

CHAPTER

25

**EQUIPMENT/
FURNISHINGS**



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 25
EQUIPMENT/FURNISHINGS**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
25-EFFECTIVE PAGES			25-00-00			25-00-00 (cont)		
1 thru 14	SEP 05/2018		701	May 05/2015		822	May 05/2018	
25-CONTENTS			702	Jul 25/2018		823	Jan 05/2018	
1	Sep 05/2017		R 703	Sep 05/2018		824	Sep 05/2017	
2	Sep 05/2016		704	Jul 25/2018		825	Jan 05/2018	
3	Sep 05/2016		705	Jul 25/2018		826	Sep 05/2017	
4	Jan 05/2015		706	Jul 25/2018		827	Sep 05/2017	
5	Jan 05/2017		707	Sep 05/2017		828	Sep 05/2017	
6	May 05/2017		708	Sep 05/2017		829	Sep 05/2017	
7	May 05/2017		709	Sep 05/2017		830	Sep 05/2017	
8	Jul 25/2018		710	Sep 05/2017		831	Sep 05/2017	
R 9	Sep 05/2018		711	Sep 05/2017		832	Sep 05/2017	
10	Sep 05/2017		712	Jul 25/2018		833	Sep 05/2017	
11	May 05/2017		713	Sep 05/2017		834	Sep 05/2017	
12	May 05/2017		714	BLANK		835	Sep 05/2017	
13	Sep 05/2017		25-00-00			836	Sep 05/2017	
14	Jul 25/2018		801	May 05/2015		837	Sep 05/2017	
15	May 05/2017		802	Jan 05/2018		838	Sep 05/2017	
16	May 05/2016		803	Jan 05/2018		25-00-00		
17	May 05/2016		804	Sep 05/2017		901	Jan 05/2015	
18	May 05/2016		805	Sep 05/2017		902	May 05/2015	
19	May 05/2016		806	Sep 05/2017		903	Jan 05/2015	
20	May 05/2016		807	May 05/2015		904	Jan 05/2015	
21	Sep 05/2016		808	Sep 05/2017		905	Jan 05/2015	
22	May 05/2016		809	Sep 05/2017		906	Jan 05/2015	
23	May 05/2016		810	Jul 25/2018		907	Jan 05/2015	
24	Sep 05/2017		811	Jan 05/2018		908	Sep 05/2017	
25	Jan 05/2017		812	Jan 05/2018		909	Sep 05/2017	
26	Jan 05/2017		813	Jan 05/2018		910	Sep 05/2016	
27	Jan 05/2017		814	Jul 25/2018		911	Jan 05/2015	
28	Jan 05/2018		815	Jul 25/2018		912	May 05/2016	
29	Jan 05/2017		816	Jul 25/2018		913	May 05/2016	
30	May 05/2016		817	Jan 05/2018		914	May 05/2016	
31	May 05/2016		818	Jan 05/2018		915	Jan 05/2015	
32	BLANK		819	Jan 05/2018		916	Jan 05/2015	
			820	Jan 05/2016		917	Jan 05/2015	
			821	Jan 05/2016		918	Jan 05/2015	

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25-EFFECTIVE PAGES



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 25
EQUIPMENT/FURNISHINGS**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
25-00-00 (cont)			25-11-01 (cont)			25-15-03 (cont)		
919	Jan 05/2015		406	May 05/2017		404	Jan 05/2015	
920	BLANK		407	May 05/2017		405	May 05/2017	
25-11-00			408	BLANK		406	May 05/2017	
501	May 05/2015		25-11-03			407	May 05/2017	
502	Jan 05/2015		401	May 05/2016		408	May 05/2017	
503	May 05/2015		402	Jan 05/2015		409	May 05/2017	
504	Jan 05/2015		403	May 05/2017		410	BLANK	
505	May 05/2017		404	May 05/2017		25-15-05		
506	May 05/2017		25-11-03			401	Jan 05/2015	
507	May 05/2017		601	May 05/2015		402	Jan 05/2015	
508	Sep 05/2017		602	BLANK		403	May 05/2017	
509	Sep 05/2017		25-13-01			404	BLANK	
510	Sep 05/2017		401	Jan 05/2015		25-15-06		
511	Sep 05/2017		402	May 05/2017		401	Jan 05/2015	
512	Sep 05/2017		25-15-01			402	Jan 05/2015	
513	Sep 05/2017		401	May 05/2017		403	Jan 05/2015	
514	Sep 05/2017		402	May 05/2017		404	May 05/2017	
515	Sep 05/2017		403	May 05/2017		405	May 05/2017	
516	Sep 05/2017		404	May 05/2017		406	BLANK	
517	Jul 25/2018		405	May 05/2017		25-16-00		
518	Sep 05/2017		406	May 05/2017		401	May 05/2017	
519	Sep 05/2017		407	May 05/2017		402	Sep 05/2017	
520	Sep 05/2017		408	May 05/2017		403	May 05/2018	
25-11-00			409	May 05/2017		404	May 05/2018	
601	Sep 05/2017		410	May 05/2017		405	May 05/2017	
602	Jan 05/2017		25-15-02			406	Sep 05/2017	
603	May 05/2017		401	Jan 05/2015		25-20-01		
604	May 05/2017		402	Jan 05/2015		201	Jan 05/2016	
605	Sep 05/2017		403	Jan 05/2015		202	Sep 05/2016	
606	Jan 05/2017		404	May 05/2017		203	Sep 05/2016	
25-11-01			405	May 05/2017		204	BLANK	
401	Sep 05/2017		406	BLANK		25-21-01		
402	Sep 05/2017		25-15-03			401	Jul 25/2018	
403	Sep 05/2017		401	Jan 05/2015		R 402	Sep 05/2018	
404	May 05/2017		402	Jan 05/2015		403	Jul 25/2018	
405	May 05/2017		403	Jan 05/2015		404	May 05/2017	

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25-EFFECTIVE PAGES



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 25
EQUIPMENT/FURNISHINGS**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
25-21-01 (cont)			25-23-01 (cont)			25-24-01 (cont)		
405	May 05/2017		204	May 05/2017		422	Jan 05/2015	
406	BLANK		205	May 05/2017		423	Jan 05/2015	
25-21-02			206	May 05/2017		424	May 05/2017	
401	Jan 05/2015		207	May 05/2017		425	May 05/2017	
402	Jan 05/2015		208	May 05/2017		426	May 05/2017	
403	Jan 05/2015		25-23-01			427	May 05/2017	
404	Jan 05/2015		401	Jul 25/2018		428	May 05/2017	
405	May 05/2017		402	Jul 25/2018		429	May 05/2017	
406	May 05/2017		403	Jul 25/2018		430	BLANK	
407	May 05/2017		404	Jul 25/2018		25-24-03		
408	May 05/2017		405	Jul 25/2018		401	May 05/2016	
25-21-06			406	Jul 25/2018		402	May 05/2016	
401	Jan 05/2015		407	Jul 25/2018		403	May 05/2016	
402	Sep 05/2017		408	Jul 25/2018		404	May 05/2017	
403	Sep 05/2017		25-24-01			405	May 05/2017	
404	May 05/2017		401	May 05/2016		406	BLANK	
405	May 05/2017		402	Jan 05/2015		25-24-06		
406	BLANK		403	Jan 05/2015		401	Jan 05/2015	
25-21-07			404	Sep 05/2015		402	Jan 05/2015	
401	Jan 05/2017		405	Jan 05/2015		403	Jan 05/2015	
402	Jan 05/2017		406	Jan 05/2015		404	Jan 05/2015	
403	Jan 05/2017		407	Jan 05/2015		405	May 05/2017	
404	May 05/2017		408	Jan 05/2015		406	May 05/2017	
405	Jan 05/2017		409	May 05/2017		407	May 05/2017	
406	May 05/2017		410	May 05/2017		408	May 05/2017	
25-21-08			411	May 05/2017		409	May 05/2017	
201	Jul 25/2018		412	May 05/2017		410	May 05/2017	
202	Jul 25/2018		413	May 05/2017		411	May 05/2017	
203	Jul 25/2018		414	May 05/2017		412	BLANK	
204	Jan 05/2017		415	May 05/2017		25-24-08		
205	May 05/2017		416	Jan 05/2015		401	Jan 05/2015	
206	May 05/2017		417	May 05/2017		402	Jan 05/2015	
25-23-01			418	Sep 05/2015		403	Jan 05/2015	
201	May 05/2017		419	May 05/2016		404	Jan 05/2015	
202	Sep 05/2017		420	Jan 05/2015		405	Jan 05/2015	
203	May 05/2017		421	Sep 05/2015		406	May 05/2017	

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25-EFFECTIVE PAGES



777-200/300 AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25 EQUIPMENT/FURNISHINGS

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
25-24-08 (cont)			25-25-01			25-25-06 Config 6 (cont)		
407	May 05/2017		401	Jan 05/2018		405	Jan 05/2015	
408	May 05/2017		402	Sep 05/2017		406	BLANK	
409	May 05/2017		403	Jan 05/2018		25-25-06		
410	May 05/2017		404	Jan 05/2018		601	May 05/2015	
25-24-10			405	Jan 05/2018		602	May 05/2017	
401	Jan 05/2015		406	Sep 05/2017		603	May 05/2015	
R 402	Sep 05/2018		407	Jan 05/2018		604	BLANK	
O 403	Sep 05/2018		408	Sep 05/2017		25-25-86		
404	Jan 05/2018		409	Sep 05/2017		201	Sep 05/2017	
405	Jan 05/2018		410	May 05/2018		202	Sep 05/2017	
R 406	Sep 05/2018		25-25-01 Config 1			203	Sep 05/2015	
R 407	Sep 05/2018		601	May 05/2015		204	Sep 05/2017	
R 408	Sep 05/2018		602	May 05/2015		205	Sep 05/2017	
R 409	Sep 05/2018		603	Sep 05/2017		206	BLANK	
R 410	Sep 05/2018		604	Sep 05/2017		25-25-86 Config 1		
O 411	Sep 05/2018		605	Sep 05/2017		401	Sep 05/2015	
412	BLANK		606	Sep 05/2017		402	Sep 05/2017	
25-24-15			607	Sep 05/2017		403	Sep 05/2015	
201	Jan 05/2016		608	Sep 05/2017		404	Sep 05/2015	
202	Jan 05/2016		609	Sep 05/2017		405	Sep 05/2015	
203	Jan 05/2016		610	BLANK		406	Sep 05/2017	
204	BLANK		25-25-06 Config 1			407	Sep 05/2015	
25-24-15			401	Jan 05/2015		408	Jan 05/2018	
401	Jan 05/2015		402	Jan 05/2015		409	Jan 05/2018	
402	Jan 05/2015		403	May 05/2017		410	Jan 05/2018	
403	May 05/2017		404	BLANK		411	Sep 05/2017	
404	BLANK		25-25-06 Config 2			412	Sep 05/2017	
25-24-50			401	Sep 05/2015		413	Sep 05/2017	
401	Jan 05/2015		402	Sep 05/2015		414	Sep 05/2017	
402	May 05/2017		403	Jan 05/2015		25-25-86		
403	Jan 05/2015		404	May 05/2017		501	Sep 05/2015	
404	May 05/2017		25-25-06 Config 6			502	Sep 05/2015	
405	May 05/2017		401	Jan 05/2015		503	Sep 05/2015	
406	May 05/2017		402	Jan 05/2015		504	Sep 05/2015	
407	Jan 05/2015		403	Jan 05/2015				
408	BLANK		404	Jan 05/2015				

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25-EFFECTIVE PAGES



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 25
EQUIPMENT/FURNISHINGS**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
25-25-86	Config 1		25-27-11			25-28-02	(cont)	
601	Sep 05/2015		401	May 05/2016		414	Sep 05/2017	
602	Sep 05/2015		402	May 05/2016		415	Sep 05/2017	
603	Sep 05/2015		403	Jan 05/2015		416	Sep 05/2017	
604	Sep 05/2015		404	BLANK		25-28-03		
605	Sep 05/2015		25-28-01			401	Jan 05/2015	
606	BLANK		401	Jan 05/2015		402	Sep 05/2017	
25-27-01			402	Sep 05/2017		403	Sep 05/2015	
401	Sep 05/2017		403	Sep 05/2017		404	Sep 05/2017	
402	Sep 05/2017		404	May 05/2017		405	Sep 05/2017	
403	Sep 05/2017		405	Jan 05/2015		406	May 05/2017	
404	May 05/2017		406	Jan 05/2015		407	May 05/2017	
405	Jul 25/2018		407	Jan 05/2015		408	May 05/2017	
406	Sep 05/2017		408	Jan 05/2015		409	May 05/2017	
407	May 05/2017		409	May 05/2017		410	BLANK	
408	Jul 25/2018		410	May 05/2017		25-28-04		
409	Sep 05/2017		25-28-02			201	May 05/2015	
410	BLANK		201	May 05/2015		202	Jan 05/2015	
25-27-03			202	May 05/2015		203	Jan 05/2015	
401	Jan 05/2015		203	May 05/2015		204	May 05/2017	
402	May 05/2017		204	May 05/2017		205	May 05/2017	
403	Jan 05/2018		205	May 05/2017		206	May 05/2017	
404	Jan 05/2017		206	May 05/2017		207	May 05/2017	
405	May 05/2017		25-28-02			208	BLANK	
406	May 05/2017		401	May 05/2015		25-28-04		
25-27-07			402	Sep 05/2017		501	Jan 05/2015	
401	Sep 05/2017		403	Sep 05/2017		502	Jan 05/2015	
402	Sep 05/2017		404	May 05/2017		503	May 05/2017	
403	Sep 05/2017		405	May 05/2017		504	May 05/2017	
404	May 05/2017		406	Jan 05/2015		25-28-05		
25-27-09			407	Jul 25/2018		401	Jul 25/2018	
401	Jan 05/2016		408	Jul 25/2018		402	Jul 25/2018	
402	Jan 05/2016		409	Jul 25/2018		403	Jul 25/2018	
403	May 05/2017		410	Jan 05/2018		404	Jul 25/2018	
404	May 05/2017		411	Sep 05/2017		25-28-06		
405	Jan 05/2016		412	Sep 05/2017		401	Jan 05/2015	
406	Jan 05/2016		413	Sep 05/2017		402	Sep 05/2017	

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25-EFFECTIVE PAGES



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 25
EQUIPMENT/FURNISHINGS**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
25-28-06 (cont)			25-29-03 (cont)			25-31-01 (cont)		
403	May 05/2017		411	Jan 05/2018		R 416	Sep 05/2018	
404	BLANK		412	Jan 05/2018		R 417	Sep 05/2018	
25-28-07			413	Jan 05/2018		418	BLANK	
401	May 05/2015		414	Jan 05/2018		25-31-02 Config 1		
402	May 05/2015		415	Jan 05/2018		201	Sep 05/2017	
403	May 05/2017		416	Jan 05/2018		202	Sep 05/2017	
404	Jan 05/2015		417	Jan 05/2018		203	Sep 05/2017	
405	Jan 05/2015		418	Jan 05/2018		204	Sep 05/2017	
406	May 05/2017		25-29-25			25-31-02		
407	May 05/2017		601	May 05/2015		401	Sep 05/2016	
408	BLANK		602	BLANK		402	May 05/2017	
25-29-01			25-31-00			403	Sep 05/2016	
401	May 05/2018		501	Jan 05/2015		404	Jan 05/2015	
402	Jan 05/2015		502	Jan 05/2015		405	Jan 05/2015	
403	Jan 05/2015		25-31-00			406	Jan 05/2015	
404	Jan 05/2015		601	Jan 05/2015		407	May 05/2018	
405	May 05/2017		602	BLANK		408	Sep 05/2016	
406	May 05/2017		25-31-01 Config 1			409	Sep 05/2016	
25-29-01			201	Sep 05/2017		410	Sep 05/2016	
501	Jan 05/2015		202	Jan 05/2016		411	Sep 05/2016	
502	Jan 05/2015		25-31-01			412	Sep 05/2016	
503	Jan 05/2015		R 401	Sep 05/2018		413	Sep 05/2016	
504	May 05/2017		O 402	Sep 05/2018		414	Sep 05/2016	
505	May 05/2017		O 403	Sep 05/2018		415	May 05/2017	
506	BLANK		R 404	Sep 05/2018		416	May 05/2017	
25-29-03			O 405	Sep 05/2018		417	May 05/2017	
401	Jan 05/2015		O 406	Sep 05/2018		418	May 05/2017	
402	Sep 05/2017		O 407	Sep 05/2018		419	May 05/2017	
403	Sep 05/2017		O 408	Sep 05/2018		420	May 05/2017	
404	Sep 05/2017		O 409	Sep 05/2018		421	May 05/2017	
405	Sep 05/2017		R 410	Sep 05/2018		422	May 05/2017	
406	Sep 05/2017		R 411	Sep 05/2018		423	May 05/2017	
407	Sep 05/2017		R 412	Sep 05/2018		424	May 05/2017	
408	Sep 05/2017		R 413	Sep 05/2018		425	May 05/2017	
409	Jan 05/2018		R 414	Sep 05/2018		426	May 05/2017	
410	Jan 05/2018		R 415	Sep 05/2018		427	May 05/2017	

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25-EFFECTIVE PAGES



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 25
EQUIPMENT/FURNISHINGS**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
25-31-02 (cont)			25-31-03 (cont)			25-32-03 Config 2 (cont)		
428	May 05/2017		422	May 05/2017		405	May 05/2018	
429	May 05/2017		423	May 05/2017		406	BLANK	
430	May 05/2017		424	Jan 05/2015		25-32-03 Config 2		
431	May 05/2017		425	Sep 05/2015		501	Jan 05/2015	
432	May 05/2017		426	Jan 05/2015		502	Jan 05/2015	
25-31-03			427	Jan 05/2015		25-33-01		
201	Sep 05/2017		428	Jan 05/2015		401	Sep 05/2017	
202	Sep 05/2017		429	May 05/2017		402	Sep 05/2017	
203	Sep 05/2017		430	May 05/2017		403	Sep 05/2017	
204	Jan 05/2017		431	May 05/2017		404	Sep 05/2017	
205	Jan 05/2017		432	May 05/2017		405	May 05/2017	
206	May 05/2017		433	May 05/2017		406	May 05/2017	
207	May 05/2017		434	May 05/2017		407	May 05/2017	
208	May 05/2017		435	May 05/2017		408	May 05/2017	
25-31-03			436	May 05/2017		25-33-03		
401	May 05/2015		437	May 05/2017		401	Sep 05/2017	
402	May 05/2017		438	May 05/2017		402	Sep 05/2017	
403	Jan 05/2015		439	May 05/2017		403	Sep 05/2017	
404	Sep 05/2017		440	May 05/2017		404	Sep 05/2017	
405	Sep 05/2015		441	May 05/2017		405	May 05/2017	
406	Sep 05/2017		442	May 05/2017		406	May 05/2017	
407	Jan 05/2015		443	May 05/2017		407	May 05/2017	
408	Jan 05/2015		444	BLANK		408	BLANK	
409	May 05/2017		25-31-09			25-33-09		
410	May 05/2017		401	May 05/2016		701	Sep 05/2017	
411	May 05/2017		402	May 05/2017		702	Jan 05/2015	
412	May 05/2017		403	May 05/2017		703	May 05/2017	
413	May 05/2017		404	BLANK		704	BLANK	
414	May 05/2017		25-31-11			25-33-97		
415	May 05/2017		601	May 05/2016		501	Jan 05/2015	
416	May 05/2017		602	Jan 05/2015		502	BLANK	
417	May 05/2017		25-32-03 Config 2			25-41-01		
418	May 05/2017		401	May 05/2016		401	Jan 05/2018	
419	May 05/2017		402	Sep 05/2015		402	Jan 05/2018	
420	May 05/2017		403	Sep 05/2015		403	Jan 05/2018	
421	May 05/2017		404	May 05/2018		404	Jan 05/2015	

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25-EFFECTIVE PAGES



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 25
EQUIPMENT/FURNISHINGS**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
25-41-01 (cont)			25-52-01 (cont)			25-52-04 (cont)		
405	May 05/2018		R 804	Sep 05/2018		809	May 05/2017	
406	May 05/2018		R 805	Sep 05/2018		810	BLANK	
407	May 05/2018		O 806	Sep 05/2018		25-52-06		
408	May 05/2018		R 807	Sep 05/2018		401	Sep 05/2015	
409	May 05/2018		O 808	Sep 05/2018		402	Sep 05/2017	
410	May 05/2018		O 809	Sep 05/2018		403	Sep 05/2017	
411	May 05/2018		810	Jan 05/2016		404	Sep 05/2017	
412	May 05/2017		811	May 05/2017		405	Sep 05/2017	
413	May 05/2017		812	May 05/2017		406	May 05/2016	
414	May 05/2017		813	May 05/2017		407	May 05/2017	
415	May 05/2017		814	BLANK		408	May 05/2017	
416	BLANK		25-52-02			409	May 05/2017	
25-41-08			801	Jan 05/2016		410	May 05/2017	
601	Jan 05/2016		802	Sep 05/2017		411	May 05/2017	
602	May 05/2015		803	Sep 05/2017		412	May 05/2017	
603	Sep 05/2015		804	Sep 05/2017		25-52-08		
604	May 05/2017		805	Sep 05/2017		601	May 05/2015	
25-41-09			806	Jan 05/2016		602	Sep 05/2017	
501	Jan 05/2015		807	Jan 05/2016		603	Sep 05/2017	
502	May 05/2017		808	May 05/2017		604	May 05/2017	
25-52-00			809	May 05/2017		25-52-09		
601	May 05/2016		810	BLANK		401	May 05/2015	
602	Sep 05/2017		25-52-03			402	Sep 05/2017	
603	Sep 05/2017		401	Jan 05/2015		403	May 05/2017	
604	Sep 05/2017		402	May 05/2017		404	May 05/2017	
25-52-00			403	Jan 05/2015		405	Sep 05/2017	
701	Jul 25/2018		404	BLANK		406	Sep 05/2017	
702	Jul 25/2018		25-52-04			25-52-10		
703	Jul 25/2018		R 801	Sep 05/2018		401	May 05/2015	
704	Jul 25/2018		R 802	Sep 05/2018		402	Sep 05/2017	
705	Jul 25/2018		R 803	Sep 05/2018		403	Sep 05/2017	
706	BLANK		O 804	Sep 05/2018		404	Sep 05/2017	
25-52-01			O 805	Sep 05/2018		405	May 05/2017	
801	Jan 05/2017		O 806	Sep 05/2018		406	May 05/2017	
802	Sep 05/2017		O 807	Sep 05/2018		407	May 05/2017	
803	Sep 05/2017		O 808	Sep 05/2018		408	May 05/2017	

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25-EFFECTIVE PAGES



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 25
EQUIPMENT/FURNISHINGS**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
25-52-10 (cont)			25-52-19			25-53-00 Config 3 (cont)		
409	May 05/2017		401	Sep 05/2017		510	Jan 05/2015	
410	May 05/2017		402	May 05/2017		511	Jan 05/2015	
411	May 05/2017		403	May 05/2017		512	Jan 05/2015	
412	May 05/2017		404	May 05/2017		513	Sep 05/2016	
25-52-11			25-52-20			514	Sep 05/2016	
401	Sep 05/2017		401	Sep 05/2017		515	Sep 05/2016	
402	Sep 05/2015		402	Sep 05/2015		516	Sep 05/2016	
403	Jan 05/2015		403	Jan 05/2015		517	Sep 05/2016	
404	May 05/2017		404	May 05/2017		518	May 05/2017	
405	May 05/2017		405	May 05/2017		519	May 05/2017	
406	May 05/2017		406	May 05/2017		520	Sep 05/2016	
407	May 05/2017		25-53-00			521	Sep 05/2016	
408	BLANK		201	Jan 05/2016		522	Sep 05/2016	
25-52-16			202	Sep 05/2017		523	Sep 05/2016	
401	Sep 05/2017		203	Sep 05/2017		524	Sep 05/2016	
402	Sep 05/2017		204	Jan 05/2016		525	Sep 05/2016	
403	Sep 05/2017		205	Sep 05/2017		526	Sep 05/2016	
404	May 05/2017		206	Sep 05/2017		527	Sep 05/2016	
405	May 05/2017		207	Sep 05/2017		528	Sep 05/2016	
406	Sep 05/2017		208	Jan 05/2016		529	Sep 05/2016	
407	Jan 05/2018		209	Sep 05/2017		530	May 05/2017	
408	BLANK		210	Sep 05/2017		531	Sep 05/2016	
25-52-17			211	Sep 05/2017		532	May 05/2017	
401	Sep 05/2017		212	Sep 05/2017		533	Sep 05/2016	
402	Sep 05/2017		213	Sep 05/2017		534	Sep 05/2016	
403	May 05/2017		214	BLANK		535	Sep 05/2016	
404	BLANK		25-53-00 Config 3			536	Sep 05/2016	
25-52-18			501	Jan 05/2015		537	Sep 05/2016	
401	Sep 05/2017		502	Jan 05/2015		538	Sep 05/2016	
402	May 05/2015		503	Jan 05/2015		539	Sep 05/2016	
403	May 05/2015		504	Jan 05/2015		540	Sep 05/2016	
404	May 05/2017		505	May 05/2017		541	Sep 05/2016	
405	May 05/2017		506	Jan 05/2015		542	Sep 05/2016	
406	BLANK		507	May 05/2017		543	Sep 05/2016	
			508	Jan 05/2016		544	Sep 05/2016	
			509	Jan 05/2015		545	Sep 05/2016	

A = Added, R = Revised, D = Deleted, O = Overflow, C = Customer Originated Change

25-EFFECTIVE PAGES



777-200/300 AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25 EQUIPMENT/FURNISHINGS

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
25-53-00 Config 3 (cont)			25-53-01 (cont)			25-53-12 (cont)		
546	Sep 05/2016		416	May 05/2017		407	May 05/2018	
547	Sep 05/2016		25-53-02			408	May 05/2017	
548	Sep 05/2016		401	Sep 05/2017		25-53-13 Config 3		
549	Sep 05/2016		402	Sep 05/2017		401	Sep 05/2017	
550	Sep 05/2016		403	Sep 05/2017		402	Jul 25/2018	
551	Sep 05/2016		404	Sep 05/2015		403	Sep 05/2017	
552	Sep 05/2016		405	May 05/2017		404	May 05/2017	
553	Sep 05/2016		406	May 05/2017		405	May 05/2017	
554	Sep 05/2016		25-53-03			406	BLANK	
555	Sep 05/2016		401	May 05/2015		25-53-14		
556	Sep 05/2016		402	Sep 05/2017		401	Sep 05/2017	
557	Sep 05/2016		403	Sep 05/2017		402	May 05/2015	
558	Sep 05/2016		404	Sep 05/2017		403	Sep 05/2017	
559	Sep 05/2016		405	May 05/2017		404	Sep 05/2015	
560	Sep 05/2016		406	May 05/2017		405	May 05/2017	
561	Sep 05/2016		25-53-04			406	May 05/2018	
562	BLANK		401	Sep 05/2017		407	May 05/2017	
25-53-01			402	Sep 05/2015		408	May 05/2018	
201	Sep 05/2017		403	May 05/2017		25-53-21		
202	Sep 05/2017		404	May 05/2017		401	Sep 05/2017	
25-53-01			405	May 05/2017		402	Jan 05/2018	
401	May 05/2017		406	BLANK		403	Sep 05/2017	
402	Sep 05/2017		25-53-11 Config 3			404	Sep 05/2017	
403	Jan 05/2015		401	Sep 05/2017		405	May 05/2017	
404	May 05/2017		402	Jul 25/2018		406	May 05/2017	
405	Sep 05/2017		403	Sep 05/2017		407	May 05/2017	
406	May 05/2015		404	Sep 05/2017		408	May 05/2017	
407	Sep 05/2017		405	Sep 05/2017		25-53-22 Config 3		
408	Sep 05/2017		406	Sep 05/2017		401	Sep 05/2017	
409	Sep 05/2017		25-53-12			402	Sep 05/2017	
410	May 05/2017		401	Sep 05/2017		403	Sep 05/2015	
411	May 05/2017		402	Jul 25/2018		404	May 05/2017	
412	May 05/2017		403	Jul 25/2018		405	May 05/2017	
413	Sep 05/2015		404	Sep 05/2015		406	BLANK	
414	Sep 05/2017		405	May 05/2017				
415	May 05/2017		406	Jan 05/2015				

