

PICTURE SHEET DATA LIST	<b>BOEING</b>	<b>CORPORATE OFFICES SEATTLE, WA 98124</b>	EXPORT CONTROL COM	CAGE 81205	NUMBER 141A4820 SHEET DL	REV C	SHEET 1 OF 4	
LIST TITLE RELEASE MECHANISM INSTL - EMERGENCY EXIT, SLIDING WINDOW					MODEL	CONTRACT NUMBER		DATE 04-03-2008
FLAGNOTES AND GEOMETRY RELATED NOTES IN THIS REPORT SUPERSEDE THE DRAWING SHEET PL FOR THIS DRAWING								
PIN/ITEM 1414-8200								
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. . . REVISIONS . . .								
REV	REVISION DESCRIPTION	APPROVED DATE	CHANGE NUMBER	PHASE		CLASS		
C	REV C IDENTICAL TO REV B EXCEPT ADDED SHTS 5, 6, AND 8 TO GN8. REASON: PRODUCTION FACILITY INADVERTANT HOSE DISCONNECT FROM 66-9201 AND 66-4742 FITTINGS. REF: ELRE022278 PROD INFO: AIRPLANES/PARTS MUST COMPLY. NO REWORK OR RETEST REQUIRED. M-NOTE: NO COMMITMENT REQUIRED. SPIRIT AEROSYSTEMS TO INCORPORATE AT LINE UNIT 2680 AND ON, REFERENCE FIRING ORDER RS148R5, GARY NEEDHAM, FAPP, 526-7754, 03/04/2008. LCCE37747, DAVID HOLLOWAY, GROUP 561, 03/10/08.	04-03-2008	LCCE	37747		NA		
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. . . FLAGNOTES . . .								
FLAG NOTE NUMBER	TITLE	DESCRIPTION						
1	FL1	INSTALL BACP18BC AND MS24665 COTTER PINS PER BAC5018.						
2	FL2	LUBRICATE ALL CONTACT SURFACES OF MECHANISMS PER BAC5008 USING MIL-G-21164 GREASE.						
3	FL3	INSTALL BACC15AJ* CLIPS PER BAC5018.						
4	FL4	FINISH F-20.02 AFTER INSTALLATION, EXPOSED SURFACE OF SHAFT ONLY.						
5	FL5	USE SHIM IF AND AS REQUIRED TO MAINTAIN A .015 MINIMUM GAP BETWEEN 141A4823-3 AND HEAD OF						
(CONTINUED ON NEXT PAGE)								
BOEING PROPRIETARY - SEE STANDARD NOTES FOR RESTRICTIONS ON DATA USE OR DISCLOSURE								

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LIST TITLE RELEASE MECHANISM INSTL - EMERGENCY EXIT, SLIDING WINDOW					MODEL	CONTRACT NUMBER		DATE 04-03-2008
(CONTINUED FROM PRECEDING PAGE)								
FLAG NOTE NUMBER	TITLE		DESCRIPTION					
			BACB30NM3K8 BOLT. DELAMINATE AS REQUIRED. FINISH F-20.05.					
6	FL6		IF VISUAL EXAMINATION INDICATES THE LOCKING PIN HOOK LIP HAS NOT FULLY ENGAGED THE INTERIOR OF THE TURNBUCKLE BODY, USE A NON-METALLIC TOOL TO FULLY SEAT THE CLIP. VERIFY OTHER LOCKING CLIP IS STILL ENGAGED WITH THE INTERIOR OF THE TURNBUCKLE BODY IF INSTALLED.					
* * * * * . . . GEOMETRY RELATED NOTES . . .								
	TITLE		DESCRIPTION					
	FINISH - SEQUENCE 0		F-20.02 APPLY ONE COAT OF BMS 10-11, TYPE I PRIMER IN ACCORDANCE WITH BAC 5736. APPLY TO THE INDICATED SURFACE.					
