

 **BOEING**  
COMPONENT  
MAINTENANCE MANUAL

TO: ALL HOLDERS OF LARGE CARGO DOOR COMPONENTS COMPONENT MAINTENANCE MANUAL  
52-34-25

REVISION NO. 2 DATED JUL 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 on the Record of Revision Sheet.

CHAPTER/SECTION

AND PAGE NO.

ALL PAGES

DESCRIPTION OF CHANGE

Changed the header block to identify that this CMM is for the Large Cargo Door instead of the Forward Cargo Door.

TITLE PAGE

1

1004,1008-1011

Changed the title and part number nomenclature from "Forward Cargo Door" to "Large Cargo Door."

**52-34-25**

HIGHLIGHTS

01.1

Page 1

Jul 01/03

# LARGE CARGO DOOR COMPONENTS

PART NUMBER SEE CONTENTS, PAGE 1

COMPONENT MAINTENANCE MANUAL  
WITH  
ILLUSTRATED PARTS LIST

**52-34-25**

TITLE PAGE

Page 1

Jul 01/03

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 |
|-----------------|---------------|------------|----|-----------------|---------------|------------|----|
|                 |               |            |    |                 |               |            |    |

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

| BOEING<br>SERVICE<br>BULLETIN | BOEING<br>TEMPORARY<br>REVISION | OTHER<br>DIRECTIVE | DATE OF<br>INCORPORATION<br>INTO MANUAL |
|-------------------------------|---------------------------------|--------------------|---|
|                               |                                 |                    |   |

**52-34-25**

TR & SB RECORD

01.1

Page 1

Jul 01/03

| PAGE                    | DATE      | CODE | PAGE                   | DATE      | CODE |
|-------------------------|-----------|------|------------------------|-----------|------|
| 52-34-25                |           |      | REPAIR 3-1             |           |      |
| TITLE PAGE              |           |      | *601                   | JUL 01/03 | 01.1 |
| *1                      | JUL 01/03 | 01.1 | 602                    | BLANK     |      |
| 2                       | BLANK     |      | ILLUSTRATED PARTS LIST |           |      |
| REVISION RECORD         |           |      | *1001                  | JUL 01/03 | 01.1 |
| *1                      | JUL 01/03 | 01.1 | *1002                  | JUL 01/03 | 01.1 |
| 2                       | BLANK     |      | *1003                  | JUL 01/03 | 01.1 |
| TR & SB RECORD          |           |      | *1004                  | JUL 01/03 | 01.1 |
| *1                      | JUL 01/03 | 01.1 | *1005                  | JUL 01/03 | 01.1 |
| 2                       | BLANK     |      | *1006                  | JUL 01/03 | 01.1 |
| LIST OF EFFECTIVE PAGES |           |      | 1007                   | BLANK     |      |
| *1                      | JUL 01/03 | 01   | *1008                  | JUL 01/03 | 01.1 |
| THRU LAST PAGE          |           |      | *1009                  | JUL 01/03 | 01.1 |
| CONTENTS                |           |      | *1010                  | JUL 01/03 | 01.1 |
| *1                      | JUL 01/03 | 01.1 | *1011                  | JUL 01/03 | 01.1 |
| 2                       | BLANK     |      | 1012                   | BLANK     |      |
| INTRODUCTION            |           |      |                        |           |      |
| *1                      | JUL 01/03 | 01.1 |                        |           |      |
| 2                       | BLANK     |      |                        |           |      |
| DESCRIPTION & OPERATION |           |      |                        |           |      |
| *1                      | JUL 01/03 | 01.1 |                        |           |      |
| 2                       | BLANK     |      |                        |           |      |
| REPAIR 1-1              |           |      |                        |           |      |
| *601                    | JUL 01/03 | 01.1 |                        |           |      |
| *602                    | JUL 01/03 | 01.1 |                        |           |      |
| *603                    | JUL 01/03 | 01.1 |                        |           |      |
| *604                    | JUL 01/03 | 01.1 |                        |           |      |
| REPAIR 2-1              |           |      |                        |           |      |
| *601                    | JUL 01/03 | 01.1 |                        |           |      |
| *602                    | JUL 01/03 | 01.1 |                        |           |      |
| *603                    | JUL 01/03 | 01.1 |                        |           |      |
| *604                    | JUL 01/03 | 01.1 |                        |           |      |

\* = REVISED, ADDED OR DELETED

**52-34-25**

EFFECTIVE PAGES  
LAST PAGE Page 1  
01 Jul 01/03

TABLE OF CONTENTS

NOTE: This manual contains overhaul data for various components of the Large Cargo Door Drive System. Functions which cannot be performed by the use of standard industry practices are included in repair instructions for each component.

LARGE CARGO DOOR COMPONENTS

| <u>PART NUMBER</u> | <u>NOMENCLATURE</u>   | <u>PAGE</u>     |
|--------------------|-----------------------|-----------------|
| - -                | REPAIR GENERAL        | 601, REPAIR-GEN |
| 258T5004           | SHAFT, DRIVE          | 601, REPAIR 1-1 |
| 258T5005           | SHAFT, DRIVE          | 601, REPAIR 2-1 |
| 258T5021           | LINK, SUPPORT         | 601, REPAIR 3-1 |
| - -                | ILLUSTRATED PART LIST | 1001            |

**52-34-25**

CONTENTS

01.1

Page 1

Jul 01/03

## INTRODUCTION

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

This manual is divided into separate sections:

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

Refer to the Table of Contents for the page location of applicable sections. An asterisked flagnote \*[ ] in place of the page number indicates that no special instructions are provided since the function can be performed using standard industry practices.

