



STANDARD OVERHAUL PRACTICES MANUAL

HOW TO INSTALL NAMEPLATE STRAPS AND SEALS

**PART NUMBER
NONE**

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20-50-21

Page 1
Jul 01/2009



STANDARD OVERHAUL PRACTICES MANUAL

Revision No. 5
Jul 01/2009

To: All holders of HOW TO INSTALL NAMEPLATE STRAPS AND SEALS 20-50-21.

Attached is the current revision to this STANDARD OVERHAUL PRACTICES MANUAL

The STANDARD OVERHAUL PRACTICES MANUAL is furnished either as a printed manual, on microfilm, or digital products, or any combination of the three. This revision replaces all previous microfilm cartridges or digital products. All microfilm and digital products are reissued with all obsolete data deleted and all updated pages added.

For printed manuals, changes are indicated on the List of Effective Pages (LEP). The pages which are revised will be identified on the LEP by an R (Revised), A (Added), O (Overflow, i.e. changes to the document structure and/or page layout), or D (Deleted). Each page in the LEP is identified by Chapter-Section-Subject number, page number and page date.

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STANDARD OVERHAUL PRACTICES MANUAL

Location of Change

Description of Change

NO HIGHLIGHTS

20-50-21

HIGHLIGHTS

Page 1

Jul 01/2009



STANDARD OVERHAUL PRACTICES MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
TITLE PAGE					
O 1	Jul 01/2009				
2	BLANK				
20-50-21 TRANSMITTAL LETTER					
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20-50-21 HIGHLIGHTS					
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20-50-21 EFFECTIVE PAGES					
1	Jul 01/2009				
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20-50-21 CONTENTS					
1	Nov 01/2006				
2	BLANK				
20-50-21 REVISION RECORD					
1	Jul 01/2005				
2	Jul 01/2005				
20-50-21 RECORD OF TEMPORARY REVISIONS					
1	Jul 01/2005				
2	Jul 01/2005				
20-50-21 INTRODUCTION					
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20-50-21 SUBJECT					
1	Nov 01/2005				
2	Jul 01/2005				
3	Jul 01/2005				
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A = Added, R = Revised, D = Deleted, O = Overflow

20-50-21

EFFECTIVE PAGES

Page 1

Jul 01/2009



STANDARD OVERHAUL PRACTICES MANUAL

TABLE OF CONTENTS

<u>Paragraph Title</u>	<u>Page</u>
HOW TO INSTALL NAMEPLATE STRAPS AND SEALS	1
INTRODUCTION	1
MATERIALS	1
EQUIPMENT	1
INSTALLATION	1

20-50-21

CONTENTS

Page 1

Nov 01/2006



STANDARD OVERHAUL PRACTICES MANUAL

All temporary revisions to this manual will be accompanied by a cover sheet bearing the temporary revision number. Enter the temporary revision number in numerical order, together with the temporary revision date, the date the temporary revision is inserted and the initials of the person filing. When the temporary revision is incorporated or cancelled, and the pages are removed, enter the date the pages are removed and the initials of the person who removed the temporary revision.

Temporary Revision		Inserted		Removed		Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials	Date	Initials	Number	Date	Date	Initials



STANDARD OVERHAUL PRACTICES MANUAL

Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

20-50-21

RECORD OF TEMPORARY REVISION

Page 2

Jul 01/2005



STANDARD OVERHAUL PRACTICES MANUAL

INTRODUCTION

1. General

- A. The instructions in this manual tell how to do standard shop procedures during maintenance functions from simple checks and replacement to complete shop-type repair.
- B. This manual is divided into separate sections:
 - (1) Title Page
 - (2) Transmittal Letter
 - (3) Highlights
 - (4) Effective Pages
 - (5) Contents
 - (6) Revision Record
 - (7) Record of Temporary Revisions
 - (8) Introduction
 - (9) Procedures
- C. Refer to SOPM 20-00-00 for a definition of standard industry practices, vendor names and addresses, and an explanation of the True Position Dimensioning symbols used.
- D. The data is general. It is not about all situations or specific installations. Use it as a guide to help you write minimum standards.
- E. If the component overhaul instructions are different from the data in this subject, use the component overhaul instructions.

