

CHAPTER 52

DOORS AND WINDOWS

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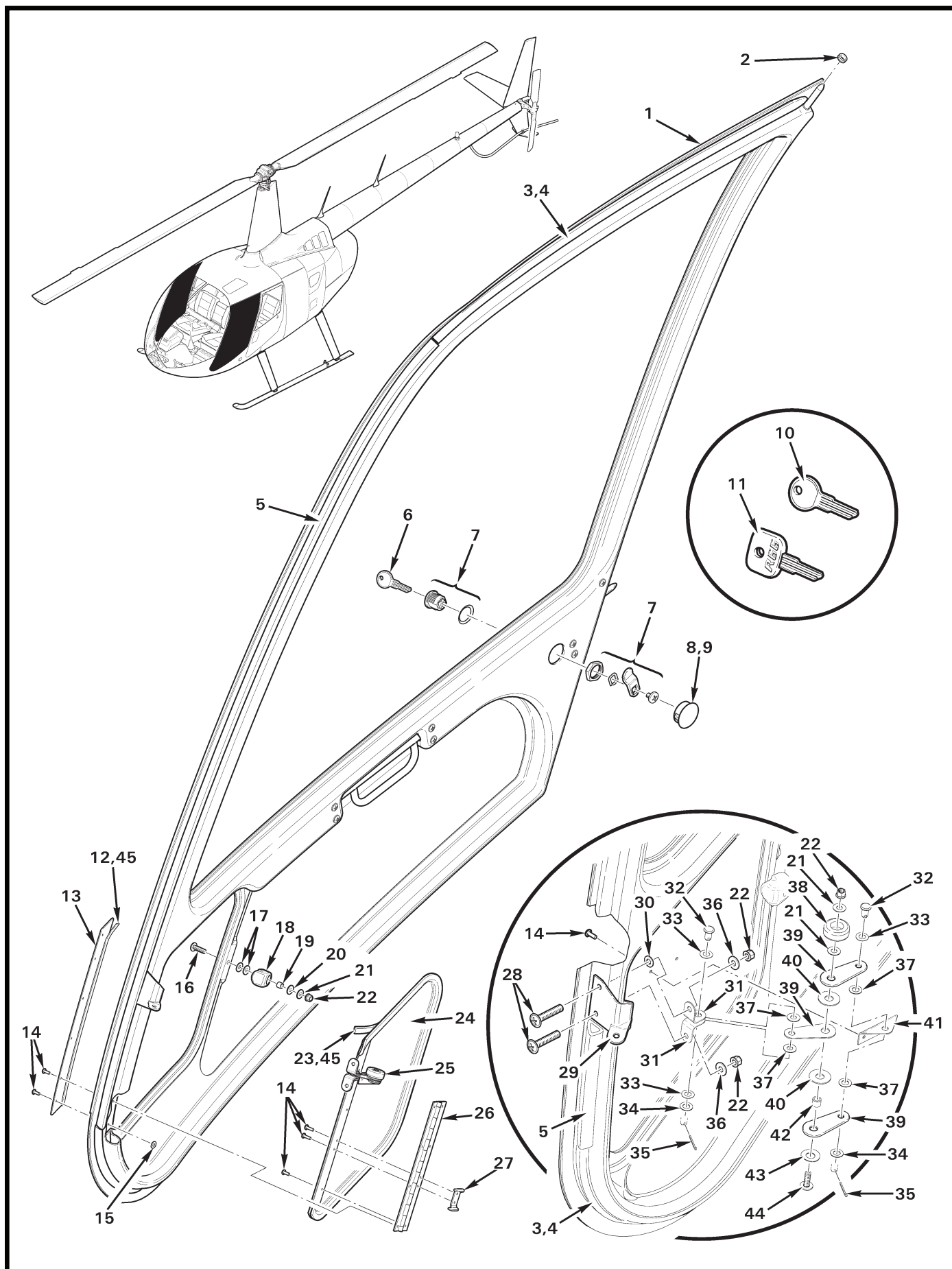


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		FORWARD DOOR ASSEMBLY		
52-1-1	C026-016	Door Assembly (RH, clear; Incl items 2 thru 30, and 36)	X	1
	C026-015	Door Assembly (LH, clear [not shown]; Incl items 2 thru 28, 34, and 43)	X	1
	C026-026	Door Assembly (RH, tinted; Incl items 2 thru 28, 34, and 43)	X	1
	C026-025	Door Assembly (LH, tinted [not shown]; Incl items 2 thru 28, 34, and 43)	X	1
	C026-036	Door Assembly (RH, bubble, clear; Incl items 2 thru 28, 34, and 43)	X	1
	C026-035	Door Assembly (LH, bubble, clear [not shown]; Incl items 2 thru 28, 34, and 43)	X	1
	C026-046	Door Assembly (RH, bubble, tinted; Incl items 2 thru 28, 34, and 43)	X	1
	C026-045	Door Assembly (LH, bubble, tinted [not shown]; Incl items 2 thru 28, 34, and 43)	X	1
	C026-006	Door Assembly (RH, large bubble, clear; Incl items 2 thru 30, and 36)	X	1
	C026-005	Door Assembly (LH, large bubble, clear [not shown]; Incl items 2 thru 28, 34, and 43)	X	1
2	NAS557-4B	Grommet	X	1
3	A226-2	Seal (install using item 4)	X	A/R
4	B270-18	Adhesive	X	A/R
5	A226-6	Seal (forward door edge, self adhesive)	X	A/R
6	D768-8	Key (metal)	X	1
7	A556-3	Lock (RH or LH)	X	1
	D768-7	Lock Set (Ref; [3] A556-3 locks, [2] D768-8 keys, and [1] F661-2 switch)		
8	2713	Hole Plug	X	1
9	B270-9	Adhesive	X	A/R
10	R8096	Key – Duplicate (specify ship S/N and “PK” numbers when ordering)	X	1
11	R8428	Key – Blank (black plastic-coated “R66” logo)	X	1
12	A226-3	Seal (install using item 45)	X	A/R
13	C682-3	Barrier	X	1
14	MS20470AD3	Rivet	X	13
15	NAS1149FN232P	Washer	X	2
16	AN525-832R10	Screw	X	1
17	NAS1149FN816P	Washer (or NAS1149FN832P as required for shimming this location)	X	A/R
NOTES				
Continues				

