

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

TO: ALL HOLDERS OF CONTROLS BAY ACCESS DOOR ASSEMBLY COMPONENT MAINTENANCE
MANUAL 52-48-61

REVISION NO. 6 DATED APR 01/88

HIGHLIGHTS

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

CHAPTER/SECTION
AND PAGE NO.

TITLE PAGE

1

TR & SB RECORD

1

501

REPAIR-GEN

602

REPAIR 1-1

601-603

701-702

1010,1019-1024

DESCRIPTION OF CHANGE

Incorporated PRR B11704 which added top assembly
148T6002-3 door assembly for redesigned latch
mechanism.

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HIGHLIGHTS

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CONTROLS BAY ACCESS DOOR ASSEMBLY

PART NUMBER 148T6602-1,-2,-3

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

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TITLE PAGE

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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.

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

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REVISION RECORD

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR B11704	APR 01/88

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TR & SB RECORD

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			604	BLANK	
TITLE PAGE			ASSEMBLY		
*1	APR 01/88	01.1	*701	APR 01/88	01.1
2	BLANK		*702	APR 01/88	01.1
REVISION RECORD			ILLUSTRATED PARTS LIST		
1	JUL 10/83	01	1001	JUL 10/83	01
2	BLANK		*1002	APR 01/88	01.1
TR & SB RECORD			*1003	APR 01/88	01.1
*1	APR 01/88	01.1	*1004	APR 01/88	01.1
2	BLANK		*1005	APR 01/88	01.1
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CONTENTS			*1009	BLANK	
1	JUL 10/83	01	*1010	APR 01/88	01.1
2	BLANK		*1011	APR 01/88	01.1
INTRODUCTION			*1012	APR 01/88	01.1
1	OCT 10/84	01.101	*1013	APR 01/88	01.1
2	BLANK		*1014	APR 01/88	01.1
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1	JUL 10/83	01	*1016	APR 01/88	01.1
2	BLANK		*1017	APR 01/88	01.1
CHECK			*1018	BLANK	
*501	APR 01/88	01.1	*1019	APR 01/88	01.1
502	BLANK		*1020	APR 01/88	01.1
REPAIR-GENERAL			*1021	APR 01/88	01.1
601	OCT 10/84	01.1	*1022	APR 01/88	01.1
*602	APR 01/88	01.1	*1023	APR 01/88	01.1
REPAIR 1-1			*1024	APR 01/88	01.1
*601	APR 01/88	01.1			
*602	APR 01/88	01.1			
*603	APR 01/88	01.1			

* = REVISED, ADDED OR DELETED

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Special Tools (not applicable)	
Illustrated Parts List	1001

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

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BOEING
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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.

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INTRODUCTION

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DESCRIPTION AND OPERATION

1. Description and Operation

- A. The controls bay access door assembly consists of a conventional frame and stringer construction with aluminum skin, latch assembly, pivot fitting, and hinge assembly. The door assembly covers the opening in the fuselage that provides access to the aft elevator controls.

2. Leading Particulars (Approximate)

- A. Length -- 22 inches
B. Width -- 18.5 inches
C. Height -- 3 inches
D. Weight -- 10 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. Perform penetrant examination per 20-20-02 on fittings (50, 55, IPL Fig. 1), hinge fairings (150, 155, IPL Fig. 1; 95, 100, IPL Fig. 2).
3. Check latch assembly (60A) per manufacturer's instructions.

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CHECK

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REPAIR – GENERAL**| 1. Content**

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

<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
--	MISCELLANEOUS PARTS	1-1

| 2. Standard Practices

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

20-30-02	Stripping of Protective Finishes
20-30-03	General Cleaning Procedures
20-41-01	Decoding Table for Boeing Finish Codes
20-43-01	Chromic Acid Anodizing
20-44-01	Application of Abrasion Resistant Finishes
20-44-02	Temporary Protective Coatings
20-50-08	Application of Dry Lubricant
20-70-01	Protection, Storage and Handling of Airplane Components

3. Materials

NOTE: Equivalent substitutes may be used.

- A. Coating, Teflon -- BMS 10-86, type 1 white (Ref 20-44-01, type 27)
- B. Enamel -- BMS 10-60, BAC707 gray gloss (Ref 20-60-02)
- C. Lubricant -- BMS 3-8 (Ref 20-60-03)
- D. Primer -- BMS 10-11, type 1 (Ref 20-60-02)

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4. Dimensioning Symbols

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

—	STRAIGHTNESS	\oplus	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
\square	FLATNESS	\varnothing	DIAMETER
\perp	PERPENDICULARITY (OR SQUARENESS)	S \varnothing	SPHERICAL DIAMETER
//	PARALLELISM	R	RADIUS
\bigcirc	ROUNDNESS	SR	SPHERICAL RADIUS
\bigcirc	CYLINDRICITY	()	REFERENCE
\frown	PROFILE OF A LINE	BASIC (BSC) OR	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.
\triangle	PROFILE OF A SURFACE	DIM	
\odot	CONCENTRICITY	-A-	DATUM
\equiv	SYMMETRY	\textcircled{M}	MAXIMUM MATERIAL CONDITION (MMC)
\sphericalangle	ANGULARITY	\textcircled{L}	LEAST MATERIAL CONDITION (LMC)
\nearrow	RUNOUT	\textcircled{S}	REGARDLESS OF FEATURE SIZE (RFS)
\nearrow	TOTAL RUNOUT	\textcircled{P}	PROJECTED TOLERANCE ZONE
\sqsubset	COUNTERBORE OR SPOTFACE	FIM	FULL INDICATOR MOVEMENT
\sphericalangle	COUNTERSINK		