20-50-21

INTRODUCTION

Page 1

Jul 01/2005



STANDARD OVERHAUL PRACTICES MANUAL

HOW TO INSTALL NAMEPLATE STRAPS AND SEALS

1. INTRODUCTION

- A. The data in this subject comes from Boeing Part Standard BACS11AK and drawing 69B80300. These straps and seals are used to hold nameplates and related instruction placards on large pieces of equipment such as hydraulic actuators and landing gear shock struts.
- B. The data is general. It is not about all situations or specific installations. Use this data to help you write minimum requirements.
- C. Refer to SOPM 20-00-00 for a full list of all the vendor names and addresses.
- D. This subject tells how to install these types of straps and seals:
 - (1) BACS11AK seals, which are crimped on the ends of the straps to hold them tight around the cylinder.
 - (2) 69B80300 straps, which are pulled tight and bent over to hold the nameplate in position.

2. MATERIALS

NOTE: Equivalent substitutes can be used.

- A. Seals – BACS11AK-series, or as specified by overhaul instructions.
- B. Straps – BACS38E, or as specified by overhaul instructions.
- C. Straps – 69B80300-series.
- D. Nameplate – as specified by overhaul instructions.

3. EQUIPMENT

NOTE: Equivalent substitutes can be used.

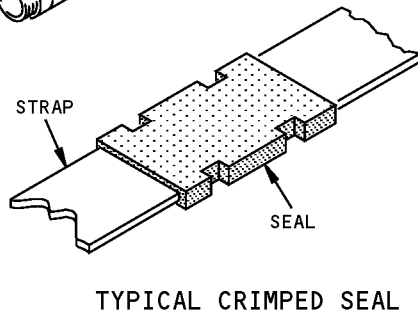
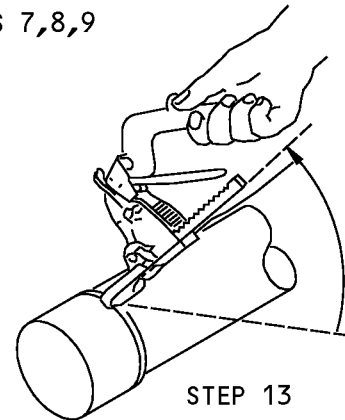
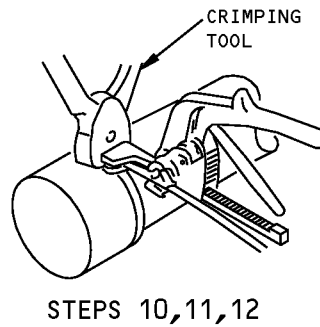
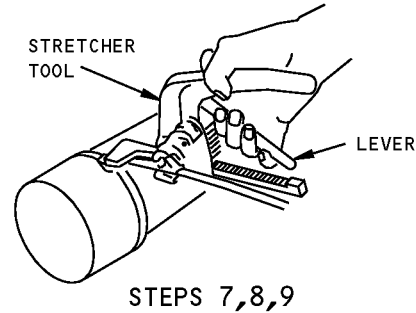
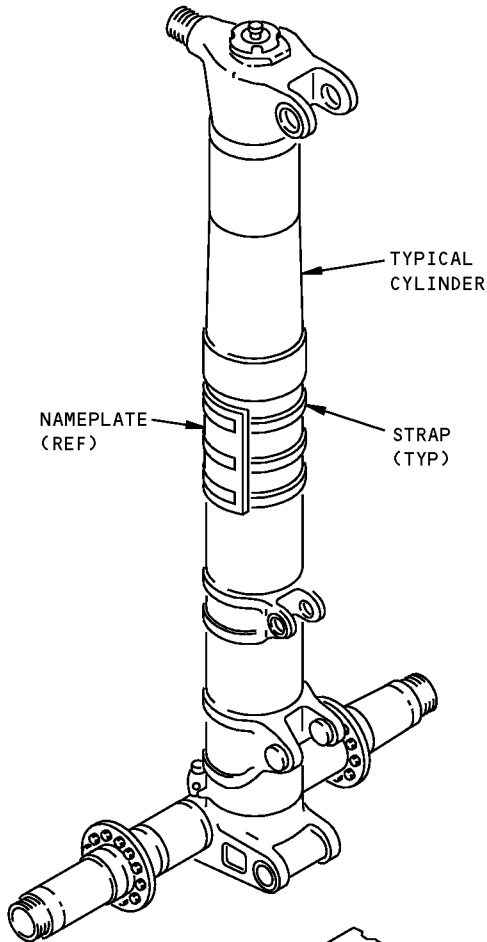
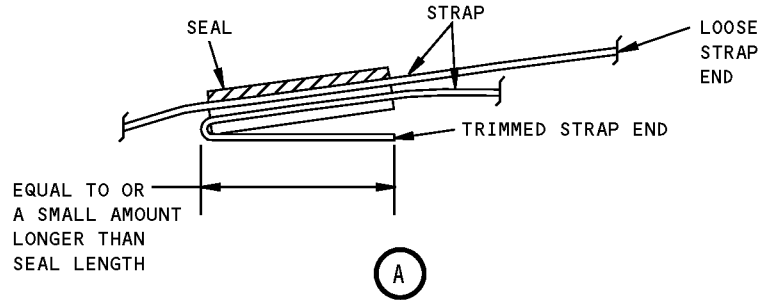
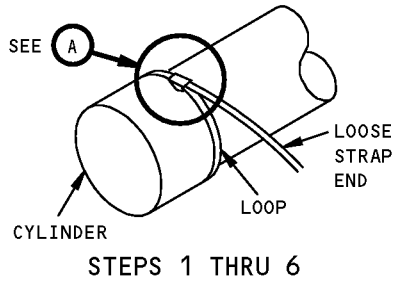
- A. Crimping tool, 1/2 inch – ASR12, V6F140 (Replaces C2A4).
- B. Stretcher tool – B2AO, V6F140.
- C. Soft-nosed hammer.

