TO: ALL HOLDERS OF NO. 2 OPENABLE CABIN WINDOW ASSEMBLY COMPONENT MAINTENANCE MANUAL 56-11-12

REVISION NO. 26 DATED NOV 01/05

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 Record of Revision sheet.

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
802-803 1022,1050,1052,1064	Added clarifications and updated callouts.
802	Changed design dimensions and wear limits at Locations C and D.
1006-1020,1028,1030, 1063	Changed fastener callouts at the power terminals.
1063-1066	Added optional windows.
1068	Changed usage of frame 141T4852-36.

NO. 2 OPENABLE CABIN WINDOW ASSEMBLY

PART NUMBERS 141T0012-5005 THRU -5008,-5013, -5014,-5025,-5026,-5031, -5032
141T4835-1 THRU -18,-21,-22,-26, -27,-28,-36,-37,-38,-41, -43,-45 THRU -48,-65 THRU -68,-503,-504,-507,-508
015T0195-7 THRU -16

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

2354

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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		PRR B10218	JUL 10/82
		PRR B10120	JUL 10/83
		PRR B10410	JUL 10/83
		PRR C20025	JUL 10/83
		PRR C20043	JAN 10/85
		PRR B10842	JAN 10/85
SB 56-002		PRR B11370	JAN 10/86
		PRR B11368	JAN 10/86
	56-1		JAN 10/86
		PRR B11567	JAN 01/89
		PRR B11567-1	OCT 01/91
		PRR 61294	MAR 01/95
SB 767-30-0020R1			MAR 01/95
		PRR B12642	JUN 01/95
		PRR B12812	DEC 01/95
		PRR B12901-58S	JUL 01/04

PAGE	DATE	CODE
56-11-12		
TITLE PAGE		
1	JUL 01/04	01.1
2	BLANK	
REVISION RECORD		
1	JUL 01/99	01.1
2	BLANK	
TR & SB RECORD		
1	JUL 01/04	01.1
2	BLANK	
LIST OF EFFECTIVE PAGES		
*1	NOV 01/05	01
THRU LAST PAGE		
CONTENTS		
1	JUL 01/99	01.1
2	BLANK	
INTRODUCTION		
1	JUL 01/99	01.1
2	BLANK	
DESCRIPTION & OPERATION		
1	JUL 01/99	01.1
2	BLANK	
TESTING & TROUBLE SHOOTING		
101	NOV 01/00	01.1
102	JUL 01/00	01.1
DISASSEMBLY		
301	JUL 01/01	01.1
302	JUL 01/99	01.1
303	JUL 01/99	01.1
304	JUL 01/01	01.1
305	JUL 01/99	01.1
306	BLANK	

PAGE	DATE	CODE
CLEANING		
401	MAR 01/04	01.1
402	BLANK	
CHECK		
501	MAR 01/04	01.1
502	JUL 01/99	01.1
503	JUL 01/99	01.1
504	JUL 01/99	01.1
505	JUL 01/05	01.1
506	JUL 01/05	01.1
507	JUL 01/99	01.1
508	JUL 01/99	01.1
REPAIR-GENERAL		
601	JUL 01/03	01.1
602	JUL 01/03	01.1
603	NOV 01/00	01.1
604	NOV 01/00	01.1
REPAIR 1-1		
601	NOV 01/00	01.1
602	JUL 01/99	01.1
REPAIR 2-1		
601	JUL 01/03	01.1
602	BLANK	
REPAIR 3-1		
601	JUL 01/03	01.1
602	JUL 01/03	01.1
603	JUL 01/03	01.1
604	JUL 01/03	01.1
605	JUL 01/03	01.1
606	JUL 01/03	01.1
REPAIR 3-2		
601	JUL 01/99	01.1
602	JUL 01/99	01.1
603	JUL 01/99	01.1
604	JUL 01/99	01.1

* = REVISED, ADDED OR DELETED

PAGE	DATE	CODE
REPAIR 3-3		
601	JUL 01/04	01.1
602	JUL 01/04	01.101
603	JUL 01/04	01.101
604	JUL 01/04	01.1
605	JUL 01/04	01.1
606	JUL 01/04	01.101
607	JUL 01/99	01.1
608	JUL 01/99	01.1
609	JUL 01/99	01.1
610	JUL 01/99	01.1
611	JUL 01/99	01.1
612	JUL 01/99	01.1
613	JUL 01/99	01.1
614	JUL 01/99	01.1
615	JUL 01/99	01.1
616	BLANK	
REPAIR 4-1		
601	NOV 01/00	01.1
602	NOV 01/00	01.1
603	NOV 01/00	01.1
604	BLANK	
REPAIR 4-2		
601	NOV 01/00	01.1
602	NOV 01/00	01.1
603	JUL 01/03	01.101
604	JUL 01/03	01.1
REPAIR 5-1		
601	NOV 01/00	01.1
602	NOV 01/00	01.1
REPAIR 6-1		
601	JUL 01/03	01.1
602	JUL 01/03	01.1
603	JUL 01/03	01.1
604	JUL 01/03	01.1
605	JUL 01/03	01.1
606	JUL 01/03	01.1

PAGE	DATE	CODE
REPAIR 6-2		
601	JUL 01/99	01.1
602	JUL 01/99	01.1
REPAIR 6-3		
601	JUL 01/03	01.1
602	JUL 01/03	01.1
603	JUL 01/99	01.1
604	JUL 01/99	01.1
605	JUL 01/99	01.1
606	JUL 01/99	01.1
607	JUL 01/99	01.1
608	JUL 01/99	01.1
REPAIR 7-1		
601	JUL 01/04	01.1
602	JUL 01/04	01.1
REPAIR 8-1		
601	JUL 01/04	01.1
602	JUL 01/04	01.1
603	JUL 01/04	01.101
604	JUL 01/04	01.1
ASSEMBLY		
701	JUL 01/01	01.1
702	JUL 01/01	01.1
703	JUL 01/01	01.1
704	JUL 01/01	01.1
705	JUL 01/00	01.1
706	JUL 01/01	01.1
707	JUL 01/01	01.1
708	JUL 01/01	01.1
709	JUL 01/01	01.1
710	JUL 01/01	01.1
711	JUL 01/04	01.1
712	JUL 01/01	01.1
713	JUL 01/01	01.1
714	JUL 01/01	01.1
715	JUL 01/01	01.1
716	JUL 01/01	01.101
717	JUL 01/01	01.101
718	BLANK	

* = REVISED, ADDED OR DELETED

PAGE	DATE	CODE
FITS AND CLEARANCES		
801	JUL 01/99	01.1
*802	NOV 01/05	01.1
*803	NOV 01/05	01.1
804	JUL 01/99	01.1
SPECIAL TOOLS		
901	JUL 01/04	01.1
902	BLANK	
ILLUSTRATED PARTS LIST		
1001	JUL 01/99	01.1
1002	JUL 01/99	01.1
1003	JUL 01/99	01.1
1004	JUL 01/99	01.1
1005	JUL 01/99	01.1
*1006	NOV 01/05	01.1
*1007	NOV 01/05	01.1
*1008	NOV 01/05	01.1
*1009	NOV 01/05	01.1
*1010	NOV 01/05	01.1
*1011	NOV 01/05	01.1
*1012	NOV 01/05	01.1
*1013	NOV 01/05	01.1
*1014	NOV 01/05	01.1
*1015	NOV 01/05	01.1
*1016	NOV 01/05	01.1
*1017	NOV 01/05	01.1
*1018	NOV 01/05	01.1
*1019	NOV 01/05	01.1
*1020	NOV 01/05	01.1
1021	JUL 01/99	01.1
*1022	NOV 01/05	01.1
1023	JUL 01/01	01.1
1024	JUL 01/99	01.1
1025	JUL 01/04	01.1
1026	JUL 01/99	01.1
1027	JUL 01/99	01.1
*1028	NOV 01/05	01.1
1029	JUL 01/99	01.1
*1030	NOV 01/05	01.1
1031	JUL 01/99	01.1
1032	JUL 01/04	01.1

PAGE	DATE	CODE
ILLUSTRATED PARTS LIST		CONT.
1033	JUL 01/99	01.1
1034	JUL 01/04	01.1
1035	JUL 01/04	01.1
1036	JUL 01/04	01.1
1037	JUL 01/04	01.1
1038	JUL 01/04	01.1
1039	JUL 01/04	01.1
1040	JUL 01/04	01.1
1041	JUL 01/04	01.1
1042	JUL 01/04	01.1
1043	JUL 01/04	01.1
1044	JUL 01/04	01.1
1045	JUL 01/04	01.1
1046	JUL 01/04	01.1
1047	JUL 01/04	01.1
1048	JUL 01/04	01.1
1049	JUL 01/04	01.1
*1050	NOV 01/05	01.1
*1051	NOV 01/05	01.101
*1052	NOV 01/05	01.1
*1053	NOV 01/05	01.101
1054	JUL 01/04	01.1
1055	JUL 01/04	01.1
1056	JUL 01/04	01.101
1057	JUL 01/04	01.1
1058	JUL 01/04	01.1
1059	JUL 01/04	01.1
1060	JUL 01/04	01.1
1061	JUL 01/04	01.1
1062	JUL 01/04	01.1
*1063	NOV 01/05	01.1
*1064	NOV 01/05	01.1
*1065	NOV 01/05	01.1
*1066	NOV 01/05	01.1
*1067	NOV 01/05	01.101
*1068	NOV 01/05	01.1
*1069	NOV 01/05	01.101
*1070	NOV 01/05	01.101
1071	JUL 01/04	01.1
1072	JUL 01/04	01.101
1073	JUL 01/04	01.1
1074	JUL 01/04	01.1

* = REVISED, ADDED OR DELETED

TABLE OF CONTENTS

INTRODUCTION

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

This manual is divided into separate sections:

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

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

The beginning of the REPAIR section includes a list of the separate repairs, a list of applicable standard Boeing practices, and an explanation of the True Position Dimensioning symbols used.

An explanation of the use of the Illustrated Parts List is provided in the Introduction to that section.

All weights and measurements used in the manual are in English units, unless otherwise stated. When metric equivalents are given they will be in parentheses following the English units.

Design changes, optional parts, configuration differences and Service Bulletin modifications create alternate part numbers. These are identified in the Illustrated Parts List (IPL) by adding an alphabetical character to the basic item number. The resulting item number is called an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless otherwise indicated.

Verification:

Testing/Troubleshooting
Assembly September 30, 1983

NO. 2 OPENABLE CABIN WINDOW ASSEMBLY

DESCRIPTION AND OPERATION

1. Description and Operation

   A. The openable cabin window permits ventilation and crew communication during ground handling of the airplane. The window frame supports a laminated windowpane consisting of either a thick vinyl core sandwiched by sheets of stretched acrylic or three glass plies separated by interlayers. A conductive film between the outer pane and the core provides electrical heating of the window. Mounted on the window frame are latch cams which lock and unlock the window. A teleflex cable operated by a latch handle rotates the latch cams. A window mounted latch hook prevents operation of the latch handle to the "closed" position unless the window is closed. When the latch is in the "open" position, the turning of a crank inside the airplane allows the window to slide open along tracks mounted at the top and bottom of the window.

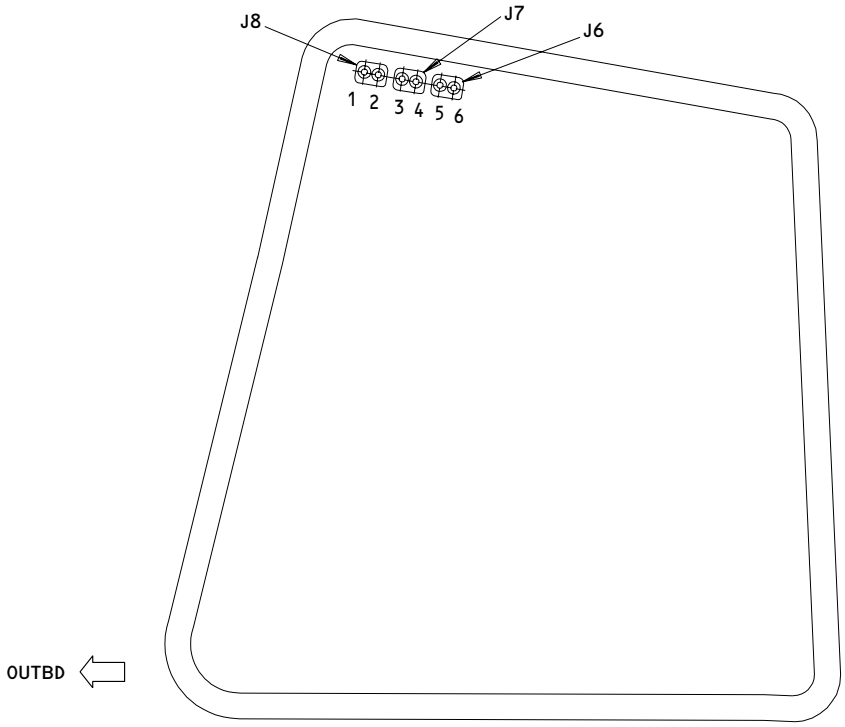
2. Leading Particulars (Approximate)

   A. Length -- 31 inches
      Width -- 4 inches
      Height -- 40 inches
      Weight -- 92 pounds (acrylic window assembly)
             -- 109 pounds (glass windshield assembly)

TESTING AND TROUBLE SHOOTING

1. Test Window Assembly (679)

A. With a Wheatstone bridge, make a check of the bus-to-bus and sensor resistance as shown in Fig. 101.



WINDOW	TERMINAL	TERMINAL LOCATION	RESISTANCE (OHM)
ALL	J6	5-6	SEE TABLE B
ALL	J7	3-4	SEE TABLE B
141T4810 (ACRYLIC)	J8	1-2	17.43 - 23.59
141T4001 (GLASS)	J8	1-2	16.60 - 20.28

J6: SENSOR TERMINAL (CONTROL)
J7: SENSOR TERMINAL (SPARE)
J8: POWER TERMINAL

TABLE A

No. 2 Window Resistance Values
Figure 101 (Sheet 1)

182851

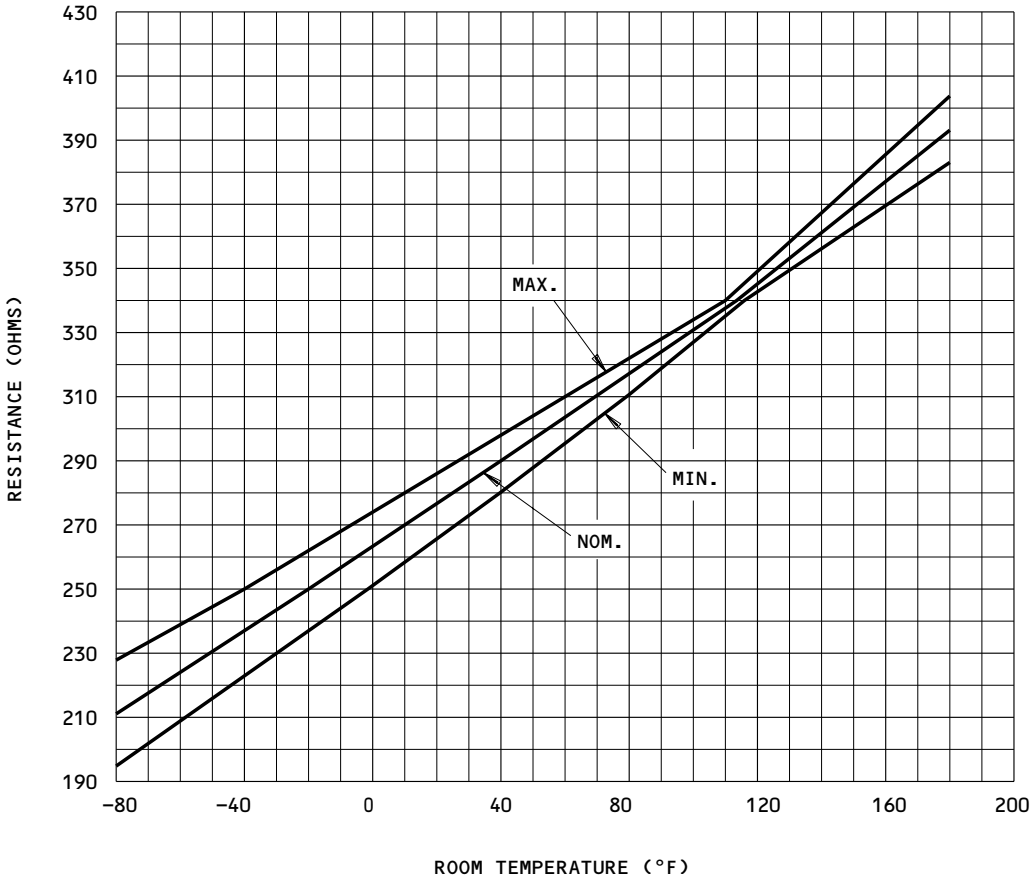


TABLE B

NOTE: CHARACTERISTICS SHOWN EQUIVALENT
TO WESTINGHOUSE AVK 1160.

No. 2 Window Resistance Values
Figure 101 (Sheet 2)

118128

DISASSEMBLY

CAUTION: GEAR HOUSINGS (460, 470), HOUSINGS (460A, 470A), HOUSINGS (465, 475), HOUSINGS (465A, 475A) ARE MATCHED SETS AND MUST BE KEPT TOGETHER TO BE SURE OF CORRECT OPERATION AFTER ASSEMBLY.

1. Use standard industry practices and these steps.

   NOTE: Disassemble this component only as necessary for fault isolation, to find the serviceability of parts, do the repairs and put the unit back in serviceable condition.

2. Make a note of the location and thickness of shims (520) and washers (524, 124, 257) to help during assembly.

3. Make a note of the location of the serrated portion of brackets (120, 121) compared to the serrated plate (67) to help during assembly.

4. Disassemble Latch Cam Helix Cable.

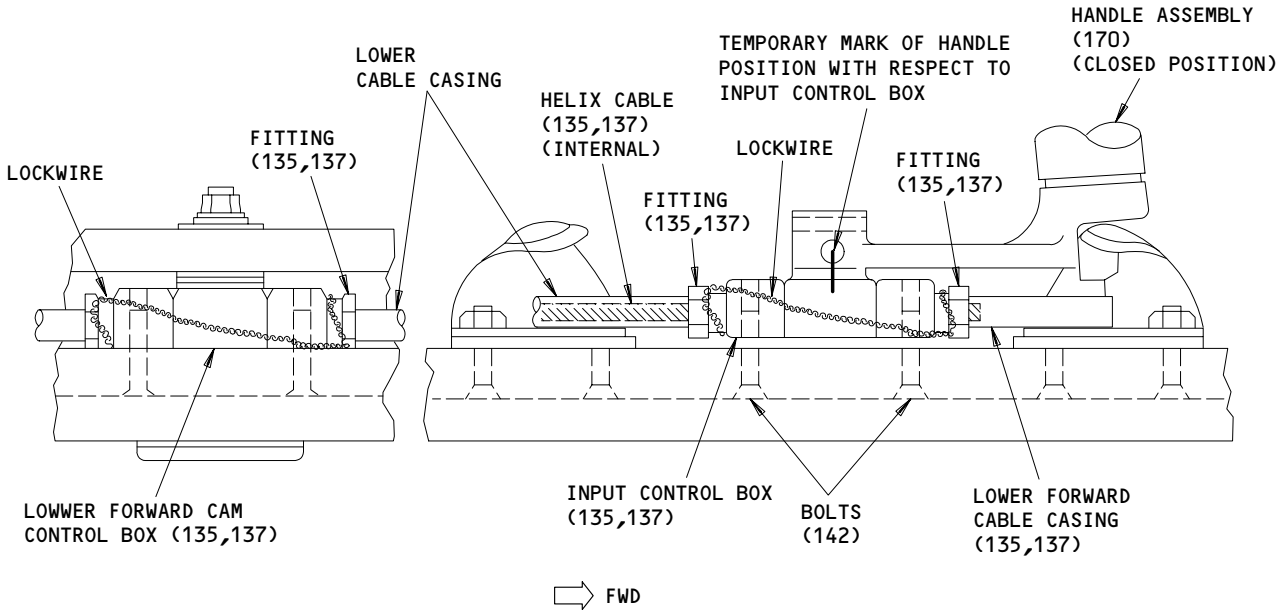
   A. Rotate handle assembly (170) to the closed position and make a temporary mark to index the handle closed position compared with the input control box (135, 137) (Fig. 301). On windows that have latch lock hook (247A, 247J), turn the latch hook away from the lower aft cam (135, 137) and hold it in this position. The handle will then go to the latched position and the cams will be free to turn during cable installation and removal (Fig. 302, Fig. 303).

   B. Keep all latch cams installed (Fig. 302, Fig. 303).

   C. Remove the lockwire and loosen the forward fitting at the lower forward cam control box (Fig. 301).

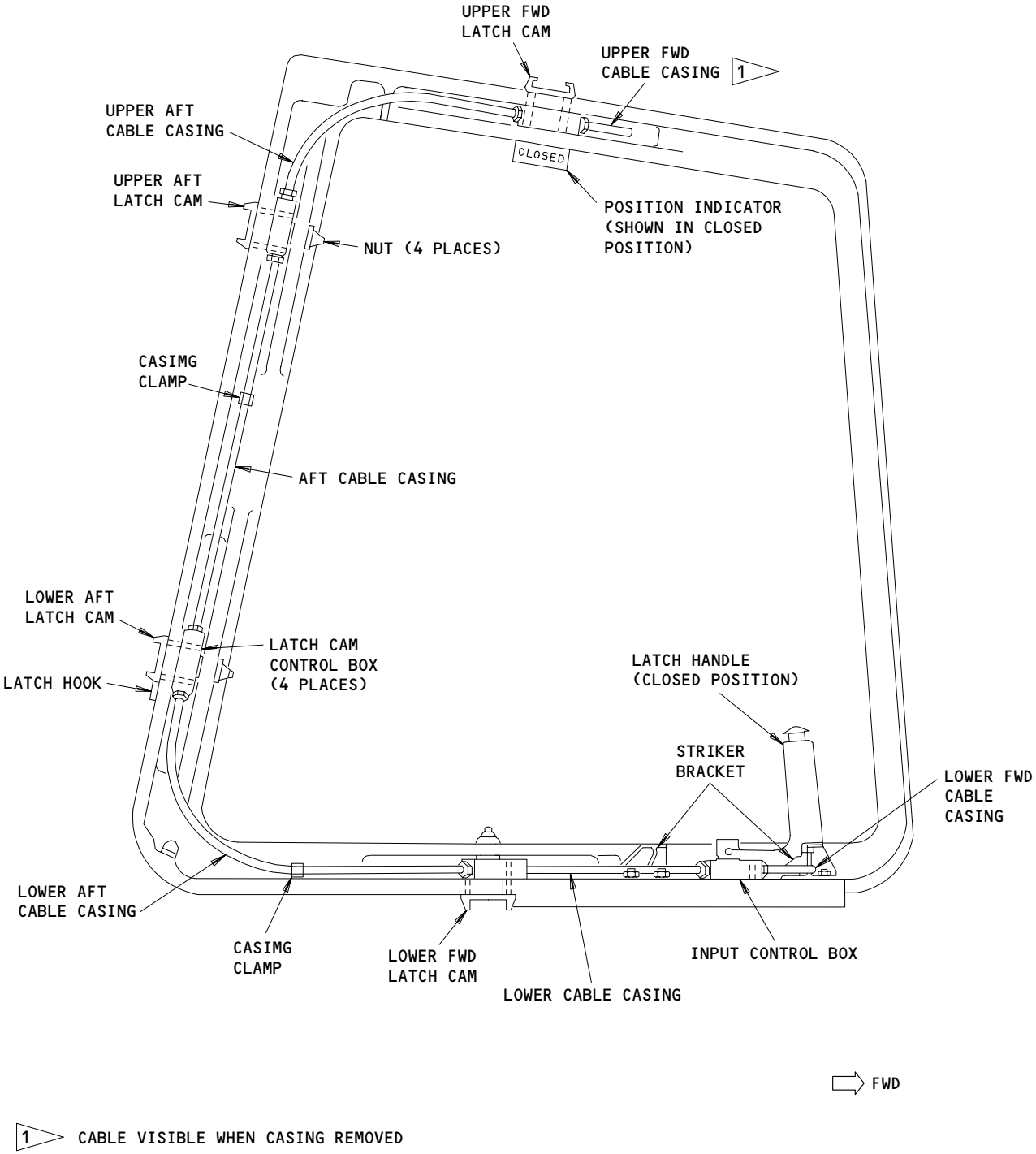
   D. Remove bolts (142) from the input control box (Fig. 301).

   E. Hold the handle and the control box with attached two tubes, and slowly remove the cable from all four latches.

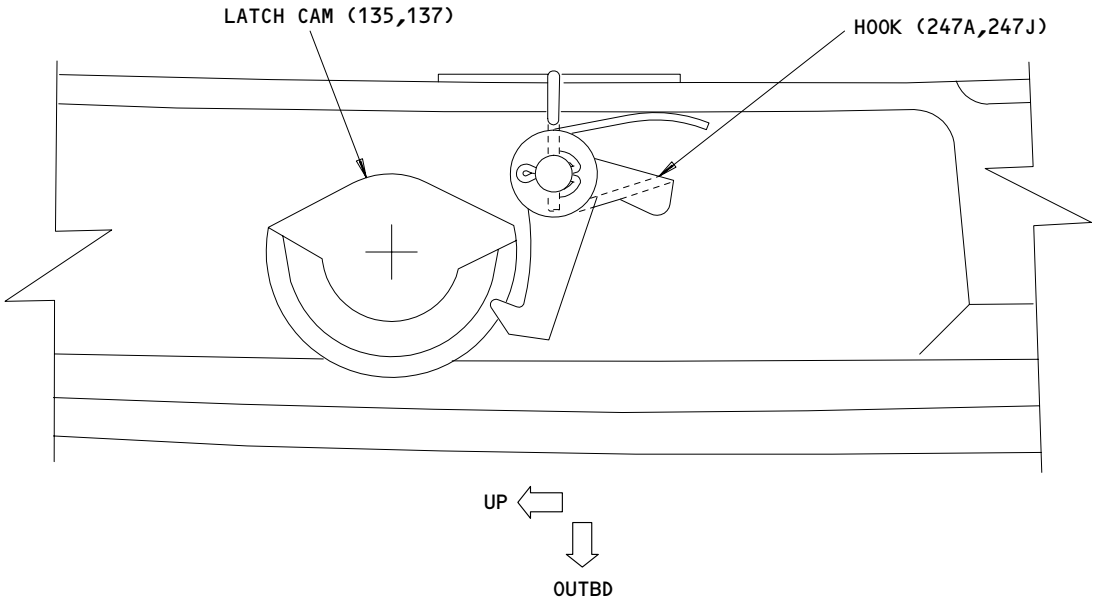


Latch Cam Helix Cable Disassembly
Figure 301

195039



Latch Cam Helix Cable Disassembly
Figure 302



Latch Cam Helix Cable Disassembly
Figure 303

200295

5. Laminate Assembly.

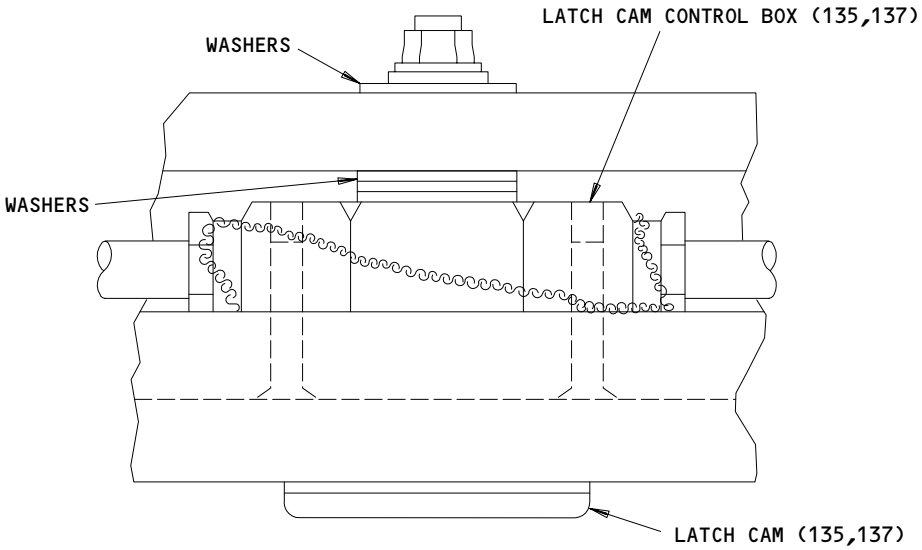
A. Do steps 4.A. thru 4.E. above.

B. Disassemble latch cams (Fig. 304).

NOTE: When you remove the washers and shims, be sure to identify them with their latch cam location, or make notes of their thickness to help during assembly.

C. Remove fasteners (545A, 680J).

D. Remove laminate assembly (535A, 540A, 679, 680E) from frame assembly (615A, 617, 620A, 622, 683H, 683M).



Latch Cam Disassembly
Figure 304

200132

CLEANING

1. Materials

A. Solvent -- TT-N-95, Aliphatic Naphtha (SOPM 20-60-01)

2. Cleaning

A. Clean all parts by standard industry practices and these steps.

CAUTION: DO NOT RUB DRY PLASTIC WITH DRY CLOTH. THIS CAN CAUSE SCRATCHES AND AN ELECTROSTATIC CHARGE WHICH ATTRACTS DUST PARTICLES.

B. Clean windowpanes with lukewarm water and castile soap. Use a soft, clean cloth to apply the soap solution to the pane, but go over the surface with only the bare hand to find and remove dirt that could scratch the surface. Wipe dry with a clean, damp chamois.

C. Clean moisture seals (570A, 575A, 682C, IPL Fig. 1) with aliphatic naphtha applied with clean, oil-free, absorbent materials. Wipe off the solvent before it evaporates, with a clean, oil-free and lint-free cloth. Apply more clean solvent as necessary.

D. Clean bearings by the instructions in SOPM 20-30-01.

CHECK

1. Examine all parts for defects by standard industry practices. Do the magnetic particle check and penetrant check only if the parts are disassembled, and if the visual check finds possible defects.

2. Magnetic particle check (SOPM 20-20-01) -- Safety catch (235, IPL Fig. 1), tube (355), gears (310A, 320A, 420, 455), plate (689), bracket (730), springs (246), hook (247A), pin (248), retainer (249).

CAUTION: GEAR HOUSINGS (460, 470), HOUSINGS (460A, 470A), HOUSINGS (465, 475) AND HOUSINGS (465A, 475A) ARE MATCHED SETS AND MUST BE KEPT TOGETHER.

3. Penetrant check (SOPM 20-20-02) -- Brackets (60A, 65A), position indicator (132), grip (210), upper guide (225), lower guide (240), gear housings (460, 460A, 465, 465A, 470, 470A, 475, 475A), and fittings (630A, 635A 685A, 686).

4. Examine moisture seals (570A, 575A, 682C) for signs of leakage.

5. Window defect definitions are as follows:

   A. Arcing:

      (1) Arcing is the flow of electricity between two points where there is a break in the circuit.

      (2) Arcing usually occurs near the window bus bars.

      (3) You can identify the heat damage caused by arcing, as follows:

         (a) Brown or black burn marks in the interlayer.

         (b) Cracks in the windshield face ply.

   B. Crazing (acrylic plies only):

      (1) Crazing is many very fine fissures with no visible width or depth at the surface of a ply.

(2) Crazing will start to be noticeable when the depth of the cracks are 0.002 to 0.004 inch.

(3) In dim light, and light normal to the surface, crazing is difficult to see.

(4) In a bright light shown from an angle to the surface, crazing looks frosted and appears to light up.

(5) Crazing often develops into cracks.

C. Cracks:

(1) A crack is a fissure that has visible width or depth.

(2) Cracks can start from a scratch or a crazing mark (Fig. 601).

(3) Cracks can be single or dual (Fig. 601).

(4) Cracks in glass will usually occur 90 degrees to the surface of the pane.

(5) Cracks in stretched acrylic plastic will occur at a 45 degree angle to the surface of the ply and can become in-plane cracking.

(6) The cracks in an outer vinyl ply (the ply between the middle structural ply and the outer ply) are caused by incorrect heat application.

(7) The cracks in the vinyl usually occur in the window corners and are within the dges of the release tape.

NOTE: Vinyl cracks are not a problem structurally.

NOTE: Only replace the windshield if your vision is limited.

D. Scratches:

(1) A scratch is the removal of material from the surface of the window.

(2) Scratches usually occur in a straight line or slight curve.

(3) The depth of a scratch is not usually preater than the width of the scratch.

(a) The depth of a small scratch is 0.001 to 0.004 inch.

NOTE: On a small scratch, the material that was removed does not remain on the sides of the scratch.

(b) The depth of a large scratch is 0.005 inch or more.

NOTE: On a large scratch, the material that was removed remains on the sides of the scratch.

E. Chips:

(1) Chips are pieces or layers of glass broken from the surface.

(2) Chips usually occur at the front part of the window.

(3) Spall (shell-type) chips:

(a) Spall chips are circular with many fine ridges.

(b) The ridges in the chip follow the outer edge and get smaller and deeper near the center and give it a clamshell appearance.

(c) Spall chips do not usually cause structural failure of the windshield.

(4) Vee-shaped chips:

(a) These chip have a sharp "V" shape bottom that continues to the surface of the ply.

(b) V-shaped chips usually do not occur in chemically treated glass.

(c) V-shaped chips can cause a windshield failure.

F. Delamination:

(1) Delamination is the separation of a ply or plies from the interlayer.

(2) Delamination can appear as a flat smooth air bubble with either a circular edge or smooth finger-like projections in the window.

(3) In reflected light, delamination at the coating surface are seen as shiny blue gold, or brown areas.

(4) In transmitted light, delamination at the coating surface are seen as brown areas.

(5) Delamination between the interlayer and the outer glass ply are usually not found until they move into the coating area.

(6) Delamination will not cause structural failure of the window assembly.

(a) Delamination at the coating surface may prevent correct operation of the window heat system.

(b) Delamination and window heat may also cause cracks in the outer glass ply.

G. In-Plane Cracking (acrylic plies only):

(1) In-plane cracking is also identified as delamination.

(2) In-plane cracking is a crack that grows parallel to the surface of the ply from an edge or crack.

(3) In-plane cracking looks like delamination but will not have the finger-like projections.

H. Bubbles:

(1) Too much window heat can cause small bubbles in the vinyl core.

6. Examine acrylic panes in window assemblies 141T4813-7, -8, -15, -16, -19, -20, -23 thru -30, -501, -502, -505, -506 for cracks, delamination, crazing, scratches, chips, and in-plane cracking as follows:

   A. Cracks of any kind -- not acceptable

   B. Delamination -- Boeing does not recommend that you use windows with edge delaminations because they will continue to delaminate and then must be replaced before the next maintenance. Windows with edge delaminations longer than 2.0 inches are not acceptable.

   C. Crazing, scraches, and chips -- permitted up to a 0.05 inch maximum depth, only if not a problem for visibility.

   D. In-plane cracking -- not acceptable.

   E. Examine panes for edge damage per Fig. 502.

7. Examine glass panes in window assemblies 141T4813-31, -32, -33, -34 only for scratches and chips as follows:

   A. Delamination -- not acceptable

   B. Scratches

      (1) Outboard glass ply -- permitted only if not a problem for visibility.

      (2) Inboard glass ply -- scratches must not be deeper than 0.002 inch.

   C. Chips

      (1) Main glass plies -- not permitted

      (2) Outboard glass ply -- permitted only if not a problem for visibility.

8. Make a check of the link arm assembly (480C) with a force scale.

   A. Push on the rod end bearing and preload nut to be sure that the preload of the assembly is 58-78 pounds. Make sure the rod end bearing operates smoothly and that the clear heat shrink sleeving is not loose or damaged.

B. Adjust the preload as follows:

(1) Remove the heat shrink sleeve at the preload nut end of the assembly

(2) Loosen the preload jamnut

(3) Adjust the preload nut to 58-78 pounds

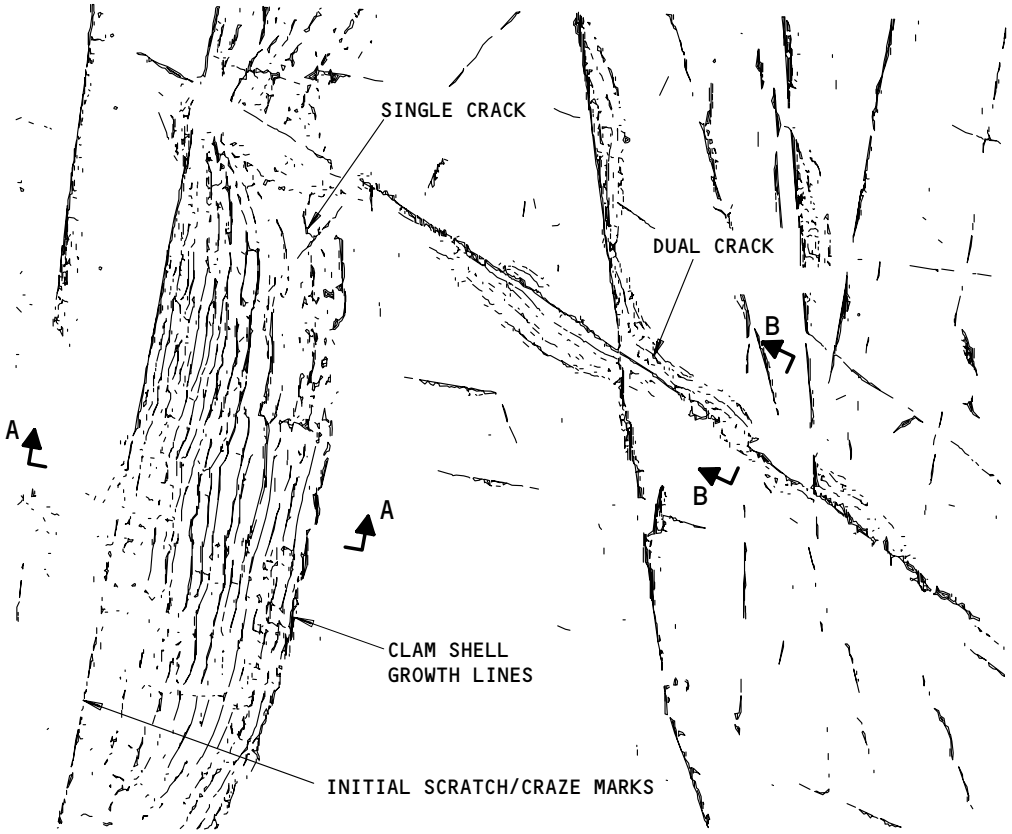
(4) Tighten the jamnut to 660-780 pound-inch

(5) Install new clear heat shrink sleeve over jamnut.

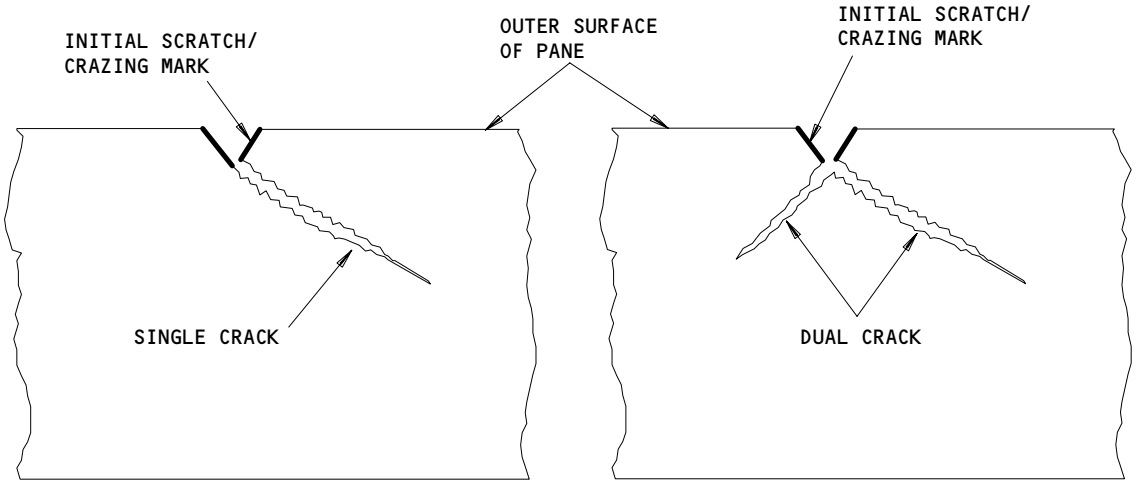
9. Examine terminal caps and terminals for a good bond. Power terminal cap (590, 682L), power terminals (600, 683C), and terminal cap (682T) must not move if given a 30 pound-inch torque, sensor terminal cap (585, 682J), sensor terminals (595, 683), and terminal cap (682T) must not move if given a 16 pound-inch torque.

10. Examine all roller bearings for radial and axial play.

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



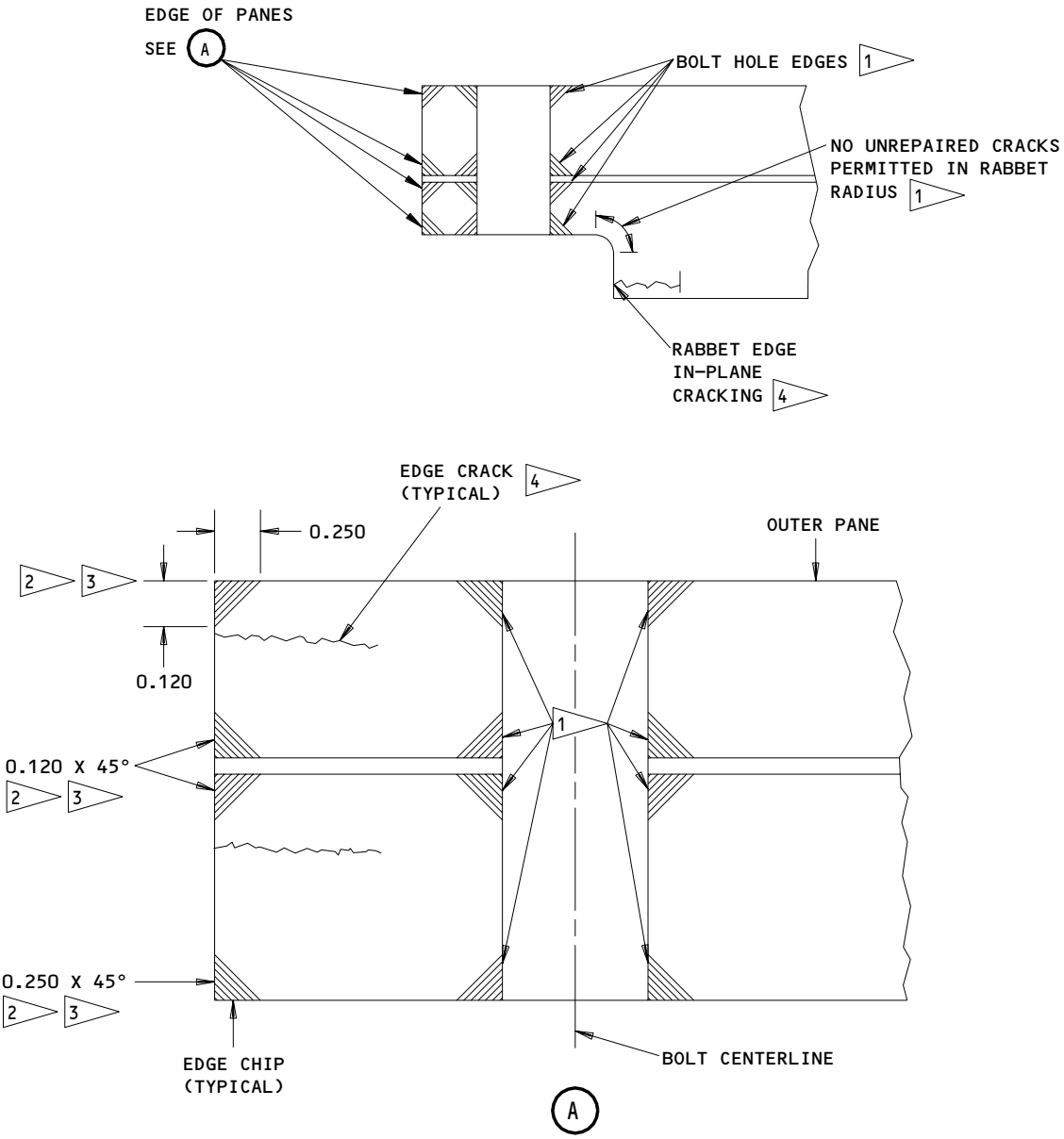
WINDOW SURFACE



A–A B–B

Window Surface Damage
Figure 501

132691



NOTE: ALL DIMENSIONS ARE IN INCHES

1. DAMAGE IN THIS AREA IS NOT PERMITTED UNREPAIRED.
2. MAY BE SMOOTHED TO 62RMS FINISH
3. ONLY ONE DEFECT PERMITTED WITHIN ANY CROSS SECTION OF THE INNER OR OUTER PANE WHEN DEFECT IS WITHIN ONE INCH OF MOUNTING HOLE CENTER LINE. THIS LIMITATION DOES NOT APPLY TO DEFECTS MORE THAN ONE INCH FROM MOUNTING BOLT HOLE CENTER LINE.
4. EDGE CRACKS (IN-PLANE CRACKS) PARALLEL TO THE PANE FACE ARE NOT PERMITTED UNREPAIRED.