EXAMPLES

$\text{—} \quad 0.002$	STRAIGHT WITHIN 0.002	$\textcircled{\odot} \text{C} \varnothing 0.0005$	CONCENTRIC TO C WITHIN 0.0005 DIAMETER
$\perp \text{B} \quad 0.002$	PERPENDICULAR TO B WITHIN 0.002	$\equiv \text{A} \quad 0.010$	SYMMETRICAL WITH A WITHIN 0.010
$// \text{A} \quad 0.002$	PARALLEL TO A WITHIN 0.002	$\sphericalangle \text{A} \quad 0.005$	ANGULAR TOLERANCE 0.005 WITH A
$\bigcirc \quad 0.002$	ROUND WITHIN 0.002	$\oplus \text{B} \varnothing 0.002 \textcircled{S}$	LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
$\bigcirc \quad 0.010$	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER	$\perp \text{A} \varnothing 0.010 \textcircled{M}$ $0.510 \textcircled{P}$	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
$\frown \text{A} \quad 0.006$	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM PLANE A	2.000	EXACT DIMENSION IS 2.000
$\triangle \text{A} \quad 0.020$	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE	OR 2.000 BSC	
(NOTE THAT $\triangle \text{A} \quad 0.020$ MAY ALSO APPEAR AS $\triangle \quad 0.020 \quad \text{A}$)			

True Position Dimensioning Symbols
Figure 601

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REPAIR-GENERAL

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MISCELLANEOUS PARTS - REPAIR 1-1

1. Repair

A. Repair of parts listed in Fig. 601 consists of restoration of the original finish.

IPL FIG. & ITEM	MATERIAL	FINISH
Structure assembly (185, IPL Fig.1; 115, IPL Fig.2)	Aluminum alloy	Interior of exterior skin: Chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (F-18.13) all over. Inner skin: Chemical treat to meet the requirements of MIL-C-5541, and apply one coat of BMS 10-11, type 1 primer (F-18.06) all over. Apply teflon coating per Fig. 602.
Hinge halves (100,105, IPL Fig. 1; 40,45, IPL Fig.2)	Aluminum alloy	Chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (F-18.13) all over, except omit primer in holes.
Hinge assembly (80, IPL Fig.1; 30, IPL Fig.2)	- - -	Clean and reactivate primed surfaces per 20-41-02. Apply one coat of BMS 10-11, type 1 primer (SRF-14.995) all over. Apply BMS 10-60, Boeing color 707 gray gloss enamel (SRF-14.9813) all over.
Adjust angle (145, IPL Fig.1; 85, IPL Fig.2)	Aluminum alloy	Chemical treat to meet the requirements of MIL-C-5541, and apply one coat of BMS 10-11, type 1 primer (F-18.06) all over.
Fittings (175, IPL Fig.1; 110, IPL Fig.2)	Aluminum alloy	Chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (F-18.13) all over.

Refinish Details
Figure 601 (Sheet 1)

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IPL FIG. & ITEM	MATERIAL	FINISH
Hinge fairing (150,155, IPL Fig. 1; 95,100, IPL Fig. 2)	Aluminum alloy	Chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (F-18.13) and one coat of BMS 10-60, Boeing color 707 gray gloss enamel (SRF-14.9813) all over.
Pin (95, IPL Fig. 1; 35, IPL Fig. 2)	CRES Cadmium-plated	Apply dry-film lubricant BMS 3-8 per 20-50-08.

Refinish Details
 Figure 601 (Sheet 2)

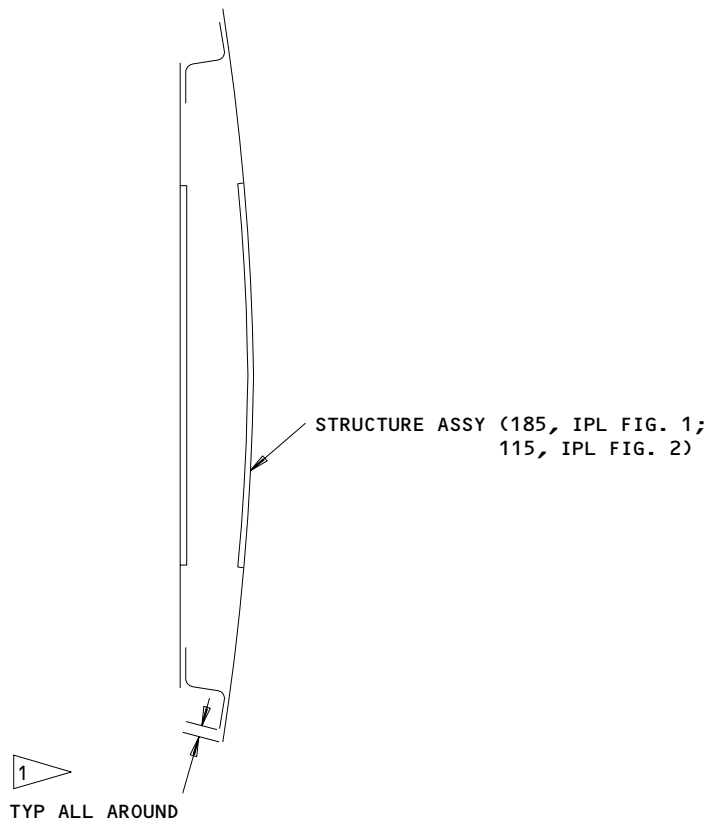
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1 APPLY BMS 10-86, TYPE 1 WHITE
TEFLON COATING PER 20-44-01,
TYPE 27 (SRF-14.9624).

Refinish of Structure Assembly
Figure 602

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ASSEMBLY

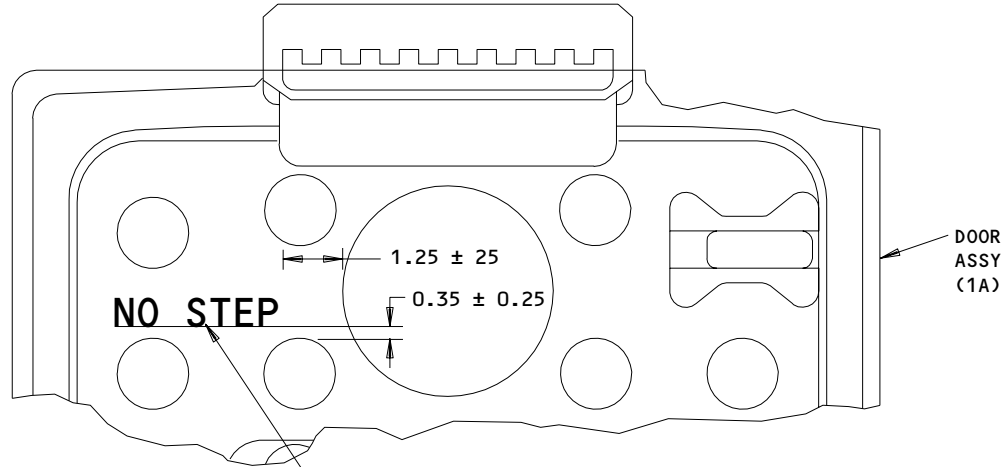
1. Materials

- A. Enamel -- BMS 10-11, type 2, BAC701 black gloss (Ref 20-60-02)
- B. Primer -- BMS 10-11, type 1 (Ref 20-60-02)

