Not ACCOMPLISHED AT DOUGLAS PRIOR TO DELIVERY

This page transmits Revision 2 for DC-10 Service Bulletin 52-37 to incorporate the following changes:

NOTE: This revision constitutes a complete reissue.

Reason for Revision: To incorporate the requirements of ADA7797 "B" and "C" change advance E.O.'s and to add one operator and five aircraft to Service Bulletin Effectivity. Additional work is required by this revision.

Pages 1 and 2: Assigned aircraft listed in original Service Bulletin Effectivity to Group I.

Added five aircraft to Service Bulletin Effectivity under Group II.

Added Group I heading to original Description and added Group II heading and Description.

Page 3: Added Group I heading to original Manpower and revised original Manpower data.

Added Group II and Manpower data.

Page 4: Added Group I heading to original Weight and Balance.

Added Group II heading and Weight and Balance data.

Added ADA7797 "B" and "C" change advance E.O.'s to References.

Page 5: Added Group I heading to original Accomplishment Instructions.

Added ADA7797 "B" and "C" change advance E.O.'s to paragraph 2.B.

Added Group II heading and Accomplishment Instructions.

Revision Sequence

Original Date	July 3/72
Revision 1	August 5/72
Revision 2	August 25/72

JJP

DOUGLAS AIRCRAFT COMPANY
MCDONNELL DOUGLAS CORPORATION
3855 Lakewood Boulevard
Long Beach, California 90801

DC-10 SERVICE BULLETIN

BULLETIN 52-37
DC-10 SC 812

DOORS - Cargo - Modify And Adjust Door Mechanism Assembly.

NOTE

This Service Bulletin is issued as a record type change. Engineering drawings are furnished in lieu of illustrations and detailed modification data.

1. Planning Information:

A. Effectivity:

(1) Aircraft Affected:

Model DC-10, Series 10

Operator	Factory Serial No.	*Mfr's Fuselage No.	Qty of Kits CZZ0812-501
	Group I		
AA	46502 thru 46515	3, 5, 7, 9, 12, 13, 20 thru 24, 30, 31, and 37	14
CO	46900 thru 46904	34, 40, 41, 43, and 44	5
NA	46700 thru 46703 46706	14, 16, 18, and 19 38	5
UA	46600 thru 46614	4, 6, 8, 10, 11, 15, 17, 25 thru 27, 32, 35, 39, 42, and 45	15
	Group II (No Kits Required)		
AA	46500 46516 thru 46518	1 48, 49, and 51	
LT	46905	47	

Affected aircraft other than those listed above will be modified prior to delivery or included in a subsequent revision to this Service Bulletin.

*Manufacturer's fuselage numbers are applicable to affected aircraft at time of Service Bulletin issue and are for reference only.

(2) Spares Affected:

Spare Part No.	Key Word
ADA3659-1	Collar Assy
ADA3668-1	Shim
ADA3668-501	Shim

B. Reason:

The load required to close the vent door without the lockpins engaged is within the capability of the cargo handlers. When the vent door handle is closed and the lockpins are not engaged, the lockpin tube will deflect and contact the lockpin limit switch striker, giving a false door closed, latched, and locked indication. Readjusting the lockpin tube assembly to prevent the vent door handle from being forced to the closed position when the lockpins are not engaged properly will provide a more positive and reliable cargo door closed, latched, and locked system.

C. Description:

This modification accomplishes the following:

Group I

(1) Replaces strike plate and adjusts pins and switches on the forward, center, and aft cargo doors.

(2) Installs support and plate on aft cargo door.

Group II

Adjusts pins and switches and vent door mechanism on the forward, center, and aft cargo doors.

D. Compliance:

Recommended.

E. Approval:

This Service Bulletin is FAA approved.

F. Manpower:

This modification may be accomplished in the following approximate man-hours or elapsed hours per aircraft.

Work Phases	Man-Hours Group I	Man-Hours Group II
Gain Access	1.5	1.5
Modify (Aircraft)	7.7	3.0
Close Up	1.5	1.5
Total Man-Hours	10.7	6.0
Total Elapsed Hours	3.5	3.0

G. Material - Cost and Availability:

(1) Aircraft:

Operators with aircraft listed under paragraph 1.A.(1) should submit a "no charge" purchase order for service change kits in the quantities shown.

The purchase order must specify this Service Bulletin number and only parts listed herein.

Operators will be advised of delivery schedule upon receipt of purchase order. Direct purchase order to:

Douglas Aircraft Company
P.O. Box 1771
Long Beach, California 90801
Attn: Manager, Warranty 7-21

A "no charge" purchase order for kits under the provisions of this bulletin must be received not later than 90 days after the issue date noted on page 1. Any purchase order received after the 90-day period will be processed on a charge basis.

(2) Spares:

Replacement parts will be supplied for spares purchased from the Douglas Aircraft Company and now in operator's possession. An additional "no charge" purchase order should be submitted referencing this Service Bulletin number, the original spares purchase order, and listing replacement parts required. Availability of replacement parts is the same as indicated in paragraph 1.G.(1).

H. Tooling - Price and Availability:

None.

I. Weight and Balance:

Group I

This modification will increase the weight of the aircraft at approximately station 1830.0, as follows:

(1)	Mfr's Empty Weight (MEW) Increase	+0.1 LB
(2)	Moment Change (MEW)	+183 IN.-LB
(3)	Index Unit Change (MEW)	0

Group II

None.

