

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

TO: ALL HOLDERS OF BULK CARGO DOOR ASSEMBLY COMPONENT MAINTENANCE MANUAL
52-36-03

REVISION NO. 3 DATED JUL 01/99

HIGHLIGHTS

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

CHAPTER/SECTION

AND PAGE NO.

DESCRIPTION OF CHANGE

TITLE PAGE

Added door assembly P/N 146T6301-4 per the latest engineering.

1

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REPAIR 9-1

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703

1017-1018

REPAIR-GEN

Updated the True Position Dimensioning Symbols.

603

REPAIR 6-1

Added the reference to the IPL figure.

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701,706

1002-1003,1005-1012,

1019-1034,1037-1042,

1044-1046,1048-1050

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Edited without technical change.

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BULK CARGO DOOR ASSEMBLY

PART NUMBERS 146T6301-1,-3,-4

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

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REVISION RECORD

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

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR B10307	OCT 10/81

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TR & SB RECORD

01

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

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INTRODUCTION

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

This manual is divided into separate sections:

- | | |
|--|------------------------------|
| 1. Title Page | 4. List of Effective Pages |
| 2. Record of Revisions | 5. Table of Contents |
| 3. Temporary Revision &
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, 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.

Verification: Mar 21/86

Assembly

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INTRODUCTION

01.1

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BULK CARGO DOOR ASSEMBLY

DESCRIPTION AND OPERATION

1. Description

A. The bulk cargo door assembly consists of a conventional frame and stringer construction with aluminum skin and a spring-actuated latching mechanism. Access panels for reaching the mechanism are built into the door. The assembly includes roller-top guides, cable fitting and snubber support assembly, and various stop fittings.

2. Operation

A. Counterclockwise rotation of the outer handle or clockwise rotation of the inner handle unlatches the door mechanism. When either handle is released, spring action returns it to the latched position. A spring loaded cable attached to the door counterbalances the door weight to ease opening and closing.

3. Leading Particulars (Approximate)

Length -- 80 inches
Width -- 40 inches
Height -- 12 inches
Weight -- 120 pounds

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DESCRIPTION & OPERATION

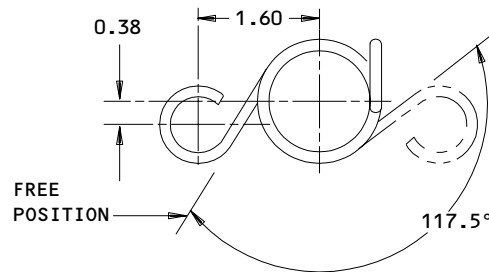
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CHECK

1. Check all parts for obvious defects in accordance with standard industry practices.
2. Magnetic particle check per 20-20-01 -- Cam-latch cranks (45 thru 45D, 50 thru 50D, IPL Fig. 2), torque tube (175, IPL Fig. 2), spring (130, IPL Fig. 2), pin (715, IPL Fig. 1).
3. Penetrant check per 20-20-02 -- Actuator crank (170, IPL Fig. 2), bearing supports (5, 30, IPL Fig. 1), forward and aft hinge fittings (420, 420A, 425, 425A, IPL Fig. 1) roller fitting (320, IPL Fig. 1), cable fitting (350, IPL Fig. 1), stop fittings (570B, 570C, 650B, 650C, IPL Fig. 1), seal retainers (520, 605, IPL Fig. 1; 5, 10, IPL Fig. 3; 5, 10, IPL Fig. 4; 5, IPL Fig. 5).
4. Check spring (130, IPL Fig. 2) (Fig. 501).
 - A. Deflect spring from free position to 25.5°–29.5° and check that load is 6.8–8.4 pounds.
 - B. Deflect spring from free position to 115.5°–119.5° and check that load is 28.6–35.0 pounds.



ALL DIMENSIONS ARE IN INCHES

SPRING (130, IPL FIG. 2)
 Spring Check
 Figure 501

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>
146T6351	ACTUATOR CRANK ASSY	1-1
146T6308	FORWARD HINGE FITTING ASSY	2-1
146T6309	AFT HINGE FITTING ASSY	3-1
146T6337	SNUBBER SUPPORT ASSY	4-1
146T6332	ROLLER ASSY	5-1
146T6338	CABLE FITTING ASSY	6-1
140T2614	UPPER PANEL ASSY	7-1
146T6312	STOP FITTING ASSY	8-1
146T6314	STOP FITTING ASSY	9-1
- -	MISCELLANEOUS PARTS	10-1

2. Standard Practices

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

20-10-01	Repair and Refinish of High-Strength Steel Parts
20-30-02	Stripping of Protective Finishes
20-30-03	General Cleaning Procedures
20-41-01	Decoding Table for Boeing Finish Codes
20-42-05	Cadmium Plating
20-43-01	Chromic Acid Anodizing
20-50-03	Bearing Installation and Retention
20-50-05	Application of Aluminum Foil and Other Markers
20-50-08	Application of Dry Lubricant
20-50-12	Application of Adhesives

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3. Materials

NOTE: Equivalent substitutes may be used.

- A. Adhesive -- Type 60 (Ref 20-50-12)
- B. Alodine 1200
- C. Enamel -- BMS 10-11, tyep 2, BAC702 white gloss (ref 20-60-02)
- D. Enamel -- BMS 10-60, BAC440 gloss (Ref 20-60-02)
- E. Lubricant, dry film -- MIL-L-8937 (Ref 20-60-03)
- F. Lubricant, dry film -- Vitrolube 1220 (Ref 20-60-03)
- G. Primer -- BMS 10-11, type 1 (Ref 20-60-02)
- H. Sealant -- BMS 5-95 (Ref 20-60-04)

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- STRAIGHTNESS
- ▭ FLATNESS
- ⊥ PERPENDICULARITY (OR SQUARENESS)
- // PARALLELISM
- ROUNDNESS
- ⊘ CYLINDRICITY
- ⌒ PROFILE OF A LINE
- ⌒ PROFILE OF A SURFACE
- ◎ CONCENTRICITY
- ≡ SYMMETRY
- ∠ ANGULARITY
- ↗ RUNOUT
- ↗ TOTAL RUNOUT
- ⊔ COUNTERBORE OR SPOTFACE
- ∇ COUNTERSINK

- ⊕ THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
- ∅ DIAMETER
- S ∅ SPHERICAL DIAMETER
- R RADIUS
- SR SPHERICAL RADIUS
- () REFERENCE
- BASIC (BSC) OR DIM A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE FROM WHICH PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
- A- DATUM
- Ⓜ MAXIMUM MATERIAL CONDITION (MMC)
- Ⓛ LEAST MATERIAL CONDITION (LMC)
- Ⓢ REGARDLESS OF FEATURE SIZE (RFS)
- Ⓟ PROJECTED TOLERANCE ZONE
- FIM FULL INDICATOR MOVEMENT

EXAMPLES

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

True Position Dimensioning Symbols
Figure 601

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ACTUATOR CRANK ASSEMBLY – REPAIR 1-1

146T6351-1

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

1. Bushing Replacement (155, 160, IPL Fig. 2)

- A. Remove bushings.
- B. Install bushings per 20-50-03 using wet BMS 5-95 sealant.
- C. Fillet seal around flanges of bushings using BMS 5-95 sealant.

2. Refinish

- A. Crank (170) -- Chromic acid anodize. Apply one coat BMS 10-11, type 1 primer (F-18.13) and one coat BMS 10-11, type 2 epoxy enamel, BAC702 white gloss (SRF-14.905-702) all over, except omit primer from boltholes and omit enamel from crank bore and boltholes. Material: Aluminum alloy.

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FORWARD HINGE FITTING ASSEMBLY - REPAIR 2-1

146T6308-1, -4

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

1. Bearing Replacement (415, IPL Fig. 1)

- A. Remove bearing.
- B. Install bearing and roller swage both sides per 20-50-03.

2. Refinish

- A. Hinge fitting (420, 420A) -- Chromic acid anodize and apply one coat BMS 10-11, type 1 primer (F-18.13) all over, except omit primer from bearing hole. Material: Aluminum alloy.

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AFT HINGE FITTING ASSEMBLY - REPAIR 3-1

146T6309-1, -4

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

1. Bearing Replacement (415, IPL Fig. 1)

- A. Remove bearing.
- B. Install bearing and roller swage both sides per 20-50-03.

2. Refinish

- A. Hinge fitting (425, 425A) -- Chromic acid anodize and apply one coat BMS 10-11, type 1 primer (F-18.13) all over, except omit primer from bearing hole. Material: Aluminum alloy.

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SNUBBER SUPPORT ASSEMBLY - REPAIR 4-1

146T6337-1

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

1. Bushing Replacement (450, 455, IPL Fig. 1)

- A. Remove bushings.
- B. Install bushings per 20-50-03 using wet BMS 5-95 sealant.
- C. Fillet seal around flanges of bushings using BMS 5-95 sealant.

2. Refinish

- A. Snubber support (460) -- Chemically treat and apply one coat BMS 10-11, type 1 primer (F-18.06) and one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over, except omit primer and enamel from bushed holes. Material: Aluminum alloy.

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ROLLER ASSEMBLY - REPAIR 5-1

146T6332-1

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

1. Bushing Replacement (300, 310, IPL Fig. 1)

- A. Remove bushings.
- B. Install bushings per 20-50-03 using wet BMS 5-95 sealant.

2. Refinish

- A. Roller fitting (320) -- Chromic acid anodize. Apply one coat BMS 10-11, type 1 primer (F-18.13) and one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over, except omit primer and enamel from bushed holes. Material: Aluminum alloy.

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CABLE FITTING ASSEMBLY – REPAIR 6-1

146T6338-1

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

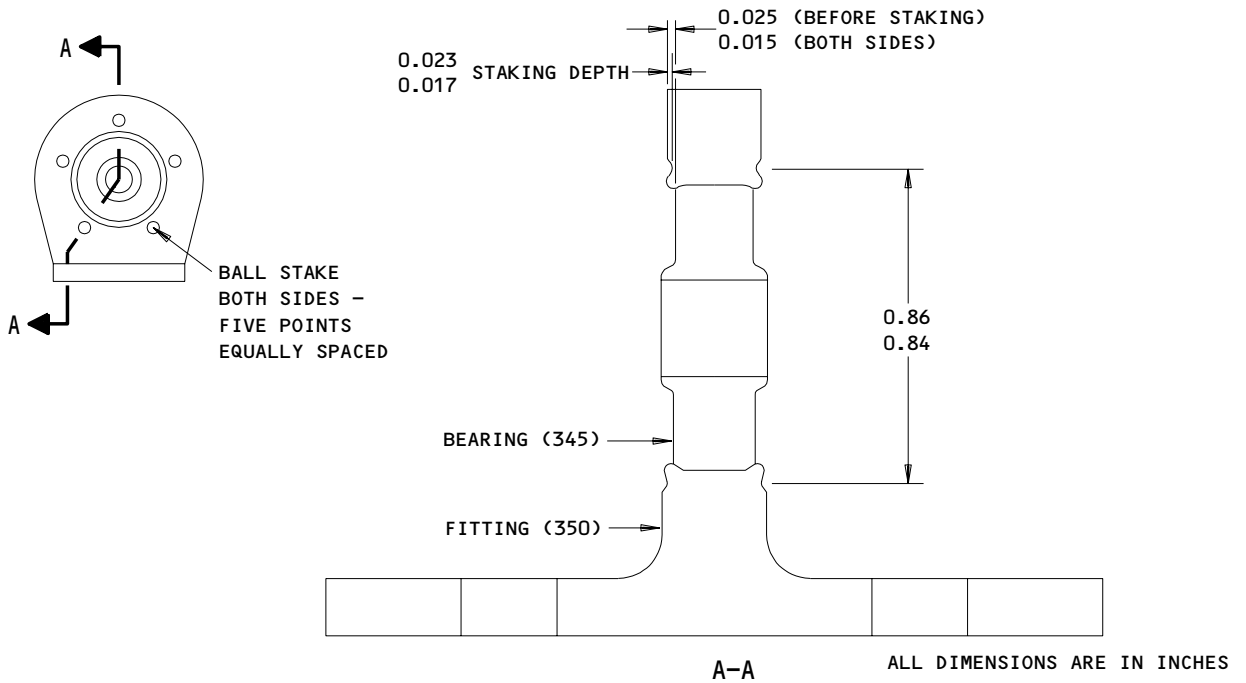
1. Bearing Replacement (345, IPL Fig. 1)

A. Remove bearing.

B. Install bearing (345) and ball stake both sides per 20-50-03 (Fig. 601). Bearing bore and staking must be concentric within 0.010 inch.

2. Refinish

A. Cable fitting (350) -- Chromic acid anodize. Apply one coat BMS 10-11, type 1 primer (F-18.13) and one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over, except omit primer and enamel from bearing hole. Material: Aluminum alloy.



146T6338-1
 Bearing Replacement
 Figure 601

UPPER PANEL ASSEMBLY – REPAIR 7-1

140T2614-15

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

1. Gasket Replacement (492A, IPL Fig. 1)

- A. Remove gasket.
- B. Clean upper panel (495) and attach gasket (492A) per 20-50-12, using adhesive type 60.

2. Refinish

- A. Upper skin (497) -- Interior surface: chemically treat. Apply one coat BMS 10-11, type 1 primer (F-18.06) and one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over. Material: Aluminum alloy.
- B. Upper panel (495) -- Chemically treat and apply one coat BMS 10-11, type 1 primer (F-18.06) and one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over. Material: Aluminum alloy.

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STOP FITTING ASSEMBLY – REPAIR 8-1

146T6312-6, -8

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

1. Bushing Replacement (645, IPL Fig. 1; 60, IPL Fig. 4)

- A. Remove bushing.
- B. Install bushing per 20-50-03. Swage bushing into countersink. Face of bushing should fit snugly against face of fitting.

2. Refinish

- A. Fitting (650B, IPL Fig. 1; 65, IPL Fig. 4) -- Chromic acid anodize and apply one coat BMS 10-11, type 1 primer (F-18.13) plus one coat BMS 10-11, type 2 epoxy enamel, BAC702 gloss white (SRF-14.905-702) all over, except omit primer and enamel from bushed hole. Material: Aluminum alloy.

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STOP FITTING ASSEMBLY - REPAIR 9-1

146T6314-6, -8

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

1. Bushing Replacement (565, IPL Fig. 1; 60, IPL Fig. 3)

- A. Remove bushing.
- B. Install bushing per 20-50-03. Swage bushing into countersink. Face of bushing should fit snugly against face of fitting.

2. Refinish

- A. Fitting (570B, IPL Fig. 1; 65, IPL Fig. 3) -- Chromic acid anodize and apply one coat BMS 10-11, type 1 primer (F-18.13) plus one coat BMS 10-11, type 2 epoxy enamel, BAC702 white gloss (SRF-14.905-702) all over, except omit primer and enamel from bushed hole. Material: Aluminum alloy.

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MISCELLANEOUS PARTS - REPAIR 10-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 1</u> Door structure assy (1)		Touch up of unpainted areas. 1. Clean and apply Alodine 1200 to any bare aluminum surfaces. Fastener heads need not be alodined. 2. Reactivate area to be touched up. 3. Touch up fastener heads, damaged paint and bared areas using BMS 10-11, type 1 yellow primer and BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.16).
Bearing support (5)	Al alloy	Chromic acid anodize, and apply one coat BMS 10-11, type 1 primer (F-18.13) all over, except omit primer from bearing bore.
Bearing support (30)	Al alloy	Chromic acid anodize. Apply one coat BMS 10-11, type 1 primer (F-18.13) and one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over, except omit primer and enamel from bearing bore.
Filler (267)	Al alloy	Chemically treat and apply one coat BMS 10-11, type 1 primer (F-18.06) all over.
Panel (55)	Al alloy	Chemically treat and apply one coat BMS 10-11, type 1 primer (F-18.06) and one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over.