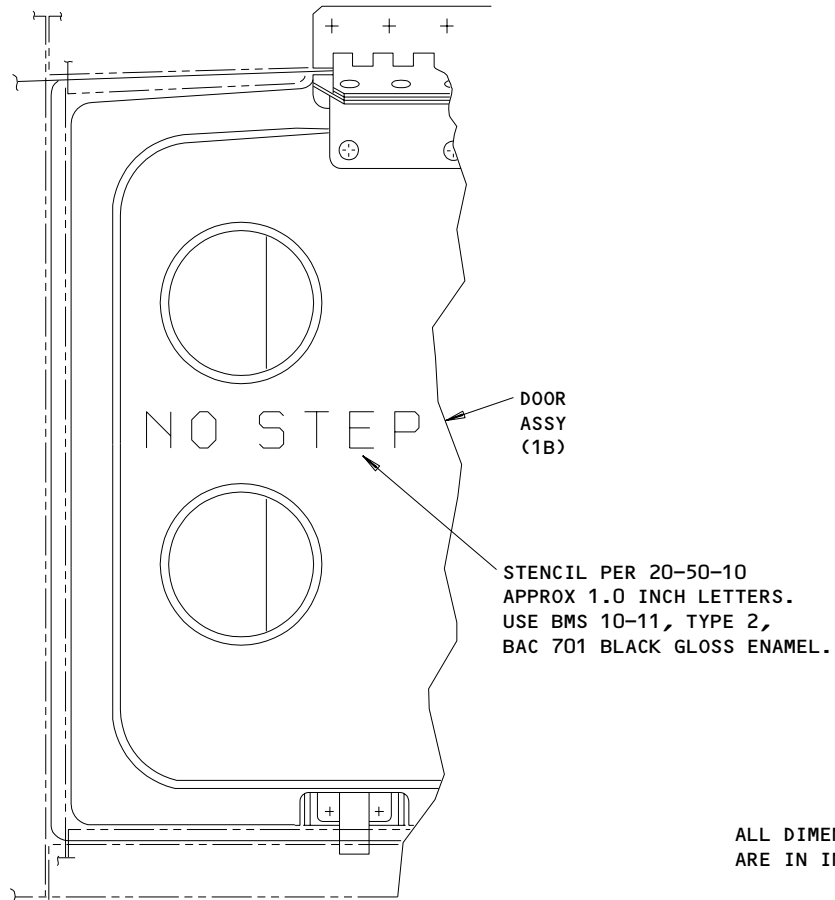
2. Assembly

- A. Use standard industry practices for assembly of this unit, with additional procedures as follows.
- B. Delaminate shim (35, IPL Fig. 1) as necessary on installation of latch (60A). After delamination, install shim using BMS 10-11, type 1 primer (F-20.05) either wet or dry per 20-41-02.
- C. Install bolts (85, 115, IPL Fig. 1; 20, 50, IPL Fig. 2), washers (120, IPL Fig. 1; 55, IPL Fig. 2), nuts (130, IPL Fig. 1; 60, IPL Fig. 2), and shims (90, 125, IPL Fig. 1; 25, 65, IPL Fig. 2). To facilitate installation on airplane, do not tighten bolts (85, IPL Fig. 1; 20, IPL Fig. 2), or nut (130, IPL Fig. 1; 60, IPL Fig. 2).
- D. Attach tag to shim (125, IPL Fig. 1; 65, IPL Fig. 2) stating "Delaminate shim (BACS40R10E87F) as necessary on installation of door. After delamination, install shim using either wet or dry BMS 10-11, type 1 primer".
- E. Attach tag to shim (90, IPL Fig. 1; 25, IPL Fig. 2) stating "Delaminate shim (BACS40R10E85F) as necessary on installation of door. After delamination, install shim using either wet or dry BMS 10-11, type 1 primer".
- F. Stencil identification number "313AL" on inboard side of door assembly, as centrally located as possible. Make letters 0.50 inch tall. Do not stencil over bolts or rivet heads. Apply stencil per 20-50-10, using BMS 10-11, type 2 enamel, BAC701 black gloss.
- G. On door assembly (1A, 1B) stencil "NO STEP" on interior side of door per Fig. 701. Make letters approximately 1 inch tall. Apply stencil per 20-50-10, using BMS 10-11, type 2 enamel, BAC701 black gloss.

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STENCIL PER 20-50-10
 APPROX 1.0 INCH LETTERS.
 USE BMS 10-11, TYPE 2,
 BAC 701 BLACK GLOSS ENAMEL.



ALL DIMENSIONS
 ARE IN INCHES

Door Assembly (1A,1B) "NO STEP" Stencil
 Figure 701

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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 Illustration 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 XXX and POST SB XXX.