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
FORWARD DOOR ASSEMBLY (Cont'd)				
52-1-18	C285-1	Knob	X	1
19	C130-5	Spacer	X	1
20	U216-0100-S	Spring Washer	X	1
21	NAS1149FN816P	Washer	X	3
22	MS21042L08	Nut	X	4
23	A226-7	Seal (install using item 45)	X	A/R
24	C425-10	Door – Vent (RH)	X	1
	C425-9	Door – Vent (LH, not shown)	X	1
25	A425-17	Arm Assembly (Incl items 21, 22, 31 thru 35, and 37 thru 44)	X	1
26	C425-5	Hinge	X	1
27	B242-2	Stop	X	1
28	AN525-832R16	Screw	X	2
29	D574-12	Bracket Weldment (RH)	X	1
	D574-11	Bracket Weldment (LH, not shown)	X	1
30	A141-19	Washer	X	1
31	A425-19	Clip	X	2
32	MS20392-2C7	Pin	X	2
33	U190-0090S	Spring Washer	X	3
34	NAS1149F0332P	Washer	X	2
35	MS24665-132	Cotter Pin	X	2
36	NAS1149FN832P	Washer	X	2
37	A141-8	Washer	X	4
38	A431-1	Knob	X	1
39	A425-7	Arm	X	3
40	A141-7	Washer	X	2
41	A425-13	Angle	X	1
42	A105-7	Journal	X	1
43	U250-0185	Spring Washer	X	1
44	AN525-832R8	Screw	X	1
45	B270-8qt	Adhesive	X	A/R
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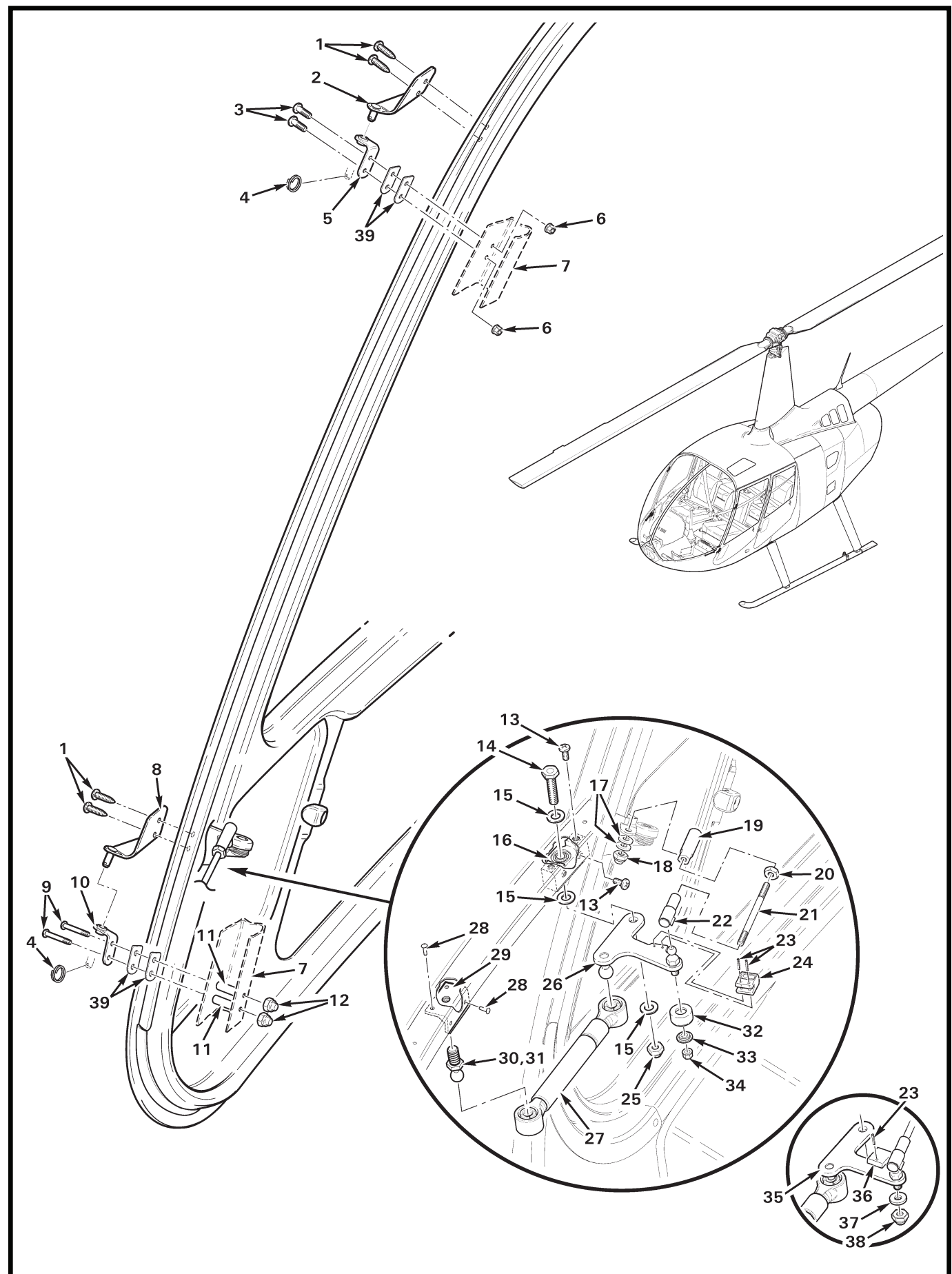


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		FORWARD DOOR INSTALLATION		
52-5-1	MS51861-37C	Screw	X	4
2	F227-4	Hinge Assembly (RH)	X	1
	F227-3	Hinge Assembly (LH, not shown)	X	1
3	MS27039C0807	Screw (if [0 to 1] of item 39 is installed)	X	4
	MS27039C0808	Screw (if [2 to 3] of item 39 is installed)	X	4
	MS27039C0809	Screw (if [4] of item 39 is installed)	X	4
4	B427-1	Ring	X	2
5	C228-4	Hinge Assembly	X	1
6	MS21042L08	Nut	X	4
7	C238	Jamb (Ref)		
8	F227-2	Hinge Assembly (RH)	X	1
	F227-1	Hinge Assembly (LH, not shown)	X	1
9	MS27039C0824	Screw (if [0 to 1] of item 39 is installed)	X	4
	MS27039C0825	Screw (if [2 to 3] of item 39 is installed)	X	4
	MS27039C0826	Screw (if [4] of item 39 is installed)	X	4
10	C228-2	Hinge Assembly	X	2
11	C130-37	Spacer	X	4
12	B340-4	Nut	X	4
13	MS27039C0806	Screw	X	4
14	NAS6604-12	Bolt	X	1
15	NAS1149F0432P	Washer	X	3
16	D573-1	Block Assembly	X	1
17	NAS1149F0363P	Washer	X	3
18	B340-8	Nut	X	2
19	D575-3	Ball Joint	X	1
20	AN315-3R	Nut	X	1
21	D573-4	Rod	X	1
22	D575-2	Ball Joint	X	1
23	MS16562-4	Spring Pin (one pin on item 36)	X	2
24	D573-7	Bumper	X	1
25	B340-10	Nut	X	1
26	D574-10*	Arm Assembly (RH, includes items 23 and 24)	X	1
	D574-9*	Arm Assembly (LH, not shown; includes items 23 and 24)	X	1
27	D575-1	Gas Spring	X	1
28	MS20470AD4	Rivet	X	4

NOTES * Revision F and prior have one bumper hole, Revision G and subsequent have two bumper holes.

Continues

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
FORWARD DOOR INSTALLATION (Cont'd)				
52-5-29	D573-3	Block	X	1
30	C394-2	Ball Stud (install using item 31)	X	1
31	B270-10	Adhesive	X	A/R
32	C119-3	Bumper	X	1
33	B138-2	Spacer	X	1
34	D210-3	Nut	X	1
35	D574-9/-10*	Arm Assembly (Ref, revision F and prior. To replace, order item 26.)		
36	D573-6	Bumper (Ref, earlier ships; no longer available.)		
37	NAS1149F0363P	Washer	X	1
38	B340-8	Nut	X	1
39	C228-7	Shim (install 1 to 4 shims to prevent preloading on doors, [all hinge locations])	X	A/R
NOTES * Revision F and prior have one bumper hole, Revision G and subsequent have two bumper holes.				

