



COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001
5701 BOLSA AVE, HUNTINGTON BEACH, CA 92647 (CAGE NO. 56135)

REVISION TRANSMITTAL LETTER

TO:

Holders of Component Maintenance Manual (CMM) 25-32-78, revision No. 14, dated Sep 29/18.

GENERAL:

Zodiac Aerospace has become part of the Safran Group and this CMM is now issued under the new company name of Safran Cabin Inc.

This transmittal letter is attached to the revision No. 15 of CMM 25-32-78, dated Apr 23/21.

The pages that 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)

This is a complete CMM package. Discard the previous issue and replace it with this issue, revision No. 15, dated Apr 23/21.

REASON FOR ISSUE:

This manual has been revised to add new configuration Skywest STC (J70) and incorporate TR25-2 and TR25-3.

The attached highlights give details of these changes.

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HIGHLIGHTS

Revision No.15 - Apr 23/21

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	
LIST OF EFFECTIVE PAGES	R	
INTRODUCTION	R	Revised Scope to reflect the new part number.
DESCRIPTION AND OPERATION	R	Revised Table 1 (Technical Properties) to add new part number. Revised Trim and Finish to reflect new configuration.
DISASSEMBLY	R	Disassembly Procedures revised to reflect the changes made into the IPL section.
INSPECTION/CHECK	R	Revised Table 5001 to reflect updates.
ASSEMBLY	R	Assembly Procedures revised to reflect the changes made into the IPL section.
DETAILED PARTS LIST		
FIGURE 1	R	Revised to update information.
FIGURE 1B	R	Revised the artwork to incorporate updates. Revised to incorporate TR25-2 and TR25-3.
FIGURE 1F	N	Added new Figure for G2 Galley Installation.
FIGURE 8	R	Revised to update information.

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(56135)
**COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST**

G2 GALLEY ASSEMBLY

Part Number

9861001-101	9861001-115
9861001-103	9861001-117
9861001-105	9861001-119
9861001-107	9861001-121
9861001-109	9861001-123
9861001-111	9861001-125
9861001-113	E179001-101

(cont.)

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Part Number

E199001-101

E199001-103

E829001-101

H511201-101

J061502-101

J709001-101

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RECORD OF REVISIONS

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Initial Issue	Sep 15/09	Sep 15/09	C&D Zodiac				
1	Dec 31/00	Dec 31/00	C&D Zodiac				
2	Apr 01/01	Apr 01/01	C&D Zodiac				
3	Sep 15/03	Sep 15/03	C&D Zodiac				
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TR25-1	Oct 29/10	Jan 05/11	C&D Zodiac		
TR25-2	Oct 27/18	Apr 23/21	Safran Cabin Inc.		
TR25-3	Nov 07/18	Apr 23/21	Safran Cabin Inc.		

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SERVICE BULLETIN LIST

SERVICE BULLETIN		INCORPORATION INTO CMM		TITLE
Number	Rev	Date	Rev	
9861001-25-01	NC	Sep 15/03	2	G2 GALLEY REPLACE DOORS
9861001-25-02	NC	Apr 30/10	6	REPLACEMENT OF CART BUMPERS

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INTRODUCTION

TASK 25-32-78-99F-801-A01

1. Scope

NOTE: To help the customer this CMM also contains some airframe level information to facilitate their airframe level documentation tasks. The customers should incorporate this information to their airframe level documents (AMM, AIPC,...) as required.

NOTE: This manual uses the task and subtask identification of the Maintenance Task Oriented Support System (MTOSS). The maintenance tasks and other data have special MTOSS numbers for the use of Electronic Data Processing (EDP).

This Component Maintenance Manual (CMM) contains maintenance instructions and lists replacement parts for the G2 Galley Assembly, PNs 9861001-101, -103, -105, -107, -109, -111, -113, -115, -117, -119, -121, -123, -125, and G2 Galley Installation, PNs E179001-101, E199001-101, -103, E829001-101, H511201-101, J061502-101, and J709001-101.

TASK 25-32-78-99F-802-A01

2. Product Support Services

Replacement parts, technical publications, and other product support services are available from Safran Cabin Inc. Please refer to:

Safran Cabin Inc.
7330 Lincoln Way
Garden Grove, CA 92841
USA
(V56135)

Telephone: (657) 227-5505

TASK 25-32-78-99F-803-A01

3. Usage Guide

- A. Refer to the TABLE OF CONTENTS to find the applicable maintenance procedures or other data.
- (1) DESCRIPTION AND OPERATION describes the purpose, primary components, operation, and technical properties of the G2 Galley Assembly.
 - (2) TESTING AND FAULT ISOLATION contains test and fault isolation procedures.
 - (3) SCHEMATIC AND WIRING DIAGRAMS contains wiring diagrams illustration.
 - (4) DISASSEMBLY contains special procedures to disassemble the G2 Galley Assembly for repair or part replacement.
 - (5) CLEANING contains procedures to clean the components of the G2 Galley Assembly.
 - (6) INSPECTION/CHECK contains procedures to inspect and check parts for wear and damage.
 - (7) REPAIR contains procedures to replace potted inserts, replace bonded components, and make other repairs.

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- (8) ASSEMBLY contains special procedures to assemble the G2 Galley Assembly.
 - (9) SPECIAL TOOLS, FIXTURES, EQUIPMENT, AND CONSUMABLES describes the recommended special tools, fixtures, test equipment, and consumables use in this manual.
 - (10) ILLUSTRATED PARTS LIST (IPL) contains the data needed to order replacement parts. An equipment designator index, a numerical index, and exploded-view illustrations keyed to the parts lists are provided to help find and identify the parts. The introduction gives more data.
- B. The sections give a table of recommended tools and materials, when applicable. Use of equivalent items is possible.
- C. The procedures in this manual follow the specifications utilized during production and are thereby shop verified.

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4. Abbreviations and Unit Symbols

Abbreviations and unit symbols used in this manual are defined below. All weights and measurements are given first in English standard units followed by the metric equivalent in parentheses.

Symbol/ Abbr.	Term
–	Not Illustrated
±	Plus or Minus
®	Registered Sign
™	Trade Mark
<	Less than
>	Greater than
°	Degrees
°C	degrees Celsius
°F	degrees Fahrenheit
Ω	Ohms
A	Ampere
ALT	Alternate
AOG	Aircraft On Ground
AR	As Required
ASSY	Assembly
ATA	Air Transport Association
ATCH	Attachment
AWG	American Wire Gauge
BFE	Buyer Furnished Equipment
CAGE	Commercial And Government Entity
CAS	Chemical Abstracts Service
CFM	Cubic Feet per Minute
CIC	Corrosion Inhibiting Compounds
cm	Centimeter (1 cm = 0.394 inch)

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CMM	Component Maintenance Manual
Co.	Company
COMPT	Compartment
Corp.	Corporation
CT	Crew Terminal
CTR	Center
DC	Direct Current
DET	Details
EFF	Effectivity
FDA	Food and Drug Administration
FIG.	Figure
FR	Fluid Resistant
FWD	Forward
H.V.L.P.	High Volume Low Pressure
ID	Identification
in	Inch
INBD	Inboard
Inc.	Incorporated
INSTL	Installation
IPL	Illustrated Parts List
kg	Kilogram (1 Kg = 2.205 pounds)
LAV	Lavatory
lb	Pound
lbf-in	Pound Force Inch
LED	Light Emitting Diode
LLC	Limited Liability Company
Ltd.	Limited Company
LWR	Lower

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MEK	Methyl-Ethyl-Ketone
MIL	Military
MISC	Miscellaneous
MSDS	Material Safety Data Sheets
MTOSS	Maintenance Task Oriented Support System
N/A	Not Applicable
NHA	Next Higher Assembly
No.	Number
OCC	Occupied
OEM	Original Equipment Manufacturer
OPT	Optional
OUTBD	Outboard
oz	Ounce
PN	Part Number
psi	Pound per square inch
RPLD	Replaced
RPLS	Replaces
REV	Revision
RF	Reference
SB	Service Bulletin
Spec.	Specification
SU	Standard Unit
SUPSD	Superseded
SUPSDS	Supersedes
TEMP.	Temporary
TEMP	Temperature
UPR	Upper
USDA	United States Department of Agriculture

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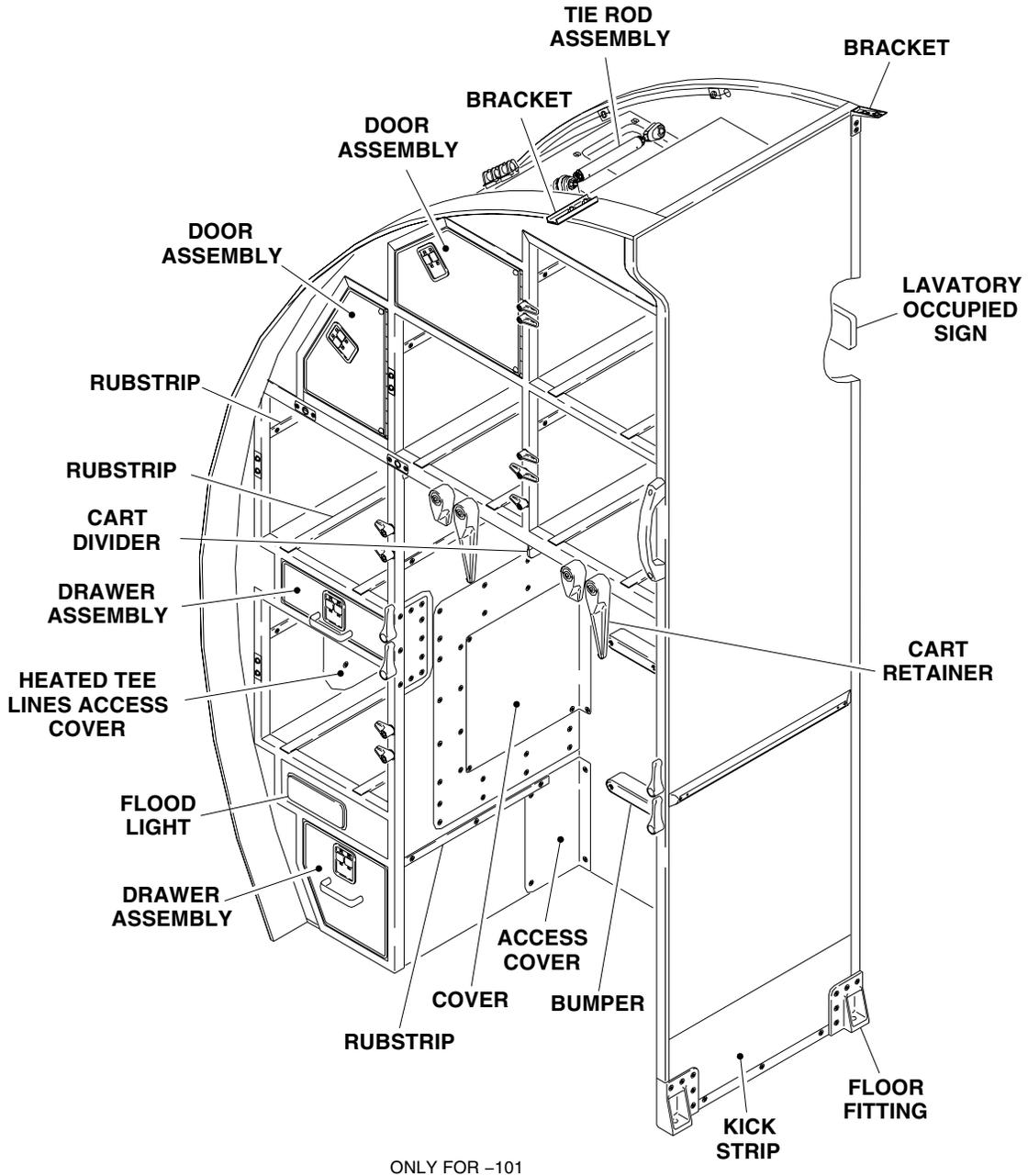
V Vendor
VDC Volts Direct Current

DESCRIPTION AND OPERATION

TASK 25-32-78-870-801-A01

1. Description

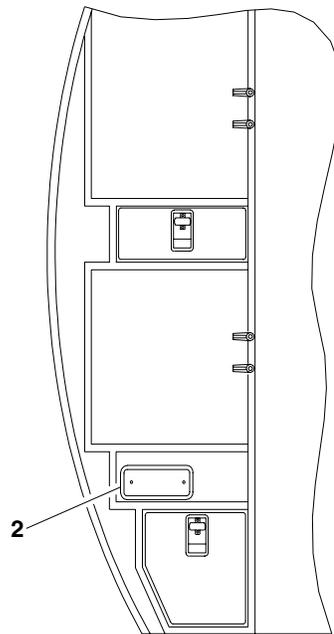
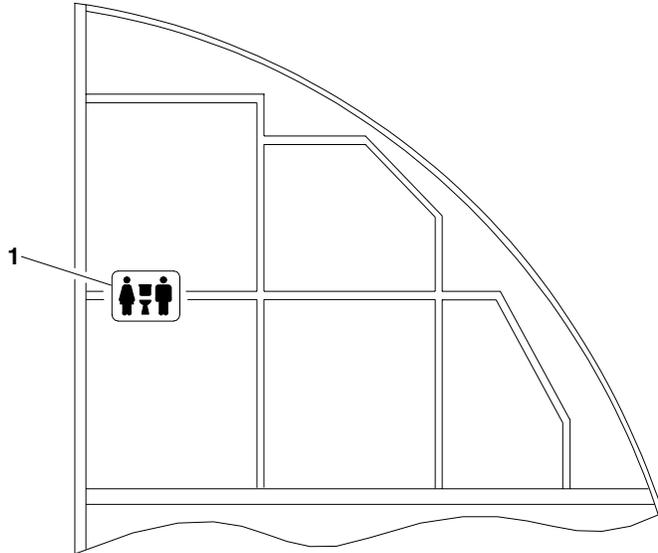
- A. The primary components of the G2 Galley Assembly are shown in Figure 1. The galley contains the items given below for supply stowage, food preparation and service cart retention.
- (1) Storage compartments in the galley are provided for miscellaneous components. These compartments are secured with hinged doors. The compartment side walls, back panel, and floor are protected with replaceable rubstrips.
 - (2) The galley electrical system includes lavatory occupied sign (DS194), flood light (DS159), and heated tee lines (HR30 and HR33).
 - (3) The galley also includes a cart divider and cart retainers. The galley provides restraint for five (5) standard units, two (2) half size carts, and four (4) miscellaneous compartments. The galley structure is secured to the aircraft ceiling with one (1) tie rod assembly. Four (4) floor fittings are provided to secure the galley to the aircraft standard seat tracks. Removable panels are provided to allow access to electrical and plumbing components.
- B. All components visible to the passengers have decorative finishes or a bonded decorative trim or laminate. All electrical wires are mounted behind panels out of passenger view.



ONLY FOR -101

253278DO0101

G2 Galley Assembly - Primary Components
 (Sheet 1 of 2)
 Figure 1/GRAPHIC 25-32-78-870-001-A01



G2 Galley Assembly - Primary Components
(Sheet 2 of 2)
Figure 1/GRAPHIC 25-32-78-870-001-A01

253278D00102

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TASK 25-32-78-870-802-A01

2. Operation

- A. Refer to Figure 2 and Table 1 for controls and indicators for the galley. The galley receives electrical power at connector P337.
- B. Miscellaneous Compartment Door Latches
 - (1) To open the miscellaneous compartment doors, move the sliding latch to the retracted position and pull the spring loaded slam latch to open the door.
 - (2) To close the door, push in on the door until the slam latch bolt engages the striker. Move the sliding latch to the extended (closed) position.

Controls and Indicators
Table 1/TABLE 25-32-78-870-001-A01

Figure 2 Item No.	Control or Indicator	Position or Indication	Function
1	LAV OCC sign	ON or OFF	Illuminates when power is supplied at connector P337.
2	FLOOD LIGHT	ON or OFF	Illuminates when power is supplied at connector P337.

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TASK 25-32-78-870-803-A01

3. Technical Properties

Technical properties of the G2 Galley Assembly are given in Table 2.

Technical Properties
Table 2/TABLE 25-32-78-870-002-A01

Property	Specification
Description:	
Manufacturer	Safran Cabin Inc. (CAGE 56135)
Nomenclature	G2 Galley Assembly
Part Number	9861001-101, -103, -105, -107, -109, -111, 113, -115, -117, -119, -121, -123, and -125 E179001-101 (G2 Galley Installation) E199001-101, -103 (G2 Galley Installation) E829001-101 (G2 Galley Installation) H511201-101 (G2 Galley Installation) J061502-101 (G2 Galley Installation) J709001-101 (G2 Galley Installation)
Overall Dimensions:	
Height	73.58 in (186.89 cm)
Width	21.00 in (53.34 cm)
Depth	38.34 in (97.38 cm)
Weight	130 lb (59 kg)

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TASK 25-32-78-870-804-A01

4. Trim and Finish

- A. Some parts of the equipment described in this manual have a decorative finish (material and/or color) that is unique to one or more operators. The part numbers in this manual do not identify decorative finishes.
- B. The decorative finish requirements for interior components are determined and identified by the assigned finish code. This code will define the specific decorative material or paint used for each component.
- C. 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 between the basic part number and the dash number, replacing the dash.

Example of part number showing the trim and finish code is shown below:

9861001-101 Specifies decorative finish requirement without operator code.
9861001BY101 Specifies decorative finish requirements for Britair.

- D. Table 3 gives the trim and finish codes of Overhead Stowage Bin Assembly.

Operator Trim and Finish Codes
Table 3/TABLE 25-32-78-870-003-A01

Operator	Trim and Finish Code	Table Number	Figure Number
Britair	BY	4	2
Lufthansa	DA	5	2
Lufthansa	DA	6	2
Air Canada	NZ	7	2
Chorus			
Lufthansa	RU	8	2
Adria Airways	FY	9	2
Adria Next Gen	YG	10	2
Lufthansa Next Gen	ABN	11	2
Ibex Airlines	ACH	12	2
American Eagle STC (E17)	ADH	13	3
Delta STC (E19)	---	14	3
AMR Next Gen	ADH	15	2
Ibex Airlines	ACH	16	2
Skywest Next Gen	WW	17	2
Us Airways STC (E82) (CRJ700 Classic)	---	18	3
Skywest-Delta STC (H51)	---	19	4

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Operator Trim and Finish Codes
Table 3/TABLE 25-32-78-870-003-A01 (continued)

Operator	Trim and Finish Code	Table Number	Figure Number
Skywest STC (J06)	JAAL	20	2
Skywest STC (J70)	JAAL	20	2

Trim and Finish For BRITAIR - PN 9861001BY101
Table 4/TABLE 25-32-78-870-004-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	Aerglas LHR/6405/670P	Medium Grey/Blue	BB	Schneller LLC (V21213)
2	Aisle Panoriginal el				
3	Forward Panel	Aerfilm LHR/8404/670HTE/54"/HA211	Light Grey/Blue	BI	Schneller LLC (V21213)
4	Door Assy	9861101BI501 / Aerfilm LHR/8404/670HTE/54"/HA211			
5	Door Assy	9861102BI501 / Aerfilm LHR/8404/670HTE/54"/HA211			
6	Drawer Assy	9861103BI501 / Aerfilm LHR/8404/670HTE/54"/HA211			
7	Drawer Assy, Lower	9861104BI501 / Aerfilm LHR/8404/670HTE/54"/HA211			
8	Outboard Panel	Aerfilm LHR/8404/670HTE/54"/HA211	Light Grey/Blue	BI	Schneller LLC (V21213)
9	Literature Pocket	9392451BY501 / Polyurethane Paint #982-1320	Medium Grey/Blue / Semi Gloss	BN	WLS Coating, Inc. (V0YY71)

* Refer to IPL, Paragraph 6, for the address.

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 Trim and Finish For LUFTHANSA - PN 9861001DA103
 Table 5/TABLE 25-32-78-870-005-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	N/A	N/A	N/A	N/A
2	Aisle Panel	Aerglas LHR II/5923/670P/48" X 96"	Medium Grey	CK	Schneller LLC (V21213)
3	Forward Panel	Aerfilm LHR/5923/670HTE/54"/HA211	Medium Grey	CG	Schneller LLC (V21213)
4	Door Assy	9861101CG503 / Aerfilm LHR/5923/670HTE/54"/HA211			
5	Door Assy	9861102CG501 / Aerfilm LHR/5923/670HTE/54"/HA211			
6	Drawer Assy	9861103CG501 / Aerfilm LHR/5923/670HTE/54"/HA211			
7	Drawer Assy, Lower	9861105CG501 / Aerfilm LHR/5923/670HTE/54"/HA211			
8	Outboard Panel	Aerfilm LHR/6037/670HTE/54"/HA211	Light Grey	CL	Schneller LLC (V21213)

* Refer to the IPL, paragraph 6, for the address.

Trim and Finish For LUFTHANSA - PN 9861001DA105
 Table 6/TABLE 25-32-78-870-006-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	N/A	N/A	N/A	N/A
2	Aisle Panel	9861101CG507 / Aerglas LHR II/5923/670P/48" X 96"	Medium Grey	CK	Schneller LLC (V21213)

* Refer to the IPL, paragraph 6, for the address.

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Trim and Finish For LUFTHANSA - PN 9861001DA105
Table 6/TABLE 25-32-78-870-006-A01 (continued)

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
3	Forward Panel	Aerfilm LHR/5923/670HTE/54"/HA211	Medium Grey	CG	Schneller LLC (V21213)
4	Door Assy	9861102CG505 / Aerfilm LHR/5923/670HTE/54"/HA211			
5	Door Assy	9861103CG501 / Aerfilm LHR/5923/670HTE/54"/HA211			
6	Drawer Assy	9861105CG501 / Aerfilm LHR/5923/670HTE/54"/HA211			
7	Drawer Assy, Lower	Aerfilm LHR/5923/670HTE/54"/HA211			
8	Outboard Panel	Aerfilm LHR/6037/670HTE/54"/HA211	Light Grey	CL	Schneller LLC (V21213)

*** Refer to the IPL, paragraph 6, for the address.**

Trim and Finish For AIR CANADA - PN 9861001NZ107 and CHORUS - PN 9861001NZ125
Table 7/TABLE 25-32-78-870-007-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	N/A	N/A	N/A	N/A
2	Aisle Panel	Airdec-GE72GE-6442L2N1	Ice Silver Frost / Leather	NS	Isovolta, Inc. (V1F7X4)
3	Forward Panel	Aerfilm LHR/6037/670HTE/54"/HA211	Light Grey / Lusterless	FC	Schneller LLC (V21213)
4	Door Assy	9861101FC505 for -107 9861101FC507 for -125 / Aerfilm LHR/6037/670HTE/54"/HA211			
5	Door Assy	9861102FC503 for -107 9861102FC505 for -125 / Aerfilm LHR/6037/670HTE/54"/HA211			

*** Refer to the IPL, paragraph 6, for the address.**

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Trim and Finish For AIR CANADA - PN 9861001NZ107 and CHORUS - PN 9861001NZ125
Table 7/TABLE 25-32-78-870-007-A01 (continued)

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
6	Drawer Assy	9861103FC501 / Aerfilm LHR/6037/670HTE/54"/HA211	Light Grey / Lusterless	FC	Schneller LLC (V21213)
7	Drawer Assy, Lower	9861105FC501 for -107 9861109FC501 for -125 / Aerfilm LHR/6037/670HTE/54"/HA211			
8	Outboard Panel	Aerfilm LHR/6037/670HTE/54"/HA211			
* Refer to the IPL, paragraph 6, for the address.					

Trim and Finish For LUFTHANSA - PN 9861001RU109
Table 8/TABLE 25-32-78-870-008-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	N/A	N/A	N/A	N/A
2	Aisle Panel	Aertrim LW P/16930/6616/DA 9.22/888P 54X96PS LHR	Light Silver	RF	Schneller LLC (V21213)
3	Forward Panel	Aerfilm LHR/5923/670HTE/54"/HA211	Medium Grey	CG	Schneller LLC (V21213)
4	Door Assy	9861101CG507 / Aerfilm LHR/5923/670HTE/54"/HA211			
5	Door Assy	9861102CG505 / Aerfilm LHR/5923/670HTE/54"/HA211			
6	Drawer Assy	9861103CG501 / Aerfilm LHR/5923/670HTE/54"/HA211			
7	Drawer Assy, Lower	9861105CG501 / Aerfilm LHR/5923/670HTE/54"/HA211			
8	Outboard Panel	Aerfilm LHR/6037/670HTE/54"/HA211	Light Grey	FC	Schneller LLC (V21213)
* Refer to the IPL, paragraph 6, for the address.					

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Trim and Finish For ADRIA AIRWAYS - PN 9861001FY109
Table 9/TABLE 25-32-78-870-009-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	N/A	N/A	N/A	N/A
2	Aisle Panel	Aertrim LHR I/7018/2638/645R/54"/HA211	Snowy	EJ	Schneller LLC (V21213)
3	Forward Panel	Aerfilm LHR/6037/670HTE/54"/HA211	Light Grey	FC	Schneller LLC (V21213)
4	Door Assy	9861101FC507 / Aerfilm LHR/6037/670HTE/54"/HA211			
5	Door Assy	9861102FC505 / Aerfilm LHR/6037/670HTE/54"/HA211			
6	Drawer Assy	9861103FC501 / Aerfilm LHR/6037/670HTE/54"/HA211			
7	Drawer Assy, Lower	9861105FC501 / Aerfilm LHR/6037/670HTE/54"/HA211			
8	Outboard Panel	Aerfilm LHR/6037/670HTE/54"/HA211			
* Refer to the IPL, paragraph 6, for the address.					

Trim and Finish For ADRIA NEXT GEN - PN 9861001YG111
Table 10/TABLE 25-32-78-870-010-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	N/A	N/A	N/A	N/A
2	Aisle Panel	Aertrim LHR I/7018/2638/645R/54"/HA211	Snowy	EJ	Schneller LLC (V21213)
* Refer to the IPL, paragraph 6, for the address.					

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Trim and Finish For ADRIA NEXT GEN - PN 9861001YG111
Table 10/TABLE 25-32-78-870-010-A01 (continued)

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
3	Forward Panel	Aerfilm LHR/6037/670HTE/54"/HA211	Light Grey	FC	Schneller LLC (V21213)
4	Door Assy	9861101FC507 / Aerfilm LHR/6037/670HTE/54"/HA211			
5	Door Assy	9861102FC505 / Aerfilm LHR/6037/670HTE/54"/HA211			
6	Drawer Assy	9861103FC501 / Aerfilm LHR/6037/670HTE/54"/HA211			
7	Drawer Assy, Lower	9861105FC501 / Aerfilm LHR/6037/670HTE/54"/HA211			
8	Outboard Panel	Aerfilm LHR/HE20-9/ 8029/670HTE/54"/HA211	Crystal White	VV	Schneller LLC (V21213)
* Refer to the IPL, paragraph 6, for the address.					

Trim and Finish For LUFTHANSA NEXT GEN - PN 9861001ABN111 and 9861001ABN119
Table 11/TABLE 25-32-78-870-011-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	N/A	N/A	N/A	N/A
2	Aisle Panel	Aertrim LW P/16930/ 6616/DA9.22/888P54X96/PS LHR	Light Silver	RF	Schneller LLC (V21213)
* Refer to the IPL, paragraph 6, for the address.					

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Trim and Finish For LUFTHANSA NEXT GEN - PN 9861001ABN111 and 9861001ABN119
Table 11/TABLE 25-32-78-870-011-A01 (continued)

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
3	Forward Panel	Aerfilm LHR/5923/670HTE/54"/HA211	Medium Grey	CG	Schneller LLC (V21213)
4	Door Assy	9861101CG507 / Aerfilm LHR/5923/670HTE/54"/HA211			
5	Door Assy	9861102CG505 / Aerfilm LHR/5923/670HTE/54"/HA211			
6	Drawer Assy	9861103CG501 / Aerfilm LHR/5923/670HTE/54"/HA211			
7	Drawer Assy, Lower	9861105CG501 / Aerfilm LHR/5923/670HTE/54"/HA211			
8	Outboard Panel	Aerfilm LHR/HE20-9/ 8029/670HTE/54"/HA211 (S08029-005-H5)	Crystal White	VV	Schneller LLC (V21213)
* Refer to the IPL, paragraph 6, for the address.					

Trim and Finish For IBEX AIRLINES - PN 9861001ACH113
Table 12/TABLE 25-32-78-870-012-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	Aertrim LHR I/7018/2638/645R/54"/HA211	Snowy	EJ	Schneller LLC (V21213)
2	Aisle Panel				
3	Forward Panel	Aerfilm LHR/7018/2638/64 5HTE/54"/HA211	Snowy	FW	Schneller LLC (V21213)
* Refer to the IPL, paragraph 6, for the address.					

COMPONENT MAINTENANCE MANUAL
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Trim and Finish For IBEX AIRLINES - PN 9861001ACH113
Table 12/TABLE 25-32-78-870-012-A01 (continued)

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
4	Door Assy	9861101FS507 / Aerfilm LHR/6035/618HTE/54"/HA211	Off White	FS	Schneller LLC (V21213)
5	Door Assy	9861102FS505 / Aerfilm LHR/6035/618HTE/54"/HA211			
6	Drawer Assy	9861103FS501 / Aerfilm LHR/6035/618HTE/54"/HA211			
7	Drawer Assy, Lower	9861104FS501 / Aerfilm LHR/6035/618HTE/54"/HA211			
8	Outboard Panel	Aerfilm LHR/7018/2638/64 5HTE/54"HA211	Snowy	FW	Schneller LLC (V21213)
9	Literature Pocket	9392452OZ501 / Skyline #2324	Grey Goose	OZ	Perrone Leather (V49U11)
* Refer to the IPL, paragraph 6, for the address.					

Trim and Finish For AMERICAN EAGLE STC (E17) - PN 9861001-117
Table 13/TABLE 25-32-78-870-013-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	Aertrim LHR I/16923/16965/16925/ 16926/6607/670R (S012526)	Multiple Grey With Blue Swoosh	ADH	Schneller LLC (V21213)
2	Aisle Panel	Aertrim LHR I/16923/16992/6607/ 670R/60 (S5980)	Grey		Schneller LLC (V21213)
3	Forward Panel And Doors	Aerfilm LHR/6037/670HTE	Light Grey		Schneller LLC (V21213)
4	Outboard Panel	Aerfilm LHR/6035/618HTE/54"/HA211	Off White		Schneller LLC (V21213)
* Refer to the IPL, paragraph 6, for the address.					

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

Trim and Finish For AMERICAN EAGLE STC (E17) - PN 9861001-117
Table 13/TABLE 25-32-78-870-013-A01 (continued)

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
5	Magazine Pouch	Featherweight (4344)	Silver A2	ADK	Perrone Leather (V49U11)
* Refer to the IPL, paragraph 6, for the address.					

Trim and Finish For DELTA STC (E19) - PN 9861001-121
Table 14/TABLE 25-32-78-870-014-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	Aertrim LW/18915/5732/670R/54 (S7205) Alternate Material: Aertrim LW/18915/5732/670R/54/PS- LHR (S7206)	Lattice Grey	---	Schneller LLC (V21213)
2	Aisle Panel				
3	Forward Panel And Doors	Aerfilm LHR/18915/5732/6 70P/54X96/HA211 (S009232)	Lattice Grey (RD)	---	Schneller LLC (V21213)
4	Outboard Panel				
5	Magazine Pouch	FW2227	Enchanted Blue	---	Perrone Leather (V49U11)
* Refer to the IPL, paragraph 6, for the address.					

Trim and Finish For AMR NEXT GEN - PN 9861001ADH115
Table 15/TABLE 25-32-78-870-015-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	Aertrim LHR I/16923/16965/16 925/16926/12448/6607/670R (S012526)	Multiple Grey with Blue Swoosh	ADW	Schneller LLC (V21213)
2	Aisle Panel	Aertrim LHR I/16923/16992/6607/670R/60 (S5980)	Grey	ADT	Schneller LLC (V21213)
* Refer to the IPL, paragraph 6, for the address.					

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Trim and Finish For AMR NEXT GEN - PN 9861001ADH115
Table 15/TABLE 25-32-78-870-015-A01 (continued)

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
3	Forward Panel	Aerfilm LHR/6037/670HTE	Light Grey	CL	Schneller LLC (V21213)
4	Door Assy	9861101CL503 / Aerfilm LHR/6037/670HTE	Light Grey	CL	
5	Door Assy	9861102CL501 / Aerfilm LHR/6037/670HTE			
6	Drawer Assy	9861103CL501 / Aerfilm LHR/6037/670HTE			
7	Drawer Assy, LWR	9861105CL501 / Aerfilm LHR/6037/670HTE	Off White	FS	
8	Outboard Panel	Aerfilm LHR/6035/618HTE/54"/HA211			
9	Literature Pocket	9392452ADK501 / Featherweight (4344)	Silver A2	ADK	Perrone Leather (V49U11)
* Refer to the IPL, paragraph 6, for the address.					

Trim and Finish For IBEX - PN 9861001ACH115
Table 16/TABLE 25-32-78-870-016-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	Aertrim LHRI/7018/2638/645R/54"/HA211	Snowy	EJ	Schneller LLC (V21213)
2	Aisle Panel				Schneller LLC (V21213)
3	Forward Panel	Aerfilm LHR/7018/2638/645HTE/54"/HA211	Snowy	FW	Schneller LLC (V21213)
4	Door Assy	9861101FS503 / Aerfilm LHRLHR/6035/618HTE/54"/HA211	Off White	FS	
5	Door Assy	9861102FS501 / Aerfilm LHRLHR/6035/618HTE/54"/HA211			
* Refer to the IPL, paragraph 6, for the address.					

COMPONENT MAINTENANCE MANUAL
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Trim and Finish For IBEX - PN 9861001ACH115
Table 16/TABLE 25-32-78-870-016-A01 (continued)

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
6	Drawer Assy	9861103FS501 / Aerfilm LHRLHR/6035/618 HTE/54"/HA211	Off White	FS	Schneller LLC (V21213)
7	Drawer Assy, LWR	9861104FS501 / Aerfilm LHRLHR/6035/618 HTE/54"/HA211			
8	Outboard Panel	Aerfilm LHR/7018/2638/64 5HTE/54"/HA211	Snowy	FW	
9	Literature Pocket	9392452OZ501 / Skyline #2324	Grey Goose	OZ	Perrone Leather (V49U11)
* Refer to the IPL, paragraph 6, for the address.					

Trim and Finish For SKYWEST NEXT GEN - PN 9861001WW115
Table 17/TABLE 25-32-78-870-017-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	Aertrim LW/18915/5732/670 R/60"/PSLHR (S7206)	Lattice Grey	QR	Schneller LLC (V21213)
2	Aisle Panel				Schneller LLC (V21213)
3	Forward Panel	Aerfilm LHR 18915/5732/670 P/54X96/HA211 (S009232)	Lattice Grey	RD	Schneller LLC (V21213)
4	Door Assy	9861101RD503 / Aerfilm LHR 18915/5732/670 P/54X96/HA211 (S009232)			
5	Door Assy	9861102RD501 / Aerfilm LHR 18915/5732/670 P/54X96/HA211 (S009232)			
* Refer to the IPL, paragraph 6, for the address.					

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9861001/E179001/E199001/E829001/H511201/J061502/J709001

Trim and Finish For SKYWEST NEXT GEN - PN 9861001WW115
Table 17/TABLE 25-32-78-870-017-A01 (continued)

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
6	Drawer Assy	9861103RD501 / Aerfilm LHR 18915/5732/670 P/54X96/HA211 (S009232)	Lattice Grey	RD	Schneller LLC (V21213)
7	Drawer Assy, LWR	9861104RD501 / Aerfilm LHR 18915/5732/670 P/54X96/HA211 (S009232)			
8	Outboard Panel	Aerfilm LHR 18915/5732/670 P/54X96/HA211 (S009232)			
9	Literature Pocket	Featherweight (FW 2227)	Enchanted Blue	WK	Perrone Leather (V49U11)
* Refer to the IPL, paragraph 6, for the address.					

Trim and Finish For US AIRWAYS STC (E82) - PN 9861001-123
Table 18/TABLE 25-32-78-870-018-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	Aertrim BD 100//695 (S009597)	W-Flag / Textured	---	Schneller LLC (V21213)
2	Aisle Panel	Aertrim LHR I/5051/10201/ 855R/PSLHR Alternate Material: Aerfilm LHR FX/5051/10201/670FX/54 (S6732)	Pinstripe (Vertical) / Textured	---	Schneller LLC (V21213)
3	Forward Panel And Doors	Aertrim LHR I/5902/855R/54"/HA111	Grey / Textured	---	Schneller LLC (V21213)
4	Outboard Panel				
5	Magazine Pouch	124-11065-01012	Dark Grey / Textured	---	Magee Plastics (V64235)
* Refer to the IPL, paragraph 6, for the address.					

COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001
 Trim and Finish For SKYWEST-DELTA STC (H51) - PN 9861001-121
 Table 19/TABLE 25-32-78-870-019-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	Aertrim LW-TRP/9018/25989/670R/60"/PSLHR (S015974)	Delta Sky Diamond	---	Schneller LLC (V21213)
2	Aisle Panel	Aertrim LW/18915/5732/670R/60"/PSLHR (S7206)	Lattice Grey	---	Schneller LLC (V21213)
3	Forward Panel and Doors	Aerfilm LHR/18915/5732/670P/54"X96"/HA211 (S009232)	Lattice Grey	---	Schneller LLC (V21213)
4	Outboard Panel				
* Refer to the IPL, paragraph 6, for the address.					

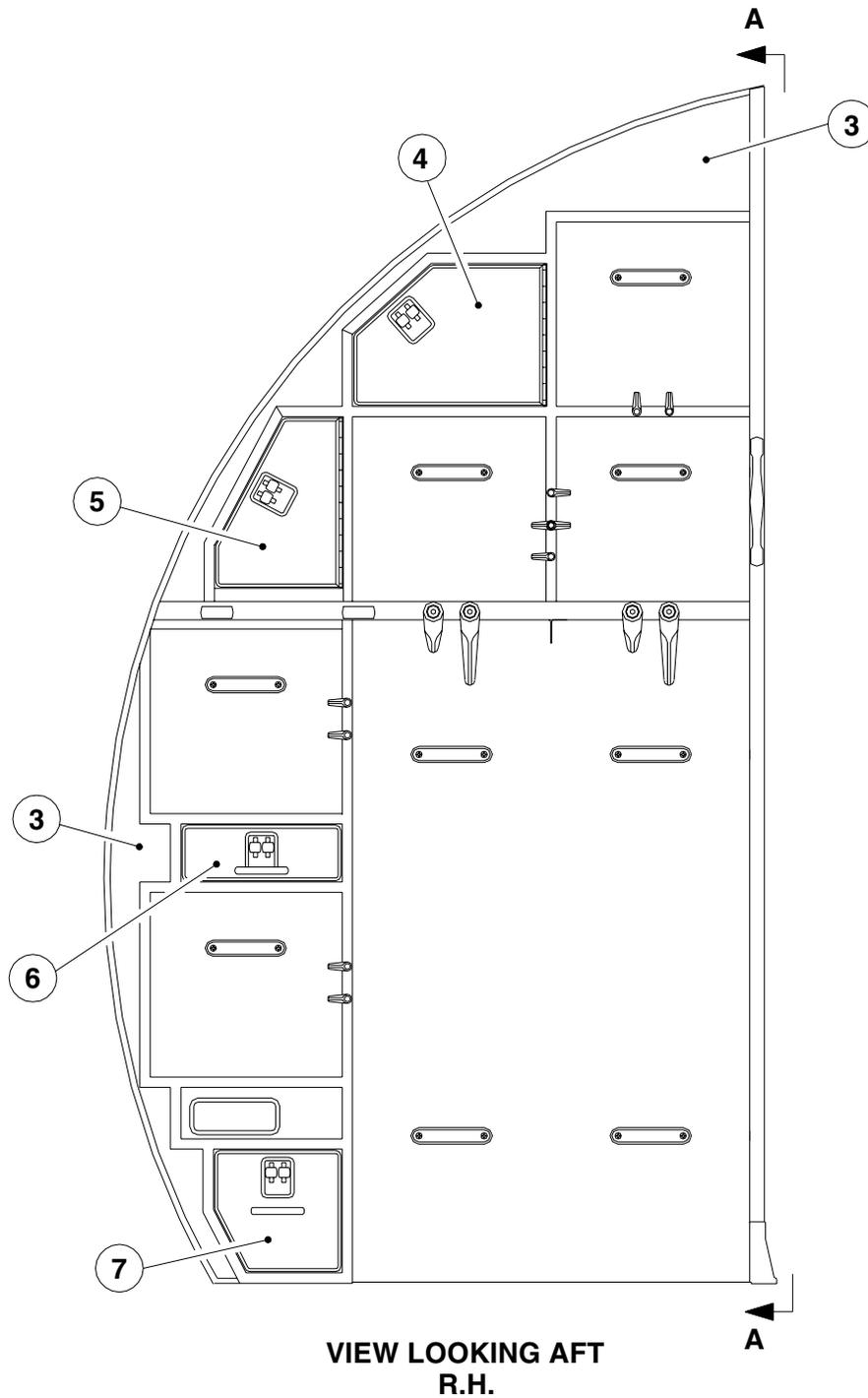
Trim and Finish For SKYWEST (J06) - PN 9861001JAAL121 and SKYWEST (J70) - PN 9861001JAAL115
 Table 20/TABLE 25-32-78-870-020-A01

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
1	Aft Panel	72GES-8245NF3-N0S	Silver Weave	ALC	Isovolta, Inc. (V1F7X4)
2	Aisle Panel				
3	Forward Panel	Aertrim LHR/6035/618HTE/54"/HA211	Off White	FS	Schneller LLC (V21213)
4	Door Assy	9861101FS503 / Aertrim LHR/6035/618HTE/54"/HA211	Off White	FS	Schneller LLC (V21213)
5	Door Assy	9861102FS501 / Aertrim LHR/6035/618HTE/54"/HA211	Off White	FS	Schneller LLC (V21213)
6	Drawer Assy	9861103FS501 / Aertrim LHR/6035/618HTE/54"/HA211	Off White	FS	Schneller LLC (V21213)
7	Drawer Assy, LWR	9861104FS501 / Aertrim LHR/6035/618HTE/54"/HA211	Off White	FS	Schneller LLC (V21213)
8	Outboard Panel	Aertrim LHR/6035/618HTE/54"/HA211	Off White	FS	Schneller LLC (V21213)
* Refer to the IPL, paragraph 6, for the address.					

COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001

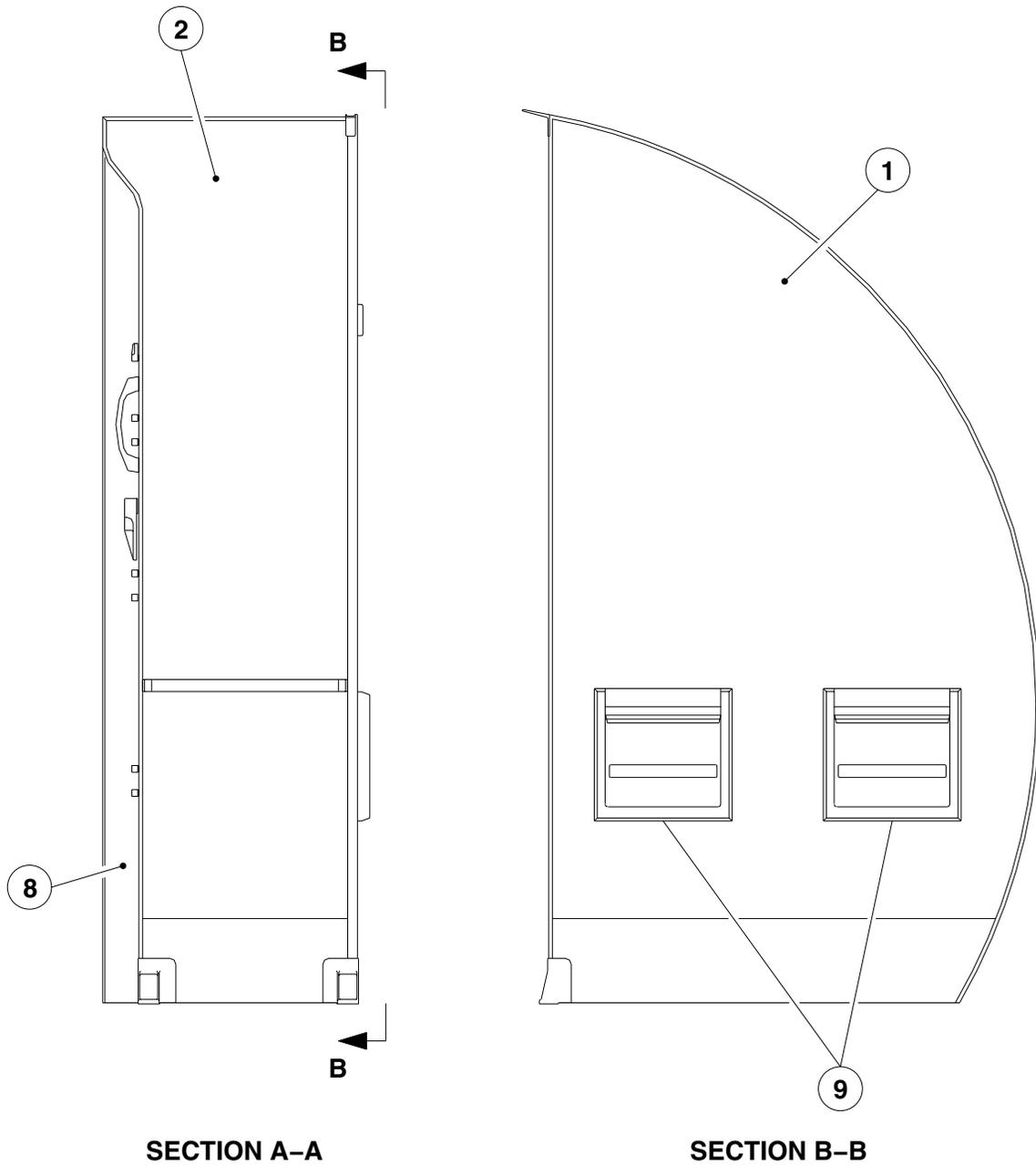
Trim and Finish For SKYWEST (J06) - PN 9861001JAAL121 and SKYWEST (J70) - PN 9861001JAAL115
 Table 20/TABLE 25-32-78-870-020-A01 (continued)

Item No.	Component	Part Number / Specifications	Color / Finish	Material Code	Source (CAGE)*
9	Literature Pocket	9392452LW501 / Skyline featherweight	Blue	LW	Perrone Leather (V49U11)
* Refer to the IPL, paragraph 6, for the address.					



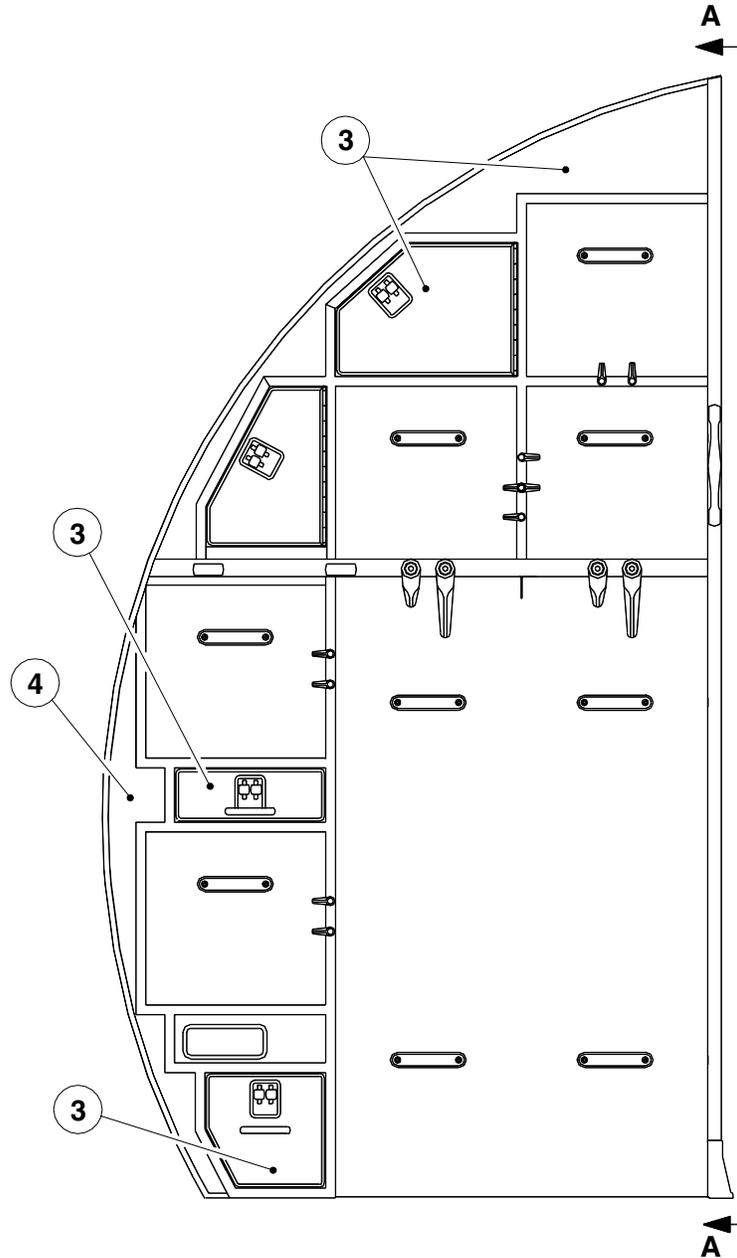
G2 Galley Assembly - Trim and Finishing
 (Sheet 1 of 2)
 Figure 2/GRAPHIC 25-32-78-870-002-A01

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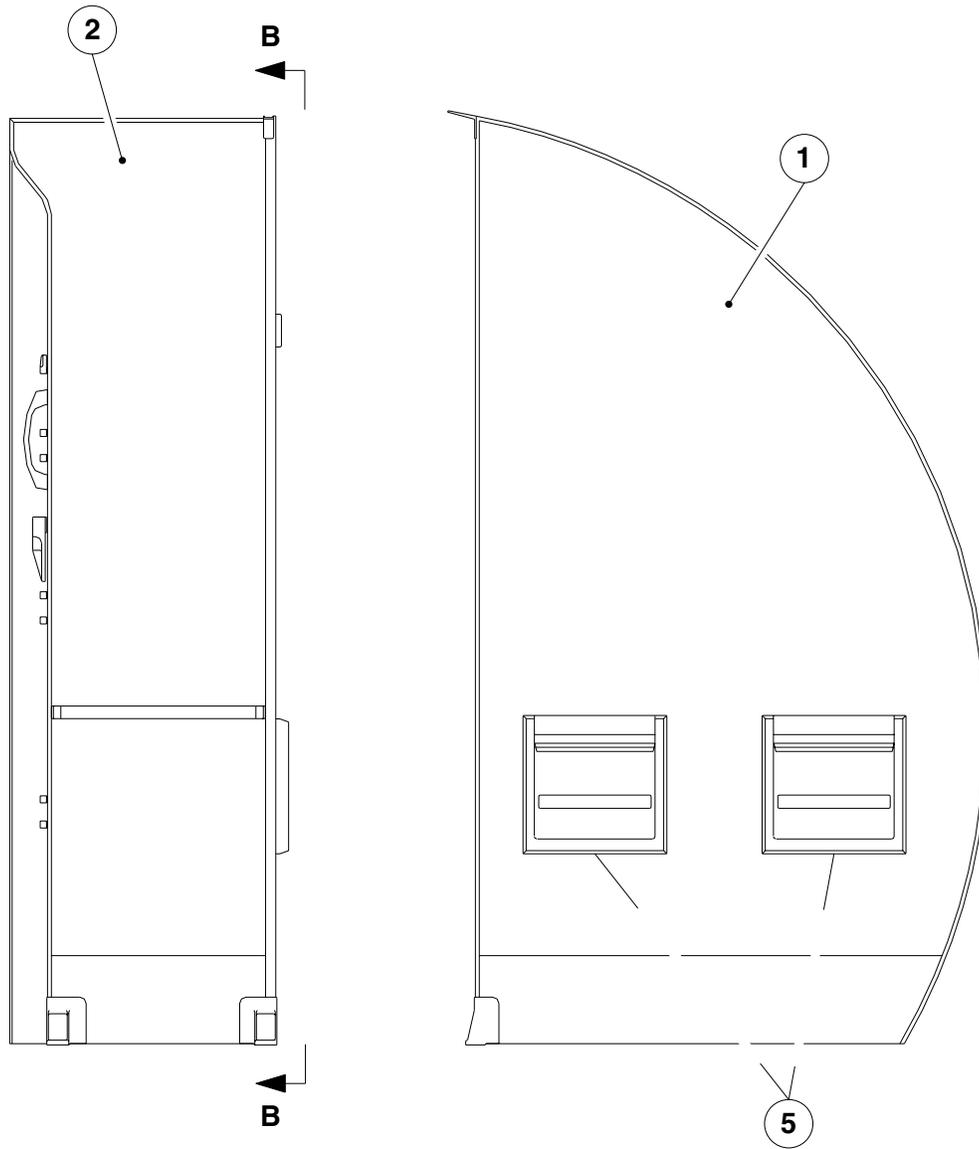
G2 Galley Assembly - Trim and Finishing
(Sheet 2 of 2)
Figure 2/GRAPHIC 25-32-78-870-002-A01



**VIEW LOOKING AFT
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G2 Galley Assembly - Trim and Finishing
(Sheet 1 of 2)
Figure 3/GRAPHIC 25-32-78-870-003-A01

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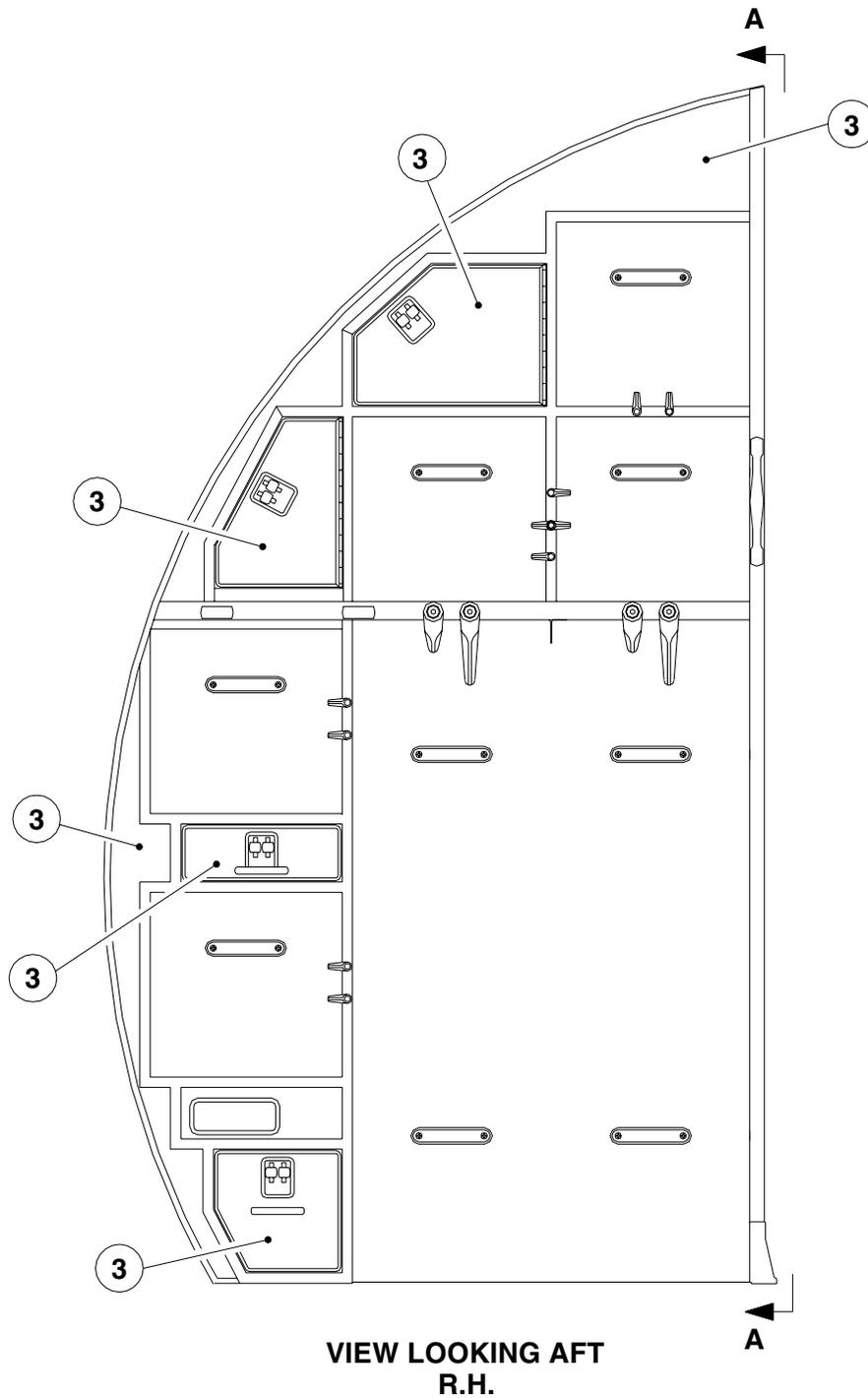


SECTION A-A

SECTION B-B

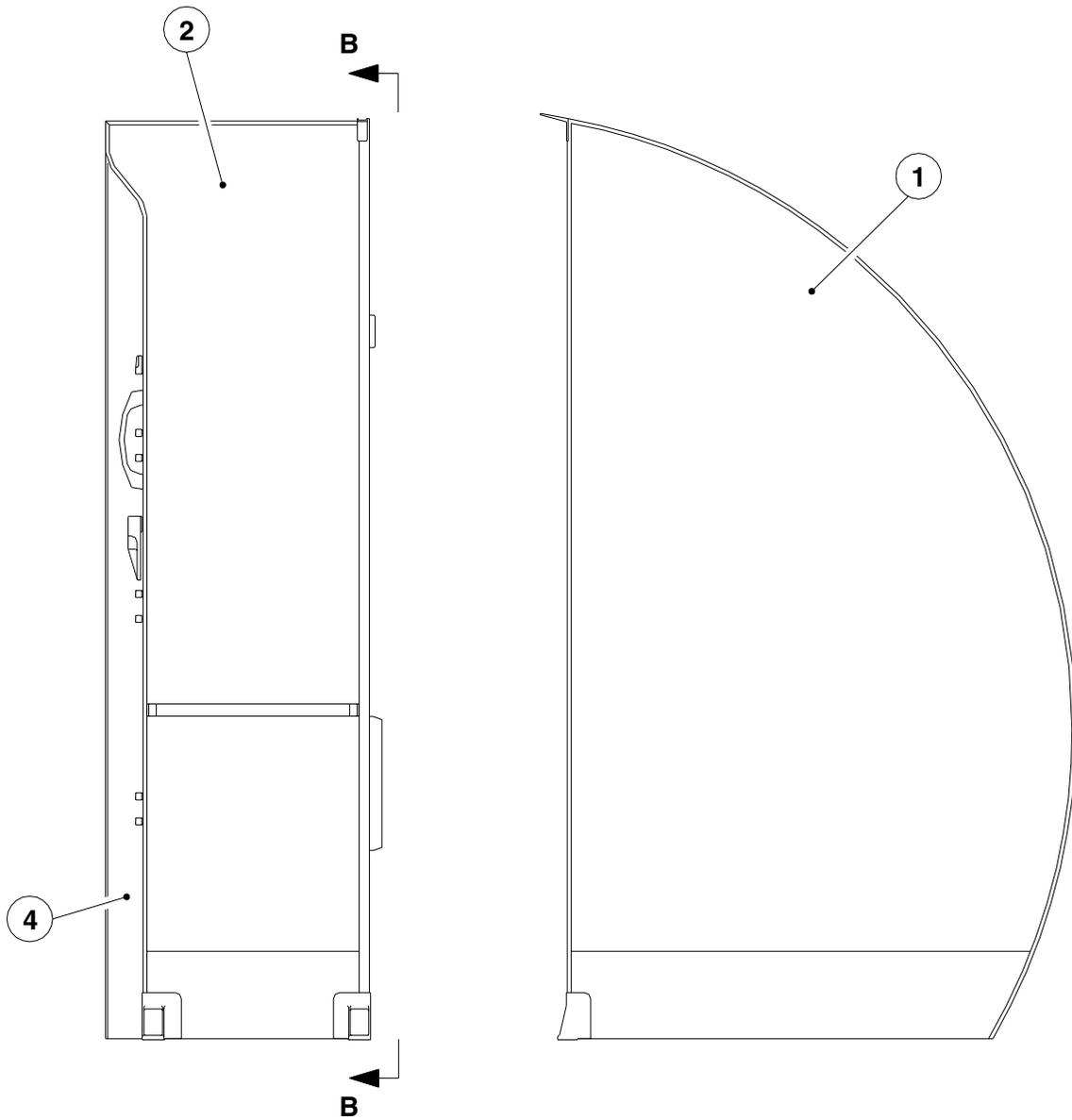
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G2 Galley Assembly - Trim and Finishing
(Sheet 2 of 2)
Figure 3/GRAPHIC 25-32-78-870-003-A01



G2 Galley Assembly - Trim and Finishing
(Sheet 1 of 2)
Figure 4/GRAPHIC 25-32-78-870-004-A01

25-32-78



SECTION A-A

SECTION B-B

253278T0302

G2 Galley Assembly - Trim and Finishing
(Sheet 2 of 2)
Figure 4/GRAPHIC 25-32-78-870-004-A01

COMPONENT MAINTENANCE MANUAL
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TESTING AND FAULT ISOLATION

TASK 25-32-78-99F-805-A01

1. General

A. This section contains test and fault isolation procedures.

NOTE: If the tests are done in a repair shop, 28VDC and 6VDC power must be provided at galley interface connector P337. Refer to Figure 2001.

B. The recommended test equipment and materials are given in Table 1001.

NOTE: Equivalent items can be used.

C. Fault isolation procedures are given in Table 1002.

D. The wiring diagram are given in Figure 2001.

Test Equipment and Materials
Table 1001/TABLE 25-32-78-940-001-A01

Nomenclature	Part or Specification Number	Source (CAGE)*
Digital Multimeter	Model 8060A	Fluke Corporation (V89536)
Power Supply	Variable DC up to 30VDC and 30W capability	Commercially Available
* Refer to the IPL, paragraph 6, for the address.		

NOTE: All test equipment must be calibrated/certified and must carry a current calibration/certification sticker.

NOTE: Equivalent test equipment can be used for testing with both Engineering and QC approval only.

TASK 25-32-78-700-801-A01

2. Electrical Test Procedures

WARNING: ELECTRICAL POWER CAN CAUSE SEVERE SHOCK AND BURNS. AVOID CONTACT WITH ENERGIZED CIRCUITS. FOLLOW STANDARD ELECTRICAL SAFETY PROCEDURES.

A. CONTINUITY TEST

Perform continuity check of all wires and make sure that all connections have been accomplished in accordance with Safran Cabin Inc. wiring diagram 9861008. All continuity check should be performed from connector P337.

B. FUNCTIONAL TEST**(1) TEST SET UP**

- (a) Connect the test harness to galley connector P337.
- (b) Make sure that the power supply is OFF and proper voltages are connected to the test harness. Refer to appropriate wiring diagram for the configuration
- (c) After continuity test, connect leads of Heated Tees to HR30J1, HR30J2, HR33P1, and HR33P2 of wire harness. Also, connect leads of flood lights to DS159P2 and DS159J1; connect leads of exit sign leads to DS158J1 and DS158P2; connect leads of lavatory occupied sign to DS194J1 and DS194P2.

(2) TEST PROCEDURES

- (a) Turn 28VDC power supply to ON.
- (b) Make sure that the Lavatory Occupied sign is illuminated.
- (c) Turn 28VDC power supply to OFF.
- (d) Make sure that the lavatory Occupied Sign is turned off.
- (e) Turn 6VDC power supply to ON.
- (f) Make sure that the flood light is illuminated.
- (g) Turn 6VDC power supply to OFF.
- (h) Make sure that the flood light is turned off.
- (i) Turn 6VDC power supply to ON.
- (j) Make sure that the exit sign is illuminated.
- (k) Turn 6VDC power supply to OFF.
- (l) Make sure that the exit sign is turned off.
- (m) Make sure that the resistance measured between pins L and M and pins N and P is in the range of 2750Ω to 3360Ω.

C. WEIGHT

- (1) Record actual weight of the top assembly unit after successful inspection and before shipment packaging in space provided in the test data sheets.

D. TEST COMPLETION

- (1) Make sure that the external power source is turned off.
- (2) Complete data sheets.

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TASK 25-32-78-810-801-A01

3. Fault Isolation Procedures

Fault Isolation Procedures
Table 1002/TABLE 25-32-78-810-001-A01

Trouble	Probable Cause	Corrective Action
CONTINUITY CHECK AND INSULATION RESISTANCE TEST		
Open or short circuit.	Damaged electrical wire harness. Damaged terminal, wire insulation, or incorrect wire routing.	Replace the wire harness. Refer to REPAIR for general electrical repair instructions; refer to Figure 2001 for wiring diagrams.
ELECTRICAL SYSTEM FUNCTIONAL TESTS		
LAV OCC sign fails to illuminate. Floodlight fails to illuminate.	Damaged electrical connection. Damaged LAV OCC sign. Damaged electrical connection. Damaged floodlight.	Check all applicable circuits for point-to-point continuity; refer to Figure 2001 and REPAIR. Replace the LAV OCC sign. Check all applicable circuits for point-to-point continuity; refer to Figure 2001 and REPAIR. Replace the floodlight.
COMPONENT FUNCTIONAL TESTS		
Door assemblies bind when opened or closed. Drawer assemblies bind when pulled or pushed. Door assemblies or drawer assemblies fail to latch/unlatch properly. Door assemblies or drawer assemblies latch does not engage striker properly. Retainers	Bent or damaged door trim. Damaged door hinge half. Bent or damaged panel trim. Damaged slide track. Bent or damaged latch assembly. Bent or damaged striker. Latch bolt is damaged. Latch assembly is damaged internally. Deformed, cracked spot weld, or damaged finish.	Replace the damaged trim. Replace the door hinge half. Replace the damaged trim. Replace the track. Replace the latch assembly. Replace striker. Replace the latch assembly. Replace the latch assembly. Replace retainer.

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COMPONENT MAINTENANCE MANUAL
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SCHEMATIC AND WIRING DIAGRAMS

TASK 25-32-78-99F-806-A01

1. General

- A. Schematic and Wiring Diagrams applicable to the component are included in this manual.
- B. Table 2001 gives the description of revision and reason for change. Figure 2001 gives the wiring diagrams for the G2 Galley Assembly.

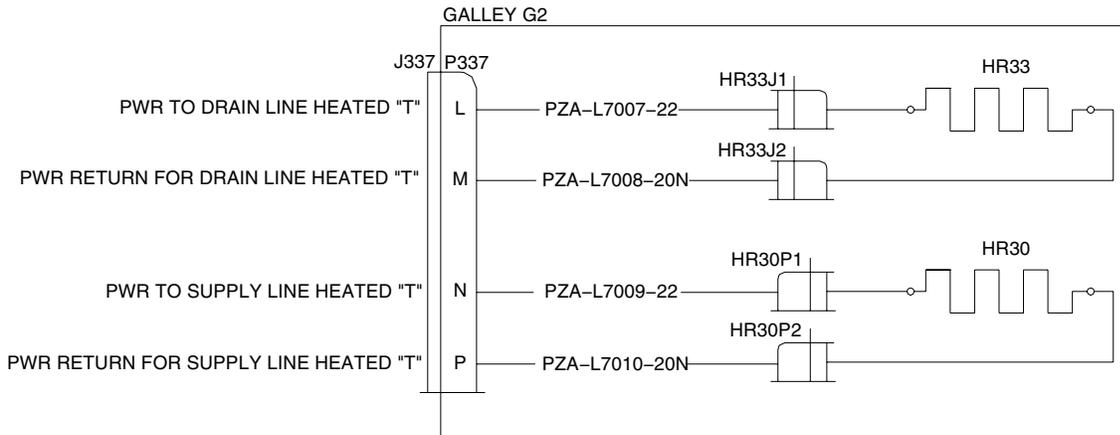
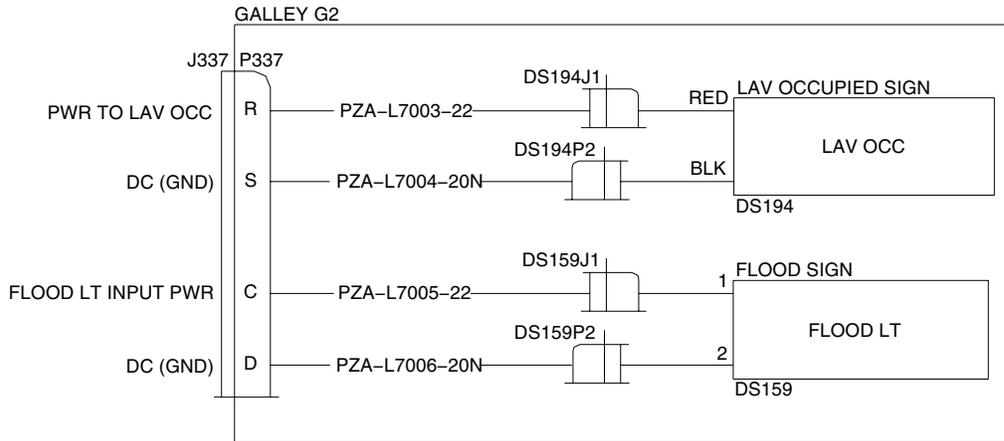
Wiring Diagram
 Table 2001/TABLE 25-32-78-99A-002-A01

SHEET	REV CODE	DESCRIPTION OF REVISION AND REASON FOR CHANGE	SERVICE BULLETIN	EFFECTIVITY
1	NC	Initial Release Figure 2001 (PN 9861008-1/-3)		All
2	1	Revised Figure 2001 to incorporated latest engineering changes and added -5.		All
2	4	Revised Figure 2001 to incorporated latest engineering changes and added -7.		All

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NOTES: UNLESS OTHERWISE SPECIFIED

1. ALL WIRES PER MIL-W-22759/34

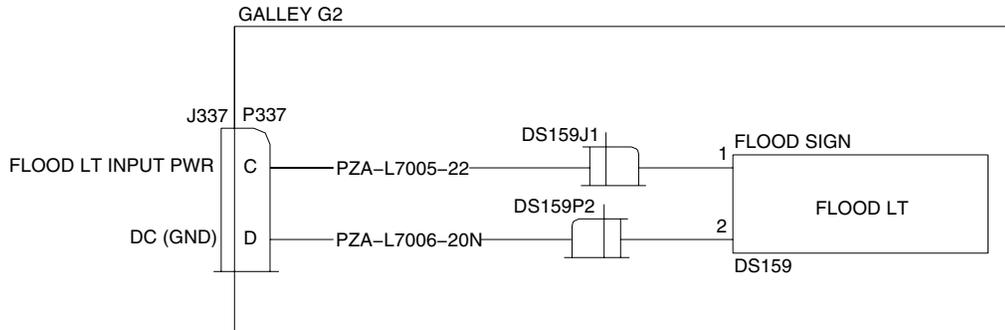


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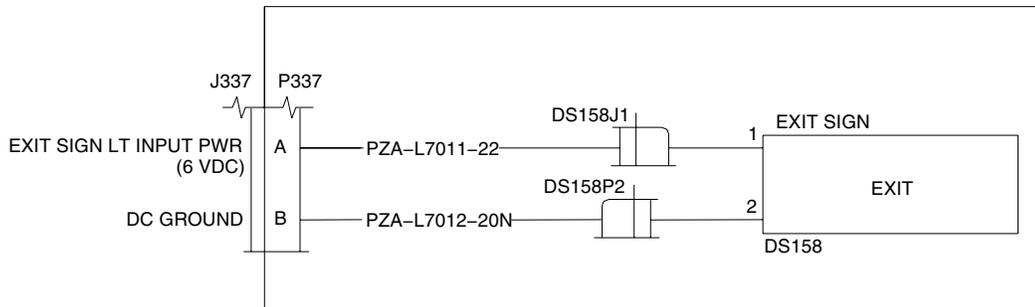
G2 Galley Assembly - Wiring Diagram PN 9861008
(Sheet 1 of 2)

Figure 2001/GRAPHIC 25-32-78-750-001-A01

COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



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G2 Galley Assembly - Wiring Diagram PN 9861008
 (Sheet 2 of 2)
 Figure 2001/GRAPHIC 25-32-78-750-001-A01

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DISASSEMBLY

TASK 25-32-78-99F-807-A01

1. General

- A. This section contains special instructions and notes needed to prevent damage to components and possible injury during disassembly of the G2 Galley Assembly.

NOTE: Disassembly sequence can be changed.