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
(REPL, REPLD BY)

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

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VENDORS

- 06710 VALLEY-TODECO INCORPORATED
12975 BRADLEY AVENUE
SYLMAR, CALIFORNIA 91342-3830
FORMERLY IN NORTH HOLLYWOOD, CALIFORNIA
FORMERLY VALLEY BOLT CORP VB0097
- 06725 AIR INDUSTRIES CORPORATION
12570 KNOTT STREET
GARDEN GROVE, CALIFORNIA 92641-3932
FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
- 06950 SCREWCORP VSI CORP AEROSPACE PRODUCTS DIV FAIRCHILD IND INC
13001 EAST TEMPLE AVE. PO BOX 730
CITY OF INDUSTRY, CALIFORNIA 91746-1417
FORMERLY SCREWCORP VB0096 AND VSI CORP SCREWCORP DIV
FORMERLY IN CULVER CITY, CALIFORNIA
SCREW CORP. SEE V.S.I. CORP. SCREWCORP DIVISION
VSI CORP SCREW CORP DIV SEE SCREWCORP VSI CORP AEROSPACE
PRODUCTS DIV SUB OF FAIRCHILD IND INC
- 08524 DEUTSCH FASTENER CORP
1315 E GRAND AVE
EL SEGUNDO, CALIFORNIA 90245
FORMERLY IN LOS ANGELES, CALIFORNIA
- 11815 TOWNSEND DIV OF TEXTRON INC CHERRY FASTENER UNIT
BOX 2157 1224 EAST WARNER AVENUE
SANTA ANA, CALIFORNIA 92707
FORMERLY IN LOS ANGELES, CALIFORNIA
FORMERLY CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC V71087
CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC SEE
TOWNSEND DIV OF TEXTRON INC CHERRY FASTENER UNIT
- 15653 KAYNAR MICRODOT AEROSPACE FASTENING SYSTEM
800 SOUTH COLLEGE BLVD PO BOX 3001
FULLERTON, CALIFORNIA 92634
FORMERLY MICRODOT AEROSPACE FASTENING SYS DIV OF MICRODOT
INC IN PICO RIVERA, CALIFORNIA
MICRODOT AEROSPACE FASTENING SYS DIV OF MICRODOT INC SEE
KAYNAR MICRODOT AEROSPACE FASTENING SYSTEM
- 17943 FEDERAL MANUFACTURING CORPORATION
6910 FARMDALE AVENUE
NORTH HOLLYWOOD, CALIFORNIA 91605
FORMERLY VB0098

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VENDORS

27624 PAUL R BRILES INC P.B. FASTENER DIV
 1700 WEST 132ND STREET PO BOX 1157
 GARDENA, CALIFORNIA 90249
 FORMERLY P.B. FASTENER DIV OF PAUL BRILLES INC
 P.B. FASTENER DIV OF PAUL BRILES INC SEE PAUL R BRILES INC

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

56878 SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV
 HIGHLAND AVENUE
 JENKINTOWN, PENNSYLVANIA 19046
 USE APPLICABLE FACILITY CODE
 FORMERLY STANDARD PRESSED STEEL
 STANDARD PRESSED STEEL CO SEE SPS TECHNOLOGIES INC

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

72962 ELASTIC STOP NUT A DIV OF HARTFORD INDUSTRIES INC
 2330 VAUXHALL ROAD
 UNION, NEW JERSEY 07083
 FORMERLY AMERACE CORP ESNA DIV
 ESNA DIV OF AMERACE CORP SEE AMERACE CORP ESNA DIV
 ELASTIC STOP NUT DIV AMERACE CORP SEE ESNA DIV AMERACE CORP
 AMERACE CORP ESNA DIV SEE ELASTIC STOP NUT A
 DIV OF HARTFORD INDUST INC V72962

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
 FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539 AND STANDARD
 PRESSED STEEL WESTERN DIV V17279
 STANDARD PRESSED STEEL CO AEROSPACE PRODUCTS DIV SEE
 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV

83014 HARTWELL CORPORATION
 900 SOUTH RICHFIELD ROAD
 PLACENTIA, CALIFORNIA 92670
 FORMERLY V0532B IN LOS ANGELES, CALIFORNIA

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VENDORS

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

97928 DEUTSCH FASTENER CORP
3969 PARAMONT BOULEVARD
LAKEWOOD, CALIFORNIA 90712
FORMERLY DUMONT AVIATION ASSOC IN LONG BEACH, CALIFORNIA
FORMERLY LITTON FASTENING SYSTEMS DIV OF LITTON SYSTEMS INC
DUMONT AVIATION ASSOCIATES DIV OF LITTON IND SEE
LITTON FASTENING SYSTEMS DIV OF LITTON SYSTEMS INC SEE
DEUTSCH FASTENER CORP
LITTON FASTENING SYSTEMS DIV OF LITTON SYSTEMS INC

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN960JD416		1	70A	2
		1	120A	8
		2	55	8
AN960PD10		1	20	4
BACB30BL6		2	135	8
BACB30LH4-4		1	85	6
		2	20	6
BACB30LK3-2		1	15	4
BACB30LK4-3		1	180	4
		2	105	4
BACB30LK4-4		1	25	4
BACB30LK4-5		1	115	4
		2	50	4
BACB30NY6K4		2	5	12
BACB30VT6K5		2	130	8
BACC30X6		2	10	12
BACN10GW4		1	75A	2
BACN10JC4		1	130	4
BACN10JN3		1	190	4
BACN10JN4		1	135	6
		1	200	4
		2	80	6
		2	125	4
BACN10JP4A		1	40	4
BACR15BA3AD		1	45	8
		1	140	12
		1	195	8
		1	205	8
		2	75	12
		2	120	8
BACR15FT5AD		1	165	6
		2	90	6
BACS40R10E85F		1	90	1
		2	25	1
BACS40R10E87F		1	125	1
		2	65	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACS40R8E8F		1	35	4
BRFM20A3		1	190	4
BRFM20A4		1	135	6
		1	200	4
		2	80	6
		2	125	4
BRH10A4		1	130	4
BRM200A4		1	40	4
HL1187-6		2	10	12
HL13VAZ6-4		2	5	12
HL87-6		2	10	12
H10-4BAC		1	130	4
H712-5-188-370		2	15	2
L801-6K4		2	5	12
MF1000-3BAC		1	190	4
MF1000-4BAC		1	135	6
		1	200	4
MF1000-4BAC		2	80	6
		2	125	4
MK1000-4BAC		1	40	4
MS20253P5-950		1	95A	1
		2	35	1
MS21042L4		2	60	4
NAS6604-22		1	65A	2
NS103197-048		1	40	4
NS103218-02		1	190	4
NS103218-048		1	135	6
		1	200	4
		2	80	6
		2	125	4
NS202101-048		1	130	4
RMF9201M4		2	80	6
		2	125	4
RMLH9075-4W		1	130	4
S148T660-1		1	60A	1
T6S428J		1	130	4
T8076S428		1	40	4
T8124S3S		1	190	4
T8124S4S		1	135	6
		1	200	4
		2	80	6
		2	125	4