Refinish Details
 Figure 601 (Sheet 1)

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IPL FIG. & ITEM	MATERIAL	FINISH
<p><u>Fig. 1</u></p> <p>Doubler (500) Seal retainers (515,520,530,580, 605,610,620,660)</p> <p>Stop fittings (680,685)</p> <p>Structure assembly (260)</p> <p>Pin (715)</p>	<p>Al alloy</p> <p>Al alloy</p> <p>15-5PH CRES or 17-4 PH CRES 180-200 ksi</p>	<p>Chromic acid anodize. Apply one coat BMS 10-11, type 1 primer (F-18.13) and one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over.</p> <p>Chromic acid anodize. Apply one coat BMS 10-11, type 1 primer (F-18.13) all over.</p> <p>Touch up unpainted areas; clean and apply Alodine to any bared aluminum surfaces. Touch up fastener heads, damaged paint, and bared areas using BMS 10-11, type 1 primer and BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.12). Enamel coating is to be 0.005-0.010 inch thick. (Coating thickness requirements only apply to surfaces covered by normal spray techniques (F-21.15)).</p> <p><u>NOTE:</u> Apply paint only to areas previously painted white. All other areas are not to be painted and must be protected by masking, removal, etc.</p> <p>Passivate (F-17.09). Apply Vitro-lube 1220 to head of pin per Fig. 604. Apply one coat BMS 10-11, type 1 primer (F-20.02) plus apply BMS 10-60, BAC440 gloss enamel primer (F-20.02) plus apply BMS 10-60, BAC440 gloss enamel</p>

Refinish Details
Figure 601 (Sheet 2)

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REPAIR 10-1

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 MAINTENANCE MANUAL

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 2</u>		
Latch crank cam (45A,50A)	15-5PH CRES 180-200 ksi	Passivate (F-17.09). Cadmium plate (0.0002-0.0004 inch) (F-15.02) all over to dimensions shown (Fig. 605), except omit plate from 0.19 and 0.50 inch diameter holes.
	OPTIONAL: 17-4PH CRES 180-200 ksi	Cadmium plate (0.0002-0.0004 inch) (F-15.02) all over to dimensions shown (Fig. 605), except omit plate from 0.19 and 0.50 inch diameter holes.
Spacer (55)	304 Steel	Passivate (F-17.09). Cadmium plate (0.0002-0.0004 inch) (F-15.02).
Spring (130)	17-7PH CRES CH900	Passivate (F-17.09).
Torque tube (75)	15-5PH CRES	Passivate (F-17.09). Cadmium plate per 20-42-05, type 2, class 2, and apply one coat BMS 10-11, type 1 primer (F-16.01) per Fig. 602. Apply dry film lubricant MIL-L-8937 per Fig. 602.
Target (25)	15-5 PH CRES	Cadmium plate per 20-42-05, type 2, class 2, and apply one coat BMS 10-11, type 1 primer (F-16.01) all over.
Latch crank cam (45,45B,45C,45D, 50,50B,50C,50D)	17-4PH CRES 180-200 ksi	Cadmium plate (0.0002-0.0004 inch) (F-15.02) all over to dimensions shown (Fig. 605), except omit plate from 0.19 and 0.50 inch diameter holes.

Refinish Details
 Figure 601 (Sheet 3)

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IPL FIG. & ITEM	MATERIAL	FINISH
<p><u>Fig. 2</u></p> <p>Rod assembly (60)</p>	<p>OPTIONAL: 15-5PH CRES 180-200 ksi</p>	<p>Passivate (F-17.09). Cadmium plate (0.0002-0.0004 inch) (F-15.02) all over to dimensions shown (Fig. 605), except omit plate from 0.19 and 0.50 inch diameter holes.</p> <p>Apply one coat BMS 10-11, type 1 primer (F-20.02) plus one coat BMS 10-11, type 2 epoxy enamel, BAC702 white gloss (SRF-14.905-702) all over exterior surface, except omit finish from rod ends (Fig. 603).</p>
<p><u>Fig. 3</u></p> <p>Seal retainer (5, 10, 20)</p>	<p>Al alloy</p>	<p>Chromic acid anodize. Apply one coat BMS 10-11, type 1 primer (F-18.13) and one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over.</p>
<p><u>Fig. 4</u></p> <p>Seal retainer (5, 10, 20)</p>	<p>Al alloy</p>	<p>Chromic acid anodize. Apply one coat BMS 10-11, type 1 primer (F-18.13) and one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over.</p>
<p><u>Fig. 5</u></p> <p>Seal retainer (5)</p>	<p>Al alloy</p>	<p>Chromic acid anodize. Apply one coat BMS 10-11, type 1 primer (F-18.13) and one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over.</p>

Refinish Details
Figure 601 (Sheet 4)

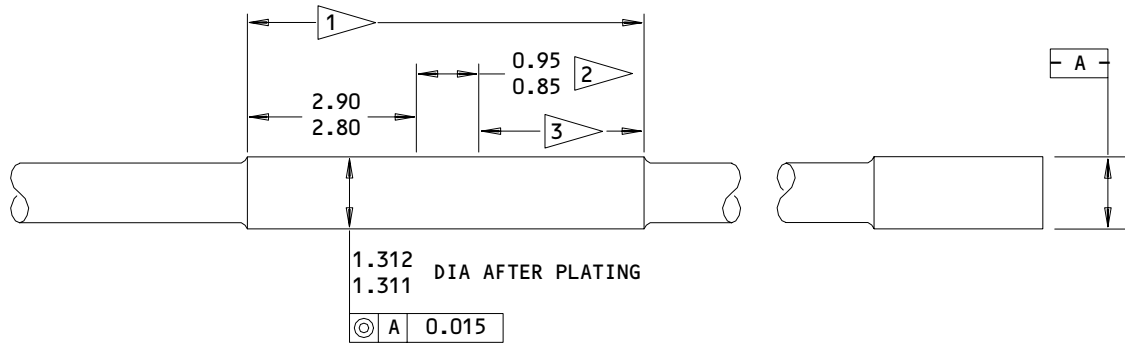
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REPAIR 10-1

01.1

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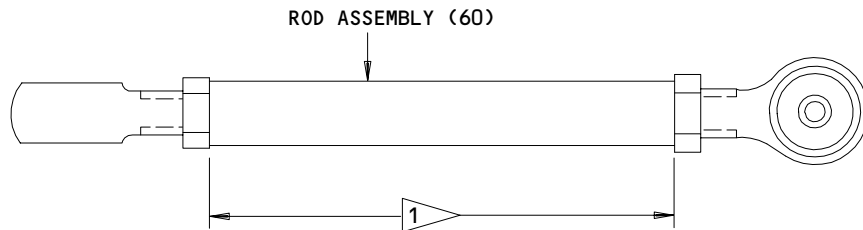


- 1 CADMIUM PLATE AND APPLY PRIMER THIS AREA
- 2 OMIT PRIMER THIS AREA
- 3 OMIT PRIMER AND APPLY DRY FILM LUBRICANT THIS AREA

ALL DIMENSIONS ARE IN INCHES

146T6352-1
 Torque Tube Refinish
 Figure 602

80



- 1 APPLY PRIMER AND ENAMEL TO THIS SURFACE ONLY

146T6304-2
 Rod Assembly Refinish
 Figure 603

19740

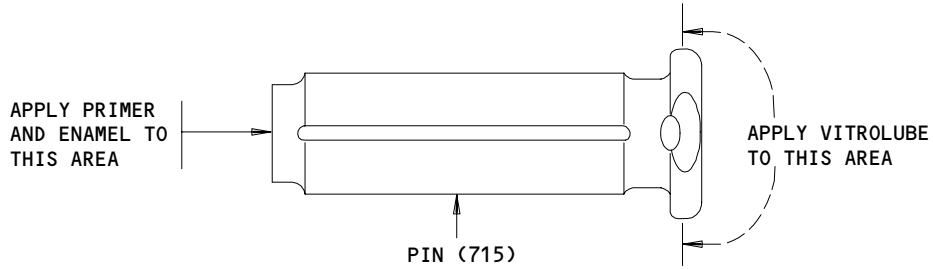
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REPAIR 10-1

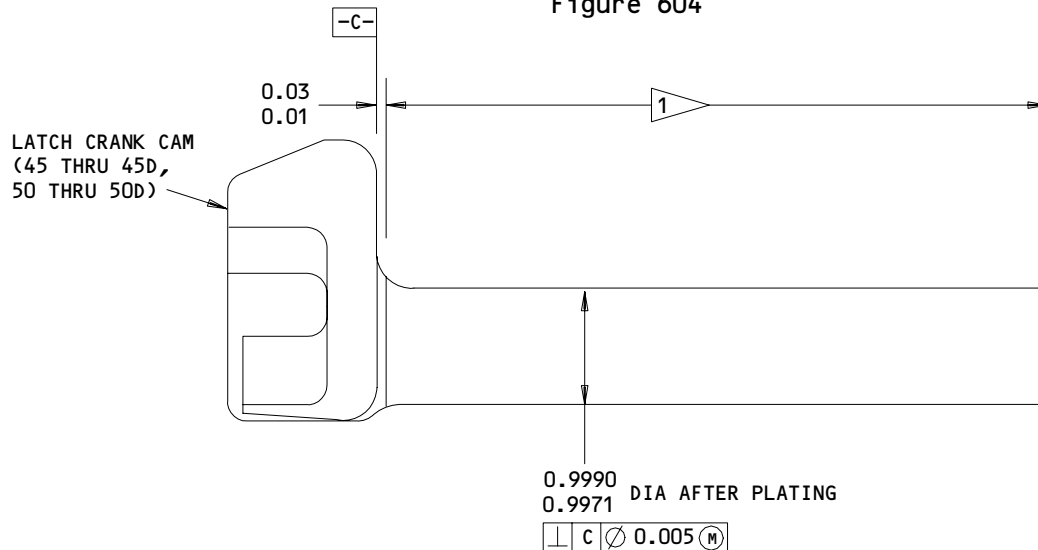
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69B17927-1
 Pin Refinish
 Figure 604



1 63AA MACHINE FINISH THIS SURFACE BEFORE PLATING

ALL DIMENSIONS ARE IN INCHES

146T6350-7 THRU -10,-11,-12,-15,-16
 Latch Crank Cam Refinish
 Figure 605

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REPAIR 10-1

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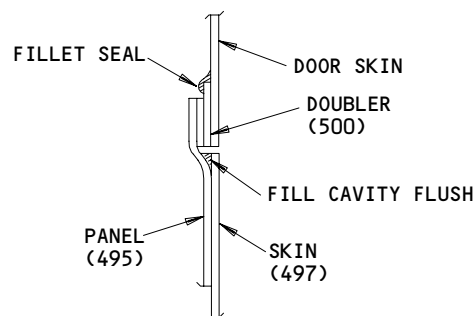
ASSEMBLY1. Materials

NOTE: Equivalent substitutes may be used.

- A. Compound, leveling -- BMS 5-125, type 1 (Ref 20-60-04)
- B. Lubricant -- Liquid soap (Ref 20-50-07)
- C. Sealant -- BMS 5-32, Class B (Ref 20-60-04)
 - BMS 5-79, Class B (Ref 20-60-04)
 - BMS 5-95, Class C (Ref 20-60-04)

2. Assembly (IPL Fig. 1 unless specified differently)

- A. Use standard industry practices for assembly of this unit, with additional procedures in the following steps.
- B. When installing latch assembly (5, IPL Fig. 2), apply faying surface seal BMS 5-95, class C, between latch assembly and doubler. Remove sealant extrusion from gap between latch assembly and door skin.
- C. When installing access panels (465), apply faying surface seal BMS 5-95, class C, between door skin and doubler (500). Tighten bolts (480) to 25-42 pound-inches. Fill cavity (Fig. 701) flush with edge of panel using BMS 5-79, class B sealant. Fillet seal around doubler (500) using BMS 5-79, class B sealant.
- D. Install all exterior non-aluminum fasteners using BMS 5-95 sealant.



Access Panel Sealing
 Figure 701

E. Mechanism installation (100).

CAUTION: TORQUE TUBE (175, IPL Fig. 2) HAS DRY FILM LUBRICATED BEARING SURFACE WHICH MUST BE KEPT CLEAN AND PROTECTED FROM MECHANICAL DAMAGE DURING INSTALLATION.

- (1) Install bearing (25) in bearing support (5) per 20-50-03.
- (2) Install bearing (50) in bearing support (30) per 20-50-03.
- (3) Use special precaution when installing inner handle (5, IPL Fig. 2) to protect O-ring seal. Always install O-ring before installing inner handle.

CAUTION: WHEN TIGHTENING NUTS (40, 125, 150, IPL Fig. 2), APPLY ONLY MINIMUM POWER NECESSARY TO LOCK. MAXIMUM PERMISSIBLE OVALIZATION OF TUBULAR WALL IS 0.01 INCH.

- (4) End play between spacer (55, IPL Fig. 2) and bearing support (30, IPL Fig. 1) is not to exceed 0.015 inch.

F. Centerline of roller guide assembly (270) is to align with backup structure within 0.05 inch.

G. Application of seal (265).

NOTE: Seals may be installed with liquid soap lubricant per 20-50-07.

CAUTION: LOCATION INDICATORS ON CORNER SEAL RETAINERS MUST MATCH LOCATION INDICATORS ON SEAL WITHIN 0.50 INCH AT ALL CORNERS. INDICATORS TO BE 0.20 ±0.05 INCH SQUARE.

- (1) Lay seal on door with flap of seal facing in outboard direction and with top and bottom of seal, as marked, at the correct location on door.
- (2) Move seal into its approximate location over seal retainer, equalizing stretch throughout the entire seal and maintaining seal corner markings at the centerline of each corner.
- (3) Install each corner for a span of 1-to-2 inches. First install the inboard edge, then, using a smooth rounded edge tool, force the outboard edge of the seal into the retainer, pushing the seal in a direction square to the seal edge, to avoid excessive bunching.

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ASSEMBLY
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- (4) Install the seal for 2-to-3 inches at the centerline of the top, bottom, and both sides of the door by the same methods. Work out from the centerline of each side to the corners. If necessary, remove the corners and refit to remove any misalignment that may occur on the first fitting.

NOTE: The seal is slightly shorter than the retainer because the seal becomes extended in length when installed to ensure uniform elongation of seal around the periphery of the door.

- (5) Indexing targets on the seal and retainer should align ± 0.50 inch.

- (6) Excessive wrinkles in the flap of the seal can be smoothed out by pulling excess material into the corners in the required direction.

H. Apply weather fillet seal BMS 5-79, class B, around seal retainers (515, 520, 530, 580, 605, 610, 620, 660, IPL Fig. 1; 5, 10, 20, IPL Fig. 3; 5, 10, 20, IPL Fig. 4; 5, IPL Fig. 5) per Fig. 702.

I. Apply pressure fillet seal BMS 5-32, class B, around seal retainers (515, 520, 530, 580, 605, 610, 620, 660, IPL Fig. 1; 5, 10, 20, IPL Fig. 3; 5, 10, 20, IPL Fig. 4; 5, IPL Fig. 5) per Fig. 702.

