



COMPONENT MAINTENANCE MANUAL
19800

REVISION TRANSMITTAL LETTER

TO:

Holders of Component Maintenance Manual (CMM) 25-20-54, revision No. 11 dated Feb 24/17.

GENERAL:

This transmittal letter is attached to the revision No. 12 of CMM 25-20-54, Jan 22/18.

The pages which are changed with this revision are shown in the List of Effective Pages (LEP). The type of change is shown in the list as follows:

R	This page has been revised (replaced)
D	This page has been erased (removed)
N	This page is new (put into the CMM)

Make sure that the contents of the CMM agrees with the List of Effective Pages (LEP).

Write the details on the Record of Revisions (ROR) page.

File this Transmittal Letter in the CMM after the Record of Temporary Revisions (RTR).

Remove and discard the pages which are changed with this Revision.

REASON FOR ISSUE:

This CMM has been revised to incorporate design changes.

The attached highlights give details of these changes.

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HIGHLIGHTS

Revision No.12 - Jan 22/18

Pages which have been added, revised or deleted are outlined below together with the Highlights of the Revision.

LOCATIONS	DESIGNATION	DESCRIPTION OF CHANGE
TITLE PAGE	R	Revised to show date of this revision.
SERVICE BULLETIN LIST	R	Revised to update Service Bulletin List.
LIST OF EFFECTIVE PAGES	R	Revised to reflect revision 12.
DESCRIPTION AND OPERATION	R	Added new Task for Trim and Finish.
CLEANING	R	Revised to update Table 4001.
REPAIR	R	Revised to update Tables 6001 thru 6003.
ASSEMBLY	R	Revised to update Table 7001.
ILLUSTRATED PARTS LIST (IPL)	R	Updated Manufacturer Names and Addresses information.

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COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

ATTENDANT SEAT ASSEMBLY

	Part Number
19800-101	19800-115()
19800-103()	19800-117()
19800-105()	19800-119()
19800-107()	19800-121()
19800-109()	19800-123()
19800-111()	
19800-113()	

WARNING:

ANY WARRANTY OFFERED BY ZODIAC SEATS CALIFORNIA LLC WILL BE DEEMED NULL AND VOID IF ITS PRODUCTS ARE USED IN AN UNINTENDED MANNER OR SHOW INDICATIONS THAT THEY HAVE BEEN ALTERED IN ANYWAY, INCLUDING, BUT NOT LIMITED TO, USE OF REPLACEMENT PARTS NOT MANUFACTURED BY ZODIAC SEATS CALIFORNIA LLC AND THAT REASONABLE OR NECESSARY MAINTENANCE AS OUTLINED IN THIS MANUAL WAS NOT PERFORMED AT THE TIME AND IN THE MANNER SPECIFIED HEREIN.

11340 JERSEY BLVD, RANCHO CUCAMONGA, CA 91730, USA (CAGE NO. 6J2A7)

Initial Issue: Apr 15/97

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RECORD OF REVISIONS

REV. No.	ISSUE DATE	INSERTED		REV. No.	ISSUE DATE	INSERTED	
		DATE	BY			DATE	BY
Rev.0	Apr 15/97	Apr 15/97	4 Flight				
Rev.1	Jul 15/00	Jul 15/00	4 Flight				
Rev.2	Aug 15/01	Aug 15/01	4 Flight				
Rev.3	Nov 15/01	Nov 15/01	4 Flight				
Rev.4	Dec 15/01	Dec 15/01	4 Flight				
Rev.5	Apr 15/02	Apr 15/02	4 Flight				
Rev.6	Jul 15/02	Jul 15/02	4 Flight				
Rev.7	Mar 30/03	Mar 30/03	4 Flight				
Rev.8	May 15/03	May 15/03	4 Flight				
Rev.9	Mar 01/05	Mar 01/05	4 Flight				
Rev.10	Oct 28/16	Oct 28/16	C&D Zodiac				
Rev.11	Feb 24/17	Feb 24/17	C&D Zodiac				
Rev.12	Jan 22/18	Jan 22/18	C&D Zodiac				

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Number	Rev	Date	Rev	
19800-25-03	0	Aug 15/01	2	EQUIPMENT/FURNISHINGS: Addition of Closeout Cover.
19800-25-05	2	Jan 22/18	12	EQUIPMENT/FURNISHINGS: Addition of Protective Cover to Restraint System.
19800-25-1	0	Jan 22/18	12	EQUIPMENT/FURNISHINGS: Dress Cover Change.
19800-25-2	0	Jan 22/18	12	EQUIPMENT/FURNISHINGS: Dress Cover Change.
19800-25-04	2	Jan 22/18	12	EQUIPMENT/FURNISHINGS: Replacement of Restraint System.
19800-25-06	1	Jan 22/18	12	EQUIPMENT/FURNISHINGS: Replacement of Restraint System.
19800-25-07	0	Jan 22/18	12	EQUIPMENT/FURNISHINGS: Addition of Protective Cover to Restraint System.
19800-25-08	0	Jan 22/18	12	EQUIPMENT/FURNISHINGS: Addition of Protective Cover to Restraint System.
19800-25-09	1	Jan 22/18	12	EQUIPMENT/FURNISHINGS: Dress Cover Change.
19800-25-10	1	Jan 22/18	12	EQUIPMENT/FURNISHINGS: Replace Dress Covers.
19800-25-11	0	Jan 22/18	12	EQUIPMENT/FURNISHINGS: Replacement of the Headrest, Back, and Bottom Dress Covers Assemblies.

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INTRODUCTION

TASK 25-20-54-99F-801-A01

1. Scope of this Component Maintenance Manual

This component maintenance manual provides instructions for off-aircraft maintenance of Attendant Seat Assembly Part No. 19800 Series, hereinafter referred to as the seat assembly, manufactured by Zodiac Seats California LLC, Rancho Cucamonga, California. Instructions are included for maintenance functions ranging from simple checks and replacement to complete shop-type repair. Repairs beyond the scope of this manual should be referred to the manufacturer. A summary of the instructions contained in this manual is as follows:

A. Description and Operation

This section provides a description, leading particulars and operational use of the seat assembly. Nomenclature used for parts in the description and on the illustrations is consistent with that used throughout this manual including the ILLUSTRATED PARTS LIST.

B. Testing and Fault Isolation

This section details testing and fault isolation methods to be used on a completely assembled seat assembly.

C. Disassembly

This section details the disassembly procedure for parts that need to be removed to allow visual inspection and for parts that can be removed.

D. Cleaning

This section provides a list of cleaning materials and instructions for cleaning the seat assembly.

E. Check

This section provides the methods and criteria for determining the serviceability of individual parts.

F. Repair

This section provides a list of all materials required for repair of the seat assembly together with repair procedures that are consistent with the DISASSEMBLY section.

G. Assembly

This section includes a list of all materials required during assembly, and the assembly procedure for all parts disassembled in DISASSEMBLY.

H. Fits and Clearances

There are no critical fit or clearance tolerances for parts listed in this manual.

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I. Special Tools, Fixtures, and Equipment

This section contains recommendations for equipment required to service the seat assembly.

J. Illustrated Parts List

This section contains a complete list of spare parts for the seat assembly ad a brief introduction on how to use the ILLUSTRATED PARTS LIST.

TASK 25-20-54-99F-802-A01

2. Verification Of Procedures In This Component Maintenance Manual

Section	Method
Testing / Fault Isolation	Verified by Simulation
Disassembly	Verified by Simulation
Assembly	Verified by Simulation

TASK 25-20-54-99F-803-A01

3. List of Abbreviations

°	Degrees
°C	Degrees Celsius
°F	Degrees Fahrenheit
-	Not Illustrated
ALT	Alternate
AR	As Required
ASSY	Assembly
ATA	Air Transport Association
CAGE	Commercial And Government Entity
cm	Centimeter (1 cm = 0.394 inch)
CMM	Component Maintenance Manual
DET	Details
EFF	Effectivity
FIG	Figure
FWD	Forward
IDENT	Identification

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in.	Inch
IPL	Illustrated Parts List
kg	Kilogram (1 kg = 2.205 pounds)
lb	Pound
LH	Left-Hand
NHA	Next Higher Assembly
NO	Number
OPP	Opposite
OPT	Optional
PN	Part Number
RPLD	Replaced
RPLS	Replaces
REV	Revision
RF	Reference
RH	Right-Hand
SB	Service Bulletin
SUPSD	Superseded
SUPSDS	Supersedes
V	Vendor



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DESCRIPTION AND OPERATION

TASK 25-20-54-870-801-A01

1. Description

The Seat Assembly is shown in Figure 1. The Seat Assembly is designed for limited use and space requirements while providing the maximum possible comfort and safety for the seat occupant. The seat assembly consists of the seat back structure with a cushion, a removable headrest, and spring-loaded seat bottom cushion/structure which folds up when in the stowed position. In addition the seat assembly features a four-point restraint harness with rotary buckle.

TASK 25-20-54-870-802-A01

2. Safety Considerations

The seat structure is designed to eliminate any protrusions, edges, or projections which might penetrate the various cushions during vertical movements. All areas of passenger contact are free of projections which might cause injury or damage to clothing. The headrest, seat back and bottom cushion assemblies are covered with fire-blocking covers. In addition, the seat assembly provides for occupant safety during emergency and routine flight conditions by means of a restraint system.

TASK 25-20-54-870-803-A01

3. Operation

- A. To deploy the seat assembly, active the latch mechanism and using the strap handle, slide the seat assembly towards the centerline of the aircraft so that the bayonet positively engages the upper and lower bayonet receptacles. Unfasten the retaining strap securing the seat bottom. Push the spring-loaded seat bottom down to occupy the seat and secure occupant with restraint system.
- B. To stow the seat assembly, push the release bracket on the upper bayonet receptacle to disengage the seat. Slide the seat to the stowed position and secure in place with the retaining latch. Fasten the strap to the seat bottom.

TASK 25-20-54-870-804-A01

4. Leading Particulars

- A. See Table 1 for leading particulars for the seat assembly covered in this manual.

Leading Particular
Table 1/TABLE 25-20-54-870-001-A01

Property	Specification
Manufacturer	Zodiac Seats California LLC (CAGE 6J2A7)
Part Number	Nomenclature
19800-101 thru -123	Attendant Seat Assembly
Overall Dimensions	
Width	15.25 in. (38,73 cm)
Height	37.50 in. (95,25 cm)



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Leading Particular
Table 1/TABLE 25-20-54-870-001-A01 (continued)

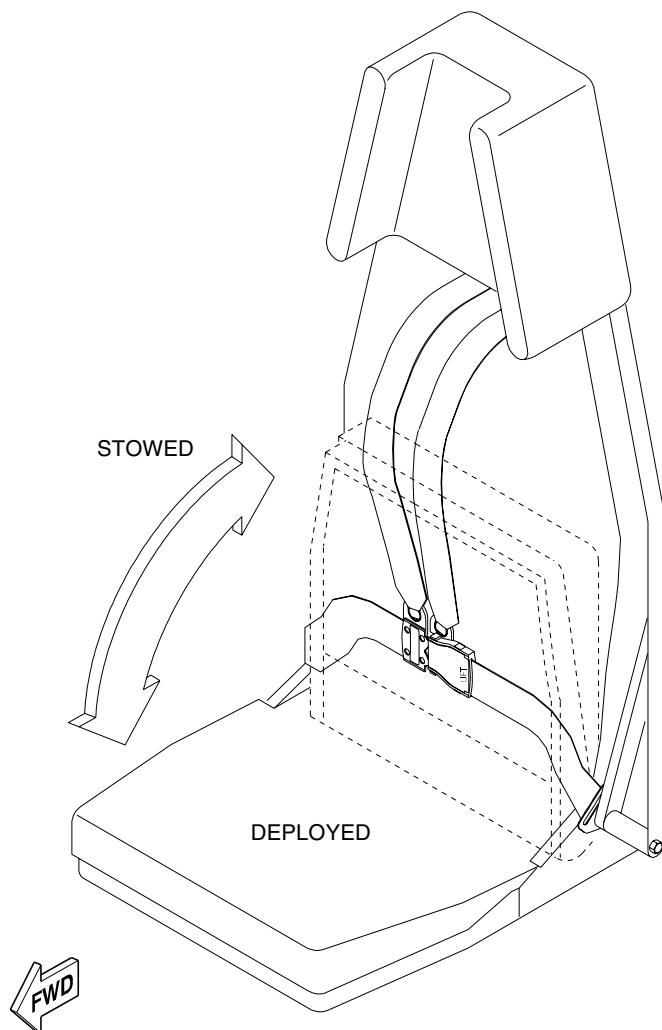
Property	Specification
Depth (Deployed)	17.0 in. (43,18 cm)
Maximum Seat Weight (Full Dressed)	55.0 lbs (24,94 kg)

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Attendant Seat Assembly
Figure 1/GRAFIC 25-20-54-870-001-A01

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TASK 25-20-54-870-805-A01

5. Trim and Finish

- A. Some parts of the equipment described in this manual have a decorative finish (material and/or color) that is peculiar to one or more operators. The part numbers in this manual do not identify decorative finishes.
- B. When ordering parts, a decorative finish code must be included (added) in the part number as listed in this manual. The decorative finish code is inserted after the dash number, replacing the dash.
- C. Trim and Finish Code

The trim and finish code for the operator is given in table 2.

