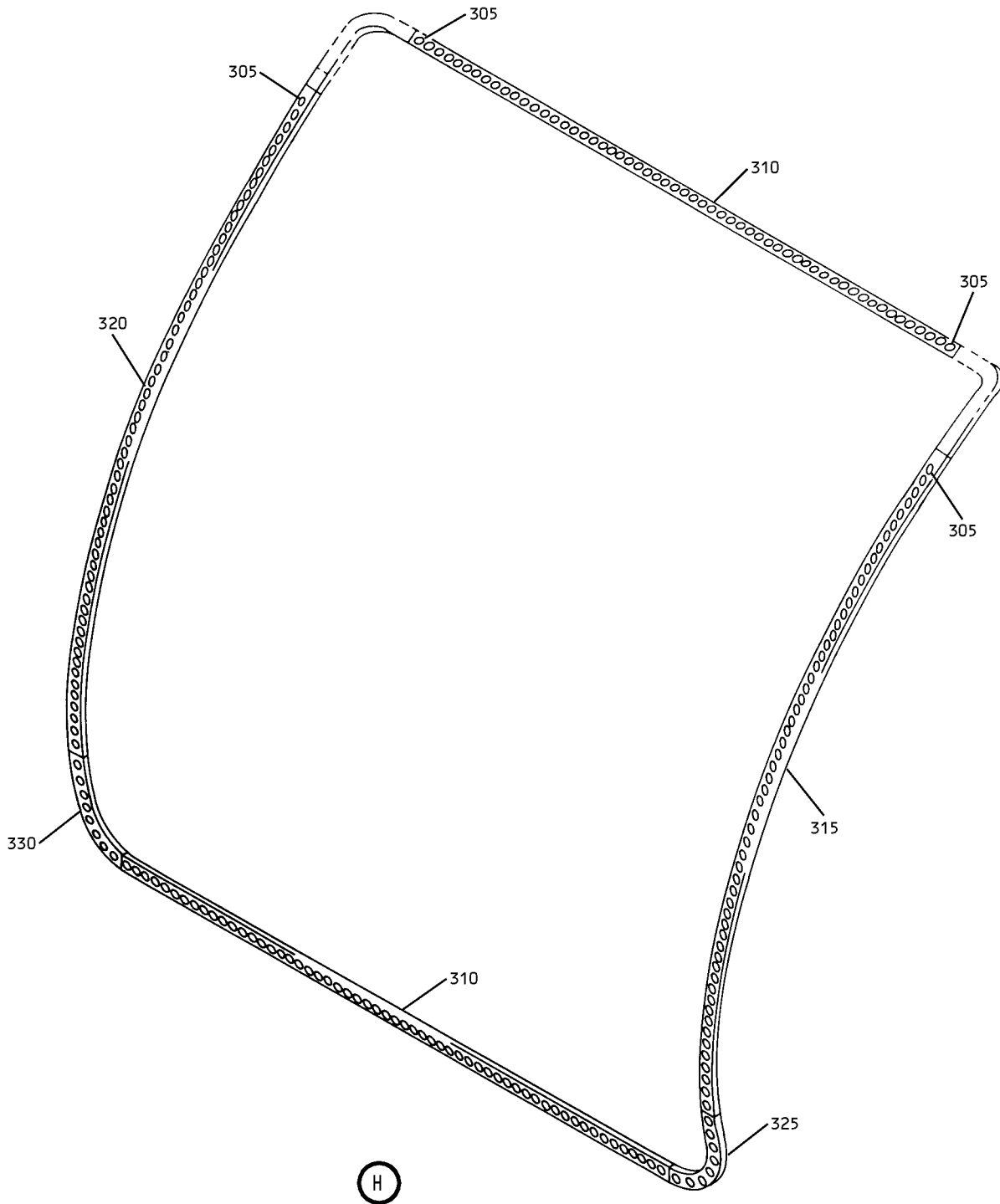
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Main Deck Cargo Door Structural Assembly
 Figure 18 (Sheet 4)

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Main Deck Cargo Door Structural Assembly
Figure 18 (Sheet 5)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 18-	143T6203-2		STRUCTURE ASSY	B	RF
R -1A	BACB30US9K23		.BOLT	B	4
R 5	BACB30US8K25		.BOLT	B	4
R 10	BACW10BP9CD		.WASHER	B	4
R 15	BACW10BP8CD		.WASHER	B	4
R 20	BACW10BP9DP		.WASHER	B	4
R 25	BACW10BP8DP		.WASHER	B	4
R 30	H51560-9		.NUT-	B	4
R 35			(V15653)		
			(SPEC BACN10HR9CD)		
			(OPT 67832CD918		
			(V56878))		
			(OPT BMN5024CWD3-9		
			(V97928))		
			(OPT 102LH9031-9		
			(V72962))		
			(OPT BH00303CM9		
			(V27238))		
			(OPT BMN10HRCWD3-9		
			(V97928))		
			(OPT BMN5024CWD39		
			(V97928))		
			(OPT CR60309		
			(V62554))		
			(OPT H51560		
			(V15653))		
			(OPT SL7108C9		
			(V11815))		
			(OPT VCU0005D9		
			(V06710))		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 18-40	H51560-8		.NUT- (V15653) (SPEC BACN10HR8CD) (OPT 67832CD820 (V56878)) (OPT BMN5024CWD3-8 (V97928)) (OPT 102LH9031-8 (V72962)) (OPT BH00303CM8 (V27238)) (OPT BMN10HRCWD3-8 (V97928)) (OPT BH00303CM8 (V27238)) (OPT BMN5024CWD38 (V97928)) (OPT CR60308 (V62554)) (OPT H51560 (V15653)) (OPT SL7108C8 (V11815))	B	4
R 45	143T6231-5		.FITTING ASSY-LIFT LINK (FOR DETAILS SEE FIG. 4)	B	1
R 50	143T6231-6		.FITTING ASSY-LIFT LINK (FOR DETAILS SEE FIG. 4)	B	1
R 55	BACB30LH6		.BOLT- (SIZE DETERMINE ON INST)	B	6
R 60	NAS1149C0632R		.WASHER	B	6
R 65	H52732-6CD		.NUT- (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))	B	6
R 70	143T6246-2		.FITTING-CENTERING ROLLER RAMP	B	1
R 75	143T6246-1		.FITTING-CENTERING ROLLER RAMP	B	1
R 80	143T6226-8		.SHIM-CENTERING ROLLER RAMP	B	1
R 85	143T6226-7		.SHIM-CENTERING ROLLER RAMP	B	1
R 90	143T6226-6		.SHIM-CENTERING ROLLER RAMP	B	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 18-95	143T6226-5		.SHIM-CENTERING ROLLER RAMP	B	1
R 100	143T6226-4		.SHIM-CENTERING ROLLER RAMP	B	1
R 105	143T6226-3		.SHIM-CENTERING ROLLER RAMP	B	1
R 110	143T6226-2		.SHIM-CENTERING ROLLER RAMP	B	1
R 115	143T6226-1		.SHIM-CENTERING ROLLER RAMP	B	1
R 120	HST11AG8-6		.BOLT- (VOPTK6) (SPEC BACB30VU8K6) (OPT HST11AG8-6 (V73197)) (OPT HST11AG8-6 (V56878)) (OPT HST11AG8-6 (V06725))	B	4
R 125	HST11AG6-6		.BOLT- (V06725) (SPEC BACB30VU6K6) (OPT HST11AG6-6 (V73197)) (OPT HST11AG6-6 (V56878)) (OPT HST11AG6-6 (VOPTK6))	B	4
R 130	HST11AG6-4		.BOLT- (V06725) (SPEC BACB30VU6K4) (OPT HST11AG6-4 (V73197)) (OPT HST11AG6-4 (V56878)) (OPT HST11AG6-4 (VOPTK6))	B	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 18-135	HST79CY8		.COLLAR- (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))	B	4
R 140	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))	B	6
R 145	143T6244-1		.BRACKET ASSY-LATCH LOCK IDLER SPRT	B	1
R 150	BACB28X5M010		..BUSHING	B	2
R 155	143T6244-2		..BRACKET	B	1
R 160	BACS40R011C021F		.SHIM	B	2
R 165	BACS40R021C040F		.SHIM	B	1
R 170	HST10AG8-25		.BOLT- (VOPTK6) (SPEC BACB30VT8K25) (OPT HST10AG8-25 (V06725)) (OPT HST10AG8-25 (V56878)) (OPT HST10AG8-25 (V73197))	B	6
R 175	HST10AG8-23		.BOLT- (VOPTK6) (SPEC BACB30VT8K23) (OPT HST10AG8-23 (V06725)) (OPT HST10AG8-23 (V56878)) (OPT HST10AG8-23 (V73197))	B	6

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 18-180	HST10AG6-8		.BOLT- (V0PTK6) (SPEC BACB30VT6K8) (OPT HST10AG6-8 (V06725)) (OPT HST10AG6-8 (V56878)) (OPT HST10AG6-8 (V73197))	B	6
R 185	HST79CY8		.COLLAR- (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))	B	12
R 190	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))	B	6
R 195	143T6206-1		.PLATE ASSY-BRG	B	5
R 200	143T6206-2		.PLATE ASSY-BRG	B	1
R 205	BACB28X8M024		..BUSHING	B	1
R 210	143T6206-3		..PLATE	B	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 18-215	HL1012AZ6-4		.BOLT- (V97928) (SPEC BACB30NX6K4) (OPT HL12VAZ6-4 (V73197)) (OPT HL12VAZ6-4 (V92215)) (OPT HL12VAZ6-4 (V97928)) (OPT L802-6K4 (V06725)) (OPT HL12VAZ6-4 (V56878)) (OPT HL1012AZ6-4 (V0PTK6)) (OPT HL1012AZ6-4 (V06725)) (OPT HL1012AZ6-4 (V06950)) (OPT HL1012AZ6-4 (V17446)) (OPT HL1012AZ6-4 (V56878)) (OPT HL1012AZ6-4 (V60516)) (OPT HL1012AZ6-4 (V73197))	B	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 18-220	HL1012AZ6-5		.BOLT- (V97928) (SPEC BACB30NX6K5) (OPT HL12VAZ6-5 (V73197)) (OPT HL12VAZ6-5 (V92215)) (OPT HL12VAZ6-5 (V97928)) (OPT L802-6K5 (V06725)) (OPT HL12VAZ6-5 (V56878)) (OPT HL1012AZ6-5 (V0PTK6)) (OPT HL1012AZ6-5 (V06725)) (OPT HL1012AZ6-5 (V06950)) (OPT HL1012AZ6-5 (V17446)) (OPT HL1012AZ6-5 (V56878)) (OPT HL1012AZ6-5 (V60516)) (OPT HL1012AZ6-5 (V73197))	B	8
R 225	BACR15FT6KE		.RIVET- (SIZE DETERMINE ON INST)	B	16
R 230	HL1187-6		.COLLAR- (V5M902) (SPEC BACC30X6) (OPT HL87-6 (V73197)) (OPT HL87-6 (V92215)) (OPT HL1187-6 (V56878)) (OPT HL1187-6 (V92215)) (OPT HL87-6 (V56878)) (OPT HL1187-6 (V73197))	B	12
235	287T0014-648		DELETED		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 18-					
R 235A	287T0014-664		.ANGLE ASSY	B	1
R 240	BACR15BB3D		DELETED		
R 240A	BACR15CE3D		..RIVET-	B	2
			(SIZE DETERMINE ON INST)		
R 245	WSI332-10		..NUTPLATE-	B	1
			(V04169)		
			(SPEC BACN10GH3-10)		
R 250	287T0014-649		..ANGLE	B	1
R 255	287T0015-381		.FILLER	B	1
R 260	143T6556-1		.FITTING-VENT DOOR TORQUE	B	4
			TUBE SPRT		
R 265	HST11AG6-5		.BOLT-	B	16
			(V06725)		
			(SPEC BACB30VU6K5)		
			(OPT HST11AG6-5		
			(V73197))		
			(OPT HST11AG6-5		
			(V56878))		
			(OPT HST11AG6-5		
			(VOPTK6))		
R 270	HST826AW		.COLLAR-	B	16
			(V5M902)		
			(SPEC BACC30BQ6)		
			(OPT HST826AW		
			(V56878))		
			(OPT HST826AW		
			(V73197))		
			(OPT HST82CY6APBW		
			(V73197))		
			(OPT HST82CY6APBW		
			(V56878))		
R 275	143T6556-2		.FITTING-VENT DOOR TORQUE	B	4
			TUBE SPRT		
R -280	143T6281-1		.WINDOW INSTL-LWR LATCH	B	6
			OBSERVATION		
			(FOR DETAILS SEE FIG. 5)		
R -285	143T6258-40		.BEAM INSTL-UPR	B	1
			(FOR DETAILS SEE		
			FIG. 19)		
R -290	143T6628-1		.SUPPORT INSTL-UPR CORNER	B	1
			PRESSURE SEAL		
			(FOR DETAILS SEE FIG. 7)		
R -295	143T6628-2		.SUPPORT INSTL-UPR CORNER	B	1
			PRESSURE SEAL		
			(FOR DETAILS SEE FIG. 7)		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 18-300	143T6629-1		.RETAINER INSTL-PRESSURE SEAL	B	1
R 305	BACR15BA4B		..RIVET- (SIZE DETERMINE ON INST)	B	244
R 310	143T6629-2		..RETAINER	B	2
R 315	143T6629-4		..RETAINER	B	1
R 320	143T6629-3		..RETAINER	B	1
R 325	143T6629-6		..RETAINER	B	1
R 330	143T6629-5		..RETAINER	B	1
R -335	143T6250-2		.INTERCOSTAL INSTL-NO. 8 MIDSPAN IDLER SPRT (FOR DETAILS SEE FIG. 8)	B	1
R -340	143T6250-1		.INTERCOSTAL INSTL-NO. 8 MIDSPAN IDLER SPRT (FOR DETAILS SEE FIG. 8)	B	1
R -345	143T6240-1		.INTERCOSTAL INSTL-NO. 9 (FOR DETAILS SEE FIG. 9)	B	1
R -350	143T6259-2		.INTERCOSTAL INSTL-NO. 10 MIDSPAN SPRT (FOR DETAILS SEE FIG. 10)	B	1
R -355	143T6259-1		.INTERCOSTAL INSTL-NO. 10 MIDSPAN SPRT (FOR DETAILS SEE FIG. 10)	B	1
R -360	143T6232-1		.FRAME INSTL-STA 546.6 (FOR DETAILS SEE FIG. 11)	B	1
R -365	143T6232-2		.FRAME INSTL-STA 577.4 (FOR DETAILS SEE FIG. 11)	B	1
R -370	143T6232-3		.FRAME INSTL-STA 590.6 (FOR DETAILS SEE FIG. 11)	B	1
R -375	143T6232-4		.FRAME INSTL-STA 533.4 (FOR DETAILS SEE FIG. 11)	B	1
R -380	143T6233-1		.FRAME INSTL-STA 524.6 (FOR DETAILS SEE FIG. 12)	B	1
R -385	143T6233-2		.FRAME INSTL-STA 555.4 (FOR DETAILS SEE FIG. 12)	B	1

