

 **BOEING**  
COMPONENT  
MAINTENANCE MANUAL

TO: ALL HOLDERS OF ACCESS DOOR ASSEMBLY COMPONENT MAINTENANCE MANUAL 54-52-11

REVISION NO. 2 DATED NOV 01/99

HIGHLIGHTS

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

CHAPTER/SECTION

AND PAGE NO.

DESCRIPTION OF CHANGE

TITLE PAGE

Added top assemblies P/N 313T3100-103, -105, -106,  
-108, -111.

1

1002,1004-1012,  
1015-1016,1021-1039,  
1041-1047

DESCRIPTION & OPERATION Edited without technical change.

1

501-502

Clarified Check section.

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HIGHLIGHTS

01.1

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## STRUT FAIRING ASSEMBLIES (JT9D-7R4)

PART NUMBERS 313T3100-2,-4,-59,-60,-88 THRU  
-90,-94 THRU -96,-99  
THRU -101,-103,-105,  
-106,-108,-111

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

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

01

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*1020	NOV 01/99	01.1			
*1021	NOV 01/99	01.1			
*1022	NOV 01/99	01.1			
*1023	NOV 01/99	01.1			
*1024	NOV 01/99	01.1			
*1025	NOV 01/99	01.1			
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*1035	NOV 01/99	01.1			
*1036	NOV 01/99	01.1			
*1037	NOV 01/99	01.1			
*1038	NOV 01/99	01.1			
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*1041	NOV 01/99	01.1			
*1042	NOV 01/99	01.1			
*1043	NOV 01/99	01.1			
*1044	NOV 01/99	01.1			
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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.

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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STRUT FAIRING ASSEMBLIES (JT9D-7R4)DESCRIPTION AND OPERATION1. Description and Operation

A. The strut fairing assemblies give the strut a smooth surface so that the airflow is not blocked. There are three different assemblies. The assemblies are the forward, the mid and the aft section assembly. Each section assembly has a panel assembly. The panel assembly has a honeycomb-sandwich core. The core has a fiberglass/epoxy surface. The forward section is kept by bolts. The mid section is kept by pin latches to the forward section and hook latches to the aft section. The aft section also is kept by bolts. It has a pressure relief door assembly.

## 2. Leading Particulars (approximate)

Length -- 82 inches  
Width -- 30 inches  
Height -- 15 inches  
Weight -- 30 pounds

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DISASSEMBLY

NOTE: Disassemble this component only as necessary to isolate defects, do necessary repairs, and put the component back in a serviceable condition.

1. Use standard industry practices to disassemble this component.

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DISASSEMBLY

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### CLEANING

CAUTION: DO NOT USE CHLORINATED AGENTS SUCH AS METHYLENE CHLORIDE, TRICHLOROETHYLENE, AND TRICHLOROETHANE TO REMOVE THE GREASE FROM THE GRAPHITE ARAMID EPOXY STRUCTURES. THE CHLORINATED AGENTS WILL CAUSE DAMAGE TO THE GRAPHITE/ARAMID EPOXY STRUCTURES.

1,1,1 - TRICHLOROETHANE IS A SOLVENT. IT IS PERMITTED TO USE THIS TRICHLOROETHANE TO CLEAN THE COMPOSITE COMPONENTS. DO NOT PUT THE PARTS INTO THE SOLVENT. DO NOT PERMIT THE SOLVENT TO STAY ON THE PARTS. DAMAGE CAN OCCUR. USE TRICHLOROETHANE ONLY AS A SOLVENT TO WIPE THE PARTS.

1. Use standard industry practices to clean all parts (Ref 20-30-03), but not the rubber seals. Use the manufacturer's instructions to clean the bearings as necessary.
2. Clean the seals (310, 315, Fig. 2) with a solution of a weak soap and water.

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CLEANING  
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CHECK| 1. General

- | A. This section has the necessary data to do a complete check of the strut fairing assemblies.
- | B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM chapters identified in this procedure.
- | C. Refer to the IPL figure noted for item numbers.

| 2. Strut Fairing Assembly

## | A. References

- | (1) SOPM 20-20-01, Magnetic Particle Inspection
- | (2) SOPM 20-20-02, Penetrant Methods of Inspection

## | B. Procedure

- | (1) Do a visual check:
  - | (a) Use standard industry procedures to examine all of the parts for defects.
  - | (b) Do a check of the seals to make sure that they are not worn or damaged.
- | (2) Do the magnetic particle check or the penetrant check if cracks or damage are seen or if you think there are cracks or damage:
  - | (a) Do a magnetic particle check (SOPM 20-20-01) on these parts:
    - | 1) Bolt index nut (10; Fig. 2)

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CHECK

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- 2) Plate (45; Fig. 2)
- (3) Do a check of the honeycomb structure:
  - (a) Do a check of the honeycomb and the bonded parts for delamination, internal water, scratches, and contour damage.
    - 1) If you see delamination or contour damage, do an ultrasonic check or a tap test to find all the damage.

NOTE: For a tap test use a solid metal disk and refer to the 767 Non-Destructive Test Manual, Part 1, 51-05-01.
    - 2) Examine areas that you think contain water radiographically or by thermography as shown in the 767 Non-Destructive Test Manual, Part 9, 51-00-01.
  - (b) Refer to the applicable 767 Structural Repair Manual (SRM) 54-20-70 for allowable damage and repair data.

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REPAIR – GENERAL1. Content

- A. Instructions for repair, refinish and replacement are divided into procedures as follows:

<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
313T3100	LUG ASSEMBLY	1-1
- - - -	REFINISH OF OTHER PARTS	2-1

2. Standard Practices

- A. Refer to these standard practices for details of the procedures in the repairs:

20-10-06 Repair of Conductive Coatings  
 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  
 20-50-03 Bearing Removal, Installation and Retention  
 20-60-02 Finishing Materials  
 20-60-04 Miscellaneous Materials

3. Materials

NOTE: Equivalent replacements can be used.

- A. Primer -- BMS 10-11, type 1 (Ref 20-60-02)  
 B. Conductive layer - BMS 10-21, type 1 (Ref 20-10-06)  
 C. Primer - BMS 10-79, type 2 (Ref 20-60-02)  
 D. Primer -- BMS 10-79, type 3 (Ref 20-60-02)

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—	STRAIGHTNESS	⊕	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
▭	FLATNESS	∅	DIAMETER
⊥	PERPENDICULARITY (OR SQUARENESS)	S ∅	SPHERICAL DIAMETER
//	PARALLELISM	R	RADIUS
○	ROUNDNESS	SR	SPHERICAL RADIUS
⊙	CYLINDRICITY	( )	REFERENCE
⌒	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.
△	PROFILE OF A SURFACE	<b>DIM</b>	
◎	CONCENTRICITY	<b>-A-</b>	DATUM
≡	SYMMETRY	Ⓜ	MAXIMUM MATERIAL CONDITION (MMC)
∠	ANGULARITY	Ⓛ	LEAST MATERIAL CONDITION (LMC)
↗	RUNOUT	Ⓢ	REGARDLESS OF FEATURE SIZE (RFS)
↗↗	TOTAL RUNOUT	Ⓟ	PROJECTED TOLERANCE ZONE
⊐	COUNTERBORE OR SPOTFACE	FIM	FULL INDICATOR MOVEMENT
∇	COUNTERSINK		

**EXAMPLES**

**— 0.002**

STRAIGHT WITHIN 0.002

**◎ ∅ 0.0005 C**

CONCENTRIC TO C WITHIN 0.0005 DIAMETER

**⊥ 0.002 B**

PERPENDICULAR TO B WITHIN 0.002

**≡ 0.010 A**

SYMMETRICAL WITH A WITHIN 0.010

**// 0.002 A**

PARALLEL TO A WITHIN 0.002

**∠ 0.005 A**

ANGULAR TOLERANCE 0.005 WITH A

**○ 0.002**

ROUND WITHIN 0.002

**⊕ ∅ 0.002 Ⓢ B**

LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE

**⊙ 0.010**

CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER

**⊥ ∅ 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

**⌒ 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

**2.000**

THEORETICALLY EXACT DIMENSION IS 2.000

**▭ 0.020 A**

SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE

OR  
2.000  
BSC

**NOTE:** DATUM MAY APPEAR AT EITHER SIDE OF TOLERANCE FRAME

**0.020 A**

**A 0.020**

True Position Dimensioning Symbols  
 Figure 601

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LUG ASSEMBLY - REPAIR 1-1

313T3100-55, -56

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

1. The Bushing Replacement (460, IPL Fig. 2)

- A. Remove the bushing.
- B. Install the new bushing. Roller swage or anvil swage per 20-50-03.

2. Refinish

- A. Lug (465) -- Cadmium plate. Apply one layer of BMS 10-11, type 1 primer (F-16.01) per 20-41-02. Material: 15-5PH, 150-170 ksi.

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REFINISH OF OTHER PARTS - REPAIR 2-1

1. Instructions given in Fig. 601 are to repair the finishes of the items.

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 1</u> Nose assembly (30)	Al alloy	Interior: Chemical treat. Apply one layer of BMS 10-11, type 1 primer (F-18.06). Exterior: Chemical treat (F-17.07). Apply one layer of BMS 10-79, type 2 primer (F-19.46).
Panel assembly (35, 35A, Fig. 1; 170, Fig. 3)	Aramid/epoxy honeycomb sandwich, Al foil on the interior surface	Exterior (only): Prepare the surface. Apply the resins, the pinhole fillers and the surfacers per 20-10-06 (F-14.672). Apply a conductive layer of BMS 10-21, type 1 per 20-10-06 (F-14.68). Apply one layer of BMS 10-79, type 2 primer (F-19.46).
Panel assembly (35B, 35C, Fig. 1; 605A, Fig. 2; 170A, Fig. 3)	Aramid/epoxy honeycomb sandwich, Al foil on the interior surface	Interior: Chemical treat (F-17.07). Apply one layer of BMS 10-79, type 3 primer (F-19.47). Exterior: Prepare the surface. Apply the resins, the pinhole fillers and the surfacers per 20-10-06 (F-14.672). Apply a conductive layer of BMS 10-21, type 1 per 20-10-06 (F-14.68). Apply one layer of BMS 10-79, type 3 primer (F-19.46).

Refinish Details  
Figure 601 (Sheet 1)

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REPAIR 2-1

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IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 2</u>		
Nut-bolt index (10)	PH 13-8, 215-235 ksi	Passivate (F-17.09).
Doubler plate (15), washer (20), clip (60,65,75,80,180,190,195), latch plate (140,385), attach bracket (165,170), latch channel (215,220,240,245), brace (260,265), frame (280,550), latch outer angle (485,490), latch inner angle (505,510), longeron (555,560)	Al alloy	Chemical treat. Apply one layer of BMS 10-11, type 1 primer per 20-41-02 (F-18.06).
Attach angle (405,410,430,435,530,535)	17-7 PH, 150-170 ksi	Cadmium plate. Apply one layer of BMS 10-11, type 1 primer per 20-41-02 (F-16.01).
Plate (45)	PH 13-8, 220-240 ksi	Passivate (F-17.09). Apply two layers of BMS 10-11, type 1 primer per 20-41-02 (F-20.03) to the side without serrations.
Seal retainer (300,305)	Al alloy	Chromic acid anodize. Apply one layer of BMS 10-11, type 1 primer (F-18.13).
Strap (575,595,600)	301 cres	Cadmium plate (F-15.06).

Refinish Details  
 Figure 601 (Sheet 2)

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IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 3</u>		
Latch striker (25)	301 cres	Passivate (F-17.09). Apply two layers of BMS 10-11, type 1 primer per 20-41-02 (F-20.03) on the near surface only.
Panel assembly (115)	Honeycomb core, Al alloy interior and exterior surface	Exterior: Chemical treat (F-17.07). Apply one layer of BMS 10-79, type 2 primer (F-19.46). Interior: Apply two layers of BMS 10-11, type 1 primer per 20-41-02 (F-20.03).
Upper filler (125 thru 140)	Al alloy	Chemical treat. Apply one layer of BMS 10-11, type 1 primer per 20-41-02 (F-18.06).
Door angle (150)	17-7 PH, 150-170 ksi	Cadmium plate. Apply one layer of BMS 10-11, type 1 primer per 20-41-02 (F-16.01).
Splice plate (165)	301 cres	Cadmium plate. Apply one layer of BMS 10-11, type 1 primer per 20-41-02 (F-16.01).