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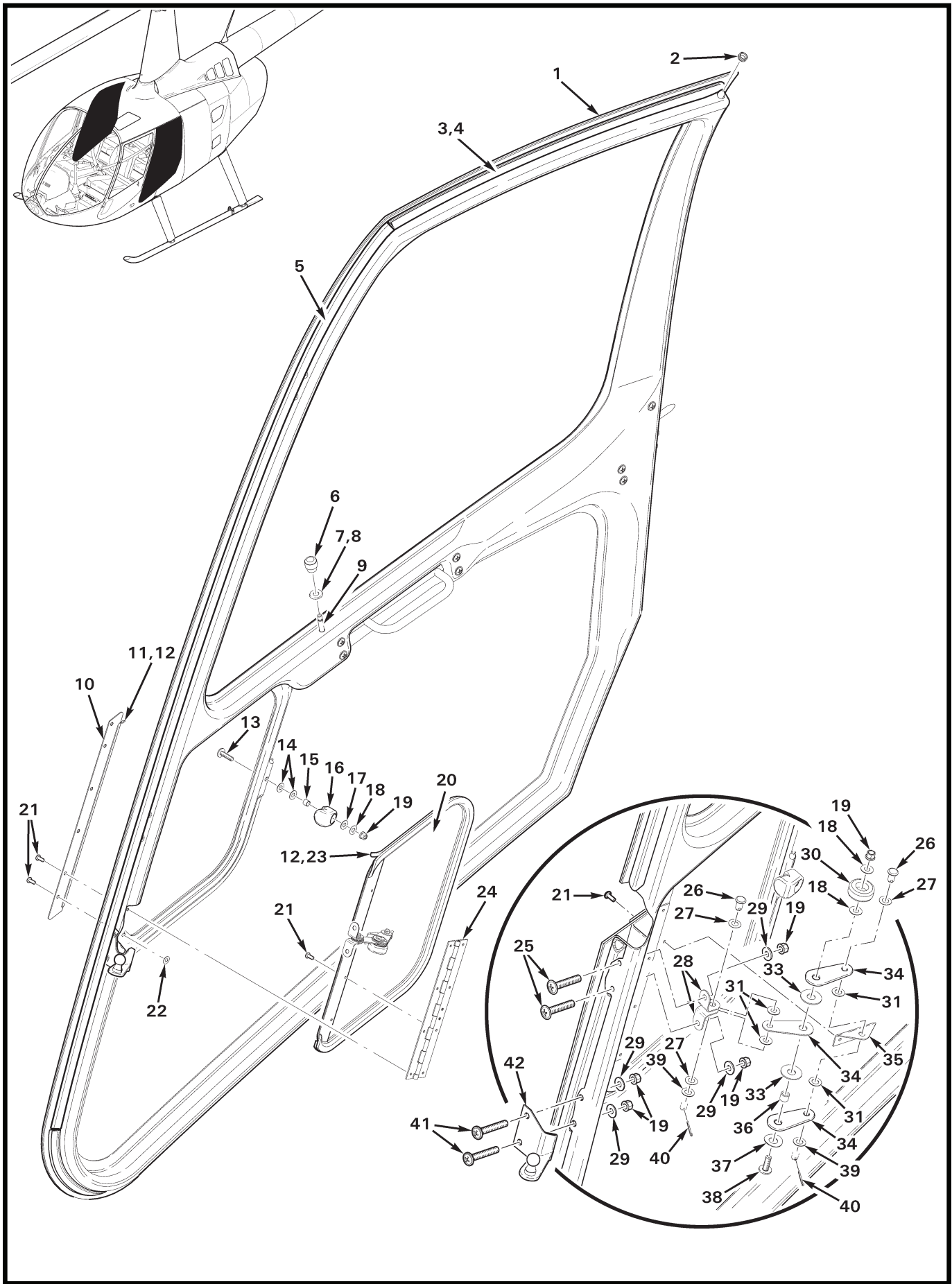


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
AFT DOOR ASSEMBLY				
52-7-1	C026-018	Door Assembly (RH, clear; Incl items 2 thru 25, 29, 32, 41, and 42)	X	1
	C026-017	Door Assembly (LH, clear [not shown]; Incl items 2 thru 25, 29, 32, 41, and 42)	X	1
	C026-028	Door Assembly (RH, tinted; Incl items 2 thru 25, 29, 32, 41, and 42)	X	1
	C026-027	Door Assembly (LH, tinted [not shown]; Incl items 2 thru 25, 29, 32, 41, and 42)	X	1
	C026-038	Door Assembly (RH, bubble, clear; Incl items 2 thru 25, 29, 32, 41, and 42)	X	1
	C026-037	Door Assembly (LH, bubble, clear [not shown]; Incl items 2 thru 25, 29, 32, 41, and 42)	X	1
	C026-048	Door Assembly (RH, bubble, tinted; Incl items 2 thru 25, 29, 32, 41, and 42)	X	1
	C026-047	Door Assembly (LH, bubble, tinted [not shown]; Incl items 2 thru 25, 29, 32, 41, and 42)	X	1
2	NAS557-4B	Grommet	X	1
3	A226-2	Seal (install using item 4)	X	A/R
4	B270-18	Adhesive	X	A/R
5	A226-6	Seal (forward door edge, self adhesive)	X	A/R
6	A431-2	Knob	X	1
7	C26005	Washer (install using item 8)	X	1
8	B270-9	Adhesive	X	A/R
9	C544-1	Pin (Ref)		
10	C682-2	Barrier	X	1
11	A226-3	Seal (install using item 12)	X	A/R
12	B270-8qt	Adhesive	X	A/R
13	AN525-832R10	Screw	X	1
14	NAS1149FN816P	Washer (or NAS1149FN832P for shimming)	X	A/R
15	C130-5	Spacer	X	1
16	C285-1	Knob	X	1
17	U216-0100-S	Spring Washer	X	1
18	NAS1149FN816P	Washer	X	3
19	MS21042L08	Nut	X	3
20	C425-12	Door – Vent (RH)	X	1
	C425-11	Door – Vent (LH, not shown)	X	1
21	MS20470AD3	Rivet	X	12
NOTES				
Continues				

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		AFT DOOR ASSEMBLY (Cont'd)		
52-7-22	NAS1149FN232P	Washer	X	2
23	A226-7	Seal (install using item 12)	X	A/R
24	C425-5	Hinge	X	1
25	MS24694-S11	Screw	X	2
26	MS20392-2C7	Pin	X	2
27	U190-0090S	Spring Washer	X	3
28	A425-19	Clip	X	2
29	NAS1149FN832P	Washer	X	4
30	A431-1	Knob	X	1
31	A141-8	Washer	X	4
32	A425-17	Arm Assembly (Incl items 18, 19, 26 thru 28, 30, 31, and 33 thru 40)	X	1
33	A141-7	Washer	X	2
34	A425-7	Arm	X	3
35	A425-13	Angle	X	1
36	A105-7	Journal	X	1
37	U250-0185	Spring Washer	X	1
38	AN525-832R8	Screw	X	1
39	NAS1149F0332P	Washer	X	2
40	MS24665-132	Cotter Pin	X	2
41	AN525-832R16	Screw	X	2
42	C393-2	Bracket (RH door)	X	1
	C393-1	Bracket (LH door; not shown)	X	1
NOTES				