- B. To use this section, first refer to TESTING AND FAULT ISOLATION and INSPECTION/CHECK to identify the damaged and worn parts. Then refer to paragraph 2 for special disassembly instructions.
- C. Refer to REPAIR to replace all bonded components, adhesive-backed placards, and potted inserts. Remove the attaching parts given in the IPL to remove all other components.

TASK 25-32-78-000-801-A01

2. Disassembly of the Unit

WARNING: AVOID INJURIES TO PERSONNEL WHILE SERVICING THE EQUIPMENT BY ENSURING THAT ALL POWER HAS BEEN REMOVED. ONLY APPROVED PERSONNEL MUST DO THE MAINTENANCE.

CAUTION: THE MONUMENT HAS DECORATIVE SURFACES THAT ARE EASILY DAMAGED. COVER THE SURFACES AND HANDLE THE UNIT WITH CARE TO PREVENT DAMAGE.

SUBTASK 25-32-78-040-001-A01

A. G2 Galley Assembly
(IPL Figure 1)

- (1) Remove the components of the electrical installation (5, -5A, -5B, -5C, -5D, -5E, -5F, or -5G) in accordance with SUBTASK 25-32-78-040-007-A01.
- (2) Remove the screws (15B) and washers (20) to release the bumpers (10B).
- (3) Remove the screws (22C or -22E) and washers (23 or -23B) to release the bumpers (21C, -21D, or -21F).
- (4) Remove the standard unit retainers (25).
- (5) Remove the standard unit retainer (26).
- (6) Remove the standard unit retainer (-27).
- (7) Remove the standard unit retainer (30).
- (8) Remove the standard unit retainer (-32).
- (9) Remove the cart retainers (40).
- (10) Remove the cart retainer (41).
- (11) Remove the cart retainers (42 or -42A).

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- (12) Remove the screws (50) to release the cart divider (48).
- (13) Remove the cart retainers (55).
- (14) Refer to REPAIR section to replace the bonded flood light bracket assembly (60 or -60A).
- (15) Remove the retainers (65).
- (16) Remove the retainers (-67).
- (17) Remove the screws (75) to release the socket assembly (70). Disassemble the socket assembly (70) as follows:
 - (a) Remove the spring pin (-77).
 - (b) Remove the socket (-78).
- (18) Remove the screws (85) to release the socket (80).
- (19) Remove the screws (95) and washers (100) to release the assist handle (90).
- (20) Remove the screws (110) to release the retainer block assemblies (105).
- (21) Remove the screws (120A or -120B) to release the rubstrips (115) and rubstrips (117 or -117A).
- (22) Remove the components of the extrusion installation (125, -125A, -125B, -125D, -125E, or -125F).
- (23) Remove the screws (135A) to release the upper attachment cover (130).
- (24) Remove the bolt (150), washers (155), and nut (157) to release the tie-rod assembly (140A or -140B).
- (25) Remove the screws (165A) and finish washers (170) to release the upper attachment bracket assembly (160).
- (26) Remove the screws (180) to release the cart retainer block (175A).
- (27) Remove the screws (190A) to release the standard unit retainer blocks (185).
- (28) Remove the screws (200) to release the strikers (195).
- (29) Remove the screws (207) and washers (208) to release the door stops (205).
- (30) Remove the rivets (-220) to release the nameplate (215). Refer to REPAIR section to replace the bonded nameplate (215).
- (31) Remove the screws (230) and washers (235) to release the door assembly (225, -225B, -225C, -225D, or -225E). Disassemble the door assembly (225, -225B, -225C, -225D, or -225E) in accordance with SUBTASK 25-32-78-040-008-A01.
- (32) Remove the screws (245) and washers (250) to release the door assembly (-240A, -240B, -240C, or 240D). Disassemble the door assembly (-240A, -240B, -240C, or 240D) in accordance with SUBTASK 25-32-78-040-009-A01.

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- (33) Remove the screws (260) to release the drawer assembly (255). Disassemble the drawer assembly (255) in accordance with SUBTASK 25-32-78-040-010-A01.
- (34) Remove the screws (270) to release the drawer assembly (265, -265A, or -265B). drawer assembly (265, -265A, or -265B) in accordance with SUBTASK 25-32-78-040-011-A01.
- (35) Remove the cart retainers (275).
- (36) Refer to REPAIR section to replace the bonded standard unit rubstrips (295).
- (37) Remove the screws (305) to release the bracket (300).
- (38) Remove and disassemble the rubstrip installation (-310) as follows:
 - (a) Remove the rubstrip (315).
 - (b) Remove the screws (325) to release the end caps (320).
 - (c) Remove the screw (335) to release the retainer (330).
- (39) Refer to REPAIR section to replace the bonded gap seal (345).
- (40) Remove the screws (355) and washers (360) to release the curtain track support bracket assembly (350).
- (41) Remove the screw (-365A).
- (42) Remove the stud (370).
- (43) Remove the rivnut (-375).
- (44) Remove the screws (385) to release the angle access cover (380).
- (45) Remove the screws (395) to release the cover assembly (390). Disassemble the cover assembly (390) as follows:
 - (a) Remove the screws (397) to release the panel assembly (396). Refer to REPAIR section to replace the bonded panel assembly (396). Disassemble the panel assembly (396) as follows:
 - 1 Remove the panel (-399).
 - (b) Remove the cover (403).
- (46) Remove the screws (405) to release the access cover (404).
- (47) Remove the washers (415).
- (48) Remove the nuts (420).
- (49) Remove the tee (425).
- (50) Remove the tee (430).
- (51) Remove the tee fitting support bracket (435).

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- (52) Remove the screws (445) and washers (450) to release the tee fitting support bracket (440).
- (53) Remove the ½ fared tubing cap assembly (455).
- (54) Remove the ½ fareless tubing cap assembly (460).
- (55) Remove the clamps (465).
- (56) Remove the airduct flexible hose (470).
- (57) Remove the vinyl cap (475).
- (58) Remove the screws (485) and washers (490) to release the airduct fitting assemblies (480).
- (59) Refer to REPAIR section to replace the bonded seal (495A).
- (60) Refer to REPAIR section to replace the bonded bumpons (500 or -500A).
- (61) Remove the screws (510) to release the base trim (505).
- (62) Remove the screw (520) and washer (525) to release the bumpers (515).
- (63) Remove the rivnuts (-530).
- (64) Remove the screw (-532).
- (65) Remove the washer (-533).
- (66) Remove and disassemble the closeout panel assembly (535) as follows:
 - (a) Refer to REPAIR section to replace the bonded trim (-537).
 - (b) Remove the panel (-538).
- (67) Remove the screw (-540).
- (68) Remove the stud (545).
- (69) Remove the rivnut (-550).
- (70) Remove the screws (-565).
- (71) Remove the studs (570).
- (72) Remove the components of the placard installation (-575 or -575A) in accordance with SUBTASK 25-32-78-040-013-A01.
- (73) Refer to REPAIR section to replace the adhesive-backed SB incorporation placard (-580).
- (74) Remove the literature pocket assemblies (585A, -585B, or -585C).

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- (75) Remove and disassemble the bonded structure assembly (590, -590A, -590B, -590C, -590D, -590E, -590F, -590G, -590H, or -590J) in accordance with SUBTASK 25-32-78-040-012-A01.

SUBTASK 25-32-78-040-002-A01

B. G2 Galley Installation
(IPL Figure 1A)

- (1) Remove the nut (2).
- (2) Remove the washers (3).
- (3) Remove the bolt (4).
- (4) Remove the screws (5).
- (5) Remove the washers (10).
- (6) Remove the screws (17) to release the cover (15).
- (7) Remove the screws (25) to release the inboard wheel guide assembly (20). Disassemble the inboard wheel guide assembly (20) as follows:
 - (a) Refer to REPAIR section to replace the bonded double sided tape (-27).
 - (b) Refer to REPAIR section to replace the bonded cap (-28).
 - (c) Remove the wheel guide (-29).
- (8) Remove the screws (35) to release the outboard wheel guide (30).
- (9) Remove the floodlight (40).
- (10) Remove the nylon finishing plug (45).
- (11) Remove the bolt (46).
- (12) Remove the bolt (47).
- (13) Remove the washers (48).
- (14) Remove the floor fitting covers (50).
- (15) Remove the bolts (52).
- (16) Remove the washers (53).
- (17) Remove and disassemble the seat track fitting assemblies (55) as follows:
 - (a) Remove the screws (65) to release the retainer (60).
 - (b) Remove the fitting (70).
- (18) Refer to REPAIR section to replace the bonded foam (-75).
- (19) Refer to REPAIR section to replace the bonded foams (-80).

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- (20) Remove and disassemble the G2 galley assembly (95) in accordance with SUBTASK 25-32-78-040-001-A01.

SUBTASK 25-32-78-040-003-A01

C. G2 Galley Installation
(IPL Figure 1B)

- (1) Remove the nut (5).
- (2) Remove the washers (10).
- (3) Remove the bolt (15).
- (4) Remove the screws (25) to release the cover (20).
- (5) Remove the screws (27) and washers (28) to release the floodlight (26).
- (6) Remove the screws (35) to release the inboard wheel guide assembly (30). Disassemble the inboard wheel guide assembly (30) as follows:
 - (a) Refer to REPAIR section to replace the bonded double sided tape (-40).
 - (b) Refer to REPAIR section to replace the bonded cap (-45).
 - (c) Remove the wheel guide (-50).
- (7) Remove the screws (60) to release the outboard wheel guide (55).
- (8) Remove the nylon finishing plug (65).
- (9) Remove the bolt (70).
- (10) Remove the bolt (75A).
- (11) Remove the washers (80).
- (12) Remove the floor fitting covers (85).
- (13) Remove the bolts (90).
- (14) Remove the washers (95).
- (15) Remove and disassemble the seat track fitting assemblies (100) as follows:
 - (a) Remove the screws (110) to release the retainer (105).
 - (b) Remove the fitting (115).
- (16) Remove the literature pocket assemblies (120).
- (17) Remove the snap style studs (-125).
- (18) Remove the screws (-135) to release the studs (-130).
- (19) Refer to REPAIR section to replace the bonded foam (-140).

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- (20) Refer to REPAIR section to replace the bonded foam (-145).
- (21) Remove and disassemble the G2 galley assembly (150) in accordance with SUBTASK 25-32-78-040-001-A01.

SUBTASK 25-32-78-040-004-A01

D. G2 Galley Installation
(IPL Figure 1C)

- (1) Remove the nut (5).
- (2) Remove the washers (10).
- (3) Remove the bolt (15).
- (4) Remove the screws (25) to release the cover (20).
- (5) Remove the nylon finishing plug (30).
- (6) Remove the bolt (35).
- (7) Remove the bolt (40).
- (8) Remove the washers (45).
- (9) Remove the floor fitting covers (50).
- (10) Remove the bolts (55).
- (11) Remove the washers (60).
- (12) Remove and disassemble the seat track fitting assemblies (65) as follows:
 - (a) Remove the screws (75) to release the retainer (70).
 - (b) Remove the fitting (80).
- (13) Remove the literature pocket assemblies (85).
- (14) Remove the snap style studs (-90).
- (15) Refer to REPAIR section to replace the bonded foams (-95).
- (16) Refer to REPAIR section to replace the bonded foam (-100).
- (17) Remove and disassemble the G2 galley assembly (105) in accordance with SUBTASK 25-32-78-040-001-A01.

SUBTASK 25-32-78-040-005-A01

E. G2 Galley Installation
(IPL Figure 1D)

- (1) Remove the nut (5).
- (2) Remove the washers (10).

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- (3) Remove the bolt (15).
- (4) Remove the screws (25) to release the cover (20).
- (5) Remove the screws (35) to release the inboard wheel guide assembly (30). Disassemble the inboard wheel guide assembly (30) as follows:
 - (a) Refer to REPAIR section to replace the bonded double sided tape (-40).
 - (b) Refer to REPAIR section to replace the bonded cap (-45).
 - (c) Remove the wheel guide (-50).
- (6) Remove the screws (60) to release the outboard wheel guide (55).
- (7) Remove the nylon finishing plug (65).
- (8) Remove the bolt (70).
- (9) Remove the bolt (75).
- (10) Remove the washers (80).
- (11) Remove the floor fitting covers (85).
- (12) Remove the bolts (90).
- (13) Remove the washers (95).
- (14) Remove and disassemble the seat track fitting assemblies (100) as follows:
 - (a) Remove the screws (110) to release the retainer (105).
 - (b) Remove the fitting (115).
- (15) Remove the literature pocket assemblies (120 or -120A).
- (16) Remove the snap style studs (-125).
- (17) Remove the screws (-135) to release the studs (-130).
- (18) Refer to REPAIR section to replace the bonded foams (-140).
- (19) Refer to REPAIR section to replace the bonded foam (-145).
- (20) Remove and disassemble the G2 galley assembly (150) in accordance with SUBTASK 25-32-78-040-001-A01.

SUBTASK 25-32-78-040-006-A01

F. G2 Galley Installation
(IPL Figure 1E)

- (1) Remove the components of the bracket installation (-5).
- (2) Remove the nut (10).

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- (3) Remove the washers (15).
- (4) Remove the bolt (20).
- (5) Remove the screws (30) to release the cover (25).
- (6) Remove the nylon finishing plug (35).
- (7) Remove the bolt (40).
- (8) Remove the bolt (45).
- (9) Remove the washers (50).
- (10) Remove the floor fitting covers (55).
- (11) Remove the bolts (60).
- (12) Remove the washers (65).
- (13) Remove and disassemble the seat track fitting assemblies (70) as follows:
 - (a) Remove the screws (80) to release the retainer (75).
 - (b) Remove the fitting (85).
- (14) Remove the screws (95) to release the logo (90).
- (15) Remove the logo backplate (100).
- (16) Refer to REPAIR section to replace the bonded placards (105).
- (17) Remove the screws (-115) and washers (-120) to release the literature pocket assemblies (110).
- (18) Refer to REPAIR section to replace the bonded foams (-125).
- (19) Refer to REPAIR section to replace the bonded foam (-130).
- (20) Remove and disassemble the G2 galley assembly (135) in accordance with SUBTASK 25-32-78-040-001-A01.

SUBTASK 25-32-78-040-015-A01

G. G2 Galley Installation
(IPL Figure 1F)

- (1) Remove the nut (5).
- (2) Remove the washers (10).
- (3) Remove the bolt (15).
- (4) Remove the screws (25) to release the cover (20).
- (5) Remove the screws (35) to release the wheel guide assembly (30). Disassemble the wheel guide assembly (30) as follows:

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- (a) Refer to REPAIR section to replace the bonded double sided tape (-40).
- (b) Remove the wheel guide (-45).
- (6) Remove the screws (55) to release the wheel guide inboard (50).
- (7) Remove the plug (60).
- (8) Remove the bolt (65).
- (9) Remove the bolt (70).
- (10) Remove the washers (75).
- (11) Remove the floor fitting covers (80).
- (12) Remove the bolt (85).
- (13) Remove the washers (90).
- (14) Remove and disassemble the fitting assemblies (95) as follows:
 - (a) Remove the screws (105) to release the retainer (100).
 - (b) Remove the fitting (110).
- (15) Remove the lens (115).
- (16) Remove the stud snaps (-125) to release the literature pocket assemblies (120).
- (17) Refer to REPAIR section to replace the bonded foams (-130).
- (18) Refer to REPAIR section to replace the bonded foam (-135).
- (19) Refer to REPAIR section to replace the bonded placard installation (140). Remove the components of the placard installation (140) in accordance with SUBTASK 25-32-78-040-013-A01.
- (20) Refer to REPAIR section to replace the bonded placards (145).
- (21) Remove and disassemble the G2 galley assembly (150) in accordance with SUBTASK 25-32-78-040-001-A01.

SUBTASK 25-32-78-040-007-A01

H. Electrical Installation
(IPL Figure 2)

- (1) Remove the screws (-10A or 10B) and washers (-15A or 15C) to release the lavatory occupied sign (5 or -5A).
- (2) Remove the lens (-16).
- (3) Remove the screws (18) and washers (19) to release the emergency exit sign housing assembly (17 or -17A).

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- (4) Remove the screws (25 or -25A) and washers (30A) to release the led exit identifier emergency (20 or -20A).
- (5) Remove the screws (-36).
- (6) Remove the washers (-37).
- (7) Remove the screws (45) and washers (50) to release the loop clamps (40).
- (8) Remove the screw (-47) and washer (-52) to release the loop clamp (-42).
- (9) Remove the screws (65) and washers (70A) to release the wire bundle retainers (55A and 60A).
- (10) Refer to REPAIR section to replace the bonded cable tie mounts (75).
- (11) Refer to REPAIR section to replace the bonded cable tie mounts (-77).
- (12) Refer to REPAIR section to replace the bonded cable tie mounts (-78).
- (13) Remove the cable ties (80).
- (14) Remove the cable ties (-82).
- (15) Remove the cable ties (-83).
- (16) Refer to REPAIR section to replace the bonded grommets (85).
- (17) Refer to REPAIR section to replace the bonded grommet (-87).
- (18) Refer to REPAIR section to replace the bonded grommets (-88).
- (19) Refer to REPAIR section to replace the bonded tubing (90).
- (20) Remove the heater tee (95).
- (21) Remove the heater tee (100).
- (22) Remove the wire harness assembly (105, -105A, or -105B).

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I. Door Assembly
(IPL Figure 3)

- (1) Remove the screws (10) to release the double slide latch (5).
- (2) Remove the backplate (15), drive screws (16), hinge pin (17), spring (18 or -18A), and door stops (19).
- (3) Remove the half-hinge (20).
- (4) Refer to REPAIR section to replace the bonded hinge trim (21, -21A, or -21B).
- (5) Refer to REPAIR section to replace the bonded trim (40).
- (6) Refer to REPAIR section to replace the bonded decor (-55).

- (7) Remove the panel (60).

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J. Door Assembly
(IPL Figure 4)

- (1) Remove the screws (10) to release the double slide latch (5).
- (2) Remove the backplate (15), drive screws (16), hinge pin (17), and spring (18 or -18A).
- (3) Remove the half-hinge (20).
- (4) Refer to REPAIR section to replace the bonded hinge trim (35 or -35A).
- (5) Refer to REPAIR section to replace the bonded trim (40).
- (6) Refer to REPAIR section to replace the bonded decor (-55).
- (7) Remove the panel (60).

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K. Drawer Assembly
(IPL Figure 5)

- (1) Remove the screws (10) to release the latch assembly (5).
- (2) Remove the backplate (15).
- (3) Remove the screws (25) to release the handle (20).
- (4) Remove the screws (35) to release the slide tracks (30).
- (5) Refer to REPAIR section to replace the bonded front panel trim (40).
- (6) Refer to REPAIR section to replace the bonded front panel trim (45).
- (7) Refer to REPAIR section to replace the bonded side panel trim (50).
- (8) Refer to REPAIR section to replace the bonded side panel trim (55).
- (9) Refer to REPAIR section to replace the bonded back panel trim (60).
- (10) Refer to REPAIR section to replace the bonded decor (-63).
- (11) Refer to REPAIR section to replace the bonded front panel assembly (65). Disassemble the front panel assembly (65) as follows:
 - (a) Remove the front panel (-72).
- (12) Refer to REPAIR section to replace the bonded side panel assembly (75). Disassemble the side panel assembly (75) as follows:
 - (a) Remove the side panel (-82).

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- (13) Refer to REPAIR section to replace the bonded side panel assembly (85). Disassemble the side panel assembly (85) as follows:
 - (a) Remove the side panel (-92).
- (14) Refer to REPAIR section to replace the bonded back panel (95).
- (15) Refer to REPAIR section to replace the bonded bottom panel (100).

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L. Drawer Assembly
(IPL Figure 6)

- (1) Remove the screws (10) to release the latch assembly (5).
- (2) Remove the backplate (15).
- (3) Remove the screws (25) to release the handle (20A).
- (4) Remove the screws (35 or 35A) to release the slide tracks (30, 30A, or -30B).
- (5) Refer to REPAIR section to replace the bonded front panel trim (40 or -40A).
- (6) Refer to REPAIR section to replace the bonded front panel trim (45).
- (7) Refer to REPAIR section to replace the bonded side panel trim (50 or -50A).
- (8) Refer to REPAIR section to replace the bonded side panel trim (55 or -55A).
- (9) Refer to REPAIR section to replace the bonded back panel trim (60).
- (10) Refer to REPAIR section to replace the bonded decor (-64, -64A, or -64B).
- (11) Refer to REPAIR section to replace the bonded front panel assembly (65 or -65A). Disassemble the front panel assembly (65 or -65A) as follows:
 - (a) Remove the front panel (-72 or -72A).
- (12) Refer to REPAIR section to replace the bonded side panel assembly (75, -75A, or -75B). Disassemble the side panel assembly (75, -75A, or -75B) as follows:
 - (a) Remove the side panel (-82, -82A, or -82B).
- (13) Refer to REPAIR section to replace the bonded side panel assembly (85, -85A, or -85B). Disassemble the side panel assembly (85, -85A, or -85B) as follows:
 - (a) Remove the side panel (-92, -92A, or -92B).
- (14) Refer to REPAIR section to replace the bonded back panel (95).

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M. Bonded Structure Assembly
(IPL Figure 7)

- (1) Remove the screws (10) and washers (15) to release the upper attachment doubler (5 and 7). Refer to REPAIR section to replace the bonded upper attachment doubler (5 and 7).
- (2) Remove the screws (25) to release the doubler (20). Refer to REPAIR section to replace the bonded doubler (20).
- (3) Remove the screws (35) and screws (40) to release the reinforcement angles (30A). Refer to REPAIR section to replace the bonded reinforcement angles (30A).
- (4) Remove the rivnuts (-42A).
- (5) Remove the screws (80) to release the reinforcement angle (70). Refer to REPAIR section to replace the bonded reinforcement angle (70).
- (6) Remove the screws (90) to release the reinforcement angle (85). Refer to REPAIR section to replace the bonded reinforcement angle (85).
- (7) Refer to REPAIR section to replace the bonded doublers (95).
- (8) Refer to REPAIR section to replace the bonded cart retainer block doublers (100A).
- (9) Remove the screws (110) to release the floor fitting (105A).
- (10) Remove the spacer (115).
- (11) Remove the screws (125) to release the floor fitting doubler (120). Refer to REPAIR section to replace the bonded floor fitting doubler (120).
- (12) Remove the screws (135) to release the floor fitting doubler (130). Refer to REPAIR section to replace the bonded floor fitting doubler (130).
- (13) Remove the screws (145) to release the floor fitting (140).
- (14) Remove the spacer (150).
- (15) Remove the screws (160) to release the floor fitting (155).
- (16) Refer to REPAIR section to replace the bonded floor fitting doubler (165).
- (17) Remove the screws (175) to release the floor fitting (170).
- (18) Refer to REPAIR section to replace the bonded floor fitting doubler (180).
- (19) Remove the screws (187) to release the floor fitting doubler (185). Refer to REPAIR section to replace the bonded floor fitting doubler (185).
- (20) Refer to REPAIR section to replace the bonded kick panel (190 or -190A).
- (21) Refer to REPAIR section to replace the bonded kick panel (195).

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- (22) Refer to REPAIR section to replace the bonded stab-in channels (200).
- (23) Refer to REPAIR section to replace the bonded stab-in channels (-202).
- (24) Remove the screws (215) and washers (220) to release the curtain track angle (210). Refer to REPAIR section to replace the bonded curtain track angle (210).
- (25) Remove the rivets (-235) to release the doubler (230). Refer to REPAIR section to replace the bonded doubler (230).
- (26) Remove the screws (245) to release the panel support doubler (240). Refer to REPAIR section to replace the bonded panel support doubler (240).
- (27) Remove the screws (255) and screws (260) to release the panel support doubler (250 or -250A). Refer to REPAIR section to replace the bonded panel support doubler (250 or -250A).
- (28) Remove the screws (270) to release the panel support doubler (265). Refer to REPAIR section to replace the bonded panel support doubler (265).
- (29) Remove the screws (285) to release the panel support doubler (280). Refer to REPAIR section to replace the bonded panel support doubler (280).
- (30) Refer to REPAIR section to replace the bonded upper fitting panel assembly (295 or -295A). Disassemble the upper fitting panel assembly (295 or -295A) as follows:
 - (a) Remove the panel (-299 or -299A).
- (31) Refer to REPAIR section to replace the bonded standard unit compartment panel (300).
- (32) Refer to REPAIR section to replace the bonded divider panel assembly (305 or -305A). Disassemble the divider panel assembly (305 or -305A) as follows:
 - (a) Remove the panel (-308 or -308A).
- (33) Refer to REPAIR section to replace the bonded standard unit compartment panel assembly (-310A) or standard unit compartment panel (310B). Disassemble the standard unit compartment panel assembly (-310A) as follows:
 - (a) Remove the panel (-312).
- (34) Refer to REPAIR section to replace the bonded standard unit compartment panel (315) or standard unit compartment panel assembly (-315A). Disassemble the standard unit compartment panel assembly (-315A) as follows:
 - (a) Remove the panel (-317).
- (35) Refer to REPAIR section to replace the bonded miscellaneous panel assembly (320). Disassemble the miscellaneous panel assembly (320) as follows:
 - (a) Remove the panel (-323).
- (36) Refer to REPAIR section to replace the bonded spacer panel assembly (325). Disassemble the spacer panel assembly (325) as follows:

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- (a) Remove the panel (-327).
- (37) Refer to REPAIR section to replace the bonded shelf panel assembly (335). Disassemble the shelf panel assembly (335) as follows:
 - (a) Remove the panel (-337).
- (38) Refer to REPAIR section to replace the bonded standard unit compartment panel assembly (340). Disassemble the standard unit compartment panel assembly (340) as follows:
 - (a) Remove the panel (-343).
- (39) Refer to REPAIR section to replace the bonded standard unit compartment panel assembly (345). Disassemble the standard unit compartment panel assembly (345) as follows:
 - (a) Remove the panel (-348).
- (40) Refer to REPAIR section to replace the bonded cart panel assembly (350, -350A, -350B, or -350C). Disassemble the cart panel assembly (350, -350A, -350B, or -350C) as follows:
 - (a) Remove the panel (-353, -353A, -353B, or -353C).
- (41) Refer to REPAIR section to replace the bonded drawer compartment panel assembly (355). Disassemble the drawer compartment panel assembly (355) as follows:
 - (a) Remove the panel (-357).
- (42) Refer to REPAIR section to replace the bonded standard unit compartment panel (360) or standard unit compartment panel assembly (-360A). Remove and disassemble the standard unit compartment panel assembly (-360A) as follows:
 - (a) Remove the panel (-362).
- (43) Refer to REPAIR section to replace the bonded standard unit compartment panel (365) or standard unit compartment panel assembly (-365A). Remove and disassemble the standard unit compartment panel assembly (-365A) as follows:
 - (a) Remove the panel (-367).
- (44) Refer to REPAIR section to replace the bonded floodlight panel (375 or -375A).
- (45) Refer to REPAIR section to replace the bonded panel assembly (380 or -380A). Disassemble the panel assembly (380 or -380A) as follows:
 - (a) Remove the panel (-383 or -383A).
- (46) Refer to REPAIR section to replace the bonded drawer compartment panel assembly (385 or -385A). Disassemble the drawer compartment panel assembly (385 or -385A) as follows:
 - (a) Remove the panel (-388 or -388A).
- (47) Refer to REPAIR section to replace the bonded enclosure panel (390).

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- (48) Refer to REPAIR section to replace the bonded drawer compartment panel assembly (395, -395A, or -395B). Disassemble the drawer compartment panel assembly (395, -395A, or -395B) as follows:
 - (a) Remove the panel (-397, -397A, or -397B).
- (49) Refer to REPAIR section to replace the bonded closeout panel (400 or -400A).
- (50) Refer to REPAIR section to replace the bonded floor panel assembly (405 or -405A). Disassemble the floor panel assembly (405 or -405A) as follows:
 - (a) Remove the panel (-406 or -406A).
- (51) Refer to REPAIR section to replace the bonded contour outboard panel (415).
- (52) Refer to REPAIR section to replace the bonded forward closeout panel (420).
- (53) Refer to REPAIR section to replace the bonded forward closeout panel (425).
- (54) Refer to REPAIR section to replace the bonded aisle panel assembly (430, -430A, -430B, -430C, or -430D). Disassemble the aisle panel assembly (430, -430A, -430B, -430C, or -430D) as follows:
 - (a) Remove the panel (-434, -434A, -434B, -434C, or -434D).
- (55) Refer to REPAIR section to replace the bonded aft panel assembly (435, -435A, -435B, -435C, or -435D). Disassemble the aft panel assembly (435, -435A, -435B, -435C, or -435D) as follows:
 - (a) Remove the panel (-439, -439A, -439B, or -439C).
- (56) Refer to REPAIR section to replace the bonded standard unit compartment panel assembly (440, -440A, or -440B). Disassemble the standard unit compartment panel assembly (440, -440A, or -440B) as follows:
 - (a) Remove the panel (-465, -465A, or -465B).

SUBTASK 25-32-78-040-013-A01

N. Placard Installation
(IPL Figure 8)

- (1) Refer to REPAIR section to replace the adhesive-backed placards (5 thru 110).

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O. Extrusion Installation
(IPL Figure 9)

- (1) Refer to REPAIR section to replace the bonded trims (5 thru 55).
- (2) Remove the rivnuts (-60).
- (3) Refer to REPAIR section to replace the bonded trims (65 or -65A thru 150).

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CLEANING

TASK 25-32-78-99F-808-A01

1. General

- A. This section provides cleaning instructions for passenger cabin interior equipment manufactured by Safran Cabin Inc. Correct use of the materials and equipment will provide acceptable cleaning, minimize hazards to personnel, and prevent possible damage to the equipment.

NOTE: The companies that make the cleaning materials can change the formula. Therefore, always follow the instructions given on the container. The instructions to mix and use the cleaning materials, given on or provided with the container, supersede the instructions given here.

Paragraph	Cleaning Procedures
3.A	General Surface Cleaning (Including Vinyl-Decor Covered Panels)
3.B	Cleaning Instructions and Material Specifications for Metal Parts
3.C	Cleaning Instructions for Adhesives
3.D	General Cleaning Instructions for Galley
3.E	General Cleaning Instructions for Galley (Field Maintenance)

- B. The recommended cleaning materials are given in Table 4001.

NOTE: Refer to applicable cleaning instructions for other materials not included in this Table.

NOTE: Equivalent items can be used.

Cleaning Tools and Materials
Table 4001/TABLE 25-32-78-940-002-A01

Nomenclature	Part or Specification Number	Source (CAGE)*
Apron	---	Commercially Available
Cotton Cloths (lint-free) (clean and dry)	---	Commercially Available
Protective eyewear or safety goggles	---	Commercially Available
Rubber Gloves or Latex	---	Commercially Available
Soft-bristled brush	NSN 0038	Industries for The Blind, Inc. (V9U362)
Solvent, cleaning Adhesive removal	Acetone CAS No. 67-64-1	Commercially Available
* Refer to the IPL, paragraph 6, for the address.		

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Cleaning Tools and Materials
Table 4001/TABLE 25-32-78-940-002-A01 (continued)

Nomenclature	Part or Specification Number	Source (CAGE)*
Solvent, cleaning Adhesive removal	MEK (Methyl Ethyl Ketone) CAS No. 78-93-3 (Fed. MIL Spec. TT-M-261) (metal parts only) BRULIN 815MX CALLA 301-A LEMON	Commercially Available Bulin Holding Company, Inc. (V94058) Andpak-Ema, Inc. (V68491)
General overall surface cleaning (including decor) (Mild Detergents)	Mild household detergent BRULIN 815MX CALLA 301-A LEMON	Commercially Available Bulin Holding Company, Inc. (V94058) Andpak-Ema, Inc. (V68491)
Metal cleaning	Solvent, Federal Specification P-D-680, Type III MEK (Methyl Ethyl Ketone) CAS No. 78-93-3 (Fed. MIL Spec. TT-M-261) (metal parts only) BRULIN 815MX CALLA 301-A LEMON Sodium Bicarbonate NaHCO ₃ CAS No. 144-55-8	Optional Commercially Available Bulin Holding Company, Inc. (V94058) Andpak-Ema, Inc. (V68491) Commercially Available
Metal Preservation, Corrosion Inhibitors/Cleaners	VCI-416 Cleaner Corrosion Inhibitor Corwipe 300	Cortec Corporation (V44695) Cortec Corporation (V44695)
Plastic Blade Scraper or Spatula	---	Commercially Available
Sponges (clean and dry)	Non-Scratch Scrub Sponge (Scotch-Brite)	3M Company (V04963)
Spray bottles	---	Commercially Available
White Vinegar	Household Vinegar. A mild acidic solution with 5-15% Acetic Acid	Commercially Available
Solvents - outside surfaces	Isopropyl Alcohol CAS No. 67-63-0 Acetone CAS No. 67-64-1	Commercially Available Commercially Available
* Refer to the IPL, paragraph 6, for the address.		

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Cleaning Tools and Materials
Table 4001/TABLE 25-32-78-940-002-A01 (continued)

Nomenclature	Part or Specification Number	Source (CAGE)*
Vacuum	Model# VK811SIWD / 125 CFM (or equivalent)	Cleva North America (V70A87)
* Refer to the IPL, paragraph 6, for the address.		

TASK 25-32-78-100-801-A01

2. Safety Precautions

- A. All cleaning materials have some hazard related to their use. Follow the safety warnings given below to make sure personnel are safe and to prevent damage to the equipment.

WARNING: METHYL ETHYL KETONE (MEK) AND ACETONE ARE POISONOUS AND FLAMMABLE. PREVENT EYE AND SKIN CONTACT AND DO NOT BREATHE THE VAPORS. KEEP AWAY FROM HEAT AND OPEN FLAME. USE IN A WELL VENTILATED AREA. DO NOT TAKE INTERNALLY. WEAR GLOVES AND USE DISCRETION TO AVOID VAPOR CONTACT WITH EYES AND NOSE. USE OF RESPIRATOR AND GOGGLES IS ADVISED.

BRULIN 815MX CONTAINS 2-AMINOETHANOL. DIRECT CONTACT CAN CAUSE EYE IRRITATION. LONG CONTACT CAN CAUSE SKIN IRRITATION. WEAR ADEQUATE AND DISCRETIONARY PROTECTION TO PREVENT AND MINIMIZE SKIN CONTACT AND EYE IRRITATION.

ALL HOUSEHOLD DETERGENTS, SOAPS, AND OTHER CLEANING AGENTS NORMALLY ARE ALKALINE SOLUTIONS. EYE IRRITATIONS AND SKIN SENSITIVITY IS POSSIBLE. WEAR ADEQUATE AND DISCRETIONARY PROTECTION TO PREVENT AND MINIMIZE HAZARDS.

CAUTION: ALL DISSIMILAR METALS ARE ISOLATED TO PREVENT GALVANIC CORROSION. IF REPAIR OR REPLACEMENT IS REQUIRED, THE MAINTENANCE MECHANICS MUST REMOVE AND REPLACE ALL SEALS AND INSULATING BARRIERS. ALL PARTS MUST BE DISASSEMBLED AND REASSEMBLED AS SHOWN IN THE DISASSEMBLY AND ASSEMBLY SECTIONS IN THIS CMM. ANY STRUCTURAL DAMAGE MUST BE REPAIRED AS DESCRIBED IN THE REPAIR SECTION IN THIS CMM.

TASK 25-32-78-100-802-A01

3. Cleaning Procedures

A. General Surface Cleaning (Including Vinyl-Decor Covered Panels)

CAUTION: THE DECORATIVE LAMINATE SURFACE OF VARIOUS INTERIOR COMPONENTS CAN BE DAMAGED BY THE USE OF INCORRECT CLEANING MATERIALS AND EQUIPMENT, OR INCORRECT MIXING OF THE SPECIFIED CLEANING MATERIALS.

DO NOT USE ABRASIVE MATERIALS ON THE DECORATIVE SURFACES. DO NOT SCRAPE THE SURFACES WITH SHARP TOOLS.

TO PREVENT CORROSION ON FLOOR FITTINGS COVERED WITH CARPET, USE BRULIN OR CALLA SOAP MATERIALS FOR CARPET CLEAN-UP AND REMOVE ANY WET OR SOAKED CARPETING IMMEDIATELY.

(1) Use of Mild Household Detergent

CAUTION: DO NOT USE BRULIN 815MX CLEANER UNDILUTED. SOLUTIONS STRONGER THAN SPECIFIED CAN DAMAGE THE DECORATIVE SURFACES.

- (a) Prepare a solution of mild household detergent (Table 4001) with warm water (90°F - 120°F) (32°C - 49°C). Solution must be 1 part of detergent to 50 parts of water by volume. Apply the solution to the surface with a sponge or cotton cloth (lint-free).
- (b) On porous surfaces, the cloth or sponge (Table 4001) should be lightly dampened with the solution and the surfaces should be cleaned using circular swipes. Do not allow excess solution to be forced from the sponge or cloth into the surface. Push lightly.
- (c) On non-porous surfaces, such as Tedlar or vinyl, surfaces can be scrubbed with a wet sponge or cloth. Do not allow excess to run off onto adjoining surfaces. Take care that excess does not come into contact with porous surfaces.
- (d) For all surfaces, scrub soiled areas as necessary, and repeat applications of mild detergent to remove contamination. Use a soft-bristled brush to clean heavily textured surfaces or crevices. Rinse the surfaces with clean water, or use a fresh sponge or cloth dampened with clean water to remove residue. Dry the surfaces with a clean, dry cotton cloth (lint-free).

(2) Use of BRULIN 815MX

- (a) Prepare a solution of BRULIN 815MX (Table 4001) with cool or warm water (90°F - 120°F) (32°C - 49°C). Solution must be 1 part of BRULIN 815MX to 64 parts of water by volume for light soil. Solution can be increased up to 1 part of BRULIN 815MX to 10 parts of water by volume. The solution can be applied using a spray bottle, soft-bristled brush, sponge, or cotton cloth (lint-free).

NOTE: Cool water works best with normal dirt and dust. Warm water works best with oily surfaces.

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- (b) On porous surfaces, do not use spray bottles. Cloth or sponge should be lightly dampened with the solution, and the surfaces should be cleaned using circular swipes. Do not allow excess solution to be forced from the sponge or cloth into the surface. Push lightly.
 - (c) On non-porous surfaces, such as Tedlar or vinyl, surfaces can be scrubbed with a wet sponge or cloth, or the material can be sprayed onto the surfaces and scrubbed with a clean sponge or cloth. Do not allow excess to run off onto adjoining surfaces. Take care that excess does not come into contact with porous surfaces.
 - (d) For all surfaces, scrub soiled areas as necessary, and repeat as necessary to remove contamination. Use a soft-bristled brush to clean heavily textured surfaces or crevices. Rinse the surfaces with clean water, or use a fresh sponge or cloth dampened with clean water to remove residue. Dry the surfaces with a clean, dry cotton cloth (lint-free).
- (3) Use of CALLA 301-A LEMON
- (a) Prepare a solution of CALLA 301-A LEMON (Table 4001) with cool or warm water (90°F - 120°F) (32°C - 49°C). Solution must be 1 part of CALLA 301-A LEMON to 4-8 parts of water by volume for normal cleaning. For concentrated dirt, or spots, use full strength. The solution can be applied using a spray bottle, soft-bristled brush, or cotton cloth (lint-free).

NOTE: Cool water works best with normal dirt and dust. Warm water works best with oily surfaces.

- (b) On porous surfaces, do not use spray bottles. Cloth or sponge should be lightly dampened with the solution, and the surfaces should be cleaned using circular swipes. Do not allow excess solution to be forced from the sponge or cloth into the surface. Push lightly.
- (c) On non-porous surfaces, such as Tedlar or vinyl, surfaces can be scrubbed with a soft-bristled brush or wet sponge or cloth, or the material can be sprayed onto the surfaces and scrubbed with the soft-bristled brush, a clean sponge or cloth. Do not allow excess to run off onto adjoining surfaces. Take care that excess does not come into contact with porous surfaces.
- (d) For all surfaces, scrub soiled areas as necessary, and repeat as necessary to remove contamination. Use a soft-bristled brush to clean heavily textured surfaces or crevices. Rinse the surfaces with clean water, or use a fresh sponge or cloth dampened with clean water to remove residue. Dry the surfaces with a clean, dry cotton cloth (lint-free).

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B. Cleaning Instructions and Material Specifications for Metal Parts

CAUTION: CLEAN UP OF ORGANIC WASTES (FOOD SPILLS, SUGAR, ETC.) MUST BE DONE IMMEDIATELY. ROUTINELY REMOVE THESE WASTES FROM THE AFFECTED AREA DURING SPOT CLEANING.

DO NOT LET SOLVENTS TOUCH THE DECOR MATERIAL OR PLASTIC COMPONENTS. MEK AND ACETONE CAN DAMAGE SOME COMPONENTS AND MATERIALS.

CAUTION: DO NOT SATURATE CLOTH WITH SOLVENT BY PLACING THE CLOTH OVER THE CONTAINER'S MOUTH AND TURNING THE CONTAINER TO WET THE CLOTH. THIS CAN CAUSE CONTAMINATION OF THE SOLVENT SOURCE. DO NOT USE OPEN CONTAINERS OR PLUNGER-TYPE SOLVENT DISPENSERS IN CLEANING SOLUTIONS. ALWAYS POUR THE SOLVENT ONTO THE CLOTH OR USE A DISPENSER CAN WHICH IS DESIGNED TO ISOLATE CONTAMINATION.

DO NOT SCOUR OR ABRASE SURFACES WITH LIGHT AL-O₂ CORROSION. CORROSION PROTECTION IS NORMALLY A THIN LAYER OF ANODIZING OR ORGANIC AGENT. ABRASION CAN REMOVE THE PROTECTIVE FILM COATING.

DO NOT TOUCH THE CLEANED SURFACES. MAKE SURE TO WEAR GLOVES AND AVOID VAPOR DURING CLEANING.

USE A SHEET LEXAN MAT OVER THE FLOORING FIXED WITH DOUBLE-COATED ADHESIVE TO REDUCE THE IMPACT, GOUGING AND CORROSION.

COURTAULDS PRC ADHESIVE (PS 1776) IS A POLYSULFIDE, 2-PART FUEL TANK SEALANT. IT HAS EXTREMELY HIGH PEEL ON METAL BUT MINIMAL IMPACT ON CERTIFICATION OR BURN.

SOLVENT/CLEANER MUST NOT DAMAGE THE BASE MATERIAL AND CHEMICAL SURFACE TREATMENT/PLATING, AND MUST NOT LEAVE A RESIDUE ON THE SURFACE. DO NOT LET THE SOLVENT DRY ON THE SURFACE.

THE CLOTHS USED IN CLEANING MUST NOT CONTAIN ANY OIL, GREASE, SILICONE COMPOUNDS, OR ANY OTHER RESIDUE THAT CAN AFFECT THE ADHESION OF THE PRIMER.

NOTE: It is recommended that regardless of cleaning method employed, that metal surfaces should be treated with a corrosion inhibitor. Metal surfaces are normally treated or anodized to prevent corrosion. Normal wear and abnormal abuse affect corrosion, and it is always a factor in aircraft.

NOTE: Calla 301-A Lemon and Brulin 815MX used as described in this section are mild corrosion inhibitors. These are pH base materials which can neutralize the weak organic acids in real coffee and orange flavored drink.

NOTE: Cortec VCI-416 and all Cortec products are specifically designed for corrosion.

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- (1) Use of Solvents
 - (a) Dampen a clean dry cotton cloth (lint-free) with the solvent by pouring the solvent onto the cloth. Wipe the metal surfaces with the solvent. Repeat applications as necessary to remove all dirt. Dry the parts with a clean, dry cotton cloth (lint-free). Do not allow solvent to evaporate on surface. Do not re-use cloth as this can redeposit contamination on the surface. For oxidation, powdery white corrosion, use corrosion inhibitor/cleaner.

- (2) Use of BRULIN 815MX
 - (a) Prepare a solution of BRULIN 815MX (Table 4001) with cool or warm water (90°F - 120°F) (32°C - 49°C). Solution must be 1 part of BRULIN 815MX to 64 parts of water by volume, for light soil. Solution can be increased up to 1 part of BRULIN 815MX to 10 parts of water by volume. The solution can be applied using a spray bottle, soft-bristled brush, sponge or cotton cloth (lint-free).

NOTE: Cool water works best with normal dirt and dust. Warm water works best with oily surfaces.
 - (b) Surfaces can be scrubbed with a wet sponge or cloth, or the material can be sprayed onto the surfaces and scrubbed with a clean sponge or cloth or soft-bristled brush. Do not allow excess to run off onto adjoining surfaces. Take care that excess does not come into contact with porous surfaces.
 - (c) For all surfaces, scrub soiled areas as necessary, and repeat applications as necessary to remove contamination. Use a soft-bristled brush to clean heavily soiled areas or crevices. Rinse the surfaces with clean water, or use a fresh sponge or cloth dampened with clean water to remove residue. Dry the surfaces with a clean, dry cotton cloth (lint-free).

- (3) Use of CALLA 301-A LEMON
 - (a) Prepare a solution of CALLA 301-A LEMON (Table 4001) with cool or warm water (90°F - 120°F) (32°C - 49°C). Solution must be 1 part of CALLA 301-A LEMON to 4-8 parts of water by volume for normal soil. Use full strength for heavy soil. The solution can be applied using a spray bottle, soft-bristled brush, sponge, or cotton cloth (lint-free).

NOTE: Cool water works best with normal dirt and dust. Warm water works best with oily surfaces.
 - (b) Surfaces can be scrubbed with a wet sponge or cloth, or the material can be sprayed onto the surfaces and scrubbed with a clean sponge or cloth or soft-bristled brush. Do not allow excess to run off onto adjoining surfaces. Take care that excess does not come into contact with porous surfaces.
 - (c) For all surfaces, scrub soiled areas as necessary, and repeat applications as necessary to remove contamination. Use a soft-bristled brush to clean heavily soiled areas or crevices. Rinse the surfaces with clean water, or use a fresh sponge or cloth dampened with clean water to remove residue. Dry the surfaces with a clean, dry cotton cloth (lint-free).

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(4) Use of VCI-416 (Recommended BEST)

- (a) Prepare a solution of VCI-416 (Table 4001) with cool or warm water (90°F - 120°F) (32°C - 49°C). Solution must be 1 part of VCI-416 to 50 parts of water by volume for light soil. Solution can be increased up to 1 part of VCI-416 to 10 parts of water by volume for heavy soil. The solution can be applied using a spray bottle, soft-bristled brush, sponge, or cotton cloth (lint-free).

NOTE: Cool water works best with normal dirt and dust. Warm water works best with oily surfaces.

- (b) Surfaces can be scrubbed with a wet sponge or cloth, or the material can be sprayed onto the surfaces and scrubbed with a clean sponge or cloth. Do not allow excess to run off onto adjoining surfaces. Take care that excess does not come into contact with porous surfaces.
- (c) For all surfaces, scrub soiled areas as necessary, and repeat as necessary to remove contamination. Use a soft-bristled brush to clean heavily textured surfaces or crevices. No rinsing is necessary. Allow metal surfaces to remain wet for a minimum of 1 minute prior to drying. Dry the surfaces with a clean, dry cotton cloth (lint-free).

(5) Use of Sodium Bicarbonate Cleaners and Strippers

- (a) Equipment that uses Sodium Bicarbonate stripping compounds can be used to remove White-aluminum oxide corrosion, and can be capable of removing limited crevice or granular corrosion products. Use of Wet bicarbonate should be inspected and make sure coating thickness of anodize to make sure its integrity. Restore protection per REPAIR section as needed.
- (b) Dry Bicarbonate used as a grit-blast media can also be used.
- (c) Regardless of wet or dry application, remove all remnants of Sodium Bicarbonate by rinsing with clean water. Dry the surfaces using either solvent or dry shop wipe. Do not allow the water to evaporate on the surfaces.

(6) Use of Cortec Corwipe 300

- (a) Corwipe 300 Wipes are impregnated with corrosion inhibitors and offer mild cleaning. These wipes can be used after final wipe down of surfaces with a clean, dry shop wipe. When used as the final wipe down they will give added corrosion resistance to metal surfaces.

C. Cleaning Instructions for Adhesives

CAUTION: DO NOT LET SOLVENTS TOUCH THE DECOR MATERIAL OR PLASTIC COMPONENTS. MEK AND ACETONE CAN DAMAGE SOME COMPONENTS, AND MATERIALS.

DO NOT SATURATE CLOTH WITH SOLVENT BY PLACING THE CLOTH OVER THE CONTAINER MOUTH AND TURNING THE CONTAINER TO WET THE CLOTH. THIS CAN CAUSE CONTAMINATION OF THE SOLVENT SOURCE. ALWAYS POUR THE SOLVENT ONTO THE CLOTH OR USE A DISPENSER CAN DESIGNED TO ISOLATE CONTAMINATION.

NOTE: It is recommended that regardless of cleaning method employed; that metal surfaces should be treated with a corrosion inhibitor. Metal surfaces are normally treated or anodized to prevent corrosion. Normal wear and abnormal abuse affect corrosion, and it is always a factor in aircraft.

(1) Use of Solvents

- (a) To remove adhesive tape or adhesive residue from metal parts, dampen a clean dry cotton cloth (lint-free) with the solvent by pouring the solvent onto the cloth. Wipe onto the adhesive residue or tape. Peel as much tape from the surface as possible. Use of a plastic scrapper or spatula to remove as much solid material is recommended. Do not scratch surfaces, this reduces corrosion protection. Do not use metal scrappers, as this increases damage risk.
- (b) Repeat solvent applications as necessary to remove all residues. Dry the parts with a clean, dry cotton cloth (lint-free). Do not allow solvent to evaporate on surface.

(2) Use of BRULIN 815MX

- (a) Prepare a solution of BRULIN 815MX (Table 4001) with warm water (90°F - 120°F) (32°C - 49°C). Solution must be 1 part of BRULIN 815MX to 10 parts of water by volume. The solution can be applied using a sponge or cotton cloth (lint-free).

NOTE: Warm water works best with most adhesive residues.

- (b) Surfaces can be wiped with a wet sponge or cloth, or the material can be sprayed onto the surfaces and wiped with a clean sponge or cloth or soft-bristled brush. Do not allow excess to run off onto adjoining surfaces. Take care that excess does not come into contact with porous surfaces.
- (c) For all surfaces, scrub soiled areas as necessary, and repeat applications as necessary to remove contamination. Use a soft-bristled brush to clean heavily soiled areas or crevices. Rinse the surfaces with clean water, or use a fresh sponge or cloth dampened with clean water to remove residue. Dry the surfaces with a clean, dry cotton cloth (lint-free).

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(3) Use of CALLA 301-A LEMON

- (a) Prepare a solution of CALLA 301-A LEMON (Table 4001). Use full strength. The solution can be applied using a spray bottle, soft-bristled brush, sponge, or cotton cloth (lint-free). Surfaces can be wiped with a wet sponge or cloth, or the material can be sprayed onto the surfaces and scrubbed with a clean sponge or cloth or soft-bristled brush. Do not allow excess to run off onto adjoining surfaces. Take care that excess does not come into contact with porous surfaces.
- (b) For all surfaces, scrub soiled areas as necessary, and repeat applications as necessary to remove contamination. Use a soft-bristled brush to clean heavily soiled areas or crevices. Rinse the surfaces with clean water, or use a fresh sponge or cloth dampened with clean water to remove residue. Dry the surfaces with a clean, dry cotton cloth (lint-free).

(4) Use of VCI-416

- (a) For use on Metal surfaces with adhesive tape or residue. Prepare a solution of VCI-416 (Table 4001) with warm water (90°F - 120°F) (32°C - 49°C). Solution must be 1 part of VCI-416 to 10 parts of water by volume. The solution can be applied using a spray bottle, soft-bristled brush, sponge, or cotton cloth (lint-free).

NOTE: Warm water works best with most adhesive residue.

- (b) Surfaces can be scrubbed with a wet sponge or cloth, or the material can be sprayed onto the surfaces and scrubbed with a clean sponge or cloth. Do not allow excess to run off onto adjoining surfaces. Take care that excess does not come into contact with porous surfaces.
- (c) Scrub soiled areas as necessary, and repeat as necessary to remove contamination. Use a soft-bristled brush to clean heavily textured surfaces or crevices. No rinsing is necessary. Allow metal surfaces to remain wet for 1 minute. Dry the surfaces with a clean, dry cotton cloth (lint-free).

D. General Cleaning Instructions for Galley

(1) Protection of Floor Mount Points

NOTE: Make sure to check carpets or coverings that are intimate with the metal components. Airlines have guidelines that require R/R of the Aisle carpet at intervals of a maximum of 550 Flight hours.

Many Airlines DO NOT clean carpets but use frequent changing to offset the caustic environment that the cleaners can produce.

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CAUTION: CARPET CLEANING SOLUTIONS AND ODOR ELIMINATORS OFTEN CAUSE CORROSION PROBLEMS WITH THE AIRCRAFT ALUMINUM PARTS. CARPET CLEANING AGENTS ARE CAUSTIC. ACTIVE INGREDIENTS SUCH AS ALKYL DIMETHYL BENZYL AMMONIUM CHLORIDES (3%; C12, 40%; C14, 50%; C16, 10%).

POOLING WATER, SOFT DRINKS, COFFEE, ORANGE JUICE, WET COFFEE GROUNDS, OR OTHER SPILLED FLUID MUST BE REMOVED FROM THE CARPET AS SOON AS POSSIBLE.

- (a) Use a wet/dry vacuum to remove the excess fluid from the surfaces.
 - (b) Use absorbent cloth or cloth towels to blot dry.
- (2) Coffee Pot, Water Tank, Water lines, and Drain Lines

NOTE: This specification details the materials and methods to remove mineral deposits and stains from potable water tanks, coffee pots and drains.

Hard water means the water has a high mineral content (e.g. calcium, magnesium, iron, etc.). This often results in whitish mineral deposits left on faucets, tanks, drains, windows. Vinegar, a weak acid, can dissolve these deposits.

- (a) Remove Mineral Deposits and Stains from Potable Water Systems (Stains Accessible):
 - 1 Rinse the tank with clean tap water.
 - 2 If deposits are accessible, place paper towels over the deposits and soak with white vinegar, full strength.
 - 3 Allow 1 hour for complete saturation.
 - 4 Rinse with clean tap water. Rinse with a minimum of two full volumes of clean water.
- (b) Remove Mineral Deposits and Stains from Potable Water Systems (Stains Inaccessible):
 - 1 Rinse tank with clean tap water.
 - 2 Determine tank volume and warm $\frac{1}{2}$ - full volume of white vinegar (full strength) to 120°F (49°C).
 - 3 Add the warm, full strength white vinegar to tank. Pour the vinegar on the sides and upper section of the tank. Allow the vinegar material up to 60 minutes to completely saturate the stains. Pour the vinegar around the tank every 5-10 minutes during the soaking process.
 - 4 Pour out the vinegar and discard.
 - 5 Add warm water 120°F (49°C) to the tank and rinse completely.
 - 6 Repeat rinse process using cold water, two times.

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(c) Clean Outside of Tank

- 1 Dampen the cloth with Isopropyl alcohol or Acetone and swipe sides, bottom and upper surfaces of the tank.
- 2 Follow the damp cloth with a dry shop wipe. Do not allow solvent to evaporate on part.

(d) Remove Mineral Deposits and Stains from Coffee Makers (Inaccessible Stains)

- 1 Clean coffee pots weekly, at a minimum.
- 2 Rinse tank with clean tap water.
- 3 Determine tank volume and warm a solution of 4 oz (118.29 ml) white vinegar (full strength) for every 20 oz (591.47 ml) of water to 120°F (49°C) (1:4 solution). Fill the reservoir and allow to soak.
- 4 Allow the vinegar material up to 60 minutes to completely saturate the stains.
- 5 Initiate the brewing sequence and allow the solution to brew through the coffee maker.
- 6 Pour out the vinegar through the drain system. This will help keep the drain and drainage hoses clean.
- 7 Add warm distilled water 120°F (49°C) to the tank and rinse completely.
- 8 Discard the water through the drain system.
- 9 Repeat rinse process using cold water, two times.

(e) Flush Drains and Drainage Lines

NOTE: When Lines become congested or drainage is poor, deposits and scale should be removed. If it is practical, remove the hoses and power flushed them with water. If it is not practical, use vinegar at full strength as described below:

- 1 Use Warm Vinegar (120°F) (49°C).
- 2 Block the drain line at base so that the lines can be soaked prior to flushing.
- 3 Fill drain line up to drain pan screen and allow to soak for 60 minutes.
- 4 Flush with warm water.
- 5 Observe water flow and determine if additional cycles are needed.

(f) General Detergent Cleaning

- 1 General purpose cleaning solutions or dishwasher cleaners can be used for general rinsing and cleaning of all components. Any residual detergent or cleaner should be removed by rinsing with sufficient amount of clean water.

E. General Cleaning Instructions for Galley (Field Maintenance)

- (1) Remove all perishable items from the galley.
- (2) Drain and dry the standing sumps.
- (3) Remove screens from sumps and clean away any debris.
- (4) Check drain strainers and remove any waste accumulation.
- (5) Remove the waste containers and dispose of waste in accordance with field waste disposal procedures.
- (6) Clean and dry the waste containers in accordance to standard sanitation practices.

CAUTION: CLEANING CLOTHS ARE TO BE DAMP, NOT WET. EXCESS WATER CAN DAMAGE ELECTRICAL COMPONENTS.

- (7) Wipe the inside surfaces of all compartments and work areas. Use a mild disinfecting detergent and clean, soft cloth. Be extra careful to fully clean any food handling surfaces or areas, such as work counters, coffee makers, drinking fountains, etc.
- (8) Vacuum the work area completely, particularly corners and crevices where soil can become trapped and accumulate.

TASK 25-32-78-100-803-A01

4. Metal Preservation and Corrosion Inhibition

A. General Surface Cleaning and Preservation Metal Surfaces. Cortec VCI-416 is non-toxic and USDA Approved for metal surfaces. Removes oxidation as well as normal dirt and contamination. It is recommended for use, to make sure metal preservation.

(1) To Use Cortec VCI-416

- (a) Cortec VCI-416 Cleaner, Corrosion Inhibitor can be purchased in 16 oz (473.18 ml) spray bottles or purchased in concentrated form. For use as a cleaner: heavy soil/ cleaning use concentrate at 1 part VCI-416 to 10 parts water. For Light Duty Cleaning, use 1 part VCI-416 to 50 parts water.
- (b) Cortec VCI-416 use as Corrosion Inhibitor: if other cleaners are used, spray metal surfaces with Cortec VCI-416 or apply with a damp cloth. Wipe surfaces with a dry clean cloth to remove any residue from cleaning process. Spray or apply a second coat of Cortec VCI-416. Leave wet for a minimum of 1 minute. Follow with a clean dry, cloth.
- (c) If Cortec VCI-416 was used as cleaner, make sure that the surfaces remain wet for 1 minute prior to drying.

(2) To Use Cortec Corwipe 300

- (a) Corwipe 300 Wipes are impregnated with corrosion inhibitors and offer mild cleaning. These wipes can be used after final wipe down of surfaces with a clean dry shop wipe.
- (b) When used as the final wipe down they will give added corrosion resistance to metal surfaces.

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INSPECTION/CHECK

TASK 25-32-78-99F-809-A01

1. General

- A. Refer to paragraph 2 to do a general visual inspection of the G2 Galley Assembly for damaged or worn parts.
- B. Refer to REPAIR to repair minor damage. If the damage is major or beyond simple repair, replace the part.

TASK 25-32-78-210-801-A01

2. Component Inspection/Checks

Component checks of the G2 Galley Assembly are given in Table 5001.

Inspection/Check Procedures
Table 5001/TABLE 25-32-78-210-001-A01

Component	Check For	Corrective Action
G2 Galley Assembly and G2 Galley Installations (IPL Figures 1 thru 1F)	Cleanliness of the galley assembly, including interior of compartment.	Refer to CLEANING for proper cleaning instructions.
	Damaged or worn latch.	Adjust hardware or replace the latch.
	Damaged, deformed or worn striker.	Replace the striker.
	Damaged door stop.	Replace the door stop.
	Loose, bent, cracked or damaged trim.	Adjust hardware or replace the trim per REPAIR section.
	Unreadable or missing nameplate.	Refer to REPAIR to replace the bonded nameplate.
	Bent or damaged tie rod assembly.	Replace the tie rod assembly.
	Loose, bent, cracked or damaged ¼-turn retainer.	If loose, tighten with attaching hardware. If damaged, replace the ¼-turn retainer.
	Deteriorated, chipped, gouged or worn rubstrip.	Replace the rubstrip.
	Loose, bent, and scratched bumper.	If loose, tighten with attaching hardware. If scratched, scrub the bumper with Scotchbrite. Any other damage, replace the bumper.
	Loose, bent, cracked or damaged cover.	Repair/replace the cover per REPAIR section.
Loose, bent, cracked or damaged bracket.	If loose, tighten with attaching hardware. If damaged, replace the bracket.	

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Inspection/Check Procedures
Table 5001/TABLE 25-32-78-210-001-A01 (continued)

Component	Check For	Corrective Action
G2 Galley Assembly and G2 Galley Installations (IPL Figures 1 thru 1F)	<p>Loose, bent, cracked or damaged retainer.</p> <p>Cracked or stripped seals in between galvanic metals or between crevices.</p> <p>Deformed or damaged handle.</p> <p>Deformed or damaged clamp.</p> <p>Damaged hoses.</p> <p>Bent or damaged tee.</p>	<p>If loose, tighten with attaching hardware. If damaged, replace the retainer.</p> <p>Replace seals. Refer to REPAIR/CLEANING sections.</p> <p>Replace the handle.</p> <p>Replace the clamp.</p> <p>Replace the hoses.</p> <p>Replace the tee.</p>
Electrical Installation (IPL Figure 2)	<p>Bent or damaged sockets or contacts in the connectors and receptacles; crossed or stripped threads on the connector shell.</p> <p>Cut or cracked insulation on the electrical wiring; burns or other electrical damage; corroded or damaged harness assembly, contacts or connections.</p> <p>Damaged electrical component; refer to TESTING AND FAULT ISOLATION to check the component function.</p> <p>Deformed or damaged clamp.</p> <p>Deteriorated or damaged grommets.</p> <p>Damaged, failed, malfunctioning, or improperly installed light.</p> <p>Loose cable tie mounts.</p> <p>Damaged heater tee.</p>	<p>Replace damaged parts.</p> <p>Repair the electrical wiring per REPAIR section.</p> <p>Replace damaged parts.</p> <p>Replace the clamp.</p> <p>Replace the grommets.</p> <p>Replace the light.</p> <p>Replace/repair the cable tie mounts per REPAIR section.</p> <p>Replace the heater tee.</p>
Door Assembly (IPL Figure 3)	<p>Damaged or worn latch.</p> <p>Misaligned, damaged or deformed hinge.</p> <p>Loose, bent, cracked or damaged plate.</p> <p>Damaged spring.</p> <p>Deformed or damaged pin.</p> <p>Damaged door stop.</p>	<p>Adjust hardware or replace the latch.</p> <p>Adjust hardware or replace the hinge.</p> <p>Repair/replace the plate per REPAIR section.</p> <p>Replace the spring.</p> <p>Replace the pin.</p> <p>Replace the door stop.</p>

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Inspection/Check Procedures
Table 5001/TABLE 25-32-78-210-001-A01 (continued)

Component	Check For	Corrective Action
Door Assembly (IPL Figure 3)	Damage on panel.	Repair the panel as required. Refer to REPAIR section.
Door Assembly (IPL Figure 4)	Damaged or worn latch. Damaged backplate. Damaged spring. Misaligned, damaged or deformed half-hinge. Deformed or damaged pin. Damage on panel.	Adjust hardware or replace the latch. Replace the backplate. Replace the spring. Adjust hardware or replace the half-hinge. Replace the pin. Repair the panel as required. Refer to REPAIR section.
Drawer Assembly (IPL Figure 5)	Damaged or worn latch. Loose, bent, cracked or damaged track. Loose, bent, cracked or damaged plate. Deformed or damaged handle. Damage on panel.	Adjust hardware or replace the latch. If loose, tighten with attaching hardware. If damaged, replace the track. Repair/replace the plate per REPAIR section. Replace the handle. Repair the panel as required. Refer to REPAIR section.
Drawer Assembly (IPL Figure 6)	Damaged or worn latch. Loose, bent, cracked or damaged track. Loose, bent, cracked or damaged plate. Deformed or damaged handle. Damage on panel.	Adjust hardware or replace the latch. If loose, tighten with attaching hardware. If damaged, replace the track. Repair/replace the plate per REPAIR section. Replace the handle. Repair the panel as required. Refer to REPAIR section.
Bonded Structure Assembly (IPL Figure 7)	Punctures, scratches, or gouges in the panel; separation between the bonded panels or bonded panel assemblies. Crossed or stripped threads in the potted inserts; inserts loose or out of alignment. Bent, cracked or damaged fitting.	Refer to REPAIR to replace the bonded nameplate. Repair/replace the inserts per REPAIR section. Replace the fitting.

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Inspection/Check Procedures
Table 5001/TABLE 25-32-78-210-001-A01 (continued)

Component	Check For	Corrective Action
Bonded Structure Assembly (IPL Figure 7)	<p>Loose, deteriorated, chipped, gouged, or worn doubler.</p> <p>Damage on panel.</p> <p>Damaged or loose spacer.</p> <p>Loose, bent, cracked or damaged angle.</p>	<p>If loose, tighten with attaching hardware. If damaged, repair/replace the doubler per REPAIR section.</p> <p>Repair the panel as required. Refer to REPAIR section.</p> <p>Replace the spacer or if loose, tighten attaching hardware.</p> <p>If loose, tighten with attaching hardware. If damaged, replace the angle.</p>
Placard Installation (IPL Figure 8)	Placards not readable or lost.	Refer to REPAIR section to replace the adhesive-backed placards.
Extrusion Installation (IPL Figure 9)	<p>Bent, cracked or damaged trim.</p> <p>Loose, bent, cracked or damaged trim.</p>	<p>Replace the trim per REPAIR section.</p> <p>Loose, bent, cracked or damaged trim.</p>

REPAIR

TASK 25-32-78-99F-810-A01

1. General

A. This section contains procedures for the general repairs given below:

Paragraph	Repair Action
2	Replace or Install Bonded Components
3	Replace Potted Inserts
4	Fill and Relocate the Insert Holes
5	Replace Adhesive-Backed Rubstrip or Placard
6	Repair Electrical Circuits
7	Repair Corrosion and Restore Metal
8	Replace Trim/Extrusion
9	Bond Stainless Steel Countertop to Galley Panels
10	Repair Fiberglass Composite Panel
11	Fill Edge Holes in Honeycomb Panels
12	Fill and Fair out Procedures for Panel
13	Paint and Prime the Composite Panels
14	Repair Tedlar
15	Replace Decorative Laminate

WARNING: REFER TO CURRENT “MATERIAL SAFETY DATA SHEETS” (MSDS). THE COMPOUND MANUFACTURER GIVES THE MSDS FOR HEALTH AND SAFETY DATA.

B. The recommended materials are given in Table 6001.

NOTE: You can apply the materials shown in Table 6001. If you would like assistance with regards to applicable materials you can contact Safran Cabin Inc. Table 6001 does not give all the recommended materials shown in the repair procedures (see the applicable procedures for material specifications). Refer to the Engineering Specifications for specific materials and other approved equivalent materials (potting compound, adhesives, solvents, primers, and other very necessary materials).

NOTE: Equivalent items can be used.