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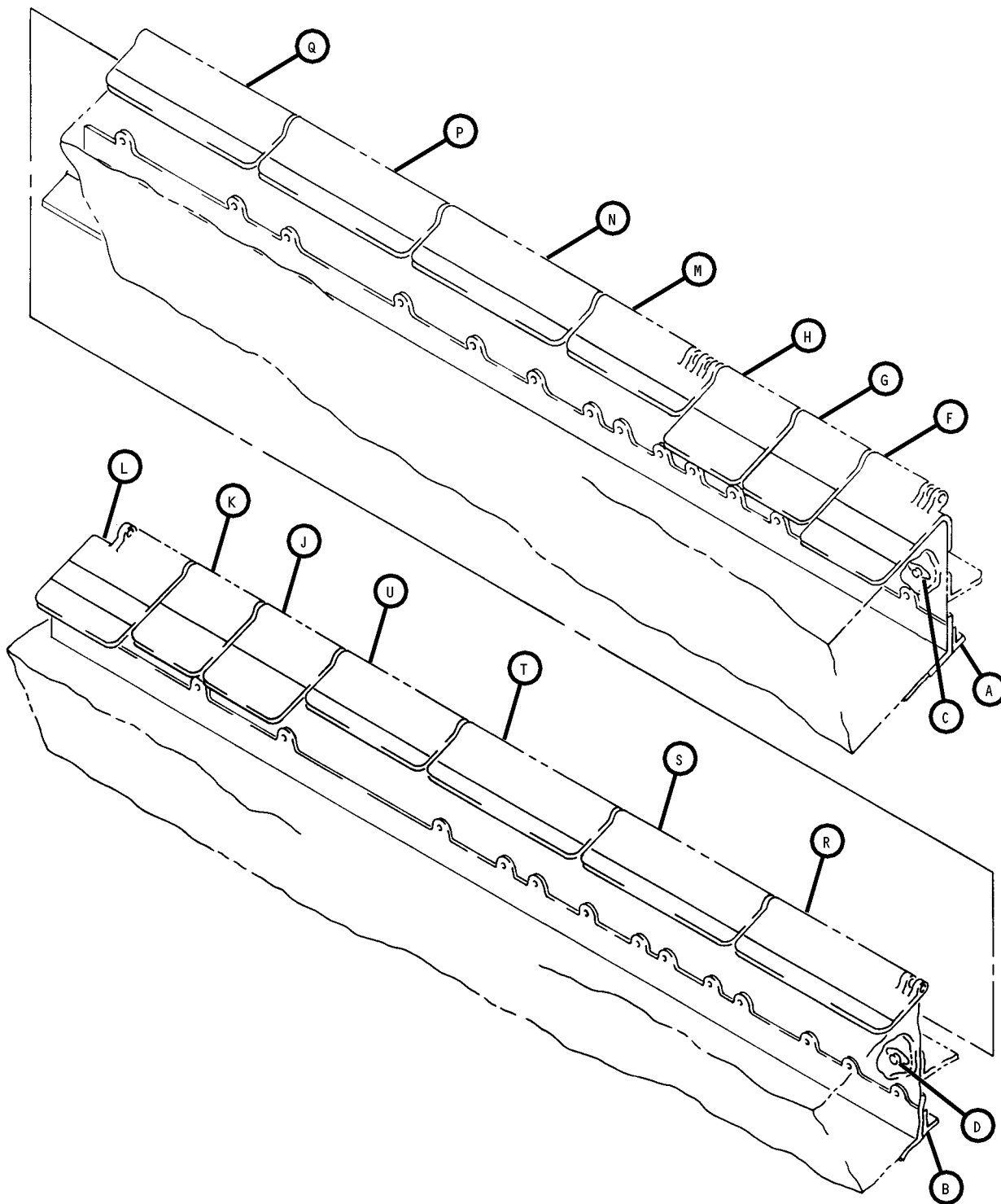
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 18-390	143T6233-3		.FRAME INSTL-STA 568.6 (FOR DETAILS SEE FIG. 12)	B	1
R -395	143T6233-16		.FRAME INSTL-STA 599.4 (FOR DETAILS SEE FIG. 12)	B	1
R -400	143T6234-1		.FRAME INSTL-STA 511.4 (FOR DETAILS SEE FIG. 11)	B	1
R -405	143T6234-2		.FRAME INSTL-STA 511.4 (FOR DETAILS SEE FIG. 11)	B	1
R -410	143T6230-1		.FRAME INSTL-STA 502.6 (FOR DETAILS SEE FIG. 13)	B	1
R -415	143T6230-2		.FRAME INSTL-STA 502.6 (FOR DETAILS SEE FIG. 13)	B	1
R -420	143T6224-1		.FRAME INSTL-STA 495.5 (FOR DETAILS SEE FIG. 14)	B	1
R -425	143T6224-2		.FRAME INSTL-STA 628.5 (FOR DETAILS SEE FIG. 14)	B	1
R -430	143T6218-1		.BEAM INSTL-LWR (FOR DETAILS SEE FIG. 15)	B	1
R -435	143T6272-1		.SKIN INSTL-OUTER (FOR DETAILS SEE FIG. 16)	B	1
R -440	143T6283-2		.SKIN INSTL-INNER (FOR DETAILS SEE FIG. 17)	B	1

- Item Not Illustrated

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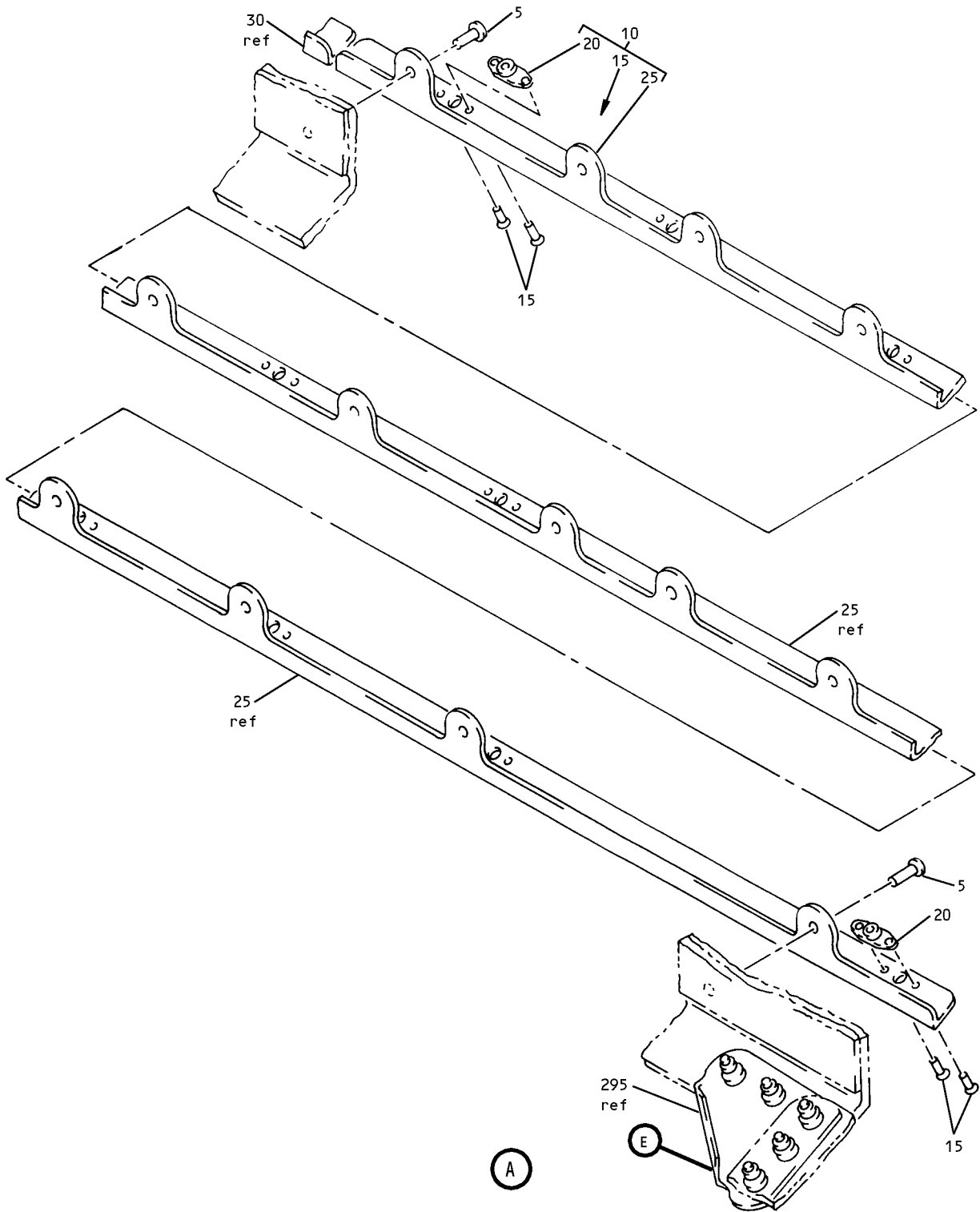
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Main Deck Cargo Door Upper Beam Installation
Figure 19 (Sheet 1)