J. Application of leveling compound (Fig. 703).

CAUTION: ALL FILLET SEALING IN AREA TO BE COVERED MUST BE TACK-FREE BEFORE APPLYING LEVELING COMPOUND.

- (1) Clean area thoroughly.

CAUTION: DOOR MUST BE PLACED EITHER IN UPRIGHT POSITION (BEAMS HORIZONTAL) OR TILTED SLIGHTLY FORWARD (SEE FIG. 703). ASSEMBLY MUST NOT BE MOVED DURING WORK LIFE OF COMPOUND.

- (2) Pour leveling compound BMS 5-125, type 1, into lowest pocket formed by structure in location indicated (Fig. 703).

K. Locate plate (710A) per Fig. 704.

L. Screw pins (715) completely into stop fitting assemblies (550C thru 550E, 640C thru 640E, IPL Fig. 1; 40, IPL Fig. 3 & 4).

NOTE: Pin spring locks will be installed upon door installation in airplane

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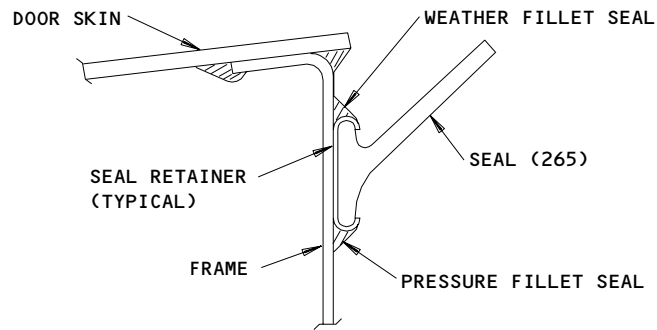
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3. Storage

- A. Prepare and store component in accordance with standard industry practices, with additional procedure as follows.
- B. Retain bushing (165, IPL Fig. 2) in place in crank assembly (135, IPL Fig. 2) for shipment or storage using masking tape. (String or stainless steel wire is optional.)

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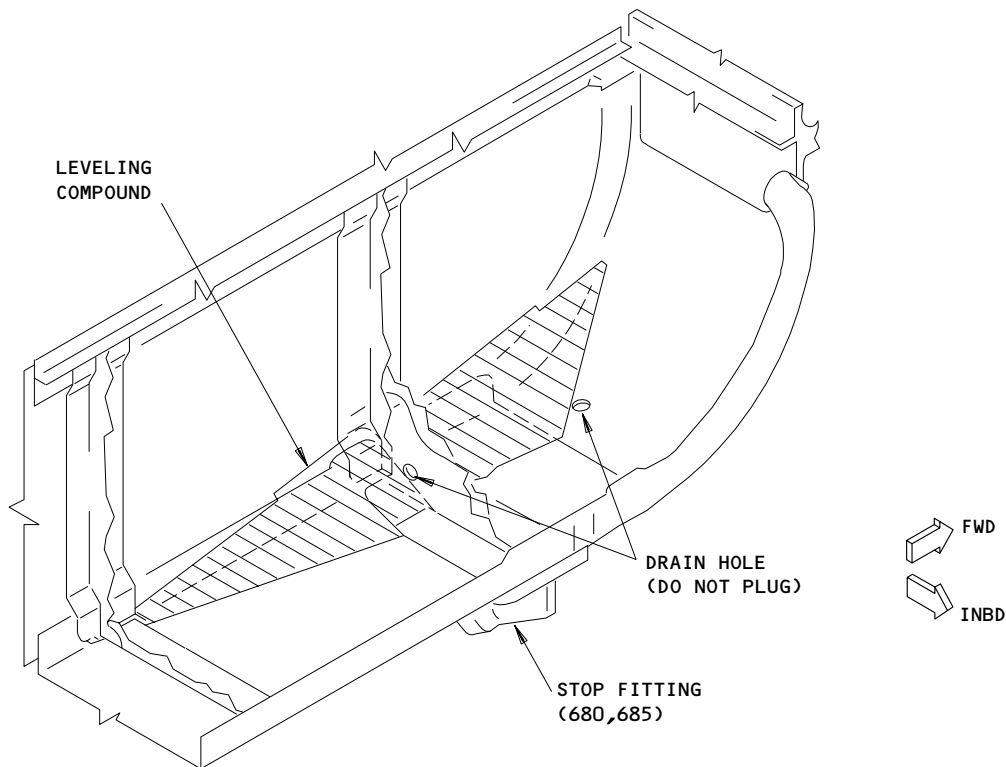


Retainer Fillet Seal
Figure 702

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ASSEMBLY
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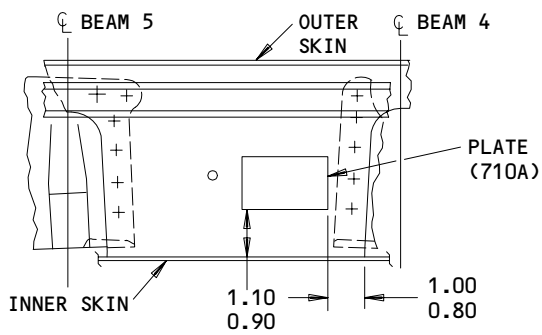


Leveling Compound Application
Figure 703

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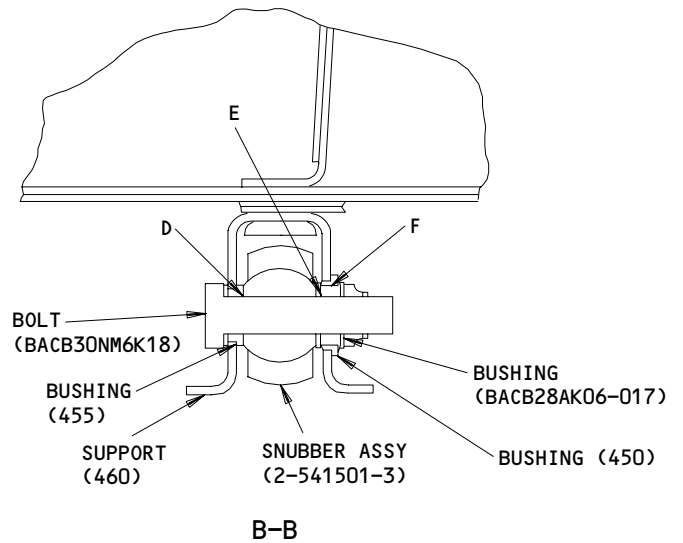
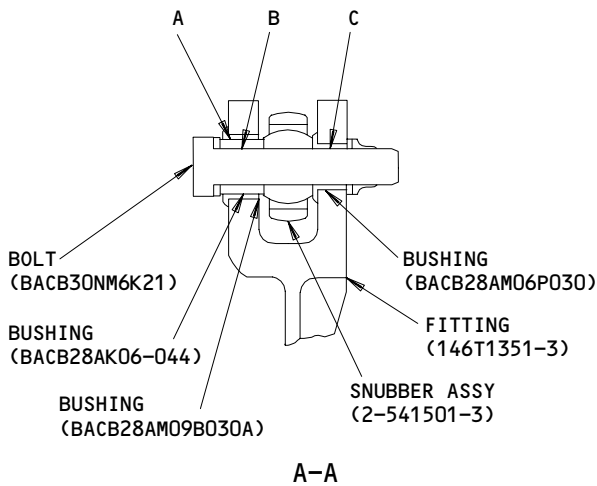
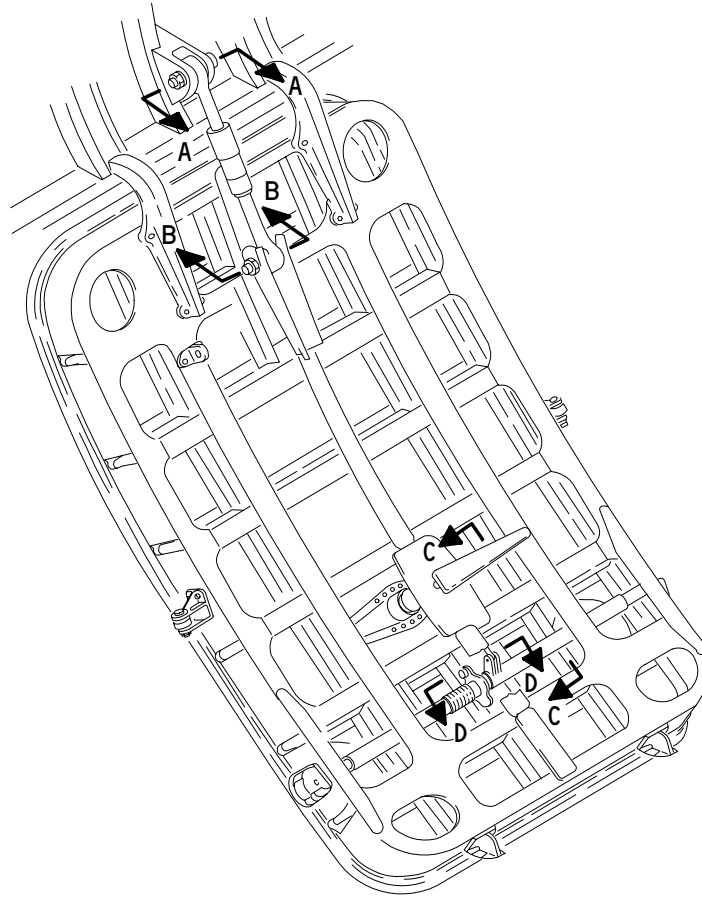
Marker Location
Figure 704

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ASSEMBLY
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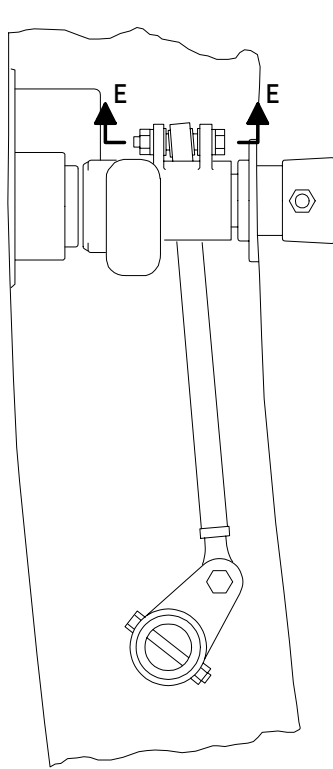
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FITS AND CLEARANCES

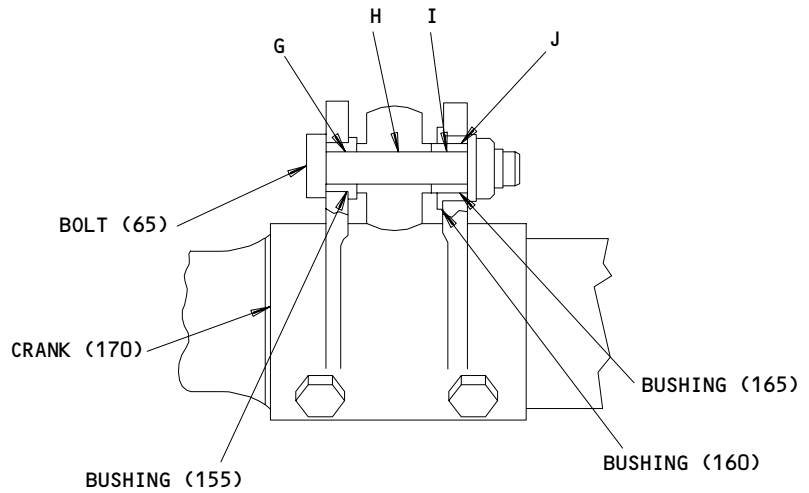


Fits and Clearances
 Figure 801 (Sheet 1)

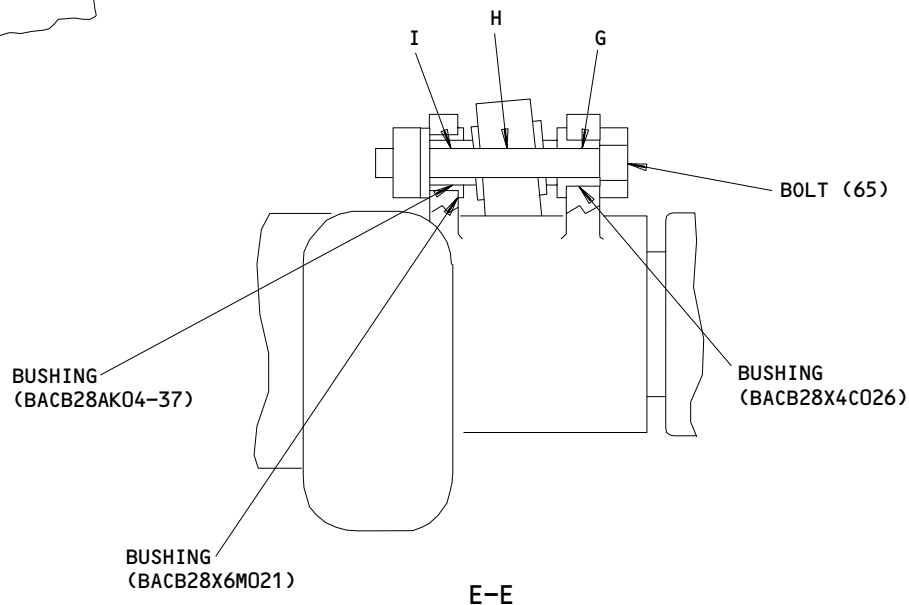
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C-C



D-D



E-E

Fits and Clearances
 Figure 801 (Sheet 2)

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BOEING
 COMPONENT
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Ref Letter Fig.801	Mating Item No.	IPL Fig. No.	Design Dimension				Service Wear Limit		
			Dimension		Assembly Clearance		Dimension Limits		Maximum Allowable Clearance
			Min	Max	Min	Max	Min	Max	
A	ID *[1]	1	0.5620	0.5627	0.0005	0.0017	0.5577	0.5665	0.005
	OD *[2]	1	0.5610	0.5615					
B	ID *[2]	1	0.3750	0.3755	0.0005	0.002	0.3705	0.3795	0.005
	OD *[3]	1	0.3735	0.3745					
C	ID *[4]	1	0.3750	0.3756	0.0005	0.0021	0.3706	0.3795	0.005
	OD *[3]	1	0.3735	0.3745					
D	ID 455	1	0.3750	0.3765	0.0005	0.003	0.3715	0.3795	0.005
	OD *[5]	1	0.3735	0.3745					
E	ID *[6]	1	0.3750	0.3755	0.0005	0.002	0.3705	0.3795	0.005
	OD *[5]	1	0.3735	0.3745					
F	ID 450	1	0.5625	0.5640	0.001	0.003	0.5590	0.5665	0.005
	OD *[6]	1	0.5610	0.5615					
G	ID 155 *[7]	2	0.2500	0.2515	0.0005	0.003	0.2465	0.2545	0.005
	OD 65	2	0.2485	0.2495					
H	ID 60	2	0.2497	0.2500	0.0002	0.0015	0.2450	0.2545	0.005
	OD 65	2	0.2485	0.2495					
I	ID 165 *[8]	2	0.2500	0.2505	0.0005	0.002	0.2455	0.2545	0.005
	OD 65	2	0.2485	0.2495					
J	ID 160	2	0.3750	0.3765	0.0005	0.0025	0.3715	0.3795	0.005
	OD 165	2	0.3740	0.3745					