Refinish Details  
 Figure 601 (Sheet 3)

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REPAIR 2-1

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ASSEMBLY1. Materials

NOTE: Equivalent replacements can be used.

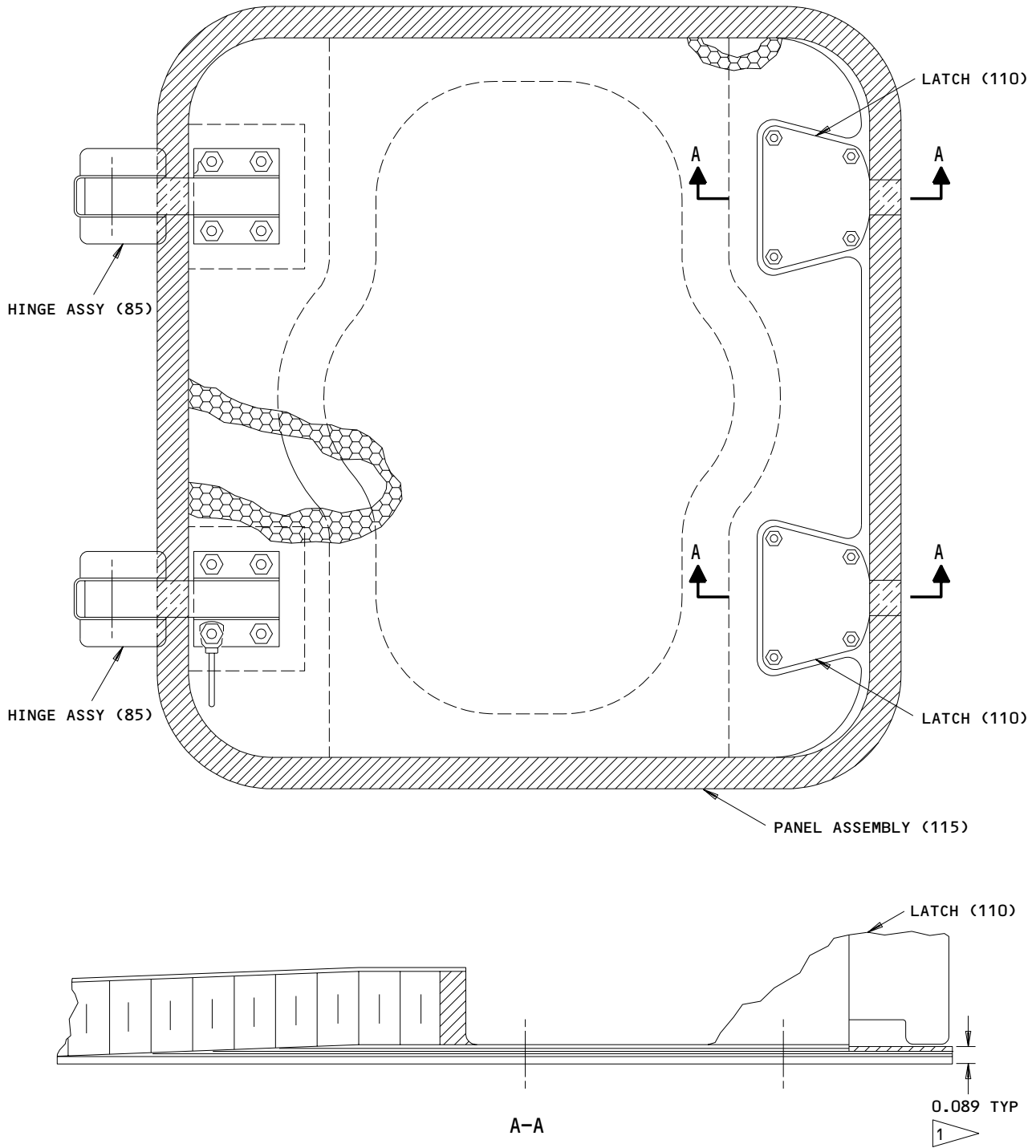
- A. Sealant, silicone -- DC-93-006 (Ref 20-60-04)
- B. Sealant -- BMS 5-63 (Ref 20-60-04)
- C. Sealant -- BMS 5-79, class B (Ref 20-60-04)
- D. Adhesive, corrosion-inhibiting primer -- BMS 5-89 (Ref 20-60-04)
- E. Primer -- BMS 10-11, type 1 (Ref 20-60-02)
- F. Tape -- P-743 (Ref 20-60-04)

2. Assembly

- A. Use standard industry practices to assemble this component. Use the subsequent procedures also.
- B. Assemble the door assembly (45, IPL Fig. 3).
  - (1) Install the shim (90) with BMS 10-11, type 1 primer. Install wet or dry (F-20.05).
  - (2) Install the bolts (50) with BMS 10-11, type 1 primer. Install wet.
  - (3) Bond the jumper (80). Refer to 20-11-03.
  - (4) Apply Dow Corning 93-006 silicone-rubber sealant around the perimeter of the panel assembly (115). Get a 0.089-inch thickness as shown in Fig. 701.
  - (5) Install the shim (107) with BMS 10-11, type 1 primer. Install wet or dry (F-20.05).
  - (6) Remove the laminations from the shim (107) if necessary. Get a 0.100 to 0.110-inch thickness of the panel assembly (115). The maximum distance permitted between the latch (110) and the panel assembly (115) is 0.005 inch.

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1 APPLY DOW CORNING 93-006 SILICONE-RUBBER SEALANT AROUND THE PERIMETER OF THE PANEL ASSEMBLY (115). GET A 0.089 INCH THICKNESS AS SHOWN.

ITEM NUMBERS REFER TO IPL FIG 3  
 ALL THE DIMENSIONS ARE IN INCHES

Application of Sealant to the Panel Perimeter  
 Figure 701

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## C. Assemble the forward section (1, IPL Fig. 1)

- (1) Fill the external clearance between the nose assembly (30) and the panel assembly (35) as shown in Fig. 702 if necessary.
- (2) Use BMS 5-79 class B sealant.

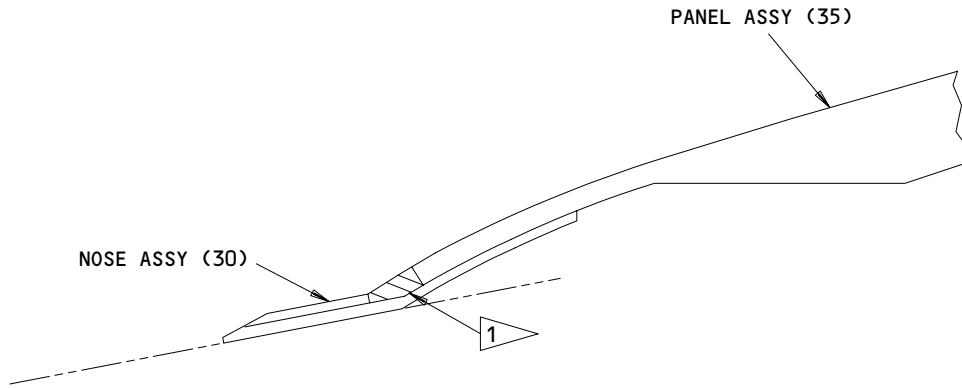
## D. Assemble the midsection (1, IPL Fig. 2).

- (1) Fay seal the area 0.25 inch from the edge of the panel assembly (610) and the filler (615) with BMS 5-63 sealant as shown in Fig. 703.
- (2) Bond the strap (575, 595, 600) to the panel assembly (605, 610) as shown in Fig. 704.
  - (a) The area to bond is 0.40 to 0.50 inch from the edge of the strap (575, 595, 600).
  - (b) Also bond along the full width of the strap (595, 600). Bond a minimum of 4.0 inches from each end of the strap.
  - (c) Apply P-743 tape to both sides of the strap (575, 595, 600). Do not tape the area on the strap to be bonded.
  - (d) Before the bond, apply BMS 5-89 adhesive primer that prevents corrosion (F-20.26) to the area that does not have tape.
  - (e) Remove the tape after the primer is dry.
  - (f) Bond the strap (575, 595, 600) 0.40 to 0.50 inch from the edge of the strap. Refer to 20-50-12 type 94.
  - (g) Bond the strap (595, 600) a minimum of 4.0 inches from each end of the strap. Refer to 20-50-12 type 44.
- (3) Fillet seal the strap (595, 600) and the frame (550) with BMS 5-63 sealant as shown in Fig. 705.
- (4) Fillet seal the strap (575) and the panel assembly (605, 610) with BMS 5-63 sealant as shown in Fig. 705.
- (5) Remove the laminations from the shim (285) to give a 0.005-inch maximum pullup.

## E. Assemble the aft section (1, IPL Fig. 3).

- (1) Bond the rubber gasket (165) to the panel assembly (170). Use 20-50-12 type 60 adhesive.

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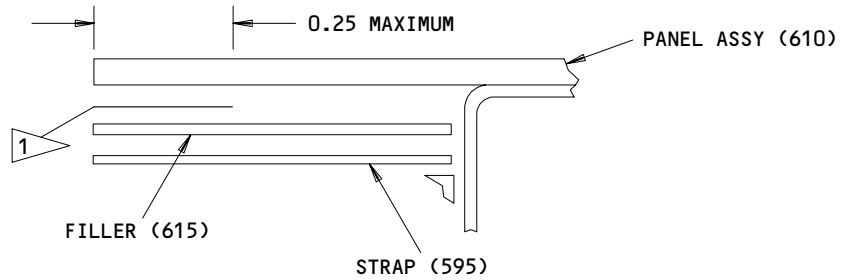


1 FILL THE EXTERNAL CLEARANCE BETWEEN THE NOSE ASSEMBLY (30) AND THE PANEL ASSEMBLY (35). USE BMS 5-79 CLASS B SEALANT.

ITEM NUMBERS REFER TO IPL FIG 1

Sealant Application Between the Nose Assembly and the Panel Assembly  
 Figure 702

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1 FAY SEAL THE FILLER (615) TO THE PANEL ASSEMBLY (610) AS SHOWN.