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Repair Materials
Table 6001/TABLE 25-32-78-940-004-A01

Nomenclature	Part or Specification Number	Source (CAGE)*
Miscellaneous Tools:		
Guide Tool	SLT 600G**	Shur-Lok Company (V97393)
Sealant Gun, Pneumatic	Model 250	Products Research and Chemical Corp. (V4J249)
Putty Knife	N/A	Commercially Available
Razor Blade	N/A	Commercially Available
Pliers or Router	N/A	Commercially Available
Heat Gun	HL1920E or similar	TE Connectivity Corporation (V06090)
Pneumatic Wrench	N/A	Commercially Available
Soldering Iron	N/A	Commercially Available
Vacuum	Model# VK811SIWD / 125 CFM (or equivalent)	Cleva North America (V70A87)
Pressure Spray Gun (JGA-502 Gun)	#FX tip and needle #765 air cap (or equivalent)	DeVilbiss Co. (V0GAZ6)
Siphon Cup Gun (JGA-502 Cup)	#FX tip and needle #765 air cap (or equivalent)	DeVilbiss Co. (V0GAZ6)
Cloth, Milled Glass Fibers	MIL-C-9084, Hammer Milled 0.03125 in (0.0793 cm) length or less	Commercially Available
Polyester tapes, used for multipurpose lay-up at 400°F (202°C). Silicone or rubber based	Flashbreaker™ Polyester Pressure-Sensitive Adhesive and Release Tape	Airtech International, Inc. (V53912)
Polyester tapes, used for multipurpose lay-up	Flashbreaker™ Pressure-Sensitive Adhesive Masking and Release Tape	Airtech International, Inc. (V53912)
Conformal Coating, Brush Application	Military Spec MIL-I-46058, Class C or Humiseal 1A33	Commercially Available or Chase Corporation (V99109)
Abrasive-Cloth, Aluminum-Oxide, Medium-Grit	Federal Specification P-C-451	Commercially Available
ScotchBrite Pad	Aircraft Cleaning Pad Ultra Fine Hand Pad 7448	3M Company (V04963) 3M Company (V04963)
Sandpaper	100-400 grit 120-240 grit 180-220 grit 200-400 grit 400-600 grit	Commercially Available
Sanding Pad	320 grit	Commercially Available

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Repair Materials
Table 6001/TABLE 25-32-78-940-004-A01 (continued)

Nomenclature	Part or Specification Number	Source (CAGE)*
Adhesives: Decor Bonding adhesive	Scotch-Weld™ #30 (Formerly Fast-Bond™ #30)	3M Company (V04963)
	Scotch-Weld™ #30 NF (Formerly Fast-Bond™ #30-NF)	3M Company (V04963)
Edge Wrap	Aerobond 1801 Aquabind	Aerocell Corporation (V1SX35) Alternative Materials Tech Inc. (Akzo Nobel Coatings) (V0ZXD0)
Sealant/Adhesive (stainless steel)	DEVCON Aluminum Filled Epoxy Per MMM-A-132 Type I or equivalent (Loctite) HYSOL EA 9394 NA Adhesive or equivalent	ITW Polymers Adhesives NA (V0RZG3) Henkel Corporation (V1N6B3)
Adhesives	Epibond 1210-A (Resin) 9615-B (Hardener) Epibond 1559-1 A/B Epocast 1618 D/B Epocast 1628 A/B L-301-A/B Versilok 506 Accelerator #4 Scotch-Weld™ #5 (Formerly Scotch-Grip #5) DP420 DP190 EC-3524	Huntsman Advanced Materials (V1532N) J.D. Lincoln, Inc. (V0K9V8) Lord Corporation (V30676) 3M Company (V04963) 3M Company (V04963)
Fill and Fair Compounds, Polyester Based	Akemi #7 Standard Filler Akemi #4 Faster Version Micro-Ultra Filler #15-3 Fire Retardant Reducer #15-3	AXSON North American, Inc. (V3VPY6) AXSON North American, Inc. (V3VPY6) Adtech Plastic Systems Corp., Inc. (V09AU0) Adtech Plastic Systems Corp., Inc. (V09AU0)
Fill and Fair Compounds, Epoxy Based	Araldite 252, 2-part Paste Adhesive Filler DP110	Huntsman Advanced Materials (V1532N) 3M Company (V04963)
Edge Fill	L-306	J.D. Lincoln, Inc. (V0K9V8)

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Repair Materials
Table 6001/TABLE 25-32-78-940-004-A01 (continued)

Nomenclature	Part or Specification Number	Source (CAGE)*
Edge Fill	Magnolia Plastics 128-135 A/B	Magnolia Advanced Materials, Inc. (V22121)
Potting Compound	L-318 Kit Form Epibond 1559-1 A/B Epibond 420 or Redux 420 Epocast 1618 D/B Epocast 89670-A/B 1631-A/B 1632-A/B Magnabond 92-1 A/B DP420 Polystrate #14270 - 5 min epoxy EY-3009 A/B or EY-3010 A/B 7160 A/B 7176 Aerobond 1507-A/B or 1508-A/B Aerofill 1504-A/B DAPCO 3040-A/B	J.D. Lincoln, Inc. (V0K9V8) Huntsman Advanced Materials (V1532N) Magnolia Advanced Materials, Inc. (V22121) 3M Company (V04963) ITW Polymers Adhesives NA (V0RZG3) HB Fuller North America (V26348) Aerocell Corporation (V1SX35) Cytec Engineered Materials, Inc. (V1KT46)
Potting Adhesive, Epoxy Based	L-318	J.D. Lincoln, Inc. (V0K9V8)
Structural Adhesive, Epoxy Based	L-301 A/B	J.D. Lincoln, Inc. (V0K9V8)
Core Sealer-Edge Seal, Epoxy Based	L-306 A/B (Alternate: Araldite 252 A-B, 2-part paste or Epocast 1628 A-B from Huntsman) DAPCO 3008 A/B DAPCO 3303 Magnolia 85-3 A/B	J.D. Lincoln, Inc. (V0K9V8) Cytec Engineered Materials, Inc. (V1KT46) Magnolia Advanced Materials, Inc. (V22121)
Laminating Resin Epoxy	Epon 828 Resin Epikure 3223 DETA Catalyst Epocast 50A1 (100 Parts by weight) 9816 Catalyst (15 Parts by weight) or 946 Catalyst (15 Parts by weight) Hysol ® EA 956 A/B	Resolution Performance Products LLC (V3FBZ6) Huntsman Advanced Materials (V1532N) Huntsman Advanced Materials (V1532N) Henkel Corporation (V1N6B3)

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Repair Materials
Table 6001/TABLE 25-32-78-940-004-A01 (continued)

Nomenclature	Part or Specification Number	Source (CAGE)*
Sealant, Silicone (white)	RTV 102 Dow Corning 7130 GE 160 GE 5242	Momentive Performance Materials, Inc. (General Electric Co.) (V01139)
Sealant/Adhesive	PR 1775/1776 Class A or B P/S 890 Class A or B	Courtaulds Aerospace (V05027) Sealants and Coatings Technologies, Inc. (V45DF3)
Metal Surface Protection: Metal Preservation, Corrosion Inhibitors/Cleaners	VCI-416 Cleaner Corrosion Inhibitor Corwipe 300	Cortec Corporation (V44695) Cortec Corporation (V44695)
Organic Coating for Aluminum Surfaces	VCI-386 Top Coat and VCI-393 / VCI-395 Primer Alodine 600/1200 White 44-W-7 Primer A/B* Light Gray 44-W-18 Primer A/B* White 44-W-7 and 44-W-18 NOTE: DO NOT HAVE CHROMATE	VCI Products are FDA and USDA approved Henkel Corporation (V1N6B3) Deft, Inc. (V33461) Deft, Inc. (V33461) Deft, Inc. (V33461)
Organic Epoxy Mastic Coating - Top Coat	M45/M46 Reduce with M95 M62-01 Epoxy Gloss Coating	Benjamin Moore and Co. Ltd. (V09585) Certified for Food Processing and FDA Approved for Food Service
Fluid Resistant Primers:	KOROPON 515-700 PAINT 910-704 CATALYST 463-12-8 PAINT CA-116 CATALYST 10-P4-7 PAINT EC-131 CATALYST 515X391 PAINT 910c780 CATALYST 010x326 THINNER MIL-P-23377 primer Ty II CIC MIL-T-81772B REDUCER (Green Primer)	Courtaulds Aerospace (V05027) Dexter Corporation (V1JB33) Courtaulds Aerospace (V05027) Courtaulds Aerospace (V05027) C&C Ventures LLC (V77672)

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Repair Materials
Table 6001/TABLE 25-32-78-940-004-A01 (continued)

Nomenclature	Part or Specification Number	Source (CAGE)*
Fluid Resistant Primers:	MIL-P-23377 primer Ty II CIC MIL-T-81772B REDUCER (Yellow Primer)	C&C Ventures LLC (V77672)
Top Coats:	#442-3 (GLOSS COLOR) #X-304 CATALYST #453-3 (FLAT COLOR) #CA-118 CATALYST #980- (GLOSS COLOR) #982- (SEMI-GLOSS) Sher Will Enamel F63 or H99 V66V29 catalyst. R7KB29 or R7K84 or R99KY29 (REDUCER) (03Y091) Top Coat (03Y091) Catalyst MIL-T-81772 Type I Reducer MIL-PRF-85285C, Type I Polyurethane #343-55 (Filler) #345-15 (Hardener) #346-65 (Top Coat) #345-65 (Hardener)	Bostik, Inc. (V5W425) Bostik, Inc. (V5W425) WLS Coatings, Inc. (V0YY71) Sherwin-Williams Company (V1JRP1) Sherwin-Williams Company (V1JRP1) Defl, Inc. (V33461) Mankiewicz GEBR. & Co. (VD2603)
Acceptable CIC Materials:	NYCOTE 7-11 DINITROL / ARDROX AV Series Compounds DINITROL AV 8 DINITROL AV 15 DINITROL AV 25 DINITROL AV 30 SOCOPAC 65H	Nycote Laboratories Corporation (V05803) or Chemetall Chemical Products, Inc. (V02CA7) Chemetall Oakite, Inc. (V0L040) Socomore (VF6892)
Solvents:	Isopropyl Alcohol CAS No. 67-63-0 Acetone CAS No. 67-64-1 MEK (Methyl Ethyl Ketone) CAS No. 78-93-3 (Fed. MIL Spec. TT-M-261)	Commercially Available Commercially Available Commercially Available

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Repair Materials
Table 6001/TABLE 25-32-78-940-004-A01 (continued)

Nomenclature	Part or Specification Number	Source (CAGE)*
Solvents:	Ethyl Alcohol (Ethanol) CAS No. 64-17-5	Commercially Available
	Peerco 321	Commercially Available
Thinner	Humiseal #33	Chase Corporation (V99109)
Electrical:	N/A or in accordance with the OEM requirements	Commercially Available
Plug, Sealing		
Splice, Wire		
Wire, Electrical (match color)		
16-AWG		
20-AWG		
22-AWG		
Wrap, Spiral		
Tubing, Heat shrink	Not specific	Commercially Available
Protective Coating, Corrosion, Blue	Nycote 7-11	Nycote Laboratories Corporation (V05803)
<p>* Refer to the IPL, paragraph 6, for the address.</p> <p>** Add the insert tab number to the guide-tool part number. Example: The Insert tab-number T2 will use guide-tool part number SLT 600G2. This tool is optional. The repair facilities must consult with the insert manufacturer and sales representative on the available shop aids to make the insert repair faster and easier. These shop aids are not necessary, but they help those operators with no or little experience in insert installation.</p>		

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2. Replace or Install Bonded Components

NOTE: Refer to Table 6001 for the recommended materials. For Structural Bonding reference “Structural Adhesives – Joints and Aluminum Doubler Bonding” section.

WARNING: **APPROVED SOLVENTS (MEK, ACETONE, ALCOHOL) ARE FLAMMABLE AND SHOULD BE USED WITH PROPER PRECAUTIONS. ALL SOLVENTS AND ADHESIVES SHOULD BE MIXED AND USED PER THESE INSTRUCTIONS AND/OR THE MANUFACTURER’S RECOMMENDED PROCEDURES.**

SHOULD A CONFLICT BETWEEN THESE INSTRUCTIONS AND MANUFACTURERS’ INSTRUCTIONS OCCUR, THE MANUFACTURERS’ INSTRUCTIONS WILL TAKE PRECEDENCE, BUT NOTIFY SAFRAN CABIN INC., DIRECTOR OF MATERIALS AS SOON AS POSSIBLE.

USE THESE ITEMS IN A WELL VENTILATED AREA AND AWAY FROM OPEN FLAMES. IF ADHESIVES OR SOLVENT MATERIALS SHOULD COME IN CONTACT WITH SKIN OR EYES; FLUSH AREA WITH CLEAN WATER AND SEEK MEDICAL ATTENTION AS NEEDED.

THE USE OF PROPER PERSONAL PROTECTIVE GEAR IS REQUIRED. AT A MINIMUM: GLOVES ARE RECOMMENDED FOR HANDLING PARTS, AND SHOULD BE WORN WHENEVER HANDLING CHEMICALS OR SOLVENTS. GOGGLES SHOULD BE WORN WHEN A SPLASH COULD OCCUR.

WHEN SANDING OR ABRADING PART SURFACES; A DUST OR PARTICULATE MASK SHOULD BE WORN.

WHEN MIXING CHEMICALS OR USING SOLVENTS, AN ORGANIC VAPOR RESPIRATOR IS RECOMMENDED, ALONG WITH GOOD VENTILATION AND ADEQUATE LIGHTING.

- A. Prior to bonding, remove any loose or damaged components. Partially bonded Metallic details and composite parts can be removed from other panels using heat and care. Heat the bond-line to 160°F - 180°F (71°C - 82°C) using a heat gun or similar tool until softened. Place the part in shear or peel or tap with a rubber or plastic mallet to dislodge the parts.
- B. After separation, inspect the parts and make sure that they are sound and can be re-bonded. If the part condition will not allow re-use, consult with Components Manual and resource new parts (panels, doublers, etc.) as needed.
- C. Remove any loose debris from the surfaces of the loosened part.
- D. Wipe down dirty or oily parts with a clean shop wipe or rag dampened with approved solvent from Table 6001, and follow with a clean dry shop wipe. This will remove any film or oil from the surface to be bonded.
- E. Once the part is free of oil or film, to make sure that a satisfactory bond can be achieved, it is recommended that the bonding surface be abraded using a medium-grit (aluminum oxide or silicone oxide) sanding medium to remove any surface gloss. Do not sand prior to solvent wipe (step C). This abrasive cloth will remove the loose particles and will make a uniform-grain pattern on the surfaces.

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- F. Follow sanding operation with a clean, lint-free cloth dampened with approved solvent. Follow the wipe-down process with a clean, lint-free cloth to dry. Do not allow solvent to evaporate on surface of the part. Do not handle clean parts with bare skin.
- G. For metallic parts-consult metal surface preparation section to make sure corrosion inhibition prior to bonding.
- H. Mix approved adhesives (two-part resin/catalyst) per the requirements of the manufacturer. Mix no more than you can use during the pot life of the adhesive. Mix the components fully but not excessively. Do not whip air into the mixture during the mixing process.

CAUTION: SOME CATALYZED ADHESIVES WILL EXOTHERM (GENERATE HEAT) IN MODERATE MASS OR IF MIXED TOO AGGRESSIVELY.

- I. Apply adhesive to both sides of the part(s) to be bonded to make sure uniform wet-out. It is recommended that an adhesive comb or pneumatic sealant gun be used to make sure a uniform coat is applied.
 - If using a sealant gun, apply a bead over the area that can be spread as appropriate to make sure uniform coverage. A spatula or similar tool can be used for this. When applying adhesive to both sides, spread one side lengthwise and spread the facing side width-wise so that the two would crisscross when pressed together.
 - If using a comb, spread using a minimum teeth with 1/16 x 1/16 spread (0.125 in (0.3175 cm) comb is preferred). When applying adhesive to both sides, spread one side lengthwise and spread the facing side width-wise so that the two would crisscross when pressed together.
- J. Push the parts together. For large areas, begin at one end and work down slowly to make sure that no air is entrapped. Work quickly per the work-life requirements of the adhesive.
- K. Remove unwanted or excess adhesive from the part using a clean spatula or similar tool. Use of a radius gauge or similar tool to provide a neat fillet is recommended. The dry tool is useful for removing the bulk of squeeze-out or excess adhesive. When large excess is removed, a cloth or cotton swab dipped in acetone, isopropyl alcohol or other approved solvent can be used to remove and residual excess away from the bond line. Do not soak or apply excess solvent to the bond line.
- L. Clamp or fixture the parts as needed for a minimum of 2 hours at room temperature prior to attempting to accelerate the cure.
 - 1. If accelerated cure is required – gently heat the part to 120°F - 140°F (49°C - 60°C) for a minimum of two hours. Do not heat above 160°F (71°C).
 - 2. If Room Temperature Cure is acceptable, allow to set a minimum of 48 hours at room temperature (62°F (17°C) minimum).
- M. Physical Inspection: Use a 6 in (15.24 cm) by 0.5 in (1.27 cm) scale or similar tool as a probe to follow adhesive bond lines. Make sure that the scale does not penetrate the bond-line greater than a depth of 0.0625 in (0.1587 cm) in any one area, these are not flaws, but where the resin has shrunk into the gaps. Check for gaps up 1 in (2.54 cm) in length and greater than 0.0625 in (0.1587 cm) in depth but no more than one-half the thickness of the base panel. These flaws can be corrected. See Touch-ups. Gaps greater than that defined here require that the detail be removed and re-bonded as the excess can compromise the part.

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- N. Touch-up: mix additional adhesive as needed to fill small gaps and inject into part areas as needed. Clean and form a fillet using the adhesive and a grout or radius gauge as necessary. Allow correction materials a minimum of 24 hours at room temperature to set, or two hours at 120°F (49°C).
- O. Parts that require separation and cleaning prior to re-bonding should begin with paragraph A.
- P. Seal the corners and clearances with white RTV 102 Sealant as required.

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3. Replace Potted Inserts

NOTE: Refer to Table 6001 for the recommended materials. For replacing potted inserts reference “Insert Potting Compounds” section.

NOTE: Use these instructions to replace inserts installed with potting compounds in the honeycomb panel. For repair of the fiberglass facings see below and referenced sections as appropriate.

WARNING: APPROVED SOLVENTS (MEK, ACETONE, ALCOHOL) ARE FLAMMABLE AND SHOULD BE USED WITH PROPER PRECAUTIONS. ALL SOLVENTS AND ADHESIVES SHOULD BE MIXED AND USED PER THESE INSTRUCTIONS AND/OR THE MANUFACTURER’S RECOMMENDED PROCEDURES.

SHOULD A CONFLICT BETWEEN THESE INSTRUCTIONS AND MANUFACTURERS’ INSTRUCTIONS OCCUR, THE MANUFACTURERS’ INSTRUCTIONS WILL TAKE PRECEDENCE, BUT NOTIFY SAFRAN CABIN INC., DIRECTOR OF MATERIALS AS SOON AS POSSIBLE.

USE THESE ITEMS IN A WELL VENTILATED AREA AND AWAY FROM OPEN FLAMES. IF ADHESIVES OR SOLVENT MATERIALS SHOULD COME IN CONTACT WITH SKIN OR EYES; FLUSH AREA WITH CLEAN WATER AND SEEK MEDICAL ATTENTION AS NEEDED.

THE USE OF PROPER PERSONAL PROTECTIVE GEAR IS REQUIRED.

AT A MINIMUM: GLOVES ARE RECOMMENDED FOR HANDLING PARTS, AND SHOULD BE WORN WHENEVER HANDLING CHEMICALS OR SOLVENTS.

GOGGLES SHOULD BE WORN WHEN A SPLASH COULD OCCUR.

WHEN SANDING OR ABRADING PART SURFACES; A DUST OR PARTICULATE MASK SHOULD BE WORN.

WHEN MIXING CHEMICALS OR USING SOLVENTS, AN ORGANIC VAPOR RESPIRATOR IS RECOMMENDED, ALONG WITH GOOD VENTILATION AND ADEQUATE LIGHTING.

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- A. Inspect suspect or damaged insert and panel surround. If the Fiberglass panel is not damaged consult with paragraph 4 for the removal of the insert.
- B. If the fiberglass panel is damaged:
- Damage is less than 1.5D (1.5x the Outside Diameter of the insert and flange):
 - a) Fill hole with potting compound and fair surface.
 - Damage is greater than 1.5D and lower than 2.5D:
 - a) Mix laminating resin and prepare chopped glass fibers to fill the damaged area.
 - b) Mask the area outside the damage, and cut flash-breaker tape to match the hole in panel.
 - c) Use milled glass or chop glass fibers from woven or roving so that the glass is 0.0625 in (0.1587 cm) or 0.25 in (0.635 cm) in length.
 - d) Add some dry fibers inside insert hole, and inject a small amount of laminating resin over them – filling hole about $\frac{1}{4}$ of the way. Mix additional fibers with adhesive selection (10% by weight) and press/fill damaged area in panel to near flush. Add some additional unfilled resin to top and fill flush with surrounding panel. Allow to cure then sand flush prior to insert installation.
 - If damaged area is greater than 2.5D it is recommended that skin restoration with either a wet lay-up or pre-cured fiberglass plug be accomplished prior to insert replacement. Consult paragraph 10 for wet lay-up.
 - a) If adding a pre-cured fiberglass plug over the damaged area, first clean surrounding area and smooth surfaces with an angle motor or sanding disk.
 - b) Wipe down surface with isopropyl alcohol or other approved solvent.
 - c) Pre-cured Fiberglass skin repair must overlap surrounding skins by a minimum of 0.25 in (0.635 cm) on all sides.
 - d) Remove one cell (0.125 in (0.3175 cm) of core) from around the ID hole.
 - e) Fill hole with structural adhesive or potting compound and bond pre-cured skin plug over the location. Make sure that the structural adhesive or potting compound adhesive fills the additional 0.125 in (0.3175 cm) area also.
 - f) Allow a minimum of 24 hours to set prior to additional sanding operations.
 - g) Fill and fair the step out of the panel surface per other sections of this specification.
- C. After insert is removed per paragraph 4 or skin is restored per paragraph 3.B.; drill hole for new insert as needed. The hole only has to large enough to install the insert and allow the flange to be flush.
- D. Inject potting compound into hole in the panel and fill a minimum of $\frac{1}{4}$ way.
- E. Clean new or restored inserts by either vapor degrease or solvent cleaning. Wipe down surfaces with a solvent damp rag, then clean and dry with a lint-free shop wipe.

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- F. Do not handle degreased surfaces with bare hands.
- G. Install insert in location. Can inserts are designed with an adhesive backed temporary fixing tab to make sure a flush installation with panel surface. The tab is larger than the flange on the insert, and allows it to seat on the panel skin surface and hold the insert in place. Consult with source and use the tab(s) and alignment tools as needed to make sure alignment is as required.
- H. Alignment tools are at the discretion of the repair shop, and not a requirement.
- I. Inject potting compound into one of the tabs on top of insert and make sure adhesive push-out from the opposite side hole.
- J. Allow adhesive to set prior to loading inserts. See Table 6002 for when part can be loaded (Green Strength). Any adhesive not listed in Table 6002 should be cured for a minimum of 24 hours prior to applying a load.

Adhesive Cure Time
Table 6002/TABLE 25-32-78-300-001-A01

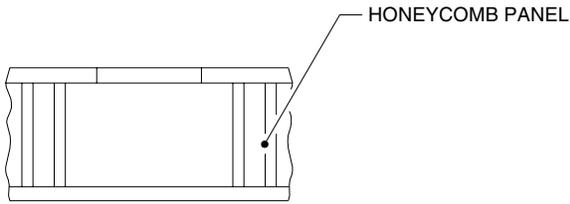
Manufacturer	Material Description	WorkLife/ Cure Time (Green strength)
Aerocell Corporation	Aerobond 1507N A/B	30 minutes at 70°F+ (21°C+) 8 hours at 70°F+ (21°C+)
ITW Polymers Adhesives NA	#14270 Polystrate	4-5 minutes at 70°F+ (21°C+) 1.5 hours at 30°F+ (-1°C+)
	Plastic Welder II	20 minutes at 70°F+ (21°C+) 1.5 hours at 35°F+ (2°C+)
Huntsman Advanced Materials	Epocast 1544 A/C	20 minutes at 70°F (21°C) 24 hours at 70°F (21°C)
	Epocast 1544 A71/D Epocast 1544 A42/D Epocast 1544 A82/D	20 minutes at 70°F (21°C) 24 hours at 70°F (21°C)
	Epocast 1559-1 A/B	6 minutes at 70°F (21°C) 1 hour at 70°F (21°C)
	Epocast 1632 A/B	45 minutes 4 hours at 70°F (21°C)
	Epocast 1633 A/B	5 minutes at 70°F (21°C) 1 hour at 70°F (21°C)
	Araldite 2043	5 minutes at 70°F (21°C) 1 hour at 70°F (21°C)
	Araldite 2012 AW 2104 + HW 2934	4 minutes at 70°F (21°C) 1 hour at 70°F (21°C)
	Epocast 1618 A/B Epocast 1618 D/B	17 minutes at 70°F (21°C) 4 hours at 70°F (21°C)
	Fastweld 10	3-4 minutes at 70°F (21°C) 1 hour at 70°F (21°C)

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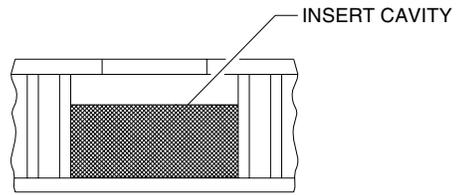
Adhesive Cure Time
Table 6002/TABLE 25-32-78-300-001-A01 (continued)

Manufacturer	Material Description	WorkLife/ Cure Time (Green strength)
Huntsman Advanced Materials	EPIBOND 420 A/B REDUX 420 A/B	80 minutes at 72°F (22°C)
HB Fuller North America	FR 7162 A/B	10 minutes at 70°F (21°C) 8 hours at 70°F (21°C)
	FR 7176 A/B	10 minutes at 70°F (21°C) 8 hours at 70°F (21°C)
Magnolia Advanced Materials, Inc.	Magnabond 92-1 A/B	10 minutes at 70°F (21°C) 8 hours at 70°F (21°C)
3M Company	DP420	20 minutes at 70°F (21°C) 4 hours at 70°F (21°C)
	DP460	60 minutes at 70°F (21°C) 4 hours at 70°F (21°C)
	EC-2216 A/B	30 minutes at 70°F (21°C) 4 hours at 70°F (21°C)
	EC-3333 B/A	30 minutes at 70°F (21°C) 4 hours at 70°F (21°C)

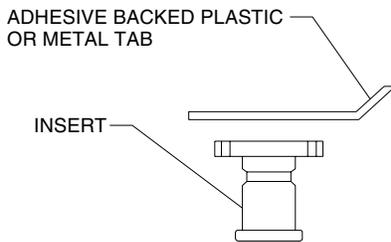
COMPONENT MAINTENANCE MANUAL
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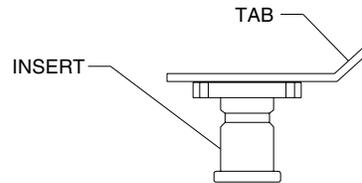
1. PREPARE THE HOLE FOR THE INSERT.
INITIAL CAVITY IS SHOWN NET SIZE.
IS NECESSARY TO REMOVE ONE CELL WIDTH CORE.



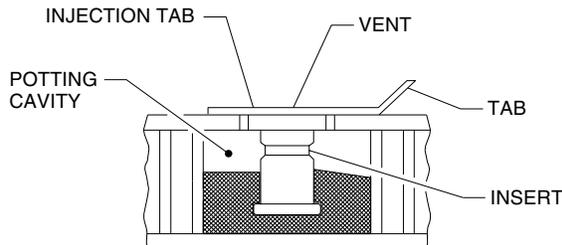
2. ENLARGE THE HOLE BENEATH SKIN.
REMOVE 1 CELL WIDTH (MIN).
ADD POTTING COMPOUND (RECOMMENDED
ON PANELS WITH 2-PLY OR MORE SKINS).
TO CAVITY (~ 1/2 FULL) TO HELP SEAT INSERT.



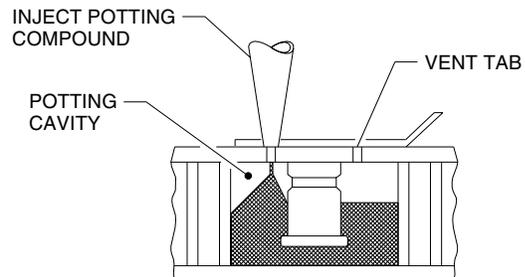
3. ALIGN THE ADHESIVE TAB TO FILL/VENT
HOLES ON THE INSERT.



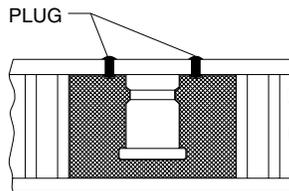
4. A PIN, PAPER CLIP, OR VENDOR
(V97393) SUPPLIED GUIDE
TOOL CAN BE USED TO AID ALIGNMENT.
(REFER TO TABLE 6001)



5. INSTALL THE INSERT, PRESS
THE TAB ON PANEL.
INSURE PROPER SEATING.



6. INJECT THE POTTING COMPOUND THROUGH
THE HOLE IN INSERT UNTIL COMPOUND
EXTRUDES THROUGH THE OPPOSITE VENT.



7. REMOVE THE TAB AND TRIM PLUGS
FLUSH WITH THE PANEL.

Insert Installation with Potting Compound
Figure 6001/GRAPHIC 25-32-78-300-001-A01

TASK 25-32-78-300-803-A01

4. Fill and Relocate the Insert Holes

NOTE: Refer to Table 6001 for the recommended materials. If you would like assistance with regards to applicable materials you can contact Safran Cabin Inc.

A. Remove the insert.

NOTE: The insert, when potted into a sandwich structure, holds the composite or other components in position. Before the insert installation, the core is relieved below the skin and around the hole perimeter of the insert. This does not let the adhesive plug to pull out of the composite.

(1) ALTERNATIVE 1:

- (a) To remove the metal inserts, apply heat to them with a soldering iron. Put the end of the soldering iron into the insert sleeve (threaded or through hole).

NOTE: The heat increases the temperature of the potting compound and the insert. As a result, the L-318 potting compound cracks around the insert. Five (5) minutes are necessary for this process to occur. The glass or carbon skins must show no cracks or fractures.

(2) ALTERNATIVE 2:

- (a) Put a bolt into the insert and, with a pneumatic wrench, apply a torque of 80 - 100 lbf-in (9 - 11.2 N-m). The standard inserts are made to get about 70 lbf-in (7.9 N-m) of torque. When you increase the torque, the insert will turn and will permit removal of the insert together with some of the defective adhesive.
- (b) Let the insert turn freely for a minute or more to build heat and friction. The heat will crack the epoxy and permit its removal. Do not cause damage to the skins. If you cannot remove the insert easily, refer to Alternative 1.

B. After the insert removal, clean the panel hole to remove all dirt, dust, or other unwanted material. If necessary, remove an additional amount of core at ~0.05 in (0.127 cm) below the surface with a router. Let the skin stay intact. This will cause a blockage of the "plug" mechanically. If necessary, clean the area with Isopropyl Alcohol, acetone, or other approved solvent.

C. Apply a 0.002 in (0.00508 cm) thick mask of flash-breaker mylar, glass, polyester, or other masking tape around the insert hole.

D. Fill the hole with an applicable potting compound. Use a spatula or an equivalent edge tool to remove the unwanted compound from the surface. Move the edge tool at an angle along the flash-breaker tape to remove the unwanted adhesive. Do this until the remaining compound is 0.002 in (0.00508 cm) maximum above the skin surface.

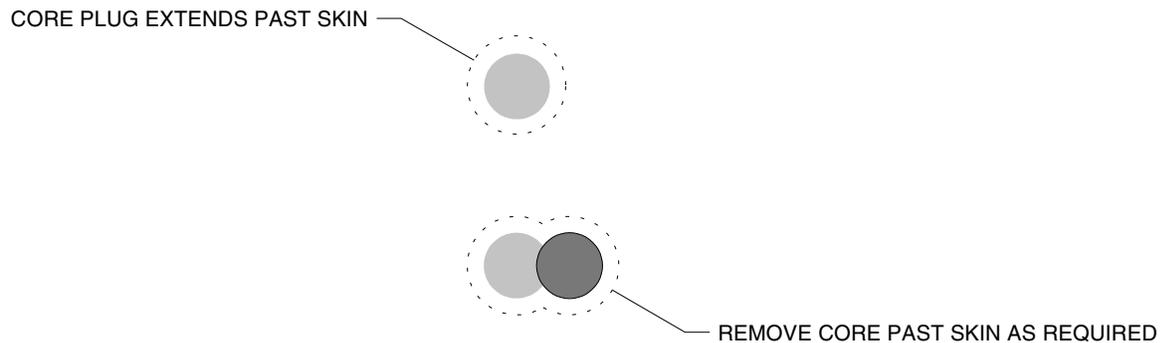
CAUTION: BE CAREFUL WHEN YOU REMOVE THE MASKING TAPE TO PREVENT DAMAGE, SCRATCH, OR CUT TO THE PANEL SURFACE.

E. Remove the masking tape. Apply the edge tool along the skin surface. Let the compound cure for a sufficient time.

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- F. After the cure of the compound, make the lifted edges smooth with a 180-220 grit sandpaper, if necessary. To paint the composite, refer to paragraph 13.
- G. Identify the new location and drill the composite to the correct diameter and depth.
- H. Remove the core below the composite skin at ~0.05 in (0.127 cm) in the new location.

NOTE: There can be an overlap between the old and the new locations. If this occurs, release the skin where it was not removed before. See Figure 6002.



Fill and Relocate the Insert holes
Figure 6002/GRAPHIC 25-32-78-300-002-A01

TASK 25-32-78-300-804-A01

5. Replace Adhesive-Backed Rubstrip or Placard

NOTE: Refer to Table 6001 for the recommended materials. If you would like assistance with regards to applicable materials you can contact Safran Cabin Inc.

- A. Use a flat-blade screwdriver or an equivalent tool to remove the damaged rubstrip or placard from the panel.
- B. Clean the panel with ethyl alcohol to remove the adhesive and other contamination.
- C. Remove the contact sheet from the back of the replacement rubstrip or placard.
- D. Install the rubstrip or placard in the same location on the panel. Push the rubstrip or placard from the center out to remove the air bubbles.

TASK 25-32-78-300-805-A01

6. Repair Electrical Circuits

NOTE: Refer to Table 6001 for the recommended materials. If you would like assistance with regards to applicable materials you can contact Safran Cabin Inc.

NOTE: When necessary, replace and connect the electrical wires again. Refer to the subsequent steps for general instructions.

- A. Replace the damaged wire leads with MIL-W-22759/XX or MIL-C-27500/XX electrical wire (Table 6001). To identify the wire gauge (AWG), refer to the last two numbers of the wire number shown on the wiring diagram, Figure 2001. Cut the replacement wire to the same length as the damaged wire. Use wires of the same color and gauge.
- B. Apply a protective sleeve or spiral wrap (Table 6001) to all wires susceptible to damage.
- C. Install the splices when necessary.
- D. Install seal plugs in all receptacles and connector holes that you will not use.
- E. Attach the wires with tiedown straps or to the existing wire bundle, if necessary.
- F. Prepare electrical ground area as follows:

NOTE: If specified, the aircraft manufacturer's requirements take precedent over the following requirements.

- (1) Sand the ground surface area with medium grit aluminum oxide abrasive cloth (Table 6001) to remove nonconductive material and surface treatment. Sanded surface must extend 0.125 in (0.3175 cm) minimum beyond the attachment point for a good electrical bond.
- (2) Clean the electrical bond surfaces with ethyl alcohol and then rinse.
- (3) Where aluminum metal is the electrical bond point, treat the area with #1200 Alodine for 1 to 2 minutes and then rinse with water.
- (4) After the ground hardware is installed, apply corrosion protective coating (NYCOTE BLUE 7-11) to cover the ground stud. Corrosion preventive color blue is mandatory.

TASK 25-32-78-300-806-A01

7. Repair Corrosion and Restore Metal

NOTE: Refer to Table 6001 for the recommended materials. If you would like assistance with regards to applicable materials you can contact Safran Cabin Inc.

CAUTION: ALL DISSIMILAR METALS ARE ISOLATED WITH SEALS TO PREVENT GALVANIC CORROSION. IF A REPAIR OR REPLACEMENT IS NECESSARY, THE MAINTENANCE MECHANICS MUST REMOVE AND REPLACE ALL SEALS AND INSULATING BARRIERS. REFER TO THE DISASSEMBLY AND ASSEMBLY SECTIONS IN THE APPLICABLE CMM, TO DISASSEMBLE AND ASSEMBLE ALL PARTS. NO DEVIATIONS ARE PERMITTED. ALL DEVIATIONS FROM THE REPAIR INSTRUCTIONS IN THIS DOCUMENT WILL VOID THE WARRANTY GIVEN BY SAFRAN CABIN INC.

DO A VISUAL INSPECTION DAILY OR AT EACH REGULAR CLEAN-UP FOR COFFEE GROUNDS IN THE SINK, DOWN THE SINK, AND IN THE PLUMBING DRAIN LINE. PUT WHITE VINEGAR THROUGH THE LINES ONE TIME A WEEK OR AT EACH 56 FLIGHT HOURS FOR NARROW BODY AND 80 PLUS HOURS FOR WIDE BODY. DO MULTIPLE VINEGAR FEED AND DRAIN CYCLES ON A OR C CHECKS. REFER TO INSPECTION/CHECK AND CLEANING SECTIONS IN THE APPLICABLE CMM.

ON ALL METAL PARTS TO PREVENT CORROSION: DILIGENTLY EXAMINE THESE PARTS MONTHLY (250 FLIGHT HOURS OR 336 FLIGHT HOURS). IF THERE IS CORROSION, REMOVE IT AT THE FIRST A/B/C CHECK IF YOU FIND IT DURING THE MONTHLY INSPECTION AND/OR DURING CHECKS. REFER TO THE REPAIR/RESTORE INSTRUCTIONS IN THIS DOCUMENT.

IMMEDIATELY REMOVE THE ORGANIC UNWANTED MATERIALS (COFFEE GROUNDS, FOOD SPILLS, SUGAR, ETC.). ROUTINELY REMOVE THESE UNWANTED MATERIALS FROM THE DIRTY AREA AND/OR COMPARTMENTS (WASTE CONTAINER COMPARTMENT INCLUDED) DURING SPOT CLEANING. REFER TO THE CLEANING SECTION IN THE APPLICABLE CMM.

NOTE: For removal and installation of the parts/items intended for corrosion repair, refer to the Disassembly, Assembly, and IPL sections in the applicable CMM. This Repair section applies only to these subsequent material specifications:

- (A) Aluminum stock, 0.375 in (0.9525 cm) thick, 7075-T73, Hard Anodized per MIL-A-8625 Ty III (Floor).
- (B) Sheet Stock Aluminum, 0.02 - 0.1 in (0.0508 - 0.254 cm) thick, Chem Filmed per MIL-C-5541, or Anodized per MIL-A-8625 Ty II or III.
- (C) Fittings Aluminum Stock 7075-T731, Chem-Filmed per MIL-C-5541, Class 1A Primer per CDSPS007 or MIL-P-23377, and Top Coat per CDSPS007.

NOTE: You will keep the structural integrity of the part if you obey the repair requirements correctly and carefully. The Flammability and other Certification will not be affected if you obey the limits and the recommended materials in this document. If you want to use alternative materials which have the same performance and requirement, if you would like assistance you can contact Safran Cabin Inc.

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NOTE: If light dust of Aluminum Oxide is the only corrosion present, obey the instructions that are given in paragraph 7.A. (Size Limits for Repairs). Obey the Corrosion Inhibition (Surface Protection) and Painting instructions (Primer Application Instructions) given in paragraphs 7.E. and 7.G.

NOTE: Safran Cabin Inc. Structural Engineering must be examine the damages case by case and determine if damaged fitting is structurally critical or not. Critical fittings require further analysis per paragraph 7.A.(2) and non-critical fittings can be determined per paragraph 7.A.(1).

WARNING: DO NOT TOUCH THE CLEANED SURFACES. BE SURE TO WEAR GLOVES AND AVOID VAPOR DURING CLEANING AND REPAIR.

A. Size Limits for Repairs

(1) Aluminum Fittings (Non-critical)

- (a) You can repair damage up to 20% of non-critical fittings. Repair the damage which is more than 20% of the fitting or includes two attachment points in a sequence. Replace the fitting.

NOTE: Refer to the Cleaning section in the applicable CMM for cleaning instructions before repair. For Corrosion Repair Instructions, refer to paragraph 7.C. Apply Aluminum-Filled Epoxy on the contour of the surface.

(2) Aluminum Fittings (Critical) (See Figure 6003)

- (a) You can repair damage from 5% to 10% on upper floor fitting installation holes (See Figure 6003).
- (b) Do not repair damage on lower floor fitting installation holes because these positions carry most of the load (See Figure 6003).
- (c) You can repair damage up to 10% on all the surfaces of the floor fittings. Do not repair damage which is more than 5% of the fitting or includes two attachment points in a sequence. Replace the fitting.

NOTE: Refer to the Cleaning section in the applicable CMM for cleaning instructions before repair. For Corrosion Repair Instructions, refer to paragraph 7.C. Use Aluminum-Filled Epoxy to fair out the surface to the contour.

(3) Stab-in Extrusions (Non-critical)

NOTE: It is not necessary to remove all signs of the epoxy adhesive on the extrusion or the panel to make the repair. Use a scribe or an equivalent tool to examine the epoxy filler. Remove all loose pieces.

NOTE: Refer to the Cleaning section in the applicable CMM for cleaning instructions before repair. For Corrosion Repair Instructions, refer to paragraph 7.C. You can bond small section of stab-in extrusion in the remaining gaps. It is permitted to fill the area with Aluminum-Filled Epoxy.

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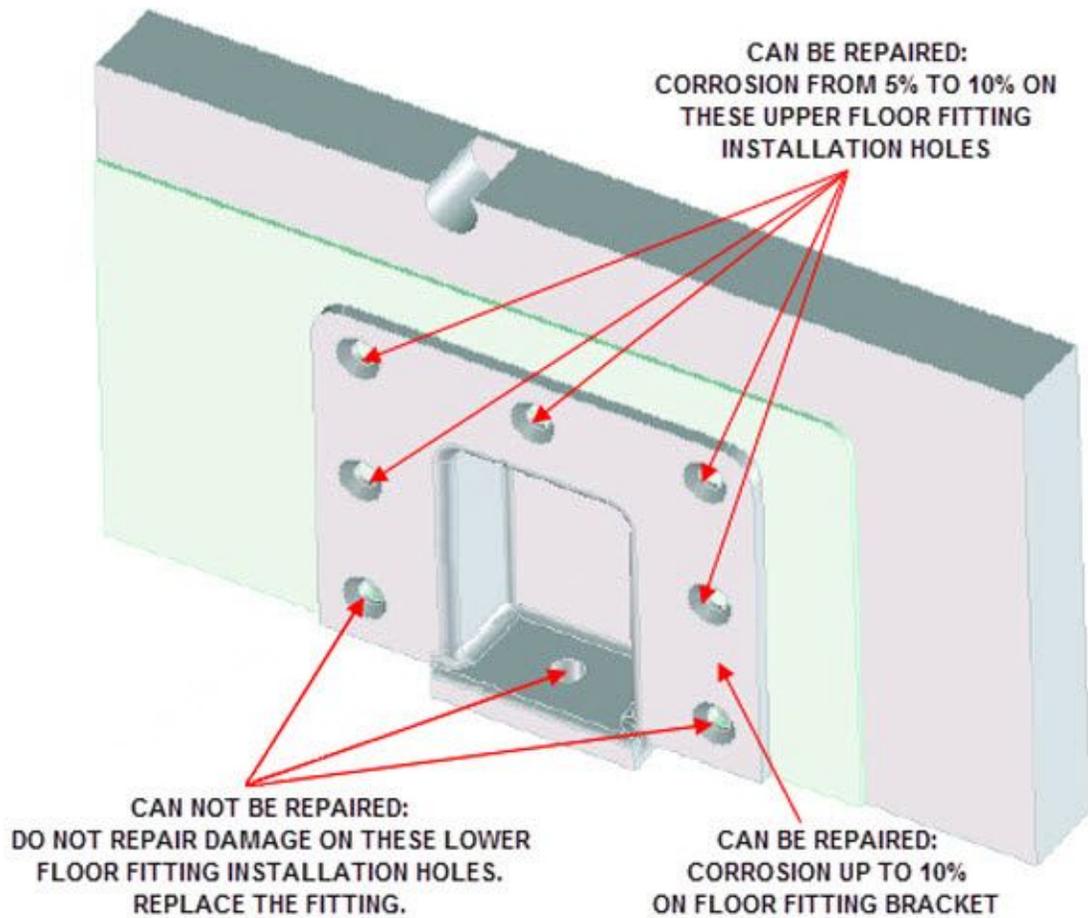
- (a) Extrusions that have through holes or clearance holes, where fittings are attached to plates or metal fittings in the panel, are non-critical extrusions. If these extrusions are non-cosmetic, you can repair them up to 30% of the length and up to ½ the thickness of the original part. The mechanics must examine the extrusion carefully to make sure that the extrusion is chemically protected/repaired to prevent more corrosion.

(4) Stab-in Extrusions (Critical)

NOTE: It is not necessary to remove all sign of the epoxy adhesive on the extrusion or the panel to make the repair. Use a scribe or an equivalent tool to examine the epoxy filler and remove all loose pieces.

NOTE: Refer to the Cleaning section in the applicable CMM for cleaning instructions before repair. For Corrosion Repair Instructions, refer to paragraph 7.C. You can bond small section of stab-in extrusion in the remaining gaps. It is permitted to fill the area with Aluminum-Filled Epoxy.

- (a) Extrusions, which are attachment points or where fittings are attached directly to, are critical components. If these extrusions are damaged, get access to and identify them. The attachment points can be critical to the related forward or downward Certification Loading of the unit (if it holds a door or other component in position). You can repair or replace these extrusions. If you would like assistance with regards to damages you can contact Safran Cabin Inc. for analysis.



Example of Critical Damage on Aluminum Fitting
Figure 6003/GRAPHIC 25-32-78-300-003-A01

B. Cleaning Requirements for Corrosion Removal

NOTE: Refer to the Cleaning section in the applicable CMM for cleaning of the metal parts.

C. Corrosion Repair Instructions

NOTE: Make sure that the damaged parts agree with the size limits for repair that are given in paragraph 7.A.

(1) For Pit or Crevice Corrosion

- (a) Use a grinding wheel or router bit to make the surface smooth and remove the pit type corrosion. Use a vacuum to remove the particles and unwanted materials.
- (b) Fill the service pits and corrosion with Devcon Aluminum-Filled Putty or Hysol EA 9394.

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- (c) Make the surface smooth.
- (d) If the anodized coating is removed in metal areas adjacent to the repair, use Alodine Solution to make the surface resistant to corrosion again. For Surface Protection, refer to paragraph 7.E.

(2) Exfoliated or Inter-Granular Corrosion

NOTE: To know the true extent of the damage and repair, remove all inter-granular corrosion.

- (a) To make sure that all metal in bad condition and corrosion products are removed, do an inspection on the component with a 5 or 10X loop.
- (b) Use rubber-base wheels soaked with aluminum oxide to grind and to blend out or to make the edges of the damaged areas smooth.
- (c) Chemically inhibit the exposed surfaces and repair the chemical surface films or paints in the same manner as other metallic surfaces.

NOTE: Cut away or abrade the exfoliated metal to clean the surface. This is not to permit the embrittled layers to spread damage through the mounting. Use an aluminum-filled epoxy that agrees with the minimum requirements of MM-A-132 Type 1.

D. Replacement of Aluminum Sections

(1) Example of replacement:

- (a) Cut away a section of a non-critical stab-in extrusion.
- (b) Bond in position one stab-in section or a solid piece of aluminum. The function of some of these extrusions are to increase the compression loading that the panel or unit can support.
- (c) Remove a section of extrusion and replace it with a solid aluminum piece of the same width and length.
- (d) Use Epoxy adhesives to bond the solid aluminum piece to make sure that the compression loads are tolerated.

E. Surface Protection

(1) Chemical Surface Protection/Repair Anodized or Chem-Filmed Surfaces

NOTE: Apply Alodine 600/1200S with a brush to the panel surfaces. Use Alodine 600 or Alodine 1200 to seal the aluminum. You must paint the surfaces with Alodine solution. Use Alodine 600 for parts that will stay in as "treated" condition. Use Alodine 1200S for parts which must be painted. Refer to Henkel Corporation (V1N6B3) or supplier for Alodine mixing Instructions and verification of material.

- (a) Make sure that the Alodine covers all surfaces without protection. Let the parts stay in Alodine for the sufficient time for them to soak fully. If it is necessary to apply the protection with a brush, apply a thin uniform. The protection is satisfactory after 5 minutes.

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- (b) Flush the surfaces with clean, cold water. If possible, use distilled water. To prevent contamination to the main body of the water, you must continuously overflow the water.

NOTE: Put the new or removed metal components into Alodine 600/1200S. For this procedure, do steps (c) and (d):

- (c) Make sure that the Alodine covers all surfaces without protection. Put the components into the solution for 1 to 5 minutes. Let the parts stay in Alodine for the sufficient time for them to soak fully.
- (d) Flush the surfaces with clean and cold water. If possible, use distilled water. To prevent contamination to the main body of the water, you must continuously overflow the water. Collect the flowing water as practical. The water and treatment solution contain acids, chromium compounds, and complex fluorides. To discard these materials, refer to paragraph 7.F.

(2) Additional Corrosion Protection

NOTE: Safran Cabin Inc. normally does extensive tests to make sure that the materials used do not significantly increase burn risks in the cabin. The related materials are those included in this section and used as primers and top coats on metal surfaces.

- (a) Use Primers per MIL-P-23377 or organic primers to make the corrosion protection better. These materials, when applied to metallic surfaces, do not significantly increase the Flammability risk. Safran Cabin Inc. recommends you use these materials in areas that are not cosmetic or viewable when you assemble the component. These materials significantly make the corrosion inhibition better. For Primer Application Instructions, refer to paragraph 7.G.

F. Waste Disposal

NOTE: You must also obey the Applicable Local Regulations. Use the information below only as a general guide.

NOTE: You can use alternative primers for metal protection. Primers must not contain chromate for Class Divider Components. Refer to Table 6001 for Primers and Top Coats that agree with USDA and FDA requirements for Food storage components.

- (1) Disposal information for Alodine 600 and Alodine Toner 22 is given on MSDS Sheet for products. Treat and neutralize the unwanted material before you discard it to the sewer (examine the Local Regulations and Waste treatment Bulletin WT1004 from Parker-Amchem). Apply a primer on the surface for full protection. Primers, shown in Table 6001, are corrosion-resistant materials. For Primer Application Instructions, refer to paragraph 7.G.

G. Primer Application Instructions

GENERAL PRIMER INSTRUCTIONS:

NOTE: Refer to Table 6001 for the recommended materials. If you would like assistance with regards to applicable materials you can contact Safran Cabin Inc.

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- (1) FR (Fluid Resistant) epoxy primers and FR epoxy top coats are two-part catalyzing materials purchased as a kit. When you mix them, only use the catalyst indicated for use with the applicable base component.

- (a) Mix the base material correctly before you add the catalyst.
- (b) Slowly add catalyst while you mix the base component.

NOTE: Before you use the catalyzed primers, let a minimum of 15 minutes for their chemical reaction. For catalyzed top coats, let a minimum of 45 minutes. When kept in a closed container at ambient temperature, catalyzed materials have an useable pot life of 4 hours. You must mix the catalyzed materials all the time.

- (c) When you use a spray gun, first put the material through a filter. Do this to prevent clogging and contamination of the applied coatings.

- (2) Mixing and Thinning Ratios

- (a) Mixing

- 1 For the correct mixture ratios, make sure to mix the full contents of each part of the kit. To use the full contents of the kits, purchase applicable kits for specific applications and job requirements. To mix less than a full kit, add accordingly (by volume or weight the necessary proportion of each component) to a mixture container.

- (b) Thinning

- 1 FR (Fluid Resistant) primers and FR top coats are prepared to use them when catalyzed. If the thinning of the top coat is necessary, change the viscosity to vary from 18 to 21.5 seconds. Use a #2 Zahn cup with thinner for optimum application. Refer to Table 6001 for list of top coats and primers.

- (3) Requirements

NOTE: The chemical surface treatment must agree with the requirements specified on the applicable Finish Specification.

- (a) Dry Film Thickness

- 1 FR Primer

NOTE: The optimum thickness for FR Primer dry-film is 0.001 - 0.0013 in (0.00254 - 0.0033 cm). The permitted primer thickness on edges, ends, and recesses can vary from 0.0006 - 0.002 in (0.001524 - 0.00508 cm), if the fit or function of the part is not damaged.

- 2 FR Top Coat

NOTE: The optimum thickness for FR Top Coat dry-film is between 0.0012 - 0.0017 in (0.00305 - 0.004318 cm).

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(b) Coating Appearance

- 1 When a primer and top coat are specified, the system must be uniform, correct color, full hiding, and with no defects (cratering, pinholes, blisters, unwanted materials, scuffs, scratches, dry over-spray, runs, or sags). Small paint runs are permitted on hidden items and items to which it is not easy to apply a coat, but make sure that the fit and clearance are not changed.
- 2 Adhesion Test: After 16 hours, you can apply a tape test to the coating system. Use 3M #250 applied to the surface with 5 - 6 lb (2.27 - 2.72 kg) of pressure. Abruptly pull the tape and examine for removal. If removal of paint occurs, paint again as necessary.

(4) Primer Application Instructions

- (a) To clean the equipment, refer to the instructions in the Cleaning section of the affected CMM.
- (b) Use a pressure spray or siphon cup gun or equivalent (Table 6001) to apply a full-covering wet cross-coat. Full coverage is indicated by the color of primer and contrast with the aluminum.

NOTE: On surfaces, which have a primer, apply one light and uniform coat of FR Primer before you apply the top coat.

NOTE: For 502 Pressure Spray gun with #FX tip and needle #765 air cap (or equivalent), control the equipment to supply 6 - 9 psi (41.37 - 62.05 kPa) at the feed tank and 35 - 45 psi (241.32 - 310.26 kPa) at the gun. For 502 Siphon Cup gun with #FX tip and needle #765 air cap (or equivalent), control the air pressure to supply 35 - 45 psi (241.32 - 310.26 kPa) at the gun.

(c) Primer Dry Time:

	Dry Time
Dry the primer in the air to permit you to touch it. Dry the primer in the air to permit you to stack it.	30 minutes
Dry the primer in the air to permit you to remove grease with vapor.	16 hours
Dry the primer in the air to make it resistant to water (Do not put it into water).	48 hours
Dry the Plumbing Lines in the air to permit you to do a Pressure Test (Do not put them into water).	2 hours minimum
Make the primer cure faster to permit you to do a Pressure Test or remove grease with vapor.	Dry in the air for a minimum of 5 minutes and then bake at approximately 200°F (93°C) for a minimum of 15 minutes.
Dry the primer in the air to permit you to top coat it.	1 hour minimum to 3 hours maximum (see Note).

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	Dry Time
Make the primer cure faster to permit you to top coat it.	Dry in the air for a minimum of 5 minutes and then bake at approximate time/temperature.
Make the primer cure faster.	Dry in the air for a minimum of 5 minutes and then bake AT A MAXIMUM TEMPERATURE OF 225°F (107°C).

NOTE: The optimum time to dry the primer in the air to top coat is 1 to 3 hours. You can extend the dry time to a maximum of 24 hours, if you do not remove the parts/surfaces from the clean environment of a paint shop and you use contamination-free methods to handle them.

(d) Top Coat:

- 1 Use a spray gun or apply a full wet cross-coat. The time to dry in the air is 16 hours minimum. Dry the top coat in the air for a minimum of 10 minutes. Then bake it at a maximum temperature of 225°F (107°C).

H. Install the Fasteners Wet to Decrease the Corrosion Rate (Refer to Table 6001 for the recommended materials. If you would like assistance with regards to applicable materials you can contact Safran Cabin Inc.).

NOTE: You must install the fasteners wet to decrease the corrosion rate. To use Corrosion Inhibiting Compounds (CIC) or catalyzed primers, refer to the instructions given in this Repair section.

(1) Refer to the Cleaning section in the applicable CMM for surface preparation (cleaning).

(2) CIC Methods of Application

(a) Method A – Dip

- 1 Put the component into the CIC momentarily with one continuous movement for full coverage of the chosen area.
- 2 Let the unwanted compound to drain freely from the surface.
- 3 Use an absorbent cloth or brush to remove the drips and sags that do not flow or fall from bottom edges.

(b) Method B – Brush

- 1 Use a clean touch-up brush to apply the compound with a smooth, continuous movement. When you soak the brush again with the compound, apply the brush in overlap movements.
- 2 Apply the brush again to those regions where it is not easy for the compound to make a continuous layer. This includes notched details, unfileted inside corners, crevices, and undercut edges (between laminated or stack shims).

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(c) Method C – Spray

NOTE: Refer to manufacturer's instructions for equipment (where applicable).

- 1 The spray technique is equivalent to other sprayable materials. You will get a full and best coverage with a smooth, continuous sweep, slightly overlapping at the ends of each pass.
- 2 Apply the spray gun again to the regions where compound shows dry or light in coverage, and in specially not easy areas where blow-back often occurs. This includes notched details, unfilleted inside corners, crevices, etc.

(3) Installation of Fasteners and Application of Torque

- (a) The “wet” (with Corrosion-Inhibiting Compound) installation of fasteners must occur before the CIC “working time” is expired. For the assembly time, refer to Table 6003.
- (b) Complete the torque application in a minimum of 60 minutes (20 minutes or less for materials with work-lives shorter than one hour) or in an approved assembly time. Tighten all bolt and nut installations to maximum values, unless specified differently.

NOTE: Use the dry bolt torque, unless the bolt is self-lubricated as shown in the applicable part specification (wet CIC is not a lubricant).

- (c) When necessary, apply torque again to the nut/bolt combination with the maximum torque value. If you would like assistance you can contact Safran Cabin Inc. Complete the reapplication of torque before the assembly time expires. The ambient temperature and humidity can change the assembly time. Refer to Materials and Process for specific application of CIC. Do not use the power-torque control tools to apply the torque again.

NOTE: It is not necessary to remove the CIC from threaded assemblies, if you apply all the torque during the assembly time.

(4) General requirements for “wet” assembly with CIC

- (a) Use a spray gun, a brush, or put the threaded components into the CIC momentarily where applicable. If you would like assistance you can contact Safran Cabin Inc.

NOTE: It is better to apply the CIC with a brush on part details, such as: small diameter holes and / or radii and fillets.

- (b) To assemble all treated surfaces, refer to the preparation, application, and installation procedures in this document.

(c) Touch-Up:

- 1 If the coating shows to be deficient, touch up the component again with a localized treatment before assembly.

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- 2 Keep the touch-up to a minimum with a sufficient coverage to make sure for the CIC layer continuity.

NOTE: You can apply the materials shown in Table 6003. If you would like assistance with regards to applicable materials you can contact Safran Cabin Inc.

Properties of Corrosion-Inhibition Compound (CIC) Materials
Table 6003/TABLE 25-32-78-300-002-A01

Material	Material Type	Design Type	Dry Layer Thickness	Handling Time (Hrs)	Assembly Time (Min)
NYCOTE 7-11	CIC, Tack-free, Thin Film, Abr. Resistant	Dry Layer	0.013 in (0.033 cm) (one dip coat)	1	< 60
DINITROL AV 8	CIC, Tack-free, water displacing, medium term.	Dry Layer	0.008 in (0.02032 cm) (nominal)	< 1	< 60
DINITROL AV 15	CIC, Tack-free, water displacing, long term.	Dry Layer	0.015 - 0.025 in (0.0381 - 0.0635 cm)	~1	< 60
DINITROL AV 25	CIC, Soft, general purpose, long term.	Tacky Layer	0.025 in (0.0635 cm)	½ - 1	< 60
DINITROL AV 30	CIC, Tack-free, water displacing, long term.	Dry Layer	0.030 in (0.0762 cm) (nominal)	3	60-90
SOCOPAC 65H	CIC, Tack-free, water displacing, long term.	Dry Layer	0.015 in (0.0381 cm)	~1	< 60
COR-BAN 22	CIC, Soft, self healing, water displacing, long term.	Tacky Long	~0.020 in (0.0508 cm) 0.040 in (0.102 cm) - wet	~1	< 60
COR-BAN 33	CIC, Soft, self healing, water displacing, medium term.	Tacky Moderate	~0.020 in (0.0508 cm) 0.040 in (0.102 cm) - wet	~1	< 60
COR-BAN 35	CIC, Tack-free, water displacing, long term.	Dry Layer	~0.020 in (0.0508 cm) 0.040 in (0.102 cm) - wet	< 1	< 60

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Properties of Corrosion-Inhibition Compound (CIC) Materials
Table 6003/TABLE 25-32-78-300-002-A01 (continued)

Material	Material Type	Design Type	Dry Layer Thickness	Handling Time (Hrs)	Assembly Time (Min)
COR-BAN D-5023NS	CIC, Tack-free, water displacing, short term.	Dry Layer	~0.010 in (0,0254 cm) 0.025 in (0.0635 cm) - wet	< 1	< 60
COR-BAN D-5029NS	CIC, Tack-free, water displacing, medium term.	Dry Layer	~0.030 in (0,0762 cm) 0.076 in (0.193 cm) - wet	< 12	> 60

TASK 25-32-78-300-807-A01

8. Replace Trim/Extrusion

NOTE: Refer to Table 6001 for the recommended materials. If you would like assistance with regards to applicable materials you can contact Safran Cabin Inc.

WARNING: DO NOT USE THE FLAMMABLE HEAT PROCEDURE INSIDE OF AN AIRCRAFT OR IN AREAS WHERE FLAMMABLE MATERIALS ARE KEPT OR ARE PRESENT. FOR THIS PROCEDURE, EXCELLENT SKILL AND PRECAUTIONS ARE NECESSARY. ONLY APPROVED PERSONS MUST DO THIS TASK. DO NOT LET THE ALUMINUM TRIM TO GET TOO HOT. THE ADHESIVE WILL BECOME DEFECTIVE WHEN THE TEMPERATURE IS HIGHER THAN ~215°F (102°C) FOR WHATEVER LENGTH OF TIME.

CAUTION: YOU MUST POINT THE HEAT ON THE TRIM. THE HEAT GUN MUST MAKE A SWEEP ALONG 6 IN (15.24 CM) TO 10 IN (25.4 CM) SECTIONS OF THE TRIM. DO THIS UNTIL THE HEAT CHANGES THE TRIM TEMPERATURE. DO NOT PERMIT THE HEAT GUN TO HEAT THE SAME LOCATION ON THE TRIM FOR TOO LONG. THE TEMPERATURE CAN INCREASE DRAMATICALLY AND CAN CAUSE A CATASTROPHIC DAMAGE TO THE RELATED TEDLAR AND THE ADJACENT PANEL.

- A. Use a spatula or equivalent flat edge tool to loosen the trim. Put the tool against the side edge of the trim. Lightly tap on it from the opposite side of the trim.
- B. Use flammable heat to fully remove the trim. Use a heat gun to make a sweep along at 6 in (15.24 cm) to 10 in (25.4 cm) sections of the trim surface, one pass at a time.
- C. After the trim removal, use a clean, lint-free cloth soaked with MEK solvent to remove the remaining adhesive from the bonding surface.
- D. To bond the trim, refer to paragraph 2.

TASK 25-32-78-300-808-A01

9. Bond Stainless Steel Countertop to Galley Panels

NOTE: Refer to Table 6001 for the recommended materials. If you would like assistance with regards to applicable materials you can contact Safran Cabin Inc.

- A. Refer to Cleaning section of this CMM to remove any loose adhesive or compounds from the surfaces. Mask counterwalls and sections outside the bonding area to speed clean-up.

NOTE: It is not necessary or required to remove all traces of the original epoxy adhesive on either the panel or the countertop in order to restore. Use a scribe or similar tool to probe the epoxy filler and remove any loose pieces.

- B. Prepare Courtaulds PR 1776 or PS 890 according to the manufacturer's instructions. These materials can be purchased with either ½ hour or 2 hours application time.

- C. Mix Ratio is 10:100 (Part A : Part B).

NOTE: These adhesives were selected because they do not have chromate, they have extremely favorable peel on stainless steel and aluminum, and they improve corrosion resistance. Although the countertops seal the material away from food sources, it is advised that any alternative product be verified for chromate.

- D. Apply 0.01 - 0.005 in (0.0254 - 0.0127 cm) layer to panel surface. Apply a layer 0.01 - 0.005 in (0.0254 - 0.0127 cm) to the mating side of the stainless steel countertop.

- E. Push the countertop on the panel and push into position.

- F. After aligning the countertop and the galley, add weights to the top of the counter to help hold and seat the metal counter. The weight should be a minimum of 10 psi (68.95 kPa) of the counter space.

- G. Vacuum can be applied to give initial pressure to the countertop. Allow the pressure to be applied for a minimum of 8 hours. Vacuum pressure should be a minimum of 15 in (38.1 cm) of Mercury. After 8 hours of vacuum, remove vacuum source and allow the countertop 2 hours at room temperature to complete cure.

- H. Remove masking tape that was used before clean-up.

TASK 25-32-78-300-809-A01

10. Repair Fiberglass Composite Panel

NOTE: Refer to Table 6001 for the recommended materials. If you would like assistance with regards to applicable materials you can contact Safran Cabin Inc.

WARNING: DIRECT CONTACT WITH ISOPROPYL ALCOHOL CAN CAUSE IRRITATION IN EYES, NOSE, THROAT, AND SKIN. EXTENDED PERIODS OF CONTACT CAN CAUSE HEADACHES, DIZZINESS, AND NAUSEA. WEAR GLOVES, APRON, AND GOGGLES. USE THIS PRODUCT IN AN AREA WITH GOOD AIRFLOW. DO NOT BREATHE THE FUMES. DO NOT TAKE INTERNALLY. IF YOU DO NOT OBEY THIS WARNING, INJURY TO OR DEATH OF PERSONS CAN OCCUR.

FILLER COMPOUNDS ARE POISONOUS AND FLAMMABLE. WEAR PROTECTIVE APPAREL TO PREVENT EYES AND SKIN CONTACT. DO NOT BREATHE THE FUMES. KEEP THESE PRODUCTS AWAY FROM HEAT AND OPEN FLAME. USE THEM IN AN AREA WITH GOOD AIRFLOW. DO NOT TAKE INTERNALLY. FLUSH THE CONTAMINATION FROM YOUR EYES WITH WATER.

A. Classifications of Damage on Honeycomb Panels:

NOTE: If you would like assistance you can contact Safran Cabin Inc. to make sure which class is applicable to the Safran Cabin Inc. unit.

- (1) Class 1: Dents, surface scratches, scars, reinforcement delamination, or resin erosion. No damage to the glass or carbon fibers. Local compression of the honeycomb core on dents. The friction and vibration of two facings cause the Resin Erosion. One sign that shows the resin erosion is the quantity of resin "dust" on the surfaces. Scratches are cosmetic defects in the resin surface that do not cause damage to the underlying reinforcement. Refer to paragraph 10.B and see photos Class 1-1 and Class 1-2 in Figure 6004.
- (2) Class 2: Small Punctures or Glass Fracture. Puncture in one side of the glass facing. Refer to paragraph 10.C and see photos Class 2-1 and Class 2-2 in Figure 6004.
- (3) Class 3: Holes or damage that extend fully through the sandwich panel. These include the two facings and the core that are less than 16 in² (103.2256 cm²). Refer to paragraph 10.D.
- (4) Class 4: Extensive Damage, greater than 16 in² (103.2256 cm²). The replacement of the panel section or parts is necessary. **DO NOT REPAIR THIS KIND OF DAMAGE.**

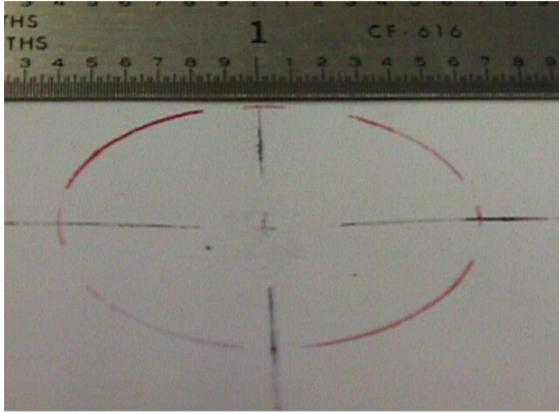


PHOTO CLASS 1-1 DENT

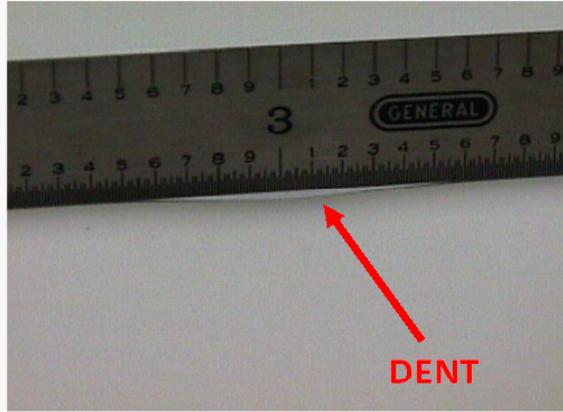


PHOTO CLASS 1-2 DENT



CLASS 2-1 FRACTURE OF GLASS FACING (ONE SIDE ONLY)

Damage in Honeycomb Panels
(Sheet 1 of 2)
Figure 6004/GRAPHIC 25-32-78-300-004-A01



CLASS 2-2

Damage in Honeycomb Panels
(Sheet 2 of 2)
Figure 6004/GRAPHIC 25-32-78-300-004-A01

25-32-78

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B. Criteria and Repair Procedures for Class 1:

(1) Imperfection: Surface Depressions; Dents, Scratches, Shallow Scars, Surface Abrasion, and Resin Erosion.

(a) Permitted Limits:

- 1 Decorative surface: Not permitted.
- 2 Non-Decorative Surface: The imperfection is permitted if it does not go into the material reinforcement.

(b) Correctable Limits:

- 1 Decorative surface: The imperfection must not go into the material fibers and the correction must not increase the panel weight by more than 2%.
- 2 Non-Decorative Surface: On imperfections that go into the material fibers, you cannot repair them by this procedure.

CAUTION: PANELS WITH MORE THAN THE MAXIMUM PERMITTED COMPRESSION STRESS (FOR A SPECIAL COMPONENT, OR SHARP CRASH, OR EQUIVALENT TRAUMA), TYPICALLY CAUSE CORE DAMAGE. THE SUBSEQUENT PROCEDURE INCREASES THE COMPRESSION STRESS OF A LOCAL AREA SIGNIFICANTLY BECAUSE OF THE WEIGHT INCREASE AND FLAMMABILITY PROBLEMS. THE REPAIR MUST NOT BE MORE THAN 16 IN² (103.2256 CM²) OF THE PANEL AREA.

(c) Repair Procedure for Dents, Scratches, and Resin Erosion:

NOTE: The 16 in² (103.2256 cm²) area for repair is the limit for an individual repair. The limit quantity of repairs per galley panel should be 3 and each individual repair should not extend in any length more than 4 in (10.16 cm) and if more than one repair is done it should be at least 12 in (30.48 cm) from any adjacent repair. If it is found that more repairs are required you should seek approval from local authorities.

- 1 Make the surface smooth with a 120-240 grit sandpaper.
- 2 Use MEK or Isopropyl Alcohol and a clean, dry shop wipe. Make the cloth moist with the solvent and rub it against the damaged area. After you use the moist cloth, apply a clean, dry shop wipe. Do not let the solvent dry on the part surfaces.

NOTE: A part will be clean if there is no indication of dirt, oil, or unwanted materials after you pass a clean, dry shop wipe on it.

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- 3 To mix Akemi #4 or Akemi #7, remove a 2 in (5.08 cm) diameter plug of filler and place it on the mixing card. Squeeze out a 1 in (2.54 cm) long ribbon of Part B on the mixing card. To mix the materials, fold Part B into Part A. The mixture must be homogeneous after you mix the materials. The material is exothermic, do not mix it for more than 1 minute.

NOTE: Furane (Huntsman) Araldite-252 epoxy paste, Akemi, and Adtech MicroFillers have equivalent mixture instructions. These products are two part materials. Part A is a light gray polyester resin. Part B is a small tube of catalyst.

- 4 Immediately apply the filler on the void/dent/scratch area. Overfill slightly the damaged area with the filler to permit its shrinkage.
- 5 Minimum cure time at 72°F (22°C) is 15 to 20 minutes, increase cure time if compound is spread thicker. After compound is cured, sand the surface.
- 6 If necessary, make the surface smooth with a 120-240 grit sandpaper.

NOTE: Non-cosmetic surfaces which only filling material is necessary: Fill the damaged area with the epoxy or polyester type materials shown here or use one part adhesives and sealers (RTV's). Apply these materials only to seal the panel from water absorption and for non-cosmetic repair.

CAUTION: DO NOT TRY TO INCREASE THE SPEED OF THE MATERIAL CURE WITH THE AID OF A LARGE QUANTITY OF CATALYST. MANY FILLERS AND ADHESIVES WILL CURE FASTER WHEN YOU ADD MORE CATALYST, BUT THIS WILL EMBRITTLE THE EPOXY RESINS.

(d) Repair Procedure for Erosion

NOTE: Vibration or fretting of two surfaces causes the erosion of the facing area. To correct the erosion areas, identify and repair them. A usual procedure to repair the erosion is to use an adhesive bridge between two components. This will prevent fretting of the surfaces. The adhesive operates as a liquid shim between the two parts and prevent clearance between them, but it increases the flammable materials. If this occurs, you must send a report to the Design Engineering and Flammability Certification for analysis before its implementation. If you increase the number of fasteners, you can also decrease the erosion or fretting, but adds substantial weight. These two procedures are out of the original design scope, and the Design Engineering and Flammability must make an analysis of them. Regardless, you must identify the source of the erosion or the problem will continue.

- 1 Clean the surface with Isopropyl Alcohol or other approved solvent to remove the contamination. Do not let the solvent dry on the panel. After you use the solvent, apply a clean, dry shop wipe to remove all contamination.
- 2 Apply Polyester or Mylar masking tape, if available, to the areas adjacent to the repair. This will prevent these surfaces from contamination by the repair procedure. It will also decrease the clean-up time.

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- 3 To remove other dirt or contamination, use a sanding pad with 320 grit or finer to make the surface lightly smooth. 3M Scotchbrite (very fine) is also permitted.
- 4 Use a Filled Epoxy adhesive such as J.D. Lincoln L-301 with milled glass or Cab-O-Sil Fumed Silica on a limited basis in field repairs. These Epoxy fillers exhibit higher smoke characteristics than Polyesters as well as higher OSU Heat Release. Use Epoxy Fillers in field repairs only. Apply them to a limit of no more than 100 in² (645.16 cm²) to each part. Remove the unwanted adhesive as shown in the subsequent step.
- 5 Use an edge tool such as a spatula or razor blade to remove the unwanted adhesive. Move the tool along the mylar tape. This will remove all unwanted filler higher than 0.002 in (0.00508 cm) thick (approximately the thickness of the tape).
- 6 It is frequently necessary to increase the speed of cure of a repair to permit you to put the component back into service on time. If necessary, make the filled area hot with a heat gun at 140°F - 160°F (60°C - 71°C) to decrease the set time.
- 7 After the cure of the filler, remove the masking tape.
- 8 Lightly sand and fair out the edges of the filler and its surrounding panel surface.
- 9 Refinish the repair if necessary. To paint the panel, refer to paragraph 13. To replace the Tedlar, refer to paragraph 14.C.

CAUTION: DO NOT TRY TO INCREASE THE SPEED OF THE MATERIAL CURE WITH THE AID OF A LARGE QUANTITY OF CATALYST. MANY FILLERS AND ADHESIVES WILL CURE FASTER WHEN YOU ADD MORE CATALYST, BUT THIS WILL EMBRITTLE THE EPOXY RESINS.

(e) Repair Procedure for Shallow Scars, Scratches, and Surface Abrasion:

- 1 Use Isopropyl Alcohol or other approved solvent to remove the contamination. Do not let the solvent dry on the panel. After you use the solvent, apply a clean, dry shop wipe to remove all contamination.
- 2 Apply Polyester or Mylar masking tape, if available, to the areas adjacent to the repair. This will prevent these surfaces from contamination by the repair procedure. It will also decrease the clean-up time.
- 3 To remove other dirt or contamination, use a sanding pad with 320 grit or finer to make the surface lightly smooth. 3M Scotchbrite (very fine) is also permitted.
- 4 Use Polyester Fillers such as Akemi #7 or Adtech MicroFiller #15-3 to fill small aberrations. Polyester Fillers do not contribute significantly to OSU Heat Release.

NOTE: You can use Epoxy Fillers and Adhesives such as 3M DP110 or DP190 or DP420 on a limited basis in field repairs. These Epoxy fillers exhibit higher smoke characteristics than Polyesters as well as higher OSU Heat Release. Use Epoxy Fillers in Field Repairs only. Apply them to a limit of no more than 16 in² (103.2256 cm²) to each part. Remove the unwanted adhesive as shown in the subsequent step.

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- 5 To remove the unwanted adhesive, use an edge tool such as a spatula or razor blade. Move the tool along the mylar tape. This will remove all unwanted filler higher than 0.002 in (0.00508 cm) thick (approximately the thickness of the tape).
- 6 It is frequently necessary to increase the speed of cure of a repair to permit you to put the component back into service on time. If necessary, make the filled area hot with a heat gun (at a temperature of 120°F (49°C) for Akemi or Adtech MicroFiller or at 140°F - 160°F (60°C - 71°C) for epoxy) to decrease the set time.

NOTE: You can add Polyester systems like Adtech MicroFiller #15-3 or Akemi #4 or #7 catalyst at various ratios. Add a 2 in (5.08 cm) wide length from the catalyst tube to a "golf ball size" portion of part A. Refer to the instructions printed on the can. The actual ratio is 100 Parts of A to 2 parts of B.
- 7 After the cure of the filler, remove the masking tape.
- 8 Lightly sand and fair out the edges of the filler and its surrounding panel surface.
- 9 Refinish the repair if necessary. To paint the panel, refer to paragraph 13. To replace the Tedlar, refer to paragraph 14.C.

(2) Imperfection: Delamination of Face Ply on Honeycomb Panels

(a) Permitted Limits:

- 1 Decorative surface: Not permitted.
- 2 Non-Decorative Surface: Not permitted.