Acrylic Edge Damage
Figure 502

G16074

REPAIR - GENERAL

1. Content

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

P/N	NAME	REPAIR
141T0012 141T4835 015T0195	NO. 2 WINDOW ASSEMBLY	1-1
141T4854	BRACKET ASSEMBLY	2-1
141T4813-7,-8, -15,16,-19, -20,-23 thru -30 -501,-502,-505, -506	WINDOW ASSEMBLY (ACRYLIC)	3-1, 3-2, 3-3
141T4912	GEAR ASSEMBLY	4-1, 4-2
- - - -	MISCELLANEOUS PARTS REFINISH	5-1
141T4813-31, -32,-33,-34	WINDOW ASSEMBLY (GLASS)	6-1, 6-2, 6-3
141T4865-10, -21	TORQUE TUBE ASSEMBLY	7-1
141T4865-11, -17,-22	TORQUE TUBE ASSEMBLY	8-1

2. Standard Practices

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

3. Materials and Equipment

NOTE: Equivalent substitutes can be used.

A. Buffing Compound -- Learok S-30 (SOPM 20-60-04)

B. Coating, Teflon -- BMS 10-86, Type 1, White (SOPM 20-60-02)

C. Enamel (SOPM 20-60-02)

(1) BMS 10-11, type 2, BAC8925 beige flat

(2) BMS 10-72, BAC8924 low sheen

D. Polish -- Learok 888 (SOPM 20-60-04)

E. Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

F. Protective Coating -- Spraylat SC-1071 (SOPM 20-44-02)

G. Protective Tape -- Scotch 670 or 3-9017 (SOPM 20-60-04)

H. Sandpaper, Aluminum Oxide -- Any source

I. Sealant -- BMS 5-95 (SOPM 20-60-04)

J. Adhesive -- PS-30 (SOPM 20-60-04)

K. Adhesive -- PS-18 (SOPM 20-60-04)

L. Solvent -- Aliphatic Naphtha TT-N-95 (SOPM 20-60-01)

M. Tape, Masking -- Any source

N. Sandpaper -- Wet-or-dry, 240 grit, any source

O. Parting Tape -- Scotch 8402 (SOPM 20-60-04)

P. Rubber -- BMS 1-23

Q. Solvent -- Ethyl Alcohol (SOPM 20-60-01)

R. Sealant -- RTV 157 (SOPM 20-60-04)

S. Sealant -- PR 1425 (SOPM 20-60-04)

T. Tape -- Polyken No. 223, 2 inches wide, color optional (SOPM 20-60-04)

U. Resin -- Acrylic Casting, MIL-A-8756, type 2 (SOPM 20-15-15)

V. Assembly Tool, No. 2 Window Assembly -- A56004-50

W. Adhesive -- EC2216 (SOPM 20-60-04)

4. Dimensioning Symbols

A. Standard True Position Dimensioning Symbols used in applicable repair procedures are shown in SOPM 20-00-00.

NO. 2 WINDOW ASSEMBLY (ACRYLIC) - REPAIR 1-1

141T0012-5005, -5006, -5007, -5008, -5013, -5014, -5025, -5026, -5031, -5032
141T4835-1 thru -18, -21, -22, -503, -504, -507, -508
015T0195-7 thru -16

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

1. Repair Chipped or Scratched Side Window

A. Cover undamaged side of window (1A, 5A, IPL Fig. 1) with protective tape or coating.

B. Remove superficial scratches by applying polish to wet, clean cloth and rubbing window. Use circular motion, starting at pane center, and work outward. Use clean, flannel cloth for each operation.

CAUTION: AVOID OVERHEATING WINDOW. KEEP BUFFING WHEEL IN CONSTANT MOTION OVER WINDOW SO THAT WINDOW SURFACE TEMPERATURE DOES NOT EXCEED 125° TO 130°F. AT THIS TEMPERATURE, WINDOW WILL NOT FEEL HOT WHEN TOUCHED BY THE BACK OF HAND WITHIN 2 SECONDS OF REMOVING PANE FROM BUFFING WHEEL.

C. Remove minor scratches and surface crazing by machine polishing or buffing.

(1) Buff if required with coarse compound (Learok S-30) at wheel surface speed of 3200 feet per minute on a stitched muslin wheel.

(2) Polish to high gloss with Learok 888 on a loosely stitched flannel wheel at wheel surface speed of 4200 feet per minute.

D. Remove chips or buildup material on major scratches by hand sanding.

(1) Using presoaked (wet-or-dry No. 400-A) sandpaper wrapped around sanding block, sand across buildup at approximately 45 degrees within diameter of approximately 4 inches. Change sandpaper as required.

(2) Remove sanding abrasions by sanding with No. 600-A wet-or-dry sandpaper.

E. Polish window with wax as follows:

(1) Thoroughly agitate wax to ensure homogeneous mixture.

(2) Apply wax directly to acrylic surface or to flannel polishing cloth and spread thin coat evenly and thoroughly over surface.

(3) Remove excess wax with flannel cloth.

(4) Polish to high luster by light polishing with clean, flannel cloth.

NOTE: Polishing may be done before or after wax has dried.

(5) Remove any streaks or fingerprints from waxed acrylic by lightly polishing with clean, flannel cloth. If appearance is still unsatisfactory, reapply wax in accordance with above procedure.

F. Measure window thickness after rework. Check that individual pane, and total window thickness are not less than shown below:

(1) Inner pane -- 0.450 inch.

(2) Outer pane -- 0.850 inch.

(3) Window total -- 1.340 inch.

NOTE: Repair limits are controlled by a minimum thickness for individual panes as well as a minimum total thickness of both panes together after rework.

BRACKET ASSEMBLY - REPAIR 2-1

141T4854-11, -12, -21, -22

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers.

1. Bearing Replacement

   A. Remove the old bearing.

   B. Install a replacement bearing and 5 point ball stake the housing over the bearing (SOPM 20-50-03).

2. Refinish

   A. Bracket (60A, 65A) -- Chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13). Apply BMS 10-11, type 2 flat beige epoxy enamel (F-21.26-8925, which replaces SRF-14.903-8925) or flat beige lacquer (F-22.32-8925, which replaces F-14.903-8925). Material: Al alloy.

WINDOW ASSEMBLY (ACRYLIC) - REPAIR 3-1

141T4813-7, -8, -15, -16, -19, -20, -23 thru -30,
-501, -502, -505, -506

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices.
Refer to IPL Fig. 1 for item numbers.

1. Bushing Replacement (531, 532, 684K, 684X) (Fig. 601)

A. Remove the old bushings.

CAUTION: DO NOT INSTALL BUSHINGS (531, 532) UNTIL AFTER THE FRAME ASSEMBLY (615A, 617, 620A, 622, 683H, 683M) AND LAMINATE ASSEMBLY (535A, 540A, 679, 679L, 680E) ARE ASSEMBLED.

B. Install replacement bushings (531, 532, 684K, 684X) by the shrink-fit method (SOPM 20-50-03).

C. Machine the bores of these bushings to design dimensions and finish.

2. Bushing Replacement (640B, 645, 684H, 684J) (Fig. 602)

A. Remove the old bushings.

B. If you find defects on hole surfaces, refer to par. 3 below for repair instructions.

C. Install replacement bushings by the shrink-fit method (SOPM 20-50-03).

D. Machine the bushings to dimensions dimensions.

3. Repair

A. Holes for bushing (640B, 645, 684H, 684J).

(1) Machine as required, within repair limits, to remove defects.

(2) Penetrant examine (SOPM 20-20-02).

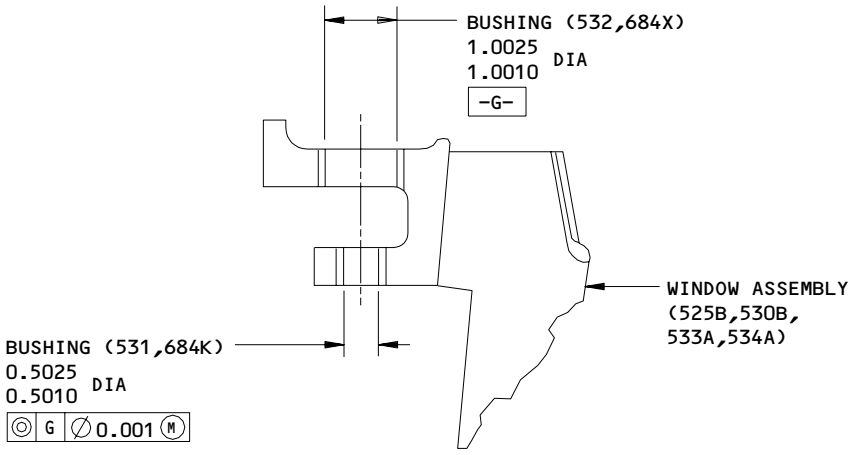
(3) Refinish per par. 4.A.

(4) Make oversize bushings (Fig. 603, Fig. 604) to adjust for the material removed.

(5) Install the bushings per par. 2, above.

4. Refinish

A. Frame fittings (630A, 635A, 687A, 688) -- Chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13), but not in holes for bushings (640B, 645, 684H, 684J) or in the 0.313-0.327 diameter hole in the opposite end of the post. Apply enamel per Fig. 605. Material: Al alloy.

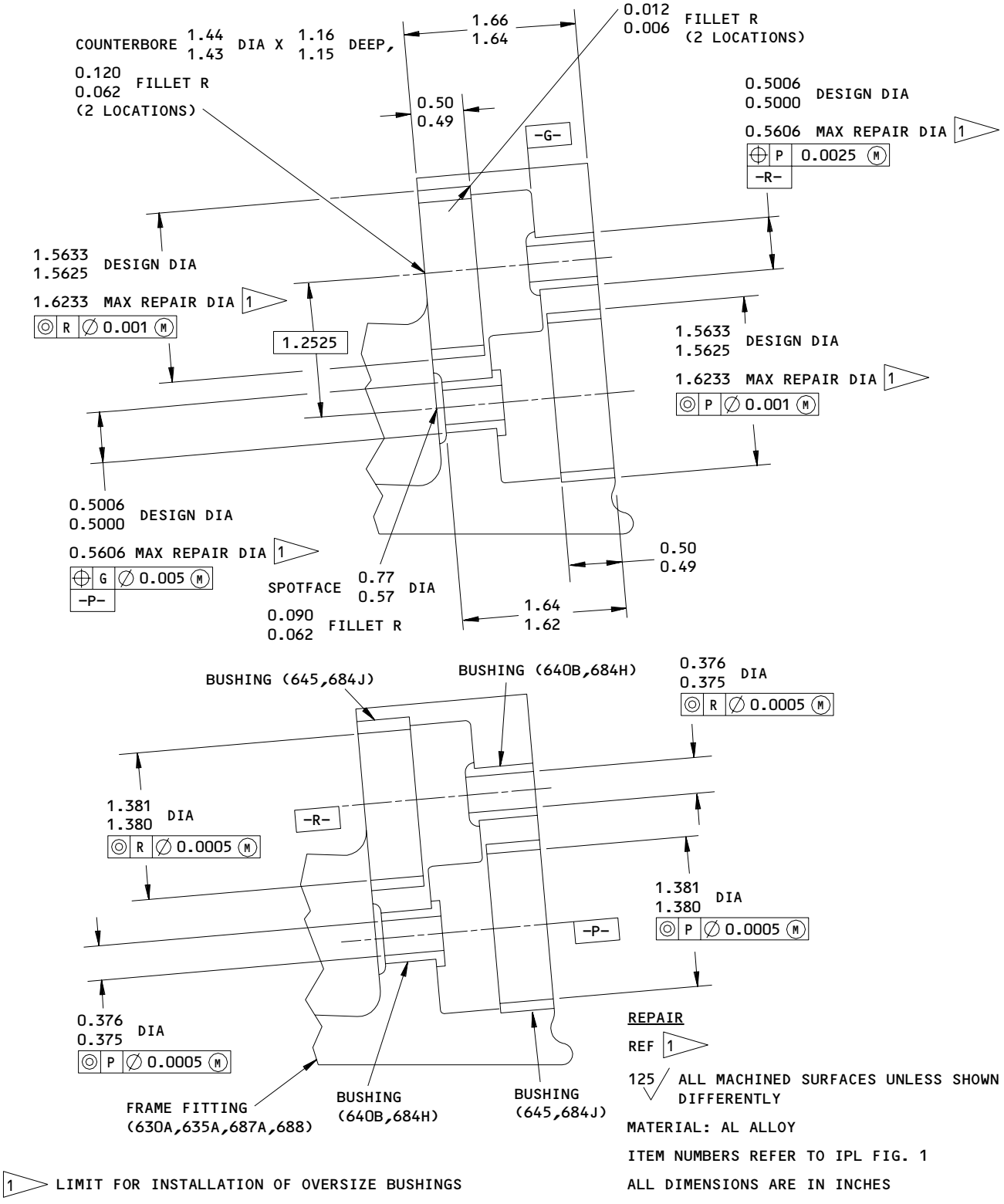


ITEM NUMBERS REFER TO IPL FIG. 1

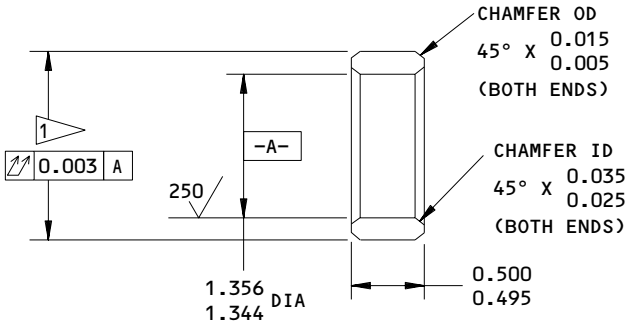
ALL DIMENSIONS ARE IN INCHES

Bushing Replacement
Figure 601

16440



141T4852-5,-6,-11 THRU -14,-21 THRU -24,-27,-28,-31,-32,-35,-36,-39,-40
Frame Fitting Assembly
Figure 602



FINISH:

CADMIUM PLATE (F-15.06)
(OPTIONAL IN BORE)

1 FINISH BUSHING OUTSIDE DIA EQUALS REPAIR DIA OF FITTING PLUS 0.0024 INTERFERENCE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL-NI-BRZ PER (AMS 4640)

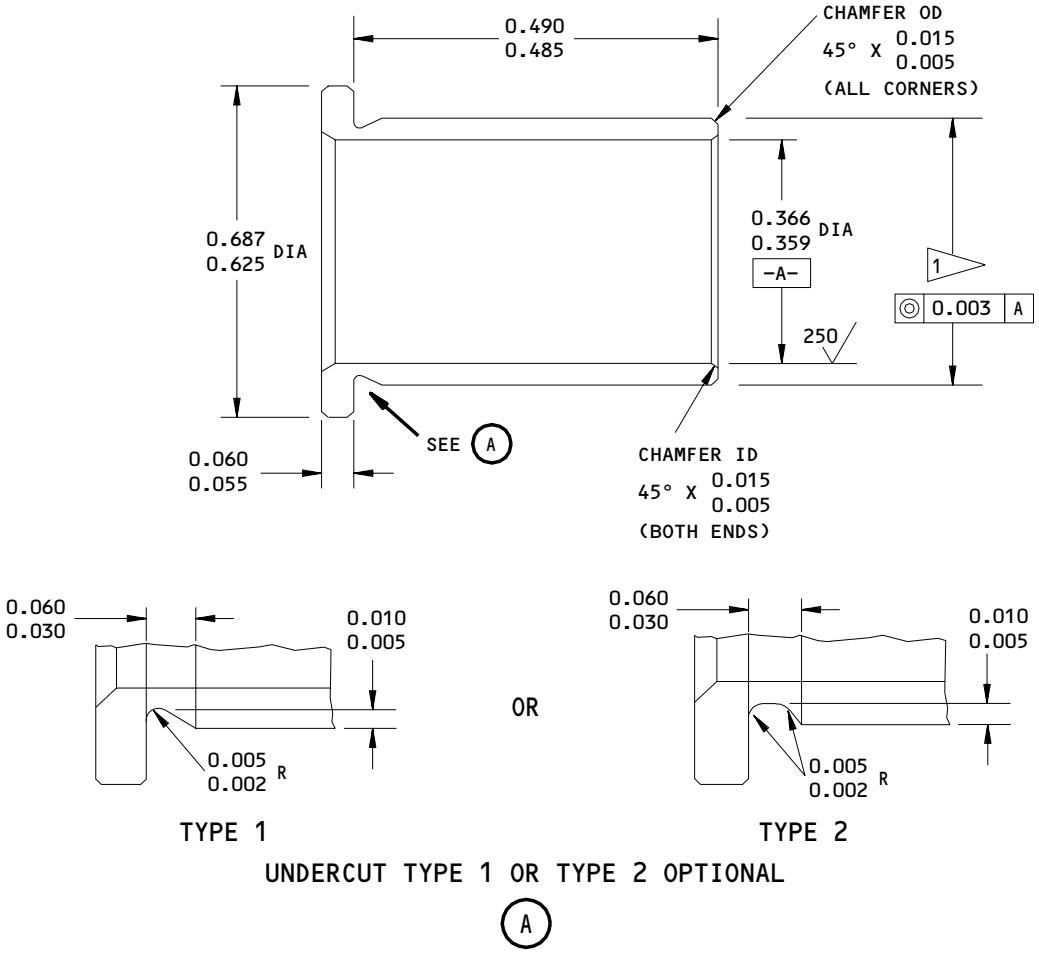
DIMENSIONS APPLY AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

REPLACES BUSHING (IPL FIG. 1; 645,684J) BACB28U22B050

Replacement Bushing Details
Figure 603

195053



FINISH:

CADMIUM PLATE (F-15.06) (OPTIONAL IN BORE)

1 FINAL BUSHING OUTSIDE DIA EQUALS REPAIR DIA OF FITTING PLUS 0.0013 INTERFERENCE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ANGULAR TOLERANCE, ±0.50 DEG

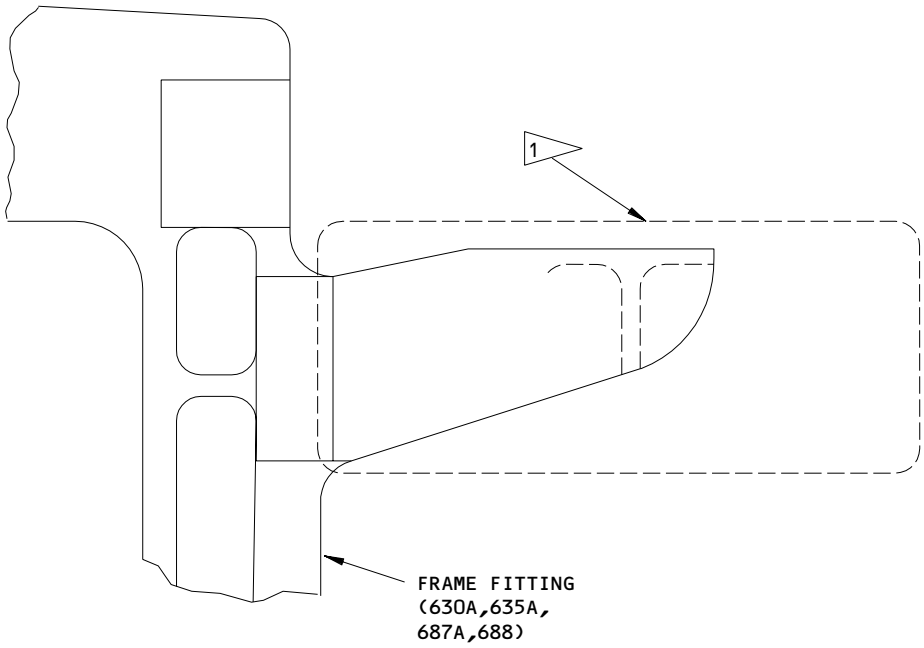
MATERIAL: AL-NI-BRZ (AMS 4640) OR QQ-C-465 ALLOY NO. 630

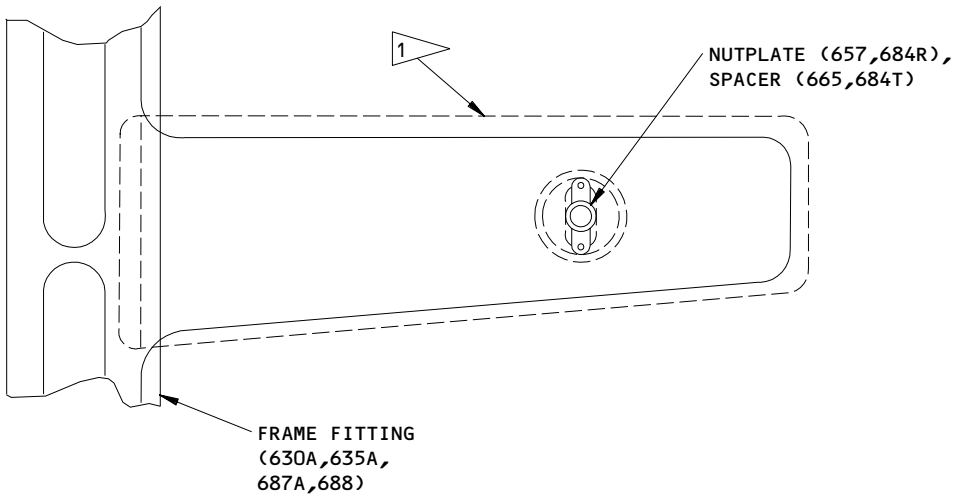
DIMENSIONS APPLY AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

REPLACES BUSHING (IPL FIG. 1; 640B,684H) BACB282WB049

Oversize Bushing Details
Figure 604





1 APPLY BMS 10-11, TYPE 2 EPOXY ENAMEL, FLAT BAC8925 BEIGE (F-21.26-8925, WHICH REPLACES SRF-14.903-8925) TO ALL SURFACES IN THIS AREA ONLY

141T4852-7 THRU -10,-15,-16,-19,-20,-25,-26,-33,-34,-37,-38,-41,-42
Fitting Refinish
Figure 605

93033

WINDOW ASSEMBLY (ACRYLIC) - REPAIR 3-2

141T4813-7, -8, -15, -16, -19, -20, -23 thru -30,
-501, -502, -505, -506

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

1. Terminal Cap (585, 590, 682J, 682L, 682T) Replacement (IPL Fig. 1)

CAUTION: PREPARE THE FAYING SURFACES SO THAT THE TWO PIECES TO BE CEMENTED FIT ACCURATELY.

A. Remove the old cement and abrade the faying surfaces with 240 grit wet-or-dry sandpaper per Fig. 601.

WARNING: USE CAUTION WHEN YOU WORK WITH ALIPHATIC NAPHTHA BECAUSE IT IS FLAMMABLE.

B. After abrading, clean the faying surfaces with aliphatic naphtha, or soap and water followed by aliphatic naphtha.

C. Dry thoroughly prior to application of cement.

D. Mask the surrounding window a minimum of 1 inch from the bonding area and within 0.031 inch of bond area to confine the softening action of the cement.

E. Mix PS-30 adhesive or PR 1425 sealant per manufacturer's instructions.

NOTE: PR 1425 sealant may be used as a bonding agent in place of PS-30 adhesive.

F. Apply sealant as follows.

(1) For laminate (535A, 540A, 679, 679L, 680E, 680G), apply a light coat of PS-30 adhesive or optional PR 1425 sealant to both faying surfaces.

(2) For laminate (679A, 679M, 680F, 680H), apply a 0.015-0.020 inch bondline of PR 1425 sealant.

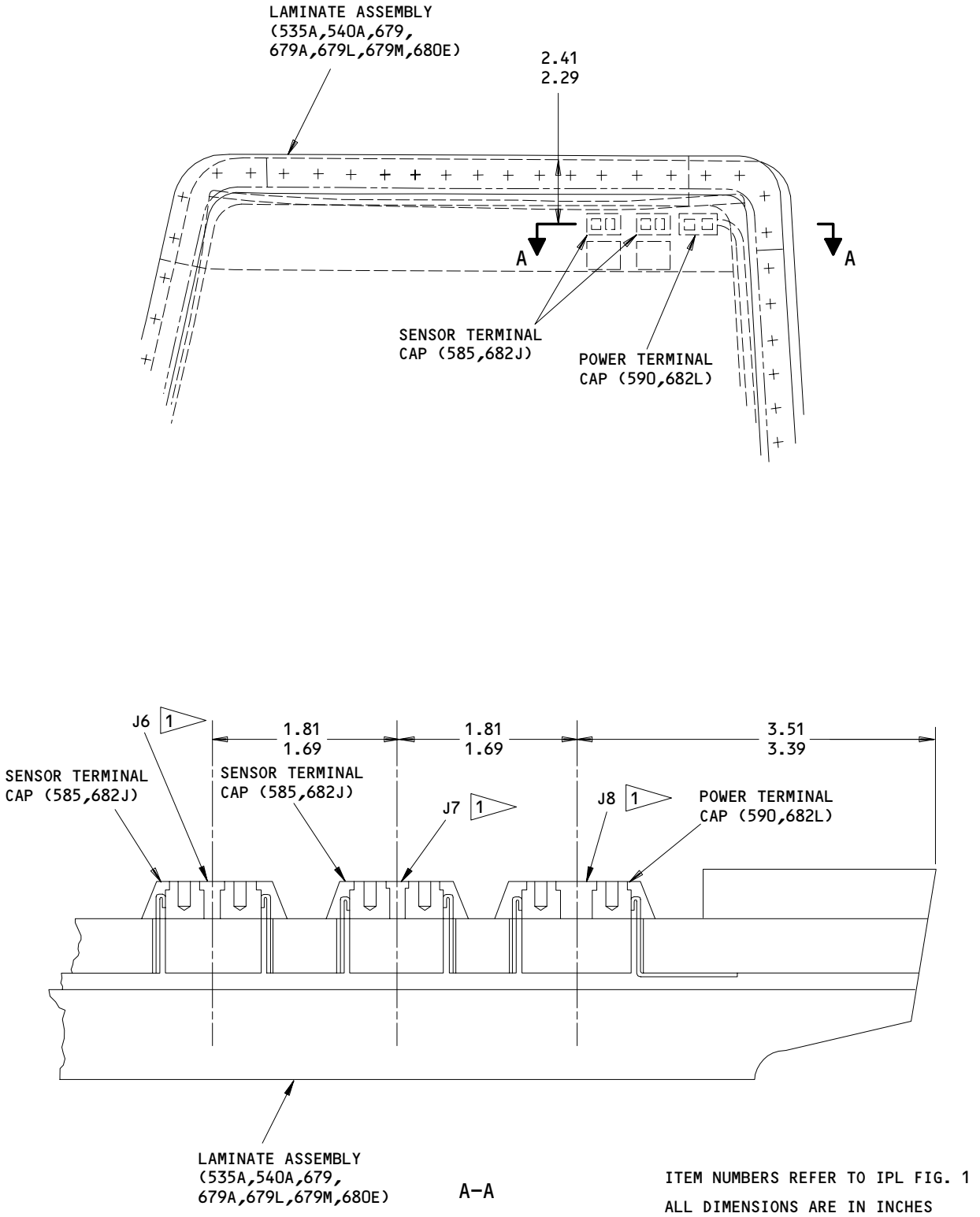
(3) For laminate (679B, 679N), apply a 0.020-0.060 inch bondline of PR 1425 sealant.

CAUTION: APPLY ONLY ENOUGH PRESSURE WITH THE SPRING CLAMPS OR THE WEIGHTS TO HOLD SURFACES TOGETHER. TOO MUCH PRESSURE CAN CAUSE CRAZING AND CAN FORCE THE CEMENT FROM THE BOND AREA.

G. Join the surfaces immediately after coating and apply pressure during cure cycle.

H. Allow to dry per manufacturer's instructions.

I. Apply 0.12-inch high letters per 20-50-10 on terminal caps (585, 590, 682J, 682L, 682T) as shown in Fig. 601.

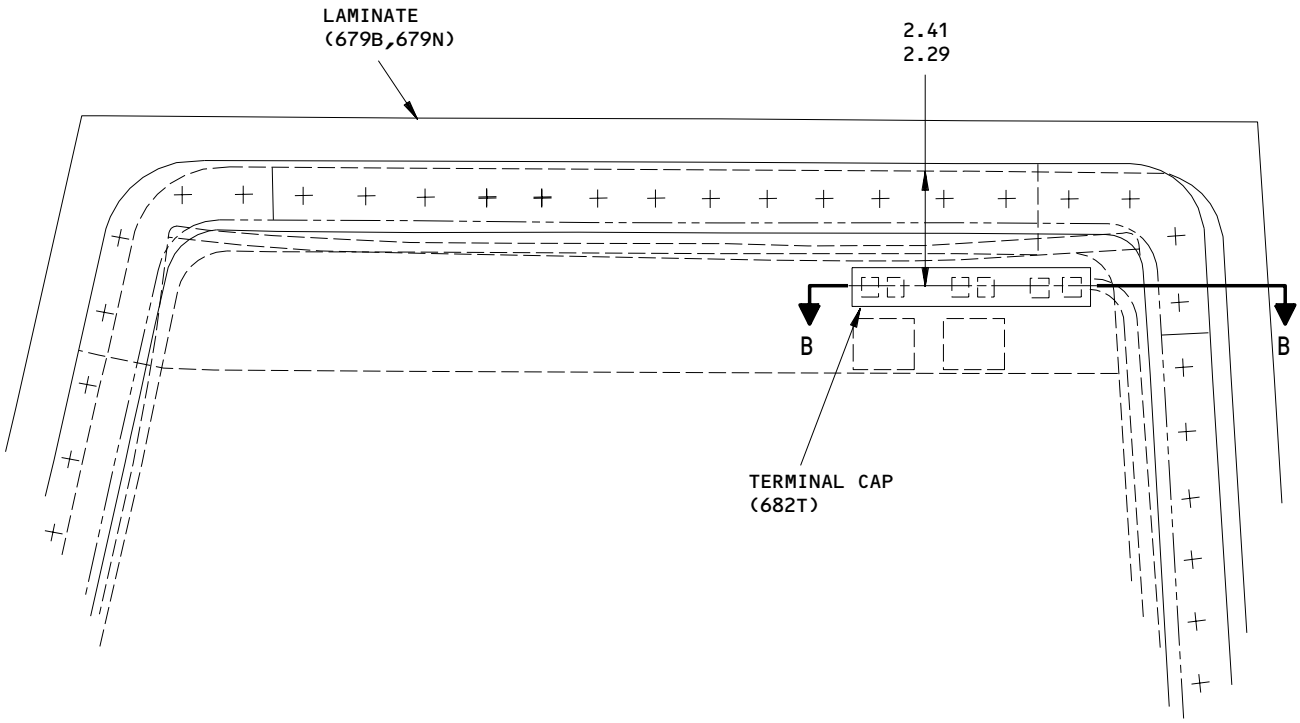


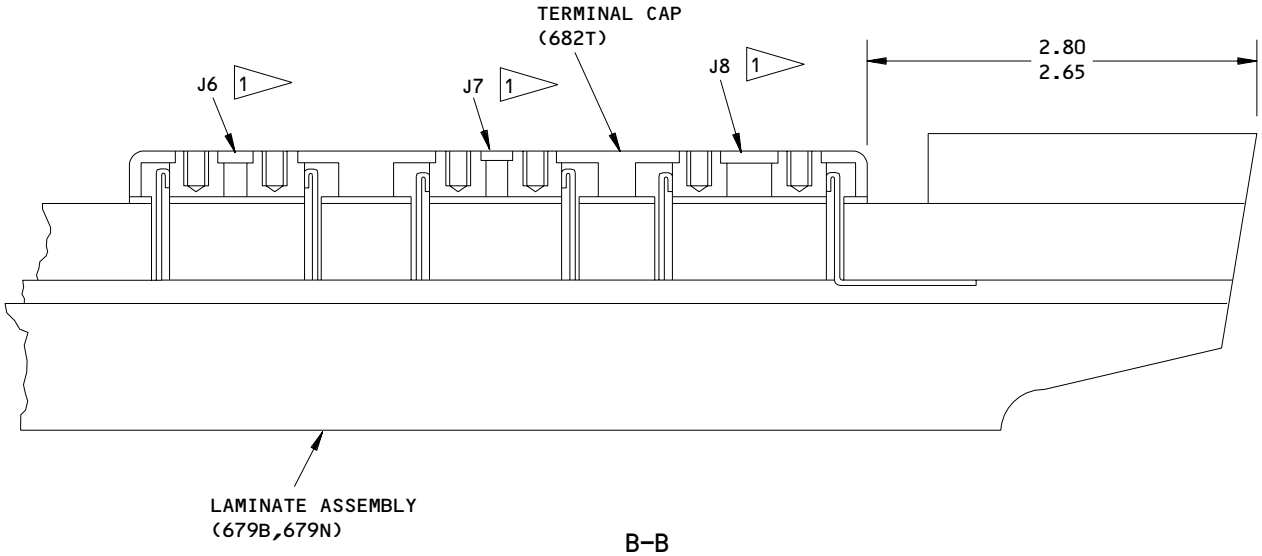
ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Terminal Cap Replacement
Figure 601 (Sheet 1)

182869





B-B

1 APPLY THE DESIGNATED LETTERS TO THE PART WITH 0.12 INCH HIGH LETTERS. THE LETTERS MUST BE VISIBLE AFTER THE ELECTRICAL CONNECTION IS MADE.

Terminal Cap Replacement
Figure 601 (Sheet 2)

C40732

WINDOW ASSEMBLY (ACRYLIC) - REPAIR 3-3

141T4813-7, -8, -15, -16, -19, -20, -23 thru -30,
-501, -502, -505, -506

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

1. Laminate Assembly (535A, 540A, 679, 679A, 679B, 679L, 679M, 679N, 680E, 680F, 680G, 680H) Replacement (IPL Fig. 1)

NOTE: Before assembly, make a check of the frame/laminate thickness (Fig. 601). If the dimension is less than the minimum given, use the liquid shim assembly method. If the dimension is more than the maximum, remove material from the peelable shim by sanding or peeling of shim layer(s).

NOTE: Assembly tool A56004-50 is necessary only if you do the liquid shim procedure.

NOTE: If the replacement windows come with inserts installed, use the procedures for glass windows (REPAIR 6-3).

A. Eliminate Gaps Between Laminate and Frame Assembly

(1) Liquid Shim Assembly Procedure.

(a) Liquid Shim Pour Preparation

1) Get the No. 2 Window Assembly tool A56004-50.

2) If not included, apply a protective covering to both sides of the laminate assembly.

3) Remove the sealant in blind fastener (545A) holes on the frame assembly (615A, 617, 620A, 622, 683H, 683M).

4) Install the laminate and the frame assembly in the tool. Put the laminate down against the supports. Hold the frame in position with the four pins.

5) Make sure the gap between the frame assembly and the laminate assembly is a minimum of 0.020 inch (Fig. 601).

6) If the gap is not in this range, remove material from the peelable laminated shim as follows:

a) Mark the areas on the laminate where shim material is to be removed.

b) Cut across layer(s) of peelable shim, remove layer(s), and fair in edges.

NOTE: If necessary, clean the laminate assembly before you continue, because dirt could change the gap measurements.

7) Do steps 4) thru 6) again until the gap is in the specific range.

8) Remove the laminate and the frame assembly from the tool.

9) Clean the mating surfaces of the laminate and the frame assembly with ethyl alcohol and cheesecloth.

10) Install Polyken tape and parting agent tape on the frame assembly mating surface, total thickness to be 0.010 inches. Remove all bubbles from the tape (Fig. 602).

11) Mask the edges and the face of the laminate assembly, and the edge of the frame assembly (Fig. 602).

NOTE: Remove masking tape on edges of laminate assembly where contact with tool pins occurs.

12) Install BMS 1-23 plugs in the laminate assembly fastener holes (Fig. 602).

13) Install the laminate assembly into the tool.

(b) Liquid Shim Pour/Cure/Cleanup

1) Install the frame assembly in the tool.

2) Look along the interface perimeter (inside and outside) edges for air bubbles. Puncture any visible bubbles.

3) Build dams along the interface perimeter (inside and outside) to contain the PS-18 liquid shim (Fig. 603).

4) Mix one quart of PS-18 liquid shim by the vendor's instructions.

5) Apply a layer of PS-18 liquid shim approximately 3/16 inch thick on the laminate assembly mating surface.

6) Let this cure for 5 hours minimum at 72°F.

7) Remove the frame assembly from the tool.

8) Look for voids in the liquid shim. If there are voids, remove them and repair by the above procedure.

9) Remove the laminate and the frame assembly from the tool. Remove masking tape, parting tape, Polyken tape, and liquid shim from the frame assembly. Remove masking tape and unwanted liquid shim from the laminate assembly.

10) Remove hole plugs on the laminate assembly. Tap them to break the bond.

11) File the edges of holes to remove any excess liquid shim.

12) Clean the laminate assembly (including holes) and the frame assembly.

(2) Non-Liquid Shim Assembly Procedure.

NOTE: This method forms the laminate to match the frame assembly by removing material from the peelable shim of the laminate assembly. Upon assembly with this method, the laminate/frame assembly will be in an unstressed condition. Do not use this procedure to refit a repaired laminate to a second frame assembly.

(a) Laminate Preparation

1) If not provided, apply a protective covering to both sides of the laminate assembly.

2) Place the laminate onto the frame and install one bolt in each corner of the laminate to temporarily locate the laminate on the frame.

3) Check the gap between the laminate and the frame around the entire periphery of the window assembly. Mark the areas on the laminate where the gap is 0.020 inch or more.

4) Remove material from the laminate in the areas where the gap is less than 0.020 inch by hand sanding or with orbital sander with 150-grit abrasive paper or equivalent. Each laminate layer is approximately 0.020 inch thick.

5) Repeat steps 2) through 4) until the laminate matches the frame contour around the entire periphery and the 0.020 inch guage will not fit between the laminate and frame in step 3).

B. Spacer (580, 682G) Installation

(1) Apply RTV 157 to sealant outside edge of the spacer and to the inside diameter of the fastener hole in the laminate assembly (Fig. 604).

(2) Push in the spacer and turn it as you go in, to make sure the spacer comes down against the retainer. If necessary, lightly tap the spacer to help get it down.

(3) Clamp two adjacent spacers at a time to hold the spacers in position during curing.

(4) Let this cure for 24 hours at 65-100°F and minimum of 20% relative humidity.

(5) Remove the clamps and clean off unwanted RTV 157 sealant from around the spacers.

(6) Machine the spacers to a height of 0.010 - 0.020 inch (Fig. 605).

(7) Remove burrs from the spacers. Clean the mating surface area of the laminate assembly.

C. Assembly of Frame and Laminate Assembly

(1) Clean the mating surface of the frame assembly and apply one layer of parting agent tape (Fig. 606).

(2) Mask the edges of the frame assembly and the laminate assembly.

(3) Mix one half quart of PR 1425 sealant by the manufacturer's instructions.

(4) Apply a thin layer of PR 1425 sealant on the laminate assembly mating surface.

(5) Install frame assembly in the tool or on a suitable table.

(6) Install fasteners (545A, 680J) around the edges as shown in Fig. 611 and incrementally tighten them to 30-50 pound-inches (Fig. 606). Temporary removal of some fasteners could be necessary to remove unwanted sealant. Movement between the frame and the laminate can occur, but this is acceptable during fastener installation.

(7) Let the unit cure for 1 hour and then make a new check of the torque values.

(8) Make a check of the rubstrip height with the gage included in tool A56004-50 or measure the dimension shown in Fig. 1.

(9) Let the unit cure for 24 hours if you used Class B 1/2 sealant, or 48 hours if you used Class 2 sealant.

(10) Remove the assembly from the fixture. Remove masking tape and unwanted sealant.

(11) Machine flush any PVB that bulged out due to assembly (Fig. 606).

D. Removal of Unwanted Laminate Assembly Trimming (Optional)

(1) Look for signs of laminate assembly overlap of frame assembly (Fig. 607).

(2) If there is an overlap, mask the laminate surface and sand or file off the overlap.

(3) Remove the masking tape from the laminate assembly.

E. Laminate and Window Assembly Inner Seal

CAUTION: BE CAREFUL WITH ALIPHATIC NAPHTHA BECAUSE IT IS FLAMMABLE.

(1) Clean the area around the window assembly with aliphatic naphtha applied with clean cheesecloth.

(2) Wipe off the aliphatic naphtha, before it dries, with a clean dry cheesecloth.

(3) Apply a fillet seal of PR 1425 sealant around the window assembly inner area by the vendor's instructions.

NOTE: Make sure PR 1425 sealant is applied around the window perimeter (Fig. 610).

F. Window Assembly Edge Seal/Fastener Seal (Fig. 608)

(1) Mask the frame assembly and moisture seal retainers and the RTV 157 sealant moisture seal on the laminate assembly.

(2) Mix approximately 1 pint of PR 1425 sealant by the vendor's instructions.

(3) Brush or spray a layer of this sealant on the edge of the laminate assembly to a thickness of 0.030 inch maximum.

(4) Cure Class B 1/2 sealant 24 hours. Cure Class B2 sealant 48 hours.

(5) Lightly hand-sand as necessary to make a smooth surface.

(6) Apply BMS 10-86, type 1, coating (F-14.9625-707, which replaces SRF-14.9625-707).

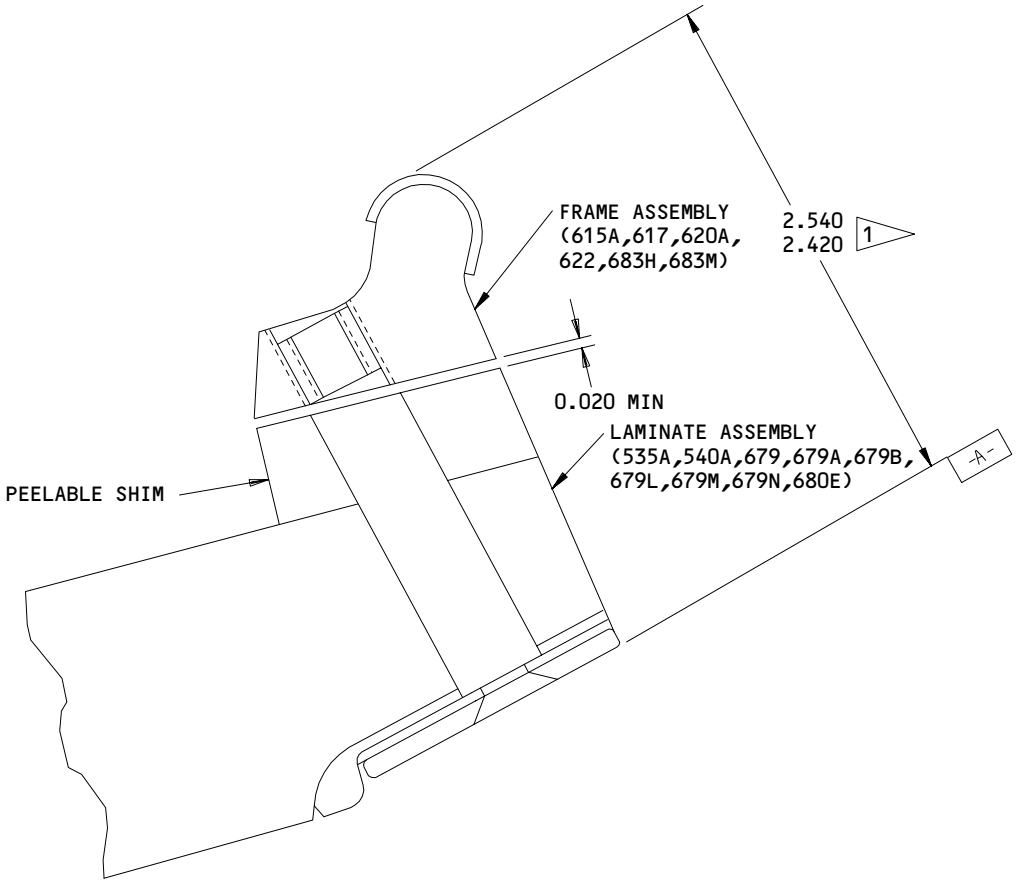
(7) Remove the masking tape.

(8) Apply BMS 5-95 sealant to backfill the fastener holes in the frame assembly (Fig. 609).

G. Frame Assembly, Fastener Heads, and Seal Retainer Touchup

(1) Touch up frame assembly (615A, 617, 620A, 622, 683H, 683M) and fastener (545A) heads with chemical treatment (SOPM 20-43-03) or chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13). Apply BMS 10-11, type 2 flat epoxy enamel (F-21.26-8925, which replaces SRF-14.903-8925).

(2) Touch up seal retainers (560A thru 567A, 680L, 681, 682) with chemical treatment (SOPM 20-43-03) or chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13). Apply BMS 10-86, type 1, white abrasion resistant teflon coating (F-14.9624, which replaces SRF 14.9624).

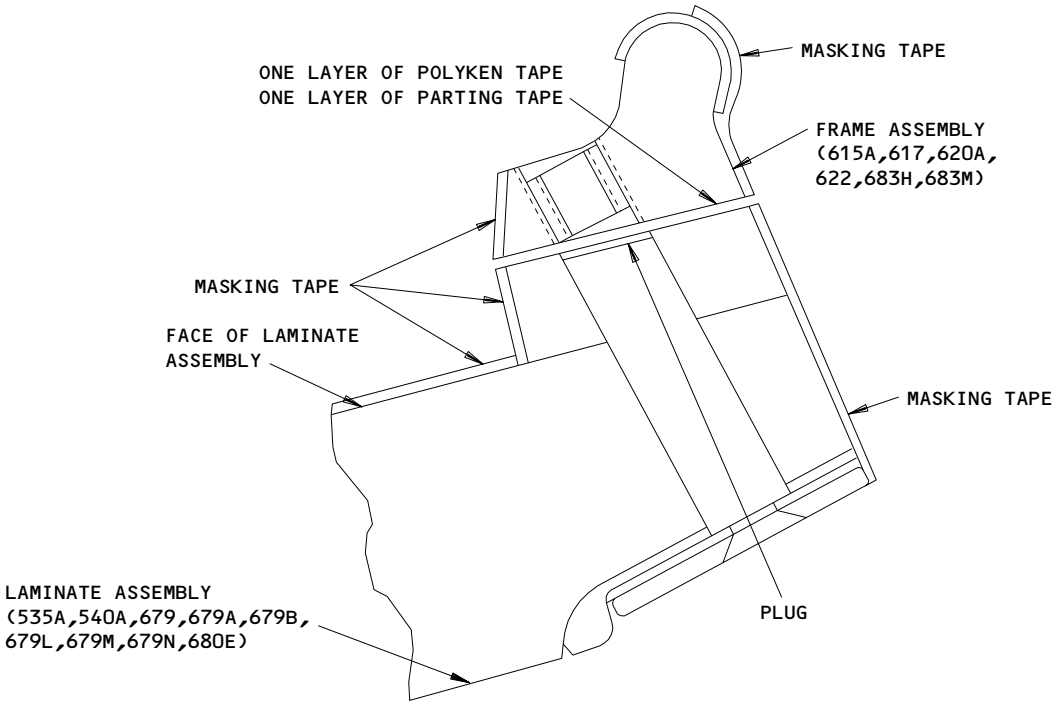


1 THIS DIMENSION IS CRITICAL FOR WINDOW INSTALLATION IN THE AIRPLANE. IF THE DIMENSION IS GREATER THAN THE MAXIMUM, REMOVE MATERIAL FROM THE PEELABLE SHIM OF THE LAMINATE ASSEMBLY UNTIL IT IS WITHIN TOLERANCES. IF THE DIMENSION IS LESS THAN THE MINIMUM, USE THE LIQUID SHIM METHOD OF ASSEMBLY.