A = Added, R = Revised, D = Deleted, O = Overflow, C = Customer Originated Change

25-EFFECTIVE PAGES



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 25
EQUIPMENT/FURNISHINGS**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
25-53-23			25-53-27			25-61-01 (cont)		
401	Sep 05/2017		401	Sep 05/2017		207	Sep 05/2015	
402	May 05/2015		402	May 05/2015		208	Sep 05/2015	
403	May 05/2015		403	Sep 05/2015		209	May 05/2017	
404	Sep 05/2015		404	May 05/2018		210	BLANK	
405	May 05/2017		405	May 05/2017		25-61-02		
406	May 05/2017		406	BLANK		201	Jan 05/2015	
407	May 05/2017		25-53-31			202	Sep 05/2017	
408	May 05/2017		401	Jan 05/2015		203	Sep 05/2017	
409	Sep 05/2017		402	Sep 05/2015		204	May 05/2017	
410	Sep 05/2017		403	Jan 05/2015		205	May 05/2017	
411	Sep 05/2017		404	Jan 05/2015		206	BLANK	
412	BLANK		405	Jan 05/2015		25-62-01		
25-53-24 Config 3			406	May 05/2017		201	May 05/2015	
401	Sep 05/2017		25-53-32			202	May 05/2017	
402	May 05/2015		401	Jan 05/2015		203	May 05/2017	
403	Sep 05/2017		402	Sep 05/2015		204	May 05/2015	
404	Sep 05/2015		403	Jan 05/2015		25-63-01		
405	May 05/2017		404	Jan 05/2015		201	Jul 25/2018	
406	May 05/2017		405	Jan 05/2015		202	Jul 25/2018	
25-53-25			406	Jan 05/2015		25-63-02		
401	Sep 05/2017		407	May 05/2017		201	May 05/2015	
402	Sep 05/2017		408	BLANK		202	Jan 05/2015	
403	Sep 05/2017		25-53-33 Config 3			203	May 05/2017	
404	May 05/2018		401	Sep 05/2017		204	Jan 05/2015	
405	May 05/2017		402	Sep 05/2017		25-64-01		
406	BLANK		403	May 05/2015		201	Sep 05/2017	
25-53-26			404	May 05/2015		202	Jan 05/2015	
401	Sep 05/2017		405	Sep 05/2017		203	May 05/2017	
402	Sep 05/2017		406	May 05/2017		204	Sep 05/2017	
403	Sep 05/2017		25-61-01			205	Jan 05/2016	
404	Sep 05/2015		201	Jan 05/2015		206	Jan 05/2016	
405	May 05/2017		202	May 05/2017		207	May 05/2017	
406	May 05/2017		203	May 05/2017		208	Jan 05/2016	
407	May 05/2017		204	Jan 05/2015		209	Jan 05/2016	
408	May 05/2017		205	Sep 05/2015		210	BLANK	
			206	Sep 05/2015				

A = Added, R = Revised, D = Deleted, O = Overflow, C = Customer Originated Change

25-EFFECTIVE PAGES



777-200/300 AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25 EQUIPMENT/FURNISHINGS

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
25-64-01			25-65-00 (cont)			25-65-01 (cont)		
601	May 05/2015		218	May 05/2017		408	Jan 05/2018	
602	BLANK		219	May 05/2017		409	May 05/2017	
25-64-02			220	May 05/2017		410	May 05/2017	
201	May 05/2015		221	May 05/2017		411	Jan 05/2018	
202	May 05/2017		222	May 05/2017		412	May 05/2017	
203	May 05/2015		223	May 05/2017		413	May 05/2017	
204	May 05/2017		224	BLANK		414	BLANK	
205	May 05/2017		25-65-00			25-65-02		
206	BLANK		501	Sep 05/2015		401	May 05/2015	
25-64-50 Config 1			502	Sep 05/2017		402	May 05/2015	
201	May 05/2015		503	Sep 05/2017		403	Sep 05/2017	
202	BLANK		504	Sep 05/2017		404	Sep 05/2017	
25-64-50 Config 2			505	Sep 05/2017		405	May 05/2015	
601	May 05/2018		506	Sep 05/2017		406	Sep 05/2017	
602	BLANK		507	Sep 05/2017		407	Sep 05/2017	
25-64-53			508	May 05/2017		408	Sep 05/2017	
401	May 05/2015		509	May 05/2017		409	Jan 05/2015	
402	BLANK		510	Jan 05/2018		410	May 05/2017	
25-65-00			511	Jan 05/2018		25-65-02		
201	Jan 05/2016		512	Jan 05/2018		601	May 05/2015	
202	Sep 05/2017		513	Jan 05/2018		602	May 05/2015	
203	May 05/2017		514	Jan 05/2018		603	May 05/2017	
204	May 05/2017		515	Jan 05/2018		604	BLANK	
205	May 05/2017		516	Jan 05/2018		25-65-10		
206	May 05/2017		517	Jan 05/2018		201	Sep 05/2017	
207	May 05/2017		518	Jan 05/2018		202	Sep 05/2017	
208	Sep 05/2017		519	Jan 05/2018		203	Sep 05/2017	
209	Sep 05/2017		520	Jan 05/2018		204	May 05/2017	
210	Sep 05/2017		25-65-01			25-65-10		
211	May 05/2017		401	Jan 05/2018		401	May 05/2018	
212	Sep 05/2017		402	Jan 05/2018		402	Sep 05/2015	
213	May 05/2017		403	Jan 05/2018		403	Jan 05/2015	
214	Sep 05/2017		404	Jan 05/2018		404	May 05/2017	
215	Sep 05/2017		405	Sep 05/2017		405	May 05/2017	
216	Sep 05/2017		406	May 05/2017		406	May 05/2017	
217	Sep 05/2017		407	May 05/2017		407	May 05/2017	

A = Added, R = Revised, D = Deleted, O = Overflow, C = Customer Originated Change

25-EFFECTIVE PAGES



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 25
EQUIPMENT/FURNISHINGS**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
25-65-10 (cont)			25-66-00 (cont)			25-80-00 (cont)		
408	BLANK		210	Sep 05/2017		413	Sep 05/2017	
25-65-11			25-66-00			414	Sep 05/2017	
401	Sep 05/2017		501	Sep 05/2017		25-80-00		
402	Jan 05/2018		502	Sep 05/2017		601	May 05/2016	
403	Sep 05/2017		503	May 05/2017		602	May 05/2016	
404	Sep 05/2017		504	May 05/2017		603	May 05/2016	
405	Jan 05/2017		25-66-01			604	May 05/2016	
406	May 05/2017		401	Jul 25/2018		605	May 05/2016	
407	May 05/2017		402	Jul 25/2018		606	Sep 05/2016	
408	BLANK		403	Jul 25/2018		607	Sep 05/2016	
25-65-12			404	Jul 25/2018		608	Sep 05/2016	
401	Sep 05/2017		405	Jul 25/2018		609	Sep 05/2016	
402	Sep 05/2017		406	Jul 25/2018		610	Sep 05/2016	
403	Jan 05/2018		407	May 05/2017		25-80-00		
404	Sep 05/2017		408	Jan 05/2018		801	Sep 05/2015	
405	Sep 05/2017		409	Jul 25/2018		802	Sep 05/2017	
406	Sep 05/2017		410	Jul 25/2018		803	Jan 05/2015	
407	Sep 05/2017		25-66-01			804	Jan 05/2015	
408	Sep 05/2017		601	May 05/2015		805	Sep 05/2015	
409	Sep 05/2017		602	Sep 05/2016		806	Sep 05/2017	
410	BLANK		25-66-06			807	Sep 05/2017	
25-65-13			401	Jan 05/2015		808	Jan 05/2015	
401	Jan 05/2015		402	May 05/2017		809	May 05/2016	
402	Jan 05/2015		25-80-00			810	Sep 05/2017	
403	May 05/2017		401	May 05/2015		811	Sep 05/2017	
404	May 05/2017		402	Sep 05/2017		812	Sep 05/2017	
25-66-00			403	Sep 05/2017		813	May 05/2016	
201	May 05/2017		404	Sep 05/2017		814	Sep 05/2017	
202	Sep 05/2017		405	Sep 05/2017		815	Sep 05/2017	
203	May 05/2017		406	Sep 05/2017		816	Sep 05/2017	
204	May 05/2017		407	Sep 05/2017		817	Sep 05/2017	
205	May 05/2017		408	Sep 05/2017		818	Sep 05/2017	
206	May 05/2017		409	Sep 05/2017		819	Sep 05/2017	
207	Sep 05/2017		410	Sep 05/2017		820	Sep 05/2016	
208	Sep 05/2017		411	Sep 05/2017		821	Sep 05/2017	
209	May 05/2017		412	Sep 05/2017		822	Sep 05/2017	

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25-EFFECTIVE PAGES



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 25
EQUIPMENT/FURNISHINGS**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
25-80-00 (cont)								
823	Sep 05/2017							
824	Sep 05/2017							
825	Sep 05/2017							
826	Sep 05/2017							

A = Added, R = Revised, D = Deleted, O = Overflow, C = Customer Originated Change

25-EFFECTIVE PAGES



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 25
EQUIPMENT/FURNISHINGS**

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>EQUIPMENT AND FURNISHINGS - CLEANING/PAINTING</u>	25-00-00		701	ARO ALL
Equipment and Furnishings Cleaning TASK 25-00-00-100-801			701	ARO ALL
Equipment and Furnishings Painting TASK 25-00-00-370-801			711	ARO ALL
<u>EQUIPMENT AND FURNISHINGS - REPAIRS</u>	25-00-00		801	ARO ALL
Repair Decorative Tedlar Covering on Flight Deck Door TASK 25-00-00-300-801			801	ARO ALL
Sandwich and Laminate Panel Repairs TASK 25-00-00-340-801			803	ARO ALL
Decorative Surfaces Repair TASK 25-00-00-340-802			810	ARO ALL
Decorative Tedlar Removal/Installation TASK 25-00-00-900-801			815	ARO ALL
Nomex Honeycomb Sandwich Panels with a Decorative Tedlar Cover Repair TASK 25-00-00-340-803			822	ARO ALL
Tedlar Laminate Covers of Aluminum Laminate - Repair TASK 25-00-00-340-804			826	ARO ALL
Perforated Panel Repair TASK 25-00-00-340-805			826	ARO ALL
Polycarbonate (Lexan), ULTEM, Radel, and Declar Plastics Repair TASK 25-00-00-340-806			831	ARO ALL
Urethane Foam Repair TASK 25-00-00-340-807			833	ARO ALL
Repair Aluminum Trim TASK 25-00-00-350-801			835	ARO ALL
Repair of Stowage Bin Edge Cap TASK 25-00-00-350-803			836	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>EQUIPMENT AND FURNISHINGS - DDG MAINTENANCE PROCEDURES</u>	25-00-00		901	ARO ALL
DDG 25-11-1 Preparation - Flight Crew Seat Inoperative TASK 25-00-00-040-801			902	ARO ALL
DDG 25-11-1 Restoration - Flight Crew Seat Inoperative TASK 25-00-00-440-801			903	ARO ALL
DDG 25-18-1 Preparation - Flotation Equipment Inoperative (EASA) TASK 25-00-00-040-820			903	ARO ALL
DDG 25-18-1 Restoration - Flotation Equipment Inoperative (EASA) TASK 25-00-00-440-819			904	ARO ALL
DDG 25-25-1 Preparation - Flight Attendant Seat Inoperative TASK 25-00-00-040-802			904	ARO ALL
DDG 25-25-1 Restoration - Flight Attendant Seat Inoperative TASK 25-00-00-440-802			905	ARO ALL
DDG 25-25-2 Preparation - Passenger Seat Inoperative TASK 25-00-00-040-803			906	ARO ALL
DDG 25-25-2 Restoration - Passenger Seat Inoperative TASK 25-00-00-440-803			907	ARO ALL
DDG 25-25-4 Preparation - Crew/Attendant Rest Seats Inoperative TASK 25-00-00-040-810			907	ARO ALL
DDG 25-25-4 Restoration - Crew/Attendant Rest Seats Inoperative TASK 25-00-00-440-810			908	ARO ALL
DDG 25-28-1 Preparation - Overhead Storage Bins/Cabin, Galley and Lavatory Storage Compartments/Closets TASK 25-00-00-040-811			908	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
DDG 25-28-1 Restoration - Overhead Storage Bins/Cabin, Galley and Lavatory Storage Compartments/Closets TASK 25-00-00-440-811			909	ARO ALL
DDG 25-29-1 Preparation - Flight Crew Rest (FCR) Door TASK 25-00-00-040-813			910	ARO ALL
DDG 25-29-1 Restoration - Flight Crew Rest (FCR) Door TASK 25-00-00-440-813			910	ARO ALL
DDG 25-29-2 Preparation - Main Deck Crew Rest (MDCR)/Main Deck Flight Crew Rest (MDFCR) Door TASK 25-00-00-040-816			911	ARO ALL
DDG 25-29-2 Restoration - Main Deck Crew Rest (MDCR)/Main Deck Flight Crew Rest (MDFCR) Door TASK 25-00-00-440-816			912	ARO ALL
DDG 25-29-3 Preparation - Overhead Flight Crew and Attendant Rest Doors TASK 25-00-00-040-807			912	ARO ALL
DDG 25-29-3 Restoration - Overhead Flight Crew and Attendant Rest Doors TASK 25-00-00-440-807			913	ARO ALL
DDG 25-29-4 Preparation - Flight Crew and Attendant Rests (OFCR, OFAR, FCR, MDCR, MDFCR, LLAR) TASK 25-00-00-040-808			913	ARO ALL
DDG 25-29-4 Restoration - Flight Crew and Attendant Rests (OFCR, OFAR, FCR, MDCR, MDFCR, LLAR) TASK 25-00-00-440-808			914	ARO ALL
DDG 25-30-1 Preparation - Galley Waste Container Door/Cover Inoperative TASK 25-00-00-040-804			914	ARO ALL
DDG 25-30-1 Restoration - Galley Waste Container Door/Cover Inoperative TASK 25-00-00-440-804			915	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
DDG 25-40-1 Preparation - Interior Lavatory Ashtrays Inoperative (EASA) TASK 25-00-00-040-818			915	ARO ALL
DDG 25-40-1 Restoration - Interior Lavatory Ashtrays Inoperative (EASA) TASK 25-00-00-440-817			915	ARO ALL
DDG 25-41-2 Preparation - Lavatory Waste Container Flapper/Access Door Inoperative TASK 25-00-00-040-805			916	ARO ALL
DDG 25-41-2 Restoration - Lavatory Waste Container Flapper/Cover Inoperative TASK 25-00-00-440-805			916	ARO ALL
DDG 25-53-2 Preparation - Lower Lobe Cargo Compartment Restraint Systems Inoperative TASK 25-00-00-040-806			917	ARO ALL
DDG 25-53-2 Restoration - Lower Lobe Cargo Compartment Restraint Components Inoperative TASK 25-00-00-440-820			917	ARO ALL
DDG 25-63-3 Preparation - Portable Emergency Locator Transmitter Inoperative (EASA) TASK 25-00-00-040-819			918	ARO ALL
DDG 25-63-3 Restoration - Portable Emergency Locator Transmitter Inoperative (EASA) TASK 25-00-00-440-818			918	ARO ALL
<u>FLIGHT COMPARTMENT SEATS - ADJUSTMENT/TEST</u>	25-11-00		501	ARO ALL
Flight Compartment Seats Operational Test - Powered TASK 25-11-00-700-801			501	ARO ALL
Flight Compartment Seats Operational Test - Manual Adjustment (Vertical and Horizontal) TASK 25-11-00-700-802			503	ARO ALL
Flight Compartment Seats Operational Test - Restraint Harness Inertia Reel TASK 25-11-00-700-803			508	ARO ALL
Flight Compartment Seats Operational Test - Lock Mechanism TASK 25-11-00-700-804			509	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
Flight Compartment Seats Limit Switch Adjustment TASK 25-11-00-820-801			510	ARO ALL
<u>FLIGHT COMPARTMENT SEATS - INSPECTION/CHECK</u>	25-11-00		601	ARO ALL
Seat Attachment Inspection TASK 25-11-00-210-801			601	ARO ALL
Seat Belt and Shoulder Harness - Inspection TASK 25-11-00-200-803			605	ARO ALL
Flight Compartment Foreign Object Debris- Inspection TASK 25-11-00-200-804			605	ARO ALL
<u>CAPTAIN/FIRST OFFICER SEAT - REMOVAL/INSTALLATION</u>	25-11-01		401	ARO ALL
Captain and First Officer Seat Removal TASK 25-11-01-000-801			401	ARO ALL
Captain and First Officer Seat - Installation TASK 25-11-01-400-801			402	ARO ALL
<u>OBSERVER SEAT - REMOVAL/INSTALLATION</u>	25-11-03		401	ARO ALL
First Observer Seat - Removal TASK 25-11-03-000-801			401	ARO ALL
Second Observer Seat - Removal TASK 25-11-03-000-802			401	ARO ALL
First Observer Seat - Installation TASK 25-11-03-400-801			402	ARO ALL
Second Observer Seat - Installation TASK 25-11-03-400-802			402	ARO ALL
<u>OBSERVER SEAT - INSPECTION/CHECK</u>	25-11-03		601	ARO ALL
Observer Seat Attachment Inspection TASK 25-11-03-210-801			601	ARO ALL
<u>CHART HOLDER - REMOVAL/INSTALLATION</u>	25-13-01		401	ARO ALL
Chart Holder Removal TASK 25-13-01-000-801			401	ARO ALL
Chart Holder Installation TASK 25-13-01-400-801			401	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>SIDE CONSOLE - REMOVAL/INSTALLATION</u>	25-15-01		401	ARO ALL
Side Console - Removal TASK 25-15-01-000-801			401	ARO ALL
Side Console - Installation TASK 25-15-01-400-801			403	ARO ALL
<u>FLIGHT DECK STOWAGE CLOSET - REMOVAL/INSTALLATION</u>	25-15-02		401	ARO ALL
Stowage Closet Removal TASK 25-15-02-010-801			401	ARO ALL
Stowage Closet Installation TASK 25-15-02-400-801			402	ARO ALL
<u>FORWARD CONSOLE - REMOVAL/INSTALLATION</u>	25-15-03		401	ARO ALL
Forward Console Removal TASK 25-15-03-000-801			401	ARO ALL
Forward Console Installation TASK 25-15-03-400-801			402	ARO ALL
<u>OBSERVERS CONSOLE - REMOVAL/INSTALLATION</u>	25-15-05		401	ARO ALL
Observers Console Removal TASK 25-15-05-010-801			401	ARO ALL
Observers Console Installation TASK 25-15-05-400-801			402	ARO ALL
<u>OVERHEAD LINING - REMOVAL/INSTALLATION</u>	25-15-06		401	ARO ALL
Overhead Lining - Removal TASK 25-15-06-000-801			401	ARO ALL
Overhead Lining - Installation TASK 25-15-06-400-801			402	ARO ALL
<u>FLIGHT COMPARTMENT DRIPSHIELDS - REMOVAL/INSTALLATION</u>	25-16-00		401	ARO ALL
Remove the Dripshields TASK 25-16-00-000-801			401	ARO ALL
Install the Dripshields TASK 25-16-00-400-801			405	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	CHAPTER SECTION <u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>CLOSEOUT SEAL - MAINTENANCE PRACTICES</u>	25-20-01		201	ARO ALL
Installation of the Closeout Seal TASK 25-20-01-400-801			201	ARO ALL
Reinstallation of Closeout Seals TASK 25-20-01-400-802			202	ARO ALL
<u>SIDEWALL PANEL - REMOVAL/INSTALLATION</u>	25-21-01		401	ARO ALL
Sidewall Panel - Removal TASK 25-21-01-000-801			401	ARO ALL
Sidewall Panel - Installation TASK 25-21-01-400-801			402	ARO ALL
<u>DOORWAY LINING - REMOVAL/INSTALLATION</u>	25-21-02		401	ARO ALL
Doorway Lining Removal TASK 25-21-02-000-801			401	ARO ALL
Doorway Lining Installation TASK 25-21-02-400-801			403	ARO ALL
<u>MAIN CEILING PANEL - REMOVAL/INSTALLATION</u>	25-21-06		401	ARO ALL
Main Ceiling Panel - Removal TASK 25-21-06-000-801			401	ARO ALL
Main Ceiling Panel - Installation TASK 25-21-06-400-801			402	ARO ALL
<u>LOWERED CEILING PANEL - REMOVAL/INSTALLATION</u>	25-21-07		401	ARO ALL
Lowered Ceiling Panel Removal TASK 25-21-07-000-801			401	ARO ALL
Lowered Ceiling Panel Installation TASK 25-21-07-400-801			402	ARO ALL
<u>OVERDOOR PANEL - MAINTENANCE PRACTICES</u>	25-21-08		201	ARO ALL
Overdoor Panel Opening/Removal TASK 25-21-08-000-801			201	ARO ALL
Overdoor Panel Installation/Closing TASK 25-21-08-400-801			202	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>PASSENGER SERVICE UNITS (PSU) - MAINTENANCE PRACTICES</u>	25-23-01		201	ARO ALL
Passenger Service Unit (PSU) Opening TASK 25-23-01-010-801			201	ARO ALL
Passenger Service Unit (PSU) Closing TASK 25-23-01-410-801			202	ARO ALL
<u>PASSENGER SERVICE UNITS (PSU) - REMOVAL/INSTALLATION</u>	25-23-01		401	ARO ALL
Passenger Service Unit (PSU) - Removal TASK 25-23-01-010-802			401	ARO ALL
Passenger Service Unit (PSU) - Installation TASK 25-23-01-400-801			407	ARO ALL
<u>CLOSETS - REMOVAL/INSTALLATION</u>	25-24-01		401	ARO ALL
Outboard Closet Removal TASK 25-24-01-000-802			401	ARO ALL
Outboard Closet Installation TASK 25-24-01-400-802			404	ARO ALL
Bulkhead Closet Removal TASK 25-24-01-000-810			416	ARO ALL
Bulkhead Closet Installation TASK 25-24-01-400-811			418	ARO ALL
Centerline Closet Removal TASK 25-24-01-000-803			419	ARO ALL
Centerline Closet Installation TASK 25-24-01-400-807			421	ARO ALL
<u>UNDERBIN CLOSETS - REMOVAL/INSTALLATION</u>	25-24-03		401	ARO ALL
Outboard Underbin Closet Removal TASK 25-24-03-000-801			401	ARO ALL
Outboard Underbin Closet Installation TASK 25-24-03-400-801			402	ARO ALL
<u>PARTITION - REMOVAL/INSTALLATION</u>	25-24-06		401	ARO ALL
Partition - Removal TASK 25-24-06-000-801			401	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
Partition - Installation TASK 25-24-06-400-801			402	ARO ALL
<u>CLASS DIVIDERS - REMOVAL/INSTALLATION</u>	25-24-08		401	ARO ALL
Class Divider Removal TASK 25-24-08-000-801			401	ARO ALL
Class Divider Installation TASK 25-24-08-400-801			403	ARO ALL
<u>VIDEO CONTROL CENTER (VCC) - REMOVAL/INSTALLATION</u>	25-24-10		401	ARO ALL
Video Control Center (VCC) Removal TASK 25-24-10-000-809			401	ARO ALL
Video Control Center (VCC) Installation TASK 25-24-10-400-808			408	ARO ALL
<u>OUTLETS - MAINTENANCE PRACTICES</u>	25-24-15		201	ARO ALL
Service Outlets - Deactivation TASK 25-24-15-040-801			201	ARO ALL
Service Outlets - Activation TASK 25-24-15-440-801			202	ARO ALL
Medical Outlets - Deactivation TASK 25-24-15-040-803			202	ARO ALL
Medical Outlets - Activation TASK 25-24-15-440-803			203	ARO ALL
<u>Service Outlets - Removal/Installation</u>	25-24-15		401	ARO ALL
Service Outlet - Removal TASK 25-24-15-000-801			401	ARO ALL
Service Outlet - Installation TASK 25-24-15-400-801			402	ARO ALL
<u>CURTAIN TRACK - REMOVAL/INSTALLATION</u>	25-24-50		401	ARO ALL
Curtain Track and Header Panel - Removal TASK 25-24-50-020-801			401	ARO ALL
Curtain Track and Header Panel - Installation TASK 25-24-50-420-801			403	ARO ALL
Ceiling Mounted Curtain Track - Removal TASK 25-24-50-000-801			403	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
Ceiling Mounted Curtain Track - Installation TASK 25-24-50-400-801			407	ARO ALL
<u>PASSENGER SEATS - REMOVAL/INSTALLATION</u>	25-25-01		401	ARO ALL
Passenger Seat - Removal TASK 25-25-01-000-801			401	ARO ALL
Passenger Seat - Installation TASK 25-25-01-400-801			403	ARO ALL
<u>PASSENGER SEATS - INSPECTION/CHECK</u>	25-25-01	1	601	ARO ALL
Passenger Seat Attachment Inspection TASK 25-25-01-200-801		1	601	ARO ALL
Passenger Seat Belt Check TASK 25-25-01-200-802		1	602	ARO ALL
Passenger Seat Recline and Breakover Check TASK 25-25-01-710-801		1	602	ARO ALL
Inflatable Passenger Seat Belt and Airbag Cover Inspection/Check TASK 25-25-01-200-808		1	609	ARO ALL
<u>WALL-MOUNTED ATTENDANT SEATS - REMOVAL/INSTALLATION</u>	25-25-06	1	401	ARO ALL
Attendant Seat Removal TASK 25-25-06-000-801		1	401	ARO ALL
Attendant Seat Installation TASK 25-25-06-400-801		1	401	ARO ALL
<u>TRACK-MOUNTED ATTENDANT SEATS - REMOVAL/INSTALLATION</u>	25-25-06	2	401	ARO ALL
Attendant Seat Removal TASK 25-25-06-000-802		2	401	ARO ALL
Attendant Seat Installation TASK 25-25-06-400-802		2	401	ARO ALL
<u>WALL-MOUNTED ATTENDANT SEAT - REMOVAL/INSTALLATION</u>	25-25-06	6	401	ARO ALL
Attendant Seat Removal TASK 25-25-06-000-806		6	401	ARO ALL
Attendant Seat Installation TASK 25-25-06-400-806		6	402	ARO ALL