(b) Correctable Limits:

- 1 Decorative or Non-Decorative Surface: Corner delamination less than 2 in (5.08 cm). Edge delamination of 3 in (7.62 cm) or less in length and 1 in (2.54 cm) in width.

(c) Repair Procedures with a Structural Laminating-Resin:

- 1 To repair local delamination, use a structural adhesive L-301 A/B or laminating resin to bond the panel surface to the honeycomb.
- 2 Apply a masking tape to the area around the delamination.
- 3 At a minimum, drill two holes into the delaminated area. These holes must be at the opposite side of the delaminated area. Use the Table 6001 for the selection of the materials. Obey the instructions for that specific type of material or equivalent material requirements.
- 4 Mix the adhesive and fill the void from the bottom. You must fill the local cells with adhesive. Fill the hole with sufficient adhesive to bond the panel surface to the core.
- 5 While you fill the delamination, move the applicator around to make sure that the surface ply is wet-out.

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- 6 Use a clean, shop wipe moist with Isopropyl alcohol or MEK or Acetone to remove the unwanted adhesive from the surface.
- 7 If possible, put a flat plate on the delamination. Apply a Mylar or flash-breaker tape to the surface of the plate to hold it.
- 8 Attach the plate in position with clamps and use sufficient pressure to push the ply down on the composite surface. Hold it until the adhesive cures.
- 9 Remove the plate. Sand the remaining adhesive from the composite surface.

(d) Repair Procedure with a Laminating Resin:

- 1 Use one of these laminating resins: Epocast 50A with 976 (100:15) or Epocast 50A with 9339 (100:15) or Shell 828 with Epikure 3233 (100:10):
 - EPON 828 Resin with mfg. Catalyst (Epikure DETA 3223 or Equivalent) or (Epikure TETA 3234 or Equivalent)
 - Epocast 50A1 with 9816 Catalyst or Epocast 50A1 with 946 Catalyst
 - Loctite (Dexter Hysol) ® EA 956 A/B
- 2 Mix sufficient resin to make the necessary repair. Weigh the material in the specified ratio and mix them fully.
- 3 Use an acid brush or nylon brush to apply the resin to the delamination and to the core. Make sure that the ply is wet-out on the mating surface.
- 4 Use a teflon or nylon squeegee or a latex gloved finger to push the ply into position.
- 5 Remove the unwanted resin with a dry, shop wipe or rag.
- 6 Let the resin cure for 6 hours. To increase the speed of the cure, dry the resin in the air until it is tack-free. Then increase the temperature to 120°F (49°C) with an infrared lamp or oven for 5-30 minutes. Increase the temperature to approximately 150°F (66°C) for 2 hours.

NOTE: When you use a two-step cure, this prevents resin from bubbling or frothing.

(e) Repair Procedure with Adhesive Potting Compound:

- 1 Use 2-part adhesives. These adhesives offer higher strength, but also increase the weight. Use one of these adhesives: L-301 or L-318 or equivalent.
- 2 For L-301 Type 4.11, mix (100:50) sufficient adhesive to apply to the damaged area. Use a brush or spatula to add sufficient adhesive to the related parts. Use clamps to attach the parts together for good contact if necessary. Let 2-3 hours for green-strength cure. Then increase the temperature to 150°F (66°C) for 2 hours for high strength cure.

C. Criteria and Repair Procedures for Class 2:

(1) Imperfection: Punctures, Core to skin Separation, and Damaged Honeycomb Core

(a) Permitted Limits:

- 1 Decorative surface: Not permitted.
- 2 Non-Decorative Surface: Not permitted.

(b) Correctable Limits:

- 1 Decorative Surface: For Punctures, correct 0.1875 in (0.4762 cm) or less in diameter. Correct no more than 1% of the total panel area. The correction must not increase the panel weight by more than 2%. For Core to Skin Separation, you can correct up to 10% of panel edge. For Damaged Honeycomb Core, the repair is not permitted.
- 2 Non-Decorative Surface: For Punctures, correct 0.1875 in (0.4762 cm) or less in diameter. The correction must not increase the panel weight by more than 2%. For Core to Skin Separation, see Decorative Surface procedure. For Damaged Honeycomb Core, no limit, but the correction must not increase the panel weight by more than 2%.

(2) Repair Procedures:

NOTE: The 16 in² (103.2256 cm²) area for repair is the limit for an individual repair. The limit quantity of repairs per galley panel should be 3 and each individual repair should not extend in any length more than 4 in (10.16 cm) and if more than one repair is done it should be at least 12 in (30.48 cm) from any adjacent repair. If it is found that more repairs are required you should seek approval from local authorities.

NOTE: The subsequent procedures apply for damage that extend through Facing Material, with collateral damage to the core. When you repair non-structural decorative panels, refer to these procedures, if the damage agrees with the flammability requirements.

NOTE: Advantages: It is not necessary to remove the damaged core. The local compression is significantly higher because of the solid filler. The local peel strength is dramatically improved because of the strength of the adhesive.

NOTE: Disadvantages: Weight Increase. More "fuel for fire" increases OSU potential. The repair is limited in size because of the weight and flammability problems. The damage cannot be greater than 16 in² (103.2256 cm²).

CAUTION: PANELS WITH MORE THAN THE MAXIMUM PERMITTED COMPRESSION-STRESS (FOR A SPECIAL COMPONENT, OR SHARP CRASH, OR EQUIVALENT TRAUMA), TYPICALLY CAUSE CORE DAMAGE. THE SUBSEQUENT PROCEDURE INCREASES THE COMPRESSION STRESS OF A LOCAL AREA SIGNIFICANTLY BECAUSE OF THE WEIGHT INCREASE AND FLAMMABILITY PROBLEMS. THE REPAIR MUST NOT BE MORE THAN 16 IN² (103.2256 CM²) OF THE PANEL AREA.

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CAUTION: DO NOT TRY TO INCREASE THE SPEED OF THE MATERIAL CURE WITH A LARGE QUANTITY OF CATALYST. MANY FILLERS AND ADHESIVES WILL CURE FASTER WHEN YOU ADD MORE CATALYST, BUT THIS WILL EMBRITTLE THE EPOXY RESINS.

SANDING OPERATIONS CAUSE SMALL GRANULAR PARTICLES INTO BREATHING SPACE. GLASS AND CARBON PARTICLES, WHEN BREATHED, CAN CAUSE CUMULATIVE DAMAGE TO LUNGS AND RESPIRATORY SYSTEMS. THE GLASS AND PHENOLIC PARTICLES ARE A SOURCE OF DERMATITIS. WEAR AN APPLICABLE BREATHING PROTECTION SUCH AS DUST FILTER MASK. USE NECESSARY PRECAUTIONS DURING ALL OPERATIONS.

(a) Potting Compound or Solid Plug Repair

- 1 Clean the surface with Isopropyl Alcohol or other approved solvent to remove the contamination. Do not let the solvent dry on the panel. After you use the solvent, apply a clean, dry shop wipe to remove all contamination.
- 2 Apply Polyester or Mylar masking tape, if available, to the areas adjacent to the repair. This will prevent these surfaces from contamination by the repair procedure. It will also decrease the clean-up time.
- 3 To remove other dirt or contamination, use a sanding pad with 320 grit or finer to make the surface lightly smooth. 3M Scotchbrite (very fine) is also permitted.
- 4 You can use Potting Compounds such as L-318 from J.D. Lincoln or Epibond 1559-1 A/B from Huntsman to fill small aberrations.
- 5 To enhance the strength, undercut the core below the upper panel surface and fill it totally. This will increase the overall strength. See Figure 6005. Make sure that the undercut is 0.125 in (0.3175 cm) of the cell width.
- 6 To remove the unwanted adhesive, use an edge tool such as a spatula or razor blade. Move the tool along the Mylar tape to remove the unwanted filler higher than 0.002 in (0.00508 cm) thick (approximately the thickness of the tape).
- 7 Do not use heat to make the cure faster.
- 8 After the cure of the filler, remove the masking tape.
- 9 Lightly sand and fair out the edges of the filler and its surrounding panel surface.
- 10 Refinish the repair if necessary. To paint the panel, refer to paragraph 13. To replace the Tedlar, refer to paragraph 14.C.

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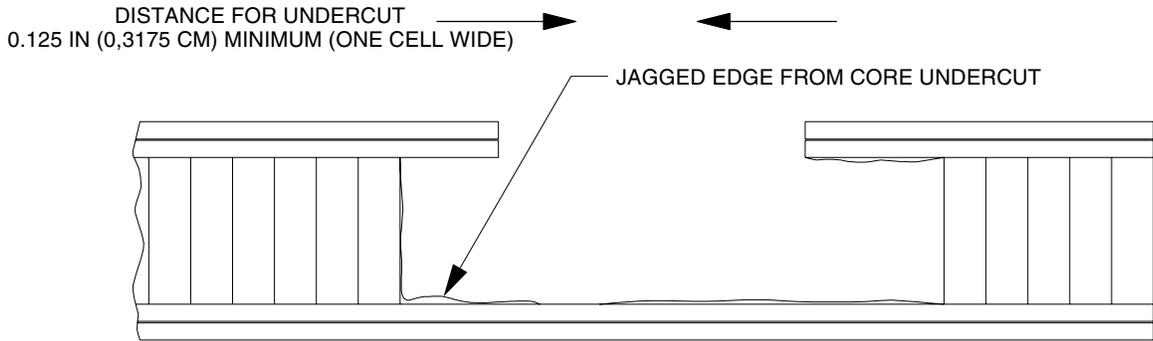
(b) Scarf Repair Procedure (Figure 6006)

NOTE: Advantages: It is necessary to remove and replace the damaged core, but this prevents the weight increase. The local compression is the same as the parent panel. The local core-peel strength is slightly better because of the strength of the adhesive. The replacement of the facing increases the total durability.

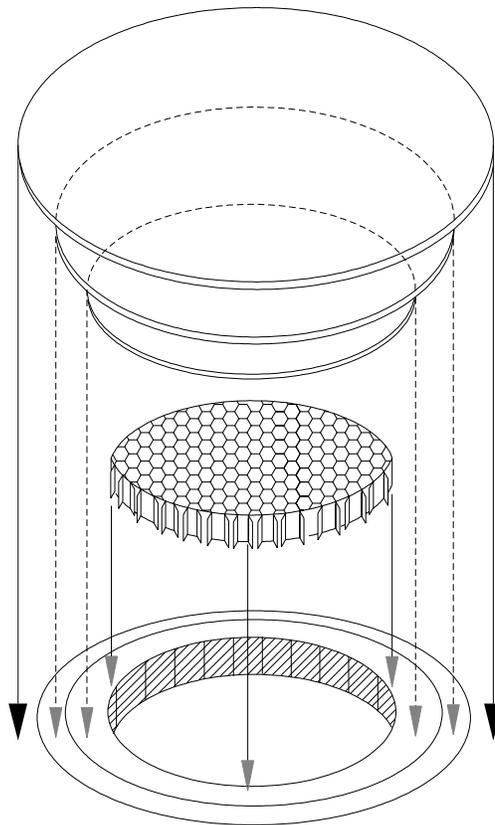
NOTE: Disadvantages: Higher skill is necessary to remove and replace the core. Time for the repair is longer. Wet lay-up or adhesive lay-up is messy.

- 1 Clean the surface with Isopropyl Alcohol or other approved solvent to remove the contamination. Do not let the solvent dry on the panel. After you use the solvent, apply a clean, dry shop wipe to remove all contamination.
- 2 Apply Polyester or Mylar masking tape, if available, to the areas adjacent to the repair. This will prevent these surfaces from contamination by the repair procedure. It will also decrease the clean-up time.
- 3 Trim the damaged area out to an oval or round shape. Rectangular or Square shapes with rounded corners is permitted.
- 4 Grind the panel surface at an angle or taper shape. The width of the scarf must be at a minimum of 100 times the facing thickness (example: 2 ply of 7781 is 0.02 in (0.0508 cm) thick, the taper must be 0.02 in (0.0508 cm) wide).
- 5 Use a vacuum or compressed air to remove all loose unwanted material and particles from the work area.
- 6 Cut a section of core equal to the size of the repair area.
- 7 Put the core into the panel to make it flush with the opposite facing.
- 8 Use Potting Compound to bond the core in position.
- 9 Replace the Upper Facing with the Wet lay-up.
- 10 To fair out the surface, refer to paragraph 12.
- 11 After the cure of the filler, remove the masking tape.
- 12 Lightly sand to make the edges of the filler and its surrounding panel surface smooth.
- 13 Refinish the repair if necessary.

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Potting Compound or Solid Repair
Figure 6005/GRAPHIC 25-32-78-300-005-A01



Scarf Repair Procedure
Figure 6006/GRAPHIC 25-32-78-300-006-A01

D. Criteria and Repair Procedure for Class 3:

(1) Imperfection: Damaged Honeycomb Core

(a) Permitted Limits:

- 1 Decorative surface: Not permitted.
- 2 Non-Decorative Surface: Not permitted.

(b) Correctable Limits:

- 1 Decorative surface: Not permitted.
- 2 Non-Decorative Surface: No limit, but the correction must not increase the panel weight by more than 2%.

(2) Repair Procedure:

NOTE: For damage that extends fully through the sandwich panel, you can repair it by two procedures: Scarf-joint procedure which is equivalent to the Class-2 Procedure and Step-Joint Class-3 Procedure.

CAUTION: SANDING OPERATIONS CAUSE SMALL GRANULAR PARTICLES INTO BREATHING SPACE. GLASS AND CARBON PARTICLES, WHEN BREATHED, CAN CAUSE CUMULATIVE DAMAGE TO LUNGS AND RESPIRATORY SYSTEMS. GLASS AND PHENOLIC PARTICLES ARE A SOURCE OF DERMATITIS. WEAR AN APPLICABLE BREATHING PROTECTION SUCH AS A DUST FILTER MASK. USE NECESSARY PRECAUTIONS DURING ALL OPERATIONS.

(a) Tapered Scarf-Joint Procedure (Figure 6007)

NOTE: Advantages: It is necessary to remove and replace the damaged core, but this prevents the weight increase. The local compression is the same as the parent panel. The local core-peel strength is slightly better because of the strength of the adhesive. The replacement of the facing increases the total durability. For solid laminates, follow the lay-up procedure.

NOTE: Disadvantages: Higher skill is necessary to remove and replace the core. Time for the repair is longer. Wet lay-up or adhesive lay-up is messy.

- 1 Clean the two surfaces with Isopropyl Alcohol or other approved solvent to remove the contamination. Do not let the solvent dry on the panel. After you use the solvent, apply a clean, dry shop wipe to remove all contamination.
- 2 Apply Polyester or Mylar masking Tape, if available, to the areas adjacent to the repair. This will prevent these surfaces from contamination by the repair procedure. It will also decrease the clean-up time.
- 3 Trim the damaged area out to an oval or round shape. Rectangular or Square shapes with rounded corners is permitted.

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- 4 Grind the panel surface at an angle or taper shape on one or on the two sides as practical. The width of the scarf joint must be at a minimum of 100 times the facing thickness (example: 2 ply of 7781 is 0.02 in (0.0508 cm) thick, the taper must be 0.02 in (0.0508 cm) wide).
- 5 Use a vacuum or compressed air to remove all loose unwanted material and particles from the work area.
- 6 Cut a section of core equal to the size of the repair area. Put a temporary shim or block on one side of the panel to hold the core and first facing repair. Make a shim that is flush against the panel. The shim must have a step on the inside because of the missing skin plies on that side. Cover the shim with teflon tape or equivalent release material. Use teflon tape to attach the shim to the panel.
- 7 Replace the upper facing with the wet lay-up. Let the repair cure.
- 8 Remove the shim from the second facing. Examine the core and make sure that it is correctly bonded in position by the wet lay-up. Add more potting compound, if necessary.
- 9 To fair out the decorative surfaces, refer to paragraph 12.
- 10 After the cure of the filler, remove the masking tape.
- 11 Lightly scarf to make the edges of the filler and its surrounding panel surface smooth.
- 12 Refinish the repair if necessary.

(b) Step-Joint Procedure:

NOTE: Advantages: It is necessary to remove and replace the damaged core, but this prevents the weight increase. The local compression is the same as the parent panel. The local core-peel strength is slightly better because of the strength of the adhesive. The replacement of the facing increases the total durability.

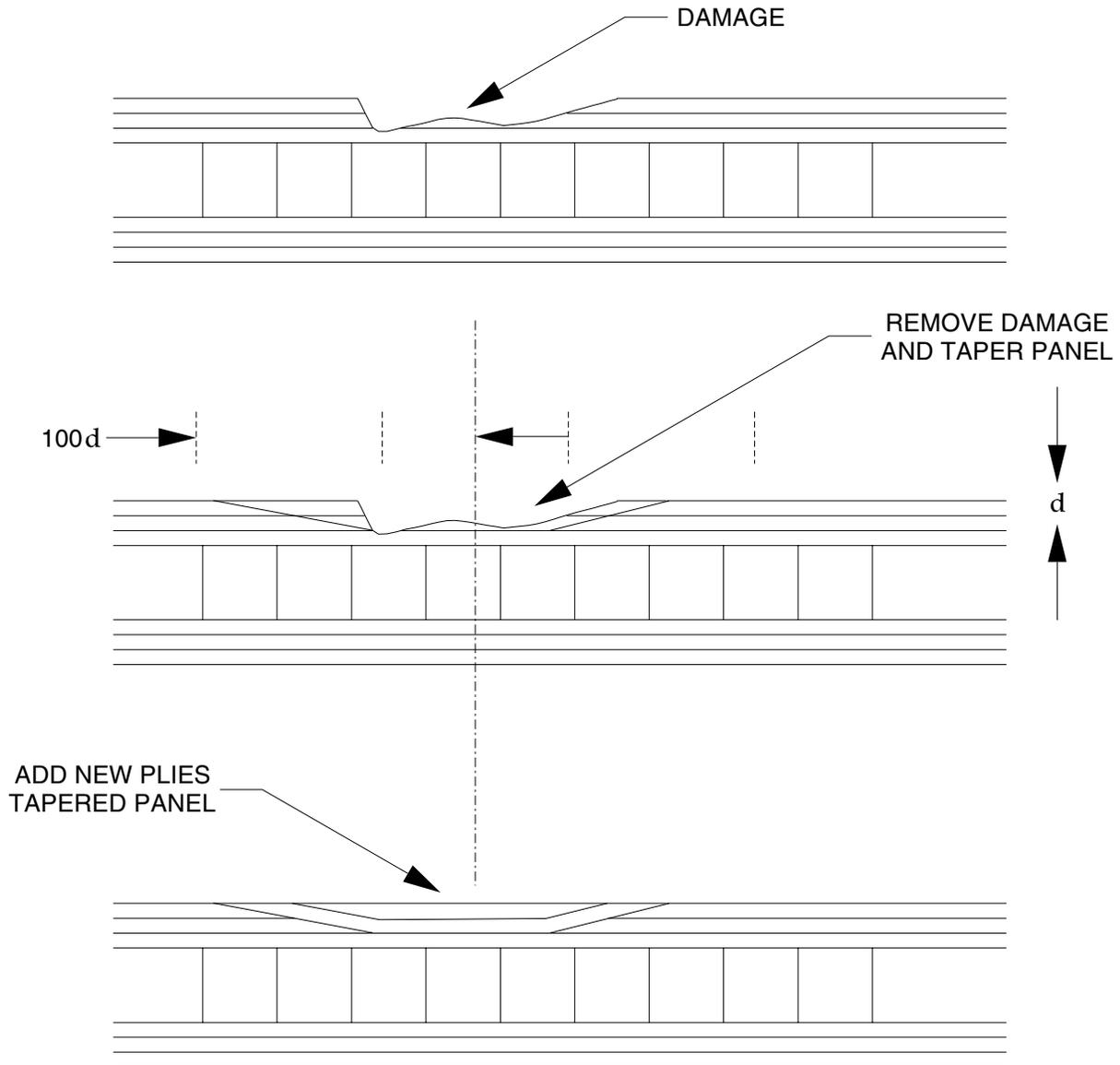
NOTE: Disadvantages: Higher skill is necessary to remove and replace the core. Time for the repair is longer, as set time for repair. Wet lay-up or adhesive lay-up is messy.

- 1 Clean the two surfaces with Isopropyl Alcohol or other approved solvent to remove the contamination. Do not let the solvent dry on the panel. After you use the solvent, apply a clean, dry shop wipe to remove all contamination.
- 2 Find the thickness of each facing and the plies used (P = plies per facing).
- 3 Multiply $(P-1) \times 1.5$. Use a divider, compass, or rule to make a mark on the panel away from the damage by the result. Be sure to use this minimum distance. Use the same dimensions to make the pattern (oval or rectangular with rounded corners).
- 4 Apply Polyester or Mylar masking Tape, if available, to the areas adjacent to the repair. This will prevent these surfaces from contamination by the repair procedure. It will also decrease the clean-up time.

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- 5 Use a sharp knife or razor to cut the outer ply of the scribe line. Carefully remove the trimmed ply section.
- 6 Do the procedure again for three (3) or more plies. Measure 1.5 in (3.81 cm) from this step and trim the ply that you laid before. The number of steps is equal to the number of plies minus 1 (3 Plies = 2 steps etc.).
- 7 For a 2-ply panel, cut a section of core equal to the size of the repair area. The core must install snugly in position.
- 8 Put a temporary shim or block on one side of the panel to hold the core and first facing repair. Make a shim that is flush with the panel. The shim must have a step on the inside to align with the missing skin plies on that side. Cover the shim with teflon tape or equivalent release material. Use Teflon tape to attach the shim to the panel.
- 9 Bond the core in position with wet lay-up resin or adhesive.
- 10 Replace the upper facing with the Wet lay-up. The dimension of each skin ply must align correctly into each step. Each skin ply must touch the composite material or keep a very small clearance. Do not increase the skin ply thickness too much. The last ply on the top of the repair must extend 0.5 in (1.27 cm) far from the ply below it. Let the repair cure.
- 11 Remove the shim from the second facing. Examine the core and make sure that it is correctly bonded in position by the wet lay-up. Add more potting compound, if necessary.



Taper Scarf Repair
Figure 6007/GRAPHIC 25-32-78-300-007-A01

TASK 25-32-78-300-810-A01

11. Fill Edge Holes in Honeycomb Panels

NOTE: Refer to Table 6001 for the recommended materials. If you would like assistance with regards to applicable materials you can contact Safran Cabin Inc.

NOTE: Use this procedure to fill the holes that you can see in the edges of each panel after the final assembly.

WARNING: THIS PROCEDURE APPLIES TO HAZARDOUS MATERIALS. FOLLOW THE SHOP SAFETY PRACTICES CAREFULLY TO PREVENT INJURY.

CAUTION: BE CAREFUL WHEN YOU USE BATCHES THAT ARE OVER THAN 500 TOTAL WEIGHT. WHEN YOU MIX TOO MUCH OF LARGE BATCHES, THE BATCHES CAN BECOME EXOTHERMIC (VERY HOT). YOU MUST USE THE STANDARD BATCH MIX SIZES.

- A. Remove all unwanted material and particles from the hole with a vacuum or dry compressed air. It is important to remove all unwanted material and loosened cell walls. Do this to make sure that the sealant will contact the core material.
- B. Use clean, lint-free cloths and MEK solvent to remove all oily dirt and unwanted materials. Let the solvent dry from the honeycomb panel at least 15 minutes at room temperature.
- C. Mix the two-part FR-8136W sealant in the mixture ratio of 100 parts by weight of Part A to 50 parts by weight of Part B. Mix no more than you can use during the pot life of the compound (45 minutes at 75°F (24°C)). Mix the two components fully but do not let too much air into the mixture.

NOTE: Always follow the instructions given by the manufacturer. It is possible that the mixture ratio can change after the publication of this manual.

- D. Fill the hole in the panel with sealant.
- E. Let the sealant cure for 12 hours at 70°F - 90°F (21°C - 32°C), or 3 hours at 120°F - 130°F (49°C - 54.4°C).
- F. Use a file or sand the sealant to make it smooth.

TASK 25-32-78-300-811-A01

12. Fill and Fair out Procedure for Panel

NOTE: Refer to Table 6001 for the recommended materials. If you would like assistance with regards to applicable materials you can contact Safran Cabin Inc.

A. Surface Preparation

- (1) Use clean cloths soaked with Isopropyl Alcohol, MEK, or other permitted solvent to remove the loose dust or dirt from the panel. Remove all grease, release agent, or other contamination type from the surface. Do this before you sand the panel surface. This step prevents contamination into the surface caused by the pressure and abrasion of the sanding operation.
- (2) Be sure that the panel surface is clean and free of dirt or grime. For this, rub the panel surface with a clean, dry shop wipe. The panel is clean if there is no indication of unwanted materials on the shop wipe.

CAUTION: DO NOT SAND THE PART AGGRESSIVELY OR TOO MUCH. SCUFF THE SURFACE RESIN ONLY. DO NOT MAKE THE REINFORCEMENT MATERIAL (GLASS, KEVLAR, OR GRAPHITE) ROUGH.

- (3) Lightly sand the surface with a 100-400 grit sandpaper to break the surface gloss and to remove release agents or other contamination. Sand all the surface with equal movements.
- (4) Do Steps (1) and (2) again until you see no dirt on a new shop wipe. The panel is now prepared for fairing and filling.

B. Fill and Fair out Procedure

(1) Necessary Materials:

(a) Type 1 Compounds

1 Akemi No. 4

The application of Akemi 4 to fill and fair has no limitation in terms of surface area being covered providing it is applied as a pore filler which requires that the amount of filler applied per square foot does not exceed 0.009 lb (4 g). A general rule of the thumb would be after the filler is applied and sanded the panel shall be visible except for a few dots of white. If more filler is required refer to the Scratch and dent repair paragraph 10.B.(1).(c) and use the limitations specified in that repair.

- 2 Akemi No. 4 is a two component system. Part A is a can of gray putty like paste. Part B is a small tube of hardener the material is white in color and approximately the same consistency as toothpaste. These mixing instructions are for small quantities of material. Should larger batches be called for, scale-up the mix accordingly.

A 2-½ inches diameter slug of Akemi No. 4 should be placed on a clean mixing tray, container, or a cardboard palette (with release paper). Place a 1 in (2.54 cm) length of Part B straight from the tube onto the palette. Thoroughly fold the hardener into the “Bondo”. A large flat spatula or putty knife will expedite the mixing process. Use the blade to “swipe a path” through the putty and lift that section and fold into the

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remaining filler on the palette, continue the process until all the Bondo is a uniform color and consistency.

The filler can be thinned with Acetone. Use a mixture of 2 oz (59.15 ml) of acetone with the above combination of material. More or less acetone can be added, depending on the desired consistency. Thinning is desired to fill surface porosity. The thinned mixture will “level” in the pores, thus reducing the time sanding the part. Dry the component in an oven for 30 minutes at 120°F (49°C) if the Akemi is cut with acetone prior to additional work.

(b) Type 2 Compounds Field Repair Fillers

- 1 The DP110 is a two-part epoxy adhesive. Use it only on field and non-structural repairs of lofted geometry less than 2 in² (12.9032 cm²) of the part total area. The DP110 and DP190 come in a two part tube. A baffled mixing-chamber tip is necessary.
- 2 Epibond 1568 A/B is a self-extinguishing adhesive/filler and you can use it for localized field repair. Use it only on field and non-structural repairs of lofted geometry less than 2 in² (12.9032 cm²) of the part total area. The material comes in Accumix cartridges with the two components in side by side cylinders. A dispenser “gun” is used with a baffled tube to mix the materials.

(2) Application of Fairing Compound:

- (a) Apply a masking tape to the areas of the panel, as applicable.
- (b) Apply the fairing compound to the structure with a spatula. Spread it as thin as possible along the surface. Use a plastic spreader, a putty knife, or an equivalent tool to apply the Filler. For thin, uniform and level application, hold the spreader at 90° to the panel surface or at a slight angle to it. Too much compound application only increases the period of time necessary to sand the part.
- (c) Before sanding, let the fairing compound set in a sufficient time (15 to 20 minutes minimum). Increase the cure time if compound is spread thicker.
- (d) Examine the fairing compound visually to be sure of its correct cure. After this, apply light pressure with a fingernail on the surface. The cure of the filler will be satisfactory when you cannot make a mark on it with your nail.

(3) Sand and Contour the Filler:

CAUTION: REMOVE ONLY GRAY/WHITE FILLER. DO NOT GRIND INTO THE REINFORCEMENT LAYERS OF THE PANEL.

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- (a) After you apply the filler and let it dry thoroughly, remove the unwanted material with a 200-400 grit sandpaper. Sand the filler with light equal movements, by hand or jitterbug sander.

NOTE: You can repair the loft or radius on a part with filler compound, but do not apply the compound too thickly. Only repair the corner or radius if you can see the fabric in the corner. A part that is correctly laid-up or pressed will always have some fabric in the corners, but the resin fill can not be sufficient. Do inspections on the part during all the processing. Only fill or sweep a part that was examined before.

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13. Paint and Prime the Composite Panels

A. Filler Application

- (1) Use a Digital Scale to Mix the Filler

(a) Materials:

- 1 Mankiewicz #343-55 Filler 15 parts
- 2 Mankiewicz #345-15 Hardener 1 Part
- 3 5-15% Water as a dilution (5% is best to prevent “running” of the paint)

NOTE: For HSH (VB4946) and WLS (V0YY71) Paints, if you would like assistance you can contact Safran Cabin Inc.

- (2) Requirements for Filler Spraying Applicator

(a) Materials:

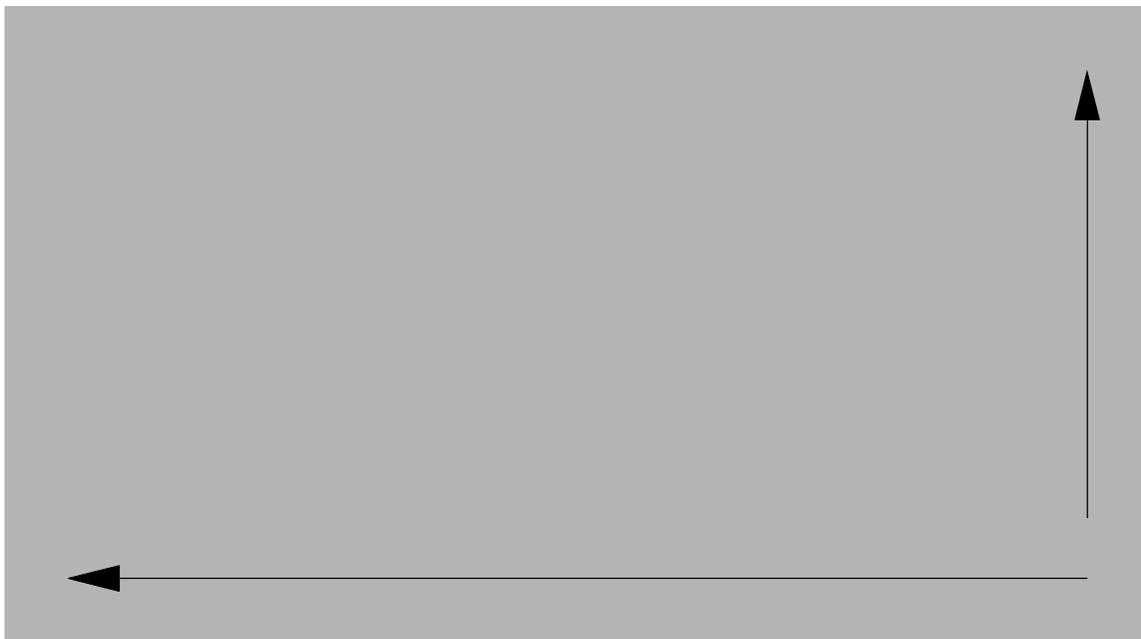
- 1 SATA JET NR95 Gravity Spray Gun
- 2 Gravity feed cap gun with a 1.5 size head
- 3 Gun pressure at 50.75 psi (349.92 kPa)
- 4 Hose outlet pressure at 95 psi (655.03 kPa)

(b) Procedure:

- 1 First clean the panels with (Greider Company) G99-S23 white tack cloth to remove all dust particles.
- 2 Apply the filler with a spray gun in a criss-cross pattern, approximately 12 in (30.48 cm) away from the panel.

NOTE: Criss-Cross pattern means one pass along the length of panel and one pass along the width. See Figure 6008.

- 3 Let the panel dry for 24 hours or until hard. To increase the speed of the cure, dry the panel in an oven at 130°F (54.4°C).



Criss-Cross Pattern
Figure 6008/GRAPHIC 25-32-78-300-008-A01

B. Top (Fog) Coat Application

(1) Panel Preparation

- (a) Do an inspection on the filler painted panels for “runs” or dust particles. Then sand lightly as necessary to remove dust particles. Examine the edges for holes or porosity. Fill them with filler paint materials for small porosity, or with Akemi filler “Bondo” for larger holes.

(2) Top (Fog) Coat Mixing

(a) Materials:

- 1 Mankiewicz #346-65 Top Coat 6 Parts
- 2 Mankiewicz #345-65 Hardener 1 Part
- 3 Water as a dilution
- 4 A \pm 0.0045 lb (2 g) of top coat or hardener is permitted

NOTE: After you mix the paint, the paint solution has approximately four (4) hours of workable time under normal environmental conditions.

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(3) Top (Fog) Coat Application

(a) Applicator requirements are as follows:

- 1 Gravity feed cap gun with a 1.5 size head
- 2 Gun pressure at 50.75 psi (349.92 kPa)
- 3 Hose outlet pressure at 95 psi (655.03 kPa)

(b) Apply top (fog) coat in one criss-cross pattern as shown in Figure 6008. Then let it dry for approximately 20 to 30 minutes or until glossy finish of the painted panel becomes dull.

NOTE: To increase the speed of the drying time, apply ventilation to panels to release the water particles.

C. Texture Coat Application

(1) Texture Coat Mixing

(a) Materials:

- 1 Mankiewicz #346-65 Top Coat 6 Parts
- 2 Mankiewicz #345-65 Hardener 1 Part
- 3 Water as a dilution

(b) Mix the Texture Coat by weight with a Digital Scale as follows:

- 1 A ± 0.0045 lb (2 g) of top coat or hardener is permitted

NOTE: After you mix the paint, the paint solution has approximately four (4) hours of workable time under normal environmental conditions.

(c) Applicator requirements are as follows:

- 1 Gravity feed cap gun with a 1.5 size head
- 2 Gun pressure at 2 psi (13.79 kPa) with H.V.L.P. gun (Non-H.V.L.P. at 20 psi (137.9 kPa))
- 3 Hose outlet pressure at 95 psi (655.03 kPa)

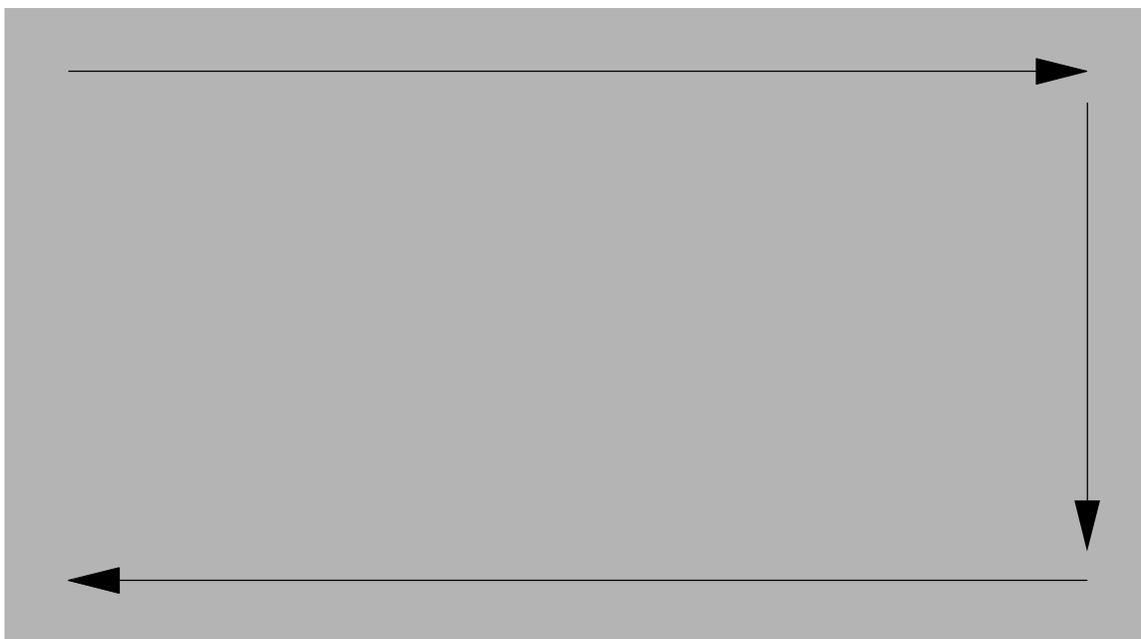
(2) Application

(a) Apply one criss-cross pattern and one criss coat or 1-1/2 coats to get the texture pattern as shown in Figure 6009.

(b) Turn down the gun pressure.

(c) Apply a texture coat test on a sample piece for texture effect.

(d) Let dry for 24 hours or until hard. To increase the speed of the drying time, use an oven.



1- ½+ Criss-Cross Pattern
Figure 6009/GRAPHIC 25-32-78-300-009-A01

D. Damage Repair

- (1) For all types of damage, sand down the panel to filler coat. For damages with pits or holes, fill with Akemi “bondo” and sand the panel to make it smooth.
- (2) For Top (Fog) Coat Application and Texture Coat Application, refer to paragraphs 13.B. and 13.C.
- (3) To blend newly painted surface with surrounding area, let the paint dry. Rub it with glass cleaner to remove slightly the sandy surface finish.

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14. Repair Tedlar

NOTE: The following information is a summary of Materials and Processes that are available in other Safran Cabin Inc. internal specifications, and that information is copied from those Specifications (CDP002-07-05) for materials and processes used in this program. Information contained in this document is the same as the information in the CDP002-07-05.

NOTE: Refer to Table 6001 for the recommended materials. If you would like assistance with regards to applicable materials you can contact Safran Cabin Inc.

NOTE: Repairs are limited to 16 in² (103.2256 cm²) or less of the component surface area, when more adhesive or paint is necessary.

NOTE: To purchase Perforating Rollers “porcupines”, refer to Aircraft Supply Companies or tool manufacturers.

NOTE: It is necessary to put a protective shim or cover on top the Tedlar before you use a perforating roller. This step will not cause holes that are too deep or pores that are too large. If the holes are too large or near each other, too many holes will be visible and the result is not correct. Make sure that the holes are shallow and sufficiently far from each other. Do as many trials as necessary with shims and covers that have different thickness and density.

A. Rework Procedure to Remove Bubbles or Small Voids

NOTE: This procedure does not add more adhesive or change the pre-existing materials. Use this procedure when necessary. This rework has no limit to size or quantity.

- (1) If there is a small bubble or void apparent in the film, remove all air from the bubble. To do this, use syringe needles of thin gauge or sewing needles if syringe needles are not available.

NOTE: A syringe is more convenient to use because you can put it directly into the film. And when you pull the plunger back, the air is removed. You can also use a sewing needle or other thin gauge needle to do the work, but two or more small holes are necessary to remove the air.

- (2) Force the air from the void with light pressure and cotton rags or gloves to make the surface smooth.
- (3) Use a heat gun set at 180°F - 210°F (82°C - 99°C) to increase the speed of the air removal procedure to make the surface smooth. This will also reactivate the adhesive primer that bonds the Tedlar, and let the technician make the Tedlar surface smooth.

B. Rework Procedure for Areas Larger than 4 in² (25.8 cm²): SECTIONING PROCEDURE

NOTE: With this procedure, you can remove and replace the original adhesive and it is not necessary to add other materials.

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CAUTION: DO NOT USE THE SECTIONING PROCEDURE WITHOUT A VISIBLE SEAM. DO A CAREFUL CHECK OF THE PANEL TO DECREASE OR TO PREVENT COSMETIC DEFECTS THAT USUALLY OCCUR WHEN YOU REMOVE A PANEL SECTION. IF THE REMOVAL OF THE PANEL SECTION IS THE ONLY ALTERNATIVE, REFER TO PARAGRAPH 10.D.

- (1) Make a lay-out of the section you want to remove. Apply a mask to the surrounding panel area.
- (2) Insulate the panel with a fiberglass mat or equivalent non-conductive material.

CAUTION: BE CAREFUL WHEN YOU CUT THE TEDLAR. MAKE SURE NOT CUT INTO THE TEDLAR SKIN.

- (3) Use an X-acto blade or safety razor to carefully trim the section from the panel.
- (4) After you cut the section, use a heat gun and a razor to lift an edge of the Tedlar.
- (5) Use Pliers to hold the material while you make it hot. Then carefully remove the section of Tedlar.
- (6) Use Peerco 321 or other solvent to remove the unwanted adhesive from the surface. Make sure that the surface is clean and free of dirt or unwanted materials. If necessary to fill aberrations in the surface, refer to paragraph 12. There is no limit to this repair in size if all the adhesive is removed and the normal Tedlar Procedures are done.

C. Replace the Tedlar:

- (1) Apply primer to the panel surface. Let the primer dry fully. Refer to Table 6001 for the recommended adhesive.
- (2) With a spray gun, apply the same primer to the backside of the Tedlar. Let it dry before you touch it.
- (3) Put a corner of the trimmed Tedlar on the cutout. Then make it warm with a heat gun. Make the Tedlar smooth on the surface as technician works the Tedlar down.

D. Rework Procedure for full Removal of the Original Tedlar

NOTE: For an extensive damage example on Tedlar, see Figure 6010.

NOTE: When you replace the Tedlar correctly, you do not add new materials to the component and it gets the original specifications back. There is no limitations for the repair when you use the original adhesives and the correct procedures. For the applicable/approved adhesives, if you would like assistance you can contact Safran Cabin Inc.

(1) INSTRUCTIONS:

- (a) Use heat guns, razor scrapers, pliers, and solvent (such as lacquer thinner or acetone) to remove the Tedlar from the panel.
- (b) After you remove the covering, remove the remaining adhesive with lacquer thinner or acetone.
- (c) Scour the surface with Scotchbrite pads as necessary to remove the unwanted adhesive.

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- (d) Let the panel dry in an oven at 150°F (65°C) for 60 minutes before you apply the Fill and Fair out Procedures. Refer to paragraph 12.
- (e) To apply decorative laminates, refer to paragraph 15.



Extensive Damage on Tedlar
Figure 6010/GRAPHIC 25-32-78-300-010-A01

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E. Repair Procedure for White Bondable Tedlar

NOTE: This repair is limited to 16 in² (103.2256 cm²) of the component surface area.

- (1) To remove the damaged sections of white bondable Tedlar, cut the white bond with a razor edge and then remove the damaged Tedlar from the surface.
- (2) Use a thin layer of filler (Refer to paragraph 12) to feather out the edge caused by the Tedlar abrupt end on the bare panel face. To feather out the 0.002 in (0.00508 cm) thickness, taper the filler from the bare panel to the white bond facing.
- (3) Carefully sand flush and make sure that the sanded area is kept to a minimum.
- (4) Clean the sanded area with Isopropyl Alcohol to prepare the component for paint. Do not let the solvent dry on the surface of the part. After you clean the sanded area with Isopropyl Alcohol, remove the unwanted solvent with a clean, dry shop wipe.
- (5) With a spray gun, apply to the prepared area a color that agrees with the Polyurethane based paint.
- (6) If necessary, touch-up the paint with a brush.
- (7) ONLY IF NECESSARY, make the surface smooth with a fine scouring material such as Scotchbrite (very fine scouring pad). Do not scour the surrounding Tedlar.

TASK 25-32-78-300-814-A01

15. Replace Decorative Laminate

A. Classification of the Decorative Laminates

NOTE: The following information is a summary of Materials and Processes that are available in other Safran Cabin Inc. internal specifications, and that information is copied from those Specifications (CDP490-00) for materials and processes used in this program. Information contained in this document is the same as the information in the CDP490-00.

NOTE: This section gives the three classes of decorative materials used for panels. Each procedure is specific for its class and is not interchangeable with other procedure of a different class. If you would like assistance with which class (procedure) is applicable you can contact Safran Cabin Inc.

- (1) CLASS 1: Decorative laminate (Tedlar or Polyvinyl Fluoride Sheeting) with a dry film of adhesive (Acrylic Based).
- (2) CLASS 2: Decorative laminate without a film of adhesive. It can be Tedlar, Tapestries and/or carpeting.
- (3) CLASS 3: Decorative laminate with Pressure Sensitive Adhesive. (Typical) Polyvinyl Fluoride Sheet/Tedlar.

CAUTION: REMOVAL OF THE BONDED DECORATIVE LAMINATE IS NOT AN EASY TASK. BE CAREFUL NOT TO CAUSE DAMAGE TO THE PANEL WHEN YOU PULL THE LAMINATE AWAY FROM THE SURFACE.

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CAUTION: THE MAXIMUM PERMITTED TEMPERATURE OF THE HEAT GUN IS 200°F (93°C).

B. Remove the existing Decorative Laminates

NOTE: The term “laminates” used in this manual refers to Tedlar, carpet, and/or tapestry only.

(1) Remove the decorative laminate that is bonded to the honeycomb panel surface, as follows:

- (a) Remove the metal trim that makes an overlap on the laminate.
- (b) Start at the top corner. Carefully pull only a small piece of the laminate away from the panel at this time.
- (c) Use a heat gun to make the adhesive soft between the laminate and the panel.
- (d) Carefully pull the laminate away from the panel in small increments while you apply continuous heat to the adhesive.

NOTE: Do this work with the smallest section possible to make the laminate removal easier.

NOTE: It is permitted to use a sharp tool to remove the laminate from the adhesive when heat is not sufficient.

- (e) Slowly and continuously remove all laminate from the panel.

C. Types of Adhesives and Primers

NOTE: See Table 6001. Do not use alternative adhesives or primers that are not recommended by Safran Cabin Inc. The recommended adhesives are aircraft certified. To replace these adhesives, you must get a waiver or approval from Safran Cabin Inc.

WARNING: SOLVENTS, ADHESIVES, AND PRIMERS ARE POISONOUS AND FLAMMABLE. USE SAFETY AND HANDLING PROCEDURES GIVEN BY THE MANUFACTURER.

CAUTION: WHEN YOU USE FASTBOND 10 AS A PRIMER, APPLY AN EQUAL, LIGHT COAT BECAUSE TOO MUCH ADHESIVE INCREASES FLAMMABILITY. FOR ACRYLIC ADHESIVE-BACKED (CLASS 1) TEDLAR, WITH A SPRAY GUN, APPLY A COAT ONLY TO THE PANEL SURFACE. FOR CLASS 2 TEDLAR, WITH A SPRAY GUN, LIGHTLY APPLY A COAT TO THE TEDLAR SURFACE AND THE PANEL.

D. Bonding Procedure for Class 1, Decorative Laminate for Panels

(1) Panel materials compatible with Class-1 Decorative Laminates are as follows:

- (a) Aluminum skinned Panels or Surfaces
- (b) Phenolic Honeycomb Panels
- (c) Polycarbonate/Plastic Panels or Surfaces

(2) Surface Preparation for Priming

- (a) Use a finish sandpaper (400-600 grit) to remove the rough areas where you will apply the primer.
- (b) To remove the sanding materials from the panels, turn the panels down and tap the rear of the panels. It is also permitted to remove the remaining dust or dirt with a shop vacuum.
- (c) Regardless of the procedure used to remove the dust, clean the panel surfaces with a clean cloth, and solvent if necessary. Use Isopropyl Alcohol, MEK, or Acetone only. The Panel will be clean when there is no indication of dirt, oil, or unwanted materials after you pass a clean, dry shop wipe on its surface.
- (d) Dry the panel surface with a clean shop wipe to distribute the solvent along the panel surface. The solvent extended in this manner can make its total evaporation easier.
- (e) The operator must examine and make sure that there is no solvent on the panel. You can use a clean-filtered-compressed air to remove or blow away the remaining solvent.

(3) Primer Application

NOTE: It is not necessary to apply a primer to the polycarbonate surface for bonding.

(a) Spray Procedure

- 1 Shake the can of primer or mix the primer until all the material is correctly mixed.
- 2 Make the primer thin. Use water if necessary.
- 3 Use a spray gun to apply one or two uniform primer coats on the panel for the decorative laminate. Apply no more than 61.24 psi (422.23 kPa) (wet weight) of primer 18.37 psi (126.67 kPa) (dry weight).
- 4 If a second coat (not usual) is necessary, dry the first coat in the air for 60 minutes. Or put it in a warm (100°F - 115°F (38°C - 46°C)) air-circulating oven or in a drying room (100°F ± 10°F (38°C ± 5.5°C) with dehumidified air) for a minimum of 20 minutes.
- 5 Dry the primed panel at room temperature for a minimum of 1 hour. Refer to the Manufacturer's instructions for the type of Primers.

NOTE: If a second coat is necessary to get a uniform coat, make sure to let the first coat dry for 15 minutes before you apply the second coat. If the total of the two adhesive coats is more than the limit, remove the adhesive from the panel. Then start all again. The total weight of the two coats must be less than 0.0026 lb (1.2 g) (dry weight).

(b) Brush or Roller Procedure

- 1 With a brush or a roller, apply a smooth, equal coat of primer on the panel surface that you will cover with the decorative laminate, and on the panel edges. Do not mix the primer with water.

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- 2 Dry the primed panel at room temperature for a minimum of 1 hour. You can decrease the drying time to one half, if you make the panels warm at 100°F ± 10°F (38°C ± 5.5°C).

(4) Preparation of the Decorative Laminate for Bonding

- (a) Cut the sheet of decorative laminate larger than the panel.
- (b) Put the decorative laminate on the panel and adjust it correctly to the corners of the panel.

CAUTION: BE CAREFUL WHEN YOU MAKE THE PANEL SURFACE SMOOTH. MAKE SURE THAT YOU REMOVE ONLY A MINIMUM QUANTITY OF PRIMER.

(5) Preparation of Panels for Bonding

NOTE: No more preparation is necessary to the panels painted with Type 8 Primers.

- (a) Make the painted surface smooth with a finish sandpaper (400-600 grit).
- (b) Remove the sanding materials from the non-acoustical parts with a clean cloth. To remove the sanding materials from the acoustical panels, turn the panels down and tap lightly the rear of the panels.
- (c) Use a clean rag moist with acetone, MEK, or Isopropyl Alcohol to remove any fingerprints, grease, or oils from the panels.

(6) Preparation of Assembly with Thermoforming Jig

NOTE: No more preparation is necessary to the panels painted with Type 8 Primers.

NOTE: On panels with draw areas, pull the decorative laminate. This is to permit approximately 1 in (2.54 cm) of clearance between the panel and laminate at the point of maximum curvature.

- (a) Put the panel on the jig. If necessary, remove the release paper from the back of the decorative laminate. Then put the laminate on top of the panel.
- (b) To hold the decorative laminate in position, put it in a frame and attach with staples or tape as necessary.

(7) Vacuum-Forming Heat-Bonding Procedure

CAUTION: USE RELEASE PAPER FOR PROTECTION OF THE DECORATIVE LAMINATE SURFACE.

- (a) Move the jig and the panel into the heat vacuum applicator.
- (b) You can monitor the bond line temperature thus: with a tape, hold a thermocouple wire between a piece of decorative laminate and a small sample of the panel that you must cover. Keep this thermocouple assembly near the panel that you must cover. Put the thermocouple at the bond line on the actual part when applicable.

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- (c) Close down the diaphragm and apply a vacuum of 1 in (2.54 cm) to 2 in (5.08 cm) of Mercury.
- (d) Make the wrinkles in the decorative laminate smooth.

NOTE: You can increase the temperature of the panel and the decorative laminate to 150°F (66°C) before you apply the vacuum to help remove the wrinkles.

- (e) Bond the decorative laminate to the primed panel as shown below:

USE	TEMP (°F+15°F)	VACUUM (inHg)	TIME (MINUTES)
Aluminum parts (no primer)	230°F (110°C)	10-15	3-4
Sidewall, Covering Panels and Deep Draw parts	210°F (99°C)	10-15	3-4
Doors and Shallow Draw Parts	200°F (93°C)	8-10	3-4

- (f) Decrease the part temperature while the part stays under the vacuum and until the bond line temperature is less than 100°F (38°C). Use a floor fan or an equivalent air cooling system to decrease the part temperature.
- (g) To release the vacuum, shut off the vacuum pump and lift the diaphragm where applicable.

(8) Wrapping Edges

- (a) Apply a coat of adhesive to the panel edges before you wrap them. This specification lets the technician use the applicable and approved adhesives (Table 6001) when necessary to wrap the panel edges; but the adhesive selection must be the same as permitted by each program and as used for Certification and Flammability. If you would like assistance you can contact Safran Cabin Inc.
- (b) Make the decorative laminate hot around the edges of the panel. To do this, use a heat gun held 6 in (15.24 cm) away from the panel edges for 5 to 10 seconds.
- (c) Hold one end of the decorative laminate. Then on the edges of the panels, rub the decorative laminate down continuously with a clean cloth or cotton glove.
- (d) Trim the unwanted part of Tedlar from the panel.

E. Bonding Procedure for Class-2 Decorative Laminate (Without Film Adhesive) to Panels

NOTE: Before you apply a Class-2 Decorative Laminate, make the panel surface smooth with a filler compound (refer to paragraph 12), unless you use tapestry or thick laminates.

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- (1) Panel Materials Compatible with Class-2 Decorative Laminates:
 - (a) Aluminum skinned Panels or Surfaces
 - (b) Phenolic Honeycomb Panels
 - (c) Polycarbonate Panels or Surfaces
- (2) Preparation of Surfaces for Bonding
 - (a) To clean the aluminum and phenolic surfaces, rub them with a clean, lint-free cheesecloth moist with MEK. Before MEK dries up, rub the panel surface with a clean, dry cheesecloth.

NOTE: Clean the Polycarbonate panels with Isopropyl Alcohol or weaker type detergent and water.

- (3) Preparation of the Decorative Laminate for Bonding
 - (a) Cut the sheet of decorative laminate larger than the panel.
 - (b) Put the decorative laminate on the panel and then adjust it correctly to the corners of the panel.

CAUTION: TO PREVENT WRINKLING AND BUBBLING ON THE DECORATIVE LAMINATE, BE VERY CAREFUL WHEN YOU APPLY HEAT TO THE LAMINATE.

- (c) Use FASTBOND #30 to do the steps below:
 - 1 Examine the adhesive shelf life.
 - 2 Mix the adhesive thoroughly. Use it as received for brush application or add water in a quantity necessary to make one part of the adhesive thin.
 - 3 Apply a uniform coat of no more than 61.24 psi (422.23 kPa) (wet weight) of primer 18.37 psi (126.67 kPa) (dry weight) of adhesive to the two surfaces. On porous surfaces, it is necessary to apply two coats. Dry the adhesive in the air until it is no longer tacky.
 - 4 Touch the adhesive with a Kraft paper to test its tackiness. If the paper does not bond, the adhesive is prepared. If the adhesive becomes too dry, add a new and thin coat of adhesive to reactivate it.
 - 5 When you apply a Class-2 decorative laminate, start from one edge of the panel. Push the decorative laminate onto the bonding surface of the panel. Be careful not to permit the remainder of the decorative laminate to touch the bonding surface. Continue to push the decorative laminate in small increments to the panel until the installation is completely done.
 - 6 Use a heat gun to apply heat and keep the quantity of bubbles at a minimum. Use the heat guns only during a short time and at a low setting at $\sim 200^{\circ}\text{F} \pm 20^{\circ}\text{F}$ ($93^{\circ}\text{C} \pm 11^{\circ}\text{C}$).
 - 7 Clean the decorative surface with a dry cloth. Then make sure that the decorative laminate is fully bonded to the panel.

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CAUTION: DO NOT TOUCH ON OR APPLY STRESS TO THE BOND UNTIL THE ADHESIVE CURES COMPLETELY.

(d) Use AKZO NOBEL AQUABIND to do the steps below:

NOTE: Aquabind has low initial-adhesion properties, but it also increases friction. For permanent bonding, you must attach the carpet tightly at the panel edges. Attach the carpet with Polyken-108 Class-2, edge-wrap adhesive, double-backed carpet tape; or hold the material mechanically to the panel (example: use a channel to hold the panel and the carpet in position). The perimeter of the adhesive must be 0.75 in (1.905 cm) width or less. Aquabind is a primer/adhesive that makes the flammability and OSU results better for marginal materials. Make sure that the edge treatment agrees with the initial installation and then complete the procedure.

NOTE: Use adhesive to attach the fabric tapestries and carpet to the aircraft panels. Because of the nature of the adhesive, you must use it on porous substrates only (fabrics or carpets). The adhesive is recommended for AMT X6 and AMT X7 flame retardant-backing materials on Fabrics.

- 1 Make sure that the panel is clean.
- 2 Mix the adhesive suspension on a shaker table for 5-10 minutes. You can also mix the adhesive aggressively by hand to make sure that all solids are hanged through the material and it is homogeneous. The adhesive must become chalky and pinkish in color.
- 3 Apply the adhesive to the panel with a roller, brush, or adhesive spreader (best) in 0.0625 in² (0.403 cm²) slots for distribution. Comb the adhesive (or coat) along the panel surface.
- 4 You must push the fabric into the adhesive quickly. The adhesive starts to set in 5 minutes. Install the Fabric and make it smooth as necessary. You can use a roller for easy fabric installation and to apply equal pressure.
- 5 Let the material cure at a temperature of 60°F - 80°F (16°C - 27°C) for four (4) hours before you handle it. The final cure strength is got in 48 hours. To make the adhesive cure faster, you can increase the temperature of the panels to 150°F - 165°F (66°C - 74°C) for two (2) hours.

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F. Bonding Procedures for Class-3 Decorative Laminate (with Pressure Sensitive Adhesive)

NOTE: Before you apply a Class-3 Decorative laminate, make the panel surface smooth with a filler compound. Refer to paragraph 12.

(1) Panel Materials Compatible with Class-3 Decorative Laminates:

- (a) Aluminum skinned Panels or Surfaces
- (b) Phenolic Honeycomb Panels
- (c) Polycarbonate Panels or Surfaces

(2) Preparation of Surfaces for Bonding

NOTE: To clean the bonding surfaces, rub them with a clean, lint-free cheesecloth moist with Acetone, Isopropyl Alcohol, Ethanol, or MEK (for aluminum or phenolic). To clean Polycarbonate surfaces, use Isopropyl Alcohol or weaker-type detergent and water. Remove the remaining solvent before it evaporates. For this, use a clean, dry cheesecloth.

(3) Preparation of the Decorative Laminate for Bonding

- (a) Cut the sheet of the decorative laminate larger than the panel on which you will install the laminate.
- (b) Put the decorative laminate on the panel and then adjust it correctly to the corners of the panel.

(4) Application of Class 3 Laminate

CAUTION: TO PREVENT WRINKLING AND BUBBLING ON THE DECORATIVE LAMINATE, BE VERY CAREFUL WHEN YOU APPLY HEAT TO THE LAMINATE.

- (a) Remove the backing paper from the decorative laminate.
- (b) Start from one edge of the panel. Push the decorative laminate on the bonding surface of the panel. Be careful not to permit the remainder of the decorative laminate to touch the bonding surface.
- (c) Use a heat gun to apply heat and keep the quantity of bubbles at a minimum. Use heat guns only during a short time and at a low setting, at $\sim 200^{\circ}\text{F} \pm 30^{\circ}\text{F}$ ($93^{\circ}\text{C} \pm 17^{\circ}\text{C}$).
- (d) Continue to push the decorative laminate in small increments onto the panel until its complete installation.
- (e) Clean the decorative surface with a dry cloth. Then make sure that the decorative laminate is fully bonded to the panel.

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ASSEMBLY

TASK 25-32-78-99F-811-A01

1. General

- A. This section contains special instructions and notes needed to prevent damage to components and possible injury during assembly of the G2 Galley Assembly.

NOTE: Assembly sequence can be changed.

- B. To use this section, first refer to TESTING AND FAULT ISOLATION and INSPECTION/CHECK to identify the damaged and worn parts. Then refer to paragraph 2 for special assembly instructions.
- C. Refer to REPAIR to replace all bonded components, adhesive-backed placards, electrical wiring, and potted inserts. Install the attaching parts given in the IPL to attach all other components.

TASK 25-32-78-400-801-A01

2. Assembly of the Unit

WARNING: TO AVOID INJURIES TO PERSONNEL WHILE SERVICING THE EQUIPMENT, MAKE SURE THAT ALL POWER HAS BEEN REMOVED. ONLY APPROVED PERSONNEL MUST DO THE MAINTENANCE.

CAUTION: THE MONUMENT HAS DECORATIVE SURFACES THAT ARE EASILY DAMAGED. COVER THE SURFACES AND BE CAREFUL WITH UNIT TO PREVENT DAMAGE.

NOTE: The bonded individual panels of the structure assembly cannot be replaced without special fixtures and tooling. Refer to REPAIR to fill holes you can see. Replace the bonded structure assembly if you cannot repair the damage.

SUBTASK 25-32-78-440-001-A01

A. G2 Galley Assembly
(IPL Figure 1)

- (1) Remove and disassemble the bonded structure assembly (590, -590A, -590B, -590C, -590D, -590E, -590F, -590G, -590H, or -590J) in accordance with SUBTASK 25-32-78-040-012-A01.
- (2) Install the literature pocket assemblies (585A, -585B, or -585C).
- (3) Refer to REPAIR section to replace the adhesive-backed SB incorporation placard (-580).
- (4) Install the components of the placard installation (-575 or -575A) in accordance with SUBTASK 25-32-78-440-013-A01.
- (5) Install the studs (570).
- (6) Install the screws (-565).
- (7) Install the rivnut (-550).
- (8) Install the stud (545).
- (9) Install the screw (-540).

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- (10) Assemble and install the closeout panel assembly (535) as follows:
 - (a) Install the panel (-538).
 - (b) Refer to REPAIR section to replace the bonded trim (-537).
- (11) Install the screw (-533).
- (12) Install the screw (-532).
- (13) Install the rivnuts (-530).
- (14) Install the bumpers (515) with screw (520) and washer (525).
- (15) Install the base trim (505) with screws (510).
- (16) Refer to REPAIR section to replace the bonded bumpons (500 or -500A).
- (17) Refer to REPAIR section to replace the bonded seal (495A).
- (18) Install the airduct fitting assemblies (480) with screws (485) and washers (490).
- (19) Install the vinyl cap (475).
- (20) Install the airduct flexible hose (470).
- (21) Install the hose clamps (465).
- (22) Install the ½ fareless tubing cap assembly (460).
- (23) Install the ½ fared tubing cap assembly (455).
- (24) Install the tee fitting support bracket (440) with screws (445) and washers (450).
- (25) Install the tee fitting support bracket (435).
- (26) Install the tee (430).
- (27) Install the tee (425).
- (28) Install the nuts (420).
- (29) Install the washers (415).
- (30) Install the access cover (404) with screws (405).
- (31) Assemble the cover assembly (390) as follows:
 - (a) Install the cover (403).
 - (b) Refer to REPAIR section to replace the bonded panel assembly (396). Assemble the panel assembly (396) as follows:
 - 1 Install the panel (-399).

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- (c) Install the panel assembly (396) with screws (397).
- (32) Install the cover assembly (390) with screws (395).
- (33) Install the angle access cover (380) with screws (385).
- (34) Install the rivnut (-375).
- (35) Install the stud (370).
- (36) Install the screw (-365A).
- (37) Install the curtain track support bracket assembly (350) with screws (355) and washers (360).
- (38) Refer to REPAIR section to replace the bonded gap seal (345).
- (39) Assemble and install the rubstrip installation (-310) as follows:
 - (a) Install the retainer (330) with screw (335).
 - (b) Install the end caps (320) with screws (325).
 - (c) Install the rubstrip (315).
- (40) Install the bracket (300) with screws (305).
- (41) Refer to REPAIR section to replace the bonded standard unit rubstrips (295).
- (42) Install the cart retainers (275).
- (43) Assemble the drawer assembly (265, -265A, or -265B) in accordance with SUBTASK 25-32-78-440-011-A01. Install the drawer assembly (265, -265A, or -265B) with screws (270).
- (44) Assemble the drawer assembly (255) in accordance with SUBTASK 25-32-78-440-010-A01. Install the drawer assembly (255) with screws (260).
- (45) Assemble the door assembly (-240A, -240B, -240C, or 240D) in accordance with SUBTASK 25-32-78-440-009-A01. Install the door assembly (-240A, -240B, -240C, or 240D) with screws (245) and washers (250).
- (46) Assemble the door assembly (225, -225B, -225C, -225D, or -225E) in accordance with SUBTASK 25-32-78-440-008-A01. Install the door assembly (225, -225B, -225C, -225D, or -225E) with screws (230) and washers (235).
- (47) Refer to REPAIR section to replace the bonded nameplate (215). Install the nameplate (215) with rivets (-220).
- (48) Install the door stops (205) with screws (207) and washers (208).
- (49) Install the strikers (195) with screws (200).
- (50) Install the standard unit retainer blocks (185) with screws (190A).
- (51) Install the cart retainer block (175A) with screws (180).

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- (52) Install the upper attachment bracket assembly (160) with screws (165A) and finish washers (170).
- (53) Install the tie-rod assembly (140A or -140B) with bolt (150), washers (155), and nut (157).
- (54) Install the upper attachment cover (130) with screws (135A).
- (55) Install the components of the extrusion installation (125, -125A, -125B, -125D, -125E, or -125F).
- (56) Install the rubstrips (115) and rubstrips (117 or -117A) with screws (120A or -120B).
- (57) Install the retainer block assemblies (105) with screws (110).
- (58) Install the assist handle (90) with screws (95) and washers (100).
- (59) Install the socket (80) with screws (85).
- (60) Assemble the socket assembly (70) as follows:
 - (a) Install the socket (-78).
 - (b) Install the spring pin (-77).
- (61) Install the socket assembly (70) with screws (75).
- (62) Install the retainers (-67).
- (63) Install the retainers (65).
- (64) Refer to REPAIR section to replace the bonded flood light bracket assembly (60 or -60A).
- (65) Install the cart retainers (55).
- (66) Install the cart divider (48) with screws (50).
- (67) Install the cart retainer (42 or -42A).
- (68) Install the cart retainer (41).
- (69) Install the cart retainers (40).
- (70) Install the standard unit retainer (-32).
- (71) Install the standard unit retainer (30).
- (72) Install the standard unit retainer (-27).
- (73) Install the standard unit retainer (26).
- (74) Install the standard unit retainers (25).
- (75) Install the bumpers (21C, -21D, or -21F) with screws (22C or -22E) and washers (23 or -23B).
- (76) Install the bumpers (10B) with screws (15B) and washers (20).

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- (77) Install the components of the electrical installation (5, -5A, -5B, -5C, -5D, -5E, -5F, or -5G) in accordance with SUBTASK 25-32-78-440-007-A01.

SUBTASK 25-32-78-440-002-A01

B. G2 Galley Installation
(IPL Figure 1A)

- (1) Assemble and install the G2 galley assembly (95) in accordance with SUBTASK 25-32-78-440-001-A01.
- (2) Refer to REPAIR section to replace the bonded foams (-80).
- (3) Refer to REPAIR section to replace the bonded foam (-75).
- (4) Assemble and install the seat track fitting assemblies (55) as follows:
 - (a) Install the fitting (70).
 - (b) Install the retainer (60) with screws (65).
- (5) Install the washers (53).
- (6) Install the bolts (52).
- (7) Install the floor fitting covers (50).
- (8) Install the washers (48).
- (9) Install the bolt (47).
- (10) Install the bolt (46).
- (11) Install the nylon finishing plug (45).
- (12) Install the floodlight (40).
- (13) Install the outboard wheel guide (30) with screws (35).
- (14) Assemble the inboard wheel guide assembly (20) as follows:
 - (a) Install the wheel guide (-29).
 - (b) Refer to REPAIR section to replace the bonded cap (-28).
 - (c) Refer to REPAIR section to replace the bonded double sided tape (-27).
- (15) Install the inboard wheel guide assembly (20) with screws (25).
- (16) Install the cover (15) with screws (17).
- (17) Install the washers (10).
- (18) Install the screws (5).
- (19) Install the bolt (4).

(20) Install the washers (3).

(21) Install the nut (2).

SUBTASK 25-32-78-440-003-A01

C. G2 Galley Installation

(IPL Figure 1B)

(1) Assemble and install the G2 galley assembly (150) in accordance with SUBTASK 25-32-78-440-001-A01.

(2) Refer to REPAIR section to replace the bonded foam (-145).

(3) Refer to REPAIR section to replace the bonded foam (-140).

(4) Install the studs (-130) with screws (-135).

(5) Install the snap style studs (-125).

(6) Install the literature pocket assemblies (120).

(7) Assemble and install the seat track fitting assemblies (100) as follows:

(a) Install the fitting (115).

(b) Install the retainer (105) with screws (110).

(8) Install the washers (95).

(9) Install the bolts (90).

(10) Install the floor fitting covers (85).

(11) Install the washers (80).

(12) Install the bolt (75A).

(13) Install the bolt (70).

(14) Install the nylon finishing plug (65).

(15) Install the outboard wheel guide (55) with screws (60).

(16) Assemble the inboard wheel guide assembly (30) as follows:

(a) Install the wheel guide (-50).

(b) Refer to REPAIR section to replace the bonded cap (-45).

(c) Refer to REPAIR section to replace the bonded double sided tape (-40).

(17) Install the inboard wheel guide assembly (30) with screws (35).

(18) Install the floodlight (26) with screws (27) and washers (28).

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- (19) Install the cover (20) with screws (25).
- (20) Install the bolt (15).
- (21) Install the washers (10).
- (22) Install the nut (5).

SUBTASK 25-32-78-440-004-A01

D. G2 Galley Installation
(IPL Figure 1C)

- (1) Assemble and install the G2 galley assembly (105) in accordance with SUBTASK 25-32-78-440-001-A01.
- (2) Refer to REPAIR section to replace the bonded foam (-100).
- (3) Refer to REPAIR section to replace the bonded foams (-95).
- (4) Install the snap style studs (-90).
- (5) Install the literature pocket assemblies (85).
- (6) Assemble and install the seat track fitting assemblies (65) as follows:
 - (a) Install the fitting (80).
 - (b) Install the retainer (70) with screws (75).
- (7) Install the washers (60).
- (8) Install the bolts (55).
- (9) Install the floor fitting covers (50).
- (10) Install the washers (45).
- (11) Install the bolt (40).
- (12) Install the bolt (35).
- (13) Install the nylon finishing plug (30).
- (14) Install the cover (20) with screws (25).
- (15) Install the bolt (15).
- (16) Install the washers (10).
- (17) Install the nut (5).

SUBTASK 25-32-78-440-005-A01

E. G2 Galley Installation
(IPL Figure 1D)

- (1) Assemble and install the G2 galley assembly (150) in accordance with SUBTASK 25-32-78-440-001-A01.
- (2) Refer to REPAIR section to replace the bonded foam (-145).
- (3) Refer to REPAIR section to replace the bonded foams (-140).
- (4) Install the studs (-130) with screws (-135).
- (5) Install the snap style studs (-125).
- (6) Install the literature pocket assemblies (120 or -120A).
- (7) Assemble and install the seat track fitting assemblies (100) as follows:
 - (a) Install the fitting (115).
 - (b) Install the retainer (105) with screws (110).
- (8) Install the washers (95).
- (9) Install the bolts (90).
- (10) Install the floor fitting covers (85).
- (11) Install the washers (80).
- (12) Install the bolt (75).
- (13) Install the bolt (70).
- (14) Install the nylon finishing plug (65).
- (15) Install the outboard wheel guide (55) with screws (60).
- (16) Assemble the inboard wheel guide assembly (30) as follows:
 - (a) Install the wheel guide (-50).
 - (b) Refer to REPAIR section to replace the bonded cap (-45).
 - (c) Refer to REPAIR section to replace the bonded double sided tape (-40).
- (17) Install the inboard wheel guide assembly (30) with screws (35).
- (18) Install the cover (20) with screws (25).
- (19) Install the bolt (15).
- (20) Install the washers (10).

- (21) Install the nut (5).

SUBTASK 25-32-78-440-006-A01**F. G2 Galley Installation**
(IPL Figure 1E)

- (1) Assemble and install the G2 galley assembly (135) in accordance with SUBTASK 25-32-78-440-001-A01.
- (2) Refer to REPAIR section to replace the bonded foam (-130).
- (3) Refer to REPAIR section to replace the bonded foams (-125).
- (4) Install the literature pocket assemblies (110) with screws (-115) and washers (-120).
- (5) Refer to REPAIR section to replace the bonded placards (105).
- (6) Install the logo backplate (100).
- (7) Install the logo (90) with screws (95).
- (8) Assemble and install the seat track fitting assemblies (70) as follows:
 - (a) Install the fitting (85).
 - (b) Install the retainer (75) with screws (80).
- (9) Install the washers (65).
- (10) Install the bolts (60).
- (11) Install the floor fitting covers (55).
- (12) Install the washers (50).
- (13) Install the bolt (45).
- (14) Install the bolt (40).
- (15) Install the nylon finishing plug (35).
- (16) Install the cover (25) with screws (30).
- (17) Install the bolt (20).
- (18) Install the washers (15).
- (19) Install the nut (10).
- (20) Install the components of the bracket installation (-5).