*[1] BUSHING (BACB28AM09B030A)

*[2] BUSHING (BACB28AK06-044)

*[3] BOLT (BACB30NM6K21)

*[4] BUSHING (BACB28AM06P030)

*[5] BOLT (BACB30NM6K18)

*[6] BUSHING (BACB28AK06-017)

*[7] BUSHING (BACB28X4C026)

*[8] BUSHING (BACB28AK04-037)

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
 Figure 801 (Sheet 3)

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FITS AND CLEARANCES
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FITS AND CLEARANCES

1. Tighten bolts (480) to 25-42 pound-inches.

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FITS AND CLEARANCES
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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

09455 BFM TRANSPORT DYNAMICS CORP
3131 WEST SEGERSTROM AVENUE PO BOX 1953
SANTA ANA, CALIFORNIA 92702-1953

11815 CHERRY AEROSPACE FASTENERS DIV OF TEXTRON
1224 EAST WARNER AVENUE PO BOX 2157
SANTA ANA, CALIFORNIA 92707-0157

15653 KAYNAR TECHNOLOGY KAYNAR DIV
800 SOUTH STATE COLLEGE BLVD PO BOX 3001
FULLERTON, CALIFORNIA 92634-3001

15860 NEW HAMPSHIRE BALL BEARINGS, INCORPORATED ASTRO DIVISION
155 LEXINGTON AVENUE
LACONIA, NEW HAMPSHIRE 03246-2937

21335 TORRINGTON CO FAFNIR BEARING DIV
59 FIELD STREET
TORRINGTON, CONNECTICUT 06790-4942

30163 VALENTEC DAYRON INC
333 MAGUIRE BLVD PO BOX 140394
ORLANDO, FLORIDA 32814-0394

38443 MRC BEARINGS
402 CHANDLER STREET
JAMESTOWN, NEW YORK 14701-3802

40920 MPB MINIATURE PRECISION BEARING DIV
PRECISION PARK PO BOX 547
KEENE, NEW HAMPSHIRE 03431

43991 FAG BEARING INCORPORATED
118 HAMILTON AVENUE
STAMFORD, CONNECTICUT 06904

5M902 FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV
3016 W LOMITA BLVD
TORRANCE, CALIFORNIA 90505-5103

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VENDORS

50294 NEW HAMPSHIRE BALL BEARINGS INC
9730 INDEPENDENCE AVENUE PO BOX 2515
CHATSWORTH, CALIFORNIA 91311-4323

50632 KAMATICS CORP SUB OF KAMAN CORP
1335 BLUE HILLS ROAD
BLOOMFIELD, CONNECTICUT 06002-1304

50744 BURKE RUBBER CO SFS DIVISION
13767 FREEWAY DRIVE
SANTA FE SPRINGS, CALIFORNIA 90670-5504

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

56878 SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV
HIGHLAND AVENUE
JENKINTOWN, PENNSYLVANIA 19046

60119 MONADNOCK CO THE
18301 ARENTH AVENUE PO BOX 1222
CITY OF INDUSTRY, CALIFORNIA 91749

60380 TORRINGTON CO BEARINGS DIV SUBSIDIARY OF INGERSOLL-RAND CORP
59 FIELD STREET PO BOX 1008
TORRINGTON, CONNECTICUT 06790-4942

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

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

72962 HARVARD INDUSTRIES INC
3 WERNER WAY SUITE 210
LEBANON, NEW JERSEY 08833

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VENDORS

73134 IMO INDUSTRIES INC HEIM BEARINGS DIV
60 ROUND HILL ROAD PO BOX 430
FAIRFIELD, CONNECTICUT 06430

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

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

83014 HARTWELL CORPORATION
900 SOUTH RICHFIELD ROAD
PLACENTIA, CALIFORNIA 92670-6732

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

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

97613 SARGENT CONTROLS & AEROSPACE/KAHR BEARING DIV
5675 W BURLINGAME RD
TUCSON, ARIZONA 85743

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ADB8V301C		1	415	2
AN960C416		2	75	2
AN960C516		2	35	4
AN960C616		1	292	4
AN960JD616L		1	293	2
AN960PD10		1	65	8
		2	145	2
AN960PD10L		2	15	2
AN960PD416		1	15	4
		1	40	8
		1	335	2
		1	380	8
		2	110	1
AN960PD416L		2	70	2
AN960PD516		1	400	8
AN970-4		2	90	2
		2	115	1
ATF6		1	305	2
BACB10AC4A		1	345	1
BACB10ES08GC		1	415	2
BACB10ET06		1	305	2
BACB10EX16		1	50	2
BACB10EX21		1	25	1
BACB28AK04-020		2	120	1
BACB28AK04-031		2	165	1
BACB28AK04-033		2	95	1
BACB28AK06-026		1	295	2
BACB28X4C017		2	155	1
BACB28X6C008		1	455	1
BACB28X6C028		1	310	2
BACB28X6M014		2	160	1
BACB28X9M008		1	450	1
BACB28X9M011		1	300	2
BACB30LH3-5		1	480	16
BACB30LJ6-21		1	285	2
BACB30LT5-20		2	30	4
BACB30MY5K		1	590	5
		1	670	5
		5	15	5
BACB30MY6K		1	540	13
		1	555	48
		1	630	13
		1	642	48
		3	30	13
		3	45	48

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30MY6K		4	30	13
		4	50	48
BACB30NM3K25		2	140	2
BACB30NM4K13		1	375	4
BACB30NM4K7		1	330	2
BACB30NM5K18		1	395	4
BACB30NR4K10		2	85	1
BACB30NR4K20		2	65	2
BACB30NR4K26		2	105	1
BACB30NR4K4		1	10	4
BACB30NR4K8		1	35	8
BACB30NW5K		1	90	45
BACB30NX6K		1	275	8
		1	440	4
BACB30NX8K		1	690	12
		5	35	12
BACC30AG6		1	545	13
		1	560	48
		1	635	13
		1	643	48
		3	35	13
		3	50	48
		4	35	13
		4	55	48
BACC30M5		1	95	45
		1	595	5
		1	675	5
		5	20	5
BACC30X6		1	280	8
BACC30X6SW		1	445	4
BACC30X8		1	705	12
		5	50	12
BACN10GW4		1	340	2
		1	390	4
BACN10GW5		1	410	4
BACN10JC3		2	20	2
		2	150	2
BACN10JC4		1	20	4
		1	45	8
		2	80	2
		2	100	1
		2	125	1
BACN10JC5		2	40	4
BACN10JC6		1	315	2
BACN10JN3		1	70	8
BACN10JP3A		1	266J	59
BACN10JP3B		1	266Q	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACN10JZ3A2		1	485	16
BACR15BA3AD		1	266C	122
		1	490	32
BACR15BA3KE		1	75	16
BACR15BB4AD		1	525A	10
		1	535A	5
		1	615A	10
		1	625A	5
		1	665A	8
		3	15	10
		3	25	5
		4	15	10
		4	25	5
		5	10	8
BACR15CE6KE		1	562	12
		1	641	12
		3	55	12
		4	45	12
BACR15FT4KE		1	585	6
BACR15FT6KE		1	435	7
BACR15FV6KE		1	498	24
		1	505	16
BACS40R10E26F		1	385	2
		1	405	2
BACW10CA104CC		1	700	12
		5	45	12
BACW10CA104CV		1	695	12
		5	40	12
BACW10P254C		1	290	6
BRFM20A3		1	70	8
BRH10A3		2	20	2
		2	150	2
BRM100A3		1	266Q	2
BRM200A3		1	266J	59
F1968-3BAC		1	485	16
HHKSP4A		1	345	1
HL1187-6		1	280	8
HL1187-8		1	705	12
		5	50	12
HL1187DUW6		1	445	4
HL70-5		1	95	45
		1	595	5
		1	675	5
		5	20	5

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL82-6APBW		1	545	13
		1	560	48
		1	635	13
		1	643	48
		3	35	13
		3	50	48
		4	35	13
		4	55	48
HL87-6		1	280	8
HL87-8		1	705	12
		5	50	12
HL87DUW6		1	445	4
HTES08VC		1	415	2
H10-3BAC		2	20	2
		2	150	2
H2863-3		2	5	1
H93-4		1	340	2
		1	390	4
H93-5		1	410	4
KNDB8-64		1	415	2
KP16BS		1	50	2
KP16BSLY196		1	50	2
KP16BSSD610		1	50	2
KP21BSLY196		1	25	1
KP21BSSD610		1	25	1
KP21BS1		1	25	1
KSC130900B6GC		1	415	2
KSP4A		1	345	1
KSP4AE9440A		1	345	1
KSP4AFS428		1	345	1
KSP4AG27		1	345	1
KSP4A2TS		1	345	1
K29646-104		1	695	12
		5	40	12
K29913-104		1	700	12
		5	45	12
MF1000-3BAC		1	70	8
MK1000-3BAC		1	266J	59
MK2000-3BAC		1	266Q	2
MS27253F2		1	710A	1
NAS1801-3-10		2	10	2
NAS623-3-3		1	60	8
NRRO8ESGC		1	415	2
NS103197-02		1	266J	59

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NS103198-02		1	266Q	2
NS103218-02		1	70	8
NS103224-02		1	485	16
NS202101-02		2	20	2
		2	150	2
RMA9201M3		1	266J	59
RMA9207-3		1	266Q	2
RMF9201M3		1	70	8
RMF9219-3		1	485	16
RMLH18-4		1	340	2
		1	390	4
RMLH18-5		1	410	4
RMLH9075-3W		2	20	2
		2	150	2
SE98A3		1	485	16
SF15-120-6		1	265	1
SL7020S428		1	340	2
		1	390	4
SL7020S524		1	410	4
S140T263-6		1	265	1
T6S1032J		2	20	2
		2	150	2
T8076S1032		1	266J	59
T8077S1032		1	266Q	2
VN201A1-02		1	266Q	2
VN202A1-02		1	266J	59
VN252A02		1	70	8
VN303A02		2	20	2
		2	150	2
VN497A048		1	340	2
		1	390	4
VN497A054		1	410	4
03-825-08E010C		1	415	2
140T2614-13		1	500	2
140T2614-14		1	492A	2
140T2614-15		1	470A	2
140T2614-23		1	465A	1
140T2614-24		1	467	1
140T2614-5		1	497	2
140T2614-7		1	495	2
140T2629-2		1	5	1
146T6301-1		1	1	RF
146T6301-2		1	260C	1
146T6301-3		1	1A	RF
146T6301-4		1	1B	RF
146T6301-5001		1	260A	1
146T6301-5003		1	260	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
146T6304-1		1	80	1
146T6304-2		2	60	1
146T6304-3		1	80A	1
		2	1G	RF
146T6304-5001		1	100A	1
		2	1A	RF
146T6304-5002		1	100	1
		2	1	RF
146T6304-5003		1	100B	1
		2	1B	RF
146T6308-1		1	355	1
146T6308-2		1	420	1
146T6308-4		1	355B	1
146T6308-5		1	420A	1
146T6309-1		1	360	1
146T6309-2		1	425	1
146T6309-4		1	360B	1
146T6309-5		1	425A	1
146T6312-6		1	640C	6
		4	40	6
146T6312-7		1	650B	6
		4	65	6
146T6312-8		1	640E	6
146T6312-9		1	650C	6
146T6313-10		1	685E	1
146T6313-7		1	680C	1
		5	25	1
146T6313-8		1	685C	1
		5	30	1
146T6313-9		1	680E	1
146T6314-6		1	550C	6
		3	40	6
146T6314-7		1	570B	6
		3	65	6
146T6314-8		1	550E	6
146T6314-9		1	570C	6
146T6320-1		1	507	1
146T6320-3		1	530	1
		3	20	1
146T6320-5001		1	510A	1
146T6320-7		1	507A	1
		3	1A	RF

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
146T6321-1		1	597	1
146T6321-3		1	620	1
		4	20	1
146T6321-5001		1	600A	1
146T6321-7		1	597A	1
		4	1A	RF
146T6322-1		1	652	1
146T6322-3		1	660	1
		5	5	1
146T6322-5		1	652A	1
		5	1A	RF
146T6322-5001		1	655A	1
146T6323-1		1	575	1
146T6323-3		1	580	1
146T6327-2		1	520	1
		3	10	1
146T6328-2		1	605	1
		4	5	1
146T6329-2		1	515	1
		3	5	1
146T6330-2		1	610	1
		4	10	1
146T6332-1		1	270	2
146T6332-2		1	320	2
146T6334-2		1	55	1
146T6337-1		1	430	1
146T6337-2		1	460	1
146T6338-1		1	325	1
146T6338-2		1	350	1
146T6350-10		2	50A	1
146T6350-11		2	45C	1
146T6350-12		2	50C	1
146T6350-15		2	45D	1
146T6350-16		2	50D	1
146T6350-7		2	45	1
146T6350-8		2	50	1
146T6350-9		2	45A	1
146T6351-1		2	135	1
146T6351-2		2	170	1
146T6352-1		2	175	1
146T6353-1		1	30	2
146T6357-1		2	130	1

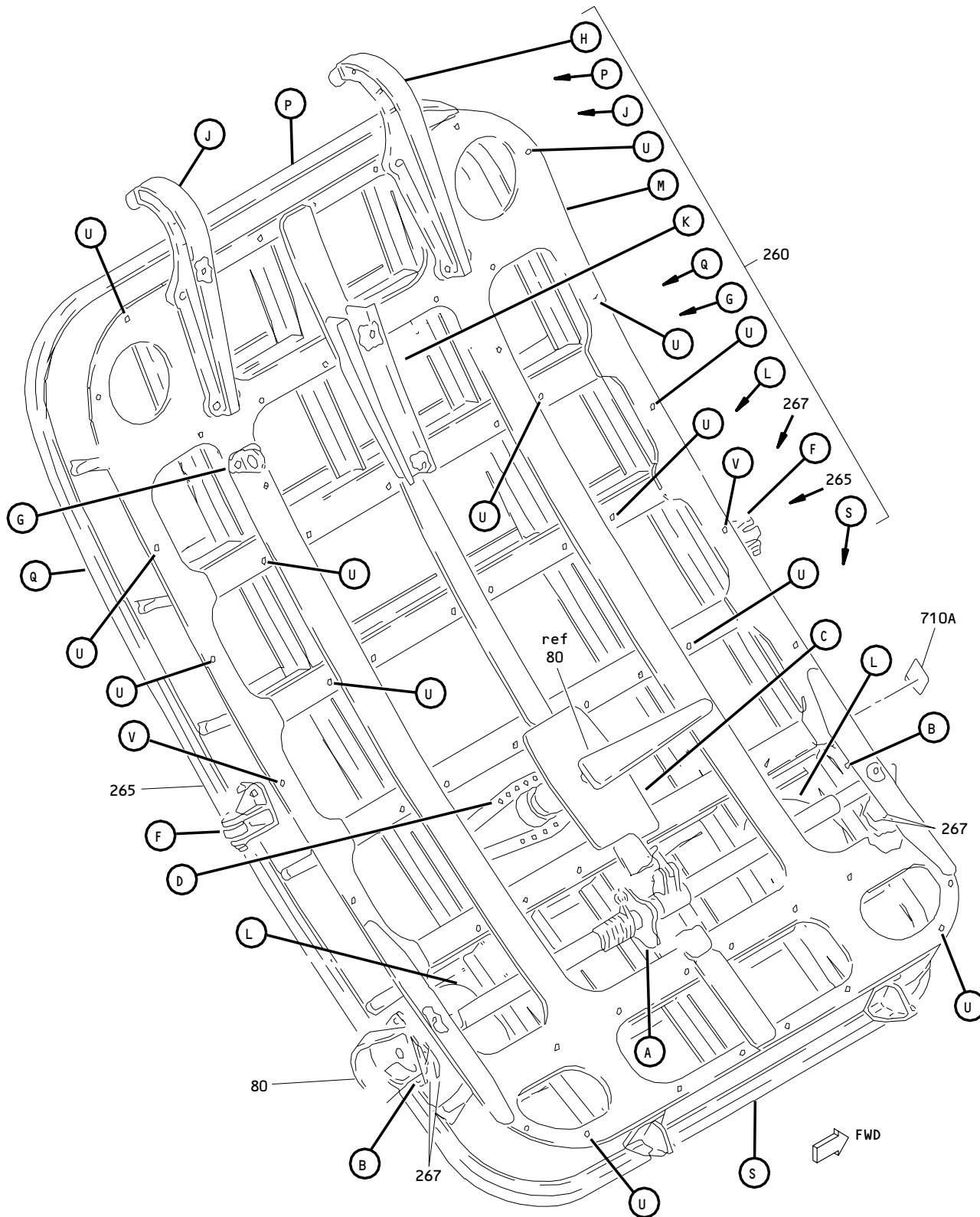
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
146T6358-1		2	55	2
146T6396-2		1	267	4
284T0482-1		2	25	1
6AFC817		1	305	2
66014-5		1	95	45
		1	595	5
		1	675	5
		5	20	5
66796-428		1	340	2
		1	390	4
66796-524		1	410	4
69B00084-1		1	565	6
		1	645	6
		3	60	6
		4	60	6
69B17927-1		1	715	12
70188-104		1	695	12
		5	40	12
70191-104		1	700	12
		5	45	12
922007-4		1	695	12
		5	40	12
922008-4		1	700	12
		5	45	12
942007-4		1	695	12
		5	40	12
942008-4		1	700	12
		5	45	12
96-02		2	20	2
		2	150	2