ITEM NUMBERS REFER TO IPL FIG. 1

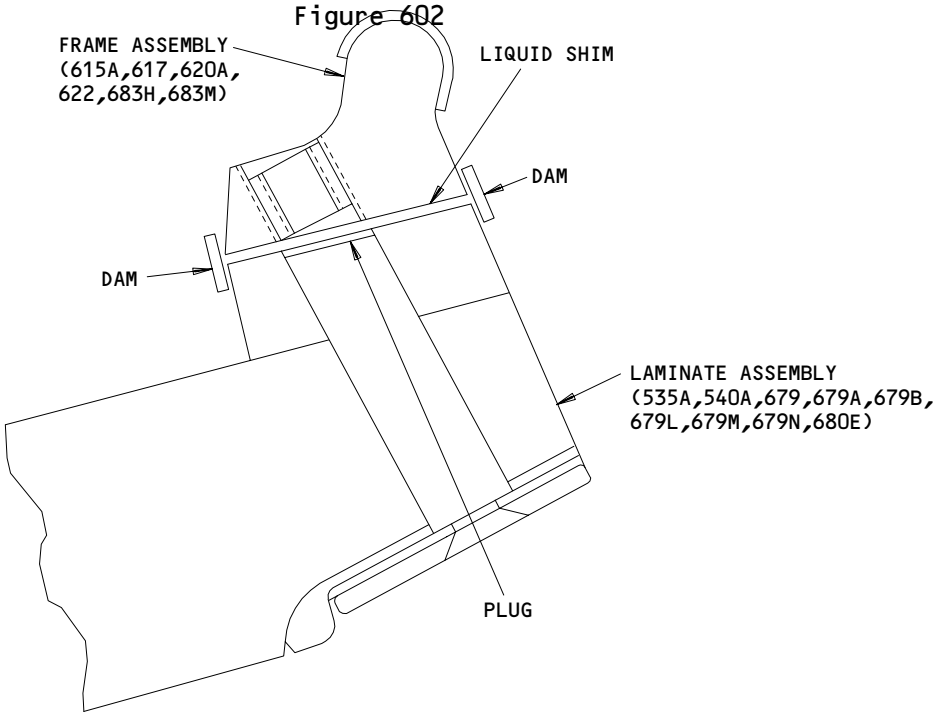
ALL DIMENSIONS ARE IN INCHES

141T4813-7,-8,-15,-16,-19,-20,-23 THRU -30,-501,-502,-505,-506
Window Assembly Repair - Laminate/Frame Clearance
Figure 601



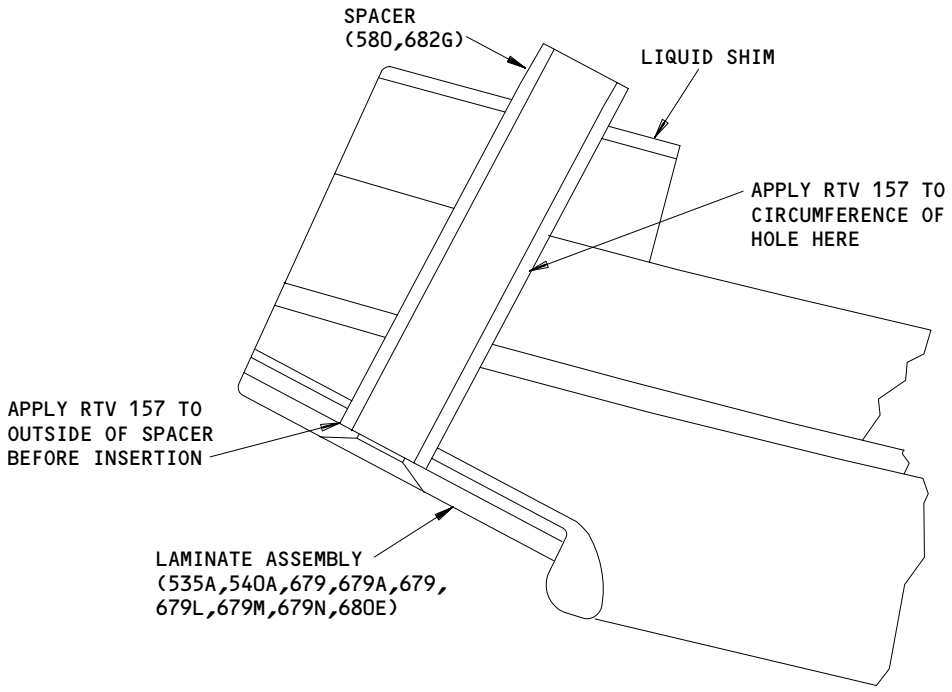
141T4813-7,-8,-15,-16,-19,-20,-23 THRU -30,-501,-502,-505,-506
Window Assembly Repair - Tape Application
Figure 602

200341



141T4813-7,-8,-15,-16,-19,-20,-23 THRU -30,-501,-502,-505,-506
Window Assembly Repair - Liquid Shim Dam Application
Figure 603

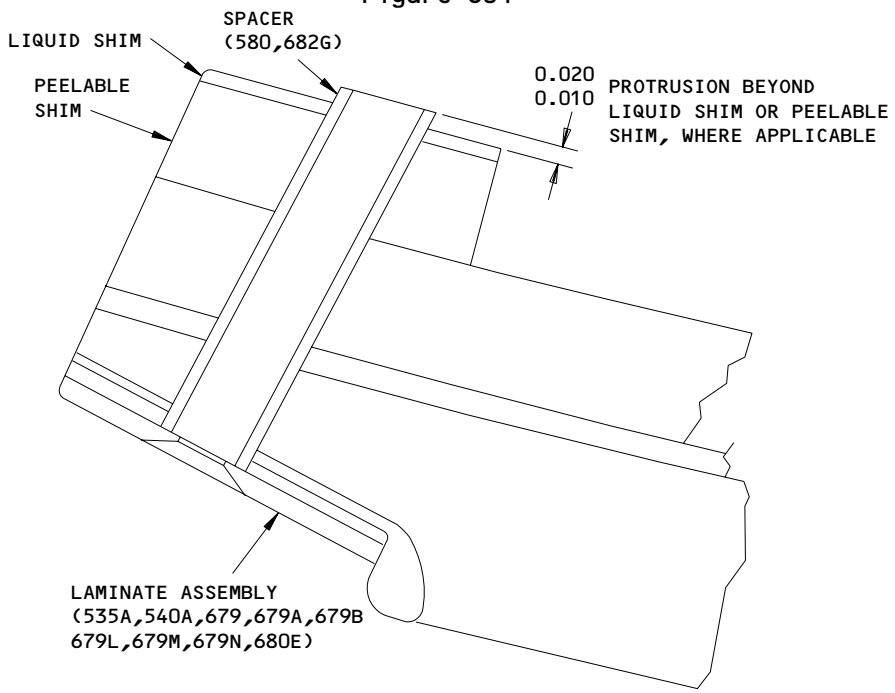
200333



141T4813-7,-8,-15,-16,-19,-20,-23 THRU -30,-501,-502,-505,-506

Window Assembly Repair - Spacer Insertion
Figure 604

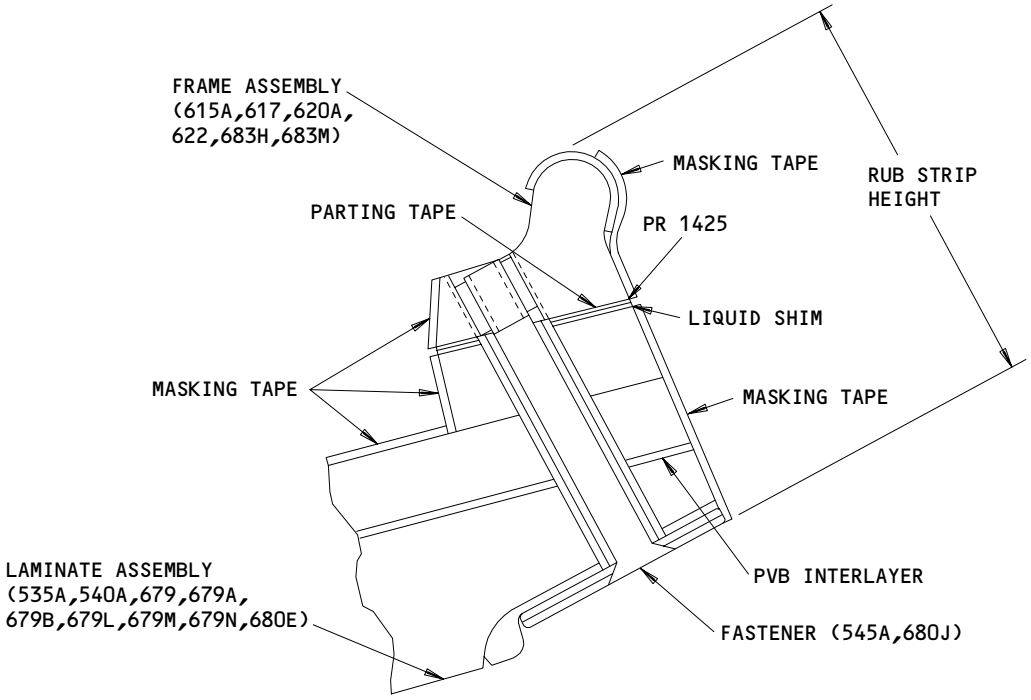
200068



141T4813-7,-8,-15,-16,-19,-20,-23 THRU -30,-501,-502,-505,-506

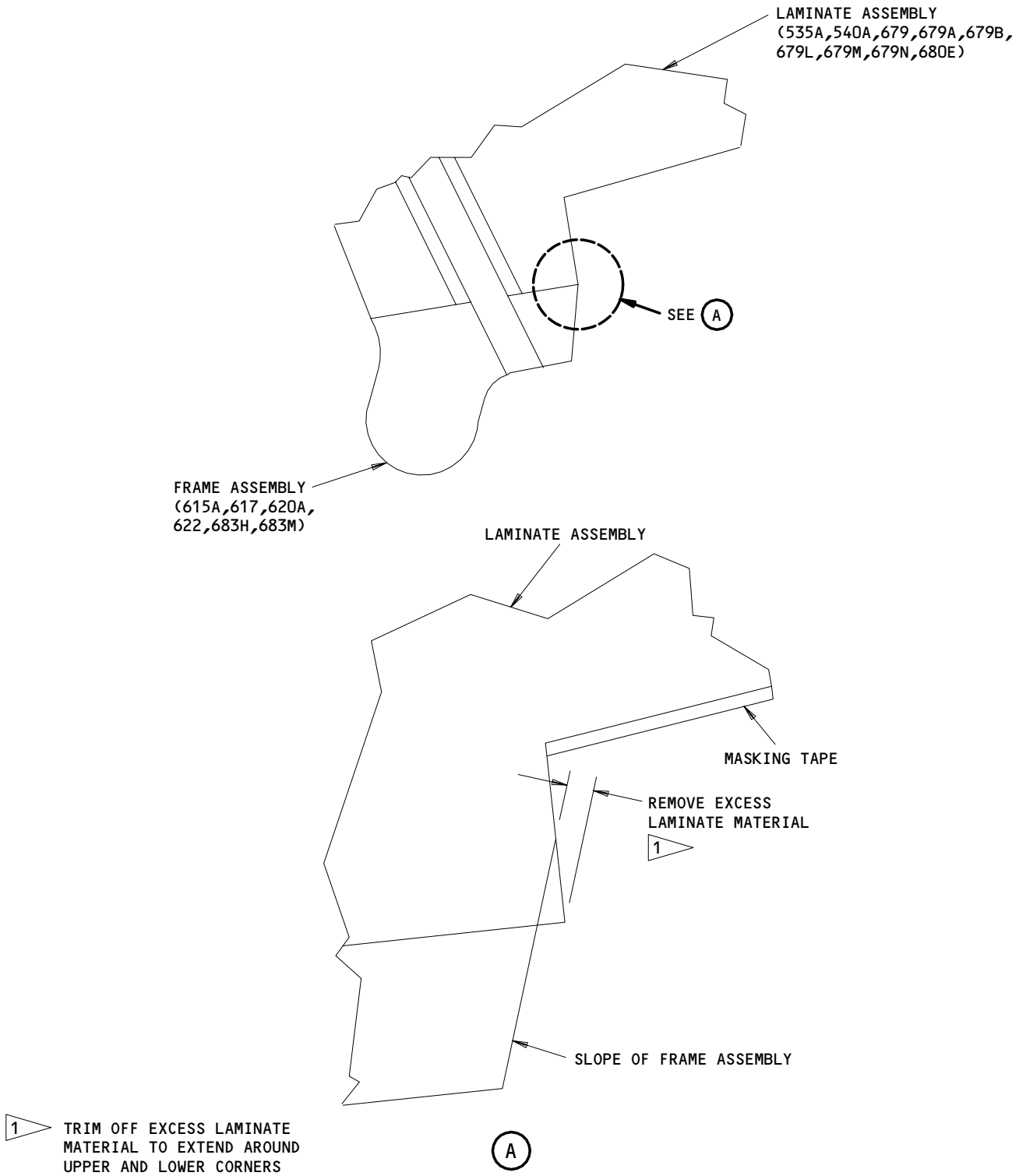
Window Assembly Repair - Spacer Machining
Figure 605

200131

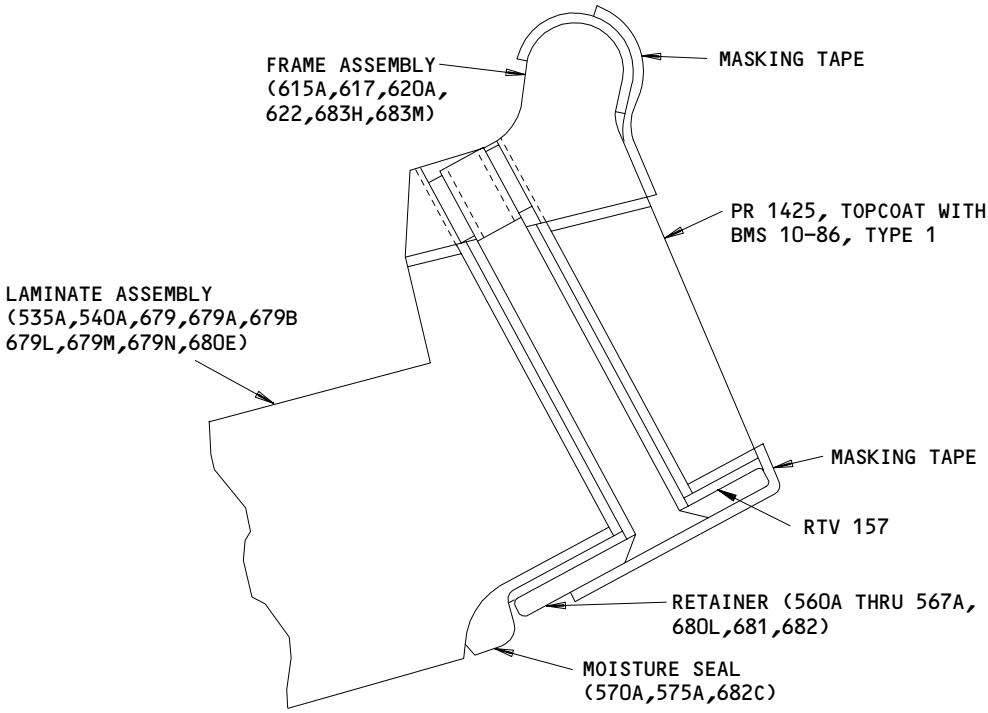


141T4813-7,-8,-15,-16,-19,-20,-23 THRU -30,-501,-502,-505,-506
Window Assembly Repair - Liquid Shim Application
Figure 606

200318

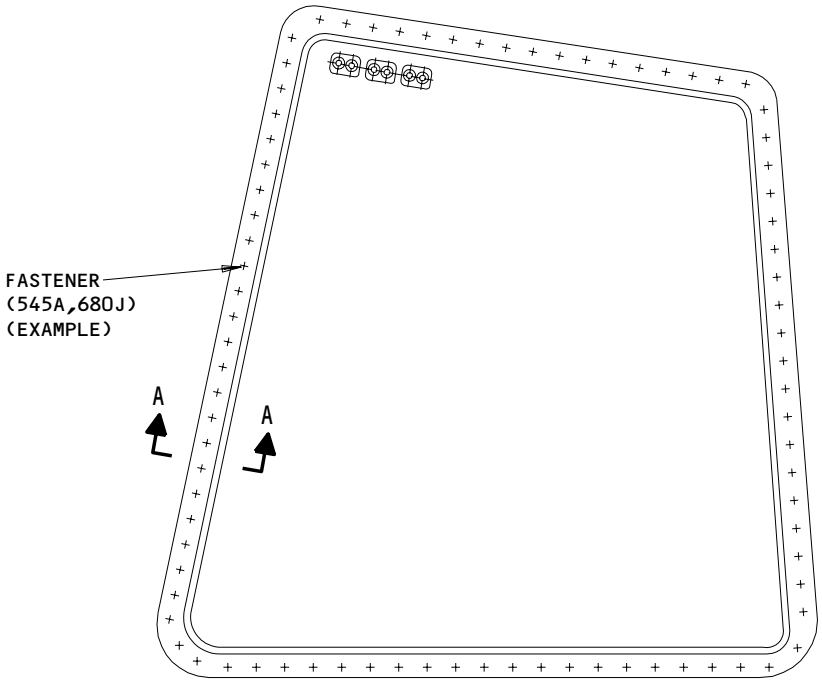


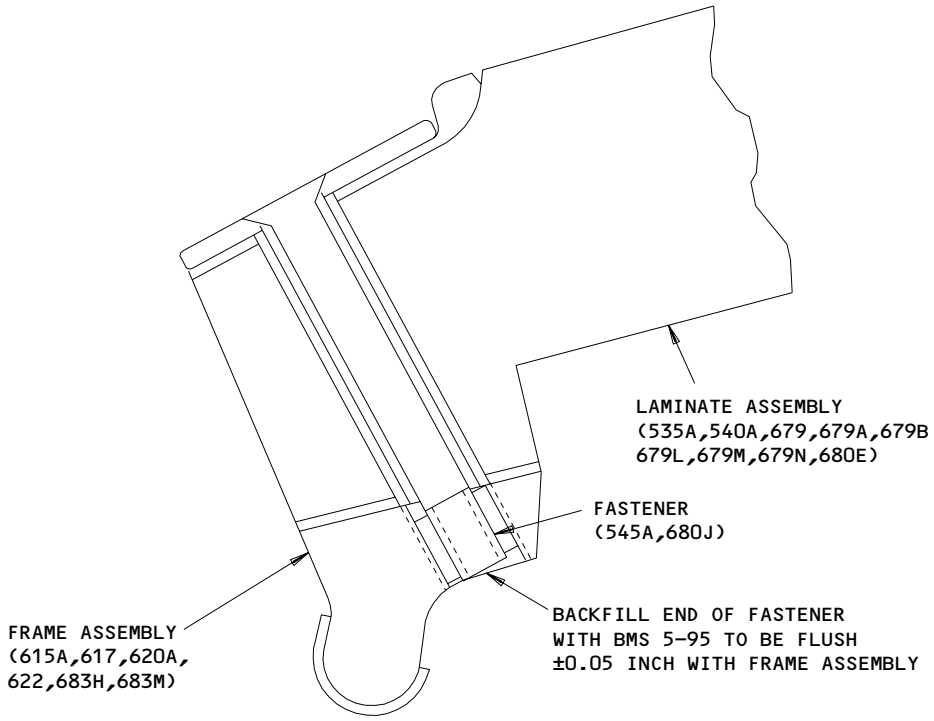
141T4813-7,-8,-15,-16,-19,-20,-23 THRU -30,-501,-502,-505,-506
Window Assembly Repair - Lqminate Trimming
Figure 607



141T4813-7,-8,-15,-16,-19,-20,-23 THRU -30,-501,-502,-505,-506
Window Assembly Repair - Sealant Application
Figure 608

200330

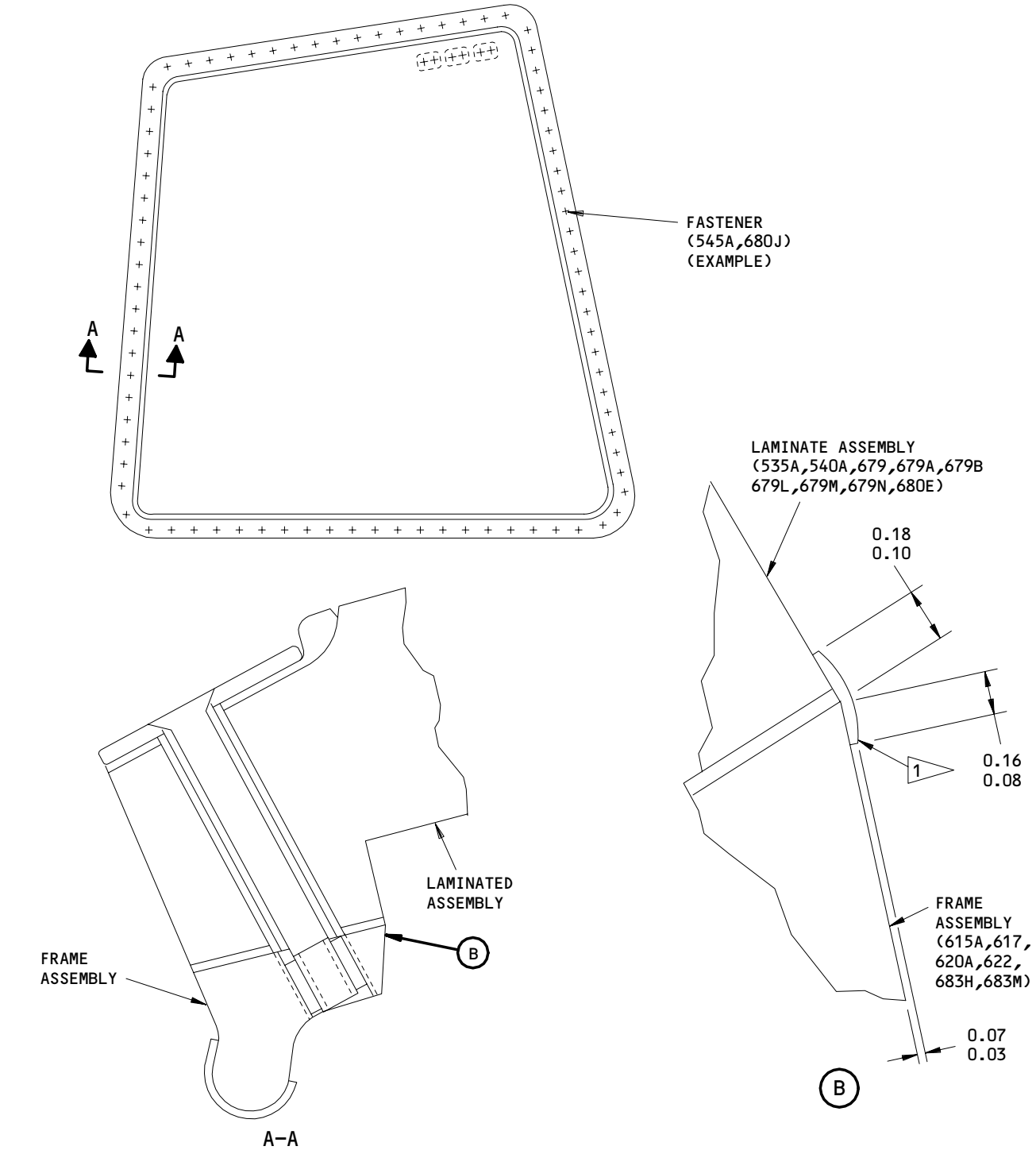




A-A

141T4813-7,-8,-15,-16,-19,-20,-23 THRU -30,-501,-502,-505,-506
Window Assembly Repair - Fastener Sealing
Figure 609

200348



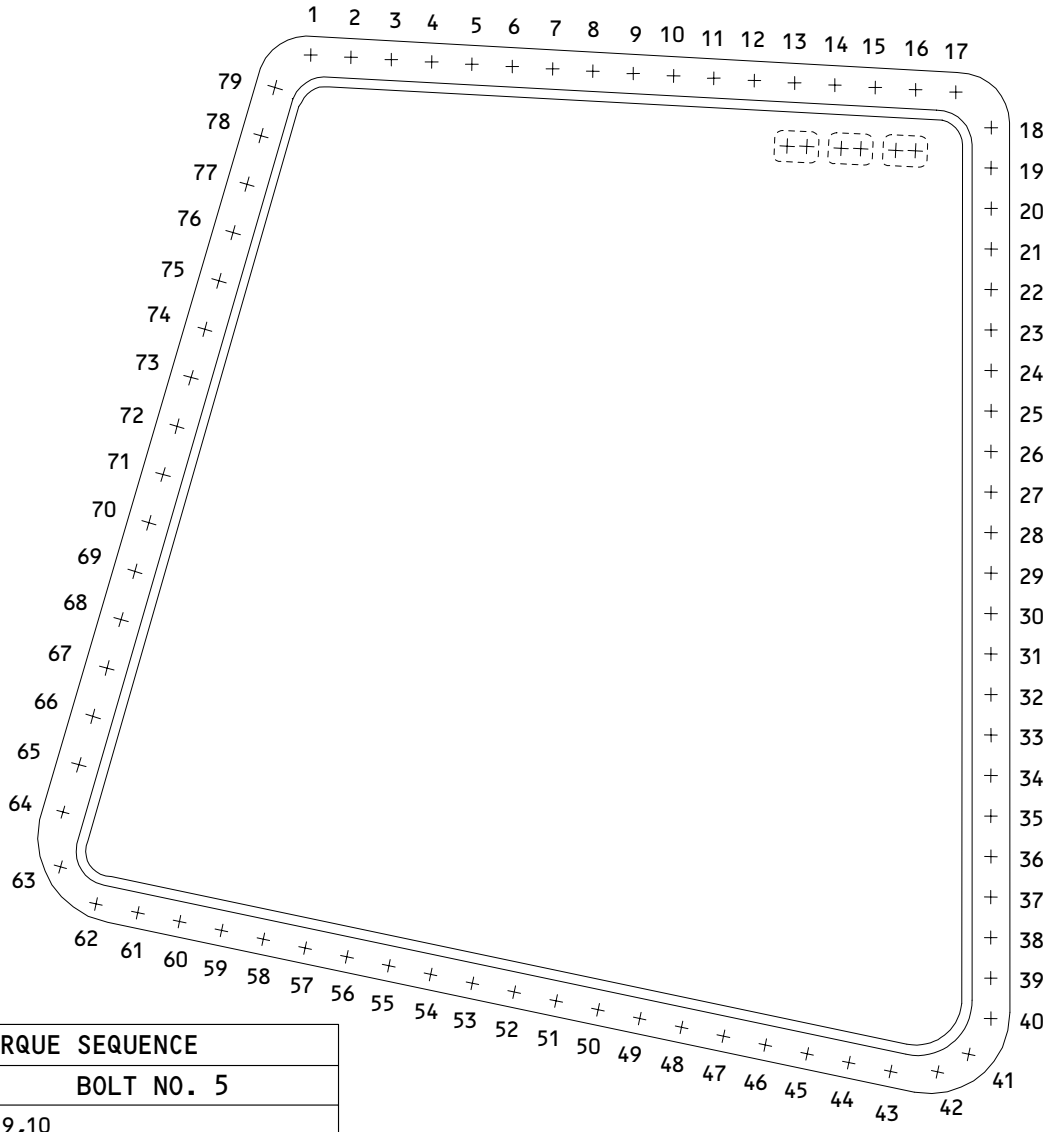
1 APPLY PR1425 SEALANT AROUND ENTIRE WINDOW INNER PERIMETER

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

141T4813-7,-8,-15,-16,-19,-20,-23 THRU -30,-501,-502,-505,-506
Window Assembly Repair - Inner Seal
Figure 610

E96015



BOLT TORQUE SEQUENCE	
STEP NO.	BOLT NO. 5
1 2 3 4	8,9,10 51,52,53 70,71,72 28,29,30,31
5 6 7 8	6,7 AND 11,12 48,49,50 AND 54,55,56 68,69 AND 73,74 24,25,26,27 AND 32,33,34,35
9 10 11 12	4,5 AND 13,14 45,46,47 AND 57,58,59 66,67 AND 75,76 21,22,23 AND 36,37,38
13 14 15 16	1,2,3 AND 15,16,17 42,43,44 AND 60,61,62 63,64,65 AND 77,78,79 18,19,20 AND 39,40,41

141T4813-7,-8,-15,-16,-19,-20,-23 THRU -30,-501,-502,-505,-506
Window Assembly Repair - Bolt Installation
Figure 611

E96058

GEAR ASSEMBLY - REPAIR 4-1

141T4912-1, -2, -7, -8

NOTE: Refer to REPAIR-GEN for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers.

1. Parts Replacement (Fig. 601)

CAUTION: HOUSINGS (460, 470), HOUSINGS (460A, 470A), HOUSINGS (465, 475), HOUSINGS (465A, 475A) ARE MATCHED SETS AND MUST BE KEPT TOGETHER.

A. Remove fasteners and disassemble the unit. Keep the housing halves together as a set. Replace the housing halves only as a set.

B. Replace other parts as necessary. If you find defects on housing surfaces, refer to par. 2 for repair instructions.

C. With the old parts as a guide, or as shown, drill holes for rivet (390) through gear (420), bushing (410) and universal joint (425). Install rivet (390).

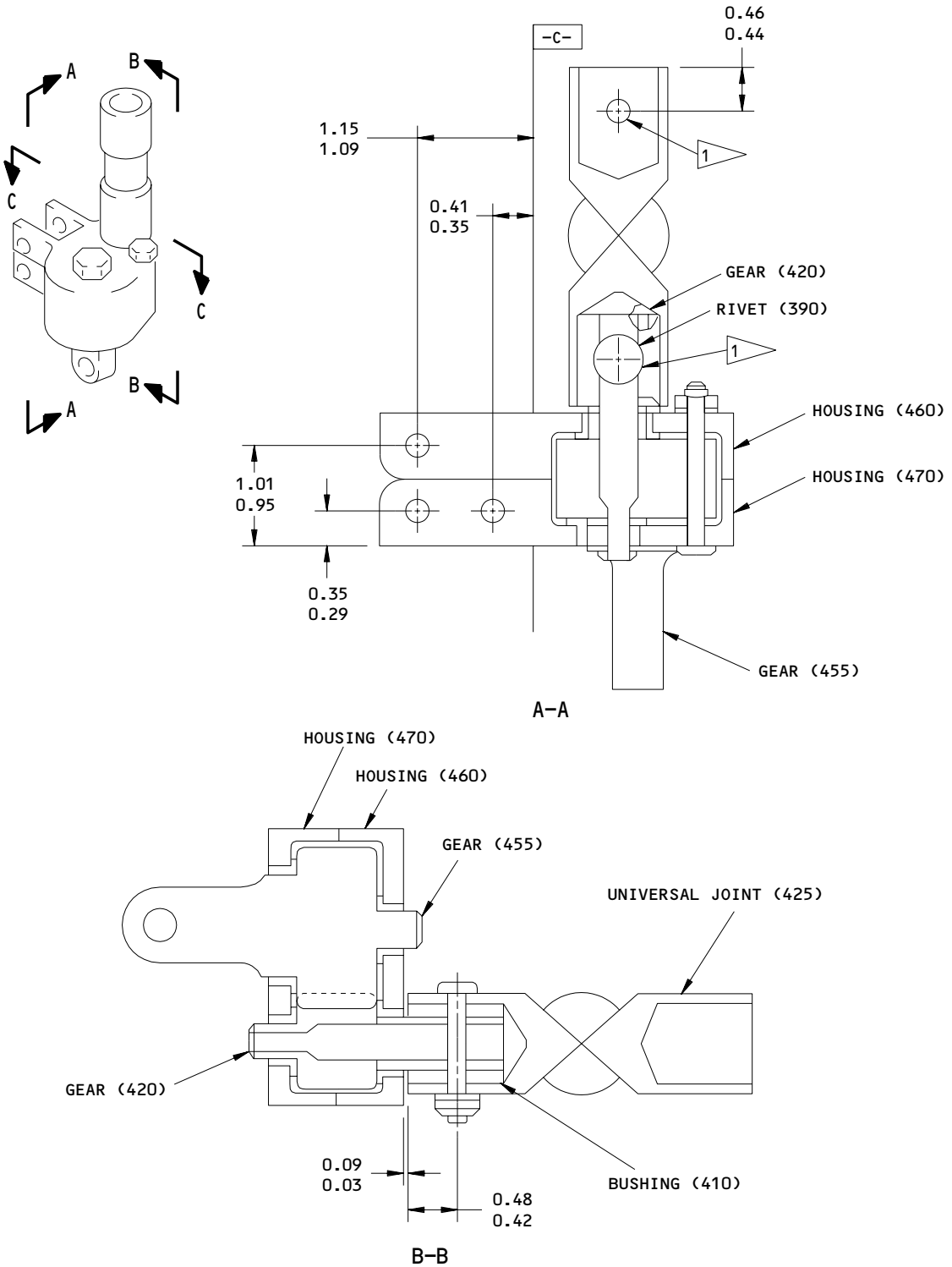
2. Bushing Replacement (Fig. 601)

A. Remove the old bushings.

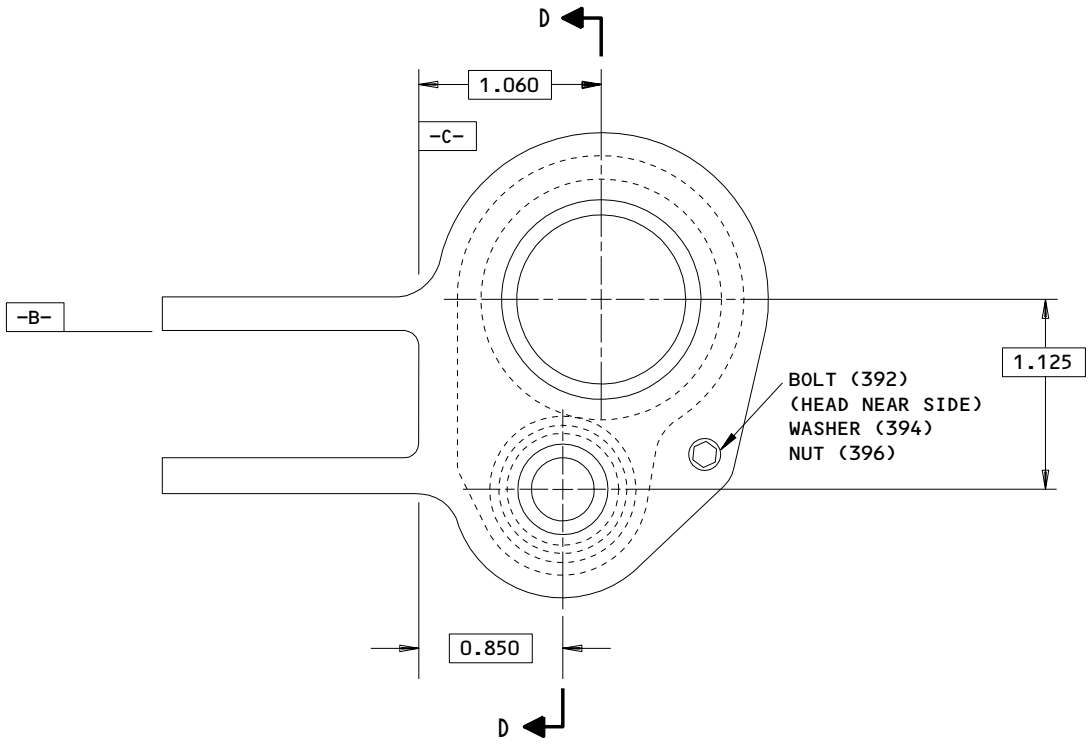
B. If you find defects on hole surfaces, refer to REPAIR 4-2 for repair instructions.

C. Install replacement bushings by the shrink-fit method (SOPM 20-50-03).

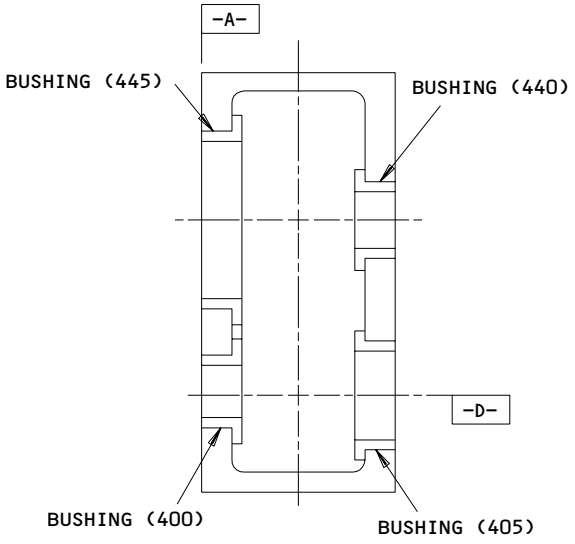
D. Fillet seal around the flanges of the bushings with BMS 5-95 sealant.



141T4912-1,-2,-7,-8
Gear Housing Assembly Parts Replacement
Figure 601 (Sheet 1)



C-C



D-D

1 THESE HOLES TO BE PERPENDICULAR TO -B- WITH HOLE IN GEAR (455) HELD PARALLEL TO -B- WITHIN 5°

141T4912-1,-2,-7,-8
Gear Housing Assembly Parts Replacement
Figure 601 (Sheet 2)

GEAR HOUSING ASSEMBLY - REPAIR 4-2

141T4912-13 THRU -16

NOTE: Refer to REPAIR-GEN for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers.

1. Holes for Bushings (Fig. 601)

CAUTION: GEAR HOUSINGS (460, 470), HOUSINGS (460A, 470A), HOUSINGS (465, 475) AND HOUSINGS (465A, 475A) ARE MATCHED SETS AND MUST BE KEPT TOGETHER.

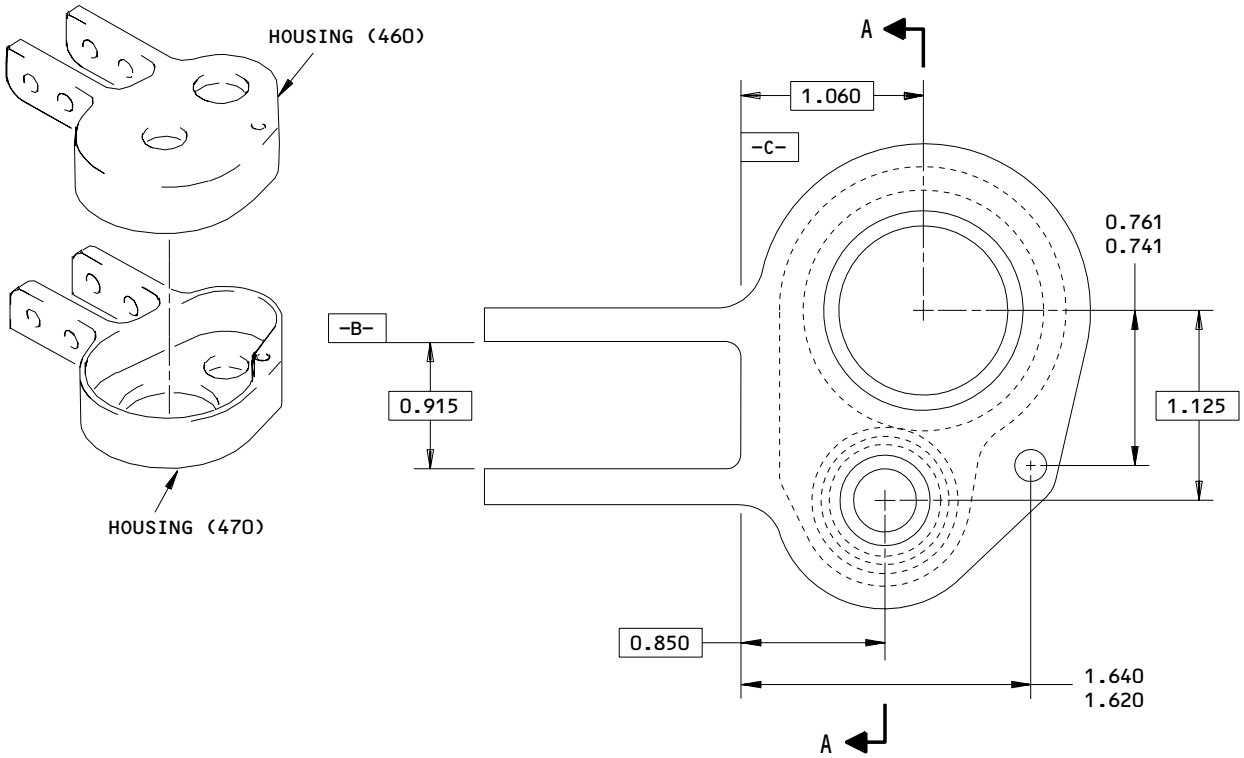
A. Machine as required, within repair limits, to remove defects.

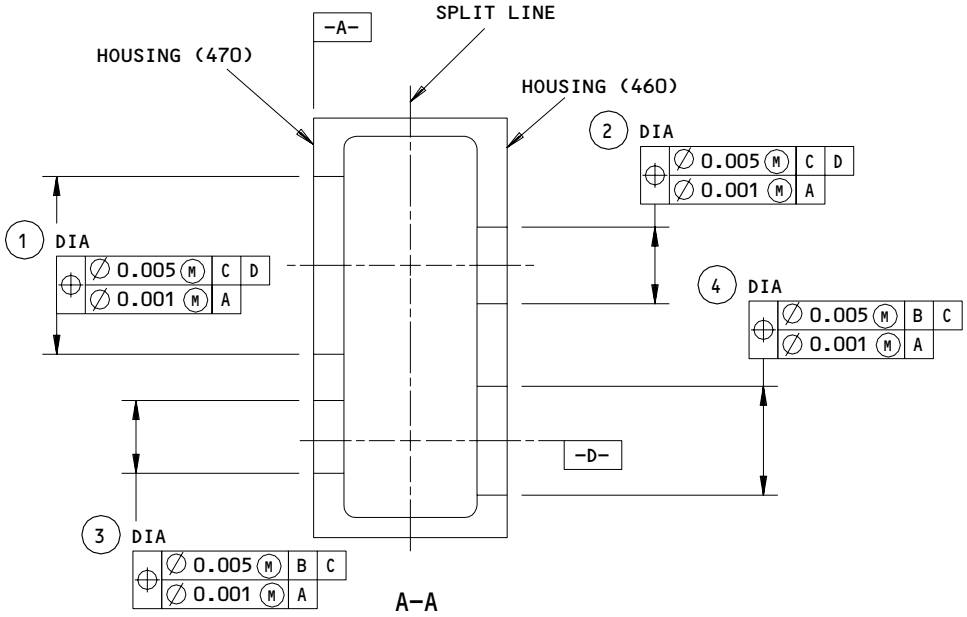
B. Penetrant examine (SOPM 20-20-02).

