TO: ALL HOLDERS OF FORWARD ACCESS DOOR ASSEMBLY COMPONENT MAINTENANCE MANUAL 52-48-42

REVISION NO. 5 DATED SEP 01/95

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 1 1002,1004-1011, 1015-1025,1029-1039	Added top assemblies 141T6401-49, -50, -52 with frames 141T6419-3 and -4.
REPAIR-GEN 602-603	Moved true position dimensioning symbols reference to the text of the general repair section.

COMPONENT
MAINTENANCE MANUAL

FORWARD ACCESS DOOR ASSEMBLY

PART NUMBERS 141T6401-23,-24,-25,-27,-28, -34 THRU -37,-43,-44, -45,-46,-48,-49,-50,-52

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

T22040

REVISION RECORD

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

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

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR C20022	APR 10/82
		PRR B10307	APR 10/82
		PRR B10926	OCT 10/84
		PRR C20040	OCT 10/84
51-0006		PRR B10988	OCT 01/88
		PRR B11696	APR 01/89
52-0050			JUL 01/91

PAGE	DATE	CODE
52-48-42		
TITLE PAGE		
*1	SEP 01/95	01.1
2	BLANK	
REVISION RECORD		
1	OCT 01/87	01
2	BLANK	
TR & SB RECORD		
1	JUL 01/91	01.1
2	BLANK	
LIST OF EFFECTIVE PAGES		
*1	SEP 01/95	01
THRU LAST PAGE		
CONTENTS		
1	OCT 01/87	01
2	BLANK	
INTRODUCTION		
1	OCT 01/92	01.1
2	BLANK	
DESCRIPTION & OPERATION		
1	OCT 01/87	01
2	BLANK	
DISASSEMBLY		
301	OCT 01/87	01
302	BLANK	
CLEANING		
401	OCT 01/87	01
402	BLANK	
CHECK		
501	APR 01/89	01.1
502	APR 01/89	01.1

PAGE	DATE	CODE
REPAIR-GENERAL		
601	OCT 01/87	01
*602	SEP 01/95	01.1
*603	SEP 01/95	01.1
*604	BLANK	
REPAIR 1-1		
601	APR 01/89	01.1
602	BLANK	
REPAIR 2-1		
601	APR 01/89	01.1
602	APR 01/89	01.1
603	APR 01/89	01.1
604	BLANK	
REPAIR 3-1		
601	APR 01/89	01.1
602	APR 01/89	01.1
603	APR 01/89	01.1
604	BLANK	
REPAIR 4-1		
601	APR 01/89	01.1
602	BLANK	
REPAIR 5-1		
601	APR 01/89	01.1
602	BLANK	
ASSEMBLY		
701	APR 01/89	01.1
702	APR 01/89	01.1
703	APR 01/89	01.1
704	APR 01/89	01.1
705	APR 01/89	01.1
706	BLANK	
FITS AND CLEARANCES		
801	OCT 01/87	01
802	APR 01/89	01.1
803	APR 01/89	01.1
804	APR 01/89	01.1

* = REVISED, ADDED OR DELETED

PAGE	DATE	CODE
FITS AND CLEARANCES		CONT.
805	APR 01/89	01.1
806	BLANK	
ILLUSTRATED PARTS LIST		
1001	OCT 01/87	01
*1002	SEP 01/95	01.1
*1003	SEP 01/95	01.1
*1004	SEP 01/95	01.1
*1005	SEP 01/95	01.1
*1006	SEP 01/95	01.1
*1007	SEP 01/95	01.1
*1008	SEP 01/95	01.1
*1009	SEP 01/95	01.1
*1010	SEP 01/95	01.1
*1011	SEP 01/95	01.1
*1012	SEP 01/95	01.1
*1013	SEP 01/95	01.1
*1014	SEP 01/95	01.1
*1015	SEP 01/95	01.1
*1016	SEP 01/95	01.1
*1017	SEP 01/95	01.1
*1018	SEP 01/95	01.1
*1019	SEP 01/95	01.1
*1020	SEP 01/95	01.1
*1021	SEP 01/95	01.1
*1022	SEP 01/95	01.1
*1023	SEP 01/95	01.1
*1024	SEP 01/95	01.1
*1025	SEP 01/95	01.1
*1026	SEP 01/95	01.1
*1027	SEP 01/95	01.1
*1028	SEP 01/95	01.1
*1029	SEP 01/95	01.1
*1030	SEP 01/95	01.1
*1031	SEP 01/95	01.1
*1032	SEP 01/95	01.1
*1033	SEP 01/95	01.1
*1034	SEP 01/95	01.1
*1035	SEP 01/95	01.1
*1036	SEP 01/95	01.1
*1037	SEP 01/95	01.1
*1038	SEP 01/95	01.1

PAGE	DATE	CODE
ILLUSTRATED PARTS LIST		CONT.
*1039	SEP 01/95	01.1
*1040	BLANK	

* = REVISED, ADDED OR DELETED

TABLE OF CONTENTS

INTRODUCTION

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

This manual is divided into separate sections:

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

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

Assembly: MAR 29/91

FORWARD ACCESS DOOR ASSEMBLY

DESCRIPTION AND OPERATION

1. Description and Operation

   A. The forward access door allows access to the forward equipment bay for the purpose of maintenance and repair of equipment located in the bay. The door is fastened to the fuselage by two hinges on the aft edge and a latch pin on the forward edge. A handle assembly, located in the center of the door, releases the latch pin to allow the door to open. The door also contains four stop fitting assemblies which distribute the load on the door to the fuselage when the bay is pressurized.

2. Leading Particulars (Approximate)

   Weight -- 18 pounds
   Width -- 18 inches
   Length -- 21 inches
   Thickness -- 6 inches

DISASSEMBLY

1. Disassemble this component only as necessary to complete fault isolation, determine the serviceability of parts, perform required repairs and restore the unit to serviceable condition.

CLEANING

1. Clean all parts using standard industry practices (Ref 20-30-03).

CHECK

1. Check all parts for obvious defects in accordance with standard industry practices.

2. Magnetic particle check per 20-20-01 -- Latch pin (75, IPL Fig. 1; 65, IPL Fig. 2) and bushings (183, 227, Fig. 1; 185, 240, Fig. 2).

3. Penetrant Check per 20-20-02 -- Fittings (125, 187, 191, 231, 235, Fig. 1; 120, 190, 195, 245, 250, Fig. 2), arms (315, 320, 320A, Fig. 1; 355, 360, Fig. 2).

4. Spring (260A Fig. 1) Check

   A. Mount spring and deflect as shown in Fig. 501 verifying:

      (1) At 0.063-0.057 inch deflection, load is 0.22 pound.

      (2) At 0.103-0.097 inch deflection, load is 0.72 pound.

5. Check Drain Valve Assembly (243, IPL Fig. 1 or 260, IPL Fig. 2).

   NOTE: Do not disassemble unless necessary for repair.

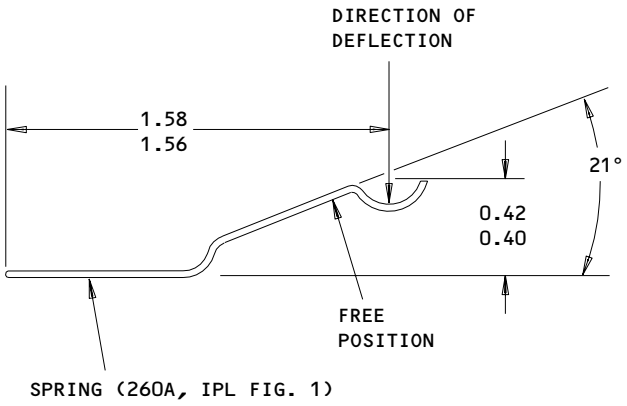
   A. Ensure spring (253 or 280) opens the valve by depressing plunger (252 or 275) with a thin rod inserted through cap (251 or 270).

   B. Check spring (253 or 280).

      (1) Apply 0.44 ±0.05 pounds max and check that length is 0.22 inches.

      (2) Apply 0.10 ±0.04 pounds min and check that length is 0.11 inches.

   C. Refer to Fits and Clearances for service wear limits.



NOTE: ASSEMBLIES 141T6401-23 THRU -37 ONLY.

Spring Check
Figure 501

13854

REPAIR - GENERAL

1. Content

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

P/N	NAME	REPAIR
141T6404	FITTING ASSY	1-1
141T6406	FITTING ASSY	2-1
141T6409	ARM ASSY	3-1
140T2810	DRAIN VALVE ASSY	4-1
- - -	MISCELLANEOUS PARTS	5-1

2. Standard Practices

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

   20-10-03 Shot Peening
   20-20-02 Penetrant Methods of Inspection
   20-30-02 Stripping of Protective Finishes
   20-30-03 General Cleaning Procedures
   20-41-01 Decoding Table for Boeing Finish Codes
   20-41-02 Application of Chemical and Solvent Resistant Finishes
   20-42-05 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. Adhesive -- type 44 (Ref 20-50-12)

   B. Enamel -- BMS 10-11 type 2, BAC702 white gloss (Ref 20-60-02)

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

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

4. Dimensioning Symbols

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

⏤	STRAIGHTNESS
▱	FLATNESS
⊥	PERPENDICULARITY (OR SQUARENESS)
//	PARALLELISM
○	ROUNDNESS
⌭	CYLINDRICITY
⌒	PROFILE OF A LINE
⌓	PROFILE OF A SURFACE
◎	CONCENTRICITY
≡	SYMMETRY
∠	ANGULARITY
↗	RUNOUT
↗↗	TOTAL RUNOUT
⌴	COUNTERBORE OR SPOTFACE
∨	COUNTERSINK

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

EXAMPLES

[⏤ | 0.002]	STRAIGHT WITHIN 0.002
[⊥ | 0.002 | B]	PERPENDICULAR TO B WITHIN 0.002
[// | 0.002 | A]	PARALLEL TO A WITHIN 0.002
[○ | 0.002]	ROUND WITHIN 0.002
[⌭ | 0.010]	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER
[⌒ | 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
[⌓ | 0.020 | A]	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE

NOTE: DATUM MAY APPEAR AT EITHER SIDE OF TOLERANCE FRAME [0.020 | A] / [A | 0.020]

[◎ | ∅ 0.0005 | C]	CONCENTRIC TO C WITHIN 0.0005 DIAMETER
[≡ | 0.010 | A]	SYMMETRICAL WITH A WITHIN 0.010
[∠ | 0.005 | A]	ANGULAR TOLERANCE 0.005 WITH A
[⌖ | ∅ 0.002 Ⓢ | B]	LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
[⊥ | ∅ 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
[2.000] OR 2.000 BSC	THEORETICALLY EXACT DIMENSION IS 2.000

True Position Dimensioning Symbols
Figure 601

T22045

FITTING ASSEMBLY - REPAIR 1-1

141T6404-1, -2, -3, -4

1. Bushings (183, 227, Fig. 1; 185, 240, Fig. 2) Replacement

   A. Remove bushings.

   B. Install bushings per 20-50-03 with wet BMS 5-95 sealant and complete flare prior to sealant cure. Flare bushings to match 30° CSK in fitting. After flaring, bushings must contact the fitting with a snug fit.

   C. Fillet seal entire periphery of bushing flange using BMS 5-95 sealant.

2. Refinish

   A. Fittings (187, 191, 231, 235, Fig. 1; 190, 195, 245, 250, Fig. 2) -- Chromic acid anodize, type 1 and apply one coat BMS 10-11, type 1 primer (F-18.13), apply one coat BMS 10-11, type 2 enamel BAC 702 white gloss (F-21.17) except omit enamel from CSK and hole for bushing. Material: Aluminum alloy.

FITTING ASSEMBLY - REPAIR 2-1

141T6406-1, -4

1. Bushing (120, 122, 123, Fig. 1; 110, 115, Fig. 2) Replacement

   A. Remove bushing.

   B. Check hole for damage or corrosion and repair if necessary per 2.

   C. Install bushing with wet primer per 20-50-03.

   D. Fillet seal around periphery of bushing flange using BMS 5-95 sealant.

2. Repair

   A. Repair hole for bushing (120, 122, 123, Fig. 1; 110, 115, Fig. 2).

      (1) Machine fitting (125, IPL Fig. 1; 120, IPL Fig. 2) as required to remove discrepancy, per Fig. 601.

      (2) Penetrant check per 20-20-02.

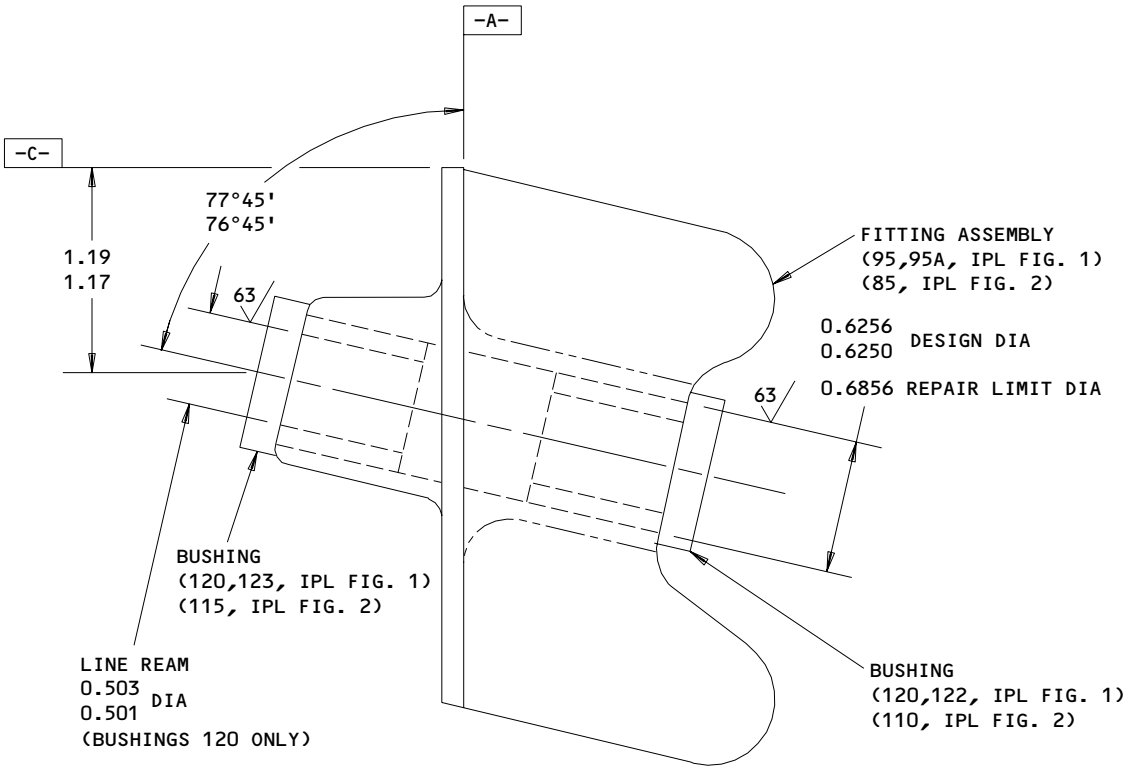
      (3) Refinish per 3.A. and 3.B.