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
VN202A1-048		1	40	4
VN252A02		1	190	4
VN252A048		1	135	6
		1	200	4
		2	80	6
		2	125	4
VN303A048		1	130	4
148T6404-2		1	80	1
		2	30	1
148T6404-3		1	100	1
		2	40	1
148T6404-4		1	105	1
		2	45	1
148T6405-17		1	110	1
		2	70	1
148T6405-6		1	145	1
148T6405-6		2	85	1
148T6408-1		1	5	1
148T6408-2		1	10	1
148T6408-3		1	50	1
148T6408-4		1	55	1
148T6411-1		1	150	1
		2	95	1
148T6411-2		1	155	1
		2	100	1
148T6602-1		1	1	RF
		2	1	RF
148T6603-1		1	185	1
148T6603-3		2	115	1
148T6607-1		1	175	1
		2	110	1
148T6611-1		2	140	1

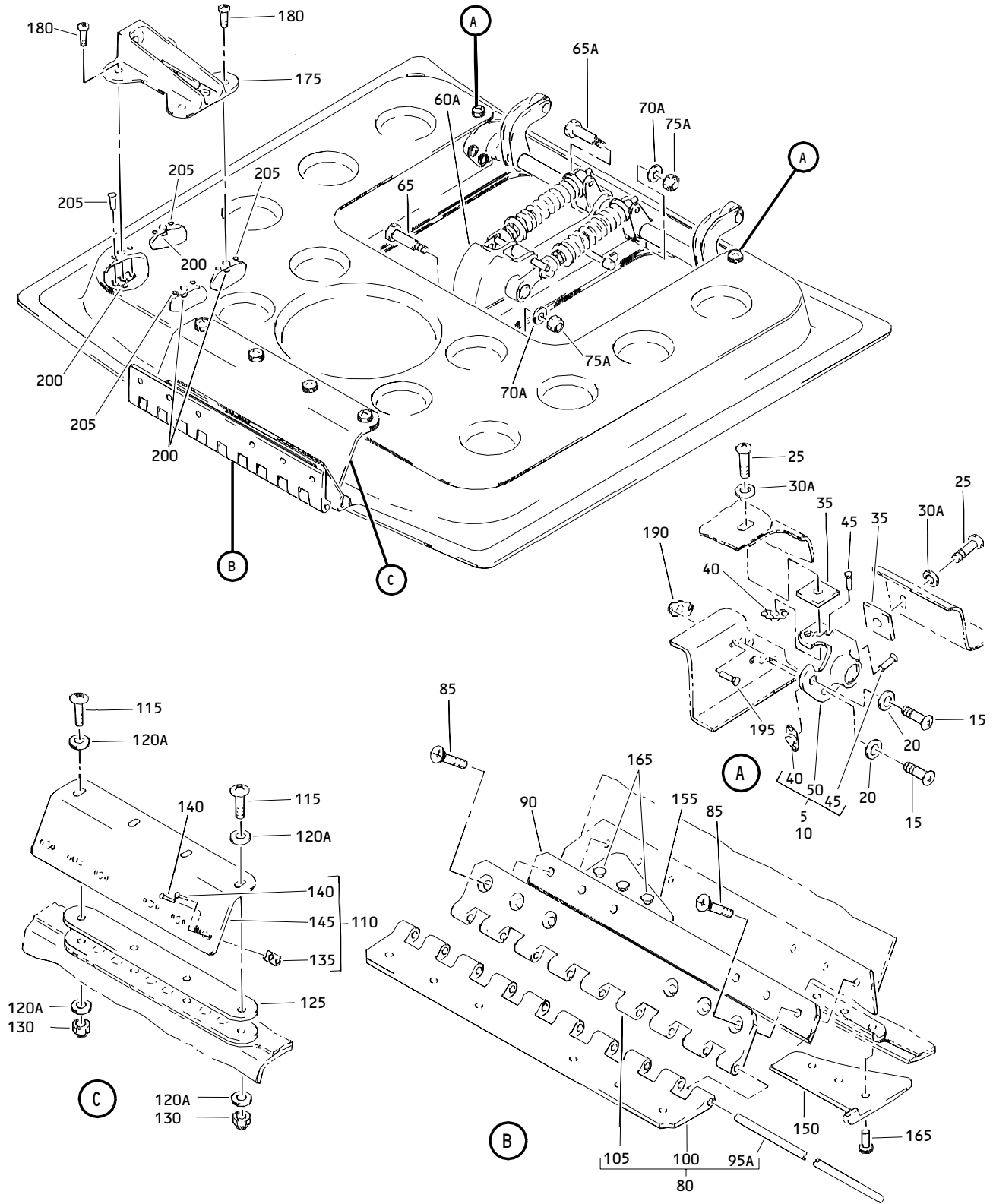
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
96-048		1	130	4