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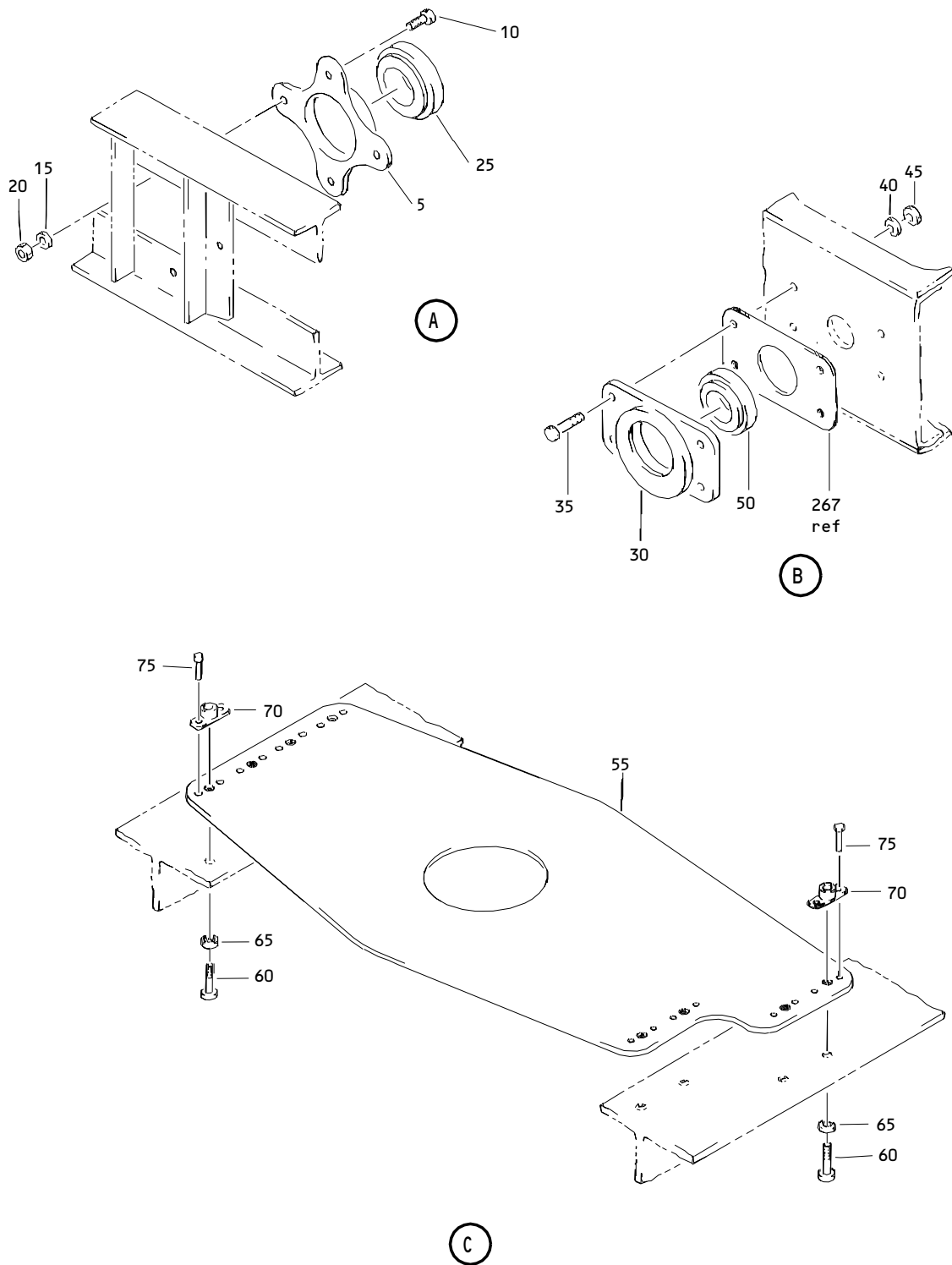
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Bulk Cargo Door, Door Assembly
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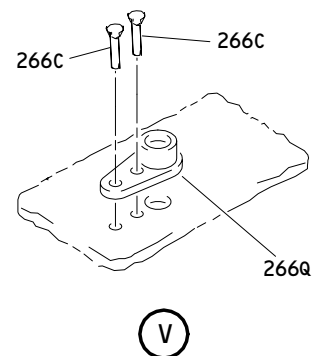
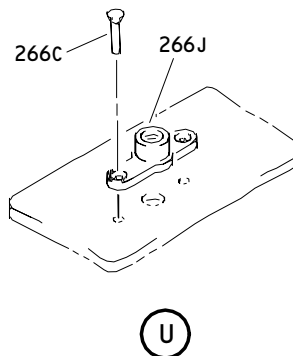
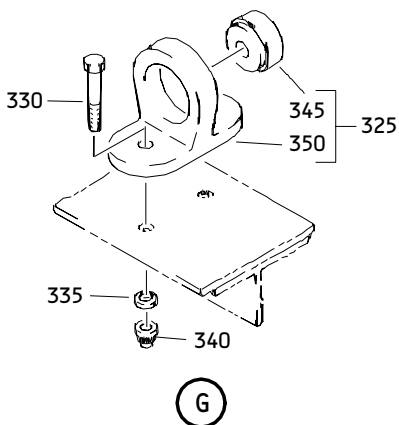
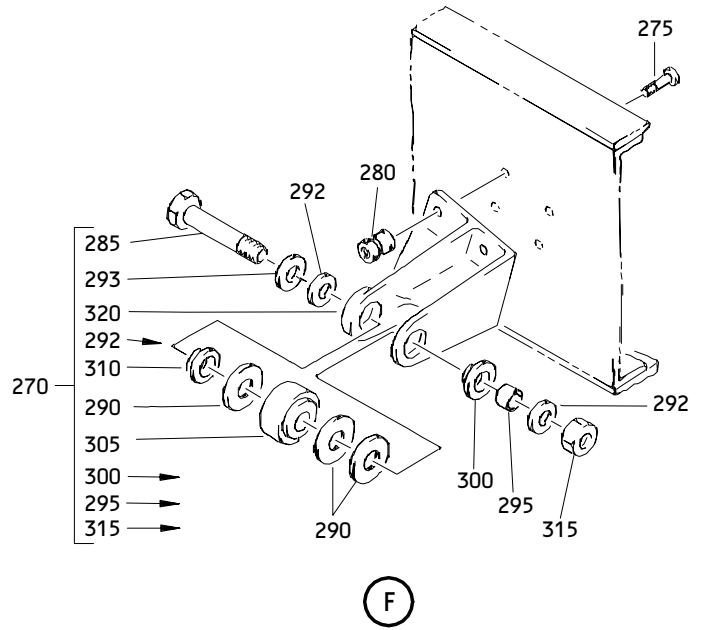
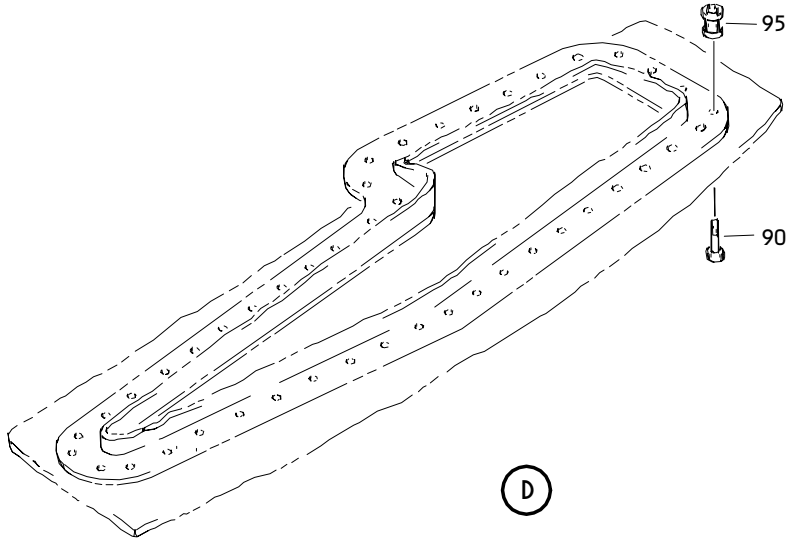
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Bulk Cargo Door Assembly
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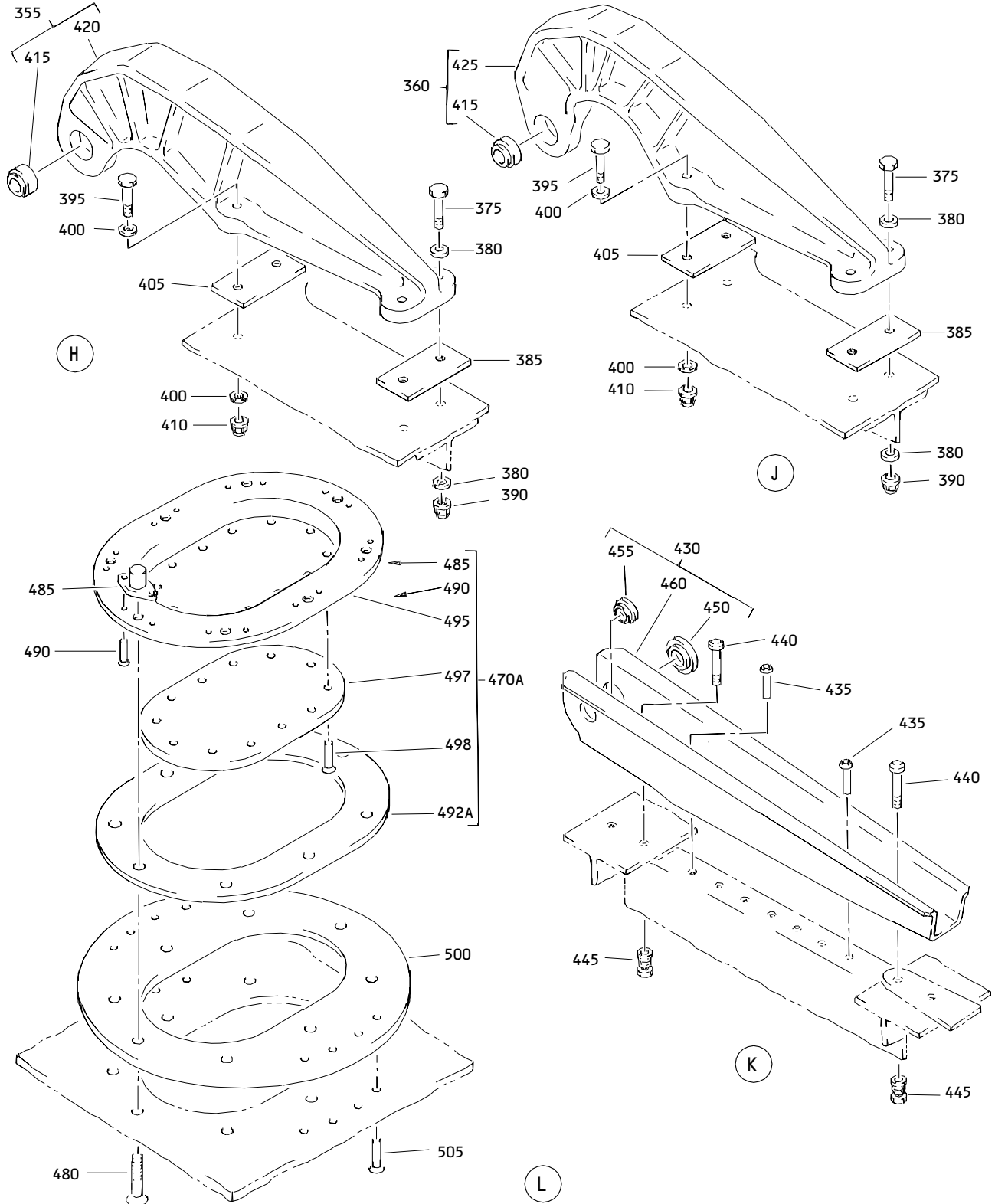
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Bulk Cargo Door Assembly
 Figure 1 (Sheet 3)