4. INSTALLATION

- A. Be sure the replacement nameplate has the data that was on the old nameplate. If necessary, write the data on the nameplate with markers, vibro-engravers, steel stamps, or other procedures as specified by the overhaul instructions.
- B. Clean the mating surface of the cylinder where the nameplate and its straps will be installed.
- C. Apply tape or equivalent protection as specified.
- D. Install the nameplate with the applicable straps and seals as shown (Figure 1, Figure 2).
- E. If specified, give the nameplate the protection of Type 41 clear coating (F-21.34) (SOPM 20-41-01).

20-50-21

STANDARD OVERHAUL PRACTICES MANUAL



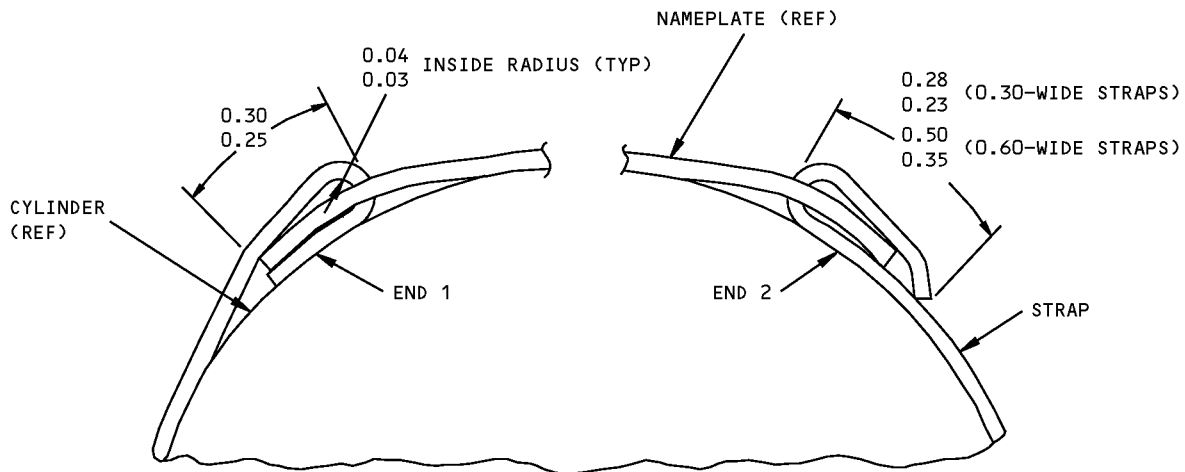
1. CUT OFF THE END OF THE STRAP IF IT HAS BURRS. DO NOT CUT THE STRAP TOO SHORT.
2. THREAD THE STRAP THROUGH THE SEAL (SLOTTED SIDE OF THE SEAL DOWN).
3. WRAP THE STRAP AROUND THE CYLINDER.
4. THREAD THE STRAP THROUGH THE SEAL AGAIN UNDER THE FIRST SECTION OF THE STRAP.
5. BEND THE CUT END OF THE STRAP UNDER THE SEAL.
6. REMOVE THE SLACK FROM THE LOOP AROUND THE CYLINDER.
7. ALIGN THE STRAP TO 88-92° WITH THE AXIS OF THE CYLINDER.
8. PUSH STRETCHER TOOL B2A0 ONTO STRAP THROUGH SLOT IN TOOL AND UNDER GRIPPING DOG.
9. OPERATE THE STRETCHER LEVER UP AND DOWN TO PUT TENSION ON THE STRAP.
10. PUT CRIMPING TOOL ASR12 OR C2A4 ON THE SEAL.
11. CLOSE THE CRIMPING TOOL HANDLES TO THEIR STOPS.
12. OPEN THE CRIMPING TOOL HANDLES TO RELEASE THE TOOL.
13. TILT THE STRETCHER TOOL FORWARD TO BREAK OFF THE STRAP AT THE SEAL.

Nameplate, Seal and Strap Installation
Figure 1

20-50-21



STANDARD OVERHAUL PRACTICES MANUAL



NOTE: THE STRAP CAN BE USED ONLY ONCE. MAKE SURE THE STRAP AND NAMEPLATE ARE TIGHT ON THE MOUNTING SURFACE.

1. BEND THE NAMEPLATE TO A RADIUS SLIGHTLY SMALLER THAN THE CYLINDER RADIUS.
2. BEND THE CORNERS OF THE NAMEPLATE SLIGHTLY TOWARDS THE MOUNTING SURFACE.
3. BEND STRAP END 1, PUT THRU THE HOLE IN THE NAMEPLATE AND BEND THE STRAP END DOWN AS SHOWN.
4. HOLD THE NAMEPLATE ON THE CYLINDER AND PUT THE STRAP THRU THE HOLE.
5. SLIGHTLY BEND STRAP END 2 WHILE YOU PULL TO MAKE THE NAMEPLATE AND STRAP TIGHT.
6. CUT STRAP END 2 TO THE DIMENSION SHOWN.
7. WHILE YOU PULL, USE A SUITABLE TOOL TO MAKE THE FINAL BEND OF STRAP END 2 AND TO MAKE THINGS TIGHTER. BE CAREFUL NOT TO TEAR THE NAMEPLATE HOLE BY TOO MUCH TENSION.
8. BEND STRAP END 2 DOWN OVER THE EDGE OF THE NAMEPLATE AND TAP LIGHTLY WITH A SOFT NOSED HAMMER TO GET A TIGHT FIT AGAINST THE CYLINDER AS SHOWN.

ALL DIMENSIONS ARE IN INCHES.

Nameplate Strap 69B80300 Installation
Figure 2

20-50-21