      (4) Fabricate oversize bushing per Fig. 602.

3. Refinish

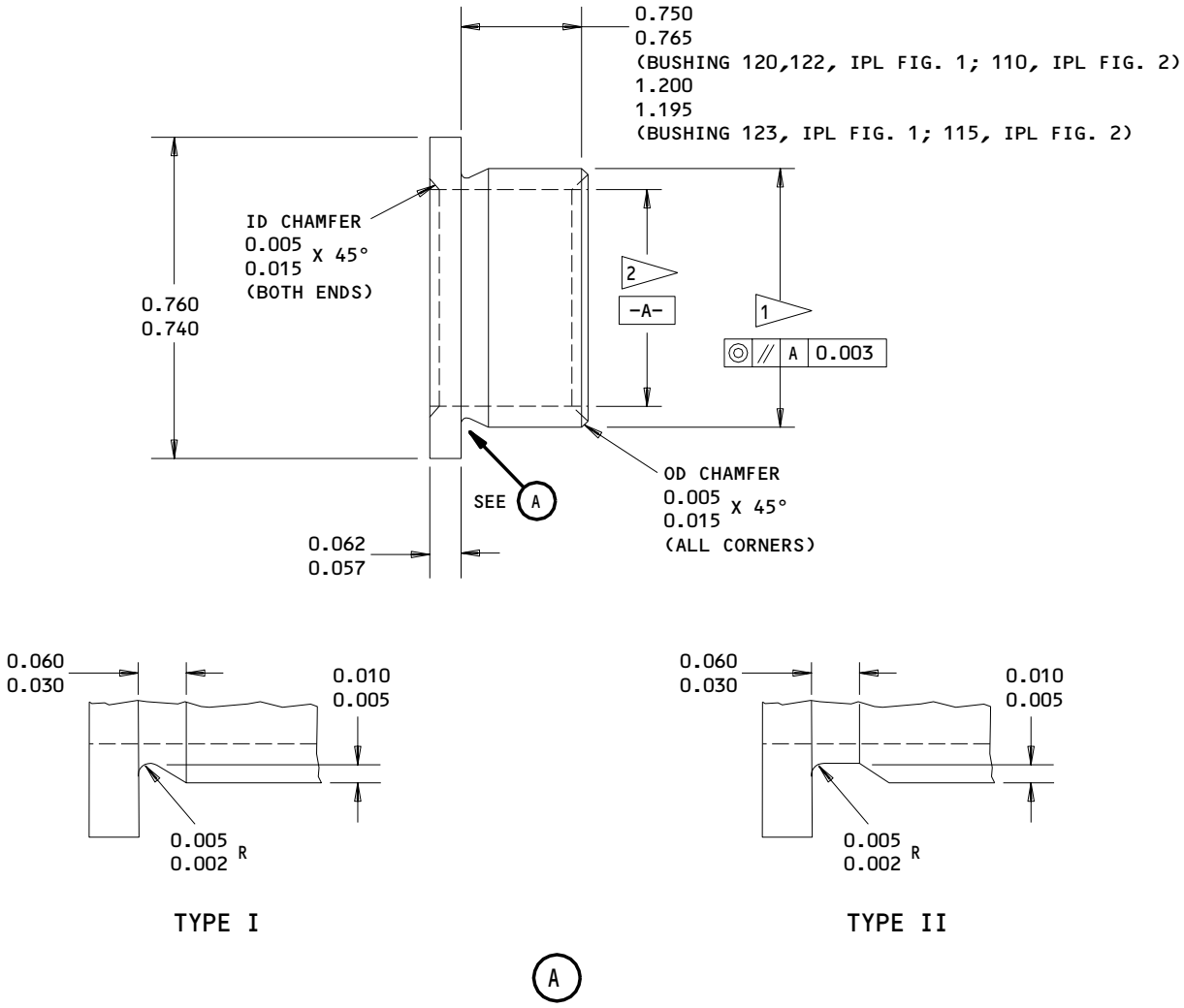
   A. Fitting (125, Fig. 1; 120, Fig. 2) -- Chromic acid anodize, type 1 and apply one coat BMS 10-11 type 1 primer (F-18.13), apply one coat BMS 10-11 type 2 enamel BAC 702 white gloss (F-21.17) per 20-41-02, except omit primer and enamel from bushing hole. Material: Aluminum alloy.

   B. Fitting assembly (95, 95A, Fig. 1; 85, Fig. 2) -- After bushing installation, apply one coat BMS 10-11 type 1 primer (F-20.02) to that surface of bushing hole not faying with bushings. Material: Aluminum alloy.



141T6406-1,-4
Fitting Assembly
Figure 601

261658



1 FINAL BUSHING OUTSIDE DIA EQUALS REPAIR DIA OF FITTING PLUS 0.0001–0.0015 INTERFERENCE

2 0.5005 / 0.4990 BUSHING 120, IPL FIG. 1 ONLY

0.5015 / 0.5000 BUSHINGS 122,123, IPL FIG. 1; 110,115, IPL FIG. 2 ONLY

PENETRANT CHECK PER 20–20–02

ALL DIMENSIONS ARE IN INCHES

DIMENSIONS APPLY AFTER PLATING

63 ALL MACHINED SURFACES, EXCEPT AS NOTED

MATERIAL: AL–NI–BRZ PER AMS 4640

FINISH: CADMIUM PLATE PER QQ–P–416, TYPE 2, CLASS 2 NO PLATING ON BUSHING BORE ALLOWED

REPLACEMENT BUSHING FOR BUSHING (120,122,123, IPL FIG. 1; 110,115, IPL FIG. 2)

Oversize Bushing Details
Figure 602

ARM ASSEMBLY - REPAIR 3-1

141T6409-1, -2, -8

1. Bushing (310, IPL Fig. 1; 350, IPL Fig. 2) Replacement

   A. Remove bushing.

   B. Check hole for damage or corrosion and repair if necessary per 2.

   C. Install bushing with wet primer per 20-50-03.

2. Repair

   A. Repair hole for bushing (310, Fig. 1; 350, Fig. 2)

      (1) Machine arm (315, 320, 320A, Fig. 1; 355, 360, Fig. 2) as required to remove discrepancy, per Fig. 601.

      (2) Penetrant check per 20-20-02

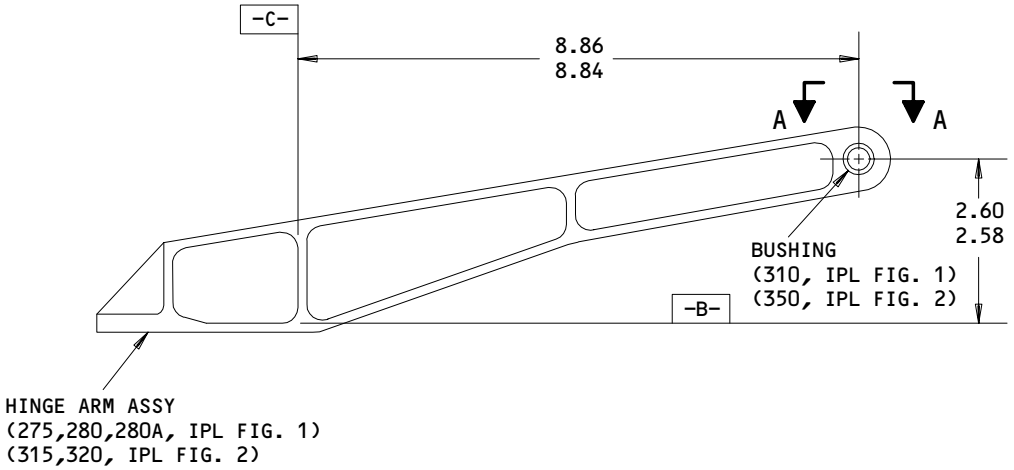
      (3) Shot-peen bore per 20-10-03 and Fig. 601.

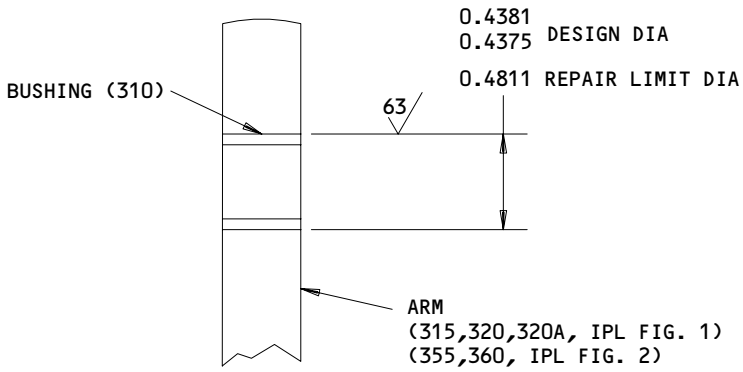
      (4) Refinish per 3.A.

      (5) Fabricate oversize bushing per Fig. 602.

3. Refinish

   A. Arms (315, 320, 320A, Fig. 1; 355, 360, Fig. 2) -- Chromic acid anodize, type 1 and apply one coat BMS 10-11 type 1 primer (F-18.13), apply one coat BMS 10-11 type 2 enamel BAC 702 white gloss (F-21.17) per 20-41-02 except omit primer and enamel from bushing hole and omit enamel from serrations. Material: Aluminum alloy.





A-A

REFINISH

SEE 3.A.

REPAIR

SHOT PEEN: 0.023-0.055 SHOT SIZE
0.006 A INTENSITY
2.0 COVERAGE

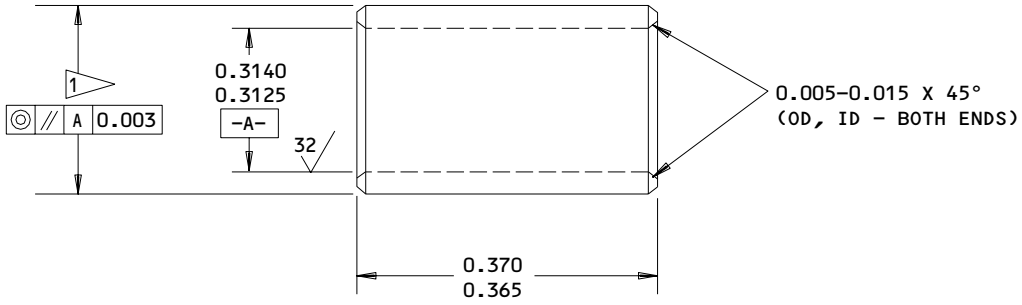
MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

141T6409-1,-2,-8

Hinge Arm Assembly
Figure 601

261663



1 FINISH BUSHING OUTSIDE DIA EQUALS REPAIR DIA OF ARM PLUS 0.0001-0.0011 INTERFERENCE

ALL DIMENSIONS ARE IN INCHES

DIMENSIONS APPLY AFTER PLATING

63 ALL MACHINED SURFACES, EXCEPT AS NOTED

MATERIAL: AL-NI-BR PER AMS 4640

FINISH: CAD PLATE PER 20-42-05, TYPE 2, CLASS 2

REPLACEMENT BUSHING FOR BUSHING (310, IPL FIG.1; 350, IPL FIG. 2)

Oversize Bushing Details
Figure 602

261665

DRAIN VALVE ASSEMBLY - REPAIR 4-1

140T2810-6

NOTE: To ease maintenance of installed drain valves, assembly 140T2810-6 should be replaced with assembly 140N2022-1 per SB 51-0006.

1. Spring Valve Assembly (255A) Replacement (IPL Fig. 1)

   A. Remove old spring valve assembly from cover (250).

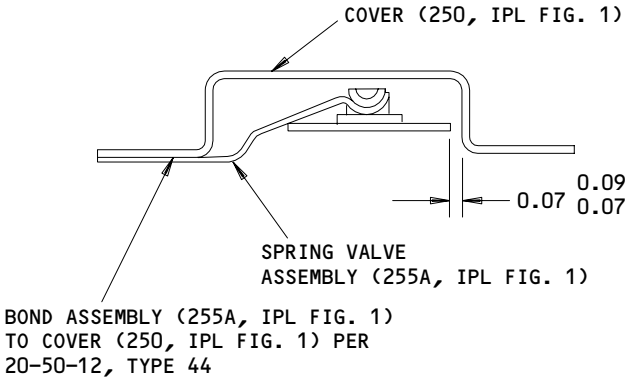
   B. Clean cover completely of old bonding material.

   C. Bond spring valve assembly to cover per Fig. 601.

2. Refinish

   A. Cover (250) -- Apply one coat BMS 10-11 type 2 enamel, BAC 702 white gloss (F-21.03) all over. Material: Al alloy.

   B. Spring (260A) -- Prepare surface and passivate, type 2 (F-17.09) all over. Material: 17-7PH CRES, 180-200 ksi.



NOTE: ASSEMBLIES 141T6401-23 THRU -37 ONLY.

