

 **BOEING**  
COMPONENT  
MAINTENANCE MANUAL

TO: ALL HOLDERS OF SERVICE ACCESS DOOR ASSEMBLY COMPONENT MAINTENANCE MANUAL  
52-49-41

REVISION NO. 4 DATED OCT 10/86

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.

TITLE PAGE

1

701-702

1009

DESCRIPTION OF CHANGE

Added new top assembly with "NO STEP" stencil on interior of door to indicate door is not to be used as a work platform.

1002-1005,1009-1015

Update vendor information.

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HIGHLIGHTS

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SERVICE ACCESS DOOR ASSEMBLY  
PART NUMBER 148T6402-1,-2

COMPONENT MAINTENANCE MANUAL  
WITH  
ILLUSTRATED PARTS LIST

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TITLE PAGE

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T22048



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

T22046

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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

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TR &amp; SB RECORD

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PAGE	DATE	CODE	PAGE	DATE	CODE
52-49-41			ASSEMBLY		
			*701	OCT 10/86	01.1
			*702	OCT 10/86	01.1
TITLE PAGE			ILLUSTRATED PARTS LIST		
*1	OCT 10/86	01.1	1001	JUL 10/83	01
2	BLANK		*1002	OCT 10/86	01.1
REVISION RECORD			*1003	OCT 10/86	01.1
1	JUL 10/83	01	*1004	OCT 10/86	01.1
2	BLANK		*1005	OCT 10/86	01.1
TR & SB RECORD			*1006	BLANK	
1	JUL 10/83	01	*1007	OCT 10/86	01.101
2	BLANK		*1008	OCT 10/86	01.101
LIST OF EFFECTIVE PAGES			*1009	OCT 10/86	01.1
*1	OCT 10/86	01	*1010	OCT 10/86	01.1
THRU LAST PAGE			*1011	OCT 10/86	01.1
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1	JUL 10/83	01	*1013	OCT 10/86	01.1
2	BLANK		*1014	OCT 10/86	01.1
INTRODUCTION			*1015	OCT 10/86	01.1
1	JUL 10/83	01	*1016	BLANK	
2	BLANK				
DESCRIPTION & OPERATION					
1	JUL 10/83	01			
2	BLANK				
CHECK					
501	JUL 10/83	01			
502	BLANK				
REPAIR 1-1					
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602	JUL 10/85	01.1			
603	JUL 10/83	01			
604	BLANK				

\* = REVISED, ADDED OR DELETED

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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 &<br>Service Bulletin Record | 6. Introduction              |
|  | 7. Procedures & IPL Sections |

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

The beginning of the REPAIR section includes a list of the separate repairs, a list of applicable standard Boeing practices (Chapter 20), 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.

For repair of structural components, refer to the appropriate structural repair manual.

Verification:

Assembly

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INTRODUCTION

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SERVICE ACCESS DOOR ASSEMBLY

DESCRIPTION AND OPERATION

1. Description and Operation

A. The service access door assembly is located just below the leading edge of the left hand horizontal stabilizer. The service access door is hinged on the forward edge and latched on the aft edge, and swings down when opened. The service access door provides access to the aft electronic equipment bay, for the purpose of maintenance and repair of equipment located in the bay.

2. Leading Particulars (Approximate)

- A. Weight -- 13 pounds
- B. Length -- 24 inches
- C. Width -- 22 inches
- D. Thickness -- 3 inches

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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. Penetrant check per 20-20-02 -- Fittings (5, 65, 70) and hinge fairings (165, 170).

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CHECK  
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REPAIR 1-1

1. Repair of these parts consists of restoration of original finish.
2. Standard Practices
  - A. Refer to the following standard practices, as applicable, for details of procedures in Repair 1-1.
    - 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
    - 20-43-01 Chromic Acid Anodizing
    - 20-44-01 Application of Abrasion Resistant Finishes

3. Materials

NOTE: Equivalent substitutes may be used.