25-CONTENTS



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 25
EQUIPMENT/FURNISHINGS**

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>ATTENDANT SEATS - INSPECTION/CHECK</u>	25-25-06		601	ARO ALL
Attendant Seat Occupant Restraint Inspection TASK 25-25-06-210-801			601	ARO ALL
Attendant Seat Attachment Inspection TASK 25-25-06-210-802			603	ARO ALL
<u>INFLATABLE PASSENGER SEAT BELT - MAINTENANCE PRACTICES</u>	25-25-86		201	ARO ALL
V23 Inflatable Seatbelt Deactivation TASK 25-25-86-040-802			201	ARO ALL
V23 Inflatable Seatbelt Activation TASK 25-25-86-440-802			204	ARO ALL
<u>INFLATABLE PASSENGER SEAT BELT - REMOVAL/INSTALLATION</u>	25-25-86	1	401	ARO ALL
V23 Inflatable Seatbelt Airbag Assembly Removal TASK 25-25-86-000-805		1	401	ARO ALL
V23 Inflatable Seatbelt Airbag Assembly Installation TASK 25-25-86-400-805		1	406	ARO ALL
V23 Inflatable Seatbelt Inflator Assembly Removal TASK 25-25-86-000-806		1	407	ARO ALL
V23 Inflatable Seatbelt Inflator Assembly Installation TASK 25-25-86-400-806		1	410	ARO ALL
V23 Inflatable Seatbelt Electronic Module Assembly Removal TASK 25-25-86-000-807		1	412	ARO ALL
V23 Inflatable Seatbelt Electronic Module Assembly Installation TASK 25-25-86-400-807		1	413	ARO ALL
<u>PASSENGER SEAT INFLATABLE SEATBELT - ADJUSTMENT/TEST</u>	25-25-86		501	ARO ALL
V23 Inflatable Seatbelt Operational Test TASK 25-25-86-710-805			501	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>PASSENGER SEAT INFLATABLE SEAT BELT - INSPECTION</u>	25-25-86	1		601	ARO ALL
V23 Inflatable Seatbelt Detailed Inspection TASK 25-25-86-200-802-001		1		601	ARO ALL
<u>CARPET - REMOVAL/INSTALLATION</u>	25-27-01			401	ARO ALL
Carpet (Without Adhesive Back) Removal TASK 25-27-01-000-801				401	ARO ALL
Carpet (Without Adhesive Back) Installation TASK 25-27-01-400-801				402	ARO ALL
Carpet (Adhesive Back) Removal TASK 25-27-01-000-811				405	ARO ALL
Carpet (Adhesive Back) Installation TASK 25-27-01-400-811				408	ARO ALL
<u>GALLEY AREA FLOOR MATS - REMOVAL/INSTALLATION</u>	25-27-03			401	ARO ALL
Galley Area Floor Mat Removal TASK 25-27-03-000-801				401	ARO ALL
Galley Area Floor Mat Installation. TASK 25-27-03-400-801				403	ARO ALL
<u>ENTRYWAY FLOOR COVERING - REMOVAL/INSTALLATION</u>	25-27-07			401	ARO ALL
Entryway Floor Covering - Removal TASK 25-27-07-000-801				401	ARO ALL
Entryway Floor Covering - Installation TASK 25-27-07-400-801				402	ARO ALL
<u>PASSENGER SEAT RACEWAYS - REMOVAL/INSTALLATION</u>	25-27-09			401	ARO ALL
RACEWAY REMOVAL TASK 25-27-09-000-801				401	ARO ALL
RACEWAY INSTALLATION TASK 25-27-09-400-801				405	ARO ALL
<u>EPOXY WALKWAY COATING - REMOVAL/INSTALLATION</u>	25-27-11			401	ARO ALL
Epoxy Walkway Coating - Removal TASK 25-27-11-000-801				401	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
Epoxy Walkway Coating - Installation TASK 25-27-11-400-801			402	ARO ALL
<u>OUTBOARD STOWAGE BIN - REMOVAL/INSTALLATION</u>	25-28-01		401	ARO ALL
Outboard Stowage Bin - Removal TASK 25-28-01-000-801			401	ARO ALL
Outboard Stowage Bin Installation TASK 25-28-01-400-801			402	ARO ALL
Outboard Stowage Bin Module Removal TASK 25-28-01-000-802			405	ARO ALL
Outboard Stowage Bin Module Installation TASK 25-28-01-400-802			406	ARO ALL
<u>CENTER STOWAGE BIN - MAINTENANCE PRACTICES</u>	25-28-02		201	ARO ALL
Change the Operation Mode TASK 25-28-02-860-802			201	ARO ALL
<u>CENTER STOWAGE BIN - REMOVAL/INSTALLATION</u>	25-28-02		401	ARO ALL
Center Stowage Bin Removal TASK 25-28-02-000-801			401	ARO ALL
Center Stowage Bin Installation TASK 25-28-02-400-801			402	ARO ALL
Center Stowage Bin Module Removal TASK 25-28-02-000-802			406	ARO ALL
Center Stowage Bin Module Installation TASK 25-28-02-400-802			407	ARO ALL
Center Stowage Bin Module Removal TASK 25-28-02-000-805			411	ARO ALL
Center Stowage Bin Module Installation TASK 25-28-02-400-805			412	ARO ALL
<u>STOWAGE BIN SNUBBER - REMOVAL/INSTALLATION</u>	25-28-03		401	ARO ALL
Stowage Bin Snubber Removal TASK 25-28-03-000-801			401	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
Stowage Bin Snubber Installation TASK 25-28-03-400-801			403	ARO ALL
<u>STOWAGE BIN LATCH - MAINTENANCE PRACTICES</u>	25-28-04		201	ARO ALL
Stowage Bin Latch - Release TASK 25-28-04-820-802			201	ARO ALL
<u>STOWAGE BIN LATCH - ADJUSTMENT/TEST</u>	25-28-04		501	ARO ALL
Stowage Bin Latch - Adjustment TASK 25-28-04-820-801			501	ARO ALL
<u>FLOOR-MOUNTED STOWAGE BOX - REMOVAL/INSTALLATION</u>	25-28-05		401	ARO ALL
Floor-Mounted Stowage Box Removal TASK 25-28-05-000-801			401	ARO ALL
Floor-Mounted Stowage Box - Installation TASK 25-28-05-400-801			401	ARO ALL
<u>CENTER STOWAGE BIN DIAGONAL BRACE</u>	25-28-06		401	ARO ALL
Center Stowage Bin Diagonal Brace Removal TASK 25-28-06-000-801			401	ARO ALL
Center Stowage Bin Diagonal Brace Installation TASK 25-28-06-400-801			401	ARO ALL
<u>OVERHEAD STOWAGE BOX - REMOVAL/INSTALLATION</u>	25-28-07		401	ARO ALL
Overhead Stowage Box Removal TASK 25-28-07-000-801			401	ARO ALL
Overhead Stowage Box Installation TASK 25-28-07-400-801			402	ARO ALL
Overhead Stowage Box Module Removal TASK 25-28-07-000-802			404	ARO ALL
Overhead Stowage Box Module Installation TASK 25-28-07-400-802			405	ARO ALL
<u>CREW REST/ATTENDANT REST DOOR LATCH - REMOVAL/INSTALLATION</u>	25-29-01		401	ARO ALL
Keyed Crew Rest/Attendant Rest Door Latch Removal TASK 25-29-01-000-801			401	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
Keyed Crew Rest/Attendant Rest Door Latch Installation TASK 25-29-01-400-802			402	ARO ALL
<u>CREW/ATTENDANT REST DOOR LATCH - ADJUSTMENT/TEST</u>	25-29-01		501	ARO ALL
Crew / Attendant Rest Door Latch Adjustment TASK 25-29-01-700-801			501	ARO ALL
<u>DOOR 1 LEFT FLIGHT CREW REST - REMOVAL/INSTALLATION</u>	25-29-03		401	ARO ALL
Flight Crew Rest Removal TASK 25-29-03-000-801			401	ARO ALL
Flight Crew Rest Installation TASK 25-29-03-400-801			403	ARO ALL
Flight Crew Rest Disassemble TASK 25-29-03-000-802			406	ARO ALL
Flight Crew Rest Assemble TASK 25-29-03-400-802			407	ARO ALL
<u>CREW REST-BUNKS AND FURNISHING-INSPECTION/CHECK</u>	25-29-25		601	ARO ALL
Crew Rest-Bunks and Furnishings- Inspection/Check TASK 25-29-25-210-801			601	ARO ALL
<u>GALLEY SYSTEMS - ADJUSTMENT/TEST</u>	25-31-00		501	ARO ALL
Galley Potable Water - Leak Test TASK 25-31-00-700-810			501	ARO ALL
Galley Light Operational Test TASK 25-31-00-700-811			501	ARO ALL
<u>GALLEY SYSTEMS - INSPECTION/CHECK</u>	25-31-00		601	ARO ALL
Inspect the Galley TASK 25-31-00-200-802			601	ARO ALL
<u>FORWARD GALLEY - MAINTENANCE PRACTICES</u>	25-31-01	1	201	ARO ALL
Forward Galley - Deactivation TASK 25-31-01-040-801-001		1	201	ARO ALL
Forward Galley - Activation TASK 25-31-01-440-801-001		1	202	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>FORWARD GALLEY - REMOVAL/INSTALLATION</u>	25-31-01		401	ARO ALL
Forward Fixed Galley Removal TASK 25-31-01-000-821			401	ARO ALL
Forward Fixed Galley Installation TASK 25-31-01-400-821			404	ARO ALL
<u>MID GALLEY - MAINTENANCE PRACTICES</u>	25-31-02	1	201	ARO ALL
Mid Galley - Deactivation TASK 25-31-02-040-801-001		1	201	ARO ALL
Mid Galley - Activation TASK 25-31-02-440-801-001		1	203	ARO ALL
<u>MID GALLEY - REMOVAL/INSTALLATION</u>	25-31-02		401	ARO ALL
Mid Galley Removal TASK 25-31-02-000-805			401	ARO ALL
Mid Galley Installation TASK 25-31-02-400-805			407	ARO ALL
<u>AFT GALLEY - MAINTENANCE PRACTICES</u>	25-31-03		201	ARO ALL
Aft Galley - Deactivation TASK 25-31-03-040-801			201	ARO ALL
Aft Galley - Activation TASK 25-31-03-440-801			202	ARO ALL
Aft Galley Disassembly TASK 25-31-03-000-803			203	ARO ALL
Aft Galley Assembly TASK 25-31-03-400-803			204	ARO ALL
<u>AFT GALLEY - REMOVAL/INSTALLATION</u>	25-31-03		401	ARO ALL
Aft Fixed Galley Removal TASK 25-31-03-000-804			401	ARO ALL
Aft Fixed Galley Installation TASK 25-31-03-400-804			405	ARO ALL
Aft Flexible Galley - Removal TASK 25-31-03-000-805			422	ARO ALL
Aft Flexible Galley Installation TASK 25-31-03-400-805			425	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>GALLEY SEALANT - REMOVAL/INSTALLATION</u>	25-31-09			401	ARO ALL
Main Deck Galley Sealing TASK 25-31-09-390-801				401	ARO ALL
<u>GALLEY WASTE ENCLOSURE - INSPECTION/CHECK</u>	25-31-11			601	ARO ALL
Inspect the Galley Waste Enclosure TASK 25-31-11-200-801				601	ARO ALL
<u>ESPRESSO MACHINE - REMOVAL/INSTALLATION</u>	25-32-03	2		401	ARO ALL
Espresso Machine Removal TASK 25-32-03-000-804-002		2		401	ARO ALL
Espresso Machine Installation TASK 25-32-03-400-803-002		2		402	ARO ALL
<u>ESPRESSO MACHINE - ADJUSTMENT/TEST</u>	25-32-03	2		501	ARO ALL
Espresso Machine Operational Test TASK 25-32-03-700-802-002		2		501	ARO ALL
<u>OVERHEAD GALLEY AIR CHILLER - REMOVAL/INSTALLATION</u>	25-33-01			401	ARO ALL
Overhead Galley Air Chiller Removal TASK 25-33-01-000-801				401	ARO ALL
Overhead Galley Air Chiller Installation TASK 25-33-01-400-801				402	ARO ALL
<u>LOWER LOBE AIR CHILLER (FOR THE AFT GALLEY) - REMOVAL/INSTALLATION</u>	25-33-03			401	ARO ALL
Lower Lobe Air Chiller Removal TASK 25-33-03-000-801				401	ARO ALL
Lower Lobe Air Chiller Installation TASK 25-33-03-400-801				402	ARO ALL
<u>CHILLER AIR FILTER - CLEANING/PAINTING</u>	25-33-09			701	ARO ALL
Chiller Air Filter Cleaning TASK 25-33-09-100-801				701	ARO ALL
<u>GALLEY AIR CHILLER - ADJUSTMENT/TEST</u>	25-33-97			501	ARO ALL
Galley Air Chiller Operational Test TASK 25-33-97-700-801				501	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>LAVATORY - REMOVAL/INSTALLATION</u>	25-41-01		401	ARO ALL
Lavatory Removal TASK 25-41-01-000-801			401	ARO ALL
Lavatory Installation TASK 25-41-01-400-801			405	ARO ALL
<u>LAVATORY WASTE COMPARTMENT - INSPECTION/CHECK</u>	25-41-08		601	ARO ALL
Lavatory Waste Compartment Inspection TASK 25-41-08-200-801			601	ARO ALL
<u>LAVATORY WASTE COMPARTMENT FLAP - ADJUSTMENT/TEST</u>	25-41-09		501	ARO ALL
Lavatory Waste Flap Adjustment TASK 25-41-09-200-801			501	ARO ALL
<u>LOWER LOBE CARGO COMPARTMENT - INSPECTION/CHECK</u>	25-52-00		601	ARO ALL
Liner Inspection TASK 25-52-00-210-801			601	ARO ALL
Tiedown Fitting Inspection TASK 25-52-00-210-802			603	ARO ALL
<u>CARGO COMPARTMENT - CLEANING/PAINTING</u>	25-52-00		701	ARO ALL
Cargo Compartment Cleaning TASK 25-52-00-100-801			701	ARO ALL
<u>FIBERGLASS LINER - REPAIRS</u>	25-52-01		801	ARO ALL
Cargo Door Liner Tape Repairs TASK 25-52-01-300-803			801	ARO ALL
Cargo Compartment Ceiling and Sidewall Liner Tape Repairs TASK 25-52-01-300-804			802	ARO ALL
Fiberglass Liner Repair TASK 25-52-01-300-801			803	ARO ALL
<u>NEOPRENE-COATED LINER - REPAIRS</u>	25-52-02		801	ARO ALL
Neoprene-Coated Liner Repair TASK 25-52-02-340-801			801	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>BULK CARGO COMPARTMENT CARGO NET - REMOVAL/INSTALLATION</u>	25-52-03		401	ARO ALL
Bulk Cargo Compartment Cargo Net - Removal TASK 25-52-03-000-801			401	ARO ALL
Bulk Cargo Compartment Cargo Net - Installation TASK 25-52-03-400-801			403	ARO ALL
<u>HONEYCOMB PANEL - REPAIRS</u>	25-52-04		801	ARO ALL
Honeycomb Panel Repair TASK 25-52-04-300-801			801	ARO ALL
<u>SIDEWALL LINERS - REMOVAL/INSTALLATION</u>	25-52-06		401	ARO ALL
Sidewall Liner Removal TASK 25-52-06-000-801			401	ARO ALL
Sidewall Liner Installation TASK 25-52-06-400-801			403	ARO ALL
<u>DECOMPRESSION PANEL - INSPECTION/CHECK</u>	25-52-08		601	ARO ALL
Decompression Panel Inspection TASK 25-52-08-200-801			601	ARO ALL
<u>CEILING LINER - REMOVAL/INSTALLATION</u>	25-52-09		401	ARO ALL
Ceiling Liner Removal TASK 25-52-09-000-801			401	ARO ALL
Ceiling Liner - Installation TASK 25-52-09-400-801			403	ARO ALL
<u>FLOOR PANELS AND WALKWAYS - REMOVAL/INSTALLATION</u>	25-52-10		401	ARO ALL
Floor Panels and Walkways Removal TASK 25-52-10-000-801			401	ARO ALL
Floor Panels and Walkways Installation TASK 25-52-10-400-801			402	ARO ALL
<u>BULK CARGO FLOOR - REMOVAL/INSTALLATION</u>	25-52-11		401	ARO ALL
Bulk Cargo Floor Removal TASK 25-52-11-000-801			401	ARO ALL
Bulk Cargo Floor Installation TASK 25-52-11-400-801			402	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>MAIN EQUIPMENT CENTER BULKHEAD LINER - REMOVAL/INSTALLATION</u>	25-52-16		401	ARO ALL
Access Door Removal TASK 25-52-16-000-801			401	ARO ALL
Access Door Installation TASK 25-52-16-400-801			402	ARO ALL
Panel Removal TASK 25-52-16-000-802			406	ARO ALL
Panel Installation TASK 25-52-16-400-802			407	ARO ALL
<u>FORWARD CARGO COMPARTMENT AFT END WALL - REMOVAL/INSTALLATION</u>	25-52-17		401	ARO ALL
Forward Cargo Compartment Aft End Wall Removal TASK 25-52-17-000-801			401	ARO ALL
Forward Cargo Compartment Aft End Wall Installation TASK 25-52-17-400-801			402	ARO ALL
<u>AFT CARGO COMPARTMENT- FORWARD END WALL - REMOVAL/INSTALLATION</u>	25-52-18		401	ARO ALL
Aft Cargo Compartment Forward End Wall Removal TASK 25-52-18-000-801			401	ARO ALL
Aft Cargo Compartment Forward End Wall Installation TASK 25-52-18-400-801			402	ARO ALL
<u>BULK CARGO COMPARTMENT - AFT END WALL - REMOVAL/INSTALLATION</u>	25-52-19		401	ARO ALL
Bulk Cargo Compartment Aft End Wall Removal TASK 25-52-19-000-801			401	ARO ALL
Bulk Cargo Compartment Aft End Wall Installation TASK 25-52-19-400-801			402	ARO ALL
<u>WASTE TANK ENCLOSURE PANELS - REMOVAL/INSTALLATION</u>	25-52-20		401	ARO ALL
Waste Tank Enclosure Panels Removal TASK 25-52-20-000-801			401	ARO ALL

25-CONTENTS



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 25
EQUIPMENT/FURNISHINGS**

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
Waste Tank Enclosure Panels Installation TASK 25-52-20-400-801			402	ARO ALL
<u>CARGO HANDLING SYSTEM - MAINTENANCE PRACTICES</u>	25-53-00		201	ARO ALL
Forward Cargo Handling System - Deactivation TASK 25-53-00-040-801			201	ARO ALL
Aft Cargo Handling System - Deactivation TASK 25-53-00-040-802			205	ARO ALL
Forward Cargo Handling System - Activation TASK 25-53-00-400-801			209	ARO ALL
Aft Cargo Handling System - Activation TASK 25-53-00-840-811			211	ARO ALL
<u>CARGO HANDLING SYSTEM - ADJUSTMENT/TEST</u>	25-53-00	3	501	ARO ALL
Prepare for the Test TASK 25-53-00-840-805-003		3	501	ARO ALL
Controller Power Test TASK 25-53-00-700-814-003		3	508	ARO ALL
Lateral Guide Test TASK 25-53-00-700-815-003		3	512	ARO ALL
Left PDU Test TASK 25-53-00-700-816-003		3	520	ARO ALL
Right PDU Test TASK 25-53-00-700-817-003		3	533	ARO ALL
PDU Bay Off and PDU Up and Braked Test TASK 25-53-00-700-818-003		3	542	ARO ALL
Interlock Test TASK 25-53-00-700-819-003		3	553	ARO ALL
Put the Airplane Back to Its Usual Condition TASK 25-53-00-840-806-003		3	559	ARO ALL
<u>POWER DRIVE UNIT - MAINTENANCE PRACTICES</u>	25-53-01		201	ARO ALL
Power Drive Unit - Cleaning TASK 25-53-01-160-801			201	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

		CHAPTER SECTION			
<u>SUBJECT</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>		<u>EFFECT</u>
<u>POWERED DRIVE UNIT - REMOVAL/INSTALLATION</u>	25-53-01		401		ARO ALL
Powered Drive Unit - Removal TASK 25-53-01-000-801			401		ARO ALL
Powered Drive Unit - Installation TASK 25-53-01-400-801			403		ARO ALL
PDU Roller Replacement TASK 25-53-01-000-802			413		ARO ALL
<u>BALL PANEL - REMOVAL/INSTALLATION</u>	25-53-02		401		ARO ALL
Ball Panel Removal TASK 25-53-02-000-801			401		ARO ALL
Ball Panel Installation TASK 25-53-02-400-801			402		ARO ALL
Ball Transfer Unit Removal TASK 25-53-02-000-802			402		ARO ALL
Ball Transfer Unit Installation TASK 25-53-02-400-802			403		ARO ALL
<u>ROLLER TRAY - REMOVAL/INSTALLATION</u>	25-53-03		401		ARO ALL
Roller Tray - Removal TASK 25-53-03-000-801			401		ARO ALL
Roller Tray - Installation TASK 25-53-03-400-801			402		ARO ALL
<u>END STOP - REMOVAL/INSTALLATION</u>	25-53-04		401		ARO ALL
End Stop Removal TASK 25-53-04-000-801			401		ARO ALL
End Stop Installation TASK 25-53-04-400-801			402		ARO ALL
<u>ROLLOUT STOP/LOCK - REMOVAL/INSTALLATION</u>	25-53-11	3	401		ARO ALL
Rollout Stop/Lock Removal TASK 25-53-11-000-805-003		3	401		ARO ALL
Rollout Stop/Lock Installation TASK 25-53-11-400-805-003		3	402		ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>GUIDE ROLLER ASSEMBLY - REMOVAL/INSTALLATION</u>	25-53-12		401	ARO ALL
Guide Roller Assembly Removal TASK 25-53-12-000-801			401	ARO ALL
Guide Roller Assembly Installation TASK 25-53-12-400-801			402	ARO ALL
<u>RETRACTABLE GUIDE ROLLER/LOCK - REMOVAL/INSTALLATION</u>	25-53-13	3	401	ARO ALL
Retractable Guide Roller/Lock Removal TASK 25-53-13-000-805-003		3	401	ARO ALL
Retractable Guide Roller/Lock Installation TASK 25-53-13-400-805-003		3	402	ARO ALL
<u>SILL ROLLER ASSEMBLY - REMOVAL/INSTALLATION</u>	25-53-14		401	ARO ALL
Sill Roller Assembly Removal TASK 25-53-14-000-801			401	ARO ALL
Sill Roller Assembly Installation TASK 25-53-14-400-801			402	ARO ALL
<u>SIDE GUIDE RAIL - REMOVAL/INSTALLATION</u>	25-53-21		401	ARO ALL
Side Guide Rail Removal TASK 25-53-21-000-801			401	ARO ALL
Side Guide Rail Installation TASK 25-53-21-400-801			402	ARO ALL
<u>CENTER AND AUXILIARY GUIDE - REMOVAL/INSTALLATION</u>	25-53-22	3	401	ARO ALL
Center Guide Removal TASK 25-53-22-000-809-003		3	401	ARO ALL
Center Guide Installation TASK 25-53-22-400-809-003		3	402	ARO ALL
<u>LATERAL GUIDE - REMOVAL/INSTALLATION</u>	25-53-23		401	ARO ALL
Lateral Guide Removal TASK 25-53-23-000-801			401	ARO ALL
Lateral Guide Installation TASK 25-53-23-400-801			402	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
Lateral Guide Actuator Removal TASK 25-53-23-000-802			409	ARO ALL
Lateral Guide Actuator Installation TASK 25-53-23-400-802			410	ARO ALL
<u>CENTER AND AUXILIARY STOP/LOCK - REMOVAL/INSTALLATION</u>	25-53-24	3	401	ARO ALL
Center Stop/Lock Removal TASK 25-53-24-000-809-003		3	401	ARO ALL
Center Stop/Lock Installation TASK 25-53-24-400-809-003		3	402	ARO ALL
<u>PARTIAL LOAD STOP - REMOVAL/INSTALLATION</u>	25-53-25		401	ARO ALL
Partial Load Stop Removal TASK 25-53-25-000-801			401	ARO ALL
Partial Load Stop Installation TASK 25-53-25-400-801			402	ARO ALL
<u>PALLET LOCK - REMOVAL/INSTALLATION</u>	25-53-26		401	ARO ALL
Pallet Lock Removal TASK 25-53-26-000-801			401	ARO ALL
Pallet Lock Installation TASK 25-53-26-400-801			402	ARO ALL
<u>STOP/LOCK - REMOVAL/INSTALLATION</u>	25-53-27		401	ARO ALL
Stop/Lock Removal TASK 25-53-27-000-801			401	ARO ALL
Stop/Lock Installation TASK 25-53-27-400-801			402	ARO ALL
<u>CARGO HANDLING CONTROL PANEL - REMOVAL/INSTALLATION</u>	25-53-31		401	ARO ALL
Cargo Handling Control Panel Removal TASK 25-53-31-000-801			401	ARO ALL
Cargo Handling Control Panel Installation TASK 25-53-31-400-801			402	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	CHAPTER SECTION	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>CARGO CONTROL JOYSTICK - REMOVAL/INSTALLATION</u>		25-53-32		401	ARO ALL
Cargo Control Joystick Removal TASK 25-53-32-000-802				401	ARO ALL
Cargo Control Joystick Installation TASK 25-53-32-400-802				402	ARO ALL
<u>CARGO SYSTEM CONTROLLER - REMOVAL/INSTALLATION</u>		25-53-33	3	401	ARO ALL
Cargo System Controller (CSC) Removal TASK 25-53-33-000-804-003			3	401	ARO ALL
Cargo System Controller (CSC) Installation TASK 25-53-33-400-804-003			3	402	ARO ALL
<u>OVER-WING LIFELINE - MAINTENANCE PRACTICES</u>		25-61-01		201	ARO ALL
Overwing Emergency Exit Door - Lifeline Removal TASK 25-61-01-000-801				201	ARO ALL
Overwing Emergency Exit Door - Lifeline Installation TASK 25-61-01-400-801				204	ARO ALL
Overwing Emergency Exit Door - Lifeline General Visual Check TASK 25-61-01-200-802				205	ARO ALL
Overwing Emergency Exit Door - Detailed Lifeline Check TASK 25-61-01-200-801				206	ARO ALL
<u>ESCAPE ROPES - MAINTENANCE PRACTICES</u>		25-61-02		201	ARO ALL
Escape Rope Removal TASK 25-61-02-000-801				201	ARO ALL
Escape Rope Installation TASK 25-61-02-400-801				201	ARO ALL
Escape Rope Inspection TASK 25-61-02-210-801				202	ARO ALL
<u>LIFE VESTS - MAINTENANCE PRACTICES</u>		25-62-01		201	ARO ALL
Life Vest Inspection TASK 25-62-01-200-801				201	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
Flotation Cot Replacement TASK 25-62-01-960-801			204	ARO ALL
<u>PORTABLE EMERGENCY LOCATOR TRANSMITTER - MAINTENANCE PRACTICES</u>	25-63-01		201	ARO ALL
Portable Emergency Locator Transmitter (ELT) - Removal TASK 25-63-01-020-801			201	ARO ALL
Portable Emergency Locator Transmitter (ELT) - Installation TASK 25-63-01-420-801			201	ARO ALL
<u>EMERGENCY EVACUATION SIGNAL SYSTEM - MAINTENANCE PRACTICES</u>	25-63-02		201	ARO ALL
Emergency Evacuation Signal System Operational Test TASK 25-63-02-700-801			201	ARO ALL
<u>DETACHABLE EMERGENCY EQUIPMENT - MAINTENANCE PRACTICES</u>	25-64-01		201	ARO ALL
Protective Breathing Equipment (Smokehood) Inspection TASK 25-64-01-200-801			201	ARO ALL
Smoke Hood Replacement TASK 25-64-01-960-801			205	ARO ALL
Detachable Emergency Equipment Visual Check TASK 25-64-01-210-801			205	ARO ALL
Flashlight Operational Test TASK 25-64-01-710-801			205	ARO ALL
Flashlight Battery Replacement TASK 25-64-01-960-802			208	ARO ALL
Life Raft Inspection TASK 25-64-01-200-804			209	ARO ALL
Life Raft Restoration TASK 25-64-01-960-803			209	ARO ALL
<u>SAFETY EQUIPMENT - INSPECTION/CHECK</u>	25-64-01		601	ARO ALL
Crash Axe - Inspection/Check TASK 25-64-01-200-805			601	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>MEGAPHONE - MAINTENANCE PRACTICES</u>	25-64-02		201	ARO ALL
Megaphone Operational Test TASK 25-64-02-710-801			201	ARO ALL
Megaphone Battery Replacement TASK 25-64-02-960-801			203	ARO ALL
<u>MEDICAL KIT - MAINTENANCE PRACTICES</u>	25-64-50	1	201	ARO ALL
Medical Kit Replacement TASK 25-64-50-960-802		1	201	ARO ALL
<u>FIRST AID KIT - INSPECTION/CHECK</u>	25-64-50	2	601	ARO ALL
First Aid Kit Examination TASK 25-64-50-200-803		2	601	ARO ALL
<u>AUTOMATED EXTERNAL DEFIBRILLATOR - REMOVAL/INSTALLATION</u>	25-64-53		401	ARO ALL
Automated External Defibrillator Removal TASK 25-64-53-020-801			401	ARO ALL
Automated External Defibrillator Installation TASK 25-64-53-420-801			401	ARO ALL
<u>OFF-WING ESCAPE SYSTEM - MAINTENANCE PRACTICES</u>	25-65-00		201	ARO ALL
Off-Wing Escape System - Deactivation TASK 25-65-00-040-802			201	ARO ALL
Off-Wing Escape System - Activation TASK 25-65-00-440-802			207	ARO ALL
Disarm the Off-Wing Escape System TASK 25-65-00-040-801			209	ARO ALL
Arm the Off-Wing Escape System TASK 25-65-00-440-801			211	ARO ALL
Release the Gas From the Inflation Bottle for the Off-Wing Escape Slide TASK 25-65-00-870-801			213	ARO ALL
Put the Off-Wing Escape System Back to its Initial Condition after Deployment TASK 25-65-00-840-801			214	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>OFF-WING ESCAPE SYSTEM - ADJUSTMENT/TEST</u>	25-65-00		501	ARO ALL
Off-Wing Escape System - Operational Test (Slide Will Inflate) TASK 25-65-00-840-802			501	ARO ALL
Off-Wing Escape Slide Mechanism - System Test (Using Tool J25016-1) TASK 25-65-00-710-801			504	ARO ALL
Off-Wing Escape Slide Mechanism - System Test (Using Tool J25009-1) TASK 25-65-00-710-802			516	ARO ALL
<u>OFF-WING ESCAPE SLIDE PACK - REMOVAL/INSTALLATION</u>	25-65-01		401	ARO ALL
Escape Slide Pack Removal TASK 25-65-01-000-801			401	ARO ALL
Escape Slide Pack Installation TASK 25-65-01-400-801			402	ARO ALL
<u>INFLATION BOTTLE FOR THE OFF-WING ESCAPE SLIDE - REMOVAL/INSTALLATION</u>	25-65-02		401	ARO ALL
Inflation Bottle for the Off-Wing Escape Slide - Removal TASK 25-65-02-000-801			401	ARO ALL
Inflation Bottle for the Off-Wing Escape Slide - Installation TASK 25-65-02-400-801			404	ARO ALL
<u>OFF-WING ESCAPE SLIDE INFLATION BOTTLE - INSPECTION/CHECK</u>	25-65-02		601	ARO ALL
Inflation Bottle Pressure Check TASK 25-65-02-200-801			601	ARO ALL
<u>OFF-WING ESCAPE SLIDE COMPARTMENT DOOR - MAINTENANCE PRACTICES</u>	25-65-10		201	ARO ALL
Open the Escape Slide Compartment Door TASK 25-65-10-010-801			201	ARO ALL
Close the Escape Slide Compartment Door TASK 25-65-10-400-801			202	ARO ALL