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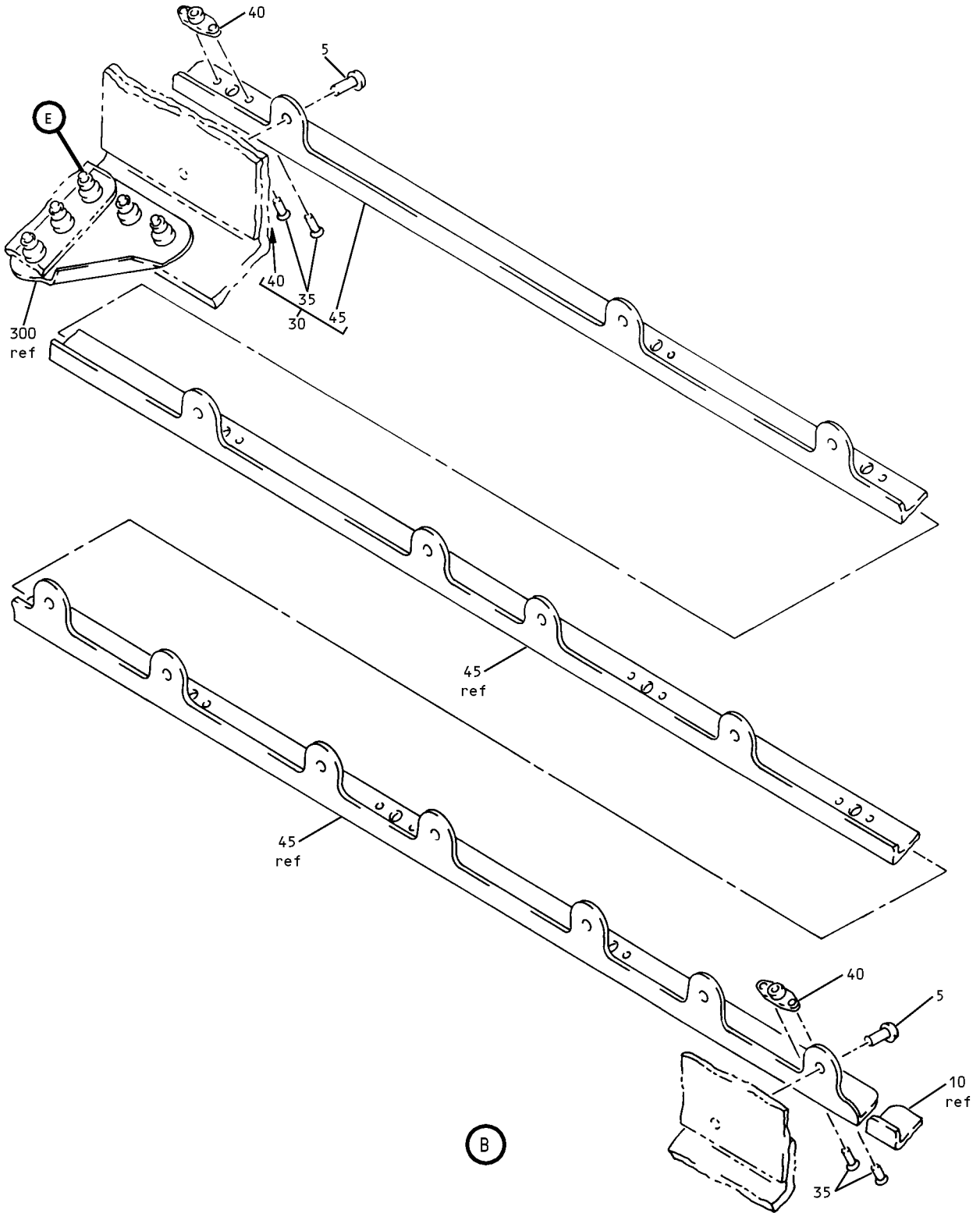
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Main Deck Cargo Door Upper Beam Installation
Figure 19 (Sheet 2)

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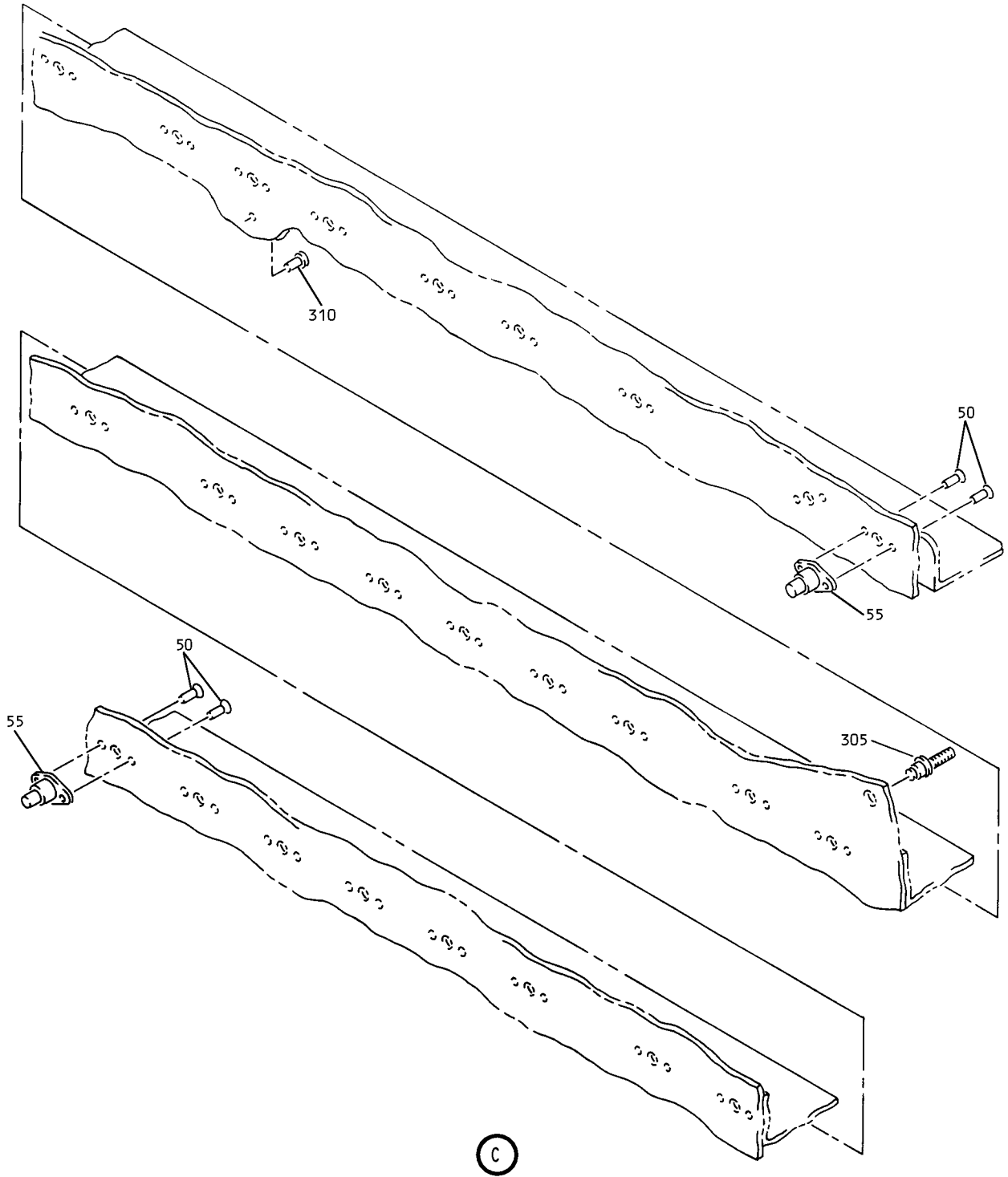
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Main Deck Cargo Door Upper Beam Installation
Figure 19 (Sheet 3)

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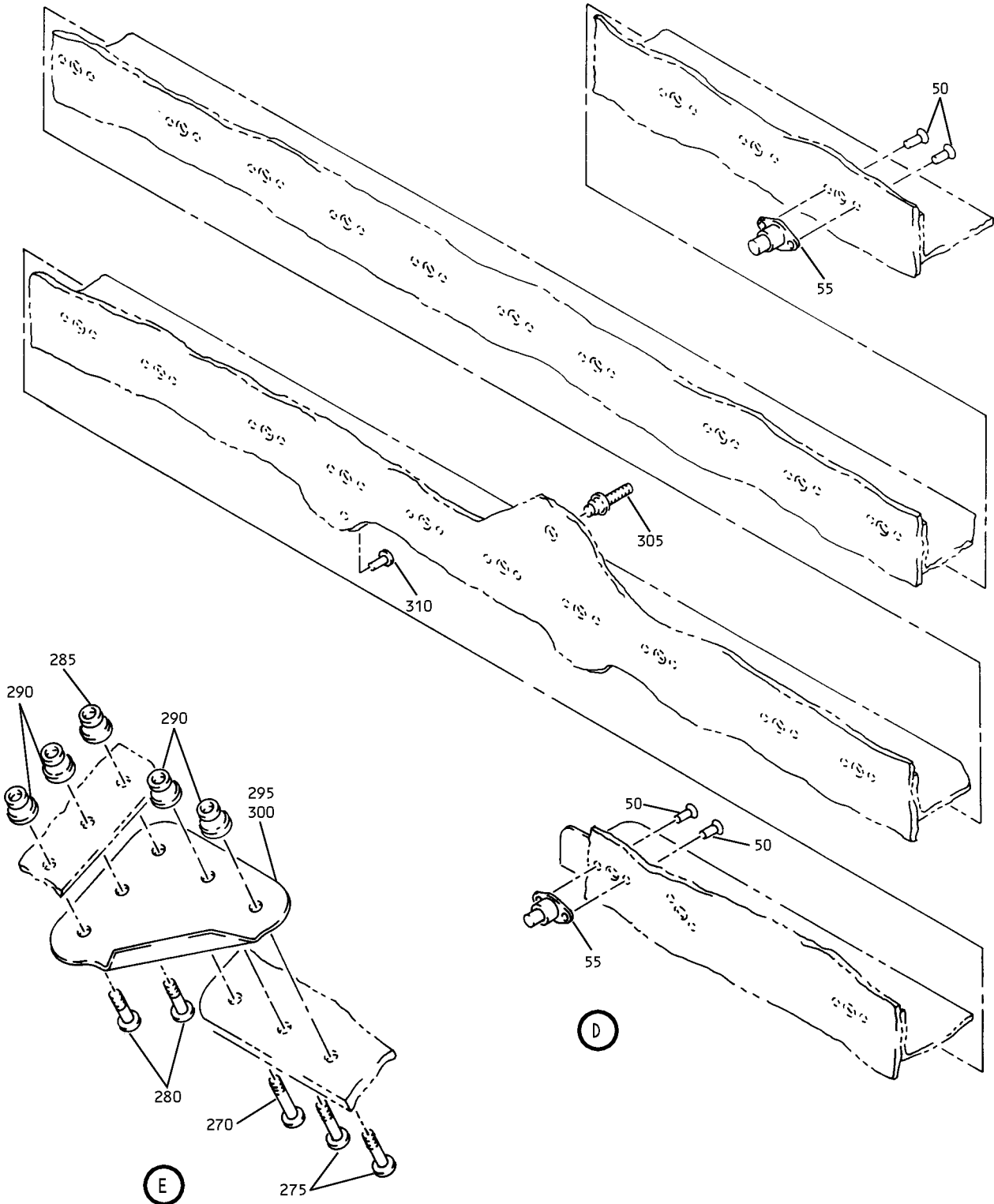
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Main Deck Cargo Door Upper Beam Installation
Figure 19 (Sheet 4)