- A. Coating, chemical -- Alodine 1000, class B (clear)
- B. Coating, Teflon filled -- BMS 10-86, type 1 white (Ref 20-60-04)
- C. Enamel -- BMS 10-60, BAC707 gray gloss (Ref 20-60-02)
- D. Primer -- BMS 10-11, type 1 (Ref 20-60-02)
  - BMS 10-11, type 1, yellow (Ref 20-60-02)

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IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 1</u>		
Fitting (5,65,70)	Aluminum alloy	Chromic acid anodize, type 1 and apply one coat BMS 10-11, type 1 primer (F-18.13) all over.
Hinge assy (95)	Aluminum alloy	Apply one coat BMS 10-11, type 1 yellow primer (SRF-14.995), apply BMS 10-60 BAC707 gray gloss enamel (SRF-14.9813), all over.
Hinge half (115, 120)	Aluminum alloy	Chromic acid anodize, type 1 and apply one coat BMS 10-11, type 1 primer (F-18.13) omit primer from holes.
Hinge Fairing (165,170)	Aluminum alloy	Chromic acid anodize, type 1 and apply one coat BMS 10-11, type 1 primer (F-18.13), apply BMS 10-60, BAC707 gray gloss enamel (SRF-14.9813), all over.
Adjust angle (160)	Aluminum alloy	Chemically treat (colored film), apply one coat BMS 10-11, type 1 primer (F-18.06), all over.
Structure assy (190)	Aluminum alloy	Exterior apply alodine 1000, class B (clear) by immersion (F-14.05). Interior surfaces chemically treat (colored film), apply one coat BMS 10-11, type 1 primer (F-18.06). Apply BMS 10-86, type 1 white per 20-44-01, type 27 (SRF-14.9624) as shown on Fig. 602.

Refinish Details  
Figure 601

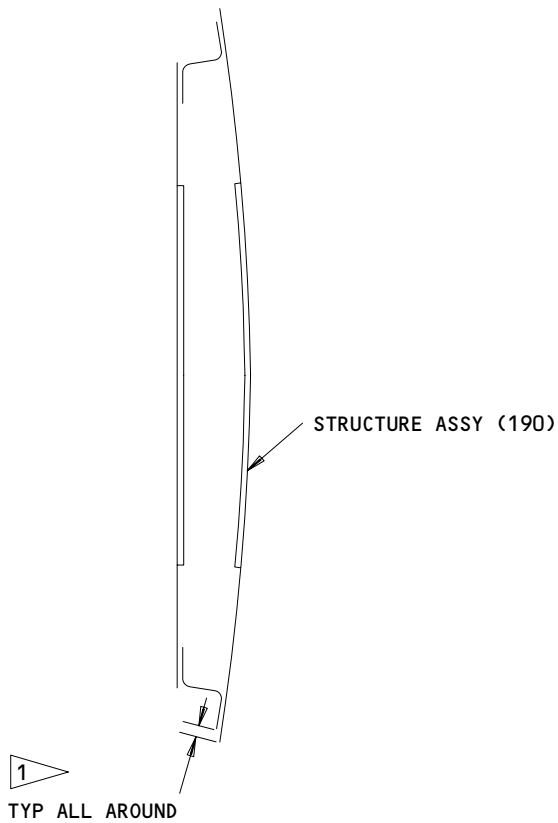
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1 APPLY BMS 10-86, TYPE 1 WHITE  
PER 20-44-01 TYPE 27 (SRF  
14-9624).

Refinish of Structure Assembly  
Figure 602

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REPAIR 1-1

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ASSEMBLY

1. Materials

NOTE: Equivalent substitutes may be used.