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

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

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

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

**52-34-25**

INTRODUCTION

01.1

Page 1

Jul 01/03

REPAIR – GENERAL

1. Content

- A. Each separate repair includes, as applicable, check, repair and refinish instructions.

2. Standard Practices

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

20-10-03 Shot Peening  
20-10-04 Grinding of Chrome Plated Parts  
20-20-01 Magnetic Particle Inspection  
20-20-02 Penetrant Methods of Inspection  
20-30-02 Stripping of Protective Finishes  
20-41-01 Decoding Table for Boeing Finish Codes  
20-41-02 Application of Chemical and Solvent Resistant Finishes  
20-42-03 Hard Chrome Plating  
20-42-05 Bright Cadmium Plating  
20-43-01 Chromic Acid Anodizing  
20-50-03 Bearing Installation and Retention

3. Materials

NOTE: Equivalent substitutes may be used.

- A. Grease -- MIL-G-23827 (Ref 20-60-03)  
B. Sealant -- BMS 5-95 (Ref 20-60-04)  
C. Primer -- BMS 10-11, type 1 (Ref 20-60-02)  
D. Enamel -- BMS 10-11, type 2, color white gloss (BAC 702) (Ref 20-60-02)  
E. Corrosion Preventive Compound -- MIL-C-11796, class 1 (Ref 20-60-02)  
F. Grease -- BMS 3-24 (Ref 20-60-03)

**52-34-25**

DESCRIPTION & OPERATION

01.1

Page 1

Jul 01/03



DRIVE SHAFT ASSEMBLY – REPAIR 1-1

258T5004-3

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. Item numbers refer to IPL Fig. 1.

1. Check

- A. Magnetic particle check fittings (45, 70) per 20-20-01.
- B. Penetrant check fitting (35), tube (75) per 20-20-02.

2. Repair

A. Parts Replacement (Fig. 601)

- (1) Remove rivets (40), fitting (35, 45) from tube (75).
- (2) Remove collars (30), washers (23), bolts (20) and bearing (50) from fitting (35).
- (3) Remove rivet (55), washers (60), bushing (65) and separate fitting (70) from tube (75).
- (4) Position fitting (70) on tube (75). Coat bushing (65) with grease, MIL-G-23827, and install bushing, washers (60) and rivet (55) to secure fitting.
- (5) Install bearing (50) in fitting and install bolts (20), washers (25) and collars (30). Install fitting (35) on fitting (45).
- (6) Coat faying surfaces of fitting (45) with sealant and install on tube (75). Secure fitting (45) with rivets (40). Install rivets with wet sealant.

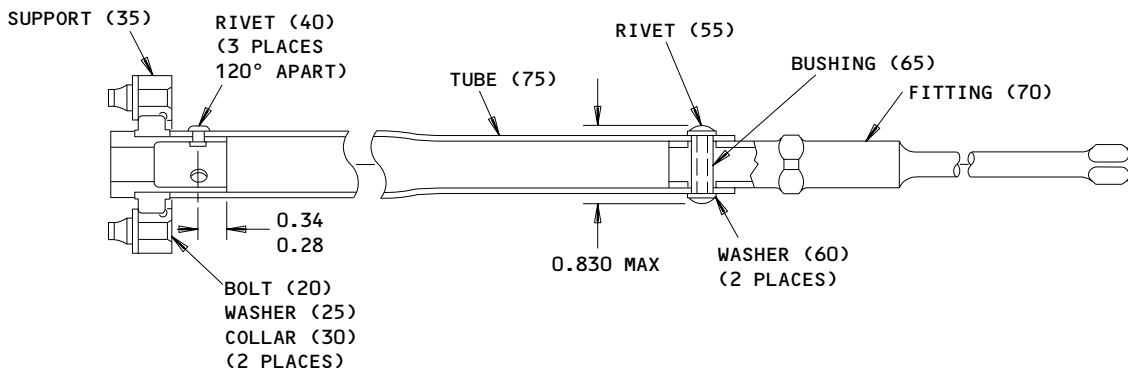
**52-34-25**

REPAIR 1-1

01.1

Page 601

Jul 01/03



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

Parts Replacement  
 Figure 601

B. Fitting (45) Bearing Seat Repair (Fig. 602)

- (1) Machine bearing seat as required, within repair limits shown, to remove defects.
- (2) Shot peen as indicated.
- (3) Build up repair surface with chrome plate and grind to design dimension and finish shown.

C. Refinish

- (1) Fitting (35) -- Chromic acid anodize and apply 1 coat of primer (F-18.13) except omit primer in bore for bearing. Material: Al alloy.
- (2) Fitting (45) -- Fig. 602
- (3) Fitting (70) -- Passivate (F-17.09) all over. Material: 15-5PH CRES, 150-170 ksi.