	FINISH - SEQUENCE 0		F-20.05 INSTALL WITH BMS 10-11, TYPE I PRIMER MIXED IN ACCORDANCE WITH BAC 5736, EITHER WET OR DRY. FOR LAMINATED SHIMS, COMPLETE DELAMINATION BEFORE APPLYING COATING. IF NO LAMINATIONS ARE REMOVED, APPLY FINISH PRIOR TO INSTALLATION. APPLY TO THE INDICATED SURFACE.					
	GN2		BREAK SHARP EDGES PER BAC5300.					
	GN3		FUNCTIONAL TEST (SEE GN4 THRU GN8).					
	GN4		(REF GN3) OBJECTIVE: TO CHECK RELEASE MECHANISM FOR OPENING OF THE TRANSLATING WINDOW, 141A4810, AND FOR POSITIONING OF THE HANDLE ASSY, 141A4821, IN THE NORMAL STOWED POSITION. IF RIGGING OF 141A4820 IS CHANGED, RECHECK FUNCTIONAL TEST OF THE 141A4810.					
	GN5		(REF GN4) REQUIREMENT 1: TRANSLATING WINDOW SHALL UNLOCK AND OPEN WHEN THE HANDLE IS MANUALLY PULLED A MAXIMUM OF 3.50 INCHES WITH A MAXIMUM OF 110 POUNDS PULLING FORCE.					
	GN6		(REF GN4) REQUIREMENT 2: THE TURNBUCKLE AND ECCENTRIC BUSHING SHALL BE ADJUSTED SO THAT THE EMERGENCY RELEASE HANDLE ASSEMBLY IS FLUSH WITHIN +/- .0300 WITH THE BODY SKIN.					
	GN7		(REF GN5) REQUIREMENT 3: THE TRANSLATING WINDOW MUST OPERATE, OPEN AND CLOSE, FREELY WHEN THE EMERGENCY RELEASE MECHANISM IS IN THE STOWED POSITION.					
(CONTINUED ON NEXT PAGE)								
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LIST TITLE RELEASE MECHANISM INSTL - EMERGENCY EXIT, SLIDING WINDOW							
(CONTINUED FROM PRECEDING PAGE)							
TITLE		DESCRIPTION					
GN8		(REF GN 5) REQUIREMENT 4: WHEN TRANSLATING WINDOW, 141A4810, IS IN THE CLOSED POSITION WITH THE HANDLE EXTENDED TO THE MAXIMUM FORWARD AND OUTBD POSITION, THE TRIGGER(9-64303-3 REF) MUST PROTRUDE FROM THE HANDLE ASSY(69-26410-1 REF) FAR ENOUGH TO ENSURE THAT THE BOLT(9-64304-3 REF) PROTRUDES INTO THE LOCKPLATE(60-3130-4 REF) ENOUGH TO BE FLUSH WITH THE BOTTOM SURFACE OF THE LOCKPLATE(60-3130-4 REF) WITHIN +/- .0300. IF THE BOLT DOES NOT PROTRUDE A SUFFICIENT DISTANCE THRU THE LOCKPLATE, THEN REMOVE THE COTTER PIN(BACP18BC REF OR MS24665 REF) FROM THE CAM SHAFT ASSY, 69-29553-1 OR 141A4827-1, AND ROTATE CAM (69-29552-1 REF OR 141A4827-2 REF) SO THAT THE INDEX MARK ON THE CAM MOVES ONE SPLINE FORWARD OF THE INDEX MARK ON THE SHAFT(69-29551-1 REF). REINSTALL BACP18BC OR MS24665 PER FL1. SEE DETAIL I, SH1, SH3, SH4, SH5, SH6, AND SH8 ZNA9. ENSURE CAM SHAFT ASSY HAS NOT CAUSED THE TRANSLATING WINDOW CAM TO ROTATE FORWARD. THE CAM SHAFT ASSY AND TRANSLATING WINDOW CAM SHOULD BE IN CONTACT ONLY. ENSURE SPRING (66-21450-1REF) IS INSTALLED WITH TENSION ON THE SPRING. RE-ADJUST THE TURNBUCKLE TO MEET ADJUSTMENT REQUIREMENTS, IF NECESSARY.					