25-CONTENTS



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 25
EQUIPMENT/FURNISHINGS**

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>OFF-WING ESCAPE SLIDE COMPARTMENT DOOR - REMOVAL/INSTALLATION</u>	25-65-10		401	ARO ALL
Escape Slide Compartment Door Removal TASK 25-65-10-000-801			401	ARO ALL
Escape Slide Compartment Door Installation TASK 25-65-10-400-802			401	ARO ALL
<u>OFF-WING ESCAPE SLIDE COMPARTMENT DOOR LATCH ACTUATOR - REMOVAL/INSTALLATION</u>	25-65-11		401	ARO ALL
Latch Actuator Removal TASK 25-65-11-000-801			401	ARO ALL
Latch Actuator Installation TASK 25-65-11-400-801			402	ARO ALL
<u>OFF-WING ESCAPE SLIDE PACK COVER LACING RELEASE CABLE - REMOVAL/INSTALLATION</u>	25-65-12		401	ARO ALL
Cover Lacing Release Cable Removal TASK 25-65-12-000-801			401	ARO ALL
Cover Lacing Release Cable Installation TASK 25-65-12-400-801			402	ARO ALL
<u>OFF-WING ESCAPE SLIDE COMPARTMENT DOOR LATCH TORQUE TUBE - REMOVAL/INSTALLATION</u>	25-65-13		401	ARO ALL
Latch Torque Tube Removal TASK 25-65-13-000-801			401	ARO ALL
Latch Torque Tube Installation TASK 25-65-13-400-801			402	ARO ALL
<u>DOOR-MOUNTED ESCAPE SYSTEM - MAINTENANCE PRACTICES</u>	25-66-00		201	ARO ALL
Door-Mounted Escape System Restoration TASK 25-66-00-840-801			201	ARO ALL
Door-Mounted Escape System - Deactivation TASK 25-66-00-040-801			207	ARO ALL
Door-Mounted Escape System - Activation TASK 25-66-00-840-803			210	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>DOOR-MOUNTED ESCAPE SYSTEM - ADJUSTMENT/TEST</u>		25-66-00		501	ARO ALL
Door-Mounted Escape System Operational Test TASK 25-66-00-840-802				501	ARO ALL
<u>DOOR-MOUNTED ESCAPE SLIDE PACK - REMOVAL/INSTALLATION</u>		25-66-01		401	ARO ALL
Door-Mounted Escape Slide Pack Removal TASK 25-66-01-000-801				401	ARO ALL
Door-Mounted Escape Slide Pack Installation TASK 25-66-01-400-801				403	ARO ALL
Escape Slide Pack - Girt Material Stowage TASK 25-66-01-820-801				405	ARO ALL
<u>DOOR-MOUNTED ESCAPE SLIDE PACK - INSPECTION/CHECK</u>		25-66-01		601	ARO ALL
Door-Mounted Escape Slide Pack Inflation Cylinder Check TASK 25-66-01-200-801				601	ARO ALL
<u>BUSTLE - REMOVAL/INSTALLATION</u>		25-66-06		401	ARO ALL
Bustle Removal TASK 25-66-06-000-801				401	ARO ALL
Bustle Installation TASK 25-66-06-400-801				401	ARO ALL
<u>INSULATION - REMOVAL/INSTALLATION</u>		25-80-00		401	ARO ALL
Insulation Blanket Removal TASK 25-80-00-000-801				401	ARO ALL
Insulation Blanket - Installation TASK 25-80-00-400-801				402	ARO ALL
<u>INSULATION - INSPECTION/CHECK</u>		25-80-00		601	ARO ALL
Passenger Compartment Insulation and Moisture Control Check TASK 25-80-00-200-801				601	ARO ALL
Flight Compartment Insulation and Moisture Control Check TASK 25-80-00-200-802				604	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 25
EQUIPMENT/FURNISHINGS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
Cargo Compartment Insulation and Moisture Control Check TASK 25-80-00-200-803			607	ARO ALL
<u>INSULATION - REPAIRS</u>	25-80-00		801	ARO ALL
Repair of the Insulation Blanket that has BMS8-396 Cover Material TASK 25-80-00-340-809			801	ARO ALL
Repair of the Insulation Blanket that has BMS8-380 Cover Material TASK 25-80-00-340-810			805	ARO ALL
Insulation Blanket Manufacturing TASK 25-80-00-340-806			809	ARO ALL
Moisture Damaged Insulation Blanket Repair TASK 25-80-00-340-804			825	ARO ALL

25-CONTENTS



777-200/300
AIRCRAFT MAINTENANCE MANUAL

EQUIPMENT AND FURNISHINGS - CLEANING/PAINTING

1. General

- A. This procedure has these tasks:
 - (1) Instructions to clean the equipment and furnishings.
 - (2) Instructions to paint the equipment and furnishings.
- B. The decorative surfaces in the airplane are made of different materials. Some of the materials are:
 - (1) Tedlar
 - (2) Polycarbonate (Lexan)
 - (3) Fabrics
 - (4) Silicone
 - (5) Rubber
 - (6) Metal
 - (7) ULTEM
 - (8) Radel
 - (9) Declar.
- C. It is necessary to paint the equipment when the surface finish is damaged. Apply the paint with a paint sprayer, a hand brush, or an air brush.
- D. Make sure the area you want to repair is smaller than 100 square inches. If the area is larger than 100 square inches, you must replace the part
- E. You must apply a surface finish that is equivalent to the initial surface finish.
- F. There must be no visual difference between the initial surface finish and the new surface finish.
- G. All cleaning materials should meet the requirements of D6-7127, Cleaning Interiors of Commercial Transport Aircraft.

TASK 25-00-00-100-801

2. Equipment and Furnishings Cleaning

A. General

- (1) Make sure you do not get the clean surfaces dirty when you clean the adjacent surfaces.
- (2) The procedures are in groups as follows:
NOTE: Each group contains equivalent types of materials that you clean with the same detergents and procedures.
 - (a) Opaque plastic and painted surfaces
 - (b) Tedlar-covered surfaces
 - (c) Mirrors
 - (d) Fabrics
 - (e) Carpets
 - (f) Leather and naugahyde
 - (g) Floor coverings
 - (h) Silicone seals
 - (i) Bare metal surfaces

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 701
May 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL

(j) Hard non-porous surfaces.



WARNING

OBEY THE INSTRUCTIONS FROM INDUSTRIAL HYGIENE, FIRE AND SAFETY ORGANIZATIONS FOR THE FACILITIES, EQUIPMENT, VENTILATION, AND PROCEDURES NECESSARY FOR SAFE OPERATIONS WHEN YOU CLEAN THE AIRPLANE. THE MATERIALS YOU USE ARE POISONOUS AND FLAMMABLE. IF THE CORRECT PROCEDURES ARE NOT USED, INJURY OR DAMAGE CAN OCCUR.



WARNING

DO NOT GET SOLVENTS IN YOUR MOUTH, YOUR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. SOLVENTS ARE DANGEROUS MATERIALS. SOLVENTS CAN BE FLAMMABLE. OBEY THE MATERIAL SAFETY DATA SHEETS (MSDS) FOR SOLVENTS. OBEY LOCAL REGULATIONS FOR THE CORRECT PROCEDURES TO USE OR DISCARD SOLVENTS. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.



CAUTION

DO NOT USE SOLVENTS, DETERGENTS, OR CLEANERS OTHER THAN THOSE SPECIFIED. IF YOU USE MATERIALS THAT ARE NOT SPECIFIED, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (3) Use a polyethylene bottle (500ml), STD-1104 or a spray paint spray gun with interchangeable nozzles, STD-1133 for the water and for the detergent.
- (4) Use a polyethylene bottle (500ml), STD-1104 with a nozzle for the solvents.
- (5) Attach metal tags to all the polyethylene bottle (500ml), STD-1104 and spray paint spray gun with interchangeable nozzles, STD-1133 to identify their contents.

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-2477	Tools - Vacuum Cleaner Set Part #: AVQ250-2 Supplier: 03FQ4 Opt Part #: 02146A Supplier: 0A5X2 Opt Part #: 44SPEC Supplier: 0Y8U0 Opt Part #: 655406-7M Supplier: 0Y8U0 Opt Part #: C-39485-41 Supplier: 16893 Opt Part #: R80 Supplier: \$0373 Opt Part #: WD80 Supplier: \$0373
STD-123	Brush - Soft Bristle
STD-1064	Scraper - Phenolic, Hard Resin
STD-1104	Bottle - HDPE Polyethylene, Capacity 500ml, with LDPE Polyethylene Internal Plug and Self Seal Polypropylene Screw Cap
STD-1133	Gun - Spray, Paint, with Interchangeable Nozzles
STD-1298	Cleaner - Carpet, Vacuum Extraction (Steam Cleaner)

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 702
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

C. Consumable Materials

Reference	Description	Specification
B00015	Cleaner - Heavy Duty, Multipurpose - Calla 301A	BAC5744, AMS 1526-A, AMS 1550-A
B00032	Cleaner - Glass - GLYST A-1859	
B00062	Solvent - Acetone (99.5% Grade)	ASTM D 329 (Supersedes O-A-51)
B00068	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002, MIL-E-51454 Type II
B00081	Solvent - Trichloroethylene	BMS11-6, ASTM D4080
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
B00090	Solvent - Inhibited Trichloroethane 1,1,1	MIL-T-81533
B00093	Solvent - Tetrachloroethylene (Perchloroethylene)	ASTM D4081
B00130	Alcohol - Isopropyl	TT-I-735
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B00460	Cleaner - Multi-Purpose - Winsol APC-120-WX	
B00541	Cleaner - General Purpose Household Detergent	
B00634	Solvent - Stabilized Limonene Cleaner	BMS11-10 Type 1, 2, or 3
B00641	Cleaner - Aircraft (Interior And Exterior) - Turco 5948	
B00700	Polish - Aluminum, Met-All	
B50004	Solvent - Cleaning - Vertrel XF	BAC5402
B50005	Solvent - Cleaning - Vertrel MCA	BAC5402
B50280	Cleaner - Zip-Chem Products Calla 1452 Disinfectant	
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00116	Sponge - Synthetic	
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Prepare to Clean

SUBTASK 25-00-00-110-017

- (1) Do the applicable step to mix the cleaner that you will use:
 - (a) Mix one part of Turco 5948 cleaner, B00641 to 20 part of water (by volume).
 - (b) Mix one part of Winsol APC-120-WX cleaner, B00460 to 32 parts of water (by volume).
 - (c) Mix one part of Calla 301A cleaner, B00015 to 3 parts water (by volume).

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 703
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

F. Clean the Opaque Plastic and Painted Surfaces

NOTE: Use foam and a vacuum cleaner to remove the unwanted materials from perforated or acoustic surfaces. If you cannot use foam and a vacuum cleaner, use moist cloths or sponges. If the cloths are soaked, too much fluid will go through the perforations and openings.

SUBTASK 25-00-00-110-001



DO NOT RUB SOLID-COLORED TEDLAR SURFACES WHEN THEY ARE DRY. PARTICLES CAN GET PUSHED INTO THE SURFACE OF THE MATERIAL, AND IT IS DIFFICULT TO GET THE SURFACES CLEAN IF THAT OCCURS.

- (1) To clean a small area on the surface, do the steps that follow:
 - (a) Lift the loose unwanted material with a cotton wiper, G00034.

NOTE: Do not rub, spread, or push the unwanted material into textured or perforated surfaces, joints or seams.
 - (b) Apply general purpose household detergent cleaner, B00541 to the dirty area with a polyethylene bottle (500ml), STD-1104 or a moist sponge, G00116.
 - (c) Lightly rub the area with a cotton wiper, G00034.
 - (d) For textured surfaces, remove the unwanted materials from recesses with a soft bristle brush, STD-123.
 - (e) Remove the general purpose household detergent cleaner, B00541 with a sponge, G00116 that is moist with water.
 - (f) Dry the area with a clean cotton wiper, G00034. Rub the area in a straight line movement. If the area stays dirty, do the steps that follow:



DO NOT GET ALIPHATIC NAPHTHA OR CITRA SAFE IN YOUR MOUTH, OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM ALIPHATIC NAPHTHA OR CITRA SAFE. PUT ON PROTECTIVE SPLASH GOGGLES AND GLOVES WHEN YOU USE ALIPHATIC NAPHTHA OR CITRA SAFE. KEEP ALIPHATIC NAPHTHA OR CITRA SAFE AWAY FROM SPARKS, FLAME, AND HEAT. ALIPHATIC NAPHTHA IS A POISONOUS AND FLAMMABLE SOLVENT WHICH CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- 1) Carefully rub the dirty area with a cotton wiper, G00034 that is moist with solvent, B00083 or Limonene solvent, B00634.
- 2) Do the steps above again to remove the solvent, B00083 or Limonene solvent, B00634 with a general purpose household detergent cleaner, B00541.

SUBTASK 25-00-00-110-032

- (2) To clean all of the surface, do the steps that follow:
 - (a) Apply a Turco 5948 cleaner, B00641 to the surface with a sponge, G00116 or a spray polyethylene bottle (500ml), STD-1104.
 - (b) Let the Turco 5948 cleaner, B00641 stay on the surface for one-half to two minutes.
 - (c) Rub the surface with a cotton wiper, G00034 that is moist with clean water.
 - (d) Remove the Turco 5948 cleaner, B00641 with a clean cotton wiper, G00034 that is soaked with clean water.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 704
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (e) Dry the surface with a clean, dry cotton wiper, G00034.

G. Clean Tedlar-covered Surfaces

SUBTASK 25-00-00-110-002

- (1) To clean the tedlar-covered surface of a part while it is installed in the airplane, do these steps:
 - (a) Apply the Turco 5948 cleaner, B00641 with a soft bristle brush, STD-123. Rub the surface in all directions with the soft bristle brush, STD-123.
 - (b) Remove the Turco 5948 cleaner, B00641 with a sponge, G00116 that is moist with clean water.
 - (c) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-110-003

- (2) To clean the tedlar-covered surface of a part that is out of the airplane, do these steps:
 - (a) Remove or cover with Scotch Flatback Masking Tape 250, G00270 all the plastic and painted parts that are not resistant to solvents.

NOTE: These solvents will remove the paint from the edge of the part.



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- (b) Clean the part with a cotton wiper, G00034 and solvent, B00090 or solvent, B00093.
- (c) If you accidentally removed paint from the part when you used the solvent, do this task: Equipment and Furnishings Painting, TASK 25-00-00-370-801.

H. Clean the Translucent and Transparent Plastic Surfaces

SUBTASK 25-00-00-110-004



DO NOT RUB THE PLASTIC SURFACES WITH A DRY CLOTH. THIS WILL CAUSE SCRATCHES AND AN ELECTROSTATIC CHARGE.

- (1) Rub the surface lightly with a cotton wiper, G00034 that is soaked with a Turco 5948 cleaner, B00641 mixture.

SUBTASK 25-00-00-110-005

- (2) Remove the Turco 5948 cleaner, B00641 mixture with a cotton wiper, G00034 that is moist with water.

SUBTASK 25-00-00-110-006

- (3) Remove a thin dust layer or electrostatic charge with a cotton wiper, G00034 that is moist with water.

I. Clean the Mirrors

SUBTASK 25-00-00-110-007

- (1) To clean the glass mirrors, do these steps:
 - (a) Use a hard resin phenolic scraper, STD-1064 to remove dry paint and other unwanted materials that are not easy to rub off.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 705
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (b) Use GLYST A-1859 cleaner, B00032 to clean the glass.

SUBTASK 25-00-00-110-008



DO NOT RUB THE PLASTIC SURFACES WITH A DRY CLOTH. THIS WILL CAUSE SCRATCHES AND AN ELECTROSTATIC CHARGE.

- (2) To clean the plastic mirrors, do these steps:

- (a) Remove the loose unwanted materials with a clean cotton wiper, G00034.



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- (b) Rub the stains with a cotton wiper, G00034 that is moist with Vertrel XF solvent, B50004, Vertrel MCA solvent, B50005, solvent, B00093, solvent, B00081, alcohol, B00068, or alcohol, B00130.
- (c) Remove the solvent or alcohol with a cotton wiper, G00034 that is moist with water.
- (d) Rub all of the surface very lightly with a cotton wiper, G00034 that is moist with water to remove the sharp particles.
- (e) Apply alcohol, B00130 to the mirror.
- (f) Rub the surface with a clean cotton wiper, G00034 that is moist with water.
- (g) Apply the alcohol, B00130 one more time.
- (h) Polish the plastic with a cotton wiper, G00034 that is moist with water.

J. Clean the Upholstery, and Drapery

NOTE: The upholstery and drapery fabrics are treated with a flame retardant finish. Most flame retardant finishes are removed when the fabric gets very wet. The flame retardant finishes and flammability properties can be maintained for 10 dry cleaning cycles by following the instructions provided by the supplier or follow the instructions below.

NOTE: The flame retardant finishes and flammability properties should be maintained for wool fabrics for 10 dry cleaning cycles by following the instructions provided by the supplier or follow the instructions below.

NOTE: There is no suggested method of applying a fire retardant finish after a wet washing.

SUBTASK 25-00-00-160-001

- (1) Do these steps to clean water based stains from the upholstery and drapery:

NOTE: Water based stains are from tea, coffee, fruit juices, syrup, perfume, vomit, urine, or liqueurs.

- (a) If the fabric has hook-and-loop tape, attach the two parts together.

NOTE: This is done to minimize snags to the fabric and protect the hook part.

- (b) Use a clean cotton wiper, G00034 to dry as much moisture from the stained area as possible.

- 1) If any part of the stain is dry, do these steps:

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 706
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- a) Use a moist cotton wiper, G00034 and a small amount of general purpose household detergent cleaner, B00541 to make the stain soft.
- b) Scrape the unwanted material from the surface with a hard resin phenolic scraper, STD-1064.
- (c) Put a clean cotton wiper, G00034 on a flat surface.
- (d) Put the fabric on the cotton wiper, G00034 with the stain down.
- (e) Working from the back side of the fabric, remove the stain from the fabric with the detergent and a small amount of water.

NOTE: The reason to remove the stain from the back side of the fabric is to eliminate the need to push the stain through the fibers and out the back side.

- 1) Use the minimal amount of water possible to minimize the loss of the fire retardant finish.

SUBTASK 25-00-00-110-018

- (2) Do these steps to clean grease or oil based stains from the upholstery or drapery:

NOTE: Oil based stains are from lipstick, ink, oil, jet fuel, and hydraulic fluid.

- (a) Remove or cover with Scotch Flatback Masking Tape 250, G00270 all the plastic and painted parts that are near the fabric and are not resistant to solvents.
- (b) If the fabric has hook-and-loop tape, attach the two parts together.

NOTE: This is done to minimize snags to the fabric and protect the hook part.

- (c) Use a clean cotton wiper, G00034 to dry as much moisture from the stained area as possible.
- (d) If any part of the stain is dry, do these steps:
 - 1) Use a moist cotton wiper, G00034 and a small amount of solvent, B00090, solvent, B00062, or solvent, B00148 to make the stain soft.
 - 2) Scrape the unwanted material from the surface with a hard resin phenolic scraper, STD-1064.
 - 3) Use a clean cotton wiper, G00034 to remove the dissolved or loosened unwanted material.
- (e) Continue to use a moist cotton wiper, G00034 and a small amount of solvent, B00090, solvent, B00062, or solvent, B00148 to remove the stain.
- (f) Put a clean cotton wiper, G00034 on a flat surface.
- (g) Put the fabric on the cotton wiper, G00034.
- (h) Clean the solvent from the stain area on the fabric with the Turco 5948 cleaner, B00641 and a small amount of water.
 - 1) Use the minimal amount of water possible to minimize the loss of the fire retardant finish.
- (i) Use a soft bristle brush, STD-123 to lift and straighten the fibers.

SUBTASK 25-00-00-110-019

- (3) Do these steps to dry clean the fabric if it is necessary:

NOTE: These steps are applicable to all fabrics and drapery such as curtains, seat cushions, and mattresses.

- (a) Use either of these cleaning methods:

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 707
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 1) Use a 99 % solution of solvent, B00093 and 1% solution of Turco 5948 cleaner, B00641 to dry clean the fabric for 10-12 minutes.
 - 2) Use 100% commercial dry cleaning grade of solvent, B00093 to dry clean the fabric for 10-12 minutes.
- (b) Dry the fabric at no more than 120°F (49°C) for 2-3 minutes.

K. Clean the Carpet

NOTE: Use this procedure if vacuuming is not sufficient to clean the carpet.

NOTE: If the carpet is badly stained or dirty, we recommend that you remove the carpet from the airplane and dry clean it.

SUBTASK 25-00-00-160-014

- (1) Use a vacuum extraction (steam cleaner) carpet cleaner, STD-1298 to clean the carpets. Use a detergent that your carpet manufacturer recommends.

NOTE: This is the type of carpet cleaner that vacuums the water immediately after it is sprayed on the carpet. Use this type of carpet cleaner to help keep extra water out of the carpets. Extra water in the carpets can cause corrosion of the seat tracks.

- (a) While you clean the carpets, keep water away from the seat tracks as much as possible.

L. Clean the Leather or Naugahyde

SUBTASK 25-00-00-110-009

- (1) To clean a small area on the surface, do these steps:
 - (a) Remove water-based stains with a Winsol APC-120-WX cleaner, B00460 or Calla 301A cleaner, B00015.



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- (b) Rub oil-based stains with a cotton wiper, G00034 that is moist with solvent, B00083, alcohol, B00130, or alcohol, B00068.
 - (c) Use a Winsol APC-120-WX cleaner, B00460 or Calla 301A cleaner, B00015 to clean the area.

SUBTASK 25-00-00-110-010

- (2) To do regular cleaning, do these steps:
 - (a) Use the manufacturers' instructions to prepare a solution of the Winsol APC-120-WX cleaner, B00460 or the Calla 301A cleaner, B00015.
 - (b) Apply only the foam to the leather or Naugahyde with a soft cotton wiper, G00034. Rub carefully in a circular movement.
 - (c) Remove the Winsol APC-120-WX cleaner, B00460 or the Calla 301A cleaner, B00015 with a clean cotton wiper, G00034 that is moist with water.
 - (d) Rub the surface with a dry soft cotton wiper, G00034.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

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Page 708
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

M. Clean the Painted, Plastic or Rubber Floor Coverings

SUBTASK 25-00-00-140-001

- (1) Use a vacuum cleaner tool set, COM-2477 to remove loose unwanted materials.

SUBTASK 25-00-00-110-011

- (2) Apply Turco 5948 cleaner, B00641 to the floor covering.

SUBTASK 25-00-00-140-002

- (3) Rub the surface with a soft bristle brush, STD-123 if it is necessary.

SUBTASK 25-00-00-140-003

- (4) Flush the surface with clean water.

SUBTASK 25-00-00-140-004

- (5) Remove the loose unwanted materials with cotton wiper, G00034.

SUBTASK 25-00-00-110-012

- (6) Do the steps again until the surface is fully clean.