ALL DIMENSIONS ARE IN INCHES

Spring Valve Assembly Replacement
Figure 601

MISCELLANEOUS PARTS - REPAIR 5-1

1. Repair of these parts consists of restoration of original finish.

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1 and 2		
Forward Access Door Assy (1B,1C,1D,1E, 1F,1G,1H,1J,1K,1L, 1M,1N)		Refinish exterior surface per operators standard color scheme using BMS 10-11 type 2 enamel.
Strap (5,15, Fig. 1; 10,20, Fig. 2), Skin-inner (40, Fig. 1; 30, Fig. 2), Filler (340, 345, Fig. 1; 380, 385, Fig. 2)	Aluminum alloy	Chemically treat (colored film) and apply one coat BMS 10-11 type 1 primer per 20-41-02 (F-18.06), apply one coat BMS 10-11 type 2 enamel BAC 702 white gloss. When painting assemblies, coating thickness requirements only apply to surfaces covered by normal spray techniques (F-21.17), all over.
Link-latch (50,50A, Fig. 1; 60, Fig. 2)	Aluminum alloy	Chemically treat (colored film) and apply one coat BMS 10-11 type 1 primer per 20-41-02 (F-18.06). Apply one coat BMS 10-11 type 2 enamel, BAC 702 white gloss per 20-41-02 (F-21.03).
Pin latch (75,75A, Fig. 1; 65, Fig. 2)	15-5PH CRES 180-200 ksi	Prepare surface and passivate, type 2 (F-17.09), all over.
Plate (330,335, Fig. 1; 370,375, Fig. 2)	Aluminum alloy	Chromic acid anodize, type 1 and apply one coat BMS 10-11 type 1 primer per 20-41-02 (F-18.13). Apply one coat BMS 10-11 type 2 enamel, BAC 702 white gloss per 20-41-02 (F-21.03). Omit enamel from holes and serrations.

Refinish Details
Figure 601

ASSEMBLY

1. Materials

NOTE: Equivalent substitutes may be used.

A. Grease -- MIL-G-23827 (Ref 20-60-03)

B. Lockwire -- MS20995NC32-10

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

D. Liquid Soap Lubricants (Ref 20-60-01)

(1) Kelite Spraywhite

(2) Turco 1526

(3) GMC 528B

E. Enamel -- BMS 10-11 type 2, color 701 black gloss (Ref 20-60-04)

F. Adhesive -- Loctite 416 or Loctite 495

2. Assembly (IPL Fig. 1 or Fig. 2)

A. Use standard industry practices for assembly of this component, and the following additional procedures.

B. Use quantity of spacers (72 or 45) as required to eliminate the rotational "free play" of the latch pin.

C. Apply a faying surface seal using BMS 5-95 between outer skin and handle assembly (130, Fig. 1), also between valve assembly (240, Fig. 1) and outer skin.

D. Lubricate latch pin (75 or 65) with MIL-G-23827 grease and install such that flat on end is oriented to centerline of handle assembly as shown in Fig. 701.

E. Adjust linkage on handle assembly (130, Fig. 1) to maintain dimension shown on Fig. 701.

F. Lockwire nut (80 or 70) to rod end lockwasher (85A or 75).

G. Wind the torsion spring on the handle assembly (130E; assembly 141T6401-45 only) (Fig. 702).

H. Use of NAS1398M5 blind rivets through inner skin (40 or 30) is optional to rivet (45 or 25) at locations inaccessible.

I. Install seal (810A, Fig. 1) as follows:

NOTE: Seal may be installed with liquid soap lubricants.

(1) Place seal on door with sealing lip faced outboard and the side of seal marked -FWD- on the forward side.

(2) Locate seal approximately over retainer stretching seal uniformly.

(3) Insert 2 or 3 inches of seal into each corner of retainer as follows:

(a) First slip lower lip of seal base into lower flange of retainer.

(b) Using round edged tool force upper lip of base into retainer.

NOTE: Push normal to seal to avoid bunching or sliding.

(4) Install 2 or 3 inches of seal at door centerlines on all sides as described in step (3).

(5) Complete installation working from centerline of each side to corners.

(6) Waviness up to 0.10 inch wave height is permissible as measured at sealing surface of seal lip.

(7) Wrinkles must be eliminated by redistributing seal elongation more uniformly in retainer.

NOTE: Seal will be adjusted after installation of door on airplane.

J. Restencil ID No. 113AL on either outboard edge of door assembly (1). Use BMS 10-11 type 2 enamel BAC 701 black gloss making characters 0.50 inch high. Stencil should not be applied over bolt or rivet heads.

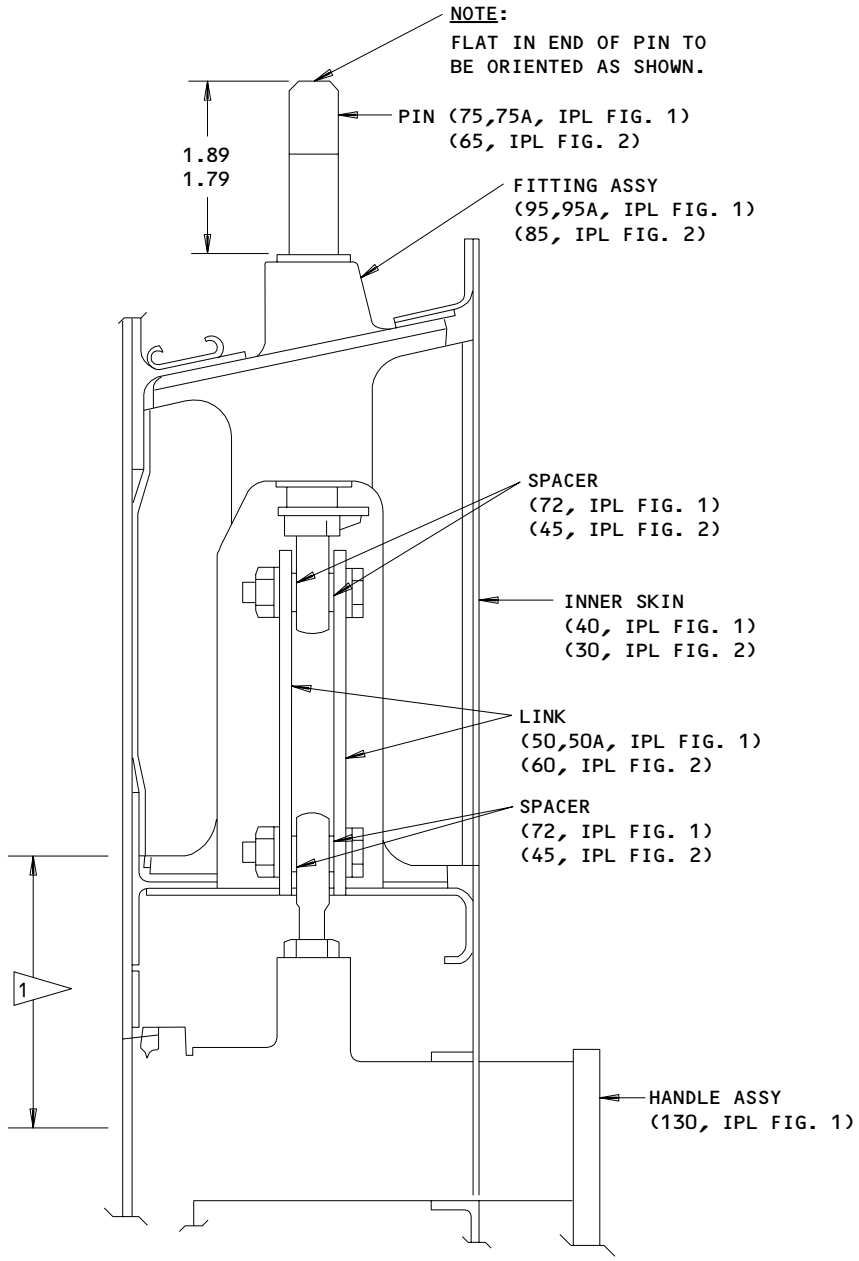
K. Install retainer (237 or 255) with sealant, BMS 5-95 on faying surfaces.

NOTE: Do not bond plunger (252 or 275) to housing (254 or 285) or cap (251 or 270).

L. Bond cap (251 or 270) to housing (254 or 285) with LOCTITE 495 or LOCTITE 416 per manufacturer's instructions. Verify operation by manually depressing plunger (252 or 275) after bond has set up.

CAUTION: EXCESSIVE TIGHTENING OF VALVE ASSEMBLY (243 or 260) WILL CAUSE HOUSING'S (254 or 285) FLANGE TO CRACK OR BREAK.

M. Install drain valve assembly (243 or 260) from outside of airplane until flange of housing (254 or 285) is snug with skin.