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Controls Bay Access Door Assembly
Figure 1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -1	148T6602-1		DOOR ASSY-CONTROLS BAY ACCESS	A	RF
R -1A	148T6602-2		DOOR ASSY-CONTROLS BAY ACCESS	B	RF
R -1B	148T6602-3		DOOR ASSY-CONTROLS BAY ACCESS (FOR DETAILS SEE FIG. 2)	C	RF
5	148T6408-1		.FITTING ASSY-LATCH BRG LH	A,B	1
10	148T6408-2		.FITTING ASSY-LATCH BRG RH	A,B	1
15	BACB30LK3-2		ATTACHING PARTS .BOLT- (V06710) (SPEC BACB30LK3-2) (OPT BACB30LK3-2 (V06725)) (OPT BACB30LK3-2 (V06950)) (OPT BACB30LK3-2 (V08524)) (OPT BACB30LK3-2 (V17943)) (OPT BACB30LK3-2 (V27624)) (OPT BACB30LK3-2 (V80539)) (OPT BACB30LK3-2 (V92215)) (OPT BACB30LK3-2 (V97928))	A,B	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 20 25	AN960PD10 BACB30LK4-4		.WASHER .BOLT- (V06710) (SPEC BACB30LK4-4) (OPT BACB30LK4-4 (V06725)) (OPT BACB30LK4-4 (V06950)) (OPT BACB30LK4-4 (V08524)) (OPT BACB30LK4-4 (V17943)) (OPT BACB30LK4-4 (V27624)) (OPT BACB30LK4-4 (V80539)) (OPT BACB30LK4-4 (V92215)) (OPT BACB30LK4-4 (V97928))	A,B A,B	4 4
R 30 30A 35	AN960PD416 AN960JD416 BACS40R8E8F		DELETED .WASHER .SHIM -----*	A,B A,B	4 4
40	BRM200A4		. .NUTPLATE- (V52828) (SPEC BACN10JP4A) (OPT MK1000-4BAC (V15653)) (OPT NS103197-048 (V80539)) (OPT T8076S428 (V71087)) (OPT T8076S428 (V11815)) (OPT VN202A1-048 (V92215)) ATTACHING PARTS	A,B	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-45	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST) -----*	A,B	4
50	148T6408-3		..FITTING-(LH SIDE)	A,B	1
-55	148T6408-4		..FITTING-(RH SIDE)	A,B	1
60	S148T660-1		DELETED		
60A	H2907-1		.LATCH ASSY- (V83014) (SPEC S148T660-1)	A,B	1
65	BACB30NF4-22		ATTACHING PARTS DELETED		
65A	NAS6604-22		.BOLT	A,B	2
70	AN960PD416		DELETED		
R 70A	AN960JD416		.WASHER	A,B	2
75	BRH10-4		DELETED		
75A	BACN10GW4		.NUT -----*	A,B	2
80	148T6404-2		.HINGE ASSY-SERVICE ACCESS ATTACHING PARTS	A,B	1
85	BACB30LH4-4		.BOLT- (V06710) (SPEC BACB30LH4-4) (OPT BACB30LH4-4 (V06725)) (OPT BACB30LH4-4 (V06950)) (OPT BACB30LH4-4 (V08524)) (OPT BACB30LH4-4 (V17943)) (OPT BACB30LH4-4 (V27624)) (OPT BACB30LH4-4 (V80539)) (OPT BACB30LH4-4 (V92215)) (OPT BACB30LH4-4 (V97928))	A,B	6

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R	01-90	BACS40R10E85F	.SHIM -----*-----	A,B	1
	95	MS20253P3-950	DELETED		
	95A	MS20253P5-950	..PIN-HINGE	A,B	1
	100	148T6404-3	..HINGE-HALF	A,B	1
	105	148T6404-4	..HINGE	A,B	1
	110	148T6405-17	.ANGLE ASSY-HINGE ATTACHING PARTS	A,B	1
	115	BACB30LK4-5	.BOLT- (V06710) (SPEC BACB30LK4-5) (OPT BACB30LK4-5 (V06725)) (OPT BACB30LK4-5 (V06950)) (OPT BACB30LK4-5 (V08524)) (OPT BACB30LK4-5 (V17943)) (OPT BACB30LK4-5 (V27624)) (OPT BACB30LK4-5 (V80539)) (OPT BACB30LK4-5 (V97928)) (OPT BACB30LK4-5 (V92215))	A,B	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R	01-		DELETED		
	120	AN960PD416	.WASHER	A,B	8
	120A	AN960JD416	.SHIM	A,B	1
	125	BACS40R10E87F	.NUT-	A,B	4
	130	H10-4BAC	(V15653) (SPEC BACN10JC4) (OPT NS202101-048 (V80539)) (OPT RMLH9075-4W (V72962)) (OPT T6S428J (V71087)) (OPT VN303A048 (V92215)) (OPT 96-048 (V80539)) (OPT BRH10A4 (V52828))		
	135	T8124S4S	-----*----- .NUTPLATE- (V71087) (SPEC BACN10JN4) (OPT BRFM20A4 (V52828)) (OPT MF1000-4BAC (V15653)) (OPT NS103218-048 (V80539)) (OPT VN252A048 (V92215)) (OPT VN252A048 (V92215)) ATTACHING PARTS	A,B	6
	140	BACR15BA3AD	..RIVET- (SIZE DETERMINE ON INST)	A,B	12
	145	148T6405-6	-----*----- ..ANGLE-ADJUST	A,B	1
	150	148T6411-1	.FAIRING-HINGE	A,B	1
	155	148T6411-2	.FAIRING-HINGE ATTACHING PARTS	A,B	1
	165	BACR15FT5AD	.RIVET- (SIZE DETERMINE ON INST)	A,B	6
	175	148T6607-1	-----*----- .FITTING-PIVOT	A,B	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 180	BACB30LK4-3		ATTACHING PARTS .BOLT- (V06710) (SPEC BACB30LK4-3) (OPT BACB30LK4-3 (V06725)) (OPT BACB30LK4-3 (V06950)) (OPT BACB30LK4-3 (V08524)) (OPT BACB30LK4-3 (V17943)) (OPT BACB30LK4-3 (V80539)) (OPT BACB30LK4-3 (V27624)) (OPT BACB30LK4-3 (V92215)) (OPT BACB30LK4-3 (V97928)) -----*	A,B	4
-185 190	148T6603-1 T8124S3S		.STRUCTURE ASSY .NUTPLATE- (V71087) (SPEC BACN10JN3) (OPT BRFM20A3 (V52828)) (OPT MF1000-3BAC (V15653)) (OPT NS103218-02 (V80539)) (OPT VN252A02 (V92215)) (OPT VN252A02 (V92215))	A,B A,B	1 4
195	BACR15BA3AD		ATTACHING PARTS .RIVET- (SIZE DETERMINE ON INST) -----*	A,B	8