ITEM NUMBERS REFER TO IPL FIG 2

ALL THE DIMENSIONS ARE IN INCHES

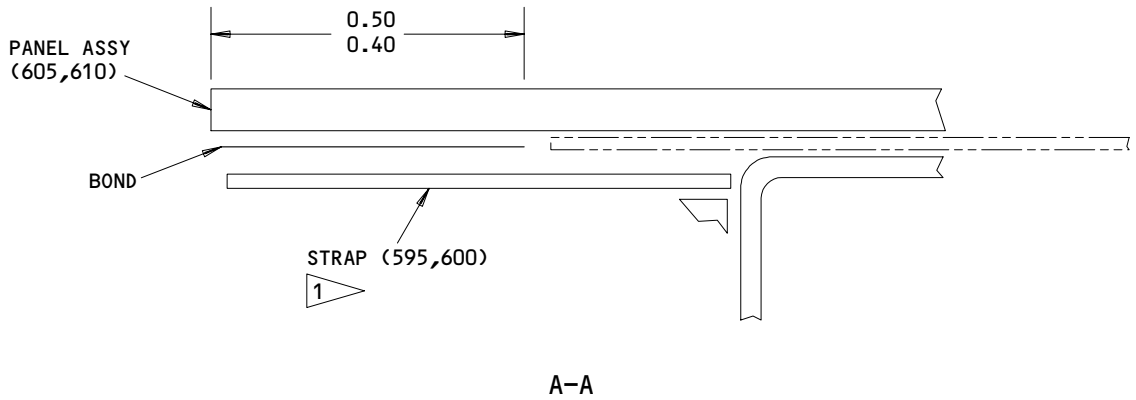
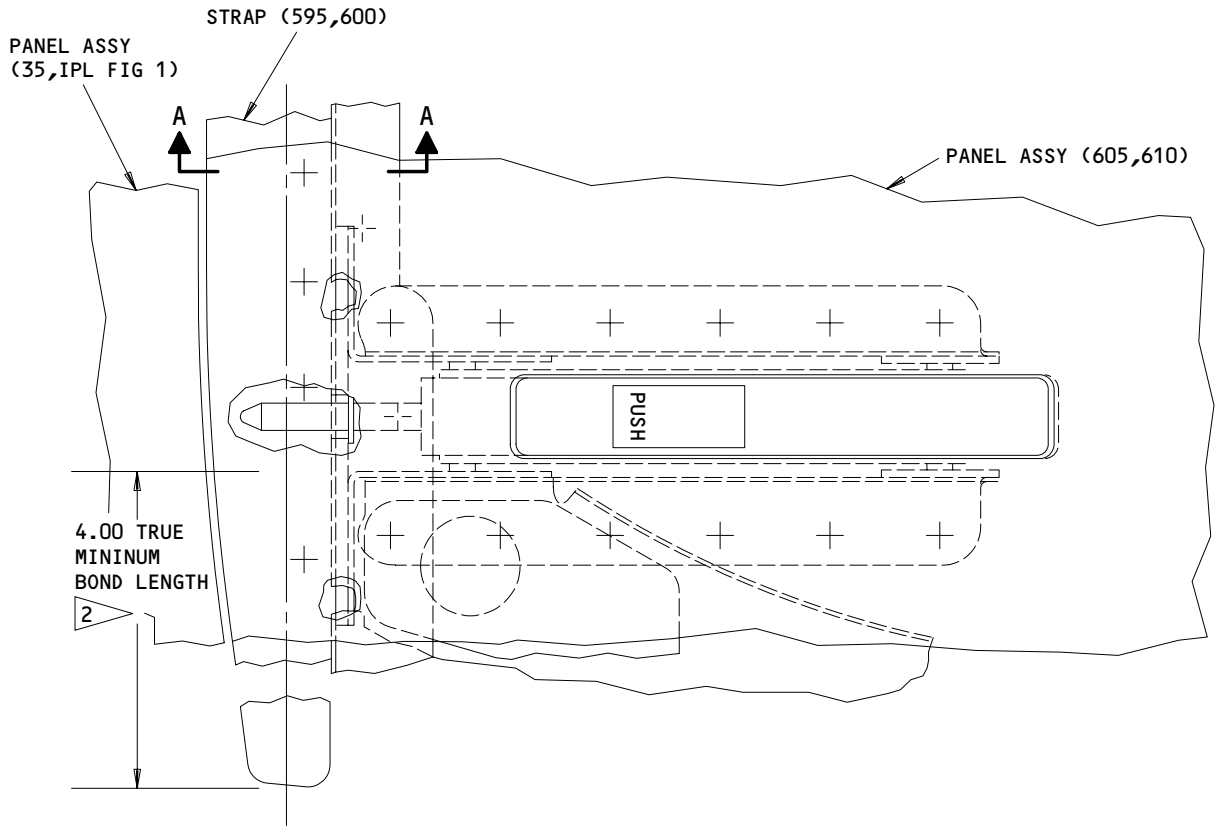
Fay Seal of the Filler  
 Figure 703

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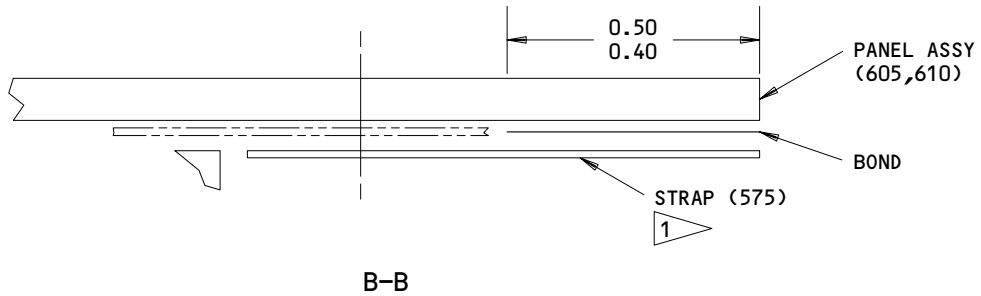
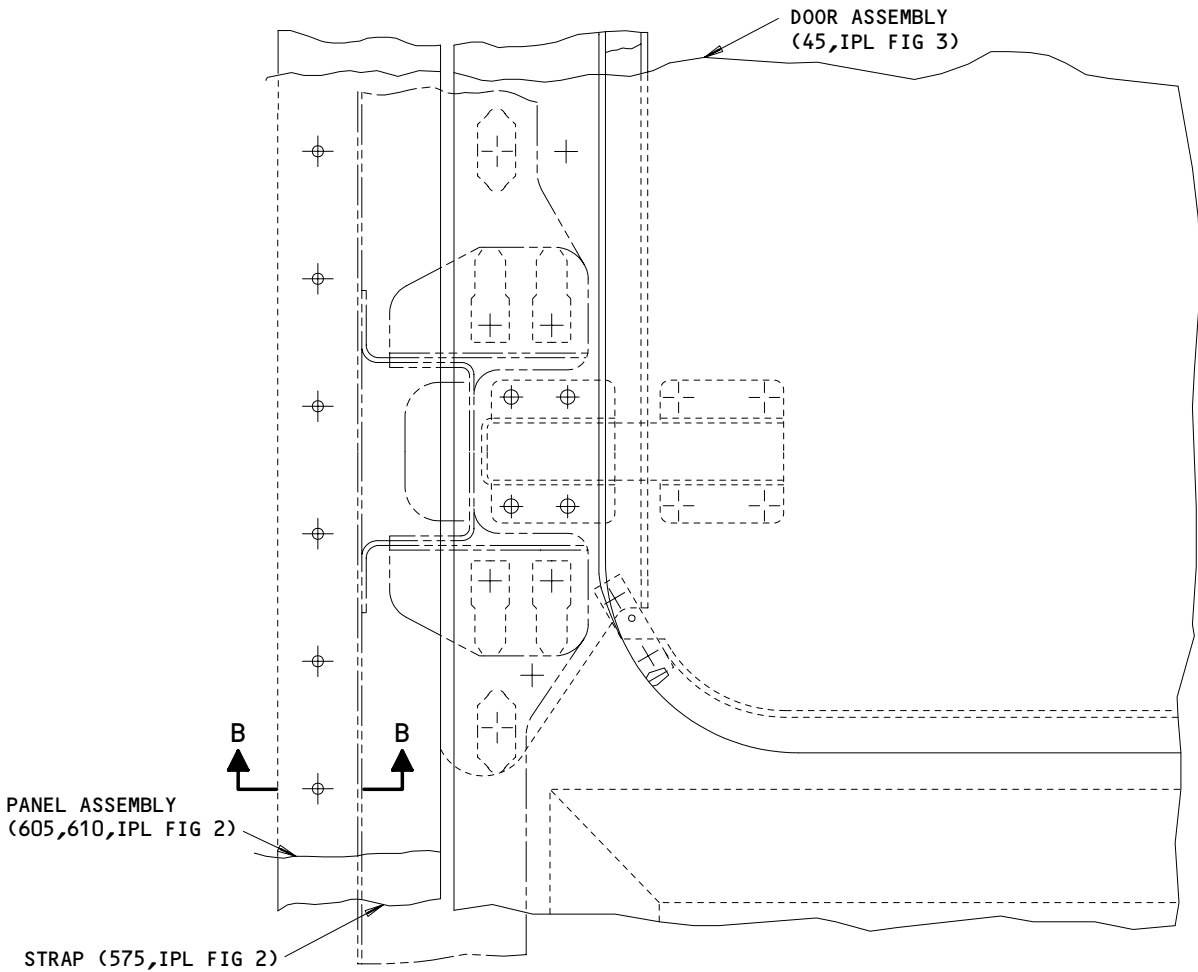
Bond of the Strap and the Panel Assembly  
Figure 704 (Sheet 1)

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- 1 BOND THE STRAP (575, 595, 600, IPL FIG 2) TO THE PANEL ASSEMBLY (605, 610, IPL FIG 2) AS SHOWN. REFER TO 20-50-12, TYPE 94.
- 2 BOND THE STRAP (595, 600, IPL FIG 2) TO THE PANEL ASSEMBLY (605, 610, IPL FIG 2) AS SHOWN. REFER TO 20-50-12, TYPE 44.

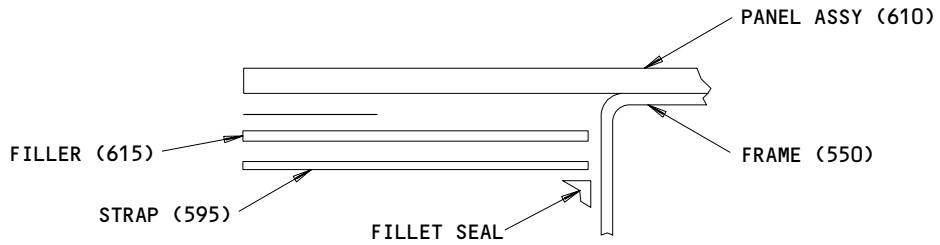
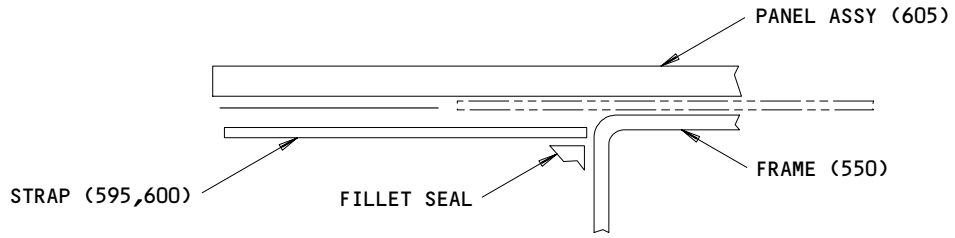
ALL THE DIMENSIONS ARE IN INCHES

Bond of the Strap and the Panel Assembly  
 Figure 704 (Sheet 2)

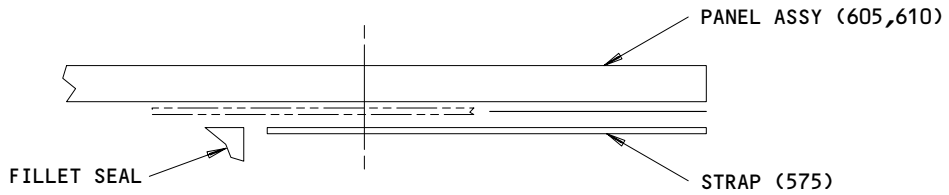
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ASSEMBLY 313T3100-59 ONLY



1 FILLET SEAL AS SHOWN

ITEM NUMBERS REFER TO IPL FIG 2

Fillet Seal of the Strap, the Panel and the Frame  
Figure 705

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3. Keep the Fairing Assemblies

- A. Prepare and keep the fairing assemblies per standard industry practices.