SUBTASK 25-32-78-440-015-A01

G. G2 Galley Installation
(IPL Figure 1F)

- (1) Assemble and install the G2 galley assembly (150) in accordance with SUBTASK 25-32-78-440-001-A01.
- (2) Refer to REPAIR section to replace the bonded placards (145).
- (3) Refer to REPAIR section to replace the bonded placard installation (140). Install the components of the placard installation (140) in accordance with SUBTASK 25-32-78-440-013-A01.
- (4) Refer to REPAIR section to replace the bonded foam (-135).
- (5) Refer to REPAIR section to replace the bonded foams (-130).
- (6) Install the literature pocket assemblies (120) with stud snaps (-125).
- (7) Install the lens (115).
- (8) Assemble and install the fitting assemblies (95) as follows:
 - (a) Install the fitting (110).
 - (b) Install the retainer (100) with screws (105).
- (9) Install the washers (90).
- (10) Install the bolt (85).
- (11) Install the floor fitting covers (80).
- (12) Install the washers (75).
- (13) Install the bolt (70).
- (14) Install the bolt (65).
- (15) Install the plug (60).
- (16) Install the wheel guide inboard (50) with screws (55).
- (17) Assemble the wheel guide assembly (30) as follows:
 - (a) Install the wheel guide (-45).
 - (b) Refer to REPAIR section to replace the bonded double sided tape (-40).
- (18) Install the wheel guide assembly (30) with screws (35).
- (19) Install the cover (20) with screws (25).
- (20) Install the bolt (15).
- (21) Install the washers (10).

- (22) Install the nut (5).

SUBTASK 25-32-78-440-007-A01

H. Electrical Installation
(IPL Figure 2)

- (1) Install the wire harness assembly (105, -105A, or -105B).
- (2) Install the heater tee (100).
- (3) Install the heater tee (95).
- (4) Refer to REPAIR section to replace the bonded tubing (90).
- (5) Refer to REPAIR section to replace the bonded grommets (-88).
- (6) Refer to REPAIR section to replace the bonded grommets (-87).
- (7) Refer to REPAIR section to replace the bonded grommets (85).
- (8) Install the cable ties (-83).
- (9) Install the cable ties (-82).
- (10) Install the cable ties (80).
- (11) Refer to REPAIR section to replace the bonded cable tie mounts (-78).
- (12) Refer to REPAIR section to replace the bonded cable tie mounts (-77).
- (13) Refer to REPAIR section to replace the bonded cable tie mounts (75).
- (14) Install the wire bundle retainers (55A and 60A) with screws (65) and washers (70A).
- (15) Install the loop clamp (-42) with screw (-47) and washer (-52).
- (16) Install the loop clamps (40) with screws (45) and washers (50).
- (17) Install the washers (-37).
- (18) Install the screws (-36).
- (19) Install the led exit identifier emergency (20 or -20A) with screws (25 or -25A) and washers (30A).
- (20) Install the emergency exit sign housing assembly (17 or -17A) with screws (18) and washers (19).
- (21) Install the lens (-16).
- (22) Install the lavatory occupied sign (5 or -5A) with screws (-10A or 10B) and washers (-15A or 15C).

SUBTASK 25-32-78-440-008-A01

I. Door Assembly
(IPL Figure 3)

- (1) Install the panel (60).

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- (2) Refer to REPAIR section to replace the bonded decor (-55).
- (3) Refer to REPAIR section to replace the bonded trim (40).
- (4) Refer to REPAIR section to replace the bonded hinge trim (21, -21A, or -21B).
- (5) Install the half-hinge (20).
- (6) Install the backplate (15), drive screws (16), hinge pin (17), spring (18 or -18A), and door stops (19).
- (7) Install the double slide latch (5) with screws (10).

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J. Door Assembly
(IPL Figure 4)

- (1) Install the panel (60).
- (2) Refer to REPAIR section to replace the bonded decor (-55).
- (3) Refer to REPAIR section to replace the bonded trim (40).
- (4) Refer to REPAIR section to replace the bonded hinge trim (35 or -35A).
- (5) Install the half-hinge (20).
- (6) Install the backplate (15), drive screws (16), hinge pin (17), and spring (18 or -18A).
- (7) Install the double slide latch (5) with screws (10).

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K. Drawer Assembly
(IPL Figure 5)

- (1) Refer to REPAIR section to replace the bonded bottom panel (100).
- (2) Install the back panel (95).
- (3) Refer to REPAIR section to replace the bonded side panel assembly (85). Assemble the side panel assembly (85) as follows:
 - (a) Install the side panel (-92).
- (4) Refer to REPAIR section to replace the bonded side panel assembly (75). Assemble the side panel assembly (75) as follows:
 - (a) Install the side panel (-82).
- (5) Refer to REPAIR section to replace the bonded front panel assembly (65). Assemble the front panel assembly (65) as follows:
 - (a) Install the front panel (-72).

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- (6) Refer to REPAIR section to replace the bonded decor (-63).
- (7) Refer to REPAIR section to replace the bonded back panel trim (60).
- (8) Refer to REPAIR section to replace the bonded side panel trim (55).
- (9) Refer to REPAIR section to replace the bonded side panel trim (50).
- (10) Refer to REPAIR section to replace the bonded front panel trim (45).
- (11) Refer to REPAIR section to replace the bonded front panel trim (40).
- (12) Install the slide tracks (30) with screws (35).
- (13) Install the handle (20) with screws (25).
- (14) Install the backplate (15).
- (15) Install the latch assembly (5) with screws (10).

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L. Drawer Assembly
(IPL Figure 6)

- (1) Refer to REPAIR section to replace the bonded back panel (95).
- (2) Refer to REPAIR section to replace the bonded side panel assembly (85, -85A, or -85B). Assemble the side panel assembly (85, -85A, or -85B) as follows:
 - (a) Install the side panel (-92, -92A, or -92B).
- (3) Refer to REPAIR section to replace the bonded side panel assembly (75, -75A, or -75B). Assemble the side panel assembly (75, -75A, or -75B) as follows:
 - (a) Install the side panel (-82, -82A, -82B).
- (4) Refer to REPAIR section to replace the bonded front panel assembly (65 or -65A). Assemble the front panel assembly (65 or -65A) as follows:
 - (a) Install the front panel (-72 or -72A).
- (5) Refer to REPAIR section to replace the bonded decor (-64, -64A, or -64B).
- (6) Refer to REPAIR section to replace the bonded back panel trim (60).
- (7) Refer to REPAIR section to replace the bonded side panel trim (55 or -55A).
- (8) Refer to REPAIR section to replace the bonded side panel trim (50 or -50A).
- (9) Refer to REPAIR section to replace the bonded front panel trim (45).
- (10) Refer to REPAIR section to replace the bonded front panel trim (40 or -40A).
- (11) Install the slide tracks (30, 30A, or -30B) with screws (35 or 35A).

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- (12) Install the handle (20A) with screws (25).
- (13) Install the backplate (15).
- (14) Install the latch assembly (5) with screws (10).

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M. Bonded Structure Assembly

(IPL Figure 7)

- (1) Refer to REPAIR section to replace the bonded standard unit compartment panel assembly (440, -440A, or -440B). Assemble the standard unit compartment panel assembly (440, -440A, or -440B) as follows:
 - (a) Install the panel (-465, -465A, or -465B).
- (2) Refer to REPAIR section to replace the bonded aft panel assembly (435, -435A, -435B, -435C, or -435D). Assemble the aft panel assembly (435, -435A, -435B-435C, or -435D) as follows:
 - (a) Install the panel (-439, -439A, -439B, or -439C).
- (3) Refer to REPAIR section to replace the bonded aisle panel assembly (430, -430A, -430B, -430C, or -430D). Assemble the aisle panel assembly (430, -430A, -430B, -430C, or -430D) as follows:
 - (a) Install the panel (-434, -434A, -434B, -434C, or -434D).
- (4) Refer to REPAIR section to replace the bonded forward closeout panel (425).
- (5) Refer to REPAIR section to replace the bonded forward closeout panel (420).
- (6) Refer to REPAIR section to replace the bonded contour outboard panel (415).
- (7) Refer to REPAIR section to replace the bonded floor panel assembly (405 or -405A). Assemble the floor panel assembly (405 or -405A) as follows:
 - (a) Install the panel (-406 or -406A).
- (8) Refer to REPAIR section to replace the bonded closeout panel (400 or -400A).
- (9) Refer to REPAIR section to replace the bonded drawer compartment panel assembly (395, -395A, or -395B). Assemble the drawer compartment panel assembly (395, -395A, or -395B) as follows:
 - (a) Install the panel (-397, -397A, or -397B).
- (10) Refer to REPAIR section to replace the bonded enclosure panel (390).
- (11) Refer to REPAIR section to replace the bonded drawer compartment panel assembly (385 or -385A). Assemble the drawer compartment panel assembly (385 or -385A) as follows:
 - (a) Install the panel (-388 or -388A).
- (12) Refer to REPAIR section to replace the bonded panel assembly (380 or -380A). Assemble the panel assembly (380 or -380A) as follows:

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- (a) Install the panel (-383 or -383A).
- (13) Refer to REPAIR section to replace the bonded floodlight panel (375 or -375A).
- (14) Refer to REPAIR section to replace the bonded standard unit compartment panel (365) or standard unit compartment panel assembly (-365A). Assemble the standard unit compartment panel assembly (-365A) as follows:
 - (a) Install the panel (-367).
- (15) Refer to REPAIR section to replace the bonded standard unit compartment panel (360) or standard unit compartment panel assembly (-360A). Assemble the standard unit compartment panel assembly (-360A) as follows:
 - (a) Install the panel (-362).
- (16) Refer to REPAIR section to replace the bonded drawer compartment panel assembly (355). Assemble the drawer compartment panel assembly (355) as follows:
 - (a) Install the panel (-357).
- (17) Refer to REPAIR section to replace the bonded cart panel assembly (350, -350A, -350B, or -350C). Assemble the cart panel assembly (350, -350A, -350B, or -350C) as follows:
 - (a) Install the panel (-353, -353A, -353B, or -353C).
- (18) Refer to REPAIR section to replace the bonded standard unit compartment panel assembly (345). Assemble the standard unit compartment panel assembly (345) as follows:
 - (a) Install the panel (-348).
- (19) Refer to REPAIR section to replace the bonded standard unit compartment panel assembly (340). Assemble the standard unit compartment panel assembly (340) as follows:
 - (a) Install the panel (-343).
- (20) Refer to REPAIR section to replace the bonded shelf panel assembly (335). Assemble the shelf panel assembly (335) as follows:
 - (a) Install the panel (-337).
- (21) Refer to REPAIR section to replace the bonded spacer panel assembly (325). Assemble the spacer panel assembly (325) as follows:
 - (a) Install the panel (-327).
- (22) Refer to REPAIR section to replace the bonded miscellaneous panel assembly (320). Assemble the miscellaneous panel assembly (320) as follows:
 - (a) Install the panel (-323).
- (23) Refer to REPAIR section to replace the bonded standard unit compartment panel (315) or standard unit compartment panel assembly (-315A). Assemble the standard unit compartment panel assembly (-315A) as follows:

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- (a) Install the panel (-317).
- (24) Refer to REPAIR section to replace the bonded standard unit compartment panel assembly (-310A) or standard unit compartment panel (310B). Assemble the standard unit compartment panel assembly (-310A) as follows:
 - (a) Install the panel (-312).
- (25) Refer to REPAIR section to replace the bonded divider panel assembly (305 or -305A). Assemble and install the divider panel assembly (305 or -305A) as follows:
 - (a) Install the panel (-308 or -308A).
- (26) Refer to REPAIR section to replace the bonded standard unit compartment panel (300).
- (27) Refer to REPAIR section to replace the bonded upper fitting panel assembly (295 or -295A). Assemble the upper fitting panel assembly (295 or -295A) as follows:
 - (a) Install the panel (-299 or -299A).
- (28) Refer to REPAIR section to replace the bonded panel support doubler (280). Install the panel support doubler (280) with screws (285).
- (29) Refer to REPAIR section to replace the bonded panel support doubler (265). Install the panel support doubler (265) with screws (270).
- (30) Refer to REPAIR section to replace the bonded panel support doubler (250 or -250A). Install the panel support doubler (250 or -250A) with screws (255) and screws (260).
- (31) Refer to REPAIR section to replace the bonded panel support doubler (240). Install the panel support doubler (240) with screws (245).
- (32) Refer to REPAIR section to replace the bonded doubler (230). Install the doubler (230) with rivets (-235).
- (33) Refer to REPAIR section to replace the bonded curtain track angle (210). Install the curtain track angle (210) with screws (215) and washers (220).
- (34) Refer to REPAIR section to replace the bonded stab-in channels (-202).
- (35) Refer to REPAIR section to replace the bonded stab-in channels (200).
- (36) Refer to REPAIR section to replace the bonded kick panel (195).
- (37) Refer to REPAIR section to replace the bonded kick panel (190 or -190A).
- (38) Refer to REPAIR section to replace the bonded floor fitting doubler (185). Install the floor fitting doubler (185) with screws (187).
- (39) Refer to REPAIR section to replace the bonded floor fitting doubler (180).
- (40) Install the floor fitting (170) with screws (175).
- (41) Refer to REPAIR section to replace the bonded floor fitting doubler (165).

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- (42) Install the floor fitting (155) with screws (160).
- (43) Install the spacer (150).
- (44) Install the floor fitting (140) with screws (145).
- (45) Refer to REPAIR section to replace the bonded floor fitting doubler (130). Install the floor fitting doubler (130) with screws (135).
- (46) Refer to REPAIR section to replace the bonded floor fitting doubler (120). Install the floor fitting doubler (120) with screws (125).
- (47) Install the spacer (115).
- (48) Install the floor fitting (105A) with screws (110).
- (49) Refer to REPAIR section to replace the bonded cart retainer block doublers (100A).
- (50) Refer to REPAIR section to replace the bonded doublers (95).
- (51) Refer to REPAIR section to replace the bonded reinforcement angle (85). Install the reinforcement angle (85) with screws (90).
- (52) Refer to REPAIR section to replace the bonded reinforcement angle (70). Install the reinforcement angle (70) with screws (80).
- (53) Install the rivnuts (-42A).
- (54) Refer to REPAIR section to replace the bonded reinforcement angles (30A). Install the reinforcement angles (30A) with screws (35) and screws (40).
- (55) Refer to REPAIR section to replace the bonded doubler (20). Install the doubler (20) with screws (25).
- (56) Refer to REPAIR section to replace the bonded upper attachment doublers (5 and 7). Install the upper attachment doublers (5 and 7) with screws (10) and washers (15).

SUBTASK 25-32-78-440-013-A01

N. Placard Installation
(IPL Figure 8)

- (1) Refer to REPAIR section to replace the adhesive-backed placards (5 thru 110).

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O. Extrusion Installation
(IPL Figure 9)

- (1) Refer to REPAIR section to replace the bonded trims (65 or -65A thru 150).
- (2) Remove the rivnuts (-60).
- (3) Refer to REPAIR section to replace the bonded trims (5 thru 55).

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SPECIAL TOOLS, FIXTURES, EQUIPMENT, AND CONSUMABLES

TASK 25-32-78-99F-812-A01

1. General

The recommended special tools, fixtures, and test equipment for the G2 Galley Assembly are given in Table 9001. The recommended consumables for the G2 Galley Assembly are given in Table 9002.

NOTE: Equivalent items can be used.

Special Tools, Fixtures, and Equipment
Table 9001/TABLE 25-32-78-94B-001-A01

Nomenclature	Part or Specification Number	Source (CAGE)*	Use
Digital Multimeter	Model 8060A	Fluke Corporation (V89536)	Testing and Fault Isolation.
Power Supply	Variable DC up to 30VDC and 30W capability	Commercially Available	Testing and Fault Isolation.
Guide Tool	SLT 600G**	Shur-Lok Company (V97393)	To install potted inserts.
Protective eyewear or safety goggles	---	Commercially Available	Cleaning.
Plastic Blade Scraper or Spatula	---	Commercially Available	Cleaning.
Vacuum	Model# VK811SIWD / 125 CFM (or equivalent)	Cleva North America (V70A87)	Cleaning / Repair.
Sealant Gun, Pneumatic	Model 250	Products Research and Chemical Corp. (V4J249)	Repair.
Putty Knife	N/A	Commercially Available	Repair.
Razor Blade	N/A	Commercially Available	Repair.
Pliers or Router	N/A	Commercially Available	Repair.
Heat Gun	HL1920E or similar	TE Connectivity Corporation (V06090)	Repair.
Pneumatic Wrench	N/A	Commercially Available	Repair.
Soldering Iron	N/A	Commercially Available	Repair.
Pressure Spray Gun (JGA-502 Gun)	#FX tip and needle #765 air cap (or equivalent)	DeVilbiss Co. (V0GAZ6)	Repair.

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Special Tools, Fixtures, and Equipment
Table 9001/TABLE 25-32-78-94B-001-A01 (continued)

Nomenclature	Part or Specification Number	Source (CAGE)*	Use
Siphon Cup Gun (JGA-502 Cup)	#FX tip and needle #765 air cap (or equivalent)	DeVilbiss Co. (V0GAZ6)	Repair.

* Refer to the IPL, paragraph 6, for the address.

** Add the insert tab number to the guide-tool part number. Example: The Insert tab-number T2 will use guide-tool part number SLT 600G2. This tool is optional. The repair facilities must consult with the insert manufacturer and sales representative on the available shop aids to make the insert repair faster and easier. These shop aids are not necessary, but they help those operators with no or little experience in insert installation.

Consumables
Table 9002/TABLE 25-32-78-94A-001-A01

Nomenclature	Part or Specification Number	Source (CAGE)*	Use
Apron	---	Commercially Available	Cleaning.
Cotton Cloths (lint-free) (clean and dry)	---	Commercially Available	Cleaning.
Rubber Gloves or Latex	---	Commercially Available	Cleaning.
Soft-bristled brush	NSN 0038	Industries for The Blind, Inc. (V9U362)	Cleaning.
Solvent, cleaning Adhesive removal	Acetone CAS No. 67-64-1	Commercially Available	Cleaning.
	MEK (Methyl Ethyl Ketone) CAS No. 78-93-3 (Fed. MIL Spec. TT-M-261) (metal parts only)	Commercially Available	
	BRULIN 815MX	Brulin Holding Company, Inc. (V94058)	
	CALLA 301-A LEMON	Andpak-Ema, Inc. (V68491)	
General overall surface cleaning (including decor) (Mild Detergents)	Mild household detergent	Commercially Available	Cleaning.
	BRULIN 815MX	Brulin Holding Company, Inc. (V94058)	

* Refer to the IPL, paragraph 6, for the address.

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Consumables
Table 9002/TABLE 25-32-78-94A-001-A01 (continued)

Nomenclature	Part or Specification Number	Source (CAGE)*	Use
General overall surface cleaning (including decor) (Mild Detergents)	CALLA 301-A LEMON	Andpak-Ema, Inc. (V68491)	Cleaning.
Metal cleaning	Solvent, Federal Specification P-D-680, Type III MEK (Methyl Ethyl Ketone) CAS No. 78-93-3 (Fed. MIL Spec. TT-M-261) (metal parts only) BRULIN 815MX CALLA 301-A LEMON Sodium Bicarbonate NaHCO ₃ CAS No. 144-55-8	Optional Commercially Available Bulin Holding Company, Inc. (V94058) Andpak-Ema, Inc. (V68491) Commercially Available	Cleaning.
Metal Preservation, Corrosion Inhibitors/Cleaners	VCI-416 Cleaner Corrosion Inhibitor Corwipe 300	Cortec Corporation (V44695) Cortec Corporation (V44695)	Cleaning.
Sponges (clean and dry)	Non-Scratch Scrub Sponge (Scotch-Brite)	3M Company (V04963)	Cleaning.
Spray bottles	---	Commercially Available	Cleaning.
White Vinegar	Household Vinegar. A mild acidic solution with 5-15% Acetic Acid	Commercially Available	Cleaning.
Solvents - outside surfaces	Isopropyl Alcohol CAS No. 67-63-0 Acetone CAS No. 67-64-1	Commercially Available Commercially Available	Cleaning.
Polyester tapes, used for multipurpose lay-up at 400°F (202°C). Silicone or rubber based	Flashbreaker™ Polyester Pressure-Sensitive Adhesive and Release Tape	Airtech International, Inc. (V53912)	Repair.

* Refer to the IPL, paragraph 6, for the address.

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Consumables
Table 9002/TABLE 25-32-78-94A-001-A01 (continued)

Nomenclature	Part or Specification Number	Source (CAGE)*	Use
Polyester tapes, used for multipurpose lay-up	Flashbreaker™ Pressure-Sensitive Adhesive Masking and Release Tape	Airtech International, Inc. (V53912)	Repair.
Conformal Coating, Brush Application	Military Spec MIL-I-46058, Class C or Humiseal 1A33	Commercially Available or Chase Corporation (V99109)	Repair.
Abrasive-Cloth, Aluminum-Oxide, Medium-Grit	Federal Specification P-C-451	Commercially Available	Repair.
Cloth, Milled Glass Fibers	MIL-C-9084, Hammer Milled 0.03125 in (0.0793 cm) length or less	Commercially Available	Repair.
ScotchBrite Pad	Aircraft Cleaning Pad Ultra Fine Hand Pad 7448	3M Company (V04963) 3M Company (V04963)	Repair.
Sandpaper	100-400 grit 120-240 grit 180-220 grit 200-400 grit 400-600 grit	Commercially Available	Repair.
Sanding Pad	320 grit	Commercially Available	Repair.
Adhesives: Decor Bonding adhesive	Scotch-Weld™ #30 (Formerly Fast-Bond™ #30) Scotch-Weld™ #30 NF (Formerly Fast-Bond™ #30-NF)	3M Company (V04963)	Repair.
Edge Wrap	Aerobond 1801 Aquabind	Aerocell Corporation (V1SX35) Alternative Materials Tech Inc. (Akzo Nobel Coatings) (V0ZXD0)	
Sealant/Adhesive (stainless steel)	DEVCON Aluminum Filled Epoxy Per MMM-A-132 Type I or equivalent	ITW Polymers Adhesives NA (V0RZG3)	

* Refer to the IPL, paragraph 6, for the address.

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Consumables
Table 9002/TABLE 25-32-78-94A-001-A01 (continued)

Nomenclature	Part or Specification Number	Source (CAGE)*	Use
Sealant/Adhesive (stainless steel)	(Loctite) HYSOL EA 9394 NA Adhesive or equivalent	Henkel Corporation (V1N6B3)	Repair.
Adhesives	Epibond 1210-A (Resin) 9615-B (Hardener) Epibond 1559-1 A/B Epocast 1618 D/B Epocast 1628 A/B L-301-A/B Versilok 506 Accelerator #4 Scotch-Weld™ #5 (Formerly Scotch-Grip #5) DP420 DP190 EC-3524	Huntsman Advanced Materials (V1532N) J.D. Lincoln, Inc. (V0K9V8) Lord Corporation (V30676) 3M Company (V04963) 3M Company (V04963)	Repair.
Fill and Fair Compounds, Polyester Based	Akemi #7 Standard Filler Akemi #4 Faster Version Micro-Ultra Filler #15-3 Fire Retardant Reducer #15-3	AXSON North American, Inc. (V3VPY6) AXSON North American, Inc. (V3VPY6) Adtech Plastic Systems Corp., Inc. (V09AU0) Adtech Plastic Systems Corp., Inc. (V09AU0)	Repair.
Fill and Fair Compounds, Epoxy Based	Araldite 252, 2-part Paste Adhesive Filler DP110	Huntsman Advanced Materials (V1532N) 3M Company (V04963)	Repair.
Edge Fill	L-306 Magnolia Plastics 128-135 A/B	J.D. Lincoln, Inc. (V0K9V8) Magnolia Advanced Materials, Inc. (V22121)	Repair.
Potting Compound	L-318 Kit Form Epibond 1559-1 A/B Epibond 420 or Redux 420 Epocast 1618 D/B Epocast 89670-A/B 1631-A/B 1632-A/B	J.D. Lincoln, Inc. (V0K9V8) Huntsman Advanced Materials (V1532N)	Repair.
* Refer to the IPL, paragraph 6, for the address.			

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Consumables
Table 9002/TABLE 25-32-78-94A-001-A01 (continued)

Nomenclature	Part or Specification Number	Source (CAGE)*	Use
Potting Compound	Magnabond 92-1 A/B DP420 Polystrate #14270 - 5 min epoxy EY-3009 A/B or EY-3010 A/B 7160 A/B 7176 Aerobond 1507-A/B or 1508-A/B Aerofill 1504-A/B DAPCO 3040-A/B	Magnolia Advanced Materials, Inc. (V22121) 3M Company (V04963) ITW Polymers Adhesives NA (V0RZG3) HB Fuller North America (V26348) Aerocell Corporation (V1SX35) Cytec Engineered Materials, Inc. (V1KT46)	Repair.
Potting Adhesive, Epoxy Based	L-318	J.D. Lincoln, Inc. (V0K9V8)	Repair.
Structural Adhesive, Epoxy Based	L-301 A/B	J.D. Lincoln, Inc. (V0K9V8)	Repair.
Core Sealer-Edge Seal, Epoxy Based	L-306 A/B (Alternate: Araldite 252 A-B, 2-part paste or Epocast 1628 A-B from Huntsman) DAPCO 3008 A/B DAPCO 3303 Magnolia 85-3 A/B	J.D. Lincoln, Inc. (V0K9V8) Cytec Engineered Materials, Inc. (V1KT46) Magnolia Advanced Materials, Inc. (V22121)	Repair.
Laminating Resin Epoxy	Epon 828 Resin Epikure 3223 DETA Catalyst Epocast 50A1 (100 Parts by weight) 9816 Catalyst (15 Parts by weight) or 946 Catalyst (15 Parts by weight) Hysol ® EA 956 A/B	Resolution Performance Products LLC (V3FBZ6) Huntsman Advanced Materials (V1532N) Huntsman Advanced Materials (V1532N) Henkel Corporation (V1N6B3)	Repair.
* Refer to the IPL, paragraph 6, for the address.			

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Consumables
Table 9002/TABLE 25-32-78-94A-001-A01 (continued)

Nomenclature	Part or Specification Number	Source (CAGE)*	Use
Sealant, Silicone (white)	RTV 102 Dow Corning 7130 GE 160 GE 5242	Momentive Performance Materials, Inc. (General Electric Co.) (V01139)	Repair.
Sealant/Adhesive	PR 1775/1776 Class A or B P/S 890 Class A or B	Courtaulds Aerospace (V05027) Sealants and Coatings Technologies, Inc. (V45DF3)	Repair.
Metal Surface Protection: Metal Preservation, Corrosion Inhibitors/Cleaners	VCI-416 Cleaner Corrosion Inhibitor Corwipe 300	Cortec Corporation (V44695) Cortec Corporation (V44695)	Repair.
Organic Coating for Aluminum Surfaces	VCI-386 Top Coat and VCI-393 / VCI-395 Primer Alodine 600/1200 White 44-W-7 Primer A/B* Light Gray 44-W-18 Primer A/B* White 44-W-7 and 44-W-18 NOTE: DO NOT HAVE CHROMATE	VCI Products are FDA and USDA approved Henkel Corporation (V1N6B3) Deft, Inc. (V33461) Deft, Inc. (V33461) Deft, Inc. (V33461)	Repair.
Organic Epoxy Mastic Coating - Top Coat	M45/M46 Reduce with M95 M62-01 Epoxy Gloss Coating	Benjamin Moore and Co. Ltd. (V09585) Certified for Food Processing and FDA Approved for Food Service	Repair.
Fluid Resistant Primers:	KOROPON 515-700 PAINT 910-704 CATALYST 463-12-8 PAINT CA-116 CATALYST 10-P4-7 PAINT EC-131 CATALYST	Courtaulds Aerospace (V05027) Dexter Corporation (V1JB33) Courtaulds Aerospace (V05027)	Repair.
* Refer to the IPL, paragraph 6, for the address.			

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Consumables
Table 9002/TABLE 25-32-78-94A-001-A01 (continued)

Nomenclature	Part or Specification Number	Source (CAGE)*	Use
Fluid Resistant Primers:	515X391 PAINT 910c780 CATALYST 010x326 THINNER MIL-P-23377 primer Ty II CIC MIL-T-81772B REDUCER (Green Primer) MIL-P-23377 primer Ty II CIC MIL-T-81772B REDUCER (Yellow Primer)	Courtaulds Aerospace (V05027) C&C Ventures LLC (V77672) C&C Ventures LLC (V77672)	Repair.
Top Coats:	#442-3 (GLOSS COLOR) #X-304 CATALYST #453-3 (FLAT COLOR) #CA-118 CATALYST #980- (GLOSS COLOR) #982- (SEMI-GLOSS) Sher Will Enamel F63 or H99 V66V29 catalystr. R7KB29 or R7K84 or R99KY29 (REDUCER) (03Y091) Top Coat (03Y091) Catalyst MIL-T-81772 Type I Reducer MIL-PRF-85285C, Type I Polyurethane #343-55 (Filler) #345-15 (Hardener) #346-65 (Top Coat) #345-65 (Hardener)	Bostik, Inc. (V5W425) Bostik, Inc. (V5W425) WLS Coatings, Inc. (V0YY71) Sherwin-Williams Company (V1JRP1) Sherwin-Williams Company (V1JRP1) Deft, Inc. (V33461) Mankiewicz GEBR. & Co. (VD2603)	Repair.
Acceptable CIC Materials:	NYCOTE 7-11	Nycote Laboratories Corporation (V05803) or Chemetall Chemical Products, Inc. (V02CA7)	Repair.
* Refer to the IPL, paragraph 6, for the address.			

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Consumables
Table 9002/TABLE 25-32-78-94A-001-A01 (continued)

Nomenclature	Part or Specification Number	Source (CAGE)*	Use
Acceptable CIC Materials:	DINITROL / ARDROX AV Series Compounds DINITROL AV 8 DINITROL AV 15 DINITROL AV 25 DINITROL AV 30 SOCOPAC 65H	Chemetall Oakite, Inc. (V0L040) Socomore (VF6892)	Repair.
Solvents:	Isopropyl Alcohol CAS No. 67-63-0 Acetone CAS No. 67-64-1 MEK (Methyl Ethyl Ketone) CAS No. 78-93-3 (Fed. MIL Spec. TT-M-261) Ethyl Alcohol (Ethanol) CAS No. 64-17-5 Peerco 321	Commercially Available Commercially Available Commercially Available Commercially Available Commercially Available	Repair.
Thinner	Humiseal #33	Chase Corporation (V99109)	Repair.
Electrical: Plug, Sealing Splice, Wire Wire, Electrical (match color) 16-AWG 20-AWG 22-AWG Wrap, Spiral Tubing, Heat shrink Protective Coating, Corrosion, Blue	N/A or in accordance with the OEM requirements Not specific Nycote 7-11	Commercially Available Commercially Available Nycote Laboratories Corporation (V05803)	Repair.
* Refer to the IPL, paragraph 6, for the address.			

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ILLUSTRATED PARTS LIST (IPL)

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TASK 25-32-78-99F-813-A01

1. General

This section describes and illustrates all component assemblies, subassemblies, and parts required for maintenance of the G2 Galley Assembly.

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2. Scope of Information

A. General

Each assembly is listed and immediately followed by a listing of its detail parts. The listing is indented to show the relationship between each part and its next higher assembly. Item numbers in the parts list correspond to the item numbers of the accompanying illustration (figure).

B. How to Identify a Part

- (1) When the part number is known: Find the part number in the numerical index and note the figure and item number. Find the item number in the applicable parts list and illustration to get the necessary information.
- (2) When the part number is not known: Review the illustrations to identify the part by physical appearance and location. Refer to the accompanying parts list to get the part number, nomenclature, effectivity, and quantity.
- (3) The effectivity code shows the part usage relative to the next higher assembly. When the EFFECTIVITY CODE column is blank, the part usage applies to all next-higher assembly versions unless otherwise specified in the NOMENCLATURE column.

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3. Equipment Designator Index

The Equipment Designator Index is an aid to find the parts in the Detail Parts List by equipment designator. The equipment designator, the part number, the figure number, and the item number are given for each entry.

The equipment designator are sorted 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.

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4. Numerical Index

The Numerical Index is an aid to find parts in the Detail Parts List by part number. The figure number, the item number, and the total quantity required are given for each entry.

The part numbers are sorted 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 25-32-78-99F-815-A01

5. Explanation of Detail Parts List Entries

The Detail Parts List is arranged in general sequence of disassembly. The parts are illustrated in an exploded-view illustration and listed in the related parts list.

A. FIG. ITEM Column

- (1) 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 assigned to the part in the illustration.
- (2) A dash (-) in front of an item number means the part is not illustrated.
- (3) Alpha-variants A through Z (except I and O) are assigned to item numbers when necessary to identify added parts, alternate parts, and parts modified by service bulletins.

B. PART NUMBER Column

This column gives the part number of the manufacturer for each part, as modified to meet the requirements of ATA 200/2000. The modifications can include:

- (1) Removal of blank spaces and special characters, with the possible exception of dashes. Dashes are permitted only between numeric characters
- (2) Insertion of a reference part number compatible with ATA 200/2000 if the part number is longer than 15 characters. In these cases, the full part number is given in the NOMENCLATURE column.

C. INDENTURE

The indenture is included in the nomenclature column and shows how parts are related. A typical relation is as follows:

- End Item or Major Assembly
- . Detail Parts or Assembly for End Item or Major Assembly
- .. Subassemblies
- ATTACHING PARTS
- .. Attaching Parts for Subassemblies
- * ---
- ... Detail Part for Subassemblies
- ATTACHING PARTS
- ... Attaching Parts for Detail Parts
- * ---

D. NOMENCLATURE Column

- (1) This column contains descriptive nomenclature for each part, and can also give the CAGE code of the manufacturer (if the part is not made by Safran Cabin Inc.), the part number (if it is longer than 15 digits or modified to ATA 200/2000), any service bulletin that affect the part, and any obsolete part numbers. The column also provides figure references for NHA and details, and additional descriptive information as required.
- (2) Assemblies, subassemblies, and detail parts subjected to modification, deletion, addition, or replacement by an issued service bulletin are annotated to indicate both the pre- and post-service bulletin configurations. The term (PRE SB XXXX) in the NOMENCLATURE column identifies the original configuration, and the term (ADDED POST SB XXXX) identifies assemblies and parts after the modification has been completed.
- (3) The terms defined below are used when applicable to indicate the interchangeability of parts.

Term	Abbreviation	Definition
Alternate	ALT	The listed part is alternate to and interchangeable with other parts within the same item number variant group or other item numbers if designated. (Two Way Interchangeable)
Optional	OPT	The part is fully interchangeable in form, fit, and function with other item numbers shown. (Two Way Interchangeable)
Incorporated By Mistake	INC BY MISTAKE	The related part was added by mistake to the IPL, so it is deleted accordingly.
Superseded By	SUPSD BY	The part is superseded by and is one way interchangeable with the item number identified in the note. (One Way Interchangeable)
Supersedes	SUPSDS	The part supersedes and is not interchangeable with the item number designated in the notation. (One Way Interchangeable)
Replaced By	RPLD BY	The part is replaced by and is interchangeable with the item number designated in the notation. (Two Way Interchangeable)
Replaces	RPLS	The part replaces and is interchangeable with the item number designated in the notation. (Two Way Interchangeable)

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- (4) The term defined below is used when applicable to indicate the trim and finish condition of a part (color-coded).

Standard Phrase	Definition
(ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM)	The part is color-coded. Refer to DESCRIPTION AND OPERATION section for trim and finish code.

E. EFF CODE Column

This column contains effectivity 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.

F. UNITS PER ASSY Column

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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6. Manufacturer's Names and Addresses

The CAGE codes for the manufacturers of the parts, special tools, test equipment, and materials referenced in the manual are given below. The five digit code is preceded by the letter V. The codes are taken from Cataloging Handbook H4/H8. No code in the NOMENCLATURE column means the part is supplied by Safran Cabin Inc.

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MANUFACTURER'S NAMES AND ADDRESSES

CODE	NAME	ADDRESS
V04963	3M COMPANY	3M CTR SAINT PAUL MN 55144-1000 PHONE 866-556-5712
V52607	ACTRON MANUFACTURING INC	1841 RAILROAD ST CORONA CA 92880-2512 PHONE 951-371-0885
V09AU0	ADTECH PLASTIC SYSTEMS CORP. INC	815 W SHEPHERD ST CHARLOTTE MI 48813 PHONE 800-255-9934
V1SX35	AEROCELL CORPORATION	12806 STATE AVE MARYSVILLE WA 98271 PHONE 360-653-2600
V53912	AIRTECH INTERNATIONAL INC	5700 SKYLAB RD HUNTINGTON BEACH CA 92647-2055 PHONE 714-899-8100
V0ZXD0	ALTERNATIVE MATERIALS TECHNOLOGY INC	311 OTTERSON DR SUITE 60 CHICO CA 95928 PHONE 530-894-3585
V68491	ANDPAK EMA INC	400 JARVIS DR MORGAN HILL CA 95037 PHONE 408-782-2500

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CODE	NAME	ADDRESS
V78276	AVK INDUSTRIES PRODUCTS INC	25323 RYE CANYON RD VALENCIA CA 91355-3338 PHONE 661-257-2329
V3VPY6	AXSON NORTH AMERICA INC	1611 HULTS DR EATON RAPIDS MI 48827-9500 PHONE 517-663-8191
V05399	BEMCO INC	233 MAIN ST CENTERTON AR 72719-9485 PHONE 479-795-2121
V09585	BENJAMIN MOORE AND CO LTD	15 LLOYD AVE TORONTO CANADA M6N 1G9 PHONE 416-766-1173
V3AB48	BOMBARDIER AEROSPACE	400 DE LA COTE-VERTU RD DORVAL CANADA H4S 1Y9 PHONE 514-855-5000
V5W425	BOSTIK INC	211 BOSTON ST MIDDLETON MA 01949-2128 PHONE 978-777-0100
V17023	BRUCE AEROSPACE INC	101 EVANS AVE DAYTON NV 89403-8300 PHONE 775-246-0101

COMPONENT MAINTENANCE MANUAL
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CODE	NAME	ADDRESS
V94058	BRULIN HOLDING COMPANY INC	2920 DR ANDREW J BROWN INDIANAPOLIS IN 46205-4066 PHONE 317-923-3211
V1YGB8	CAREY MANUFACTURING COMPANY INC	5 PASCO HILL RD CROMWELL CT 06416 PHONE 860-829-1803
V77672	CC VENTURES LLC	33 HAYNES CIRCLE CHICOPEE MA 01020-3712 PHONE 413-592-4191
V99109	CHASE CORPORATION	128 1ST ST PITTSBURGH PA 15238-3223 PHONE 781-332-0759
V02CA7	CHEMETALL CHEMICAL PRODUCTSINC	50 VALLEY RD BERKELEY HEIGHTS NJ 07922 PHONE 908-665-9466
V0L040	CHEMETALL OAKITE INC	675 CENTRAL AVE NEW PROVIDENCE NJ 07974-1560 PHONE 800-526-4473
V70A87	CLEVA NORTH AMERICA	601 REGENT PARK CT GREENVILLE SC 29607 PHONE 866-384-8432

COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001

CODE	NAME	ADDRESS
V44695	CORTEC CORPORATION	4119 WHITE BEAR PKWY SAINT PAUL MN 55110-7634 PHONE 800-426-7832
V05027	COURTAULDS AEROSPACE	410 JERSEY AVE GLOUCESTER CITY NJ 08030-2350 PHONE 856-742-9321
V1KT46	CYTEC ENGINEERED MATERIALS INC	645 N CYPRESS ST ORANGE CA 92867-6603 PHONE 714-666-4342
V33461	DEFT INC	17451 VON KARMAN AVE IRVINE CA 92614-6205 PHONE 949-476-6723
V0GAZ6	DEVILBISS CO	12878 E FLORENCE SANTA FE SPRINGS CA 90670 PHONE 562-463-9559
V1JB33	DEXTER CORPORATION	1 DEXTER DR SEABROOK NH 03874 PHONE 603-474-5541
V89536	FLUKE CORPORATION	6920 SEAWAY BLVD EVERETT WA 98203-5829 PHONE 425-446-5401

COMPONENT MAINTENANCE MANUAL
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CODE	NAME	ADDRESS
V26348	HB FULLER NORTH AMERICA	1200 WILLOW LAKE BLVD VADNAIS HEIGHTS MN 55110-5146 PHONE 651-236-5912
V1N6B3	HENKEL CORPORATION	32100 STEPHENSON HWY MADISON HEIGHTS MI 48071-5514 PHONE 248-577-2126
VB4946	HSH AEROSPACE FINISHES NV	DE HAAK 3 RESEARCH PARK ZONE 1 ZELLIK BELGIUM 1731 PHONE 322-481-1065
V1532N	HUNTSMAN ADVANCED MATERIALS (AUSTRIA) GMBH	WIPPLINGERSTRASSE 24 WIEN AUSTRIA 1010 PHONE 431-801-4320
V1F7X4	ISOVOLTA INC	495 TERRITORIAL ST HARRISBURG OR 97446-9608 PHONE 541-995-6395
V9U362	INDUSTRIES FOR THE BLIND AND VISUALLY IMPAIRED INC	445 S CURTIS RD WEST ALLIS WI 53214-1016 PHONE 414-778-3055
V0RZG3	ITW POLYMERS ADHESIVES NA	30 ENDICOTT ST DANVERS MA 01923-3712 PHONE 978-646-5853

COMPONENT MAINTENANCE MANUAL
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CODE	NAME	ADDRESS
V0K9V8	J.D. LINCOLN INC	851 W 18TH ST COSTA MESA CA 92627-4410 PHONE 949-650-8106
V30676	LORD CORPORATION	2455 ROBISON RD W ERIE PA 16509-4675 PHONE 814-217-6994
V64235	MAGEE PLASTICS COMPANY	303 BRUSH CREEK RD WARRENDALE PA 15086-7529 PHONE 724-776-2220
V22121	MAGNOLIA ADVANCED MATERIALS INC	5547 PEACHTREE BLVD CHAMBLEE GA 30341-2234 PHONE 770-451-2777
VD2603	MANKIEWICZ GEBR. AND CO	GEORG-WILHELM-ST 189 HAMBURG HH 21107 PHONE 494-075-1030
V3A054	MCMASTER-CARR SUPPLY COMPANY	9630 NORWALK BLVD SANTA FE SPRINGS CA 90670-2932 PHONE 562-692-5911
V01139	MOMENTIVE PERFORMANCE MATERIALS INC (GENERAL ELECTRIC CO)	260 HUDSON RIVER RD WATERFORD NY 12188-1910 PHONE 518-233-3241

COMPONENT MAINTENANCE MANUAL
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CODE	NAME	ADDRESS
V05803	NYCOTE LABORATORIES CORPORATION	12750 RAYMER ST STE 3 NORTH HOLLYWOOD CA 91605-4228 PHONE 818-764-9498
V06383	PANDUIT CORP	18900 PANDUIT DR TINLEY PARK IL 60487-3600 PHONE 708-532-1800
V49U11	PERRONE LEATHER LLC	182 RIVERSIDE DR FULTONVILLE NY 12072-1750 PHONE 518-853-4300
V4J249	PRODUCTS RESEARCH AND CHEMICAL CORP	2919 EMPIRE AVE BURBANK CA 91505 PHONE 818-240-2060
V5P104	RD AERONAUTICAL ENGINEERING	CADDO MILLS AIRPORT BLDG B CADDOMILLS TX 75135 PHONE 903-527-2006
V3FBZ6	RESOLUTION PERFORMANCE PRODUCTS LLC	1600 SMITH ST 24TH FL HOUSTON TX 77002-7496 PHONE 832-366-2385
V56135	SAFRAN CABIN INC.	5701 BOLSA AVE HUNTINGTONBEACH CA 92647-2063 PHONE 714-934-2287

COMPONENT MAINTENANCE MANUAL
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CODE	NAME	ADDRESS
V21213	SCHNELLER LLC	6019 POWDERMILL RD KENT OH 44240-7109 PHONE 330-676-7127
V45DF3	SEALANTS AND COATINGS TECHNOLOGIES INC	106 INDUSTRIAL WAY CHARLESTOWN IN 47111 PHONE 812-256-3378
V1JRP1	SHERWIN-WILLIAMS COMPANY	2640 MAIN ST SAN DIEGO CA 92113-3613 PHONE 216-515-4825
V97393	SHUR-LOK COMPANY	2541 WHITE RD IRVINE CA 92614-6235 PHONE 949-655-9256
VF6892	SOCOMORE	3707 PAUL DUPLEIX AVE VANNES FRANCE 56000 PHONE 029-743-7690
V06090	TE CONNECTIVITY CORPORATION	501 OAKSIDE AVE SIDE REDWOOD CITY CA 94063-3800 PHONE 800-806-0480
VSF309	TOHOKU CONSTRUCTION EQUIPMENT SALES	144-738 AZA-IDOGASHIRA OAZA-HORANAI TOWADA-CITY AOMORI-KEN JAPAN PHONE 0118-117-623-6278

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

CODE	NAME	ADDRESS
V0YY71	WLS COATINGS INC	13413 S BROADWAY LOS ANGELES CA 90061 PHONE 310-538-2155

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COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001
ALPHA/NUMERIC INDEX

PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
A5210-12P		6	30B 32	2 D
A5210-15P		5 6	30 30	2 2
A5210-9P		6	30A 31	2 D
ABMMD		2	75 77 78	7 12 5
AD32BS		1 1A 8	220 90 10	4 D D
AD42BS		7	235	10
AKS4-1032-130L		7	42A	4
AKS4-1032-80L		7	42	2
AKS4-832-80L		1	375 530 530A 530B 550 60	1 4 D D 1 4
AN834-8J		9	425	1
AN929-8J		1	455	1
AS4134J080808		1	430	1
BA670-40415-1		1E	5	1
BE725-8-88-5		1	470	1
BF1-0099-005		2	20A	1
BF5-0384-901		2	17A	1
BF5-0390-901		2	16	1

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9861001/E179001/E199001/E829001/H511201/J061502/J709001

PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
BF5-0828-901		2	17	1
BF5-0830-905		1F	115	1
BR9279-232		1A	40	1
		1B	26	1
		2	20	1
BR9410-6		2	5	1
BR9749-006		2	5A	1
CD1054-11		1A	85	D
CD1N07-3-6		7	225	D
CDIN07-04-20		7	436	4
CDIN07-3-6		7	225A	2
CDPL1008		8	70	1
CDPL1017		8	30	1
CDPL1068-1		8	105	D
			110	2
CDPL1069-1		8	5	1
CDPL1070-1		1F	145	2
CDPL1127-1		1E	105	2
CDPL160-13		1	215	1
CDPL466-201		8	65	1
CDPL466-202		8	15	1
CDPL466-203		8	55	1
CDPL466-204		8	75	1
CDPL466-205		8	25	1
CDPL466-206		8	50	1
CDPL466-207		8	80	1



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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
CDPL466-208		8	45	1
CDPL466-209		8	40	1
CDPL466-210		8	90	1
CDPL466-211		8	100	1
CDPL479-10-45		8	85	1
CDPL479-132-599		8	95A	2
CDPL479-150-682		8	95	2
CDPL479-20-91		8	35	2
CDPL479-30-136		8	60	1
CDPL479-50-227		8	20	5
CDPL604-1-98610		1	580	1
CDSP1004-3		3	5	1
		4	5	1
		5	5	1
		6	5	1
CDSP1107-1		1	195	4
CDSP1201-2		1	41	1
			42	1
			42B	D
CDSP1202-1		1	40	2
CDSP1203-1		1	25	4
			26	1
			27	1
CDSP1203-2		1	65	3
			67	3
CDSP1217-1		1	275	2
CDSP1217-2		1	55	2
CDSP1218-1		1	30	1
			32	1

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
CDSP1220-2		1	42A	1
			43	D
CDSP1403-501		1	185	9
			187	D
CDSP1416-501		1	105	2
CDSP1417-1		7	95	2
CDSP1418-1		1	175	2
CDSP1419-1		7	100	D
CDSP1900-1		1A	60	1
		1B	105	1
		1C	70	1
		1D	105	1
		1E	75	1
		1F	100	1
CDSP1900-3		1A	70	1
		1B	115	1
		1C	80	1
		1D	115	1
		1E	85	1
		1F	110	1
CDSP1900-501		1A	55	2
		1B	100	2
		1C	65	2
		1D	100	2
		1E	70	2
		1F	95	2
CDSP2020-1		1A	50	2
		1B	85	2
		1C	50	2
		1D	85	2
		1E	55	2
		1F	80	2
CDSP2110-513		1	140A	1

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D	
CDSP5002		3	15	1	
		4	15	1	
		5	15	1	
		6	15	1	
CDSP5304-100-10		1	495	1	
CDSP5307		1	495B	D	
CDSP5307-100-10		1	495A	1	
		1A	75	1	
			80	2	
		1B	140	AR	
			145	AR	
		1C	100	1	
			95	2	
		1D	140	2	
			145	1	
		1E	125	2	
			130	1	
	130	2			
	135	1			
CDSP5601-90		3	19	2	
			32	D	
CDSP5602-1		1	205	4	
CDSP5801-2AL		1	235	3	
			250	3	
			1E	120	6
CDSP5801-3AL		1	170	6	
			1A	10	2
			1B	28	2
			7	15	10
CDSP5810-4-7		1	1A	65	2
			1B	110	2
			1C	75	2
			1D	110	2
			1E	80	2
			1F	105	2
CDSP5903-3-500		5	70	D	
			6	70	D

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
CDSP5905-06-13		7	298	6
			298A	2
			322	2
			347	2
			387	2
CDSP5905-06-20		7	433	3
CDSP5905-08-06		5	80	5
			90	5
		6	80	5
			81	3
			81A	4
			90	5
			91	3
			91A	4
CDSP5905-08-13		1	398	4
			7	297
		297A		11
		307		6
		342		3
		346		1
		352		21
		352A		51
		352B		24
		352C		51
		356		6
		361		4
		366		4
		381	2	
386	1			
396	6			
445	3			
445A	5			
460	3			
CDSP5905-08-20		7	432	12
			432A	14
			438	8
			438A	6
			438B	18



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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
CDSP5905-3-13		7	296	1
			296A	1
			306	10
			311	6
			316	4
			321	1
			326	4
			341	6
			351	18
			351A	21
			351B	20
			382	8
			450	4
			455	4
CDSP5905-3-20		7	431	12
			431A	15
			431B	17
			437	26
			437A	28
CDSP5905-3-28		7	336	31
D3899926FE26PN		2	110	D
			130	D
D461202-505		1	140B	1
E179001-101		1C	1	RF
E191032-1		1A	30	1
			1B	55
			1D	55
			1F	50
E191032-3		1A	29	1
			1B	50
			1D	50
E191032-5		1A	27	AR
			1B	40
			1D	40
			1F	40
E191032-501		1A	20	1
			1B	30
			1D	30

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
E191032-503		1F	30	1
E191032-7		1A	28	1
		1B	45	1
		1D	45	1
E191032-9		1F	45	1
E199001-101		1D	1	RF
E199001-103		1D	1A	RF
E829001-101		1E	1	RF
E829101-1		1E	100	1
H511201-101		1A	1	RF
J061502-101		1B	1	RF
J709001-101		1F	1	RF
M25L1006-9		1	320	2
MS16562-214		1	77	1
MS20253P2-0812		3	17	1
			30	D
MS20253P2-0990		4	17	1
			30	D
MS21042L6		1	145	D
			157	1
			44	4
		1A	2	1
		1B	5	1
		1C	5	1
		1D	5	1
		1E	10	1
		1F	5	1
MS21083C12		1	420	2
MS21318-15		3	16	2
			25	D
		4	16	2
			25	D

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
MS21914-8J		1	460	1
MS25281R3		2	40	2
			42	1
MS27980-12N		1B	125	8
		1C	90	12
		1D	125	8
		1F	125	12
MS27980-7C		1	370	1
			377	D
			545	1
			560	D
			570	2
MS27983-3N		1B	130	4
		1D	130	4
MS3367-5-9		2	80	7
			82	12
			83	5
MS35206-213		2	10	4
MS35206-226		2	25	2
			36	2
			65	4
MS35206-227		1	335	1
NAS1096-3-5		1	355	2
NAS1149C1290R		1	415	3
NAS1149F0332P		1	100	2
			20	10
			23	8
			23A	8
			23B	8
			290	D
			360	2
			450	4
			490	12
		7	220	2
NAS1149F0363P		1	208	4
		2	19	2

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
NAS1149F0532P		1A	53	4
		1B	95	2
		1C	60	2
		1D	95	2
		1E	65	2
		1F	90	2
NAS1149F0632P		1	155	2
			46	4
		1A	3	2
			48	3
		1B	10	2
			80	2
		1C	10	2
			45	2
		1D	10	2
			80	2
		1E	15	2
			50	2
	10	2		
	75	2		
NAS1149F1032P		2	15C	4
NAS1149FN1032P		2	15B	D
NAS1149FN416P		2	15	4
NAS1149FN616P			30	2
			70	4
NAS1149FN632P		2	15A	4
NAS1149FN816P			50	2
			52	1
NAS1149FN832P			525	8
			525A	D
			533	1
NAS1368N6A			85	2
			87	1
			88	3
NAS1922-0200-3		1	465	3

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
NAS514P0832-4		5	10	4
			35	10
			10	4
NAS514P0832-5		6	35	10
			35A	6
			36	D
NAS514P1032-13		7	75	D
NAS514P1032-14		5	25	2
			6	2
NAS514P1032-16		1	15	D
NAS514P1032-20		1	285	D
NAS514P1032-21		1	165	6
NAS514P1032-22		1	165A	6
NAS514P1032-4		7	187	4
			40	2
			50	D
			65	D
NAS514P1032-5		7	25	6
			35	2
			60	D
			80	12
			90	2
NAS514P1032-6		1	120	D
			135	D
			190A	18
			305	2
			50	8
			510	3
			1A	5
			1B	27
			7	10
				125
				135
	175			

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D	
NAS514P1032-7		1	180	12	
			190	18	
		7	110	7	
			145	5	
			160	8	
NAS514P1032-8		1	110	20	
			210	D	
NAS514P632-5		1	200	8	
NAS514P632-6		1	325	2	
NAS514P832-10		1	207	4	
NAS514P832-4		1A	17	4	
		1B	25	4	
		1D	25	4	
		3	10	4	
		4	10	4	
		7	260	6	
			275	D	
			285	10	
NAS514P832-5		1	385	4	
			395	4	
			397	4	
			405	4	
		1F	25	4	
			7	245	22
				255	16
				270	10
NAS514P832-6		1	120A	42	
			120B	40	
			122	D	
			135A	4	
			230	3	
			245	3	
			260	12	
			270	12	
			75	2	
			85	2	
			1C	25	4
			1E	30	4
		NAS514P832-7		1E	115

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
NAS514P832-8		1	365A	1
			376	D
			540	1
			555	D
			565	2
NAS514P832-9		1B	135	4
		1D	135	4
NAS601-5P		2	25A	2
NAS601-6P		2	10A	4
NAS602-13		1	520	8
NAS602-5		2	45	2
			47	1
NAS602-6P		1	520A	D
			532	1
NAS602-8		1	365	1
NAS603-16P		1E	95	2
NAS603-18		1	15A	6
			22A	D
			95	2
NAS603-20		1	22C	8
			22D	8
			22E	8
NAS603-21		1	22B	8
NAS603-22		1	15B	10
NAS603-5		1	445	4
NAS603-5P		2	18	2
		7	215	2

COMPONENT MAINTENANCE MANUAL
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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
NAS603-6P		1A	25	4
			35	3
		1B	35	2
			60	3
		1D	35	4
			60	3
		1F	35	2
			55	3
2	10B	4		
NAS603-7		1	485	12
NAS603-8		1	22	8
			285A	D
NAS620-6L		2	30A	2
			37	2
			70A	4
NAS6205-5		1A	52	2
			90	2
			55	2
			90	2
			60	2
			85	1
NAS6606-11		1A	4	1
			46	1
		1B	15	1
			70	1
		1C	15	1
			35	1
		1D	15	1
			70	1
		1E	20	1
			40	1
		1F	15	1
65	1			
NAS6606-15		1A	47	1
			40	1
			45	1
NAS6606-16		1	150	1
NAS6606-17		1B	75	1
			1D	75

COMPONENT MAINTENANCE MANUAL
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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
NAS6606-19		1B	75A	1
		1F	70	1
RER5S6		2	55A	1
RER75S6		2	60A	1
SJ5303		1	500	4
			500A	2
TC188		2	55	1
TC86		2	60	1
10822A1032-23		6	20	1
10822A1032-2E		5	20	1
		6	20A	1
124-11065-01012		1E	110	2
124-11099-2		1E	90	1
458-4-2693		3	18	1
			18A	1
			50	D
		4	50A	D
			18	1
			18A	1
			50	D
			50A	D
4602308-501		7	200	2
			202	2
4602326-1		1	175A	2
			175B	D
4603059-509		1	140	1
48-7190		2	115	D
			135	D
48-7191		2	120	D
			140	D
4E4010-1		2	95	1

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
4E4011-1		2	100	1
85985K27		1A	45	1
		1B	65	1
		1C	30	1
		1D	65	1
		1E	35	1
		1F	60	1
9331073-1		7	100A	2
9331112-1		1	90	1
9331528-1		1	80	1
9331528-5		1	78	1
9331528-501		1	70	1
9391251-1		7	155	1
9391251-3		7	105	D
9392451-501		1	585A	RF
9392452-501		1	585B	RF
		1B	120	2
		1C	85	2
		1F	120	2
9392453-501		1D	120	2
9392453-503		1	585C	RF
		1D	120A	2
9392453-505		1	585	D
9393251-3		7	170	1
9393401-5		1	315	1
9393401-505		1	310	1
9393401-55		1	330	1
9393451-501		1	60	1
9393451-503		1	60A	1



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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
9394702-505		1	350	1
9753K93		1	475	1
9861001-1		1	345	1
9861001-101		1	1	RF
9861001-103		1	1A	RF
9861001-105		1	1B	RF
9861001-107		1	1C	RF
9861001-109		1	1D	RF
9861001-111		1	1E	RF
9861001-113		1	1F	RF
9861001-115		1 1F	1J 150	RF 1
9861001-117		1 1C	1G 105	RF 1
9861001-119		1	1L	RF
9861001-121		1 1A 1B 1D	1H 95 150 150	RF 1 1 1
9861001-123		1 1E	1K 135	RF 1
9861001-125		1	1M	RF
9861003-101		1	35	D
9861004-3		7	150	1
9861004-5		7	115	1
9861004-501		1 7	340 590 1	D 1 RF

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
9861004-503		1	340A	D
		7	590A 1A	1 RF
9861004-505		1	340B	D
		7	590B 1B	1 RF
9861004-507		1	340C	D
		7	590C 1C	1 RF
9861004-509		1	340D	D
		7	590D 1D	1 RF
9861004-511		1	340E	D
		7	590E 1E	1 RF
9861004-513		1	340G	D
		7	590G 1G	1 RF
9861004-515		1	340F	D
		7	590F 1F	1 RF
9861004-517		1	340H	D
		7	590H 1H	1 RF
9861004-519		1	340J	D
		7	590J 1J	1 RF
9861005-1		2	90	1
9861005-501		1	5	1
		2	1	RF
9861005-503		1	5A	1
		2	1A	RF
9861005-505		1	5B	1
		2	1B	RF



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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
9861005-507		1	5C	1
		2	1C	RF
9861005-509		1	5F	1
		2	1F	RF
9861005-511		1	5D	1
		2	1D	RF
9861005-513		1	5E	1
		2	1E	RF
9861005-515		1	5G	1
		2	1G	RF
9861007-501		1	575A	1
		8	1A	RF
9861007-503		1	575	1
		1F	140	1
		8	1	RF
9861009-1		9	130	1
9861009-11		9	10	1
9861009-13		9	15	1
9861009-15		9	45	1
9861009-17		9	25	1
9861009-19		9	35	1
9861009-21		9	30	1
9861009-25		9	70	1
9861009-27		9	75	1
9861009-29		9	80	1
9861009-3		9	135	1
9861009-31		9	85	1
9861009-33		9	90	1
9861009-37		9	100	1

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
9861009-39		9	105	1
9861009-41		9	110	1
9861009-43		9	115	1
9861009-45		9	5	1
9861009-47		9	20	1
9861009-49		9	95	1
9861009-501		1 9	125 1	1 RF
9861009-503		1 9	125A 1A	1 RF
9861009-505		1 9	125B 1B	1 RF
9861009-509		1 9	125C 1C	1 RF
9861009-51		9	140A	1
9861009-511		1 9	125D 1D	1 RF
9861009-513		1 9	125E 1E	1 RF
9861009-515		1 9	125F 1F	1 RF
9861009-53		9	145	1
9861009-55		9	135A	1
9861009-61		9	130A	1
9861009-63		9	25A	1
9861009-65		9	75A	1
9861009-67		9	100A	1
9861009-69		9	15A	1

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
9861009-7		9	140	1
9861009-9		9	125	1
9861011-1		7	439	1
9861011-11		7	439C	1
9861011-3		7	439A	1
9861011-5		7	439B	1
9861011-501		7	435	1
9861011-503		7	435A	1
9861011-505		7	435B	1
9861011-507		7	435C	1
9861011-509		7	435D	1
9861012-1		7	434	1
9861012-3		7	434A	1
9861012-5		7	434B	1
9861012-501		7	430	1
9861012-503		7	430A	1
9861012-505		7	430B	1
9861012-507		7	430C	1
9861012-509		7	430D	1
9861012-7		7	434C	1
9861012-9		7	434D	1
9861013-1		7	420	1
9861014-1		7	425	1
9861015-1		7	337	1
9861015-501		7	335	1

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
9861016-1		7	353	1
9861016-3		7	353A	1
9861016-5		7	353B	1
9861016-501		7	350	1
9861016-503		7	350A	1
9861016-505		7	350B	1
9861016-507		7	350C	1
9861016-7		7	353C	1
9861017-1		7	308	1
9861017-3		7	308A 309	1 D
9861017-501		7	305	1
9861017-503		7	305A	1
9861018-1		7	299	1
9861018-3		7	299A	1
9861018-501		7	295	1
9861018-503		7	295A	1
9861019-1		7	323	1
9861019-501		7	320	1
9861020-1		7	310B	1
9861020-3		7	315	1
9861020-5		7	300	1
9861020-501		7	310	D
9861020-503		7	310A	1
9861020-505		7	315A	1
9861020-7		7	312	1



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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
9861020-9		7	317	1
9861021-1		7	343	1
9861021-3		7	357	1
9861021-5		7	348	1
9861021-501		7	340	1
9861021-503		7	355	1
9861021-505		7	345	1
9861022-1		7	465	1
9861022-11		7	362	1
9861022-13		7	367	1
9861022-3		7	360	1
9861022-5		7	365	1
9861022-501		7	370 440	D 1
9861022-503		7	370A 440A	D 1
9861022-505		7	360A	1
9861022-507		7	365A	1
9861022-7		7	465A	1
9861023-1		7	388	1
9861023-11		7	390	1
9861023-3		7	383	1
9861023-5		7	375	1
9861023-501		7	385	1
9861023-503		7	380	1
9861023-505		7	385A	1

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
9861023-507		7	380A	1
9861023-7		7	388A	1
9861023-9		7	383A	1
9861024-1		7	397	1
9861024-3		7	397A	1
9861024-5		7	397B	1
9861024-501		7	395	1
9861024-503		7	395A	1
9861024-505		7	395B	1
9861025-1		7	406	1
9861025-3		7	406A 407	1 D
9861025-501		7	405	1
9861025-503		7	405A	1
9861026-3		7	327	1
9861026-503		7	325	1
9861027-1		7	415	1
9861028-1		7	400	1
9861029-1		7	465B	1
9861029-501		7	370B 440B	D 1
9861030-1		1	538	1
9861030-3		1	537	1
9861030-501		1	535	1
9861101-1		3	45 60	D 1



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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
9861101-11		3	21A 35A	1 D
9861101-13		3	21B 35B	1 D
9861101-3		3	40	1
9861101-5		3	55	AR
9861101-501		1 3	225 1	1 RF
9861101-503		1 3	225A 225E 1A	1 1 D
9861101-505		1 3	225D 1C	1 RF
9861101-507		1 3	225B 225C 1B	1 1 RF
9861101-7		3	21 35	1 D
9861101-9		3	20	1
9861102-1		4	45 60	D 1
9861102-11		4	35A	1
9861102-3		4	40	1
9861102-5		4	55	AR
9861102-501		1 4	240 240D 1	1 1 RF
9861102-503		1 4	240C 1B	1 RF
9861102-505		1 4	240A 240B 1A	1 1 RF

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
9861102-7		4	35	1
9861102-9		4	20	1
9861103-1		5	72	1
9861103-11		5	45	1
9861103-13		5	50	1
9861103-14		5	55	1
9861103-15		5	60	1
9861103-17		5	105 63	D AR
9861103-3		5	82	1
9861103-4		5	92	1
9861103-5		5	95	1
9861103-501		1 5	255 1	1 RF
9861103-601		5	65	1
9861103-603		5	75	1
9861103-604		5	85	1
9861103-7		5	100	1
9861103-9		5	40	1
9861104-1		6	72	1
9861104-11		6	45	1
9861104-13		6	50	1
9861104-14		6	55	1
9861104-15		6	60	1
9861104-17		6	100 64	D AR

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
9861104-3		6	82	1
9861104-5		6	92	1
9861104-501		1 6	265 1	1 RF
9861104-601		6	65	1
9861104-603		6	75	1
9861104-605		6	85	1
9861104-7		6	95	1
9861104-9		6	40	1
9861105-1		6	82A 83	1 D
9861105-3		6	92A 93	1 D
9861105-5		6	50A	1
9861105-501		1 6	265A 1A	1 RF
9861105-6		6	55A	1
9861105-601		6	75A	1
9861105-603		6	85A	1
9861105-7		6	105 64A	D AR
9861151-1		1	399	1
9861151-501		1	390	1
9861151-601		1	396	1
9861251-1		7	140	1
9861251-3		7	105A	1
9861252-501		1	160	1

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
9861253-501		1	300	1
9861254-1		1	45 48	D 1
9861260-501		1	480	3
9861301-1		9	65	1
9861301-11		9	150	1
9861301-13		9	65A	1
9861301-15		9	120A	1
9861301-17		9	50A	1
9861301-19		9	120B	1
9861301-3		9	120	1
9861301-5		9	50	1
9861301-7		9	55	1
9861301-9		9	40	1
9861302-1		1	435	1
9861302-3		1	440	1
9861352-1		1 1A 1B 1C 1D 1E 1F	130 15 20 20 20 25 20	1 1 1 1 1 1 1
9861352-3		1	400 404	D 1
9861352-5		1	403	1
9861352-7		7	210	1
9861352-9		1	380	1
9861353-1		7	130	1



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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
9861353-3		7	120	1
9861353-5		7	165	1
9861353-7		7	180	1
9861353-9		7	185	1
9861354-1		7	5	1
9861354-2		7	7	1
9861354-3		7	20	1
9861355-1		7	70	1
9861355-3		7	85	1
9861356-1		7	30 45 55	2 D D
9861356-3		7	30A	2
9861357-1		7	195	1
9861357-3		7	190	1
9861357-9		7	190A	1
9861359-1		7	240	1
9861359-13		7	250A	1
9861359-3		7	250	1
9861359-5		7	265	1
9861359-7		7	280	1
9861360-1		7	230	1
9861401-1		1	21B 21D 21F 280	4 4 4 D
9861401-11		1	10B	5

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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
9861401-15		1	21A	D
9861401-3		1	10	D
9861401-5		1	21	4
			21C	4
			21E	4
9861401-7		1	10A	3
9861402-11		1	115	12
			117	2
9861402-3		1	117A	2
			118	D
9861403-1		1	295	10
9861405-1		1	515	4
9861701-501		2	105	1
			35	D
9861701-503		2	105A	1
			125	D
9861705-501		2	105B	1
			145	D
9862038-1		7	400A	1
9862109-1		6	82B	1
			84	D
9862109-3		6	72A	1
			73	D
			92B	1
			94	D
9862109-501		1	265B	1
		6	1B	RF
9862109-601		6	75B	1
9862109-603		6	85B	1
9862109-605		6	65A	1
			66	D



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PART NUMBER	AIRLINE STOCK NUMBER	FIGURE NUMBER	ITEM NUMBER	TOTAL REQ'D
9862109-7		6	40A	1
9862109-9		6	110 64B	D AR
9863028-1		7	375A	1
9863303-1		1	505	1

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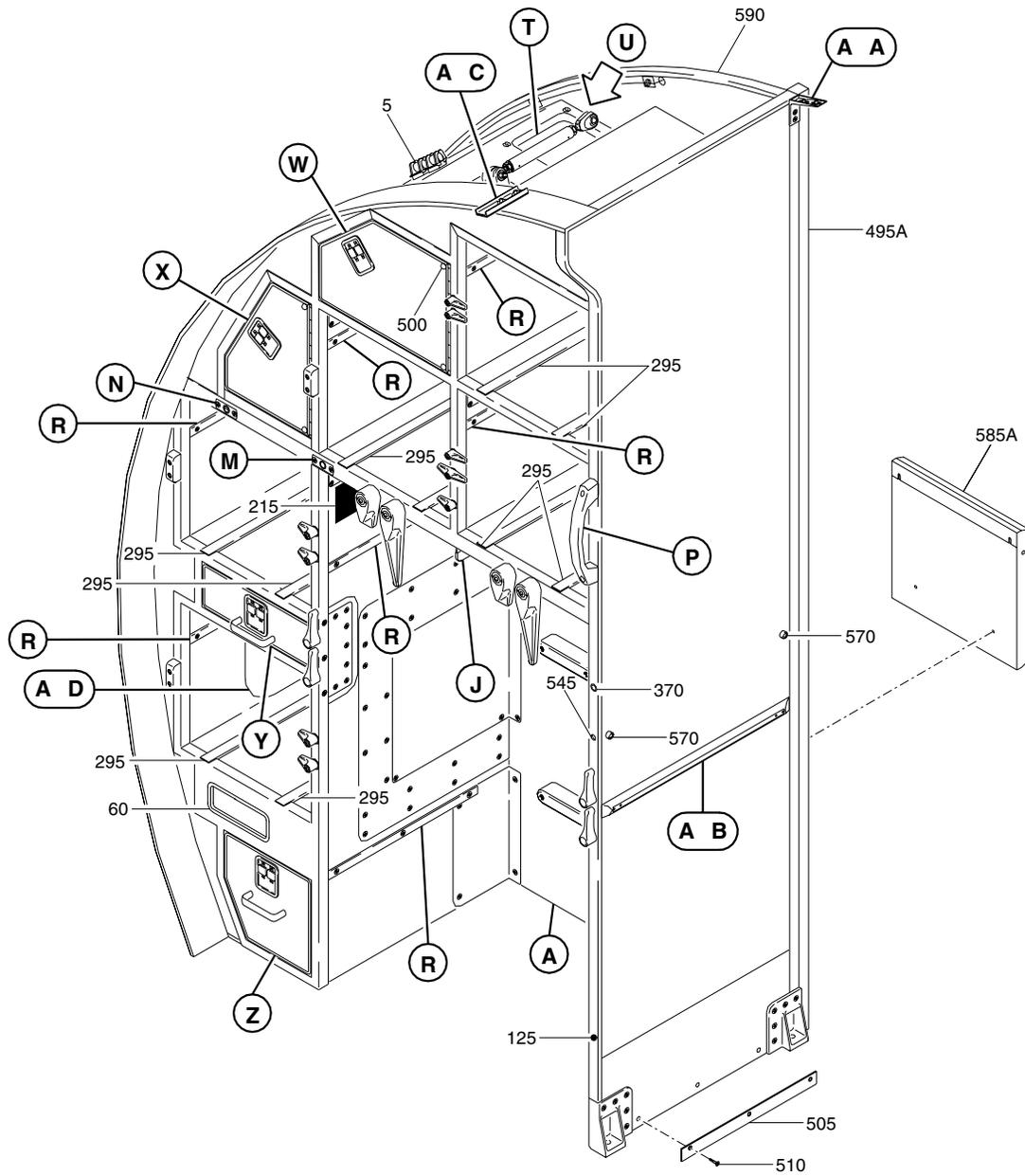
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DETAILED PARTS LIST