J. References:

(1) Data used in preparation of this Service Bulletin:

Data Identification	Change	Type of Data
ADA7797	New	Rework Drawing
ADA7797	A, B, and C	Advance E.O.
CMM Chapter 52		Component Maintenance Manual

(2) Data supplied in support of this Service Bulletin:

Data Identification	Change	Type of Data
ADA7797	New	Rework Drawing
ADA7797	A, B, and C	Advance E.O.

NOTE: One reproducible and two copies of the drawing and advance E.O.'s will be furnished to each affected operator.

K. Publications Affected:

The modification outlined in this Service Bulletin affects the following DAC DC-10 aircraft publications.

Publication	Chapter and/or Section
Component Maintenance Manual	52-31 and 52-33
Illustrated Parts Catalog	52-31, 52-32, and 52-33

2. Accomplishment Instructions:

CAUTION: STATICALLY GROUND THE AIRCRAFT.

NOTE: Instructions are identical for forward, center, and aft cargo door assemblies, except as noted.

Group I

A. Remove and retain door liner and attaching parts.

B. Aft cargo door only - Install plate, support, jumper, and attaching parts. (See drawing ADA7797, sheets 1, 3, and 5.)

C. Replace striker and adjust pins and switches. (See drawing ADA7797, sheets 1 through 5, and ADA7797 "A", "B", and "C" change advance E.O.'s.)

D. Reinstall door liner and attaching parts.

Group II

A. Remove and retain door liner and attaching parts.

B. Adjust pins, switches, and vent door mechanism. (See drawing ADA7797, sheets 1 through 5, and ADA7797 "A", "B", and "C" change advance E.O.'s.)

C. Reinstall door liner and attaching parts.

2. Accomplishment Instructions:

CAUTION: STATICALLY GROUND THE AIRCRAFT.

NOTE: Instructions are identical for forward, center, and aft cargo door assemblies, except as noted.

Group I

A. Remove and retain door liner and attaching parts.

B. Aft cargo door only - Install plate, support, jumper, and attaching parts. (See drawing ADA7797, sheets 1, 3, and 5.)

C. Replace striker and adjust pins and switches. (See drawing ADA7797, sheets 1 through 5, and ADA7797 "A", "B", and "C" change advance E.O.'s.)

D. Reinstall door liner and attaching parts.

Group II

A. Remove and retain door liner and attaching parts.

B. Adjust pins, switches, and vent door mechanism. (See drawing ADA7797, sheets 1 through 5, and ADA7797 "A", "B", and "C" change advance E.O.'s.)

C. Reinstall door liner and attaching parts.

3. Material Information:

A. The basis for the following material data is per aircraft.

(1) Parts furnished in service change kit.

New Part No.	Qty Kit CZZ0812-501	Key Word	Old Part No.	Instructions-Disposition
ADA7773-1	3	Shim		
ADA7773-501	30	Shim	ADA3668-1	Discard
ADA7773-503	3	Shim	ADA3668-501	Discard
ADA7797-3	3	Striker	ADA3659-1	Discard
ADA7797-5	1	Support	(Collar Assy)	
ADA7797-7	1	Plate		
MS20426AD3-7	18	Rivet		
MS21042L3	4	Nut		
MS21075L08	6	Nutplate		
MS25083-2BB4	1	Jumper		
MS25281R2	1	Clamp		
NAS1252-10L	10	Washer		
NAS5602-12	6	Screw		
NAS6103U8	1	Screw		
NAS6403U13	3	Screw		
NAS6403U5	3	Screw		
RMF9421-3	3	Nutplate		

(2) Parts to be modified by the operator. Reidentification is at operator's option.

New Part No.	Qty	Key Word	Old Part No.
None	1	Tube	ADA7313-1
None	1	Tube	ADA7350-1
None	1	Tube	ADA7350-501
None	1	Tube	ADA7403-501

B. The basis for the following material data is per spares.

(1) Discard spare shims and order replacement parts as indicated in paragraph 3.A.(1).

(2) Discard spare ADA3659-1 collar assembly and order ADA7797-3 striker as a replacement part.

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3. Material Information:

A. The basis for the following material data is per aircraft.

(1) Parts furnished in service change kit.

New Part No.	Qty Kit CZ20812-501	Key Word	Old Part No.	Instructions-Disposition
ADA7773-1	3	Shim		
ADA7773-501	30	Shim	ADA3668-1	Discard
ADA7773-503	3	Shim	ADA3668-501	Discard
ADA7797-3	3	Striker	ADA3659-1	Discard
ADA7797-5	1	Support	(Collar Assy)	
ADA7797-7	1	Plate		
MS20426AD3-7	18	Rivet		
MS21042L3	4	Nut		
MS21075L08	6	Nutplate		
MS25083-2B84	1	Jumper		
MS25281R2	1	Clamp		
NAS1252-10L	10	Washer		
NAS560Z-12	6	Screw		
NAS6103U8	1	Screw		
NAS6403U13	3	Screw		
NAS6403U5	3	Screw		
PNF9421-3	3	Nutplate		

(2) Parts to be modified by the operator. Reidentification is at operator's option.

New Part No.	Qty	Key Word	Old Part No.
None	1	Tube	ADA7313-1
None	1	Tube	ADA7350-1
None	1	Tube	ADA7350-501
None	1	Tube	ADA7403-501

B. The basis for the following material data is per spares.

(1) Discard spare shims and order replacement parts as indicated in paragraph 3.A.(1).

(2) Discard spare ADA3659-1 collar assembly and order ADA7797-3 striker as a replacement part.

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