C. Refinish as indicated.

D. Make oversize bushings (Fig. 602) as necessary to adjust for the material removed in step A.

E. Install the bushings and seal them per REPAIR 4-1.





141T4912-13 Thru -16
Gear Housing Assembly Repair and Refinish
Figure 601 (Sheet 1)

REFERENCE NUMBER	(1)	(2)	(3)	(4)	(5)
DESIGN DIMENSION	1.1898 1.1888	0.5013 0.5006	0.5013 0.5006	0.6892 0.6882	0.194 0.190
REPAIR LIMIT	1.2498	0.5613 	0.5613 	0.7492 	---

REFINISH

CHROMIC ACID ANODIZE AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.13), BUT NO PRIMER IN HOLES FOR BUSHINGS

 LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS (FIG. 602)

REPAIR

REF 

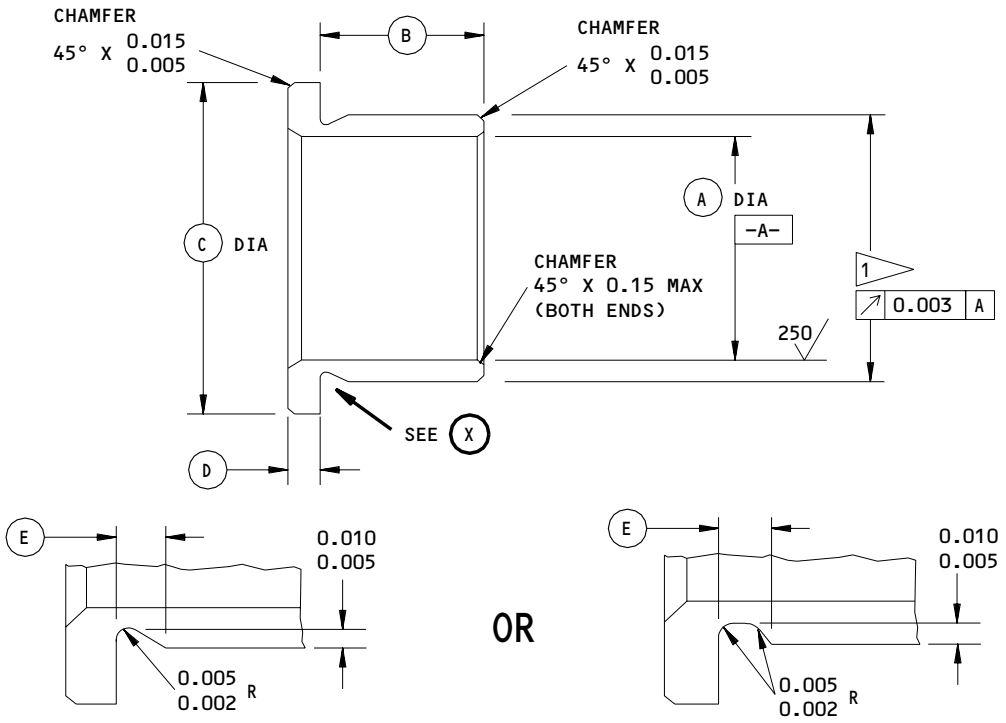
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

141T4912-13 Thru -16
Gear Housing Assembly Repair and Refinish
Figure 601 (Sheet 2)



TYPE 1 TYPE 2

UNDERCUT TYPE 1 OR TYPE 2 OPTIONAL

X

HOLE LOCATION (FIG. 601)	REPLACES BUSHING (IPL FIG. 1)	A	B	C	D	E	INTERFERENCE
2 3	BACB28X6C020 (400,440)	0.3765 0.3650	0.200 0.195	0.635 0.615	0.062 0.057	0.030 0.015	0.0000–0.0007
4	BACB28X9C020 (405)	0.5640 0.5625	0.200 0.195	0.822 0.802	0.062 0.057	0.030 0.015	0.0000–0.0010
1	BACB28X16C020 (445)	1.0015 1.0000	0.200 0.195	1.385 1.365	0.062 0.057	0.030 0.015	0.0000–0.0010

1 FINAL BUSHING OUTSIDE DIAMETER EQUALS REPAIR DIAMETER OF FITTING PLUS INTERFERENCE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ANGULAR TOLERANCE, ±0.50 DEGREES

MATERIAL: 17-4PH CRES, RC 40-43

FINISH: CADMIUM PLATE (F-15.06)
PLATING IN BORE OPTIONAL

DIMENSIONS APPLY AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602

MISCELLANEOUS PARTS REFINISH - REPAIR 5-1

NOTE: Repair of these parts is only replacement of the original finish.

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Carriage bracket (38A,40)	17-4PH CRES, 150 ksi min	Passivate (F-17.25, which replaces F-17.09).
Filler (44)	Al alloy	Chemical treat (F-17.07).
Plate (67)	15-5PH CRES, 150-170 ksi	Cadmium plate (F-15.06), but not on serrations.
Striker bracket (150A,155A)	17-4PH CRES, 150 ksi min	Cadmium plate (F-15.06) all over.
Washer (200)	Al-Nickel Bronze	Cadmium plate (F-15.06) all over.
Grip (210)	304 CRES	Apply BMS 10-11, type 1 primer (F-20.02). Apply BMS 10-72 enamel (F-22.03). Finish outside surface only.
Upper guide (225) Lower guide (240)	Al alloy	Chromic acid anodize (F-17.04) all over.
Safety catch (235) Bracket (730)	15-5PH CRES, 150-170 ksi	Passivate (F-17.25, which replaces F-17.09) all over.
Crank arm (245)	17-4PH CRES, 150 ksi min	Passivate (F-17.25, which replaces F-17.09) all over, but cadmium plate (F-15.06) areas mating with washer (200) and lower guide (240).

Refinish Details
Figure 601 (Sheet 1)

IPL FIG. & ITEM	MATERIAL	FINISH
Spacer (295,325) Pin (300)	15-5PH CRES, 150-170 ksi	Passivate (F-17.25, which replaces F-17.09).
Gear (420,455)	15-5PH CRES, 180-200 ksi	Passivate (F-17.25, which replaces F-17.09).
Rub strip (532H) Shim (69)	301 CRES	Apply BMS 10-11, type 1 primer (F-20.02) to concave surface only.
Rub strip (532F)	301 CRES	Apply BMS 10-11, type 1 primer (F-20.02) and BMS 10-11, type 2 epoxy enamel (F-21.26-8925, which replaces SRF-14.903-8925).
Seal retainer (560A,561A,562A, 563A,564A,565A, 566A,567A)	Al alloy	On exposed surface only: Chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13). Then apply BMS 10-86, type 1, white abrasion resistant teflon coating (F-14.9624, which replaces SRF-14.9624) all over.
Plate (684W,689)	15-5PH CRES 150-170 ksi	Apply BMS 10-11, type 1 primer (F-20.02) all over.

Refinish Details
Figure 601 (Sheet 2)

WINDOW ASSEMBLY (GLASS) - REPAIR 6-1

141T4813-31, -32, -33, -34

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers.

1. Bushing Replacement (684K, 684X) (Fig. 601)

   A. Remove the old bushings.

   CAUTION: DO NOT INSTALL BUSHINGS (684K, 684X) UNTIL AFTER THE FRAME ASSEMBLY (683H, 683K) AND LAMINATE ASSEMBLY (679G, 679T) ARE ASSEMBLED.

   B. Install replacement bushings (684K, 684X) by the shrink-fit method (SOPM 20-50-03).

   C. Machine the bores of these bushings to design dimensions and finish.

2. Bushing Replacement (684H, 684J) (Fig. 602)

   A. Remove the old bushings.

   B. If you find defects on hole surfaces, refer to par. 3, below.

   C. Install replacement bushings by the shrink-fit method (SOPM 20-50-03).

   D. Machine the bushings to design dimensions and finish.

3. Repair

   A. Holes for bushings (684H, 684J).

      (1) Machine as necessary, within repair limits, to remove defects.

      (2) Penetrant examine (SOPM 20-20-02).

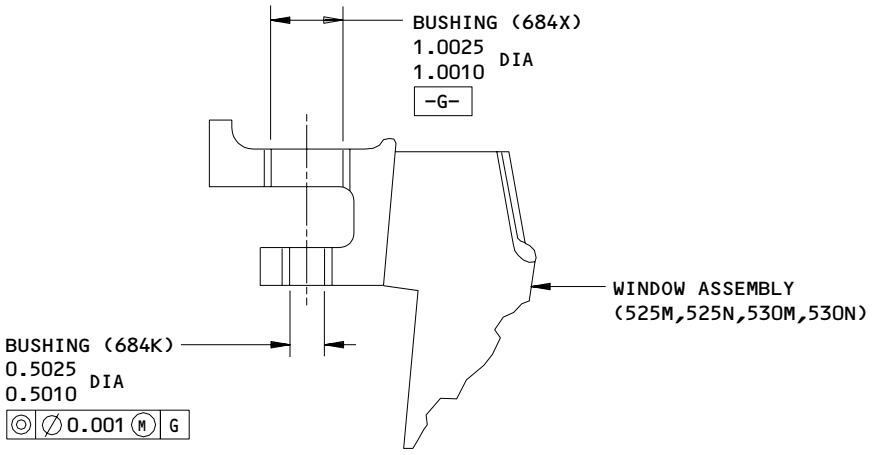
      (3) Refinish per par. 4.A.

      (4) Make oversize bushings (Fig. 603, Fig. 604) to adjust for the material removed.

(5) Install the bushings per par. 2. above.

4. Refinish

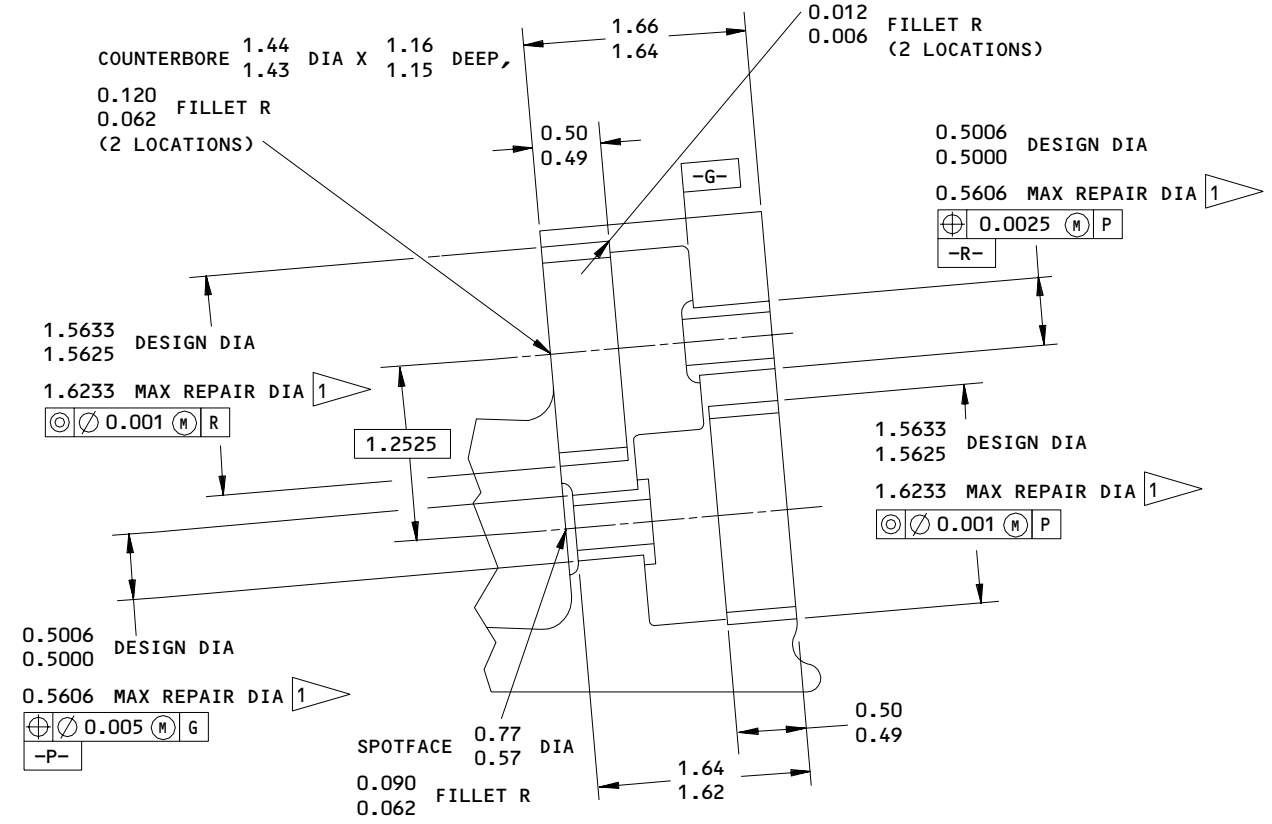
A. Frame fittings (687B, 688A) -- Chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13) but no primer in holes for bushings (684H, 684J) or in the 0.313-0.327 diameter hole in opposite end of the post. Apply enamel per Fig. 605. Material: Al alloy.

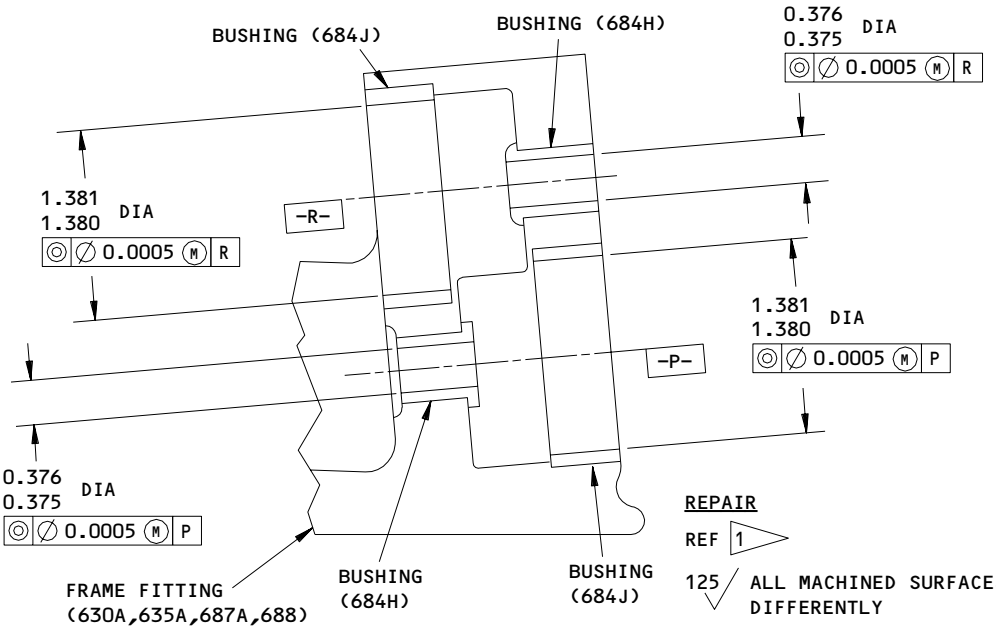


ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

Bushing Replacement
Figure 601

E96060





REPAIR

REF 1

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY

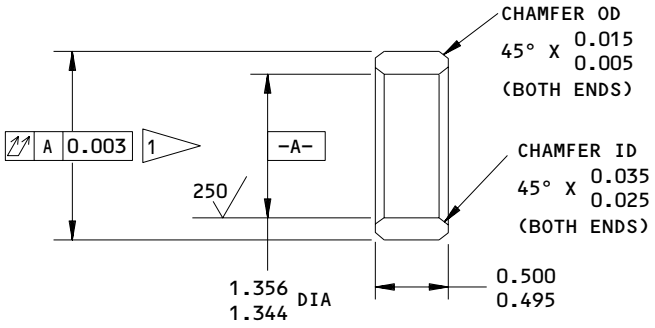
ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

1 LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS

141T4852-35,-36
Frame Fitting Assembly
Figure 602

E96063



FINISH:

CADMIUM PLATE (F-15.06)
(OPTIONAL IN BORE)

1 FINISH BUSHING OUTSIDE DIA EQUALS REPAIR DIA OF FITTING PLUS 0.0024 INTERFERENCE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL-NI-BRZ PER (AMS 4640)

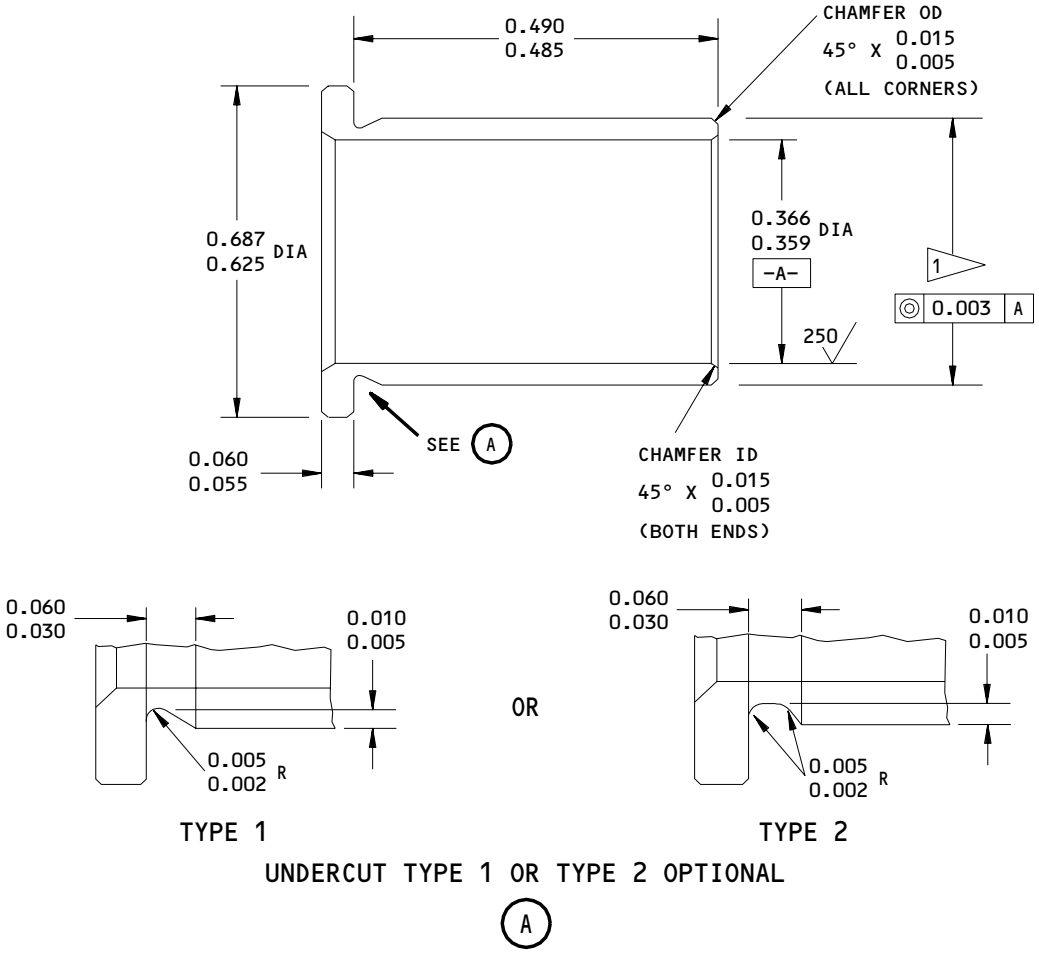
DIMENSIONS APPLY AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

REPLACES BUSHING (IPL FIG. 1; 684J) BACB28UB050

Replacement Bushing Details
Figure 603

E96067



FINISH:

CADMIUM PLATE (F-15.06) (OPTIONAL IN BORE)

1 FINAL BUSHING OUTSIDE DIA EQUALS REPAIR DIA OF FITTING PLUS 0.0013 INTERFERENCE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ANGULAR TOLERANCE, ±0.50 DEG

MATERIAL: AL-NI-BRZ (AMS 4640) OR QQ-C-465 ALLOY NO. 630

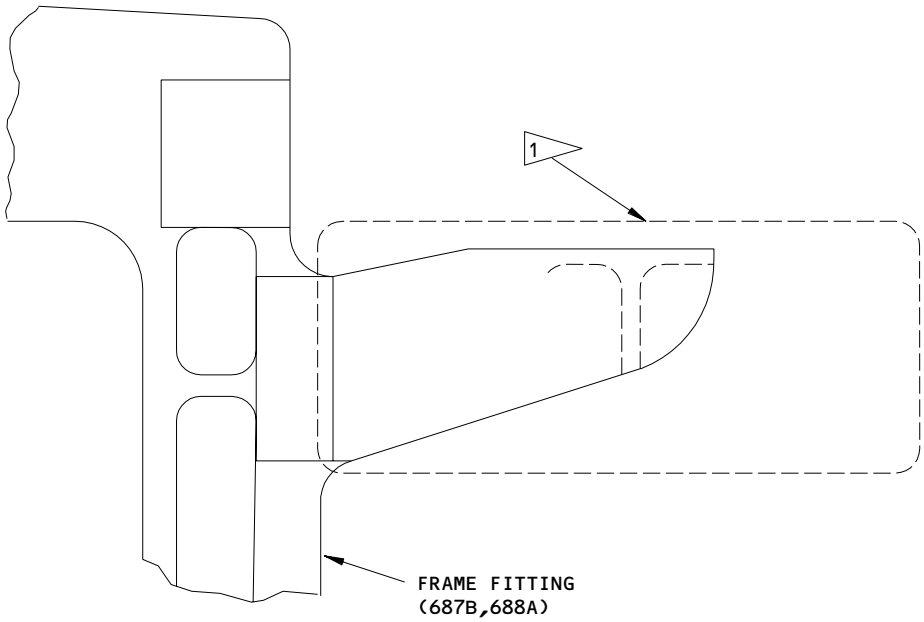
DIMENSIONS APPLY AFTER PLATING

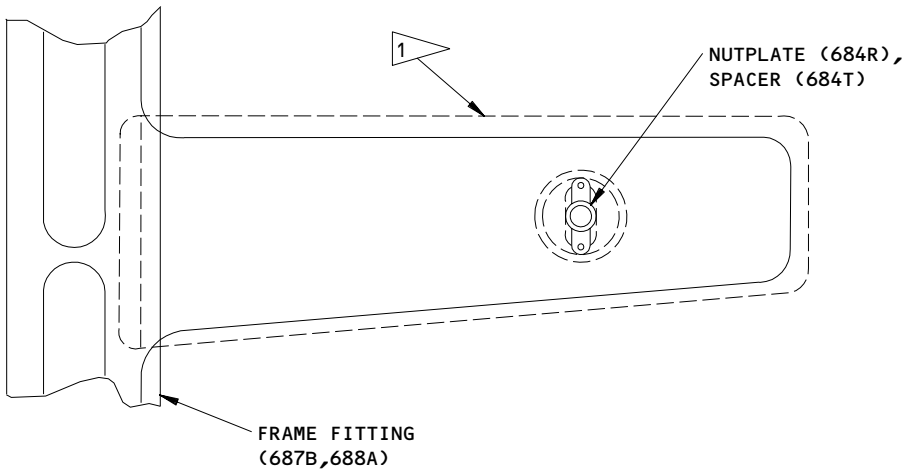
ALL DIMENSIONS ARE IN INCHES

REPLACES BUSHING (IPL FIG. 1; 640B,684H) BACB28W6B049

Oversize Bushing Details
Figure 604

E96070





1 APPLY BMS 10-11, TYPE 2 FLAT BEIGE EPOXY ENAMEL (SRF-14.903-8925) IN THIS AREA

141T4852-41,-42
Fitting Refinish
Figure 605

E96074

WINDOW ASSEMBLY (GLASS) - REPAIR 6-2

141T4813-31, -32, -33, -34

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

1. Terminal Block (65, 80) Replacement (IPL Fig. 2)

   CAUTION: PREPARE THE FAYING SURFACES SO THAT THE TWO PIECES TO BE CEMENTED FIT ACCURATELY.

   A. Remove the old cement and abrade the faying surfaces with 240-grit wet or dry sandpaper per Fig. 601.

   WARNING: USE CAUTION WHEN YOU WORK WITH ALIPHATIC NAPHTHA BECAUSE IT IS FLAMMABLE.

   B. After abrading, clean the faying surfaces with aliphatic naphtha, or soap and water followed by aliphatic naphtha.

   C. Dry thoroughly prior to application of cement.

   D. Mask the surrounding window a minimum of 1 inch from the bonding area and within 0.031 inch of bond area to confine the softening action of the cement.

   E. Mix PR 1425 sealant per manufacturer's instructions.

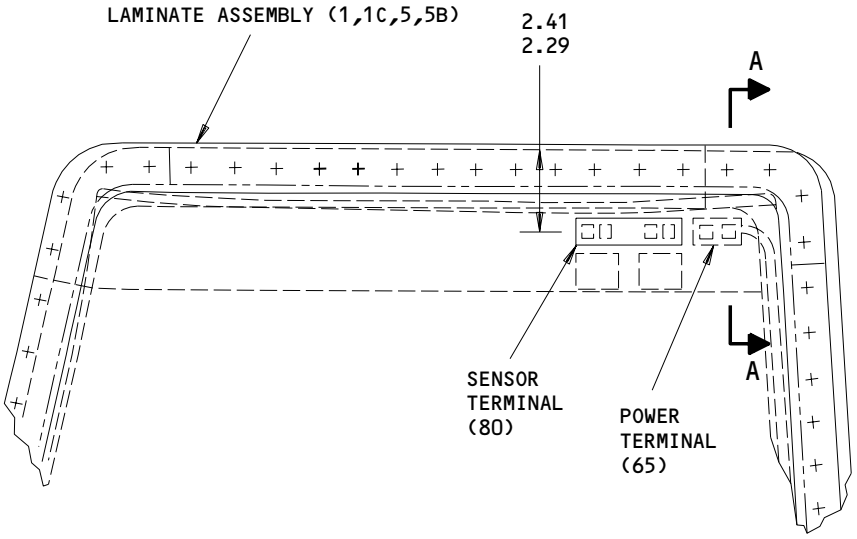
   F. For laminate (1, 5, IPL Fig. 2), apply a 0.020-0.060-inch bondline of PR 1425 sealant.

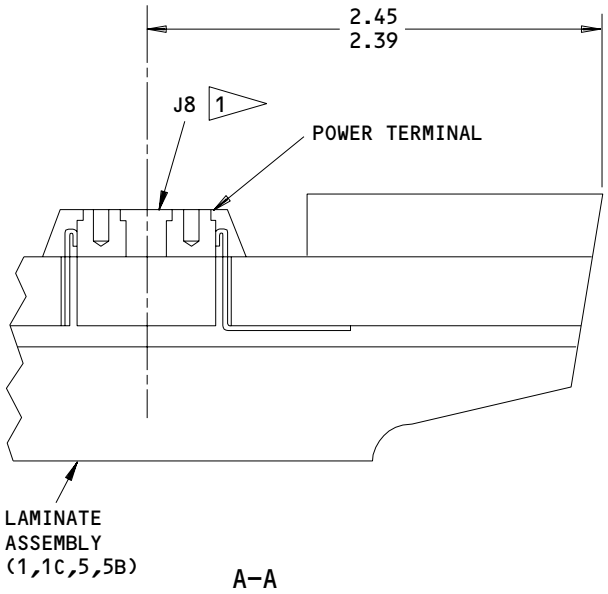
   CAUTION: APPLY ONLY ENOUGH PRESSURE WITH THE SPRING CLAMPS OR THE WEIGHTS TO HOLD SURFACES TOGETHER. TOO MUCH PRESSURE CAN CAUSE CRAZING AND CAN FORCE THE CEMENT FROM THE BOND AREA.

   G. Join the surfaces immediately after coating and apply pressure during cure cycle.

   H. Allow to dry per manufacturer's instructions.

   I. Apply 0.12-inch high letters per 20-50-10 on terminal caps (65, 80, IPL Fig. 2) as shown in Fig. 601.





A–A

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

141T4813-31,-32,-33,-34
Terminal Cap Replacement
Figure 601

E96088

WINDOW ASSEMBLY (GLASS) - REPAIR 6-3

141T4813-31, -32, -33, -34

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

NOTE: Use these procedures also for acrylic windows supplied with the spacers installed.

1. Laminate Assembly (1, 5) Replacement (IPL Fig. 2)

A. Spacer Installation

NOTE: This section and related Fig. 601 and 602 were deleted. The 141T4001-series windows came with the spacers installed and adjusted.

B. Assembly of Frame and Laminate Assembly

(1) Clean the mating surface of the frame assembly and apply one layer of parting agent tape (Fig. 603).

(2) Mask the edges of the frame assembly and the laminate assembly.

(3) Mix PR 1425 sealant by the vendor's instructions.

(4) Apply a thin layer of PR 1425 sealant on the mating surfaces of the laminate assembly and the frame.

(5) Install fasteners (680J) around perimeter in the sequence shown in Fig. 604 and tighten to 30-50 pound-inches.

NOTE: Temporary removal of some fasteners could be necessary for removal of unwanted sealant. Movement between the frame and the laminate is normal and acceptable during fastener installation.

(6) Let the sealant cure for 1 hour and then make a check of the torque values.

(7) Cure Class B 1/2 sealant 24 hours. Cure Class B2 sealant 48 hours.

C. Laminate and Window Assembly Inner Seal

CAUTION: BE CAREFUL WITH ALIPHATIC NAPHTHA BECAUSE IT IS FLAMMABLE.

(1) Clean the area around the window assembly with aliphatic naphtha applied with clean cheesecloth.

(2) Wipe off the aliphatic naphtha, before it dries, with a clean dry cheesecloth.

(3) Apply a fillet seal of PR 1425 sealant around the window assembly inner area by the vendor's instructions.

NOTE: Make sure PR 1425 sealant is applied around the window perimeter (Fig. 605).

D. Window Assembly Edge Seal/Fastener Seal (Fig. 606)

(1) Make the frame assembly, the moisture seal retainers and the RTV 157 sealant moisture seal RTV 157 on the laminate assembly.

(2) Mix PR 1425 sealant by the vendor's instructions.

(3) Brush or spray a layer of this sealant on the edge of laminate assembly to a thickness of 0.030 inch maximum.

(4) Cure Class B 1/2 sealant 24 hours. Cure Class B2 sealant 48 hours.

(5) Lightly hand-sand as necessary to make a smooth surface.

(6) Apply BMS 10-86, type 1 coating (F-14.9625-707, which replaces SRF-14.9625-707).

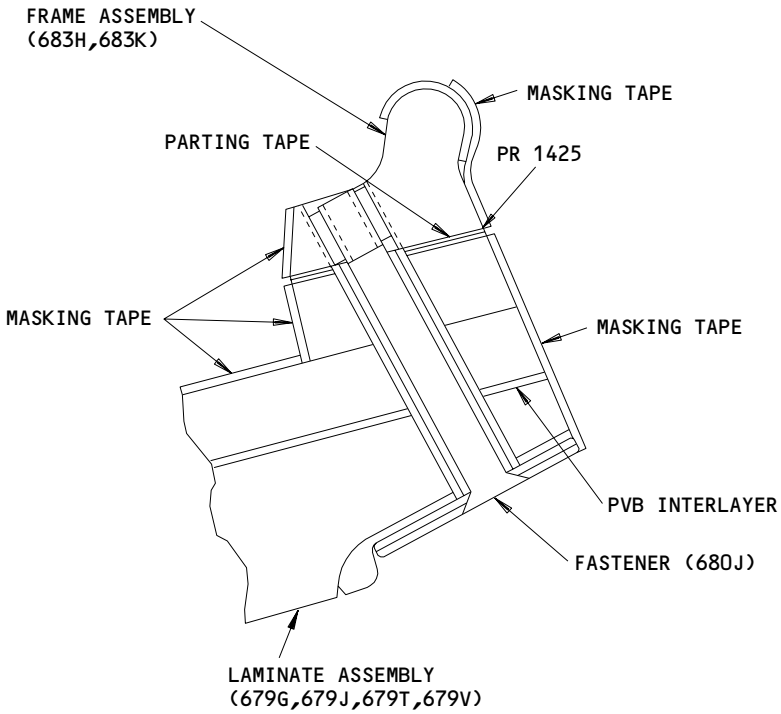
(7) Remove the masking tape.

(8) Apply BMS 5-95 sealant to backfill the fastener holes in the frame assembly (Fig. 607).

E. Frame Assembly, Fastener Heads, and Seal Retainer Touchup

(1) Touch up frame assembly (683H, 683K) and fastener (680J) heads with chemical treatment (SOPM 20-43-03) or chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13). Apply BMS 10-11, type 2 flat epoxy enamel (F-21.26-8925, which replaces SRF-14.903-8925).

(2) Touch up retainer rings (10, 20, 30, 40) with chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13).

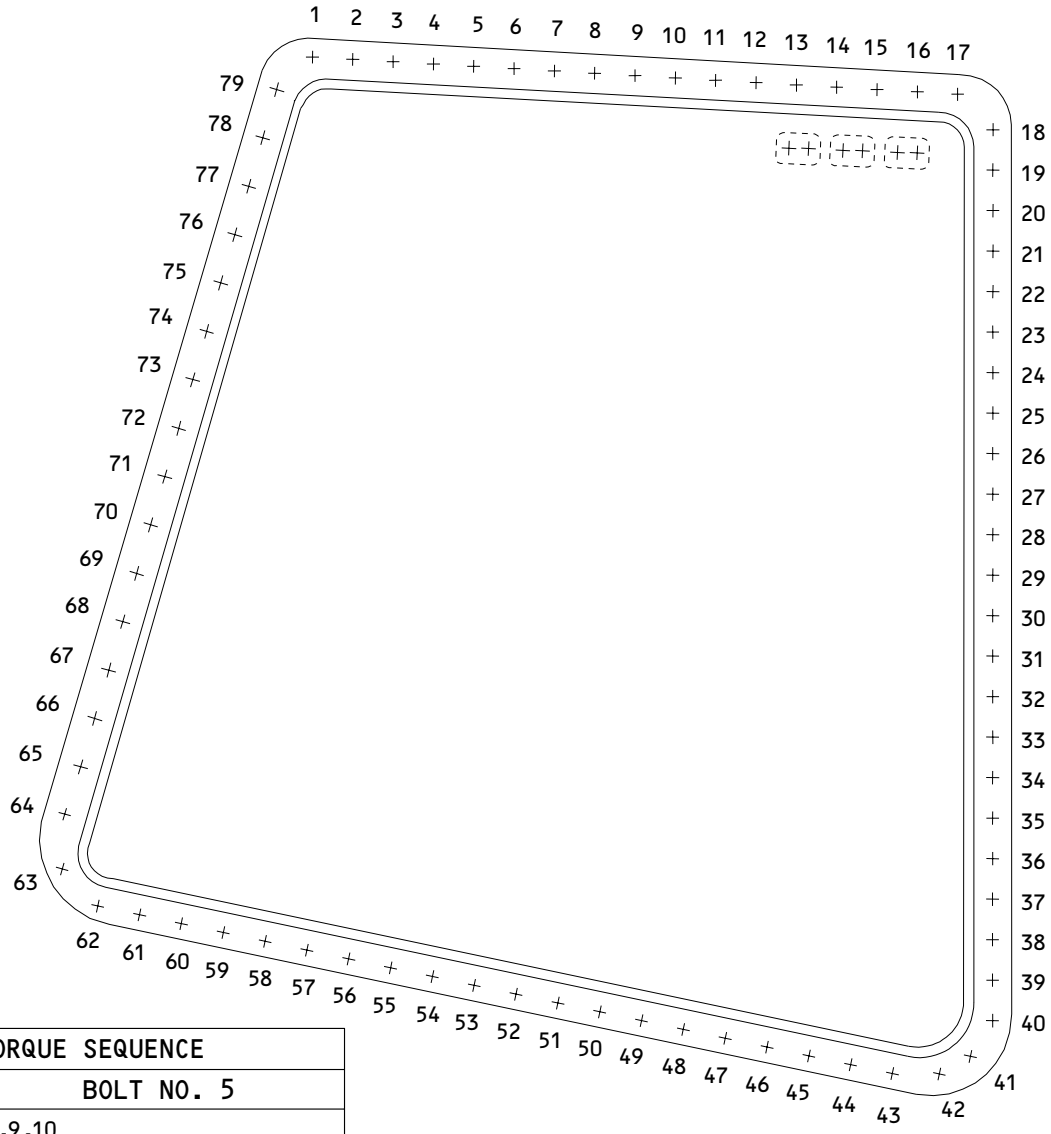


ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

141T4813-31,-32,-33,-34
Window Assembly Repair - Liquid Shim Application
Figure 603

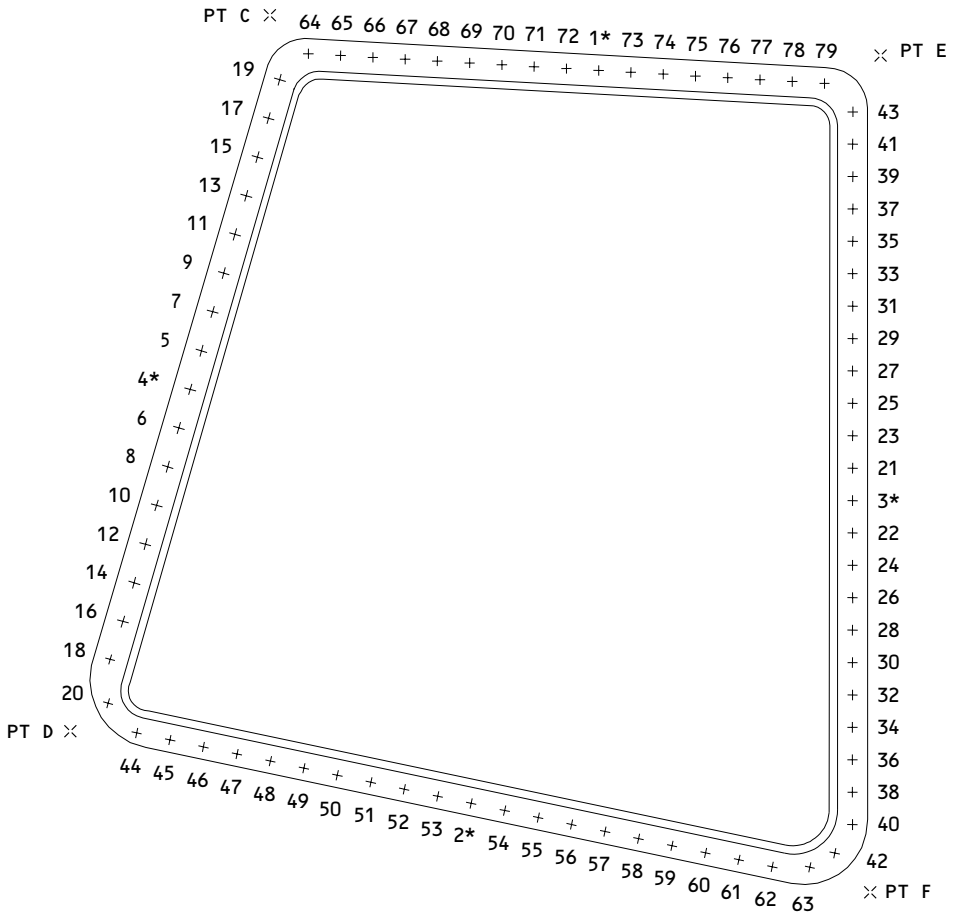
E97471



BOLT TORQUE SEQUENCE	
STEP NO.	BOLT NO. 5
1	8,9,10
2	51,52,53
3	70,71,72
4	28,29,30,31
5	6,7 AND 11,12
6	48,49,50 AND 54,55,56
7	68,69 AND 73,74
8	24,25,26,27 AND 32,33,34,35
9	4,5 AND 13,14
10	45,46,47 AND 57,58,59
11	66,67 AND 75,76
12	21,22,23 AND 36,37,38
13	1,2,3 AND 15,16,17
14	42,43,44 AND 60,61,62
15	63,64,65 AND 77,78,79
16	18,19,20 AND 39,40,41

141T4813-31,-32
Window Assembly Repair - Bolt Installation
Figure 604 (Sheet 1)

E96115

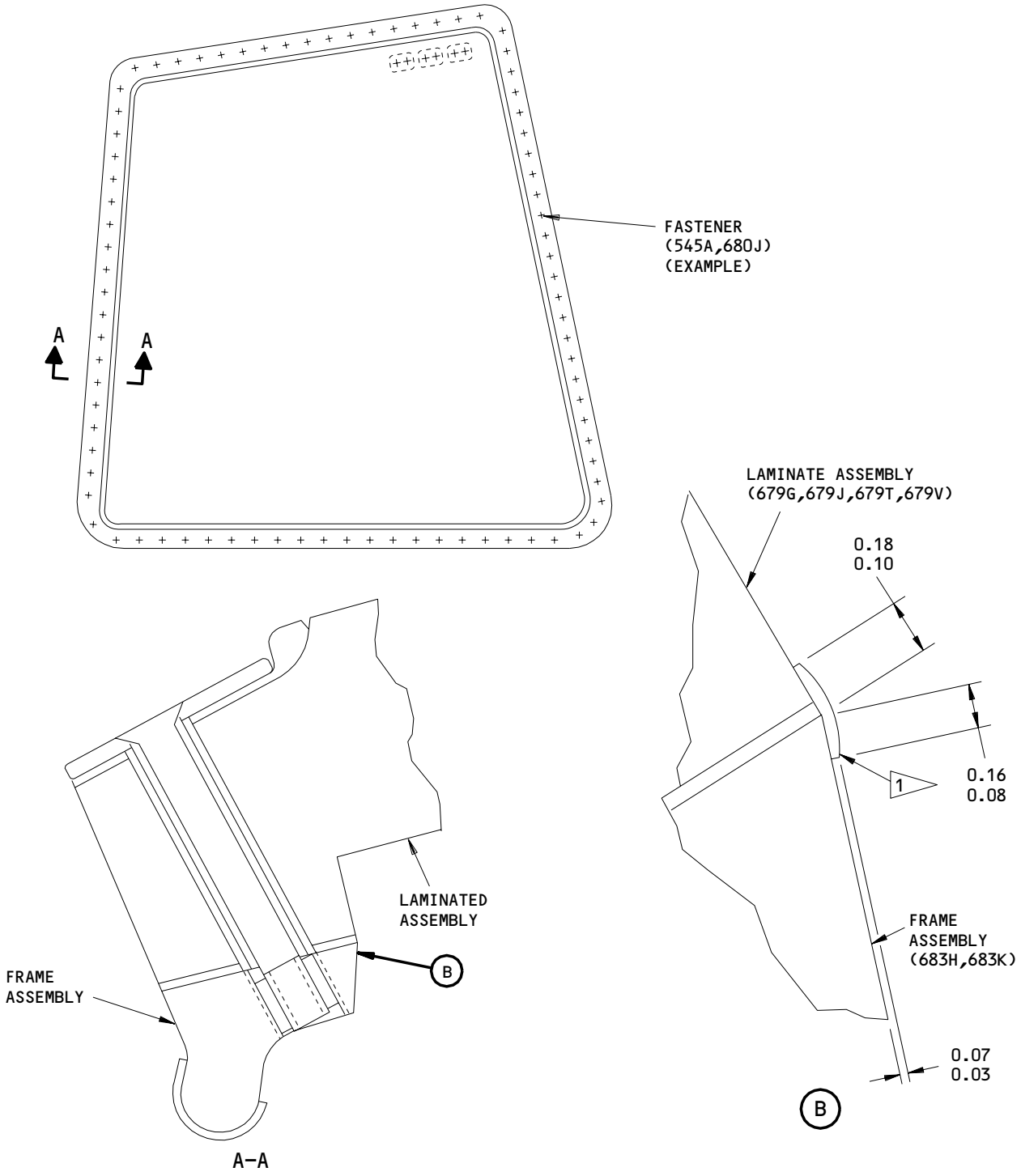


BOLT TORQUE SEQUENCE		
TORQUE ORDER	BOLT NO.	TORQUE
1*	1*–4*	40 IN LB
2▲	4▲–20▲	50 IN LB
3	21–43	40 IN LB
4	44–63	40 IN LB
5	64–79	40 IN LB

▲ NOTE: BOLT NO. 4 MUST BE TORQUED TO 40 INCH POUND, THEN TO 50 INCH POUND

141T4813-31,-32,-33,-34
Window Assembly Repair - Bolt Installation
Figure 604 (Sheet 2)

G47759



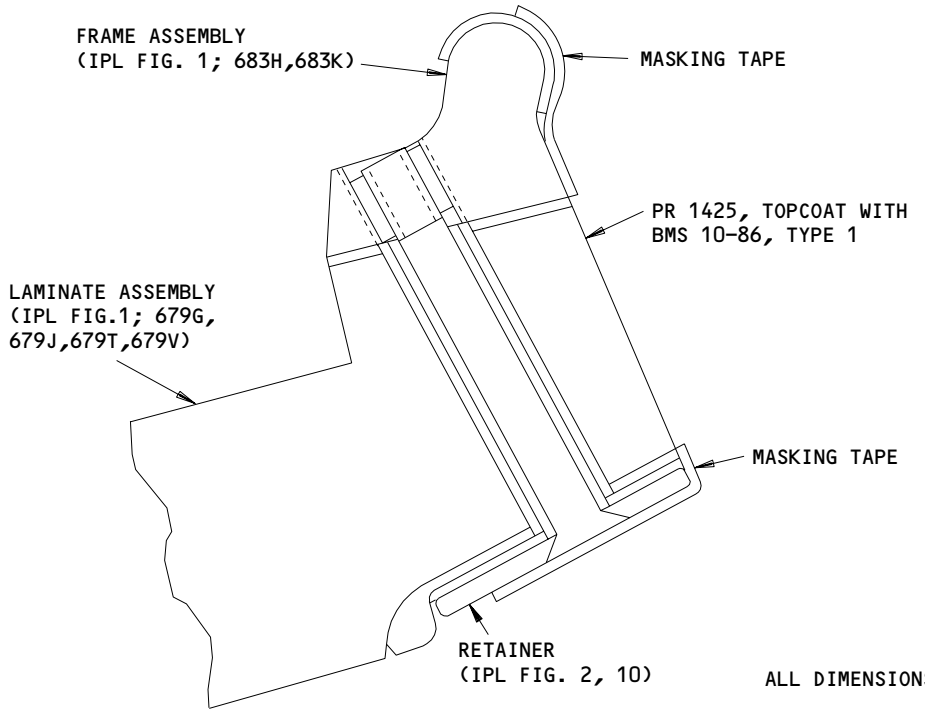
1 APPLY PR1425 SEALANT AROUND ENTIRE WINDOW INNER PERIMETER

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

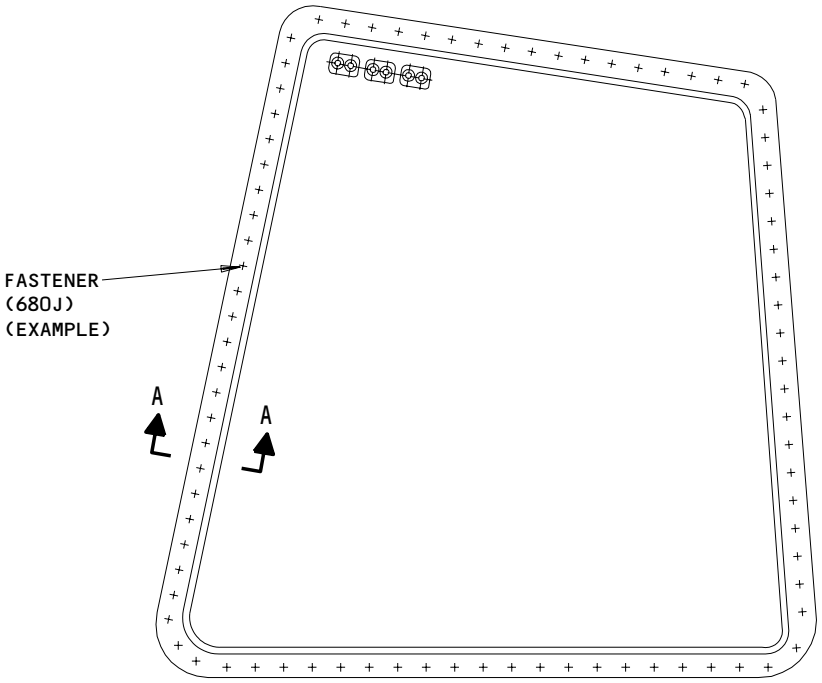
141T4813-31,-32,-33,-34
Window Assembly Repair - Inner Seal
Figure 605

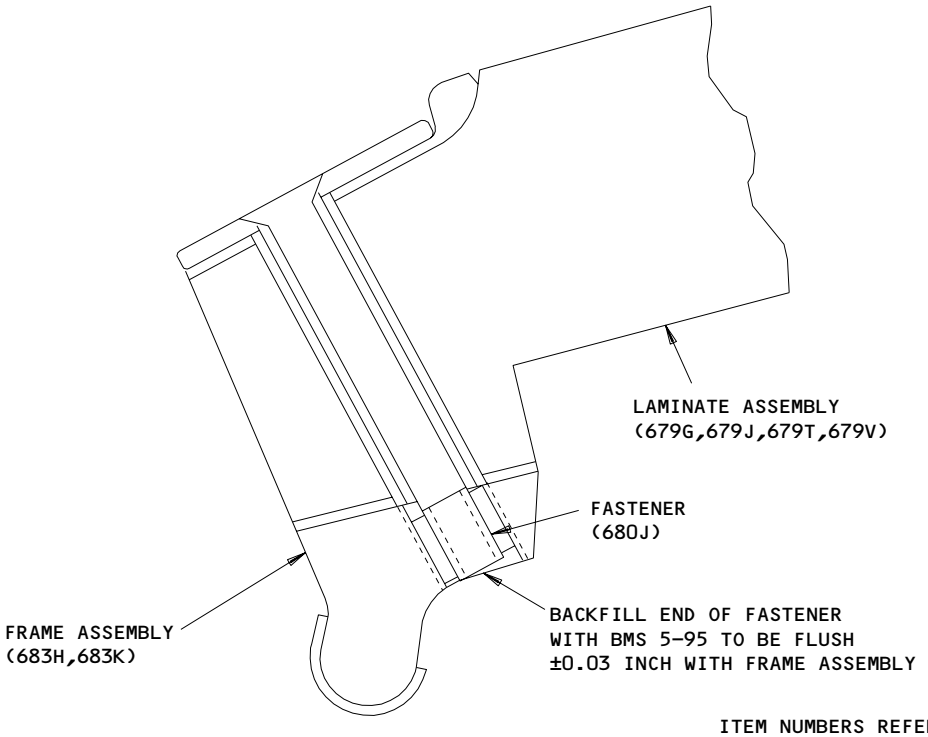
E96117



141T4813-31,-32,-33,-34
Window Assembly Repair - Sealant Application
Figure 606

E96120





ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

A-A

141T4813-31,-32,-33,-34
Window Assembly Repair - Fastener Sealing
Figure 607

E96123

TORQUE TUBE ASSEMBLY - REPAIR 7-1

141T4865-10, -21, -27

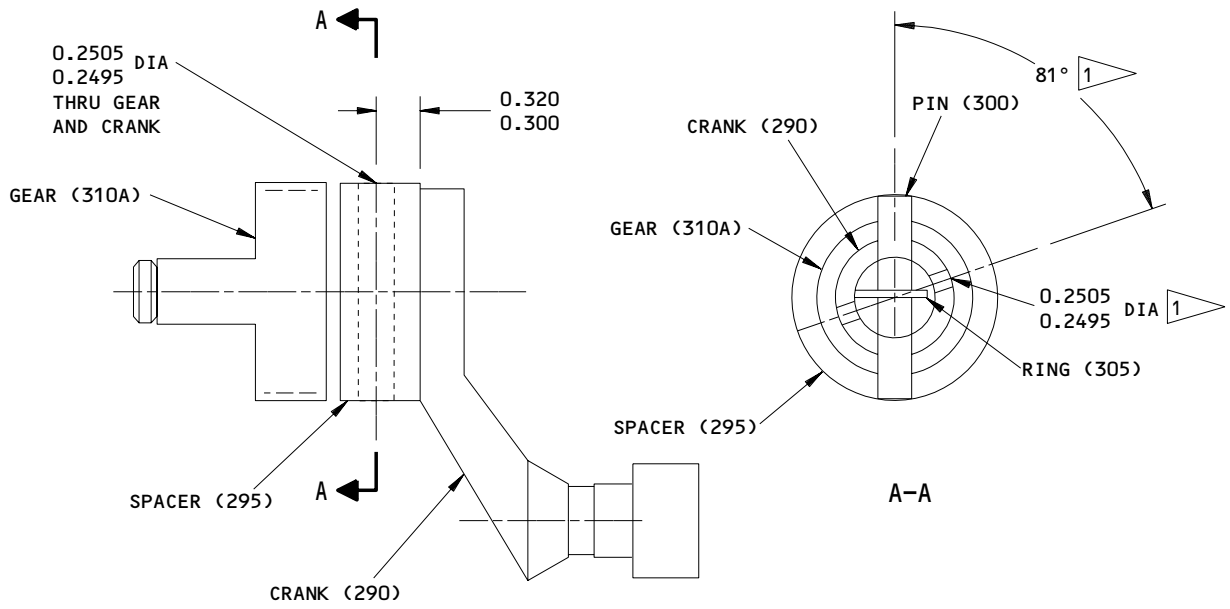
NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers.