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

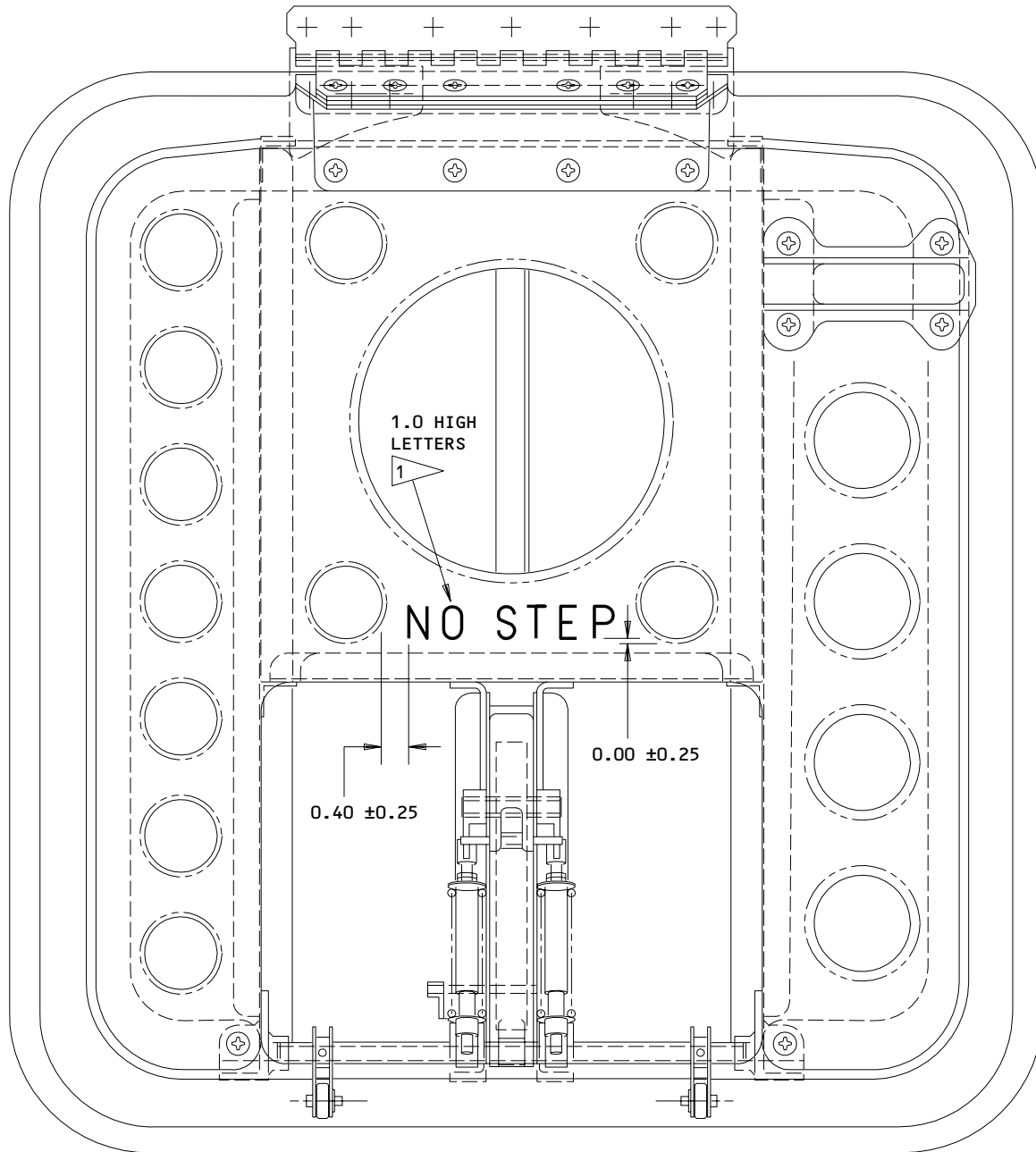
2. Assembly (IPL Fig. 1)

- A. Use standard industry practices for assembly of this component and the following additional procedures.
- B. Delaminate shim (50) as necessary on installation of latch assembly (75), after delamination install shim with BMS 10-11, type 1 primer either wet or dry.
- C. Adjustment of shims (105, 140) will be accomplished when door is installed on airplane.
- D. Restencil ID No. 312AR to internal face of door assembly (1, 1A). Use BMS 10-11, type 2 enamel BAC701 black gloss, making characters 0.50 inch high. Stencil should not be applied over bolt or rivet heads.
- E. Restencil "NO STEP" to internal face of door assembly (1A). Stencil per 20-50-10 and Fig. 701 using BMS 10-11, type 2 enamel BAC701 black gloss, making characters 1.0 inch high.