159432

**52-34-25**

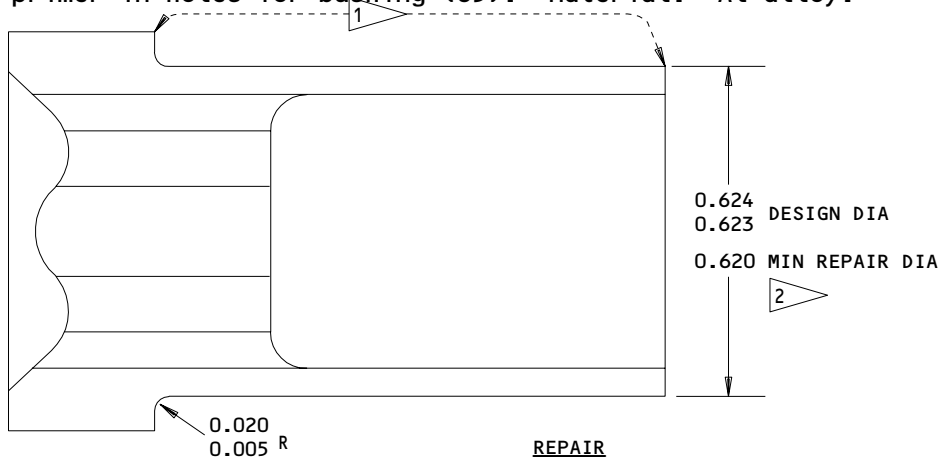
REPAIR 1-1

01.1

Page 602

Jul 01/03

- (4) Tube (75) -- Chemical treat and apply 1 coat of primer (F-18.07) all over and coat interior with corrosion preventive compound (F-19.03). Omit primer in holes for bushing (65). Material: Al alloy.



**REFINISH**

PASSIVATE (F-17.09) ALL OVER AND CADMIUM PLATE (F-15.06) AREA INDICATED BY 1

- 1 CADMIUM PLATE (F-15.06) THIS SURFACE
- 2 BUILD UP WITH CHROME PLATE (F-15.03) AND GRIND TO DESIGN DIMENSION SHOWN. CHROME PLATE RUNOUT 0.00-0.08. NO PLATING ALLOWED IN FILLET RADIUS OR EDGE. CHROME PLATE BEARING INTERFACE AREA ONLY

**REPAIR**

REF 2

SHOT PEEN: (REF 20-10-03)  
0.017-0.046 SHOT SIZE  
0.003-0.005A2 INTENSITY

ALL MACHINED SURFACES 125 ✓ OR GREATER  
BREAK SHARP EDGES 0.008R

MATERIAL: 15-5PH CRES, 150-170 KSI

ALL DIMENSIONS ARE IN INCHES

Fitting Repair  
Figure 602

159434

52-34-25

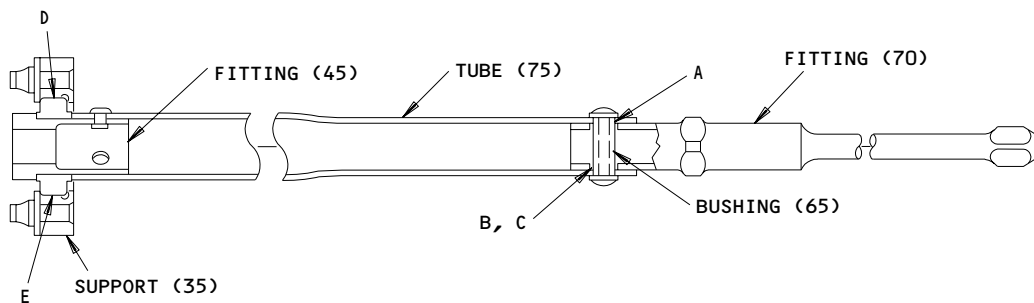
REPAIR 1-1

01.1

Page 603

Jul 01/03

**3. Fits and Clearances**



| Ref Letter<br>Fig.603 | Mating Item No.<br>IPL Fig.1 | Design Dimension |        |                         |        | Service Wear Limit |        |                   |
|-----------------------|------------------------------|------------------|--------|-------------------------|--------|--------------------|--------|-------------------|
|                       |                              | Dimension        |        | Assembly Clearance *[1] |        | Dimension          |        | Maximum Clearance |
|                       |                              | Min              | Max    | Min                     | Max    | Min                | Max    |                   |
| A                     | ID 75                        | 0.2500           | 0.2520 | -0.0010                 | 0.0020 | 0.2460             | 0.2550 | 0.0040            |
|                       | OD 65                        | 0.2500           | 0.2510 |                         |        |                    |        |                   |
| B                     | 70 *[2]                      | 0.280            | 0.300  | 0.029                   | 0.050  | 0.243              | 0.259  | 0.060             |
|                       | OD 65                        | 0.2500           | 0.2510 |                         |        |                    |        |                   |
| C                     | 70 *[3]                      | 0.251            | 0.254  | 0.0000                  | 0.004  | 0.243              | 0.259  | 0.008             |
|                       | OD 65                        | 0.2500           | 0.2510 |                         |        |                    |        |                   |
| D                     | ID 50                        | 0.6245           | 0.6250 | 0.0005                  | 0.0020 | 0.6205             | 0.6280 | 0.0040            |
|                       | OD 45                        | 0.6230           | 0.6240 |                         |        |                    |        |                   |
| E                     | ID 35                        | 1.1250           | 1.1265 | 0.0000                  | 0.0020 | 1.1210             | 1.1290 | 0.0040            |
|                       | OD 45                        | 1.1245           | 1.1250 |                         |        |                    |        |                   |

\*[1] NEGATIVE VALUES DENOTE INTERFERENCE FIT  
 \*[2] SLOT LENGTH  
 \*[3] SLOT WIDTH  
 ALL DIMENSIONS ARE IN INCHES

Fits and Clearances  
 Figure 603

159445

**52-34-25**

REPAIR 1-1

01.1

Page 604

Jul 01/03

DRIVE SHAFT ASSEMBLY – REPAIR 2-1

258T5005-3, -5

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. Item numbers refer to IPL Fig. 2.