1. Parts Replacement (Fig. 601)

   A. Remove ring (305). Push out pin (300).

   B. Replace defective parts.

   C. Assemble replacement crank (290) and gear (310) with spacer (295). Install pin (300), ring (305).



1 FOR 141T4865-27 ONLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

141T4865-10,-21,-27
Torque Tube Assembly Parts Replacement
Figure 601

L49182

TORQUE TUBE ASSEMBLY - REPAIR 8-1

141T4865-11, -17, -22, -28

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers.

1. Parts Replacement (Fig. 601)

   A. Remove rivets (330, 335) and universal joint (350) from tube (355) and gear (320).

   B. Replace defective parts.

   C. Install tube (355) into universal joint (350) and push the tube in until the end of the tube gets to the bottom of the bore of the joint. Look through the inspection hole to make sure the tube is fully into the joint.

   D. With the old parts as a guide, or as shown, drill a hole through the replacement parts for rivet (335). Install rivet (335).

   E. Install a replacement gear (320) on the other end of universal joint (350). Push the gear into the universal joint until the shoulder of the gear is against the end of the universal joint. With the old parts as a guide, or as shown, drill a hole through the replacement parts for rivet (335). Install rivet (335).

2. Parts Replacement (Fig. 602)

   A. Remove rivets (330, 335), shim (345) and universal joint (350) from tube (355) and gear (320).

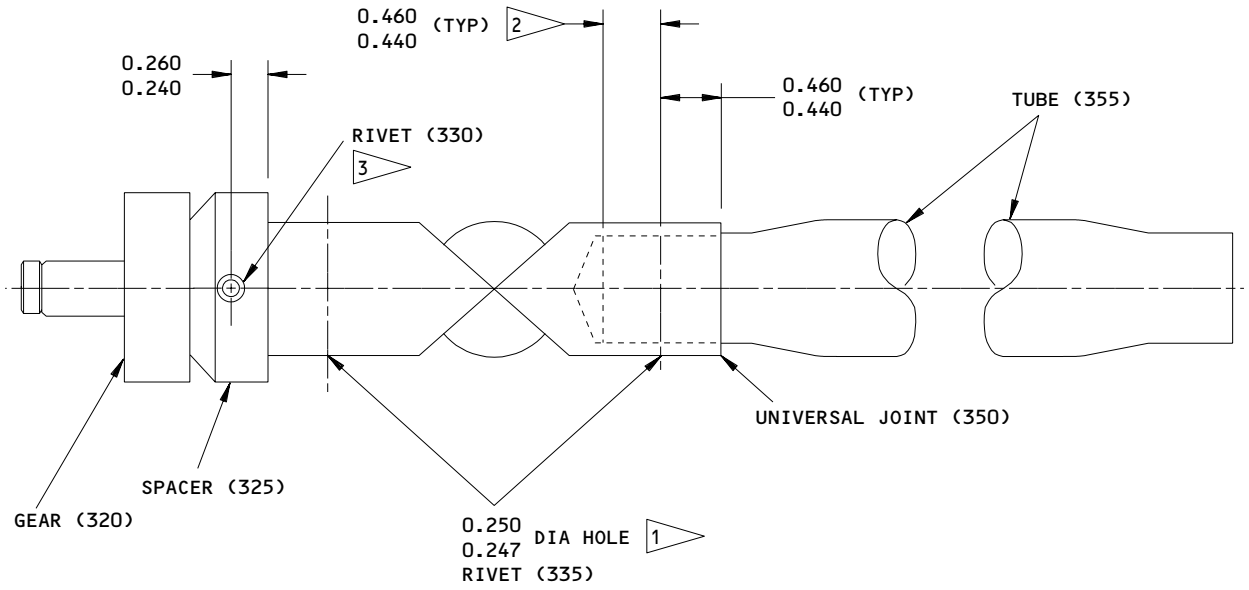
   B. Replace defective parts. If you replace shim (345), make a note of the thickness of the old shim to help during assembly.

C. Bend the replacement shim into a C shape around the mating curved surface of the tube. Remove 0.003-inch laminations from the shim as necessary to decrease the gap to 0.006 inch or less. Install the shim away from the inspection hole, as shown.

D. Install the tube (355) into universal joint (350) and push the tube in until you can see the tube through the inspection hole.

E. With the old parts as a guide, or as shown, drill a hole through the replacement parts for rivet (335). Install rivet (335).

F. Install replacement gear (320) on the other end of universal joint (350). Push the gear into the universal joint until the shoulder of the gear is against the end of the universal joint. With the old parts as a guide, or as shown, drill a hole through the replacement parts for rivet (335). Install rivet (335).



1 INCREASE THE HOLE TO 0.254–0.265 DIAMETER IF RIVET (355A) IS USED

2 MAKE SURE TUBE END IS AT THE BOTTOM OF THE BORE

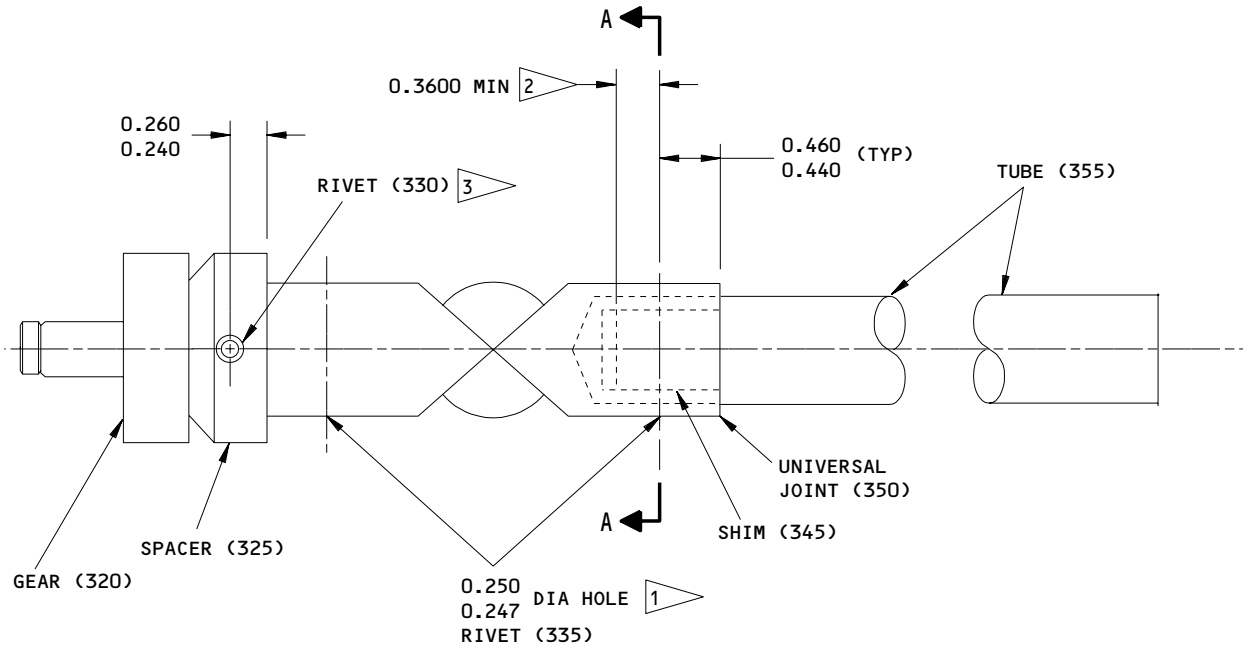
3 HEADS 0.005–0.020 BELOW SURFACE OF SPACER (325)

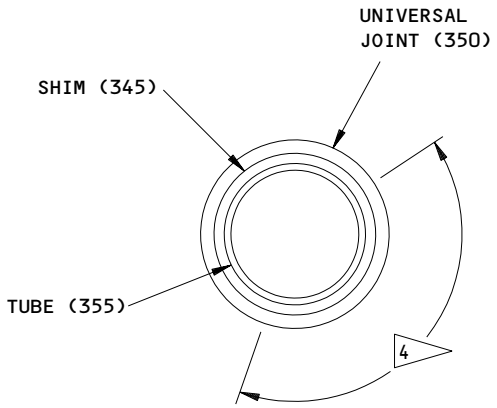
NO GAPS BETWEEN MATING PARTS UNLESS SHOWN

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

141T4865-11,-17,-22
Torque Tube Assembly Parts Replacement
Figure 601





A-A

1 INCREASE THE HOLE TO 0.254-0.265 DIAMETER IF RIVET (355A) IS USED

2 MAKE SURE YOU CAN SEE THE TUBE THROUGH ANY PART OF THE INSPECTION HOLE. KEEP THE MINIMUM END MARGIN DIMENSION AS SHOWN

3 HEADS 0.005-0.020 BELOW SURFACE OF SPACER (325)

4 LOCATION OF INSPECTION HOLE

NO GAPS BETWEEN MATING PARTS UNLESS SHOWN

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

141T4865-28
Torque Tube Assembly Parts Replacement
Figure 602

419303

ASSEMBLY

CAUTION: DO NOT TIGHTEN SCREWS NAS1802-3-9 OR NAS1802-06-9 UNLESS IT IS WHEN YOU INSTALL THE WIRE BUNDLE INSTALLATION. DAMAGE TO SENSOR E1190-14 COULD OCCUR BECAUSE OF INCORRECTLY TIGHTENED SCREWS.

1. Materials

NOTE: Equivalent substitutes can be used.

A. Adhesives (SOPM 20-60-04)

(1) PS-30

(2) RTV157

B. Compound, Retaining -- Loctite, Grade B (SOPM 20-60-04)

C. Primer -- Lockquic, Grade T (SOPM 20-60-04)

D. Grease -- BMS 3-33 or MIL-G-23827 (SOPM 20-60-03)

E. Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

F. Sealants (SOPM 20-60-04)

(1) BMS 5-95

(2) PR 1425

G. Enamel -- BMS 10-83, Type 3 (SOPM 20-60-02)

2. Assembly (IPL Fig. 1)

A. Use standard industry practices and these steps.

CAUTION: GEAR HOUSINGS (460, 470), HOUSINGS (460A, 470A), HOUSINGS (465, 475), AND HOUSINGS (465A, 475A) ARE MATCHED SETS AND MUST BE KEPT TOGETHER FOR CORRECT OPERATION AFTER ASSEMBLY.

B. Bond terminal caps (585, 590, 682J, 682L, 682T) to terminals (595, 600, 683, 683C) as shown in REPAIR 3-2, par. 1.

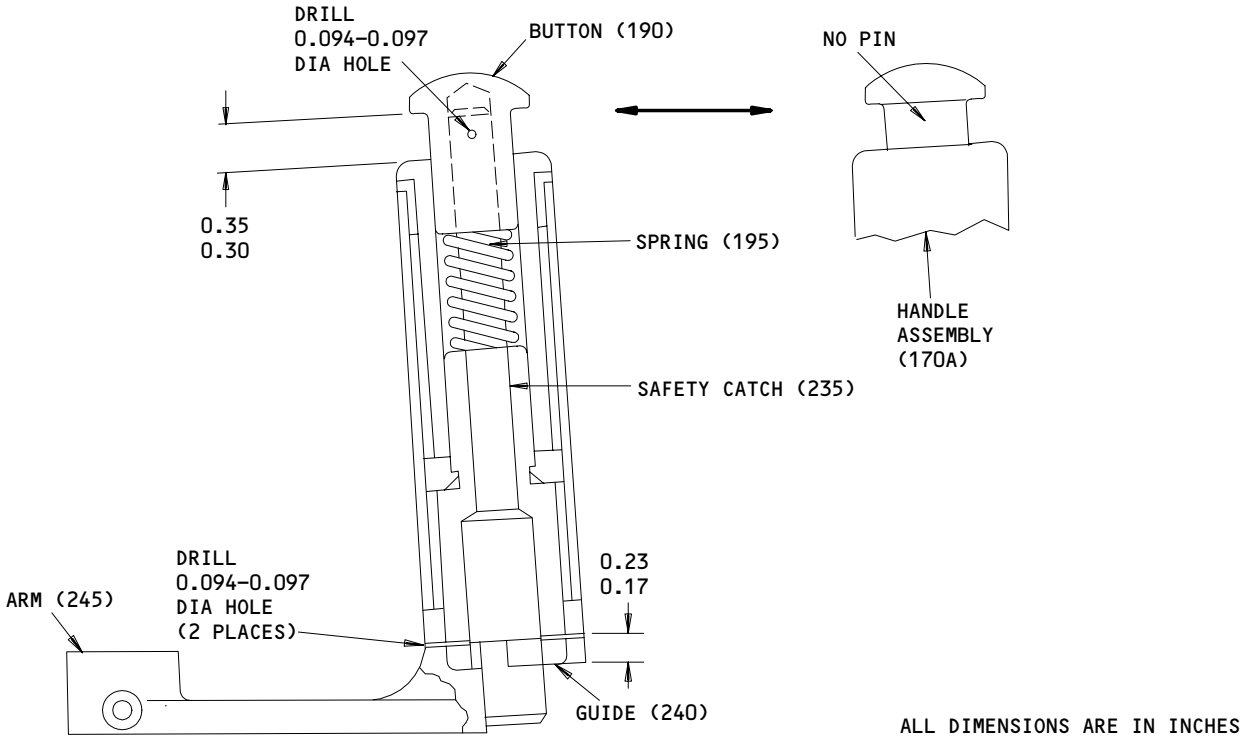
C. Apply fay surface sealant BMS 5-95 on all of the mating surface between rub strip (532H) and frame assembly (615A thru 615E, 615G, 617 thru 617B, 620A thru 620E, 620G, 622 thru 622B).

D. Press fit lower guide (240) into crank arm (245) with safety catch (235) in position shown in Fig. 701. Drill two holes in line through arm (245) and guide (240) only, angular location optional. Install pins (228) to flush (+0.00 - 0.02) with arm (245) surface.

NOTE: Assembly instructions steps D. thru I. are for the 141T14859-2 handle (170). For assembly instructions for the Avibank 9332-series handles, refer to the vendor's instructions.

E. If necessary, apply replacement decals (133, 134) to position indicator (132) (SOPM 20-50-05).

F. Apply BMS 5-95 sealant between washer (200) and crank arm (245) until sealant comes out between the washer (200) and crank arm (245). Remove unwanted sealant.



Spring Pin Installation - Handle Assembly (170)
Figure 701

2363

G. Apply grease to interior surfaces of grip assembly (210) and mating surfaces of bushings (205, 220). Also apply grease to unthreaded interior surface of upper guide (225), mating surface of button (190), grip (210), and all accessible surfaces of safety catch (235).

H. With washer (200), bushing (205), and grip (210) in place on lever assembly (230), thread upper guide (225) onto lower guide (240) with Loctite primer and compound on threads. Hand tighten upper guide (225) against bushing (205).

I. With safety catch (235) in the up position as shown (Fig. 701), install spring (195) and button (190) over extruded end of safety catch shaft. Drill the safety catch shaft with button (190) in the position as shown (Fig. 701) and install spring pin (185).

J. Refer to par. W below for installation and adjustment of the latch release system (135, 137).

NOTE: Items (250A, 252, 260) are not installed until the window assembly is installed in the airplane.

K. Attach handle assembly (170) to latch release system (135, 137) with rivet (175) or spring pin (176). If necessary, drill 0.187-0.192 inch diameter hole thru handle assy (170) and latch release system (135, 137). Use hole locations in handle assy (170). Install spring pins (176). Cover ends of spring pins (176), and fill the countersink with BMS 5-95 sealant. Make the sealant smooth and flush with handle assy (170). Apply BMS 10-83, Type 3 dark brown enamel (F-22.32-8924) over sealant.

L. Apply Locquic primer and Loctite compound to bolt (25, 27) and cam follower (20).

M. Tighten cam follower (20) to 100-125 pound-inches.

N. Tighten hex drive bolt (25, 27) to 18-33 pound-inches.

O. Apply Locquic primer and Loctite compound to the threads of cam roller (294).

P. Tighten nut (495) on bolt (485) to 15-20 pound-inches.

Q. Install shims (380) between gear housing (460, 460A, 465, 465A, 470, 470A, 475, 475A) and frame assembly (615A, 617, 620A, 622, 683H, 683M) as necessary, with BMS 10-11 primer on mating surfaces.

R. Apply faying surface seal of BMS 5-95 sealant between window assembly (525B, 530B) and plates (67, 684W, 685).

S. Find the shim and washer thickness for bearing (122A), roller - cam bearing (250A), carriage assembly (10), and the location of bracket (120, 121) relative to its serrated mounting plate as follows:

NOTE: Make replacement washers and shims from the dimensions you found during disassembly.

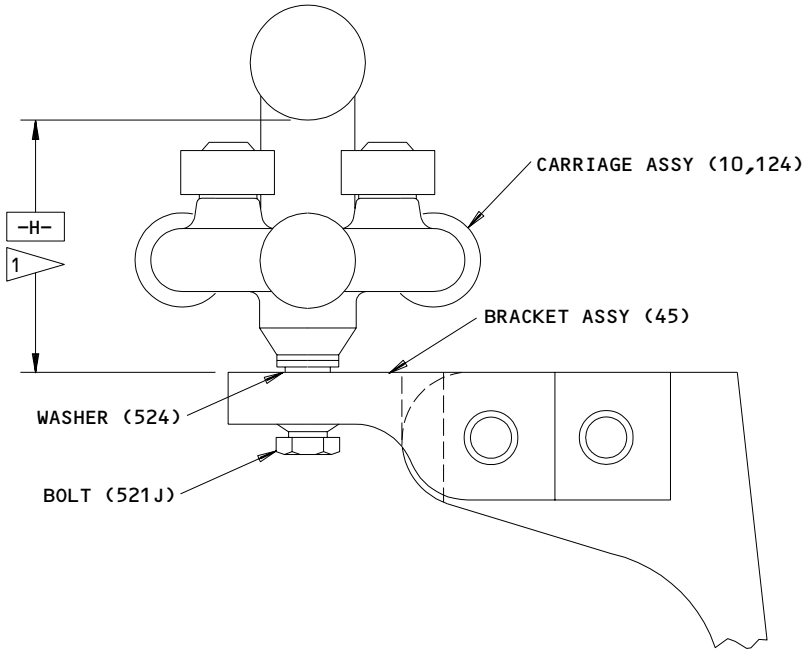
(1) Put bearings (122A, 250A, 250B, 250C, 250D) against the frame and make a note of the necessary thickness of washers (124, 257).

(2) Install a sufficient number of shims (520) to let the shim thickness be adjusted when the window is installed in the airplane.

(3) Install a sufficient number of washers (524) to let the washer thickness be adjusted when the window is installed in the airplane.

(4) Put bracket (120, 121) on frame (630A, 687A) and install bolts (76), washer (77), and nuts (78). Final adjustment of bracket will be made upon installation in airplane.

T. Install carriage assy (10) per Fig. 702.



WINDOW	CARRIAGE	-H-
015T0195-() 141T0012-()	141T4855-4	1.970 1.910 1
141T4835-()	141T4855-4	1.970 1.910 2
	141T4855-8	1.977 1.957 2

1 REMOVE WASHERS (524) AS REQUIRED TO GET THIS DIMENSION

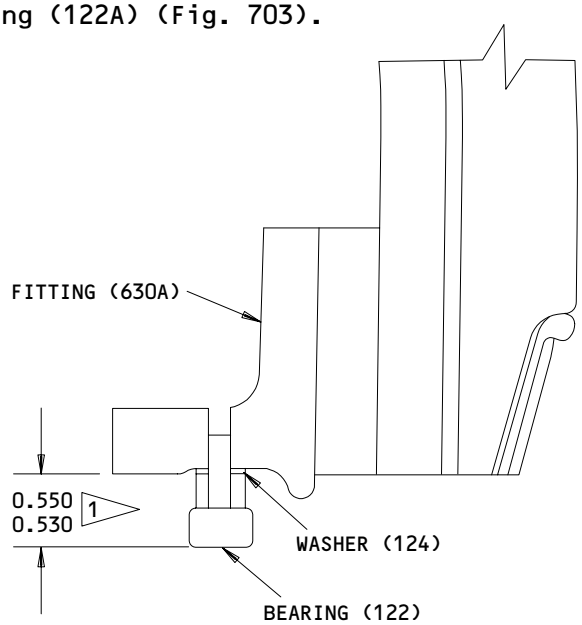
2 AJUST BOLT (521J) TO GET THIS DIMENTION

ALL DIMENSIONS ARE IN INCHES

Carriage Installation
Figure 702

153308

U. Install bearing (122A) (Fig. 703).



1 REMOVE OR DELAMINATE WASHER (124) AS REQUIRED TO MAINTAIN THIS DIMENSION. APPLY ONE COAT PRIMER, BMS 10-11, TYPE 1 TO WASHER AFTER DELAMINATION

ALL DIMENSIONS ARE IN INCHES

Roller Installation
Figure 703

153309

V. Install latch cams (Fig. 704).

NOTE: These procedures start from scratch with basic shim packs. If you use the shims and washers that came with the window, you can start with them and make adjustments as necessary.

(1) Apply BMS 3-33 or MIL-G-23827 grease on the indicated mating surfaces.

(2) Install each latch cam without the S141T492 shim pack of the AN960C816L washer. If the latch cam does not go through the latch cam control box easily, loosen the fasteners that attach the box to the window frame. After you get the latch cam in, gradually tighten each fastener as you slowly turn the latch cam.

(3) Install a short piece of S141T492 cable, approximately 6 inches long and visually straight into either cable access opening in the latch cam control box and engage the teeth of the latch cam. Turn the latch cam a small amount, if necessary, to help engage the cable with the cam.

(4) Push the cable through until it extends approximately the same from each side of the box.

(5) Inside shims

(a) With the cable engaged, apply a light force to the latch cam as shown.

(b) With a feeler gage, measure the gap between the window frame and the latch cam, as shown.

(c) Install the S141T492 shim package and an AN960C816L washer (to make the inside shim stack) as shown.

(d) Push on the latch cam with your hand as shown. Turn the cable several turns to screw the cable through the box. Make sure the cable turns freely. If the cable does not turn freely, increase the thickness of the shim package by 0.01-inch increments until the cable does turn freely.

(6) Outside shims

(a) With the cable engaged as before, and the inside shims in position, apply a light force to the latch cam in the direction shown.

(b) With a feeler gage, measure the gap between the window frame and the latch cam, as shown.

(c) Install the S141T492 shim package and an AN960C816L washer (to make the outside shim stack) as shown.

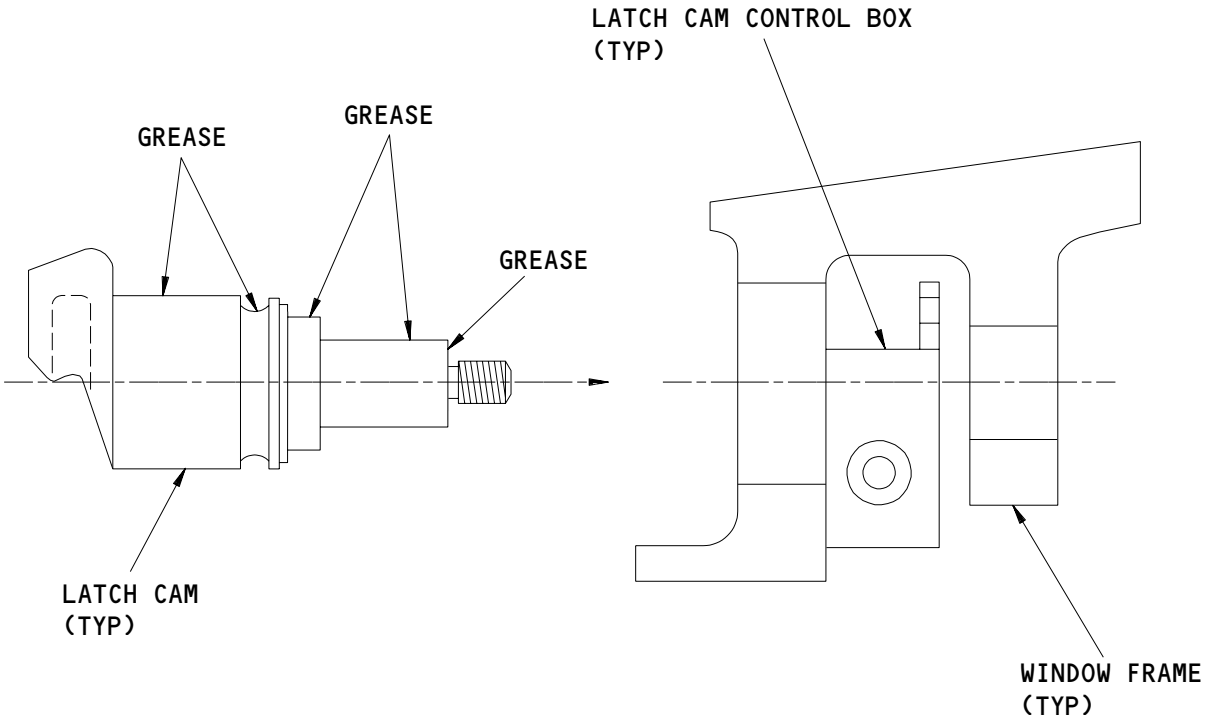
(d) Remove the piece of cable from the unit.

(e) Install the S141T492 washer over the threads of the latch cam. On the upper forward cam, be sure to first also install position indicator (130).

(f) Install the S141T492 nut. Slowly and gradually tighten the nut to 30-50 pound-inches. While you do this, make sure the shim stack is correctly against the shaft bearing surface of the cam, and that the latch cam turns freely until the nut is finally tight. If the cam does not turn freely, remove the nut and decrease the shim thickness by 0.01 inch.

(g) Do this until the latch cam turns freely with the nut fully tightened.

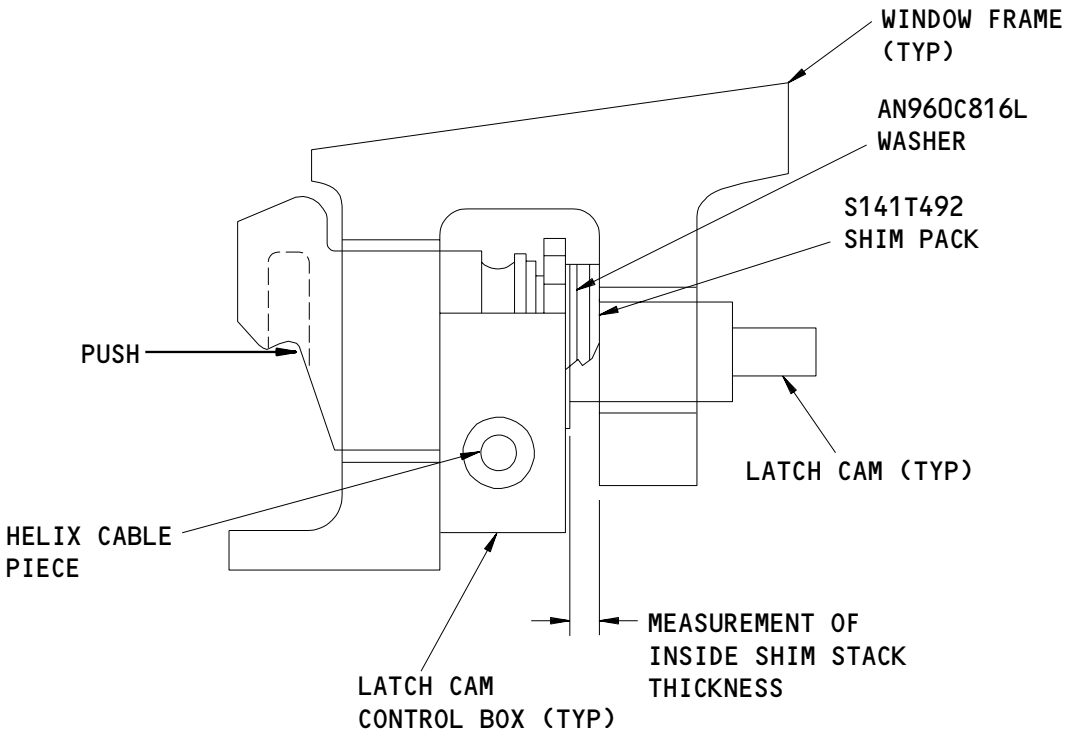
(h) Now put the piece of cable back into the box and engage the cam. Apply a heavy hand load to the latch cam in the direction shown. Turn the cable several turns to screw the cable through the box. Make sure the cable turns freely. If the cable does not turn easily through the box, increase the thickness of the outside shim stack in 0.01 inch increments until the cable turns freely. If the latch cam now does not turn freely, a decrease of the inside shim thickness could be necessary.



LATCH CAM READY TO GO INTO WINDOW FRAME

Latch Cam Installation
Figure 704 (Sheet 1)

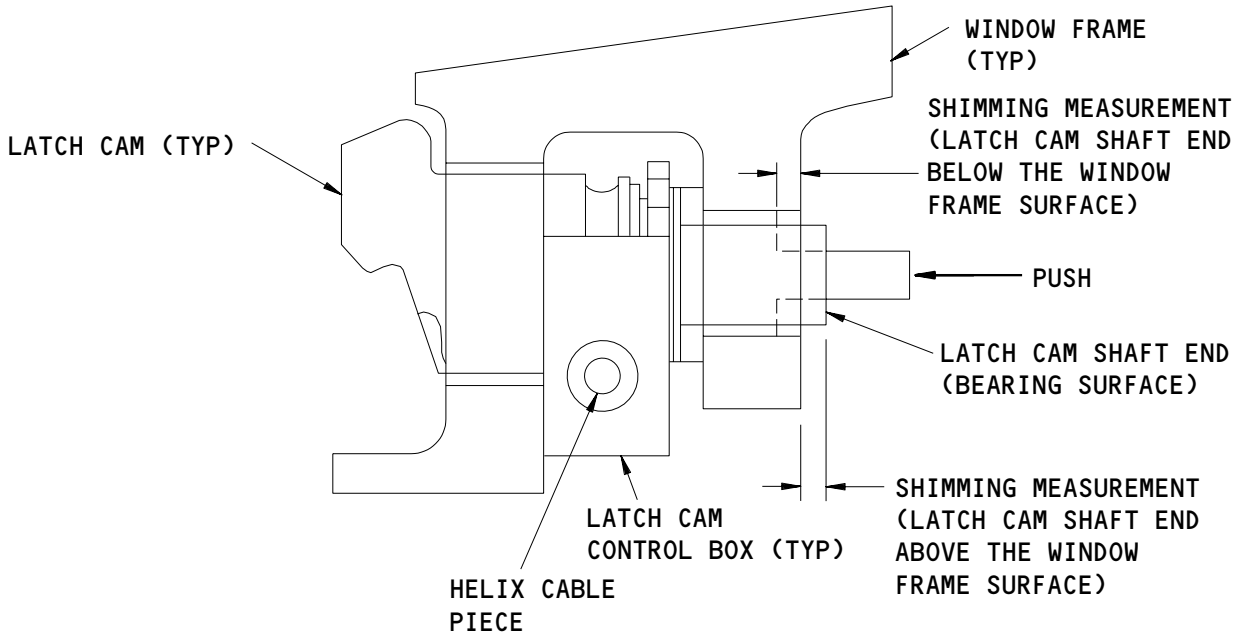
MD4524



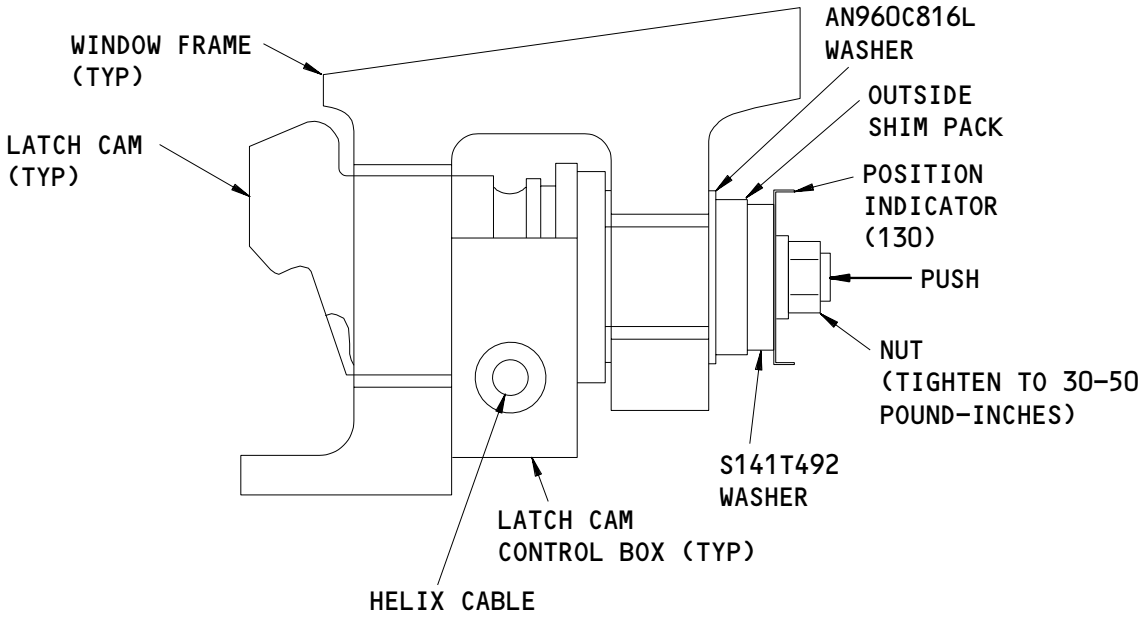
INSIDE SHIM STACK THICKNESS ADJUSTMENTS

Latch Cam Installation
Figure 704 (Sheet 2)

MD4539



OUTSIDE SHIM STACK THICKNESS ADJUSTMENTS



LATCH CAM INSTALLED

Latch Cam Installation
Figure 704 (Sheet 3)

MD4546

W. Latch Cam Helix Cable Assembly

(1) Put each cam in the closed position and make an index mark (Fig. 705, Fig. 706). Lubricate the cable mating surface with grease.

(2) Remove the lockwire from the input control box. Loosen the forward fitting and remove the lower forward cable casing. Do not remove lower cable casing (Fig. 707).

(3) Put the mark you made on handle (170, 170A) approximately 180 degrees from the index mark on the control box.

CAUTION: FEED THE CABLE IN SLOWLY. IF YOU FEED THE CABLE IN TOO FAST THE CABLE OR OTHER COMPONENTS COULD BE DAMAGED.

(4) Lubricate the cable and the mating surface of the input control box with grease. Put the cable thru the end of the lower cable casing until it comes to the input control box.

(5) To engage the cable, carefully turn the handle in the direction which will pull the cable into the control box. Continue to turn the handle until the index marks align.

(6) Thread or turn the cable as necessary into the input control box until the cable starts to come out from the end of control box with index marks aligned.

(7) Align the index marks on the lower forward cam.

(8) Push the cable thru all four latch cams with the input control box on the cable.

(9) Put the input control box in its correct location on the window. Make sure the handle is in the latched position. Make sure the cable end starts to come out from the input control box.

(10) Make a note of the position of the lower forward cam from the index mark on window.

(11) Pull the cable from all four cams with the input control box on the cable. Make sure the handle box stays on the cable.

(12) Move the cam to a position that will align the cam index marks, when you do the next step, when the input control box is moved again to its correct location on thewindow.

(13) Push the cable thru all four latch cams with the handle box on the cable. Do steps 11 and 12 again as necessary to align the index marks. After you do this, always be sure the end of the cable starts to come out from the input control box.

(14) Pull the cable from the three cams upstream of the cam which was correctly aligned.

(15) Align the index marks on the next cam upstream of the correctly aligned cam.

(16) Do steps (8) and (9) again.

(17) Do the above procedure for the remaining cams.

(18) Install fasteners (142) to hold the input control box after all cams are in the correct position (Fig. 707) and the cable starts to come from the input control box.

(19) Move the latch handle from closed to open to closed six times.

(20) Make a check of the latch cam positions (Fig. 706) and that the end of the cable starts to come from the input control box.

(21) If applicable, release the latch hook (247A, 247J) that is at the lower aft latch cam (Fig. 706).

(22) Turn handle (170) to the open position and make sure the latch hook engages.

(23) Do a test of the latch cam system as follows:

(a) Put the handle in open position. Make sure the latch position indicator clearly shows "open" (Fig. 705).

(b) Turn the latch handle towards the closed position.

(c) If the window has the latch lock hook, make sure the latch handle turns from the open position and then stops.

(d) If applicable, push the latch hook (247A, 247J) down and turn the handle to the closed position. Make sure the latch position indicator clearly shows "closed".

(e) At each position (open-closed):

1) The latch position indicator must clearly show the correct position of the handle.

2) All four cams must be within the indexed range when the handle is in the closed position (Fig. 706).

3) The latch handle must turn smoothly in both directions with the handle load not more than 5 pounds.

4) The cable end must come out a small amount from the exposed end of the input control box when the handle is in the closed position.

(24) If necessary, use shims (164) between the striker brackets and the window frame to adjust the alignment between the latch system handle and the striker brackets.

(a) On passenger units 141T4845-1, -2, -15, -16, -501, -502:

1) The handle must lock into the open or closed position without a push on the handle button.

2) The handle must not release from the locked-open or locked-closed position until the handle button is pushed.

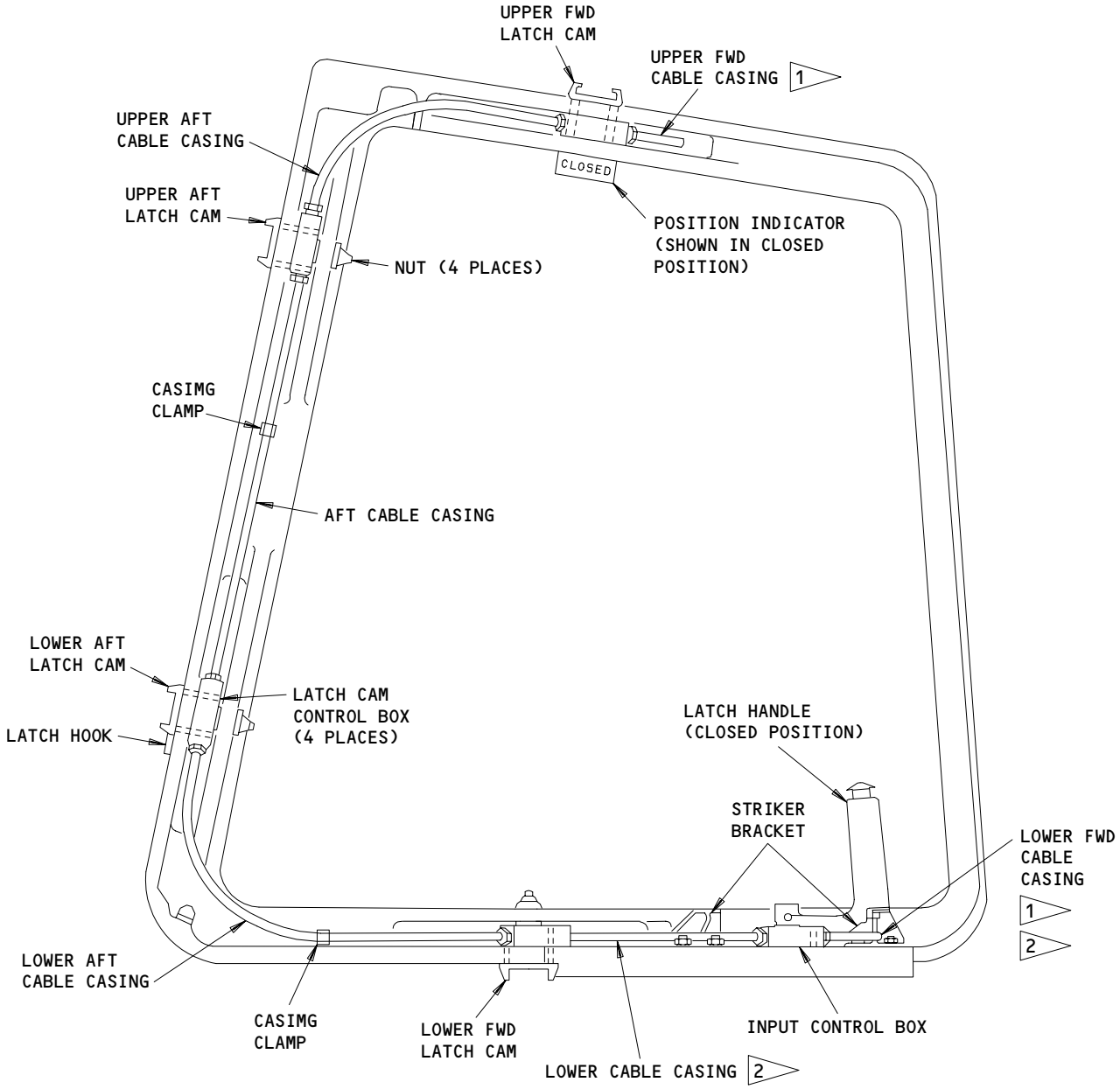
(b) On freighter units 141T4845-26, -33, the handle must engage and disengage the two striker brackets without a push on the handle button.