Operator Trim and Finish Codes
Table 2/TABLE 25-20-54-870-002-A01

Operator	Trim and Finish Code	Table Number	Figure Number
Mesa / Adria / Sax / Shandong / Cameroon	N	3	2
Southern Winds	C	4	2
Brit Air / Midway	H	5	2
Kendall	K	6	2
10005 / Maersk / Mesa	V	7	2
10009 / AMR / Horizon	U	8	2
Palestinian	AB	9	2
Horizon Air	AC	10	2
US Airways	AD	11	2
Skywest	AE	12	2
Styrian Airways	AG	13	2
Lufthansa (CLH)	AH	14	2
Lufthansa (CLH)	AU	15	2



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Trim and Finish For Mesa / Adria / Sax / Shandong / Cameroon P/N 19800 -103N and -119N
Table 3/TABLE 25-20-54-870-003-A01

Item No.	Components	Color / Finish	Material Specifications	Source (CAGE) (1)
1	Dress Cover	Gray	P/N: 2041 / 74 S2 Upholstery: Fabric	Lantal Textiles (V0YRK7)
2	Restraint System	Black	503037-401-2251	AM Safe (V35FB9)
3	Seat Structure Surfaces	White, Pepperdust / Semi-gloss	Primer with IP750M	HSH Aerospace Finishes (VB4946)

(1) Refer to Manufacturer Names and Addresses section for vendor information

Trim and Finish For Southern Winds P/N 19800 -103C
Table 4/TABLE 25-20-54-870-004-A01

Item No.	Components	Color / Finish	Material Specifications	Source (CAGE) (1)
1	Dress Cover	Taupe, Blue Red / Jacquard	P/N: 6574 Upholstery: Fabric	Lantal Textiles (V0YRK7)
2	Restraint System	Black	503037-401-2251	AM Safe (V35FB9)
3	Seat Structure Surfaces	White, Pepperdust / Semi-gloss	Primer With IP750M	HSH Aerospace Finishes (VB4946)

(1) Refer to Manufacturer Names and Addresses section for vendor information



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Trim and Finish For Brit Air / Midway P/N 19800 -103H
Table 5/TABLE 25-20-54-870-005-A01

Item No.	Components	Color / Finish	Material Specifications	Source (CAGE) (1)
1	Dress Cover	Blue / Jacquard	P/N: 2041P / 49 Upholstery: Fabric	Lantal Textiles (V0YRK7)
2	Restraint System	Black	503037-401-2251	AM Safe (V35FB9)
3	Seat Structure Surfaces	White, Rose Gray / Semi-gloss	Primer With IP750M	HSH Aerospace Finishes (VB4946)
(1) Refer to Manufacturer Names and Addresses section for vendor information				

Trim and Finish For Kendall P/N 19800 -103K
Table 6/TABLE 25-20-54-870-006-A01

Item No.	Components	Color / Finish	Material Specifications	Source (CAGE) (1)
1	Dress Cover	Cinder	P/N: 3622D65-41 Upholstery: Leather	Douglass Interior (V0HGX6)
2	Restraint System	Black	503037-401-2251	AM Safe (V35FB9)
3	Seat Structure Surfaces	White, Rose Gray / Semi-gloss	Primer With IP750M	HSH Aerospace Finishes (VB4946)
(1) Refer to Manufacturer Names and Addresses section for vendor information				



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Trim and Finish For 10005 / Maersk / Mesa P/N 19800 -105V, -109V, -113V, and -115V
Table 7/TABLE 25-20-54-870-007-A01

Item No.	Components	Color / Finish	Material Specifications	Source (CAGE) (1)
1	Dress Cover	Navy Blue / Jacquard	P/N: 2041P / 49 Upholstery: Fabric	Lantal Textiles (V0YRK7)
2	Restraint System	Pearl Black	503037-401-1449	AM Safe (V35FB9)
			504813-401-1449	
		Midnight Blue	503037-401-2258	
3	Seat Structure Surfaces	White, Rose Gray / Semi-gloss	Primer With IP750M	HSH Aerospace Finishes (VB4946)

(1) Refer to Manufacturer Names and Addresses section for vendor information

Trim and Finish For 10009 / AMR / Horizon P/N 19800 -103U, -107U, -111U, and -117U
Table 8/TABLE 25-20-54-870-008-A01

Item No.	Components	Color / Finish	Material Specifications	Source (CAGE) (1)
1	Dress Cover	Admiral Blue	P/N: 2556 Upholstery: Ultra Leather	Tapis Corporation (V3ULF6)
2	Restraint System	Black	503037-401-2251	AM Safe (V35FB9)
		Cruiser Gray	504813-401-2847 503037-401-2847	
3	Seat Structure Surfaces	White, Rose Gray / Semi-gloss	Primer With IP750M	HSH Aerospace Finishes (VB4946)

(1) Refer to Manufacturer Names and Addresses section for vendor information



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Trim and Finish For Palestinian P/N 19800 -103AB
Table 9/TABLE 25-20-54-870-009-A01

Item No.	Components	Color / Finish	Material Specifications	Source (CAGE) (1)
1	Dress Cover	Gray / Jacquard	P/N: 2736LS / 760 Airstream Upholstery: Fabric	Lantal Textiles (V0YRK7)
2	Restraint System	Black	503037-401-2251	AM Safe (V35FB9)
3	Seat Structure Surfaces	White, Rose Gray / Semi-gloss	Primer With IP750M	HSH Aerospace Finishes (VB4946)
(1) Refer to Manufacturer Names and Addresses section for vendor information				

Trim and Finish For Horizon Air P/N 19800 -121AC
Table 10/TABLE 25-20-54-870-010-A01

Item No.	Components	Color / Finish	Material Specifications	Source (CAGE) (1)
1	Dress Cover	Burgundy	P/N: LL 3108 Upholstery: Leather	Douglass Interior (V0HGX6)
2	Restraint System	Pearl Black	503037-401-1449	AM Safe (V35FB9)
3	Seat Structure Surfaces	White, Pepperdust / Semi-gloss	Primer With IP750M	HSH Aerospace Finishes (VB4946)
(1) Refer to Manufacturer Names and Addresses section for vendor information				



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Trim and Finish For US Airways P/N 19800 -117AD
Table 11/TABLE 25-20-54-870-011-A01

Item No.	Components	Color / Finish	Material Specifications	Source (CAGE) (1)
1	Dress Cover	Gray	P/N: LT4437 Upholstery: Leather	Douglass Interior (V0HGX6)
2	Restraint System	Cruiser Gray	503037-401-2847	AM Safe (V35FB9)
3	Seat Structure Surfaces	White, Pepperdust / Semi-gloss	Primer With IP750M	HSH Aerospace Finishes (VB4946)

(1) Refer to Manufacturer Names and Addresses section for vendor information

Trim and Finish For Skywest P/N 19800 -121AE
Table 12/TABLE 25-20-54-870-012-A01

Item No.	Components	Color / Finish	Material Specifications	Source (CAGE) (1)
1	Dress Cover	Blue	P/N: SKYLINE FEATHERWEIGHT Upholstery: Leather	Perrone (V49U11)
2	Restraint System	Pearl Black	503037-401-1449	AM Safe (V35FB9)
3	Seat Structure Surfaces	White, Pepperdust / Semi-gloss	Primer With IP750M	HSH Aerospace Finishes (VB4946)

(1) Refer to Manufacturer Names and Addresses section for vendor information

Trim and Finish For Styrian Airways P/N 19800 -123AG
Table 13/TABLE 25-20-54-870-013-A01

Item No.	Components	Color / Finish	Material Specifications	Source (CAGE) (1)
1	Dress Cover	Gray Goose / Leather	P/N: SKYLINE #2324	Perrone (V49U11)
2	Restraint System	Dark Moss Green	503037-401-2051	AM Safe (V35FB9)
3	Seat Structure Surfaces	White, Pepperdust / Semi-gloss	Primer With IP750M	HSH Aerospace Finishes (VB4946)

(1) Refer to Manufacturer Names and Addresses section for vendor information



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Trim and Finish For Lufthansa (CLH) P/N 19800 -119AH
Table 14/TABLE 25-20-54-870-014-A01

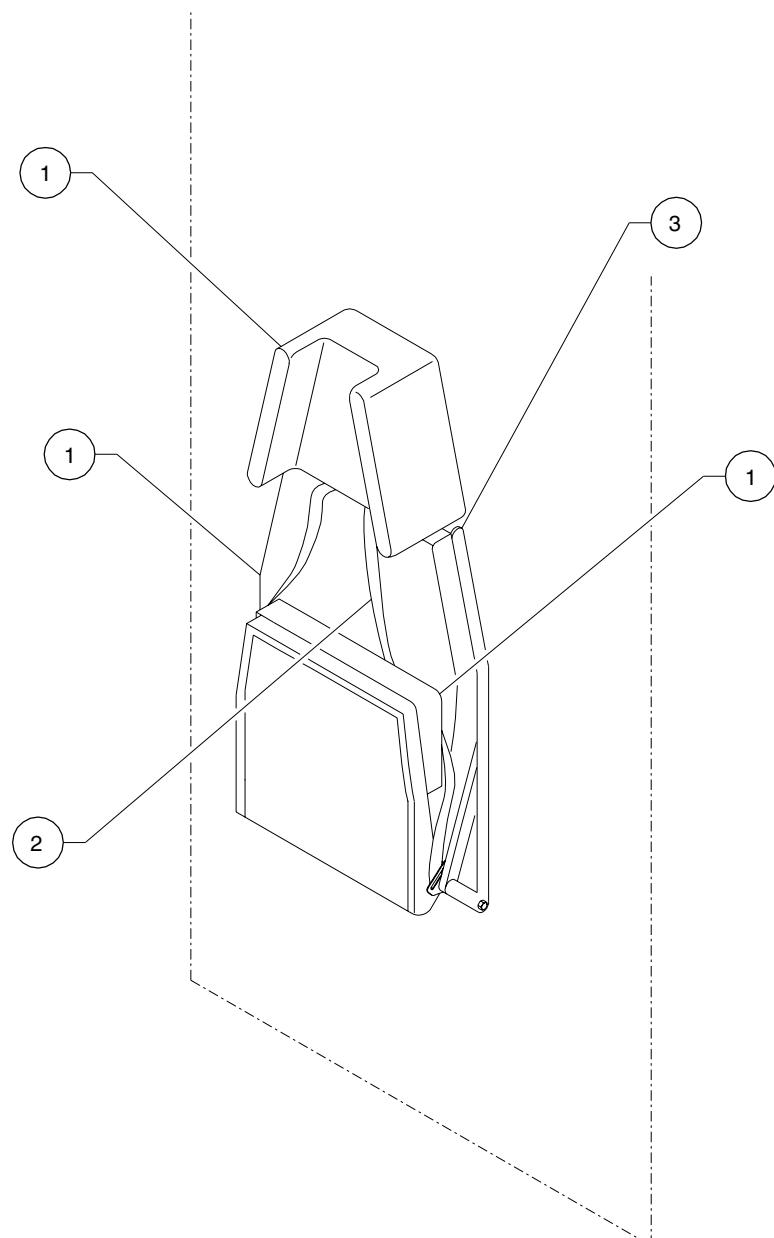
Item No.	Components	Color / Finish	Material Specifications	Source (CAGE) (1)
1	Dress Cover	Dark Gray	P/N: LU-35 Upholstery: Leather	Cortina (V5XL95)
2	Restraint System	Black	503037-401-2251	AM Safe (V35FB9)
3	Seat Structure Surfaces	White, Rose Gray / Semi-gloss	Primer With IP750M	HSH Aerospace Finishes (VB4946)
(1) Refer to Manufacturer Names and Addresses section for vendor information				

Trim and Finish For Lufthansa (CLH) P/N 19800 -119AU
Table 15/TABLE 25-20-54-870-015-A01

Item No.	Components	Color / Finish	Material Specifications	Source (CAGE) (1)
1	Dress Cover	Gray	P/N: 2041 / 74S2 Upholstery: Fabric	Lantal Textiles (V0YRK7)
2	Restraint System	Black	503037-401-2251	AM Safe (V35FB9)
3	Seat Structure Surfaces	White, Rose Gray / Semi-gloss	Primer With IP750M	HSH Aerospace Finishes (VB4946)
(1) Refer to Manufacturer Names and Addresses section for vendor information				



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Trim and Finish - Single Seat Assembly
Figure 2/GRAFIC 25-20-54-870-002-A01

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TESTING AND FAULT ISOLATION

TASK 25-20-54-700-801-A01

1. Testing

A. Test Equipment

(1) No special test equipment is required to test the seat assembly although a fixture to simulate the mounting provisions of the aircraft is recommended.

B. Test Conditions

(1) Testing is to be conducted at temperature of 57 to 97 °F (13.9 to 36.1 °C) with relative humidity of 90% maximum.