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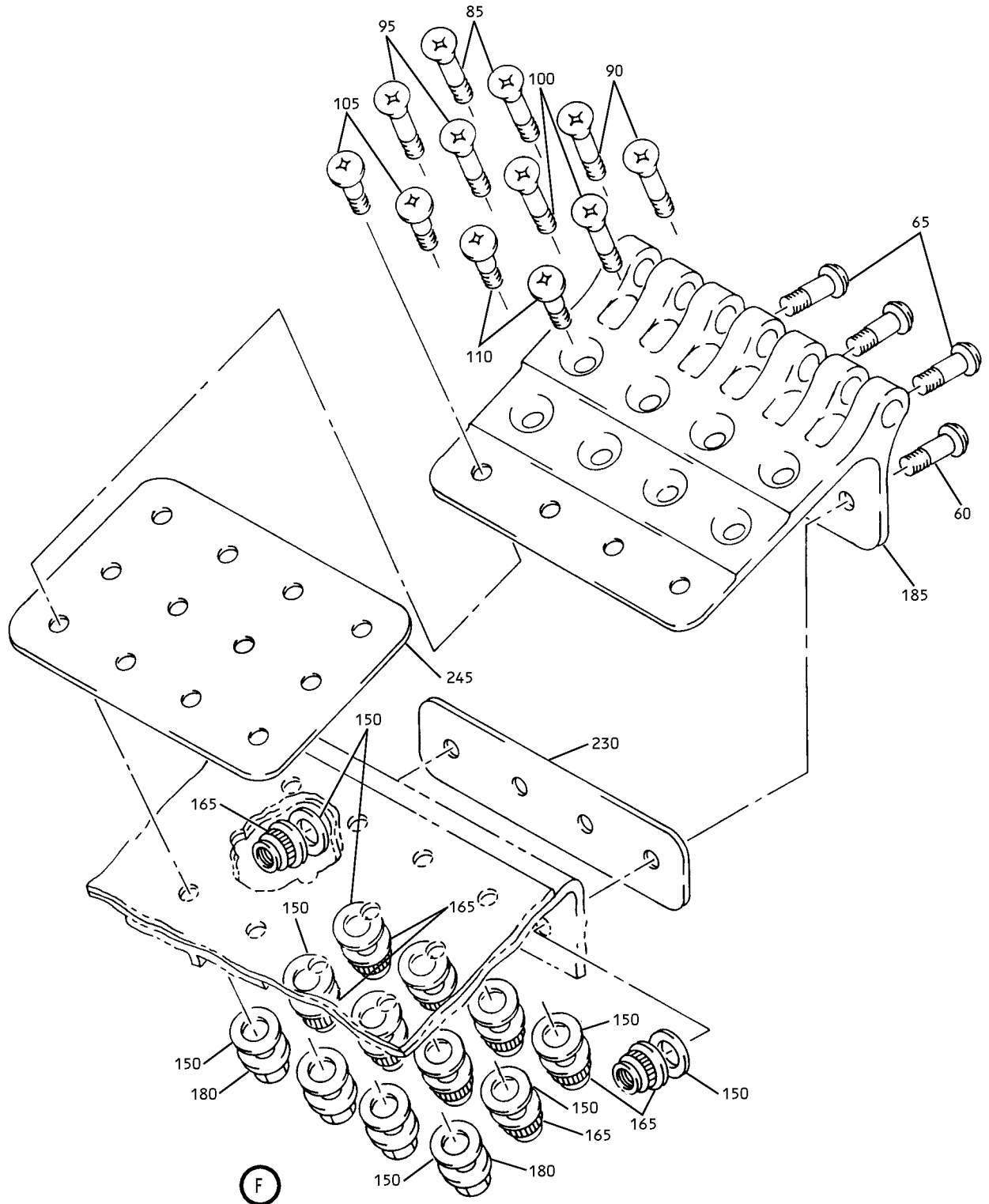
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Main Deck Cargo Door Upper Beam Installation
Figure 19 (Sheet 5)

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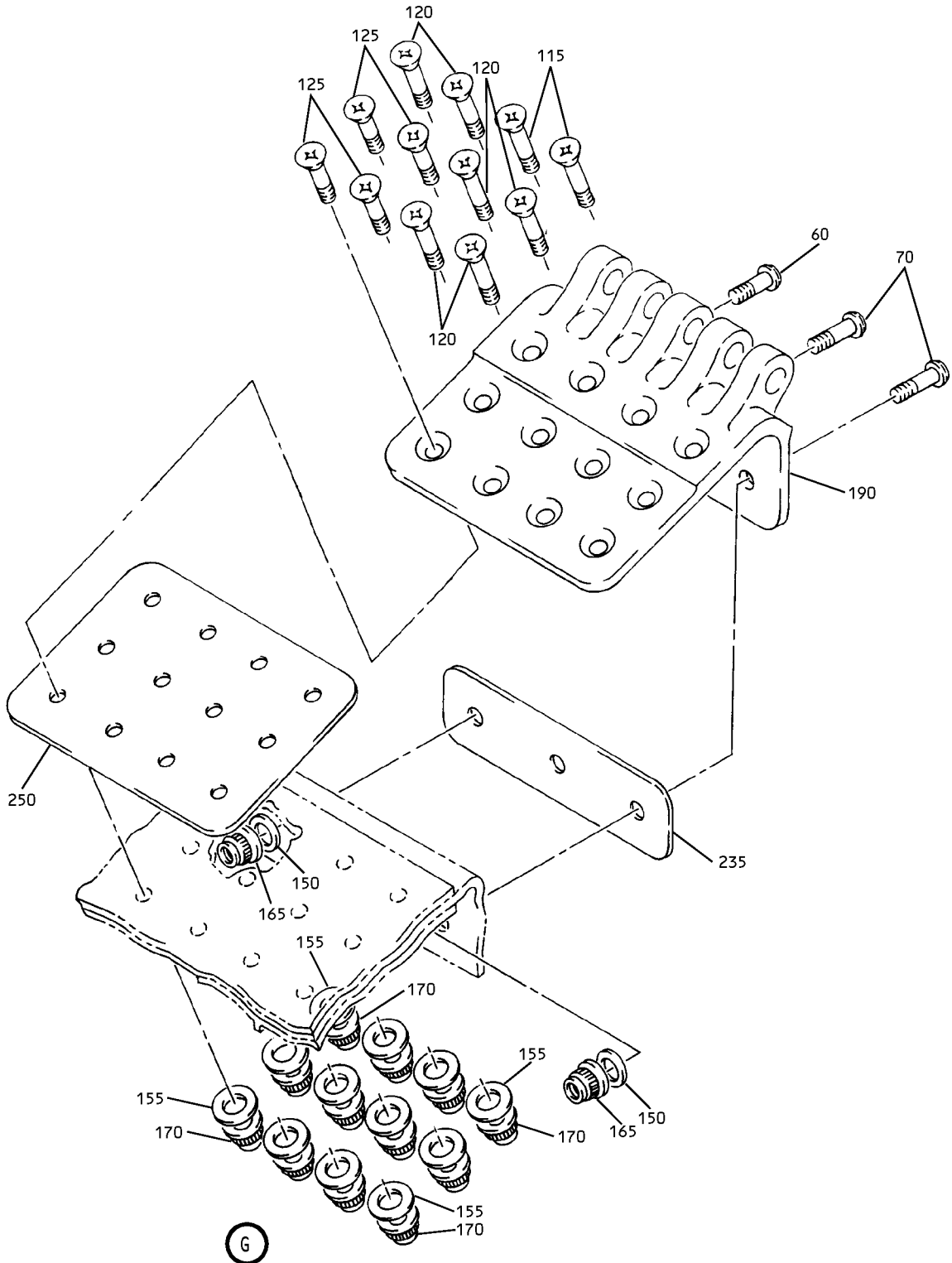
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Main Deck Cargo Door Upper Beam Installation
Figure 19 (Sheet 6)

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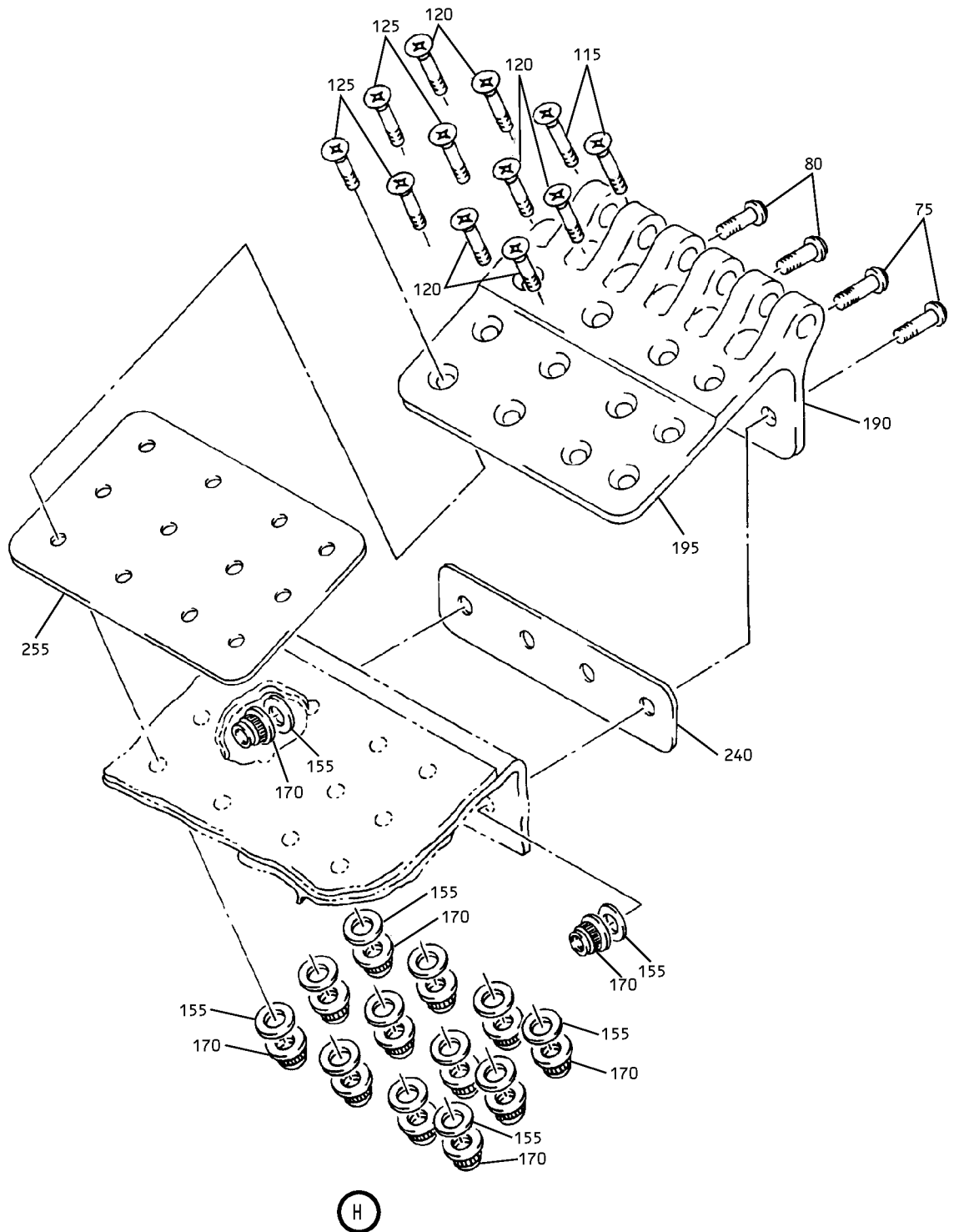
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Main Deck Cargo Door Upper Beam Installation
 Figure 19 (Sheet 7)

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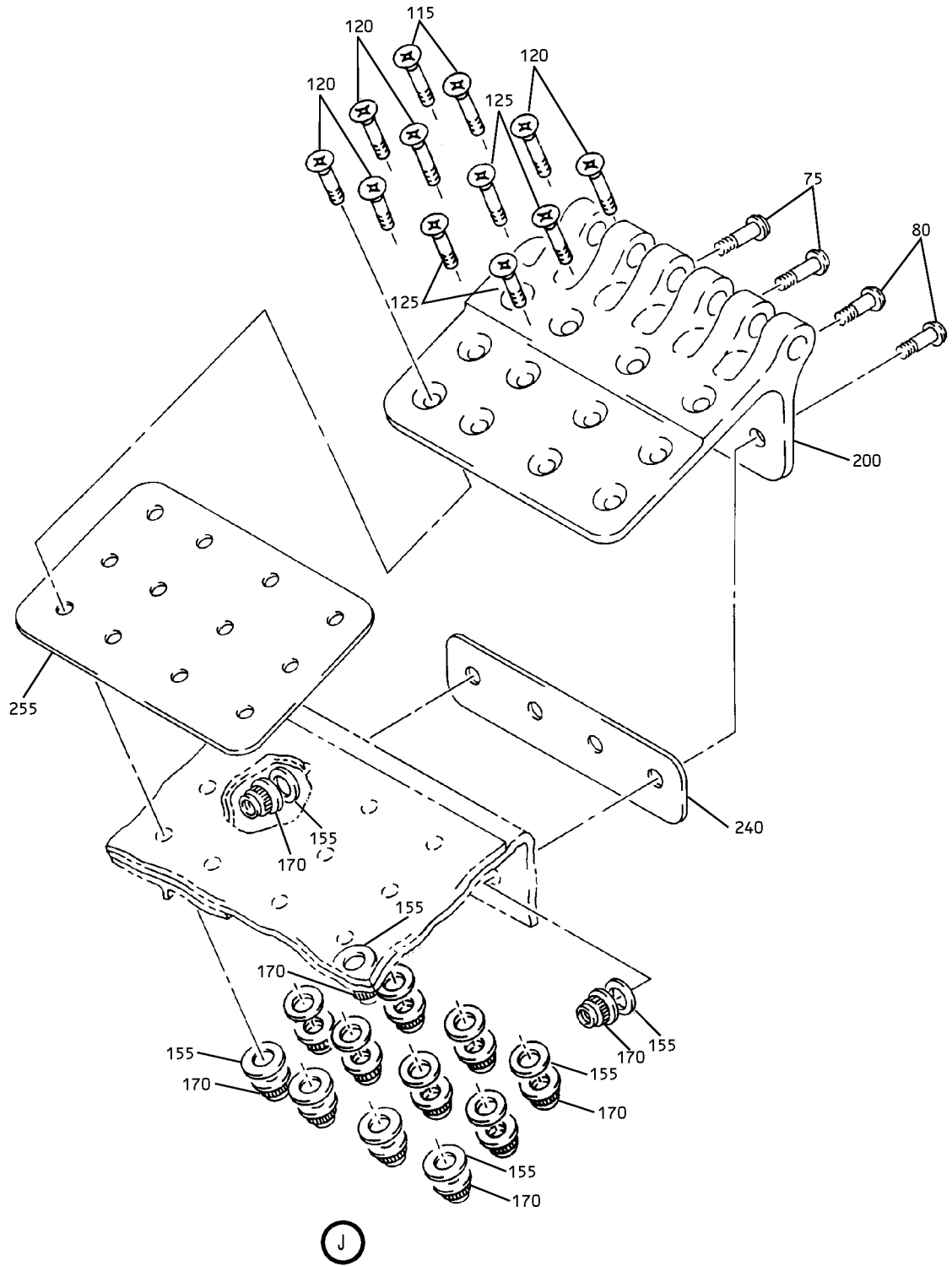
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Main Deck Cargo Door Upper Beam Installation
Figure 19 (Sheet 8)