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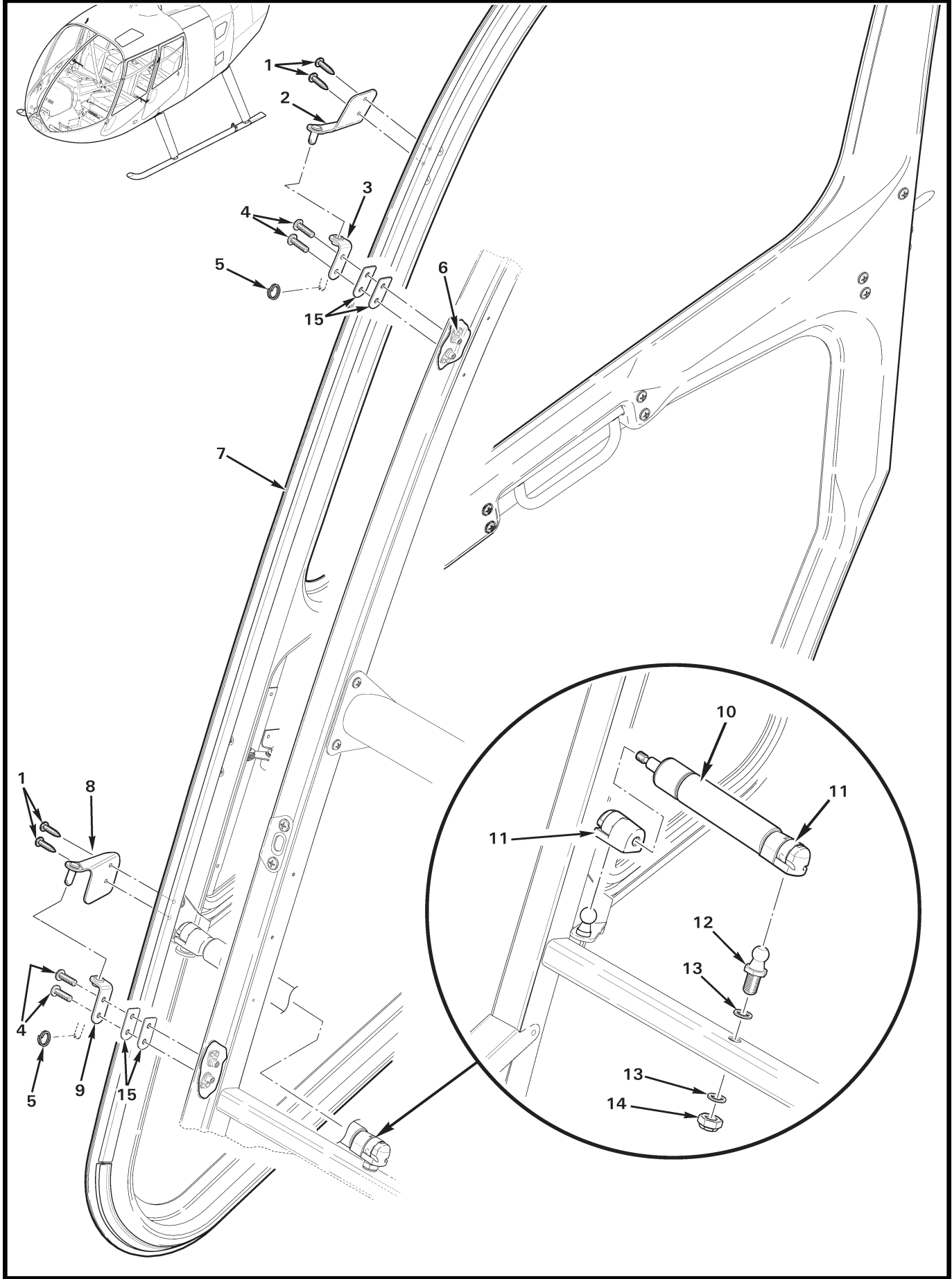


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		AFT DOOR INSTALLATION		
52-11-1	MS51861-37C	Screw	X	4
2	C389-4	Hinge Assembly (RH, upper)	X	1
	C389-3	Hinge Assembly (LH, upper; not shown)	X	1
3	A228-1	Hinge (upper)	X	1
4	MS27039C0809	Screw (if [0 to 1] of item 15 is installed)	X	4
	MS27039C0810	Screw (if [2 to 3] of item 15 is installed)	X	4
	MS27039C0811	Screw (if [4] of item 15 is installed)	X	4
5	B427-1	Ring	X	2
6	MS21086L08	Nutplate (Ref)		
7	C026	Aft Door Assembly (Ref)		
8	C389-10	Hinge Assembly (RH, lower)	X	1
	C389-9	Hinge Assembly (LH, lower; not shown)	X	1
9	A228-2	Hinge (lower)	X	1
10	C394-1	Gas Spring (Incl item 11)	X	1
11	PC1249-2	End Connector	X	2
12	C394-2	Ball Stud	X	1
13	C141-15	Washer	X	2
14	21FKF-518	Nut	X	1
15	C228-7	Shim (install 1 to 4 shims to prevent preloading on doors, [all hinge locations])	X	A/R
NOTES				