C. Operation Tests

(1) Lower the seat bottom to the in use position. There shall be no roughness or binding.

(2) Release the seat bottom so that it returns to the stowed position. The seat bottom shall fold up with no evidence of roughness or binding.

(3) Isolate faults in the seat assembly in accordance with Table 1001.

TASK 25-20-54-810-801-A01

2. Fault Isolation

A. Table 1001 gives the fault isolation procedures.

Fault Isolation Chart
Table 1001/TABLE 25-20-54-810-001-A01

Fault	Probable Cause	Remedy
Operational Test, Para 1.C.		
Seat bottom does not fold down or does not fold up when released.	Broken or defective return springs: binding in pivot mechanism.	Check for proper installation of pivot mechanism; replace return springs (70, 75, IPL Figs. 1)



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DISASSEMBLY

TASK 25-20-54-99F-804-A01

1. General

- A. Use of these instructions is limited to the extent necessary to correct a malfunction or incorporate a modification. Accomplish test procedure detailed in TESTING AND FAULT ISOLATION prior to any disassembly. If requirements of test cannot be attained, disassemble only as necessary to accomplish corrective action required to return unit to a serviceable and reliable status.
- B. Partial maintenance may actually be performed without removing the particular seat assembly from the aircraft. If partial disassembly of a component is necessary, comply with applicable portions of the instructions in this section.
- C. Complete disassembly of the seat assembly is neither anticipated nor recommended. Remove only those parts required to gain access to worn or damaged parts requiring replacement.
- D. Proceed with disassembly as outlined below, referring to the exploded view illustrations in the ILLUSTRATED PARTS LIST (IPL) portion of this manual, noting that attaching parts are listed immediately following the parts which they attach.

NOTE: Carefully inspect all riveted, spot-welded, or bonded assemblies and components prior to disassembly or removal. Do not remove these items unless required by damage or other need for replacement. If replacement is required, refer to the applicable portions of REPAIR for detailed instructions.

CAUTION: DISASSEMBLE THE SEAT ASSEMBLY IN A CLEAN, WELL-ILLUMINATED AREA. PROTECT COMPONENTS FROM DIRT OR OTHER DAMAGE BY PLACING IN A CLEAN CONTAINER AFTER DISASSEMBLY.

TASK 25-20-54-000-801-A01

2. Removal

Removal of the seat assembly is not necessary for normal maintenance procedures such as removal of cushions or dress covers for cleaning. Removal is not anticipated with the exception of periodic major overhaul of the aircraft or modifications that may require removing the seat assembly.

TASK 25-20-54-000-802-A01

3. Disassembly Procedures

SUBTASK 25-20-54-040-001-A01

A. Single Attendant Seat Assembly (Refer to Figure 1)

- (1) Remove the upholstered headrest assembly (5) from the upholstered back assembly (25).
- (2) Remove the close out cover assembly (20) from the upholstered bottom assembly (115).
- (3) Remove the upholstered back assembly (25), spring sleeves (65), return springs (70 and 75), and spring cover (80) from the upholstered bottom assembly (115) by removing nuts (30), washers (35), nuts (40), washers (45 and 55), nylon washers (50), and bolts (60).
- (4) Disassemble the upholstered back assembly (25) in accordance with SUBTASK 25-20-54-040-002-A01.

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- (5) Remove the restraint system (90) from the upholstered back assembly (25) by removing nuts (95), washers (100), and bolts (105).
- (6) Remove the protective cover assemblies (110) from the restraint system (90).

SUBTASK 25-20-54-040-002-A01

B. Upholstered Back Assembly (Refer to Figure 2)

- (1) Remove the dress cover assembly (5) from the fireblocked cushion assembly (10) and structure assembly (20).
- (2) Remove the fireblocked cushion assembly (10) from structure assembly (20).
- (3) Remove the sleeves (15) from the structure assembly (20).

NOTE: Refer to CLEANING section to clean parts.

NOTE: Refer to REPAIR section to repair parts.

- (4) Disassemble the structure assembly (20) as follows:
 - (a) Remove the velcro strips (25 and 30) from the diaphragm (35).
 - (b) Remove the diaphragm (35) from the seat back weldment assembly (40).

NOTE: Refer to CLEANING section to clean parts.

NOTE: Refer to REPAIR section to repair parts.

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CLEANING

TASK 25-20-54-99F-805-A01

1. General

Thorough cleaning is an essential prelude to any close inspection to determine existence of, extent of, and exact location of defects. Cleaning also removes accumulations and deposits of residue which can adversely affect performance of the equipment.

TASK 25-20-54-940-001-A01

2. Cleaning Materials

SUBTASK 25-20-54-94A-001-A01

Recommended cleaning materials are listed in Table 4001. Equivalent materials that do not react with the area being cleaned may be substituted for items listed.

WARNING: KEEP CLEANING SOLVENTS AWAY FROM SPARKS OR OPEN FLAME. AVOID INHALING FUMES OR PROLONGED CONTACT OF SOLVENT WITH SKIN. PROVIDE ADEQUATE VENTILATION.

Cleaning Materials
Table 4001/TABLE 25-20-54-94A-001-A01

Material	Identification	Source (1)
Aliphatic Naphtha	Federal Specification TT-N-95	Commercially available
Corrosion Removing Compound	Federal Specification MIL-C-38334	Commercially available
Detergent Activator For Stoddard Solvent	No. 195 (For Stoddard Solvent) No. G84 (For Perchloroethylene)	Commercially available Commercially available
Isopropyl Alcohol	Federal Specification TT-1-735	Commercially available
Perchloroethylene	Federal Specification 0-T-236	Commercially available
Solvent Degreaser	Federal Specification MIL-D-12391	Commercially available
Stoddard Solvent	Federal Specification PP-S-600	Commercially available
(1) Refer to Manufacturer Names and Addresses section for vendor information		



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Cleaning Materials
Table 4001/TABLE 25-20-54-94A-001-A01 (continued)

Material	Identification	Source (1)
Trichloroethane	Specification MIL-T-81533	Commercially available
Upholstery Shampoo	DuPont Dry Cleaner	Dupont E.I. Nemours Co., INC. (V0VYR8)
(1) Refer to Manufacturer Names and Addresses section for vendor information		

TASK 25-20-54-100-801-A01

3. Cleaning Procedures

A. Non-Upholstered Parts

- (1) Clean plastic or naugahyde surfaces by wiping with a damp cloth.

WARNING: ALIPHATIC NAPHTHA IS FLAMMABLE. USE ONLY IN A WELL VENTILATED AREA AND AWAY FROM OPEN FLAME. AVOID PROLONGED OR REPEATED CONTACT WITH SKIN OR INHALATION OF VAPORS. USE STANDARD SAFETY PRECAUTIONS FOR HANDLING FLAMMABLE MATERIAL.

- (2) Clean metal components with aliphatic naphtha. Dry with a clean, lint-free cloth or allow to air dry.
- (3) Remove any stains or deposits on non-electrical metal parts not removed by Aliphatic Naphtha with a cloth moistened with Stoddard solvent.
- (4) Remove any signs of corrosion with corrosion removing compound.

B. Upholstery

CAUTION: SEAT COVERS MUST BE DRY CLEANED ONLY. REMOVAL OF SMALL STAINS, ETC. IS COVERED IN STEPS (1) THRU (4) BELOW. COMPLETE CLEANING IS COVERED IN STEPS (3) AND SUBSEQUENT.

- (1) Vacuum upholstery thoroughly or brush with a medium stiff bristle upholstery or clothes brush. Do not pound or beat upholstered covers as this does not effectively clean the upholstery and can hasten its wear.
- (2) Remove dry or water-borne soil with concentrated detergent preparations, commonly called upholstery shampoo. Mix upholstery shampoo as directed on container and apply to a small area (approximately one square foot) with a small clean brush. Liberal application will assist in loosening deep-seated dirt. Steam may also be used to assist in removing the stain.

WARNING: USE SOLVENT-TYPE CLEANING AGENTS IN WELL VENTILATED AREA. AVOID BREATHING SOLVENT VAPORS AND PROLONGED SOLVENT CONTACT WITH SKIN. OBSERVE APPROPRIATE FIRE PRECAUTIONS.



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- (3) Oil-type grease spots are best removed with solvent-type cleaning fluid such as DuPont Cleaner or with solvent impregnated Powderene powder. Test the material to be cleaned by first applying cleaning agent to a small inconspicuous area of the material. Use cleaning agents sparingly, without saturating fabric, to avoid spotting and damage. Apply cleaning agent with a soft clean cloth and avoid spreading any stains by working from outer edges toward center of stain.
- (4) After using upholstery shampoo or solvent-type cleaning agent, roll a clean, turkish towel, or other absorbent cloth, into a cylindrical shape and wipe off detergent and dirt. Rotate rolled cloth frequently to present a clean section to the fabric surface.

NOTE: Dirt and soil are absorbed or transferred to the clean towel from the fabric. Vigorous rubbing may be required to obtain even soil removal and to avoid spotty or blotchy appearance after drying.

- (5) Prepare seat covers for dry cleaning by covering all "velcro" hook tape with corresponding pile tape. Heavy stains should be pretreated as outlined in steps (2) and (3) above. Turn seat covers inside out during actual dry cleaning procedure.

CAUTION: TO AVOID SHRINKAGE AND LOSS OF FLAME RESISTANCE, SEAT COVERS MUST NEVER BE WASHED. USE ONLY APPROVED DRY CLEANING METHODS.

- (6) Dry clean seat covers in Perchloroethylene or Stoddard solvent with addition of 1/2% commercial detergent activator. Use activator per manufacturer's instructions. Use cleaning solvent cold in room temperature drum.

NOTE: Water content of cleaning solution must not exceed 0.8%. If water content exceeds this proportion, there is possibility of fabric shrinkage.

- (7) Extract solvent by spin drying followed by hot air drying at 90 to 110 °F for 20 to 40 minutes. After completion of dry cleaning process, waterbound stains can be removed secondarily with steam and detergent preparations as outlined in step (2) above.

C. Polycarbonate Material Parts

NOTE: Due to sensitivity of polycarbonate material to some cleaners and solvents, use only mild liquid detergents such as "Joy" or "Ivory Liquid" or equivalent.

CAUTION: DO NOT USE CHLORINATED SOLVENTS, MEK, ACETONE AND/OR STRONG DETERGENTS WITH HIGH AMMONIA OR ALKALINE CONTENTS.

- (1) Clean surfaces by wiping with a cloth dampened with recommended cleaners listed in Table 4001.
- (2) Dry with a clean, lint-free cloth or allow to air dry.



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INSPECTION/CHECK

TASK 25-20-54-99F-806-A01

1. General

A. A preliminary examination before initial cleaning will facilitate location of obvious defects.

NOTE: Establish requirements of any service bulletins applicable to this equipment. During check, determine which service bulletins, if any, are to be incorporated.

B. All hardware, piece parts, minor assemblies and minor subassemblies are to be visually examined using a strong light and preferably some means of magnification.

C. Visually examine parts for nicks, cracks, cuts, corrosion, crossed and stripped threads, scoring, wear, and obvious defects that could impair efficient seat operation.

TASK 25-20-54-210-801-A01

2. Check

SUBTASK 25-20-54-210-001-A01

A. Visual Examinations

- (1) Check parts for nicks, cracks, cuts, corrosion, crossed, and stripped threads, scoring, wear, and obvious defects that could impair efficient seat operation.
- (2) Check sewn seams for fraying or separation.
- (3) Check fabric and plastic for fraying, scuffing, and pics.
- (4) Check attaching bolts, nuts, screws, and pins for tightness and seat mounting hardware for wear or deformation.
- (5) Check helical inserts for damage and security of installation.
- (6) Check structural parts including clips, brackets, and machined parts for damage, cracks, and burrs or sharp nicks.

NOTE: Burrs are defined as material raised above the normal surface, which if not removed would prevent complete and proper mating of parts and sealing surfaces. Where nicks or scratches allow bare metal to show through a protective finish, note defect and assign part for repair. Dents or other damage must not impair finish or functional operation of any part.

- (7) Check paint and finishes for chipping and worn spots, and note condition of bonding on parts and assemblies.
- (8) Check nameplates and identification plates for legibility and security of attachment.

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REPAIR

TASK 25-20-54-99F-807-A01

1. General

A. Repair of the seat assembly is generally limited to parts replacement or those repairs that can be effected by standard shop practices. Major structural repairs are to be avoided since the safety and integrity of the seat can be compromised by improper disassembly and assembly of major structural components.