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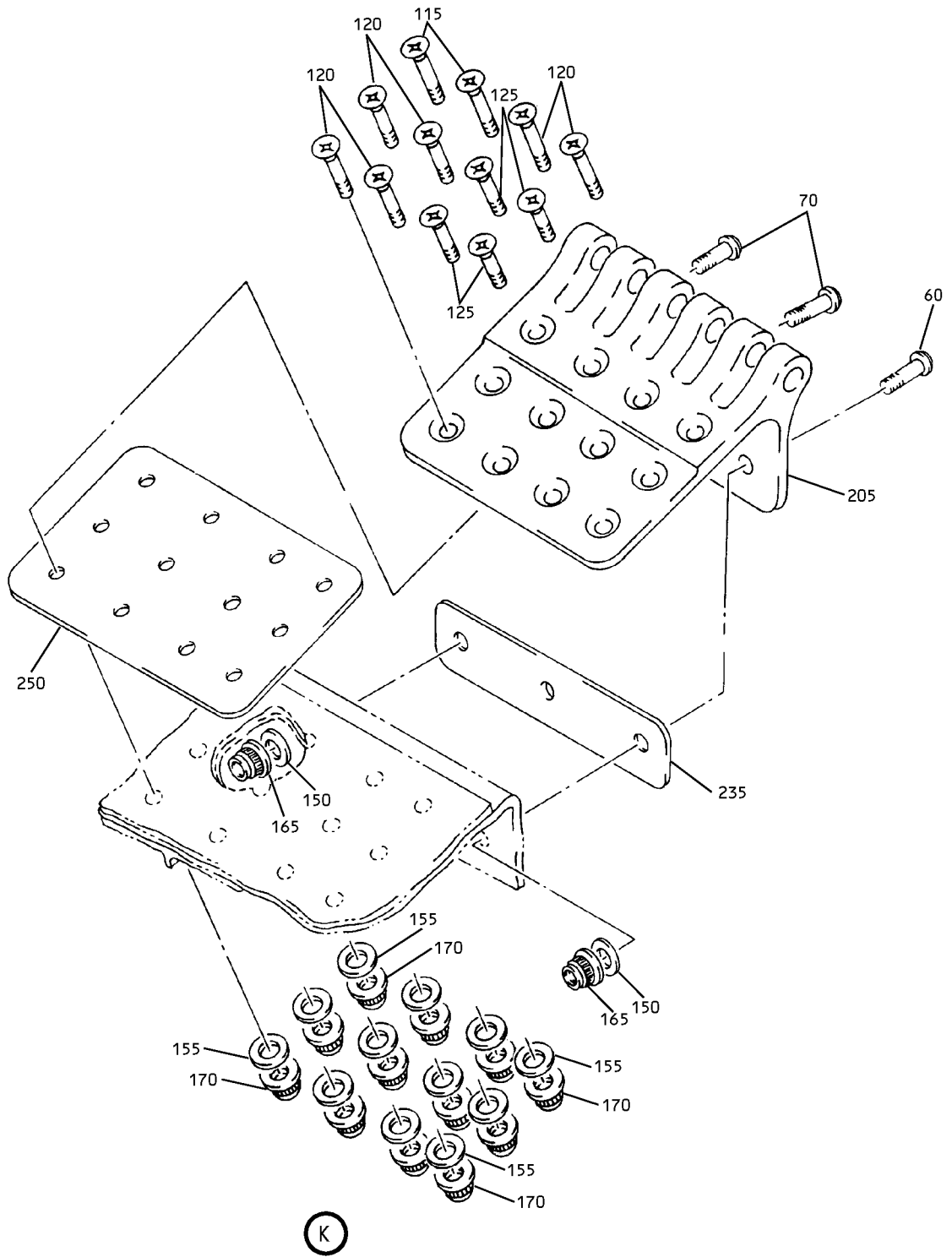
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Main Deck Cargo Door Upper Beam Installation
 Figure 19 (Sheet 9)

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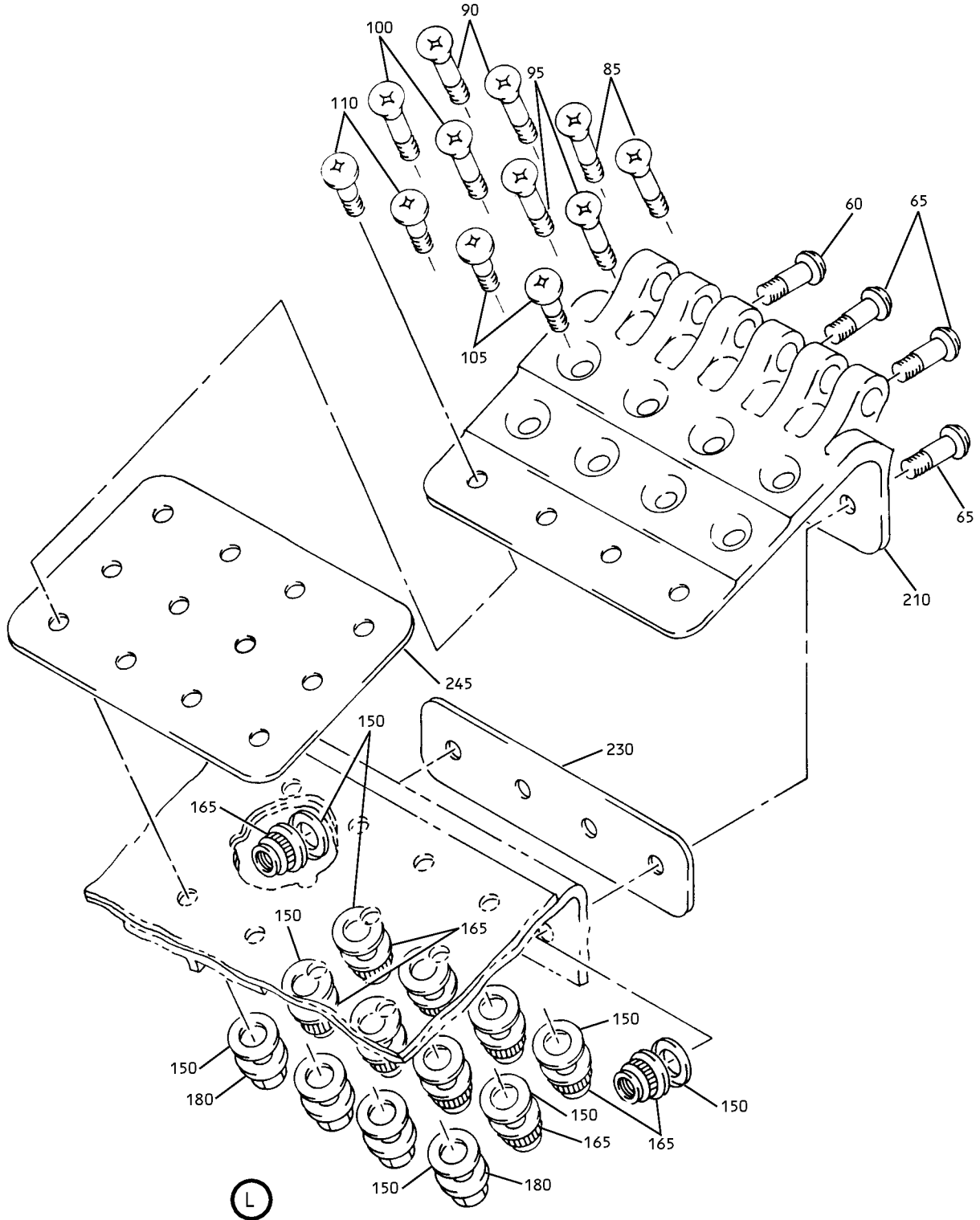
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Main Deck Cargo Door Upper Beam Installation
Figure 19 (Sheet 10)

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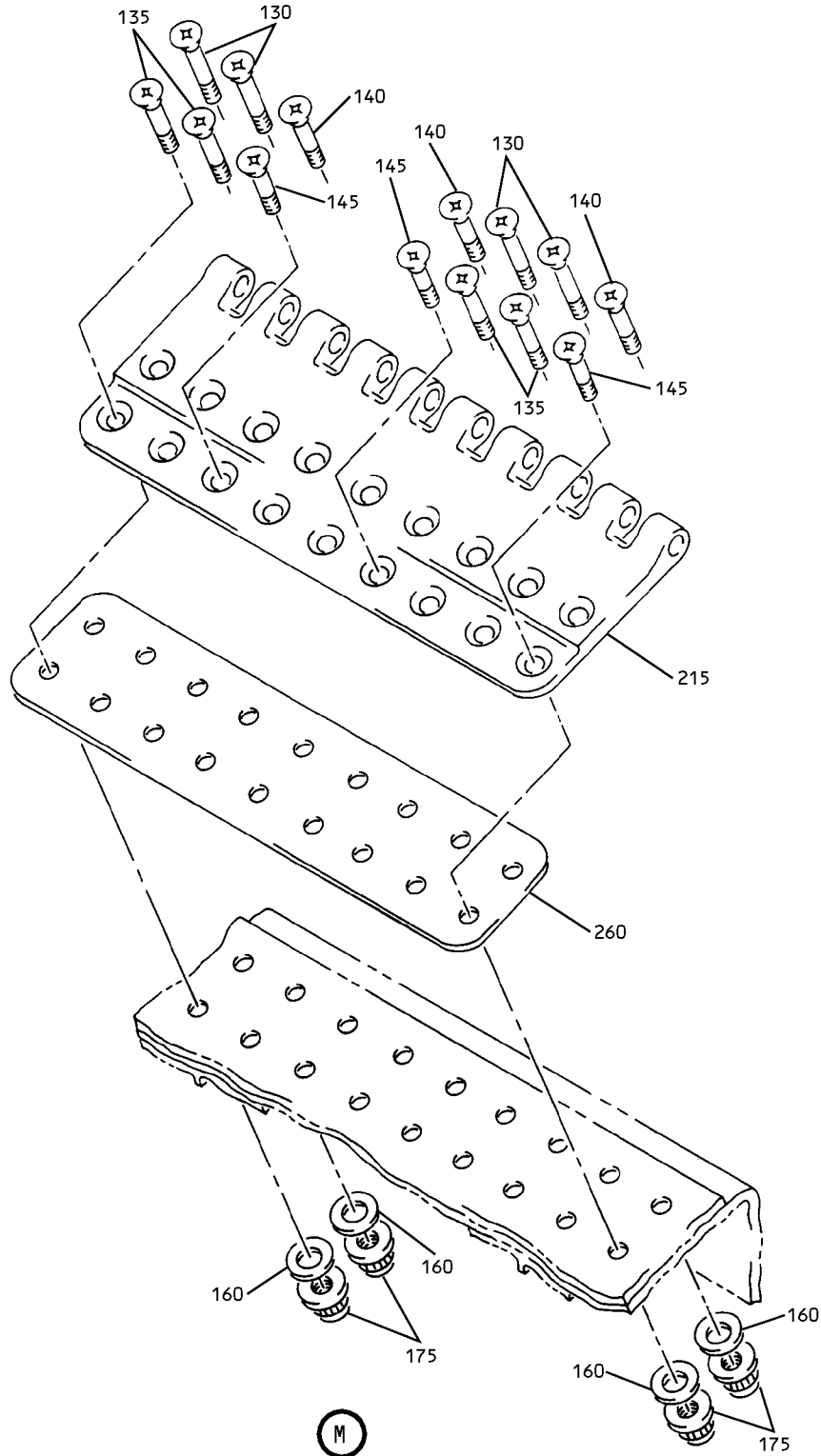
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Main Deck Cargo Door Upper Beam Installation
 Figure 19 (Sheet 11)