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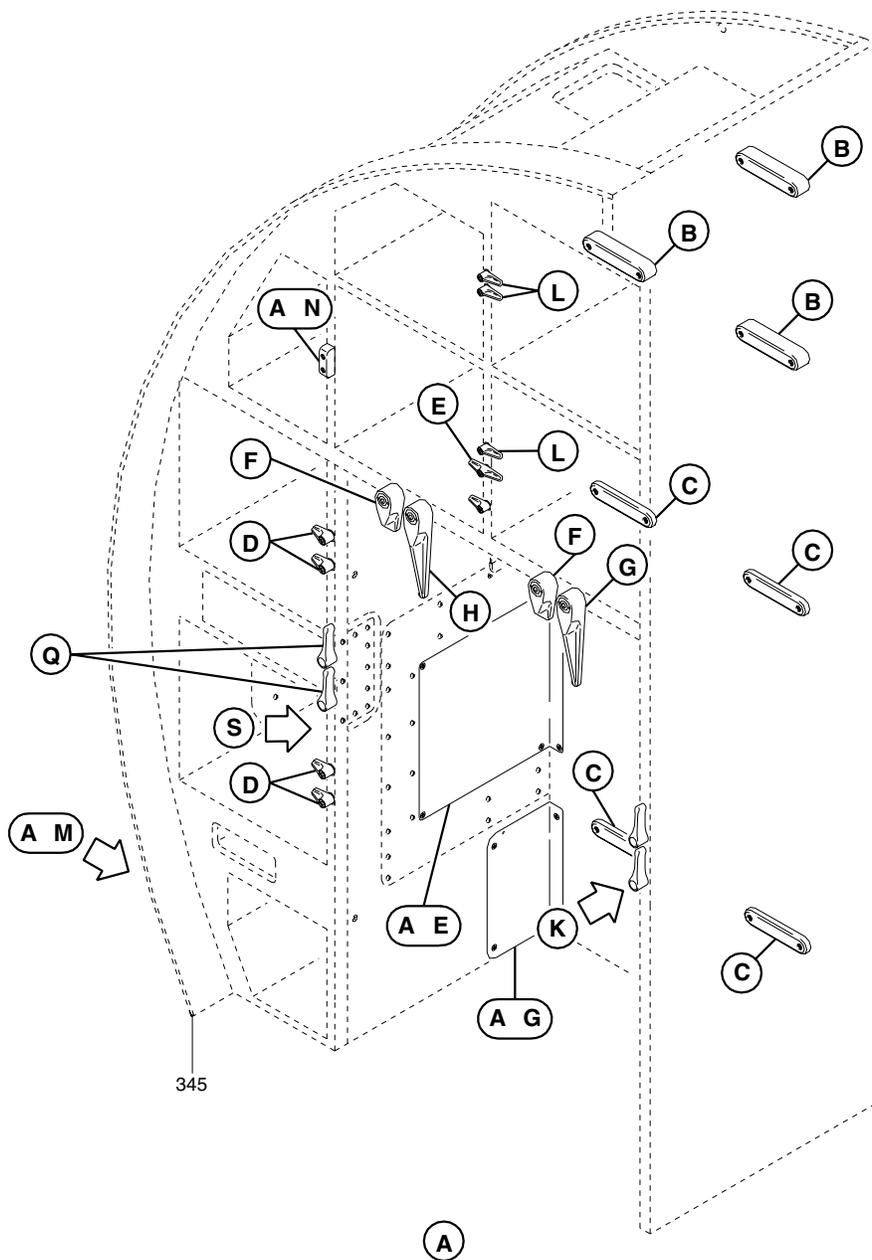
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G2 Galley Assembly
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 Figure 1/GRAPHIC 25-32-78-99b-001-A01

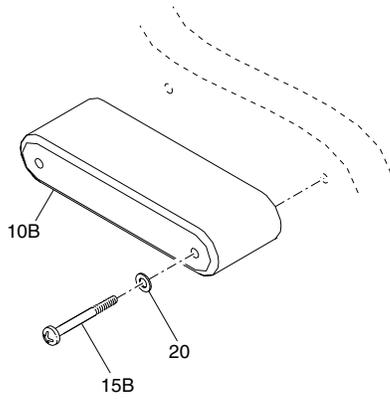
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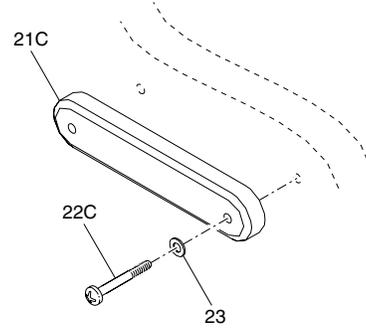
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G2 Galley Assembly
 (Sheet 2 of 13)
 Figure 1/GRAPHIC 25-32-78-99b-001-A01

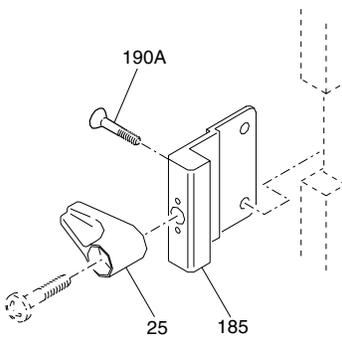
COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



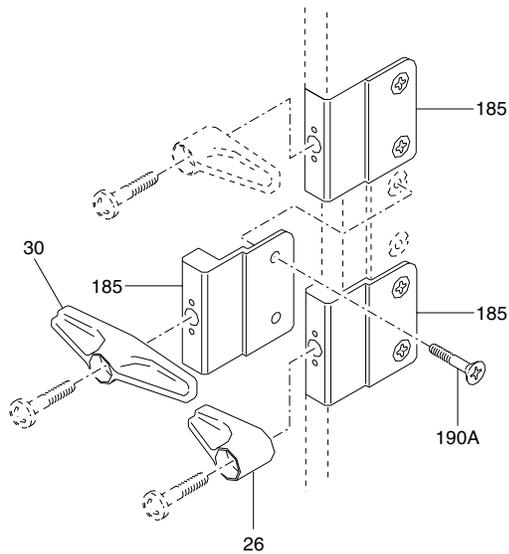
(B)



(C)



(D)

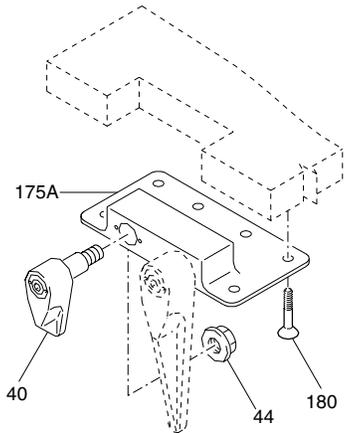


(E)

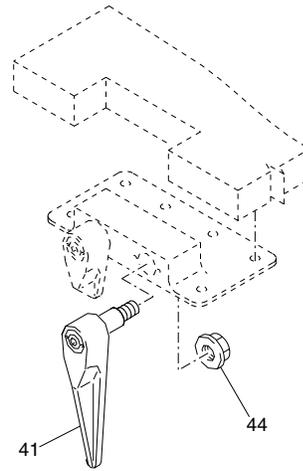
2532780103

G2 Galley Assembly
 (Sheet 3 of 13)
 Figure 1/GRAPHIC 25-32-78-99b-001-A01

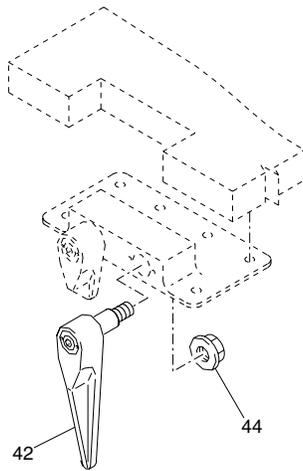
COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



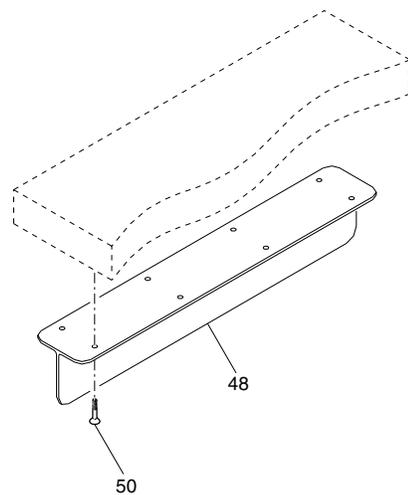
(F)



(G)



(H)

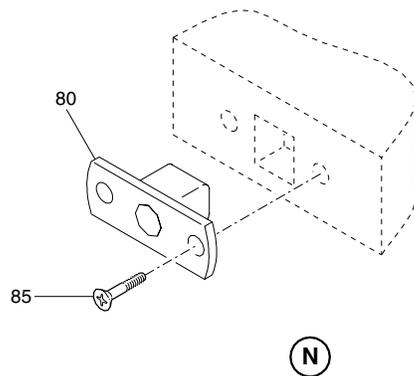
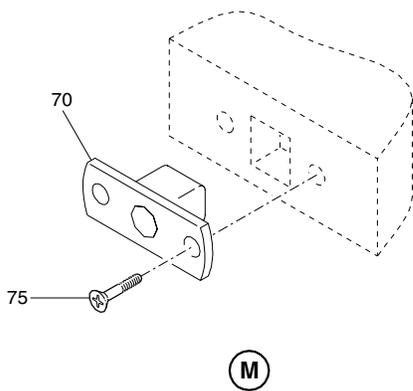
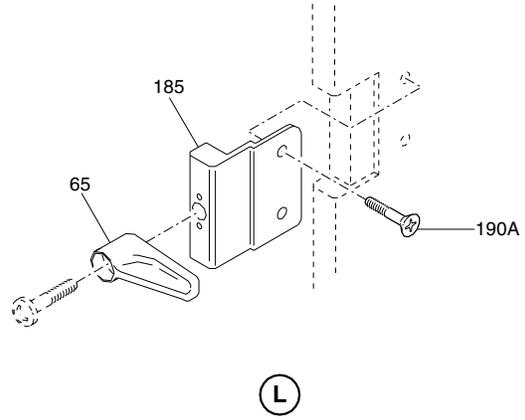
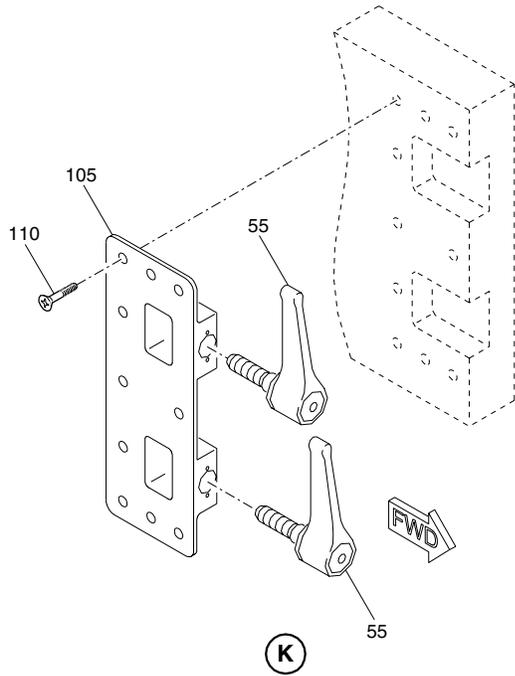


(J)

G2 Galley Assembly
 (Sheet 4 of 13)
 Figure 1/GRAPHIC 25-32-78-99b-001-A01

2532780104

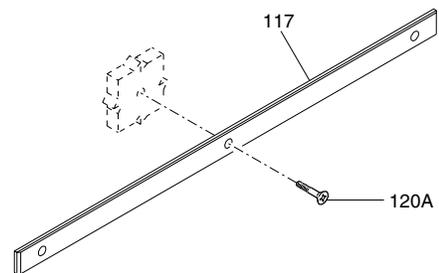
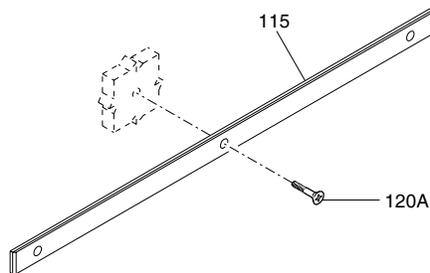
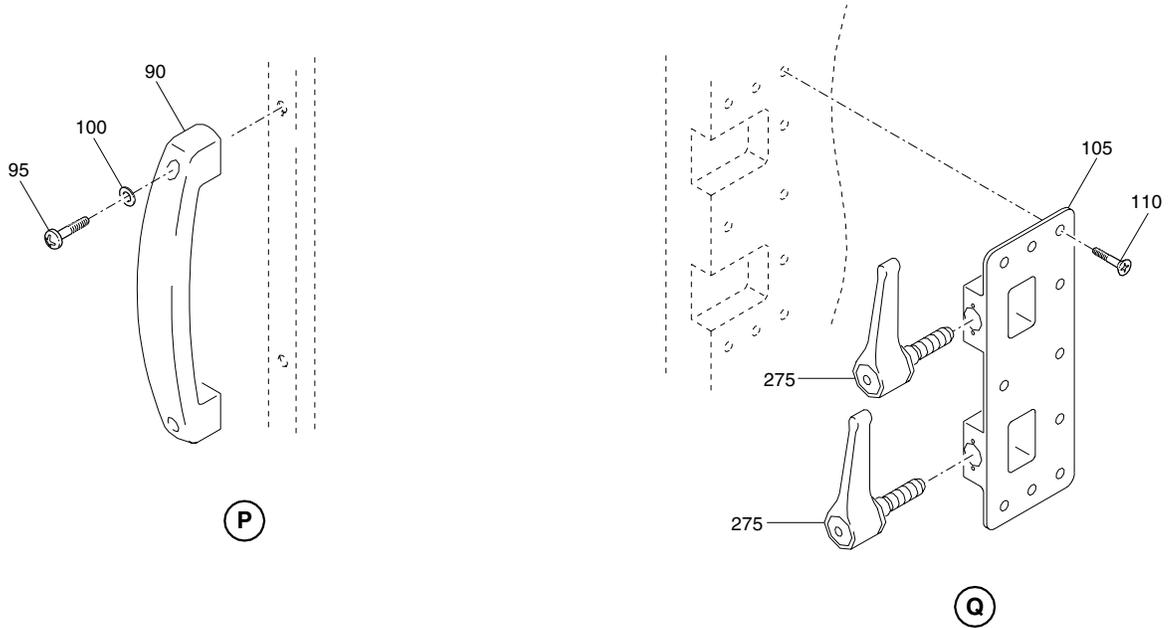
COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



2532780105

G2 Galley Assembly
 (Sheet 5 of 13)
 Figure 1/GRAPHIC 25-32-78-99b-001-A01

COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



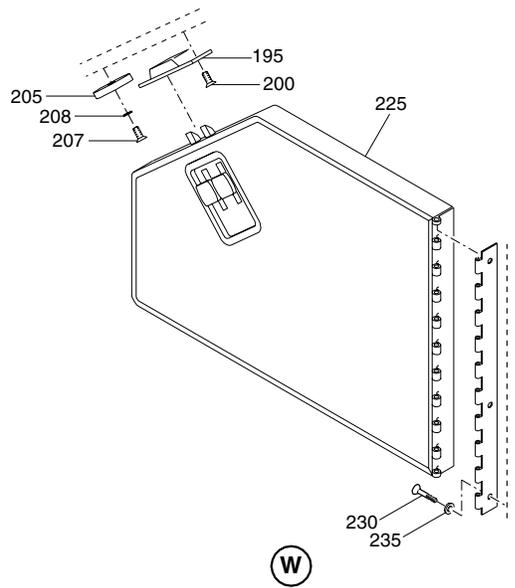
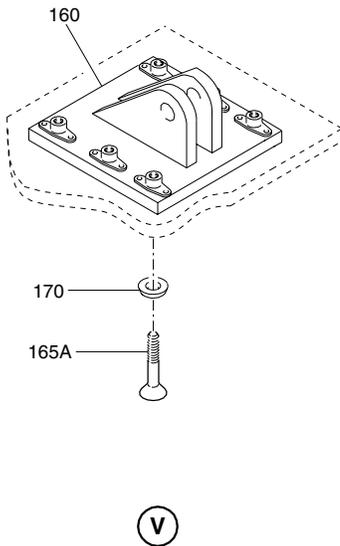
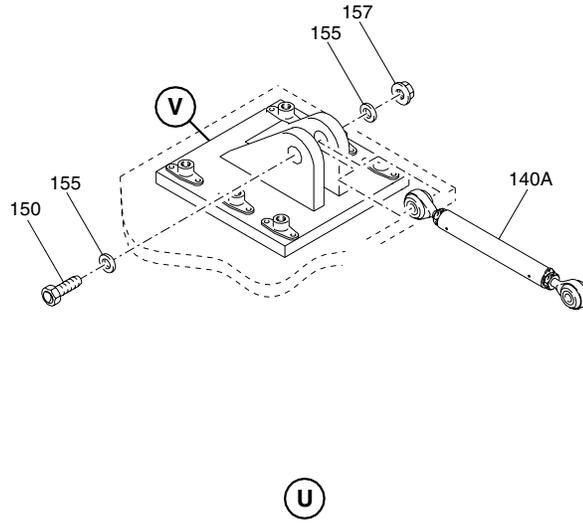
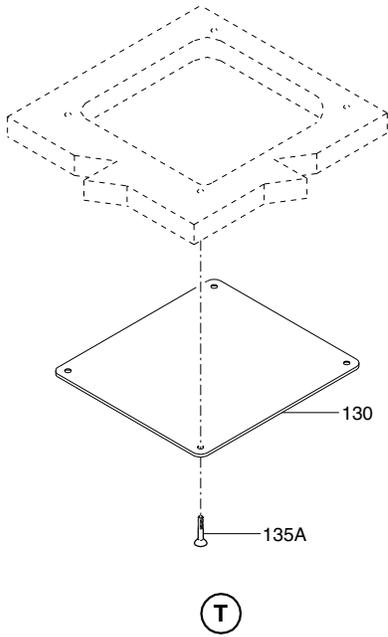
(R)

(S)

2532780106

G2 Galley Assembly
 (Sheet 6 of 13)
 Figure 1/GRAPHIC 25-32-78-99b-001-A01

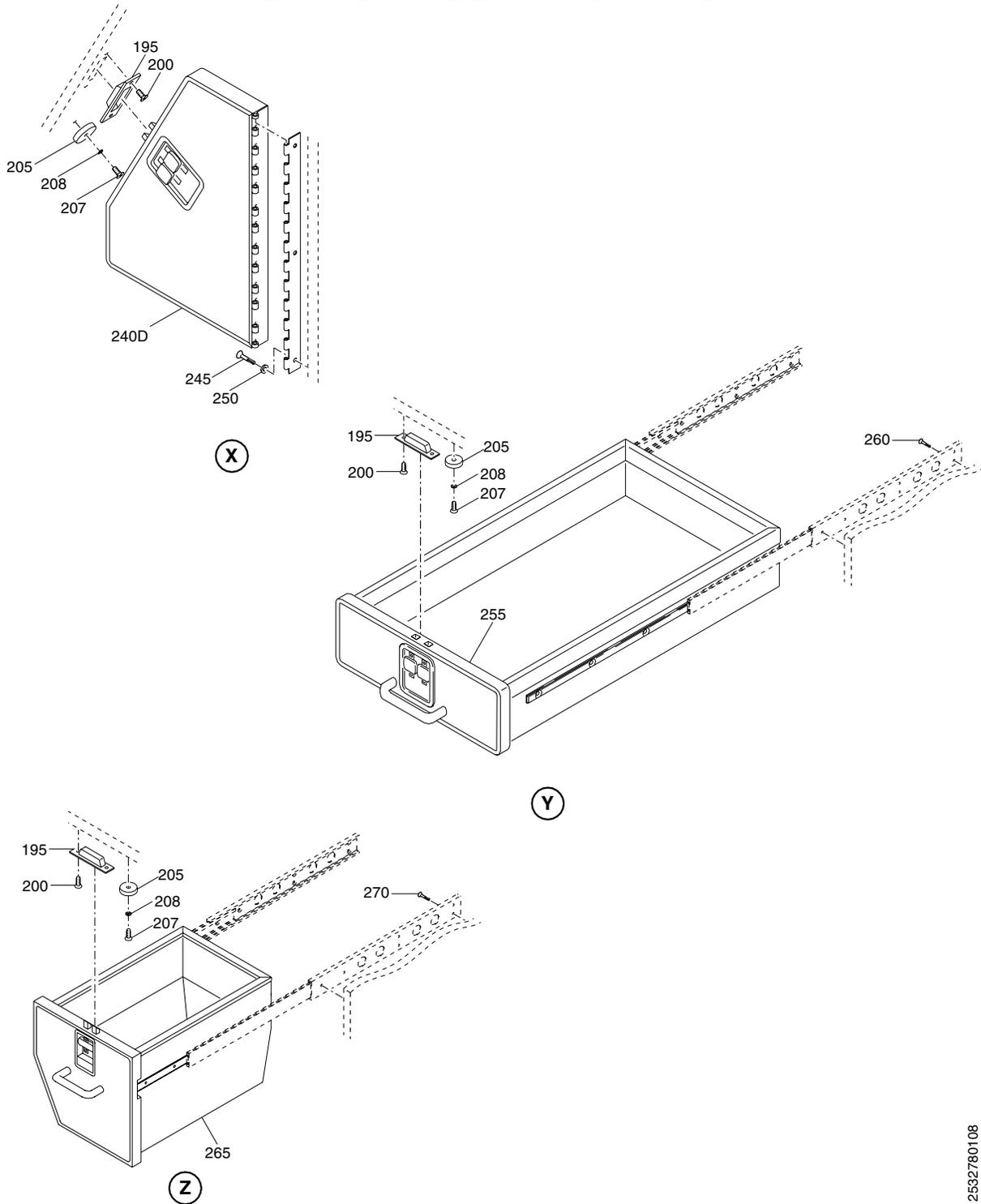
COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



2532780107

G2 Galley Assembly
 (Sheet 7 of 13)
 Figure 1/GRAPHIC 25-32-78-99b-001-A01

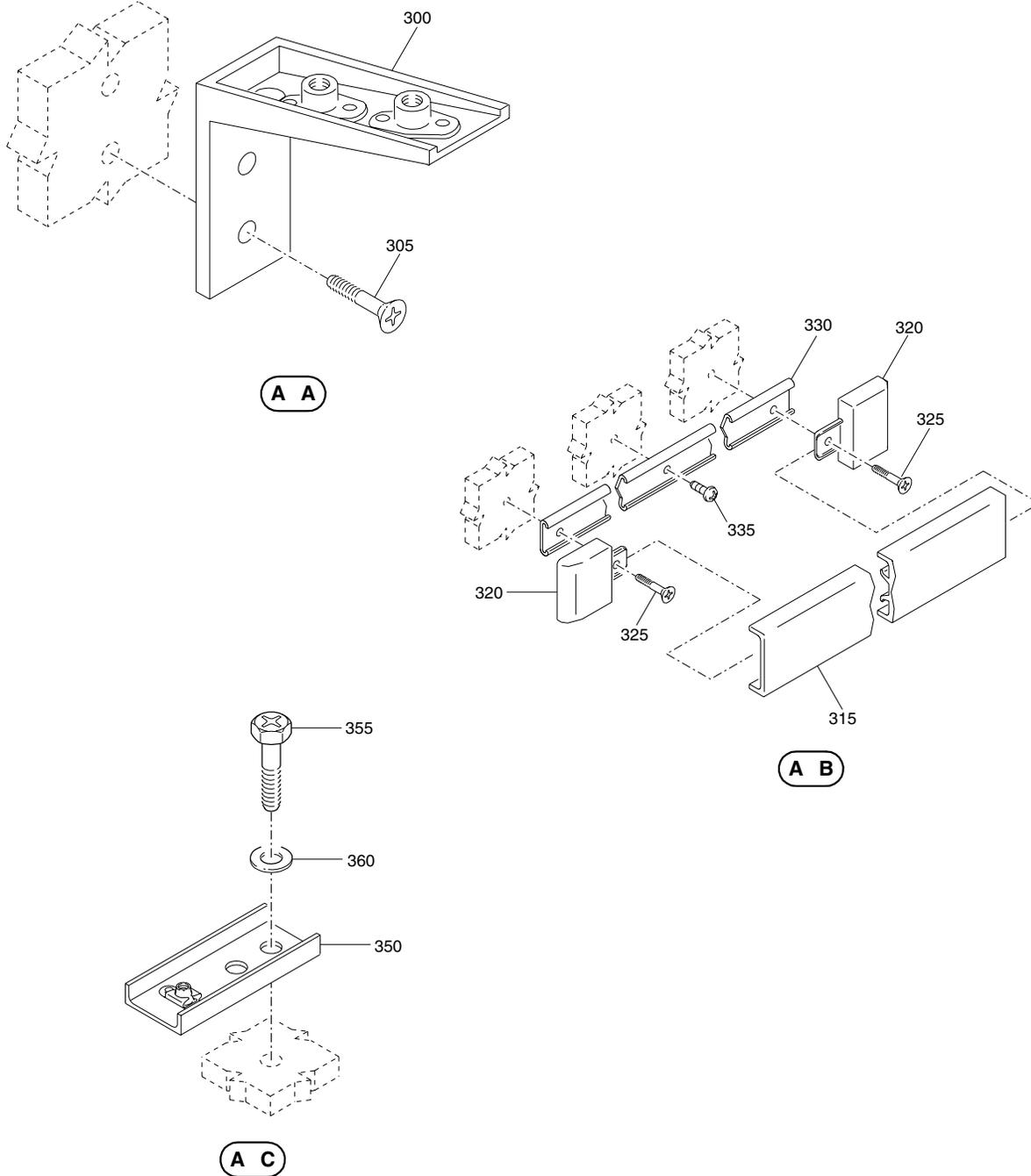
COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



G2 Galley Assembly
 (Sheet 8 of 13)
 Figure 1/GRAPHIC 25-32-78-99b-001-A01

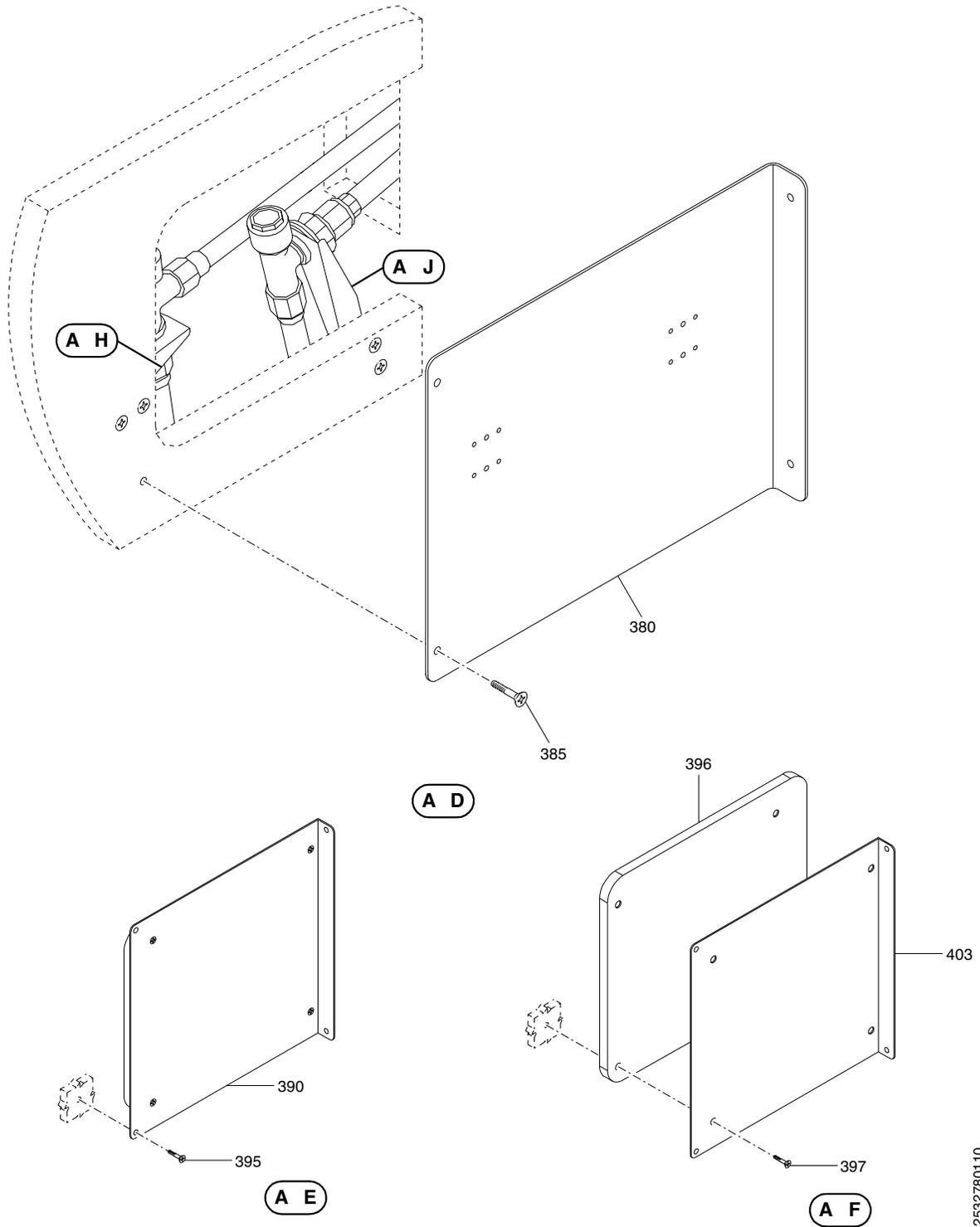
2532780108

COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



G2 Galley Assembly
 (Sheet 9 of 13)
 Figure 1/GRAPHIC 25-32-78-99b-001-A01

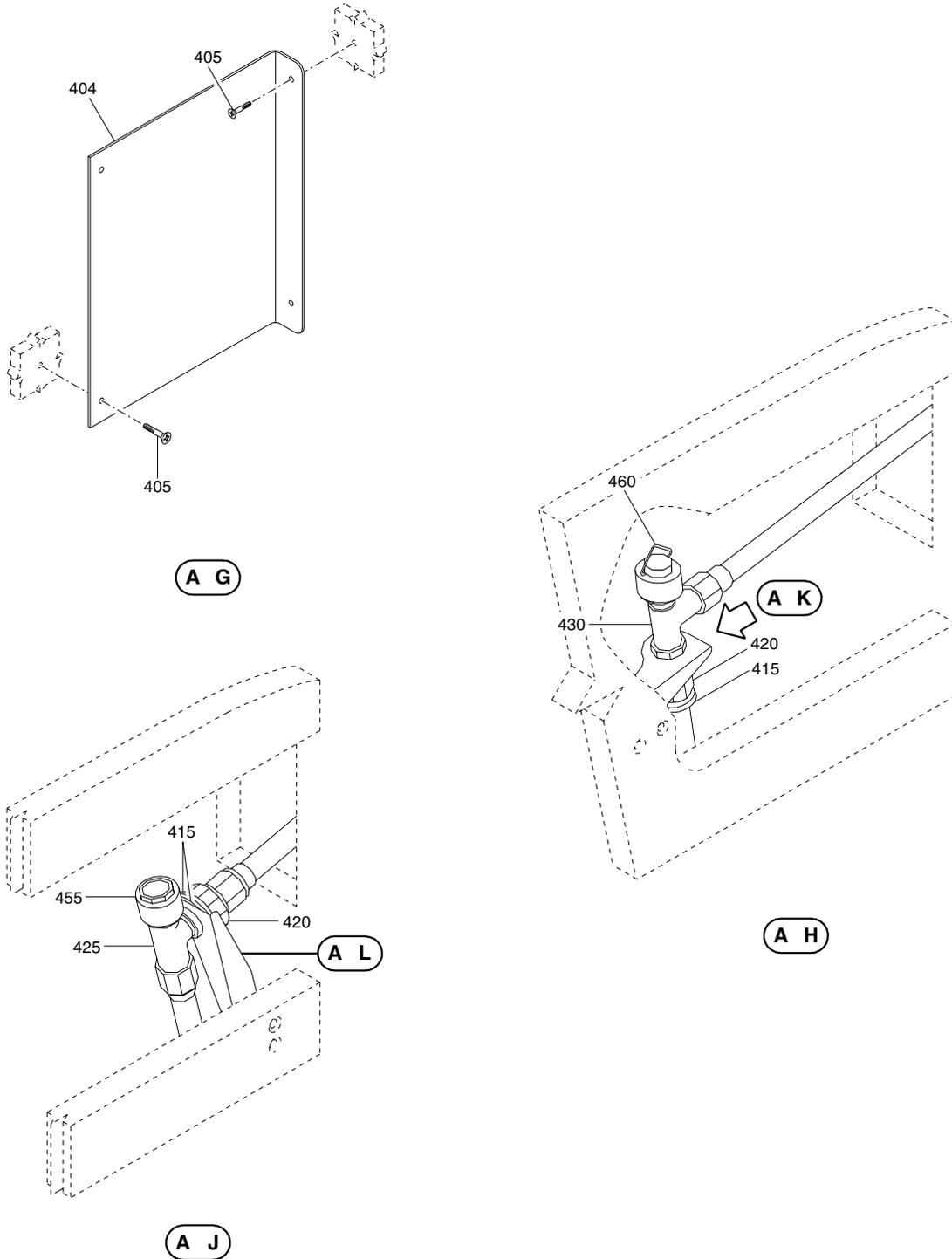
2532780109



2532780110

G2 Galley Assembly
 (Sheet 10 of 13)
 Figure 1/GRAPHIC 25-32-78-99b-001-A01

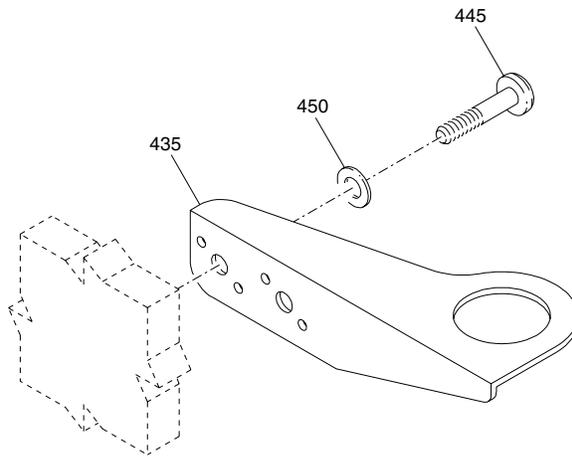
COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



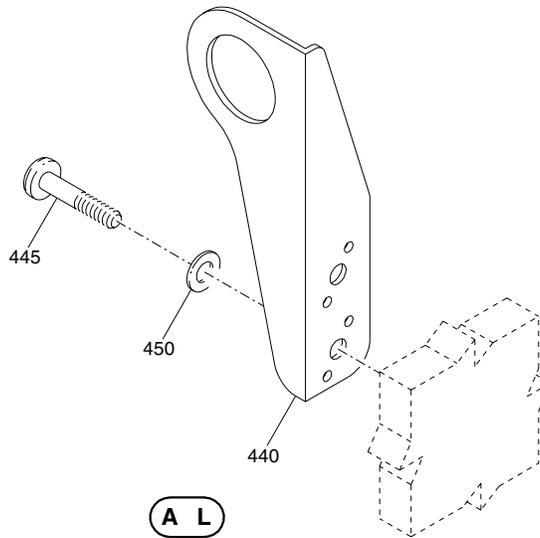
G2 Galley Assembly
 (Sheet 11 of 13)
 Figure 1/GRAPHIC 25-32-78-99b-001-A01

2532780111

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001



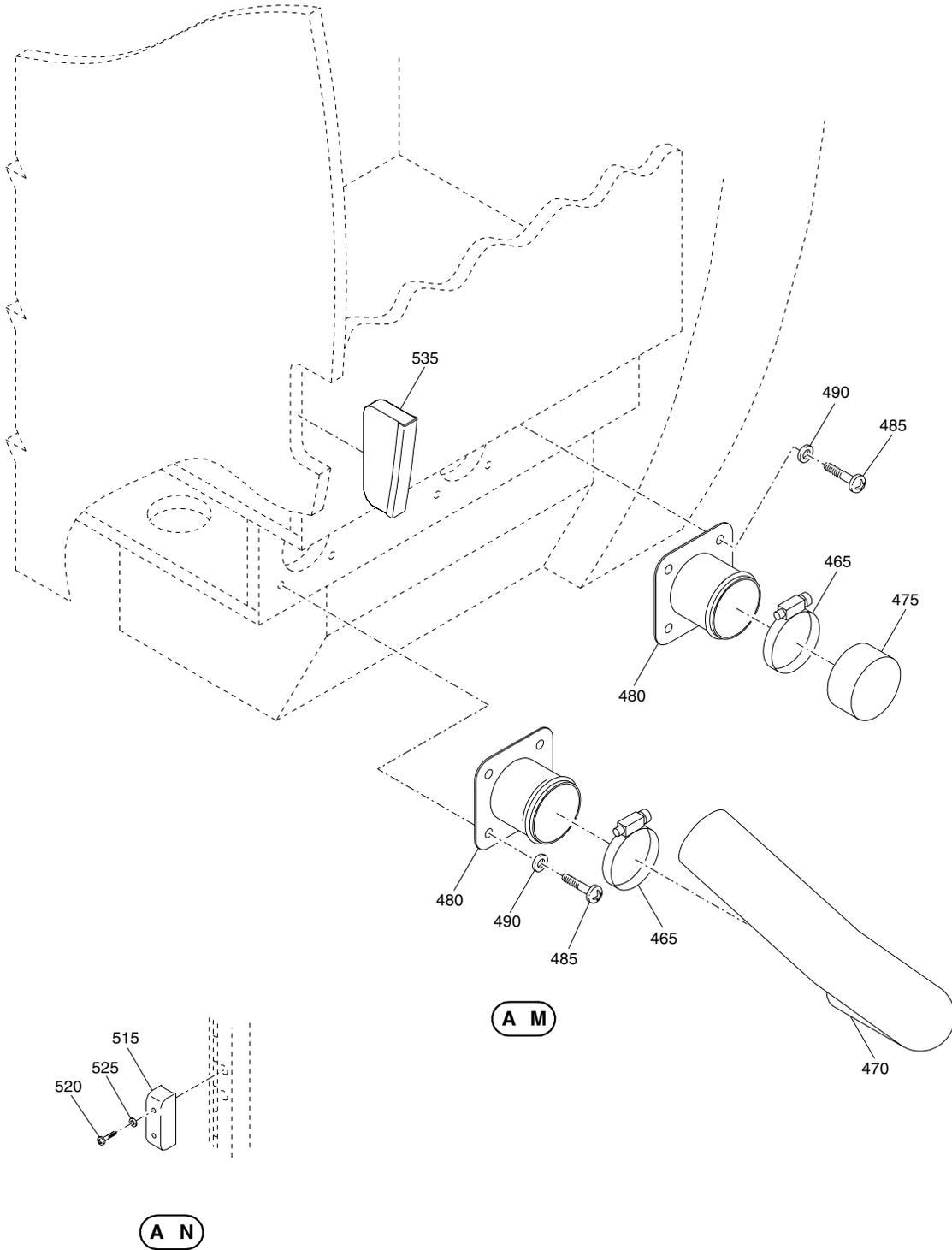
A K



A L

2532780112

G2 Galley Assembly
(Sheet 12 of 13)
Figure 1/GRAPHIC 25-32-78-99b-001-A01



G2 Galley Assembly
 (Sheet 13 of 13)
 Figure 1/GRAPHIC 25-32-78-99b-001-A01

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1 - 1	9861001-101		GALLEY ASSY, G2 (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM)	A	RF
- 1A	9861001-103		GALLEY ASSY, G2 (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM)	B	RF
- 1B	9861001-105		GALLEY ASSY, G2 (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM)	C	RF
- 1C	9861001-107		GALLEY ASSY, G2 (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM)	D	RF
- 1D	9861001-109		GALLEY ASSY, G2 (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM)	E	RF
- 1E	9861001-111		GALLEY ASSY, G2 (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM)	F	RF
- 1F	9861001-113		GALLEY ASSY, G2 (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM)	G	RF
- 1G	9861001-117		GALLEY ASSY, G2 (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM)	H	RF

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1 - 1H	9861001-121		GALLEY ASSY, G2 (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM)	J	RF
- 1J	9861001-115		GALLEY ASSY, G2 (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM) SEE FIG. 1F FOR NHA	K	RF
- 1K	9861001-123		GALLEY ASSY, G2 (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM)	L	RF
- 1L	9861001-119		GALLEY ASSY, G2 (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM)	M	RF
- 1M	9861001-125		GALLEY ASSY, G2 (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM)	N	RF
5	9861005-501		. ELECTRICAL INSTL SEE FIG. 2 FOR DET	A	1
- 5A	9861005-503		. ELECTRICAL INSTL SEE FIG. 2 FOR DET	B-E	1
- 5B	9861005-505		. ELECTRICAL INSTL SEE FIG. 2 FOR DET	F,M	1
- 5C	9861005-507		. ELECTRICAL INSTL SEE FIG. 2 FOR DET	G	1
- 5D	9861005-511		. ELECTRICAL INSTL SEE FIG. 2 FOR DET	H,L	1
- 5E	9861005-513		. ELECTRICAL INSTL SEE FIG. 2 FOR DET	J	1

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1 - 5F	9861005-509		. ELECTRICAL INSTL SEE FIG. 2 FOR DET	K	1
- 5G	9861005-515		. ELECTRICAL INSTL SEE FIG. 2 FOR DET	N	1
- 10	9861401-3		. DELETED		D
- 10A	9861401-7		. BUMPER, SU SUPSD BY ITEM 10B		3
10B	9861401-11		. BUMPER SUPSDS ITEM -10A ATTACHING PARTS		5
- 15	NAS514P1032-16		. DELETED		D
- 15A	NAS603-18		. SCREW SUPSD BY ITEM 15B		6
15B	NAS603-22		. SCREW SUPSDS ITEM -15A		10
20	NAS1149F0332P		. WASHER * * *		10
- 21	9861401-5		. BUMPER SUPSD BY ITEM -21B	A,G	4
- 21A	9861401-15		. DELETED (INC BY MISTAKE)	G	D
- 21B	9861401-1		. BUMPER SUPSD BY ITEM 21C SUPSDS ITEM -21	A,G	4
21C	9861401-5		. BUMPER SUPSDS ITEM -21B	A,G	4
- 21D	9861401-1		. BUMPER	H-N	4
- 21E	9861401-5		. BUMPER PRE SB 9861001-25-02	B-G	4
- 21F	9861401-1		. BUMPER ADDED POST SB 9861001-25-02	B-G	4

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1			ATTACHING PARTS		
- 22	NAS603-8		. SCREW SUPSD BY ITEM -22B	A-G	8
- 22A	NAS603-18		. DELETED (INC BY MISTAKE)		D
- 22B	NAS603-21		. SCREW SUPSD BY ITEM 22C SUPSDS ITEM -22	A-G	8
22C	NAS603-20		. SCREW SUPSDS ITEM -22B		8
- 22D	NAS603-20		. SCREW PRE SB 9861001-25-02	B-G	8
- 22E	NAS603-20		. SCREW ADDED POST SB 9861001-25-02	B-G	8
23	NAS1149F0332P		. WASHER		8
- 23A	NAS1149F0332P		. WASHER PRE SB 9861001-25-02	B-G	8
- 23B	NAS1149F0332P		. WASHER ADDED POST SB 9861001-25-02	B-G	8
			* * *		
25	CDSP1203-1		. RETAINER, SU		4
26	CDSP1203-1		. RETAINER, SU	A	1
- 27	CDSP1203-1		. RETAINER, SU	B-N	1
30	CDSP1218-1		. RETAINER, SU	A	1
- 32	CDSP1218-1		. RETAINER, SU	B-N	1
- 35	9861003-101		. DELETED		D
40	CDSP1202-1		. RETAINER, CART		2
41	CDSP1201-2		. RETAINER, CART		1
42	CDSP1201-2		. RETAINER, CART	A,D,N	1
- 42A	CDSP1220-2		. RETAINER, CART	B,C, E-M	1

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1 - 42B	CDSP1201-2		. DELETED	N	D
- 43	CDSP1220-2		. RETAINER, CART (MOVED TO ITEM -42A)	B,C, E-G	D
			ATTACHING PARTS		
44	MS21042L6		. NUT * * *		4
- 45	9861254-1		. DIVIDER, CART (MOVED TO ITEM 48)		D
			ATTACHING PARTS		
- 46	NAS1149F0632P		. WASHER * * *		4
48	9861254-1		. DIVIDER, CART ATTACHING PARTS		1
50	NAS514P1032-6		. SCREW * * *		8
55	CDSP1217-2		. RETAINER, CART		2
60	9393451-501		. BRACKET ASSY, FLOOD LIGHT (BONDED)	A-E,H, J,L	1
- 60A	9393451-503		. BRACKET ASSY, FLOOD LIGHT (BONDED)	F,G,K, M,N	1
65	CDSP1203-2		. RETAINER	A	3
- 67	CDSP1203-2		. RETAINER	B-N	3
70	9331528-501		. SOCKET ASSY ATTACHING PARTS		1
75	NAS514P832-6		. SCREW * * *		2
- 77	MS16562-214		.. PIN, SPRING		1
- 78	9331528-5		.. SOCKET		1

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1	80	9331528-1	. SOCKET ATTACHING PARTS		1
	85	NAS514P832-6	. SCREW * * *		2
	90	9331112-1	. HANDLE, ASSIST ATTACHING PARTS	A,E-N	1
	95	NAS603-18	. SCREW	A,E-N	2
	100	NAS1149F0332P	. WASHER * * *	A,E-N	2
	105	CDSP1416-501	. BLOCK ASSY, RETAINER ATTACHING PARTS		2
	110	NAS514P1032-8	. SCREW * * *		20
	115	9861402-11	. RUBSTRIP		12
	117	9861402-11	. RUBSTRIP	A,G-L	2
-	117A	9861402-3	. RUBSTRIP	B-F, M,N	2
-	118	9861402-3	. RUBSTRIP (MOVED TO ITEM 117A) ATTACHING PARTS	B-F, M,N	D
-	120	NAS514P1032-6	. DELETED		D
	120A	NAS514P832-6	. SCREW	A,G-L	42
-	120B	NAS514P832-6	. SCREW	B-F, M,N	40
-	122	NAS514P832-6	. SCREW (MOVED TO ITEM -120B) * * *	B-F, M,N	D
	125	9861009-501	. EXTRUSION INSTL SEE FIG. 9 FOR DET	A	1

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1 - 125A	9861009-503		. EXTRUSION INSTL SEE FIG. 9 FOR DET	B-E,G	1
- 125B	9861009-505		. EXTRUSION INSTL SEE FIG. 9 FOR DET	F	1
- 125C	9861009-509		. EXTRUSION INSTL SEE FIG. 9 FOR DET SUPSD BY ITEM -125D	H-K	1
- 125D	9861009-511		. EXTRUSION INSTL SEE FIG. 9 FOR DET SUPSDS ITEM -125C	H-L	1
- 125E	9861009-513		. EXTRUSION INSTL SEE FIG. 9 FOR DET	M	1
- 125F	9861009-515		. EXTRUSION INSTL SEE FIG. 9 FOR DET	N	1
130	9861352-1		. COVER, UPR ATCH ATTACHING PARTS	A-D	1
- 135	NAS514P1032-6		. DELETED		D
135A	NAS514P832-6		. SCREW * * *	A-D	4
- 140	4603059-509		. TIE-ROD ASSY SUPSD BY ITEM 140A	A-D	1
140A	CDSP2110-513		. TIE-ROD ASSY SUPSDS ITEM -140	A-M	1
- 140B	D461202-505		. TIE-ROD ASSY ATTACHING PARTS	N	1
- 145	MS21042L6		. DELETED		D
150	NAS6606-16		. BOLT		1
155	NAS1149F0632P		. WASHER		2
157	MS21042L6		. NUT * * *		1
160	9861252-501		. BRACKET ASSY, UPR ATCH		1

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1			ATTACHING PARTS		
- 165	NAS514P1032-21		. SCREW SUPSD BY ITEM 165A	A-C	6
165A	NAS514P1032-22		. SCREW SUPSDS ITEM -165		6
170	CDSP5801-3AL		. WASHER * * *		6
- 175	CDSP1418-1		. BLOCK, CART RETAINER SUPSD BY ITEM 175A	A	2
175A	4602326-1		. BLOCK, CART RETAINER SUPSDS ITEM -175		2
- 175B	4602326-1		. DELETED ATTACHING PARTS	N	D
180	NAS514P1032-7		. SCREW * * *		12
185	CDSP1403-501		. BLOCK, SU RETAINER		9
- 187	CDSP1403-501		. DELETED ATTACHING PARTS	D	D
- 190	NAS514P1032-7		. SCREW SUPSD BY ITEM 190A	A-D	18
190A	NAS514P1032-6		. SCREW SUPSDS ITEM -190 * * *		18
195	CDSP1107-1		. STRIKER ATTACHING PARTS		4
200	NAS514P632-5		. SCREW * * *		8
205	CDSP5602-1		. STOP, DOOR		4

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1			ATTACHING PARTS		
	207	NAS514P832-10	. SCREW		4
	208	NAS1149F0363P	. WASHER		4
	- 210	NAS514P1032-8	. DELETED * * *		D
	215	CDPL160-13	. NAMEPLATE		1
			ATTACHING PARTS		
	- 220	AD32BS	. RIVET * * *		4
	225	9861101-501	. DOOR ASSY SEE FIG. 3 FOR DET	A	1
	- 225A	9861101-503	. DOOR ASSY SEE FIG. 3 FOR DET PRE SB 9861001-25-01	B	1
	- 225B	9861101-507	. DOOR ASSY SEE FIG. 3 FOR DET ADDED POST SB 9861001-25-01	B	1
	- 225C	9861101-507	. DOOR ASSY SEE FIG. 3 FOR DET	C,E-G, M,N	1
	- 225D	9861101-505	. DOOR ASSY SEE FIG. 3 FOR DET	D	1
	- 225E	9861101-503	. DOOR ASSY SEE FIG. 3 FOR DET ATTACHING PARTS	B,H-L	1
	230	NAS514P832-6	. SCREW		3
	235	CDSP5801-2AL	. WASHER * * *		3
	- 240	9861102-501	. DOOR ASSY SEE FIG. 4 FOR DET PRE SB 9861001-25-01	B	1

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1 - 240A	9861102-505		. DOOR ASSY SEE FIG. 4 FOR DET ADDED POST SB 9861001-25-01	B	1
- 240B	9861102-505		. DOOR ASSY SEE FIG. 4 FOR DET	C,E-G, M,N	1
- 240C	9861102-503		. DOOR ASSY SEE FIG. 4 FOR DET	D	1
240D	9861102-501		. DOOR ASSY SEE FIG. 4 FOR DET ATTACHING PARTS	A,B, H-L	1
245	NAS514P832-6		. SCREW		3
250	CDSP5801-2AL		. WASHER * * *		3
255	9861103-501		. DRAWER ASSY SEE FIG. 5 FOR DET ATTACHING PARTS		1
260	NAS514P832-6		. SCREW * * *		12
265	9861104-501		. DRAWER ASSY SEE FIG. 6 FOR DET	A,G,H-L	1
- 265A	9861105-501		. DRAWER ASSY SEE FIG. 6 FOR DET	B-F,M	1
- 265B	9862109-501		. DRAWER ASSY SEE FIG. 6 FOR DET ATTACHING PARTS	N	1
270	NAS514P832-6		. SCREW * * *		12
275	CDSP1217-1		. RETAINER, CART		2
- 280	9861401-1		. DELETED ATTACHING PARTS		D
- 285	NAS514P1032-20		. DELETED		D

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1 - 285A	NAS603-8		. DELETED		D
- 290	NAS1149F0332P		. DELETED * * *		D
295	9861403-1		. RUBSTRIP, SU (BONDED)		10
300	9861253-501		. BRACKET ATTACHING PARTS	A,E	1
305	NAS514P1032-6		. SCREW * * *	A,E	2
- 310	9393401-505		. RUBSTRIP ASSY		1
315	9393401-5		.. RUBSTRIP		1
320	M25L1006-9		.. END CAP ATTACHING PARTS		2
325	NAS514P632-6		.. SCREW * * *		2
330	9393401-55		.. RETAINER ATTACHING PARTS		1
335	MS35206-227		.. SCREW * * *		1
- 340	9861004-501		. STRUCTURE ASSY, BONDED (MOVED TO ITEM 590)	A	D
- 340A	9861004-503		. STRUCTURE ASSY, BONDED (MOVED TO ITEM -590A)	B,C	D
- 340B	9861004-505		. STRUCTURE ASSY, BONDED (MOVED TO ITEM -590B)	D	D
- 340C	9861004-507		. STRUCTURE ASSY, BONDED (MOVED TO ITEM -590C)	E	D
- 340D	9861004-509		. STRUCTURE ASSY, BONDED (MOVED TO ITEM -590D)	F,M	D

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1 - 340E	9861004-511		. STRUCTURE ASSY, BONDED (MOVED TO ITEM -590E)	G	D
- 340F	9861004-515		. STRUCTURE ASSY, BONDED (MOVED TO ITEM -590F)	H,J	D
- 340G	9861004-513		. STRUCTURE ASSY, BONDED (MOVED TO ITEM -590G)	K	D
- 340H	9861004-517		. STRUCTURE ASSY, BONDED (MOVED TO ITEM -590H)	L	D
- 340J	9861004-519		. STRUCTURE ASSY, BONDED (MOVED TO ITEM -590J)	N	D
345	9861001-1		. SEAL, GAP (BONDED)		1
350	9394702-505		. BRACKET ASSY, CURTAIN TRACK SUPPORT	B-D	1
			ATTACHING PARTS		
355	NAS1096-3-5		. SCREW	B-D	2
360	NAS1149F0332P		. WASHER	B-D	2
			* * *		
- 365	NAS602-8		. SCREW SUPSD BY ITEM -365A	B-D	1
- 365A	NAS514P832-8		. SCREW SUPSDS ITEM -365	B-E,N	1
370	MS27980-7C		. STUD	B-E,N	1
- 375	AKS4-832-80L		. RIVNUT (V78276)	B-E,N	1
- 376	NAS514P832-8		. DELETED (INC BY MISTAKE)	G-L	D
- 377	MS27980-7C		. DELETED (INC BY MISTAKE)	G-L	D
380	9861352-9		. COVER, ANGLE ACCESS	B-D	1

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1			ATTACHING PARTS		
	385 NAS514P832-5		. SCREW * * *	B-D	4
	390 9861151-501		. COVER ASSY ATTACHING PARTS	B-D	1
	395 NAS514P832-5		. SCREW * * *	B-D	4
	396 9861151-601		.. PANEL ASSY (BONDED) ATTACHING PARTS		1
	397 NAS514P832-5		.. SCREW * * *		4
- 398	CDSP5905-08-13		... INSERT		4
- 399	9861151-1		... PANEL		1
- 400	9861352-3		. COVER, ACCESS (MOVED TO ITEM 404)	B-D	D
	403 9861352-5		.. COVER		1
	404 9861352-3		. COVER, ACCESS ATTACHING PARTS	B-D	1
	405 NAS514P832-5		. SCREW * * *	B-D	4
	415 NAS1149C1290R		. WASHER	B-F, M,N	3
	420 MS21083C12		. NUT	B-F, M,N	2
	425 AN834-8J		. TEE	B-F, M,N	1
	430 AS4134J080808		. TEE	B-F, M,N	1

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1	435 9861302-1		. BRACKET, TEE FITTING SUPPORT	B-F, M,N	1
	440 9861302-3		. BRACKET, TEE FITTING SUPPORT	B-F, M,N	1
			ATTACHING PARTS		
	445 NAS603-5		. SCREW	B-F, M,N	4
	450 NAS1149F0332P		. WASHER	B-F, M,N	4
			* * *		
	455 AN929-8J		. CAP ASSY, ½ FARED TUBING	B-F, M,N	1
	460 MS21914-8J		. CAP ASSY, ½ FARELESS TUBING	B-F, M,N	1
	465 NAS1922-0200-3		. CLAMP, HOSE	B-F, M,N	3
	470 BE725-8-88-5		. HOSE, AIR DUCT FLEXIBLE (V05399)	B-F, M,N	1
	475 9753K93		. CAP, VINYL (V3A054)	B-F, M,N	1
	480 9861260-501		. FITTING ASSY, AIR DUCT	B-F, M,N	3
			ATTACHING PARTS		
	485 NAS603-7		. SCREW	B-F, M,N	12
	490 NAS1149F0332P		. WASHER	B-F, M,N	12
			* * *		
	- 495 CDSP5304-100-10		. SEAL (TRUE PN CDSP5304-100-100-74) SUPSD BY ITEM 495A	B,C	1

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1 495A	CDSP5307-100-10		. SEAL (BONDED) (TRUE PN CDSP5307-100-100-74) SUPSDS ITEM -495	B-E	1
- 495B	CDSP5307		. DELETED	D	D
500	SJ5303		. BUMPON (V04963) (BONDED)	C,E-G, M,N	4
- 500A	SJ5303		. BUMPON (V04963) (BONDED)	H-L	2
505	9863303-1		. TRIM, BASE ATTACHING PARTS	D-N	1
510	NAS514P1032-6		. SCREW * * *	D-N	3
515	9861405-1		. BUMPER ATTACHING PARTS	E-M	4
520	NAS602-13		. SCREW	E-M	8
- 520A	NAS602-6P		. DELETED	N	D
525	NAS1149FN832P		. WASHER	E-M	8
- 525A	NAS1149FN832P		. DELETED * * *	N	D
- 530	AKS4-832-80L		. RIVNUT (V78276)	E-N	4
- 530A	AKS4-832-80L		. DELETED	M	D
- 530B	AKS4-832-80L		. DELETED	N	D
- 532	NAS602-6P		. SCREW	N	1
- 533	NAS1149FN832P		. WASHER	N	1
535	9861030-501		. PANEL ASSY, CLOSEOUT	G	1
- 537	9861030-3		. TRIM (BONDED)		1

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1 - 538	9861030-1		. . PANEL		1
- 540	NAS514P832-8		. SCREW	F,M	1
545	MS27980-7C		. STUD	F,M	1
- 550	AKS4-832-80L		. RIVNUT (V78276)	F,M	1
- 555	NAS514P832-8		. DELETED	F,G	D
- 560	MS27980-7C		. DELETED	F,G	D
- 565	NAS514P832-8		. SCREW	G-L	2
570	MS27980-7C		. STUD	G-L	2
- 575	9861007-503		. PLACARD INSTL SEE FIG. 8 FOR DET	J,L	1
- 575A	9861007-501		. PLACARD INSTL SEE FIG. 8 FOR DET	H	1
- 580	CDPL604-1-98610		. PLACARD, SB INCORPORATION (BONDED) (TRUE PN CDPL604-1-9861001-25-02) ADDED BY SB 9861001-25-02	B-G	1
- 585	9392453-505		. DELETED		D
585A	9392451-501		. LITERATURE POCKET ASSY	A	RF
- 585B	9392452-501		. LITERATURE POCKET ASSY	G,H,K	RF
- 585C	9392453-503		. LITERATURE POCKET ASSY	J	RF
590	9861004-501		. STRUCTURE ASSY, BONDED SEE FIG. 7 FOR DET	A	1
- 590A	9861004-503		. STRUCTURE ASSY, BONDED SEE FIG. 7 FOR DET	B,C	1
- 590B	9861004-505		. STRUCTURE ASSY, BONDED SEE FIG. 7 FOR DET	D	1
- 590C	9861004-507		. STRUCTURE ASSY, BONDED SEE FIG. 7 FOR DET	E	1
- 590D	9861004-509		. STRUCTURE ASSY, BONDED SEE FIG. 7 FOR DET	F,M	1

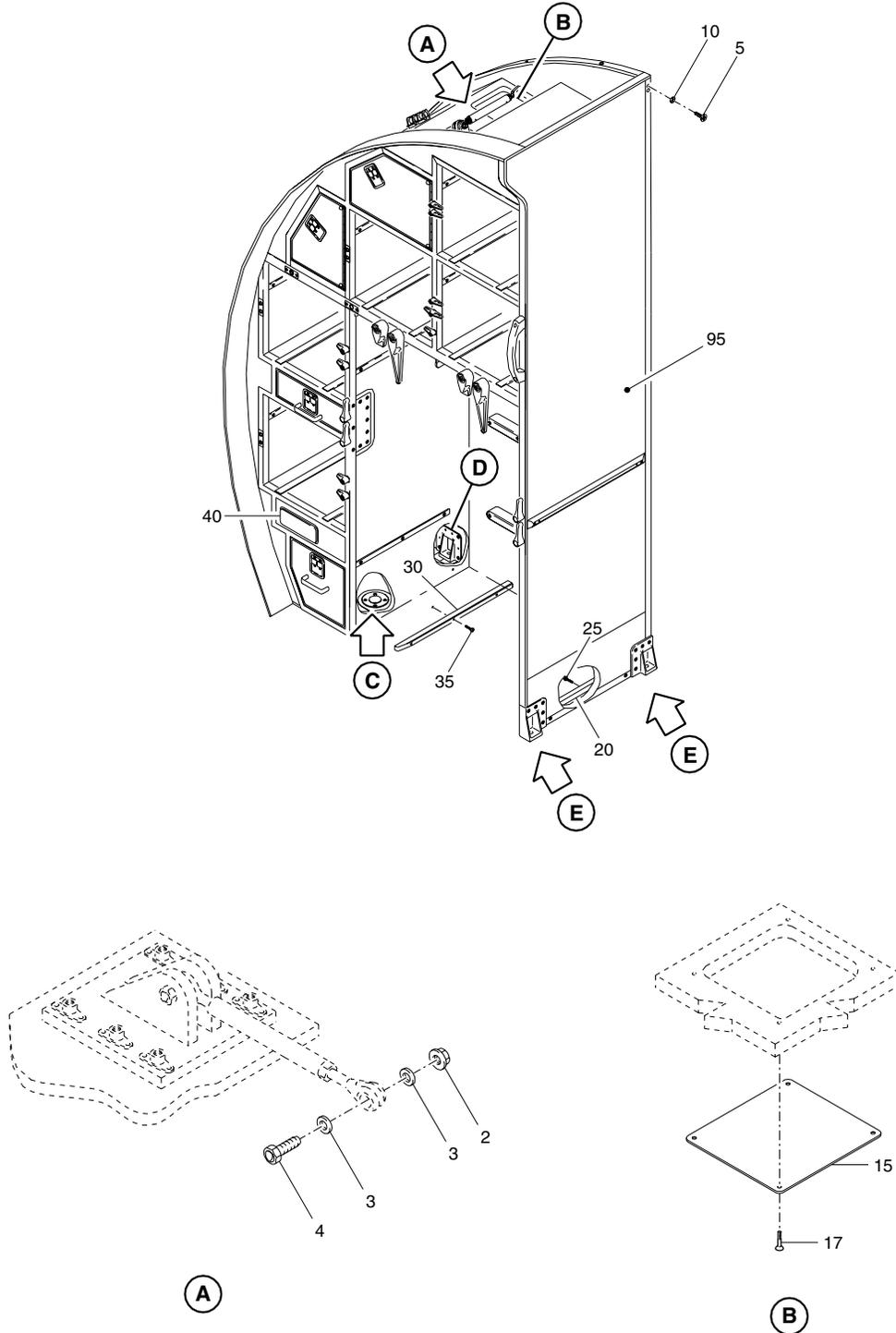
- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1 - 590E	9861004-511		. STRUCTURE ASSY, BONDED SEE FIG. 7 FOR DET	G	1
- 590F	9861004-515		. STRUCTURE ASSY, BONDED SEE FIG. 7 FOR DET	H,J	1
- 590G	9861004-513		. STRUCTURE ASSY, BONDED SEE FIG. 7 FOR DET	K	1
- 590H	9861004-517		. STRUCTURE ASSY, BONDED SEE FIG. 7 FOR DET	L	1
- 590J	9861004-519		. STRUCTURE ASSY, BONDED SEE FIG. 7 FOR DET	N	1

- ITEM NOT ILLUSTRATED

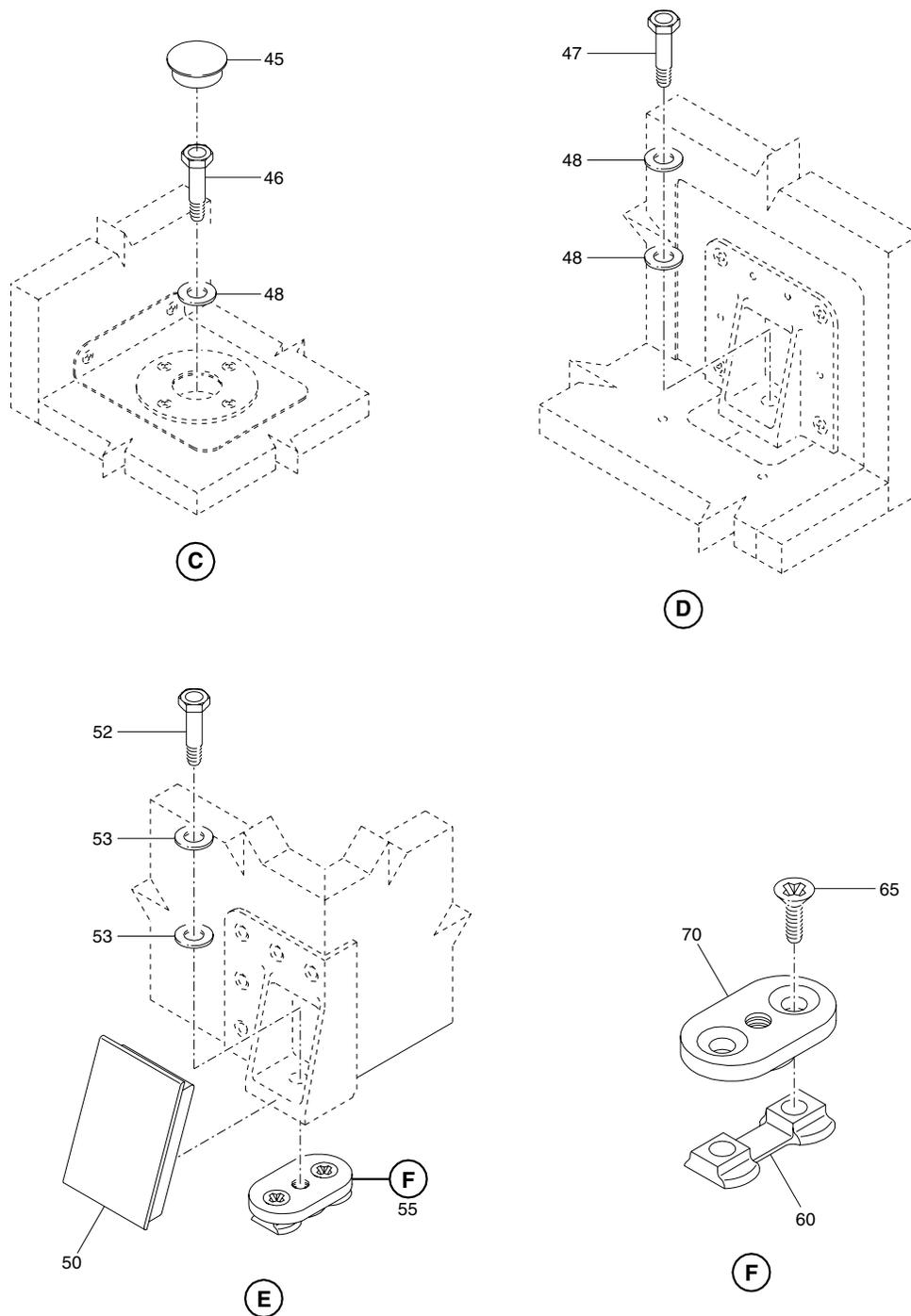
COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



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G2 Galley Installation
 (Sheet 1 of 2)
 Figure 1A/GRAPHIC 25-32-78-99b-002-A01

COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



G2 Galley Installation
 (Sheet 2 of 2)
 Figure 1A/GRAPHIC 25-32-78-99b-002-A01

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COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1A	- 1	H511201-101	GALLEY INSTL, G2		RF
	2	MS21042L6	. NUT		1
	3	NAS1149F0632P	. WASHER		2
	4	NAS6606-11	. BOLT		1
	5	NAS514P1032-6	. SCREW		2
	10	CDSP5801-3AL	. WASHER		2
	15	9861352-1	. COVER		1
			ATTACHING PARTS		
	17	NAS514P832-4	. SCREW		4

	20	E191032-501	. WHEEL GUIDE ASSY, INBD		1
			ATTACHING PARTS		
	25	NAS603-6P	. SCREW		4

	- 27	E191032-5	.. TAPE, DOUBLE SIDED (BONDED)		AR
	- 28	E191032-7	.. CAP (BONDED)		1
	- 29	E191032-3	.. WHEEL GUIDE (ALT PN CDSP2400-62)		1
	30	E191032-1	. WHEEL GUIDE, OUTBD		1
			ATTACHING PARTS		
	35	NAS603-6P	. SCREW		3

	40	BR9279-232	. FLOODLIGHT (V17023)		1
	45	85985K27	. PLUG, NYLON FINISHING (V3A054)		1

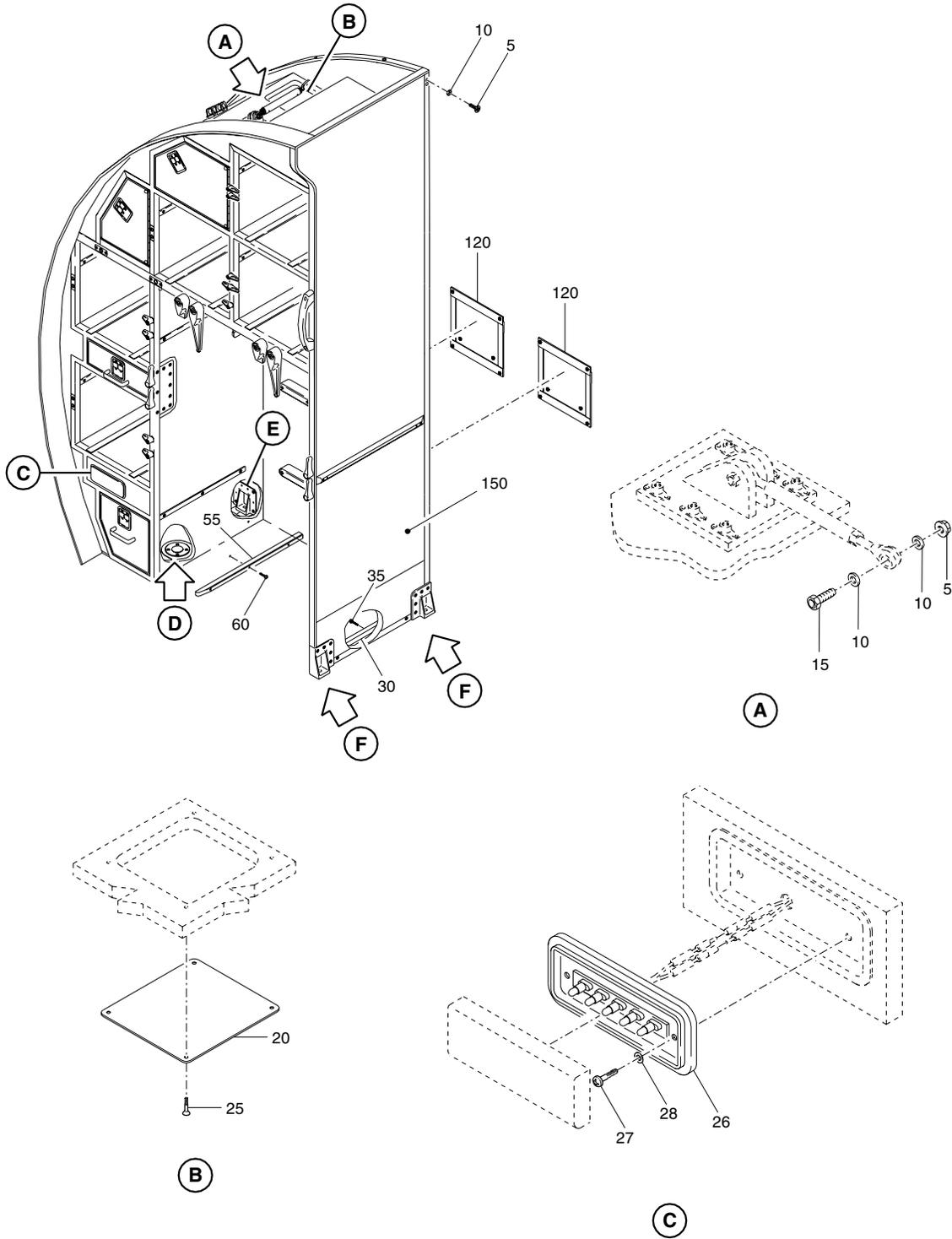
- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1A	46	NAS6606-11	. BOLT		1
	47	NAS6606-15	. BOLT		1
	48	NAS1149F0632P	. WASHER		3
	50	CDSP2020-1	. COVER, FLOOR FITTING		2
	52	NAS6205-5	. BOLT		2
	53	NAS1149F0532P	. WASHER		4
	55	CDSP1900-501	. FITTING ASSY, SEAT TRACK		2
	60	CDSP1900-1	.. RETAINER		1
			ATTACHING PARTS		
	65	CDSP5810-4-7	.. SCREW		2
			* * *		
	70	CDSP1900-3	.. FITTING		1
	- 75	CDSP5307-100-10	. FOAM (BONDED) (TRUE PN CDSP5307-100-100-100)		1
	- 80	CDSP5307-100-10	. FOAM (BONDED) (TRUE PN CDSP5307-100-100-025)		2
	- 85	CD1054-11	. DELETED		D
			ATTACHING PARTS		
	- 90	AD32BS	. DELETED		D
			* * *		
	95	9861001-121	. GALLEY ASSY, G2 SEE FIG. 1 FOR DET		1