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1 STENCIL LETTERS PER 20-50-10  
USING BMS 10-11, TYPE 2,  
BAC 701 BLACK GLOSS.

"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 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

06710 VALLEY-TODECO INCORPORATED  
12975 BRADLEY AVENUE  
SYLMAR, CALIFORNIA 91342

06725 AIR INDUSTRIES CORPORATION  
12570 KNOTT STREET  
GARDEN GROVE, CALIFORNIA 92641

06950 SCREWCORP VSI CORP AEROSPACE PRODUCTS DIV FAIRCHILD IND INC  
13001 EAST TEMPLE AVE. PO BOX 730  
CITY OF INDUSTRY, CALIFORNIA 91746

08524 DEUTSCH FASTENER CORP  
1315 E GRAND AVE  
EL SEGUNDO, CALIFORNIA 90245

11815 TOWNSEND DIV OF TEXTRON INC CHERRY FASTENER UNIT  
BOX 2157 1224 EAST WARNER AVENUE  
SANTA ANA, CALIFORNIA 92707

15653 KAYNAR MICRODOT AEROSPACE FASTENING SYSTEM  
800 SOUTH COLLEGE BLVD PO BOX 3001  
FULLERTON, CALIFORNIA 92634

17943 FEDERAL MANUFACTURING CORPORATION  
6910 FARMDALE AVENUE  
NORTH HOLLYWOOD, CALIFORNIA 91605

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

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

71087 SEE V11815

72962 ELASTIC STOP NUT A DIV OF HARTFORD INDUSTRIES INC  
2330 VAUXHALL ROAD  
UNION, NEW JERSEY 07083

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

83014 HARTWELL CORPORATION  
900 SOUTH RICHFIELD ROAD  
PLACENTIA, CALIFORNIA 92670

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

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN960PD416		1	15	4
		1	45	4
		1	85	2
		1	135	8
BACB30LH4-4		1	100	6
BACB30LK3-2		1	30	4
BACB30LK4-3		1	10	4
BACB30LK4-4		1	40	4
BACB30LK4-5		1	130	4
BACN10GW4		1	90A	2
BACN10JC4		1	145	4
BACN10JN3		1	195	4
BACN10JN4		1	150	6
		1	197	4
BACN10JP4A		1	55	4
BACR15BA3AD		1	60	8
		1	155	12
		1	200	16
BACR15FT5AD		1	175	6
BACS40R10E85F		1	105	1
BACS40R10E87F		1	140	1
BACS40R8E8F		1	50	4
BRFM20A3		1	195	4
BRFM20A4		1	150	6
		1	197	4
BRH10A4		1	145	4
BRM200A4		1	55	4
H10-4BAC		1	145	4
H2907-3		1	75C	1
MF1000-3BAC		1	195	4
MF1000-4BAC		1	150	6
		1	197	4
MK1000-4BAC		1	55	4
MS20253P5-950		1	110A	1
NAS6604-22		1	80A	2
NS103197-048		1	55	4
NS103218-02		1	195	4
NS103218-048		1	150	6
		1	197	4
NS202101-048		1	145	4
S148T660-2		1	75C	1
T6S428J		1	145	4
T8076S428		1	55	4
T8124S3S		1	195	4
T8124S4S		1	150	6
		1	197	4