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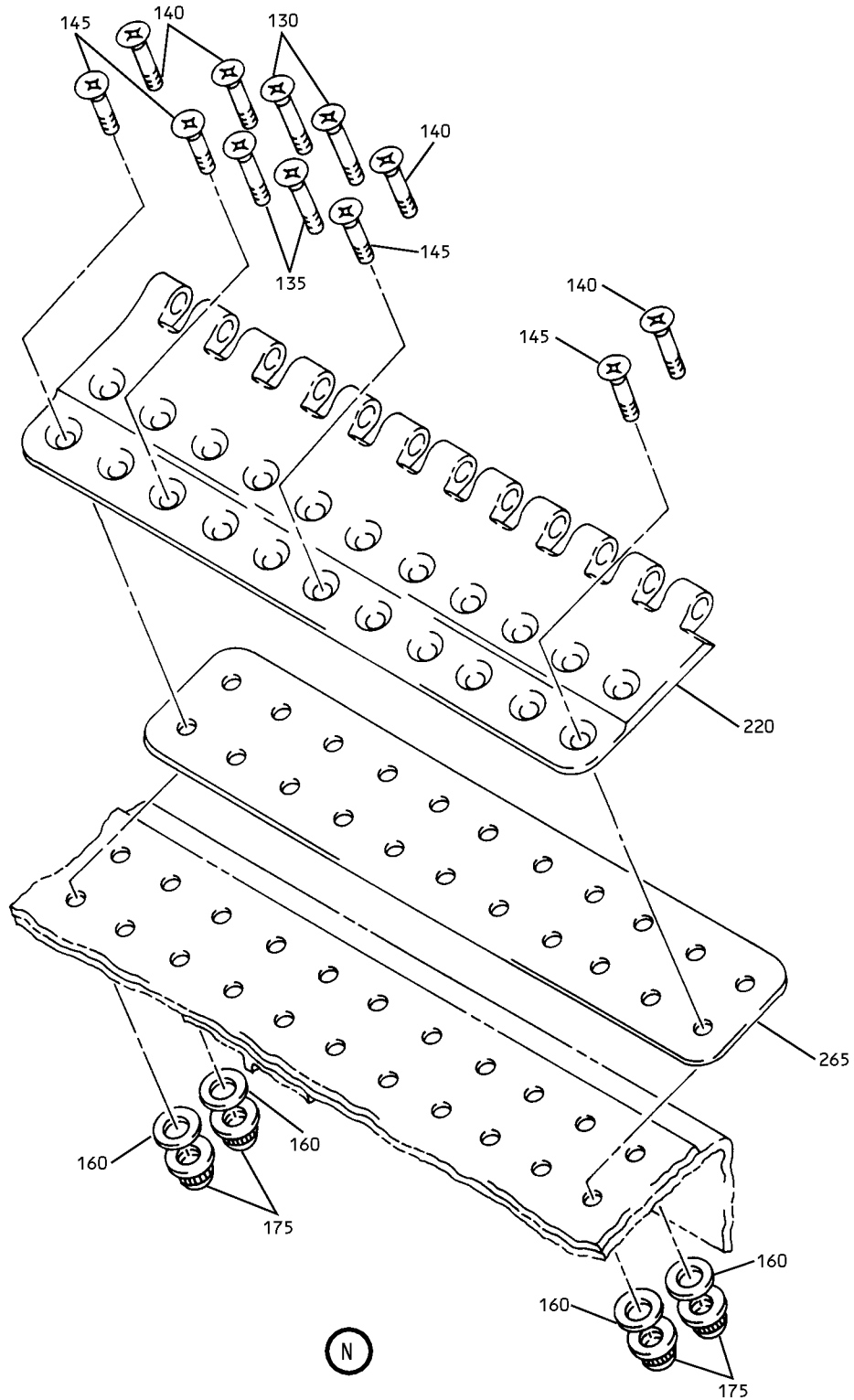
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Main Deck Cargo Door Upper Beam Installation
Figure 19 (Sheet 12)

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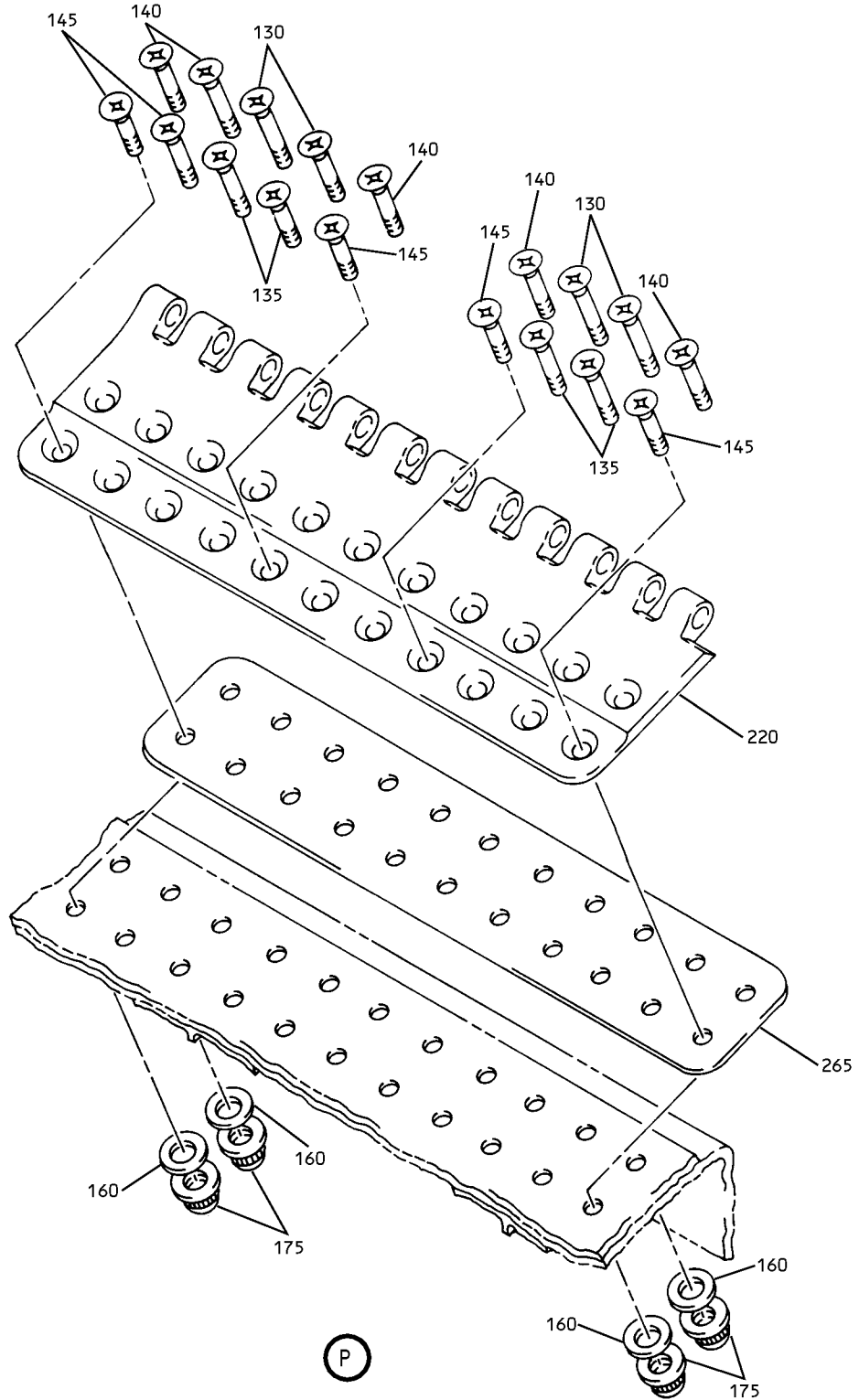
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Main Deck Cargo Door Upper Beam Installation
Figure 19 (Sheet 13)

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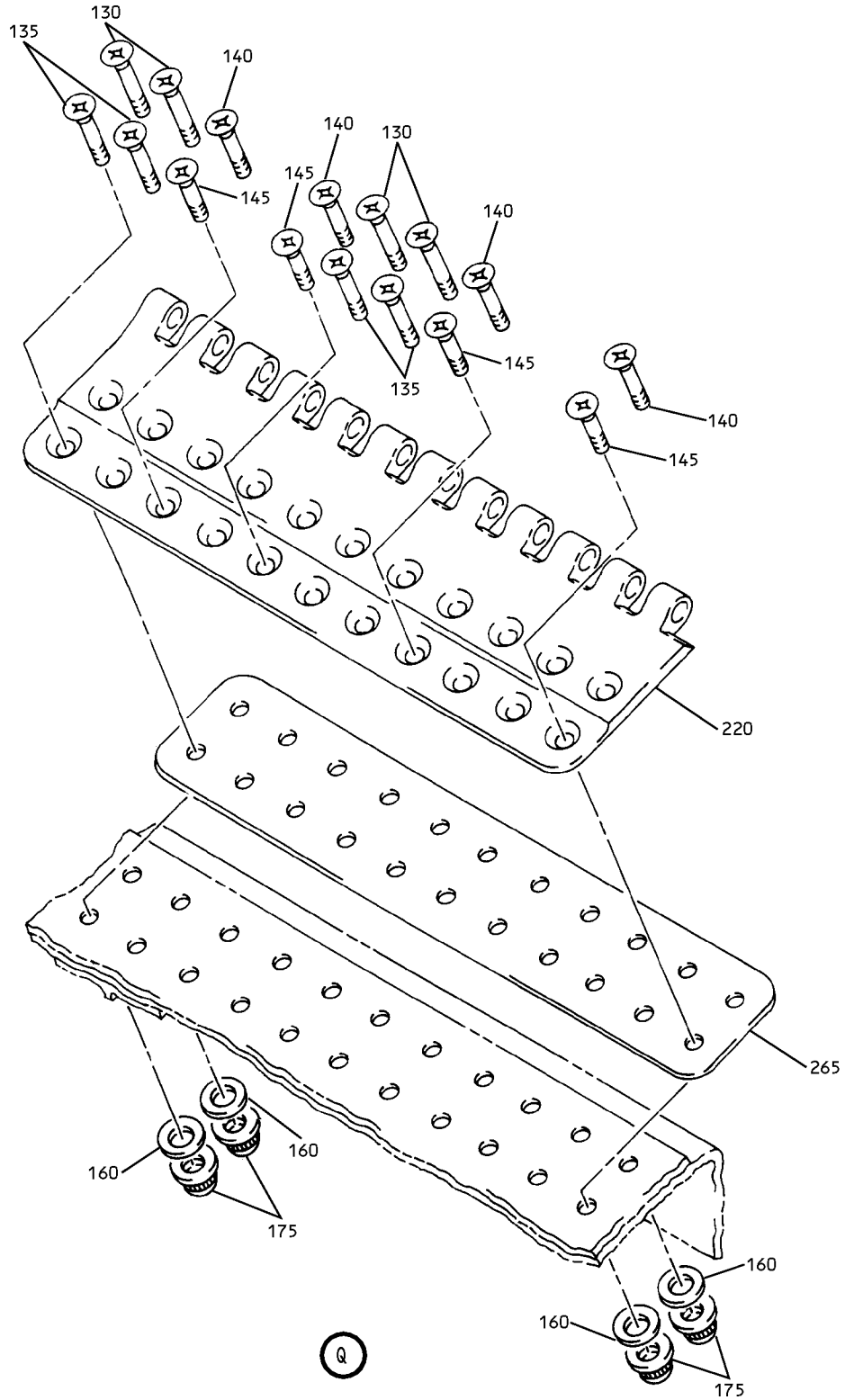
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Main Deck Cargo Door Upper Beam Installation
Figure 19 (Sheet 14)