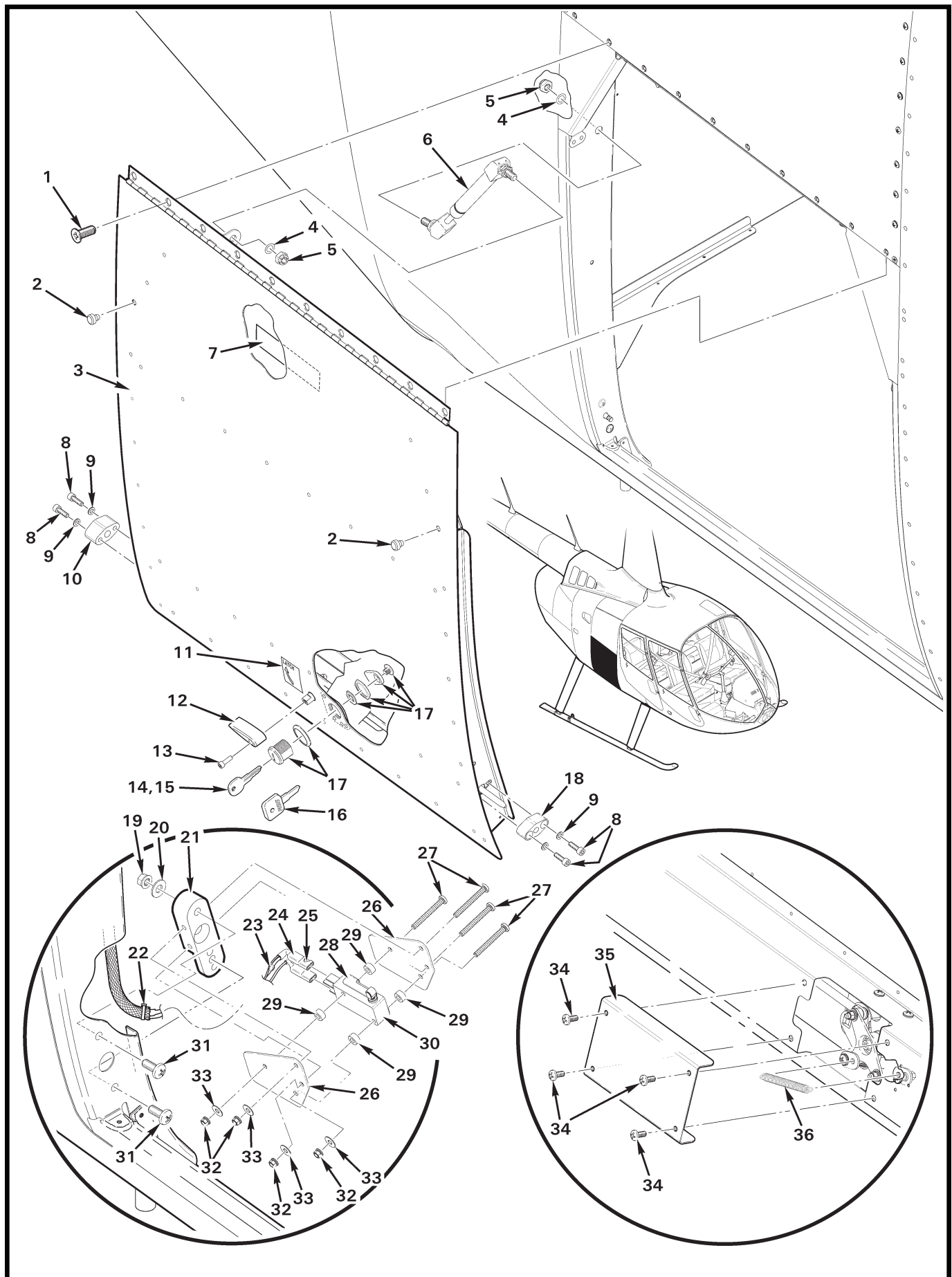


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		BAGGAGE DOOR INSTALLATION		
52-13-1	MS24694-S4	Screw	X	12
2	G405-1	Bumper (black rubber)	X	2
3	G900-1	Door Assembly – Baggage (Incl items 8 thru 9, 12, 13, 17, 18, and 34 thru 36)	X	1
4	NAS1149F0532P	Washer	X	2
5	21FKF-518	Nut	X	2
6	G904-1	Spring Assembly	X	1
7	F654-7	Decal (baggage load limits)	X	1
8	NAS1351-3-10P	Screw	X	4
9	NAS620-10L	Washer	X	4
10	G903-3	Block	X	1
11	F654-8	Decal – “LATCH” (light color ships)	X	1
	F654-9	Decal – “LATCH” (dark color ships)	X	1
12	G902-5	Knob	X	1
13	NAS1352-08-8P	Screw	X	1
14	—	Key (metal)	O	1
15	R8096	Key – Duplicate (metal; specify ship S/N and “PK” numbers when ordering)	X	1
16	D768-4	Key (blank; black plastic-coated “R66” logo)	X	1
17	A556-1	Lock Set (set of two; includes item 14[4])	X	1
18	G903-4	Block	X	1
19	MS21042L3	Nut	X	1
20	NAS1149F0332P	Washer	X	1
21	G903-1	Block Assembly	X	1
22	MS3367-5-9	Ty-Rap	X	1
23	1N4005G	Diode	X	1
	B261-2	Splice (not shown)	X	1
	B158-103	Heat Shrink	X	A/R
24	B158-3	Heat Shrink	X	A/R
25	B262-2	Receptacle	X	2
26	G903-7	Bracket	X	2
27	MS35206-227	Screw	X	4
28	JV-5	Actuator	X	1
29	A130-14	Spacer	X	4
30	D2VW-5L3-1HS	Switch	X	1
NOTES				
Continues				

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
BAGGAGE DOOR INSTALLATION (Cont'd)				
52-13-31	MS27039C1-07	Screw	X	2
32	MS21042L04	Nut	X	4
33	NAS1149FN416P	Washer	X	4
34	MS27039C0806	Screw	X	4
35	G906-2	Cover	X	1
36	B774-5	Spring	X	1
* * *				
37	KI-207*	R66 Baggage Door Seals Kit (see R66 SL-02)	X	A/R
NOTES * See www.robinsonheli.com for kit contents and instructions.				

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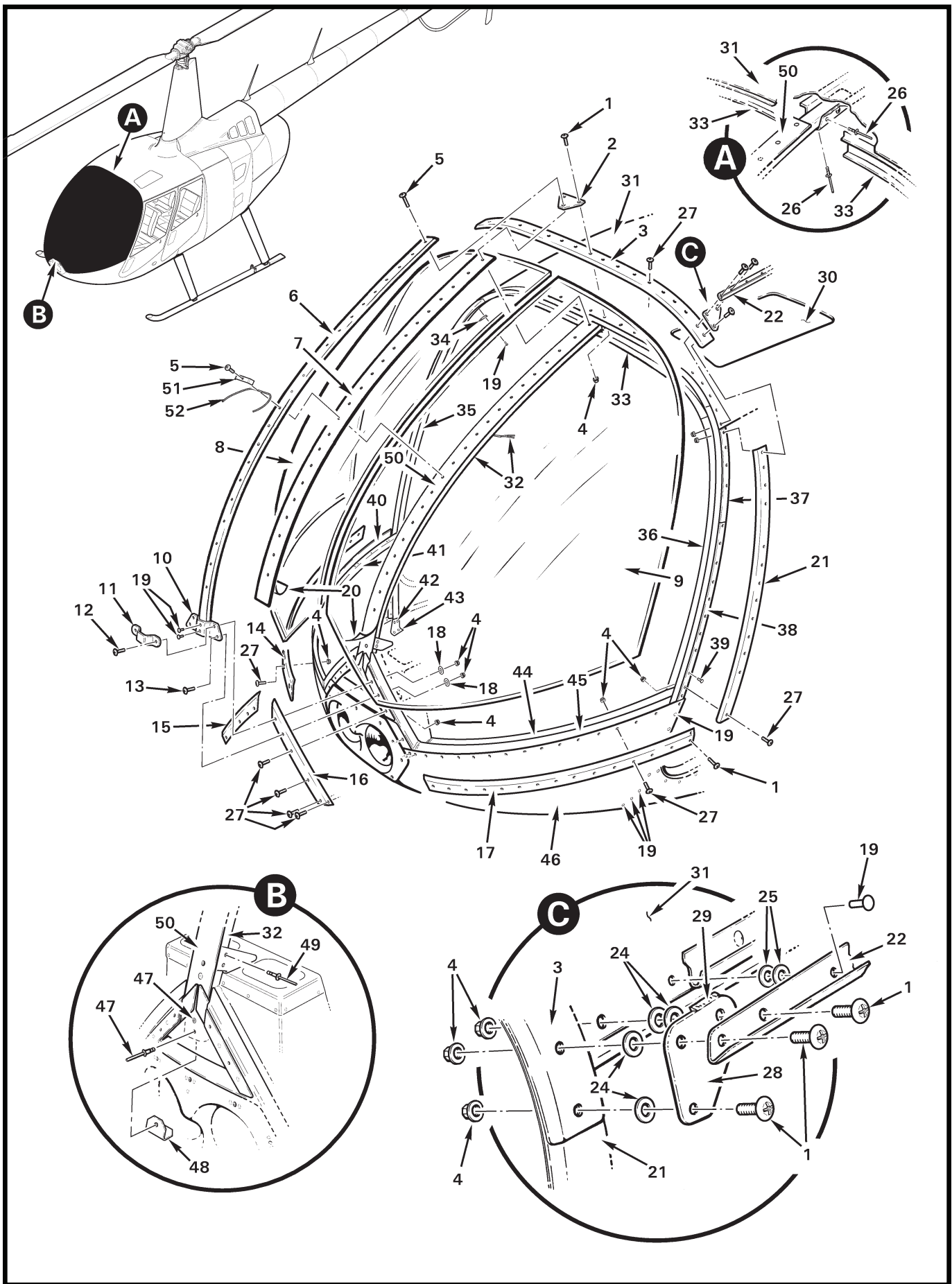