N. Clean the Silicone Seals

SUBTASK 25-00-00-110-013

- (1) Apply Turco 5948 cleaner, B00641 with a spray polyethylene bottle (500ml), STD-1104 or sponge, G00116.

SUBTASK 25-00-00-110-014

- (2) Let the Turco 5948 cleaner, B00641 soak on the seal for one-half to two minutes.

SUBTASK 25-00-00-140-005

- (3) Rub the surface of the seal with a cotton wiper, G00034 that is moist with water.

SUBTASK 25-00-00-110-015

- (4) Remove the Turco 5948 cleaner, B00641 from the seal with a clean cotton wiper, G00034 that is soaked with water.

SUBTASK 25-00-00-140-006

- (5) Dry the seal with a clean, dry cotton wiper, G00034.

O. Clean the Bare Metal Surfaces

SUBTASK 25-00-00-110-020



USE ONLY CLEAN WATER OR CHLORINATED WATER TO CLEAN THE FRONT COVERS OF OVENS. DETERGENTS CAN CAUSE DETERIORATION OF THE SURFACE FINISH. DO NOT USE POLISHES ON DECORATIVE ALUMINUM. THE POLISHES CAN CAUSE DAMAGE TO THE DECORATIVE SURFACES.

- (1) To clean a small area of an aluminum surface, do these steps:
 - (a) Remove the loose unwanted material with a cotton wiper, G00034.
 - (b) Apply mixed detergent to the dirty area with a spray bottle or a moist sponge, G00116.
 - (c) Carefully rub the area with a clean cotton wiper, G00034 to remove the unwanted material.
 - (d) Remove the detergent with a sponge, G00116 that is moist with water.
 - (e) Dry the surface with a clean cotton wiper, G00034. Rub the surface in a straight line movement. If the area is still dirty, do these steps:

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

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Page 709
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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- 1) Rub the area with a cotton wiper, G00034 that is moist with solvent, B00083, alcohol, B00130, alcohol, B00068, solvent, B00081, solvent, B00093, Vertrel MCA solvent, B50005, or Vertrel XF solvent, B50004.
- 2) After the surface looks fully clean, remove the solvent or alcohol with a Turco 5948 cleaner, B00641.

SUBTASK 25-00-00-110-021

- (2) To clean the aluminum, do these steps:
 - (a) Apply Turco 5948 cleaner, B00641 to the surface with a sponge, G00116 or a spray polyethylene bottle (500ml), STD-1104.
 - (b) Let it soak on the surface for one-half to two minutes.
 - (c) Rub the surface with a clean cotton wiper, G00034 that is moist with water.
 - (d) Remove the detergent with a clean cotton wiper, G00034 that is soaked with water.
 - (e) Dry the surface with a clean, dry cotton wiper, G00034.

SUBTASK 25-00-00-110-016

- (3) To clean stainless steel, do these steps:
 - (a) Do the procedure given for opaque plastic or painted surfaces to clean the steel; then polish the steel with these steps:
 - 1) Use a cotton wiper, G00034 to apply polish to a small area.
 - a) Use Met-All polish, B00700 for highly-polished surfaces and satin finishes.
 - 2) Rub the area until the polish becomes black.
 - 3) Rub the surface with a clean, dry cotton wiper, G00034 until the rubbed area looks bright and continuous.
 - 4) Remove the remaining polish with a Turco 5948 cleaner, B00641.

P. Clean the Hard Non-porous Surfaces

SUBTASK 25-00-00-110-037

- (1) Use the Calla 1452 cleaner, B50280 disinfectant product, EPA Registration No. 1839-168, to disinfect the hard non-porous surfaces on the aircraft.

NOTE: This product is to be used only on the hard non-porous surfaces in the lavatory and galley waste container area, not in the galley work place or on the food trolleys.

NOTE: The galley and lavatory sinks, countertops, toilet shrouds, and toilet seats may be porous surfaces and Calla 1452 should not be used.

- (a) Please follow the directions for use under the Virucidal Activity and make sure that surfaces remain wet for 10 minutes.

NOTE: The EPA continues to work on criteria to determine which registered disinfectant products would be most likely to inactivate the Ebola virus on hard, non-porous surfaces and the development of communications strategies.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 710
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

Q. Clean the Return Air Grilles

SUBTASK 25-00-00-140-007

- (1) Use a vacuum cleaner tool set, COM-2477 to clean the return air grilles.

————— **END OF TASK** —————

TASK 25-00-00-370-801

3. Equipment and Furnishings Painting

A. General

- (1) Make sure the area you want to repair is smaller than 100 square inches. If the area is larger than 100 square inches, you must replace the part.
- (2) The procedures that follow are in groups in relation to the type of decorative surface you will paint: Tedlar, polycarbonate (Lexan), ULTEM, and Declar.

NOTE: Only paint the components that were previously painted by design intent and production drawing.

NOTE: Unless the interior component was previously painted by design, painting is limited to 100 sq. in. for repair and touch up purposes only.



WARNING

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WARNING

DO NOT GET THE PAINT MATERIALS IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATHE PAINT FUMES. PUT ON PROTECTIVE SPLASH GOGGLES AND GLOVES WHEN YOU USE THESE MATERIALS. KEEP THESE MATERIALS AWAY FROM SPARKS, FLAME, AND HEAT. PAINT MATERIALS ARE POISONOUS AND FLAMMABLE AND WILL CAUSE INJURY OR DAMAGE.

- (3) Fully mix the coating, C00040 before you use it. It is better to use a mechanical mixer. Do not shake the water emulsion paint too much, because air bubbles will occur.
- (4) Mix the coating, C00040 to the correct consistency before you spray it. Do not mix thinners from different vendors.
- (5) Keep the air clean. Dirt or lint can contaminate the coating, C00040 before it is dry.
- (6) The color of the new coating, C00040 must be the same as the old coating, C00040 or you will see an outline.

B. Consumable Materials

Reference	Description	Specification
B00102	Abrasive - Aluminum Oxide Coated Cloth	
B00130	Alcohol - Isopropyl	TT-I-735
B00641	Cleaner - Aircraft (Interior And Exterior) - Turco 5948	
C00039	Primer - Interior Decorative Urethane, White	BMS10-83 Type I
C00040	Coating - Interior Decorative Urethane Topcoat, Semigloss	BMS10-83 Type II

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 711
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description	Specification
C00923	Coating - Interior Decorative Urethane Enamel, Low Gloss	BMS10-83 Type III
C50029	Primer - Interior Decorative Urethane, White Primer for Solvent Resistant Thermoplastic & Composite Parts	BMS10-83 Type IV
D00147	Compound - Interior Surface Filling, Polyester Resin	BMS5-136
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Prepare to Paint the Interior Surfaces of the Airplane

SUBTASK 25-00-00-370-001

- (1) Prepare to paint the tedlar surfaces with these steps:
 - (a) Do this task: SUBTASK 25-00-00-110-002.
 - (b) Apply Scotch Flatback Masking Tape 250, G00270 to the adjacent surfaces.
 - (c) Apply Alexit primer, C50029 to the area you will paint.

SUBTASK 25-00-00-370-002

- (2) Prepare to paint the polycarbonate (Lexan) surfaces with these steps:
 - (a) Clean the surface with a cotton wiper, G00034 that is moist with a Turco 5948 cleaner, B00641.
 - (b) Rub the surface lightly with abrasive cloth, B00102 to remove the gloss.
 - (c) Clean the surface with a clean cotton wiper, G00034 that is moist with the Turco 5948 cleaner, B00641.
 - (d) Examine the surface for porosity and voids. If you find surface porosity or voids, do these steps:
 - 1) Put compound, D00147 on a clean cotton wiper, G00034 at package consistency.
 - 2) Rub the surface with the cotton wiper, G00034 to push the compound, D00147 into the surface defects.
 - 3) Let the compound, D00147 dry for 3/4 to one hour.
 - 4) Remove the unwanted compound, D00147 with abrasive cloth, B00102.
 - 5) Clean the surface with cotton wiper, G00034 that is moist with a Turco 5948 cleaner, B00641.



CAUTION

YOU MUST USE PRIMER BEFORE YOU PAINT POLYCARBONATE SURFACES. THE SOLVENTS IN THE PAINT CAN DAMAGE THE POLYCARBONATE IF YOU DO NOT USE THE CORRECT PRIMER.

- (e) Apply primer, C00039 to the surface of the part you want to paint.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 712
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-370-003

- (3) Prepare to paint the ULTEM and Declar surfaces with these steps:
- (a) Clean the surface of the part with a cotton wiper, G00034 that is moist with a Turco 5948 cleaner, B00641 or alcohol, B00130.
 - (b) Dry the surface with a clean dry cotton wiper, G00034.
 - 1) If you use alcohol, B00130, dry the surface before the alcohol becomes dry.
 - (c) Clean the surface of the part again with a cotton wiper, G00034 that is moist with Turco 5948 cleaner, B00641 or alcohol, B00130.
 - (d) Dry the surface with a clean dry cotton wiper, G00034.
 - 1) If you use alcohol, B00130, dry the surface before the alcohol becomes dry.
 - (e) Apply the Alexit primer, C50029 to the surface.

E. Paint the Tedlar, Polycarbonate, ULTEM, and Declar Surfaces

SUBTASK 25-00-00-370-004

- (1) Obey the manufacturer's instructions to mix the coating, C00040 or coating, C00923.

SUBTASK 25-00-00-370-005

- (2) Apply several cross-layers of coating, C00040 or coating, C00923 until the color agrees with the adjacent areas.

SUBTASK 25-00-00-950-001

- (3) Remove the Scotch Flatback Masking Tape 250, G00270, if applicable.

SUBTASK 25-00-00-370-006

- (4) Let the first layer of coating, C00040 or coating, C00923 dry for two hours at 70 to 80 °F before you touch it.

SUBTASK 25-00-00-370-007

- (5) If it is necessary, apply a texture layer of the same coating, C00040 or coating, C00923.

SUBTASK 25-00-00-370-008

- (6) Let it dry for three hours after you apply the texture layer before you touch it.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 713
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
EQUIPMENT AND FURNISHINGS - REPAIRS

1. General

- A. This procedure supplies instructions to repair these items:
- (1) Repair Decorative Tedlar Covering on Flight Deck Door
 - (2) Sandwich and Laminate panels
 - (3) Decorative surfaces
 - (4) Decorative tedlar removal/installation
 - (5) Nomex honeycomb sandwich panels with a decorative surface.
 - (6) Tedlar laminate covers of aluminum laminates
 - (7) Perforated Panels
 - (8) Polycarbonate (Lexan), ULTEM, Radel, and Declar plastics
 - (9) Urethane Foam.
 - (10) Aluminum trim
 - (11) Stowage Bin Edge Cap

TASK 25-00-00-300-801

2. Repair Decorative Tedlar Covering on Flight Deck Door

A. General

- (1) This task contains instructions to repair Tedlar laminate surfaces that have small scratches, small holes, and gouges.
- (2) Make sure the following conditions exist before beginning repair:
 - (a) The repair depth cannot be larger than 0.10 in. (2.5 mm) in a Tedlar laminate covered panel that is 0.25 in. (6.35 mm) thick or more, or 0.005 in. (0.127 mm) deep in a panel that is less than 0.25 in. (6.35 mm) thick.
 - (b) Make sure the area you want to repair is smaller than 100 square inches. If the area is larger than 100 square inches, you must replace the full decorative tedlar using the Decorative Tedlar Removal/Installation procedure Decorative Tedlar Removal/Installation, TASK 25-00-00-900-801 or replace the part.
- (3) Make sure replacement material is equivalent to existing material.
- (4) This task contains these repairs:
 - (a) Repair of small scratches and unwanted marks.
 - (b) Repair of the pattern on the tedlar laminate.
 - (c) Repair of small holes and gouges.

B. Tools/Equipment

Reference	Description
STD-1080	Brush - Paint
STD-1205	Wheel - Buffer, Cotton Cloth, 80/92 Thread Count, Spiral Sewn, 6 Inch Diameter, 7/8 Inch Thick, 1/4 Inch Arbor Hole

C. Consumable Materials

Reference	Description	Specification
B00026	Compound - Buffing - Learok 119	

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 801
May 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description	Specification
B00027	Compound - Buffing - Learok 884E (Formerly Learock 888)	
B00102	Abrasive - Aluminum Oxide Coated Cloth	
B01027	Solvent - Butyl Carbitol (Dow Chemical - E-Series Glycol Ethers)	
C00040	Coating - Interior Decorative Urethane Topcoat, Semigloss	BMS10-83 Type II
C00368	Ink - Screen Printing, Clear	BMS10-73 Type II
C00923	Coating - Interior Decorative Urethane Enamel, Low Gloss	BMS10-83 Type III
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G02022	Rubber - Silicone Casting (Must Not Contain Iron Oxide)	
G02310	Ink - Water-Based, Screen Printing	BMS10-107

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Repair of Small Scratches and Unwanted Marks

SUBTASK 25-00-00-300-002

- (1) Make sure the area you want to repair is smaller than 100 in² (645 cm²). If the area is larger than 100 in² (645 cm²), you must replace the full decorative tedlar part. Decorative Tedlar Removal/Installation, TASK 25-00-00-900-801.
- (2) Rub the surface lightly with the abrasive cloth, B00102 until the area is not rough.
- (3) Polish the damaged area with the cotton cloth buffer wheel, STD-1205 and Learok 119 compound, B00026 or Learok 884E compound, B00027 until the area is as glossy as the adjacent areas.

F. Repair of the Pattern on the Tedlar Laminate

SUBTASK 25-00-00-300-003

- (1) Apply the silk screen ink, C00368, ink, G02310 or coating, C00923 on the tedlar laminate surface as necessary.
- (2) Apply coating, C00040 on the tedlar laminate surface as necessary.

G. Repair of Small Holes and Gouges

SUBTASK 25-00-00-100-018



WARNING

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- (1) Do these steps for the door panels:
 - (a) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 802
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (b) Dry the area with a clean cotton wiper, G00034.
 - (c) Make a frame, approximately $\frac{3}{8}$ in. (10 mm) wide by $\frac{1}{2}$ in. (13 mm) high, around the clean surface.
 - (d) Apply a thin layer of the prepared silicone castable silicone rubber, G02022 on the textured surface in the frame with a paint brush, STD-1080. Continue to use the brush until you cannot see air bubbles.
NOTE: Almost all of the brands, types or colors of the castable silicone rubber are satisfactory, but not the dark red types which contain finely divided iron oxide. Dow Corning RTV B, E, 587, or 93072, and General Electric RTV41 or RTV61 are also preferred. Prepare the silicone with the manufacturer's instructions.
 - (e) Pour the remaining silicone castable silicone rubber, G02022 on the brushed surface until it is $\frac{1}{4}$ in. (6 mm) thick.
 - (f) Let it cure at room temperature for 48 hours.
 - (g) When the silicone castable silicone rubber, G02022 is dry, remove the texture blanket from the surface.
- (2) Apply the silk screen inks ink, C00368 or ink, G02310 of the correct color to the repair surface.
 - (3) Let it dry for 15 minutes.
 - (4) Apply the silicone texture blanket to the repaired surface.
 - (5) Apply a vacuum of approximately 10 in. (25 cm) of mercury at 160°F (71°C).
 - (6) If the repair is not satisfactory, replace the Tedlar laminate Decorative Tedlar Removal/Installation, TASK 25-00-00-900-801.
 - (7) Make sure replacement material is equivalent to existing material.

— END OF TASK —

TASK 25-00-00-340-801

3. Sandwich and Laminate Panel Repairs

A. General

- (1) This task gives instructions to repair sandwich and laminate panels with these types of damage:
 - (a) Small scratches and dents
 - (b) Small holes and gouges
 - (c) Damage that is more than 0.5 square inch without core damage
 - (d) Damage that is more than 0.5 square inch with core damage.

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-10679	Hole Saw Part #: A32091-1920 Supplier: 81205

EFFECTIVITY
ARO ALL

D633W101-ARO

25-00-00

Page 803
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

C. Consumable Materials

Reference	Description	Specification
A01018	Compound - Honeycomb Edge Filling & Potting	BMS5-28 Type 28
A01021	Compound - Honeycomb Edge Filling & Potting, Epoxy Based, 2 Part, RT Cure (12-25 Min Gel)	BMS5-28 Type 18
A50042	Compound - Honeycomb Edge Filling & Potting, Epoxy Based, 2 Part, RT Cure (20-40 Min Gel)	BMS5-28 Type 19
A50145	Resin - Self-Extinguishing Laminating - Epocast 50-A1 with Epocast 946	BMS8-201 Type IV (Short work life)
B00102	Abrasive - Aluminum Oxide Coated Cloth	
B01027	Solvent - Butyl Carbitol (Dow Chemical - E-Series Glycol Ethers)	
D00147	Compound - Interior Surface Filling, Polyester Resin	BMS5-136
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00077	Foam - Flame Retardant Rigid Urethane	BMS8-133
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G00278	Core Material - Nonmetallic Honeycomb Core	BMS8-124
G00288	Material - Release Sheet	BMS15-3
G00316	Fabric - Woven Glass Reinforcements For Laminating Plastics	BMS9-3
G00335	Fiber - Carbon Fiber Reinforcements, Yarn And Fabric	BMS9-8
G02316	Material - Foil-Backed Laminate, Flexible	BAC5596 Type 14

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Small Scratches and Dents Repair

SUBTASK 25-00-00-110-022

- (1) Make sure the area you want to repair is smaller than 100 square inches. If the area is larger than 100 square inches, you must apply a foil-backed decorative laminate over the repair. Refer to the Decorative Surfaces Repair, TASK 25-00-00-340-802.
- (2) Use this task to repair panels that have damage that does not go into the fiberglass or carbon skins.
- (3) Use this procedure to repair scratches and small surface dents for panels that are less than 0.25-inch thick with a maximum depth of 0.005-inch.
- (4) Use this task to repair scratches and small surface dents for panels that are 0.25-inch thick or more, that are not more than 0.01-inch deep.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 804
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



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- (5) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.

SUBTASK 25-00-00-160-002

- (6) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-340-115

- (7) Use the manufacturer's instructions to mix the compound, D00147.

SUBTASK 25-00-00-390-001

- (8) Apply the compound, D00147 to the necessary contour and smoothness of the panel.

SUBTASK 25-00-00-220-001

- (9) If it is necessary to obey the heat and smoke release rules, the repair area must be as follows:
- (a) The width of the compound, D00147 must not be more than 3 inches.
 - (b) When you smooth the radii, the width of the compound, D00147 must not be more than 3 inches.
 - (c) The total amount of compound, D00147 you use for a total area must not be more than 100 square inches on any one panel.
 - (d) If it is not possible to repair the panel within the limits above, apply a material, G02316 over the repair. Refer to the Decorative Surfaces Repair, TASK 25-00-00-340-802.

SUBTASK 25-00-00-120-001

- (10) After the compound, D00147 has cured, do these steps:
- (a) Apply Scotch Flatback Masking Tape 250, G00270 to the area around the repair that you do not want to damage during the sanding.
 - (b) Rub the compound, D00147 with abrasive cloth, B00102 paper to the same level as the surface of the panel.
 - (c) Remove the Scotch Flatback Masking Tape 250, G00270.

SUBTASK 25-00-00-340-001

- (11) If this is a decorative panel, do this task: Decorative Surfaces Repair, TASK 25-00-00-340-802.

F. Small Holes and Gouges Repair

NOTE: Use this task for damage that is less than 0.5 square inches and damages the core by less than 0.5 inch.

SUBTASK 25-00-00-160-003

- (1) Use this task for damage that is less than 0.5 square inches and damages the core by less than 0.5 inch.
- (2) Remove the loose and broken pieces, contamination, and other unwanted material from the hole.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 805
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-110-023



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- (3) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.

SUBTASK 25-00-00-160-004

- (4) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-340-002

- (5) Use the manufacturer's instructions to mix the compound, A01018 or compound, A50042

SUBTASK 25-00-00-340-003

- (6) Fill the hole or gouge with the compound, A01018 or compound, A50042

SUBTASK 25-00-00-340-004

- (7) Let the compound, A01018 or compound, A50042 cure for 7 days at 75 to 79 °F, or 5 hours at 120 to 130 °F.

SUBTASK 25-00-00-340-116

- (8) To resurface the panel do this task: Small scratches and Dents Repair for the Sandwich and Laminate Panel Repairs, TASK 25-00-00-340-801.

SUBTASK 25-00-00-340-117

- (9) If this is a decorative panel, do this task: Decorative Surfaces Repair, TASK 25-00-00-340-802.

G. Large Holes and Gouges in the Laminates Repair

SUBTASK 25-00-00-340-005

- (1) Use this task to repair the panels that have between 0.5 square inch and 100 square inches of damage but no core damage.
- (2) Remove the damaged area plies from the panel.

SUBTASK 25-00-00-340-006

- (3) Rub the damaged area to a taper of 0.5 to 1 inch per ply.

SUBTASK 25-00-00-110-024



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- (4) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.

SUBTASK 25-00-00-160-005

- (5) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-340-007

- (6) Use the manufacturer's instructions to mix the resin, A50145.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 806
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-340-008

- (7) Do these steps to replace the plies of fabric, G00316 or carbon fiber, G00335:
- Cut the same number of plies of fabric, G00316 or carbon fiber, G00335 to fit the taper sanded area.
NOTE: The weave of the replacement fabric should be the same as the weave of the original fabric.
 - Apply the resin, A50145 to the taper sanded area and the smallest ply of fabric, G00316 or carbon fiber, G00335.
 - Put the smallest ply of fabric, G00316 or carbon fiber, G00335 on the taper sanded area.
 - Continue the above steps with each ply until the patch is complete.
NOTE: All of the overlaps should be at least 0.5 inch.

SUBTASK 25-00-00-340-009

- (8) Apply a release sheet, G00288 and 10 psi, and cure the part.
NOTE: The pressure may be applied with positive weights and a caul plate or vacuum. The minimum weight is 10 pounds multiplied by the repair area (in square inches). If a vacuum is used to apply the pressure, cover the entire area with a vacuum bag and apply 20 inches of mercury.

SUBTASK 25-00-00-340-010

- (9) Cure at 70 to 80 °F for 8 to 16 hours.

SUBTASK 25-00-00-340-011

- (10) Do this task to resurface the panel: Small Scratches and Dents Repair for the Sandwich and Laminate Panel Repairs, TASK 25-00-00-340-801.

SUBTASK 25-00-00-340-012

- (11) If this is a decorative panel, do this task: Decorative Surfaces Repair, TASK 25-00-00-340-802.

H. Repair the Panels that have Core Damage

NOTE: There are two alternative tasks for this repair.

SUBTASK 25-00-00-340-013

- Use this task to repair the panels that have more than 0.5 square inch of damage and a damaged core.
- Remove the damaged skin until you can see a minimum of 0.5 inch of the core without damage.

SUBTASK 25-00-00-340-014

- Remove the damaged part of the core.
 - Make sure there is a minimum of 0.5 inch of the core without damage shown on all sides of the damaged area.

SUBTASK 25-00-00-340-015

- Rub the skin around the damaged area to taper out 2 inches around the edge of the cut out area.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-00-00

Page 807
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-110-025



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- (5) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.

SUBTASK 25-00-00-160-006

- (6) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-340-016

- (7) Use this task to repair panels with a damaged core with a diameter of less than 3 inches, and less than 100 square inches of damaged surface area.

- (8) Do these steps for the first alternative repair:

- (a) Bond a piece of foam, G00077 or nonmetallic honeycomb core, G00278 with resin, A50145 to the area where the damaged core was removed.

NOTE: The foam or core thickness must be the same thickness as the honeycomb core that was removed from the damaged area.

- (b) Apply a release sheet, G00288 and 10 psi, and cure the part.

NOTE: The pressure may be applied with positive weights and a caul plate or vacuum. The minimum weight is 10 pounds multiplied by the repair area (in square inches). If the vacuum is used to apply the pressure, cover the entire area with a vacuum bag and apply 20 inches of mercury.

- (c) Cure at 70 to 80 °F for 8 to 16 hours.

- (d) Do this task to repair the skin: Large Holes and Gouges in the Laminates Repair in the Sandwich and Laminate Panel Repairs, TASK 25-00-00-340-801.

SUBTASK 25-00-00-340-017

- (9) Use this task to repair panels with damage to the core of more than 3 inches in diameter and less than 100 square inches of damaged surface area.

- (10) Do these steps for the second alternative repair:

- (a) Cut and replace the damaged core with the same thickness, type, class, and grade of nonmetallic honeycomb core, G00278.

- (b) Apply resin, A50145 around the edge if it is necessary to bond the core.

NOTE: The core must have the same ribbon direction and bonded the same as on the engineering drawing.

- (c) Do this task to repair the skin: Large Holes and Gouges in the Laminates Repair in the Sandwich and Laminate Panel Repairs, TASK 25-00-00-340-801.

I. Potted Inserts Repair

SUBTASK 25-00-00-340-018

- (1) Remove the damaged skin and approximately 0.5 inch more on all sides of the damage.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

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Page 808
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-110-026



WARNING

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- (2) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.

SUBTASK 25-00-00-160-007

- (3) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-340-019

- (4) Cut around the insert from the back side of the panel with a hole saw, SPL-10679 or an equivalent tool.

NOTE: Be careful not to cut the front side of the panel.

SUBTASK 25-00-00-340-020



CAUTION

BE CAREFUL WHEN YOU APPLY HEAT NEAR THE MATERIALS THAT CAN BURN. THE TEMPERATURE OF THE TEDLAR LAMINATE MUST NEVER BE MORE THAN 200 °F OR THE TEMPERATURE AT WHICH THE TEDLAR LAMINATE DISTORTS, WHICHEVER IS LOWER. TOO MUCH HEAT CAN CAUSE DAMAGE TO THE TEDLAR LAMINATE.

- (5) Carefully increase the temperature of the insert with an induction heater until you can remove the insert from the panel.

NOTE: If you do not use heat during the removal of the insert, damage to the front panel can occur.

SUBTASK 25-00-00-340-021

- (6) Use the manufacturer's instructions to mix the compound, A01021 or compound, A50042.

SUBTASK 25-00-00-340-022

- (7) Fill the hole with the compound, A01021 or compound, A50042.

SUBTASK 25-00-00-340-023

- (8) Push a new insert slowly into the compound, A01021 or compound, A50042.

SUBTASK 25-00-00-340-024

- (9) Let the compound, A01021 flow around the insert and fill the hole.

SUBTASK 25-00-00-340-118

- (10) Let the compound, A01021 or compound, A50042 cure for 7 days at 75 to 79 °F, or 5 hours at 120 to 130 °F.

SUBTASK 25-00-00-340-025

- (11) Do this task to repair the skin: Large Holes and Gouges in the Laminates Repair in Sandwich and Laminate Panel Repairs, TASK 25-00-00-340-801.

————— END OF TASK —————

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 809
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-00-00-340-802

4. Decorative Surfaces Repair

A. General

- (1) This task contains instructions to repair painted or Tedlar laminate surfaces that have small scratches, small holes, and gouges.
- (2) This task has these repairs:
 - (a) A repair of small scratches and unwanted marks.
 - (b) A repair of the pattern on the tedlar laminate.
 - (c) A repair of small holes and gouges.
 - (d) Application of decorative tedlar laminate - non-acoustical (non-adhesive-back).
 - (e) Application of decorative tedlar laminate with a pressure sensitive adhesive (adhesive-back).

NOTE: This is the preferred repair when tedlar material (laminate, G02446 or decorative laminate, G51199) will be applied inside the airplane.

- (3) The area for repair of decorative surfaces must be smaller than 100 square inches. If the area is larger than 100 in² (645 cm²), you must replace the part.