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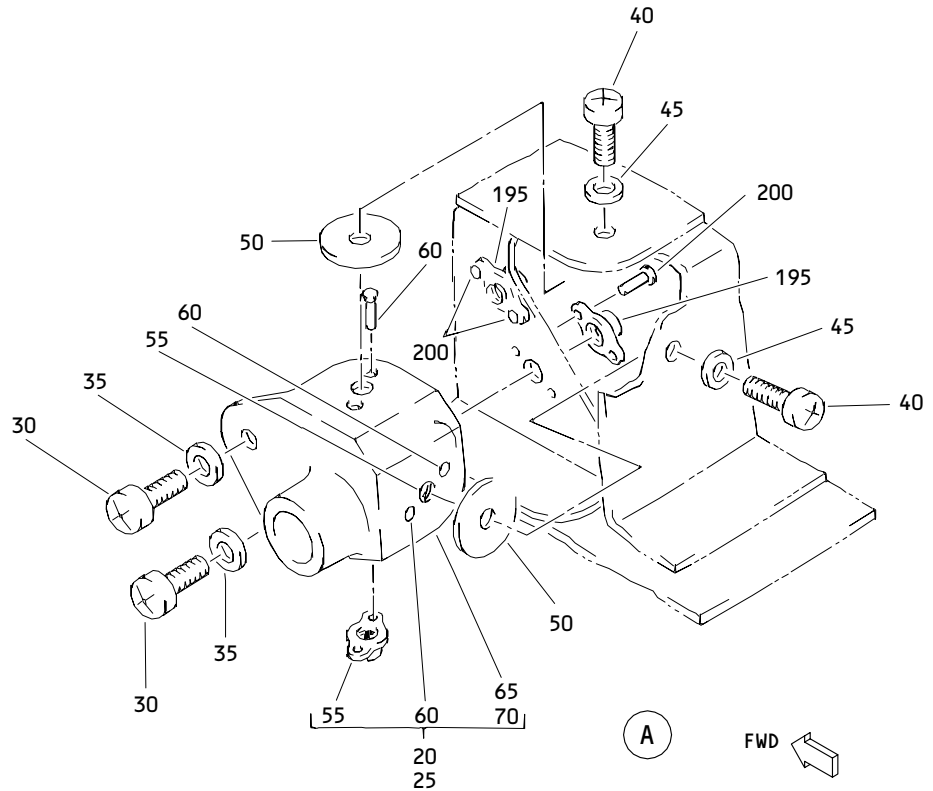
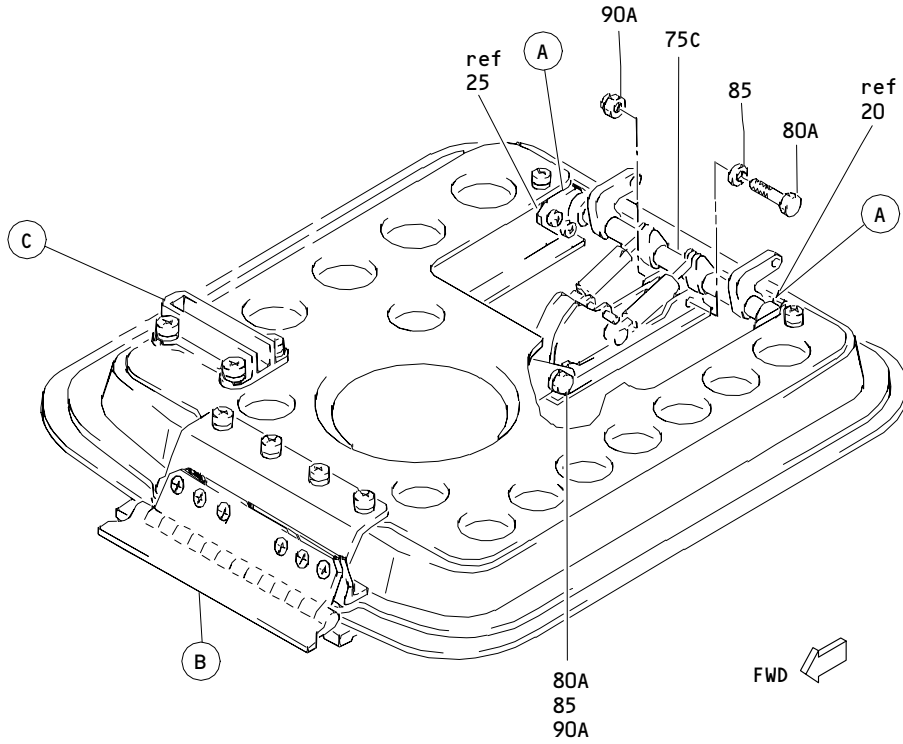
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
VN202A1-048		1	55	4
VN252A02		1	195	4
VN252A048		1	150	6
		1	197	4
VN303A048		1	145	4
148T6402-1		1	1	RF
148T6402-2		1	1A	RF
148T6403-1		1	190	1
148T6404-1		1	95	1
148T6404-4		1	120	1
148T6404-5		1	115	1
148T6405-17		1	125	1
148T6405-6		1	160	1
148T6406-1		1	5	1
148T6408-1		1	20	1
148T6408-2		1	25	1
148T6408-3		1	65	1
148T6408-4		1	70	1
148T6411-1		1	165	1
148T6411-2		1	170	1
96-048		1	145	4