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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

OPTK6 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

08524 DEUTSCH FASTENER CORP SEE CODE V97928

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

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

29372 FAIRCHILD IND INC AEROSP FSTNRS DIV SOUTHBAY OPNS/TRIDAIR  
3000 WEST LOMITA BLVD  
TORRANCE, CALIFORNIA 90505-5103

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

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

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

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ILLUSTRATED PARTS LIST  
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VENDORS

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

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

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

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

84256 AVIBANK MANUFACTURING COMPANY  
210 SOUTH VICTORY BLVD PO BOX 391  
BURBANK, CALIFORNIA 91503

92215 FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV  
3010 W LOMITA BLVD  
TORRANCE, CALIFORNIA 90505-5102

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

**54-52-11**ILLUSTRATED PARTS LIST  
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN960C10L		3	35	8
AN960C6L		3	100	8
AN960D8L		3	70	2
AN960PD10		2	330	4
		2	355	4
AN960PD10L		2	330A	4
		2	335	2
		2	355A	4
		2	360	2
AN960PD416L		2	115	2
AN960PD716		2	25	2
AN960PD8L		3	55	7
BACB28AM05A013A		2	460	2
BACB30JC5-10		3	65	1
BACB30LU04-2		3	5	4
BACB30LU04-3		3	10	2
BACB30LU06-2		3	95	8
BACB30MY5K		2	145	6
BACB30MY5K2		2	85	6
BACB30MY6K2		2	200	2
		2	225	2
		2	390	8
		2	420	4
BACB30MY6K3		2	250	14
		2	440	4
		2	515	6
BACB30MY6K4		2	395	4
		2	415	4
BACB30M4DK21		2	110	2
BACB30NM3K24		2	320	2
		2	345	2
BACB30NY5K2		2	565	21
		2	580	15
BACB30NY5K3		1	15	19
BACB30NY5K8		3	50	7
BACB30NY6K3		2	205	12
		2	230	6
		2	270	21
		2	290	48
		2	470	12
		2	495	12
		2	540	21
		3	30	8

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 ILLUSTRATED PARTS LIST  
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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30VT5K2		2	95	6
		2	155	4
BACB30VU5K		2	35	4
BACC30BL5		2	40	4
		2	100	6
		2	160	4
BACC30M5		1	20	19
		2	90	6
		2	150	6
		2	570	21
		2	585	15
BACC30M6		2	210	14
		2	235	8
		2	255	14
		2	275	21
		2	295	48
		2	400	12
		2	425	8
		2	445	4
		2	480	8
		2	500	12
		2	520	6
		2	545	21
BACJ40A20-6		3	80	1
BACN10JC04		3	15	6
BACN10JC06		3	105	8
BACN10JC08		3	60	7
		3	75	1
BACN10JC3		2	340	2
		2	365	2
		3	40	8
BACN10JD104		2	120	2
BACR15BA5AD		1	25	6
		3	120	16
		3	145	4
BACR15BA5KE		2	135	16
		2	380	16
BACR15BA5KE2		2	590	2
BACR15CE5KE		2	175	6
		2	185	6
BACR15FT5KE		2	55	4
		2	70	8
		2	525	12
BACR15FT5KE2C		2	50	4
BACS40R014B016F		3	90	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACS40R08A28F		2	285	2
BCREF8739		2	460	2
BRH10A04		3	15	6
BRH10A06		3	105	8
BRH10A08		3	60	7
		3	75	1
BRH10A3		2	340	2
		2	365	2
		3	40	8
HL10VAZ5-2		2	85	6
HL10VAZ6-2		2	200	2
		2	225	2
		2	390	8
		2	420	4
HL10VAZ6-3		2	250	14
		2	440	4
		2	515	6
HL10VAZ6-4		2	395	4
		2	415	4
HL13VAZ5-2		2	565	21
		2	580	15
HL13VAZ5-3		1	15	19
HL13VAZ5-8		3	50	7
HL13VAZ6-3		2	205	12
		2	230	6
		2	270	21
		2	290	48
		2	470	12
		2	495	12
		2	540	21
		3	30	8
HL13V2		2	565	21
		2	580	15
HL13V3		1	15	19
		2	205	12
		2	230	6
		2	270	21
		2	290	48
		2	470	12
		2	495	12
		2	540	21
		3	30	8

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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL13V8		3	50	7
HL21-10		3	65	1
HL21-5-10		3	65	1
HL215-10		3	65	1
HL70-5		1	20	19
		2	90	6
		2	150	6
		2	570	21
		2	585	15
HL79-6		2	210	14
HL79-6		2	235	8
		2	255	14
		2	275	21
		2	295	48
		2	400	12
		2	425	8
		2	445	4
		2	480	8
		2	500	12
		2	520	6
		2	545	21
HST10AG5-2		2	95	6
		2	155	4
HST79-5		2	40	4
		2	100	6
		2	160	4
HST79CY5		2	40	4
		2	100	6
		2	160	4
H10-04BAC		3	15	6
H10-06BAC		3	105	8
H10-08BAC		3	60	7
		3	75	1
H10-3BAC		2	340	2
		2	365	2
		3	40	8
H245-9		2	130A	2
H2901-1		3	110	2
H2904-1		3	85	2
L8006K4		2	395	4
		2	415	4

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 ILLUSTRATED PARTS LIST  
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
L801-5K2		2	565	21
		2	580	15
L801-5K3		1	15	19
L801-5K8		3	50	7
L801-6K3		2	205	12
		2	230	6
		2	270	21
		2	290	48
		2	470	12
		2	495	12
		2	540	21
		3	30	8
L838-5-10		3	65	1
MS20427M2		3	155	4
MS24665-134		2	125	2
NAS1805-3N		2	475	4
NAS1805-7		2	30	2
NAS43DD3-4		2	325	4
NAS43DD3-7		2	350	4
NAS6704D21		2	110A	2
NS202101-02		2	340	2
		2	365	2
		3	40	8
NS202101-40		3	15	6
NS202101-62		3	105	8
NS202101-82		3	60	7
		3	75	1
RMLH9075-3W		2	340	2
		2	365	2
		3	40	8
RMLH9075-40W		3	15	6
RMLH9075-62W		3	105	8
RMLH9075-82W		3	60	7
		3	75	1
S213T310-2		2	375B	1
S311T306-2		3	110	2
S313T310-1		2	370	1
S313T310-2		2	375	1
S313T310-5		2	370C	1
S313T310-7		2	370A	1
S313T310-8		2	375A	1
TL22013-102		3	110	2
T6S1032J		2	340	2
		2	365	2
		3	40	8

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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
T6S440J		3	15	6
T6S632J		3	105	8
T6S832J		3	60	7
		3	75	1
VN303A02		2	340	2
		2	365	2
		3	40	8
VN303A40		3	15	6
VN303A62		3	105	8
VN303A82		3	60	7
		3	75	1
WC15-5-10		3	65	1
10-60401-6		2	130A	2
313T3100-10		2	510	1
313T3100-100		1	5D	RF
		2	1D	RF
313T3100-101		1	5E	RF
		2	1E	RF
313T3100-103		1	5F	RF
		2	1F	RF
313T3100-104		2	550A	1
313T3100-105		1	10C	RF
		3	1C	RF
313T3100-106		1	10D	RF
		3	1D	RF
313T3100-107		3	150A	1
313T3100-108		1	5G	RF
		2	1G	RF
313T3100-109		2	190A	1
313T3100-11		2	485	1
313T3100-110		2	195A	1
313T3100-111		1	10E	RF
		3	1E	RF
313T3100-12		2	490	1
313T3100-15		2	465	2
313T3100-16		2	385	4
313T3100-17		2	405	1
313T3100-18		2	410	1
313T3100-19		2	430	1
313T3100-2		1	1	RF
313T3100-20		2	435	1
313T3100-21		2	530	1
313T3100-22		2	535	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
313T3100-23		2	555	1
313T3100-24		2	560	1
313T3100-25		2	300	1
313T3100-26		2	305	1
313T3100-27		2	310	1
313T3100-28		2	315	1
313T3100-29		2	280	1
313T3100-31		2	260	1
313T3100-32		2	265	1
313T3100-37		2	215	1
313T3100-38		2	220	1
313T3100-39		2	60	1
313T3100-4		1	10	RF
		3	1	RF
313T3100-43		2	165	1
313T3100-44		2	170	1
313T3100-45		2	15	2
313T3100-46		2	140	4
313T3100-48		3	20	2
313T3100-5		1	30	1
313T3100-51		3	150	1
313T3100-53		2	550	1
313T3100-54		2	65	1
313T3100-55		2	450	1
313T3100-56		2	455	1
313T3100-58		3	25	2
313T3100-59		1	5	RF
		2	1	RF
313T3100-60		1	5A	RF
		2	1A	RF
313T3100-64		2	20	2
313T3100-66		2	180	2
313T3100-67		2	75	1
313T3100-68		2	80	1
313T3100-73		2	190	1
313T3100-74		2	195	1
313T3100-75		2	105	2
313T3100-77		3	135	1
313T3100-78		3	140	1
313T3100-79		3	125	1
313T3100-80		3	130	1
313T3100-81		2	575	1
313T3100-82		2	595	1
313T3100-83		2	615	1
313T3100-86		3	165	1

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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
313T3100-87		3	160	2
313T3100-88		1	10A	RF
		3	1A	RF
313T3100-89		1	1A	RF
313T3100-9		2	505	1
313T3100-90		1	1B	RF
313T3100-91		2	240	1
313T3100-92		2	245	1
313T3100-94		1	10B	RF
		3	1B	RF
313T3100-95		1	5B	RF
		2	1B	RF
313T3100-96		1	1C	RF
313T3100-98		2	600	1
313T3100-99		1	5C	RF
		2	1C	RF
313T3101-1		1	35	1
313T3101-18		2	605	1
313T3101-20		2	610	1
313T3101-21		1	35A	1
313T3101-22		1	35B	1
313T3101-27		3	170A	1
313T3101-28		2	605A	1
313T3101-29		1	35C	1
313T3101-3		3	170	1
313T3103-1		3	45	1
313T3103-10		3	115	1
313T3103-12		3	115A	1
313T3103-16		3	45A	1
313T3103-17		3	115B	1
313T3103-22		3	45B	1
313T3103-23		3	115C	1
313T3115-1		2	45	2
313T3116-1		2	10	2
66014-5		1	20	19
		2	90	6
		2	150	6
		2	570	21
		2	585	15

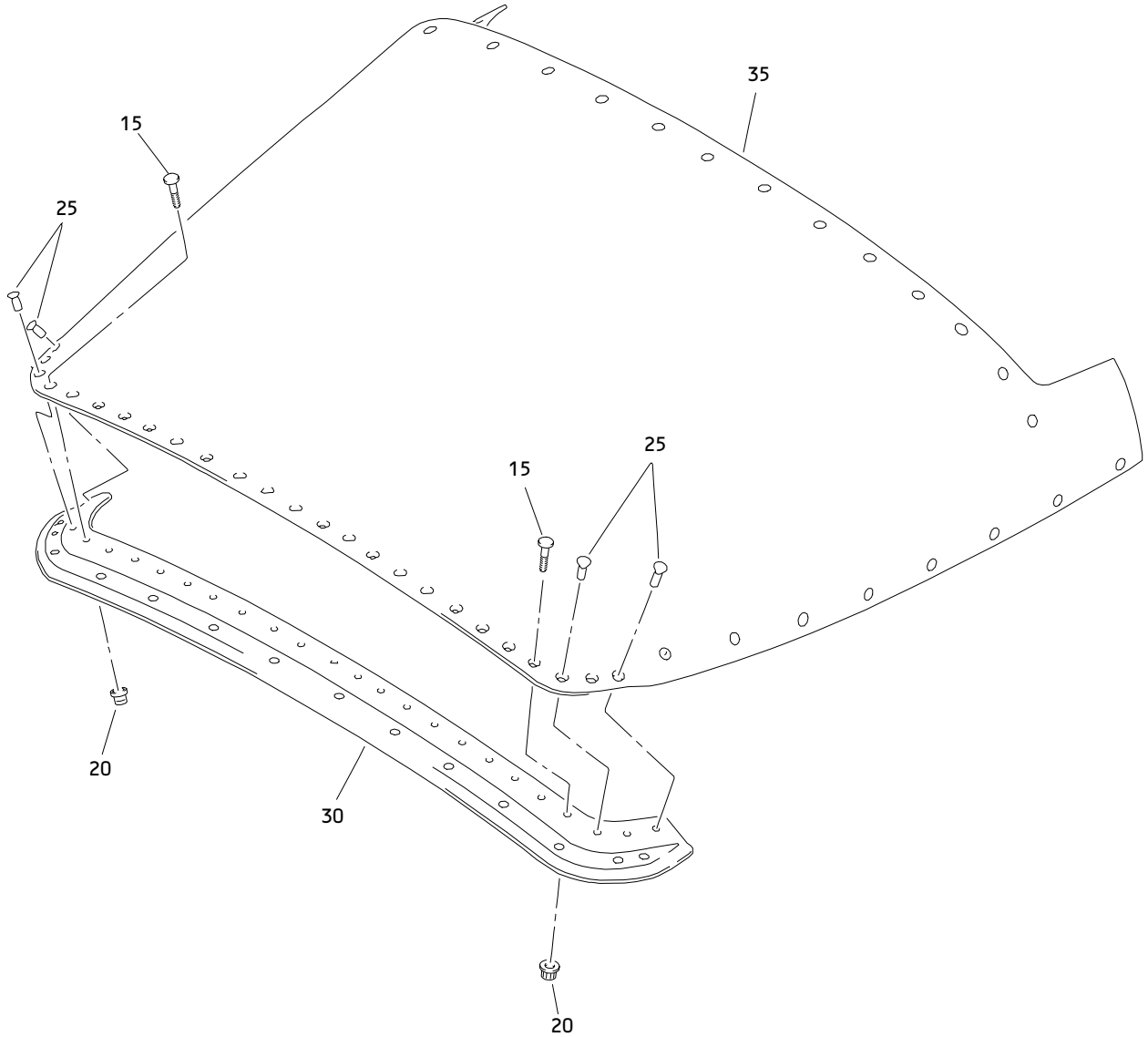
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ		
66014-6		2	210	14		
		2	235	8		
		2	255	14		
		2	275	21		
		2	295	48		
		2	400	12		
		2	425	8		
		2	445	4		
		2	480	8		
		2	500	12		
		2	520	6		
		2	545	21		
		69B91056-600		2	5	2
				2	370	1
2	375			1		
2	370C			1		
2	375C			1		
2	370A			1		
2	375A			1		
3	85A			2		
3	110			2		
2	340			2		
2	365			2		
3	40			8		
3	15			6		
3	105			8		
3	60	7				
3	75	1				