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		WINDSHIELD INSTALLATION – STANDARD (ACRYLIC)		
52-17-1	AN526C832R9	Screw (do not substitute MS27039 screws)	X	8
2	B409-5	Gusset	X	1
3	F238-4	Retainer (apply item 29 to edges)	X	1
4	MS21042L08	Nut	X	94
5	AN526C832R12	Screw (do not substitute MS27039 screws)	X	22
6	F367-12	Stiffener	X	1
7	F367-10	Retainer	X	1
8	F274-2*	Windshield** (Acrylic; RH, clear)	X	1
	F274-4*	Windshield** (Acrylic; RH, tinted)	X	1
9	F274-1*	Windshield** (Acrylic; LH, clear)	X	1
	F274-3*	Windshield** (Acrylic; LH, tinted)	X	1
10	C366-8	Retainer	X	1
11	C366-5	Bracket	X	1
12	MS27039C0810	Screw	X	2
13	MS27039C0808	Screw	X	2
14	F367-6*	Retainer (RH)	X	1
15	F367-8*	Retainer (RH)	X	1
16	F367-7*	Retainer (LH)	X	1
17	F367-5*	Retainer (LH)	X	1
18	NAS1149FN832P	Washer	X	4
19	MS20470AD4	Rivet	X	26
20	C367-11	Tape	X	A/R
21	C238-27*	Retainer (LH)	X	1
	C238-28*	Retainer (RH; not shown)	X	1
22	F230-8	Rain Gutter (RH; apply item 29 to edges)	X	1
	F230-7	Rain Gutter (LH; apply item 29 to edges)	X	1
23	B270-13.100Z	Sealant (10.3 oz. cartridge)	X	A/R
24	NAS1149FN832P	Washer	X	A/R
25	NAS620-5	Washer	X	A/R
26	NAS9301B-4-02	Rivet (blind)	X	5
27	AN526C832R8	Screw	X	82
28	D805-2	Restraint (LH and RH. Use item 29 to fill gap between items 22, 28, and 31.)	X	2
29	B270-1	Sealant (2-oz tube)	X	A/R
30	C273-3	Window (clear acrylic)	X	1
NOTES				
Continues				

FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		WINDSHIELD INSTALLATION – STANDARD (ACRYLIC) (Cont'd)		
52-17-31	F273-1	Roof (Incl item 30)	X	1
32	F090-5	Bow Assembly (includes wires)	X	1
33	F087-2	Frame (forward; roof)	X	1
34	C211-3	Gusset (LH and RH)	X	2
35	C238-4	Door Jamb – RH (attach to cabin using items 19, 39, 42, and 43)	X	1
36	C238-3	Door Jamb – LH (attach to cabin using items 19, 39, 42, and 43)	X	1
37	C238-34	Spacer (LH and RH, 0.125 in. thick polycarbonate. Attach to items 35 and 36 using item 39.)	X	2
38	D661-1	Spacer (LH and RH, 0.125 in. thick polycarbonate. Attach to items 35 and 36 using item 39.)	X	2
39	MS20426AD3	Rivet (flush)	X	56
40	F367-2	Retainer (RH)	X	1
41	F090-2	Frame (RH; attach with item 40 to chin [item 46] using item 39)	X	1
42	MS20470AD3	Rivet (flush)	X	8
43	A414-1	Angle (LH)	X	1
	A414-2	Angle (RH; not shown)	X	1
44	F090-1	Frame (LH; attach with item 40 to chin [item 46] using item 39)	X	1
45	F367-1	Retainer (LH)	X	1
46	F272-1	Chin	X	1
47	NAS9301B-4-03	Rivet (blind)	X	2
48	C366-6	Cap	X	1
49	NAS9301B-4-02	Rivet (blind; or NAS9301B-4-03 as required)	X	4
50	F367-9	Retainer	X	1
51	B295-1	Clip (install 10th hole from bottom).	X	1
52	—	Yaw String (Ref; yarn, white acrylic, source locally. 0.10- inch dia., 3-inch length each side of clip.)		
NOTES				

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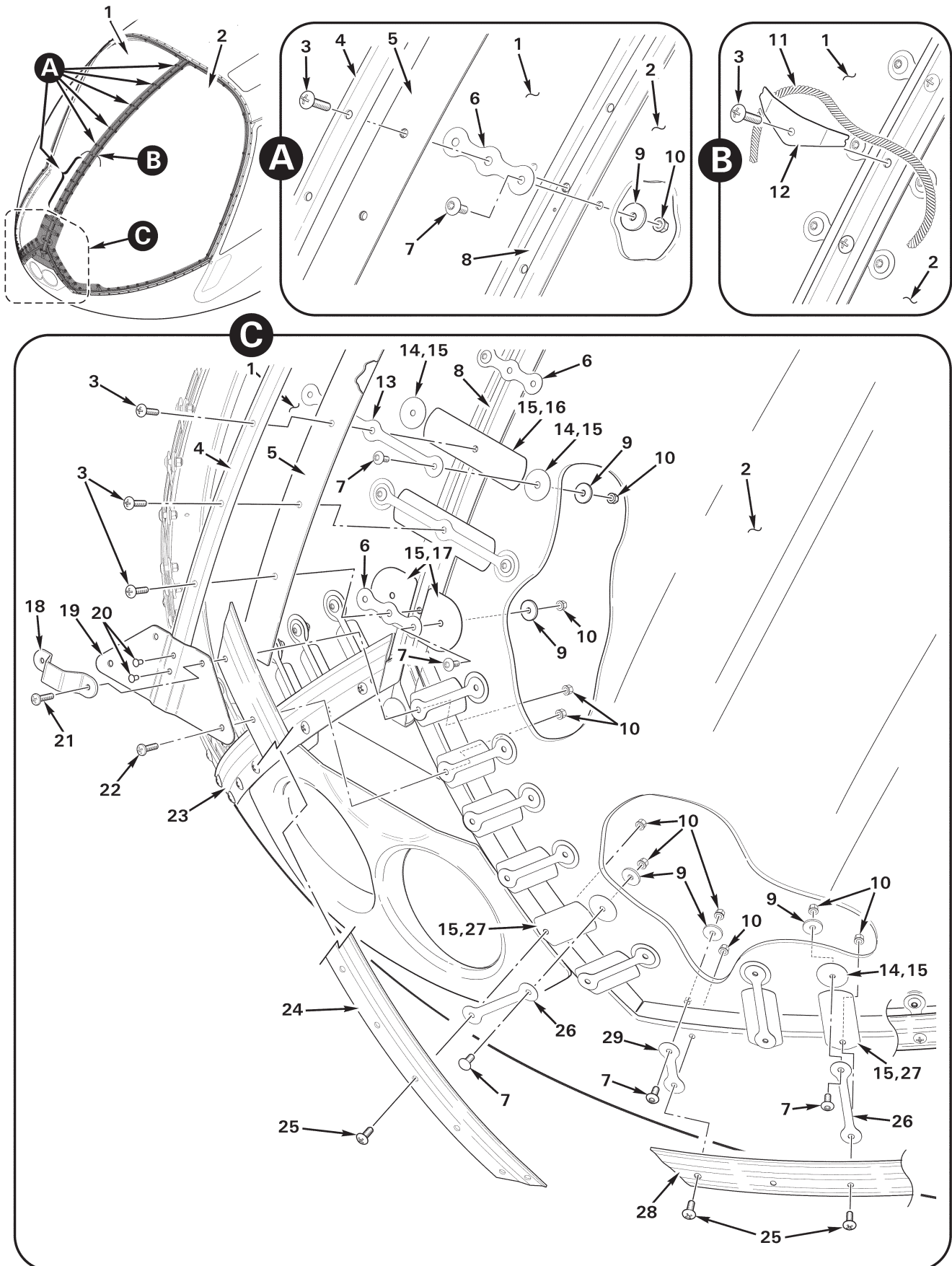