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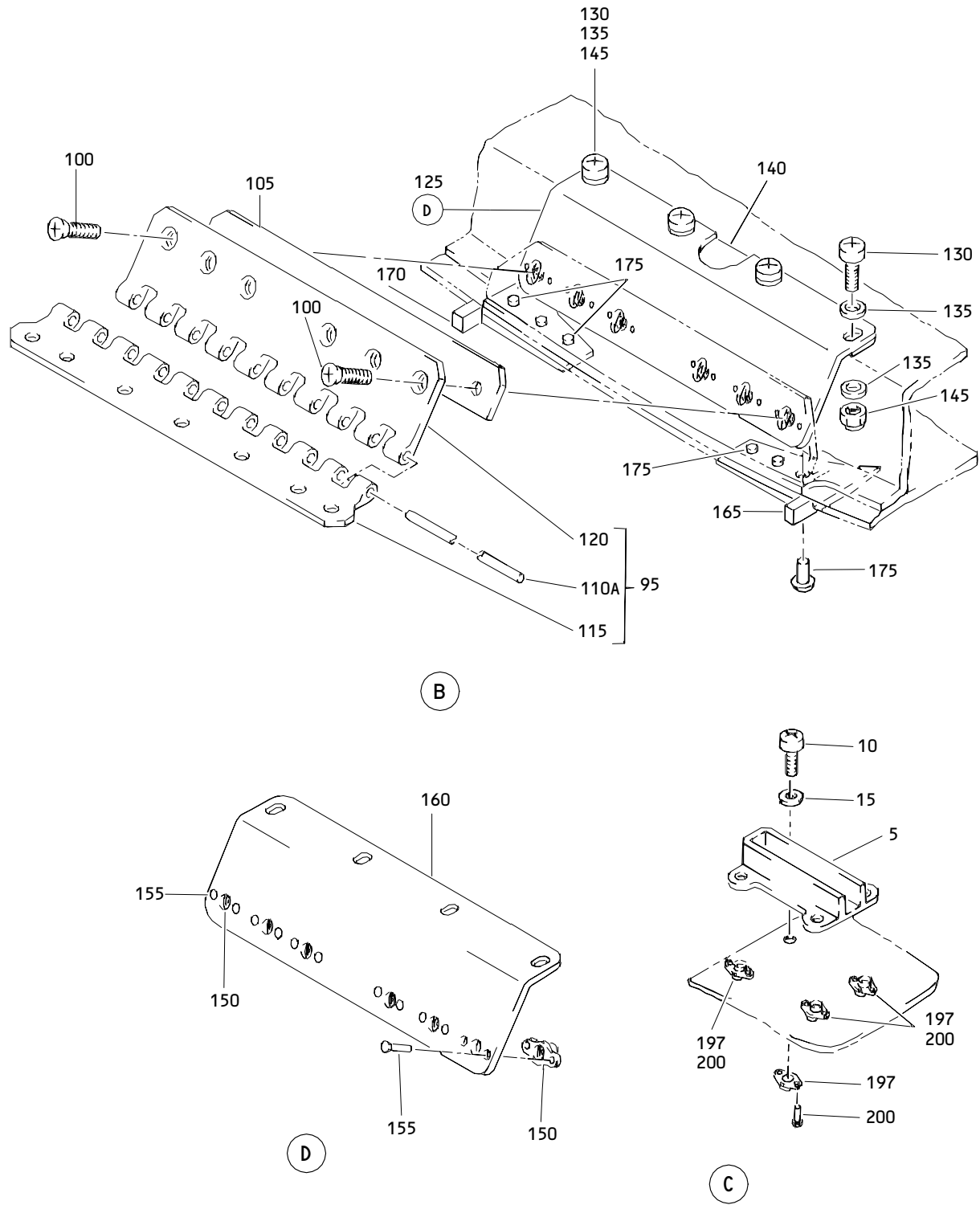
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Service Access Door Assembly  
 Figure 1 (Sheet 1)