1. Check

- A. Magnetic particle check fittings (20), couplings (25) per 20-20-01.
- B. Penetrant check tube (30, 40) per 20-20-02.

2. Repair

- A. Parts replacement (Fig. 601)
  - (1) Remove and discard plugs (15).
  - (2) Remove rivets (5, 10) and fittings (20) from tube (30 or 40). Separate couplings (25) from fittings (20).
  - (3) Assemble couplings (25) on fittings (20).
  - (4) Position fittings on tube (30 or 40) at dimensions shown and secure with rivets (5, 10). Install fittings with sealant on faying surfaces and install rivets with sealant.
  - (5) Install plugs (15) into fittings (20).
  - (6) Fillet seal joints between fittings (20) and tube (30 or 40) with sealant.

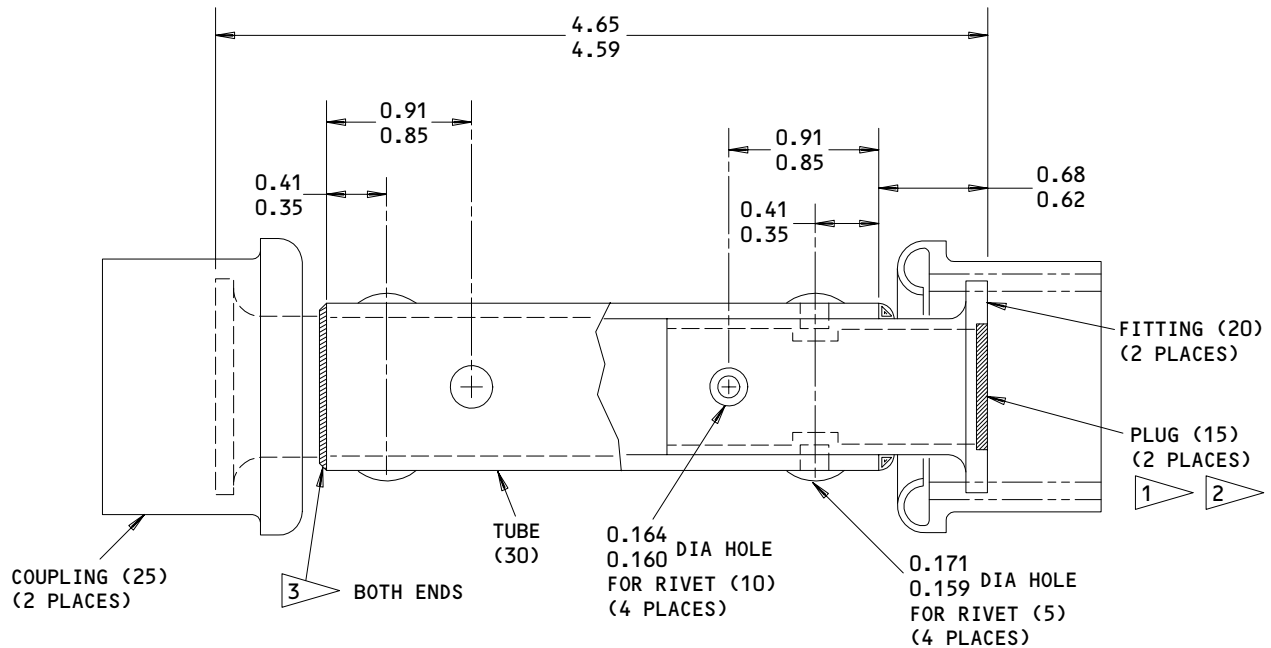
**52-34-25**

REPAIR 2-1

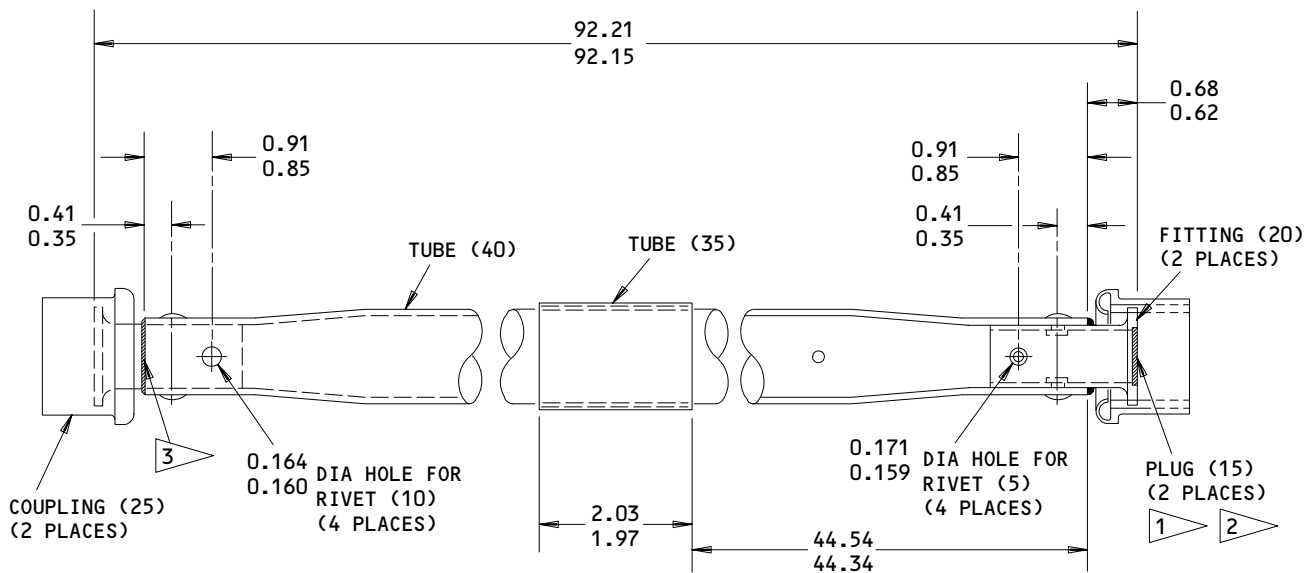
01.1

Page 601

Jul 01/03



258T5005-3



- 1 DEFORM PLUG UNTIL FLAT UPON INSTALLATION
- 2 INSTALL PLUG AFTER FITTINGS ARE INSTALLED
- 3 FILLET SEAL WITH SEALANT, BMS 5-95

ITEM NUMBERS REFER TO IPL FIG. 2  
 ALL DIMENSIONS ARE IN INCHES

258T5005-5  
 Parts Replacement  
 Figure 601

**52-34-25**

REPAIR 2-1

Page 602

Jul 01/03

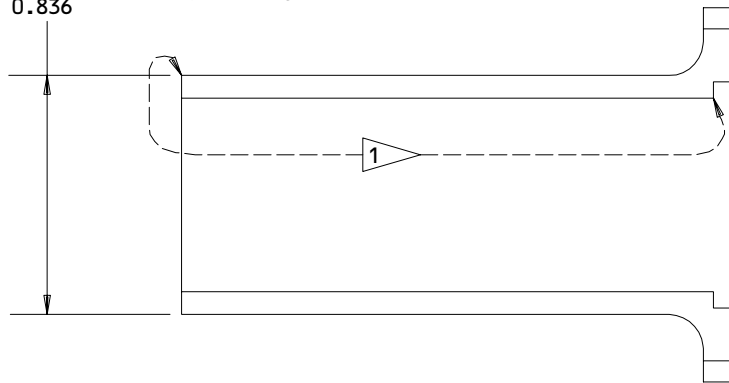
01.1

B. Refinish

- (1) Fitting (20) -- Fig. 602.
- (2) Coupling (25) -- Fig. 603.
- (3) Tube (30, 40) -- Chemical treat and apply 1 coat of primer (F-18.07) all over and apply corrosion preventive compound (F-19.03) to interior surfaces. Omit primer and corrosion preventive compound to 0.842-0.846 inch I.D.. Material: Al alloy.