B. Repair materials are listed in Table 6001. Equivalent substitutes may be used for listed items.

TASK 25-20-54-940-002-A01

2. Repair Materials

SUBTASK 25-20-54-94A-002-A01

Repair Materials
Table 6001/TABLE 25-20-54-940-003-A01

Material	Identification	Source (1)
Abrasive cloth, aluminum oxide	Federal Specification P-C-451	Commercially available
Adhesive	NS-230	Stabond Corporation (V25670)
Adhesive	3M EC2155	3M Co. (V76381)
Adhesive	FR11016A/B	HB Fullerr North America. (V26348)
Epoxy Adhesive	DP420	3M Co. (V76381)
Aliphatic Naphtha	Federal Specification TT-N-95	Commercially available
Cloth Crocus	Federal Specification P-C-458	Commercially available
Corrosion Preventative Petrolatum	Federal Specification MIL-C-10382	Commercially available
Detergent	"Joy" or similar	Commercially available
Dress Cover (fabric)	2041/74/S2, Grey	Langenthal Corp. (V7W290)
Isopropyl Alcohol	Federal Specification TT-I-735	Commercially available
Paint, touch-up (vinyl)	"Pepperdust" No. 26424, semi-gloss per Federal Standard 595.	Crown Metro Inc. (V0S4B8)
Primer	DZL 32, Grey, per Federal Specification MIL-P-23377, Type I, Class I.	Crown Metro Inc. (V0S4B8)
Thread, Kevlar	3650-N-T-50, 91 natural spun	Commercially available
Thread, Nylon UVR	BZT-69	Commercially available
(1) Refer to Manufacturer Names and Addresses section for vendor information		



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Repair Materials

Table 6001/TABLE 25-20-54-940-003-A01 (continued)

Material	Identification	Source (1)
Toluene	Federal Specification TT-T-548	Commercially available
Velcro Tape (hook)	Pile V-200-1(80)-75	Hartwell Corp. (V83014)
Velcro Tape (pile)	V-200-2-75	Hartwell Corp. (V83014)
(1) Refer to Manufacturer Names and Addresses section for vendor information		

TASK 25-20-54-300-801-A01

3. Repair Procedures

SUBTASK 25-20-54-300-001-A01

A. Metal Surfaces

- (1) Polish out minor nicks and scratches on steel surfaces with crocus cloth. Polish out minor nicks and scratches on aluminum parts with 600 to 800 grit aluminum oxide abrasive cloth.
- (2) Treat all corroded areas with corrosion preventative petrolatum.

SUBTASK 25-20-54-300-002-A01

B. Bonding

- (1) Placards which have been removed are not repairable. To replace with a new placard, dampen a clean, lint-free cloth in Aliphatic Naphtha. Clean mating surfaces of dirt, grit and old adhesive. Replace with new placard following installation instructions printed on the back of the placard.
- (2) To remove grommets, pads and panels cemented to structure, apply Toluene to edges of adhesive to soften adhesive, then pry the part free from structure. Prior to installing new grommets, pads, or panels to structure, sand surface to remove all traces of scale, dirt oxides, oils and old adhesive, then wipe with a clean cloth dampened in Aliphatic Naphtha. To cement grommets, pads and panels, apply a coat of adhesive to both surfaces with a clean, lint-free cloth which is slightly dampened with Toluene. Immediately press both surfaces together and allow to air-dry for 24 hours.



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(3) To bond metal assemblies, clean surface with isopropyl alcohol. To bond plastic assemblies, clean surface with Aliphatic Naphtha. Spread a thin, even coat on one of the parts to be bonded with a brush or spray. Allow adhesive to dry for 20 to 30 minutes. Press parts firmly together, using weights or clamps, as necessary. To accelerate drying and curing time, subject assembly to heat at 150°F for one hour.

SUBTASK 25-20-54-300-003-A01

C. Rivets

(1) Permissible limitation son size of rivet holes, where rivets were drilled out on disassembly, are controlled by standard shop-practiceuse of oversized replacement rivets.

NOTE: The minimum pitch and edge distances for rivets are determined by the original design and should be closely observed during repair.

SUBTASK 25-20-54-300-004-A01

D. Inserts

(1) Helical inserts are used extensively in the assembly of aluminum components and offer higher strength and install/remove cycles than tapped holes in the parent metal.

(2) The inserts used on the assemblies in this manual are of the locking variety. Though unlikely, it is possible that frequent install/remove cycles may cause the locking feature to lose its effectiveness. Thread repair kits are available from the insert manufacturer and typically include a drill, tap, tool and inserts. Specify the insert by part number when ordering thread repair kits.

SUBTASK 25-20-54-300-005-A01

E. Fireblocking Covers

NOTE: There are two methods of accomplishing cover repair, sewing or bonding. Sewing is the preferred method.

(1) Sew Repair. Sew patch in place with MIL-T-441 00, Size T-50 Aramid thread per Federal Specification 751, Type 301,7-9 stitches per inch.

(2) Bond Repair. Bond patch in place with NS-230 adhesive (or equivalent) with 1.0 inch minimum overlap. Tack patch with MIL-T-44100, Size T-50 Aramid thread, minimum 1/2 inch spacing.

NOTE: Bonding method (2) shall be used on backs only. Fabric is to be the same as the fireblocking covers.

NOTE: For areas with unusual wear points, sew on a layer of fireblocking fabric using MIL-T-44100, Size T-50 Aramid thread per Federal Specification 751, Type 301, 7-9 stitches per inch.

TASK 25-20-54-300-802-A01

4. Paint Retouching

WARNING: CONDUCT ALL WORK IN A WELL VENTILATED AREA AS THESE FINISHES AND SOLVENTS CONTAIN TOXIC AND FLAMMABLE INGREDIENTS.



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WARNING: AVOID BREATHING VAPORS. IF FINISHES OR SOLVENTS ARE SPATTERED IN EYES, FLUSH WITH WATER FOR 15 MINUTES AND GET MEDICAL ATTENTION IMMEDIATELY. IF SPATTERED ON SKIN, WASH WITH PLENTY OF WATER.

WARNING: CLEAN UP IMMEDIATELY ANY SPILLAGE OF FINISHES AND SOLVENTS USED FOR CLEANING AND PAINTING.

WARNING: THE REQUIREMENTS FOR THE USE OF PROTECTIVE CLOTHING SHOULD BE ESTABLISHED BY THE APPROPRIATE SAFETY ORGANIZATION.

NOTE: Repair of painted surface is divided into the different paint finishes used. There are two basic finishes used. An epoxy enamel is used for certain structural metal parts such as angles partitions, etc. A suede textured epoxy enamel is used for other metal and most synthetic decor.

SUBTASK 25-20-54-300-006-A01

A. Repair of Non-textured Surfaces

- (1) Remove soil from damaged area with clean, lint-free cloth dampened in Trichlorethylene.
- (2) Lightly sand damaged area with abrasive cloth or paper having a grit of 320 or finer.
- (3) Remove sanding residue by wiping with a clean, lint-free cloth dampened in Trichlorethylene. Wipe dry with a clean cheesecloth.

NOTE: Paint may be applied by brush or spray application. Refer to Table 6002 for specified coating materials.

- (4) Brush application of the coating may be made with a good quality bristle brush. When brush application is employed, apply material in one direction as much as practicable, using light pressure on brush to form an even, continuous film. Avoid repeated brushing out of wet coatings to preclude pickup, air bubbles and voids.

NOTE: Spray application is recommended when surface damage is such that brush application would create a finish incompatible with surrounding areas.

- (5) Using spray equipment that is clean and free of other materials, apply the paint by cross-coating from a distance of approximately 8-10 inches (20-25 cm).

NOTE: Curing will require 24 hours at 75 °F (24 °C). Prior to application of finish coat, primer undercoat must be permitted to dry for approximately 30 minutes at 75 °F (24 °C).

SUBTASK 25-20-54-300-007-A01

B. Repair of Surfaces Finished in Suede Texture Enamel

NOTE: Steps (1) thru (4) show general preparation of paint materials, equipment adjustments and application procedures for paint repair of fiberglass reinforced plastic resin, polycarbonate resin and decorative metal parts.

- (1) Thoroughly blend equal parts of applicable undercoat or enamel base and catalyst according to manufacturer's instructions.

CAUTION: DO NOT THIN MIXTURE.

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Recommended Finishes
Table 6002/TABLE 25-20-54-300-001-A01

Finish	Material	Source (1)
Primer, Light Grey	DZL32	Crown Metro Inc. (V0S4B8)
Paint, "Pepperdust"	No. 26424, semi-gloss	Crown Metro Inc. (V0S4B8)
(1) Refer to Manufacturer Names and Addresses section for vendor information		

(2) Strain mixture through 150 mesh paint strainer. Label container with date and hour of mixing and allow mixture to stand for 1 hour before using.

NOTE: Pot life of mixed coatings is 16 hours at a temperature below 80 °F (27 °C), 12 hours at 80-85 °F (27-30 °C), and 8 hours at temperatures above 85 °F (30 °C). Pot life may be extended go as much as 36 hours if the material can be stored below 40 °F (5 °C).

CAUTION SCRAP ALL MATERIAL WHOSE POT LIFE HAS EXPIRED.

(3) Adjust spray booth line adjustments as follows:

(a) Air line pressure to 100 psi.
(b) Pot pressure to 8 psi.

(4) Adjust spray gun as follows:

(a) For a finer texture, decrease paint output by adjusting paint meter valve. Increase atomization by increasing air volume thru gun by adjusting air metering valve.
(b) For a coarser texture, increase paint output by adjusting paint metering valve. Decrease atomization by increasing air volume through gun by adjusting air metering valve.
(c) Spray application should be accomplished approximately 18 inches (46 cm) from part.

NOTE: Table 603 lists recommended spray paint equipment used to apply sueded texture finish. It is not mandatory that the listed equipment be used, however, similar equipment is required to create a finish compatible with area adjacent to damaged part.

Recommended Spray Paint Equipment
Table 6003/TABLE 25-20-54-300-002-A01

Item	Part No.	Source (1)
Spray	Type MBC510	De Vilbiss Co. (V0GAZ6)
Nozzle	30	De Vilbiss Co. (V0GAZ6)
Fluid tip	IAV-15EX	De Vilbiss Co. (V0GAZ6)
Fluid needle	MBC 496D-EX	De Vilbiss Co. (V0GAZ6)
(1) Refer to Manufacturer Names and Addresses section for vendor information		



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- (5) Repair painted fiberglass reinforced plastic resin parts as follows:
 - (a) Feather sand damaged area. Wipe sanding residue from area with clean, lint-free cloth dampened in Aliphatic Naphtha.
 - (b) Remove any additional sanding residue by wiping area with a clean, lint-free cloth dampened in Aliphatic Naphtha.

NOTE: If the epoxy undercoats is damaged, prepare under coat mixture and apply one coat. Allow to cure for 8 hours at 75 °F (24 °C). Lightly sand undercoat. Clean sanding residue with clean, dry, compressed air.

- (c) Prepare the applicable finish enamel paint mixture. Apply and allow to cure for 12 hours at 75 °F (24 °C).

- (6) Repair painted polycarbonate resin parts as follows:
 - (a) Clean damaged area with clean, lint-free cloth dampened in Isopropyl Alcohol.
 - (b) Prepare semigloss enamel coating mixture and apply. Oven cure for 1/2 hour at 150-200 °F (66-93 °C).
- (7) Repair painted metallic parts as follows:
 - (a) Clean surface to be painted with clean, lint-free cloth dampened with Toluene. Before the solvent evaporates, wipe dry with clean cloth.
 - (b) Thoroughly blend a mixture of epoxy enamel according to Table 603 and apply. Oven cure for 1/2 hour at 150-200 °F (66-93 °C) or allow to air dry for 4 hours at 75 °F (24 °C).
- (8) Prepare applicable enamel finish and apply. Oven cure for 1/2 hour at 150-200 °F (60-93 °C).

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ASSEMBLY

TASK 25-20-54-99F-808-A01

1. General

- A. During assembly, always use new low-cost items, such as cotter pins, screws, washers, nuts, grommets, etc., when possible to prevent future maintenance requirements due to failure of these items. Prior to initiating assembly procedures, inspect all parts for wear and/or damage which could result in failure of the seat assembly or any of its component assemblies.
- B. Recommended assembly materials are listed in Table 7001. Equivalent substitutes may be used for listed items.

TASK 25-20-54-940-003-A01

2. Assembly Materials

SUBTASK 25-20-54-94A-003-A01

Assembly Materials
Table 7001/TABLE 25-20-54-94A-004-A01

Material	Identification	Source (1)	Use
Adhesive	FR11016A/B	HB Fullerr North America. (V26348)	Bonding of seat back diaphragm.
Epoxy Adhesive	DP420	3M Co. (V76381)	Bonding of sleeves.
Velcro tape (hook) (color to match, cut to length)	V200-1(80)-200	Hartwell Corp. (V83014)	Applied to seat back or bottom to mate with tapes on cushions.
Velcro tape (pile) (color to match, cut to length)	V200-2-200	Hartwell Corp. (V83014)	Applied to dress cover.
Velcro tape (hook) (color to match, cut to length)	V200-1(80)-75	Hartwell Corp. (V83014)	Applied to dress cover.
Velcro tape (pile) (color to match, cut to length)	V200-2-75	Hartwell Corp. (V83014)	Apply to fireblock cushion.
(1) Refer to Manufacturer Names and Addresses section for vendor information			

TASK 25-20-54-400-001-A01

3. Assembly Procedures

SUBTASK 25-20-54-440-001-A01

A. Single Attendant Seat Assembly (Refer to Figure 1)

- (1) Install the protective cover assemblies (110) to the restraint system (90).
- (2) Install the restraint system (90) to the upholstered back assembly (25) with bolts (105), washers (100), and nuts (95).
- (3) Assemble the upholstered back assembly (25) in accordance with SUBTASK 25-20-54-440-002-A01.