(c) Remove laminations from the shims as necessary. Install the shims with BMS 10-11 type 1 primer.

(25) Install the lower forward cable casing. Tighten the attach fittings to 35-40 pound-inches (Fig. 705) on the input control box and the lower forward cam box.

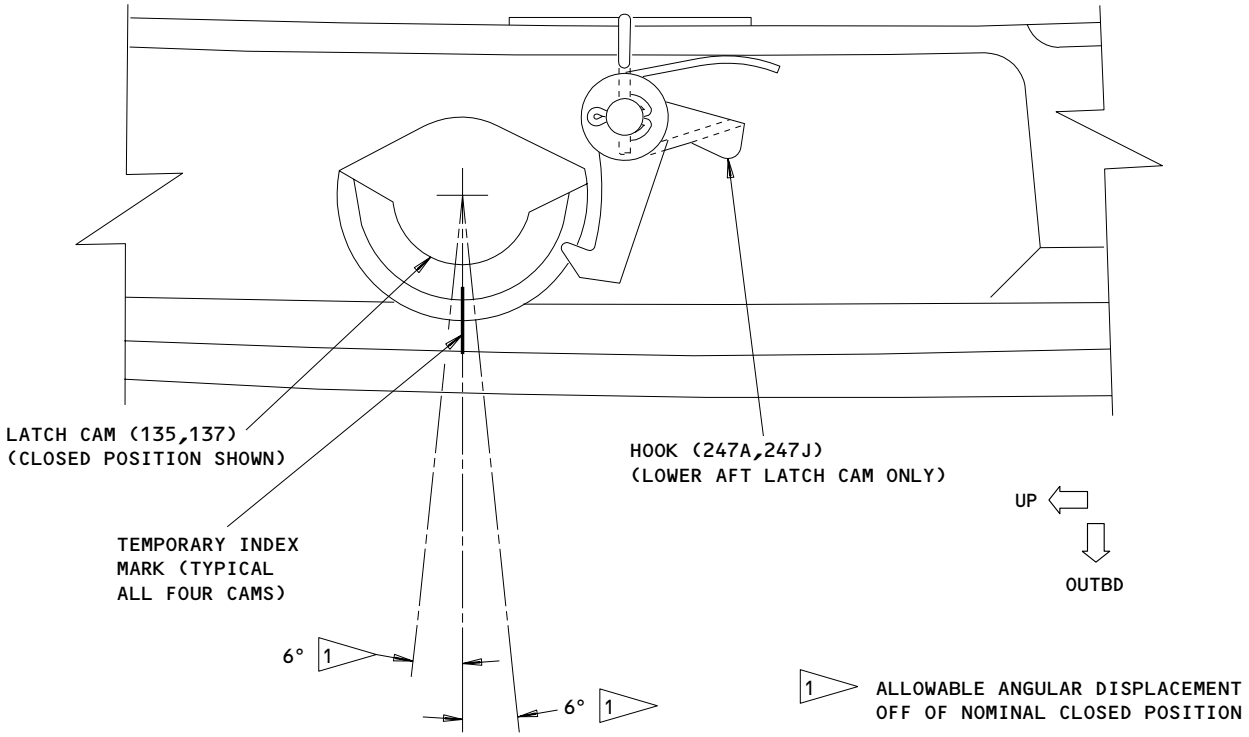
(26) Lockwire the attach fittings.

(27) Give protection to the window and put it away by standard industry practices and the instructions in SOPM 20-44-02 and 20-70-01.



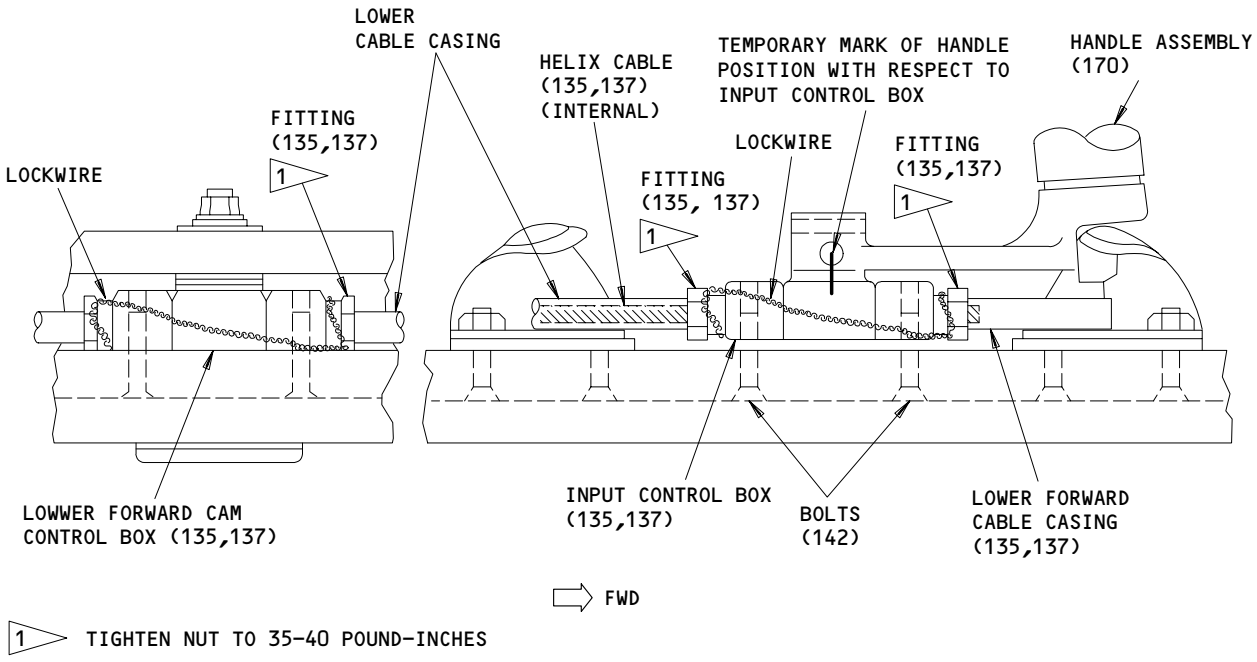
Latch Cam Helix Cable Assembly
Figure 705

200293



Latch Cam Helix Cable Assembly
Figure 706

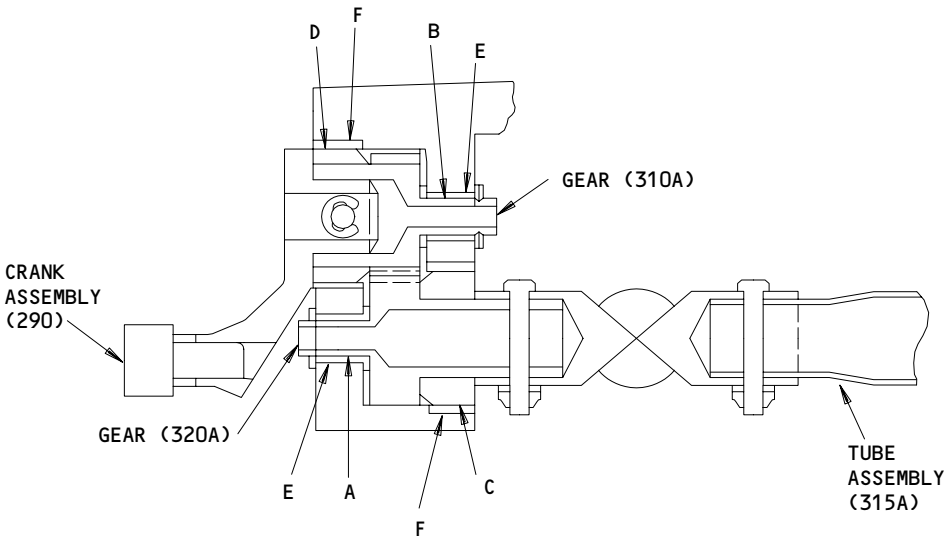
200303

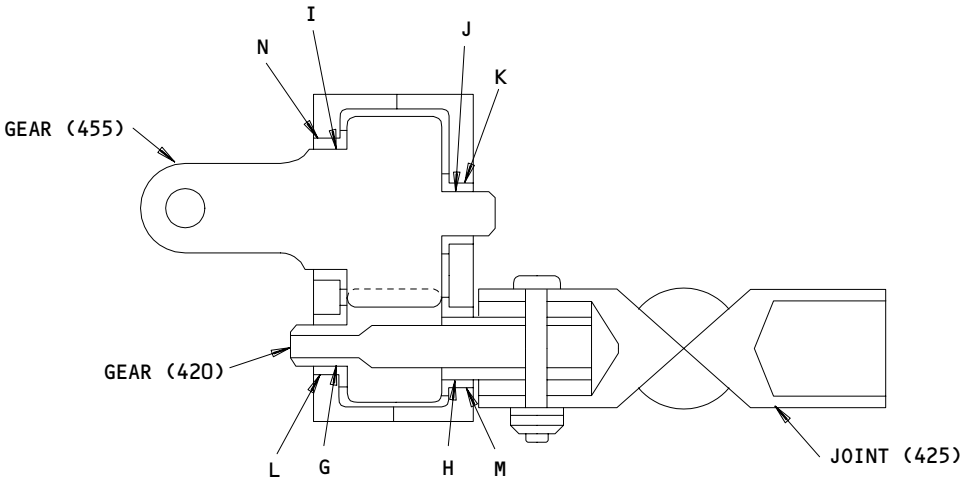


Latch Cam Helix Cable Assembly
Figure 707

195150

FITS AND CLEARANCES





Fits and Clearances
Figure 801 (Sheet 1)

REF LETTER FIG. 801	MATING ITEM NO. IPL FIG. 1	DESIGN DIMENSION				SERVICE WEAR LIMIT		
		DIMENSION		ASSEMBLY CLEARANCE 1		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
A	ID 640B OD 320A	0.3750 0.3730	0.3760 0.3740	0.0010	0.0030	0.3700	0.3800	0.0040
B	ID 640B OD 310A	0.3750 0.3730	0.3760 0.3740	0.0010	0.0030	0.3700	0.3800	0.0040
C	ID 645 OD 325	1.3800 1.3780	1.3810 1.3790	0.0010	0.0030	1.3760	1.3840	0.0050
D	ID 645 OD 295	1.3800 1.3780	1.3810 1.3790	0.0010	0.0030	1.3760	1.3840	0.0050
E	ID 630A, 635A OD 640B	0.5000 0.5006	0.5006 0.5013	-0.0013	0.0000			
F	ID 630A, 635A OD 645	1.5625 1.5639	1.5633 1.5649	-0.0024	-0.0006			
G	ID 400 OD 420	0.3750 0.3730	0.3765 0.3740	0.0010	0.0035	0.3700	0.3795	0.0060
H	ID 405 OD 420	0.5625 0.5605	0.5640 0.5615	0.0010	0.0035	0.5575	0.5670	0.0060
I	ID 445 OD 455	1.0000 0.9985	1.0015 0.9995	0.0005	0.0030	0.9955	1.0045	0.0060
J	ID 440 OD 455	0.3750 0.3730	0.3765 0.3740	0.0010	0.0035	0.3700	0.3795	0.0060

Fits and Clearances
Figure 801 (Sheet 2)

92240

REF LETTER	REF IPL FIG. 1, MATING ITEM NO.	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE 1		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
K	ID 460,465 OD 440	0.5006 0.5006	0.5013 0.5013	-0.0007	0.0007			
L	ID 470,475 OD 400	0.5006 0.5006	0.5013 0.5013	-0.0007	0.0007			
M	ID 460,465 OD 405	0.6882 0.6882	0.6892 0.6892	-0.0010	0.0010			
N	ID 470,475 OD 445	1.1888 1.1888	1.1898 1.1898	-0.0010	0.0010			

* ALL DIMENSIONS ARE IN INCHES

1 NEGATIVE VALUES ARE IN INTERFERENCE FIT

Fits and Clearances
Figure 801 (Sheet 3)

92241

REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	20	FOLLOWER	100-125	
1	25,27	BOLT	18-33	
1	495	NUT	15-20	
1	545A,680J	BOLT	30-50	
1	1	JAMNUT	660-780	

* REFER TO SOPM 20-50-01 FOR TORQUE VALUES OF STANDARD FASTENERS.

1 JAMNUT PART OF LINK ASSEMBLY (480C)

Torque Table
Figure 802

E96826

SPECIAL TOOLS, FIXTURES AND EQUIPMENT

NOTE: Equivalent substitutes can be used.

1. A56004-50 -- No. 2 Window Assembly tool (used only with liquid shim method).

ILLUSTRATED PARTS LIST

1. This section lists and illustrates replaceable or repairable component parts. The Illustrated Parts Catalog contains a complete explanation of the Boeing part numbering system.

2. Indentures show parts relationships as follows:

    Assembly
      Detail Parts for Assembly
      Subassembly
      Attaching Parts for Subassembly
        Detail Parts for Subassembly

    Detail Installation Parts (Included only if installation parts may be returned to shop as part of assembly)

3. One use code letter (A, B, C, etc.) is assigned in the EFF CODE column for each variation of top assembly. All listed parts are used on all top assemblies except when limitations are shown by use code letter opposite individual part entries.

4. Letter suffixes (alpha-variants) are added to item numbers for optional parts, Service Bulletin modification parts, configuration differences (except left- and right-hand parts), product improvement parts, and parts added between two sequential item numbers. The alpha-variant is not shown on illustrations when appearance and location of all variants of the part is the same.

5. Service Bulletin modifications are shown by the notations PRE SB XXXX and POST SB XXXX.

    A. When a new top assembly part number is assigned by Service Bulletin, the notations appear at the top assembly level only. The configuration differences at detail part level are then shown by use code letter.

    B. When the top assembly part number is not changed by the Service Bulletin, the notations appear at the detail part level.

6. Parts Interchangeability

Optional (OPT)	The parts are optional to and interchangeable with other parts having the same item number.
Supersedes, Superseded By (SUPSDS, SUPSD BY)	The part supersedes and is not interchangeable with the original part.
Replaces, Replaced By (REPLS, REPLD BY)	The part replaces and is interchangeable with, or is an alternate to, the original part.

VENDORS

0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SPO BOX 18459 KEARNS, UTAH 84118
05693	CHERRY/TEXTRON INC CHERRY COMMERCIAL FASTENERS PROD DIV 1224 EAST WARNER STREET PO BOX 2157 SANTA ANA, CALIFORNIA 92707-3149
06710	LAMSON AND SESSIONS CO THE VALLEY-TODECO 12975 BRADLEY AVENUE SYLMAR, CALIFORNIA 91342-3830
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932
07484	ACCURATE BUSHING CO INC 443 NORTH AVENUE GARWOOD, NEW JERSEY 07027-1014
08524	DEUTSCH FASTENER CORP SEE CODE V97928
08730	VEMALINE PRODUCTS DIV OF SQUARE HEAD INC 333 STRAWBERRY FIELD ROAD PO BOX 6979 WARWICK, RHODE ISLAND 02887-6979
11346	SEE V04638
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157
12035	SIERRACIN-SYLMAR 12780 SAN FERNANDO ROAD SYLMAR, CALIFORNIA 91342-3728

VENDORS

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

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

18076 UMPCO, INCORPORATED
7100 LAMPSON AVENUE PO BOX 5158
GARDEN GROVE, CALIFORNIA 92645

27238 BRISTOL INDUSTRIES
630 EAST LAMBERT ROAD PO BOX 630
BREA, CALIFORNIA 92621-4119

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

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

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

53117 PPG INDUSTRIES INC
CENRAL BANK BLDG SUITE 777
HUNTSVILLE, ALABAMA 35801-4816

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

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

VENDORS

60516 WEST COAST AEROSPACE INC
812 MIRAFLORES STREET
SAN PEDRO, CALIFORNIA 90731-1439

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

72285 EXACTO IND INC SEE V83930

72962 ELASTIC STOP NUT A DIV OF HARTFORD INDUSTRIES INC
2330 VAUXHALL ROAD
UNION, NEW JERSEY 07083-5038

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

78710 TELEFLEX INC AEROSPACE DEFENSE DIV
CHURCH ROAD PO BOX 218
NORTH WALES, PENNSYLVANIA 19454

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

83930 IMO DELAVAL INC ADEL FASTENERS DIV
1444 WASHINGTON AVENUE PO BOX 7727
HUNTINGTON, WEST VIRGINIA 25778

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

84971 TA MANUFACTURING CORP SUB OF CRITON CORP
375 WEST ARDEN AVENUE PO BOX 2500
GLENDALE, CALIFORNIA 91209-2500

VENDORS

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

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

97613 SARGENT TECHNOLOGIES
1851 SOUTH PANTANO ROAD
TUCSON, ARIZONA 85710

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

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ABYT4-108		1	55H	1
ABYT5		1	55D	
ABYT5-109		1	55F	1
ABYT5H		1	55E	1
ADBY4		1	55	1
ADBY5		1	55B	
AN960-10		1	77	4
AN960-416		1	42	2
AN960-416L		1	700	2
AN960-516L		1	490	1
AN960C10L		1	30	4
		1	32	1
		1	33	1
		1	162	
AN960C616		1	15	1
AN960JD10		1	147A	
AN960JD10L		1	124A	AR
AN960JD10LL		1	66C	
		1	740	
		1	121P	
		1	124B	
		1	262A	
AN960JD516		1	255A	AR
AN960JD516L		1	257A	AR
AN960PD10		1	147	3
		1	394	1
		1	499G	1
AN960PD10L		1	124	AR
		1	262	2
AN960PD416L		1	499	1
AN960PD516		1	255	AR
AN960PD516L		1	257	AR
BACB10AF3K4HS		1	122C	
BACB10AF3N4HS		1	122D	1
BACB10ET03		1	35	4
		1	37	1
		1	37J	1
BACB10FKGF1HS		1	20A	
BACB10FK3N4HS		1	122E	1
BACB10FK6F1HS		1	20B	1
BACB10FK6F4HS		1	80A	1
BACB28AK06-015		1	293	1
BACB28AK07-008		1	245W	1
BACB28U22B050		1	645	2
		1	684J	2
BACB28U8B048		1	531	4
		1	684K	4

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB28W6B049		1	640B	2
		1	684H	2
BACB28X16C019		1	445A	1
BACB28X16C020		1	445	1
BACB28X6C019		1	400A	1
		1	440A	1
BACB28X6C020		1	400	1
		1	440	1
BACB28X9C019		1	405A	1
BACB28X9C020		1	405	1
BACB28Y4E026		1	728	1
BACB28Z9-090		1	410	1
BACB30FM8A13		1	108	1
BACB30FM8A8		1	710C	1
BACB30LH3-10		1	146H	
BACB30LH3-7		1	142A	
BACB30LH3-9		1	160A	
BACB30LR3U10		1	160	4
		1	146G	1
BACB30LR3U7		1	142	10
BACB30LU3-10		1	261	2
BACB30LU3-7		1	261A	2
BACB30MB6A5U		1	25	4
		1	27	1
BACB30MY6K21		1	392	1
BACB30NM3K5		1	28	1
BACB30NM3K9		1	146	1
BACB30NN4K27		1	545A	79
		1	680J	79
BACB30NU4K8		1	695	2
BACB30NW6K18)		1	375	3
BACB30PF4-14		1	498	1
BACB30US4K14		1	41A	1
BACB30US4K16		1	41K	1
BACB30VF4K8		1	695A	
BACB30VT6K7		1	76	4
BACB30VT8K12		1	41	1
BACB30VT8K14		1	41J	1
BACC10DW5		1	149	
BACC10DW5D		1	149A	2
BACC30M6		1	385	3
BACN10GW4AS		1	705	2
BACN10HR4CD		1	43A	2
BACN10JC3CD		1	263M	2
BACN10JC3CM		1	78	4
		1	148	2
		1	396	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACN10JC4		1	115	1
BACN10JC4C		1	725A	1
BACN10JC4CM		1	43	2
BACN10JD105		1	260	1
BACN10JD105ASU		1	495	1
BACN10JD106		1	90	1
BACN10JN3		1	655	6
		1	66W	2
		1	684Q	6
BACN10JR3F		1	657	4
		1	684R	5
BACN10KE3D		1	684S	1
BACP18BC02A06P		1	245K	1
BACP18BC02C08P		1	252A	1
BACR15BA3		1	66V	4
BACR15BA3AD		1	68	2
		1	653	16
		1	684N	20
BACR15BA4AD		1	330	1
BACR15BB3AD		1	654	6
		1	684P	8
BACR15CE4AD		1	684Y	8
BACR15CE4D		1	532J	8
BACR15CE5M15		1	175	2
BACS18G43B3		1	670A	1
BACS18G47B3		1	672	1
		1	680	
BACS18G50B3		1	665	2
		1	684T	2
BACS18G55B3		1	684U	1
BACS18G60B3		1	684V	2
BACS40R008B020F		1	164A	AR
BACS40R009U016		1	345	1
		1	352	1
BACS40R010C018F		1	520A	2
BACS40R018B023F		1	69K	AR
BACS40R018C023F		1	69A	AR
BACS40R08B20F		1	164	AR
BACS40R10W18		1	520	2
BACS40R13B15F		1	380	2
BACS40R18U23		1	69J	AR
BACS40R18W23		1	69	AR
BACW10BP4ACU		1	522	1
		1	522A	
BACW10BP4C		1	41R	2
BACW10BP4CD		1	522B	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACW10BP4DP		1	524K	AR
		1	524S	
BACW10BP4P		1	110	1
		1	42A	2
BACW10BP4PTU		1	524R	
BACW10BP5CD		1	521N	1
BACW10BP6P		1	85	1
BACW10P250C		1	523A	1
BACW10P32C		1	245T	AR
BACW10P32CC		1	245U	1
BACW10UC103P		1	263	2
BAC27TBY0007		1	133	1
BAC27TBY0008		1	134	1
BM835-2		1	66A	1
BRFM20A3		1	684Q	6
BRF200A3		1	684R	5
B0500-038		1	506	
CCF3-4S		1	294	1
CR7-8-86		1	80	1
CR7-8-87		1	20	1
CSR925-8		1	266	1
CSR925-8-16		1	266A	1
		1	390A	
CSR925-8-16R		1	335	2
CSR925-8-22		1	335B	2
		1	390B	1
E1190-14		1	605	1
		1	610	1
		1	683E	1
		1	683G	1
F5000-3BAC		1	684R	5
F51754-3		1	684S	1
HL440UC8-10		1	710B	
H10-3BAC		1	263J	
H52732-3CD		1	148A	
		1	165A	
		1	263L	
H52732-4CD		1	705B	
KDSY5-22		1	55G	1
KRP119105VT		1	250B	1
		1	250D	1
KSBY4		1	55A	1
KSBY5		1	55C	
MF1000-3BAC		1	684Q	6
		1	684Q	6
MF53049-3		1	684Q	6
MS16562-21		1	228	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
MS16562-236		1	176	2
MS16562-26		1	185	1
MS16633-4025		1	305	1
MS16633-4037		1	360	2
MS20270B16		1	350	1
		1	425	1
MS20615-8M16		1	266B	1
		1	335C	2
MS20615-8M22		1	390	1
		1	335A	2
MS21042L3		1	263K	2
MS21042L4		1	705A	2
MS21043-4		1	725	
MS21209F1-15		1	650	4
		1	684L	4
MS21209F1-20		1	652	1
		1	684M	1
MS21209F4-15		1	625	79
		1	683V	79
MS21432-3R4A		1	122A	1
		1	122B	1
MS24585-1362		1	195	1
MS24665-1013		1	497	1
MS24665-136		1	252	1
MS24665-153		1	245J	1
MS24665-287		1	83	1
MS35333-38		1	676B	4
MS35333-39		1	678B	2
MS35338-41		1	676A	4
MS35338-43		1	678A	2
NAS1056E10-025		1	253	1
NAS1056E6-029		1	123	1
NAS1149D0316J		1	262B	2
NAS1149D0516J		1	257B	AR
NAS1149D0563J		1	255B	AR
NAS1149F0363P		1	77A	4
NAS1149F0463P		1	42B	2
NAS1193K5CP		1	521V	1
NAS1423-5		1	521R	2
NAS1802-06-9		1	673	2
NAS1802-3-9		1	674	4
NAS1804-3		1	499J	1
NAS1805-3		1	165	4
NAS43DD4-25		1	105	1
NAS43DD5-116		1	580	79
		1	682G	79
NAS43DD5-116FC		2	60	79

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NAS514P1032-16		1	66M	4
NAS620C416L		1	720	1
NAS6305D16		1	485	1
NAS6603-6		1	121L	
NAS6603-7		1	735	
		1	76A	4
		1	121K	
NAS6603-9		1	66B	
NAS6604P11		1	521B	1
NAS6704P11		1	521A	
NS103193-02		1	660	1
		1	684S	1
NS103203-02		1	684R	5
NS103218-02		1	684Q	6
PSE2-1		2	95	1
		2	100	1
RMF9201-3		1	684R	5
RMF9201M3		1	684Q	6
S141T492-1		1	135	1
S141T492-2		1	137	1
S141T492-4		1	137A	
		1	137B	1
T8091S1032		1	684R	5
VN152A1-02		1	684R	5
VN252A02		1	684Q	6
015T0195-10		1	5J	RF
015T0195-11		1	10	RF
015T0195-12		1	50	RF
015T0195-13		1	1U	RF
015T0195-14		1	5T	RF
015T0195-15		1	1V	RF
015T0195-16		1	5V	RF
015T0195-7		1	1I	RF
015T0195-8		1	5I	RF
015T0195-9		1	1J	RF
141T0012-22		1	250A	1
		1	250C	1
141T0012-23		1	532H	1
141T0012-29		1	524	AR
		1	524J	AR
141T0012-36		1	532F	1
141T0012-5005		1	1A	RF
141T0012-5006		1	5A	RF
141T0012-5007		1	1B	RF
141T0012-5008		1	5B	RF
141T0012-5013		1	1C	RF
141T0012-5014		1	5C	RF

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T0012-5025		1	1D	RF
141T0012-5026		1	5D	RF
141T0012-5031		1	1F	RF
141T0012-5032		1	5F	RF
141T4001-1		1	679G	1
		2	1A	RF
141T4001-2		1	679T	1
		2	5	RF
141T4001-23		2	50	1
141T4001-24		2	55	1
141T4001-29		1	679H	1
		2	1B	RF
141T4001-30		1	679U	1
		2	5A	RF
141T4001-31		1	679J	1
		2	1C	RF
141T4001-32		1	679V	1
		2	5B	RF
141T4002-1		2	40	1
141T4002-10		2	45A	1
141T4002-11		2	30A	1
141T4002-12		2	35A	1
141T4002-13		2	20A	1
141T4002-14		2	25A	1
141T4002-15		2	10A	1
141T4002-16		2	15A	1
141T4002-2		2	45	1
141T4002-3		2	30	1
141T4002-4		2	35	1
141T4002-5		2	20	1
141T4002-6		2	25	1
141T4002-7		2	10	1
141T4002-8		2	15	1
141T4002-9		2	40A	1
141T4003-1		2	80	1
141T4003-2		2	90	1
141T4003-3		2	65	1
141T4003-4		2	75	1
141T4003-7		2	85	4
141T4003-8		2	70	2
141T4810-11		1	535A	1
141T4810-12		1	540A	1
141T4810-15		1	679	1
		1	679C	1
		1	680E	

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T4810-16		1	679L	1
		1	679P	1
		1	680G	
141T4810-17		1	679A	1
		1	680F	
141T4810-18		1	679M	1
		1	680H	
141T4810-19		1	679B	1
141T4810-20		1	679N	1
141T4810-21		1	679D	1
		1	679E	1
		1	679F	1
141T4810-22		1	679Q	1
		1	679R	1
		1	679S	1
141T4813-11		1	533A	1
		1	533C	1
141T4813-12		1	534A	1
		1	534C	1
141T4813-15		1	525B	1
141T4813-16		1	530B	1
141T4813-19		1	525D	1
141T4813-20		1	530D	1
141T4813-21		1	533D	1
141T4813-22		1	534D	1
141T4813-23		1	525E	1
141T4813-24		1	530E	1
141T4813-25		1	525J	1
141T4813-26		1	530J	1
141T4813-27		1	525K	1
141T4813-28		1	530K	1
141T4813-29		1	525L	1
141T4813-30		1	530L	1
141T4813-31		1	525M	1
141T4813-32		1	530M	1
141T4813-33		1	525N	1
141T4813-34		1	530N	1
141T4813-5		1	533B	1
141T4813-501		1	525F	1
141T4813-502		1	530F	1
141T4813-505		1	525H	1
141T4813-506		1	530H	1
141T4813-6		1	534B	1
141T4813-7		1	525C	1
141T4813-8		1	530C	1
141T4814-3		1	570A	1
		1	682C	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T4814-4		1	575A	1
		1	682E	1
141T4815-10		1	681	1
		1	561A	1
141T4815-11		1	562A	1
		1	681C	1
141T4815-12		1	563A	1
		1	681E	1
141T4815-13		1	564A	1
		1	681G	1
141T4815-14		1	565A	1
		1	681J	1
141T4815-15		1	566A	1
		1	681L	1
141T4815-16		1	682	1
		1	567A	1
141T4815-9		1	560A	1
		1	680L	1
141T4821-1		1	684Z	
		1	686D	1
141T4821-2		1	44	1
141T4821-3		1	686E	1
141T4821-5		1	44A	
141T4835-1		1	1E	RF
141T4835-10		1	5N	RF
141T4835-11		1	1Q	RF
141T4835-12		1	5Q	RF
141T4835-13		1	1R	RF
141T4835-14		1	5R	RF
141T4835-15		1	1S	RF
141T4835-16		1	5S	RF
141T4835-17		1	1T	RF
141T4835-18		1	5U	RF
141T4835-19		1	1V	
		1	5T	
141T4835-2		1	5E	RF
141T4835-20		1	5W	
141T4835-21		1	1U	
141T4835-22		1	5V	
141T4835-25		1	5X	
141T4835-26		1	5Y	RF
141T4835-27		1	1W	RF
141T4835-28		1	5Z	RF
141T4835-3		1	1G	RF
141T4835-36		1	6	RF
141T4835-37		1	1X	RF
141T4835-38		1	6A	RF

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T4835-4		1	5G	RF
141T4835-41		1	1Y	RF
141T4835-43		1	1Z	RF
141T4835-45		1	2	RF
141T4835-46		1	6B	RF
141T4835-47		1	2A	RF
141T4835-48		1	6C	RF
141T4835-5		1	1L	
		1	1P	RF
141T4835-503		1	1H	RF
141T4835-504		1	5H	RF
141T4835-507		1	1K	RF
141T4835-508		1	5K	RF
141T4835-6		1	5L	
		1	5P	RF
141T4835-65		1	2B	RF
141T4835-66		1	6D	RF
141T4835-67		1	2C	RF
141T4835-68		1	6E	RF
141T4835-7		1	1M	RF
141T4835-8		1	5M	RF
141T4835-9		1	1N	RF
141T4845-1		1	125	1
141T4845-15		1	125B	1
141T4845-16		1	127B	1
141T4845-17		1	125C	
141T4845-18		1	127C	
141T4845-2		1	127	1
141T4845-26		1	127D	1
141T4845-33		1	125D	1
141T4845-501		1	125A	1
141T4845-502		1	127A	1
141T4845-6		1	180	1
141T4850-1		1	240	1
141T4852-10		1	635A	1
141T4852-11		1	617	1
		1	615A	1
		1	615C	1
141T4852-12		1	622	1
		1	620A	1
		1	620C	1
141T4852-13		1	615D	1
		1	617A	1
141T4852-14		1	620D	1
		1	622A	1
141T4852-15		1	630B	1
141T4852-16		1	635C	1

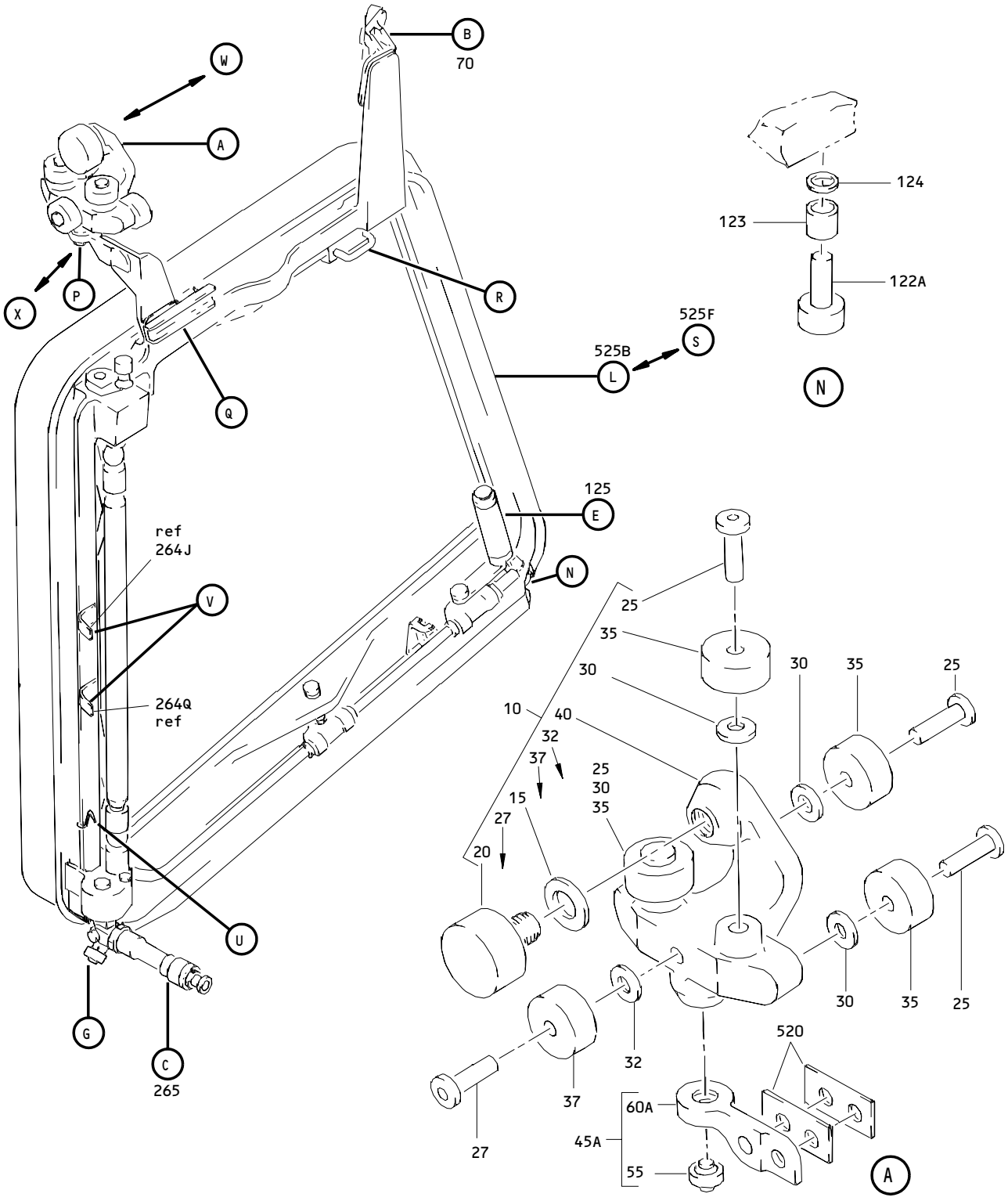
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T4852-19		1	630D	1
141T4852-20		1	635D	1
141T4852-21		1	615E	1
141T4852-22		1	620E	1
141T4852-23		1	617B	1
141T4852-24		1	622B	1
141T4852-25		1	630E	1
141T4852-26		1	635E	1
141T4852-27		1	683T	1
141T4852-28		1	683U	1
141T4852-31		1	683M	1
141T4852-32		1	683N	1
141T4852-33		1	685A	
		1	687A	1
141T4852-34		1	686	
		1	688	1
141T4852-35		1	683H	1
141T4852-36		1	683K	1
141T4852-37		1	685C	
		1	687C	1
141T4852-38		1	686B	
		1	688B	1
141T4852-39		1	683R	1
141T4852-40		1	683S	1
141T4852-41		1	685B	
		1	687B	1
141T4852-42		1	686A	
		1	688A	1
141T4852-5		1	615B	1
141T4852-6		1	620B	1
141T4852-7		1	630C	1
141T4852-8		1	635B	1
141T4852-9		1	630A	1
141T4853-11		1	70	1
141T4853-12		1	75	1
141T4853-13		1	120	1
141T4853-14		1	121	1
141T4853-501		1	120A	1
141T4853-502		1	121A	1
141T4853-9		1	95	1
141T4854-11		1	45A	1
141T4854-12		1	50A	1
141T4854-13		1	60A	1
141T4854-14		1	65A	1
141T4854-19		1	60B	1
141T4854-20		1	65B	1
141T4854-21		1	45B	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T4854-22		1	50B	1
141T4855-4		1	10	1
141T4855-5		1	40	1
141T4855-6		1	12	
141T4855-7		1	38	
141T4855-8		1	12A	1
141T4855-9		1	38A	1
141T4857-1		1	190	1
141T4858-1		1	230	1
141T4859-2		1	170	1
141T4860-1		1	245	1
141T4861-3		1	210	1
141T4862-1		1	235	1
141T4863-10		1	155B	1
141T4863-13		1	150D	1
		1	155F	
141T4863-14		1	155D	1
		1	155E	
141T4863-15		1	150G	1
141T4863-16		1	155G	1
141T4863-19		1	150E	
141T4863-20		1	150F	
141T4863-23		1	150H	1
141T4863-24		1	155H	1
141T4863-5		1	150A	1
		1	150C	1
141T4863-6		1	155A	1
		1	155C	1
141T4863-9		1	150B	1
141T4864-2		1	205	1
141T4864-3		1	200	1
141T4864-4		1	220	1
141T4865-10		1	285A	1
141T4865-11		1	315A	1
141T4865-13		1	265A	1
141T4865-14		1	270A	1
141T4865-15		1	265B	1
141T4865-16		1	270B	1
141T4865-17		1	315B	1
141T4865-19		1	265C	1
141T4865-20		1	270C	1
141T4865-21		1	285B	1
141T4865-22		1	315C	
141T4865-23		1	265D	
141T4865-24		1	270D	
141T4865-25		1	265E	1
141T4865-26		1	270E	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T4865-27		1	285C	1
141T4865-28		1	315D	1
141T4865-6		1	325	1
141T4865-7		1	300	1
141T4865-8		1	295	1
141T4868-2		1	455	1
141T4871-4		1	290	1
141T4871-5		1	292	1
141T4871-6		1	290A	1
141T4871-7		1	292A	1
141T4872-1		1	225	1
141T4872-2		1	215	1
141T4873-1		1	355	1
141T4873-2		1	355A	1
141T4873-3		1	355B	1
141T4905-1		1	420	1
141T4906-2		1	320A	1
141T4906-4		1	320B	1
141T4907-3		1	310A	1
141T4909-1		1	130	1
141T4909-2		1	132	1
141T4912-1		1	365	1
141T4912-10		1	465A	1
141T4912-11		1	470A	1
141T4912-12		1	475A	1
141T4912-13		1	456	1
141T4912-14		1	457	1
141T4912-15		1	456A	1
141T4912-16		1	457A	1
141T4912-2		1	370	1
141T4912-3		1	460	1
141T4912-4		1	465	1
141T4912-5		1	470	1
141T4912-6		1	475	1
141T4912-7		1	365A	1
141T4912-8		1	370A	1
141T4912-9		1	460A	1
141T4913-1		1	67	1
141T4914-10		1	524X	
141T4914-11		1	524Y	
141T4914-12		1	524Z	
141T4914-13		1	524Q	
141T4914-6		1	524P	
141T4914-7		1	524U	
141T4914-8		1	524V	
141T4914-9		1	524W	

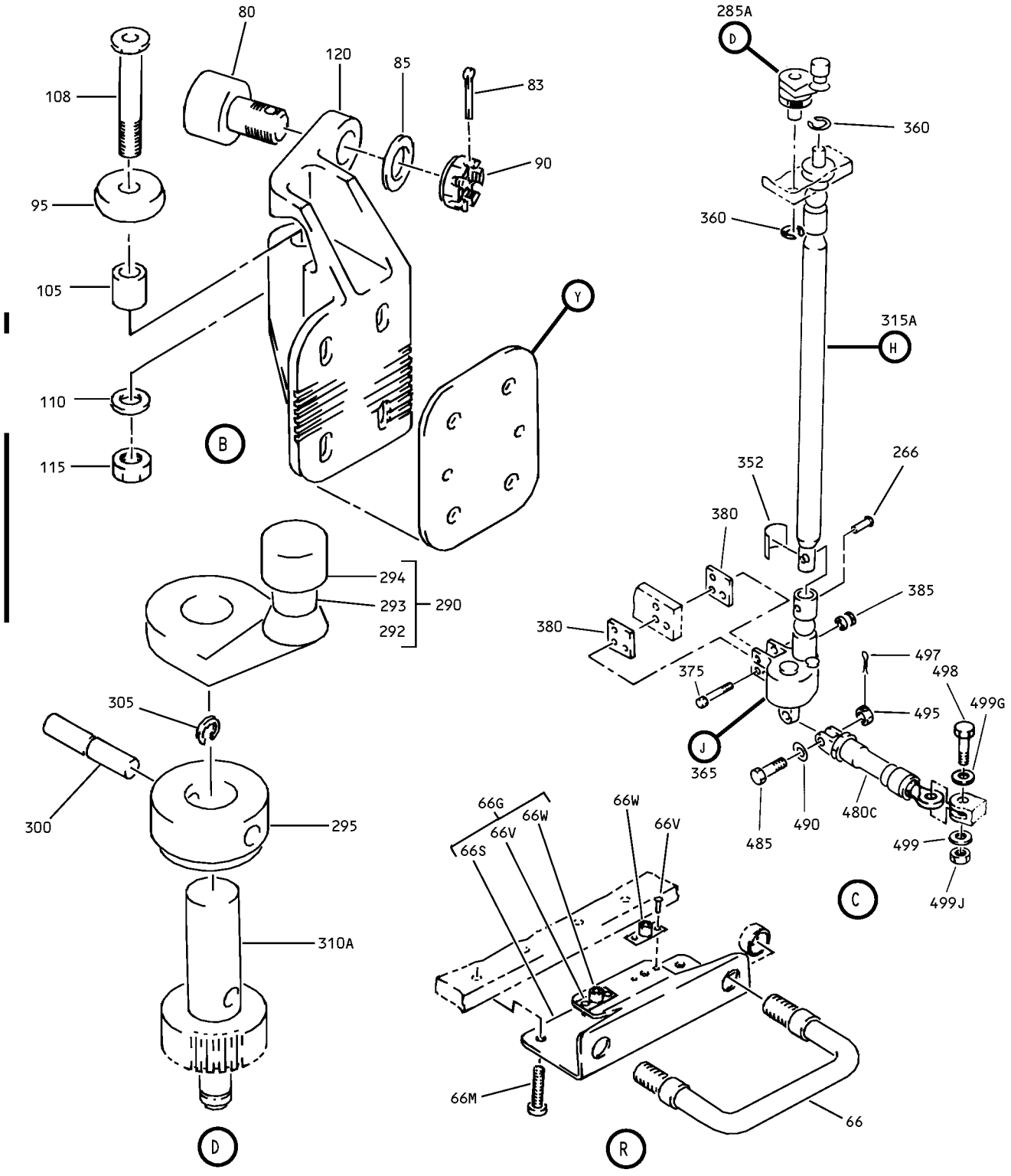
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T4924-1		1	532	4
		1	684X	4
141T4934-10		1	715B	1
141T4934-11		1	690C	1
141T4934-2		1	730	1
141T4934-4		1	689	1
		1	684W	1
141T4934-8		1	715A	1
141T4934-9		1	690B	1
141T4948-1		1	246	1
141T4948-2		1	246J	1
141T4949-1		1	247A	1
141T4949-2		1	247J	1
141T4950-1		1	248	1
141T4951-1		1	249	1
141T4953-1		1	521J	1
141W7413-1		1	525U	
141W7413-2		1	530U	
22-17-4920		2	65A	1
		2	65B	1
22-17-4922		2	80A	1
		2	80B	1
232T1433-3		1	264	2
232T4219-3		1	66G	1
232T4219-4		1	66S	1
232W1801-25		1	745	
232W1801-26		1	750	
232W1801-31		1	66D	
232W1801-32		1	66F	
232W1801-33		1	121T	
232W1801-55		1	264Q	
232W1801-57		1	264J	
34375		1	135	1
500007-02		1	595	4
		1	683	4
500007-1		1	600	2
		1	683C	2
500204-1		1	590	1
		1	682L	1
500205-1		1	585	2
		1	682J	2
500206-1		1	682T	1
53677-1		1	480C	1
7-43902-1		1	135	1
7-43902-2		1	137	1
7-43902-5		1	137B	1
76-3BA		1	66	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
9332		1	170A	1
9332-1		1	170B	1
		1	170C	



