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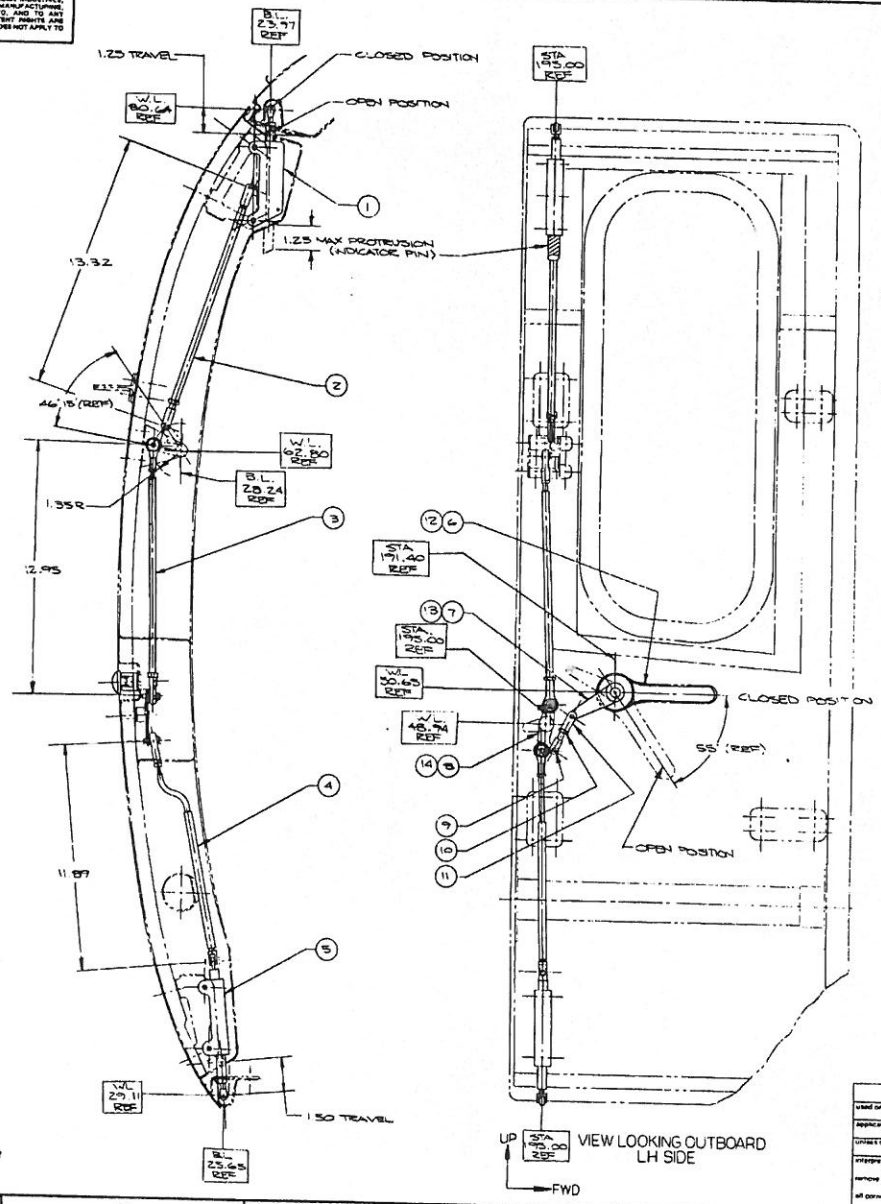
SYM	REVISIONS DESCRIPTION	DATE	BY APPROVAL
	EFFECTIVE ON DISP EXIST PARTS		
NC	PRODUCTION RELEASE	1-7-94	
A	ADDED -402 / WT, EST	3-30-94	
B	ADDED INDICATOR PIN / PROTRUSION	6-24-94	
C	UPDATED PER CUST. REQ.	4-5-95	
D	REVISED PER BELL VTDE 006163	6-22-95	
E	REVISED PER VTDE 006177	1-17-96	T.C.



RIGGING INSTRUCTIONS

1. WITH LATCH ASSY (3103-201) IN CLOSED POSITION AND ACTIVATION BELLCRANK (3103-1) POSITIONED AS SHOWN, ADJUST ROD ASSY (3102-205) TO REQ'D LENGTH. ATTACH AND SECURE ROD ASSY.
2. WITH HANDLE ASSY (1000-401) IN CLOSED POSITION AND ACTIVATION BELLCRANK (3105-1) POSITIONED AS SHOWN, ADJUST CLEVIS (1061-1) TO REQ'D LENGTH. ATTACH AND SECURE CLEVIS.
3. WITH HANDLE ASSY (1000-401) AND LATCH ASSY (3100-201) IN CLOSED POSITION, ADJUST ROD ASSYS (3102-201/-203) EQUALLY TO REQ'D LENGTHS, ATTACH AND SECURE ROD ASSYS.