- ITEM NOT ILLUSTRATED

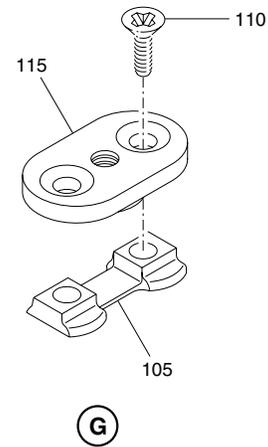
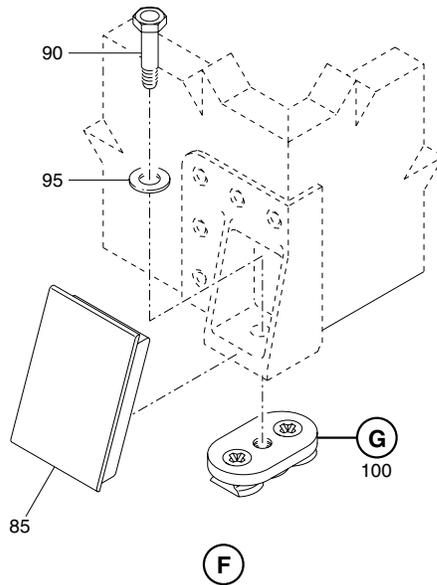
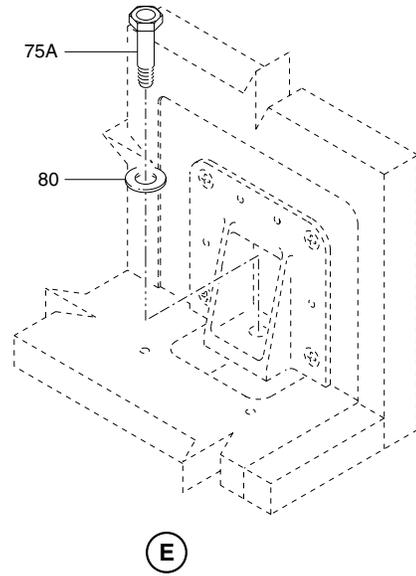
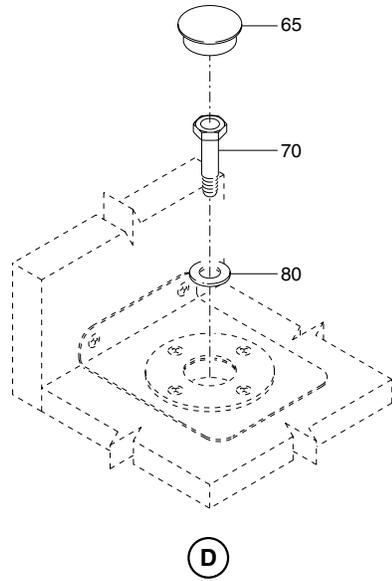
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G2 Galley Installation
 (Sheet 1 of 2)
 Figure 1B/GRAPHIC 25-32-78-99b-003-A01

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COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



G2 Galley Installation
 (Sheet 2 of 2)
 Figure 1B/GRAPHIC 25-32-78-99b-003-A01

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COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1B	- 1 J061502-101		GALLEY INSTL, G2		RF
	5 MS21042L6		. NUT		1
	10 NAS1149F0632P		. WASHER		2
	15 NAS6606-11		. BOLT		1
	20 9861352-1		. COVER		1
			ATTACHING PARTS		
	25 NAS514P832-4		. SCREW		4

	26 BR9279-232		. FLOODLIGHT		1
			ATTACHING PARTS		
	27 NAS514P1032-6		. SCREW		2
	28 CDSP5801-3AL		. WASHER		2

	30 E191032-501		. WHEEL GUIDE ASSY, INBD		1
			ATTACHING PARTS		
	35 NAS603-6P		. SCREW		2

	- 40 E191032-5		.. TAPE, DOUBLE SIDED (BONDED)		AR
	- 45 E191032-7		.. CAP (BONDED)		1
	- 50 E191032-3		.. WHEEL GUIDE (ALT PN CDSP2400-62)		1
	55 E191032-1		. WHEEL GUIDE, OUTBD (ALT PN CDSP2400-62)		1
			ATTACHING PARTS		
	60 NAS603-6P		. SCREW		3

- ITEM NOT ILLUSTRATED

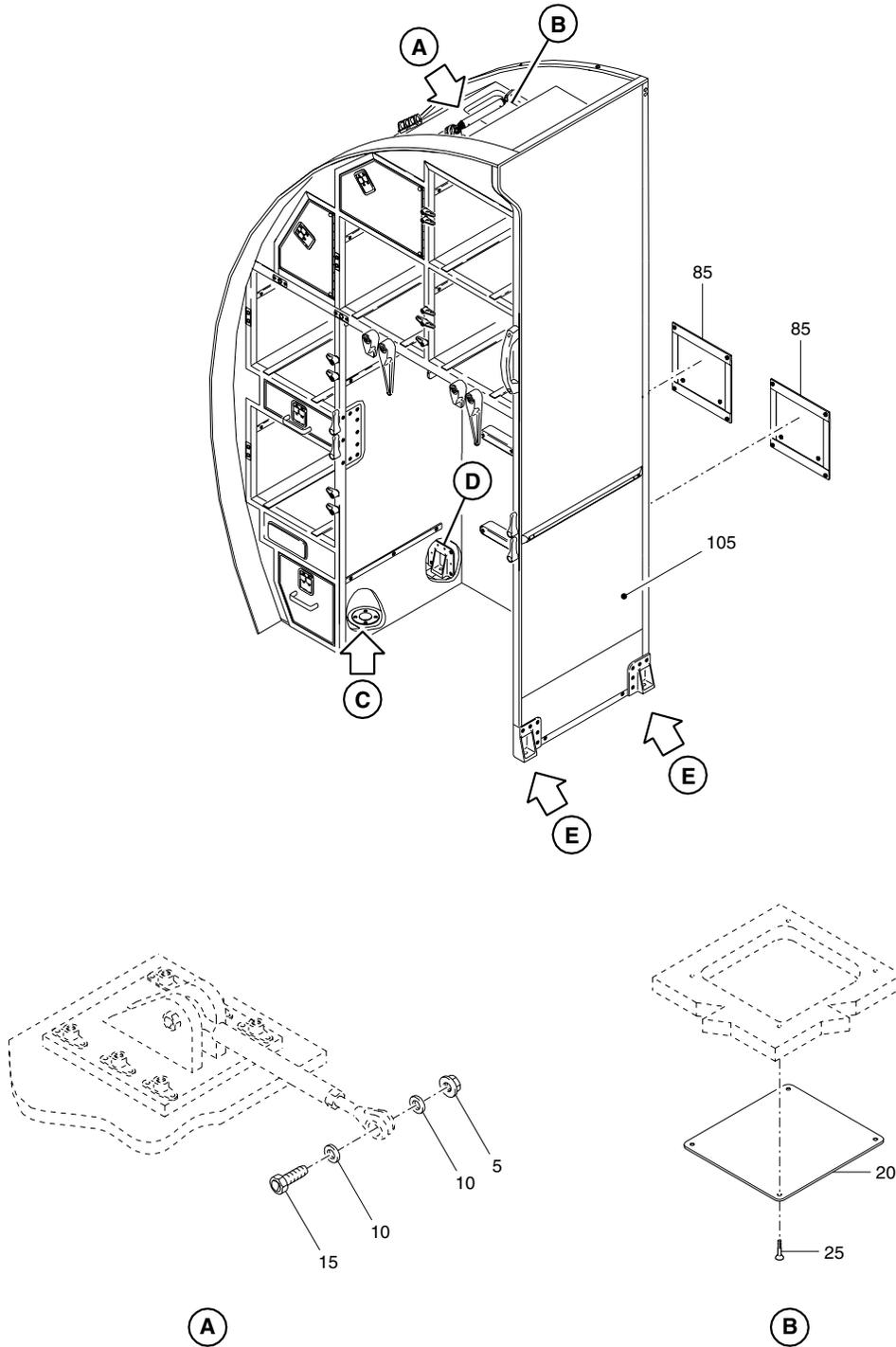
COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1B 65	85985K27		. PLUG, NYLON FINISHING (V3A054)		1
70	NAS6606-11		. BOLT		1
- 75	NAS6606-17		. BOLT SUPSD BY ITEM 75A		1
75A	NAS6606-19		. BOLT SUPSDS ITEM -75		1
80	NAS1149F0632P		. WASHER		2
85	CDSP2020-1		. COVER, FLOOR FITTING		2
90	NAS6205-5		. BOLT		2
95	NAS1149F0532P		. WASHER		2
100	CDSP1900-501		. FITTING ASSY, SEAT TRACK		2
105	CDSP1900-1		.. RETAINER ATTACHING PARTS		1
110	CDSP5810-4-7		.. SCREW * * *		2
115	CDSP1900-3		.. FITTING		1
120	9392452-501		. LITERATURE POCKET ASSY		2
- 125	MS27980-12N		. STUD, SNAP STYLE		8
- 130	MS27983-3N		. STUD ATTACHING PARTS		4
- 135	NAS514P832-9		. SCREW * * *		4
- 140	CDSP5307-100-10		. FOAM (BONDED) (TRUE PN CDSP5307-100-100-100)		AR
- 145	CDSP5307-100-10		. FOAM (BONDED) (TRUE PN CDSP5307-100-100-025)		AR
150	9861001-121		. GALLEY ASSY, G2 SEE FIG. 1 FOR DET		1

- ITEM NOT ILLUSTRATED

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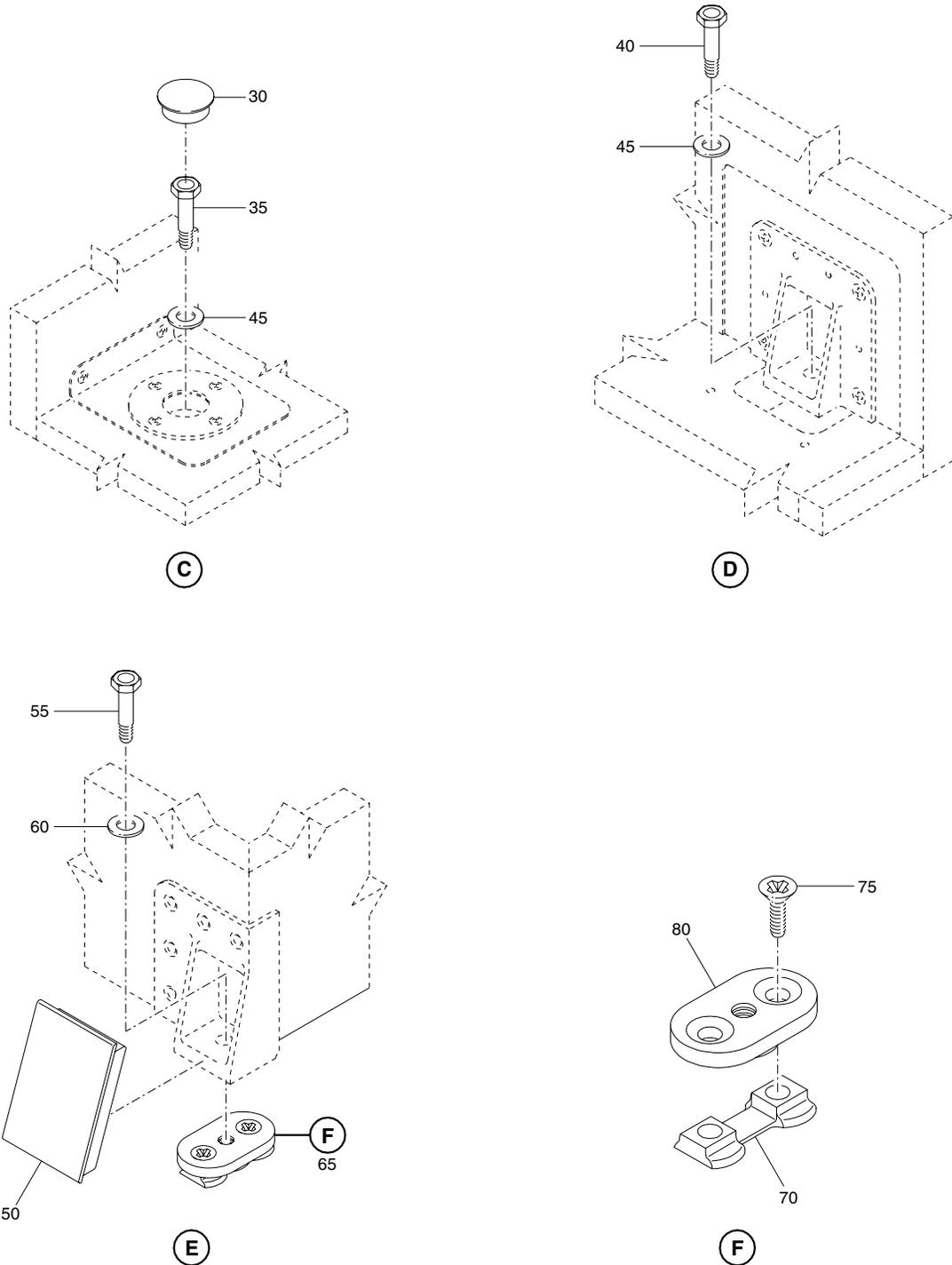
COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



G2 Galley Installation
 (Sheet 1 of 2)
 Figure 1C/GRAPHIC 25-32-78-99b-004-A01

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 9861001/E179001/E199001/E829001/H511201/J061502/J709001



G2 Galley Installation
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 Figure 1C/GRAPHIC 25-32-78-99b-004-A01

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COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1C	- 1 E179001-101		GALLEY INSTL, G2		RF
	5 MS21042L6		. NUT		1
	10 NAS1149F0632P		. WASHER		2
	15 NAS6606-11		. BOLT		1
	20 9861352-1		. COVER		1
			ATTACHING PARTS		
	25 NAS514P832-6		. SCREW		4

	30 85985K27		. PLUG, NYLON FINISHING (V3A054)		1
	35 NAS6606-11		. BOLT		1
	40 NAS6606-15		. BOLT		1
	45 NAS1149F0632P		. WASHER		2
	50 CDSP2020-1		. COVER, FLOOR FITTING		2
	55 NAS6205-5		. BOLT		2
	60 NAS1149F0532P		. WASHER		2
	65 CDSP1900-501		. FITTING ASSY, SEAT TRACK		2
	70 CDSP1900-1		.. RETAINER		1
			ATTACHING PARTS		
	75 CDSP5810-4-7		.. SCREW		2

	80 CDSP1900-3		.. FITTING		1
	85 9392452-501		. LITERATURE POCKET ASSY		2
	- 90 MS27980-12N		. STUD, SNAP STYLE		12
	- 95 CDSP5307-100-10		. FOAM (BONDED) (TRUE PN CDSP5307-100-100-100)		2

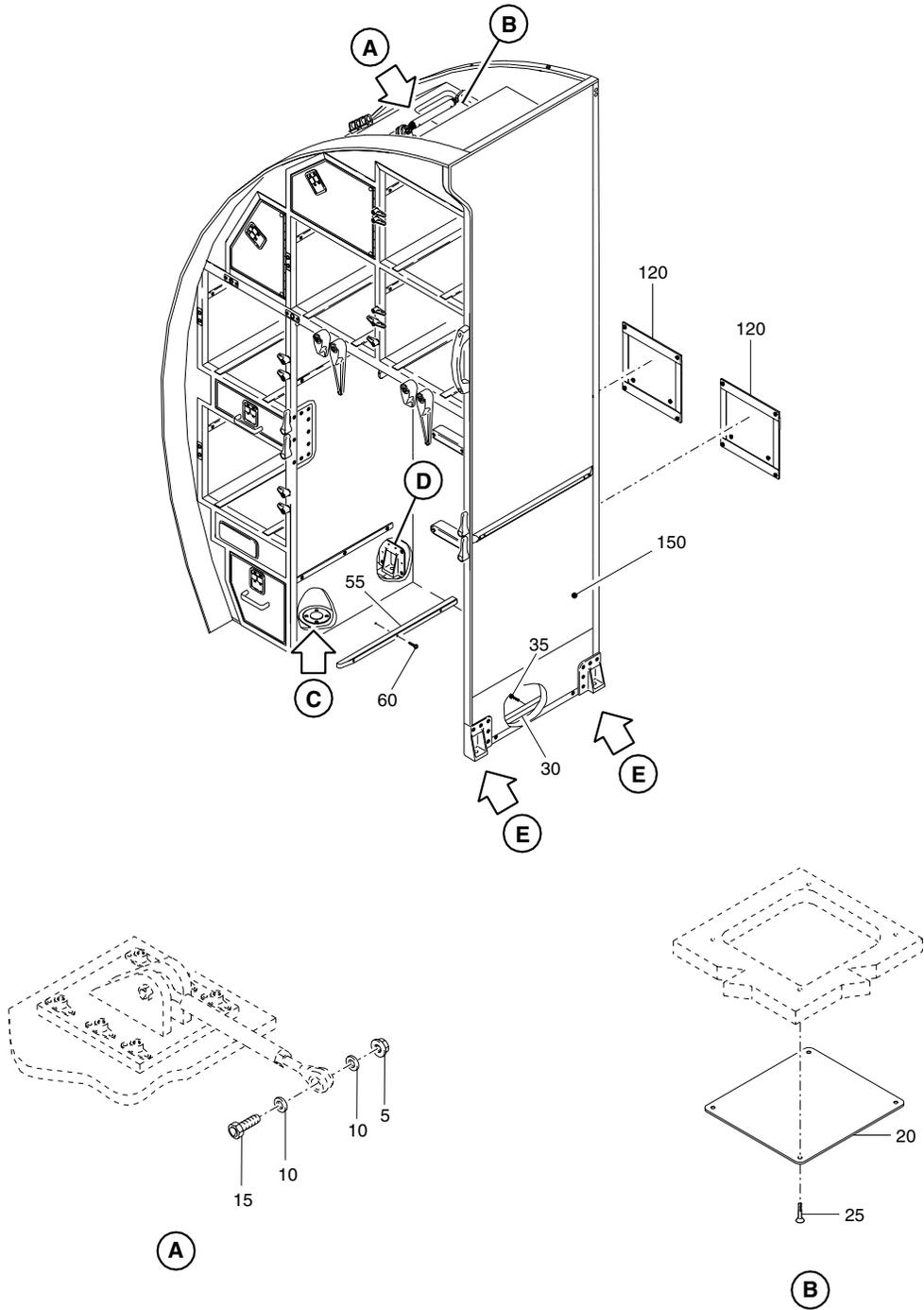
- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1C - 100	CDSP5307-100-10		. FOAM (BONDED) (TRUE PN CDSP5307-100-100-025)		1
105	9861001-117		. GALLEY ASSY, G2 SEE FIG. 1 FOR DET		1

- ITEM NOT ILLUSTRATED

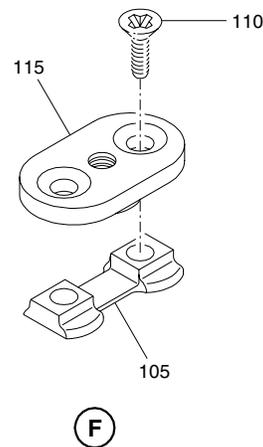
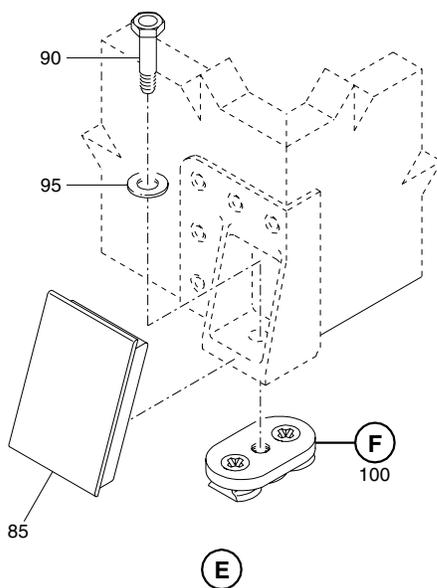
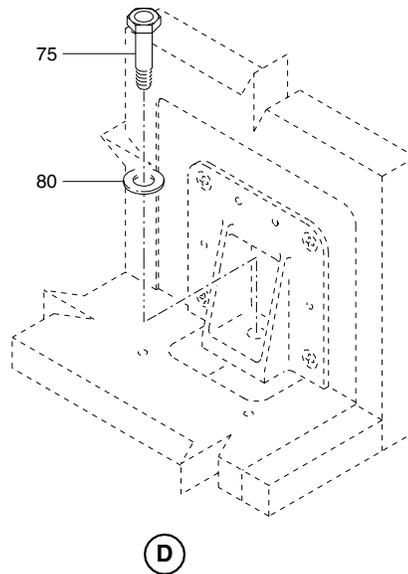
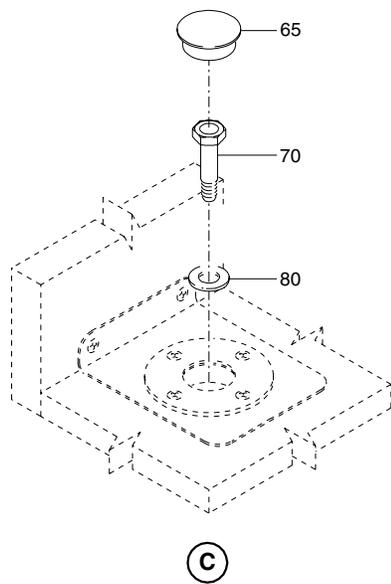
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G2 Galley Installation
 (Sheet 1 of 2)
 Figure 1D/GRAPHIC 25-32-78-99b-005-A01

COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



G2 Galley Installation
 (Sheet 2 of 2)
 Figure 1D/GRAPHIC 25-32-78-99b-005-A01

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COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1D - 1	E199001-101		GALLEY INSTL, G2	A	RF
- 1A	E199001-103		GALLEY INSTL, G2	B	RF
5	MS21042L6		. NUT		1
10	NAS1149F0632P		. WASHER		2
15	NAS6606-11		. BOLT		1
20	9861352-1		. COVER		1
			ATTACHING PARTS		
25	NAS514P832-4		. SCREW		4

30	E191032-501		. WHEEL GUIDE ASSY, INBD		1
			ATTACHING PARTS		
35	NAS603-6P		. SCREW		4

- 40	E191032-5		.. TAPE, DOUBLE SIDED (BONDED)		AR
- 45	E191032-7		.. CAP (BONDED)		1
- 50	E191032-3		.. WHEEL GUIDE (ALT PN CDSP2400-62)		1
55	E191032-1		. WHEEL GUIDE, OUTBD		1
			ATTACHING PARTS		
60	NAS603-6P		. SCREW		3

65	85985K27		. PLUG, NYLON FINISHING (V3A054)		1
70	NAS6606-11		. BOLT		1
75	NAS6606-17		. BOLT		1
80	NAS1149F0632P		. WASHER		2

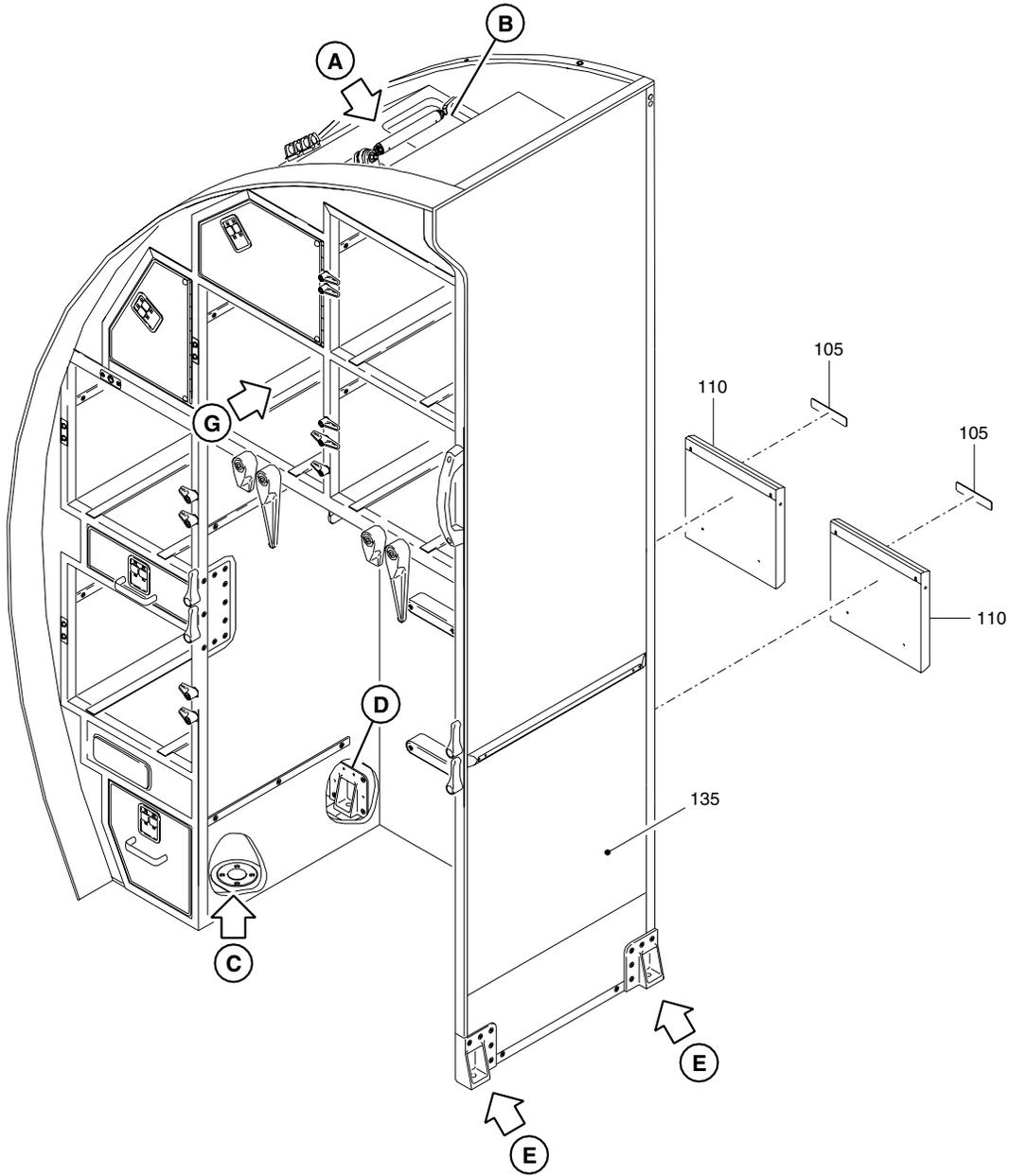
- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1D 85	CDSP2020-1		. COVER, FLOOR FITTING		2
90	NAS6205-5		. BOLT		2
95	NAS1149F0532P		. WASHER		2
100	CDSP1900-501		. FITTING ASSY, SEAT TRACK		2
105	CDSP1900-1		.. RETAINER		1
			ATTACHING PARTS		
110	CDSP5810-4-7		.. SCREW		2
			* * *		
115	CDSP1900-3		.. FITTING		1
120	9392453-501		. LITERATURE POCKET ASSY	A	2
- 120A	9392453-503		. LITERATURE POCKET ASSY	B	2
- 125	MS27980-12N		. STUD, SNAP STYLE		8
- 130	MS27983-3N		. STUD		4
			ATTACHING PARTS		
- 135	NAS514P832-9		. SCREW		4
			* * *		
- 140	CDSP5307-100-10		. FOAM (BONDED) (TRUE PN CDSP5307-100-100-100)		2
- 145	CDSP5307-100-10		. FOAM (BONDED) (TRUE PN CDSP5307-100-100-025)		1
150	9861001-121		. GALLEY ASSY, G2 SEE FIG. 1 FOR DET		1

- ITEM NOT ILLUSTRATED

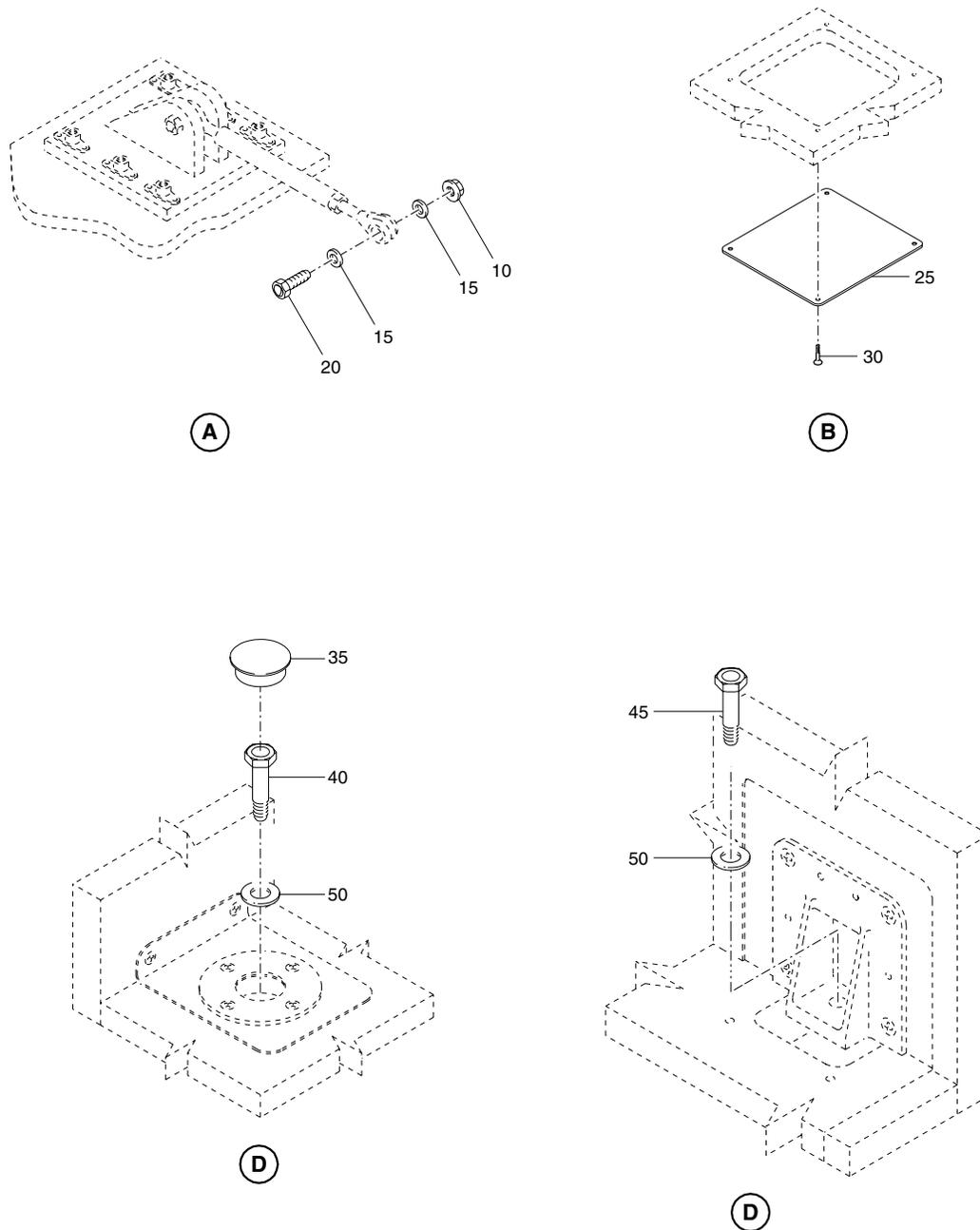
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G2 Galley Installation
(Sheet 1 of 3)
Figure 1E/GRAPHIC 25-32-78-99b-006-A01

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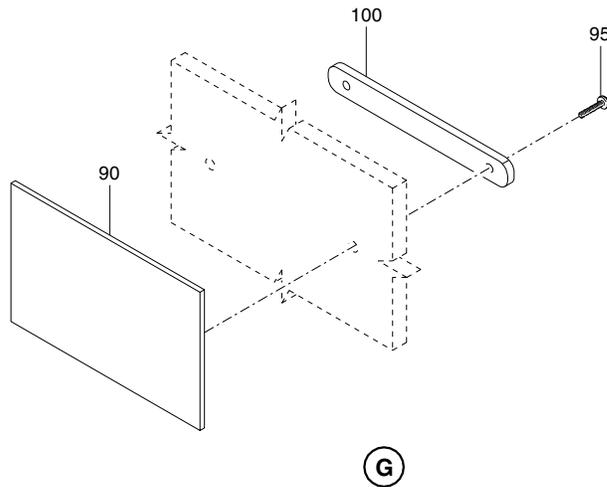
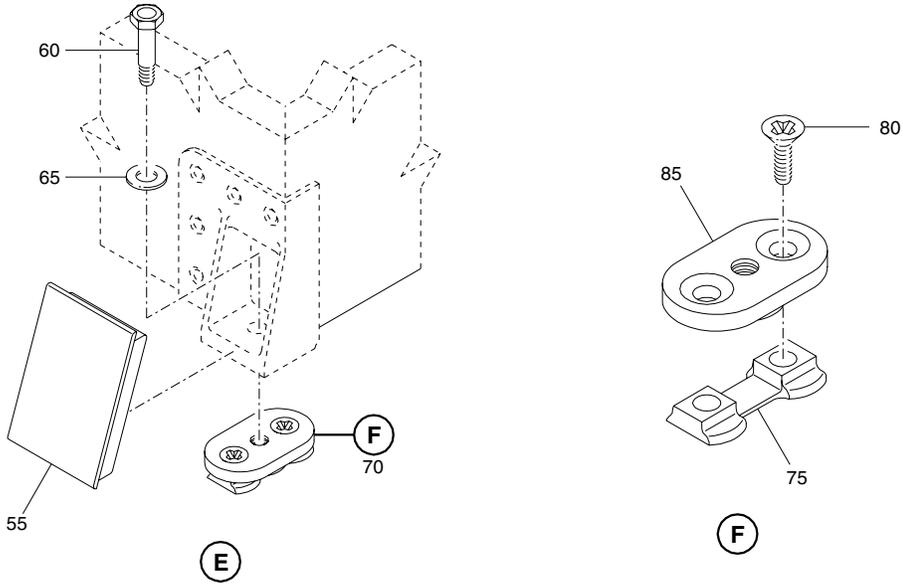
COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



25327801E02

G2 Galley Installation
 (Sheet 2 of 3)
 Figure 1E/GRAPHIC 25-32-78-99b-006-A01

COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



25327801E03

G2 Galley Installation
 (Sheet 3 of 3)
 Figure 1E/GRAPHIC 25-32-78-99b-006-A01

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1E	- 1	E829001-101	GALLEY INSTL, G2		RF
	- 5	BA670-40415-1	. BRACKET INSTL (V3AB48)		1
	10	MS21042L6	. NUT		1
	15	NAS1149F0632P	. WASHER		2
	20	NAS6606-11	. BOLT		1
	25	9861352-1	. COVER		1
			ATTACHING PARTS		
	30	NAS514P832-6	. SCREW		4

	35	85985K27	. PLUG, NYLON FINISHING (V3A054)		1
	40	NAS6606-11	. BOLT		1
	45	NAS6606-15	. BOLT		1
	50	NAS1149F0632P	. WASHER		2
	55	CDSP2020-1	. COVER, FLOOR FITTING		2
	60	NAS6205-5	. BOLT		2
	65	NAS1149F0532P	. WASHER		2
	70	CDSP1900-501	. FITTING ASSY, SEAT TRACK		2
	75	CDSP1900-1	.. RETAINER		1
			ATTACHING PARTS		
	80	CDSP5810-4-7	.. SCREW		2

	85	CDSP1900-3	.. FITTING		1
	90	124-11099-2	. LOGO (V64235) (BFE)		1

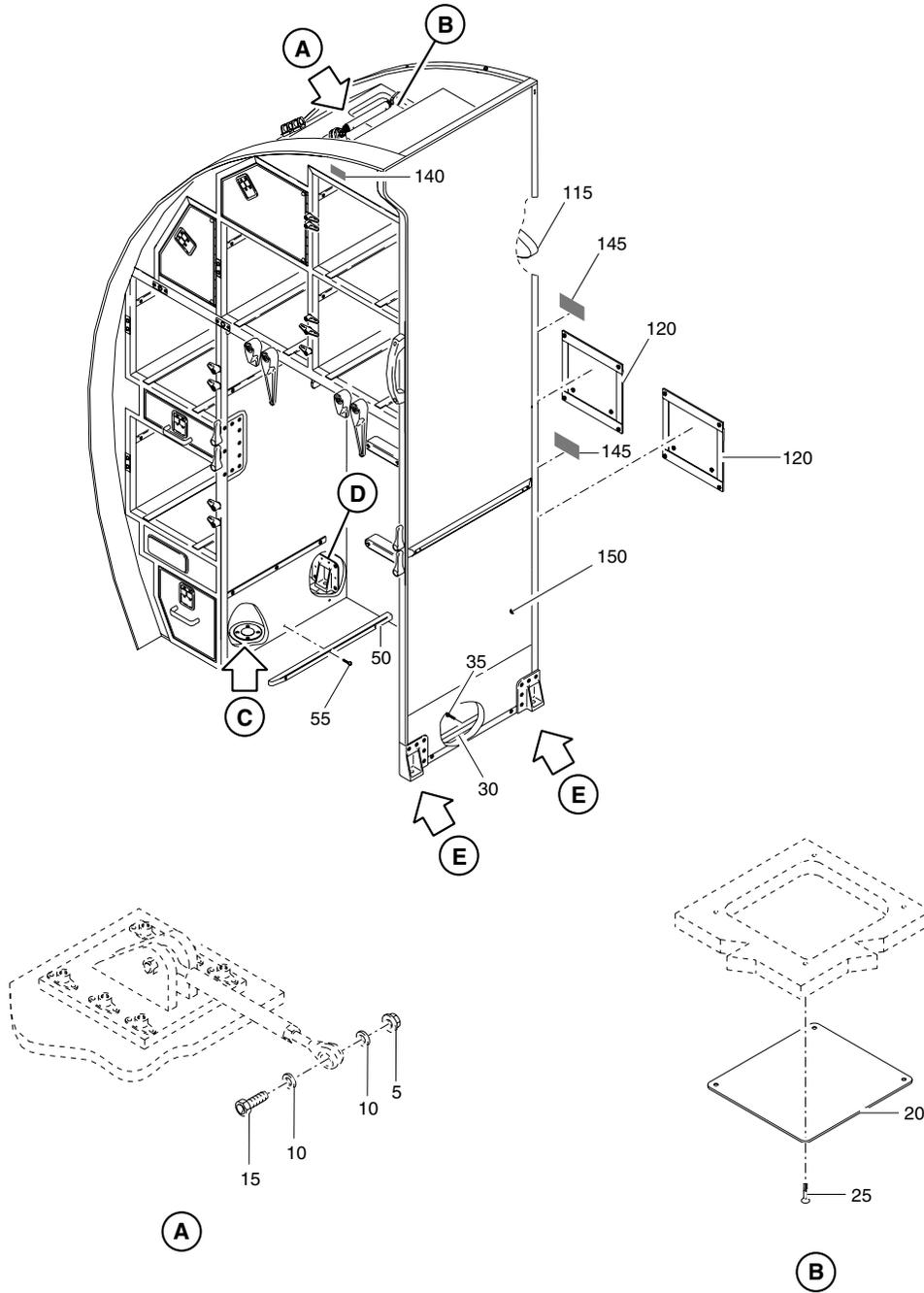
- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1E			ATTACHING PARTS		
	95 NAS603-16P		. SCREW * * *		2
	100 E829101-1		. BACKPLATE, LOGO		1
	105 CDPL1127-1		. PLACARD (BONDED)		2
	110 124-11065-01012		. LITERATURE POCKET ASSY (V64235) (BFE) ATTACHING PARTS		2
	- 115 NAS514P832-7		. SCREW		6
	- 120 CDSP5801-2AL		. WASHER * * *		6
	- 125 CDSP5307-100-10		. FOAM (BONDED) (TRUE PN CDSP5307-100-100-100)		2
	- 130 CDSP5307-100-10		. FOAM (BONDED) (TRUE PN CDSP5307-100-100-025)		1
	135 9861001-123		. GALLEY ASSY, G2 SEE FIG. 1 FOR DET		1

- ITEM NOT ILLUSTRATED

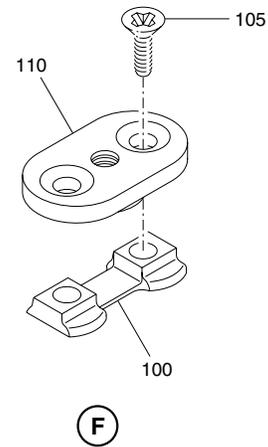
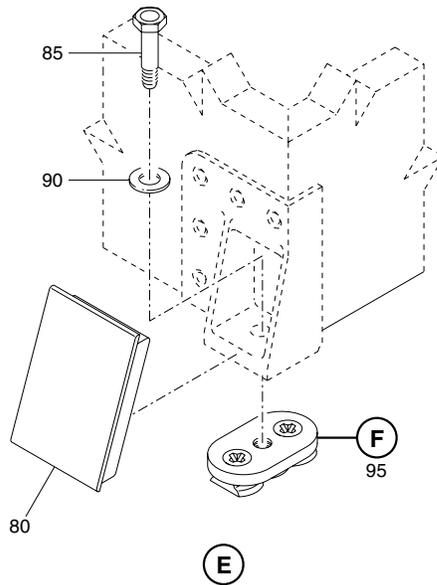
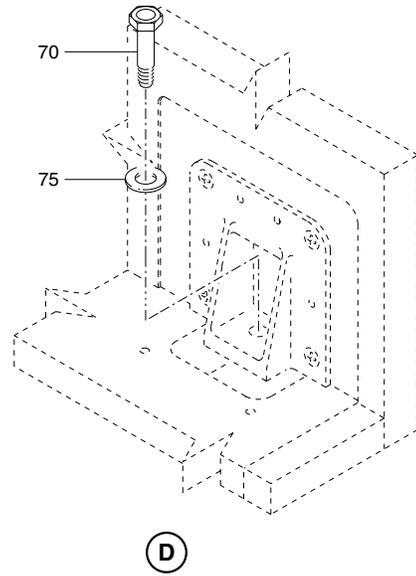
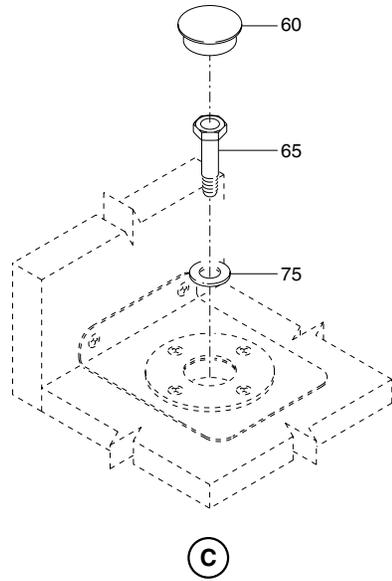
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G2 Galley Installation
 (Sheet 1 of 2)
 Figure 1F/GRAPHIC 25-32-78-99B-015-A01

COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



G2 Galley Installation
 (Sheet 2 of 2)
 Figure 1F/GRAPHIC 25-32-78-99B-015-A01

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COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1F - 1	J709001-101		GALLEY INSTL, G2		RF
5	MS21042L6		. NUT		1
10	NAS1149F0632P		. WASHER		2
15	NAS6606-11		. BOLT		1
20	9861352-1		. COVER		1
			ATTACHING PARTS		
25	NAS514P832-5		. SCREW		4

30	E191032-503		. WHEEL GUIDE ASSY (BONDED)		1
			ATTACHING PARTS		
35	NAS603-6P		. SCREW		2

- 40	E191032-5		.. TAPE, DOUBLE SIDED (BONDED)		AR
- 45	E191032-9		.. WHEEL GUIDE (ALT PN CDSP2400-62)		1
50	E191032-1		. WHEEL GUIDE INBD		1
			ATTACHING PARTS		
55	NAS603-6P		. SCREW		3

60	85985K27		. PLUG (V3A054)		1
65	NAS6606-11		. BOLT		1
70	NAS6606-19		. BOLT		1
75	NAS1149F0632P		. WASHER		2
80	CDSP2020-1		. COVER, FLOOR FITTING		2
85	NAS6205-5		. BOLT		1

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

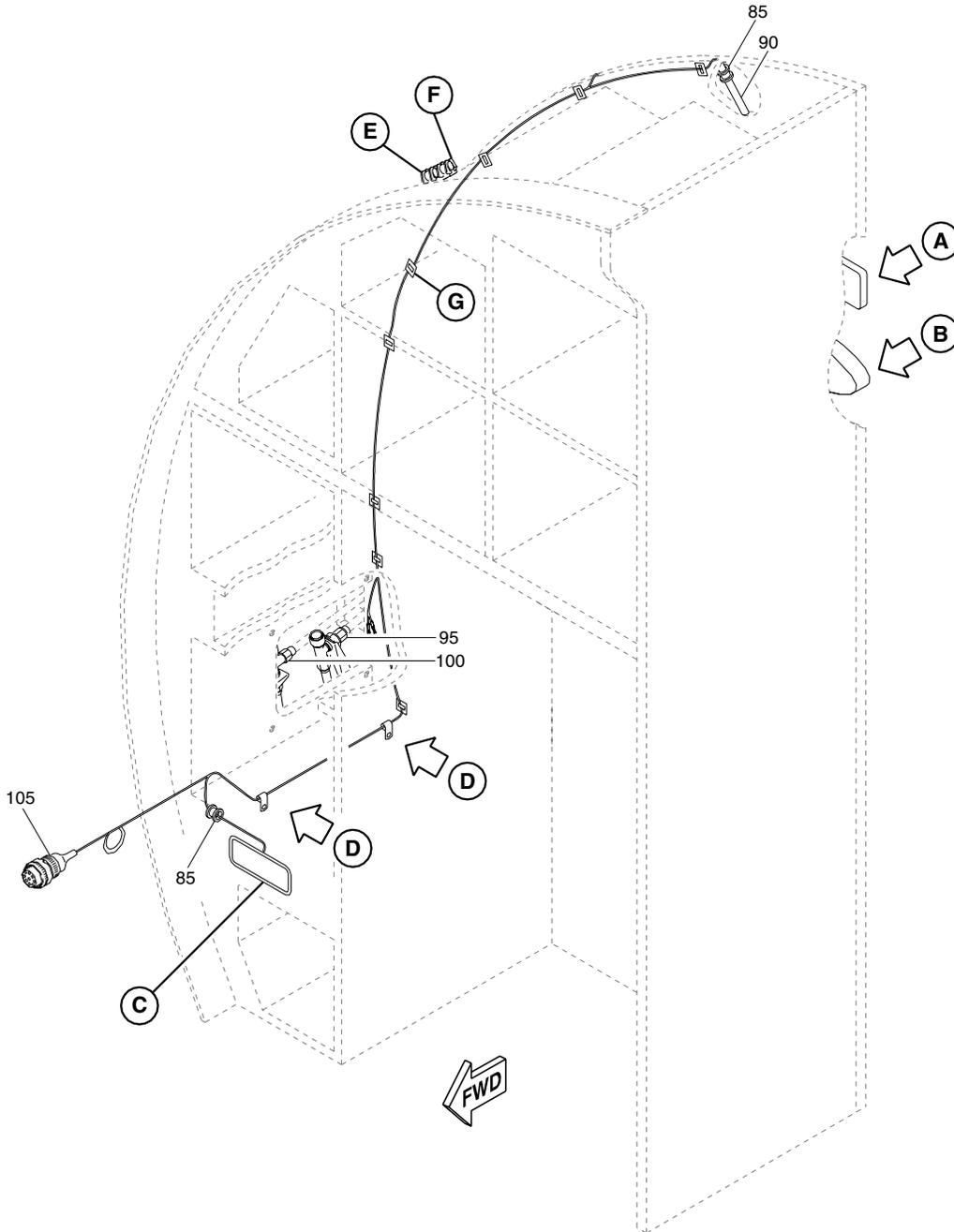
FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
1F 90	NAS1149F0532P		. WASHER		2
95	CDSP1900-501		. FITTING ASSY		2
100	CDSP1900-1		.. RETAINER		1
			ATTACHING PARTS		
105	CDSP5810-4-7		.. SCREW		2

110	CDSP1900-3		.. FITTING		1
115	BF5-0830-905		. LENS		1
120	9392452-501		. POCKET ASSY, LITERATURE		2
			ATTACHING PARTS		
- 125	MS27980-12N		. STUD SNAP		12

- 130	CDSP5307-100-10		. FOAM (BONDED) (TRUE PN CDSP5307-100-100-100)		2
- 135	CDSP5307-100-10		. FOAM (BONDED) (TRUE PN CDSP5307-100-100-025)		1
140	9861007-503		. PLACARD INSTL (BONDED) SEE FIG. 8 FOR DET		1
145	CDPL1070-1		. PLACARD (BONDED)		2
150	9861001-115		. GALLEY ASSY, G2 SEE FIG. 1 FOR DET		1

- ITEM NOT ILLUSTRATED

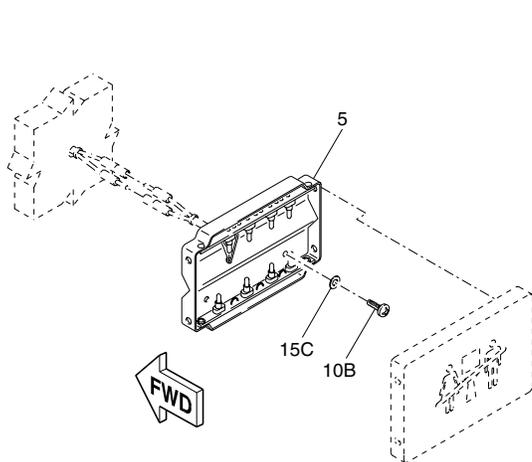
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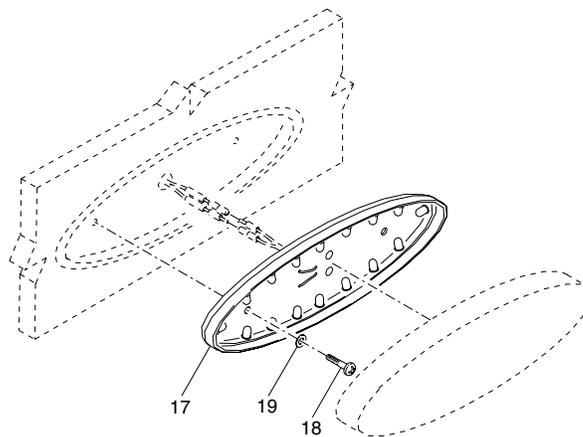
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Electrical Installation
(Sheet 1 of 3)
Figure 2/GRAPHIC 25-32-78-99b-007-A01

COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001

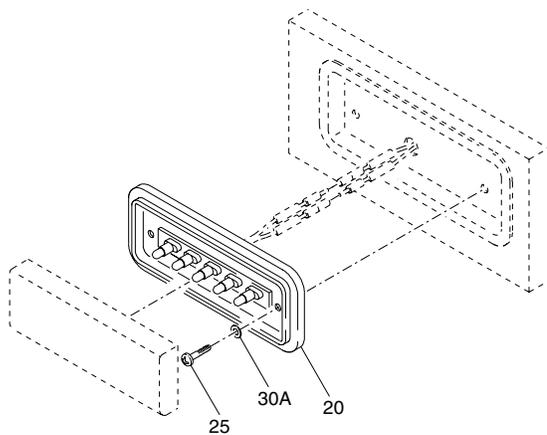


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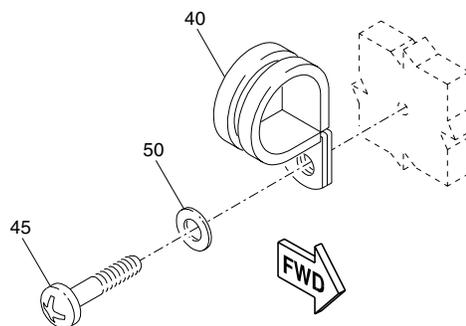


(B)

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(C)

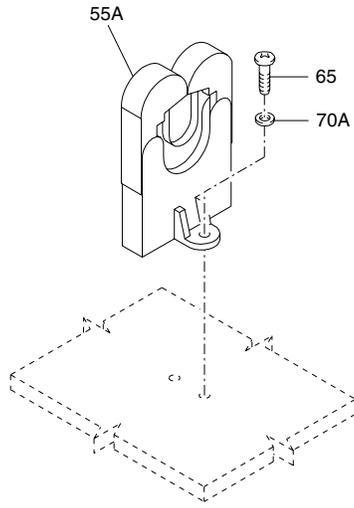


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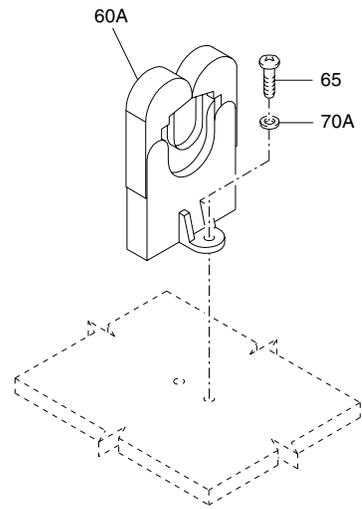
Electrical Installation
 (Sheet 2 of 3)
 Figure 2/GRAPHIC 25-32-78-99b-007-A01

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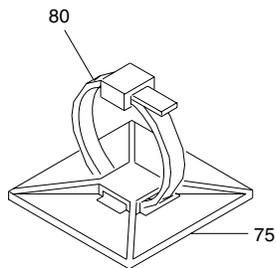
COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



(E)



(F)



(G)

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Electrical Installation
 (Sheet 3 of 3)
 Figure 2/GRAPHIC 25-32-78-99b-007-A01

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
2 - 1	9861005-501		ELECTRICAL INSTL SEE FIG. 1 FOR NHA	A	RF
- 1A	9861005-503		ELECTRICAL INSTL SEE FIG. 1 FOR NHA	B	RF
- 1B	9861005-505		ELECTRICAL INSTL SEE FIG. 1 FOR NHA	C	RF
- 1C	9861005-507		ELECTRICAL INSTL SEE FIG. 1 FOR NHA	D	RF
- 1D	9861005-511		ELECTRICAL INSTL SEE FIG. 1 FOR NHA	E	RF
- 1E	9861005-513		ELECTRICAL INSTL SEE FIG. 1 FOR NHA	F	RF
- 1F	9861005-509		ELECTRICAL INSTL SEE FIG. 1 FOR NHA	G	RF
- 1G	9861005-515		ELECTRICAL INSTL SEE FIG. 1 FOR NHA	H	RF
5	BR9410-6		. SIGN, LAV OCC (V17023)	A,D-F	1
- 5A	BR9749-006		. SIGN, LAV OCC (V17023)	G	1
			ATTACHING PARTS		
- 10	MS35206-213		. SCREW SUPSD BY ITEM 10B	A	4
- 10A	NAS601-6P		. SCREW	D-G	4
10B	NAS603-6P		. SCREW SUPSDS ITEM -10	A	4
- 15	NAS1149FN416P		. WASHER SUPSD BY ITEM -15B	A	4
- 15A	NAS1149FN632P		. WASHER	D-G	4
- 15B	NAS1149FN1032P		. WASHER (INCORRECT PN) SUPSDS ITEM -15	A	D

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
2	15C	NAS1149F1032P	. WASHER (CORRECT PN) * * *	A	4
- 16	BF5-0390-901		. LENS (V17023)	E,F	1
17	BF5-0828-901		. HOUSING ASSY, EMERGENCY EXIT SIGN (V17023)	D,G	1
- 17A	BF5-0384-901		. HOUSING ASSY, EMERGENCY EXIT SIGN (V17023) ATTACHING PARTS	E,F	1
18	NAS603-5P		. SCREW	D-G	2
19	NAS1149F0363P		. WASHER * * *	D-G	2
20	BR9279-232		. FLOODLIGHT (V17023)	A,B, E	1
- 20A	BF1-0099-005		. EXIT IDENTIFIER EMERGENCY, LED (V17023) ATTACHING PARTS	C,D,G,H	1
25	MS35206-226		. SCREW	A,B,E	2
- 25A	NAS601-5P		. SCREW	C,D,G,H	2
- 30	NAS1149FN616P		. WASHER SUPSD BY ITEM 30A	A,B	2
30A	NAS620-6L		. WASHER SUPSDS ITEM -30 * * *	A,B,E	2
- 35	9861701-501		. DELETED		D
- 36	MS35206-226		. SCREW	F	2
- 37	NAS620-6L		. WASHER	F	2
40	MS25281R3		. CLAMP, LOOP (TRUE PN MS25281-R3)	A,D-G	2

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
2 - 42	MS25281R3		. CLAMP, LOOP (TRUE PN MS25281-R3)	B,C,H	1
			ATTACHING PARTS		
45	NAS602-5		. SCREW	A,D-G	2
- 47	NAS602-5		. SCREW	B,C,H	1
50	NAS1149FN816P		. WASHER	A,D-G	2
- 52	NAS1149FN816P		. WASHER	B,C,H	1

- 55	TC188		. RETAINER, WIRE BUNDLE (V06383) SUPSD BY ITEM 55A		1
55A	RER5S6		. RETAINER, WIRE BUNDLE (V06383) (TRUE PN RER.5-S6-1) SUPSDS ITEM -55	A-G	1
- 60	TC86		. RETAINER, WIRE BUNDLE (V06383) SUPSD BY ITEM 60A		1
60A	RER75S6		. RETAINER, WIRE BUNDLE (V06383) (TRUE PN RER.75-S6-1) SUPSDS ITEM -60	A-G	1
			ATTACHING PARTS		
65	MS35206-226		. SCREW	A-G	4
- 70	NAS1149FN616P		. WASHER SUPSD BY ITEM 70A		4
70A	NAS620-6L		. WASHER SUPSDS ITEM -70	A-G	4

75	ABMMD		. MOUNT, CABLE TIE (V06383) (BONDED) (TRUE PN ABMM-D)	A,D-G	7

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

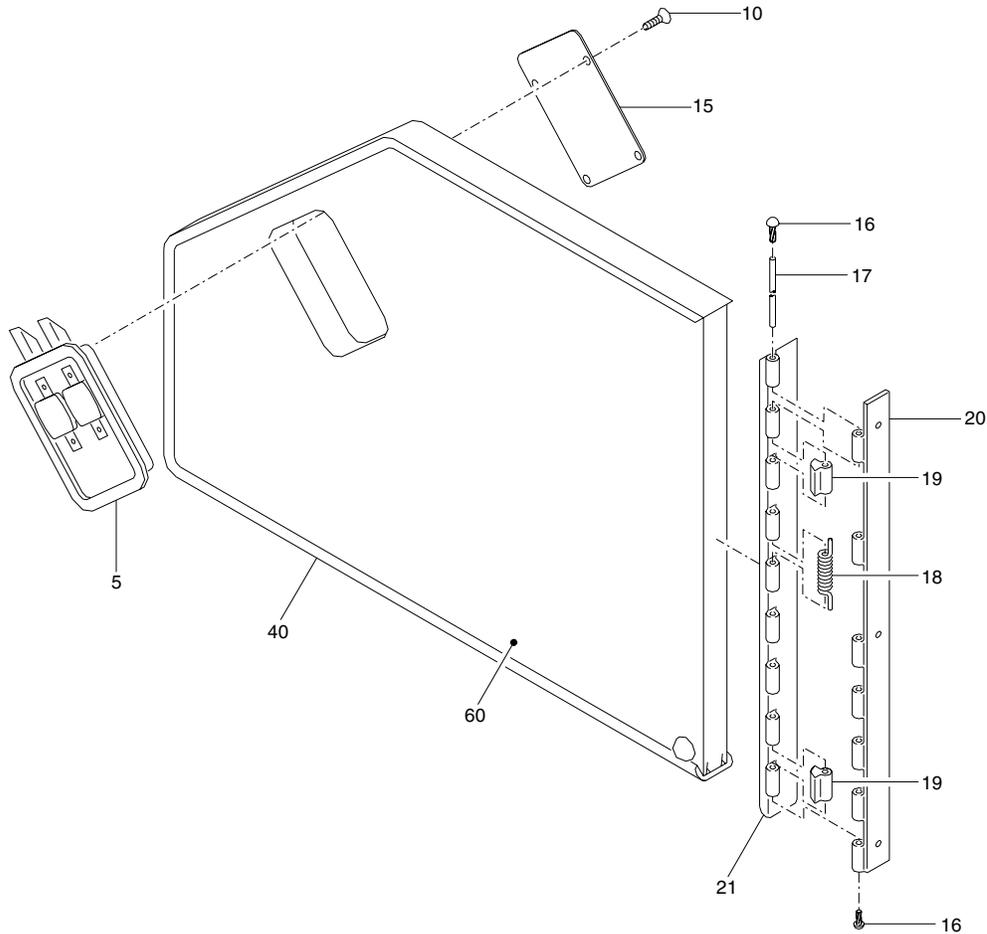
FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
2 - 77	ABMMD		. MOUNT, CABLE TIE (V06383) (BONDED) (TRUE PN ABMM-D)	B,C	12
- 78	ABMMD		. MOUNT, CABLE TIE (V06383) (BONDED) (TRUE PN ABMM-D)	H	5
80	MS3367-5-9		. CABLE TIE	A,D-G	7
- 82	MS3367-5-9		. CABLE TIE	B,C	12
- 83	MS3367-5-9		. CABLE TIE	H	5
85	NAS1368N6A		. GROMMET (BONDED)	A	2
- 87	NAS1368N6A		. GROMMET (BONDED)	B,C,H	1
- 88	NAS1368N6A		. GROMMET (BONDED)	D-G	3
90	9861005-1		. TUBING (BONDED)	A	1
95	4E4010-1		. TEE, HEATER (VSF309)	B,C,H	1
100	4E4011-1		. TEE, HEATER (VSF309)	B,C,H	1
105	9861701-501		. WIRE HARNESS ASSY	A	1
- 105A	9861701-503		. WIRE HARNESS ASSY	B,C,H	1
- 105B	9861705-501		. WIRE HARNESS ASSY	D-G	1
- 110	D3899926FE26PN		.. DELETED	A	D
- 115	48-7190		.. DELETED	A	D
- 120	48-7191		.. DELETED	A	D
- 125	9861701-503		. WIRE HARNESS ASSY (MOVED TO ITEM -105A)	B,C,H	D
- 130	D3899926FE26PN		.. DELETED	B,C,H	D
- 135	48-7190		.. DELETED	B,C,H	D

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
2 - 140	48-7191		.. DELETED	B,C,H	D
- 145	9861705-501		. WIRE HARNESS ASSY (MOVED TO ITEM -105B)	D-G	D

- ITEM NOT ILLUSTRATED



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Door Assembly
Figure 3/GRAPHIC 25-32-78-99b-008-A01

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
3 - 1	9861101-501		DOOR ASSY (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM) SEE FIG. 1 FOR NHA	A	RF
- 1A	9861101-503		DELETED	B	D
- 1B	9861101-507		DOOR ASSY (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM) SEE FIG. 1 FOR NHA	C	RF
- 1C	9861101-505		DOOR ASSY (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM) SEE FIG. 1 FOR NHA	D	RF
5	CDSP1004-3		. LATCH, DOUBLE SLIDE ATTACHING PARTS		1
10	NAS514P832-4		. SCREW * * *		4
15	CDSP5002		. BACKPLATE		1
16	MS21318-15		. SCREW, DRIVE		2
17	MS20253P2-0812		. PIN, HINGE		1
18	458-4-2693		. SPRING (V5P104) (TO OPEN THE DOOR)	C	1
- 18A	458-4-2693		. SPRING (V5P104) (TO CLOSE THE DOOR)	D	1
19	CDSP5601-90		. STOP, DOOR	A	2
20	9861101-9		. HALF-HINGE		1

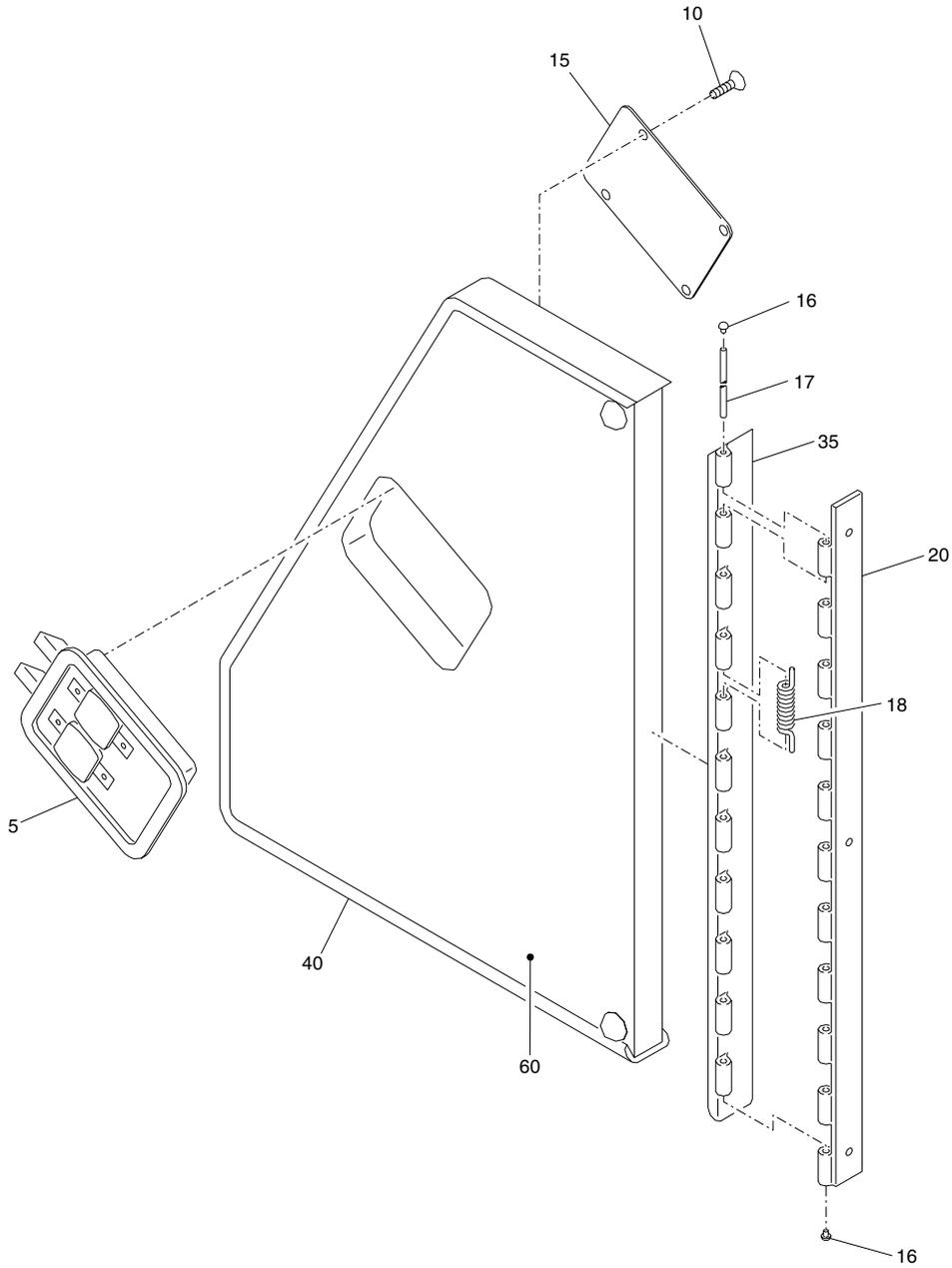
- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
3 21	9861101-7		. TRIM, HINGE (BONDED)	A	1
- 21A	9861101-11		. TRIM, HINGE (BONDED)	B	1
- 21B	9861101-13		. TRIM, HINGE (BONDED)	C,D	1
			ATTACHING PARTS		
- 25	MS21318-15		. SCREW, DRIVE (MOVED TO ITEM 16)		D
- 30	MS20253P2-0812		. PIN, HINGE (MOVED TO ITEM 17)		D
			* * *		
- 32	CDSP5601-90		. STOP, DOOR (MOVED TO ITEM 19)	A	D
- 35	9861101-7		. TRIM, HINGE (MOVED TO ITEM 21)	A	D
- 35A	9861101-11		. DELETED	B	D
- 35B	9861101-13		. TRIM, HINGE (MOVED TO ITEM -21B)	C,D	D
40	9861101-3		. TRIM (BONDED)		1
- 45	9861101-1		. PANEL (MOVED TO ITEM 60)		D
- 50	458-4-2693		. SPRING (V5P104) (TO OPEN THE DOOR) (MOVED TO ITEM 18)	C	D
- 50A	458-4-2693		. SPRING (V5P104) (TO CLOSE THE DOOR) (MOVED TO ITEM -18A)	D	D
- 55	9861101-5		. DECOR (BONDED)		AR
60	9861101-1		. PANEL		1

- ITEM NOT ILLUSTRATED

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2532780401

Door Assembly
Figure 4/GRAPHIC 25-32-78-99b-009-A01

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
4 - 1	9861102-501		DOOR ASSY (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM) SEE FIG. 1 FOR NHA	A	RF
- 1A	9861102-505		DOOR ASSY (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM) SEE FIG. 1 FOR NHA	B	RF
- 1B	9861102-503		DOOR ASSY (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM) SEE FIG. 1 FOR NHA	C	RF
5	CDSP1004-3		. LATCH, DOUBLE SLIDE ATTACHING PARTS		1
10	NAS514P832-4		. SCREW * * *		4
15	CDSP5002		. BACKPLATE		1
16	MS21318-15		. SCREW, DRIVE		2
17	MS20253P2-0990		. PIN, HINGE		1
18	458-4-2693		. SPRING (V5P104) (TO OPEN THE DOOR)	B	1
- 18A	458-4-2693		. SPRING (V5P104) (TO CLOSE THE DOOR)	C	1
20	9861102-9		. HALF-HINGE ATTACHING PARTS		1
- 25	MS21318-15		. SCREW, DRIVE (MOVED TO ITEM 16)		D

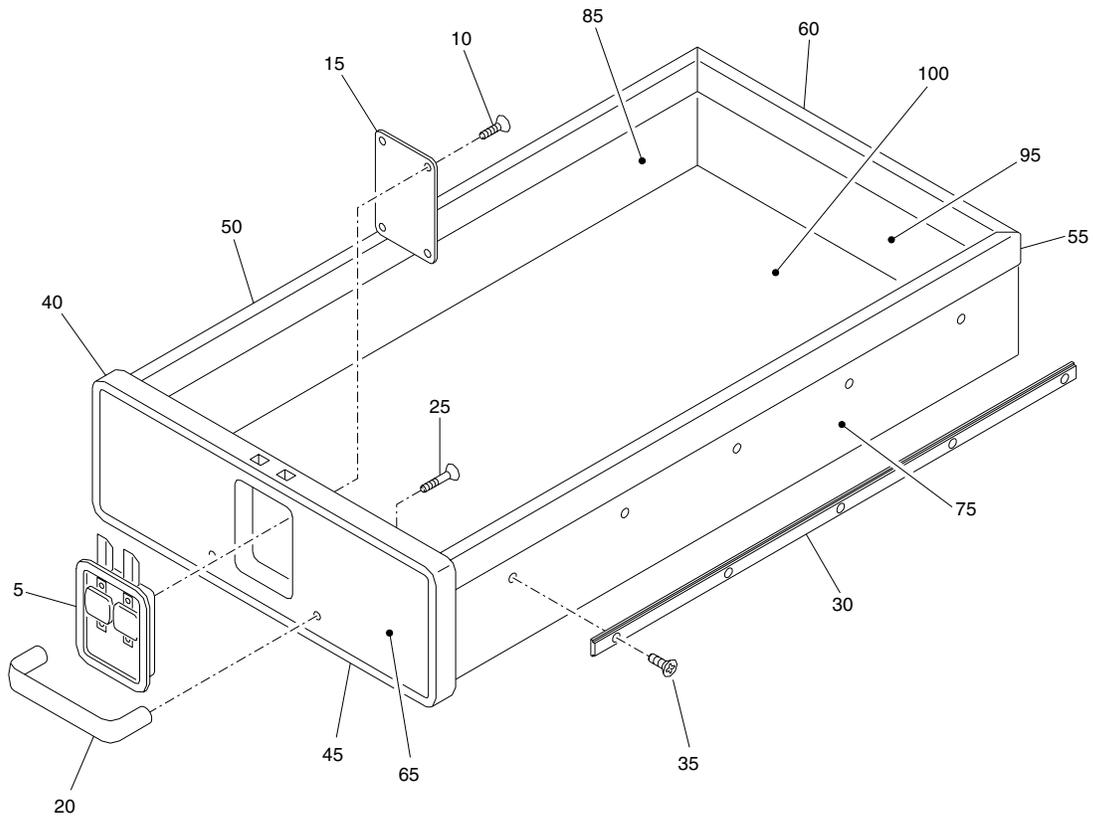
- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
4 - 30	MS20253P2-0990		. PIN, HINGE (MOVED TO ITEM 17) * * *		D
35	9861102-7		. TRIM, HINGE (BONDED)	A	1
- 35A	9861102-11		. TRIM, HINGE (BONDED)	B,C	1
40	9861102-3		. TRIM (BONDED)		1
- 45	9861102-1		. PANEL (MOVED TO ITEM 60)		D
- 50	458-4-2693		. SPRING (V5P104) (TO OPEN THE DOOR) (MOVED TO ITEM 18)	B	D
- 50A	458-4-2693		. SPRING (V5P104) (TO CLOSE THE DOOR) (MOVED TO ITEM -18A)	C	D
- 55	9861102-5		. DECOR (BONDED)		AR
60	9861102-1		. PANEL		1