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- (4) Install the upholstered back assembly (25), spring sleeves (65), return springs (70 and 75), and spring cover (80) to the upholstered bottom assembly (115) with bolts (60), nylon washers (50), washers (45 and 55), nuts (40), washers (35), and nuts (30).

NOTE: Washer may vary between AN960-516L and AN960-516 in order to achieve 1.5 - 2.0 thread protrusion with nut installed.

- (5) Install the close out cover assembly (20) to the upholstered bottom assembly (115).
- (6) Install the upholstered headrest assembly (5) to the upholstered back assembly (25).

SUBTASK 25-20-54-440-002-A01

B. Upholstered Back Assembly (Refer to Figure 2)

- (1) Assemble the structure assembly (20) as follows:
 - (a) Install the velcro strips (25 and 30) to the diaphragm (35).
 - (b) Install the diaphragm (35) to the seat back weldment assembly (40).

NOTE: Install the diaphragm (35) using FR11016, Adhesive.

- (2) Install the sleeves (15) to the structure assembly (20).

NOTE: Install the sleeves (15) using DP420, Epoxy Adhesive.
- (3) Install the fireblocked cushion assembly (10) to structure assembly (20).
- (4) Install the dress cover assembly (5) to the fireblocked cushion assembly (10) and structure assembly (20).

TASK 25-20-54-400-002-A01

4. Installation

Place seat assembly in position on bulkhead and install seat mounting hardware using Loctite thread locking compound.

TASK 25-20-54-550-802-A01

5. Storage Procedure

- A. The seat assembly is essentially corrosion-resistant and no special preservation is required other than would normally be accorded to an item having trim and finish items visible to the passengers or crew.
- B. Wrap seat assembly in waterproof wrapping paper (Federal Specification UU-P-271) or equivalent, or a plastic cover. Use tape (Federal Specification JAN-P-127) or equivalent, to secure wrapping paper or cover.
- C. Identify seat assembly part number and date of overhaul on a tag, or in a convenient location on the seat assembly wrapper.
- D. Store seat assembly in a cool, dry place, away from sunlight and heat source.



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FITS AND CLEARANCES

TASK 25-20-54-99F-809-A01

1. General

There are no fits and clearances applicable to the parts detailed in this manual.

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SPECIAL TOOLS, FIXTURES, EQUIPMENT AND CONSUMABLE

TASK 25-20-54-99F-810-A01

1. General

- A. There are no special tools or equipment required.
- B. It is recommended that a test fixture simulating the mounting provisions of the aircraft be used during maintenance upon and testing of the seat assembly.

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ILLUSTRATED PARTS LIST (IPL)

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TASK 25-20-54-99F-8011-A01

1. Scope of Information

A. Introduction

(1) General

(a) Each assembly is recorded and immediately followed by a record of its detail parts. The record is indentured to show the difference between each part and the higher assembly. Item numbers in the parts list agree with the item numbers of the included illustration (figure).

(2) How to Identify a Part

(a) When the part number is known, find the part number in the index. Record the figure and item number. Find the item number in the applicable parts list and illustration to get the necessary data.

(b) When the part number is not known, look at the illustrations to identify the part by shape and location. Refer to the included parts list to get the PART NUMBER, NOMENCLATURE, EFFECTIVITY, and QUANTITY.

(c) Use the EFFECTIVITY CODE to show the use of a part to its higher assembly. When the EFFECTIVITY CODE column is empty, the use of the part applies to all NEXT-HIGHER-ASSEMBLIES unless specified differently in the NOMENCLATURE column.

TASK 25-20-54-99F-812-A01

2. Equipment Designator Index

A. General

(1) The EQUIPMENT DESIGNATOR INDEX is an aid to find the parts in the DETAIL PARTS LIST by the EQUIPMENT DESIGNATOR. Each entry gives the EQUIPMENT DESIGNATOR, the PART NUMBER, the FIGURE NUMBER, and the ITEM NUMBER.

(2) Put the EQUIPMENT DESIGNATOR INDEX in sequence, one character at a time, from left to right. The correct sequence is (1) dash, (2) letters A through Z, and (3) numerals 0 through 9.

TASK 25-20-54-99F-812-A01

3. Numerical Index

A. General

(1) The NUMERICAL INDEX is an aid to find parts in the DETAIL PARTS LIST by part number. It gives the FIGURE NUMBER, the ITEM NUMBER, and the TOTAL QUANTITY REQUIRED for each entry.

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(2) Put the PART NUMBERS in sequence, one character at a time, from left to right. The correct sequence is (1) dash, (2) letters A through Z, and (3) numerals 0 through 9.

TASK 25-20-54-99F-813-A01

4. Explanation of Detail Parts List Entries

A. General

(1) The DETAIL PARTS LIST is the general sequence of disassembly. Illustrate the parts and record them in the related parts list.

(2) FIG. ITEM Column

- (a) The first number at the top of each FIG. ITEM column is the figure number of the exploded-view illustration. The number given opposite each part number is the item number given to the part in the illustration.
- (b) A dash (-) in front of an item number shows that the part is not illustrated.
- (c) Alpha-variants A through Z (except I and O) are given to item numbers when necessary to identify added parts, alternate parts, and parts changed by service bulletins.

(3) PART NUMBER Column

- (a) This column gives the part number of the manufacturer for each part, as changed to meet the requirements of ATA 200/2000. The changes can include:
 - 1 Removal of empty spaces and special characters. Dashes are permitted only between number characters.
 - 2 Add a reference part number that agrees with ATA 200/2000 if the PART NUMBER is longer than 15 characters. In these cases, give the full part number in the NOMENCLATURE column.

(4) INDENTURE Column

- (a) The indenture column shows how parts are related. A typical relation is as follows:

0 1 2 3

Assembly

 - * Detailed parts for assembly
 - * Sub- assembly
 - * * Detailed parts for sub-assembly
 - * * Sub-sub-assembly
 - * * * Detailed parts for sub-sub-assembly



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(5) NOMENCLATURE Column

- (a) This column gives descriptive nomenclature for each part. It can also give the CAGE code of the manufacturer (if the part is not made by Zodiac Seats California LLC), the part number (if it is longer than 15 digits or changed to ATA 200/2000), a service bulletin that changes the part, and expired part numbers. The column also gives the figure for NHA and more data as necessary.
- (b) Record both the pre- and post-service bulletin configurations of assemblies, subassemblies, and detail parts subjected to modification, deletion, addition, or replacement by an issued service bulletin. The term (PRE SB XXXX) in the NOMENCLATURE column identifies the initial configuration, and the term (POST SB XXXX) identifies assemblies and parts after the change is completed.
- (c) When applicable, use the terms defined below to indicate the interchangeability of parts. These names show how parts are interchangeable.

Abbreviation	Term	Definition
ALT	Alternate	The recorded part is an alternative to and interchangeable with other parts in the same item number group or other item numbers when identified.
SUPSD BY	Superseded By	The part is superseded by and is not interchangeable with the item number identified in the note.
SUPSDS	Supersedes	The part supersedes and is not interchangeable with the item number identified in the note.
RPLD BY	Replaced By	The part is replaced by and is interchangeable with the item number identified in the note.
RPLS	Replaces	The part replaces and is interchangeable with the item number identified in the note.



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(6) EFF CODE Column

(a) This column contains effectiveness codes (A, B, etc.) to indicate the alternate models or configurations of the end items to which the parts apply. This column is left blank when the parts apply to all models or configurations in the parts list. When an asterisk (*) is used, the part is contained in a kit which is listed at the end of the detail parts lists.

(7) UNITS PER ASSY Column

(a) The quantity shown in this column is the units required for one next higher assembly (NHA). The abbreviation RF (reference) means the end item or assembly is shown completely assembled in the figure referenced in the NOMENCLATURE column.

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CODE	NAME	ADDRESS
VB4946	HSH AEROSPACE FINISHES NV	RESEARCH PARK ZONE 1 DE HAAK 3 ZELLIK BELGIUM 1731
V0FYV4	ACCURATE SCREW MACHINE CO	23685 ELK WOOD ST CANOGA PARK CA 91304
V0GAZ6	DEVILBISS CO.	12878 E FLORENCE SANTA FE SPRINGS CA 90670
V0HGX6	DOUGLASS INTERIOR PRODUCTS INC.	1910 132ND AVENUE NE BELLEVUE WA 98005-2198
V0S4B8	CROWN METRO AEROSPACE COATINGS INC.	315 ECHELON RD GREENVILLE SC 29606
V0VYR8	DUPONT E I DE NEMOURS AND CO.	3300 PACIFIC AVE. BURBANK CA 91505
V0YRK7	LANTAL TEXTILES INC.	1300 LANGENTHAL DR RURAL HALL NC 27045 0000
V25670	STABOND CORP.	1722 W 139TH ST. GARDENA CA 90249-3092

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CODE	NAME	ADDRESS
V26348	HB FULLER NORTH AMERICA	1200 WILLOW LAKE BLVD VADNAIS HEIGHTS MN 55110-5146
V3ULF6	TAPIS CORPORATION	28 KAYSAL COURT ARMONK NY 10504 1344
V35FB9	AM SAFE INC.	1043 NORTH 47TH AVE PHOENIX AZ 85043-1817
V49U11	PERRONE LEATHER LLC	182 RIVERSIDE DR FULTONVILLE NY 12072-1750
V5XL95	CORTINA LEATHERS INC.	45 WEST 25TH STREET FL 3 NEW YORK NY 10010 2080
V6J2A7	ZODIAC SEATS CALIFORNIA LLC	11340 JERSEY BLVD RANCHO CUCAMONGA CA 91730-4919
V7W290	LANGENTHAL CORP.	300 120TH AVE NE BELLEVUE WA 98005-3001
V76381	3M COMPANY	3M CENTER BLDG 220 11W 02 SAINT PAUL MN 55144-1001
V83014	HARTWELL CORPORATION	900 S RICHFIELD RD PLACENTIA CA 92870-6732

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ALPHA/NUMERIC INDEX

PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
AN960-1216L		1	55	2
AN960-516		1	100A 45A 55A	4 8 2
AN960-516L		1	100 45	4 6
AN970-3		1	35	4
DP420		2	16	AR
FR11016		2	36	AR
MS21042-3		1	30	2
MS21042-5		1	40 95	2 2
NAS1305-36		1	60	2
NAS1305-40		1	60A	2
NAS6205-17		1	105	4
V20080100		2	25	AR
V20080200		2	30	AR
121-7		1	70	1
121-8		1	75	1
121-9		1	65	2
122-7		1	80	2
16285-1		2	15	2
16287-31		2	35	1
16441-1		1	130	1
16442-11		1	120	1

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
16442-11AB		1	120F	1
16442-11AC		1	120T	1
16442-11AD		1	120P	1
16442-11AE		1	120U	1
16442-11AG		1	120V	1
16442-11AH		1	120R	1
16442-11AU		1	120S	1
16442-11C		1	120A	1
16442-11H		1	120B	1
16442-11K		1	120C	1
16442-11N		1	120D	1
			120Q	1
16442-11U		1	120E	1
			120H	1
			120K	1
			120N	1
16442-11V		1	120G	1
			120J	1
			120L	1
			120M	1
16442-3		1	115	1
16442-3AB		1	115F	1
16442-3AC		1	115T	1
16442-3AD		1	115P	1
16442-3AE		1	115U	1
16442-3AG		1	115V	1
16442-3AH		1	115R	1

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
16442-3AU		1	115S	1
16442-3C		1	115A	1
16442-3H		1	115B	1
16442-3K		1	115C	1
16442-3N		1	115D	1
			115Q	1
16442-3U		1	115E	1
			115H	1
			115K	1
			115N	1
16442-3V		1	115G	1
			115J	1
			115L	1
			115M	1
16442-7		1	125	1
17981-1		1	135A	1
			135B	1
19733-501		2	20	1
19733-503		2	40	1
19736-501		1	25	1
		2	1	RF
19736-501AB		1	25F	1
		2	1F	RF
19736-501AC		1	25T	1
		2	1T	RF
19736-501AD		1	25P	1
		2	1P	RF
19736-501AE		1	25U	1
		2	1U	RF

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
19736-501AG		1 2	25V 1V	1 RF
19736-501AH		1 2	25R 1R	1 RF
19736-501AU		1 2	25S 1S	1 RF
19736-501C		1 2	25A 1A	1 RF
19736-501H		1 2	25B 1B	1 RF
19736-501K		1 2	25C 1C	1 RF
19736-501N		1 2	25D 25Q 1D 1Q	1 1 RF RF
19736-501U		1 2	25E 25H 25K 25N 1E 1H 1K 1N	1 1 1 1 RF RF RF RF
19736-501V		1 2	25G 25J 25L 25M 1G 1J 1L 1M	1 1 1 1 RF RF RF RF
19736-503		2	10	1
19736-505		2	5	1