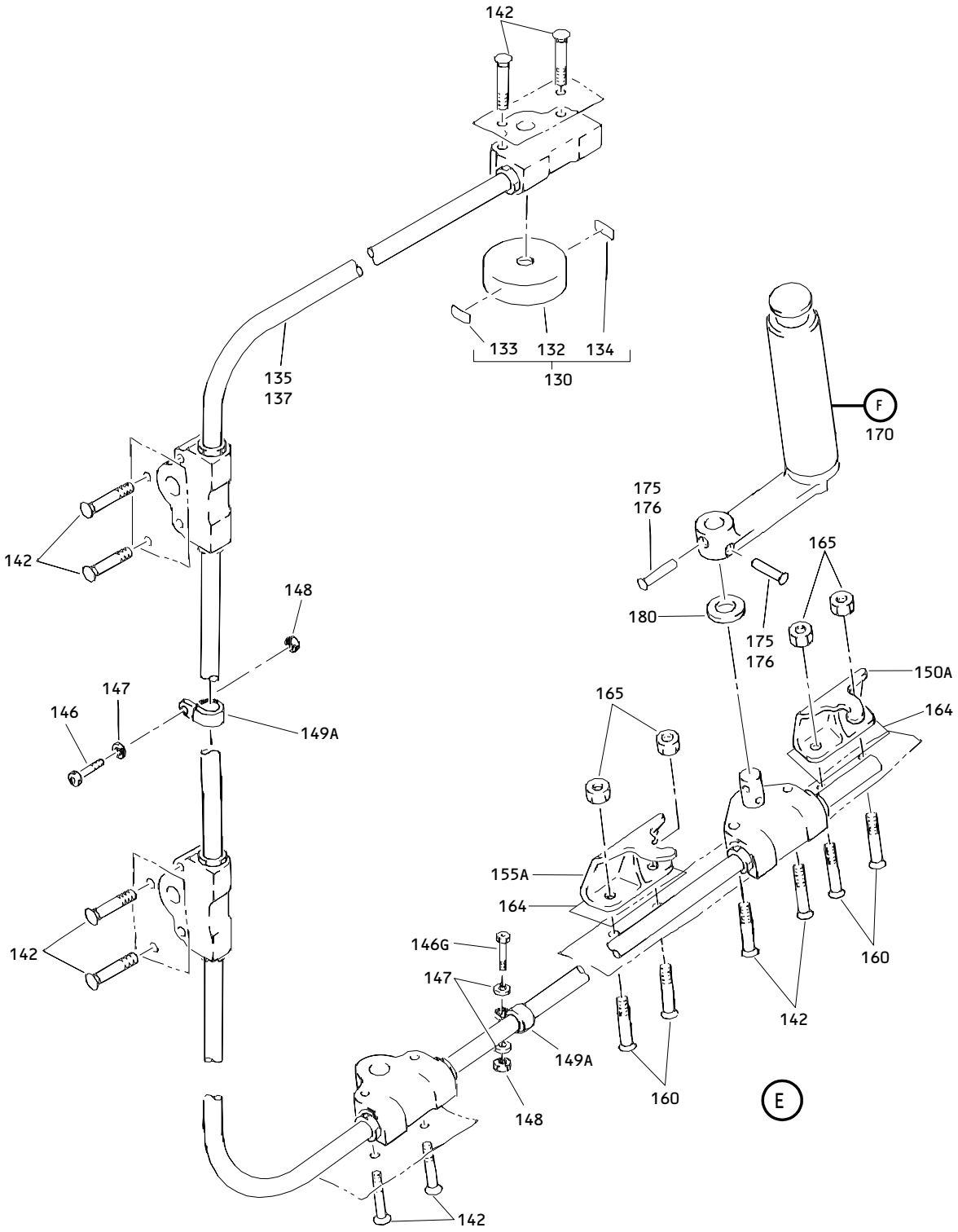
Cabin No. 2 Openable Window Assembly
Figure 1 (Sheet 1)

T56050



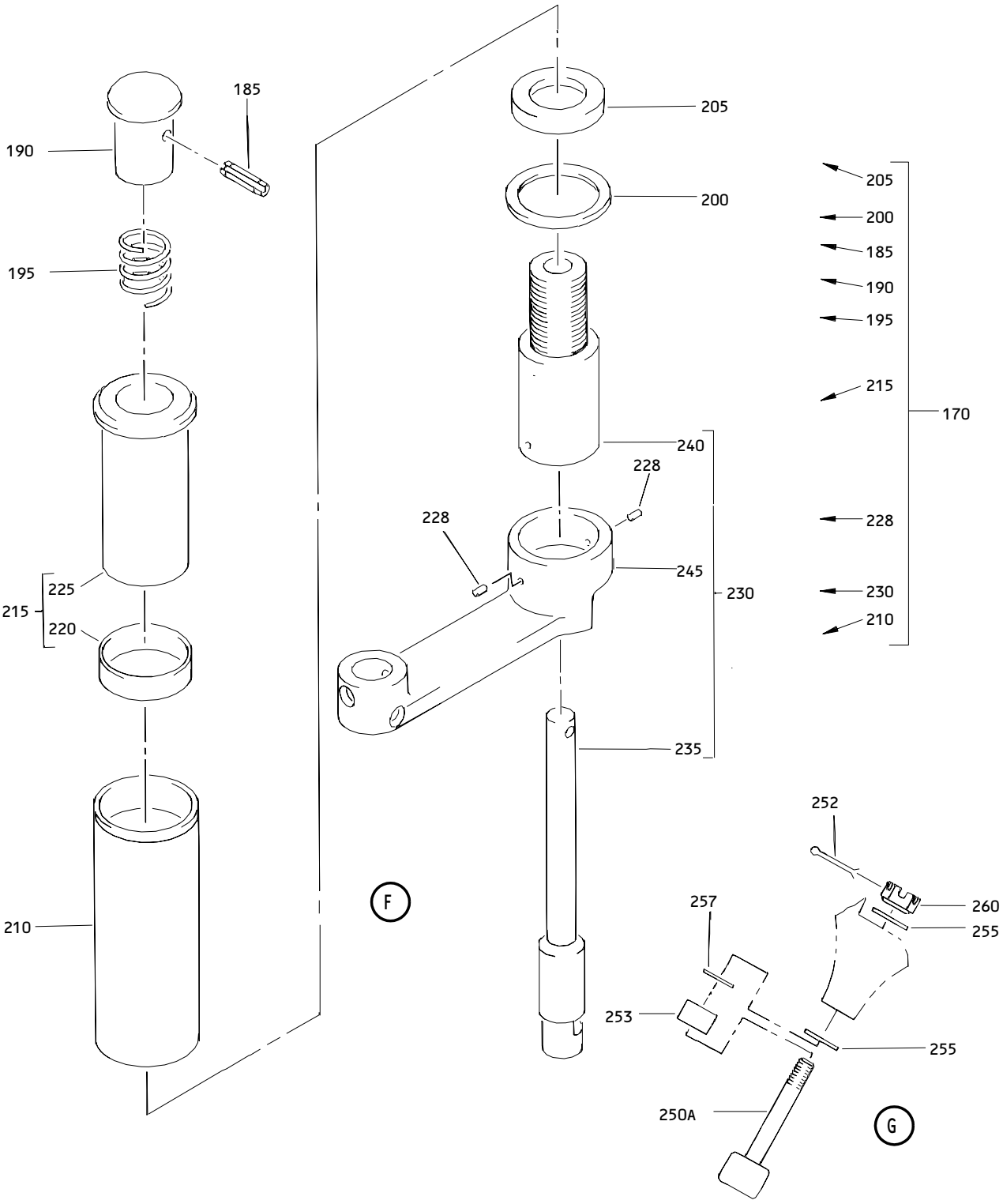
Cabin No. 2 Openable Window Assembly
Figure 1 (Sheet 2)

T56051



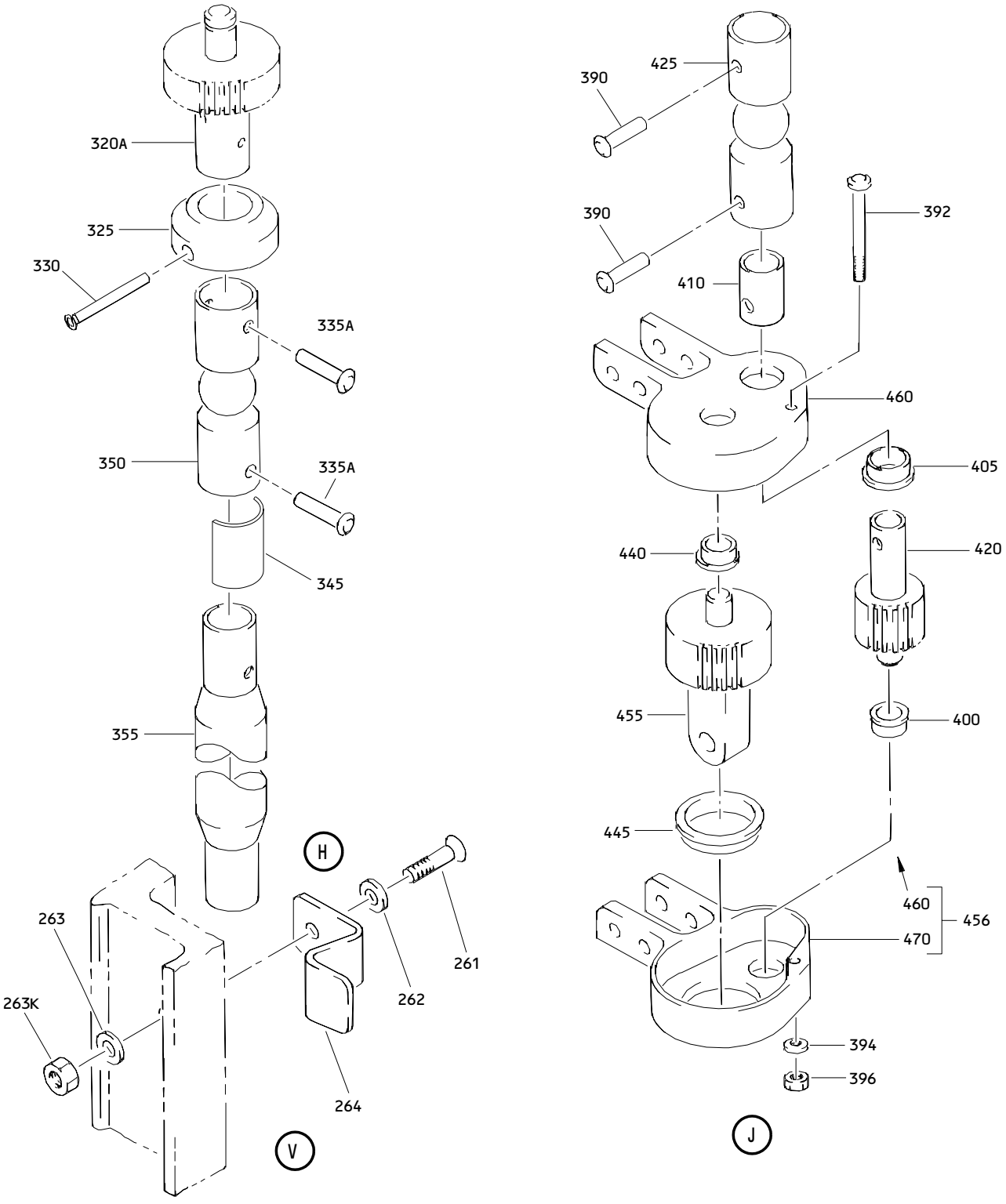
Cabin No. 2 Openable Window Assembly
Figure 1 (Sheet 3)

T77862



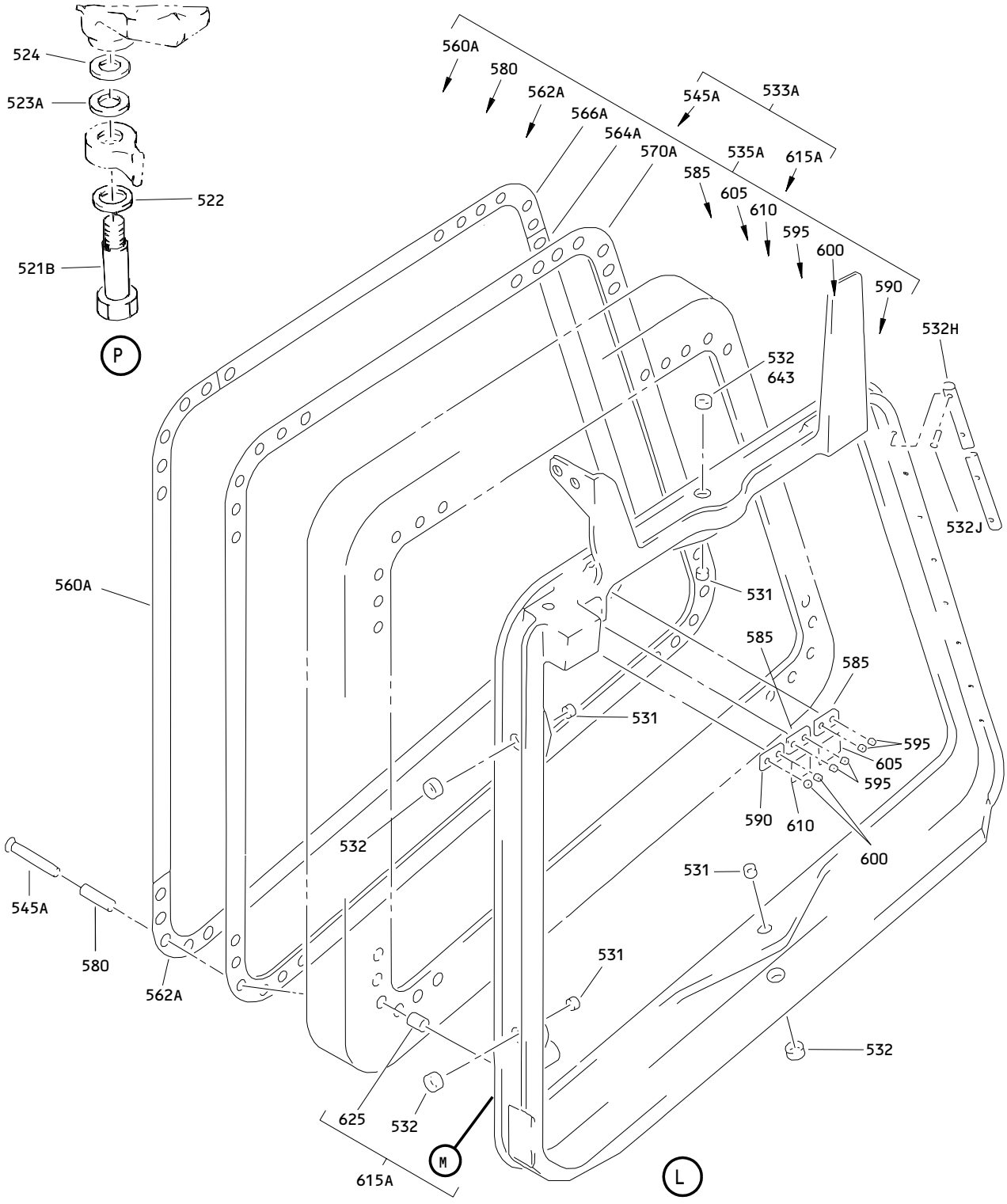
Cabin No. 2 Openable Window Assembly
Figure 1 (Sheet 4)

T77863



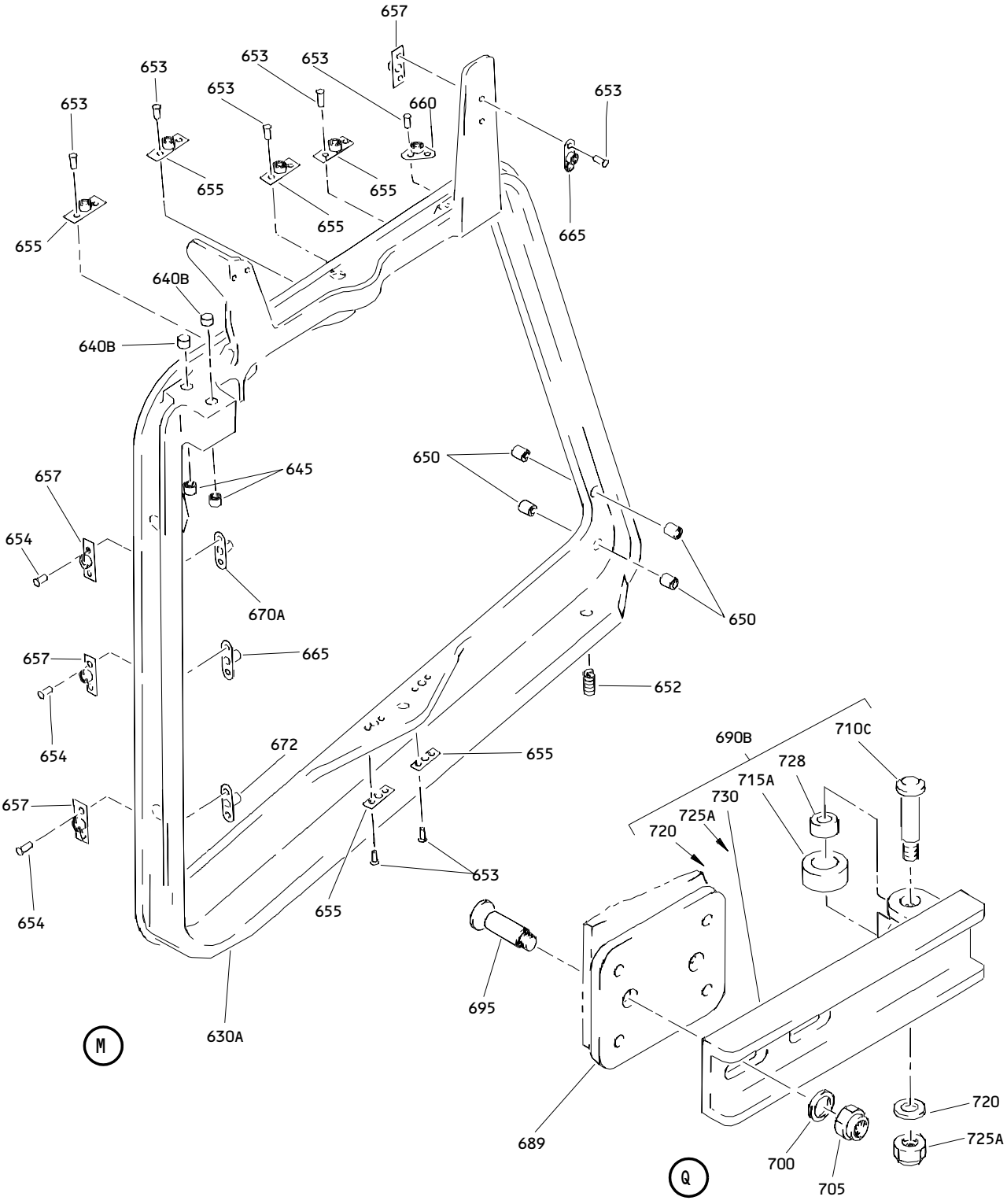
Cabin No. 2 Openable Window Assembly
Figure 1 (Sheet 5)

T56054



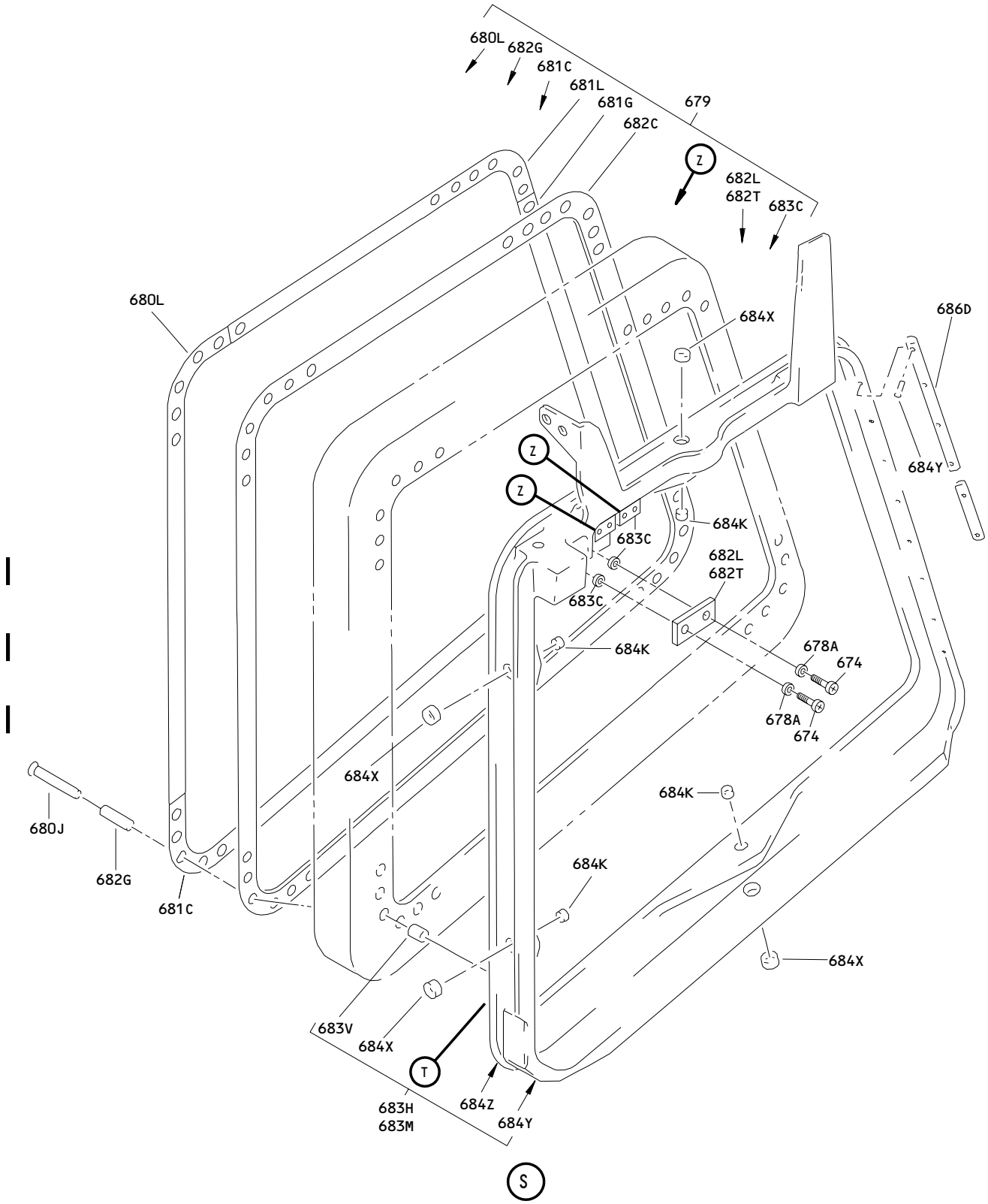
Cabin No. 2 Openable Window Assembly
Figure 1 (Sheet 6)

T77864



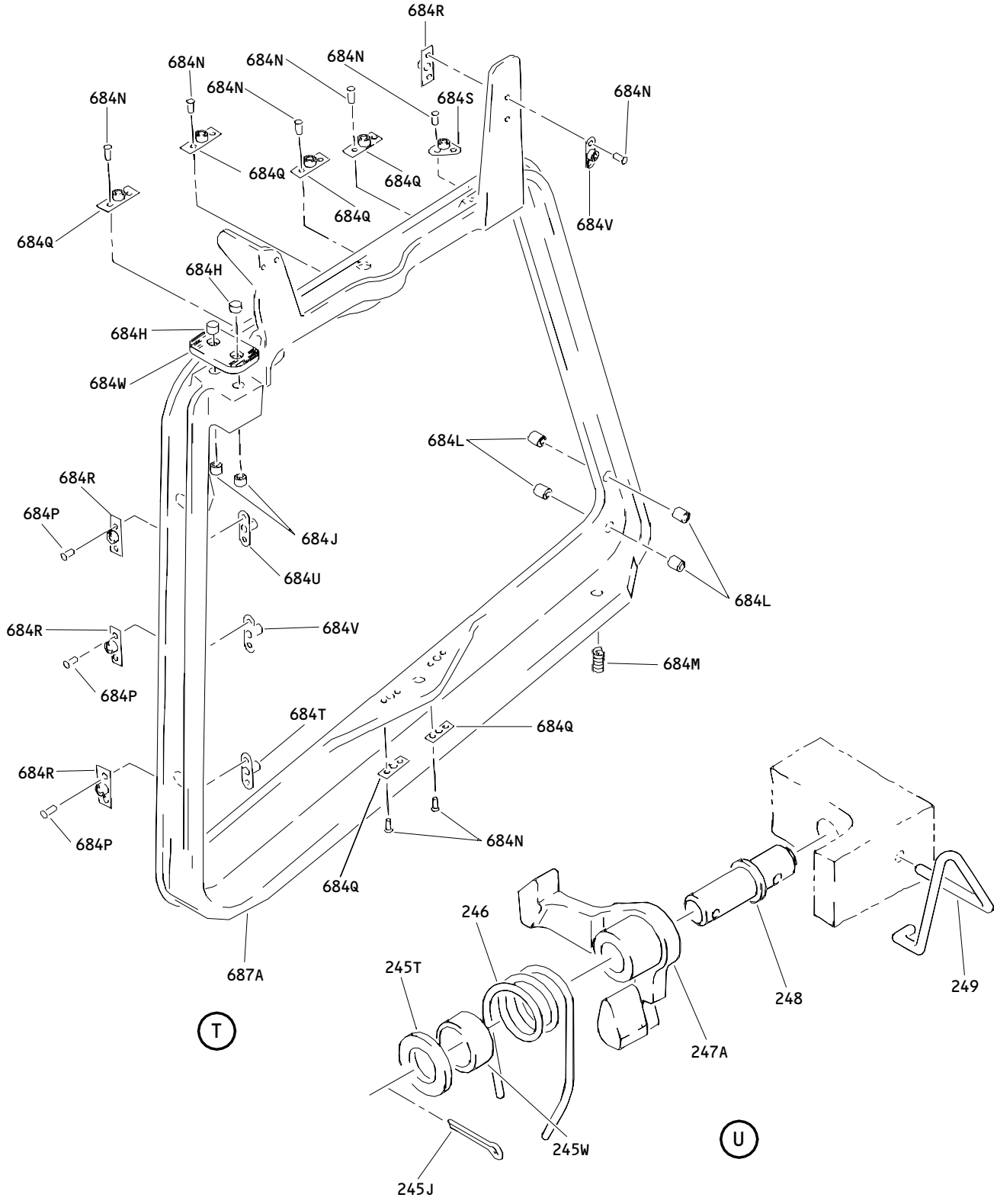
Cabin No. 2 Openable Window Assembly
Figure 1 (Sheet 7)

T77865



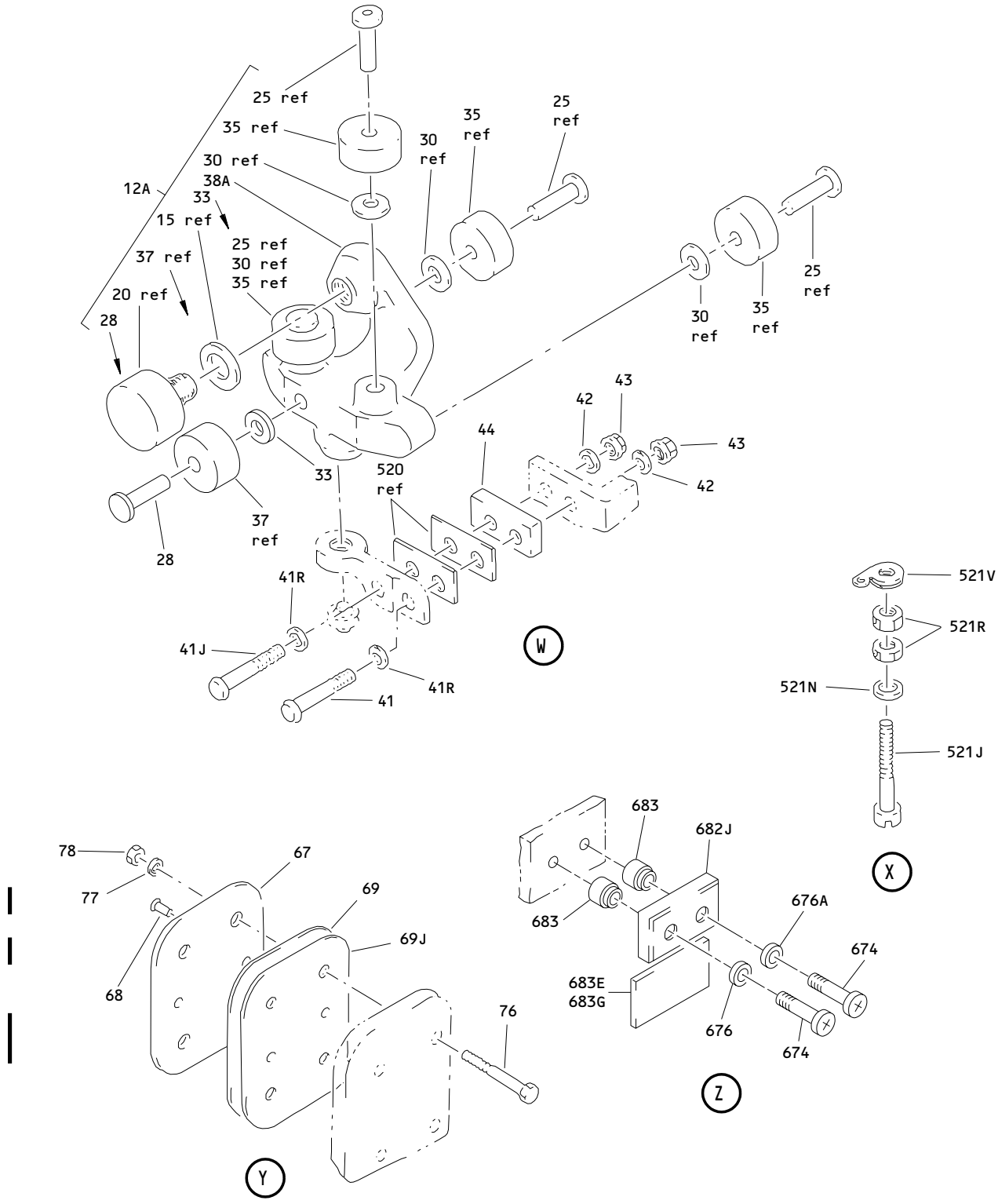
Cabin No. 2 Openable Window Assembly
Figure 1 (Sheet 8)

T95894



Cabin No. 2 Openable Window Assembly
Figure 1 (Sheet 9)

T95895



Cabin No. 2 Openable Window Assembly
Figure 1 (Sheet 10)

599178

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1A	141T0012-5005		WINDOW ASSY-CAB. NO. 2 OPENABLE LH (PRE-SB 767-56-0002)	A	RF
-1B	141T0012-5007		WINDOW ASSY-CAB. NO. 2 OPENABLE LH (PRE-SB 767-56-0002)	C	RF
-1C	141T0012-5013		WINDOW ASSY-CAB. NO. 2 OPENABLE LH (PRE-SB 767-56-0002)	E	RF
-1D	141T0012-5025		WINDOW ASSY-CAB. NO. 2 OPENABLE LH (PRE-SB 767-56-0002)	G	RF
-1E	141T4835-1		WINDOW ASSY-NO. 2 OPENABLE LH	J	RF
-1F	141T0012-5031		WINDOW ASSY-CAB. NO. 2 OPENABLE LH (PRE-SB 767-56-0002)	L	RF
-1G	141T4835-3		WINDOW ASSY-NO. 2 OPENABLE LH	Q	RF
-1H	141T4835-503		WINDOW ASSY-NO. 2 OPENABLE LH	R	RF
-1I	015T0195-7		WINDOW ASSY-NO. 2 OPENABLE LH (POST-SB 767-56-0002)	AW	RF
-1J	015T0195-9		WINDOW ASSY-NO. 2 OPENABLE LH (POST-SB 767-56-0002)	AY	RF
-1K	141T4835-507		WINDOW ASSY-NO. 2 OPENABLE LH	N	RF
-1L	141T4835-5		DELETED		
-1M	141T4835-7		WINDOW ASSY-NO. 2 OPENABLE LH	W	RF
-1N	141T4835-9		WINDOW ASSY-NO. 2 OPENABLE LH	X	RF
-1O	015T0195-11		WINDOW ASSY-NO. 2 OPENABLE LH (POST-SB 767-56-0002)	BB	RF
-1P	141T4835-5		WINDOW ASSY-NO. 2 OPENABLE LH	U	RF
-1Q	141T4835-11		WINDOW ASSY-NO. 2 OPENABLE LH	AA	RF
-1R	141T4835-13		WINDOW ASSY-NO. 2 OPENABLE LH	AC	RF

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1S	141T4835-15		WINDOW ASSY-NO. 2 OPENABLE LH	AE	RF
-1T	141T4835-17		WINDOW ASSY-NO. 2 OPENABLE LH	AG	RF
-1U	141T4835-21		DELETED		
-1U	015T0195-13		WINDOW ASSY-NO. 2 OPENABLE LH (POST-SB 767-56-0002)	BD	RF
-1V	141T4835-19		DELETED		
-1V	015T0195-15		WINDOW ASSY-NO. 2 OPENABLE LH (POST-SB 767-56-0002)	BF	RF
-1W	141T4835-27		WINDOW ASSY-NO. 2 OPENABLE LH	AJ	RF
-1X	141T4835-37		WINDOW ASSY-NO. 2 OPENABLE LH	AP	RF
-1Y	141T4835-41		WINDOW ASSY-NO. 2 OPENABLE LH	AQ	RF
-1Z	141T4835-43		WINDOW ASSY-NO. 2 OPENABLE LH	AR	RF
-2	141T4835-45		WINDOW ASSY-NO. 2 OPENABLE LH	AS	RF
-2A	141T4835-47		WINDOW ASSY-NO. 2 OPENABLE LH	AU	RF
-2B	141T4835-65		WINDOW ASSY-NO. 2 OPENABLE LH	BH	RF
-2C	141T4835-67		WINDOW ASSY-NO. 2 OPENABLE LH	BJ	RF
-5A	141T0012-5006		WINDOW ASSY-CAB. NO. 2 OPENABLE RH (PRE-SB 767-56-0002)	B	RF
-5B	141T0012-5008		WINDOW ASSY-CAB. NO. 2 OPENABLE RH (PRE-SB 767-56-0002)	D	RF
-5C	141T0012-5014		WINDOW ASSY-CAB. NO. 2 OPENABLE RH (PRE-SB 767-56-0002)	F	RF
-5D	141T0012-5026		WINDOW ASSY-CAB. NO. 2 OPENABLE RH (PRE-SB 767-56-0002)	H	RF
-5E	141T4835-2		WINDOW ASSY-NO. 2 OPENABLE RH	K	RF