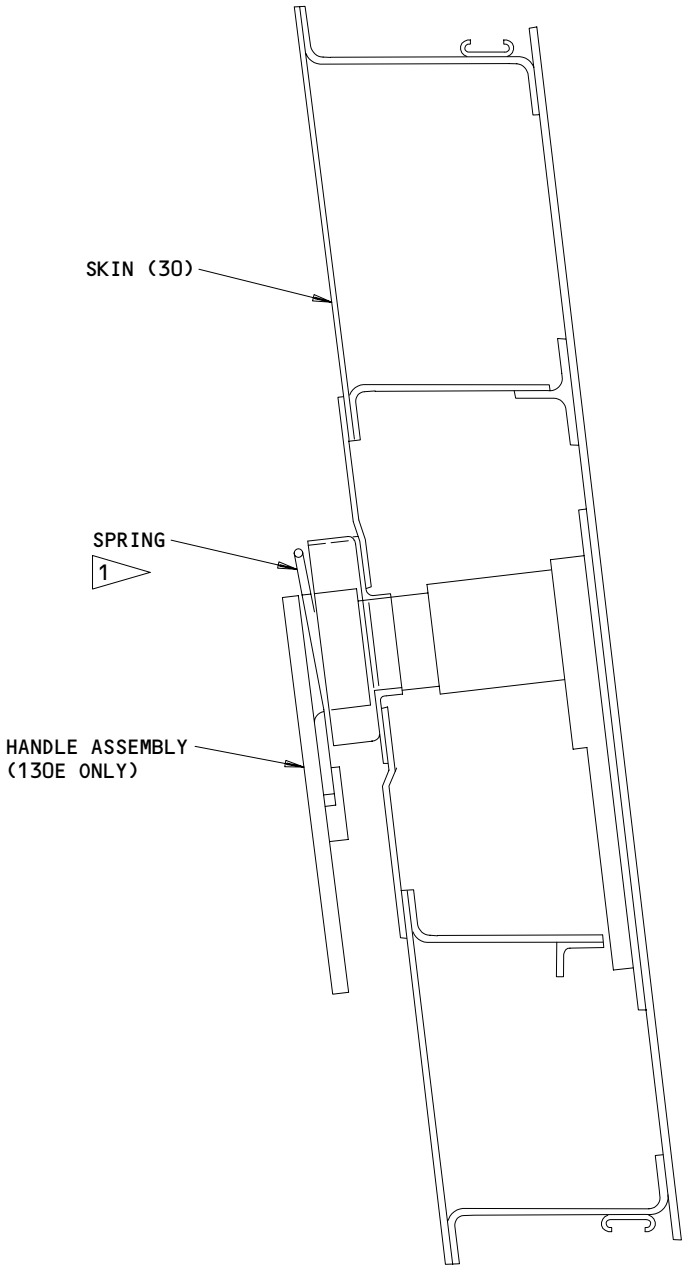


1 ADJUST LINKAGE TO MAINTAIN DIMENSION SHOWN ON PIN (75,75A, IPL FIG. 1; 65, IPL FIG. 2)

ALL DIMENSIONS ARE IN INCHES

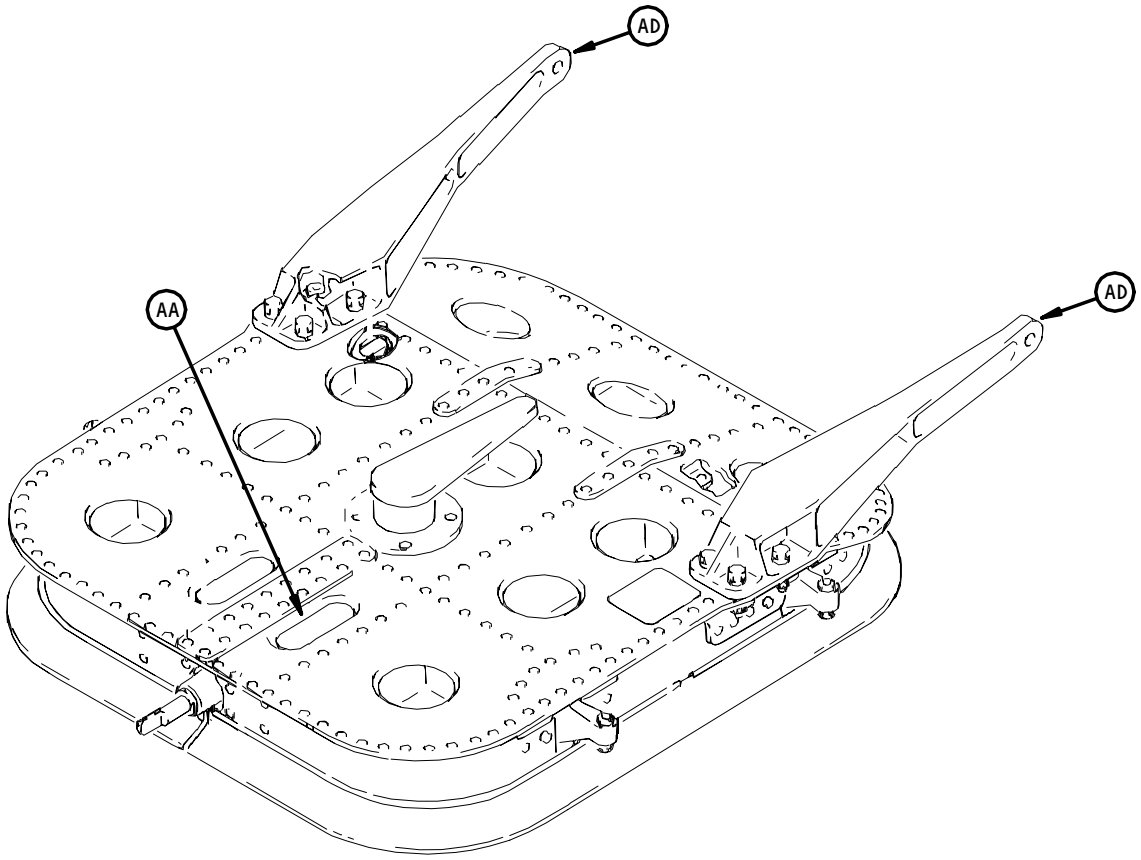
Adjustment of Latch Pin
Figure 701

12423

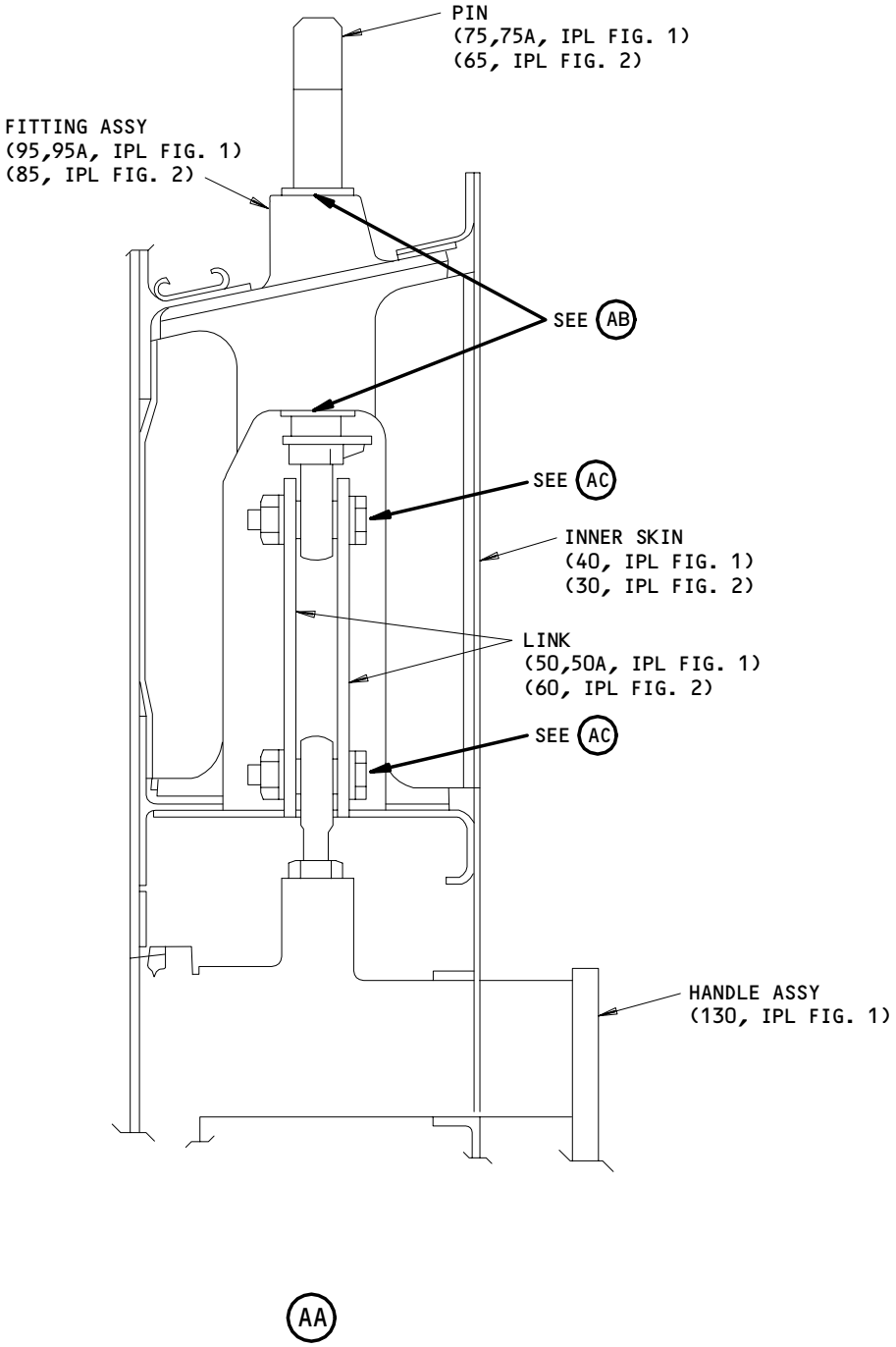


1 WIND TORSION SPRING APPROXIMATELY 270 DEGREES FROM FREE POSITION. SPRING WILL FORCE HANDLE TOWARDS LATCHED POSITION WHEN CORRECTLY INSTALLED. (141T6401-45 ASSEMBLY ONLY)

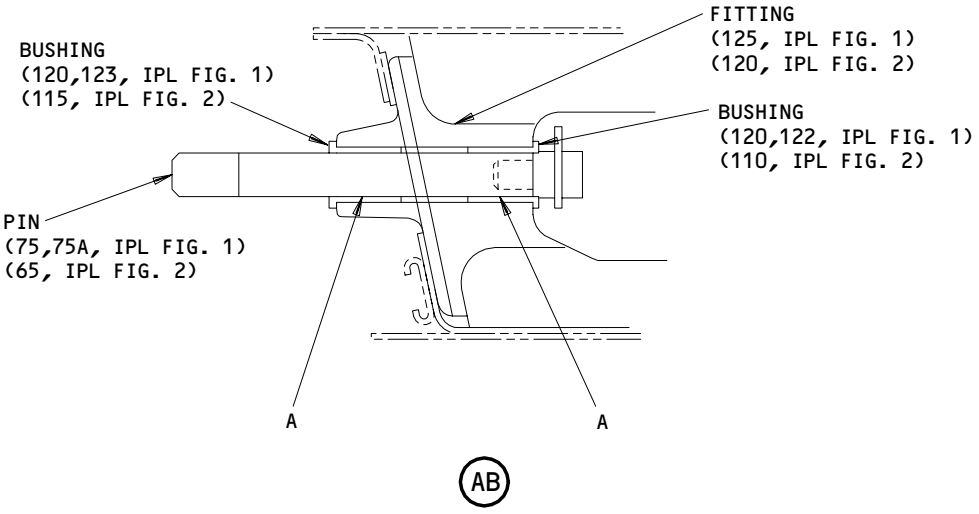
Adjustment of Handle Assembly
Figure 702

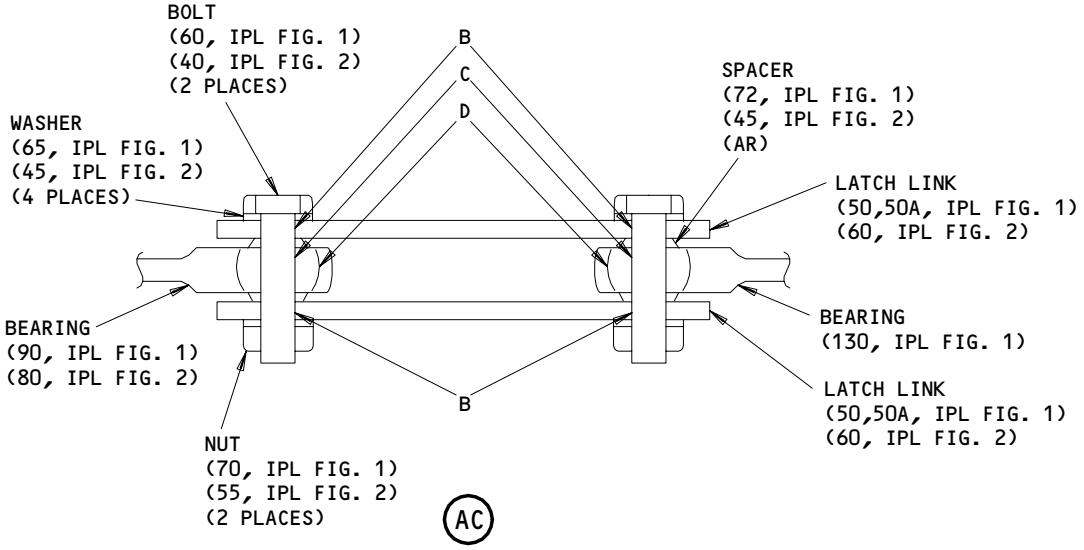


Fits and Clearances
Figure 801 (Sheet 1)

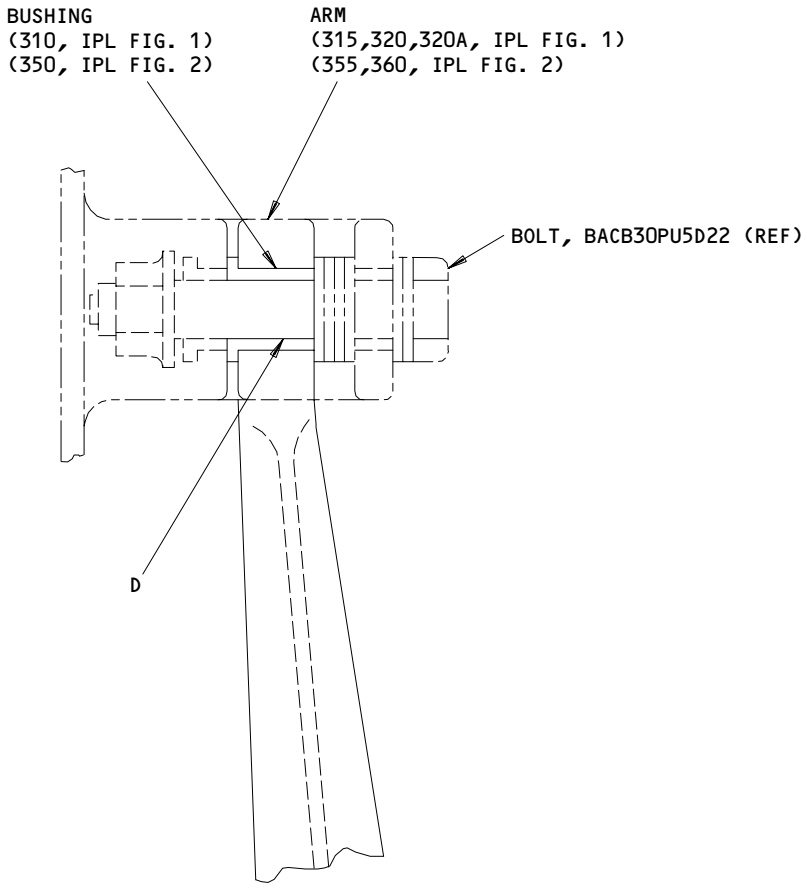


Fits and Clearances
Figure 801 (Sheet 2)





Fits and Clearances
Figure 801 (Sheet 3)



AD

Fits and Clearances
Figure 801 (Sheet 4)

263784

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 120,122, 123	1	0.5010	0.5030	0.0010	0.0070	0.4870	0.5140	0.0140
	110,115	2							
	OD 75,75A	1	0.4960	0.5000					
	65	2							
B	ID 50,50A	1	0.2500	0.2540	0.0005	0.0055	0.2390	0.2605	0.0110
	60	2							
	OD 60	1	0.2485	0.2495					
	40	2							
C	ID 90,130D	1	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
	80	2							
	OD 60	1	0.2485	0.2495					
	40	2							
D	ID 1	1	----	----	0.0000	0.0000	----	----	0.0160
	OD 1	1	----	----					
E	ID 310	1	0.3125	0.3140	0.0005	0.0025	0.3075	0.3170	0.0050
	350	2							
	OD 2	1	0.3115	0.3120					

1 TOTAL RADIAL PLAY BETWEEN SPHERICAL BALL AND BEARING RACE SHALL NOT EXCEED 0.016

2 BOLT, BACB30PU5D22 (REF)

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 5)

261657

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

0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SPO BOX 18459 KEARNS, UTAH 84118
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932
10630	ANILLO INDUSTRIES, INCORPORATED 2090 NORTH GLASSELL ORANGE, CALIFORNIA 92667
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157
11960	HASKON CORPORATIONS 336 WEIR STREET PO BOX 1091 TAUNTON, MASSACHUSETTS 02780
15653	KAYNAR TECHNOLOGY KAYNAR DIV 800 SOUTH STATE COLLEGE BLVD PO BOX 3001 FULLERTON, CALIFORNIA 92634-3001
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
60516	WEST COAST AEROSPACE INC 812 MIRAFLORES STREET SAN PEDRO, CALIFORNIA 90731-1439
72962	ELASTIC STOP NUT A DIV OF HARTFORD INDUSTRIES INC 2330 VAUXHALL ROAD UNION, NEW JERSEY 07083-5038
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

VENDORS

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

92215 FAIRCHILD IND INC FAIRCHILD AEROSP FASTNR DIV DESIGN & ENGRG
3000 WEST LOMITA BLVD
TORRANCE, CALIFORNIA 90505-5102

92595 AUTOMATIC SCREW MACHINE PRODUCTS CO
PO BOX 1608 709 2ND AVENUE SE
DECATUR, ALABAMA 35602

97928 DEUTSCH FASTENER CORP
3969 PARAMONT BOULEVARD
LAKEWOOD, CALIFORNIA 90712-4193

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN960KD4		1	249	2
BACB28X8M075		1	120	2
		1	122	1
		2	110	1
BACB28X8M120		1	123	1
		2	115	1
BACB28Y5M037		1	310	2
		2	350	2
BACB30MY5K4		1	152	4
		2	140	4
BACB30MY6K4		1	211	4
		2	220	4
BACB30MY6K7		1	160	2
		1	207	4
		2	150	2
		2	215	4
BACB30NM4K11		1	285	2
		2	325	2
BACB30NM4K12		1	290	4
		2	330	4
BACB30NM4K14		1	295	2
		2	335	2
BACB30NR4DK12		1	60	2
		2	40	2
BACB30NR4DK13		2	42	1
BACB30NR4DK14		2	43	1
BACB30NW5K4		1	175	2
		1	219	4
		2	175	2
		2	230	4
BACB30NW6K4		1	167	2
		2	160	2
BACB30NW6K7		1	170	2
		2	165	2
BACB30NX6K4		1	110	4
		2	100	4
BACB30VT5K4		2	140A	4
BACB30VT6K4		2	220A	4
BACB30VT6K7		2	150A	2
		2	215A	4
BACB30VU5K4		2	175A	2
		2	230A	4
BACB30VU5K6		2	56	2
BACB30VU6K4		2	160A	2
BACB30VU6K7		2	165A	2
BACC30AG5		1	156	4
		2	145	4

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACC30AG6		1	164	2
		1	215	8
		2	155	2
		2	225	8
BACC30BQ5		2	145A	4
		2	180A	2
		2	235A	4
BACC30BQ6		2	155A	2
		2	170A	4
		2	225A	8
BACC30BS5		2	56H	2
BACC30M5		1	179	2
		1	223	4
		2	180	2
		2	235	4
BACC30M6		1	171	4
		2	170	4
BACC30X6		1	115	4
		2	105	4
BACF3T01A13G10		1	18	1
BACN10JD4		2	55A	2
BACN10JD4AU		1	70	2
		2	55	2
BACN10JR3F		1	35	4
BACR15BA3AD		1	36	8
BACR15CE4AD		1	248A	2
BACR15CE4KE		1	245	4
		1	248	2
		2	265	2
BACR15CE5KE		1	100	2
		1	135	16
BACR15CE5KE		2	90	2
BACR15CE6KE		1	325	4
		2	365	4
BACR15FT5KE		1	10	10
		1	20	18
		1	45	181
		1	105	6
		2	5	10
		2	15	18
		2	25	181
		2	95	6
BACR15FT6KE		1	148	18
		1	203	18
		2	135	18
		2	210	18
BACW10P203AM		2	47	3