- (4) Drive shaft assembly (1, 1A) -- Apply 1 coat of enamel (SRF-14.905-702) except omit enamel on splines. On item 1A, apply enamel prior to installation of tube (35).

0.8402 DIA BEFORE PLATING  
0.8356

0.841 DIA AFTER PLATING  
0.836



**REFINISH**

CADMIUM PLATE (F-15.02) ALL OVER AND APPLY  
PRIMER AS NOTED

MATERIAL: 4340 STEEL, 150-170 KSI  
ALL DIMENSIONS ARE IN INCHES

 APPLY ONE COAT OF PRIMER (F-20.02)

Fitting Refinish  
Figure 602

159441

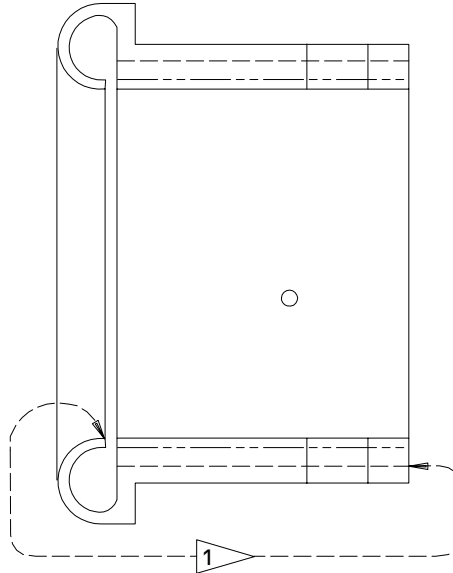
**52-34-25**

REPAIR 2-1

01.1

Page 603

Jul 01/03



**REFINISH**

CADMIUM PLATE (F-15.02) ALL OVER AND APPLY  
PRIMER AS NOTED

1 APPLY ONE COAT OF PRIMER (F-20.02) THIS  
SURFACE ONLY

MATERIAL: 4140 STEEL, 150-170 KSI

Coupling Refinish  
Figure 603

159442

**52-34-25**

REPAIR 2-1

01.1

Page 604

Jul 01/03



SUPPORT LINK ASSEMBLY – REPAIR 3-1

258T5021-1

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require stripping and restoration of original finish, refer to REFINISH instruction, Fig. 601. Item numbers refer to IPL Fig. 3.

1. Penetrant check link (10) per 20-20-02.
2. Repair
  - A. Bearing (5) Replacement
    - (1) Remove bearing.
    - (2) Install replacement bearing with grease, BMS 3-24 and roller swage per 20-50-03.
  - B. Link (10) refinish -- Chromic acid anodize and apply 1 coat of primer (F-18.13) all over, then apply 1 coat of enamel (SRF-14.905-702). Omit primer and enamel in holes. Material: Al alloy.