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-5F	141T0012-5032		WINDOW ASSY-CAB. NO. 2 OPENABLE RH (PRE-SB 767-56-0002)	M	RF
-5G	141T4835-4		WINDOW ASSY-NO. 2 OPENABLE RH	S	RF
-5H	141T4835-504		WINDOW ASSY-NO. 2 OPENABLE RH	T	RF
-5I	015T0195-8		WINDOW ASSY-CAB. NO. 2 OPENABLE RH (POST-SB 767-56-0002)	AX	RF
-5J	015T0195-10		WINDOW ASSY-CAB. NO. 2 OPENABLE RH (POST-SB 767-56-0002)	AZ	RF
-5K	141T4835-508		WINDOW ASSY-NO. 2 OPENABLE RH	P	RF
-5L	141T4835-6		DELETED		
-5M	141T4835-8		WINDOW ASSY-NO. 2 OPENABLE RH	Y	RF
-5N	141T4835-10		WINDOW ASSY-NO. 2 OPENABLE RH	Z	RF
-5O	015T0195-12		WINDOW ASSY-NO. 2 OPENABLE RH (POST-SB 767-56-0002)	BC	RF
-5P	141T4835-6		WINDOW ASSY-NO. 2 OPENABLE RH	V	RF
-5Q	141T4835-12		WINDOW ASSY-NO. 2 OPENABLE RH	AB	RF
-5R	141T4835-14		WINDOW ASSY-NO. 2 OPENABLE RH	AD	RF
-5S	141T4835-16		WINDOW ASSY-NO. 2 OPENABLE RH	AF	RF
-5T	141T4835-19		DELETED		
-5T	015T0195-14		WINDOW ASSY-NO. 2 OPENABLE RH (POST-SB 767-56-0002)	BE	RF
-5U	141T4835-18		WINDOW ASSY-NO. 2 OPENABLE RH	AH	RF
-5V	141T4835-22		DELETED		
-5V	015T0195-16		WINDOW ASSY-NO. 2 OPENABLE RH (POST-SB 767-56-00029)	BG	RF
-5W	141T4835-20		DELETED		
-5X	141T4835-25		DELETED		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-5Y	141T4835-26		WINDOW ASSY-NO. 2 OPENABLE RH	AK	RF
-5Z	141T4835-28		WINDOW ASSY-NO. 2 OPENABLE RH	AM	RF
-6	141T4835-36		WINDOW ASSY-NO. 2 OPENABLE RH	AL	RF
-6A	141T4835-38		WINDOW ASSY-NO. 2 OPENABLE RH	AN	RF
-6B	141T4835-46		WINDOW ASSY-NO. 2 OPENABLE RH	AT	RF
-6C	141T4835-48		WINDOW ASSY-NO. 2 OPENABLE RH	AV	RF
-6D	141T4835-66		WINDOW ASSY-NO. 2 OPENABLE RH	BI	RF
-6E	141T4835-68		WINDOW ASSY-NO. 2 OPENABLE RH	BK	RF
10	141T4855-4		.CARRIAGE ASSY- (ON RH WINDOW 141T4855-4 TOGETHER WITH 141T4854-12 I/W 141T4855-8 TOGETHER WITH 141T4854-22, ON LH WINDOW 141T4855-4 TOGETHER WITH 141T4854-11 I/W 141T4854-8 TOGETHER WITH 141T4854-21)	A-T AW-BG	1
12	141T4855-6		DELETED		
12A	141T4855-8		.CARRIAGE ASSY- (ON RH WINDOW 141T4855-4 TOGETHER WITH 141T4854-12 I/W 141T4855-8 TOGETHER WITH 141T4854-22, ON LH WINDOW 141T4855-4 TOGETHER WITH 141T4854-11 I/W 141T4854-8 TOGETHER WITH 141T4854-21)	U-AV BH-BK	1
15	AN960C616		..WASHER		1
20	CR7-8-87		..FOLLOWER-CROWNED CAM (V07484) (OPT ITEM 20B)		1
-20A	BACB10FKGF1HS		DELETED		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-20B	BACB10FK6F1HS		..FOLLOWER-CAT (OPT ITEM 20)		1
25	BACB30MB6A5U		..BOLT-		4
27	BACB30MB6A5U		..BOLT- (USED ON ITEM 10)		1
28	BACB30NM3K5		..BOLT (USED ON ITEM 12A)		1
30	AN960C10L		..WASHER		4
32	AN960C10L		..WASHER (USED ON ITEM 10)		1
33	AN960C10L		..WASHER (USED ON ITEM 12A)		1
35	BACB10ET03		..BEARING-		4
37	BACB10ET03		..BEARING- (USED ON ITEM 10)		1
37J	BACB10ET03		..BEARING- (USED ON ITEM 12A)		1
38	141T4855-7		DELETED		
38A	141T4855-9		..BRACKET (USED ON ITEM 12A)		1
40	141T4855-5		..BRACKET (USED ON ITEM 10)		1
41	BACB30VT8K12		.BOLT-	J,K, N-AJ, AM-AU BH-BJ	1
-41A	BACB30US4K14		.BOLT	AK,AL AV,BK	1
41J	BACB30VT8K14		.BOLT-	J,K, N-AJ, AM-AU BH-BJ	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-41K	BACB30US4K16		.BOLT	AK,AL AV,BK	1
41R	BACW10BP4C		.WASHER	AK,AL AV,BK	2
42	AN960-416		.WASHER	J,K, N-AJ, AM-AU	2
-42A	BACW10BP4P		.WASHER	AK,AL ,AV	2
-42B	NAS1149F0463P		.WASHER	BH-BK	2
43	BACN10JC4CM		.NUT	J,K, N-AJ, AM-AU BH-BJ	2
-43A	BACN10HR4CD		.NUT-	AK,AL AV,BK	2
44	141T4821-2		.FILLER	J,K, N-AV, BK	1
-44A	141T4821-5		DELETED		
45A	141T4854-11		.BRACKET ASSY- (ON LH WINDOW 141T4855-4 TOGETHER WITH 141T4854-11 I/W 141T4855-8 TOGETHER WITH 141T4854-21)	A,C,E ,G,J, L,N,Q ,R,AW ,AY, BB,BD ,BF	1
-45B	141T4854-21		.BRACKET ASSY- (ON LH WINDOW 141T4855-4 TOGETHER WITH 141T4854-11 I/W 141T4855-8 TOGETHER WITH 141T4854-21)	U,W,X ,AA,A C,AE, AG,AJ AP-AS AU, BH-BJ	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-50A	141T4854-12		.BRACKET ASSY- (ON RH WINDOW 141T4855-4 TOGETHER WITH 141T4854-12 I/W 141T4855-8 TOGETHER WITH 141T4854-22)	B,D,F ,H,K, M,P,S ,T,AX ,AZ, BC,BE ,BG	1
-50B	141T4854-22		.BRACKET ASSY- (ON RH WINDOW 141T4855-4 TOGETHER WITH 141T4854-12 I/W 141T4855-8 TOGETHER WITH 141T4854-22)	V,Y,Z ,AB,A D,AF, AH,A K-AN AT,AV BH	1
55	ADBY4		..BEARING-SPHER (V15860) (OPT ITEMS 55A, 55H) (USED ON ITEMS 45A,50A)		1
-55A	KSBY4		..BEARING-SPHER (V97613) (OPT ITEMS 55, 55H) (USED ON ITEMS 45A,50A)		1
-55B	ADBY5		DELETED		
-55C	KSBY5		DELETED		
-55D	ABYT5		DELETED		
-55E	ABYT5H		..BEARING-SPHER (V50294) (OPT ITEMS 55F, 55G) (USED ON ITEMS 45B,50B)		1
-55F	ABYT5-109		..BEARING-SPHER (V50294) (OPT ITEMS 55E, 55G) (USED ON ITEMS 45B,50B)		1
-55G	KDSY5-22		..BEARING-SPHER (V97613) (OPT ITEMS 55E, 55F) (USED ON ITEMS 45B,50B)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-55H	ABYT4-108		..BEARING-SPHER (V50294) (OPT ITEMS 55, 55A) (USED ON ITEMS 45A,50A)		1
60A	141T4854-13		..BRACKET (USED ON ITEM 45A)		1
-60B	141T4854-19		..BRACKET (USED ON ITEM 45B)		1
-65A	141T4854-14		..BRACKET (USED ON ITEM 50A)		1
-65B	141T4854-20		..BRACKET (USED ON ITEM 50B)		1
66	76-3BA		.HANDLE-ASSIST (V08730) (OPT ITEM 066A)	C-E, G-L, AY,AZ ,BB, BD,BF	1
-66A	BM835-2		.HANDLE-ASSIST (V08730) (OPT ITEM 066)	C-E, G-L AY,AZ ,BB, BD,BF	1
66B	NAS6603-9		DELETED		
66C	AN960JD10LL		DELETED		
66D	232W1801-31		DELETED		
-66F	232W1801-32		DELETED		
66G	232T4219-3		.BRACKET ASSY ATTACHING PARTS	C-M, AY,AZ ,BB, BC,BD ,BE, BF,BG	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
66M	NAS514P1032-16		.SCREW	C-M, AY,AZ ,BB, BC,BD ,BE, BF,BG	4
			-------*-------		
66S	232T4219-4		..BRACKET		1
66V	BACR15BA3		..RIVET- (SIZE DETERMINE ON INST)		4
66W	BACN10JN3		..NUTPLATE-		2
67	141T4913-1		.PLATE-SERRATED		1
68	BACR15BA3AD		.RIVET- (SIZE DETERMINE ON INST) (NHA 232T4219)	J,K, N-AV BH-BK	2
69	BACS40R18W23		.SHIM	J,K, N-AB	AR
-69A	BACS40RO18CO23F		.SHIM	AC-AV BH-BK	AR
69J	BACS40R18U23		.SHIM	J,K, N-AB	AR
-69K	BACS40RO18BO23F		.SHIM	AC-AV BH-BK	AR
70	141T4853-11		.BRACKET ASSY-FWD	A,C,E ,G,J, L,N,Q ,R,U, W,X AA,AC ,AE,A G,AJ, AP-AS ,AU, AW,AY ,BB, BD,BF BH,BJ	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-75	141T4853-12		.BRACKET ASSY-FWD	B,D,F,H,K,M,P,S,T,V,Y,Z AB,AD,AF,AH,AK-AN,AT,AV AX,AZ,BC,BE,BG BI,BK	1
			ATTACHING PARTS		
76	BACB30VT6K7		.BOLT-	J,K,N-T	4
-76A	NAS6603-7		.BOLT	U-AV BH-BK	4
77	AN960-10		.WASHER	J,K,N-AV	4
-77A	NAS1149F0363P		.WASHER	BH-BK	4
78	BACN10JC3CM		.NUT	J,K,N-AV BH-BK	4
			-------*-------		
80	CR7-8-86		..CAM FOLLOWER- (V07484) (OPT ITEM 80A)		1
-80A	BACB10FK6F4HS		..CAM FOLLOWER- (OPT ITEM 80) ATTACHING PARTS		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
83	MS24665-287		..PIN-COTTER		1
85	BACW10BP6P		..WASHER		1
90	BACN10JD106		..NUT		1
			-------*-------		
95	141T4853-9		..BEARING-BALL RADIAL		1
105	NAS43DD4-25		..SPACER		1
			ATTACHING PARTS		
108	BACB30FM8A13		..BOLT-		1
110	BACW10BP4P		..WASHER		1
115	BACN10JC4		..NUT		1
			-------*-------		
120	141T4853-13		..BRACKET-		1
			(USED ON ITEM 70)		
-120A	141T4853-501		..BRACKET-		1
			(OPT)		
			(USED ON ITEM 70)		
-121	141T4853-14		..BRACKET-		1
			(USED ON ITEM 75)		
-121A	141T4853-502		..BRACKET-		1
			(OPT)		
			(USED ON ITEM 75)		
121K	NAS6603-7		DELETED		
121L	NAS6603-6		DELETED		
121P	AN960JD10LL		DELETED		
121T	232W1801-33		DELETED		
122A	MS21432-3R4A		.BEARING	A-H,L ,M, AW-BG	1
-122B	MS21432-3R4A		.BEARING-	J,K,	1
			(OPT ITEM 122D)	N-AB	
-122C	BACB10AF3K4HS		DELETED		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-122D	BACB10AF3N4HS		.BEARING-	J,K, N-AB	1
-122E	BACB10FK3N4HS		.BEARING	AC-AV BH-BJ	1
123	NAS1056E6-029		.SPACER		1
124	AN960PD10L		.WASHER	A-T, AW-BG	AR
-124A	AN960JD10L		.WASHER	U-AV	AR
-124B	AN960JD10LL		DELETED		
125	141T4845-1		.LATCH INSTL	A,C,E ,G,J, L,Q, AX,AZ ,BC, BE,BG	1
-125A	141T4845-501		.LATCH INSTL	N,R	1
-125B	141T4845-15		.LATCH INSTL	U,W,X ,AA,A C,AE, AG,AJ ,AP AS,BH	1
-125C	141T4845-17		DELETED		
-125D	141T4845-33		.LATCH INSTL	AQ,AR AU,BJ	1
-127	141T4845-2		.LATCH INSTL	B,D,F ,H,K, M,S, AX,AZ ,BE, BE,BG	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-127A	141T4845-502		.LATCH INSTL	P,T	1
-127B	141T4845-16		.LATCH INSTL	V,Y,Z ,AB,A D,AF, AH,AM ,AN AT,BI	1
-127C	141T4845-18		DELETED		
-127D	141T4845-26		.LATCH INSTL	AK,AL AV,BK	1
130	141T4909-1		..INDICATOR ASSY-POSITION		1
132	141T4909-2		...INDICATOR		1
133	BAC27TBY0007		...DECAL-OPEN		1
134	BAC27TBY0008		...DECAL-CLOSED		1
135	7-43902-1		..RELEASE SYSTEM- (V78710) (SPEC S141T492-1) (OPT 34375 (V11346)) (USED ON ITEMS 125-125D)		1
137	7-43902-2		..RELEASE SYSTEM- (V78710) (SPEC S141T492-2) (USED ON ITEMS 127-127B)		1
-137A	S141T492-4		DELETED		
-137B	7-43902-5		..RELEASE SYSTEM- (V78710) (SPEC S141T492-4) (USED ON ITEM 127D) ATTACHING PARTS		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
142	BACB30LR3U7		..BOLT		10
-142A	BACB30LH3-7		DELETED		
146	BACB30NM3K9		..BOLT		1
146G	BACB30LR3U10		..BOLT		1
-146H	BACB30LH3-10		DELETED		
147	AN960PD10		..WASHER		3
-147A	AN960JD10		DELETED		
148	BACN10JC3CM		..NUT		2
-148A	H52732-3CD		DELETED		
149	BACC10DW5		DELETED		
149A	BACC10DW5D		..CLAMP-		2
150A	141T4863-5		..BRACKET-STRIKER (REWORK) (OPT ITEM 150B) (USED ON ITEMS 125, 125A,125B,127,127A, 127B)		1
-150B	141T4863-9		..BRACKET-STRIKER (OPT ITEM 150A) (USED ON ITEMS 125, 127)		1
-150C	141T4863-5		..BRACKET-STRIKER (REWORK) (OPT ITEM 150D) (USED ON ITEMS 125A, (125B,127A,127B)		1
-150D	141T4863-13		..BRACKET-STRIKER (OPT ITEM 150C) (USED ON ITEMS 125A, 125B,127A,127B)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-150E	141T4863-19		DELETED		
-150F	141T4863-20		DELETED		
-150G	141T4863-15		..BRACKET-STRIKER (USED ON ITEM 127D)		1
-150H	141T4863-23		..BRACKET-STRIKER (USED ON ITEM 125D)		1
155A	141T4863-6		..BRACKET-STRIKER (REWORK) (OPT ITEM 155B) (USED ON ITEMS 125, 125A,125B,127,127A, 127B)		1
-155B	141T4863-10		..BRACKET-STRIKER (OPT ITEM 155A) (USED ON ITEMS 125, 127)		1
-155C	141T4863-6		..BRACKET-STRIKER (REWORK) (OPT ITEM 155D) (USED ON ITEMS 125, 125A,125B,127,127A, 127B)		1
-155D	141T4863-14		..BRACKET-STRIKER (OPT ITEM 155C) (USED ON ITEMS 125A, 125B,127A,127B)		1
-155E	141T4863-14		DELETED		
-155F	141T4863-13		DELETED		
-155G	141T4863-16		..BRACKET-STRIKER (USED ON ITEM 125D)		1
-155H	141T4863-24		..BRACKET-STRIKER (USED ON ITEM 127D)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
160	BACB30LR3U10		..BOLT		4
-160A	BACB30LH3-9		DELETED		
162	AN960C10L		DELETED		
164	BACS40R08B20F		..SHIM (REPLD BY ITEM 164A)		AR
-164A	BACS40R008B020F		..SHIM (REPLS ITEM 164)		AR
165	NAS1805-3		..NUT		4
-165A	H52732-3CD		DELETED		
170	141T4859-2		..HANDLE ASSY- (OPT) (USED ON ITEMS 125, 125A,127,127A)		1
-170A	9332		..HANDLE ASSY- (V84256) (OPT) (USED ON ITEMS 125, 125A,127,127A)		1
-170B	9332-1		..HANDLE ASSY- (V84256) (USED ON ITEMS 125B, 125D,127B,127D)		1
-170C	9332-1		DELETED		
175	BACR15CE5M15		..RIVET- (OPT ITEM 176)		2
176	MS16562-236		..PIN-SPR (OPT ITEM 175)		2
180	141T4845-6		..WASHER-SHIM -------*-------		1
185	MS16562-26		...PIN-SPR (USED ON ITEM 170)		1
190	141T4857-1		...BUTTON- (USED ON ITEM 170)		1
195	MS24585-1362		...SPRING- (USED ON ITEM 170)		1
200	141T4864-3		...WASHER- (USED ON ITEM 170)		1
205	141T4864-2		...BUSHING- (USED ON ITEM 170)		1
210	141T4861-3		...GRIP- (USED ON ITEM 170)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
215	141T4872-2		...GUIDE ASSY-UPR (USED ON ITEM 170)		1
220	141T4864-4		....BUSHING		1
225	141T4872-1		....GUIDE-UPR		1
228	MS16562-21		...PIN-SPR (USED ON ITEM 170)		2
230	141T4858-1		...LEVER ASSY- (USED ON ITEM 170)		1
235	141T4862-1		....CATCH-SAFETY		1
240	141T4850-1		....GUIDE-LWR		1
245	141T4860-1		....ARM-CRANK		1
245J	MS24665-153		.PIN-COTTER	J,K, N-BG	1
-245K	BACP18BC02A06P		.PIN-COTTER	BH-BK	1
245T	BACW10P32C		.WASHER	J,K, N-BG	AR
-245U	BACW10P32CC		.WASHER	BH-BK	1
245W	BACB28AK07-008		.BUSHING	J,K, N-BK	1
246	141T4948-1		.SPRING	J,N,Q ,R,U, W,X,A A,AC, AE,AG AJ,AG P-AS, AU,AW ,AY,B B,BD, BF,BH BJ	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-246J	141T4948-2		.SPRING	K,P,S,T,V,Y,Z,AB,AD,AF,AH AK-AN,AT,AV,AX,AZ,BC,BE,BG,BI BK	1
247A	141T4949-1		.HOOK	J,N,Q,R,U,W,X,AA,AC,AE,AG AJ,AG P-AS,AU,AY,BB,BD,BF,BH,BJ	1
-247J	141T4949-2		.HOOK	K,P,S,T,V,Y,Z,AB,AD,AF,AH AK-AN,AT,AV,AX,AZ,BC,BE,BG,BI,BK	1
248	141T4950-1		.PIN	J,K,N-BK	1
249	141T4951-1		.RETAINER	J,K,N-BK	1
250A	141T0012-22		.BEARING-CAM ROLLER	A-D AW-AZ	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-250B	KRP119105VT		.BEARING-CAM ROLLER (V50632)	E-K, N-AK, AM, BB-BE	1
-250C	141T0012-22		.BEARING-CAM ROLLER (OPT ITEM 250D)	L,M, BF,BG	1
-250D	KRP119105VT		.BEARING-CAM ROLLER (V50632) (OPT ITEM 250C)	L,M, BF-BG	1
252	MS24665-136		.PIN-COTTER	A-BG	1
-252A	BACP18BC02C08P		.PIN-COTTER	BH-BK	1
253	NAS1056E10-025		.SPACER		1
255	AN960PD516		.WASHER	A-T, AW-BG	AR
-255A	AN960JD516		.WASHER	U-AV	AR
-255B	NAS1149D0563J		.WASHER	BH-BK	AR
257	AN960PD516L		.WASHER	A-T, AW-BG	AR
-257A	AN960JD516L		.WASHER	U-AV	AR
-257B	NAS1149D0516J		.WASHER	BH-BK	AR
260	BACN10JD105		.NUT		1
261	BACB30LU3-10		.BOLT	J,K, N-AV	2
-261A	BACB30LU3-7		.BOLT	BH-BK	2
262	AN960PD10L		.WASHER	J,K, N-AV	2
-262B	NAS1149D0316J		.WASHER	BH-BK	2
-262A	AN960JD10LL		DELETED		
263	BACW10UC103P		.WASHER	J,K, N-AV	2
263J	H10-3BAC		DELETED		
263K	MS21042L3		.NUT	J,K, N-AV	2
-263L	H52732-3CD		DELETED		
-263M	BACN10JC3CD		.NUT	BH-BK	2
264	232T1433-3		.BRACKET	J,K, N-AV, BH-BK	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
264J	232W1801-57		DELETED		
264Q	232W1801-55		DELETED		
-265A	141T4865-13		.TUBE INSTL-TORQUE	A,C,E,G,J,L,N,Q,R,U,W,X,AW,AY,BB,BD,BF	1
-265B	141T4865-15		.TUBE INSTL-TORQUE	AA	1
-265C	141T4865-19		.TUBE INSTL-TORQUE	AC,AE,AG,AJ,AP-AS,AU	1
-265D	141T4865-23		DELETED		
-265E	141T4865-25		.TUBE ASSY-TORQUE	BH,BJ	1
266	CSR925-8		.RIVET (V05693) (SIZE DETERMINE ON INST.)	A-AV	1
-266A	CSR925-8-16		.RIVET (V05693) (OPT ITEM 266B)	AW-AZ	1
-266B	MS20615-8M16		.RIVET (OPT ITEM 266A)	AW-AZ	1
-270A	141T4865-14		.TUBE INSTL-TORQUE	B,D,F,H,K,M,P,S,T,V,Y,Z,AX,AZ,BC,BE,BG	1
-270B	141T4865-16		.TUBE INSTL-TORQUE	AB	1
-270C	141T4865-20		.TUBE INSTL-TORQUE	AD,AF,AH,AK-AN,AT,AV	1
-270D	141T4865-24		DELETED		
-270E	141T4865-26		.TUBE ASSY-TORQUE	BI,BK	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
285A	141T4865-10		..TUBE ASSY (USED ON ITEMS 265A, 265B)		1
-285B	141T4865-21		..TUBE ASSY (USED ON ITEMS 265C, 270C)		1
-285C	141T4865-27		..TUBE ASSY (USED ON ITEMS 265E, 270E)		1
290	141T4871-4		...CRANK ASSY (USED ON ITEM 285A)		1
-290A	141T4871-6		...CRANK ASSY (USED ON ITEMS 285B, 285C)		1
292	141T4871-5		....CRANK (USED ON ITEM 290)		1
-292A	141T4871-7		....CRANK (USED ON ITEM 290A)		1
293	BACB28AK06-015		....BUSHING		1
294	CCF3-4S		....ROLLER-CAM		1
295	141T4865-8		...SPACER		1
300	141T4865-7		...PIN		1
305	MS16633-4025		...RING		1
310A	141T4907-3		...GEAR		1
315A	141T4865-11		..TUBE ASSY (USED ON ITEMS 265A, 270A)		1
-315B	141T4865-17		..TUBE ASSY (USED ON ITEMS 265B, 265C,270B,270C)		1
-315C	141T4865-22		DELETED		
-315D	141T4865-28		..TUBE ASSY (USED ON ITEMS 265E, 270E)		1
320A	141T4906-2		...GEAR (USED ON ITEM 315A)		1
-320B	141T4906-4		...GEAR (USED ON ITEMS 315B, 315C)		1
325	141T4865-6		...SPACER		1
330	BACR15BA4AD		...RIVET- (SIZE DETERMINE ON INST) (USED ON ITEMS 315A, 315B)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
335	CSR925-8-16R		...RIVET (USED ON ITEM 315D)		2
335A	MS20615-8M22		...RIVET (OPT ITEM 335B)*[1] (USED ON ITEMS 315A, 315B)		2
-335B	CSR925-8-22		...RIVET (V05693) (OPT ITEM 335A)*[1] (USED ON ITEMS 315A, 315B)		2
-335C	MS20615-8M16		...RIVET (OPT) (USED ON ITEM 315D)		2
345	BACS40R009U016		...SHIM (USED ON ITEM 315D)		1
350	MS20270B16		...JOINT-UNIVERSAL		1
352	BACS40R009U016		.SHIM	AW-AZ	1
355	141T4873-1		...TUBE- (OPT) (USED ON ITEMS 315A, 315B)		1
-355A	141T4873-2		...TUBE- (USED ON ITEMS 315A, 315B)		1
-355B	141T4873-3		..TUBE- (USED ON ITEM 315D)		1
360	MS16633-4037		..RING		2
365	141T4912-1		..GEAR ASSY- (USED ON ITEMS 265A-265D)		1
-365A	141T4912-7		..GEAR ASSY- (OPT) (USED ON ITEMS 265A-265D)		1
-370	141T4912-2		..GEAR ASSY- (USED ON ITEMS 270A-270D)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-370A	141T4912-8		..GEAR ASSY-		1
			(OPT)		
			(USED ON ITEMS		
			270A-270D)		
			ATTACHING PARTS		
375	BACB30NW6K18)		..BOLT-		3
380	BACS40R13B15F		..SHIM		2
385	BACC30M6		..COLLAR-		3
			-------*-------		
390	MS20615-8M22		...RIVET		1
			(OPT ITEM 390B)*[1]		
-390A	CSR925-8-16		DELETED		
-390B	CSR925-8-22		...RIVET		1
			(V05693)		
			(OPT ITEM 390)*[1]		
392	BACB30MY6K21		...BOLT-		1
394	AN960PD10		...WASHER		1
396	BACN10JC3CM		...NUT		1
400	BACB28X6C020		...BUSHING-		1
			(OPT)		
-400A	BACB28X6C019		...BUSHING-		1
405	BACB28X9C020		...BUSHING-		1
			(OPT)		
-405A	BACB28X9C019		...BUSHING-		1
410	BACB28Z9-090		...BUSHING		1
420	141T4905-1		...GEAR		1
425	MS20270B16		...JOINT		1
440	BACB28X6C020		...BUSHING-		1
			(OPT)		
-440A	BACB28X6C019		...BUSHING-		1
445	BACB28X16C020		...BUSHING-		1
			(OPT)		
-445A	BACB28X16C019		...BUSHING-		1
455	141T4868-2		...GEAR		1
456	141T4912-13		...HOUSING ASSY-		1
			(USED ON ITEM 365)		
-456A	141T4912-15		...HOUSING ASSY-		1
			(USED ON ITEM 365A)		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-457	141T4912-14		...HOUSING ASSY- (USED ON ITEM 370)		1
-457A	141T4912-16		...HOUSING ASSY- (USED ON ITEM 370A)		1
460	141T4912-3		....HOUSING- (USED ON ITEM 456)		1
-460A	141T4912-9		....HOUSING- (USED ON ITEM 456A)		1
-465	141T4912-4		....HOUSING- (USED ON ITEM 457)		1
-465A	141T4912-10		....HOUSING- (USED ON ITEM 457A)		1
470	141T4912-5		....HOUSING- (USED ON ITEM 456)		1
-470A	141T4912-11		....HOUSING- (USED ON ITEM 456A)		1
-475	141T4912-6		....HOUSING- (USED ON ITEM 457)		1
-475A	141T4912-12		....HOUSING- (USED ON ITEM 457A)		1
480C	53677-1		..ARM ASSY-LINK (V84256)		1
			ATTACHING PARTS		
485	NAS6305D16		..BOLT		1
490	AN960-516L		..WASHER		1
495	BACN10JD105ASU		..NUT		1
497	MS24665-1013		..PIN-COTTER		1
498	BACB30PF4-14		..BOLT		1
499	AN960PD416L		..WASHER		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
499G	AN960PD10		..WASHER		1
499J	NAS1804-3		..NUT		1
			-------*-------		
506	B0500-038		DELETED		
520	BACS40R10W18		.SHIM	A-AB, AW-BG	2
-520A	BACS40R010C018F		.SHIM	AC-AR	2
521A	NAS6704P11		DELETED		
521B	NAS6604P11		.BOLT	A-T, AW-BG	1
521J	141T4953-1		.BOLT-ADJUSTMENT	U-AV, BH-BK	1
521N	BACW10BP5CD		.WASHER	U-AV, BH-BK	1
521R	NAS1423-5		.NUT	U-AV, BH-BK	2
521V	NAS1193K5CP		.LOCKING DEVICE	U-AV, BH-BK	1
522	BACW10BP4ACU		.WASHER	A-H,L ,M, AW-BG	1
-522A	BACW10BP4ACU		DELETED		
-522B	BACW10BP4CD		.WASHER	J,K, N-T	1
523A	BACW10P250C		.WASHER	A-H,L ,M, AW-BG	1
524	141T0012-29		.WASHER- (ALT FROM BACW10P250C)	A-H,L ,M, AW-BG	AR

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-524J	141T0012-29		.WASHER- (ALT FROM BACW10P250C) (OPT ITEM 524K)	J,K,N,P-T	AR
-524K	BACW10BP4DP		.WASHER- (OPT ITEM 524J)	J,K,N,P-T	AR
524P	141T4914-6		DELETED		
524Q	141T4914-13		DELETED		
-524R	BACW10BP4PTU		DELETED		
-524S	BACW10BP4DP		DELETED		
524U	141T4914-7		DELETED		
-524V	141T4914-8		DELETED		
524W	141T4914-9		DELETED		
-524X	141T4914-10		DELETED		
524Y	141T4914-11		DELETED		
-524Z	141T4914-12		DELETED		
525B	141T4813-15		.WINDOW ASSY- (FOR SPARES PROCURE 141T4813-23) (FOR SPARES PROCURE 141T4813-17)	C,E,AY,BB	1
-525C	141T4813-7		.WINDOW ASSY- (FOR SPARES PROCURE 141T4813-23)	A,L,AW,BF	1
-525D	141T4813-19		.WINDOW ASSY	G,BD	1
525E	141T4813-23		.WINDOW ASSY	J	1
525F	141T4813-501		.WINDOW ASSY	Q,R	1
-525H	141T4813-505		.WINDOW ASSY	N,U,W	1
-525J	141T4813-25		.WINDOW ASSY	X,AA,AC	1
-525K	141T4813-27		.WINDOW ASSY	AE	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-525L	141T4813-29		.WINDOW ASSY- (UPON CUSTOMER REQUEST ACRYLIC SHALL BE AVAILABLE FULLY I/W)	AG	1
-525M	141T4813-31		.WINDOW ASSY- (UPON CUSTOMER REQUEST ACRYLIC SHALL BE AVAILABLE FULLY I/W)	AJ,AP-AR	1
-525N	141T4813-33		.WINDOW ASSY	AS,AU BH,BJ	1
-525U	141W7413-1		DELETED		
-530B	141T4813-16		.WINDOW ASSY- (FOR SPARES PROCURE 141T4813-24) (FOR SPARES PROCURE 141T4813-18)	D,F AZ,BC	1
-530C	141T4813-8		.WINDOW ASSY- (FOR SPARES PROCURE 141T4813-24)	B,M, AX,BG	1
-530D	141T4813-20		.WINDOW ASSY- (FOR SPARES PROCURE 141T4813-24)	H,BE	1
-530E	141T4813-24		.WINDOW ASSY	K	1
-530F	141T4813-502		.WINDOW ASSY	S,T	1
-530H	141T4813-506		.WINDOW ASSY	P,V,Y	1
-530J	141T4813-26		.WINDOW ASSY	Z,AB, AD	1
-530K	141T4813-28		.WINDOW ASSY	AF	1
-530L	141T4813-30		.WINDOW ASSY- (UPON CUSTOMER REQUEST ACRYLIC SHALL BE AVAILABLE FULLY I/W)	AH	1
-530M	141T4813-32		.WINDOW ASSY- (UPON CUSTOMER REQUEST ACRYLIC SHALL BE AVAILABLE FULLY I/W)	AK-AN	1
-530N	141T4813-34		.WINDOW ASSY	AT,AV BI,BK	1
-530U	141W7413-2		DELETED		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
531	BACB28U8B048		..BUSHING (USED ON ITEMS 525B-525D, 530B-530D)		4
532	141T4924-1		..BUSHING (USED ON ITEMS 525B-525D, 530B-530D)		4
-532F	141T0012-36		..STRIP-RUB (USED ON ITEMS 525D, 530D)		1
532H	141T0012-23		..STRIP-RUB (USED ON ITEMS 525B, 525C,530C,530D)		1
532J	BACR15CE4D		..RIVET- (SIZE DETERMINE ON INST) (USED ON ITEMS 525B-525D, 530B-530D)		8
533A	141T4813-11		..WINDOW ASSY (USED ON ITEM 525B)		1
-533B	141T4813-5		..WINDOW ASSY (USED ON ITEM 525C)		1
-533C	141T4813-11		..WINDOW ASSY- (OPT) (USED ON ITEM 525D)		1
-533D	141T4813-21		..WINDOW ASSY- (OPT) (USED ON ITEM 525D)		1
-534A	141T4813-12		..WINDOW ASSY (USED ON ITEM 530B)		1
-534B	141T4813-6		..WINDOW ASSY (USED ON ITEM 530C)		1
-534C	141T4813-12		..WINDOW ASSY- (OPT) (USED ON ITEM 530D)		1
-534D	141T4813-22		..WINDOW ASSY- (USED ON ITEM 530D)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
535A	141T4810-11		...WINDOW ASSY (USED ON ITEMS 533B-533D)		1
-540A	141T4810-12		...WINDOW ASSY (USED ON ITEMS 534B-534D)		1
			ATTACHING PARTS		
545A	BACB30NN4K27		...BOLT (USED ON ITEMS 533B-533D, 534B-534D)		79
			-------*-------		
560A	141T4815-9		....RETAINER-SEAL (USED ON ITEM 535A)		1
-561A	141T4815-10		....RETAINER-SEAL (USED ON ITEM 540A)		1
562A	141T4815-11		....RETAINER-SEAL (USED ON ITEM 535A)		1
-563A	141T4815-12		....RETAINER-SEAL (USED ON ITEM 540A)		1
564A	141T4815-13		....RETAINER-SEAL (USED ON ITEM 535A)		1
-565A	141T4815-14		....RETAINER-SEAL (USED ON ITEM 540A)		1
566A	141T4815-15		....RETAINER-SEAL (USED ON ITEM 535A)		1
-567A	141T4815-16		....RETAINER-SEAL (USED ON ITEM 540A)		1
570A	141T4814-3		....SEAL-MOISTURE (USED ON ITEM 535A)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-575A	141T4814-4		....SEAL-MOISTURE (USED ON ITEM 540A)		1
580	NAS43DD5-116		....SPACER		79
585	500205-1		....CAP-SENSOR TERM. (V12035)		2
590	500204-1		....CAP-PWR TERM. (V12035)		1
595	500007-02		....TERMINAL-SENSOR (V12035)		4
600	500007-1		....TERMINAL-PWR (V12035)		2
605	E1190-14		....SENSOR-CONT (V12035)		1
610	E1190-14		....SENSOR-SPARE (V12035)		1
615A	141T4852-11		...FRAME ASSY- (USED ON ITEM 533B)		1
-615B	141T4852-5		...FRAME ASSY- (OPT) (USED ON ITEM 533B)		1
-615C	141T4852-11		...FRAME ASSY- (OPT) (USED ON ITEM 533C)		1
-615D	141T4852-13		...FRAME ASSY- (OPT) (USED ON ITEM 533C)		1
-615E	141T4852-21		...FRAME ASSY- (USED ON ITEM 535C)		1
-617	141T4852-11		...FRAME ASSY- (OPT) (USED ON ITEM 533D)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-617A	141T4852-13		...FRAME ASSY- (OPT) (USED ON ITEM 533D)		1
-617B	141T4852-23		...FRAME ASSY- (USED ON ITEM 533D)		1
-620A	141T4852-12		...FRAME ASSY- (USED ON ITEM 534B)		1
-620B	141T4852-6		...FRAME ASSY- (OPT) (USED ON ITEM 534B)		1
-620C	141T4852-12		...FRAME ASSY- (OPT) (USED ON ITEM 534C)		1
-620D	141T4852-14		...FRAME ASSY- (OPT) (USED ON ITEM 534C)		1
-620E	141T4852-22		...FRAME ASSY- (USED ON ITEM 534C)		1
-622	141T4852-12		...FRAME ASSY- (OPT) (USED ON ITEM 534D)		1
-622A	141T4852-14		...FRAME ASSY- (OPT) (USED ON ITEM 534D)		1
-622B	141T4852-24		...FRAME ASSY- (USED ON ITEM 534D)		1
625	MS21209F4-15		....INSERT		79
630A	141T4852-9		....FITTING- (USED ON ITEMS 615A, 615C, 617)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-630B	141T4852-15		....FITTING- (USED ON ITEMS 615D, 617A)		1
-630C	141T4852-7		....FITTING- (USED ON ITEM 615B)		1
-630D	141T4852-19		....FITTING- (USED ON ITEM 615E)		1
-630E	141T4852-25		....FITTING- (USED ON ITEM 617B)		1
-635A	141T4852-10		....FITTING- (USED ON ITEMS 620A, 620C, 622)		1
-635B	141T4852-8		....FITTING- (USED ON ITEM 620B)		1
-635C	141T4852-16		....FITTING- (USED ON ITEMS 620D, 622A)		1
-635D	141T4852-20		....FITTING- (USED ON ITEM 620E)		1
-635E	141T4852-26		....FITTING- (USED ON ITEM 622B)		1
640B	BACB28W6B049		....BUSHING		2
645	BACB28U22B050		....BUSHING		2
650	MS21209F1-15		....INSERT		4
652	MS21209F1-20		....INSERT		1
653	BACR15BA3AD		....RIVET- (SIZE DETERMINE ON INST)		16
654	BACR15BB3AD		....RIVET- (SIZE DETERMINE ON INST)		6

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
655	BACN10JN3		....NUTPLATE-		6
657	BACN10JR3F		....NUTPLATE-		4
660	NS103193-02		....NUTPLATE-		1
665	BACS18G50B3		....SPACER		2
670A	BACS18G43B3		....SPACER		1
672	BACS18G47B3		....SPACER		1
673	NAS1802-06-9		..SCREW	J,K, N-AZ	2
674	NAS1802-3-9		..SCREW	J,K, N-AZ	4
676A	MS35338-41		..WASHER (OPT ITEM 676B)	J,K, N-AZ	4
676B	MS35333-38		..WASHER (OPT ITEM 676A)	J,K, N-AZ	4
678A	MS35338-43		..WASHER (OPT ITEM 678B)	J,K, N-AZ	2
678B	MS35333-39		..WASHER (OPT ITEM 678A)	J,K, N-AZ	2
679	141T4810-15		..WINDOW ASSY (ITEM 679G OR 679J CAN REPLACE ITEMS 679,679C) (USED ON ITEMS 525E, 525F)		1
-679A	141T4810-17		..WINDOW ASSY- (ITEM 679A OPT TO ITEM 679E FOR IN-SERVICE AIRPLANES ONLY) (ITEM 679G OR 679J CAN REPLACE ITEM 679A) (USED ON ITEM 525K)		1
-679B	141T4810-19		..WINDOW ASSY- (UPON CUSTOMER REQUEST ACRYLIC SHALL BE AVAILABLE FULLY I/W) (ITEM 679B OPT TO ITEM 679F FOR IN-SERVICE AIRPLANES ONLY) (ITEM 679G OR 679J CAN REPLACE ITEM 679B) (USED ON ITEM 525L)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-679C	141T4810-15		..WINDOW ASSY- (ITEM 679C OPT TO ITEM 679D FOR IN-SERVICE AIRPLANES ONLY) (ITEM 679G OR 679J CAN REPLACE ITEMS 679,679C) (USED ON ITEM 525J)		1
-679D	141T4810-21		..WINDOW ASSY- (ITEM 679C OPT TO ITEM 679D FOR IN-SERVICE AIRPLANES ONLY) (USED ON ITEM 525J)		1
-679E	141T4810-21		..WINDOW ASSY- (ITEM 679A OPT TO ITEM 679E FOR IN-SERVICE AIRPLANES ONLY) (USED ON ITEM 525K)		1
-679F	141T4810-21		..WINDOW ASSY- (ITEM 679B OPT TO ITEM 679F FOR IN-SERVICE AIRPLANES ONLY) (USED ON ITEM 525L)		1
-679G	141T4001-1		..WINDOW ASSY- (UPON CUSTOMER REQUEST ACRYLIC SHALL BE AVAILABLE FULLY I/W) (OPT ITEM 679H) (ITEM 679G CAN REPLACE ITEMS 679,679A, 679B,679C) (USED ON ITEM 525M) (FOR DETAILS SEE FIG. 2)		1
-679H	141T4001-29		..WINDOW ASSY- (OPT ITEM 679G) (FOR DETAILS SEE FIG. 2)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-679J	141T4001-31		..WINDOW ASSY- (ITEM 679J CAN REPLACE ITEMS 679,679A, 679B,679C) (USED ON ITEM 525N) (FOR DETAILS SEE FIG. 2)		1
-679L	141T4810-16		..WINDOW ASSY (ITEM 679T OR 679V CAN REPLACE ITEMS 679L,679P) (USED ON ITEMS 530E, 530F)		1
-679M	141T4810-18		..WINDOW ASSY- (ITEM 679M OPT TO ITEM 679R FOR IN-SERVICE AIRPLANES ONLY) (ITEM 679T OR 679V CAN REPLACE ITEM 679M) (USED ON ITEM 530K)		1
-679N	141T4810-20		..WINDOW ASSY- (UPON CUSTOMER REQUEST ACRYLIC SHALL BE AVAILABLE FULLY I/W) (ITEM 679N OPT TO ITEM 679S FOR IN-SERVICE AIRPLANES ONLY) (ITEM 679T OR 679V CAN REPLACE ITEM 679N) (USED ON ITEM 530L)		1
-679P	141T4810-16		..WINDOW ASSY- (ITEM 679P OPT TO ITEM 679Q FOR IN-SERVICE AIRPLANES ONLY) (USED ON ITEMS 530H, 530J)		1
-679Q	141T4810-22		..WINDOW ASSY- (ITEM 679P OPT TO ITEM 679Q FOR IN-SERVICE AIRPLANES ONLY) (USED ON ITEMS 530H, 530J)		1
-679R	141T4810-22		..WINDOW ASSY- (ITEM 679M OPT TO ITEM 679R FOR IN-SERVICE AIRPLANES ONLY) (USED ON ITEM 530K)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-679S	141T4810-22		..WINDOW ASSY- (ITEM 679N OPT TO ITEM 679S FOR IN-SERVICE AIRPLANES ONLY) (USED ON ITEM 530L)		1
-679T	141T4001-2		..WINDOW ASSY- (UPON CUSTOMER REQUEST ACRYLIC SHALL BE AVAILABLE FULLY I/W) (OPT ITEM 679U) (ITEM 679T CAN REPLACE ITEMS 679L,679M,679N, 679P) (USED ON ITEM 530M) (FOR DETAILS SEE FIG. 2)		1
-679U	141T4001-30		..WINDOW ASSY- (OPT ITEM 679T) (FOR DETAILS SEE FIG. 2)		1
-679V	141T4001-32		..WINDOW ASSY- (ITEM 679V CAN REPLACE ITEMS 679L,679M,679N, 679P) (USED ON ITEM 530N) (FOR DETAILS SEE FIG. 2)		1
680	BACS18G47B3		DELETED		
680E	141T4810-15		DELETED		
-680F	141T4810-17		DELETED		
-680G	141T4810-16		DELETED		
-680H	141T4810-18		DELETED ATTACHING PARTS		
680J	BACB30NN4K27		..BOLT -------*-------		79
680L	141T4815-9		...RETAINER-SEAL (USED ON ITEMS 679-679F)		1
-681	141T4815-10		...RETAINER-SEAL (USED ON ITEMS 679L-679S)		1
681C	141T4815-11		...RETAINER-SEAL (USED ON ITEMS 679-679F)		1
-681E	141T4815-12		...RETAINER-SEAL (USED ON ITEMS 679L-679S)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
681G	141T4815-13		...RETAINER-SEAL (USED ON ITEMS 679-679F)		1
-681J	141T4815-14		...RETAINER-SEAL (USED ON ITEMS 679L-679S)		1
681L	141T4815-15		...RETAINER-SEAL (USED ON ITEMS 679-679F)		1
-682	141T4815-16		...RETAINER-SEAL (USED ON ITEMS 679L-679S)		1
682C	141T4814-3		...SEAL-MOISTURE (USED ON ITEMS 679-679F)		1
-682E	141T4814-4		...SEAL-MOISTURE (USED ON ITEMS 679L-679S)		1
682G	NAS43DD5-116		...SPACER		79
682J	500205-1		...CAP-SENSOR TERM. (V12035) (USED ON ITEMS 679, 679A, 679C, 679L, 679M, 679P)		2
682L	500204-1		...CAP-PWR TERM. (V12035) (USED ON ITEMS 679, 679A, 679C, 679L, 679M, 679P)		1
682T	500206-1		...CAP-TERM. (V12035) (USED ON ITEMS 679D, 679E, 679F, 679Q, 679R, 679S)		1

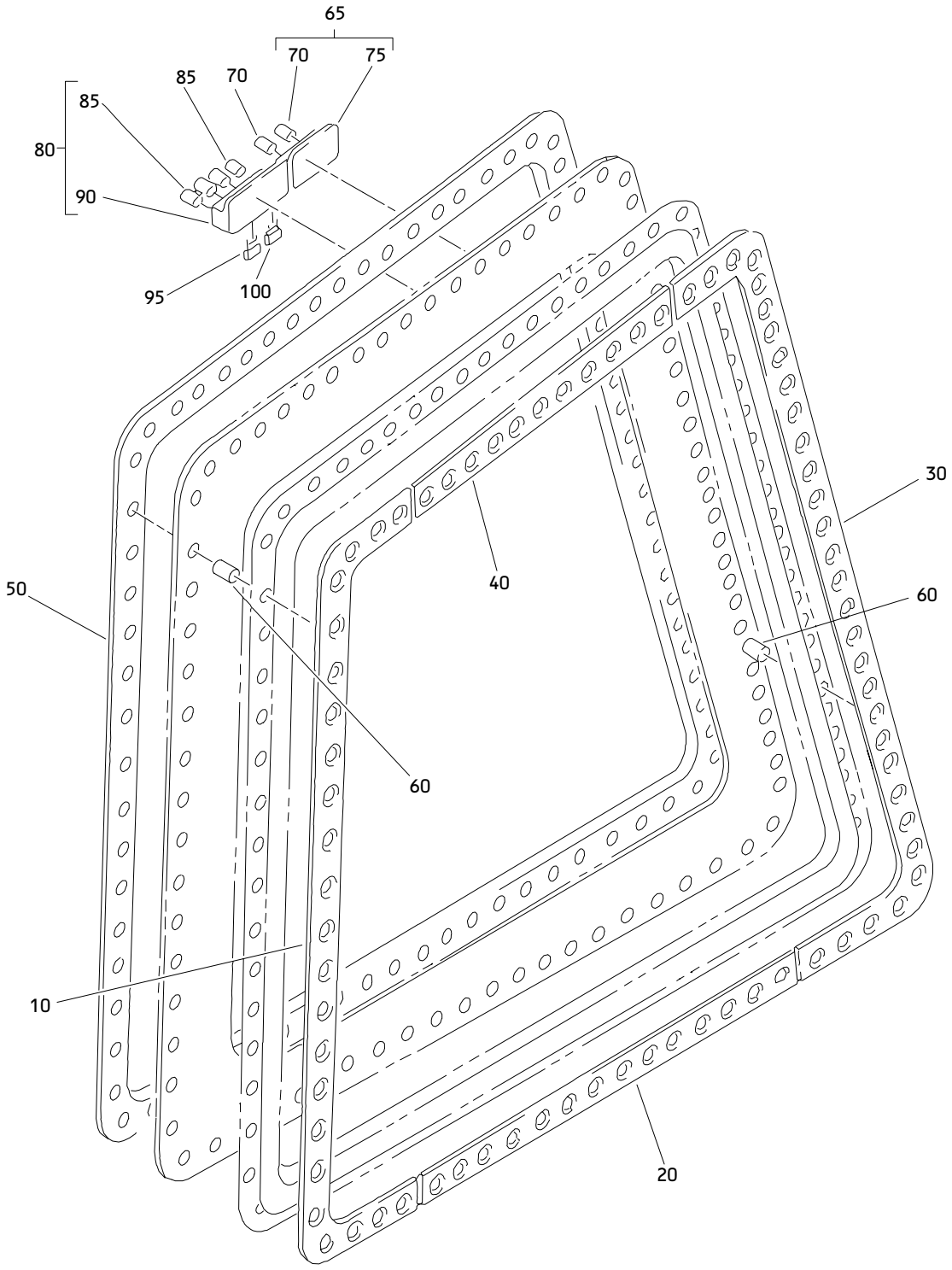
FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
683	500007-02		...TERMINAL-SENSOR (V12035) (USED ON ITEMS 679-679F, 679L-679S)		4
683C	500007-1		...TERMINAL-PWR (V12035) (USED ON ITEMS 679-679F, 679L-679S)		2
683E	E1190-14		...SENSOR-CONT (V12035) (USED ON ITEMS 679-679F, 679L-679S)		1
683G	E1190-14		...SENSOR-SPARE (V12035) (USED ON ITEMS 679-679F, 679L-679S)		1
683H	141T4852-35		..FRAME ASSY (USED ON ITEMS 525J-525N)		1
-683K	141T4852-36		..FRAME ASSY (USED ON ITEMS 530J-530N)		1
-683M	141T4852-31		..FRAME ASSY (USED ON ITEM 525F)		1
-683N	141T4852-32		..FRAME ASSY (USED ON ITEM 530F)		1
-683R	141T4852-39		..FRAME ASSY (USED ON ITEM 525H)		1
-683S	141T4852-40		..FRAME ASSY (USED ON ITEM 530H)		1
-683T	141T4852-27		..FRAME ASSY (USED ON ITEM 525E)		1
-683U	141T4852-28		..FRAME ASSY (USED ON ITEM 530E)		1
683V	MS21209F4-15		...INSERT		79
684H	BACB28W6B049		...BUSHING		2
684J	BACB28U22B050		...BUSHING		2
684K	BACB28U8B048		...BUSHING		4
684L	MS21209F1-15		...INSERT		4
684M	MS21209F1-20		...INSERT		1
684N	BACR15BA3AD		...RIVET- (SIZE DETERMINE ON INST)		20
684P	BACR15BB3AD		...RIVET- (SIZE DETERMINE ON INST)		8

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
684Q	BRFM20A3		...NUTPLATE- (V52828) (SPEC BACN10JN3) (OPT MF1000-3BAC (V15653)) (OPT NS103218-02 (V80539)) (OPT RMF9201M3 (V72962)) (OPT VN252A02 (V92215)) (OPT MF1000-3BAC (V15653)) (OPT MF53049-3 (V15653))		6
684R	F5000-3BAC		...NUTPLATE- (V15653) (SPEC BACN10JR3F) (OPT NS103203-02 (V80539)) (OPT RMF9201-3 (V72962)) (OPT T8091S1032 (V11815)) (OPT VN152A1-02 (V92215)) (OPT BRF200A3 (V52828))		5
684S	NS103193-02		...NUTPLATE- (V80539) (SPEC BACN10KE3D) (OPT F51754-3 (V15653))		1
684T	BACS18G50B3		...SPACER		2
684U	BACS18G55B3		...SPACER		1
684V	BACS18G60B3		...SPACER		2
684W	141T4934-4		...PLATE-SERRATED		1
684X	141T4924-1		...BUSHING		4
684Y	BACR15CE4AD		...RIVET- (SIZE DETERMINE ON INST)		8
684Z	141T4821-1		DELETED		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
685A	141T4852-33		DELETED		
-685B	141T4852-41		DELETED		
-685C	141T4852-37		DELETED		
-686	141T4852-34		DELETED		
-686A	141T4852-42		DELETED		
-686B	141T4852-38		DELETED		
686D	141T4821-1		...STRIP (USED ON ITEMS 683M-683S)		1
-686E	141T4821-3		...STRIP (USED ON ITEMS 683H,683K)		1
687A	141T4852-33		...FITTING (USED ON ITEM 683M)		1
-687B	141T4852-41		...FITTING (USED ON ITEMS 683H,683R)		1
-687C	141T4852-37		...FITTING (USED ON ITEM 683T)		1
-688	141T4852-34		...FITTING (USED ON ITEM 683N)		1
-688A	141T4852-42		...FITTING (USED ON ITEM 683J,683S)		1
-688B	141T4852-38		...FITTING (USED ON ITEM 683U)		1
689	141T4934-4		.PLATE-SERRATED	A-H,L,M,AW-BG	1
690B	141T4934-9		.BRACKET ASSY	A-AK,AM,AQ AW-BG	1
-690C	141T4934-11		.BRACKET ASSY	AL,AN,AP,AR,AS,AU,BH BJ	1
			ATTACHING PARTS		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
695	BACB30NU4K8		.BOLT		2
-695A	BACB30VF4K8		DELETED		
700	AN960-416L		.WASHER		2
705	BACN10GW4AS		.NUT	A-H,L ,M, AW-BG	2
-705A	MS21042L4		.NUT	J,K, N-T, V-AV, BH-BK	2
-705B	H52732-4CD		DELETED		
710B	HL440UC8-10		DELETED		
710C	BACB30FM8A8		.BOLT		1
715A	141T4934-8		..ROLLER (USED ON ITEM 690B)		1
-715B	141T4934-10		..ROLLER (USED ON ITEM 690C)		1
720	NAS620C416L		..WASHER		1
725	MS21043-4		DELETED		
725A	BACN10JC4C		..NUT		1
728	BACB28Y4E026		..BUSHING		1
730	141T4934-2		..BRACKET-ROLLER		1
735	NAS6603-7		DELETED		
740	AN960JD10LL		DELETED		
745	232W1801-25		DELETED		
-750	232W1801-26		DELETED		

*[1] Rivet grip length may be determined on installation.



No. 2 Laminated Window Assembly
Figure 2

E96157

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
-1A	141T4001-1		WINDOW ASSY-	A	RF
-1B	141T4001-29		WINDOW ASSY-	C	RF
-1C	141T4001-31		WINDOW ASSY	E	RF
-5	141T4001-2		WINDOW ASSY-	B	RF
-5A	141T4001-30		WINDOW ASSY-	D	RF
-5B	141T4001-32		WINDOW ASSY	F	RF
10	141T4002-7		.RING-RETAINER	A	1
-10A	141T4002-15		.RING-RETAINER	CE	1
-15	141T4002-8		.RING-RETAINER	B	1
-15A	141T4002-16		.RING-RETAINER	DF	1
20	141T4002-5		.RING-RETAINER	A	1
-20A	141T4002-13		.RING-RETAINER	CE	1
-25	141T4002-6		.RING-RETAINER	B	1
-25A	141T4002-14		.RING-RETAINER	DF	1
30	141T4002-3		.RING-RETAINER	A	1
-30A	141T4002-11		.RING-RETAINER	CE	1
-35	141T4002-4		.RING-RETAINER	B	1
-35A	141T4002-12		.RING-RETAINER	DF	1
40	141T4002-1		.RING-RETAINER	A	1
-40A	141T4002-9		.RING-RETAINER	CE	1
-45	141T4002-2		.RING-RETAINER	B	1
-45A	141T4002-10		.RING-RETAINER	DF	1
50	141T4001-23		.FILLER- (V53117)	ACE	1
-55	141T4001-24		.FILLER- (V53117)	BDF	1
60	NAS43DD5-116FC		.SPACER		79
65	141T4003-3		.BLOCK ASSY-TERM.	A-D	1
-65A	22-17-4920		.TERMINAL-PWR (V53117) (OPT)	A-D	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
-65B	22-17-4920		.TERMINAL-PWR (V53117)	EF	1
70	141T4003-8		..TERMINAL-PWR (USED ON ITEM 65)		2
75	141T4003-4		..TERMINAL- (USED ON ITEM 65)		1
80	141T4003-1		.BLOCK ASSY-TERM.	A-D	1
-80A	22-17-4922		.TERMINAL-SENSOR (V53117) (OPT)	A-D	1
-80B	22-17-4922		.TERMINAL-SENSOR (V53117)	EF	1
85	141T4003-7		..TERMINAL-SENSOR (USED ON ITEM 80)		4
90	141T4003-2		..CAP- (USED ON ITEM 80)		1
95	PSE2-1		.SENSOR-CONT (V53117)		1
100	PSE2-1		.SENSOR-SPARE (V53117)		1