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACW10P227TF		2	52	2
BRF200A3		1	35	4
B30NW5K4		1	175	2
		1	219	4
		2	175	2
		2	230	4
B30NW6K4		1	167	2
		2	160	2
B30NW6K7		1	170	2
		2	165	2
F5000-3BAC		1	35	4
HL10VAZ5-4		1	152	4
		2	140	4
HL10VAZ6-4		1	211	4
		2	220	4
HL10VAZ6-7		1	160	2
		1	207	4
		2	150	2
		2	215	4
HL11VAZ5-4		1	175	2
		1	219	4
		2	175	2
		2	230	4
HL11VAZ6-4		1	167	2
		2	160	2
HL11VAZ6-7		1	170	2
		2	165	2
HL11V6-4		1	167	2
		2	160	2
HL11V6-7		1	170	2
		2	165	2
HL1187-6		1	115	4
		2	105	4
HL12-4		1	110	4
		2	100	4
HL12VAZ6-4		1	110	4
		2	100	4
HL70-5		1	179	2
		1	223	4
		2	180	2
		2	235	4
HL79-6		1	171	4
		2	170	4

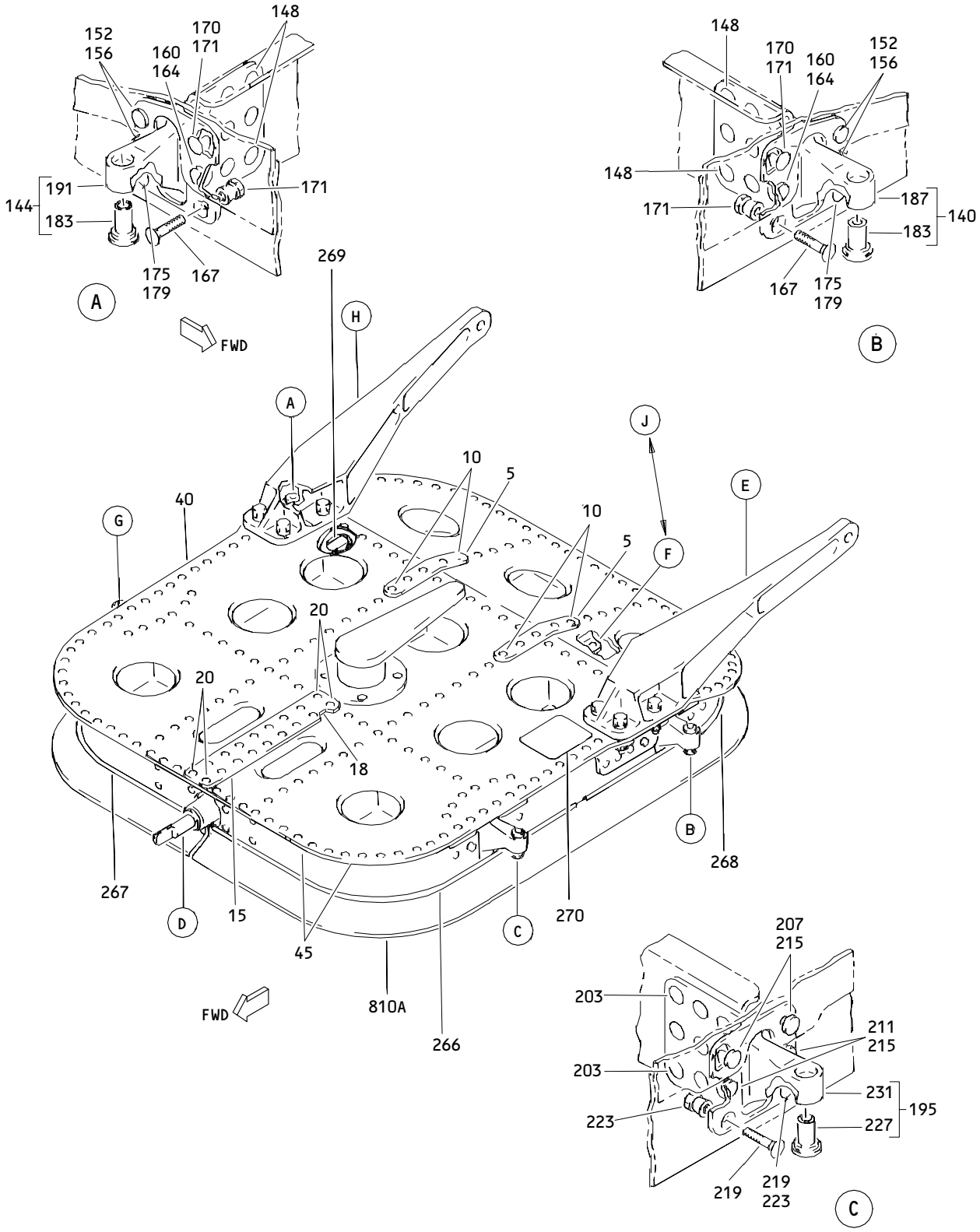
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL82-5APBW		1	156	4
		2	145	4
HL82-6APBW		1	164	2
		1	215	8
		2	155	2
		2	225	8
HL87-6		1	115	4
		2	105	4
HST10AG5-4		2	140A	4
HST10AG6-4		2	220A	4
HST10AG6-7		2	150A	2
		2	215A	4
HST1094KP5		2	56H	2
HST11AG5-4		2	175A	2
		2	230A	4
HST11AG5-6		2	56	2
HST11AG6-4		2	160A	2
HST11AG6-7		2	165A	2
HST825AW		2	145A	4
		2	180A	2
		2	235A	4
HST826AW		2	155A	2
		2	170A	4
		2	225A	8
H2860-13		1	130E	1
L802-6K4		1	110	4
		2	100	4
L803-5K4		1	175	2
		1	219	4
		2	175	2
		2	230	4
L803-6-4		1	167	2
		2	160	2
L803-6-7		1	170	2
		2	165	2
L803-6K4		1	167	2
		2	160	2
L803-6K7		1	170	2
		2	165	2
MS21242S4K		1	90	1
		2	80	1
MS24665-153		1	55	2
		2	35	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
MS27253F3		1	270	1
NAS1149C0463R		1	65A	4
		2	50A	4
NAS1149D0363J		1	30A	4
NAS1149F0463P		1	300A	16
		2	340A	16
NAS1193K5C		1	85A	1
		2	75	1
NAS1423-5		1	80	1
		2	70	1
NAS1805-4		1	305	8
		2	345	8
NAS623-3-2		1	25	4
NS103203-02		1	35	4
RMF9201-3		1	35	4
S140T263-5		1	810A	1
S141T640-3		1	130D	1
S141T640-5		1	130E	1
T8091S1032		1	35	4
VN152A1-02		1	35	4
140N2020-1		1	253	1
		2	280	1
140N2021-1		1	237	1
		2	255	1
140N2022-1		1	243	1
		2	260	1
140N2022-2		1	254	1
		2	285	1
140N2022-3		1	252	1
		2	275	1
140N2022-4		1	251	1
		2	270	1
140T2810-6		1	240	1
140T2810-7		1	250	1
140T6401-47		1	40B	1
141T6322-1		1	50A	2
		2	60	2
141T6401-23		1	1B	RF
141T6401-3		1	15	1
		2	20	1
141T6401-34		1	1G	RF
141T6401-51		1	137	1
141T6401-52		1	1T	RF

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T6401-53		1	137A	1
141T6401-7001		1	3	1
		2	1	RF
141T6401-7002		1	3A	1
		2	1A	RF
141T6404-1		1	140	1
		2	125	1
141T6404-2		1	144	1
		2	130	1
141T6404-3		1	195	1
		2	200	1
141T6404-4		1	199	1
		2	205	1
141T6404-5		1	187	1
		2	190	1
141T6404-6		1	191	1
		2	195	1
141T6404-7		1	231	1
		2	245	1
141T6404-8		1	235	1
		2	250	1
141T6406-1		1	95	1
141T6406-2		1	125	1
		2	120	1
141T6406-4		1	95A	1
		2	85	1
141T6407-1		1	75	1
		2	65	1
141T6408-1		1	183	2
		1	227	2
		2	185	2
		2	240	2
141T6409-1		1	275	1
141T6409-1		2	315	1
141T6409-10		1	320	1
		2	360A	1
141T6409-2		1	280A	1
		2	320	1
141T6409-3		1	315	1
		2	355	1
141T6409-4		1	320A	1
		2	360	1
141T6409-501		1	315A	1
		2	355A	1

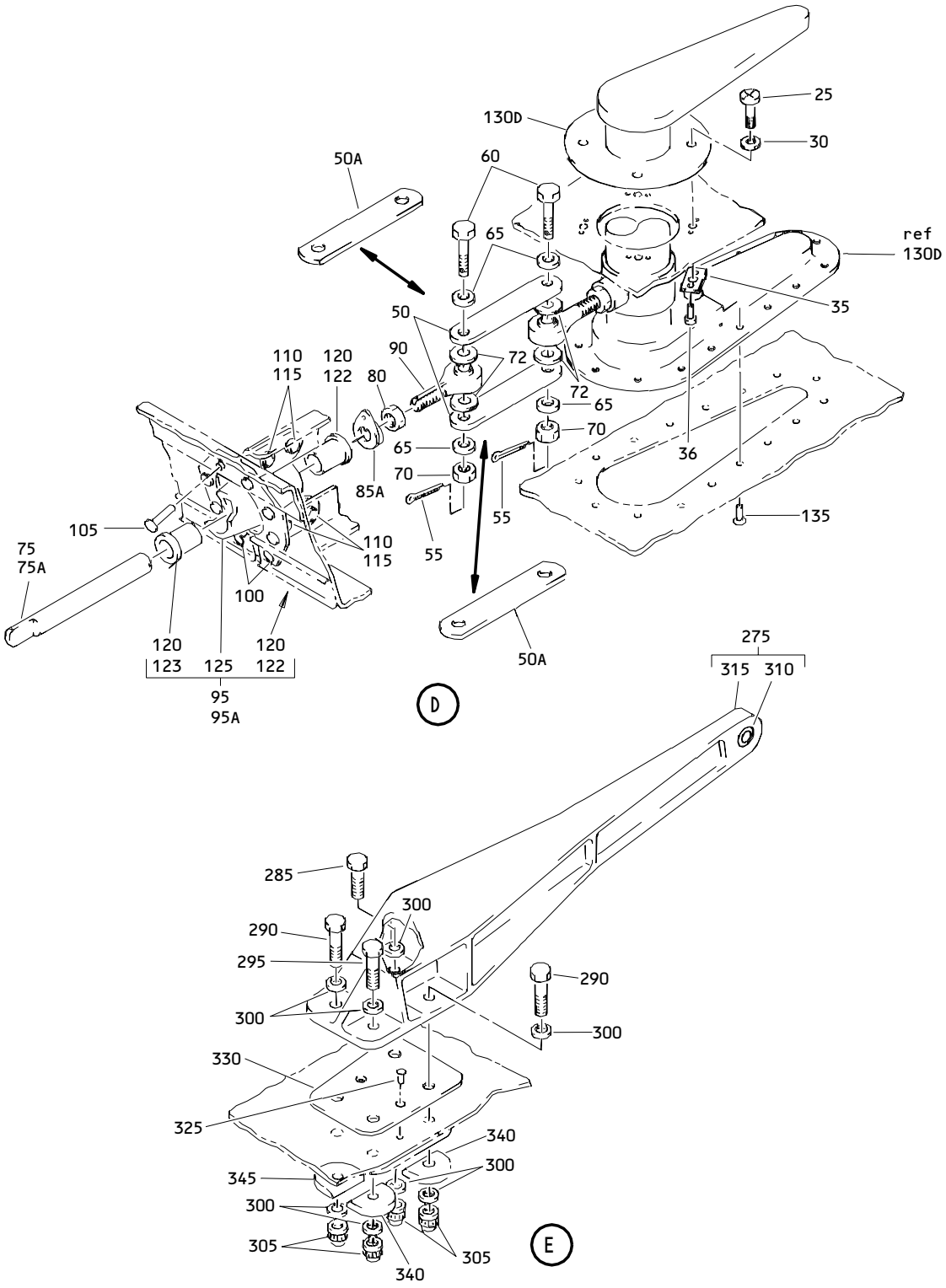
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T6409-8		1	280	1
141T6414-3		1	330	1
		2	370	1
141T6414-4		1	335	1
		2	375	1
141T6420-1		1	266	1
		2	290	1
141T6420-2		1	267	1
		2	295	1
141T6420-3		1	268	1
		2	300	1
141T6420-4		1	269	1
		2	305	1
141T6421-1		1	50	2
141T6422-29		1	5	2
		2	10	2
141T6422-30		1	340	4
		2	380	4
141T6422-33		1	345	2
		2	385	2
141T6422-36		1	40	1
		2	30	1
141T6422-43		2	57	1
141T6422-44		2	59	1
141T6422-45		2	58	1
141T6422-48		1	40C	1
141T6423-1		1	72	12
		2	45	12
66014-5		1	179	2
		1	223	4
		2	180	2
		2	235	4
66014-6		1	171	4
		2	170	4

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
69-68855-3		1	255A	1
69-68855-4		1	260A	1
69-68856-1		1	265	1
8304-5		1	810A	1