B. References

Reference	Title
20-10-26-910-801	Precautions for Heat Devices (P/B 201)

C. Tools/Equipment

Reference	Description
STD-442	Gun - Heat, 180 F (82 C) Maximum Output Temperature
STD-1080	Brush - Paint
STD-1089	Source - Vacuum, 0 to -3.00 PSIG
STD-1133	Gun - Spray, Paint, with Interchangeable Nozzles
STD-1205	Wheel - Buffer, Cotton Cloth, 80/92 Thread Count, Spiral Sewn, 6 Inch Diameter, 7/8 Inch Thick, 1/4 Inch Arbor Hole
STD-6639	Vacuum Source, 10-30 Inches of Mercury (absolute)

D. Consumable Materials

Reference	Description	Specification
A00555	Adhesive - For Bonding Decorative Laminate, 2 Part, Sprayable	BMS5-127 Type II
B00026	Compound - Buffing - Learok 119	
B00027	Compound - Buffing - Learok 884E (Formerly Learock 888)	
B00102	Abrasive - Aluminum Oxide Coated Cloth	
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B01027	Solvent - Butyl Carbitol (Dow Chemical - E-Series Glycol Ethers)	
C00040	Coating - Interior Decorative Urethane Topcoat, Semigloss	BMS10-83 Type II
C00368	Ink - Screen Printing, Clear	BMS10-73 Type II
C00923	Coating - Interior Decorative Urethane Enamel, Low Gloss	BMS10-83 Type III

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 810
Jul 25/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description	Specification
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G02022	Rubber - Silicone Casting (Must Not Contain Iron Oxide)	
G02310	Ink - Water-Based, Screen Printing	BMS10-107
G02446	Laminate - Tedlar	BAC5596 Type 13
G51199	Material - Double Flexible Decorative Laminate	BAC5596 Type VIA

E. Location Zones

Zone	Area
200	Upper Half of Fuselage

F. Small Scratch and Unwanted Mark Repair

SUBTASK 25-00-00-960-001

- (1) The repair depth cannot be larger than 0.10 in. (2.5 mm) in a Tedlar laminate covered panel that is 0.25 in. (6.35 mm) thick or more, or 0.005 in. (0.127 mm) deep in a panel that is less than 0.25 in. (6.35 mm) thick.
- (2) Make sure the area you want to repair is smaller than 100 in² (645 cm²). If the area is larger than 100 in² (645 cm²), you must replace the full decorative tedlar (Decorative Tedlar Removal/Installation, TASK 25-00-00-900-801) or replace the part.

SUBTASK 25-00-00-140-008



CAUTION DO NOT RUB THROUGH THE TEDLAR LAMINATE WHEN YOU REPAIR THE SMALL SCRATCHES OR UNWANTED MARKS. YOU WILL CAUSE MORE EXPENSIVE REPAIRS TO BE NECESSARY IF YOU RUB THROUGH THE TEDLAR LAMINATE.

- (3) Rub the surface lightly with the abrasive cloth, B00102 until the area is not rough.

SUBTASK 25-00-00-320-001

- (4) Polish the damaged area with the cotton cloth buffer wheel, STD-1205 and Learok 119 compound, B00026 or Learok 884E compound, B00027 until the area is as glossy as the adjacent areas.

G. Tedlar Pattern Repair

SUBTASK 25-00-00-370-009

- (1) Apply the silk screen ink, C00368, ink, G02310 or coating, C00923 on the tedlar laminate surface as necessary.

SUBTASK 25-00-00-340-120

- (2) Apply coating, C00040 on the tedlar laminate surface as necessary.

H. Small Hole and Gouge Repair

SUBTASK 25-00-00-340-026

- (1) Do the repair for small holes and gouges in Sandwich and Laminate Panel Repairs, TASK 25-00-00-340-801 if it is necessary before you repair the Tedlar laminate.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 811
Jan 05/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-340-027

- (2) Do these steps for panels that are flat or have easy contours:



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- (a) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.
- (b) Dry the area with a clean cotton wiper, G00034.
- (c) Make a frame, approximately $\frac{3}{8}$ in. (10 mm) wide by $\frac{1}{2}$ in. (13 mm) high, around the clean surface.
NOTE: Use wood, clay, or high temperature vacuum sealant tape for the frame.
- (d) Apply a thin layer of the prepared silicone castable silicone rubber, G02022 on the textured surface in the frame with a paint brush, STD-1080. Continue to use the brush until you cannot see air bubbles.
NOTE: Almost all of the brands, types or colors of the castable silicone rubber are satisfactory, but not the dark red types which contain finely divided iron oxide. Dow Corning RTV B, E, 587, or 93072, and General Electric RTV41 or RTV61 are also preferred. Prepare the silicone with the manufacturer's instructions.
- (e) Pour the remaining silicone castable silicone rubber, G02022 on the brushed surface until it is $\frac{1}{4}$ in. (6 mm) thick.
NOTE: One pound of prepared silicone castable silicone rubber, G02022 will make a 10 in. (25 cm) by 10 in. (25 cm) by $\frac{1}{4}$ in. (6 mm) replica.
- (f) Let the silicone cure at room temperature for 48 hours.
- (g) When the silicone is dry, remove the embossed pad from the surface.

SUBTASK 25-00-00-370-010

- (3) Apply the silk screen inks ink, C00368 or ink, G02310 of the correct color to the repair surface.

SUBTASK 25-00-00-370-011

- (4) Let it dry for 15 minutes.

SUBTASK 25-00-00-340-028

- (5) Apply the silicone embossing pad to the repaired surface.

SUBTASK 25-00-00-340-029

- (6) Apply a vacuum source, STD-6639 to apply a vacuum of approximately 10 in. (25 cm) of mercury at 160°F (71°C).

SUBTASK 25-00-00-340-030

- (7) If the repair is not satisfactory, replace the Tedlar laminate Decorative Tedlar Removal/Installation, TASK 25-00-00-900-801.

I. Apply Decorative Tedlar Laminate - Non-Acoustical (Non-adhesive-back)

NOTE: If it is necessary, repair the panel before you apply the Tedlar laminate.

SUBTASK 25-00-00-000-001

- (1) Remove the trim strips from the panel.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-00-00

Page 812
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-140-009

- (2) Rub the area with abrasive cloth, B00102 paper until the area is not glossy.

SUBTASK 25-00-00-110-027



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- (3) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027 or solvent, B00148.

SUBTASK 25-00-00-160-008

- (4) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-340-031

- (5) Mix the adhesive, A00555.
 - (a) Mix 16 parts by volume of adhesive with one part curing agent.

SUBTASK 25-00-00-340-032

- (6) Let the mixture set for 2 minutes.

SUBTASK 25-00-00-340-033



DO NOT GET METHYL ETHYL KETONE (MEK) IN YOUR MOUTH, OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM MEK. PUT ON A PROTECTIVE SPLASH GOGGLE AND GLOVES WHEN YOU USE MEK. KEEP MEK AWAY FROM SPARKS, FLAME, AND HEAT. MEK IS A POISONOUS AND FLAMMABLE SOLVENT WHICH CAN CAUSE INJURY OR DAMAGE.

- (7) If you want to spray the adhesive mixture, mix (by volume) one part of the adhesive mixture with one part solvent, B00148.

SUBTASK 25-00-00-340-034

- (8) Carefully spray the mixture with a paint spray gun with interchangeable nozzles, STD-1133 or apply the mixture to the surface with a paint brush, STD-1080.

SUBTASK 25-00-00-340-035

- (9) Let the surface dry at room temperature for a minimum of 2 hours.

NOTE: The surface must be fully dry before you install the tedlar laminate. If you install the tedlar to a wet surface you will not get a satisfactory bond.

SUBTASK 25-00-00-340-036

- (10) Put the Tedlar laminate, G02446 or the decorative laminate, G51199 in position.

NOTE: Use Scotch Flatback Masking Tape 250, G00270 to hold the decorative tedlar laminate in the correct position.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 813
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-340-037

- (11) Use a 180 F (82 C) maximum output temperature heat gun, STD-442 to reactivate the adhesive.

NOTE: Make sure the temperature is constant across the surface of the laminate. Refer to Precautions for Heat Devices, TASK 20-10-26-910-801 for cautions to obey when you use the heat guns.

NOTE: These steps are recommended to achieve a better adhesion. This is not required.

SUBTASK 25-00-00-340-038

- (12) Rub the Tedlar laminate, G02446 or the decorative laminate, G51199 until the bond is satisfactory and you cannot see bubbles.

SUBTASK 25-00-00-340-039

- (13) Do these steps with a vacuum source (0 to -3 PSIG), STD-1089 to make sure the laminate touches all of the panel:

NOTE: These steps are recommended to achieve a better repair. They are not required.

- (a) Use the maximum vacuum possible that will not cause damage to the panel.
- (b) Let the laminate cure for 24 hours at room temperature, for two hours at 120°F (49°C) or for 30 minutes at 180°F (82°C).
- (c) Let the part cool to 90°F (32°C) before you remove the vacuum pressure.

J. Apply Decorative Tedlar Laminate with a Pressure Sensitive Adhesive (adhesive-back)

NOTE: Use this task to apply laminate to non-acoustical (not perforated) panels with flat or simple contours.

If it is necessary, repair the panel before you apply the Tedlar laminate.

SUBTASK 25-00-00-010-001

- (1) Remove the trim strips from the panel.

SUBTASK 25-00-00-140-010

- (2) Rub the area where you will apply the Tedlar laminate with abrasive cloth, B00102 to remove the surface contamination.

SUBTASK 25-00-00-110-028



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- (3) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027 or solvent, B00148.

SUBTASK 25-00-00-160-009

- (4) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-540-001

- (5) Remove the release paper from the laminate you want to apply.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 814
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-340-040

- (6) Apply the laminate.

NOTE: Make sure the pattern is in the correct position. If the patterns are not aligned, the repair will not look satisfactory.

NOTE: Bubbles will result if you let the air get below the laminate.

SUBTASK 25-00-00-350-009

- (7) Use a 180 F (82 C) maximum output temperature heat gun, STD-442 to increase the temperature of the tedlar laminate.

NOTE: Make sure the temperature remains constant across the surface of the laminate. Refer to (Precautions for Heat Devices, TASK 20-10-26-910-801) for cautions to obey when you use heat guns.

SUBTASK 25-00-00-140-011

- (8) Rub the telar laminate until the bond is satisfactory and you cannot see bubbles.

SUBTASK 25-00-00-340-041

- (9) Use a vacuum source (0 to -3 PSIG), STD-1089 to make sure the laminate touches all of the panel:

NOTE: These steps are recommended to achieve a better repair. They are not required.

- (a) Use the maximum vacuum possible that will not cause damage to the panel.
- (b) Let the laminate cure for 24 hours at room temperature, for two hours at 120°F (49°C) or for 30 minutes at 180°F (82°C).
- (c) Let the part cool to 90°F (32°C) before you remove the vacuum pressure.

————— **END OF TASK** —————

TASK 25-00-00-900-801

5. Decorative Tedlar Removal/Installation

A. General

- (1) This task gives instructions to replace damaged decorative tedlar laminate on the honeycomb sandwich panels.
 - (a) To do this repair, it is necessary to replace the damaged laminate.
- (2) This task has these repairs:
 - (a) Removal of the decorative tedlar laminate (non-adhesive-backed).
 - (b) Installation of the decorative tedlar laminate (non-adhesive-backed).
 - (c) Removal of the decorative tedlar laminate (pressure sensitive adhesive backed).
 - (d) Installation of the decorative tedlar laminate (pressure sensitive adhesive backed).

B. References

Reference	Title
20-10-26-910-801	Precautions for Heat Devices (P/B 201)

C. Tools/Equipment

Reference	Description
STD-94	Bag - Vacuum
STD-442	Gun - Heat, 180 F (82 C) Maximum Output Temperature
STD-549	Knife - Putty, Broad Blade

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 815
Jul 25/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description
STD-745	Roller - Hard Rubber
STD-821	Squeegee - Plastic
STD-1134	Vacuum - Source, 24 Inch Hg Minimum
STD-1181	Gloves - Heat Protective

D. Consumable Materials

Reference	Description	Specification
A00555	Adhesive - For Bonding Decorative Laminate, 2 Part, Sprayable	BMS5-127 Type II
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B01018	Solvent - Cleaning Of Specific Polymeric - Series 98	
B01027	Solvent - Butyl Carbitol (Dow Chemical - E-Series Glycol Ethers)	
D00147	Compound - Interior Surface Filling, Polyester Resin	BMS5-136
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G02316	Material - Foil-Backed Laminate, Flexible	BAC5596 Type 14
G02446	Laminate - Tedlar	BAC5596 Type 13
G50381	Abrasive - Aluminum Oxide Paper, 180 Grit	
G51199	Material - Double Flexible Decorative Laminate	BAC5596 Type VIA
G51343	Sleeve - Felt, Low-Friction (FS-4)	

E. Location Zones

Zone	Area
200	Upper Half of Fuselage

F. Removal of the Decorative Tedlar Laminate (non-adhesive-backed)

SUBTASK 25-00-00-000-002

- (1) Do these steps to remove the decorative laminate, G02446 or decorative laminate, G51199 from the base panel.

NOTE: This repair procedure is best completed after the panel is removed from the airplane.

- (a) Attach the panel safely with the decorative side in the up position.
- (b) Put on the heat protective gloves, STD-1181.
- (c) Use a 180 F (82 C) maximum output temperature heat gun, STD-442 to apply heat to the corner of the panel (TASK 20-10-26-910-801).

NOTE: Do not let the heat collect in one spot for more than 20 seconds.

- (d) Pry at the corner of the panel to remove the laminate.
- (e) Slowly pull the laminate from the panel surface.
- (f) Point the heat gun in front of the area where the laminate continues to be attached to the panel.
 - 1) Keep a constant pressure on the laminate while you pull it from the panel.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 816
Jul 25/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL

2) When the temperature is at the correct level, the laminate will release from the panel.

(g) Continue this procedure until the laminate is fully removed.

G. Installation of the Decorative Tedlar Laminate (non-adhesive-backed)

SUBTASK 25-00-00-400-001

(1) Do these steps to install the laminate, G02446 or decorative laminate, G51199 to the base panel.

(a) Prepare the panel surface as follows:

- 1) Use a broad blade putty knife, STD-549 to remove unwanted adhesive.
- 2) Use compressed air or a dry cotton wiper, G00034 to remove dust or other contamination.
- 3) If necessary, use compound, D00147 to fill surface defects.
 - a) Make sure that the filler dries sufficiently.
 - b) Use 180 grit abrasive paper, G50381 to smooth the filler.
 - c) Use compressed air or a dry cotton wiper, G00034 to remove dust or other contamination.



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- (b) Clean the panel surface with a clean cotton wiper, G00034 that is soaked with Series 98 solvent, B01018.
- (c) Apply adhesive, A00555 to panel surface.
- (d) Put the laminate, G02446 or the decorative laminate, G51199 on the panel surface
 - 1) Align the laminate, G02446 by the pattern location.
- (e) Use a vacuum bag, STD-94 or vacuum (24 Inch Hg Minimum), STD-1134 to apply 20 in/Hg (68 kPa) vacuum to the panel.



WHEN YOU DO WORK AROUND THE TEDLAR LAMINATE, MAKE SURE THAT YOU DO NOT APPLY MORE THAN 220°F (104°C) OF HEAT TO THE TEDLAR LAMINATE. TOO MUCH HEAT CAN CAUSE DAMAGE TO THE TEDLAR LAMINATE.

- (f) Preheat the laminate to 170°F (77°C) to allow the laminate to form to the panel contours when vacuum is applied.

NOTE: This cycle will have to be determined for each part.
- (g) Use a vacuum with a minimum of 20.0 in/Hg (67.7 kPa) to pull the flexible laminate onto the panel surface.
- (h) Let the part cure.

NOTE: Use the cure cycle time that was used before for the specific part that provided the minimum bondline temperature at 170°F (77°C).

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 817
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (i) Remove the vacuum only when the part cools to 90°F (32°C) or below, or to a temperature that will make sure that the laminate does not delaminate from the panel.
- (j) Remove the unwanted laminate from the edge of the panel.

H. Removal of the Decorative Tedlar Laminate (pressure sensitive adhesive backed)

SUBTASK 25-00-00-000-003

- (1) Do these steps to remove the decorative laminate material, G02316, from the interior panel.
 - (a) Make sure that the surrounding equipment and components are protected from damage during the removal.
 - (b) Remove the components on the interior panel that will keep you from removing the laminate.
 - (c) Use a utility knife, to make vertical cuts in the decorative laminate at intervals of 3 in. (8 cm) to 4 in. (10 cm).

NOTE: Make sure that you do not cut into the panel below the laminate.
 - (d) Carefully remove the decorative laminate and manually peel the laminate from the panel.
 - (e) If necessary, use a broad blade putty knife, STD-549 to remove unwanted PSA adhesive.

NOTE: Make sure that the panel below the laminate is not damaged.

I. Decorative Tedlar Installation (pressure sensitive adhesive-backed)

NOTE: Use this task to apply laminate to non-acoustical (not perforated) panels with flat or simple contours.

SUBTASK 25-00-00-400-002

- (1) Do these steps to install the laminate, G02446 or the decorative laminate, G51199 to the base panel.
 - (a) Prepare the panel surface as follows:
 - 1) Use a broad blade putty knife, STD-549 to remove unwanted adhesive.
 - 2) Use compressed air or a dry cotton wiper, G00034 to remove dust or other contamination.
 - 3) If necessary, use compound, D00147 to fill surface defects.
 - a) Make sure that the filler dries sufficiently.
 - b) Use 180 grit abrasive paper, G50381 to smooth the filler.
 - c) Use compressed air or a dry cotton wiper, G00034 to remove dust or other contamination.



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- (b) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027 or solvent, B00148.
- (c) Dry the area with a clean cotton wiper, G00034.
- (d) Remove the release paper from the laminate, G02446 or the decorative laminate, G51199 that you want to apply.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 818
Jan 05/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (e) Do these steps to apply the Tedlar decorative laminate, G51199:
- 1) Put the laminate in the correct position.
 - a) Make sure that the pattern is in the correct position. If the patterns are not aligned, the installation will not look satisfactory.
NOTE: Bubbles will result if you let air get below the laminate.
 - 2) Smoothly apply the laminate.
 - a) Use a plastic squeegee, STD-821 and a felt sleeve, G51343 to apply firm and even pressure to the surface of the decorative laminate in the area of the adhesive backing.
 - 3) Work down the length of the panel to completely install the laminate.
 - a) Make sure that no air bubbles are trapped between the applied laminate and the underlying panel.
 - 4) Use a hard rubber roller, STD-745 to do these steps:
 - a) Manually apply 5 lbf (22 N) to 10 lbf (44 N) while moving the tool over the entire face of the laminate.
 - <1> Apply the correct force in the recommended direction.
 - <2> If air bubbles are seen when you use the roller, then remove and replace the decorative laminate.
 - <3> If a 'crackling' sound is heard when you use the roller, then remove and replace the decorative laminate.
- (f) If necessary, do these steps with vacuum pressure to make sure that the laminate touches all of the panel:
- 1) Use the maximum vacuum possible that will not cause damage to the panel.
 - 2) Let the laminate cure for 24 hours at room temperature, for two hours at 120°F (49°C) or for 30 minutes at 180°F (82°C).
 - 3) Let the part cool to 90°F (32°C) before you remove the vacuum pressure.

———— **END OF TASK** ————

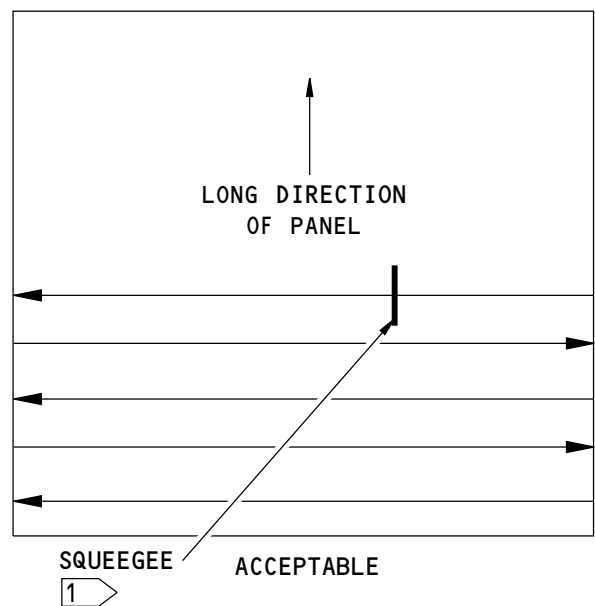
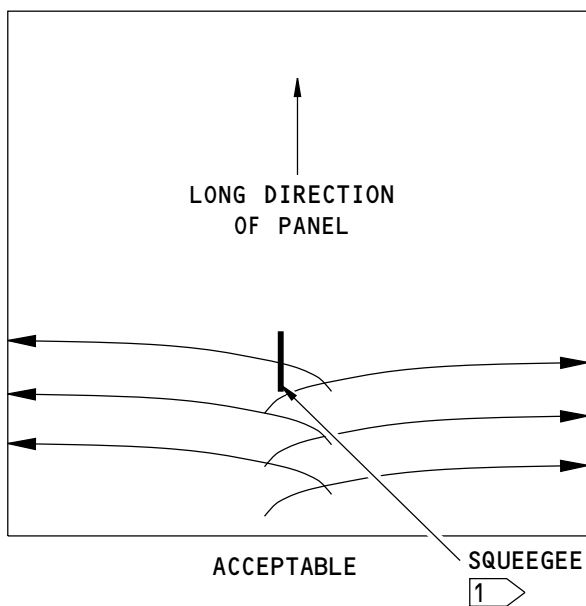
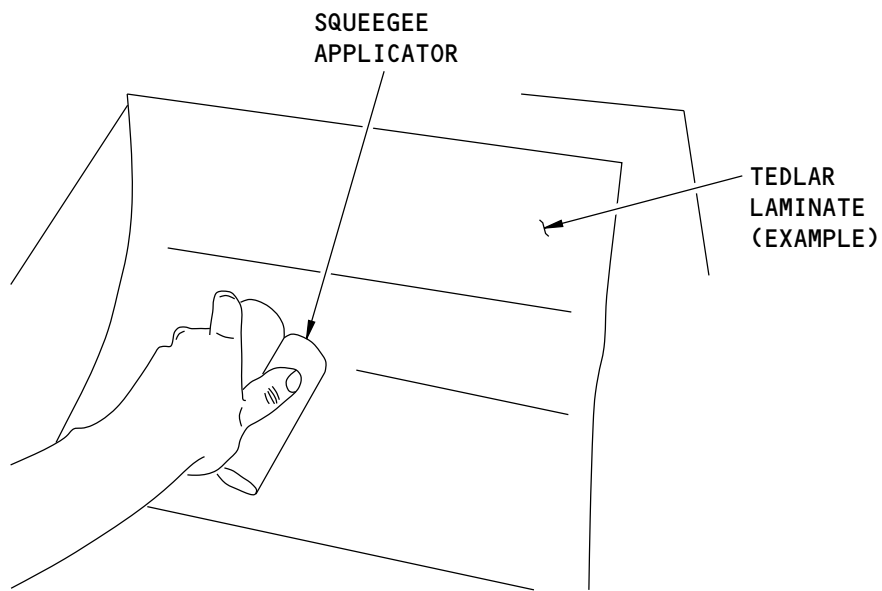
EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 819
Jan 05/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



METHODS FOR LAMINATE INSTALLATION

- 1 SQUEEGEE IS HELD PERPENDICULAR AND IS USED TO SWEEP THE DECORATIVE LAMINATE INTO PLACE ALONG LINES INDICATED ABOVE

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**Decorative Tedlar Laminate Repair
Figure 801/25-00-00-990-802 (Sheet 1 of 2)**

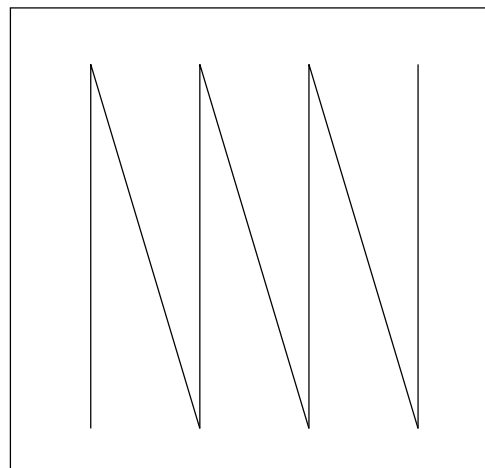
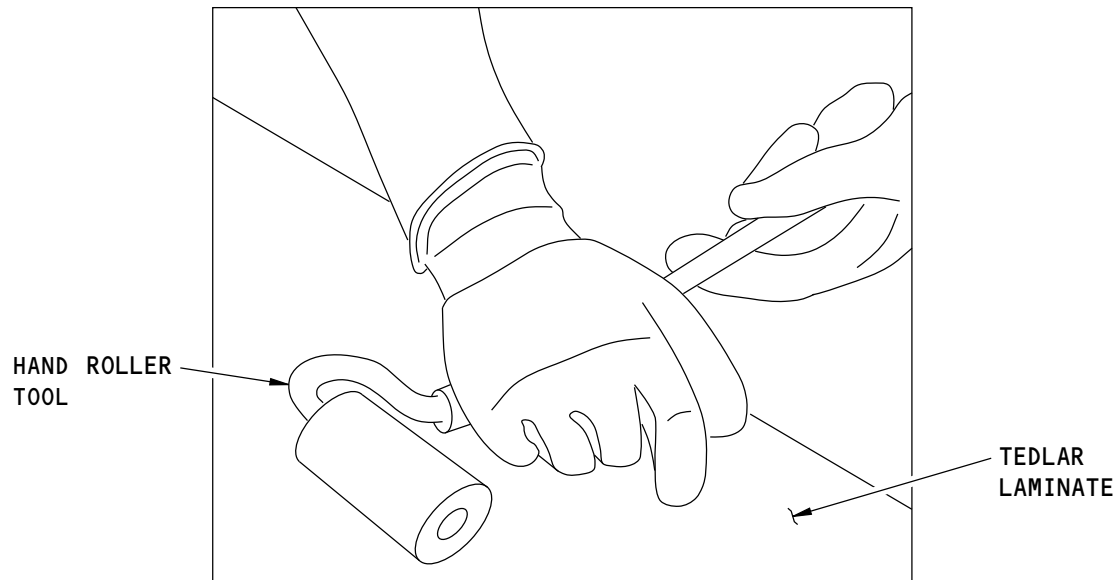
EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 820
Jan 05/2016

 BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



**RECOMMENDED PATTERN
OF FORCE APPLICATION**

METHOD FOR LAMINATE INSTALLATION

2465894 S0000575298_V1

Decorative Tedlar Laminate Repair
Figure 801/25-00-00-990-802 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-00-00

Page 821
Jan 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-00-00-340-803

6. Nomex Honeycomb Sandwich Panels with a Decorative Tedlar Cover Repair

A. General

- (1) This task gives instructions to repair damage that went through the decorative Tedlar laminate into the honeycomb sandwich panels.
- (2) Make sure the area you want to repair is smaller than 100 in² (645 cm²). If the area is larger than 100 in² (645 cm²), you must replace the full decorative tedlar laminate, do this task: Decorative Tedlar Removal/Installation, TASK 25-00-00-900-801 or replace the part.