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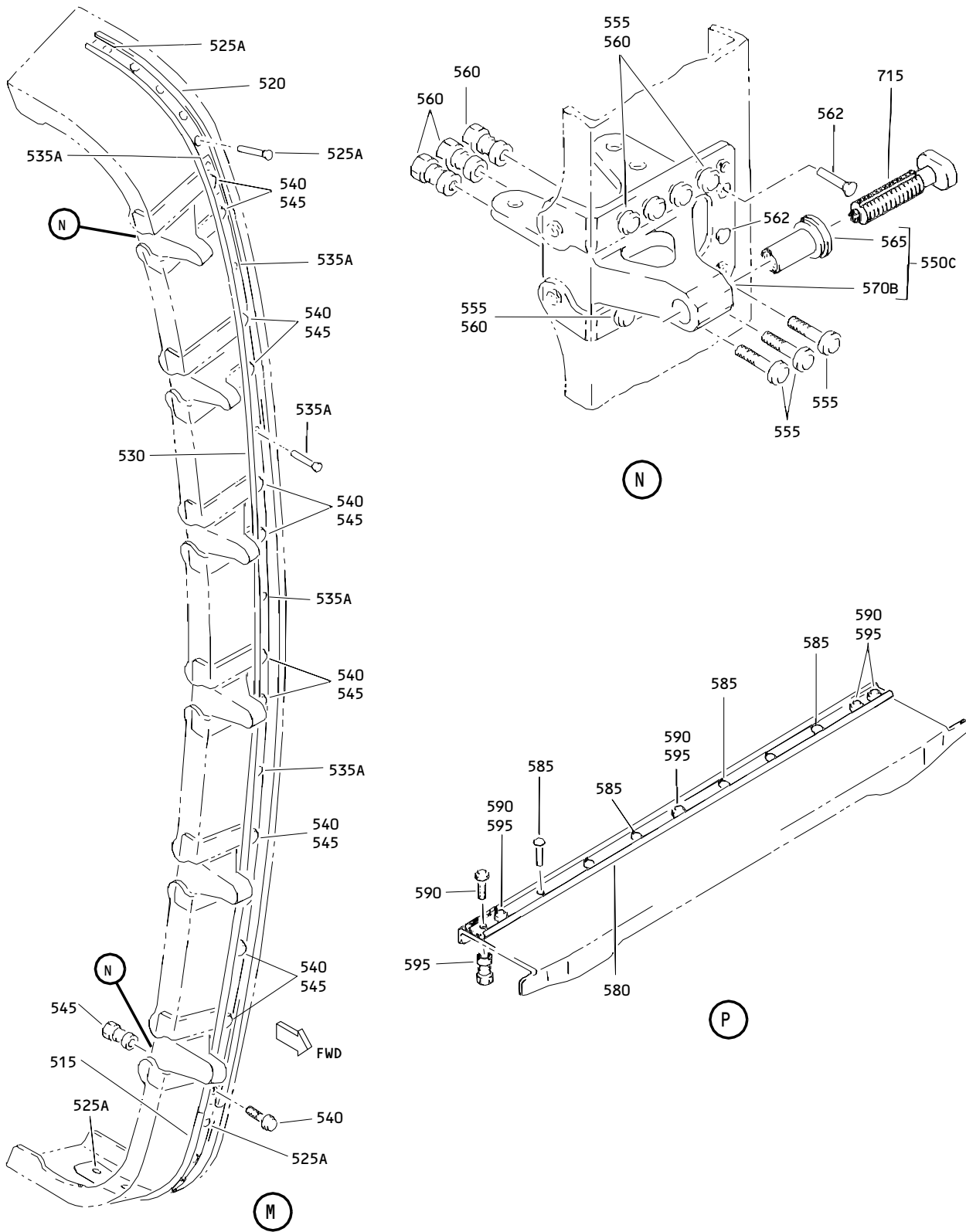
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Bulk Cargo Door Assembly
 Figure 1 (Sheet 4)

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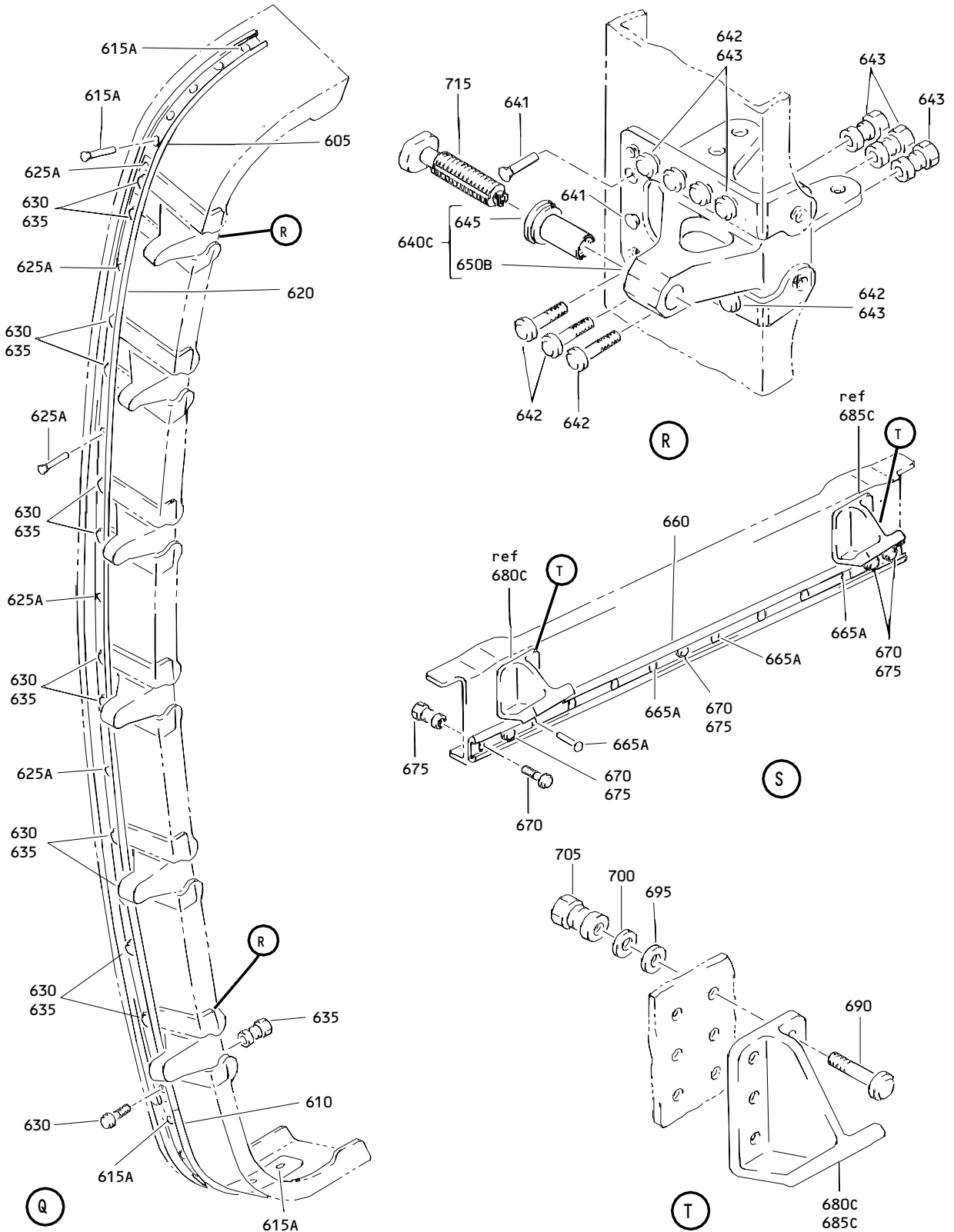
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Bulk Cargo Door Assembly
Figure 1 (Sheet 6)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1	146T6301-1		DOOR ASSY-BULK CARGO DOOR	A	RF
-1A	146T6301-3		DOOR ASSY-BULK CARGO DOOR	B	RF
-1B	146T6301-4		DOOR ASSY-BULK CARGO DOOR	C	RF
5	140T2629-2		.SUPPORT-TORQUE TUBE BRG ATTACHING PARTS		1
10	BACB30NR4K4		.BOLT		4
15	AN960PD416		.WASHER		4
20	BACN10JC4		.NUT		4
			-----*-----		
25	KP21BSLY196		.BEARING- (V40920) (SPEC BACB10EX21) (OPT KP21BSSD610 (V83086)) (OPT KP21BS1 (V38443))		1
30	146T6353-1		.SUPPORT-TORQUE TUBE BRG ATTACHING PARTS		2
35	BACB30NR4K8		.BOLT		8
40	AN960PD416		.WASHER		8
45	BACN10JC4		.NUT		8
			-----*-----		
50	KP16BSLY196		.BEARING- (V40920) (SPEC BACB10EX16) (OPT KP16BSSD610 (V83086)) (OPT KP16BS (V38443))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-55	146T6334-2		.PANEL-HANDLE ATTACHING PARTS		1
60	NAS623-3-3		.SCREW		8
65	AN960PD10		.WASHER		8
			-----*		
70	BRFM20A3		.NUTPLATE- (V52828) (SPEC BACN10JN3) (OPT MF1000-3BAC (V15653)) (OPT NS103218-02 (V80539)) (OPT RMF9201M3 (V72962)) (OPT VN252A02 (V92215)) (OPT MF1000-3BAC (V15653)) (OPT MF53049-3 (V15653)) ATTACHING PARTS		8
75	BACR15BA3KE		.RIVET- (SIZE DETERMINE ON INST)		16
			-----*		
80	146T6304-1		.MECHANISM INSTL	A	1
-80A	146T6304-3		.MECHANISM INSTL- (FOR DETAILS SEE FIG. 2) ATTACHING PARTS	B,C	1
90	BACB30NW5K		.BOLT- (SIZE DETERMINE ON INST)		45
95	HL70-5		.COLLAR- (V56878) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878)) -----*		45

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -100	146T6304-5002		..MECHANISM INSTL- (REPLD BY ITEMS 100A, 100B) (FOR DETAILS SEE FIG. 2)	A	1
-100A	146T6304-5001		..MECHANISM INSTL- (REPLS ITEM 100) (REPLD BY ITEM 100B) (FOR DETAILS SEE FIG. 2)	A	1
-100B	146T6304-5003		..MECHANISM INSTL- (REPLS ITEMS 100, 100A) (FOR DETAILS SEE FIG. 2)	A	1
260	146T6301-5003		.STRUCTURE ASSY- (REPLD BY ITEM 260A)	A	1
-260A	146T6301-5001		.STRUCTURE ASSY- (REPLS ITEM 260)	A	1
-260B	146T6301-5001		.STRUCTURE ASSY	B	1
-260C	146T6301-2		.DOOR ASSY	C	1
265	SF15-120-6		..SEAL- (V50744) (SPEC S140T263-6)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
266	BACR15CE3KE		DELETED		
266B	BRM200C3M		DELETED		
266C	BACR15BA3AD		..RIVET-		122
			(SIZE DETERMINE ON INST)		
266J	BRM200A3		..NUTPLATE-		59
			(V52828)		
			(SPEC BACN10JP3A)		
			(OPT MK1000-3BAC		
			(V15653))		
			(OPT NS103197-02		
			(V80539))		
			(OPT RMA9201M3		
			(V72962))		
			(OPT T8076S1032		
			(V11815))		
			(OPT VN202A1-02		
			(V92215))		
266Q	BRM100A3		..NUTPLATE-		2
			(V52828)		
			(SPEC BACN10JP3B)		
			(OPT MK2000-3BAC		
			(V15653))		
			(OPT NS103198-02		
			(V80539))		
			(OPT RMA9207-3		
			(V72962))		
			(OPT T8077S1032		
			(V11815))		
			(OPT VN201A1-02		
			(V92215))		
267	146T6396-2		..FILLER		4
270	146T6332-1		..ROLLER ASSY		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
275	BACB30NX6K		ATTACHING PARTS ..BOLT- (SIZE DETERMINE ON INST)		8
280	HL1187-6		..COLLAR- (V73197) (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 (V5M902)) -----*-----		8
285	BACB30LJ6-21		...BOLT		1
290	BACW10P254C		...WASHER		3
292	AN960C616		...WASHER		2
293	AN960JD616L		...WASHER		1
295	BACB28AK06-026		...BUSHING		1
300	BACB28X9M011		...BUSHING		1
305	ATF6		...BEARING- (V60380) (SPEC BACB10ET06) (OPT 6AFC817 (V92563))		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
310	BACB28X6C028		...BUSHING		1
315	BACN10JC6		...NUT		1
320	146T6332-2		...FITTING		1
325	146T6338-1		..FITTING ASSY-CABLE ATTACHING PARTS		1
330	BACB30NM4K7		..BOLT		2
335	AN960PD416		..WASHER		2
340	BACN10GW4		..NUT- (OPT H93-4 (V15653)) (OPT RMLH18-4 (V72962)) (OPT SL7020S428 (V11815)) (OPT VN497A048 (V92215)) (OPT 66796-428 (V56878)) -----*		2
345	KSP4A		...BEARING- (V38443) (SPEC BACB10AC4A) (OPT HHKSP4A (V38443)) (OPT KSP4AE9440A (V21335)) (OPT KSP4AFS428 (V21335)) (OPT KSP4A2TS (V43991)) (OPT KSP4AG27 (V30163))		1
350	146T6338-2		...FITTING		1
355	146T6308-1		..FITTING ASSY-FWD HINGE ARM (USED ON ITEM 260A,260C)		1
-355A	146T6308-1		..FITTING ASSY-FWD HINGE ARM (OPT ITEM 355B) (USED ON ITEM 260)	A	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -355B	146T6308-4		..FITTING ASSY-FWD HINGE ARM (OPT ITEM 355A) (USED ON ITEM 260)	A	1
360	146T6309-1		..FITTING ASSY-AFT HINGE ARM (USED ON ITEM 260A,260C)		1
-360A	146T6309-1		..FITTING ASSY-AFT HINGE ARM (OPT ITEM 360B) (USED ON ITEM 260)	A	1
-360B	146T6309-4		..FITTING ASSY-AFT HINGE ARM (OPT ITEM 360A) (USED ON ITEM 260)	A	1
375	BACB30NM4K13		ATTACHING PARTS		4
380	AN960PD416		..BOLT		8
385	BACS40R10E26F		..WASHER		2
390	BACN10GW4		..SHIM		4
			..NUT- (OPT H93-4 (V15653)) (OPT RMLH18-4 (V72962)) (OPT SL7020S428 (V11815)) (OPT VN497A048 (V92215)) (OPT 66796-428 (V56878))		
395	BACB30NM5K18		..BOLT		4
400	AN960PD516		..WASHER		8
405	BACS40R10E26F		..SHIM		2
410	BACN10GW5		..NUT- (OPT H93-5 (V15653)) (OPT RMLH18-5 (V72962)) (OPT SL7020S524 (V11815)) (OPT VN497A054 (V92215)) (OPT 66796-524 (V56878))		4
			-----*		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-415	ADB8V301C		...BEARING- (V15860) (SPEC BACB10ES08GC) (OPT HTES08VC (V50294)) (OPT KNDB8-64 (V97613)) (OPT KSC130900B6GC (V50632)) (OPT NRR08ESGC (V73134)) (OPT 03-825-08E010C (V09455))		1
420	146T6308-2		...FITTING- (USED ON ITEMS 355, 355A)		1
-420A	146T6308-5		...FITTING- (USED ON ITEM 355B)	A	1
425	146T6309-2		...FITTING- (USED ON ITEMS 360, 360A)		1
-425A	146T6309-5		...FITTING- (USED ON ITEM 360B)	A	1
430	146T6337-1		..SUPPORT ASSY-SNUBBER ATTACHING PARTS		1
435	BACR15FT6KE		..RIVET- (SIZE DETERMINE ON INST)		7
440	BACB30NX6K		..BOLT- (SIZE DETERMINE ON INST)		4
445	HL1187DUW6		..COLLAR- (V73197) (SPEC BACC30X6SW) (OPT HL87DUW6 (V73197)) (OPT HL87DUW6 (V92215)) (OPT HL1187DUW6 (V56878)) (OPT HL1187DUW6 (V92215)) (OPT HL87DUW6 (V56878)) (OPT HL1187DUW6 (V5M902)) -----*		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
450	BACB28X9M008		...BUSHING		1
455	BACB28X6C008		...BUSHING		1
460	146T6337-2		...SUPPORT		1
-465	140T2614-12		DELETED		
-465A	140T2614-23		..PANEL INSTL-ACCESS		1
-467	140T2614-24		..PANEL INSTL-ACCESS		1
470A	140T2614-15		...PANEL ASSY-UP. ATTACHING PARTS		1
480	BACB30LH3-5		...BOLT -----*-----		8
485	F1968-3BAC	NUTPLATE- (V15653) (SPEC BACN10JZ3A2) (OPT NS103224-02 (V80539)) (OPT RMF9219-3 (V72962)) (OPT SE98A3 (V62554)) ATTACHING PARTS		8
490	BACR15BA3AD	RIVET- (SIZE DETERMINE ON INST) -----*-----		16
492A	140T2614-14	GASKET		1
495	140T2614-7	PANEL		1
497	140T2614-5	SKIN ATTACHING PARTS		1
498	BACR15FV6KE	RIVET- (SIZE DETERMINE ON INST) -----*-----		12