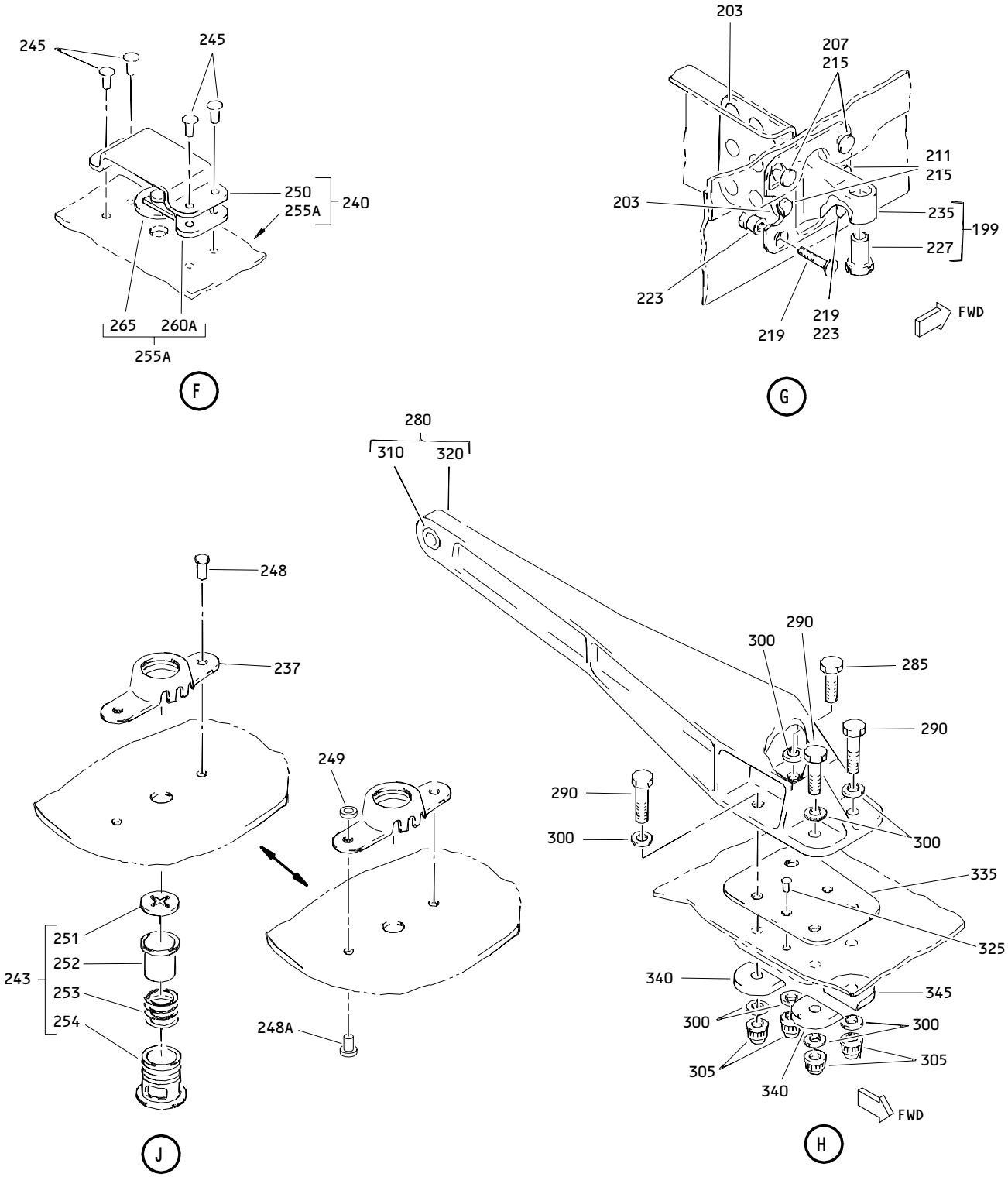
Forward Access Door Assembly
Figure 1 (Sheet 1)

T59230



Forward Access Door Assembly
Figure 1 (Sheet 2)

T82899



Forward Access Door Assembly
Figure 1 (Sheet 3)

T93609

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-1B	141T6401-23		DOOR ASSY-FWD ACCESS (FOR SPARES PROCURE 141T6401-33)	A	RF
	-1C	141T6401-24		DOOR ASSY-FWD ACCESS (FOR SPARES PROCURE 141T6401-31)	B	RF
	-1D	141T6401-25		DOOR ASSY-FWD ACCESS	C	RF
	-1E	141T6401-27		DOOR ASSY-FWD ACCESS	D	RF
	-1F	141T6401-28		DOOR ASSY-FWD ACCESS	E	RF
	-1G	141T6401-34		DOOR ASSY-FWD ACCESS (REWORK)	F	RF
	-1H	141T6401-35		DOOR ASSY-FWD ACCESS (REWORK)	G	RF
	-1J	141T6401-36		DOOR ASSY-FWD ACCESS (REWORK)	H	RF
	-1K	141T6401-37		DOOR ASSY-FWD ACCESS (REWORK)	J	RF
	-1L	141T6401-43		DOOR ASSY-FWD ACCESS	K	RF
	-1M	141T6401-44		DOOR ASSY-FWD ACCESS	L	RF
	-1N	141T6401-45		DOOR ASSY-FWD ACCESS	M	RF
	-1P	141T6401-46		DOOR ASSY-FWD ACCESS (REWORK)	N	RF
	-1Q	141T6401-48		DOOR ASSY-FWD ACCESS	P	RF
R	-1R	141T6401-49		DOOR ASSY-FWD ACCESS	Q	RF
R	-1S	141T6401-50		DOOR ASSY-FWD ACCESS	R	RF
R	-1T	141T6401-52		DOOR ASSY-FWD ACCESS	S	RF
	-3	141T6401-7001		.COLLECTOR-COMMON PART (FOR DETAILS SEE FIG. 2)	M	1
	-3A	141T6401-7002		.COLLECTOR-COMMON PART (FOR DETAILS SEE FIG. 2)	P-S	1
	5	141T6422-29		.STRAP ATTACHING PARTS	A-L	2
	10	BACR15FT5KE		.RIVET- (SIZE DETERMINE ON INST) -------*-------	A-L	10
	15	141T6401-3		.STRAP ATTACHING PARTS	A-L,N	1
	18	BACF3T01A13G10		.FILLER	A,B,F,G,N	1
	20	BACR15FT5KE		.RIVET- (SIZE DETERMINE ON INST) -------*-------	A-L,N	18
	25	NAS623-3-2		.SCREW	A-L	4
	-25A	NAS623-3-3		.SCREW	M-S	4
	30	AN960PD10		DELETED		

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	30A	NAS1149D0363J		.WASHER		4
	35	F5000-3BAC		.NUTPLATE-		4
				(V15653)		
				(SPEC BACN10JR3F)		
				(OPT NS103203-02		
				(V80539))		
				(OPT RMF9201-3		
				(V72962))		
				(OPT T8091S1032		
				(V11815))		
				(OPT VN152A1-02		
				(V92215))		
				(OPT BRF200A3		
				(V52828))		
				ATTACHING PARTS		
	36	BACR15BA3AD		.RIVET-		8
				(SIZE DETERMINE ON INST)		
				-------*-------		
	40	141T6422-36		.SKIN-INNER	A-K	1
	-40A	141T6422-42		.SKIN-INNER	L,P,Q,S	1
	-40B	140T6401-47		.SKIN-INNER	N	1
R	-40C	141T6422-48		.SKIN-INNER	R	1
				ATTACHING PARTS		
	45	BACR15FT5KE		.RIVET-	A-L, N-S	181
				(SIZE DETERMINE ON INST)		
				-------*-------		
	50	141T6421-1		.LINK-LATCH	A-C, F-J	2
	50A	141T6322-1		.LINK-LATCH	D,E,K,L,N	2
				ATTACHING PARTS		
	55	MS24665-153		.PIN-COTTER	A-L,N	2
	60	BACB30NR4DK12		.BOLT	A-L,N	2
	65	AN960C416		DELETED		
R	65A	NAS1149C0463R		.WASHER	A-L,N	4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
70	BACN10JD4AU		.NUT- (V15653) (SPEC BACN10JD4AU) (OPT BACN10JD4AU (V56878)) (OPT BACN10JD4AU (V72962)) (OPT BACN10JD4AU (V92595)) -------*-------	A-L,N	2
72	141T6423-1		.SPACER	C-E, H-L,N	AR
75	141T6407-1		.PIN-LATCH	A-C, F-H	1
75A	141T6407-2		.PIN-LATCH	D,E, J-L,N	1
80	NAS1423-5		.NUT	A-L,N	1
85A	NAS1193K5C		.LOCKING DEVICE	A-L,N	1
90	MS21242S4K		.BEARING	A-L,N	1
95	141T6406-1		.FITTING ASSY-LATCH	A-K	1
95A	141T6406-4		.FITTING ASSY-LATCH ATTACHING PARTS	L,N	1
100	BACR15CE5KE		.RIVET- (SIZE DETERMINE ON INST)	A-L,N	2
105	BACR15FT5KE		.RIVET- (SIZE DETERMINE ON INST)	A-L,N	6
110	HL12VAZ6-4		.BOLT- (V56878) (SPEC BACB30NX6K4) (OPT HL12VAZ6-4 (V73197)) (OPT HL12VAZ6-4 (V92215)) (OPT HL12VAZ6-4 (V97928)) (OPT L802-6K4 (V06725)) (OPT HL12-4 (V06725))	A-L,N	4

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	115	HL1187-6		.COLLAR-	A-L,N	4
				(V73197)		
				(SPEC BACC30X6)		
				(OPT HL87-6		
				(V73197))		
				(OPT HL87-6		
				(V92215))		
				(OPT HL1187-6		
				(V56878))		
				(OPT HL1187-6		
				(V92215))		
				(OPT HL87-6		
				(V56878))		
				-------*-------		
	120	BACB28X8M075		..BUSHING	A-K	2
	122	BACB28X8M075		..BUSHING	L,N	1
	123	BACB28X8M120		..BUSHING	L,N	1
	125	141T6406-2		..FITTING	A-L,N	1
	130D	H2860-5		.HANDLE ASSY-	A-L	1
				(V83014)		
				(SPEC S141T640-3)		
	-130E	H2860-13		.HANDLE ASSY-	M-S	1
				(V83014)		
				(SPEC S141T640-5)		
				ATTACHING PARTS		
	135	BACR15CE5KE		.RIVET-		16
				(SIZE DETERMINE ON INST)		
R	137	141T6401-51		.SPACER	S	1
R	-137A	141T6401-53		.SPACER	R	1
				-------*-------		
	140	141T6404-1		.FITTING ASSY-STOP	A-L,N	1
	144	141T6404-2		.FITTING ASSY-STOP	A-L,N	1
				ATTACHING PARTS		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
148	BACR15FT6KE		.RIVET- (SIZE DETERMINE ON INST)	A-L,N	18
152	HL10VAZ5-4		.BOLT- (V60516) (SPEC BACB30MY5K4) (OPT HL10VAZ5-4 (V0PTK6))	A-L,N	4
156	HL82-5APBW		.COLLAR- (V73197) (SPEC BACC30AG5) (OPT HL82-5APBW (V56878))	A-L,N	4
160	HL10VAZ6-7		.BOLT- (V60516) (SPEC BACB30MY6K7) (OPT HL10VAZ6-7 (V0PTK6))	A-L,N	2
164	HL82-6APBW		.COLLAR- (V73197) (SPEC BACC30AG6) (OPT HL82-6APBW (V92215)) (OPT HL82-6APBW (V56878))	A-L,N	2
167	HL11VAZ6-4		.BOLT- (V56878) (SPEC BACB30NW6K4) (OPT HL11V6-4 (V92215)) (OPT HL11V6-4 (V97928)) (OPT L803-6-4 (V06725)) (OPT B30NW6K4 (V97928)) (OPT HL11VAZ6-4 (V73197)) (OPT HL11VAZ6-4 (V92215)) (OPT HL11VAZ6-4 (V97928)) (OPT L803-6K4 (V06725)) (OPT HL11V6-4 (V80539))	A-L,N	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-170	HL11VAZ6-7		.BOLT- (V56878) (SPEC BACB30NW6K7) (OPT HL11V6-7 (V92215)) (OPT HL11V6-7 (V97928)) (OPT L803-6-7 (V06725)) (OPT B30NW6K7 (V97928)) (OPT HL11VAZ6-7 (V73197)) (OPT HL11VAZ6-7 (V92215)) (OPT HL11VAZ6-7 (V97928)) (OPT L803-6K7 (V06725)) (OPT HL11VAZ6-7 (VOPTK6))	A-L,N	2
171	HL79-6		.COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))	A-L,N	4