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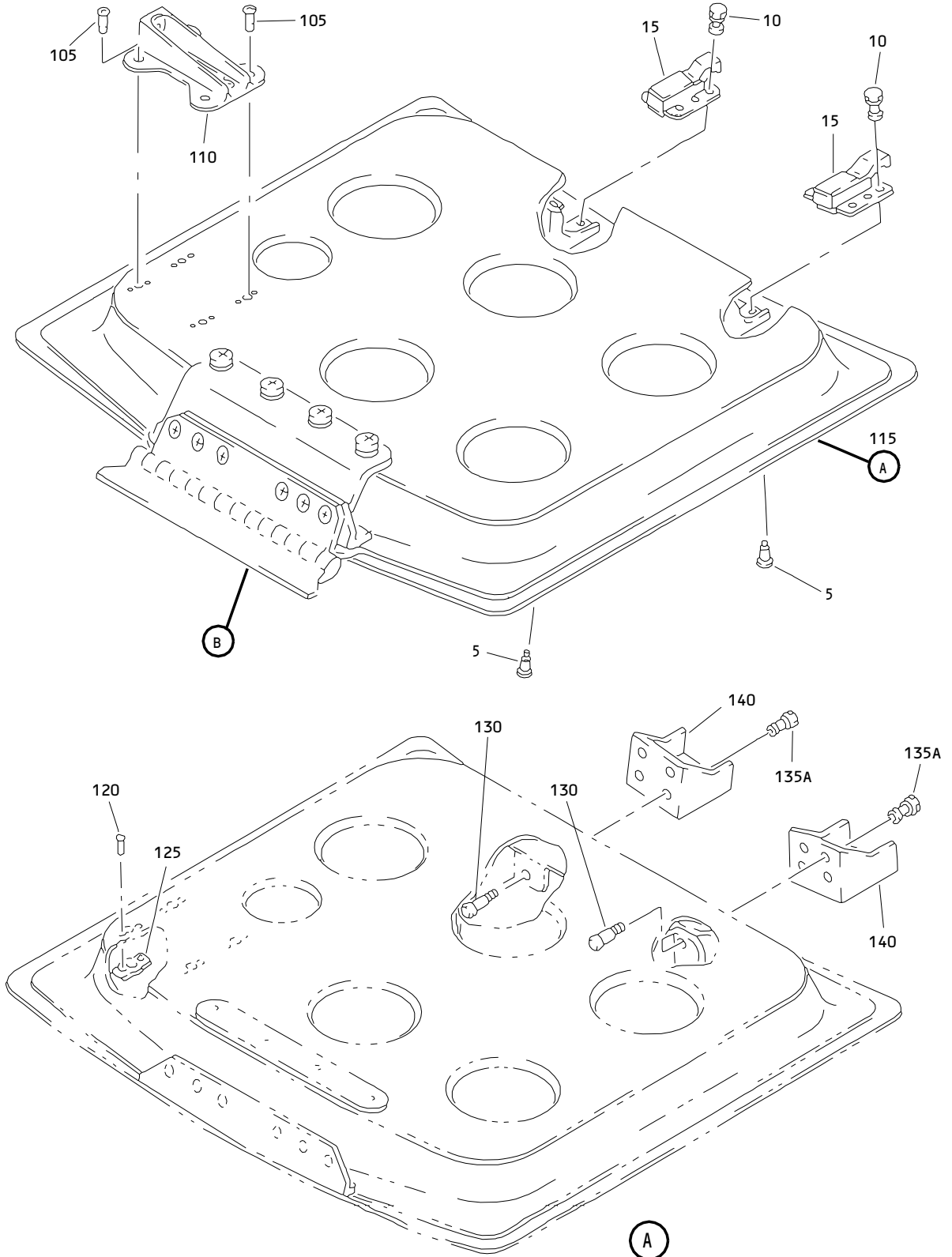
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
01-200	T8124S4S		..NUTPLATE- (V71087) (SPEC BACN10JN4) (OPT BRFM20A4 (V52828)) (OPT MF1000-4BAC (V15653)) (OPT NS103218-048 (V80539)) (OPT VN252A048 (V92215)) (OPT VN252A048 (V92215)) ATTACHING PARTS	A,B	4
205	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST) -----*-----	A,B	8