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Forward Section Assembly  
Figure 1

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ILLUSTRATED PARTS LIST  
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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1	313T3100-2		SECTION ASSY-FWD	A	RF
-1A	313T3100-89		SECTION ASSY-FWD	B	RF
-1B	313T3100-90		SECTION ASSY-FWD	C	RF
-1C	313T3100-96		SECTION ASSY-FWD	D	RF
-5	313T3100-59		SECTION ASSY-MID (FOR DETAILS SEE FIG. 2)	E	RF
-5A	313T3100-60		SECTION ASSY-MID (FOR DETAILS SEE FIG. 2)	F	RF
-5B	313T3100-95		SECTION ASSY-MID (FOR DETAILS SEE FIG. 2)	G	RF
-5C	313T3100-99		SECTION ASSY-MID (FOR DETAILS SEE FIG. 2)	H	RF
-5D	313T3100-100		SECTION ASSY-MID (FOR DETAILS SEE FIG. 2)	J	RF
-5E	313T3100-101		SECTION ASSY-MID (FOR DETAILS SEE FIG. 2)	K	RF
R -5F	313T3100-103		SECTION ASSY-MID (FOR DETAILS SEE FIG. 2)	P	RF
R -5G	313T3100-108		SECTION ASSY-MID (FOR DETAILS SEE FIG. 2)	Q	RF
-10	313T3100-4		SECTION ASSY-AFT (FOR DETAILS SEE FIG. 3)	L	RF
-10A	313T3100-88		SECTION ASSY-AFT (FOR DETAILS SEE FIG. 3)	M	RF
-10B	313T3100-94		SECTION ASSY-AFT (FOR DETAILS SEE FIG. 3)	N	RF
R -10C	313T3100-105		SECTION ASSY-AFT (FOR DETAILS SEE FIG. 3)	S	RF
R -10D	313T3100-106		SECTION ASSY-AFT (FOR DETAILS SEE FIG. 3)	R	RF
R -10E	313T3100-111		SECTION ASSY-AFT (FOR DETAILS SEE FIG. 3)	T	RF

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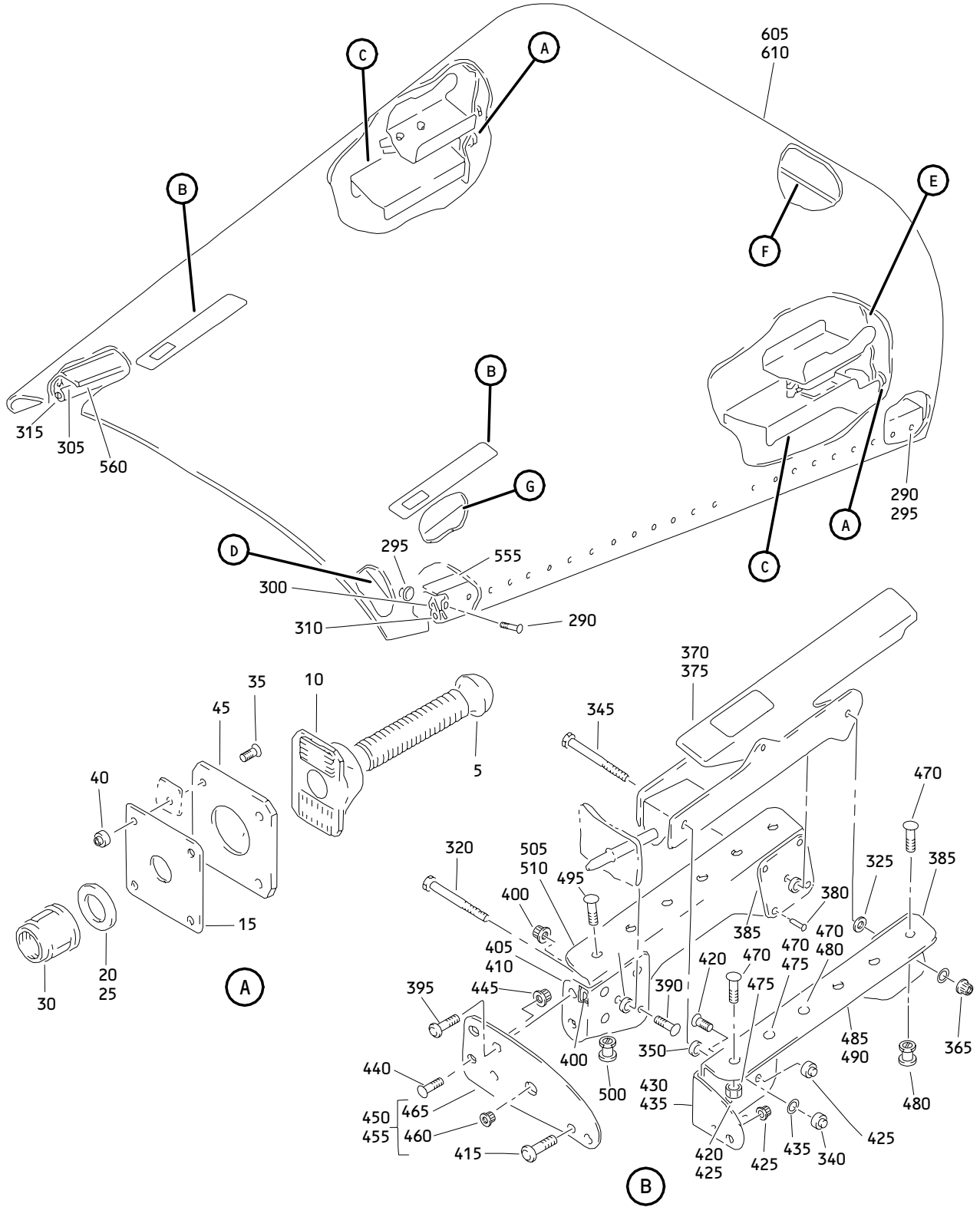
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-15	HL13VAZ5-3		.BOLT- (V56878) (SPEC BACB30NY5K3) (OPT HL13VAZ5-3 (V73197)) (OPT HL13VAZ5-3 (V92215)) (OPT HL13VAZ5-3 (V97928)) (OPT L801-5K3 (V06725)) (OPT HL13VAZ5-3 (V08524)) (OPT HL13V3 (V06725))	A-D	19
20	HL70-5		.COLLAR- (V56878) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878))	A-D	19
25	BACR15BA5AD		.RIVET- (SIZE DETERMINE ON INST)	A-D	6
30	313T3100-5		.NOSE ASSY	A-D	1
35	313T3101-1		.PANEL ASSY	A	1
-35A	313T3101-21		.PANEL ASSY	B	1
-35B	313T3101-22		.PANEL ASSY	C	1
-35C	313T3101-29		.PANEL ASSY	D	1

- Item Not Illustrated

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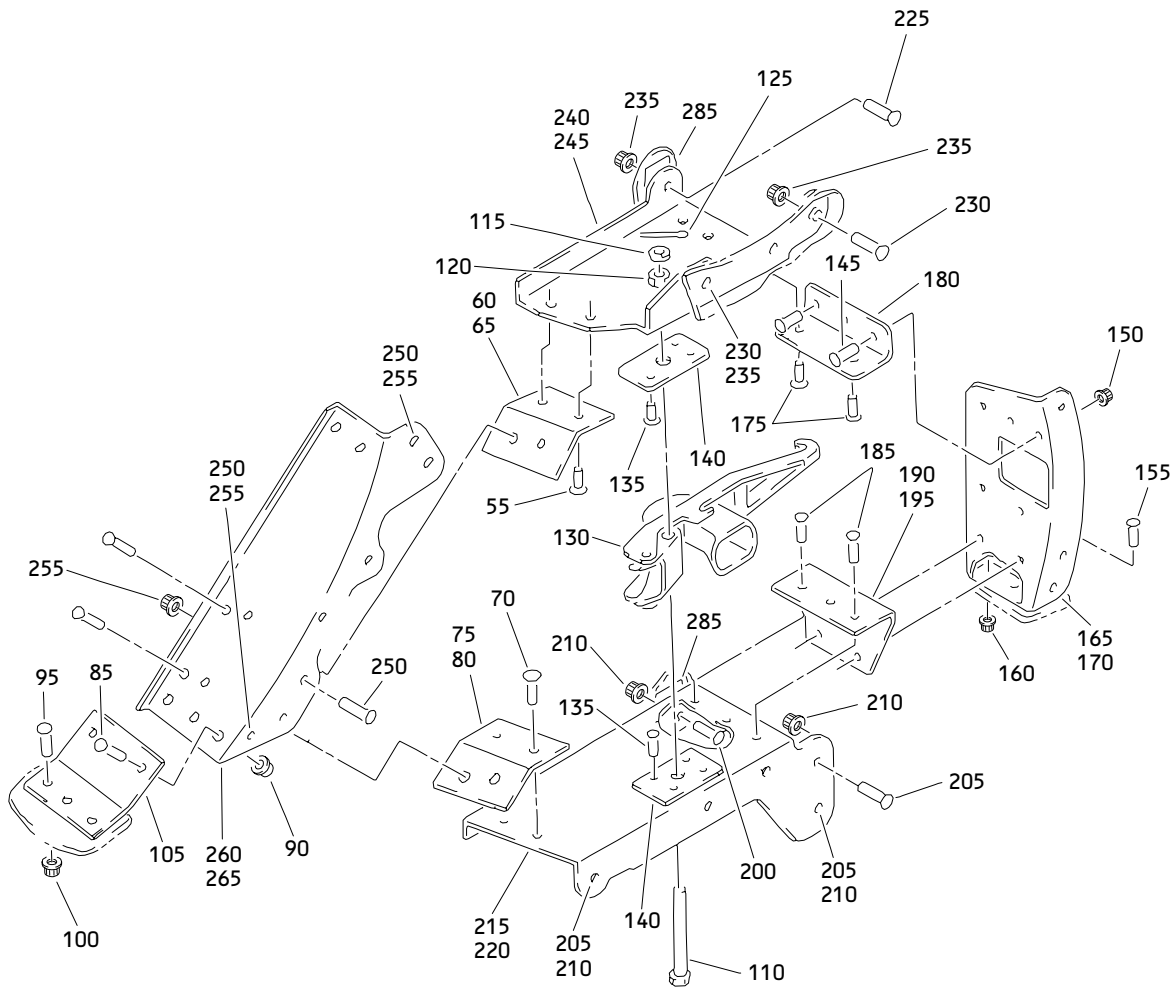
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Mid Section Assembly  
 Figure 2 (Sheet 1)