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		WINDSHIELD INSTALLATION – IMPACT-RESISTANT (POLYCARBONATE)		
52-21-1	F274-6*	Windshield** (Polycarbonate; RH, clear)	X	1
	F274-8*	Windshield** (Polycarbonate; RH, tinted)	X	1
2	F274-5*	Windshield** (Polycarbonate; LH, clear)	X	1
	F274-7*	Windshield** (Polycarbonate; LH, tinted)	X	1
3	AN526C832R12	Screw (do not substitute MS27039 screws)	X	23
4	F467-12***	Stiffener (Ref)		
5	F367-10***	Retainer (Ref)		
6	G367-2	Tie	X	12
7	B526-6	Screw (do not substitute MS27039 screws)	X	74
8	F367-9***	Retainer (Ref)		
9	C141-25	Washer	X	74
10	MS21042L08	Nut	X	74
11	—	Yaw String (Ref; yarn, white acrylic, source locally. 0.10- inch dia., 3-inch length each side of clip.)		
12	B295-2	Clip (install 10th screw from bottom)	X	1
13	G367-11	Tie	X	2
14	G367-15*	Pad	X	20
15	B270-26	Sealant	X	A/R
16	G367-13*	Tab	X	2
17	G367-14*	Pad	X	2
18	C366-5***	Bracket (Ref)		
19	C366-8***	Retainer (Ref)		
20	MS20470AD4***	Rivet (Ref)		
21	MS27039C0810***	Screw (Ref)		
22	MS27039C0809	Screw	X	2
23	F367-8***	Retainer (Ref)		
24	F367-7***	Retainer (Ref)		
25	AN526C832R8	Screw (Ref)		
26	G367-10	Strap	X	16
27	G367-12*	Tab	X	16
28	F367-5***	Retainer (LH, Ref)		
	F367-6***	Retainer (RH, Ref)		
29	G367-1	Strap	X	30
NOTES * Install using item 15. ** See Figure 99-11 for shipping box. *** See Figure 52-17.				