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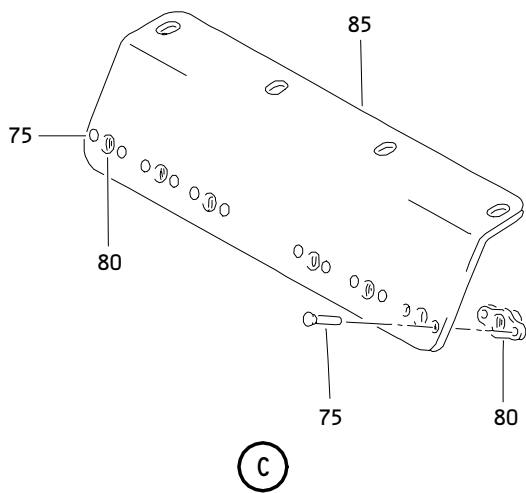
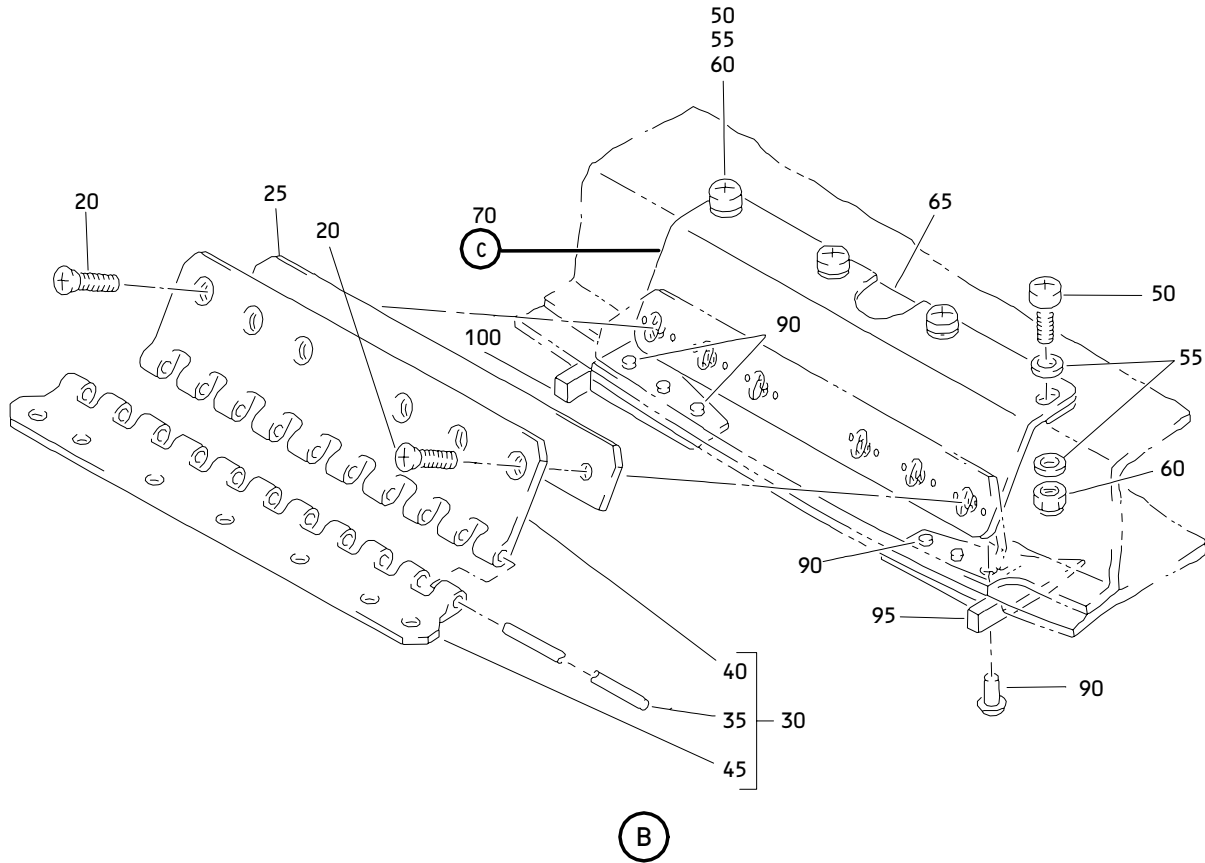
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Controls Bay Access Door Assembly
Figure 2 (Sheet 2)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02-1	148T6602-3		DOOR ASSY-CONTROLS BAY ACCESS	C	RF
R 5	HL13VAZ6-4		.BOLT- (V56878) (SPEC BACB30NY6K4) (OPT HL13VAZ6-4 (V73197)) (OPT HL13VAZ6-4 (V92215)) (OPT HL13VAZ6-4 (V97928)) (OPT L801-6K4 (V06725)) (OPT HL13VAZ6-4 (V08524))	C	12
R 10	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))	C	12
R 15	H712-5-188-370		.LATCH- (V83014)	C	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02-20	BACB30LH4-4		.BOLT- (V06710) (SPEC BACB30LH4-4) (OPT BACB30LH4-4 (V06725)) (OPT BACB30LH4-4 (V06950)) (OPT BACB30LH4-4 (V08524)) (OPT BACB30LH4-4 (V17943)) (OPT BACB30LH4-4 (V27624)) (OPT BACB30LH4-4 (V80539)) (OPT BACB30LH4-4 (V92215)) (OPT BACB30LH4-4 (V97928))	C	6
R 25	BACS40R10E85F		.SHIM	C	1
R 30	148T6404-2		.HINGE ASSY-SERVICE ACCESS	C	1
R 35	MS20253P5-950		..PIN-HINGE	C	1
R 40	148T6404-3		..HINGE-HALF	C	1
R 45	148T6404-4		..HINGE-HALF	C	1
R 50	BACB30LK4-5		.BOLT- (V06710) (SPEC BACB30LK4-5) (OPT BACB30LK4-5 (V06725)) (OPT BACB30LK4-5 (V06950)) (OPT BACB30LK4-5 (V08524)) (OPT BACB30LK4-5 (V17943)) (OPT BACB30LK4-5 (V27624)) (OPT BACB30LK4-5 (V80539)) (OPT BACB30LK4-5 (V97928)) (OPT BACB30LK4-5 (V92215))	C	4
R 55	AN960JD416		.WASHER	C	8
R 60	MS21042L4		.NUT	C	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02-65	BACS40R10E87F		.SHIM	C	1
R 70	148T6405-17		.ANGLE ASSY-HINGE	C	1
R 75	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	C	12
R 80	T8124S4S		..NUTPLATE- (V71087) (SPEC BACN10JN4) (OPT BRFM20A4 (V52828)) (OPT MF1000-4BAC (V15653)) (OPT NS103218-048 (V80539)) (OPT RMF9201M4 (V72962)) (OPT VN252A048 (V92215))	C	6
R 85	148T6405-6		..ANGLE-ADJUST	C	1
R 90	BACR15FT5AD		.RIVET- (SIZE DETERMINE ON INST)	C	6
R 95	148T6411-1		.FAIRING-HINGE LH	C	1
R 100	148T6411-2		.FAIRING-HINGE RH	C	1
R 105	BACB30LK4-3		.BOLT- (V06710) (SPEC BACB30LK4-3) (OPT BACB30LK4-3 (V06725)) (OPT BACB30LK4-3 (V06950)) (OPT BACB30LK4-3 (V08524)) (OPT BACB30LK4-3 (V17943)) (OPT BACB30LK4-3 (V80539)) (OPT BACB30LK4-3 (V27624)) (OPT BACB30LK4-3 (V92215)) (OPT BACB30LK4-3 (V97928))	C	4
R 110	148T6607-1		.FITTING-PIVOT	C	1
R 115	148T6603-3		.STRUCTURE ASSY	C	1
R 120	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	C	8

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02-125	T8124S4S		..NUTPLATE- (V71087) (SPEC BACN10JN4) (OPT BRFM20A4 (V52828)) (OPT MF1000-4BAC (V15653)) (OPT NS103218-048 (V80539)) (OPT RMF9201M4 (V72962)) (OPT VN252A048 (V92215))	C	4
R 130	BACB30VT6K5		..BOLT	C	8
R 135	BACB30BL6		..COLLAR	C	8
R 140	148T6611-1		..FITTING-LATCH SPRT	C	1

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