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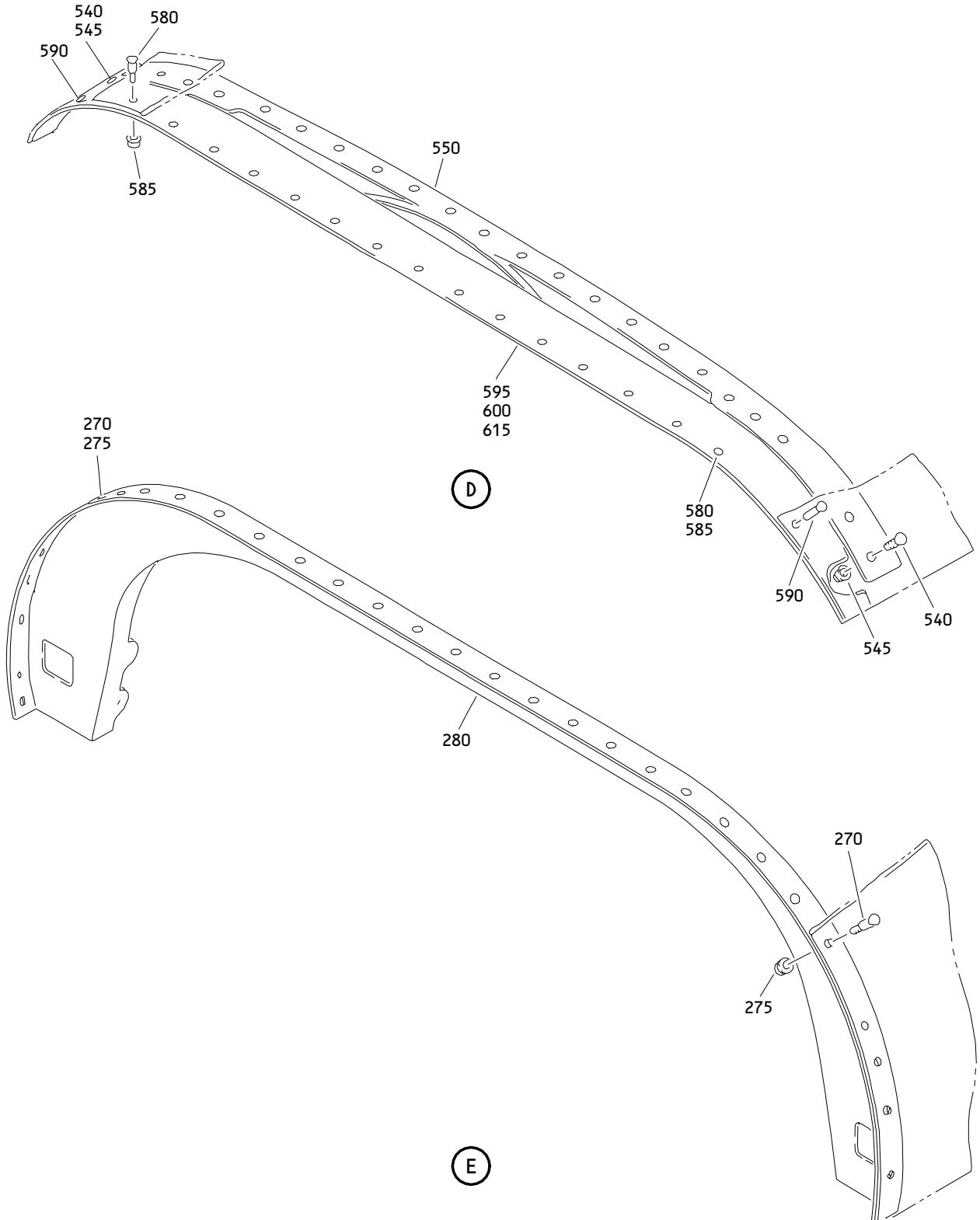


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Mid Section Assembly  
Figure 2 (Sheet 2)

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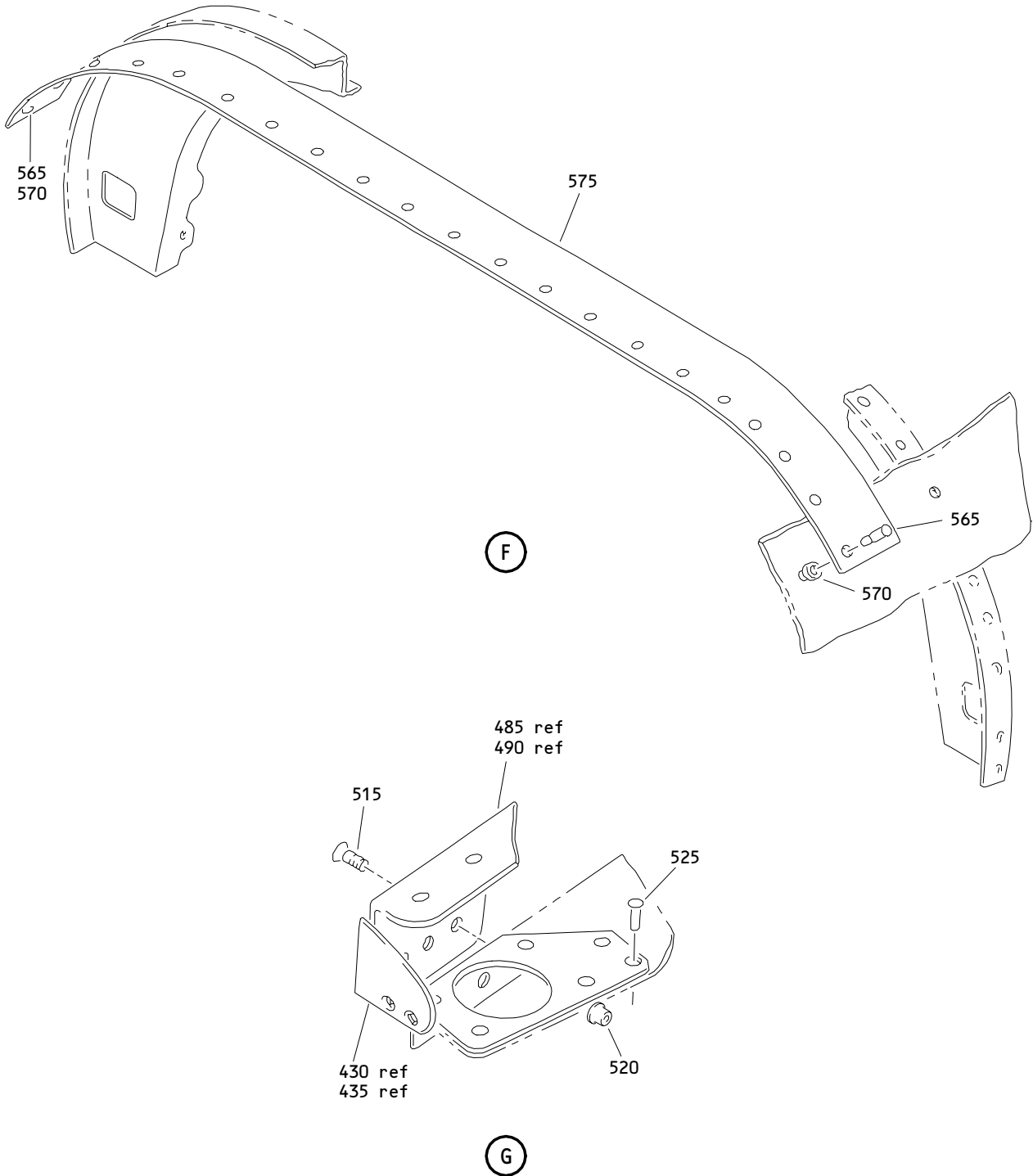
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Mid Section Assembly  
Figure 2 (Sheet 3)

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Mid Section Assembly  
Figure 2 (Sheet 4)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
-1	313T3100-59		SECTION ASSY-MID	E	RF
-1A	313T3100-60		SECTION ASSY-MID	F	RF
-1B	313T3100-95		SECTION ASSY-MID	G	RF
-1C	313T3100-99		SECTION ASSY-MID	H	RF
-1D	313T3100-100		SECTION ASSY-MID	J	RF
-1E	313T3100-101		SECTION ASSY-MID	K	RF
R -1F	313T3100-103		SECTION ASSY-MID	P	RF
R -1G	313T3100-108		SECTION ASSY-MID	Q	RF
5	69B91056-600		.BOLT	E-K,P ,Q	2
10	313T3116-1		.NUT-BOLT INDEX	E-K,P ,Q	2
15	313T3100-45		.PLATE-DOUBLER	E-K,P ,Q	2
20	313T3100-64		.WASHER	E-K,P ,Q	2
25	AN960PD716		.WASHER	F-K,P	2
30	NAS1805-7		.NUT	E-K,P ,Q	2
35	BACB30VU5K		.BOLT- (SIZE DETERMINE ON INST)	E-K,P ,Q	4
R 40	HST79CY5		.COLLAR- (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79-5 (V56878)) (OPT HST79-5 (V5M902))	E-K,P ,Q	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-45	313T3115-1		.PLATE	E-K,P ,Q	2
50	BACR15FT5KE2C		.RIVET	E-K,P ,Q	4
55	BACR15FT5KE		.RIVET- (SIZE DETERMINE ON INST)	E-K,P ,Q	4
60	313T3100-39		.CLIP	E-K,P ,Q	1
65	313T3100-54		.CLIP	E-K,P ,Q	1
70	BACR15FT5KE		.RIVET- (SIZE DETERMINE ON INST)	E-K,P ,Q	8
75	313T3100-67		.CLIP	E-K,P ,Q	1
80	313T3100-68		.CLIP	E-K,P ,Q	1
85	HL10VAZ5-2		.BOLT- (V60516) (SPEC BACB30MY5K2) (OPT HL10VAZ5-2 (VOPTK6))	E-K,P ,Q	6
90	HL70-5		.COLLAR- (V56878) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878))	E-K,P ,Q	6

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-95	HST10AG5-2		.BOLT- (V0PTK6) (SPEC BACB30VT5K2) (OPT HST10AG5-2 (V06725)) (OPT HST10AG5-2 (V56878)) (OPT HST10AG5-2 (V73197))	E-K,P ,Q	6
R 100	HST79CY5		.COLLAR- (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79-5 (V56878)) (OPT HST79-5 (V5M902))	E-K,P ,Q	6
105	313T3100-75		.CLIP	E-K,P ,Q	2
110	BACB30M4DK21		.BOLT- (OPT ITEM 110A)	E-K,P ,Q	2
-110A	NAS6704D21		.BOLT- (OPT ITEM 110)	E-K,P ,Q	2
115	AN960PD416L		.WASHER	E-K,P ,Q	2
120	BACN10JD104		.NUT	E-K,P ,Q	2
125	MS24665-134		.PIN-COTTER	E-K,P ,Q	2
130	H245-7		DELETED		
R 130A	H245-9		.LATCH- (V83014) (SPEC 10-60401-6)	E-K,P ,Q	2
135	BACR15BA5KE		.RIVET- (SIZE DETERMINE ON INST)	E-K,P ,Q	16