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Service Access Door Assembly  
 Figure 1 (Sheet 2)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R	01-				
	-1	148T6402-1	DOOR ASSY-SERVICE ACCESS	A	RF
	-1A	148T6402-2	DOOR ASSY-SERVICE ACCESS	B	RF
	5	148T6406-1	.FITTING-HOLD OPEN STRUT PIVOT		1
	10	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))		4
	15	AN960PD416	.WASHER -----*		4
	20	148T6408-1	.FITTING ASSY-LATCH BEARING LH		1
	25	148T6408-2	.FITTING ASSY-LATCH BEARING RH		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 30	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))		4
35 40	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))		4 4
45 50	AN960PD416 BACS40R8E8F		.WASHER .SHIM -----*-----		4 4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-55	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		2
60	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST) -----*-----		4
65	148T6408-3		..FITTING-(LH)		1
70	148T6408-4		..FITTING-(RH)		1
75	H2907-3		DELETED		
75A	S148T660-2		DELETED		
75B	H2907-2		DELETED		
75C	H2907-3		.LATCH ASSY- (V83014) (SPEC S148T660-2) ATTACHING PARTS		1
80	BACB30NF4-22		DELETED		
80A	NAS6604-22		.BOLT		2
85	AN960PD416		.WASHER		2
90	BRH10-4		DELETED		
90A	BACN10GW4		.NUT -----*-----		2
95	148T6404-1		.HINGE ASSY		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
100	BACB30LH4-4		ATTACHING PARTS .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))		6
105	BACS40R10E85F		.SHIM -----*-----		1
110	MS20253P3-950		DELETED		
110A	MS20253P5-950		..PIN		1
115	148T6404-5		..HINGE HALF		1
120	148T6404-4		..HINGE HALF		1
125	148T6405-17		.ANGLE ASSY-HINGE		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
130	BACB30LK4-5		ATTACHING PARTS .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))		4
135	AN960PD416		.WASHER		8
140	BACS40R10E87F		.SHIM		1
145	H10-4BAC		.NUT- (V15653) (SPEC BACN10JC4) (OPT NS202101-048 (V80539)) (OPT RMLH9075-4W (V72962)) (OPT T6S428J (V71087)) (OPT VN303A048 (V92215)) (OPT 96-048 (V80539)) (OPT BRH10A4 (V52828)) -----*		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-150	T8124S4S		..NUTPLATE- (V71087) (SPEC BACN10JN4) (OPT BRFM20A4 (V52828)) (OPT MF1000-4BAC (V15653)) (OPT NS103218-048 (V80539)) (OPT VN252A048 (V92215)) (OPT VN252A048 (V92215)) ATTACHING PARTS		6
155	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST) -----*-----		12
160	148T6405-6		..ANGLE-ADJUST		1
165	148T6411-1		.FAIRING-HINGE		1
170	148T6411-2		.FAIRING-HINGE ATTACHING PARTS		1
175	BACR15FT5AD		.RIVET- (SIZE DETERMINE ON INST) -----*-----		6
-190	148T6403-1		.STRUCTURE ASSY		1
195	T8124S3S		..NUTPLATE- (V71087) (SPEC BACN10JN3) (OPT BRFM20A3 (V52828)) (OPT MF1000-3BAC (V15653)) (OPT NS103218-02 (V80539)) (OPT VN252A02 (V92215)) (OPT VN252A02 (V92215))		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
01-197	T8124S4S		..NUTPLATE- (V71087) (SPEC BACN10JN4) (OPT BRFM20A4 (V52828)) (OPT MF1000-4BAC (V15653)) (OPT NS103218-048 (V80539)) (OPT VN252A048 (V92215)) (OPT VN252A048 (V92215)) ATTACHING PARTS		4
200	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST) -----*-----		16

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