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
19736-505AB		2	5F	1
19736-505AC		2	5T	1
19736-505AD		2	5P	1
19736-505AE		2	5U	1
19736-505AG		2	5V	1
19736-505AH		2	5R	1
19736-505AU		2	5S	1
19736-505C		2	5A	1
19736-505H		2	5B	1
19736-505K		2	5C	1
19736-505N		2	5D 5Q	1 1
19736-505U		2	5E 5H 5K 5N	1 1 1 1
19736-505V		2	5G 5J 5L 5M	1 1 1 1
19738-501		1	5	1
19738-501AB		1	5F	1
19738-501AC		1	5T	1
19738-501AD		1	5P	1
19738-501AE		1	5U	1
19738-501AG		1	5V	1
19738-501AH		1	5R	1

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
19738-501AU		1	5S	1
19738-501C		1	5A	1
19738-501H		1	5B	1
19738-501K		1	5C	1
19738-501N		1	5D	1
			5Q	1
19738-501U		1	5E	1
			5H	1
			5K	1
			5N	1
19738-501V		1	5G	1
			5J	1
			5L	1
			5M	1
19738-503		1	15	1
19738-505		1	10	1
19738-505AB		1	10F	1
19738-505AC		1	10T	1
19738-505AD		1	10P	1
19738-505AE		1	10U	1
19738-505AG		1	10V	1
19738-505AH		1	10R	1
19738-505AU		1	10S	1
19738-505C		1	10A	1
19738-505H		1	10B	1
19738-505K		1	10C	1

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
19738-505N		1	10D 10Q	1 1
19738-505U		1	10E 10H 10K 10N	1 1 1 1
19738-505V		1	10G 10J 10L 10M	1 1 1 1
19800-101		1	1	RF
19800-103AB		1	1F	RF
19800-103C		1	1A	RF
19800-103H		1	1B	RF
19800-103K		1	1C	RF
19800-103N		1	1D	RF
19800-103U		1	1E	RF
19800-105V		1	1G	RF
19800-107U		1	1H	RF
19800-109V		1	1J	RF
19800-111U		1	1K	RF
19800-113V		1	1L	RF
19800-115V		1	1M	RF
19800-117AD		1	1P	RF
19800-117U		1	1N	RF
19800-119AH		1	1R	RF
19800-119AU		1	1S	RF

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
19800-119N		1	1Q	RF
19800-121AC		1	1T	RF
19800-121AE		1	1U	RF
19800-123AG		1	1V	RF
19928-501		1	20	1
19928-501AB		1	20F	1
19928-501AC		1	20T	1
19928-501AD		1	20P	1
19928-501AE		1	20U	1
19928-501AG		1	20V	1
19928-501AH		1	20R	1
19928-501AU		1	20S	1
19928-501C		1	20A	1
19928-501H		1	20B	1
19928-501K		1	20C	1
19928-501N		1	20D	1
			20Q	1
19928-501U		1	20E	1
			20H	1
			20K	1
			20N	1
19928-501V		1	20G	1
			20J	1
			20L	1
			20M	1
19933-501		1	110	2
19935-1		1	85	D

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
281-030N1		1	50	4
379-5		1	135	1
503037-401-1449AC		1	90T	1
503037-401-1449AE		1	90U	1
503037-401-1449V		1	90G	1
503037-401-2051AG		1	90V	1
503037-401-2251		1	90	1
503037-401-2251AB		1	90F	1
503037-401-2251AH		1	90R	1
503037-401-2251AU		1	90S	1
503037-401-2251C		1	90A	1
503037-401-2251H		1	90B	1
503037-401-2251K		1	90C	1
503037-401-2251N		1	90D 90Q	1
503037-401-2251U		1	90E	1
503037-401-2258V		1	90L	1
503037-401-2847AD		1	90P	1
503037-401-2847U		1	90N	1
504813-401-1449V		1	90J 90M	1
504813-401-2847U		1	90H 90K	1

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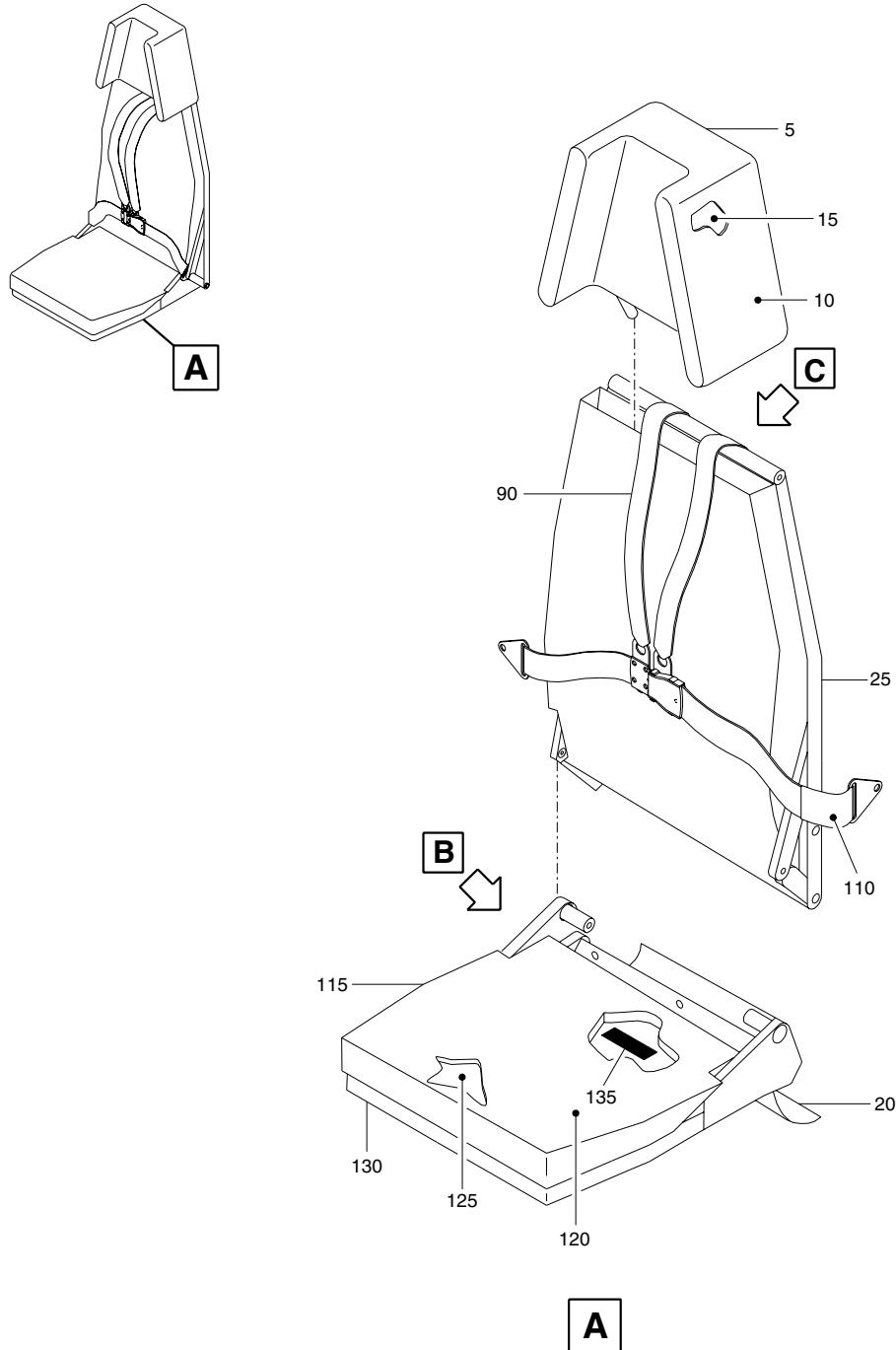
DETAILED PARTS LIST

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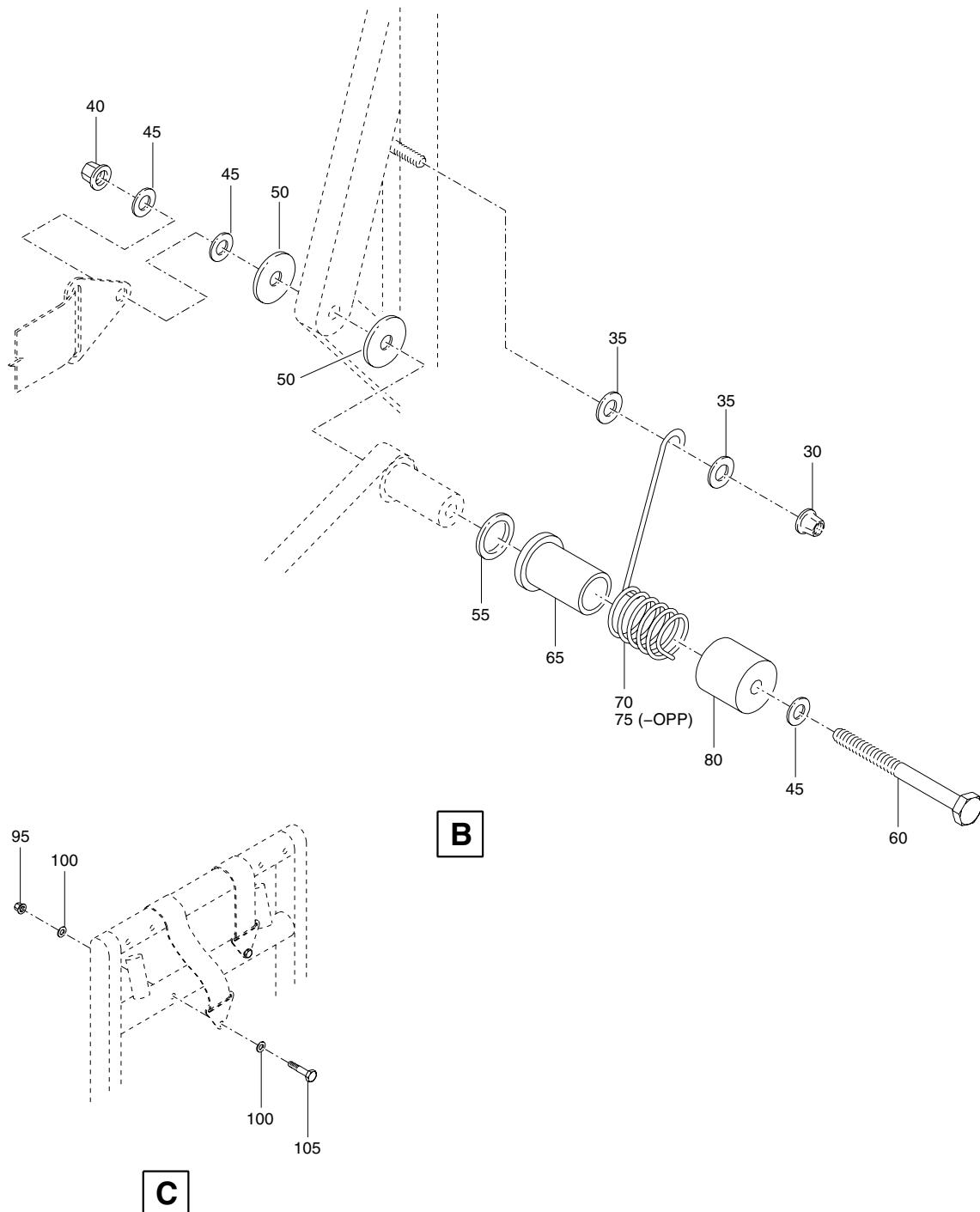
Single Attendant Seat Assembly
(Sheet 1 of 2)
Figure 1/GRAFIC 25-20-54-950-001-A01

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Single Attendant Seat Assembly
(Sheet 2 of 2)
Figure 1/GRAFIC 25-20-54-950-001-A01

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE	EFFECT CODE	UNITS PER ASSY
1 – 1	19800-101		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	A	RF
– 1A	19800-103C		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	B	RF
– 1B	19800-103H		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	C	RF
– 1C	19800-103K		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	D	RF
– 1D	19800-103N		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	E	RF
– 1E	19800-103U		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	F	RF
– 1F	19800-103AB		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	G	RF
– 1G	19800-105V		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	H	RF
– 1H	19800-107U		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	J	RF
– 1J	19800-109V		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	K	RF
– 1K	19800-111U		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	L	RF
– 1L	19800-113V		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	M	RF
– 1M	19800-115V		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	N	RF
– 1N	19800-117U		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	P	RF
– 1P	19800-117AD		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	Q	RF
– 1Q	19800-119N		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	R	RF
– 1R	19800-119AH		SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	S	RF