GN9		RIGGING PROCEDURE (SEE GN10 THRU GN15)					
GN10		(REF GN9) STEP1: WITH SPRING, 66-21450-1, AND TURNBUCKLE, 66-19424-1, DISCONNECTED, ROTATE BELLCRANK, 141A4823-4, IN THE UNLOCKING DIRECTION WHILE HOLDING THE HANDLE ASSY(141A4821 REF) FLUSH WITHIN +/- .0300 WITH THE BODY SKIN, UNTIL THE HANDLE ASSY BOTTOMS. SECURE ECCENTRIC BUSHING, 66-19406-2, AGAINST BELLCRANK, 141A4823-4.					
GN11		(REF GN9) STEP 2: CLOSE AND LOCK TRANSLATING WINDOW (141A4810 REF). TEMPORARILY REMOVE LWR BELLCRANK FITTING, 141A4825-1 OR 69-26395-18, FROM CAM SHAFT ASSY, 69-29553-1 OR 141A4827-1. ROTATE CAM SHAFT ASSY 69-29553-1 OR 141A4827-1, IN THE OPENING DIRECTION UNTIL THE CAM SHAFT ASSY COMES IN CONTACT WITH THE TRANSLATING WINDOW CAM(69-26469 REF). REINSTALL BELLCRANK FITTING, 69-26395-18 OR 141A4825-1, ONTO CAM SHAFT ASSY SUCH THAT THE DISTANCE BETWEEN THE TURNBUCKLE, 66-19424-1, ATTACH HOLES IS BETWEEN 4.75 AND 5.40 INCHES.					
GN12		(REF GN9) STEP 3: ADJUST TURNBUCKLE, 66-19424-1, TO THE LENGTH DETERMINED FROM STEP 2 (REF GN 11).					
GN13		(REF GN9) STEP 4: INSTALL TURNBUCKLE, 66-19424-1, AND SPRING, 66-21450-1.					
GN14		(REF GN9) STEP 5: CHECK PER FUNCTIONAL TEST INSTRUCTIONS (REF GN3 THRU GN8), AND IF ACCEPTABLE SECURE TURNBUCKLE LENGTH PER FL3.					
GN15		(REF GN9) CAUTION: TRANSLATING WINDOW ASSY (141A4810 REF) MUST NOT BE ALTERED DURING THIS PROCEDURE.					
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TITLE		DESCRIPTION					
PROCESS SPECIFICATION		SEE FLAGNOTE(S) OR PICTURE SHEET(S) FOR PROCESSING REQUIREMENTS PER BAC 5018					
PROCESS SPECIFICATION		INSTALL BEARING PER BAC 5435.					
PROCESS SPECIFICATION		INSTALL BEARING USING BMS 5-95 SEALANT PER BAC 5000. .					
PROCESS SPECIFICATION		SEE FLAGNOTE(S) OR PICTURE SHEET(S) FOR PROCESSING REQUIREMENTS PER BAC 5008					
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. . . STANDARD NOTES . . .							
NOTICE - THE INFORMATION CONTAINED HEREIN IS PROPRIETARY TO THE BOEING COMPANY AND SHALL NOT BE REPRODUCED OR DISCLOSED IN WHOLE OR IN PART OR USED FOR ANY PURPOSE EXCEPT WHEN SUCH USER POSSESSES DIRECT, WRITTEN AUTHORIZATION FROM THE BOEING COMPANY.							
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES							
DIMENSIONS AND SURFACE TEXTURE DESIGNATIONS APPLY BEFORE PLATING OR SURFACE FINISH COATING UNLESS OTHERWISE NOTED.							