-401 (LH) SHOWN
-402 (RH) OPP

NOTES: UNLESS OTHERWISE SPECIFIED

1. REMOVE ALL SHARP CORNERS AND EDGES.
2. VAL-1 LATCH HOUSINGS, 2005 AND HANDLE, ALUM ALLOY; ALL OTHER COMPONENTS; CRES. (SEE M/L FOR CLARIFICATION).
3. FINISH: ALUM; ANODIZE PER MIL-A-8625, TYPE II, CLASS I; CRES; PASSIVATE PER QQ-P-35.
4. DECORATIVE FINISH: EXTERIOR HANDLE: SATIN BRUSH AND COAT WITH INTERNATIONAL 500 S CLEAR POLYURETHANE WITH 19% S ACTIVATOR.
5. PROTECTIVE FINISH: 2005; POLYAMIDE EPOXY PRIMER PER MIL-P-23377.
6. ROLLER MUST BE CAPABLE OF WITHSTANDING A 60 LB LOAD APPLIED NORMAL TO ITS AXIS WITHOUT PERMANENT DEFORMATION.
7. HANDLE ASSY MUST BE CAPABLE OF WITHSTANDING THE FOLLOWING "STOVE REQUIREMENTS APPLIED LOADS REFLECTED BY THE SHAFT; 300 IN-LBS WITHOUT YIELD, 600 IN-LBS WITHOUT FAILURE.
8. WHEN THE LATCH SUPPORTED THROUGH THE ATTACHMENT HOLES ONLY, IT MUST BE CAPABLE OF WITHSTANDING THE FOLLOWING LOADS, 153 LBS WITHOUT YIELD, 230 LBS WITHOUT FAILURE.
9. APPLY COATING OF MIL-C-16173, GR 2, CORROSION PREVENTIVE COMPOUND AT ALL MOVEABLE POINTS, AND AT ALL DISSIMILAR METAL CONTACT AREAS.
10. DO NOT LUBRICATE TEFLON BUSHINGS OF LATCHES.
11. DIMENSIONS OF ROD ASSYS ARE NOMINAL, PRIOR TO RIGGING OF INSTALLATION.
12. MARK PER BPS 4050 EXCEPT DO NOT OVERSPRAY "S" & M/L

-			3105-2	BELLCRANK, ACT.	17-4 PH CRES, HEAT TREATED
1			3104-2	BELLCRANK, HANDLE	17-4 PH CRES, HEAT TREATED
1			1000-402	HANDLE ASSY	356 AL. ALLOY/CRES PIN & ROLLER
-	1		1061-1	CLEVIS	17-4 PH CRES, HEAT TREATED
1	1		AN316-4R	NUT	
1	1		1060-1	CLEVIS	17-4 PH CRES, HEAT TREATED
-	1		3105-1	BELLCRANK, ACT	17-4 PH CRES, HEAT TREATED
	1		3104-1	BELLCRANK, HANDLE	17-4 PH CRES, HEAT TREATED
	1		1000-401	HANDLE ASSY	356 AL. ALLOY/CRES PIN & ROLLER
1	1		3103-201	LATCH ASSY-BOLT	6061-T6 AL. HOUSING/BALANCE CRES
1	1		3102-205	ROD ASSY	2024-T3 ROD/BALANCE CRES
1	1		3102-203	ROD ASSY	2024-T3 ROD/BALANCE CRES
1	1		3102-201	ROD ASSY	2024-T3 ROD/BALANCE CRES
1	1		3100-201	LATCH ASSY-BOLT	6061-T6 AL. HOUSING/BALANCE CRES
-402	-401	qty req'd	part no	description	material size specification

parts list

14				
13				
12				
11				
10				
9				
8				
7				
6				
5				
4				
3				
2				
1				
item no				

unless otherwise specified: dimensions are in inches; tolerances on decimals ± .1, ± .03, .XXX ± .010; angles ± 0° 30' AND 10387; drilled holes; do not scale this drawing; material — finish

drawn by: B. CRAIG 1-7-94
checked: T.C. 1-7-94
engineer: 1-7-94
project
approval: T.C. 1-7-94
approval

Skylock Industries Incorporated Monrovia California

DOOR BOLTING SYSTEM, LITTER DOOR, 430

size	scale blank no	drawing no	rev
D	51941	20894	E
scale NONE	wt 2.7 LBS	sheet 1 of 1	

20894 | 1/1