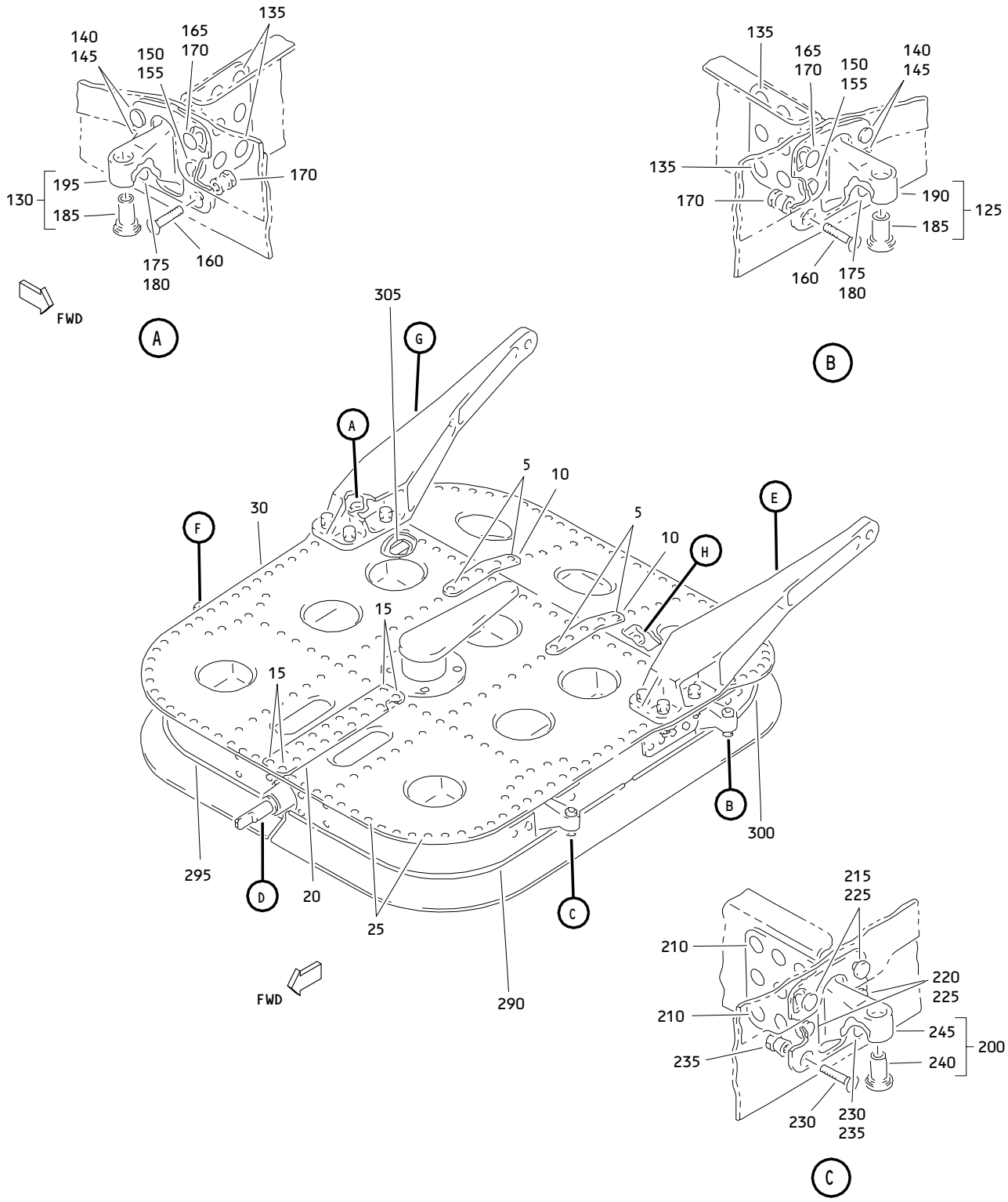
FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
175	HL11VAZ5-4		.BOLT- (V56878) (SPEC BACB30NW5K4) (OPT B30NW5K4 (V97928)) (OPT HL11VAZ5-4 (V73197)) (OPT HL11VAZ5-4 (V92215)) (OPT HL11VAZ5-4 (V97928)) (OPT L803-5K4 (V06725)) (OPT HL11VAZ5-4 (VOPTK6)) (OPT HL11VAZ5-4 (V60516))	A-L,N	2
179	HL70-5		.COLLAR- (V56878) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878)) -------*-------	A-L,N	2
183	141T6408-1		..BUSHING	A-L,N	1
187	141T6404-5		..FITTING- (USED ON ITEM 140)	A-L,N	1
191	141T6404-6		..FITTING- (USED ON ITEM 144)	A-L,N	1
195	141T6404-3		.FITTING ASSY-STOP	A-L,N	1
199	141T6404-4		.FITTING ASSY-STOP ATTACHING PARTS	A-L,N	1
203	BACR15FT6KE		.RIVET- (SIZE DETERMINE ON INST)	A-L,N	18
207	HL10VAZ6-7		.BOLT- (V60516) (SPEC BACB30MY6K7) (OPT HL10VAZ6-7 (VOPTK6))	A-L,N	4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
211	HL10VAZ6-4		.BOLT- (V60516) (SPEC BACB30MY6K4) (OPT HL10VAZ6-4 (VOPTK6))	A-L,N	4
215	HL82-6APBW		.COLLAR- (V73197) (SPEC BACC30AG6) (OPT HL82-6APBW (V92215)) (OPT HL82-6APBW (V56878))	A-L,N	8
219	HL11VAZ5-4		.BOLT- (V56878) (SPEC BACB30NW5K4) (OPT B30NW5K4 (V97928)) (OPT HL11VAZ5-4 (V73197)) (OPT HL11VAZ5-4 (V92215)) (OPT HL11VAZ5-4 (V97928)) (OPT L803-5K4 (V06725)) (OPT HL11VAZ5-4 (VOPTK6)) (OPT HL11VAZ5-4 (V60516))	A-L,N	4

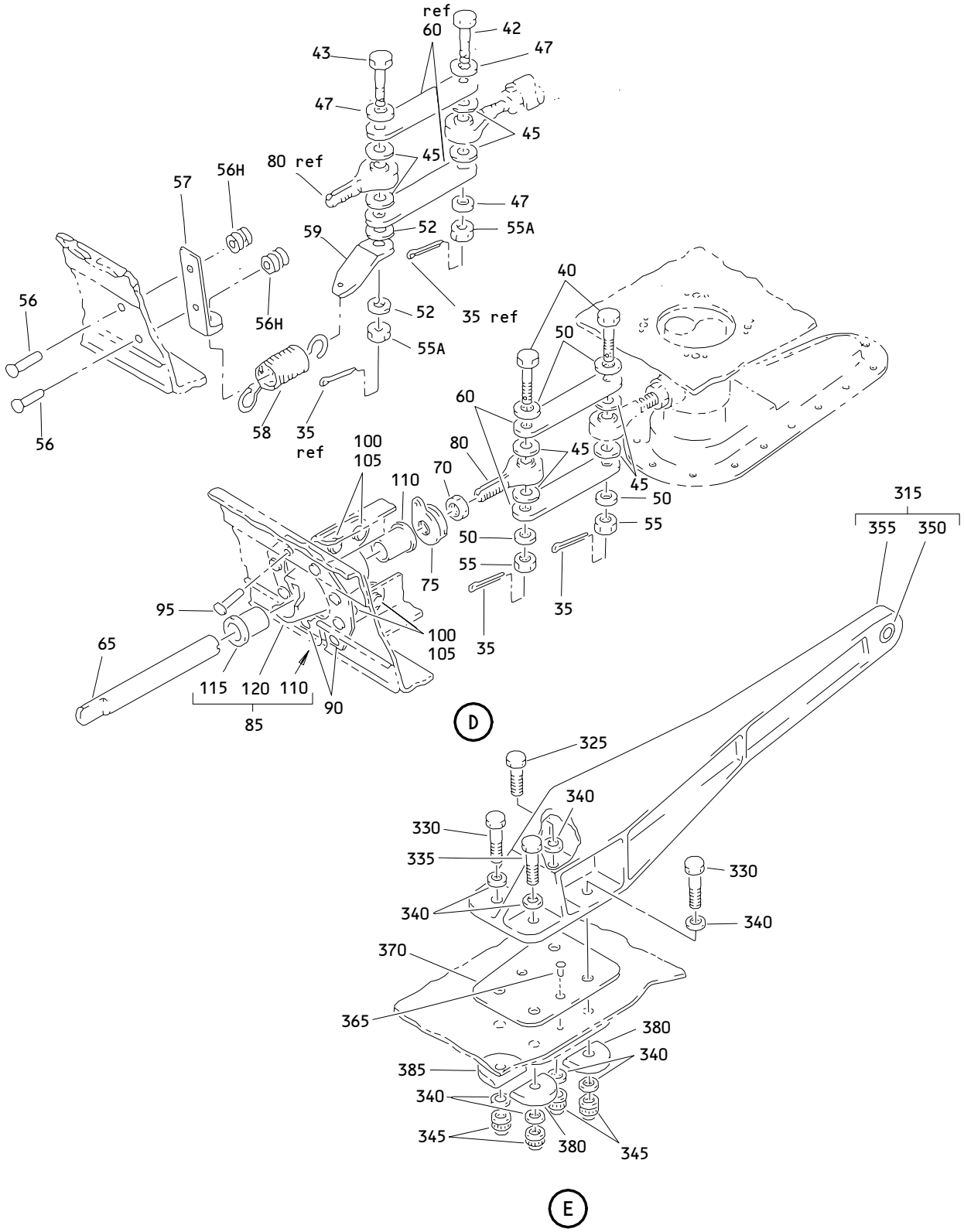
	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	223	HL70-5		.COLLAR- (V56878) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878)) -------*-------	A-L,N	4
	227	141T6408-1		..BUSHING	A-L,N	1
	231	141T6404-7		..FITTING- (USED ON ITEM 195)	A-L,N	1
	235	141T6404-8		..FITTING- (USED ON ITEM 199)	A-L,N	1
	237	140N2021-1		.RETAINER	K,L,N	1
	-237A	140N2021-1		.RETAINER- (POST SB 51-0006)	A-J	1
R	240	140T2810-6		.VALVE ASSY-DRAIN (PRE SB 51-0006)	A-J	1
	243	140N2022-1		.VALVE ASSY-DRAIN	K,L,N	1
	-243A	140N2022-1		.VALVE ASSY-DRAIN (POST SB 51-0006) ATTACHING PARTS	A-J	1
	245	BACR15CE4KE		.RIVET- (SIZE DETERMINE ON INST) (PRE SB 51-0006)	A-J	4
	248	BACR15CE4KE		.RIVET- (SIZE DETERMINE ON INST)	K,L,N	2
	-248A	BACR15CE4AD		.RIVET- (SIZE DETERMINE ON INST) (POST SB 51-0006)	A-J	2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	249	AN960KD4		.WASHER- (POST SB 51-0006)	A-J	2
				-------*-------		
	250	140T2810-7		..COVER- (USED ON ITEM 240)	A-J	1
	251	140N2022-4		..CAP- (USED ON ITEMS 243, 243A)	A-L,N	1
	252	140N2022-3		..PLUNGER- (USED ON ITEMS 243, 243A)	A-L,N	1
	253	140N2020-1		..SPRING- (USED ON ITEMS 243, 243A)	A-L,N	1
	254	140N2022-2		..HOUSING- (USED ON ITEMS 243, 243A)	A-L,N	1
	255A	69-68855-3		..VALVE ASSY-SPR (USED ON ITEM 240)	A-J	1
	260A	69-68855-4		...SPRING	A-J	1
	265	69-68856-1		...VALVE	A-J	1
	266	141T6420-1		.SEAL-RTNR	A-L,N	1
	267	141T6420-2		.SEAL-RTNR	A-L,N	1
	268	141T6420-3		.SEAL-RTNR	A-L,N	1
	269	141T6420-4		.SEAL-RTNR	A-L,N	1
	270	MS27253F3		.PLATE		1
	275	141T6409-1		.ARM ASSY-HINGE	A-L,N	1
	280	141T6409-8		.ARM ASSY-HINGE	B,F	1
	-280A	141T6409-2		.ARM ASSY-HINGE	A,C-E,G-L,N	1
				ATTACHING PARTS		
	285	BACB30NM4K11		.BOLT	A-L,N	2
	290	BACB30NM4K12		.BOLT	A-L,N	4
	295	BACB30NM4K14		.BOLT	A-L,N	2
	300	AN960-416		DELETED		
R	300A	NAS1149F0463P		.WASHER	A-L,N	16
	305	NAS1805-4		.NUT	A-L,N	8
				-------*-------		
	310	BACB28Y5M037		..BUSHING	A-L,N	1
	315	141T6409-3		..ARM- (OPT ITEM 315A) (USED ON ITEM 275)	A-L,N	1

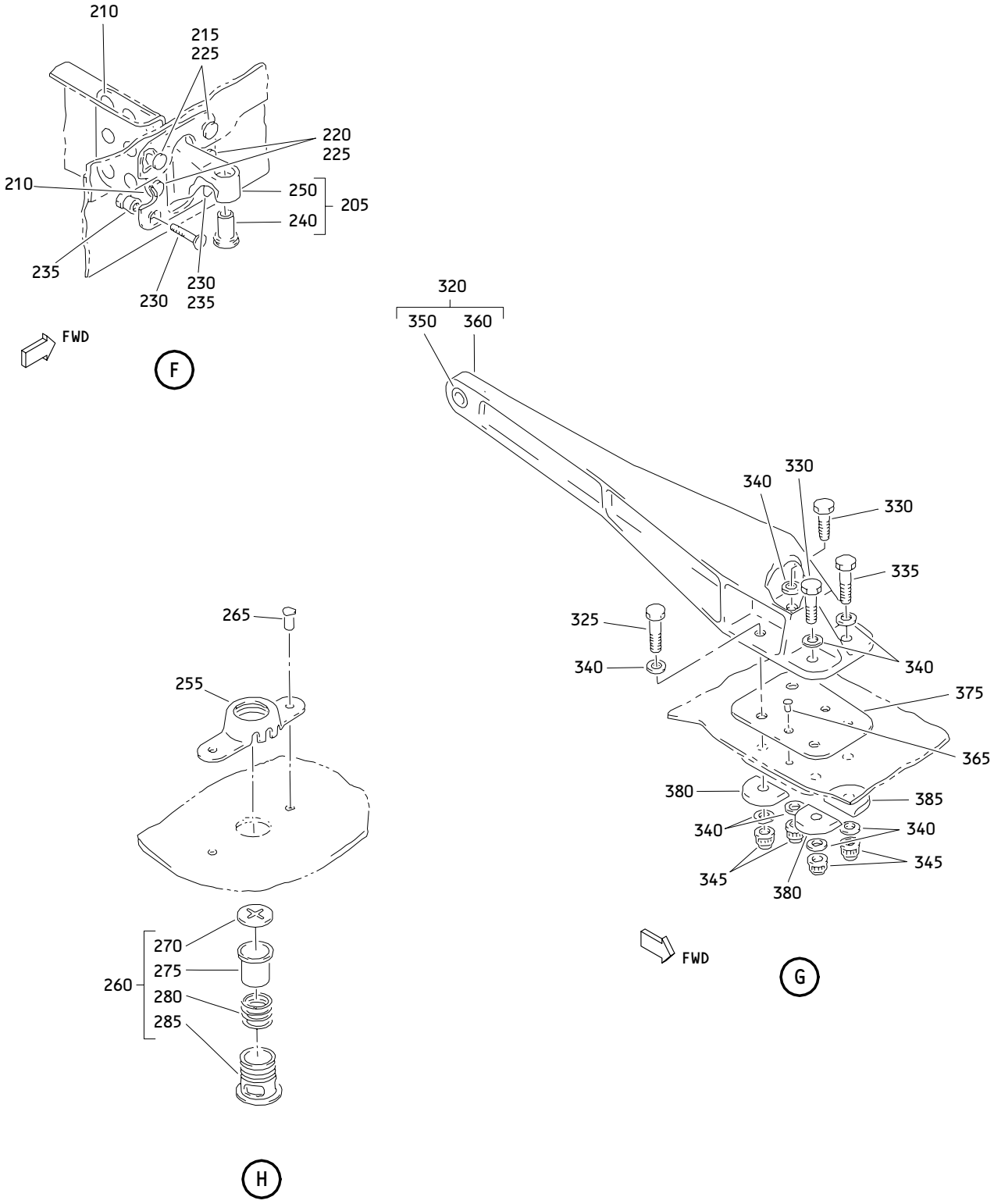
FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-315A	141T6409-501		..ARM- (OPT ITEM 315) (USED ON ITEM 275)	A-L,N	1
320	141T6409-10		..ARM- (USED ON ITEM 280)	B,F	1
-320A	141T6409-4		..ARM- (OPT ITEM 320B) (USED ON ITEM 280A)	A,C-E,G-L,N	1
-320B	141T6409-10		..ARM- (OPT ITEM 320A) (USED ON ITEM 280A)	A,C-E,G-L,N	1
325	BACR15CE6KE		.RIVET- (SIZE DETERMINE ON INST)	A-L,N	4
330	141T6414-3		.PLATE-SERRATED	A-L,N	1
335	141T6414-4		.PLATE-SERRATED	A-L,N	1
340	141T6422-30		.FILLER-RADIUS	A-L,N	4
345	141T6422-33		.FILLER-RADIUS	A-L,N	2
			INSTALLATION PARTS		
810A	8304-5		SEAL- (V11960) (SPEC S140T263-5)		1