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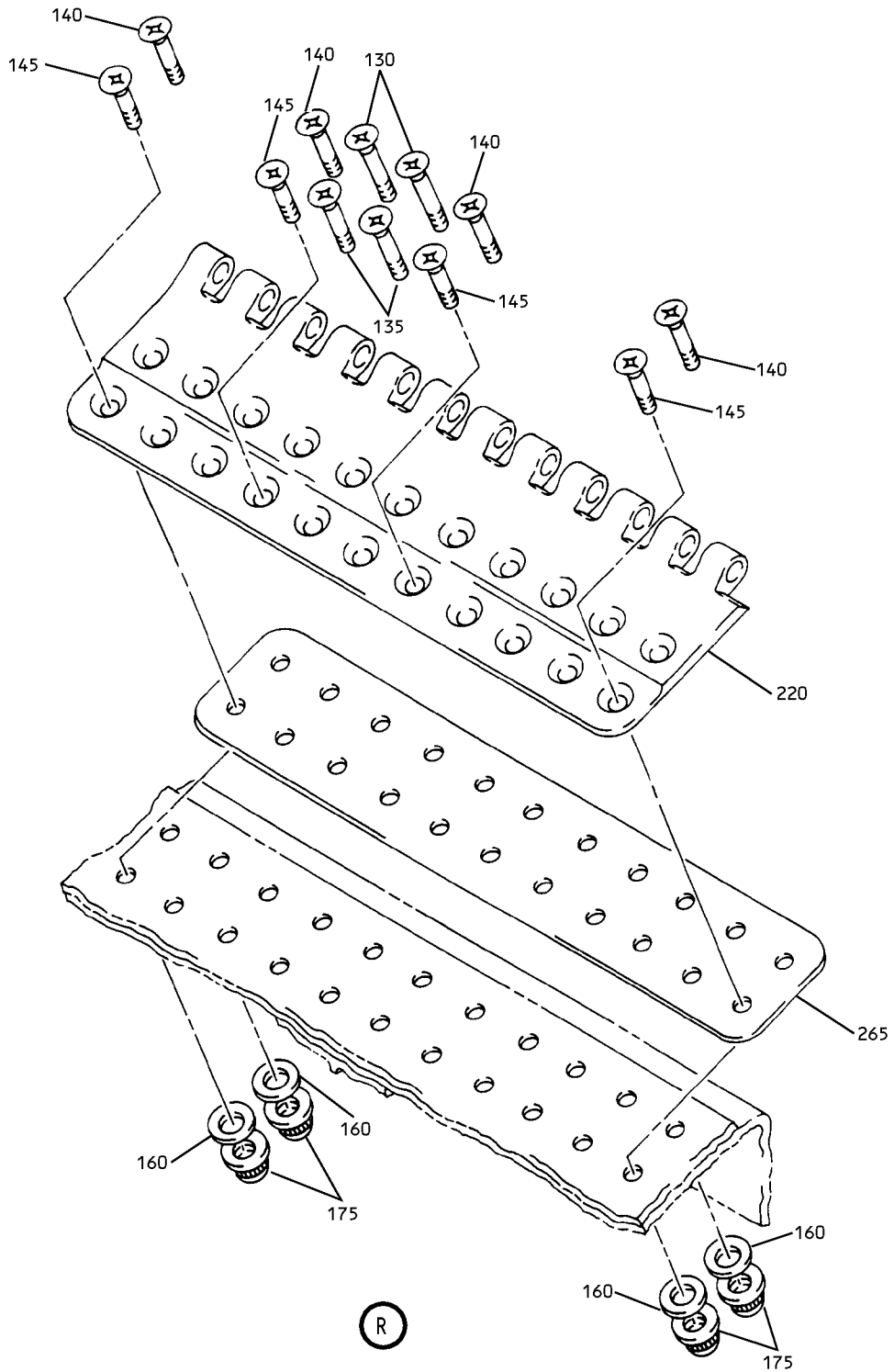
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Main Deck Cargo Door Upper Beam Installation
 Figure 19 (Sheet 15)

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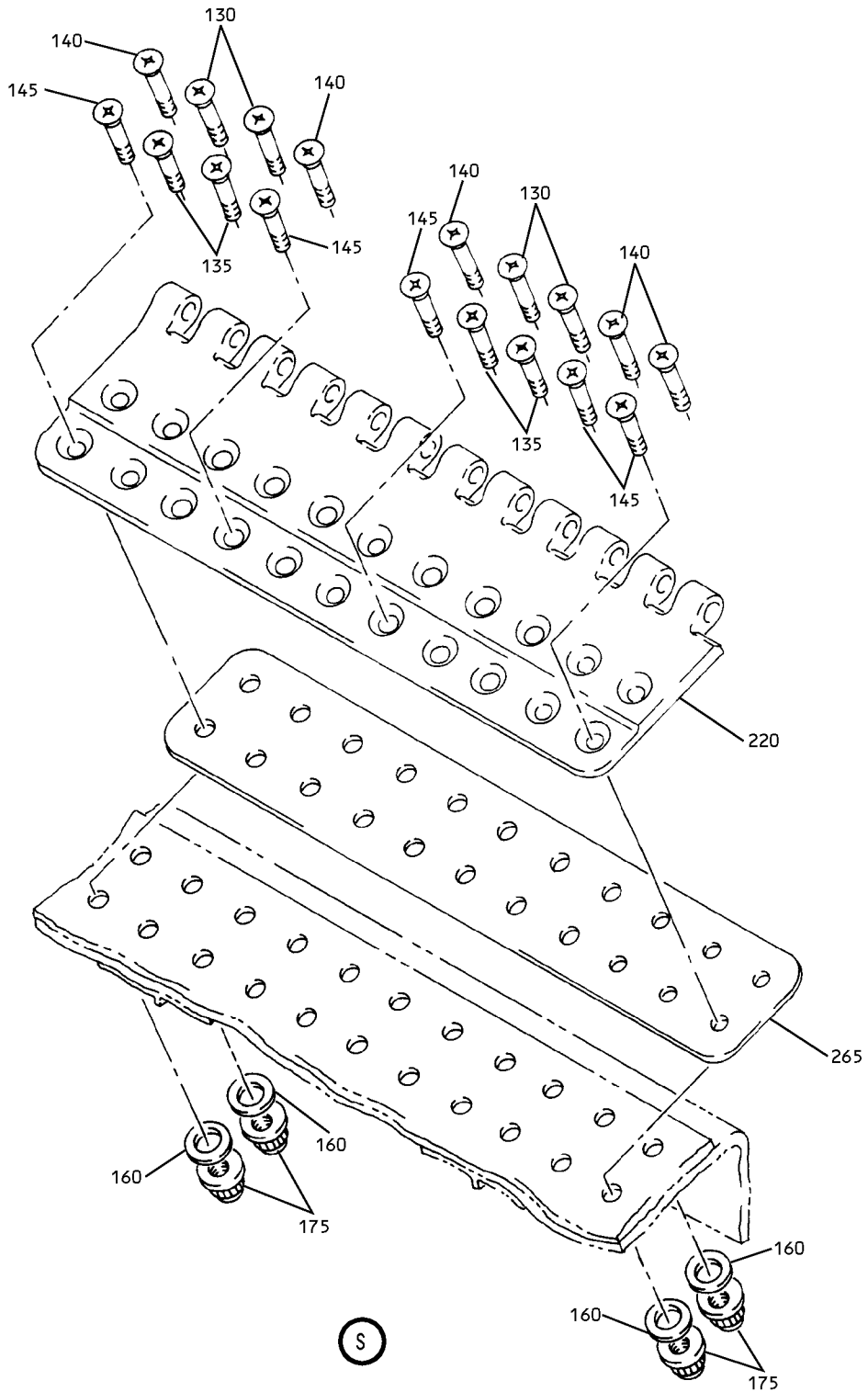
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Main Deck Cargo Door Upper Beam Installation
Figure 19 (Sheet 16)

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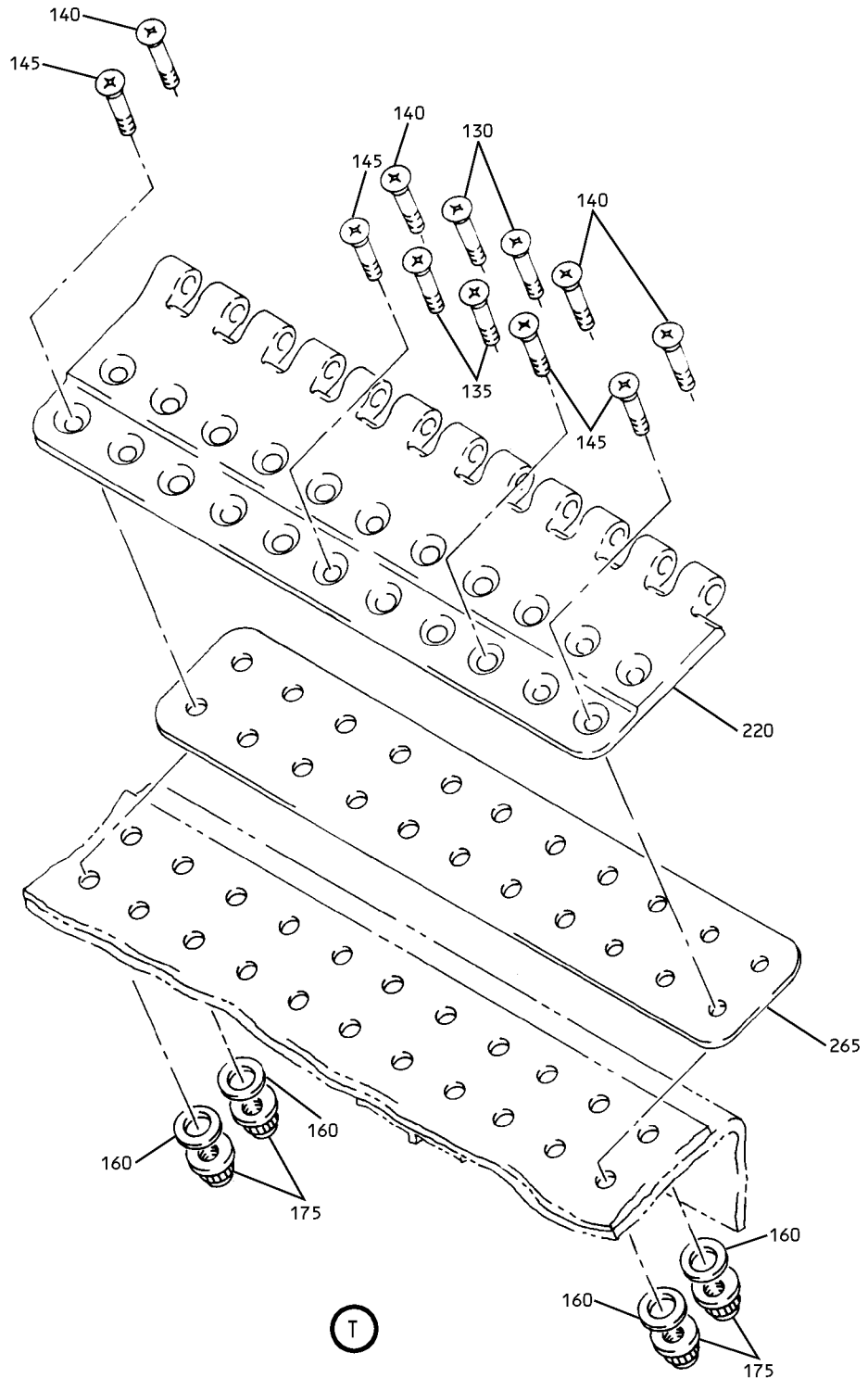
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Main Deck Cargo Door Upper Beam Installation
Figure 19 (Sheet 17)