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-500	140T2614-13		...DOUBLER ATTACHING PARTS		1
505	BACR15FV6KE		...RIVET- (SIZE DETERMINE ON INST) -----*-----		8
-507	146T6320-1		..FRAME INSTL-FWD	A,B	1
-507A	146T6320-7		..FRAME INSTL-FWD (FOR DETAILS SEE FIG. 3)	C	1
-510	146T6320-5003		...FRAME INSTL-FWD (REPLD BY ITEM 510A)	A,B	1
-510A	146T6320-5001		...FRAME INSTL-FWD (REPLS ITEM 510)	A,B	1
515	146T6329-2	RETAINER-SEAL	A,B	1
520	146T6327-2	RETAINER-SEAL ATTACHING PARTS	A,B	1
525	BACR15FT4KE		DELETED		
525A	BACR15BB4AD	RIVET- (SIZE DETERMINE ON INST) -----*-----	A,B	10
530	146T6320-3	RETAINER-SEAL ATTACHING PARTS	A,B	1
535	BACR15FT4KE		DELETED		
535A	BACR15BB4AD	RIVET- (SIZE DETERMINE ON INST)	A,B	5
540	BACB30MY6K	BOLT- (SIZE DETERMINE ON INST)	A,B	13
545	HL82-6APBW	COLLAR- (V73197) (SPEC BACC30AG6) (OPT HL82-6APBW (V92215)) (OPT HL82-6APBW (V56878)) -----*-----	A,B	13

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-550C	146T6314-6	FITTING ASSY-STOP (USED ON ITEM 510A)	A,B	6
-550D	146T6314-6	FITTING ASSY-STOP (OPT ITEM 550E) (USED ON ITEM 510)	A,B	6
-550E	146T6314-8	FITTING ASSY-STOP (OPT ITEM 550D) (USED ON ITEM 510) ATTACHING PARTS	A,B	6
555	BACB30MY6K	BOLT- (SIZE DETERMINE ON INST)	A,B	48
560	HL82-6APBW	COLLAR- (V73197) (SPEC BACC30AG6) (OPT HL82-6APBW (V92215)) (OPT HL82-6APBW (V56878))	A,B	48
562	BACR15CE6KE	RIVET- (SIZE DETERMINE ON INST) -----*	A,B	12
565	69B00084-1	BUSHING	A,B	1
570B	146T6314-7	FITTING- (USED ON ITEMS 550C, 550D)	A,B	1
-570C	146T6314-9	FITTING- (USED ON ITEM 550E)	A,B	1
-575	146T6323-1		..FRAME INSTL-UPR		1
580	146T6323-3		...RETAINER-SEAL ATTACHING PARTS		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-585	BACR15FT4KE		...RIVET- (SIZE DETERMINE ON INST)		6
590	BACB30MY5K		...BOLT- (SIZE DETERMINE ON INST)		5
595	HL70-5		...COLLAR- (V56878) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878)) -----*		5
-597	146T6321-1		..FRAME INSTL-AFT	A,B	1
-597A	146T6321-7		..FRAME INSTL-AFT (FOR DETAILS SEE FIG. 4)	C	1
-600	146T6321-5003		...FRAME INSTL-AFT (REPLD BY ITEM 600A)	A,B	1
-600A	146T6321-5001		...FRAME INSTL-AFT (REPLS ITEM 600)	A,B	1
605	146T6328-2	RETAINER-SEAL	A,B	1
610	146T6330-2	RETAINER-SEAL ATTACHING PARTS	A,B	1
615A	BACR15BB4AD	RIVET- (SIZE DETERMINE ON INST) -----*	A,B	10
620	146T6321-3	RETAINER-SEAL ATTACHING PARTS	A,B	1
625A	BACR15BB4AD	RIVET- (SIZE DETERMINE ON INST) -----*	A,B	5
630	BACB30MY6K	BOLT- (SIZE DETERMINE ON INST) ATTACHING PARTS	A,B	13
635	HL82-6APBW	COLLAR- (V73197) (SPEC BACC30AG6) (OPT HL82-6APBW (V92215)) (OPT HL82-6APBW (V56878)) -----*	A,B	13

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-640C	146T6312-6	FITTING ASSY-STOP (USED ON ITEM 600A)	A,B	6
-640D	146T6312-6	FITTING ASSY-STOP (OPT ITEM 640E) (USED ON ITEM 600)	A,B	6
-640E	146T6312-8	FITTING ASSY-STOP (OPT ITEM 640D) (USED ON ITEM 600) ATTACHING PARTS	A,B	6
641	BACR15CE6KE	RIVET- (SIZE DETERMINE ON INST)	A,B	12
642	BACB30MY6K	BOLT- (SIZE DETERMINE ON INST)	A,B	48
643	HL82-6APBW	COLLAR- (V73197) (SPEC BACC30AG6) (OPT HL82-6APBW (V92215)) (OPT HL82-6APBW (V56878)) -----*	A,B	48
645	69B00084-1	BUSHING	A,B	1
650B	146T6312-7	FITTING- (USED ON ITEMS 640C, 640D)	A,B	1
-650C	146T6312-9	FITTING- (USED ON ITEM 640E)	A,B	1
-652	146T6322-1		..FRAME INSTL-LWR	A,B	1
-652A	146T6322-5		..FRAME INSTL-LWR (FOR DETAILS SEE FIG. 5)	C	1
-655	146T6322-5003		...FRAME INSTL-LWR (REPLD BY ITEM 655A)	A,B	1
-655A	146T6322-5001		...FRAME INSTL-LWR (REPLS ITEM 655)	A,B	1
660	146T6322-3	RETAINER-SEAL ATTACHING PARTS	A,B	1
665	BACR15FT4KE		DELETED		
665A	BACR15BB4AD	RIVET- (SIZE DETERMINE ON INST)	A,B	8
670	BACB30MY5K	BOLT- (SIZE DETERMINE ON INST)	A,B	5

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-675	HL70-5	COLLAR- (V56878) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878)) -----*	A,B	5
680	146T6313-1		DELETED		
-680A	146T6313-1		DELETED		
-680B	146T6313-4		DELETED		
680C	146T6313-7	FITTING-STOP (USED ON ITEM 655A)	A,B	1
-680D	146T6313-7	FITTING-STOP (OPT ITEM 680E) (USED ON ITEM 655)	A,B	1
-680E	146T6313-9	FITTING-STOP (OPT ITEM 680D) (USED ON ITEM 655)	A,B	1
685	146T6313-2		DELETED		
-685A	146T6313-2		DELETED		
-685B	146T6312-5		DELETED		
685C	146T6313-8	FITTING-STOP (USED ON ITEM 655A)	A,B	1
-685D	146T6313-8	FITTING-STOP (OPT ITEM 685E) (USED ON ITEM 655)	A,B	1
-685E	146T6313-10	FITTING-STOP (OPT ITEM 685D) (USED ON ITEM 655) ATTACHING PARTS	A,B	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-690	BACB30NX8K	BOLT- (SIZE DETERMINE ON INST)	A,B	12
695	K29646-104	WASHER- (V15653) (SPEC BACW10CA104CV) (OPT 70188-104 (V56878)) (OPT 922007-4 (V60119)) (OPT 942007-4 (V60119))	A,B	12
700	K29913-104	WASHER- (V15653) (SPEC BACW10CA104CC) (OPT 70191-104 (V56878)) (OPT 922008-4 (V60119)) (OPT 942008-4 (V60119))	A,B	12
705	HL1187-8	COLLAR- (V73197) (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 (V5M902)) -----*	A,B	12

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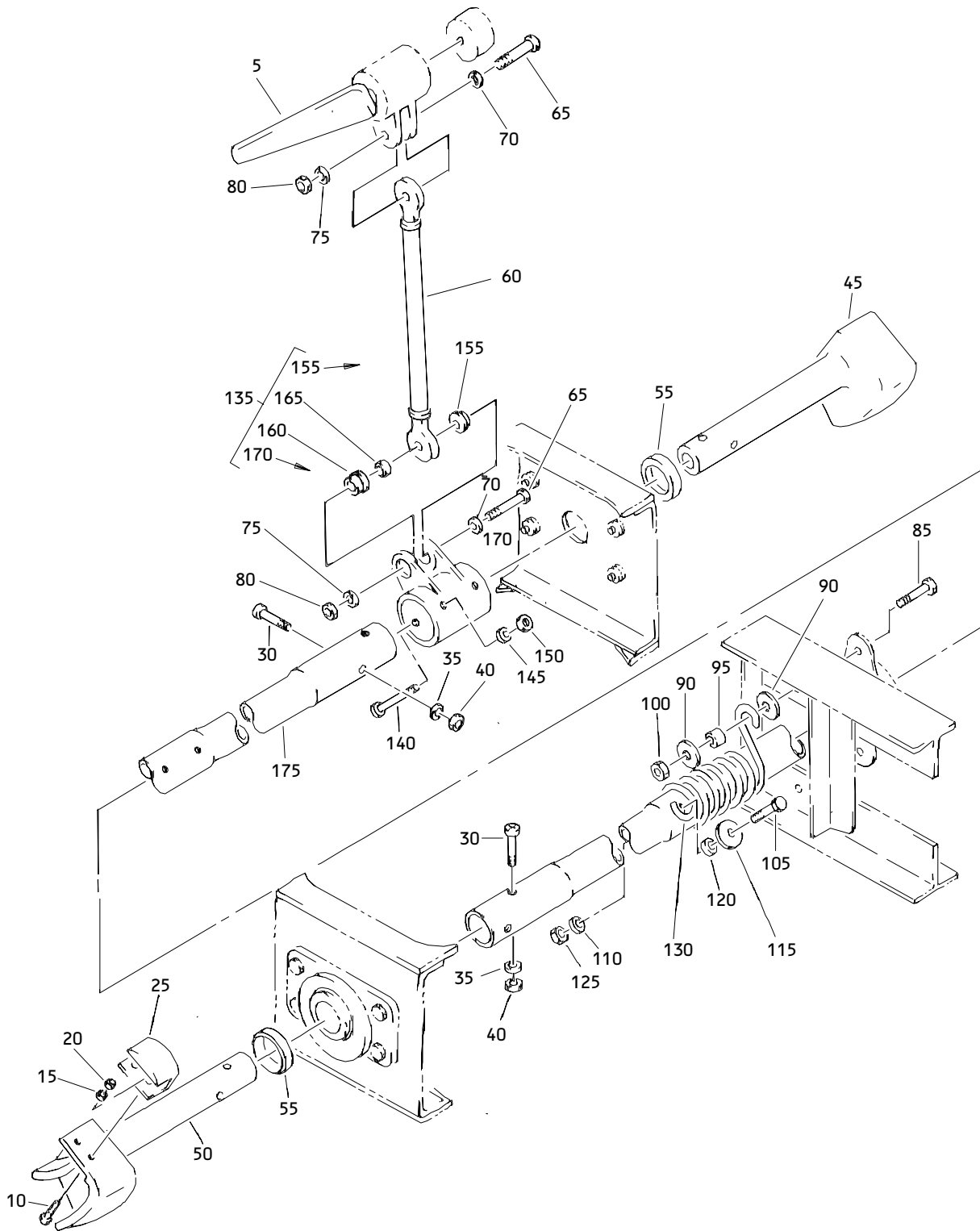
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
01- 710A 715	MS27253F2 69B17927-1		1234567 .PLATE .PIN		1 12

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**Bulk Cargo Door Mechanism Installation
 Figure 2**

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02- -1	146T6304-5002		MECHANISM INSTL-BULK CARGO DOOR	A	RF
-1A	146T6304-5001		MECHANISM INSTL-BULK CARGO DOOR	A	RF
-1B	146T6304-5003		MECHANISM INSTL-BULK CARGO DOOR	A	RF
-1G	146T6304-3		MECHANISM INSTL-BULK CARGO DOOR	B,C	RF
5	H2863-3		.LATCH ASSY- (V83014)		1
10	NAS1801-3-10		.SCREW		2
15	AN960PD10L		.WASHER		2
20	H10-3BAC		.NUT- (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828))		2
25	284T0482-1		.TARGET- (USED WITH ITEMS 50, 50B, 50C, 50D)		1
30	BACB30LT5-20		.BOLT		4
35	AN960C516		.WASHER		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-40	BACN10JC5		.NUT		4
45	146T6350-7		.CAM-LATCH CRANK (USED ON ITEM 1) (OPT ITEM 45A)	A	1
-45A	146T6350-9		.CAM-LATCH CRANK (USED ON ITEM 1) (OPT ITEM 45)	A	1
-45B	146T6350-7		.CAM-LATCH CRANK (USED ON ITEM 1A)	A	1
-45C	146T6350-11		.CAM-LATCH CRANK (USED ON ITEM 1B)	A	1
-45D	146T6350-15		.CAM-LATCH CRANK	B,C	1
50	146T6350-8		.CAM-LATCH CRANK (USED ON ITEM 1) (OPT ITEM 50A)	A	1
-50A	146T6350-10		.CAM-LATCH CRANK (USED ON ITEM 1) (OPT ITEM 50)	A	1
-50B	146T6350-8		.CAM-LATCH CRANK (USED ON ITEM 1A)	A	1
-50C	146T6350-12		.CAM-LATCH CRANK (USED ON ITEM 1B)	A	1
-50D	146T6350-16		.CAM-LATCH CRANK	B,C	1
55	146T6358-1		.SPACER		2
60	146T6304-2		.ROD ASSY		1
			ATTACHING PARTS		
65	BACB30NR4K20		.BOLT		2
70	AN96OPD416L		.WASHER		2
75	AN96OC416		.WASHER		2
80	BACN10JC4		.NUT		2
			-----*-----		
85	BACB30NR4K10		.BOLT		1
90	AN970-4		.WASHER		2
95	BACB28AK04-033		.BUSHING		1
100	BACN10JC4		.NUT		1
105	BACB30NR4K26		.BOLT		1
110	AN96OPD416		.WASHER		1
115	AN970-4		.WASHER		1
120	BACB28AK04-020		.BUSHING		1
125	BACN10JC4		.NUT		1
130	146T6357-1		.SPRING		1
135	146T6351-1		.CRANK ASSY		1
			ATTACHING PARTS		
140	BACB30NM3K25		.BOLT		2
145	AN96OPD10		.WASHER		2