Forward Access Door Common Collector
Figure 2 (Sheet 1)



Forward Access Door Common Collector
Figure 2 (Sheet 2)



Forward Access Door Common Collector
Figure 2 (Sheet 3)

641593

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-					
	-1	141T6401-7001		COLLECTOR-COMMON PART FWD ACCESS DOOR	M	RF
	-1A	141T6401-7002		COLLECTOR-COMMON PART FWD ACCESS DOOR	P-S	RF
	5	BACR15FT5KE		.RIVET- (SIZE DETERMINE ON INST)	M,P-S	10
	10	141T6422-29		.STRAP	M,P-S	2
	15	BACR15FT5KE		.RIVET- (SIZE DETERMINE ON INST)	M,P-S	18
	20	141T6401-3		.STRAP	M,P-S	1
	25	BACR15FT5KE		.RIVET- (SIZE DETERMINE ON INST)	M,P-S	181
	30	141T6422-42		.SKIN-INNER	M,P-S	1
	35	MS24665-153		.PIN-COTTER	M,P-S	2
	40	BACB30NR4DK12		.BOLT	M	2
	42	BACB30NR4DK13		.BOLT	P-S	1
	43	BACB30NR4DK14		.BOLT	P-S	1
	45	141T6423-1		.SPACER	M,P-S	AR
	47	BACW10P203AM		.WASHER	P-S	3
	50	AN960C416		DELETED		
R	50A	NAS1149C0463R		.WASHER	M	4
	52	BACW10P227TF		.WASHER- (V10630) (SPEC BACW10P227TF)	P-S	2
	55	BACN10JD4AU		.NUT- (V15653) (SPEC BACN10JD4AU) (OPT BACN10JD4AU (V56878)) (OPT BACN10JD4AU (V72962)) (OPT BACN10JD4AU (V92595))	M	2
	-55A	BACN10JD4		.NUT- (V15653) (SPEC BACN10JD4) (OPT BACN10JD4 (V56878)) (OPT BACN10JD4 (V72962)) (OPT BACN10JD4 (V92595))	P-S	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
56	HST11AG5-6		.BOLT- (V06725) (SPEC BACB30VU5K6) (OPT HST11AG5-6 (V73197)) (OPT HST11AG5-6 (V0PTK6)) (OPT HST11AG5-6 (V56878))	P-S	2
56H	HST1094KP5		.COLLAR- (V73197) (SPEC BACC30BS5)	P-S	2
57	141T6422-43		.SUPPORT-SPRING	P-S	1
58	141T6422-45		.SPRING-EXTENSION	P-S	1
59	141T6422-44		.SUPPORT-SPRING	P-S	1
60	141T6322-1		.LINK-LATCH	M,P-S	2
65	141T6407-2		.PIN-LATCH	M,P-S	1
70	NAS1423-5		.NUT	M,P-S	1
75	NAS1193K5C		.LOCKING DEVICE	M,P-S	1
80	MS21242S4K		.BEARING	M,P-S	1
85	141T6406-4		.FITTING ASSY-LATCH ATTACHING PARTS	M,P-S	1
90	BACR15CE5KE		.RIVET- (SIZE DETERMINE ON INST)	M,P-S	2
95	BACR15FT5KE		.RIVET- (SIZE DETERMINE ON INST)	M,P-S	6
100	HL12VAZ6-4		.BOLT- (V56878) (SPEC BACB30NX6K4) (OPT HL12VAZ6-4 (V73197)) (OPT HL12VAZ6-4 (V92215)) (OPT HL12VAZ6-4 (V97928)) (OPT L802-6K4 (V06725)) (OPT HL12-4 (V06725))	M,P-S	4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
105	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)) -------*-------	M,P-S	4
110	BACB28X8M075		..BUSHING	M,P-S	1
115	BACB28X8M120		..BUSHING	M,P-S	1
120	141T6406-2		..FITTING	M,P-S	1
125	141T6404-1		.FITTING ASSY-STOP	M,P-S	1
130	141T6404-2		.FITTING ASSY-STOP ATTACHING PARTS	M,P-S	1
135	BACR15FT6KE		.RIVET- (SIZE DETERMINE ON INST)	M,P-S	18
140	HL10VAZ5-4		.BOLT- (V60516) (SPEC BACB30MY5K4) (OPT HL10VAZ5-4 (VOPTK6))	M	4
-140A	HST10AG5-4		.BOLT- (VOPTK6) (SPEC BACB30VT5K4) (OPT HST10AG5-4 (V06725)) (OPT HST10AG5-4 (V56878)) (OPT HST10AG5-4 (V73197))	P-S	4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
145	HL82-5APBW		.COLLAR- (V73197) (SPEC BACC30AG5) (OPT HL82-5APBW (V56878))	M	4
-145A	HST825AW		.COLLAR- (V73197) (SPEC BACC30BQ5) (OPT HST825AW (V56878))	P-S	4
150	HL10VAZ6-7		.BOLT- (V60516) (SPEC BACB30MY6K7) (OPT HL10VAZ6-7 (VOPTK6))	M	2
-150A	HST10AG6-7		.BOLT- (VOPTK6) (SPEC BACB30VT6K7) (OPT HST10AG6-7 (V06725)) (OPT HST10AG6-7 (V56878)) (OPT HST10AG6-7 (V73197))	P-S	2
155	HL82-6APBW		.COLLAR- (V73197) (SPEC BACC30AG6) (OPT HL82-6APBW (V92215)) (OPT HL82-6APBW (V56878))	M	2
-155A	HST826AW		.COLLAR- (V73197) (SPEC BACC30BQ6) (OPT HST826AW (V56878))	P-S	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-160	HL11VAZ6-4		.BOLT- (V56878) (SPEC BACB30NW6K4) (OPT HL11V6-4 (V92215)) (OPT HL11V6-4 (V97928)) (OPT L803-6-4 (V06725)) (OPT B30NW6K4 (V97928)) (OPT HL11VAZ6-4 (V73197)) (OPT HL11VAZ6-4 (V92215)) (OPT HL11VAZ6-4 (V97928)) (OPT L803-6K4 (V06725)) (OPT HL11V6-4 (V80539))	M	2
-160A	HST11AG6-4		.BOLT- (V06725) (SPEC BACB30VU6K4) (OPT HST11AG6-4 (V73197)) (OPT HST11AG6-4 (V56878)) (OPT HST11AG6-4 (VOPTK6))	P-S	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-165	HL11VAZ6-7		.BOLT- (V56878) (SPEC BACB30NW6K7) (OPT HL11V6-7 (V92215)) (OPT HL11V6-7 (V97928)) (OPT L803-6-7 (V06725)) (OPT B30NW6K7 (V97928)) (OPT HL11VAZ6-7 (V73197)) (OPT HL11VAZ6-7 (V92215)) (OPT HL11VAZ6-7 (V97928)) (OPT L803-6K7 (V06725)) (OPT HL11VAZ6-7 (VOPTK6))	M	2
-165A	HST11AG6-7		.BOLT- (V06725) (SPEC BACB30VU6K7) (OPT HST11AG6-7 (V73197)) (OPT HST11AG6-7 (V56878)) (OPT HST11AG6-7 (VOPTK6))	P-S	2
170	HL79-6		.COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))	M	4
-170A	HST826AW		.COLLAR- (V73197) (SPEC BACC30BQ6) (OPT HST826AW (V56878))	P-S	4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
175	HL11VAZ5-4		.BOLT- (V56878) (SPEC BACB30NW5K4) (OPT B30NW5K4 (V97928)) (OPT HL11VAZ5-4 (V73197)) (OPT HL11VAZ5-4 (V92215)) (OPT HL11VAZ5-4 (V97928)) (OPT L803-5K4 (V06725)) (OPT HL11VAZ5-4 (VOPTK6)) (OPT HL11VAZ5-4 (V60516))	M	2
-175A	HST11AG5-4		.BOLT- (V06725) (SPEC BACB30VU5K4) (OPT HST11AG5-4 (V73197)) (OPT HST11AG5-4 (VOPTK6)) (OPT HST11AG5-4 (V56878))	P-S	2
180	HL70-5		.COLLAR- (V56878) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878))	M	2
-180A	HST825AW		.COLLAR- (V73197) (SPEC BACC30BQ5) (OPT HST825AW (V56878)) -------*-------	P-S	2
185	141T6408-1		..BUSHING	M,P-S	1
190	141T6404-5		..FITTING- (USED ON ITEM 125)	M,P-S	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
195	141T6404-6		..FITTING-	M,P-S	1
			(USED ON ITEM 130)		
200	141T6404-3		.FITTING ASSY-STOP	M,P-S	1
205	141T6404-4		.FITTING ASSY-STOP	M,P-S	1
			ATTACHING PARTS		
210	BACR15FT6KE		.RIVET-	M,P-S	18
			(SIZE DETERMINE ON INST)		
215	HL10VAZ6-7		.BOLT-	M	4
			(V60516)		
			(SPEC BACB30MY6K7)		
			(OPT HL10VAZ6-7		
			(VOPTK6))		
-215A	HST10AG6-7		.BOLT-	P-S	4
			(VOPTK6)		
			(SPEC BACB30VT6K7)		
			(OPT HST10AG6-7		
			(V06725))		
			(OPT HST10AG6-7		
			(V56878))		
			(OPT HST10AG6-7		
			(V73197))		
220	HL10VAZ6-4		.BOLT-	M	4
			(V60516)		
			(SPEC BACB30MY6K4)		
			(OPT HL10VAZ6-4		
			(VOPTK6))		
-220A	HST10AG6-4		.BOLT-	P-S	4
			(V06725)		
			(SPEC BACB30VT6K4)		
			(OPT HST10AG6-4		
			(V73197))		
			(OPT HST10AG6-4		
			(V56878))		
			(OPT HST10AG6-4		
			(VOPTK6))		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
225	HL82-6APBW		.COLLAR- (V73197) (SPEC BACC30AG6) (OPT HL82-6APBW (V92215)) (OPT HL82-6APBW (V56878))	M	8
-225A	HST826AW		.COLLAR- (V73197) (SPEC BACC30BQ6) (OPT HST826AW (V56878))	P-S	8
230	HL11VAZ5-4		.BOLT- (V56878) (SPEC BACB30NW5K4) (OPT B30NW5K4 (V97928)) (OPT HL11VAZ5-4 (V73197)) (OPT HL11VAZ5-4 (V92215)) (OPT HL11VAZ5-4 (V97928)) (OPT L803-5K4 (V06725)) (OPT HL11VAZ5-4 (VOPTK6)) (OPT HL11VAZ5-4 (V60516))	M	4
-230A	HST11AG5-4		.BOLT- (V06725) (SPEC BACB30VU5K4) (OPT HST11AG5-4 (V73197)) (OPT HST11AG5-4 (VOPTK6)) (OPT HST11AG5-4 (V56878))	P-S	4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
235	HL70-5		.COLLAR- (V56878) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878))	M	4
-235A	HST825AW		.COLLAR- (V73197) (SPEC BACC30BQ5) (OPT HST825AW (V56878)) -------*-------	P-S	4
240	141T6408-1		..BUSHING	M,P-S	1
245	141T6404-7		..FITTING- (USED ON ITEM 200)	M,P-S	1
250	141T6404-8		..FITTING- (USED ON ITEM 205)	M,P-S	1
255	140N2021-1		.RETAINER	M,P-S	1
260	140N2022-1		.VALVE ASSY-DRAIN ATTACHING PARTS	M,P-S	1
265	BACR15CE4KE		.RIVET- (SIZE DETERMINE ON INST) -------*-------	M,P-S	2
270	140N2022-4		..CAP	M,P-S	1
275	140N2022-3		..PLUNGER	M,P-S	1
280	140N2020-1		..SPRING	M,P-S	1
285	140N2022-2		..HOUSING	M,P-S	1
290	141T6420-1		.SEAL-RTNR	M,P-S	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-					
	295	141T6420-2		.SEAL-RTNR	M,P-S	1
	300	141T6420-3		.SEAL-RTNR	M,P-S	1
	305	141T6420-4		.SEAL-RTNR	M,P-S	1
	310	MS27253F3		DELETED		
	315	141T6409-1		.ARM ASSY-HINGE	M,P-S	1
	320	141T6409-2		.ARM ASSY-HINGE	M,P-S	1
				ATTACHING PARTS		
	325	BACB30NM4K11		.BOLT	M,P-S	2
	330	BACB30NM4K12		.BOLT	M,P-S	4
	335	BACB30NM4K14		.BOLT	M,P-S	2
	340	AN960-416		DELETED		
R	340A	NAS1149F0463P		.WASHER	M,P-S	16
	345	NAS1805-4		.NUT	M,P-S	8
				-------*-------		
	350	BACB28Y5M037		..BUSHING	M,P-S	1
	355	141T6409-3		..ARM-	M,P-S	1
				(OPT ITEM 355A)		
				(USED ON ITEM 315)		
	-355A	141T6409-501		..ARM-	M,P-S	1
				(OPT ITEM 355)		
				(USED ON ITEM 315)		
	360	141T6409-4		..ARM-	M,P-S	1
				(OPT ITEM 360A)		
				(USED ON ITEM 320)		
	-360A	141T6409-10		..ARM-	M,P-S	1
				(OPT ITEM 360)		
				(USED ON ITEM 320)		
	365	BACR15CE6KE		.RIVET-	M,P-S	4
				(SIZE DETERMINE ON INST)		
	370	141T6414-3		.PLATE-SERRATED	M,P-S	1
	375	141T6414-4		.PLATE-SERRATED	M,P-S	1
	380	141T6422-30		.FILLER-RADIUS	M,P-S	4
	385	141T6422-33		.FILLER-RADIUS	M,P-S	2