- ITEM NOT ILLUSTRATED

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Drawer Assembly
Figure 5/GRAPHIC 25-32-78-99b-010-A01

2532780501

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
5 - 1	9861103-501		DRAWER ASSY (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM) SEE FIG. 1 FOR NHA		RF
5	CDSP1004-3		. LATCH ASSY ATTACHING PARTS		1
10	NAS514P0832-4		. SCREW * * *		4
15	CDSP5002		. BACKPLATE		1
20	10822A1032-2E		. HANDLE (V1YGB8) (TRUE PN 10822-A-1032-2E) ATTACHING PARTS		1
25	NAS514P1032-14		. SCREW * * *		2
30	A5210-15P		. TRACK, SLIDE (V52607) ATTACHING PARTS		2
35	NAS514P0832-4		. SCREW * * *		10
40	9861103-9		. TRIM, FRONT PANEL (BONDED)		1
45	9861103-11		. TRIM, FRONT PANEL (BONDED)		1
50	9861103-13		. TRIM, SIDE PANEL (BONDED)		1
55	9861103-14		. TRIM, SIDE PANEL (BONDED)		1
60	9861103-15		. TRIM, BACK PANEL (BONDED)		1

- ITEM NOT ILLUSTRATED

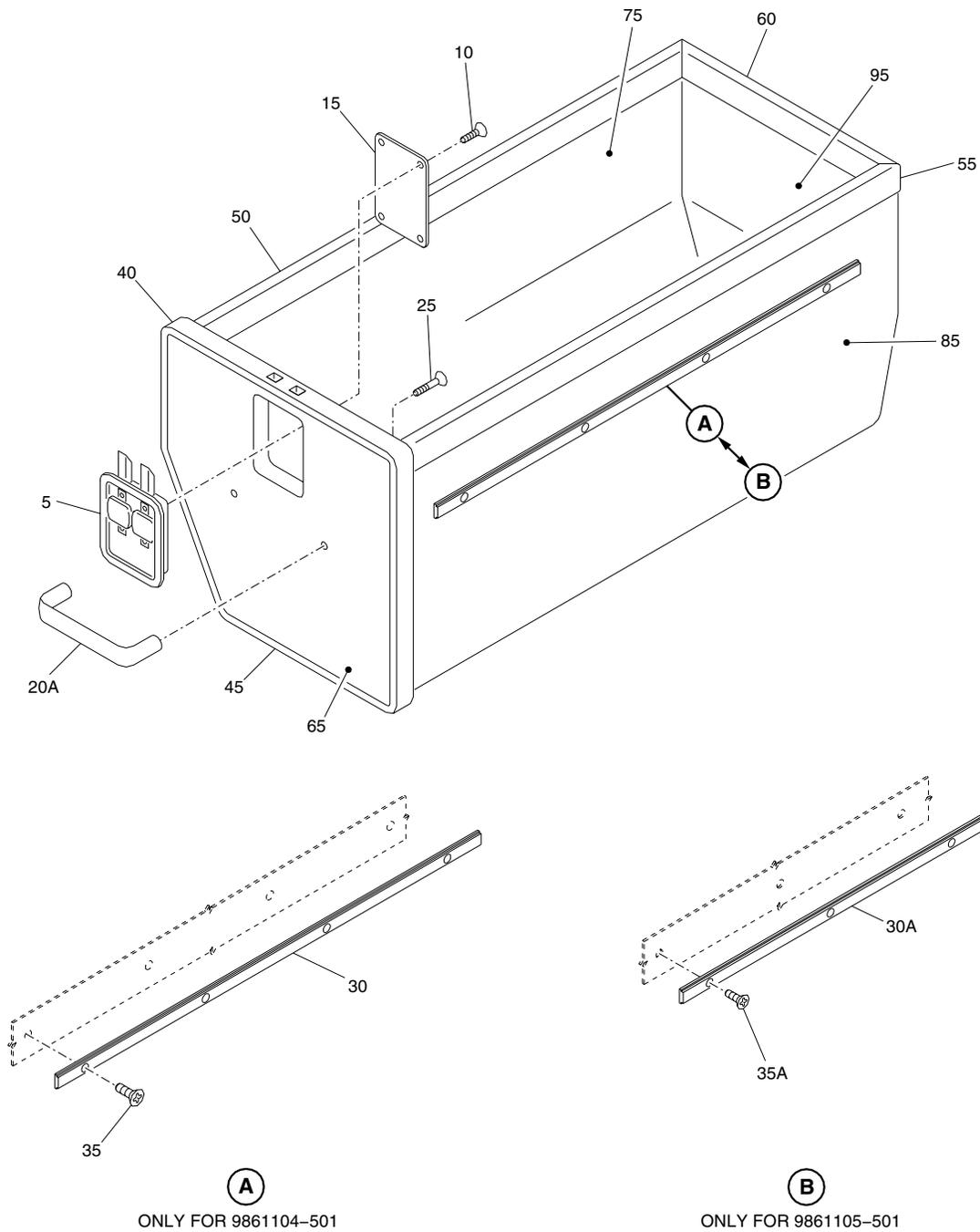
COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
5 - 63	9861103-17		. DECOR (BONDED)		AR
65	9861103-601		. PANEL ASSY, FRONT (BONDED)		1
- 70	CDSP5903-3-500		.. DELETED		D
- 72	9861103-1		.. PANEL, FRONT		1
75	9861103-603		. PANEL ASSY, SIDE (BONDED)		1
- 80	CDSP5905-08-06		.. INSERT (BONDED)		5
- 82	9861103-3		.. PANEL, SIDE		1
85	9861103-604		. PANEL ASSY, SIDE (BONDED)		1
- 90	CDSP5905-08-06		.. INSERT (BONDED)		5
- 92	9861103-4		.. PANEL, SIDE		1
95	9861103-5		. PANEL, BACK (BONDED)		1
100	9861103-7		. PANEL, BOTTOM (BONDED)		1
- 105	9861103-17		. DECOR (MOVED TO ITEM -63)		D

- ITEM NOT ILLUSTRATED

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COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001



Drawer Assembly
 Figure 6/GRAPHIC 25-32-78-99b-011-A01

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
6	- 1 9861104-501		DRAWER ASSY (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM) SEE FIG. 1 FOR NHA	A	RF
	- 1A 9861105-501		DRAWER ASSY (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM) SEE FIG. 1 FOR NHA	B	RF
	- 1B 9862109-501		DRAWER ASSY (ORDER PER THE TRIM AND FINISH SPECIFICATIONS IN DESCRIPTION AND OPERATION SECTION [PARA 4] OF THIS CMM) SEE FIG. 1 FOR NHA	C	RF
	5 CDSP1004-3		. LATCH ASSY ATTACHING PARTS		1
	10 NAS514P0832-4		. SCREW * * *		4
	15 CDSP5002		. BACKPLATE		1
	- 20 10822A1032-23		. HANDLE SUPSD BY ITEM 20A		1
	20A 10822A1032-2E		. HANDLE (V1YGB8) (TRUE PN 10822-A-1032-2E) SUPSDS ITEM -20 ATTACHING PARTS		1
	25 NAS514P1032-14		. SCREW * * *		2
	30 A5210-15P		. TRACK, SLIDE (V52607)	A	2

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
6 30A	A5210-9P		. TRACK, SLIDE (V52607)	B	2
- 30B	A5210-12P		. TRACK, SLIDE (V52607)	C	2
- 31	A5210-9P		. TRACK, SLIDE (V52607) (MOVED TO ITEM 30A)	B	D
- 32	A5210-12P		. TRACK, SLIDE (V52607) (MOVED TO ITEM -30B)	C	D
			ATTACHING PARTS		
35	NAS514P0832-5		. SCREW	A	10
35A	NAS514P0832-5		. SCREW	B,C	6
- 36	NAS514P0832-5		. SCREW (MOVED TO ITEM 35A)	B,C	D
			* * *		
40	9861104-9		. TRIM, FRONT PANEL (BONDED)	A,B	1
- 40A	9862109-7		. TRIM, FRONT PANEL (BONDED)	C	1
45	9861104-11		. TRIM, FRONT PANEL (BONDED)	A,B	1
50	9861104-13		. TRIM, SIDE PANEL (BONDED)	A	1
- 50A	9861105-5		. TRIM, SIDE PANEL (BONDED)	B,C	1
55	9861104-14		. TRIM, SIDE PANEL (BONDED)	A	1
- 55A	9861105-6		. TRIM, SIDE PANEL (BONDED)	B,C	1
60	9861104-15		. TRIM, BACK PANEL (BONDED)		1
- 64	9861104-17		. DECOR (BONDED)	A	AR

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
6 - 64A	9861105-7		. DECOR (BONDED)	B	AR
- 64B	9862109-9		. DECOR (BONDED)	C	AR
65	9861104-601		. PANEL ASSY, FRONT (BONDED)	A,B	1
- 65A	9862109-605		. PANEL ASSY, FRONT (BONDED)	C	1
- 66	9862109-605		. PANEL ASSY, FRONT (BONDED) (MOVED TO ITEM -65A)	C	D
- 70	CDSP5903-3-500		.. DELETED		D
- 72	9861104-1		.. PANEL, FRONT	A,B	1
- 72A	9862109-3		.. PANEL, FRONT	C	1
- 73	9862109-3		.. PANEL, FRONT (MOVED TO ITEM -72A)	C	D
75	9861104-603		. PANEL ASSY, SIDE (BONDED)	A	1
- 75A	9861105-601		. PANEL ASSY, SIDE (BONDED)	B	1
- 75B	9862109-601		. PANEL ASSY, SIDE (BONDED)	C	1
- 80	CDSP5905-08-06		.. INSERT (BONDED)	A	5
- 81	CDSP5905-08-06		.. INSERT (BONDED)	B	3
- 81A	CDSP5905-08-06		.. INSERT (BONDED)	C	4
- 82	9861104-3		.. PANEL, SIDE	A	1
- 82A	9861105-1		.. PANEL, SIDE	B	1
- 82B	9862109-1		.. PANEL, SIDE	C	1
- 83	9861105-1		.. PANEL, SIDE (MOVED TO ITEM -82A)	B	D

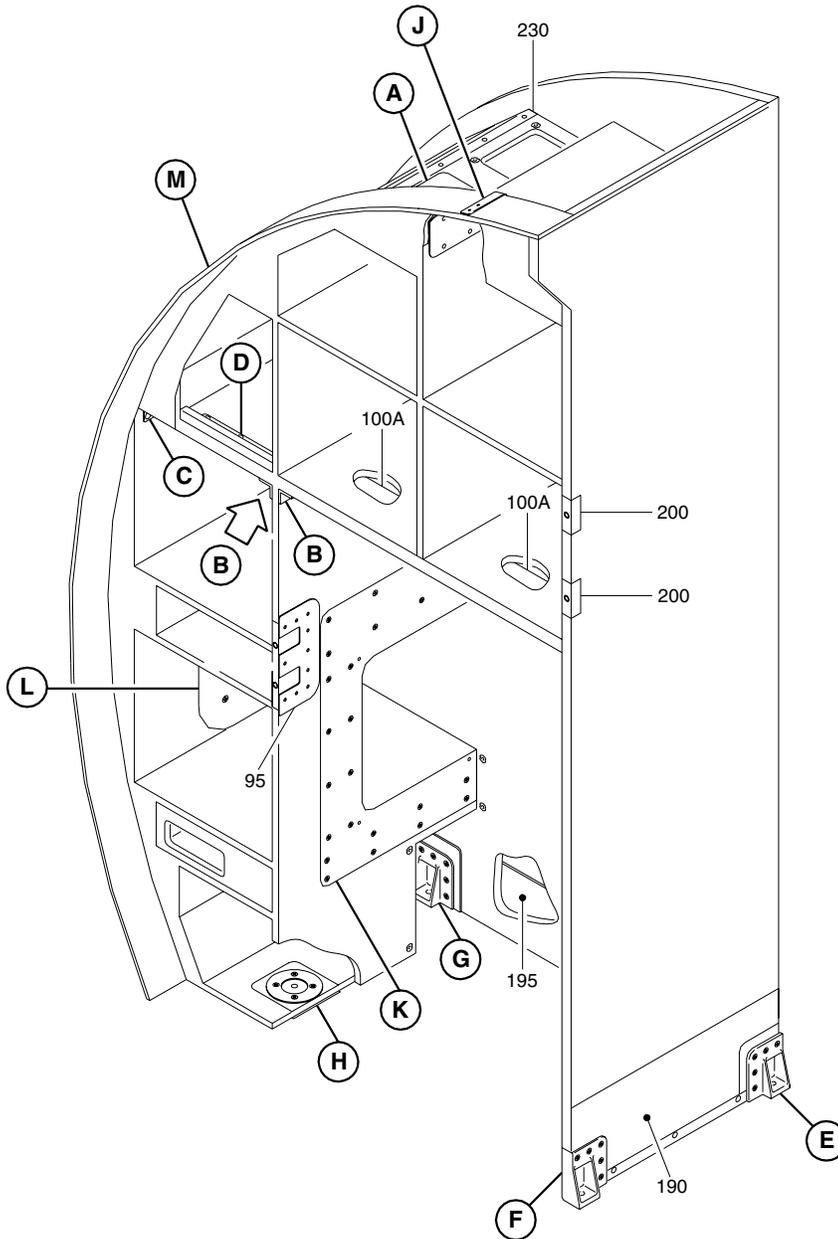
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COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
6 - 84	9862109-1		.. PANEL, SIDE (MOVED TO ITEM -82B)	C	D
- 85	9861104-605		. PANEL ASSY, SIDE (BONDED)	A	1
- 85A	9861105-603		. PANEL ASSY, SIDE (BONDED)	B	1
- 85B	9862109-603		. PANEL ASSY, SIDE (BONDED)	C	1
- 90	CDSP5905-08-06		.. INSERT (BONDED)	A	5
- 91	CDSP5905-08-06		.. INSERT (BONDED)	B	3
- 91A	CDSP5905-08-06		.. INSERT (BONDED)	C	4
- 92	9861104-5		.. PANEL, SIDE	A	1
- 92A	9861105-3		.. PANEL, SIDE	B	1
- 92B	9862109-3		.. PANEL, SIDE	C	1
- 93	9861105-3		.. PANEL, SIDE (MOVED TO ITEM -92A)	B	D
- 94	9862109-3		.. PANEL, SIDE (MOVED TO ITEM -92B)	C	D
95	9861104-7		. PANEL, BACK (BONDED)		1
- 100	9861104-17		. DECOR (BONDED) (MOVED TO ITEM -64)	A	D
- 105	9861105-7		. DECOR (BONDED) (MOVED TO ITEM -64A)	B	D
- 110	9862109-9		. DECOR (BONDED) (MOVED TO ITEM -64B)	C	D

- ITEM NOT ILLUSTRATED

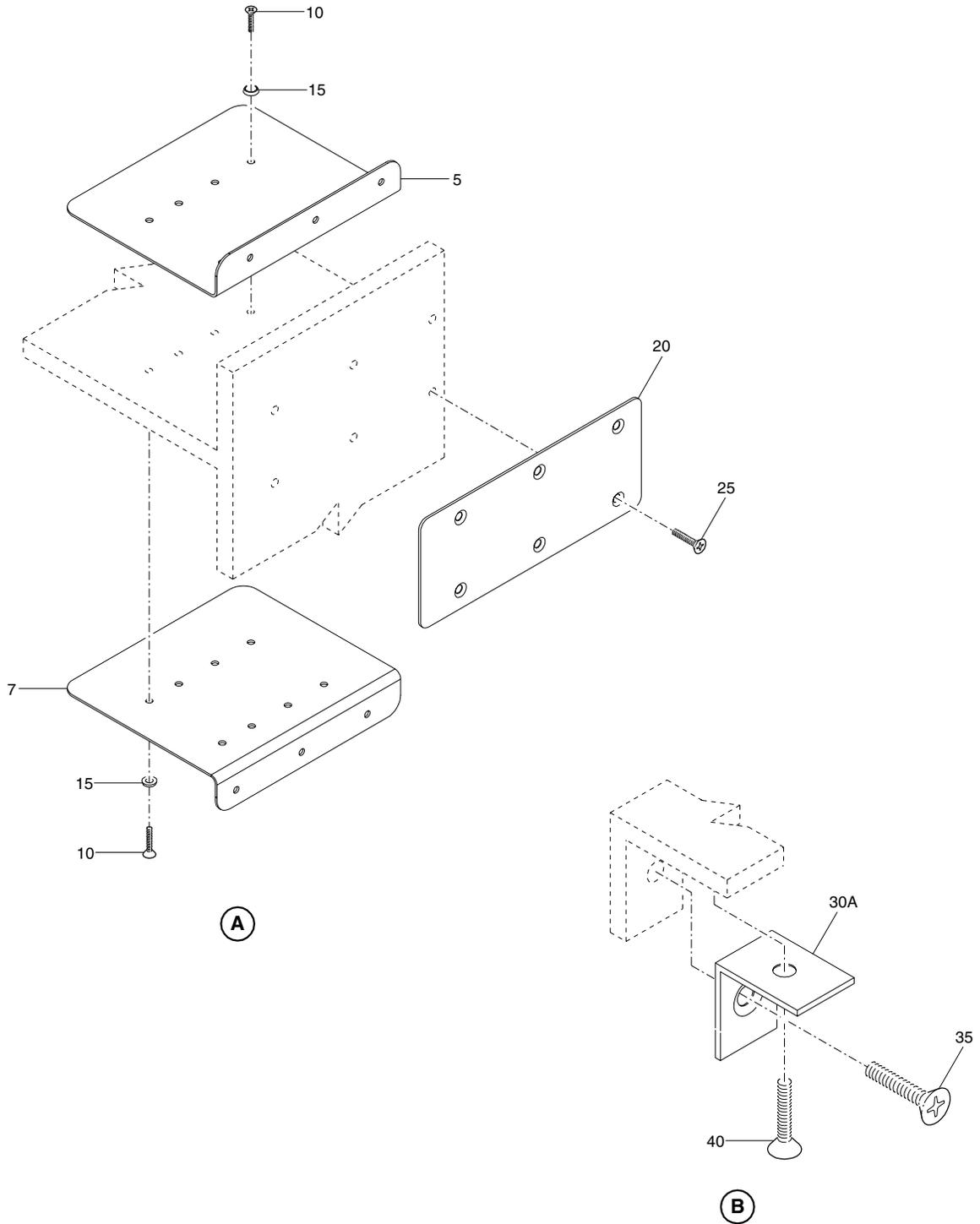
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Bonded Structure Assembly
 (Sheet 1 of 6)
 Figure 7/GRAPHIC 25-32-78-99b-012-A01

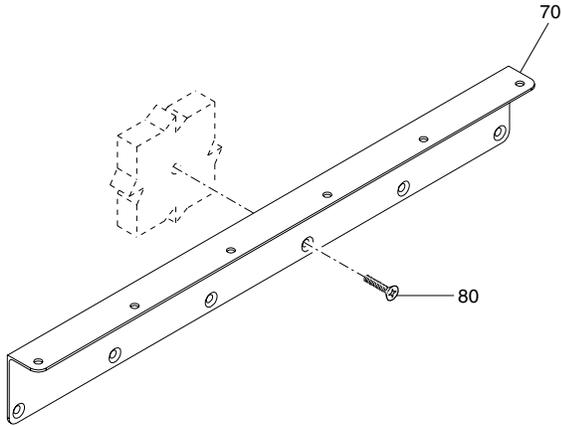
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 9861001/E179001/E199001/E829001/H511201/J061502/J709001



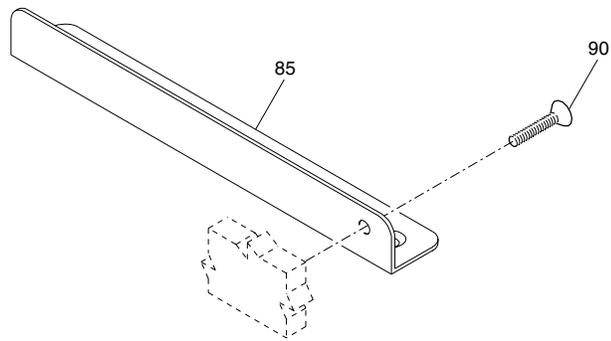
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Bonded Structure Assembly
 (Sheet 2 of 6)
 Figure 7/GRAPHIC 25-32-78-99b-012-A01

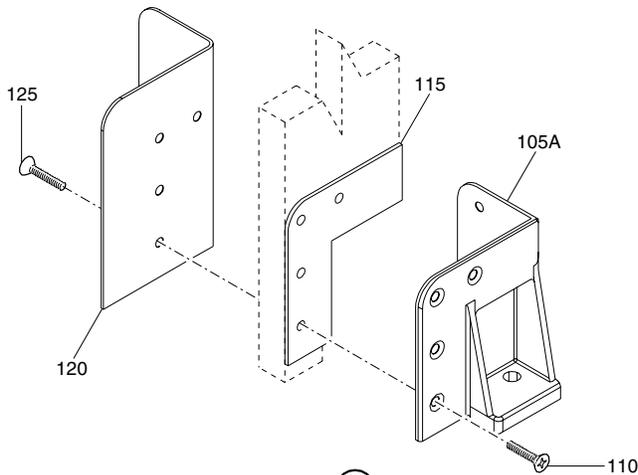
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 9861001/E179001/E199001/E829001/H511201/J061502/J709001



(C)



(D)

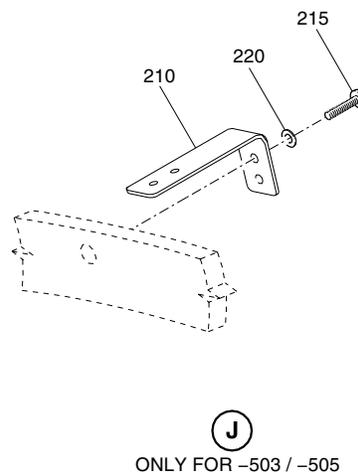
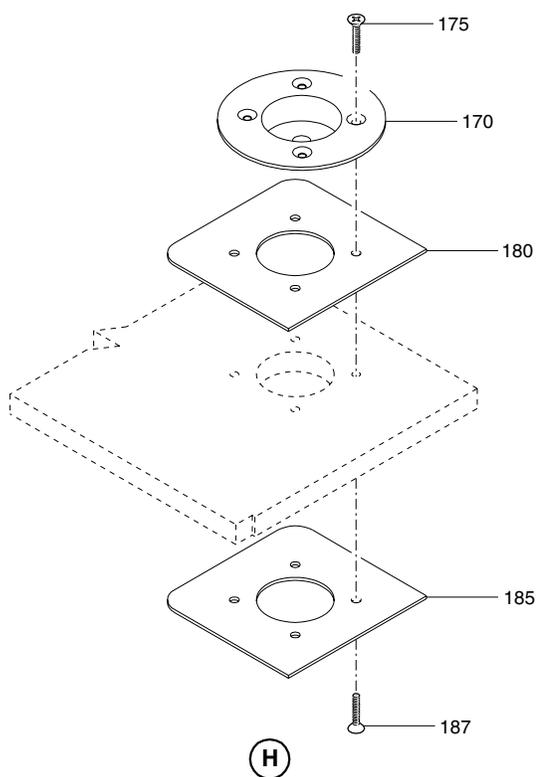
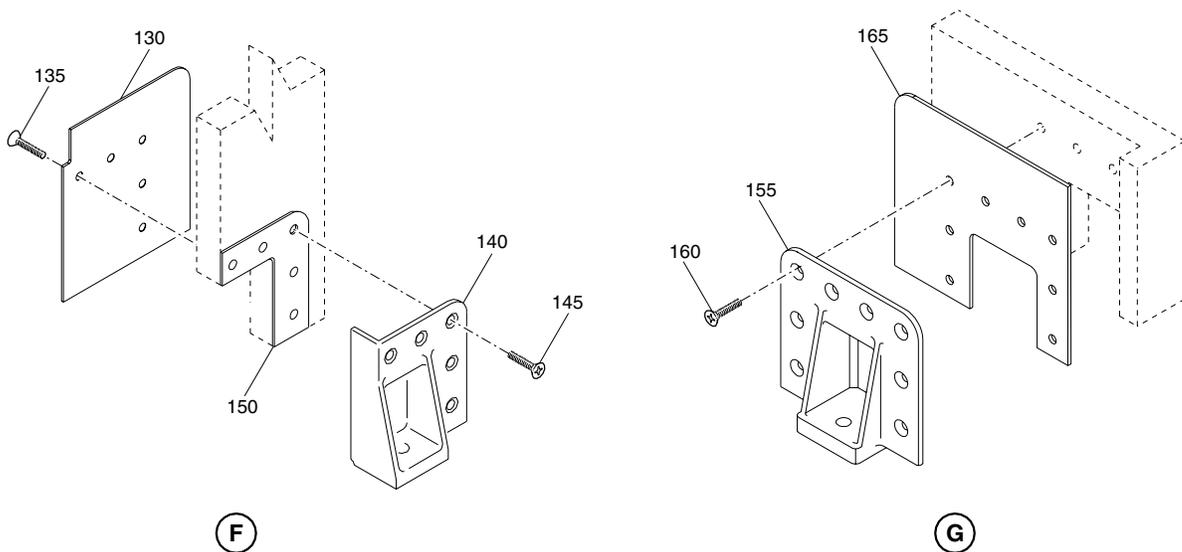


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Bonded Structure Assembly
 (Sheet 3 of 6)
 Figure 7/GRAPHIC 25-32-78-99b-012-A01

COMPONENT MAINTENANCE MANUAL
 9861001/E179001/E199001/E829001/H511201/J061502/J709001

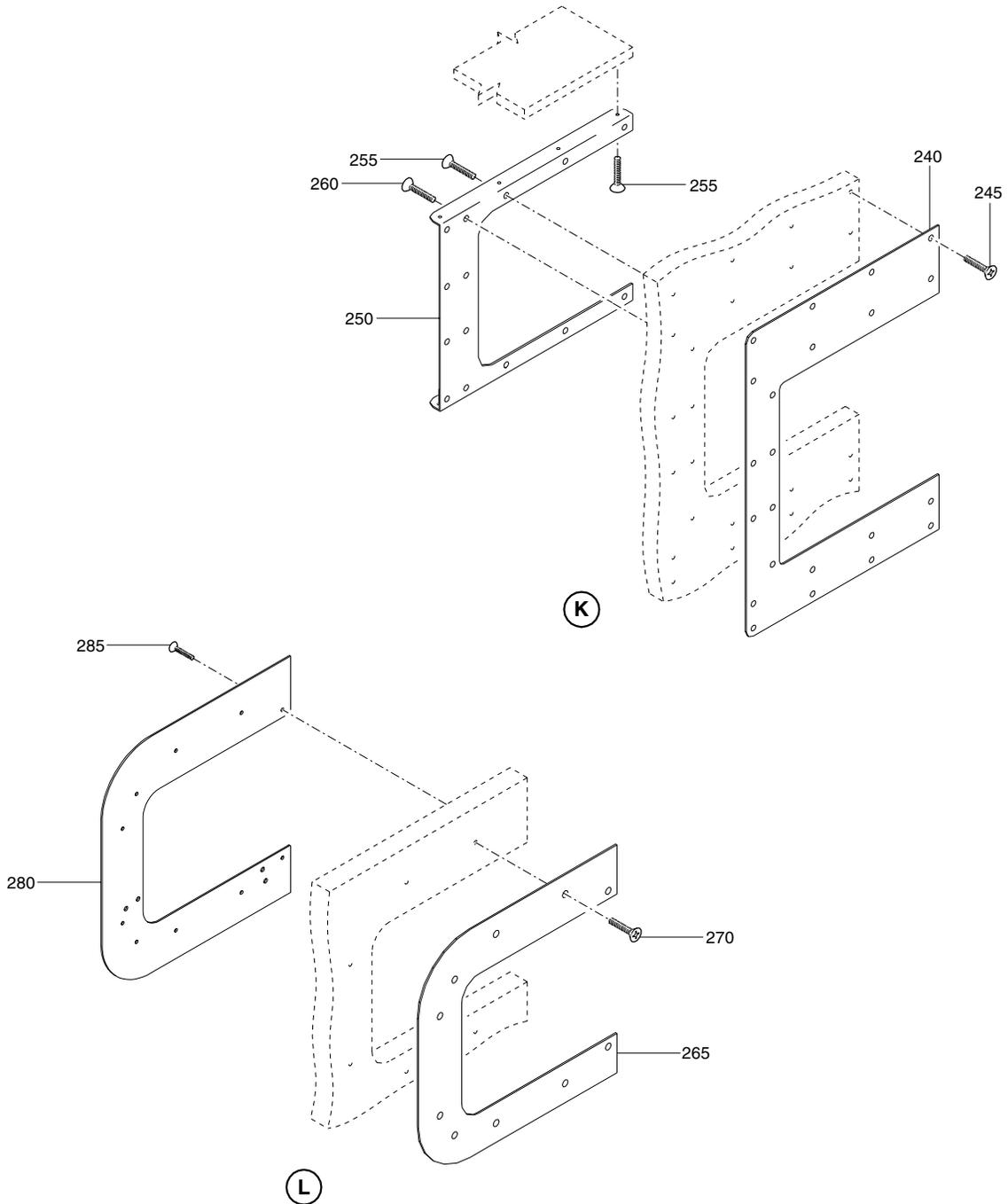


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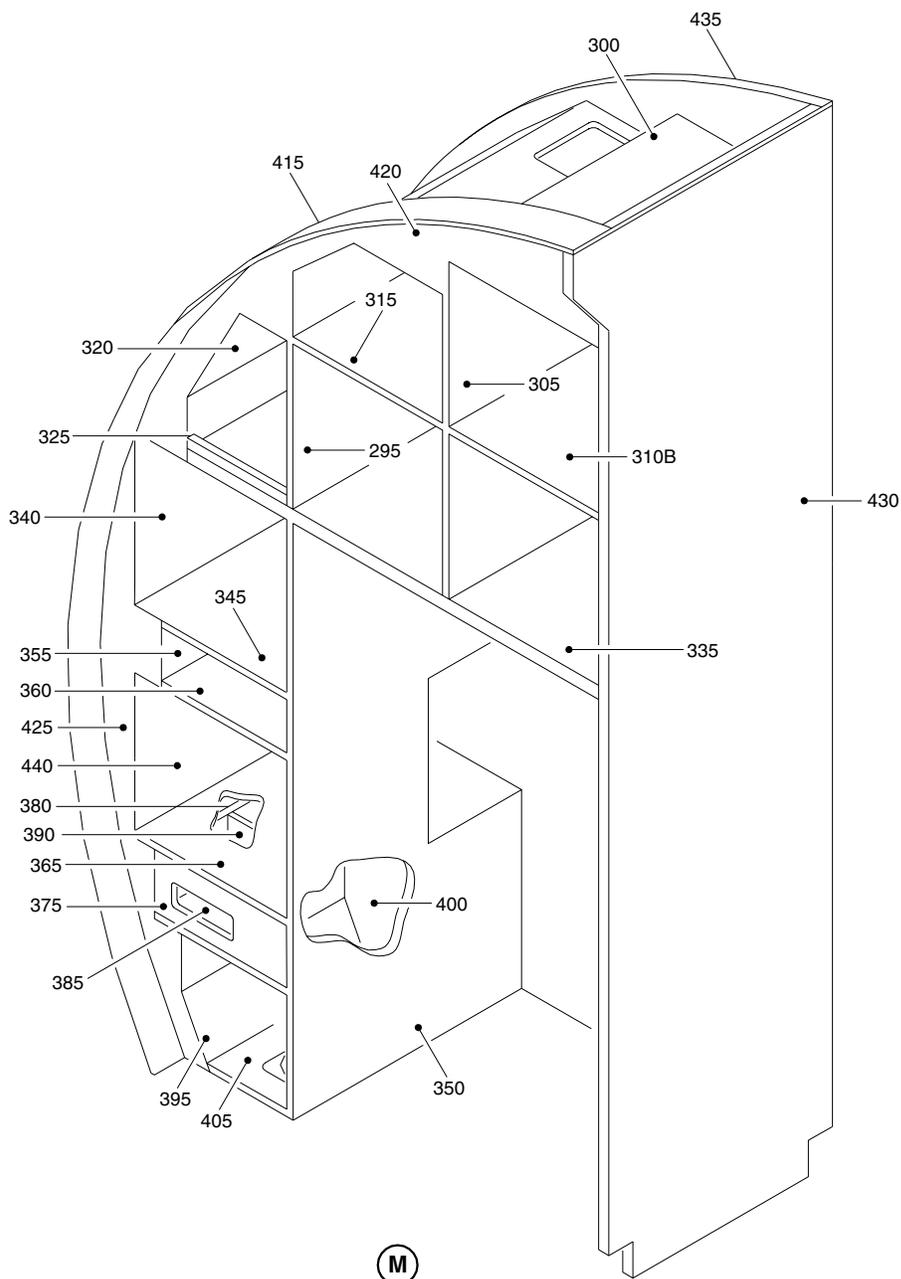
Bonded Structure Assembly
 (Sheet 4 of 6)
 Figure 7/GRAPHIC 25-32-78-99b-012-A01

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001



Bonded Structure Assembly
(Sheet 5 of 6)
Figure 7/GRAPHIC 25-32-78-99b-012-A01

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2532780706

Bonded Structure Assembly
 (Sheet 6 of 6)
 Figure 7/GRAPHIC 25-32-78-99b-012-A01

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COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
7 - 1	9861004-501		STRUCTURE ASSY, BONDED SEE FIG. 1 FOR NHA	A	RF
- 1A	9861004-503		STRUCTURE ASSY, BONDED SEE FIG. 1 FOR NHA	B	RF
- 1B	9861004-505		STRUCTURE ASSY, BONDED SEE FIG. 1 FOR NHA	C	RF
- 1C	9861004-507		STRUCTURE ASSY, BONDED SEE FIG. 1 FOR NHA	D	RF
- 1D	9861004-509		STRUCTURE ASSY, BONDED SEE FIG. 1 FOR NHA	E	RF
- 1E	9861004-511		STRUCTURE ASSY, BONDED SEE FIG. 1 FOR NHA	F	RF
- 1F	9861004-515		STRUCTURE ASSY, BONDED SEE FIG. 1 FOR NHA	G	RF
- 1G	9861004-513		STRUCTURE ASSY, BONDED SEE FIG. 1 FOR NHA	H	RF
- 1H	9861004-517		STRUCTURE ASSY, BONDED SEE FIG. 1 FOR NHA	J	RF
- 1J	9861004-519		STRUCTURE ASSY, BONDED SEE FIG. 1 FOR NHA	K	RF
5	9861354-1		. DOUBLER, UPR ATCH (BONDED)		1
7	9861354-2		. DOUBLER, UPR ATCH (BONDED)		1
			ATTACHING PARTS		
10	NAS514P1032-6		. SCREW		10
15	CDSP5801-3AL		. WASHER		10

20	9861354-3		. DOUBLER (BONDED)		1

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
7			ATTACHING PARTS		
25	NAS514P1032-5		. SCREW * * *		6
- 30	9861356-1		. ANGLE, REINFORCEMENT (BONDED) SUPSD BY ITEM 30A		2
30A	9861356-3		. ANGLE, REINFORCEMENT (BONDED) SUPSDS ITEM -30 ATTACHING PARTS		2
35	NAS514P1032-5		. SCREW		2
40	NAS514P1032-4		. SCREW * * *		2
- 42	AKS4-1032-80L		. RIVNUT (78276) SUPSD BY ITEM -42A		2
- 42A	AKS4-1032-130L		. RIVNUT (78276) SUPSDS ITEM -42		4
- 45	9861356-1		. DELETED ATTACHING PARTS		D
- 50	NAS514P1032-4		. DELETED * * *		D
- 55	9861356-1		. DELETED ATTACHING PARTS		D
- 60	NAS514P1032-5		. DELETED * * *		D
- 65	NAS514P1032-4		. DELETED		D
70	9861355-1		. ANGLE, REINFORCEMENT (BONDED)		1

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
7			ATTACHING PARTS		
- 75	NAS514P1032-13		. DELETED		D
80	NAS514P1032-5		. SCREW * * *		12
85	9861355-3		. ANGLE, REINFORCEMENT (BONDED) ATTACHING PARTS		1
90	NAS514P1032-5		. SCREW * * *		2
95	CDSP1417-1		. DOUBLER (BONDED)		2
- 100	CDSP1419-1		. DELETED		D
100A	9331073-1		. DOUBLER, CART RETAINER BLOCK (BONDED)		2
- 105	9391251-3		. DELETED		D
105A	9861251-3		. FLOOR FITTING ATTACHING PARTS		1
110	NAS514P1032-7		. SCREW * * *		7
115	9861004-5		. SPACER		1
120	9861353-3		. DOUBLER, FLOOR FITTING (BONDED) ATTACHING PARTS		1
125	NAS514P1032-6		. SCREW * * *		7
130	9861353-1		. DOUBLER, FLOOR FITTING (BONDED)		1

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
7			ATTACHING PARTS		
135	NAS514P1032-6		. SCREW * * *		5
140	9861251-1		. FLOOR FITTING ATTACHING PARTS		1
145	NAS514P1032-7		. SCREW * * *		5
150	9861004-3		. SPACER		1
155	9391251-1		. FLOOR FITTING ATTACHING PARTS		1
160	NAS514P1032-7		. SCREW * * *		8
165	9861353-5		. DOUBLER, FLOOR FITTING (BONDED)		1
170	9393251-3		. FLOOR FITTING ATTACHING PARTS		1
175	NAS514P1032-6		. SCREW * * *		4
180	9861353-7		. DOUBLER, FLOOR FITTING (BONDED)		1
185	9861353-9		. DOUBLER, FLOOR FITTING (BONDED) ATTACHING PARTS		1
187	NAS514P1032-4		. SCREW * * *		4
190	9861357-3		. PANEL, KICK (BONDED)	A,B	1
- 190A	9861357-9		. PANEL, KICK (BONDED)	C-J	1

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
7 195	9861357-1		. PANEL, KICK (BONDED)		1
200	4602308-501		. CHANNEL, STAB-IN (BONDED)	A	2
- 202	4602308-501		. CHANNEL, STAB-IN (BONDED)	D-H	2
210	9861352-7		. ANGLE, CURTAIN TRACK (BONDED)	A-J	1
			ATTACHING PARTS		
215	NAS603-5P		. SCREW	A-J	2
220	NAS1149F0332P		. WASHER	A-J	2
			* * *		
- 225	CD1N07-3-6		. INSERT (INCORRECT PN)	B,C	D
- 225A	CDIN07-3-6		. INSERT (CORRECT PN)	A-J	2
230	9861360-1		. DOUBLER (BONDED)		1
			ATTACHING PARTS		
- 235	AD42BS		. RIVET		10
			* * *		
240	9861359-1		. DOUBLER, PANEL SUPPORT (BONDED)	B-E,K	1
			ATTACHING PARTS		
245	NAS514P832-5		. SCREW	B-E,K	22
			* * *		
250	9861359-3		. DOUBLER, PANEL SUPPORT (BONDED)	B-E	1
- 250A	9861359-13		. DOUBLER, PANEL SUPPORT (BONDED)	K	1

- ITEM NOT ILLUSTRATED

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
7			ATTACHING PARTS		
	255 NAS514P832-5		. SCREW	B-E,K	16
	260 NAS514P832-4		. SCREW	B-E,K	6
			* * *		
	265 9861359-5		. DOUBLER, PANEL SUPPORT (BONDED)	B-E,K	1
			ATTACHING PARTS		
	270 NAS514P832-5		. SCREW	B-E,K	10
	- 275 NAS514P832-4		. DELETED		D
			* * *		
	280 9861359-7		. DOUBLER, PANEL SUPPORT (BONDED)	B-E,K	1
			ATTACHING PARTS		
	285 NAS514P832-4		. SCREW	B-E,K	10
			* * *		
	295 9861018-501		. PANEL ASSY, UPR FITTING (BONDED)	A-J	1
	- 295A 9861018-503		. PANEL ASSY, UPR FITTING (BONDED)	K	1
	- 296 CDSP5905-3-13		.. INSERT (BONDED)	A-J	1
	- 296A CDSP5905-3-13		.. INSERT (BONDED)	K	1
	- 297 CDSP5905-08-13		.. INSERT (BONDED)	A-J	10
	- 297A CDSP5905-08-13		.. INSERT (BONDED)	K	11
	- 298 CDSP5905-06-13		.. INSERT (BONDED)	A-J	6
	- 298A CDSP5905-06-13		.. INSERT (BONDED)	K	2

- ITEM NOT ILLUSTRATED

COMPONENT MAINTENANCE MANUAL
9861001/E179001/E199001/E829001/H511201/J061502/J709001

FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
7 - 299	9861018-1		.. PANEL	A-J	1
- 299A	9861018-3		.. PANEL	K	1
300	9861020-5		. PANEL, SU COMPT (BONDED)		1
305	9861017-501		. PANEL ASSY, DIVIDER (BONDED)	A	1
- 305A	9861017-503		. PANEL ASSY, DIVIDER (BONDED)	B-J	1
- 306	CDSP5905-3-13		.. INSERT (BONDED)	A	10
- 307	CDSP5905-08-13		.. INSERT (BONDED)		6
- 308	9861017-1		.. PANEL	A	1
- 308A	9861017-3		.. PANEL	B-J	1
- 309	9861017-3		.. PANEL (MOVED TO ITEM 308A)	B-J	D
- 310	9861020-501		. DELETED		D
- 310A	9861020-503		. PANEL ASSY, SU COMPT (BONDED)	B-J	1
310B	9861020-1		. PANEL, SU COMPT (BONDED)	A	1
- 311	CDSP5905-3-13		.. INSERT (BONDED)	B-J	6
- 312	9861020-7		.. PANEL	B-J	1
315	9861020-3		. PANEL, SU COMPT (BONDED)	A	1
- 315A	9861020-505		. PANEL ASSY, SU COMPT (BONDED)	B-J	1
- 316	CDSP5905-3-13		.. INSERT (BONDED)	B-J	4
- 317	9861020-9		.. PANEL	B-J	1
320	9861019-501		. PANEL ASSY, MISC (BONDED)		1

- ITEM NOT ILLUSTRATED

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
7 - 321	CDSP5905-3-13		.. INSERT (BONDED)		1
- 322	CDSP5905-06-13		.. INSERT (BONDED)		2
- 323	9861019-1		.. PANEL		1
325	9861026-503		. PANEL ASSY, SPACER (BONDED)		1
- 326	CDSP5905-3-13		.. INSERT (BONDED)		4
- 327	9861026-3		.. PANEL		1
335	9861015-501		. PANEL ASSY, SHELF (BONDED)		1
- 336	CDSP5905-3-28		.. INSERT (BONDED)		31
- 337	9861015-1		.. PANEL		1
340	9861021-501		. PANEL ASSY, SU COMPT (BONDED)		1
- 341	CDSP5905-3-13		.. INSERT (BONDED)		6
- 342	CDSP5905-08-13		.. INSERT (BONDED)		3
- 343	9861021-1		.. PANEL		1
345	9861021-505		. PANEL ASSY, SU COMPT (BONDED)		1
- 346	CDSP5905-08-13		.. INSERT (BONDED)		1
- 347	CDSP5905-06-13		.. INSERT (BONDED)		2
- 348	9861021-5		.. PANEL		1
350	9861016-501		. PANEL ASSY, CART (BONDED)	A,F	1
- 350A	9861016-503		. PANEL ASSY, CART (BONDED)	B-E	1

- ITEM NOT ILLUSTRATED

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
7 – 350B	9861016-505		. PANEL ASSY, CART (BONDED)	G-J	1
– 350C	9861016-507		. PANEL ASSY, CART (BONDED)	K	1
– 351	CDSP5905-3-13		.. INSERT (BONDED)	A-F	18
– 351A	CDSP5905-3-13		.. INSERT (BONDED)	G,J	21
– 351B	CDSP5905-3-13		.. INSERT (BONDED)	K	20
– 352	CDSP5905-08-13		.. INSERT (BONDED)	A,F	21
– 352A	CDSP5905-08-13		.. INSERT (BONDED)	B-E	51
– 352B	CDSP5905-08-13		.. INSERT (BONDED)	G,J	24
– 352C	CDSP5905-08-13		.. INSERT (BONDED)	K	51
– 353	9861016-1		.. PANEL	A,F	1
– 353A	9861016-3		.. PANEL	B-E	1
– 353B	9861016-5		.. PANEL	G,J	1
– 353C	9861016-7		.. PANEL	K	1
355	9861021-503		. PANEL ASSY, DRAWER COMPT (BONDED)		1
– 356	CDSP5905-08-13		.. INSERT (BONDED)		6
– 357	9861021-3		.. PANEL		1
360	9861022-3		. PANEL, SU COMPT (BONDED)		1
– 360A	9861022-505		. PANEL ASSY, SU COMPT (BONDED)	B-E,K	1
– 361	CDSP5905-08-13		.. INSERT (BONDED)	B-E,K	4

– ITEM NOT ILLUSTRATED

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
7 - 362	9861022-11		.. PANEL	B-E,K	1
365	9861022-5		. PANEL, SU COMPT (BONDED)	A,F-J	1
- 365A	9861022-507		. PANEL ASSY, SU COMPT (BONDED)	B-E,K	1
- 366	CDSP5905-08-13		.. INSERT (BONDED)	B-E,K	4
- 367	9861022-13		.. PANEL	B-E,K	1
- 370	9861022-501		. PANEL ASSY, SU COMPT (BONDED) (MOVED TO ITEM -440)	A,F-H,J	D
- 370A	9861022-503		. PANEL ASSY, SU COMPT (BONDED) (MOVED TO ITEM -440A)	B	D
- 370B	9861029-501		. PANEL ASSY, SU COMPT (BONDED) (MOVED TO ITEM -440B)	C-E,K	D
375	9861023-5		. PANEL, FLOOD LIGHT (BONDED)	A-D,H,J	1
- 375A	9863028-1		. PANEL, FLOOD LIGHT (BONDED)	E-H,K	1
380	9861023-503		. PANEL ASSY (BONDED)	A,F-J	1
- 380A	9861023-507		. PANEL ASSY (BONDED)	B-E,K	1
- 381	CDSP5905-08-13		.. INSERT (BONDED)	A,F-J	2
- 382	CDSP5905-3-13		.. INSERT (BONDED)	B-E,K	8
- 383	9861023-3		.. PANEL	A,F-J	1
- 383A	9861023-9		.. PANEL	B-E,K	1
385	9861023-501		. PANEL ASSY, DRAWER COMPT (BONDED)	A,F-J	1

- ITEM NOT ILLUSTRATED

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
7 - 385A	9861023-505		. PANEL ASSY, DRAWER COMPT (BONDED)	B-E,K	1
- 386	CDSP5905-08-13		.. INSERT (BONDED)		1
- 387	CDSP5905-06-13		.. INSERT (BONDED)		2
- 388	9861023-1		.. PANEL	A,F-J	1
- 388A	9861023-7		.. PANEL	B-E,K	1
390	9861023-11		. PANEL, ENCLOSURE (BONDED)	B-E,K	1
395	9861024-501		. PANEL ASSY, DRAWER COMPT (BONDED)	A,F-J	1
- 395A	9861024-503		. PANEL ASSY, DRAWER COMPT (BONDED)	B-E	1
- 395B	9861024-505		. PANEL ASSY, DRAWER COMPT (BONDED)	K	1
- 396	CDSP5905-08-13		.. INSERT (BONDED)		6
- 397	9861024-1		.. PANEL	A,F-J	1
- 397A	9861024-3		.. PANEL	B-E	1
- 397B	9861024-5		.. PANEL	K	1
400	9861028-1		. PANEL, CLOSEOUT (BONDED)	B-E	1
- 400A	9862038-1		. PANEL, CLOSEOUT (BONDED)	K	1
405	9861025-501		. PANEL ASSY, FLOOR (BONDED)	A,F-J	1
- 405A	9861025-503		. PANEL ASSY, FLOOR (BONDED)	B-E,K	1
- 406	9861025-1		.. PANEL	A,F-J	1
- 406A	9861025-3		.. PANEL	B-E,K	1
- 407	9861025-3		.. PANEL (MOVED TO ITEM -406A)	B-E,K	D

- ITEM NOT ILLUSTRATED

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
7 415	9861027-1		. PANEL, CONTOUR OUTBD (BONDED)		1
420	9861013-1		. PANEL, FWD CLOSEOUT (BONDED)		1
425	9861014-1		. PANEL, FWD CLOSEOUT (BONDED)		1
430	9861012-501		. PANEL ASSY, AISLE (BONDED)	A,B	1
- 430A	9861012-503		. PANEL ASSY, AISLE (BONDED)	C,D,K	1
- 430B	9861012-505		. PANEL ASSY, AISLE (BONDED)	E	1
- 430C	9861012-507		. PANEL ASSY, AISLE (BONDED)	F	1
- 430D	9861012-509		. PANEL ASSY, AISLE (BONDED)	G,H,J	1
- 431	CDSP5905-3-20		.. INSERT (BONDED)	A,B,K	12
- 431A	CDSP5905-3-20		.. INSERT (BONDED)	C-F	15
- 431B	CDSP5905-3-20		.. INSERT (BONDED)	G,H,J	17
- 432	CDSP5905-08-20		.. INSERT (BONDED)	A-D,K	12
- 432A	CDSP5905-08-20		.. INSERT (BONDED)	F,G,H,J	14
- 433	CDSP5905-06-20		.. INSERT (BONDED)		3
- 434	9861012-1		.. PANEL	A,B	1
- 434A	9861012-3		.. PANEL	C,D,K	1
- 434B	9861012-5		.. PANEL	E	1
- 434C	9861012-7		.. PANEL	F	1
- 434D	9861012-9		.. PANEL	G,H,J	1

- ITEM NOT ILLUSTRATED

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
7 435	9861011-501		. PANEL ASSY, AFT (BONDED)	A	1
- 435A	9861011-503		. PANEL ASSY, AFT (BONDED)	B-E,K	1
- 435B	9861011-505		. PANEL ASSY, AFT (BONDED)	F	1
- 435C	9861011-507		. PANEL ASSY, AFT (BONDED)	G,H	1
- 435D	9861011-509		. PANEL ASSY, AFT (BONDED)	J	1
- 436	CDIN07-04-20		.. INSERT (BONDED)	A	4
- 437	CDSP5905-3-20		.. INSERT (BONDED)	A-E,K	26
- 437A	CDSP5905-3-20		.. INSERT (BONDED)	F,G,H	28
- 438	CDSP5905-08-20		.. INSERT (BONDED)	A	8
- 438A	CDSP5905-08-20		.. INSERT (BONDED)	B-E,K	6
- 438B	CDSP5905-08-20		.. INSERT (BONDED)	F,G,H	18
- 439	9861011-1		.. PANEL	A	1
- 439A	9861011-3		.. PANEL	B-E,K	1
- 439B	9861011-5		.. PANEL	F	1
- 439C	9861011-11		.. PANEL	G,H	1
440	9861022-501		. PANEL ASSY, SU COMPT (BONDED)	A,F-J	1
- 440A	9861022-503		. PANEL ASSY, SU COMPT (BONDED)	B	1
- 440B	9861029-501		. PANEL ASSY, SU COMPT (BONDED)	C-E,K	1

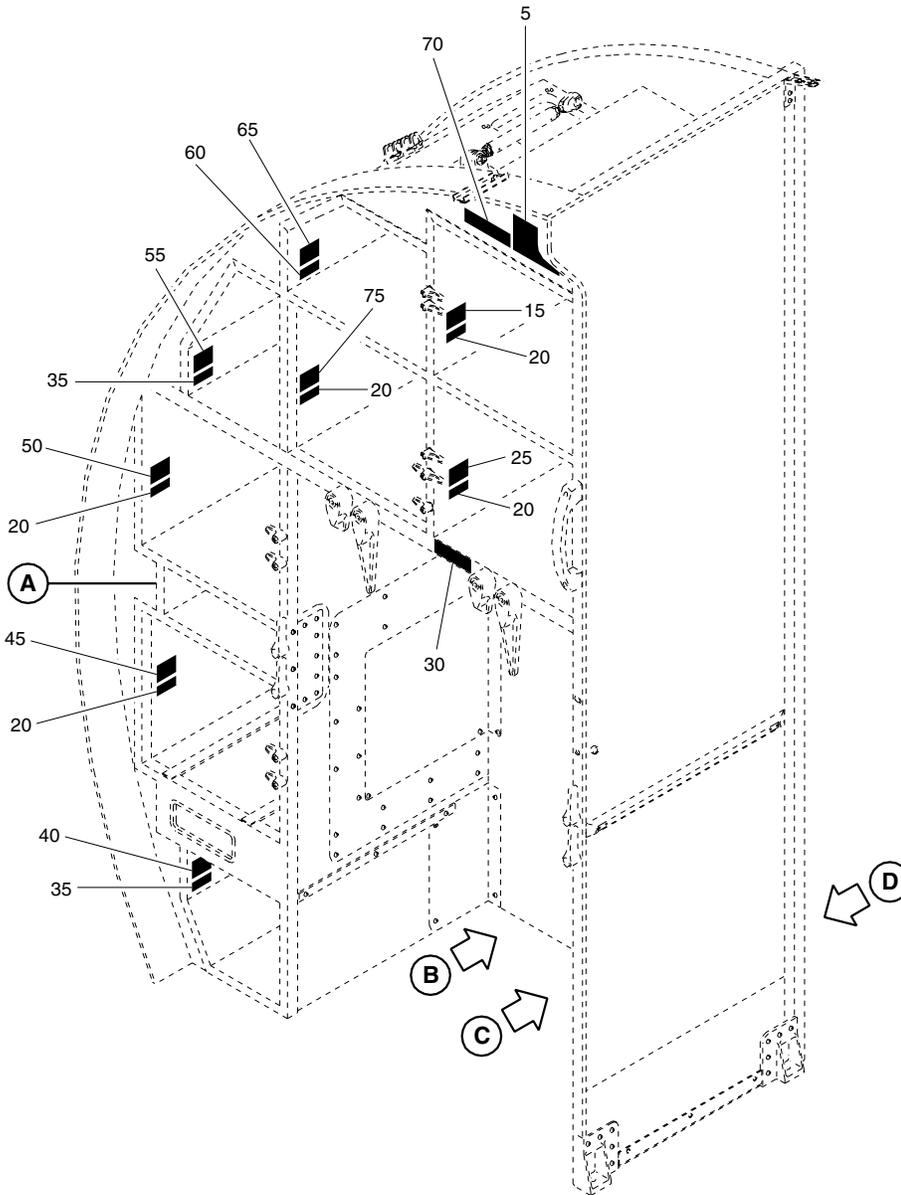
- ITEM NOT ILLUSTRATED

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
7 - 445	CDSP5905-08-13		.. INSERT (BONDED)	A,F-H	3
- 445A	CDSP5905-08-13		.. INSERT (BONDED)	B	5
- 450	CDSP5905-3-13		.. INSERT (BONDED)	B	4
- 455	CDSP5905-3-13		.. INSERT (BONDED)	C-E,K	4
- 460	CDSP5905-08-13		.. INSERT (BONDED)	C-E,K	3
- 465	9861022-1		.. PANEL	A,F-J	1
- 465A	9861022-7		.. PANEL	B	1
- 465B	9861029-1		.. PANEL	C-E,K	1

- ITEM NOT ILLUSTRATED

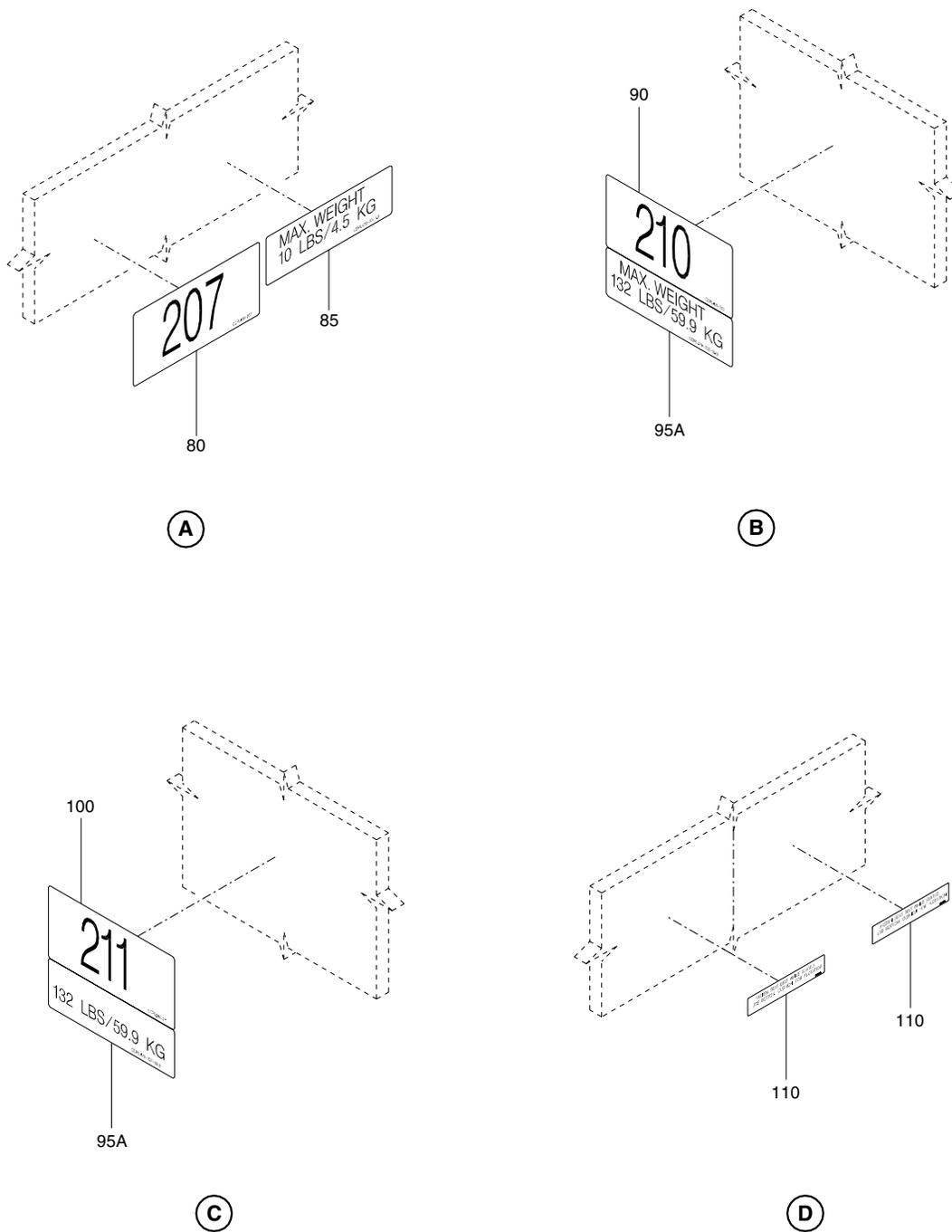
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Placard Installation
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 Figure 8/GRAPHIC 25-32-78-99b-013-A01

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Placard Installation
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 Figure 8/GRAPHIC 25-32-78-99b-013-A01

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
8 - 1	9861007-503		PLACARD INSTL SEE FIG. 1 FOR NHA SEE FIG. 1F FOR NHA	A	RF
- 1A	9861007-501		PLACARD INSTL SEE FIG. 1 FOR NHA	B	RF
5	CDPL1069-1		. PLACARD (BONDED) ATTACHING PARTS		1
- 10	AD32BS		. DELETED * * *		D
15	CDPL466-202		. PLACARD (BONDED)		1
20	CDPL479-50-227		. PLACARD (BONDED) (TRUE CDPL479-50-22.7)		5
25	CDPL466-205		. PLACARD (BONDED)		1
30	CDPL1017		. PLACARD (BONDED)		1
35	CDPL479-20-91		. PLACARD (BONDED) (TRUE CDPL479-20-9.1)		2
40	CDPL466-209		. PLACARD (BONDED)		1
45	CDPL466-208		. PLACARD (BONDED)		1
50	CDPL466-206		. PLACARD (BONDED)		1
55	CDPL466-203		. PLACARD (BONDED)		1
60	CDPL479-30-136		. PLACARD (BONDED) (TRUE CDPL479-30-13.6)		1

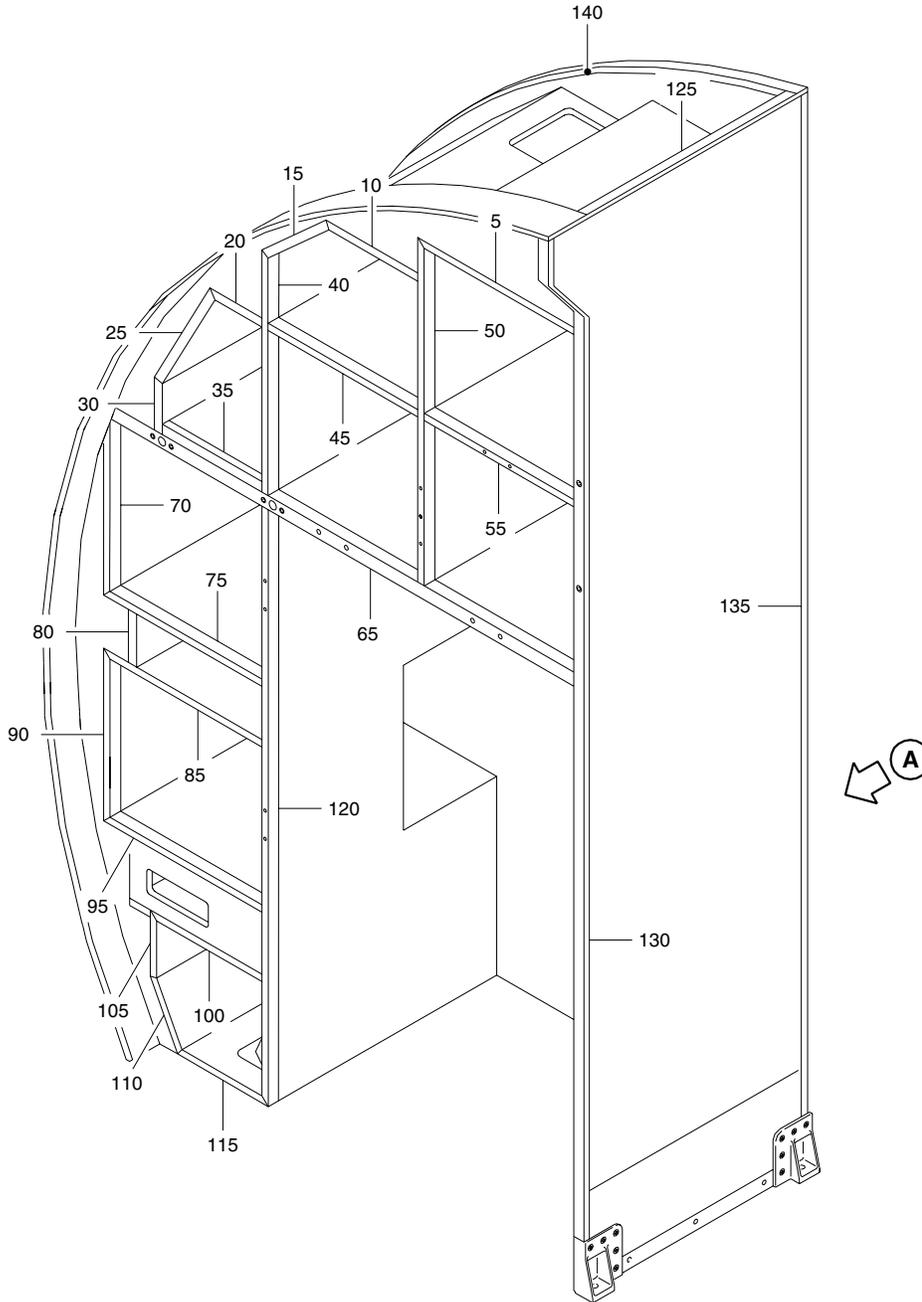
- ITEM NOT ILLUSTRATED

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
8	65	CDPL466-201	. PLACARD (BONDED)		1
	70	CDPL1008	. PLACARD (BONDED)		1
	75	CDPL466-204	. PLACARD (BONDED)		1
	80	CDPL466-207	. PLACARD (BONDED)		1
	85	CDPL479-10-45	. PLACARD (BONDED) (TRUE CDPL479-10-4.5)		1
	90	CDPL466-210	. PLACARD (BONDED)		1
	- 95	CDPL479-150-682	. PLACARD (BONDED) (TRUE CDPL479-150-68.2) SUPSD BY ITEM 95A		2
	95A	CDPL479-132-599	. PLACARD (BONDED) (TRUE CDPL479-132-59.9) SUPSDS ITEM -95		2
	100	CDPL466-211	. PLACARD (BONDED)		1
	- 105	CDPL1068-1	. DELETED		D
	110	CDPL1068-1	. PLACARD (BONDED)	B	2

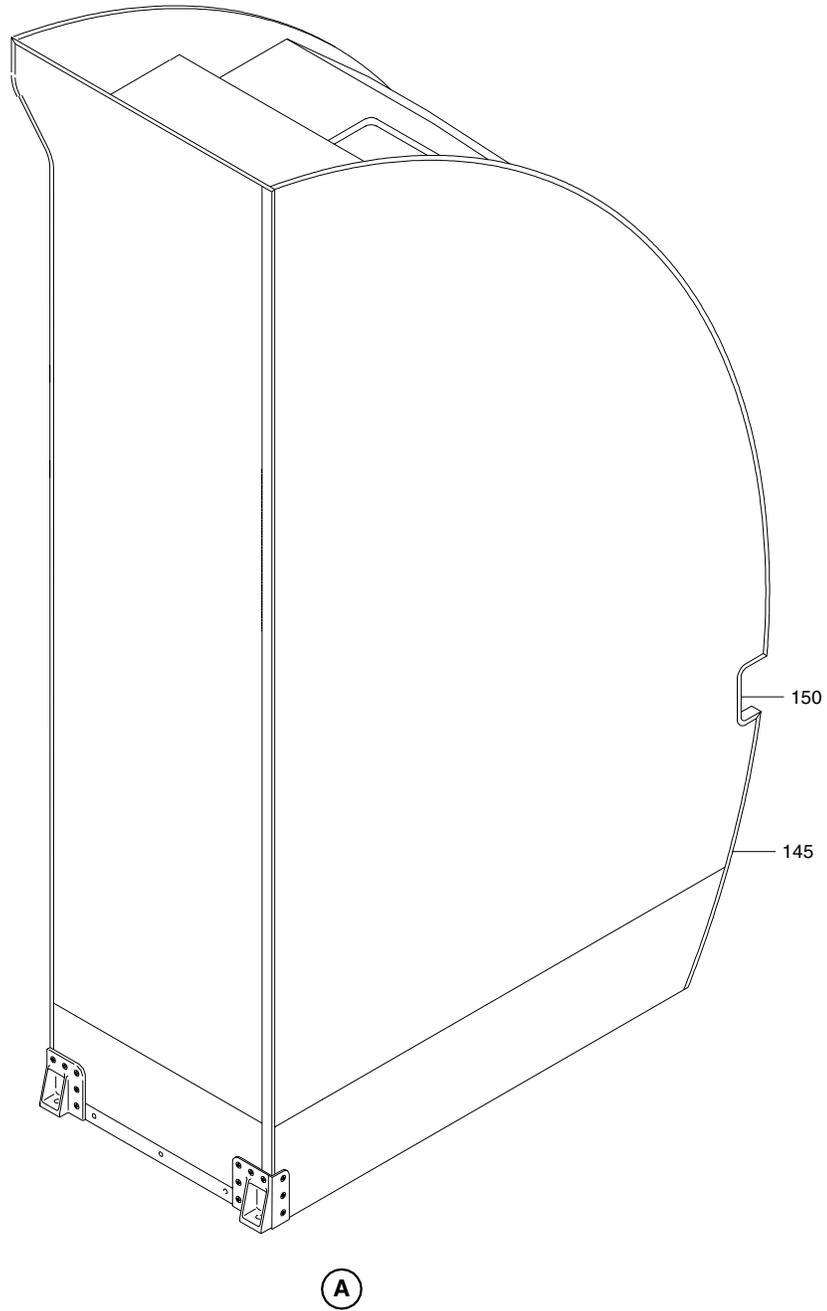
- ITEM NOT ILLUSTRATED

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Extrusion Installation
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 Figure 9/GRAPHIC 25-32-78-99b-014-A01



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Extrusion Installation
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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
9 - 1	9861009-501		EXTRUSION INSTL SEE FIG. 1 FOR NHA	A	RF
- 1A	9861009-503		EXTRUSION INSTL SEE FIG. 1 FOR NHA	B	RF
- 1B	9861009-505		EXTRUSION INSTL SEE FIG. 1 FOR NHA	C	RF
- 1C	9861009-509		EXTRUSION INSTL SEE FIG. 1 FOR NHA	D	RF
- 1D	9861009-511		EXTRUSION INSTL SEE FIG. 1 FOR NHA	E	RF
- 1E	9861009-513		EXTRUSION INSTL SEE FIG. 1 FOR NHA	F	RF
- 1F	9861009-515		EXTRUSION INSTL SEE FIG. 1 FOR NHA	G	RF
5	9861009-45		. TRIM (BONDED)		1
10	9861009-11		. TRIM (BONDED)		1
15	9861009-13		. TRIM (BONDED)	A-C, F,G	1
- 15A	9861009-69		. TRIM (BONDED)	D,E	1
20	9861009-47		. TRIM (BONDED)		1
25	9861009-17		. TRIM (BONDED)	A-C, F,G	1
- 25A	9861009-63		. TRIM (BONDED)	D,E	1
30	9861009-21		. TRIM (BONDED)		1
35	9861009-19		. TRIM (BONDED)		1
40	9861301-9		. TRIM (BONDED)		1

- ITEM NOT ILLUSTRATED

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
9	45 9861009-15		. TRIM (BONDED)		1
	50 9861301-5		. TRIM (BONDED)	A-D	1
	- 50A 9861301-17		. TRIM (BONDED)	E-G	1
	55 9861301-7		. TRIM (BONDED)		1
	- 60 AKS4-832-80L		. RIVNUT		4
	65 9861301-1		. TRIM (BONDED)	A-D	1
	- 65A 9861301-13		. TRIM (BONDED)	E-G	1
	70 9861009-25		. TRIM (BONDED)		1
	75 9861009-27		. TRIM (BONDED)	A-C, F,G	1
	- 75A 9861009-65		. TRIM (BONDED)	D,E	1
	80 9861009-29		. TRIM (BONDED)		1
	85 9861009-31		. TRIM (BONDED)		1
	90 9861009-33		. TRIM (BONDED)		1
	95 9861009-49		. TRIM (BONDED)		1
	100 9861009-37		. TRIM (BONDED)	A-C, F,G	1
	- 100A 9861009-67		. TRIM (BONDED)	D,E	1
	105 9861009-39		. TRIM (BONDED)		1

- ITEM NOT ILLUSTRATED

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FIG. ITEM	PART NUMBER	AIRLINE STOCK NUMBER	NOMENCLATURE 1234567	EFFECT CODE	UNITS PER ASSY
9 110	9861009-41		. TRIM (BONDED)		1
115	9861009-43		. TRIM (BONDED)		1
120	9861301-3		. TRIM (BONDED)	A-D	1
- 120A	9861301-15		. TRIM (BONDED)	E,F	1
- 120B	9861301-19		. TRIM (BONDED)	G	1
125	9861009-9		. TRIM (BONDED)		1
130	9861009-1		. TRIM (BONDED)	A-C	1
- 130A	9861009-61		. TRIM (BONDED)	D-G	1
135	9861009-3		. TRIM (BONDED)	A,B,D, E,G	1
- 135A	9861009-55		. TRIM (BONDED)	C,F	1
140	9861009-7		. TRIM (BONDED)	A,D,E	1
- 140A	9861009-51		. TRIM (BONDED)	B,C, F,G	1
145	9861009-53		. TRIM (BONDED)	B,C, F,G	1
150	9861301-11		. TRIM (BONDED)	B,C, F,G	1

- ITEM NOT ILLUSTRATED

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