B. Tools/Equipment

Reference	Description
STD-1089	Source - Vacuum, 0 to -3.00 PSIG

C. Consumable Materials

Reference	Description	Specification
A00273	Adhesive - Epoxy Polyamide, 2 Part, Natural Colored	BMS5-126 Type II Class 1
A50414	Adhesive - Silicone Rubber - RTV 108 (Clear)	BAC5010 Type 60 Class A Grade 2 / MIL-A-46106 Type 1
B00102	Abrasive - Aluminum Oxide Coated Cloth	
B01027	Solvent - Butyl Carbitol (Dow Chemical - E-Series Glycol Ethers)	
C00063	Ink - Screen Printing, Pigmented	BMS10-73 Type I
C00368	Ink - Screen Printing, Clear	BMS10-73 Type II
D00147	Compound - Interior Surface Filling, Polyester Resin	BMS5-136
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00077	Foam - Flame Retardant Rigid Urethane	BMS8-133
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G01288	Tape - Carpet	BMS5-133
G02022	Rubber - Silicone Casting (Must Not Contain Iron Oxide)	
G02446	Laminate - Tedlar	BAC5596 Type 13
G50400	Resin - Fiberglass Layup, Short Worklife, Non-Brominated	BMS8-201 Type IV (Supersedes BMS8-201 Type II)
G51199	Material - Double Flexible Decorative Laminate	BAC5596 Type VIA

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

EFFECTIVITY
ARO ALL

D633W101-ARO

25-00-00

Page 822
May 05/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL

E. Repair Flat Panels or Simple Contoured Panels with a Large Radii

SUBTASK 25-00-00-340-042

- (1) Do these steps to make a texture blanket of the surface that is adjacent to the area you will repair:



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- (a) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.
- (b) Dry the area with a clean cotton wiper, G00034.
- (c) Make a frame, approximately $\frac{3}{8}$ in. (10 mm) wide by $\frac{1}{2}$ in. (13 mm) high, around the clean surface.

NOTE: Use wood, clay, or high temperature vacuum sealant tape for the frame.

- (d) Apply a thin layer of prepared silicone castable silicone rubber, G02022 or RTV 108 adhesive, A50414 on the textured surface in the frame with a brush. Continue to use the brush until you cannot see air bubbles.

NOTE: Almost all brands, types, or colors of castable silicone rubber are satisfactory, but not the dark red types which contain finely divided iron oxide. Dow Corning RTV E, 587, or 93-072, and General Electric RTV41 or RTV61 are also preferred. Prepare the silicone with the manufacturer's instructions.

- (e) Pour the remaining castable silicone rubber, G02022 or RTV 108 adhesive, A50414 on the brushed surface until it is 1/4-inch thick.

NOTE: One pound of castable silicone rubber, G02022 or RTV 108 adhesive, A50414 will make a 10 in. (25 cm) by 10 in. (25 cm) by $\frac{1}{4}$ in. (6 mm) texture blanket.

- (f) Let it cure at room temperature for 48 hours.
- (g) When the silicone castable silicone rubber, G02022 or RTV 108 adhesive, A50414 is dry, remove the texture blanket from the surface.

SUBTASK 25-00-00-340-043

- (2) Attach a template with the correct hole diameter in the damaged area with doubleback carpet tape, G01288. Use a hole saw to remove the damaged area.

NOTE: Use a guard to make sure you do not cut the aft surface of the panel.

SUBTASK 25-00-00-340-044



WARNING

DO NOT TOUCH THE ADHESIVES OR BREATHE THE VAPORS. THE ADHESIVE COMPOUND CONTAINS EPOXY RESINS. THE ADHESIVE CAN CAUSE INJURY TO PERSONS.

- (3) Mix the adhesive. If the adhesive is a four-component system, do the steps that follow:
- (a) Mix the equal parts (by weight) to form Component A of adhesive, A00273.
- (b) Mix the equal parts (by weight) to form Component B of adhesive, A00273.
- (c) Mix equal parts (by weight) of components A and B to make the adhesive mixture.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 823
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-340-045

- (4) Bond a piece of the tedlar laminate, G02446 or the decorative laminate, G51199 of the proper color, design, and texture to a piece of foam, G00077 with the adhesive mixture.

NOTE: The foam thickness must be the same thickness as the honeycomb core from the damaged area.

SUBTASK 25-00-00-340-046

- (5) Let the adhesive cure.

SUBTASK 25-00-00-340-047

- (6) Attach a template to the piece of foam with the doubleback tape.

NOTE: The diameter of hole in the panel must equal the inner diameter of the cutter.

SUBTASK 25-00-00-340-048

- (7) Cut a repair plug from the piece of foam.

SUBTASK 25-00-00-140-012

- (8) Rub the repair plug with abrasive cloth, B00102 paper if it is necessary to get a satisfactory fit.

SUBTASK 25-00-00-340-049

- (9) Bond the repair plug in the cutout with the adhesive mixture.

NOTE: Use the minimum quantity necessary to get a satisfactory bond.

SUBTASK 25-00-00-340-050

- (10) Fill the clearance around the repair plug with compound, D00147.
 - (a) Apply more than is necessary to make sure the clearance is fully filled.

NOTE: The unwanted material is removed in the subsequent step.

SUBTASK 25-00-00-340-052

- (11) Apply Scotch Flatback Masking Tape 250, G00270 to the area around the repair.

SUBTASK 25-00-00-140-013

- (12) Rub the compound, D00147 with 240-320 grit abrasive cloth, B00102 paper until it is smooth and level with the adjacent surfaces.

SUBTASK 25-00-00-370-012

- (13) Apply silk screen ink, C00063 or silk screen ink, C00368 of the correct color to match the adjacent area.

SUBTASK 25-00-00-370-013

- (14) Let the ink dry for 15 minutes.

SUBTASK 25-00-00-340-053

- (15) Apply the texture blanket to the surface you repaired.

SUBTASK 25-00-00-340-119

- (16) Apply vacuum pressure with a vacuum source (0 to -3 PSIG), STD-1089 (approximately 10 inches of Hg).
 - (a) Keep this configuration until the surface is cured (15 minutes at 160°F (71°C)).

F. Repair Panels with Compound Curvature

SUBTASK 25-00-00-340-054

- (1) Attach a template with the correct hole diameter on the damaged area with doubleback carpet tape, G01288.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

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Page 824
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-340-055

- (2) Cut out the damaged area; go through the full thickness of the panel (non-decorative skin too).

SUBTASK 25-00-00-340-056

- (3) In areas where you cannot use a template, do the steps that follow:
 - (a) Drill a ¼ in. (6 mm) hole through the damaged area.
 - (b) Use a hole saw with a ¼ in. (6 mm) pilot to remove the damaged area.

SUBTASK 25-00-00-340-057

- (4) Do these steps to make a texture blanket of the surface that is adjacent to the area you will repair:



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- (a) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.
- (b) Dry the area with a clean cotton wiper, G00034.
- (c) Make a frame that is approximately ⅜ in. (10 mm) wide by ½ in. (13 mm) high, around the clean surface.

NOTE: Use wood, clay, or high temperature vacuum sealant tape for the frame.

- (d) Apply a thin layer of prepared silicone castable silicone rubber, G02022 or RTV 108 adhesive, A50414 on the textured surface in the frame with a brush. Continue to use the brush until you cannot see air bubbles.

NOTE: Almost all brands, types, or colors of castable silicone rubber are satisfactory, but not the dark red types which contain finely divided iron oxide. Dow Corning RTV E, 587, or 93-072, and General Electric RTV41 or RTV61 are also preferred. Prepare the silicone with the manufacturer's instructions.

- (e) Pour the remaining silicone rubber on the brushed surface until it is ¼ in. (6 mm).

NOTE: One pound of silicone castable silicone rubber, G02022 or RTV 108 adhesive, A50414 will make a 10 in. (25 cm) by 10 in. (25 cm) by ¼ in. (6 mm) texture blanket.

- (f) Let it cure at room temperature for 48 hours.
- (g) When the silicone is dry, remove the texture blanket from the surface.

SUBTASK 25-00-00-340-058

- (5) Put the texture blanket over the hole on the decorative face of the panel.

SUBTASK 25-00-00-340-059

- (6) Hold the texture blanket in the correct position with weights or a vacuum bag.
 - (a) In areas where you cannot use a texture blanket, seal the hole with Scotch Flatback Masking Tape 250, G00270 masking tape.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 825
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-340-060



DO NOT GET RESIN, G50400 ADHESIVE IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES. PUT ON A PROTECTIVE SPLASH GOGGLE AND GLOVES. RESIN, G50400 ADHESIVE CONTAINS EPOXY RESINS WHICH CAN CAUSE INJURY TO PERSONS.

- (7) Fill the hole, from the nondecorative side of the panel, with resin, G50400.

NOTE: Chopped fiberglass fibers 1/16 in. (2 mm) can be added into the resin as reinforcement.

SUBTASK 25-00-00-340-061

- (8) Let the adhesive cure at 75 ±5°F (23.9 ±2.8°C) for 8 hours.

SUBTASK 25-00-00-340-062

- (9) Remove the texture blanket or the tape.

SUBTASK 25-00-00-370-014

- (10) Apply silk screen ink, C00063 or silk screen ink, C00368 of the correct color.

SUBTASK 25-00-00-370-015

- (11) Let the silk screen ink dry for 15 minutes.

SUBTASK 25-00-00-340-063

- (12) Apply the texture blanket to the repaired surface, if it is possible.

SUBTASK 25-00-00-340-064

- (13) Apply vacuum pressure, approximately 10 inches of Hg.

SUBTASK 25-00-00-340-065

- (14) Let the surface cure for 15 minutes at 160°F (71°C) before you remove the texture blanket.

————— END OF TASK —————

TASK 25-00-00-340-804

7. Tedlar Laminate Covers of Aluminum Laminate - Repair

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Tedlar Laminate Covers of Aluminum Laminate Repair

SUBTASK 25-00-00-340-066

- (1) To repair scratches or small dents (not more than 0.050-inch depth), do the repair procedures given for Sandwich and Laminate Panel Repairs, TASK 25-00-00-340-801.

————— END OF TASK —————

TASK 25-00-00-340-805

8. Perforated Panel Repair

A. General

- (1) This task gives instructions to do the repairs (not more than 1.5 in. (38.1 mm) in diameter) that follow:
- (a) Acoustical panels that have damage through the decorative surface and fiberglass screen.
 - (b) Apply Tedlar laminate to the surface of the acoustical panels.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

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Page 826
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

B. References

Reference	Title
20-10-26-910-801	Precautions for Heat Devices (P/B 201)

C. Tools/Equipment

Reference	Description
STD-1080	Brush - Paint
STD-1089	Source - Vacuum, 0 to -3.00 PSIG
STD-1125	Heater - Blower, Explosion Proof

D. Consumable Materials

Reference	Description	Specification
A00039	Adhesive - Epibond 126-A/B Epoxy Adhesive (126-A/B System)	
A00040	Resin - Self-Extinguishing Laminating - Epocast 50-A1 with Epocast 9816	BMS8-201 Type III (Long work life)
A00153	Adhesive - Low Odor, Synthetic Rubber Cement	BMS5-30
B00102	Abrasive - Aluminum Oxide Coated Cloth	
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B00153	Solvent - Toluene, Nitration	JAN-T-171 Grade A
B01027	Solvent - Butyl Carbitol (Dow Chemical - E-Series Glycol Ethers)	
C00063	Ink - Screen Printing, Pigmented	BMS10-73 Type I
C00368	Ink - Screen Printing, Clear	BMS10-73 Type II
D00147	Compound - Interior Surface Filling, Polyester Resin	BMS5-136
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G00450	Fabric, Flow Resistant Acoustic	BMS8-64
G01288	Tape - Carpet	BMS5-133
G02446	Laminate - Tedlar	BAC5596 Type 13
G02480	Tape - Mylar, Clear, 3.5 mils, Maximum 16.5" Width - Permacel P-255	
G51199	Material - Double Flexible Decorative Laminate	BAC5596 Type VIA

E. Location Zones

Zone	Area
200	Upper Half of Fuselage

F. Repair the Perforated Panels

SUBTASK 25-00-00-340-067

- (1) Put a routing template, with a hole diameter larger than the damaged area, over the area with damage.
 - (a) Hold the template in the correct position with the doubleback carpet tape, G01288.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 827
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-340-068

- (2) Remove the damaged area with a router.
 - (a) Make sure the depth of the router does not cause damage to the screen below the decorative layer.
 - (b) For panels with Tedlar laminate covers, put one or two layers of Permacel P-255 tape, G02480 over the damaged area and the perforated decorative sheet.

NOTE: This will help prevent damage to the Tedlar laminate.

SUBTASK 25-00-00-340-069

- (3) Remove the flow-resistant fabric.

SUBTASK 25-00-00-340-070

- (4) Mix the adhesive as follows:
 - (a) Mix (by weight) 60 to 65 parts of resin, A00040 with 100 parts of Epibond 126-A/B epoxy adhesive, A00039.



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- (b) Mix (by volume) one part of adhesive mixture with one part of solvent, B00148 and one part of solvent, B00153.

SUBTASK 25-00-00-340-071

- (5) Cut a piece of fabric, G00450 that is larger than the damaged area.

SUBTASK 25-00-00-340-072

- (6) Bond the flow-resistant fabric to a piece of perforated decorative sheet with the adhesive mixture.

SUBTASK 25-00-00-340-073

- (7) Use a routing template and route out a patch from the perforated sheet you made in the previous step.

SUBTASK 25-00-00-140-014

- (8) Rub the patch with abrasive cloth, B00102 to make sure the patch fits correctly in the cutout.

SUBTASK 25-00-00-930-001

- (9) Make two marks on the patch and on the adjacent surface.

NOTE: This will help you install the patch in the position that it has the best fit.

SUBTASK 25-00-00-950-002

- (10) Apply Scotch Flatback Masking Tape 250, G00270 to the decorative side of the patch and around the cutout area.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 828
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-110-029



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- (11) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.

SUBTASK 25-00-00-160-010

- (12) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-340-074

- (13) Apply a heavy layer of the mixed adhesive with a paint brush, STD-1080 on the surfaces of the patch and the cutout.

SUBTASK 25-00-00-340-075

- (14) Let the adhesive dry for 10 minutes.

SUBTASK 25-00-00-950-003

- (15) Remove the masking tape from the patch and the panel.

SUBTASK 25-00-00-340-076

- (16) Apply the doubleback carpet tape, G01288 to the decorative side of the patch and to the area around the cutout.

NOTE: The patch marks you made must be shown.

SUBTASK 25-00-00-350-001

- (17) Put the patch on a 6 in. (15 cm) by 6 in. (15 cm) or a 8 in. (20 cm) by 8 in. (20 cm), ¼ in. (6 mm) thick piece of Plexiglas.

SUBTASK 25-00-00-340-077

- (18) Put the flow-resistant fabric between the patch and the fiberglass screen.

SUBTASK 25-00-00-340-078

- (19) Put the patch into the cutout.

SUBTASK 25-00-00-820-001

- (20) Look through the Plexiglas to align the marks that you made.

SUBTASK 25-00-00-820-002

- (21) Apply pressure to the Plexiglas, as necessary, to make sure that the patch is level with the adjacent surfaces.

SUBTASK 25-00-00-340-079

- (22) Let the patch cure for 24 hours at room temperature, or for 3 hours at 120 ±5°F (49 ±3°C).

SUBTASK 25-00-00-340-080

- (23) Put the compound, D00147 in all of the cracks that you can see.

SUBTASK 25-00-00-340-081

- (24) Let the compound, D00147 cure.

SUBTASK 25-00-00-950-004

- (25) Apply Scotch Flatback Masking Tape 250, G00270 to the area around the repair.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 829
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-140-015

- (26) Rub the compound, D00147 with abrasive cloth, B00102 until it is smooth and flush with the adjacent surfaces.

SUBTASK 25-00-00-370-016

- (27) Apply silk screen ink, C00063 or silk screen ink, C00368 of the correct color to match the adjacent area.

SUBTASK 25-00-00-370-017

- (28) Let the ink dry for 15 minutes.

SUBTASK 25-00-00-340-082

- (29) Drill holes to make perforations if it is necessary.

NOTE: Use a piece of perforated material for a template.

G. Apply Tedlar laminate to Acoustical (Perforated) Panels

SUBTASK 25-00-00-010-002

- (1) Remove the trim strips from the panel.

SUBTASK 25-00-00-140-016

- (2) Rub the area where you will apply the adhesive with abrasive cloth, B00102 paper until the area is not glossy.

SUBTASK 25-00-00-110-030



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- (3) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.

SUBTASK 25-00-00-160-011

- (4) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-340-083



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- (5) Mix (by volume) one part of adhesive, A00153 adhesive with one part of solvent, B00148.

SUBTASK 25-00-00-340-084

- (6) Carefully apply the mixture to the surface with a paint brush, STD-1080.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 830
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-340-085



CAUTION

LET THE SURFACE BECOME TACKY BEFORE YOU INSTALL THE TEDLAR LAMINATE. IF YOU INSTALL THE TEDLAR LAMINATE TO A WET SURFACE, YOU WILL NOT GET A SATISFACTORY BOND.

- (7) Let the surface dry at room temperature for a minimum of 2 hours.

SUBTASK 25-00-00-340-086

- (8) Put the Tedlar laminate, G02446 or the decorative laminate, G51199 in the correct position.
- (a) Use Scotch Flatback Masking Tape 250, G00270 to hold the Tedlar laminate, G02446 or the decorative laminate, G51199 in the correct position.
- (b) If you use perforated a Tedlar laminate for the repair, align the holes in the Tedlar laminate with the holes in the panel you will cover.

SUBTASK 25-00-00-340-087

- (9) Use the explosion proof heater, STD-1125 to increase the temperature of the Tedlar laminate.
- (a) Be careful to make sure the temperature is constant across the surface of the laminate. Refer to (TASK 20-10-26-910-801) for CAUTIONS to obey when you use a heat gun: Heat Guns, Soldering Guns, and Soldering Irons.

SUBTASK 25-00-00-340-088

- (10) Do these steps with a vacuum source (0 to -3 PSIG), STD-1089 to make sure the laminate touches all of the panel:
- (a) Use the maximum vacuum possible that will not cause damage to the panel.
- (b) Let the laminate cure for 24 hours at room temperature, for two hours at 120°F (49°C) or for 30 minutes at 180°F (82°C).
- (c) Let the part cool to 90°F (32°C) before you remove the vacuum pressure.

— END OF TASK —

TASK 25-00-00-340-806

9. Polycarbonate (Lexan), ULTEM, Radel, and Declar Plastics Repair

A. General

- (1) This task give instructions to repair the cracks and gouges in the decorative and nondecorative plastics.
- (2) Make sure the following conditions exist before beginning repair:
- (a) Make sure the area you want to repair is smaller than 100 square inches. If the area is larger than 100 square inches, you must replace the part

B. References

Reference	Title
25-00-00-370-801	Equipment and Furnishings Painting (P/B 701)

C. Consumable Materials

Reference	Description	Specification
A00112	Hardener - Adhesive - Hysol 3561	
A50005	Resin - Adhesive, Flame-Out Casting - Hysol EE1067	
B00102	Abrasive - Aluminum Oxide Coated Cloth	

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 831
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description	Specification
B01027	Solvent - Butyl Carbitol (Dow Chemical - E-Series Glycol Ethers)	
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Repair the Cracked Areas

SUBTASK 25-00-00-340-089

- (1) Drill a 1/16-inch diameter hole at each end of the crack.

SUBTASK 25-00-00-340-090

- (2) Remove the material from the crack until the width of the crack is approximately equal to the thickness of the part.

SUBTASK 25-00-00-140-017

- (3) Rub the surface with abrasive cloth, B00102 paper until the surface is not glossy.

SUBTASK 25-00-00-110-031

 WARNING	DO NOT GET SOLVENTS IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. PUT ON A RESPIRATOR, PROTECTIVE SPLASH GOGGLES, AND GLOVES WHEN YOU USE SOLVENTS. KEEP THE SOLVENTS AWAY FROM SPARKS, FLAME, AND HEAT. SOLVENTS ARE POISONOUS AND FLAMMABLE. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (4) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.

SUBTASK 25-00-00-160-012

- (5) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-00-00-340-091

- (6) If the part you want to repair is a Declar part, apply primer to the surface.

SUBTASK 25-00-00-340-092

- (7) Mix the repair resin as follows:

- (a) Mix one hundred parts of Hysol EE1067 resin, A50005 with 15 or 16 parts of Hysol 3561 hardener, A00112.

SUBTASK 25-00-00-340-093

- (8) Fill the crack with the mixed repair resin.

SUBTASK 25-00-00-340-094

- (9) Let the repair resin cure until it is hard.

SUBTASK 25-00-00-340-095

- (10) Apply glass fabric that is wet with the repair resin to make the repair stronger.

SUBTASK 25-00-00-160-013

- (11) Remove all of the unwanted resin.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 832
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-340-096

- (12) Let the repair cure until it is hard at a temperature between 70 and 130 °F.

SUBTASK 25-00-00-140-018

- (13) Rub the area with the abrasive cloth, B00102 paper until the repair is smooth.

SUBTASK 25-00-00-340-097

- (14) Apply the water emulsion finish to the area.

SUBTASK 25-00-00-370-018

- (15) If you will paint the part out of the airplane, use the primer and paint and refer to this procedure: do this task: Equipment and Furnishings Painting, TASK 25-00-00-370-801.

F. Repair the Gouged Areas

SUBTASK 25-00-00-340-098

- (1) If there is not a dent in the gouge, make the gouge smooth with the abrasive cloth, B00102 paper.

SUBTASK 25-00-00-340-099

- (2) If the appearance is not satisfactory after it is smooth, fill the gouge with repair resin.

SUBTASK 25-00-00-340-100

- (3) Complete the repair with this task: Repair the Cracked Areas.

SUBTASK 25-00-00-340-101

- (4) If the surface has dents, remove the area with dents and do this task: Repair the Cracked Areas.

————— END OF TASK —————

TASK 25-00-00-340-807

10. Urethane Foam Repair

A. General

- (1) The task that follows gives instructions to repair the urethane foam material with these alternatives:
 - (a) Repair the foam with a Plug
 - (b) Repair the foam with an adhesive resin
- (2) The use of BMS 8-39 Urethane foam for replacement or repair of insulation in areas where it is used to prevent fire or smoke penetration is not permitted due to the degradation in flammability properties over time.
 - (a) BMS8-371 insulation foam or BMS1-68 silicone foam rubber replaces BMS8-39 Urethane foam in areas where it is used to prevent fire or smoke penetration. The selection of either BMS8-371 or BMS1-68 material will be based on requirements for use and its location in the airplane. BMS8-39 foam is replaced in areas of the airplane where it is not easy to access for fire and smoke detection or suppression. The BMS8-39 foam is also replaced in areas where it is used to prevent fire or smoke penetration. It is not replaced in areas where it is encapsulated by a protective fire resistant barrier or where it is physically isolated from an ignition source.

NOTE: Foam pads installed at insulation blanket penetrations and foam seals around systems penetrations are affected by AD 2013-11-04.

- (b) Refer to PAGEBLOCK 53-17-00/201 for flight compartment and cargo compartment foam Urethane foam identification and replacement.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

ECCN 9E991 BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

Page 833
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

B. Consumable Materials

Reference	Description	Specification
A00188	Adhesive - Urethane, Two Component	BMS5-105 Type V
A01021	Compound - Honeycomb Edge Filling & Potting, Epoxy Based, 2 Part, RT Cure (12-25 Min Gel)	BMS5-28 Type 18
D00091	Oil - General Purpose, Low Temperature, Lubricating	MIL-PRF-7870 (NATO O-142)
G00111	Sheet - Mylar	
G01288	Tape - Carpet	BMS5-133

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Repair the Foam with a Plug

SUBTASK 25-00-00-340-102

- (1) Remove the damage with a cork bore or an equivalent tool.

NOTE: The tool size must be equal to the size of the damaged area, or up to a 1/2-inch larger in diameter.

SUBTASK 25-00-00-340-103

- (2) Use the same tool to cut a repair plug from the foam to fit in the damaged area.

SUBTASK 25-00-00-340-104

- (3) Apply a layer of the adhesive, A00188 adhesive to each surface of the repair plug and the damaged area.

SUBTASK 25-00-00-340-105

- (4) Push the repair plug into the damaged area with hand pressure.

NOTE: Do not stress the adhesive bond for 24 hours.

E. Repair the Foam with Adhesive Resin

SUBTASK 25-00-00-340-106

- (1) Remove the damage with a cork bore or an equivalent tool.

NOTE: The tool size must be equal to the size of the damaged area, or up to a 1/2-inch larger in diameter.

SUBTASK 25-00-00-340-107

- (2) Use the manufacturer's instructions to mix the compound, A01021.

SUBTASK 25-00-00-340-108

- (3) Fill the area fully with the compound, A01021 (potting compound).

SUBTASK 25-00-00-340-109

- (4) Put a sheet of mylar sheet, G00111 over the potting compound.

NOTE: The mylar film must go approximately 2 inches more than the outer edge of all sides of the filled area.

SUBTASK 25-00-00-340-110

- (5) Put a small amount of the oil, D00091 on the top surface of the mylar film.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

ECCN 9E991 BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

Page 834
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-340-111

- (6) Start at the center of the repair and rub the potting compound with a squeegee until you get the shape necessary.

SUBTASK 25-00-00-340-112

- (7) Apply the carpet tape, G01288 to hold the mylar film in the correct position.

SUBTASK 25-00-00-340-113

- (8) Let the compound cure for 1 hour at room temperature and then 5 hours at 115 °F.

SUBTASK 25-00-00-340-114

- (9) Carefully remove the mylar film after the compound has cured.

————— **END OF TASK** —————

TASK 25-00-00-350-801

11. Repair Aluminum Trim

A. General

- (1) This procedure gives instructions to repair aluminum trim.

B. References

Reference	Title
20-10-26-910-801	Precautions for Heat Devices (P/B 201)

C. Consumable Materials

Reference	Description	Specification
A00028	Adhesive - Modified Epoxy For Rigid PVC, Foam Cored Sandwiches	BAC5010 Type 70 (BMS5-92 Type 1)
A00279	Adhesive - Fast-Setting Epoxy	BMS5-123 or BAC5010 Type 71
D00147	Compound - Interior Surface Filling, Polyester Resin	BMS5-136
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G01601	Abrasive - Aluminum Oxide Coated Cloth, 400 to 600 grit	

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Repair aluminum trim

SUBTASK 25-00-00-350-002

- (1) Remove any fasteners from the aluminum trim if they are installed.

SUBTASK 25-00-00-020-001

- (2) Remove the aluminum trim from the panel.
 - (a) If the trim is bonded, use a heat gun (1,200-1,500 watts) to help remove the trim, (TASK 20-10-26-910-801).
 - 1) Apply heat while pulling trim away from the panel.
 - 2) Remove the trim progressively from one end to the other.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

ECCN 9E991 BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

Page 835
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-840-001

- (3) Restore the trim to its original straightness and contour.

NOTE: Use metal working techniques to remove dents and straighten the trim as much as possible.

SUBTASK 25-00-00-410-001

- (4) Put the trim onto the panel and reattach any fasteners.

- (a) If the trim is applied with fasteners and adhesive, apply epoxy adhesive to the edge of the panel and quickly reattach the trim with the fasteners.
- (b) If the trim is applied with adhesive only, apply an epoxy adhesive to the edge of the panel and quickly position the trim.