**52-34-25**

REPAIR 3-1

01.1

Page 601

Jul 01/03

ILLUSTRATED PARTS LIST

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

2. Indentures show parts relationships as follows:

Assembly

Detail Parts for Assembly

Subassembly

Attaching Parts for Subassembly

Detail Parts for Subassembly

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

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

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

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

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

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

6. Parts Interchangeability

Optional  
(OPT)

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

Supersedes, Superseded By  
(SUPSDS, SUPSD BY)

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

Replaces, Replaced By  
(REPLS, REPLD BY)

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

VENDORS

09192 ALUMINUM COMPANY OF AMERICA VERNON WORKS  
5151 ALCOA AVENUE  
VERNON, CALIFORNIA 90058

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

42838 NATIONAL RIVET AND MANUFACTURING COMPANY  
1-21 EAST JEFFERSON STREET  
WAUPUN, WISCONSIN 53963

50294 NMB INC  
9730 INDEPENDENCE AVENUE  
CHATSWORTH, CALIFORNIA 91311

53551 ALLFAST FASTENING SYSTEMS INC  
15252 DON JULIAN ROAD PO BOX 3166  
CITY OF INDUSTRY, CALIFORNIA 91744

55580 BRILES RIVET CORP  
2640 VISTA PACIFIC DRIVE  
OCEANSIDE, CALIFORNIA 92056

56878 SPS TECHNOLOGIES INC  
HIGHLAND AVENUE  
JENKINTOWN, PENNSYLVANIA 19046

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

73287 HUBBARD, M.D. SPRING CO INC  
595 SOUTH LAPEER PO BOX 425  
OXFORD, MICHIGAN 48051

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

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

52-34-25

ILLUSTRATED PARTS LIST  
01.1 Page 1002  
Jul 01/03

LARGE CARGO DOOR  
COMPONENTS (SEE  
CONTENTS FOR P/N'S)



VENDORS

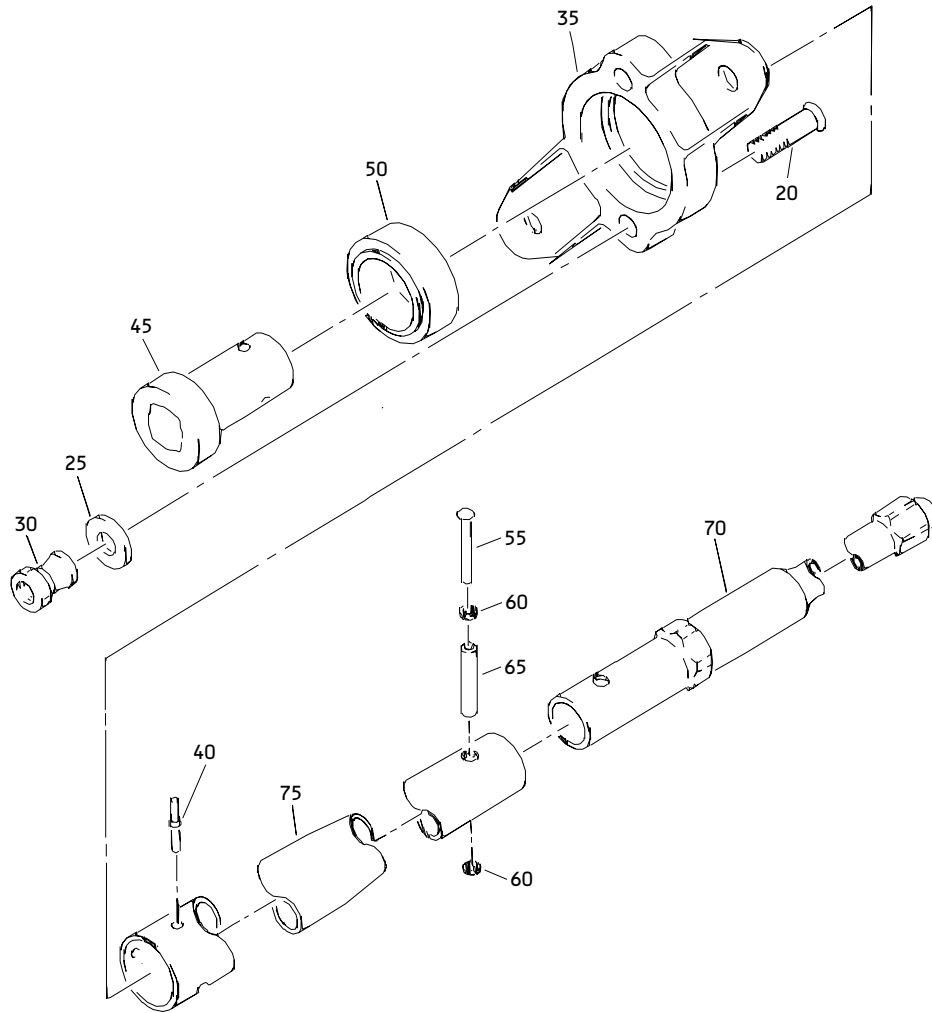
92215 VOI-SHAN DIV OF VSI CORP SUB OF FAIRCHILD INDUSTRIAL INC  
8463 HIGUERA STREET  
CULVER CITY, CALIFORNIA 90230