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE	EFFECT CODE	UNITS PER ASSY
1	– 1S	19800-119AU	SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	T	RF
	– 1T	19800-121AC	SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	U	RF
	– 1U	19800-121AE	SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	V	RF
	– 1V	19800-123AG	SEAT ASSY, SINGLE ATTENDANT (FWD FACING)	W	RF
	5	19738-501	. HEADREST ASSY, UPHOLSTERED	A	1
	– 5A	19738-501C	. HEADREST ASSY, UPHOLSTERED	B	1
	– 5B	19738-501H	. HEADREST ASSY, UPHOLSTERED	C	1
	– 5C	19738-501K	. HEADREST ASSY, UPHOLSTERED	D	1
	– 5D	19738-501N	. HEADREST ASSY, UPHOLSTERED	E	1
	– 5E	19738-501U	. HEADREST ASSY, UPHOLSTERED	F	1
	– 5F	19738-501AB	. HEADREST ASSY, UPHOLSTERED	G	1
	– 5G	19738-501V	. HEADREST ASSY, UPHOLSTERED	H	1
	– 5H	19738-501U	. HEADREST ASSY, UPHOLSTERED	J	1
	– 5J	19738-501V	. HEADREST ASSY, UPHOLSTERED	K	1
	– 5K	19738-501U	. HEADREST ASSY, UPHOLSTERED	L	1
	– 5L	19738-501V	. HEADREST ASSY, UPHOLSTERED	M	1
	– 5M	19738-501V	. HEADREST ASSY, UPHOLSTERED	N	1
	– 5N	19738-501U	. HEADREST ASSY, UPHOLSTERED	P	1
	– 5P	19738-501AD	. HEADREST ASSY, UPHOLSTERED	Q	1
	– 5Q	19738-501N	. HEADREST ASSY, UPHOLSTERED	R	1
	– 5R	19738-501AH	. HEADREST ASSY, UPHOLSTERED	S	1
	– 5S	19738-501AU	. HEADREST ASSY, UPHOLSTERED	T	1
	– 5T	19738-501AC	. HEADREST ASSY, UPHOLSTERED	U	1
	– 5U	19738-501AE	. HEADREST ASSY, UPHOLSTERED	V	1

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE	EFFECT CODE	UNITS PER ASSY
1 – 5V	19738-501AG		. HEADREST ASSY, UPHOLSTERED	W	1
10	19738-505		.. COVER ASSY, DRESS	A	1
– 10A	19738-505C		.. COVER ASSY, DRESS (FABRIC)	B	1
– 10B	19738-505H		.. COVER ASSY, DRESS (FABRIC)	C	1
– 10C	19738-505K		.. COVER ASSY, DRESS (LEATHER)	D	1
– 10D	19738-505N		.. COVER ASSY, DRESS (FABRIC)	E	1
– 10E	19738-505U		.. COVER ASSY, DRESS (ULTRA LEATHER)	F	1
– 10F	19738-505AB		.. COVER ASSY, DRESS (FABRIC)	G	1
– 10G	19738-505V		.. COVER ASSY, DRESS (FABRIC)	H	1
– 10H	19738-505U		.. COVER ASSY, DRESS (ULTRA LEATHER)	J	1
– 10J	19738-505V		.. COVER ASSY, DRESS (FABRIC)	K	1
– 10K	19738-505U		.. COVER ASSY, DRESS (ULTRA LEATHER)	L	1
– 10L	19738-505V		.. COVER ASSY, DRESS (FABRIC)	M	1
– 10M	19738-505V		.. COVER ASSY, DRESS (FABRIC)	N	1
– 10N	19738-505U		.. COVER ASSY, DRESS (ULTRA LEATHER)	P	1
– 10P	19738-505AD		.. COVER ASSY, DRESS (LEATHER)	Q	1
– 10Q	19738-505N		.. COVER ASSY, DRESS (FABRIC)	R	1
– 10R	19738-505AH		.. COVER ASSY, DRESS (LEATHER)	S	1

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE	EFFECT CODE	UNITS PER ASSY
1 – 10S	19738-505AU		.. COVER ASSY, DRESS (FABRIC)	T	1
– 10T	19738-505AC		.. COVER ASSY, DRESS (LEATHER)	U	1
– 10U	19738-505AE		.. COVER ASSY, DRESS (LEATHER)	V	1
– 10V	19738-505AG		.. COVER ASSY, DRESS (LEATHER)	W	1
15	19738-503		.. CUSHION ASSY, FIREBLOCKED		1
20	19928-501		. COVER ASSY, CLOSE OUT (OPT)	A	1
– 20A	19928-501C		. COVER ASSY, CLOSE OUT (FABRIC) (OPT)	B	1
– 20B	19928-501H		. COVER ASSY, CLOSE OUT (FABRIC) (OPT)	C	1
– 20C	19928-501K		. COVER ASSY, CLOSE OUT (LEATHER) (OPT)	D	1
– 20D	19928-501N		. COVER ASSY, CLOSE OUT (FABRIC) (OPT)	E	1
– 20E	19928-501U		. COVER ASSY, CLOSE OUT (ULTRA LEATHER) (OPT)	F	1
– 20F	19928-501AB		. COVER ASSY, CLOSE OUT (FABRIC) (OPT)	G	1
– 20G	19928-501V		. COVER ASSY, CLOSE OUT (FABRIC) (OPT)	H	1
– 20H	19928-501U		. COVER ASSY, CLOSE OUT (ULTRA LEATHER) (OPT)	J	1

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE	EFFECT CODE	UNITS PER ASSY
1 – 20J	19928-501V		. COVER ASSY, CLOSE OUT (FABRIC) (OPT)	K	1
– 20K	19928-501U		. COVER ASSY, CLOSE OUT (ULTRA LEATHER) (OPT)	L	1
– 20L	19928-501V		. COVER ASSY, CLOSE OUT (FABRIC) (OPT)	M	1
– 20M	19928-501V		. COVER ASSY, CLOSE OUT (FABRIC) (OPT)	N	1
– 20N	19928-501U		. COVER ASSY, CLOSE OUT (ULTRA LEATHER) (OPT)	P	1
– 20P	19928-501AD		. COVER ASSY, CLOSE OUT (LEATHER) (OPT)	Q	1
– 20Q	19928-501N		. COVER ASSY, CLOSE OUT (FABRIC) (OPT)	R	1
– 20R	19928-501AH		. COVER ASSY, CLOSE OUT (LEATHER) (OPT)	S	1
– 20S	19928-501AU		. COVER ASSY, CLOSE OUT (FABRIC) (OPT)	T	1
– 20T	19928-501AC		. COVER ASSY, CLOSE OUT (LEATHER) (OPT)	U	1
– 20U	19928-501AE		. COVER ASSY, CLOSE OUT (LEATHER) (OPT)	V	1
– 20V	19928-501AG		. COVER ASSY, CLOSE OUT (LEATHER) (OPT)	W	1
25	19736-501		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	A	1

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE	EFFECT CODE	UNITS PER ASSY
1 - 25A	19736-501C		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	B	1
- 25B	19736-501H		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	C	1
- 25C	19736-501K		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	D	1
- 25D	19736-501N		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	E	1
- 25E	19736-501U		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	F	1
- 25F	19736-501AB		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	G	1
- 25G	19736-501V		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	H	1
- 25H	19736-501U		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	J	1
- 25J	19736-501V		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	K	1
- 25K	19736-501U		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	L	1
- 25L	19736-501V		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	M	1
- 25M	19736-501V		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	N	1
- 25N	19736-501U		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	P	1
- 25P	19736-501AD		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	Q	1
- 25Q	19736-501N		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	R	1
- 25R	19736-501AH		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	S	1
- 25S	19736-501AU		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	T	1

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE	EFFECT CODE	UNITS PER ASSY
1 - 25T	19736-501AC		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	U	1
- 25U	19736-501AE		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET	V	1
- 25V	19736-501AG		. BACK ASSY, UPHOLSTERED SEE FIG. 2 FOR DET ATTACHING PARTS	W	1
30	MS21042-3		. NUT (SPRING RETAINING)		2
35	AN970-3		. WASHER (SPRING RETAINING)		4
40	MS21042-5		. NUT		2
45	AN960-516L		. WASHER		6
- 45A	AN960-516		. WASHER (ALT TO ITEM 45)		8
50	281-030N1		. WASHER, NYLON (V0FYV4) (TRUE PN 281-030-N-1)		4
55	AN960-1216L		. WASHER SUPSD BY ITEM -55A		2
- 55A	AN960-516		. WASHER SUPSDS ITEM 55		2
60	NAS1305-36		. BOLT	A-K, R-W	2
- 60A	NAS1305-40		. BOLT * * *	L-Q	2
65	121-9		. SLEEVE, SPRING		2
70	121-7		. SPRING, RETURN (LH)		1
75	121-8		. SPRING, RETURN (RH)		1
80	122-7		. COVER, SPRING		2
- 85	19935-1		*** DELETED ***		D

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE	EFFECT CODE	UNITS PER ASSY
1 90	503037-401-2251		. RESTRAINT SYSTEM (V35FB9)	A	1
– 90A	503037-401-2251C		. RESTRAINT SYSTEM (V35FB9)	B	1
– 90B	503037-401-2251H		. RESTRAINT SYSTEM (V35FB9)	C	1
– 90C	503037-401-2251K		. RESTRAINT SYSTEM (V35FB9)	D	1
– 90D	503037-401-2251N		. RESTRAINT SYSTEM (V35FB9)	E	1
– 90E	503037-401-2251U		. RESTRAINT SYSTEM (V35FB9)	F	1
– 90F	503037-401-2251AB		. RESTRAINT SYSTEM (V35FB9)	G	1
– 90G	503037-401-1449V		. RESTRAINT SYSTEM (V35FB9)	H	1
– 90H	504813-401-2847U		. RESTRAINT SYSTEM (V35FB9)	J	1
– 90J	504813-401-1449V		. RESTRAINT SYSTEM (V35FB9)	K	1
– 90K	504813-401-2847U		. RESTRAINT SYSTEM (V35FB9)	L	1
– 90L	503037-401-2258V		. RESTRAINT SYSTEM (V35FB9)	M	1
– 90M	504813-401-1449V		. RESTRAINT SYSTEM (V35FB9)	N	1
– 90N	503037-401-2847U		. RESTRAINT SYSTEM (V35FB9)	P	1
– 90P	503037-401-2847AD		. RESTRAINT SYSTEM (V35FB9)	Q	1
– 90Q	503037-401-2251N		. RESTRAINT SYSTEM (V35FB9)	R	1
– 90R	503037-401-2251AH		. RESTRAINT SYSTEM (V35FB9)	S	1

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE	EFFECT CODE	UNITS PER ASSY
1 – 90S	503037-401-2251AU		. RESTRAINT SYSTEM (V35FB9)	T	1
– 90T	503037-401-1449AC		. RESTRAINT SYSTEM (V35FB9)	U	1
– 90U	503037-401-1449AE		. RESTRAINT SYSTEM (V35FB9)	V	1
– 90V	503037-401-2051AG		. RESTRAINT SYSTEM (V35FB9) ATTACHING PARTS	W	1
95	MS21042-5		. NUT		2
100	AN960-516L		. WASHER		4
– 100A	AN960-516		. WASHER (ALT TO ITEM 100)		4
105	NAS6205-17		. BOLT		4
			* * *		
110	19933-501		. COVER ASSY, PROTECTIVE	L-W	2
115	16442-3		. BOTTOM ASSY, UPHOLSTERED	A	1
– 115A	16442-3C		. BOTTOM ASSY, UPHOLSTERED	B	1
– 115B	16442-3H		. BOTTOM ASSY, UPHOLSTERED	C	1
– 115C	16442-3K		. BOTTOM ASSY, UPHOLSTERED	D	1
– 115D	16442-3N		. BOTTOM ASSY, UPHOLSTERED	E	1
– 115E	16442-3U		. BOTTOM ASSY, UPHOLSTERED	F	1
– 115F	16442-3AB		. BOTTOM ASSY, UPHOLSTERED	G	1
– 115G	16442-3V		. BOTTOM ASSY, UPHOLSTERED	H	1
– 115H	16442-3U		. BOTTOM ASSY, UPHOLSTERED	J	1
– 115J	16442-3V		. BOTTOM ASSY, UPHOLSTERED	K	1
– 115K	16442-3U		. BOTTOM ASSY, UPHOLSTERED	L	1
– 115L	16442-3V		. BOTTOM ASSY, UPHOLSTERED	M	1
– 115M	16442-3V		. BOTTOM ASSY, UPHOLSTERED	N	1