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-140	313T3100-46		.PLATE-LATCH	E-K,P ,Q	4
145	BACB30MY5K		.BOLT- (SIZE DETERMINE ON INST)	E-K,P ,Q	6
150	HL70-5		.COLLAR- (V56878) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878))	E-K,P ,Q	6
155	HST10AG5-2		.BOLT- (VOPTK6) (SPEC BACB30VT5K2) (OPT HST10AG5-2 (V06725)) (OPT HST10AG5-2 (V56878)) (OPT HST10AG5-2 (V73197))	E-K,P ,Q	4
R 160	HST79CY5		.COLLAR- (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79-5 (V56878)) (OPT HST79-5 (V5M902))	E-K,P ,Q	4
165	313T3100-43		.BRACKET-ATTACH	E-K,P ,Q	1
170	313T3100-44		.BRACKET-ATTACH	E-K,P ,Q	1
175	BACR15CE5KE		.RIVET- (SIZE DETERMINE ON INST)	E-K,P ,Q	6
180	313T3100-66		.CLIP	E-K,P ,Q	2
185	BACR15CE5KE		.RIVET- (SIZE DETERMINE ON INST)	E-K,P ,Q	6
190	313T3100-73		.CLIP	E-K,P	1
R 190A	313T3100-109		.CLIP	Q	1
195	313T3100-74		.CLIP	E-K,P	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R	02-195A	313T3100-110	.CLIP	Q	1
	200		HL10VAZ6-2	.BOLT- (V60516) (SPEC BACB30MY6K2) (OPT HL10VAZ6-2 (VOPTK6))	E-K,P ,Q
	205	HL13VAZ6-3	.BOLT- (V56878) (SPEC BACB30NY6K3) (OPT HL13VAZ6-3 (V73197)) (OPT HL13VAZ6-3 (V92215)) (OPT HL13VAZ6-3 (V97928)) (OPT L801-6K3 (V06725)) (OPT HL13VAZ6-3 (V08524)) (OPT HL13V3 (V06725))	E-K,P ,Q	12
210	HL79-6		.COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))	E-K,P ,Q	14

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-215	313T3100-37		.CHANNEL-LATCH	E-K,P ,Q	1
220	313T3100-38		.CHANNEL-LATCH	E-K,P ,Q	1
225	HL10VAZ6-2		.BOLT- (V60516) (SPEC BACB30MY6K2) (OPT HL10VAZ6-2 (VOPTK6))	E-K,P ,Q	2
230	HL13VAZ6-3		.BOLT- (V56878) (SPEC BACB30NY6K3) (OPT HL13VAZ6-3 (V73197)) (OPT HL13VAZ6-3 (V92215)) (OPT HL13VAZ6-3 (V97928)) (OPT L801-6K3 (V06725)) (OPT HL13VAZ6-3 (V08524)) (OPT HL13V3 (V06725))	E-K,P ,Q	6
235	HL79-6		.COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))	E-K,P ,Q	8

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-240	313T3100-91		.CHANNEL-LATCH	E-K,P /Q	1
245	313T3100-92		.CHANNEL-LATCH	E-K,P /Q	1
250	HL10VAZ6-3		.BOLT- (V60516) (SPEC BACB30MY6K3) (OPT HL10VAZ6-3 (VOPTK6))	E-K,P /Q	14
255	HL79-6		.COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))	E-K,P /Q	14
260	313T3100-31		.BRACE	E-K,P /Q	1
265	313T3100-32		.BRACE	E-K,P /Q	1
270	HL13VAZ6-3		.BOLT- (V56878) (SPEC BACB30NY6K3) (OPT HL13VAZ6-3 (V73197)) (OPT HL13VAZ6-3 (V92215)) (OPT HL13VAZ6-3 (V97928)) (OPT L801-6K3 (V06725)) (OPT HL13VAZ6-3 (V08524)) (OPT HL13V3 (V06725))	E-K,P /Q	21

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-275	HL79-6		.COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))	E-K,P ,Q	21
280	313T3100-29		.FRAME-STA 153.47	E-K,P ,Q	1
285	BACS40R08A28F		.SHIM	E-K,P ,Q	AR
290	HL13VAZ6-3		.BOLT- (V56878) (SPEC BACB30NY6K3) (OPT HL13VAZ6-3 (V73197)) (OPT HL13VAZ6-3 (V92215)) (OPT HL13VAZ6-3 (V97928)) (OPT L801-6K3 (V06725)) (OPT HL13VAZ6-3 (V08524)) (OPT HL13V3 (V06725))	E-K,P ,Q	48
295	HL79-6		.COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))	E-K,P ,Q	48
300	313T3100-25		.RETAINER-SEAL	E-K,P ,Q	1
305	313T3100-26		.RETAINER-SEAL	E-K,P ,Q	1
310	313T3100-27		.SEAL- (MFD FROM RUBBER SECT. F-25.01 BAC1530-32 X 28.46 IN.)	E-K,P ,Q	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-315	313T3100-28		.SEAL- (MFD FROM RUBBER SECT. F-25.01 BAC1530-32 X 28.46 IN.)	E-K,P ,Q	1
320	BACB30NM3K24		.BOLT	E-K,P ,Q	2
325	NAS43DD3-4		.SPACER- (OPT TO ITEM 325, INSTALL ITEM 330 AND/OR ITEM 330A AS REQUIRED)	E-K,P ,Q	4
-330	AN960PD10		.WASHER- (OPT TO ITEM 325, INSTALL ITEM 330 AND/OR ITEM 330A AS REQUIRED)	E-K,P ,Q	AR
-330A	AN960PD10L		.WASHER- (OPT TO ITEM 325, INSTALL ITEM 330 AND/OR ITEM 330A AS REQUIRED)	E-K,P ,Q	AR
-335	AN960PD10L		.WASHER	E-K,P ,Q	AR
340	H10-3BAC		.NUT- (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828))	E-K,P ,Q	AR

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-345	BACB30NM3K24		.BOLT	E-K,P ,Q	2
350	NAS43DD3-7		.SPACER- (OPT TO ITEM 350, INSTALL ITEM 355 AND/OR ITEM 355A AS REQUIRED)	E-K,P ,Q	4
-355	AN960PD10		.WASHER- (OPT TO ITEM 350, INSTALL ITEM 355 AND/OR ITEM 355A AS REQUIRED)	E-K,P ,Q	AR
-355A	AN960PD10L		.WASHER- (OPT TO ITEM 350, INSTALL ITEM 355 AND/OR ITEM 355A AS REQUIRED)	E-K,P	AR
-360	AN960PD10L		.WASHER	E-K,P ,Q	AR
365	H10-3BAC		.NUT- (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828))	E-K,P ,Q	AR

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-370	9284-1		.LATCH ASSY-PIN (V84256) (SPEC S313T310-1)	E,F	1
-370A	9284-7		.LATCH ASSY-PIN (V84256) (SPEC S313T310-7)	J,K,P ,Q	1
-370B	9284-1		.LATCH ASSY-PIN (V84256) (SPEC S313T310-1) (OPT ITEM 370C)	G,H	1
-370C	9284-5		.LATCH ASSY-PIN (V84256) (SPEC S313T310-5) (OPT ITEM 370B)	G,H	1
375	9284-2		.LATCH ASSY-PIN (V84256) (SPEC S313T310-2)	E,F	1
-375A	9284-8		.LATCH ASSY-PIN (V84256) (SPEC S313T310-8)	J,K,P ,Q	1
-375B	9284-2		.LATCH ASSY-PIN (V84256) (SPEC S213T310-2) (OPT ITEM 375C)	G,H	1
-375C	9284-6		.LATCH ASSY-PIN (V84256) (SPEC S213T310-6) (OPT ITEM 375B)	G,H	1
380	BACR15BA5KE		.RIVET- (SIZE DETERMINE ON INST)	E-K,P ,Q	16

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-385	313T3100-16		.PLATE-LATCH (SIZE DETERMINE ON INST)	E-K,P ,Q	4
390	HL10VAZ6-2		.BOLT- (V60516) (SPEC BACB30MY6K2) (OPT HL10VAZ6-2 (VOPTK6))	E-K,P ,Q	8
395	HL10VAZ6-4		.BOLT- (V60516) (SPEC BACB30MY6K4) (OPT HL10VAZ6-4 (VOPTK6)) (OPT HL10VAZ6-4 (V92215)) (OPT HL10VAZ6-4 (V97928)) (OPT L8006K4 (V06725)) (OPT HL10VAZ6-4 (V08524))	E-K,P ,Q	4
400	HL79-6		.COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))	E-K,P ,Q	12
405	313T3100-17		.ANGLE-ATTACH	E-K,P ,Q	1
410	313T3100-18		.ANGLE-ATTACH	E-K,P ,Q	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-415	HL10VAZ6-4		.BOLT- (V60516) (SPEC BACB30MY6K4) (OPT HL10VAZ6-4 (VOPTK6)) (OPT HL10VAZ6-4 (V92215)) (OPT HL10VAZ6-4 (V97928)) (OPT L8006K4 (V06725)) (OPT HL10VAZ6-4 (V08524))	E-K,P ,Q	4
420	HL10VAZ6-2		.BOLT- (V60516) (SPEC BACB30MY6K2) (OPT HL10VAZ6-2 (VOPTK6))	E-K,P ,Q	4
425	HL79-6		.COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))	E-K,P ,Q	8
430	313T3100-19		.ANGLE-ATTACH	E-K,P ,Q	1
435	313T3100-20		.ANGLE-ATTACH	E-K,P ,Q	1
440	HL10VAZ6-3		.BOLT- (V60516) (SPEC BACB30MY6K3) (OPT HL10VAZ6-3 (VOPTK6))	E-K,P ,Q	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-445	HL79-6		.COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))	E-K,P ,Q	4
450	313T3100-55		.LUG ASSY	E-K,P ,Q	1
455	313T3100-56		.LUG ASSY	E-K,P ,Q	1
460	BCREF8739		..BUSHING- (BACB28AM05A013AS)	E-K,P ,Q	1
465	313T3100-15		..LUG	E-K,P ,Q	1
470	HL13VAZ6-3		.BOLT- (V56878) (SPEC BACB30NY6K3) (OPT HL13VAZ6-3 (V73197)) (OPT HL13VAZ6-3 (V92215)) (OPT HL13VAZ6-3 (V97928)) (OPT L801-6K3 (V06725)) (OPT HL13VAZ6-3 (V08524)) (OPT HL13V3 (V06725))	E-K,P ,Q	12

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-475	NAS1805-3N		.NUT	E-K,P /Q	4
480	HL79-6		.COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))	E-K,P /Q	8
485	313T3100-11		.ANGLE-LATCH OUTER	E-K,P /Q	1
490	313T3100-12		.ANGLE-LATCH OUTER	E-K,P /Q	1
495	HL13VAZ6-3		.BOLT- (V56878) (SPEC BACB30NY6K3) (OPT HL13VAZ6-3 (V73197)) (OPT HL13VAZ6-3 (V92215)) (OPT HL13VAZ6-3 (V97928)) (OPT L801-6K3 (V06725)) (OPT HL13VAZ6-3 (V08524)) (OPT HL13V3 (V06725))	E-K,P /Q	12
500	HL79-6		.COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))	E-K,P /Q	12

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-505	313T3100-9		.ANGLE-LATCH INNER	E-K,P ,Q	1
510	313T3100-10		.ANGLE-LATCH INNER	E-K,P ,Q	1
515	HL10VAZ6-3		.BOLT- (V60516) (SPEC BACB30MY6K3) (OPT HL10VAZ6-3 (VOPTK6))	E-K,P ,Q	6
520	HL79-6		.COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))	E-K,P ,Q	6
525	BACR15FT5KE		.RIVET- (SIZE DETERMINE ON INST)	E-K,P ,Q	12
530	313T3100-21		.ANGLE-ATTACH	E-K,P ,Q	1
535	313T3100-22		.ANGLE-ATTACH	E-K,P ,Q	1
540	HL13VAZ6-3		.BOLT- (V56878) (SPEC BACB30NY6K3) (OPT HL13VAZ6-3 (V73197)) (OPT HL13VAZ6-3 (V92215)) (OPT HL13VAZ6-3 (V97928)) (OPT L801-6K3 (V06725)) (OPT HL13VAZ6-3 (V08524)) (OPT HL13V3 (V06725))	E-K,P ,Q	21