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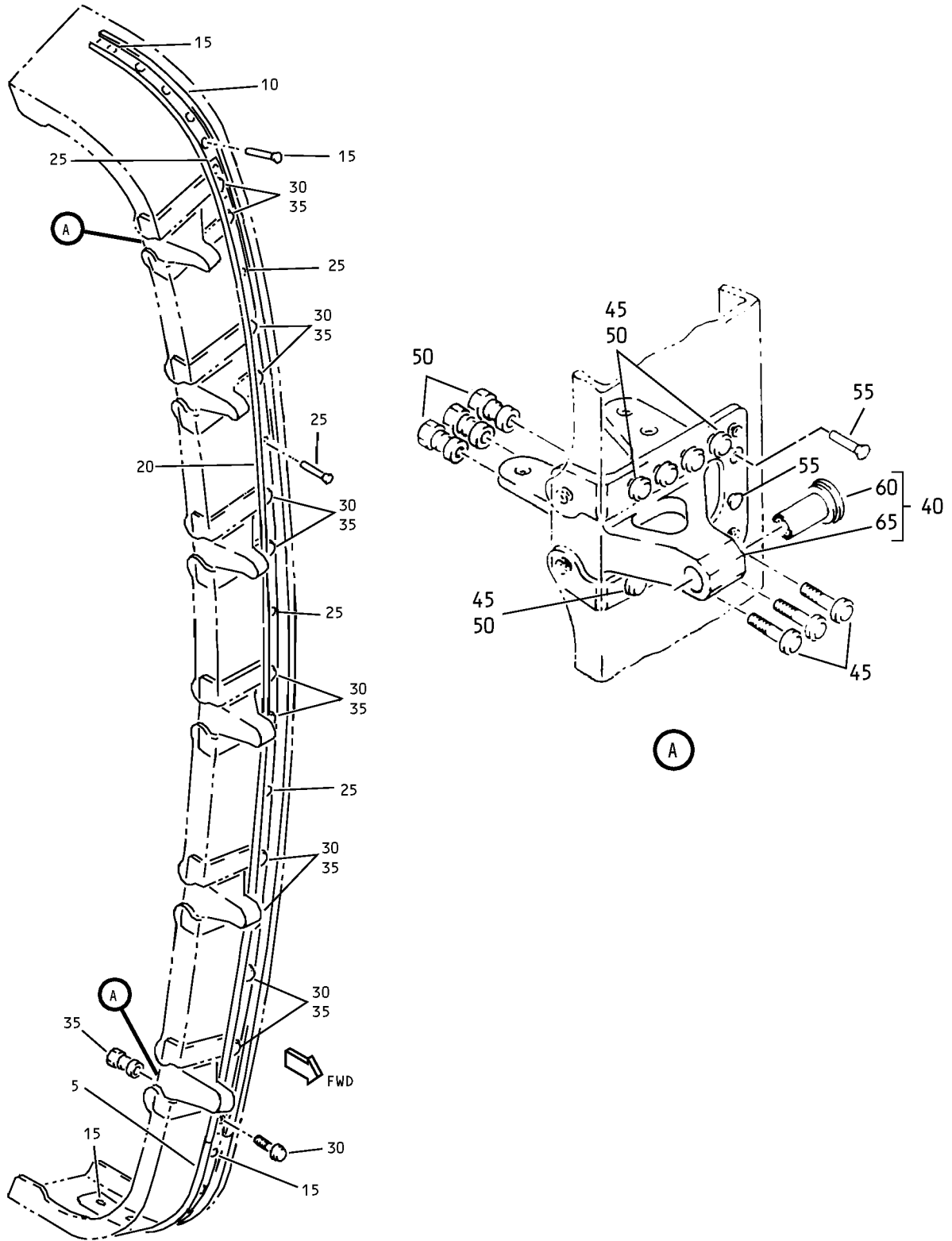
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
02-150	H10-3BAC		.NUT- (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828)) -----*-----		2
155	BACB28X4C017		..BUSHING		1
160	BACB28X6M014		..BUSHING		1
165	BACB28AK04-031		..BUSHING		1
170	146T6351-2		..CRANK		1
175	146T6352-1		.TUBE-TORQUE		1

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Forward Installation Frame
 Figure 3

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
-1A	146T6320-7		FRAME INSTL-FWD	C	RF
5	146T6329-2		.RETAINER-SEAL	C	1
10	146T6327-2		.RETAINER-SEAL	C	1
			ATTACHING PARTS		
15	BACR15BB4AD		.RIVET-	C	10
			(SIZE DETERMINE ON INST)		
			-----*		
20	146T6320-3		.RETAINER-SEAL	C	1
			ATTACHING PARTS		
25	BACR15BB4AD		.RIVET-	C	5
			(SIZE DETERMINE ON INST)		
30	BACB30MY6K		.BOLT-	C	13
			(SIZE DETERMINE ON INST)		
35	HL82-6APBW		.COLLAR-	C	13
			(V73197)		
			(SPEC BACC30AG6)		
			(OPT HL82-6APBW		
			(V92215))		
			(OPT HL82-6APBW		
			(V56878))		
			-----*		
40	146T6314-6		.FITTING ASSY-STOP	C	6
			ATTACHING PARTS		
45	BACB30MY6K		.BOLT-	C	48
			(SIZE DETERMINE ON INST)		
50	HL82-6APBW		.COLLAR-	C	48
			(V73197)		
			(SPEC BACC30AG6)		
			(OPT HL82-6APBW		
			(V92215))		
			(OPT HL82-6APBW		
			(V56878))		

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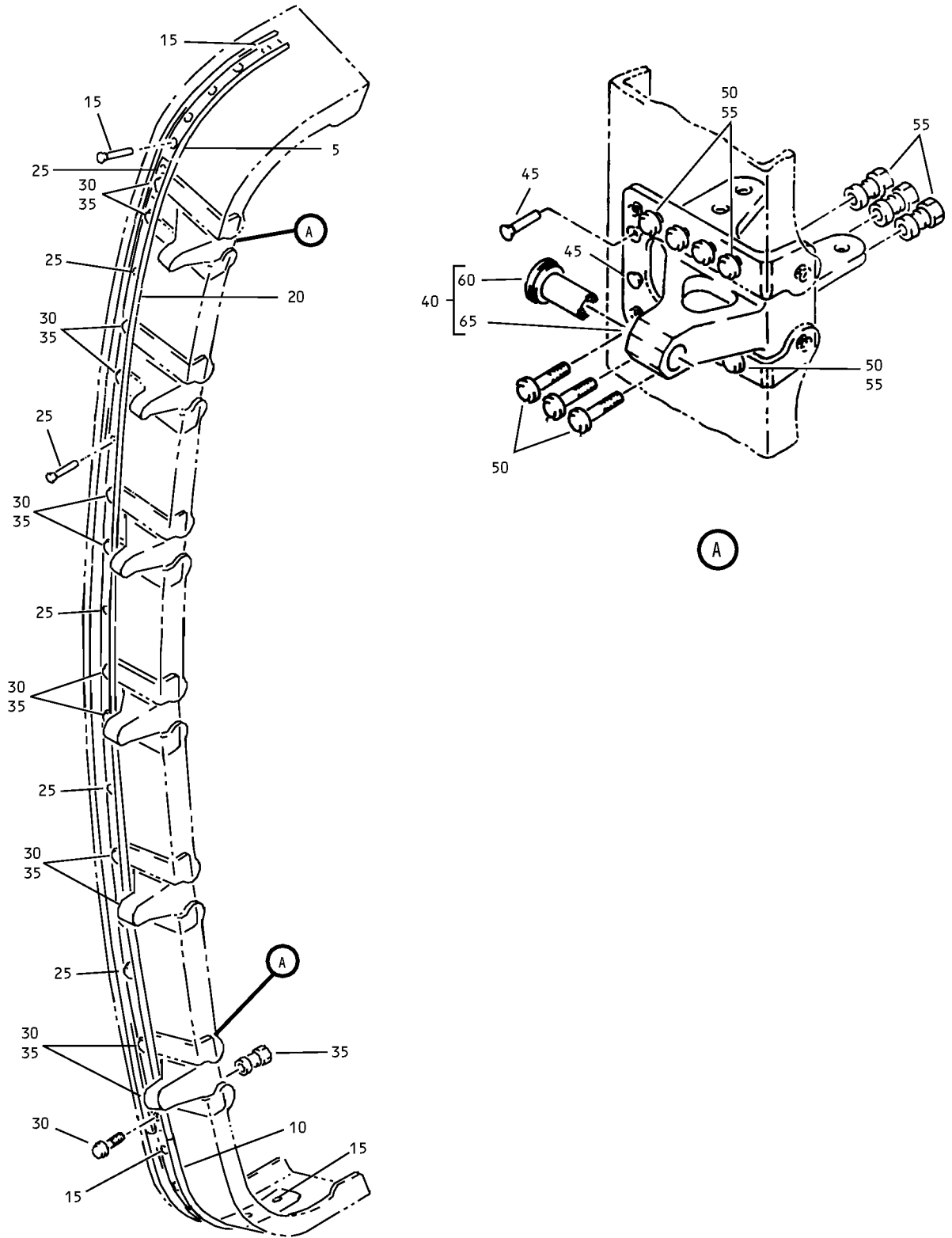
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
03-55	BACR15CE6KE		.RIVET- (SIZE DETERMINE ON INST) -----*-----	C	12
60	69B00084-1		..BUSHING	C	1
65	146T6314-7		..FITTING	C	1

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Aft Installation Frame
 Figure 4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
-1A	146T6321-7		FRAME INSTL-AFT	C	RF
5	146T6328-2		.RETAINER-SEAL	C	1
10	146T6330-2		.RETAINER-SEAL	C	1
			ATTACHING PARTS		
15	BACR15BB4AD		.RIVET-	C	10
			(SIZE DETERMINE ON INST)		
			-----*		
20	146T6321-3		.RETAINER-SEAL	C	1
			ATTACHING PARTS		
25	BACR15BB4AD		.RIVET-	C	5
			(SIZE DETERMINE ON INST)		
30	BACB30MY6K		.BOLT-	C	13
			(SIZE DETERMINE ON INST)		
35	HL82-6APBW		.COLLAR-	C	13
			(V73197)		
			(SPEC BACC30AG6)		
			(OPT HL82-6APBW		
			(V92215))		
			(OPT HL82-6APBW		
			(V56878))		
			-----*		
40	146T6312-6		.FITTING ASSY-STOP	C	6
			ATTACHING PARTS		
45	BACR15CE6KE		.RIVET-	C	12
			(SIZE DETERMINE ON INST)		
50	BACB30MY6K		.BOLT-	C	48
			(SIZE DETERMINE ON INST)		
55	HL82-6APBW		.COLLAR-	C	48
			(V73197)		
			(SPEC BACC30AG6)		
			(OPT HL82-6APBW		
			(V92215))		
			(OPT HL82-6APBW		
			(V56878))		
			-----*		

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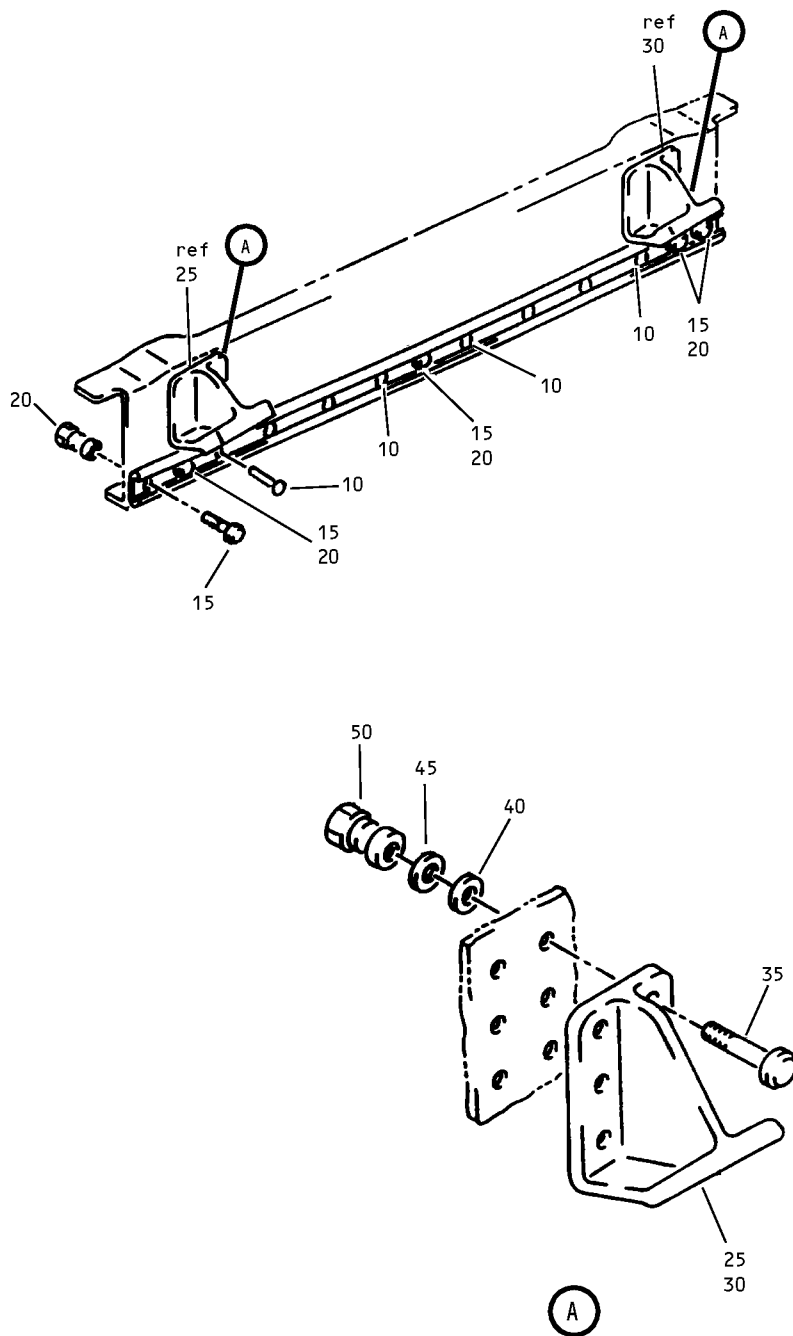
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04- 60 65	69B00084-1 146T6312-7		..BUSHING ..FITTING	C C	1 1

- Item Not Illustrated

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Lower Installation Frame
 Figure 5

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
-1A	146T6322-5		FRAME INSTL-LWR	C	RF
5	146T6322-3		.RETAINER-SEAL	C	1
			ATTACHING PARTS		
10	BACR15BB4AD		.RIVET-	C	8
			(SIZE DETERMINE ON INST)		
15	BACB30MY5K		.BOLT-	C	5
			(SIZE DETERMINE ON INST)		
20	HL70-5		.COLLAR-	C	5
			(V56878)		
			(SPEC BACC30M5)		
			(OPT HL70-5		
			(V73197))		
			(OPT HL70-5		
			(V92215))		
			(OPT 66014-5		
			(V56878))		
			-----*		
25	146T6313-7		.FITTING-STOP	C	1
30	146T6313-8		.FITTING-STOP	C	1
			ATTACHING PARTS		
35	BACB30NX8K		.BOLT-	C	12
			(SIZE DETERMINE ON INST)		
40	K29646-104		.WASHER-	C	12
			(V15653)		
			(SPEC BACW10CA104CV)		
			(OPT 70188-104		
			(V56878))		
			(OPT 922007-4		
			(V60119))		
			(OPT 942007-4		
			(V60119))		
45	K29913-104		.WASHER-	C	12
			(V15653)		
			(SPEC BACW10CA104CC)		
			(OPT 70191-104		
			(V56878))		
			(OPT 922008-4		
			(V60119))		
			(OPT 942008-4		
			(V60119))		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-50	HL1187-8		.COLLAR- (V73197) (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 (V5M902)) -----*	C	12

- Item Not Illustrated

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