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE	EFFECT CODE	UNITS PER ASSY
1 – 115N	16442-3U		. BOTTOM ASSY, UPHOLSTERED	P	1
– 115P	16442-3AD		. BOTTOM ASSY, UPHOLSTERED	Q	1
– 115Q	16442-3N		. BOTTOM ASSY, UPHOLSTERED	R	1
– 115R	16442-3AH		. BOTTOM ASSY, UPHOLSTERED	S	1
– 115S	16442-3AU		. BOTTOM ASSY, UPHOLSTERED	T	1
– 115T	16442-3AC		. BOTTOM ASSY, UPHOLSTERED	U	1
– 115U	16442-3AE		. BOTTOM ASSY, UPHOLSTERED	V	1
– 115V	16442-3AG		. BOTTOM ASSY, UPHOLSTERED	W	1
120	16442-11		.. COVER ASSY, DRESS	A	1
– 120A	16442-11C		.. COVER ASSY, DRESS (FABRIC)	B	1
– 120B	16442-11H		.. COVER ASSY, DRESS (FABRIC)	C	1
– 120C	16442-11K		.. COVER ASSY, DRESS (LEATHER)	D	1
– 120D	16442-11N		.. COVER ASSY, DRESS (FABRIC)	E	1
– 120E	16442-11U		.. COVER ASSY, DRESS (ULTRA LEATHER)	F	1
– 120F	16442-11AB		.. COVER ASSY, DRESS (FABRIC)	G	1
– 120G	16442-11V		.. COVER ASSY, DRESS (FABRIC)	H	1
– 120H	16442-11U		.. COVER ASSY, DRESS (ULTRA LEATHER)	J	1
– 120J	16442-11V		.. COVER ASSY, DRESS (FABRIC)	K	1
– 120K	16442-11U		.. COVER ASSY, DRESS (ULTRA LEATHER)	L	1
– 120L	16442-11V		.. COVER ASSY, DRESS (FABRIC)	M	1

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE	EFFECT CODE	UNITS PER ASSY
1 - 120M	16442-11V		.. COVER ASSY, DRESS (FABRIC)	N	1
- 120N	16442-11U		.. COVER ASSY, DRESS (ULTRA LEATHER)	P	1
- 120P	16442-11AD		.. COVER ASSY, DRESS (LEATHER)	Q	1
- 120Q	16442-11N		.. COVER ASSY, DRESS (FABRIC)	R	1
- 120R	16442-11AH		.. COVER ASSY, DRESS (LEATHER)	S	1
- 120S	16442-11AU		.. COVER ASSY, DRESS (FABRIC)	T	1
- 120T	16442-11AC		.. COVER ASSY, DRESS (LEATHER)	U	1
- 120U	16442-11AE		.. COVER ASSY, DRESS (LEATHER)	V	1
- 120V	16442-11AG		.. COVER ASSY, DRESS (LEATHER)	W	1
125	16442-7		.. CUSHION ASSY, FIREBLOCKED		1
130	16441-1		.. STRUCTURE ASSY		1
135	379-5		. PLACARD (NON-SPAREABLE) SUPSD BY ITEM -135A	A	1
- 135A	17981-1		. PLACARD (NON-SPAREABLE) SUPSDS ITEM 135	A	1
- 135B	17981-1		. PLACARD (NON-SPAREABLE)		1

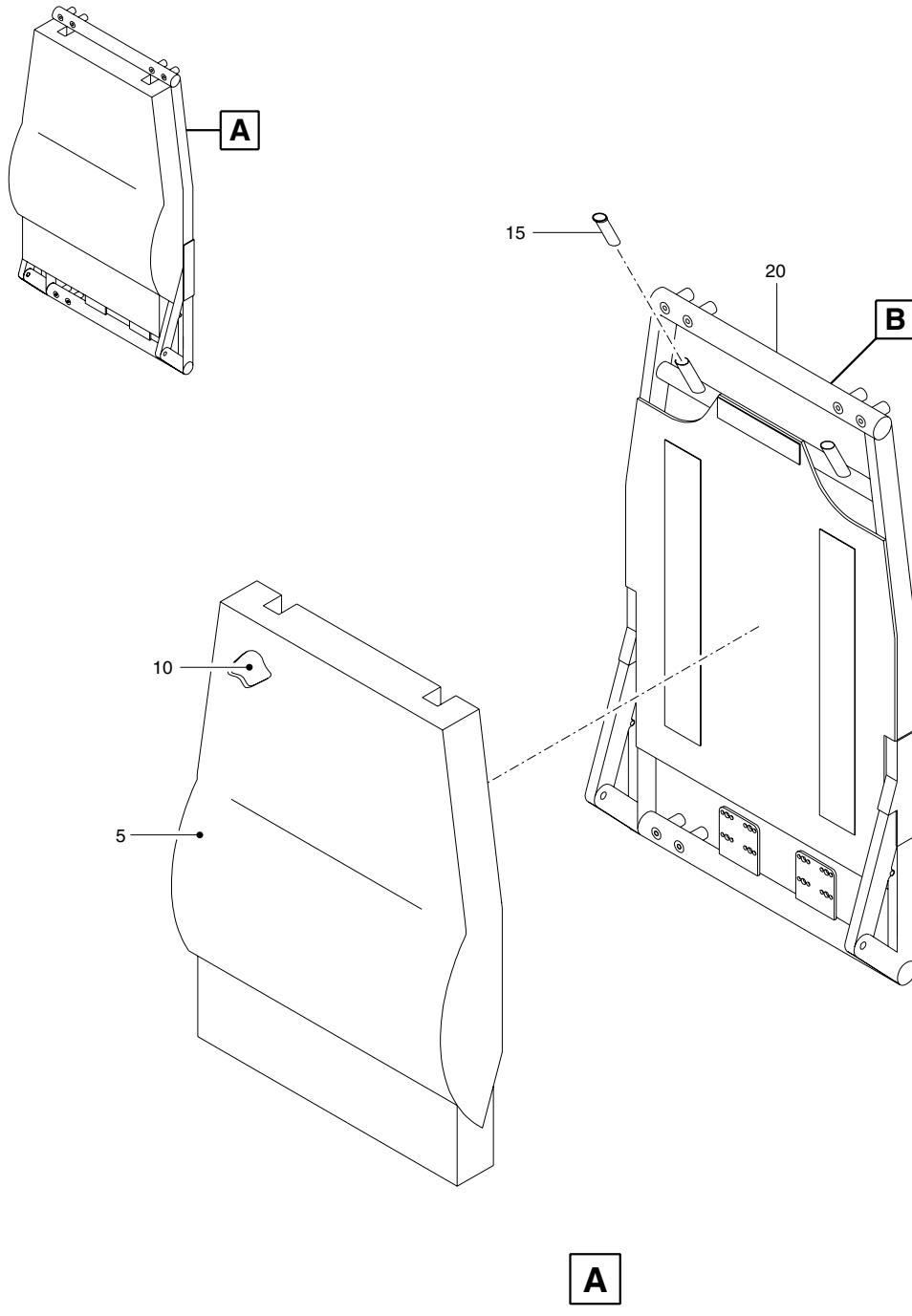
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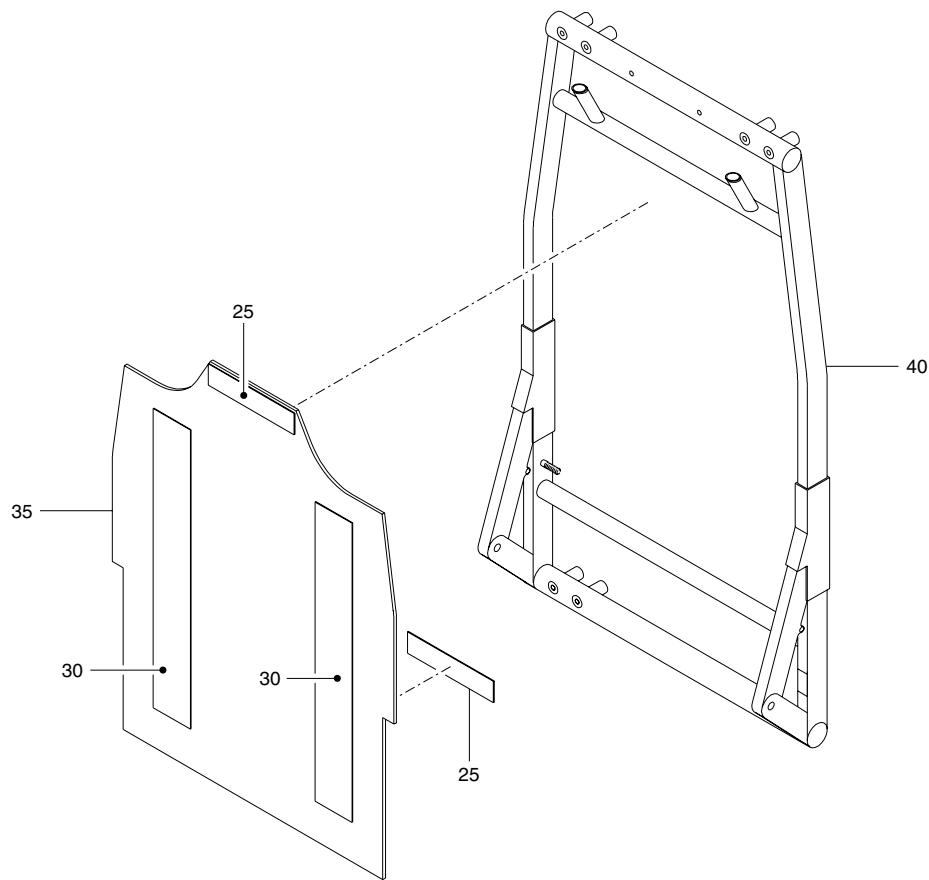
Upholstered Back Assembly
(Sheet 1 of 2)
Figure 2/GRAFIC 25-20-54-950-002-A01

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Upholstered Back Assembly
(Sheet 2 of 2)
Figure 2/GRAFIC 25-20-54-950-002-A01

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE	EFFECT CODE	UNITS PER ASSY
2 - 1	19736-501		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	A	RF
- 1A	19736-501C		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	B	RF
- 1B	19736-501H		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	C	RF
- 1C	19736-501K		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	D	RF
- 1D	19736-501N		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	E	RF
- 1E	19736-501U		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	F	RF
- 1F	19736-501AB		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	G	RF
- 1G	19736-501V		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	H	RF
- 1H	19736-501U		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	J	RF
- 1J	19736-501V		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	K	RF
- 1K	19736-501U		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	L	RF
- 1L	19736-501V		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	M	RF
- 1M	19736-501V		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	N	RF
- 1N	19736-501U		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	P	RF
- 1P	19736-501AD		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	Q	RF
- 1Q	19736-501N		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	R	RF
- 1R	19736-501AH		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	S	RF

- ITEM NOT ILLUSTRATED

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE	EFFECT CODE	UNITS PER ASSY
2	– 1S 19736-501AU		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	T	RF
	– 1T 19736-501AC		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	U	RF
	– 1U 19736-501AE		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	V	RF
	– 1V 19736-501AG		BACK ASSY, UPHOLSTERED SEE FIG. 1 FOR NHA	W	RF
5	19736-505		. COVER ASSY, DRESS	A	1
– 5A	19736-505C		. COVER ASSY, DRESS (FABRIC)	B	1
– 5B	19736-505H		. COVER ASSY, DRESS (FABRIC)	C	1
– 5C	19736-505K		. COVER ASSY, DRESS (LEATHER)	D	1
– 5D	19736-505N		. COVER ASSY, DRESS (FABRIC)	E	1
– 5E	19736-505U		. COVER ASSY, DRESS (ULTRA LEATHER)	F	1
– 5F	19736-505AB		. COVER ASSY, DRESS (FABRIC)	G	1
– 5G	19736-505V		. COVER ASSY, DRESS (FABRIC)	H	1
– 5H	19736-505U		. COVER ASSY, DRESS (ULTRA LEATHER)	J	1
– 5J	19736-505V		. COVER ASSY, DRESS (FABRIC)	K	1
– 5K	19736-505U		. COVER ASSY, DRESS (ULTRA LEATHER)	L	1
– 5L	19736-505V		. COVER ASSY, DRESS (FABRIC)	M	1
– 5M	19736-505V		. COVER ASSY, DRESS (FABRIC)	N	1

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE	EFFECT CODE	UNITS PER ASSY
2 - 5N	19736-505U		. COVER ASSY, DRESS (ULTRA LEATHER)	P	1
- 5P	19736-505AD		. COVER ASSY, DRESS (LEATHER)	Q	1
- 5Q	19736-505N		. COVER ASSY, DRESS (FABRIC)	R	1
- 5R	19736-505AH		. COVER ASSY, DRESS (LEATHER)	S	1
- 5S	19736-505AU		. COVER ASSY, DRESS (FABRIC)	T	1
- 5T	19736-505AC		. COVER ASSY, DRESS (LEATHER)	U	1
- 5U	19736-505AE		. COVER ASSY, DRESS (LEATHER)	V	1
- 5V	19736-505AG		. COVER ASSY, DRESS (LEATHER)	W	1
10	19736-503		. CUSHION ASSY, FIREBLOCKED		1
15	16285-1		. SLEEVE (BONDED)		2
- 16	DP420		. ADHESIVE, EPOXY (V76381)	AR	
20	19733-501		. STRUCTURE ASSY		1
25	V20080100		.. VELCRO STRIP, HOOK (V83014) (HOOK) (TRUE PN V200-1(80)-100)	AR	
30	V20080200		.. VELCRO STRIP, HOOK (V83014) (HOOK) (TRUE PN V200-1(80)-200)	AR	
35	16287-31		.. DIAPHRAGM (BONDED)		1
- 36	FR11016		.. ADHESIVE (V26348)	AR	
40	19733-503		.. WELDMENT ASSY, SEAT BACK		1

- ITEM NOT ILLUSTRATED

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