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-545	HL79-6		.COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))	E-K,P ,Q	21
R	550	313T3100-53	.FRAME-STA 126.3	E-K	1
	-550A	313T3100-104	.FRAME-STA 126.3	P,Q	1
	555	313T3100-23	.LONGERON	E-K,P ,Q	1
	560	313T3100-24	.LONGERON	E-K,P ,Q	1
	565	HL13VAZ5-2	.BOLT- (V56878) (SPEC BACB30NY5K2) (OPT HL13VAZ5-2 (V73197)) (OPT HL13VAZ5-2 (V92215)) (OPT HL13VAZ5-2 (V97928)) (OPT L801-5K2 (V06725)) (OPT HL13VAZ5-2 (V08524)) (OPT HL13V2 (V06725))	E-K,P ,Q	21

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-570	HL70-5		.COLLAR- (V56878) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878))	E-K,P ,Q	21
575	313T3100-81		.STRAP	E-K,P ,Q	1
580	HL13VAZ5-2		.BOLT- (V56878) (SPEC BACB30NY5K2) (OPT HL13VAZ5-2 (V73197)) (OPT HL13VAZ5-2 (V92215)) (OPT HL13VAZ5-2 (V97928)) (OPT L801-5K2 (V06725)) (OPT HL13VAZ5-2 (V08524)) (OPT HL13V2 (V06725))	E-K,P ,Q	15
585	HL70-5		.COLLAR- (V56878) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878))	E-K,P ,Q	15

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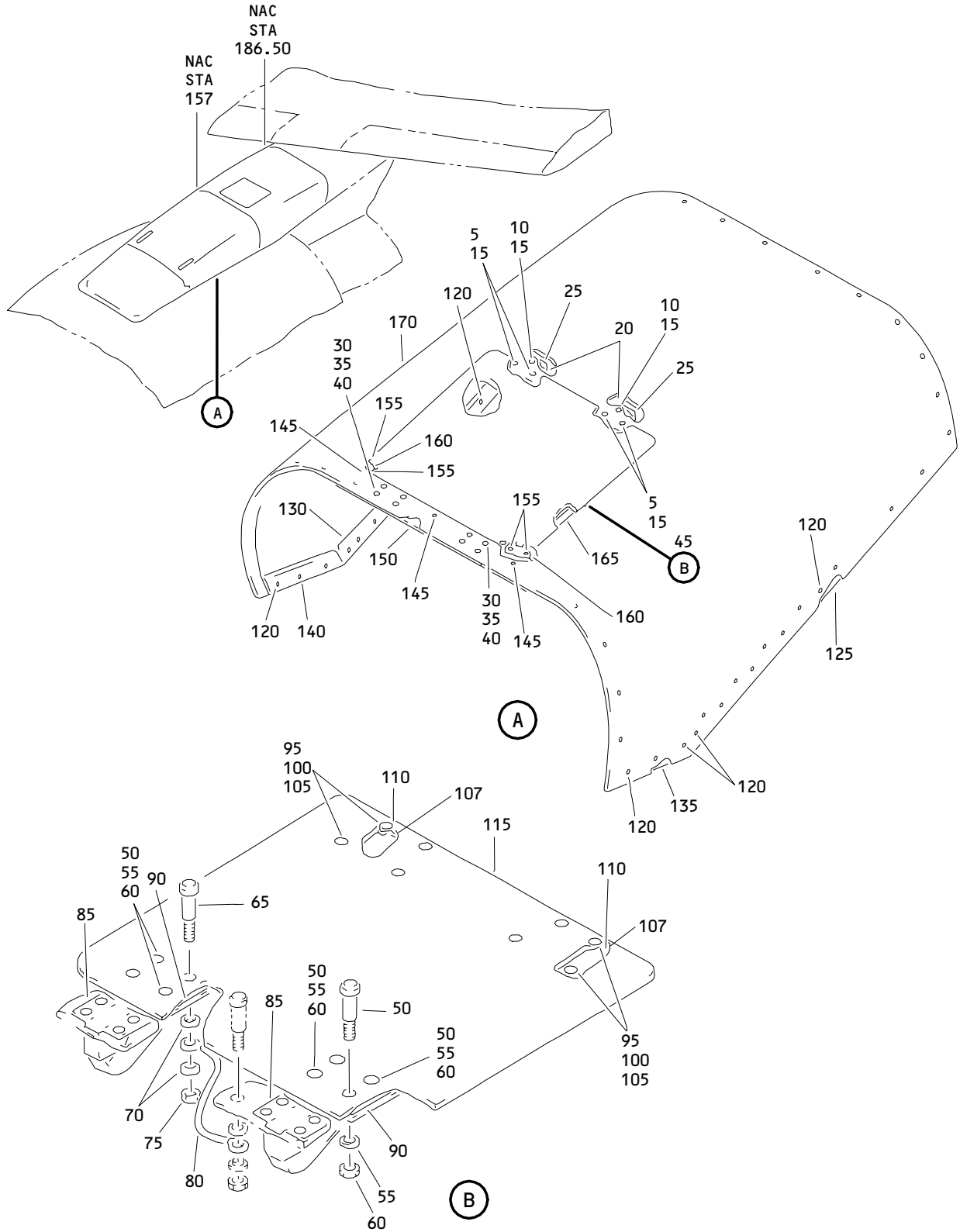

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-590	BACR15BA5KE2		.RIVET	E-K,P,Q	2
595	313T3100-82		.STRAP	E,F,Q	1
600	313T3100-98		.STRAP	G-K,P,Q	1
605	313T3101-18		.PANEL ASSY	F,H,J	1
-605A	313T3101-28		.PANEL ASSY	G,K,P,Q	1
-605B	313T3101-18		.PANEL ASSY- (ITEM 610 TOGETHER WITH ITEM 615 OPT ITEM 605B)	E	1
610	313T3101-20		.PANEL ASSY- (ITEM 610 TOGETHER WITH ITEM 615 OPT ITEM 605B)	E	1
615	313T3100-83		.FILLER- (ITEM 610 TOGETHER WITH ITEM 615 OPT ITEM 605B)	E	1

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Aft Section Assembly  
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
-1	313T3100-4		SECTION ASSY-AFT	L	RF
-1A	313T3100-88		SECTION ASSY-AFT	M	RF
-1B	313T3100-94		SECTION ASSY-AFT	N	RF
R -1C	313T3100-105		SECTION ASSY-AFT	S	RF
R -1D	313T3100-106		SECTION ASSY-AFT	R	RF
R -1E	313T3100-111		SECTION ASSY-AFT	T	RF
5	BACB30LU04-2		.SCREW	L-N, R-T	4
10	BACB30LU04-3		.BOLT	L-N, R-T	2
15	H10-04BAC		.NUT- (V15653) (SPEC BACN10JC04) (OPT NS202101-40 (V80539)) (OPT RMLH9075-40W (V72962)) (OPT T6S440J (V11815)) (OPT VN303A40 (V92215)) (OPT 96-40 (V80539)) (OPT BRH10A04 (V52828))	L-N, R-T	6
20	313T3100-48		.SHIM-LATCH (MFD FROM AL SH BAC1534-15 X .8 IN. X 2.0 IN.)	L-N, R-T	2
25	313T3100-58		.STRIKER-LATCH	L-N, R-T	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-30	HL13VAZ6-3		.BOLT- (V56878) (SPEC BACB30NY6K3) (OPT HL13VAZ6-3 (V73197)) (OPT HL13VAZ6-3 (V92215)) (OPT HL13VAZ6-3 (V97928)) (OPT L801-6K3 (V06725)) (OPT HL13VAZ6-3 (V08524)) (OPT HL13V3 (V06725))	L-N, R-T	8
35	AN960C10L		.WASHER	L-N, R-T	8
40	H10-3BAC		.NUT- (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828))	L-N, R-T	8
45	313T3103-1		.DOOR ASSY	L-N	1
R -45A	313T3103-16		.DOOR ASSY	R,S	1
R -45B	313T3103-22		.DOOR ASSY	T	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-50	HL13VAZ5-8		..BOLT- (V56878) (SPEC BACB30NY5K8) (OPT HL13VAZ5-8 (V73197)) (OPT HL13VAZ5-8 (V92215)) (OPT HL13VAZ5-8 (V97928)) (OPT L801-5K8 (V06725)) (OPT HL13VAZ5-8 (V08524)) (OPT HL13V8 (V06725))	L-N, R-T	7
55	AN960PD8L		..WASHER	L-N, R-T	7
60	H10-08BAC		..NUT- (V15653) (SPEC BACN10JC08) (OPT NS202101-82 (V80539)) (OPT RMLH9075-82W (V72962)) (OPT T6S832J (V71087)) (OPT VN303A82 (V92215)) (OPT 96-82 (V80539)) (OPT BRH10A08 (V52828))	L-N, R-T	7

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-65	HL215-10		..BOLT- (V56878) (SPEC BACB30JC5-10) (OPT HL215-10 (V73197)) (OPT HL215-10 (V80539)) (OPT HL215-10 (V92215)) (OPT HL215-10 (V97928)) (OPT L8385-10 (V06725)) (OPT WC155-10 (V60516)) (OPT HL21-5-10 (V56878)) (OPT HL21-5-10 (V73197)) (OPT HL21-5-10 (V80539)) (OPT HL21-5-10 (V92215)) (OPT HL21-5-10 (V97928)) (OPT L838-5-10 (V06725)) (OPT WC15-5-10 (V60516)) (OPT HL21-5-10 (V60516)) (OPT HL21-10 (V08524))	L-N, R-T	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-70	AN960D8L		..WASHER	L-N, R-T	2
75	H10-08BAC		..NUT- (V15653) (SPEC BACN10JC08) (OPT NS202101-82 (V80539)) (OPT RMLH9075-82W (V72962)) (OPT T6S832J (V71087)) (OPT VN303A82 (V92215)) (OPT 96-82 (V80539)) (OPT BRH10A08 (V52828))	L-N, R-T	1
80	BACJ40A20-6		..JUMPER	L-N, R-T	1
85	H2904-1		..HINGE ASSY- (V83014) (OPT ITEM 85A)	L-N, R-T	2
-85A	9313-1		..HINGE ASSY- (V84256) (OPT ITEM 85)	L-N, R-T	2
90	BACS40R014B016F		..SHIM	L-N, R-T	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-95	BACB30LU06-2		..BOLT	L-N, R-T	8
100	AN960C6L		..WASHER	L-N, R-T	8
105	H10-06BAC		..NUT- (V15653) (SPEC BACN10JC06) (OPT RMLH9075-62W (V72962)) (OPT T6S632J (V11815)) (OPT VN303A62 (V92215)) (OPT 96-62 (V80539)) (OPT BRH10A06 (V52828)) (OPT NS202101-62 (V80539))	L-N, R-T	8
110	9488-13		..LATCH- (V84256) (SPEC S311T306-2) (OPT H2901-1 (83014)) (TL22013-102 (V29372))	L-N, R-T	2
115	313T3103-10		..PANEL ASSY- (OPT ITEM 115A)	L-N	1
-115A	313T3103-12		..PANEL ASSY- (OPT ITEM 115)	L-N	1
R -115B	313T3103-17		..PANEL ASSY	R,S	1
R -115C	313T3103-23		..PANEL ASSY	T	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-120	BACR15BA5AD		.RIVET- (SIZE DETERMINE ON INST)	L-N, R-T	16
125	313T3100-79		.FILLER-UPR	L-N, R-T	1
130	313T3100-80		.FILLER-UPR	L-N, R-T	1
135	313T3100-77		.FILLER-LWR	L-N, R-T	1
140	313T3100-78		.FILLER-LWR	L-N, R-T	1
145	BACR15BA5AD		.RIVET- (SIZE DETERMINE ON INST)	L-N, R-T	4
150	313T3100-51		.ANGLE-DOOR	L-N,S	1
R 150A	313T3100-107		.ANGLE-DOOR	R,T	1
155	MS20427M2		.RIVET- (SIZE DETERMINE ON INST)	M	4
160	313T3100-87		.PLATE-SPLICE	M	2
165	313T3100-86		.GASKET-RUBBER	M	1
170	313T3101-3		.PANEL ASSY	L,M	1
-170A	313T3101-27		.PANEL ASSY	N,R-T	1

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