52-34-25

ILLUSTRATED PARTS LIST

01.1 Page 1003

Jul 01/03



Manual Drive Large Cargo Door Components Shaft Assembly  
Figure 1

**52-34-25**

ILLUSTRATED PARTS LIST  
01.1 Page 1004  
Jul 01/03

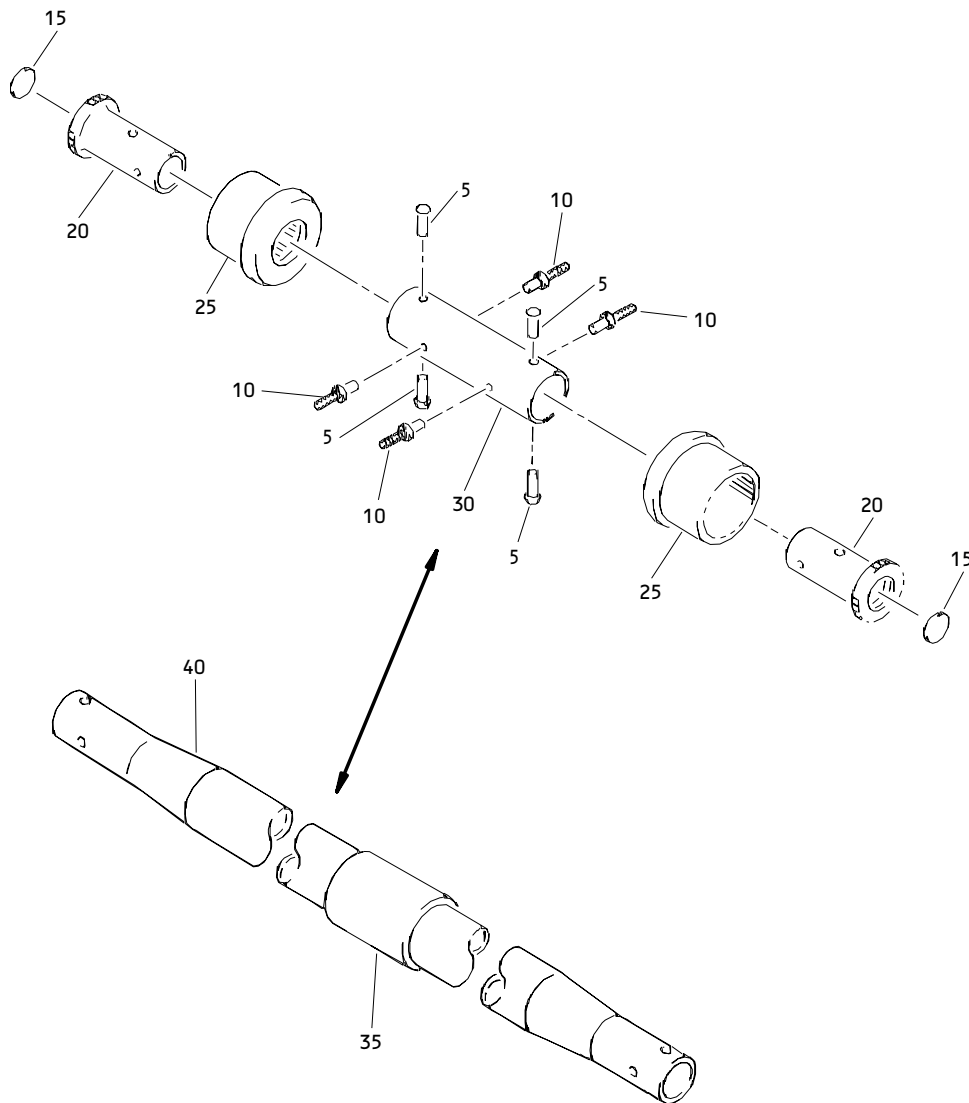
| FIG. & ITEM | PART NO.      | AIRLINE PART NUMBER | NOMENCLATURE<br>1234567  | EFF CODE | QTY PER ASSY |
|-------------|---------------|---------------------|--|----------|--------------|
| 01-         |               |                     | LARGE CARGO DOOR COMPONENTS  |          |              |
| -5          | 258T5004-3    |                     | SHAFT ASSY-MANUAL DRIVE  | A        | RF           |
| -10         | 258T5005-3    |                     | SHAFT ASSY-PWR DRIVE<br>(FOR DETAILS SEE FIG. 2)   | B        | RF           |
| -10A        | 258T5005-5    |                     | SHAFT ASSY-PWR DRIVE<br>(FOR DETAILS SEE FIG. 2)   | C        | RF           |
| -15         | 258T5021-1    |                     | LINK ASSY-PWR UNIT SPRT<br>(FOR DETAILS SEE FIG. 3)  | D        | RF           |
| 20          | HL505-6-7     |                     | .BOLT-<br>(V73197)<br>(SPEC BACB30HA6R7)<br>(OPT HL505-6-7<br>(V92215))  | A        | 2            |
| 25          | BACW10P136AL  |                     | .WASHER-<br>(V10630)<br>(SPEC BACW10P136AL)  | A        | 2            |
| 30          | HL77-6        |                     | .COLLAR-<br>(V56878)<br>(SPEC BACC30P6)<br>(OPT HL77-6<br>(V73197))<br>(OPT HL77-6<br>(V92215))<br>(OPT 66015-6<br>(V56878))                         | A        | 2            |
| 35          | 258T5022-1    |                     | .FITTING-SPRT  | A        | 1            |
| 40          | NAS1738E4-2   |                     | .RIVET   | A        | 3            |
| 45          | 258T5018-2    |                     | .FITTING   | A        | 1            |
| 50          | SA10-18B4     |                     | .BEARING-<br>(V77896)<br>(SPEC BACB10CK10)   | A        | 1            |
| 55          | BACR15BB4AD13 |                     | .RIVET-<br>(V09192)<br>(SPEC BACR15BB4AD13)<br>(OPT BACR15BB4AD13<br>(V42838))<br>(OPT BACR15BB4AD13<br>(V53551))<br>(OPT BACR15BB4AD13<br>(V55580)) | A        | 1            |