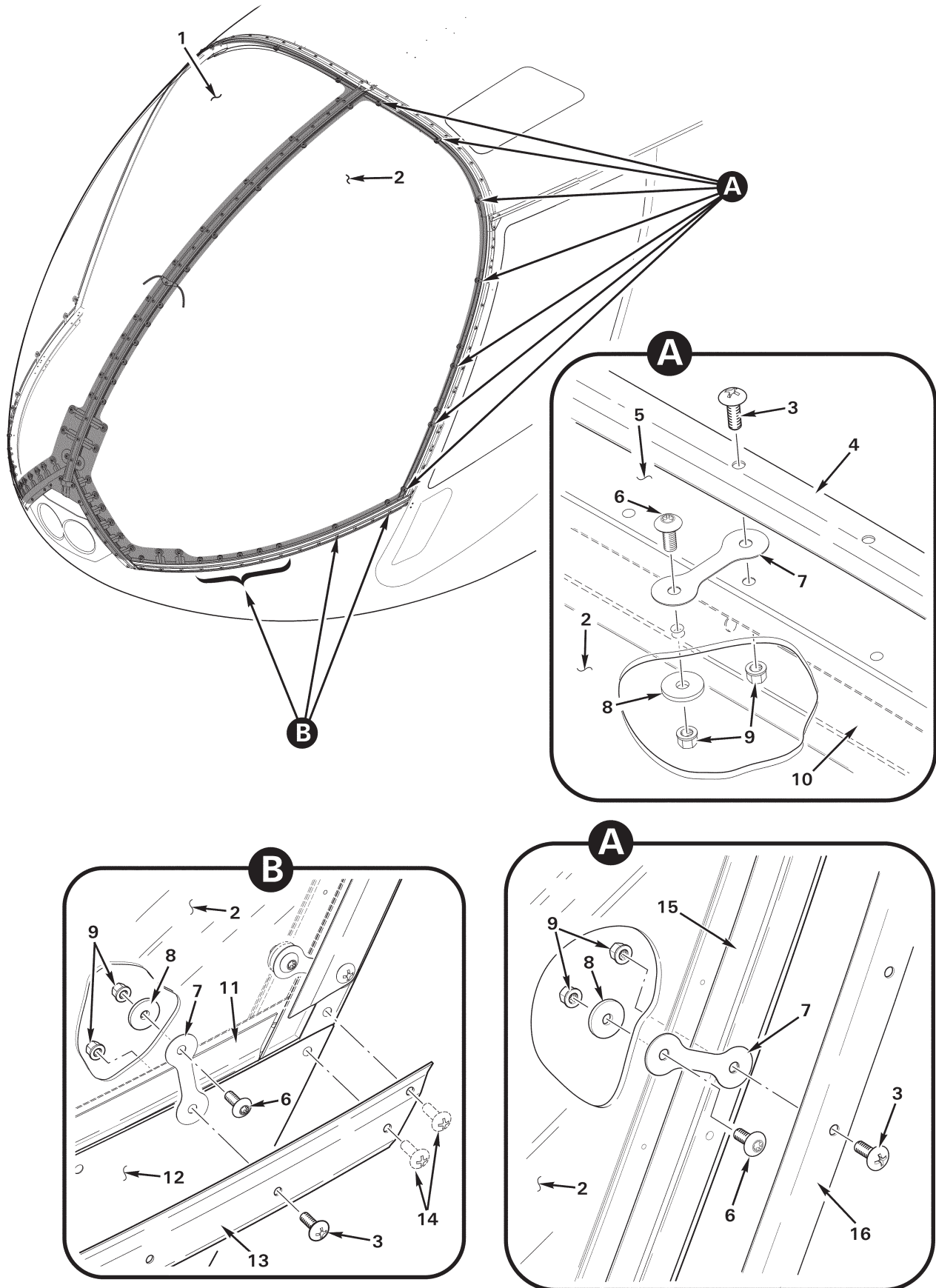


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
		WINDSHIELD INSTALLATION – IMPACT-RESISTANT (POLYCARBONATE)		
52-23-1	F274-6	Windshield (Ref*; Polycarbonate; RH, clear)		
	F274-8	Windshield (Ref*; Polycarbonate; RH, tinted)		
2	F274-5	Windshield (Ref*; Polycarbonate; LH, clear)		
	F274-7	Windshield (Ref*; Polycarbonate; LH, tinted)		
3	AN526C832R8	Screw (do not substitute MS27039 screws)	X	60
4	F238-4	Retainer (Ref**)		
5	F273-1	Roof (Ref**)		
6	B526-6	Screw (do not substitute MS27039 screws)	X	30
7	G367-1	Strap	X	30
8	C141-25	Washer	X	30
9	MS21042L08	Nut	X	60
10	F087-2	Frame (forward, roof; Ref**)		
11	F367-1	Retainer (LH, Ref**)		
	F367-2	Retainer (RH, not shown; Ref**)		
12	F272-1	Chin (Ref**)		
13	F367-5	Retainer (LH, Ref**)		
	F367-6	Retainer (LH, not shown; Ref**)		
14	AN526832R9	Screw (Ref**)		
15	C238-3	Door Jamb (LH, Ref**)		
16	C238-27	Retainer (LH, Ref**)		
	C238-28	Retainer (RH, not shown; Ref**)		
NOTES * See Figure 52-21. ** See Figure 52-17.				

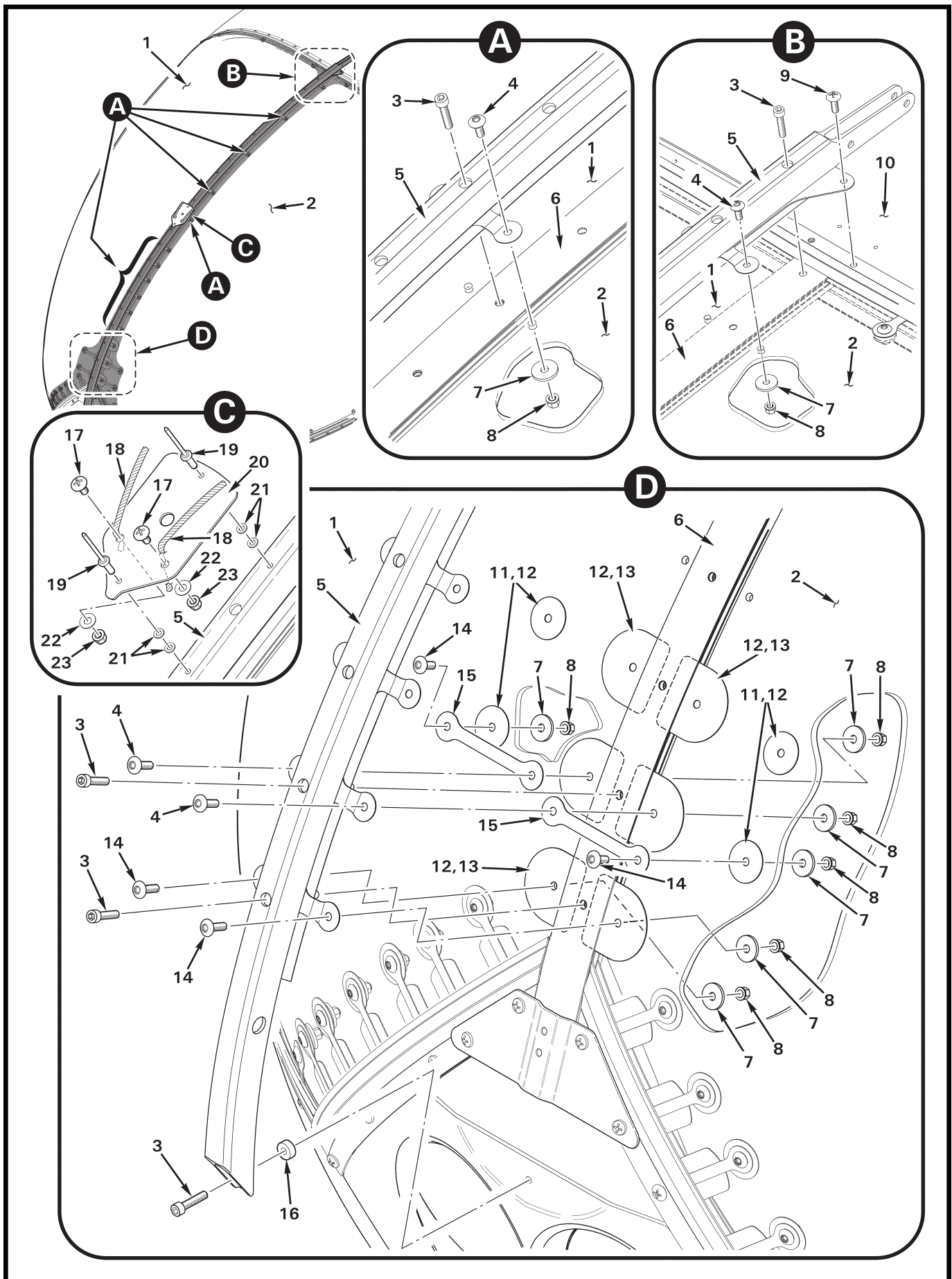


FIGURE AND INDEX NUMBER	PART NUMBER	DESCRIPTION	PARTS AVAIL	QTY PER ASSY
52-25-1		WINDSHIELD INSTALLATION – IMPACT-RESISTANT (POLYCARBONATE) WITH WIRE STRIKE PROVISIONS		
	F274-6	Windshield (Ref*; Polycarbonate; RH, clear)		
	F274-8	Windshield (Ref*; Polycarbonate; RH, tinted)		
	2 F274-5	Windshield (Ref*; Polycarbonate; LH, clear)		
	F274-7	Windshield (Ref*; Polycarbonate; LH, tinted)		
	3 NAS1352-08-12P	Screw	X	24
	4 B526-8	Screw (do not substitute MS27039 screws)	X	4
	5 G933-2	Bow Assembly	X	1
	6 G935-2	Retainer (replaces F367-10 retainer)	X	1
	7 C141-25	Washer	X	78
	8 MS21042L08	Nut	X	78
	9 AN526C832R9	Screw (Ref**)		
	10 F273-1	Roof (Ref**)		
	11 G367-15	Pad (install using item 12)	X	4
	12 B270-26	Adhesive	X	A/R
	13 G367-14	Pad (install using item 12)	X	6
	14 B526-6	Screw (do not substitute MS27039 screws)	X	74
	15 G367-10	Strap	X	20
	16 A130-37	Spacer	X	1
	17 AN526C832R6	Screw	X	2
	18 –	Yaw String (Ref; yarn, white acrylic, 0.10-inch dia., source locally. 1.9-inches length from screw [each side], 0.06 inch max beyond washer; trim as required.)		
	19 B204-2	Rivet (blind)	X	2
	20 G935-7	Plate (install at 11th screw from bottom).	X	1
	21 NAS620-5	Washer ([2] with each item 18 between item 17 and item 5)	X	4
	22 NAS1149FN816P	Washer	X	2
	23 MS21042L08	Nut	X	2
NOTES * See Figure 52-21. ** See Figure 52-17.				

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