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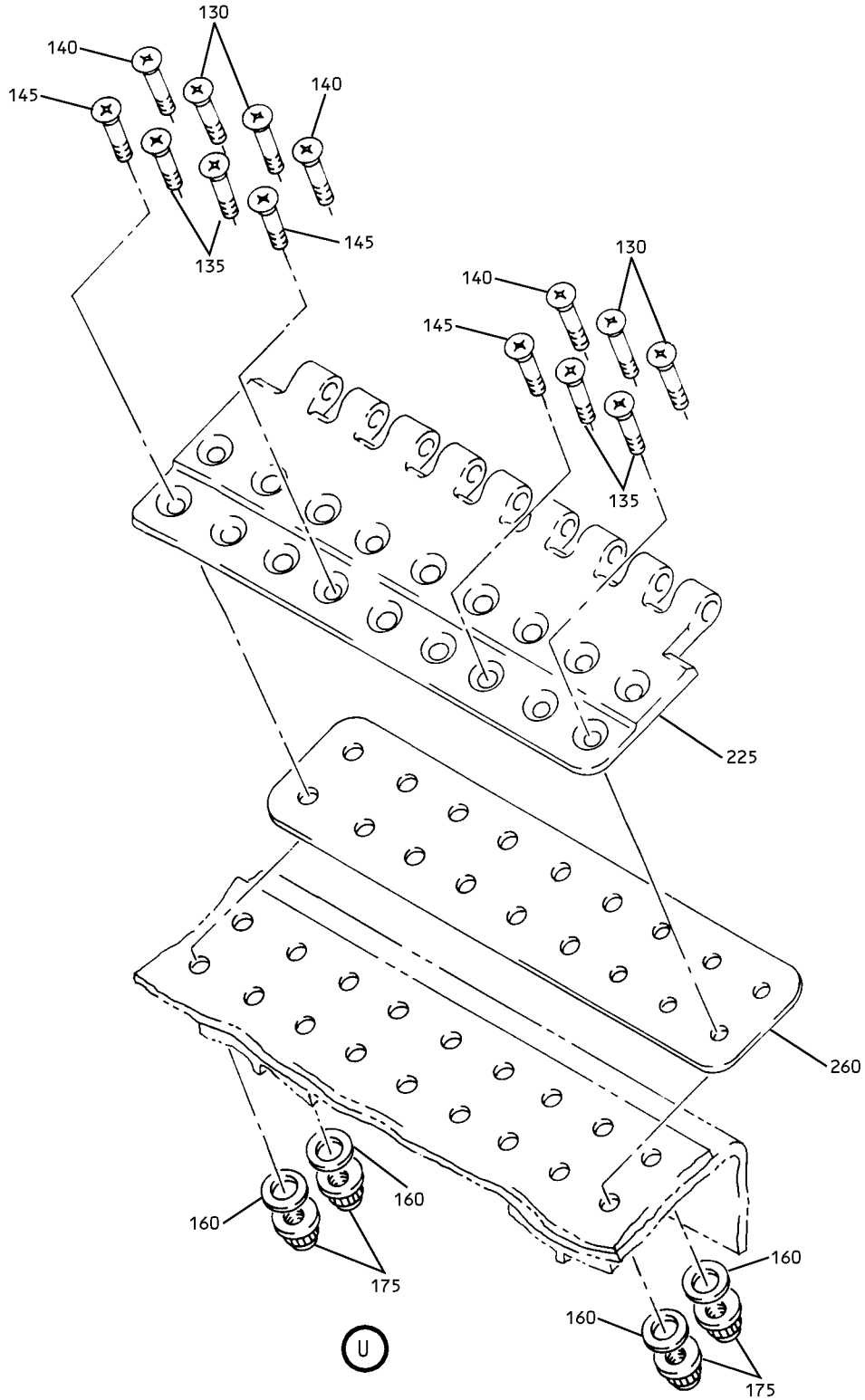
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Main Deck Cargo Door Upper Beam Installation
Figure 19 (Sheet 18)

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Main Deck Cargo Door Upper Beam Installation
Figure 19 (Sheet 19)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 19-					
R -1A	143T6258-40		BEAM INSTL-UPR	B	RF
R 5	BACR15FT6KE		.RIVET-	B	27
			(SIZE DETERMINE ON INST)		
R 10	453T7034-51		.SUPPORT ASSY-SIDEWALL	B	1
R 15	BACR15BA3AD		..RIVET-	B	18
			(SIZE DETERMINE ON INST)		
R 20	BRF200C3D		..NUTPLATE-	B	9
			(V52828)		
			(SPEC BACN10JR3CFD)		
			(OPT K51602-3BAC		
			(V15653))		
			(OPT NS202476-02		
			(V80539))		
			(OPT 102F9201-3		
			(V72962))		
			(OPT T8092C1032CD		
			(V11815))		
R 25	453T7034-52		..ANGLE	B	1
R 30	453T7034-43		.SUPPORT ASSY-SIDEWALL	B	1
R 35	BACR15BA3AD		..RIVET-	B	20
			(SIZE DETERMINE ON INST)		
R 40	BRF200C3D		..NUTPLATE-	B	10
			(V52828)		
			(SPEC BACN10JR3CFD)		
			(OPT K51602-3BAC		
			(V15653))		
			(OPT NS202476-02		
			(V80539))		
			(OPT 102F9201-3		
			(V72962))		
			(OPT T8092C1032CD		
			(V11815))		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 19-45	453T7034-44		. . ANGLE	B	1
R 50	BACR15CE3AD		. RIVET- (SIZE DETERMINE ON INST)	B	104
R 55	F51645-3BAC		. NUTPLATE- (V15653) (SPEC BACN10JZ3A4CDM) (OPT 102F9221-3 (V72962)) (OPT NS202492A02 (V80539))	B	52
R 60	HL1012AZ12-7		. BOLT- (VOPTK6) (SPEC BACB30NX12K7) (OPT HL12VAZ12-7 (V73197)) (OPT HL12VAZ12-7 (V92215)) (OPT HL12VAZ12-7 (V97928)) (OPT L802-12K7 (V06725)) (OPT HL12VAZ12-7 (V56878)) (OPT HL1012AZ12-7 (V06725)) (OPT HL1012AZ12-7 (V06950)) (OPT HL1012AZ12-7 (V17446)) (OPT HL1012AZ12-7 (V56878)) (OPT HL1012AZ12-7 (V60516)) (OPT HL1012AZ12-7 (V73197)) (OPT HL1012AZ12-7 (V97928))	B	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 19-65	HL1012AZ12-10		.BOLT- (VOPTK6) (SPEC BACB30NX12K10) (OPT HL12VAZ12-10 (V73197)) (OPT HL12VAZ12-10 (V92215)) (OPT HL12VAZ12-10 (V97928)) (OPT L802-12K10 (V06725)) (OPT HL12VAZ12-10 (V56878)) (OPT HL1012AZ12-10 (V06725)) (OPT HL1012AZ12-10 (V06950)) (OPT HL1012AZ12-10 (V17446)) (OPT HL1012AZ12-10 (V56878)) (OPT HL1012AZ12-10 (V60516)) (OPT HL1012AZ12-10 (V73197)) (OPT HL1012AZ12-10 (V97928))	B	6

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 19-70	HL1012AZ12-9		.BOLT- (VOPTK6) (SPEC BACB30NX12K9) (OPT HL12VAZ12-9 (V73197)) (OPT HL12VAZ12-9 (V92215)) (OPT HL12VAZ12-9 (V97928)) (OPT L802-12K9 (V06725)) (OPT HL12VAZ12-9 (V56878)) (OPT HL1012AZ12-9 (V06725)) (OPT HL1012AZ12-9 (V06950)) (OPT HL1012AZ12-9 (V17446)) (OPT HL1012AZ12-9 (V56878)) (OPT HL1012AZ12-9 (V60516)) (OPT HL1012AZ12-9 (V73197)) (OPT HL1012AZ12-9 (V97928))	B	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 19-75	HL1012AZ10-9		.BOLT- (VOPTK6) (SPEC BACB30NX10K9) (OPT HL12VAZ10-9 (V73197)) (OPT HL12VAZ10-9 (V92215)) (OPT HL12VAZ10-9 (V97928)) (OPT L802-10K9 (V06725)) (OPT HL12VAZ10-9 (V56878)) (OPT HL1012AZ10-9 (V06725)) (OPT HL1012AZ10-9 (V06950)) (OPT HL1012AZ10-9 (V17446)) (OPT HL1012AZ10-9 (V56878)) (OPT HL1012AZ10-9 (V60516)) (OPT HL1012AZ10-9 (V73197)) (OPT HL1012AZ10-9 (V97928))	B	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 19-80	HL1012AZ10-7		.BOLT- (VOPTK6) (SPEC BACB30NX10K7) (OPT HL12VAZ10-7 (V73197)) (OPT HL12VAZ10-7 (V92215)) (OPT HL12VAZ10-7 (V97928)) (OPT L802-10K7 (V06725)) (OPT HL12VAZ10-7 (V56878)) (OPT HL1012AZ10-7 (V06725)) (OPT HL1012AZ10-7 (V06950)) (OPT HL1012AZ10-7 (V17446)) (OPT HL1012AZ10-7 (V56878)) (OPT HL1012AZ10-7 (V60516)) (OPT HL1012AZ10-7 (V73197)) (OPT HL1012AZ10-7 (V97928))	B	4
R 85	BACB30NN6K15		.BOLT	B	4
R 90	BACB30NN6K12		.BOLT	B	4
R 95	BACB30NN6K14		.BOLT	B	4
R 100	BACB30NN6K10		.BOLT	B	4
R 105	BACB30NT6K13		.BOLT	B	4
R 110	BACB30NT6K9		.BOLT	B	4
R 115	BACB30NN5K13		.BOLT	B	8
R 120	BACB30NN5K11		.BOLT	B	24
R 125	BACB30NN5K9		.BOLT	B	16
R 130	BACB30NN4K12		.BOLT	B	26
R 135	BACB30NN4K11		.BOLT	B	26
R 140	BACB30NN4K10		.BOLT	B	58
R 145	BACB30NN4K9		.BOLT	B	58
R 150	BACW10BP6DP		.WASHER	B	38
R 155	BACW10BP5DP		.WASHER	B	56
R 160	BACW10BP4DP		.WASHER	B	168
R 165	NAS1804-6		.NUT	B	30
R 170	NAS1804-5		.NUT	B	56

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 19-					
R 175	NAS1804-4		.NUT	B	168
R 180	H52732-6CD		.NUT- (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))	B	8
R 185	143T6263-10		.FITTING-HINGE	B	1
R 190	143T6263-4		.FITTING-HINGE	B	1
R 195	143T6263-7		.FITTING-HINGE	B	1
R 200	143T6263-9		.FITTING-HINGE	B	1
R 205	143T6263-2		.FITTING-HINGE	B	1
R 210	143T6263-8		.FITTING-HINGE	B	1
R 215	143T6262-3		.FITTING-HINGE	B	1
R 220	143T6262-2		.FITTING-HINGE	B	6
R 225	143T6262-1		.FITTING-HINGE	B	1
R 230	143T6258-25		.SHIM-LAMINATED	B	2
R 235	143T6258-26		.SHIM-LAMINATED	B	2
R 240	143T6258-27		.SHIM-LAMINATED	B	2
R 245	143T6258-20		.SHIM-LAMINATED	B	2
R 250	143T6258-21		.SHIM-LAMINATED	B	2
R 255	143T6258-22		.SHIM-LAMINATED	B	2
R 260	143T6258-23		.SHIM-LAMINATED	B	2
R 265	143T6258-24		.SHIM-LAMINATED	B	6

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 19-270	HL1012AZ8-5		.BOLT- (VOPTK6) (SPEC BACB30NX8K5) (OPT HL12VAZ8-5 (V73197)) (OPT HL12VAZ8-5 (V92215)) (OPT HL12VAZ8-5 (V97928)) (OPT L802-8K5 (V06725)) (OPT HL12VAZ8-5 (V56878)) (OPT HL1012AZ8-5 (V06725)) (OPT HL1012AZ8-5 (V06950)) (OPT HL1012AZ8-5 (V17446)) (OPT HL1012AZ8-5 (V56878)) (OPT HL1012AZ8-5 (V60516)) (OPT HL1012AZ8-5 (V73197)) (OPT HL1012AZ8-5 (V97928))	B	2
R 275	HST10AG6-4		.BOLT- (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (VOPTK6))	B	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 19-280	HST10AG6-3		.BOLT- (V0PTK6) (SPEC BACB30VT6K3) (OPT HST10AG6-3 (V06725)) (OPT HST10AG6-3 (V56878)) (OPT HST10AG6-3 (V73197))	B	4
R 285	HL1187-8		.COLLAR- (V5M902) (SPEC BACC30X8) (OPT HL87-8 (V73197)) (OPT HL87-8 (V92215)) (OPT HL1187-8 (V56878)) (OPT HL1187-8 (V92215)) (OPT HL87-8 (V56878)) (OPT HL1187-8 (V73197))	B	2
R 290	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))	B	8
R 295	143T6261-2		.GUSSET	B	1
R 300	143T6261-1		.GUSSET	B	1
R 305	VNS1924CA1-8		.STUD- (V5M902) (SPEC BACS53B1EA1) (OPT VNS1924CA3-1-8 (V92215))	B	2
R 310	BACR15BB8AD		.RIVET- (SIZE DETERMINE ON INST)	B	2

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