52-34-25

| FIG.<br>&<br>ITEM | PART NO.     | AIRLINE<br>PART<br>NUMBER | NOMENCLATURE<br>1234567                     | EFF<br>CODE | QTY<br>PER<br>ASSY |
|-------------------|--------------|---------------------------|---|-------------|--------------------|
| 01-<br>60         | BACW10P211AL |                           | .WASHER-<br>(V10630)<br>(SPEC BACW10P211AL) | A           | 2                  |
| 65                | 257T3105-19  |                           | .BUSHING                                    | A           | 1                  |
| 70                | 258T5017-3   |                           | .FITTING                                    | A           | 1                  |
| 75                | 258T5004-2   |                           | .TUBE                                       | A           | 1                  |

**52-34-25**

ILLUSTRATED PARTS LIST  
 01.1 Page 1006  
 Jul 01/03



Large Cargo Door Power Drive Shaft Assembly  
 Figure 2

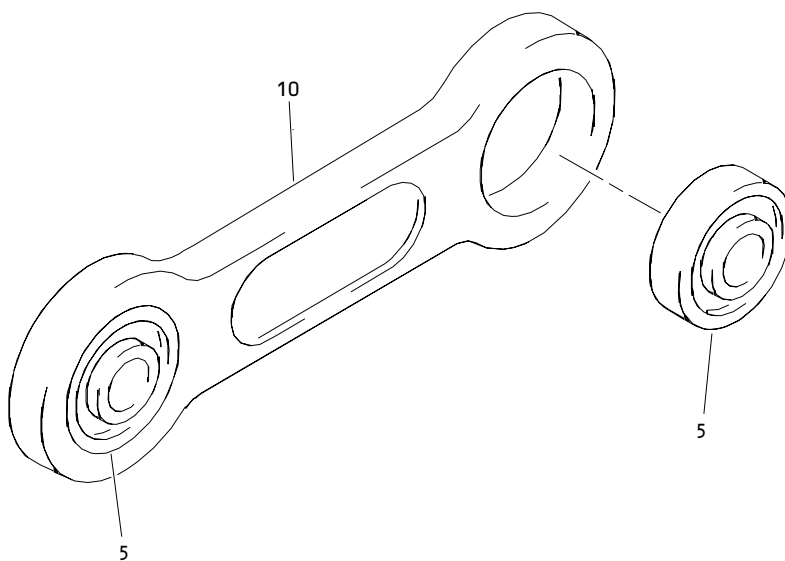
**52-34-25**

ILLUSTRATED PARTS LIST  
 01.1 Page 1008  
 Jul 01/03



| FIG. & ITEM | PART NO.     | AIRLINE PART NUMBER | NOMENCLATURE<br>1234567                  | EFF CODE | QTY PER ASSY |
|-------------|--------------|---------------------|--|----------|--------------|
| 02-<br>-1   | 258T5005-3   |                     | SHAFT ASSY-LARGE CARGO<br>DOOR PWR DRIVE | A        | RF           |
| -1A         | 258T5005-5   |                     | SHAFT ASSY-LARGE CARGO<br>DOOR PWR DRIVE | B        | RF           |
| 5           | BACR15BB5AD  |                     | .RIVET                                   |          | 4            |
| 10          | MS90354-0502 |                     | .RIVET                                   |          | 4            |
| 15          | HP750A32     |                     | .PLUG-<br>(V73287)                       |          | 2            |
| 20          | 256T2806-1   |                     | .FITTING                                 |          | 2            |
| 25          | 256T2801-1   |                     | .COUPLING                                |          | 2            |
| 30          | 258T5005-4   |                     | .TUBE                                    | A        | 1            |
| 35          | 258T5005-6   |                     | .TUBE-HEAT SHRINK                        | B        | 1            |
| 40          | 258T5005-2   |                     | .TUBE                                    | B        | 1            |

52-34-25



Large Cargo Door Power Unit Support Link Assembly  
Figure 3

**52-34-25**

ILLUSTRATED PARTS LIST  
01.1 Page 1010  
Jul 01/03

| FIG. & ITEM | PART NO.   | AIRLINE PART NUMBER | NOMENCLATURE<br>1234567                     | EFF CODE | QTY PER ASSY |
|-------------|------------|---------------------|---|----------|--------------|
| 03-<br>-1   | 258T5021-1 |                     | LINK ASSY-LARGE CARGO<br>DOOR PWR UNIT SPRT |          | RF           |
| 5           | ADB4V313   |                     | .BEARING-<br>(V83086)<br>(OPT ITEM 5A)      |          | 2            |
| -5A         | HTC4V      |                     | .BEARING-<br>(V50294)<br>(OPT ITEM 5)       |          | 2            |
| 10          | 258T5021-2 |                     | .LINK                                       |          | 1            |

**52-34-25**

ILLUSTRATED PARTS LIST  
01.1 Page 1011  
Jul 01/03