NOTE: adhesive, A00279 has a very short working life. If more time is required for the repair, use an adhesive such as adhesive, A00028.

- (c) Use Scotch Flatback Masking Tape 250, G00270 to hold the trim in the correct position until the adhesive is fully cured.

SUBTASK 25-00-00-300-001

- (5) Fill any dents, gouges, or imperfections with compound, D00147 to make a crown above the adjacent area.

- (a) After the compound, D00147 is hard, rub it with 400 to 600 grit abrasive cloth, G01601 to the same level as the surface of the panel.

SUBTASK 25-00-00-370-019

- (6) Apply aluminum spray paint to the repaired area. Any commercially available spray paint is acceptable.

————— END OF TASK —————

TASK 25-00-00-350-803

12. Repair of Stowage Bin Edge Cap

A. General

- (1) This procedure gives instructions to repair stowage bin edge cap.

B. References

Reference	Title
20-10-26-910-801	Precautions for Heat Devices (P/B 201)
20-30-83-910-801	General Cleaning of Composites (Series 83) (P/B 201)

C. Tools/Equipment

Reference	Description
STD-183	Cleaner - Vacuum
STD-449	Gun - Sealant
STD-6554	Gun - Heat

D. Consumable Materials

Reference	Description	Specification
A00870	Adhesive - Urethane Adhesive for Bonding, 2 Part, Room Temp Cure (for automatic blending)	BMS5-105 Type II
A50091	Adhesive - Urethane	BAC5010 Type 82 (BMS5-105)

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

ECCN 9E991 BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

Page 836
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description	Specification
B00137	Abrasive - Garnet Coated Paper	
B50095	Solvent	BAC5750
D00147	Compound - Interior Surface Filling, Polyester Resin	BMS5-136
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G01601	Abrasive - Aluminum Oxide Coated Cloth, 400 to 600 grit	

E. Location Zones

Zone	Area
200	Upper Half of Fuselage

F. Repair of Stowage Bin Edge Cap

SUBTASK 25-00-00-020-018

- (1) Remove the stowage bin edge cap from the panel.
 - (a) Use a heat gun, STD-6554, to help remove the plastic trim (TASK 20-10-26-910-801).
 - 1) Apply heat while you pull the trim away from the panel.
 - 2) Remove the trim progressively from one end to the other.

SUBTASK 25-00-00-120-002

- (2) If it is necessary, lightly abrade the panel edge with abrasive, B00137, to level out any high spots of adhesive.

NOTE: You do not need to remove all the used adhesive.

- (a) Remove all dust or debris with a vacuum cleaner, STD-183.

SUBTASK 25-00-00-300-004

- (3) Fill any dents, gouges, or imperfections in the panel surface with compound, D00147, or equivalent.
 - (a) After the compound, D00147, is hard, rub it with 400 to 600 grit abrasive cloth, G01601, to the same level as the surface of the panel.
 - (b) Remove all dust or debris with a vacuum cleaner, STD-183.

SUBTASK 25-00-00-100-019

- (4) Clean inside surface of the trim with solvent, B50095 (TASK 20-30-83-910-801).
 - (a) Remove all dust or debris with a cotton wiper, G00034, before the solvent dries.

SUBTASK 25-00-00-340-122

- (5) Use a sealant gun, STD-449 (or equivalent), to apply a layer of BMS5-105 Type VI adhesive, A50091, or adhesive, A00870, to inside surface of the trim.
 - (a) Make sure the adhesive is continuous and approximately 0.25 in. (6.35 mm) in radius

SUBTASK 25-00-00-410-005

- (6) Carefully put the trim onto the panel.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 837
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (a) Use a cotton wiper, G00034, with solvent, B50095, to remove excess adhesive squeeze out between the panel and the trim (TASK 20-30-83-910-801).

NOTE: Do not use unblended isopropyl alcohol as a cleaning solvent.

- 1) Do not let solvent flow into the bond line.
 - 2) Cut the trim to fit the panel as necessary.
- (b) Use Scotch Flatback Masking Tape 250, G00270 (or equivalent), to hold the trim in the correct position until the adhesive is fully cured.
- 1) Apply the tape approximately 4 in. (102 mm) apart and not more than 1 in. (25 mm) from trim ends.
- (c) Remove the tape after the adhesive is fully cured.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-00-00

Page 838
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

EQUIPMENT AND FURNISHINGS - DDG MAINTENANCE PROCEDURES

1. General

A. This procedure has these tasks:

- (1) DDG 25-11-1 Preparation - Flight Crew Seat Inoperative Procedure
- (2) DDG 25-11-1 Restoration - Flight Crew Seat Inoperative Procedure
- (3) DDG 25-18-1 Preparation - Flotation Equipment Inoperative (EASA)
- (4) DDG 25-18-1 Restoration - Flotation Equipment Inoperative (EASA)
- (5) DDG 25-25-1 Preparation - Flight Attendant Seat Inoperative Procedure
- (6) DDG 25-25-1 Restoration - Flight Attendant Seat Inoperative Procedure
- (7) DDG 25-25-2 Preparation - Passenger Seat Inoperative Procedure
- (8) DDG 25-25-2 Restoration - Passenger Seat Inoperative Procedure
- (9) DDG 25-25-4 Preparation - Crew/Attendant Rest Seats
- (10) DDG 25-25-4 Restoration - Crew/Attendant Rest Seats
- (11) DDG 25-28-1 Preparation - Overhead Storage Bins/Cabin and Galley Storage Compartments/Closets
- (12) DDG 25-28-1 Restoration - Overhead Storage Bins/Cabin and Galley Storage Compartments/Closets
- (13) DDG 25-29-1 Preparation - Flight Crew Rest (FCR) Door
- (14) DDG 25-29-1 Restoration - Flight Crew Rest (FCR) Door
- (15) DDG 25-29-2 Preparation - Main Deck Crew Rest (MDCR)/Main Deck Flight Crew Rest (MDFCR) Door
- (16) DDG 25-29-2 Restoration - Main Deck Crew Rest (MDCR)/Main Deck Flight Crew Rest (MDFCR) Door
- (17) DDG 25-29-3 Preparation - Overhead Flight Crew and Attendant Rest Doors
- (18) DDG 25-29-3 Restoration - Overhead Flight Crew and Attendant Rest Doors
- (19) DDG 25-29-4 Preparation - Flight Crew and Attendant Rests (OFCR, OFAR, FCR, MDCR, MDFCR, LLAR)
- (20) DDG 25-29-4 Deactivation - Flight Crew and Attendant Rests (OFCR, OFAR, FCR, MDCR, MDFCR, LLAR)
- (21) DDG 25-30-1 Preparation - Galley Waste Container Door/Cover Inoperative
- (22) DDG 25-30-1 Restoration - Galley Waste Container Door/Cover Inoperative
- (23) DDG 25-40-1 Preparation - Interior Lavatory Ashtrays Inoperative (EASA)
- (24) DDG 25-40-1 Restoration - Interior Lavatory Ashtrays Inoperative (EASA)
- (25) DDG 25-41-2 Preparation - Lavatory Waste Container Flapper/Access Door Inoperative
- (26) DDG 25-41-2 Restoration - Lavatory Waste Container Flapper/Access Door Inoperative
- (27) DDG 25-53-2 Preparation - Lower Lobe Cargo Compartment Restraint Components Inoperative
- (28) DDG 25-53-2 Restoration - Lower Lobe Cargo Compartment Restraint Components Inoperative
- (29) DDG 25-63-3 Preparation - Portable Emergency Locator Transmitter Inoperative (EASA)
- (30) DDG 25-63-3 Restoration - Portable Emergency Locator Transmitter Inoperative (EASA)

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 901
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-00-00-040-801

2. DDG 25-11-1 Preparation - Flight Crew Seat Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when one or more flight crew seat assembly positions do not operate correctly.

B. Tools/Equipment

Reference	Description
STD-1062	Lock - Circuit breaker, Open Position, Approved for Flight

C. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

D. Flight Crew Seat Deactivation

SUBTASK 25-00-00-040-034

- (1) Deactivate the inoperative flight crew seat power adjustment function:

- (a) For the Captain's seat, open and collar this circuit breaker:

Left Power Management Panel, P110

Row	Col	Number	Name
D	18	C25323	CAPT SEAT

For the First Officer's seat, open and collar this circuit breaker:

Right Power Management Panel, P210

Row	Col	Number	Name
B	13	C25324	F/O SEAT

- (b) Use the approved for flight, open position circuit breaker lock, STD-1062 on these circuit breakers.

SUBTASK 25-00-00-040-001

- (2) Do the steps that follow for seats that have the recline adjustment inoperative:

- (a) Make sure the affected seat is secured in the upright position and is acceptable to the affected crew member

SUBTASK 25-00-00-040-002

- (3) Do the steps that follow for seats that have an inoperative armrest:

- (a) Make sure the inoperative armrest is stowed in the retracted position and is acceptable to the affected crew member.

SUBTASK 25-00-00-040-003

- (4) Crew seats can have the lumbar and thigh supports inoperative if the seat is acceptable to the affected crew member.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 902
May 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-00-00-440-801

3. DDG 25-11-1 Restoration - Flight Crew Seat Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).
- (2) This task puts the airplane back to its usual condition after operating with one or more flight crew seats assemblies that do not operate correctly.

B. References

Reference	Title
25-11-01-000-801	Captain and First Officer Seat Removal (P/B 401)
25-11-01-400-801	Captain and First Officer Seat - Installation (P/B 401)

C. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

D. Flight Crew Seat Reactivation

SUBTASK 25-00-00-900-001

- (1) Replace the flight crew seat that does not operate correctly.
These are the tasks:
Captain and First Officer Seat Removal, TASK 25-11-01-000-801
Captain and First Officer Seat - Installation, TASK 25-11-01-400-801

———— **END OF TASK** ————

TASK 25-00-00-040-820

4. DDG 25-18-1 Preparation - Flotation Equipment Inoperative (EASA)

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviation Guide (DDG). These tasks prepare the airplane for flight with flotation equipment that does not operate.
 - (a) This procedure is only for aircraft using the EASA MMEL. DDG Maintenance procedures with no regulatory authority identification in the procedure title apply to both FAA and EASA MMELs.

B. Prepare for Deactivation

SUBTASK 25-00-00-040-032

- (1) Do one of the steps that follow:
 - (a) Remove the equipment that can not operate from the airplane.
 - (b) Put a placard with "INOPERATIVE" on the unit.
 - 1) Stow the equipment that can not operate in an approved location that can not be seen.
 - 2) Put a placard with "INOPERATIVE" on the stowage location.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 903
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-040-033

- (2) Make sure that the necessary distribution of operative equipment is kept in the airplane.

————— END OF TASK —————

TASK 25-00-00-440-819

5. DDG 25-18-1 Restoration - Flotation Equipment Inoperative (EASA)

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviation Guide (DDG). These tasks return the airplane to its usual condition after operation with flotation equipment that does not operate.
 - (a) This procedure is only for aircraft using the EASA MMEL. DDG Maintenance procedures with no regulatory authority identification in the procedure title apply to both FAA and EASA MMELs.

B. Flotation Equipment - Activation

SUBTASK 25-00-00-440-010

- (1) Install the flotation equipment at the necessary locations.
 - (a) Make sure that the necessary quantity of flotation equipment is in the airplane.
 - (b) Remove the 'INOPERATIVE' placard.

————— END OF TASK —————

TASK 25-00-00-040-802

6. DDG 25-25-1 Preparation - Flight Attendant Seat Inoperative

A. General

- (1) This procedure is a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight with applicable system/components inoperative.
- (2) This task prepares the airplane for flight with one required flight attendant seat or an assembly (two seat positions) inoperative.
- (3) A flight attendant seat is inoperative if one or more of these conditions are present:
 - (a) An automatic folding seat will not stow automatically.
 - (b) A seat position with a seat belt that is missing or does not operate.
- (4) This task applies to the wall-mounted and the floor-mounted attendant seats.
- (5) A flight attendant seat can be inoperative on:
 - (a) Airplane carrying passengers
NOTE: DDG 25-25-01-01A
 - (b) Airplane not carrying passengers
NOTE: DDG 25-25-01-01B

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 904
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

C. Required Flight Attendant Seat Assembly Deactivation

SUBTASK 25-00-00-040-004

- (1) Do these steps for an inoperative flight attendant seat on an airplane carrying passengers:
 - (a) Secure the seat in the stowed or retracted position.
 - 1) Apply tape to secure the seat in the stowed position if it is necessary.
 - (b) Install an INOP placard on the affected seat..
 - (c) If a passenger seat is assigned to the flight attendant, install FOR FLIGHT ATTENDANT USE ONLY placard at the seat.

SUBTASK 25-00-00-040-005

- (2) Do these steps for an inoperative flight attendant seat on an airplane not carrying passengers:
 - (a) Apply tape to secure the seat in the stowed or retracted position.
 - (b) Install an INOP placard on the affected seat.

————— END OF TASK —————

TASK 25-00-00-440-802

7. DDG 25-25-1 Restoration - Flight Attendant Seat Inoperative

A. General

- (1) This procedure is a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).
- (2) This task puts the airplane back to its usual condition after a flight with one required flight attendant seat or an assembly (two seat positions) inoperative.
- (3) A flight attendant seat is inoperative if one or more of these conditions are present:
 - (a) An automatic folding seat will not stow automatically.
 - (b) A seat position with a seat belt that is missing or does not operate.
- (4) This task applies to the wall-mounted and the floor-mounted flight attendant seats.
- (5) A flight attendant seat can be inoperative on:
 - (a) Airplane carrying passengers
NOTE: DDG 25-25-01-01A
 - (b) Airplane not carrying passengers
NOTE: DDG 25-25-01-01B

B. References

Reference	Title
25-25-06-000-801	Attendant Seat Removal (P/B 401)
25-25-06-000-802	Attendant Seat Removal (P/B 401)
25-25-06-000-806	Attendant Seat Removal (P/B 401)
25-25-06-400-801	Attendant Seat Installation (P/B 401)
25-25-06-400-802	Attendant Seat Installation (P/B 401)
25-25-06-400-806	Attendant Seat Installation (P/B 401)

C. Location Zones

Zone	Area
221	Passenger Compartment, Left - Section 41
222	Passenger Compartment, Right - Section 41

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 905
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Required Flight Attendant Seat Reactivation

SUBTASK 25-00-00-960-002

- (1) For a flight attendant seat that is inoperative, do these tasks to replace the seat: Attendant Seat Removal, TASK 25-25-06-000-801 or Attendant Seat Removal, TASK 25-25-06-000-802 or Attendant Seat Removal, TASK 25-25-06-000-806, and Attendant Seat Installation, TASK 25-25-06-400-801 or Attendant Seat Installation, TASK 25-25-06-400-802 or Attendant Seat Installation, TASK 25-25-06-400-806

————— END OF TASK —————

TASK 25-00-00-040-803

8. DDG 25-25-2 Preparation - Passenger Seat Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when a passenger seat does not operate correctly

B. References

Reference	Title
25-25-01-000-801	Passenger Seat - Removal (P/B 401)

C. Location Zones

Zone	Area
221	Passenger Compartment, Left - Section 41
222	Passenger Compartment, Right - Section 41

D. Passenger Seat Deactivation

SUBTASK 25-00-00-040-006

- (1) Do these steps for a passenger seat with an inoperative recline mechanism:
 - (a) Secure the seat in the upright position.
 - (b) Refer to the seat manufacturer's specifications to safety the seat in the upright position.
- NOTE: The seat may be used during flight if the seat belts operate correctly.

SUBTASK 25-00-00-040-007

- (2) Do these steps for a passenger seat that is inoperative:
 - (a) Make sure that the inoperative passenger seat does not cause a blockage to the aisle or the emergency exit
 - (b) If the inoperative seat does cause a blockage to an emergency exit
 - 1) Do this task: Passenger Seat - Removal, TASK 25-25-01-000-801
 - (c) If the inoperative seat does cause a blockage to the aisle:
 - 1) Safety the row of seats aft of the inoperative passenger seat.
 - (d) If the inoperative seat does not cause a blockage:
 - 1) Block affected seat row and placard entire row "DO NOT OCCUPY".

————— END OF TASK —————

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 906
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-00-00-440-803

9. DDG 25-25-2 Restoration - Passenger Seat Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).
- (2) This task puts the airplane back to its usual condition after operating with a passenger seat that does not operate correctly.

B. References

Reference	Title
25-25-01-000-801	Passenger Seat - Removal (P/B 401)
25-25-01-400-801	Passenger Seat - Installation (P/B 401)

C. Location Zones

Zone	Area
221	Passenger Compartment, Left - Section 41
222	Passenger Compartment, Right - Section 41

D. Passenger Seat Reactivation

SUBTASK 25-00-00-900-002

- (1) If the inoperative seat caused a blockage to an emergency exit:
Do this task: Passenger Seat - Installation, TASK 25-25-01-400-801

SUBTASK 25-00-00-900-003

- (2) If the inoperative seat caused a blockage to the aisle
 - (a) Replace the passenger seat(s) that does not operate correctly.
These are the tasks:
Passenger Seat - Removal, TASK 25-25-01-000-801
Passenger Seat - Installation, TASK 25-25-01-400-801

————— **END OF TASK** —————

TASK 25-00-00-040-810

10. DDG 25-25-4 Preparation - Crew/Attendant Rest Seats Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when a crew/attendant seat does not operate correctly.

B. Location Zones

Zone	Area
221	Passenger Compartment, Left - Section 41
222	Passenger Compartment, Right - Section 41

C. Passenger Seat Deactivation

SUBTASK 25-00-00-040-017

- (1) Do these steps for a crew/attendant rest seat with an inoperative recline mechanism:
 - (a) Secure the seat in the full upright position.

NOTE: The seat may be used during flight if the seat belts operate correctly.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 907
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-040-018

- (2) Do these steps for a crew/attendant rest seat with an inoperative arm rest:
 - (a) Stow the arm rest in the retracted position or remove the armrest.

SUBTASK 25-00-00-040-036

- (3) Block the affected inoperative seats.

————— END OF TASK —————

TASK 25-00-00-440-810

11. DDG 25-25-4 Restoration - Crew/Attendant Rest Seats Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).
- (2) This task puts the airplane back to its usual condition after operating with a crew/attendant rest seat that does not operate correctly.

B. Location Zones

Zone	Area
221	Passenger Compartment, Left - Section 41
222	Passenger Compartment, Right - Section 41

C. Crew/Attendant Rest Seat Reactivation

SUBTASK 25-00-00-440-003

- (1) If the inoperative seat had a faulty recline mechanism:
 - (a) Refer to the seat manufacturers instructions to repair or replace the recline mechanism.

SUBTASK 25-00-00-440-004

- (2) If the inoperative seat had a faulty arm rest:
 - (a) Refer to the seat manufacturers instructions to repair or replace the arm rest.

SUBTASK 25-00-00-900-005

- (3) Unblock the affected inoperative seats.

————— END OF TASK —————

TASK 25-00-00-040-811

12. DDG 25-28-1 Preparation - Overhead Storage Bins/Cabin, Galley and Lavatory Storage Compartments/Closets

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when overhead storage bins or cabin, galley and lavatory storage compartments or closets do not operate correctly.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 908
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

C. Overhead Storage Compartment Inoperative.

SUBTASK 25-00-00-040-019

- (1) Do these steps as they apply to your situation for an inoperative overhead storage bin or cabin bin or galley and lavatory storage compartment or closet compartment:

NOTE: One latch/lug per compartment may be inoperative if the remaining latch(es)/lug(s) on affected compartments operates normally.

NOTE: Storage compartment key locks may be inoperative in the unlocked position provided doors can be secured by other means.

- (a) Secure the inoperative compartments closed.

- 1) Associated bin or compartment (do not use for storage of any items, except those permanently affixed) is prominently placarded DO NOT USE.

NOTE: If no partitions are installed, the entire overhead storage compartment is considered one bin or compartment.

- (b) Remove the affected compartment door.

NOTE: Associated bin or compartment is not used for storage of any items, except those permanently affixed.

- 1) Associated bin or compartment (do not use for storage of any items, except those permanently affixed) is prominently placarded DO NOT USE.

NOTE: If no partitions are installed, the entire overhead storage compartment is considered one bin or compartment.

NOTE: Any emergency equipment located in the associated compartment (permanently affixed) is available for use.

————— END OF TASK —————

TASK 25-00-00-440-811

13. DDG 25-28-1 Restoration - Overhead Storage Bins/Cabin, Galley and Lavatory Storage Compartments/Closets

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).
- (2) This task puts the airplane back to its usual condition after operating with overhead storage bins/cabin, galley and lavatory storage compartments/closets that do not operate correctly.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-00-00-020-005

- (1) If bin or compartment was closed, repair bin or compartment.

SUBTASK 25-00-00-020-006

- (2) If door was removed from compartment, repair or replace the door.
 - (a) Install door.

SUBTASK 25-00-00-020-007

- (3) If latch/lug on compartment was inoperative, replace latch/lug.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 909
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-00-00-020-019

- (4) Release the door for normal use when the compartment is operative again.

————— END OF TASK —————

TASK 25-00-00-040-813

14. DDG 25-29-1 Preparation - Flight Crew Rest (FCR) Door

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when the Flight Crew Rest (FCR) door is inoperative.

B. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

C. Flight Crew Rest Door inoperative

SUBTASK 25-00-00-040-021

- (1) Do these steps as they apply to your situation for an inoperative FCR door:
- (a) Deactivate associated FCR door closed.
- 1) Removal all baggage and personal items from the associated FCR.
 - 2) Close, lock and appropriately placard the associated door.

D. Flight Crew Rest Door inoperative

SUBTASK 25-00-00-040-022

- (1) Do these steps for an inoperative FCR door lock:
- (a) Associated FCR door lock is deactivated in the unlocked position
- 1) Associated FCR door opens and closes normally.
 - 2) Install an INOP (inoperative) placard on the outside of the door lock
- NOTE: If installed, the lock assembly override feature may be used to deactivate the door lock.

————— END OF TASK —————

TASK 25-00-00-440-813

15. DDG 25-29-1 Restoration - Flight Crew Rest (FCR) Door

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).
- (2) This task puts the airplane back to its usual condition after operating with a Flight Crew Rest (FCR) Door that does not operate correctly.

B. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

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Page 910
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

C. Procedure

SUBTASK 25-00-00-020-009

- (1) If the door lock was deactivated in the unlocked position, replace the door lock

SUBTASK 25-00-00-020-010

- (2) If the door was inoperative, repair or replace the door or frame

————— END OF TASK —————

TASK 25-00-00-040-816

16. DDG 25-29-2 Preparation - Main Deck Crew Rest (MDCR)/Main Deck Flight Crew Rest (MDFCR) Door

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when the main deck crew rest (MDCR)/main deck flight crew rest (MDFCR) door is inoperative.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Main Deck Crew Rest (MDCR)/Main Deck Flight Crew Rest (MDFCR) Door inoperative

SUBTASK 25-00-00-040-027

- (1) Do these steps as they apply to your situation for an inoperative Main Deck Crew Rest (MDCR)/Main Deck Flight Crew Rest (MDFCR) Door:
 - (a) Deactivate associated Main Deck Crew Rest (MDCR)/Main Deck Flight Crew Rest (MDFCR) DoorClosed.
 - 1) Removal all baggage and personal items from the associated MDCR/MDFCR.
NOTE: Blankets, pillows and other items normally used in the crew rest may remain.
 - 2) Close the inoperative MDCR/MDFCR door.

D. Main Deck Crew Rest (MDCR)/Main Deck Flight Crew Rest (FCR) Door Lock inoperative

SUBTASK 25-00-00-040-028

- (1) Do these steps for an inoperative Main Deck Crew Rest (MDCR)/Main Deck Flight Crew Rest (FCR) Door Lock:
 - (a) Make sure the associated MDCR/MDFCR door lock is deactivated in the unlocked position
 - (b) Make sure the associated MDCR/MDFCR door opens and closes normally.
 - (c) Install an INOP (inoperative) placard on the outside of the door lock
NOTE: If installed, the lock assembly override feature may be used to deactivate the door lock.

————— END OF TASK —————

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 911
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-00-00-440-816

17. DDG 25-29-2 Restoration - Main Deck Crew Rest (MDCR)/Main Deck Flight Crew Rest (MDFCR) Door

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).
- (2) This task puts the airplane back to its usual condition after operating with a Main Deck Crew Rest (MDCR)/Main Deck Flight Crew Rest (MDFCR) Door that does not operate correctly.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-00-00-440-005

- (1) If the door lock was deactivated in the unlocked position, replace the door lock

SUBTASK 25-00-00-440-006

- (2) If the door was inoperative, repair or replace the door or frame

————— **END OF TASK** —————

TASK 25-00-00-040-807

18. DDG 25-29-3 Preparation - Overhead Flight Crew and Attendant Rest Doors

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when a door for the Overhead Flight Crew Rest or Overhead Flight Attendant Rest is inoperative.

B. Location Zones

Zone	Area
222	Passenger Compartment, Right - Section 41
252	Passenger Compartment, Right - Section 46

C. Procedure

SUBTASK 25-00-00-040-026

- (1) Do these steps as they apply to your situation for an inoperative OFCR/OFAR (Overhead Flight Crew/Attendant Rest) door:
 - (a) Deactivate the associated OFCR/OFAR closed.
 - 1) Remove all baggage and personal items from the associated OFCR/OFAR.
NOTE: Blankets, pillows and other items normally used in the crew rest may remain.
 - (b) Close the inoperative OFCR/OFAR entrance door.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 912
May 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-00-00-440-807

19. DDG 25-29-3 Restoration - Overhead Flight Crew and Attendant Rest Doors

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).
- (2) This task gives the maintenance steps to put the airplane back to its usual condition after operation when a door for the Overhead Flight Crew Rest or Overhead Flight Attendant Rest is inoperative.

B. Location Zones

Zone	Area
222	Passenger Compartment, Right - Section 41
252	Passenger Compartment, Right - Section 46

C. Procedure

SUBTASK 25-00-00-020-002

- (1) If the door lock was deactivated in the unlocked position, replace the door lock.

SUBTASK 25-00-00-350-003

- (2) If the door was inoperative, repair or replace the door or frame.

————— **END OF TASK** —————

TASK 25-00-00-040-808

20. DDG 25-29-4 Preparation - Flight Crew and Attendant Rests (OFCR, OFAR, FCR, MDCR, MDFCR, LLAR)

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when the Overhead Flight Crew Rest or Overhead Flight Attendant Rest can not be used.

B. Location Zones

Zone	Area
220	Subzone 220 - Section 41
240	Subzone 240 - Section 44
250	Subzone 250 - Section 46

C. Procedure

SUBTASK 25-00-00-869-001

- (1) If necessary, remove baggage and personal items from the OFCR or OFAR.

NOTE: Blankets, pillows and other items normally used in the crew rest may remain.

SUBTASK 25-00-00-040-012

- (2) Close the door and install a marker that indicates that the OFCR or OFAR is not to be used.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 913
May 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-00-00-440-808

21. DDG 25-29-4 Restoration - Flight Crew and Attendant Rests (OFCR, OFAR, FCR, MDCR, MDPCR, LLAR)

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).
- (2) This task puts the airplane back to its usual condition after operation when the Overhead Flight Crew Rest or Overhead Flight Attendant Rest could not be used.

B. Location Zones

Zone	Area
220	Subzone 220 - Section 41
240	Subzone 240 - Section 44
250	Subzone 250 - Section 46

C. Procedure

SUBTASK 25-00-00-020-003

- (1) Remove the marker.

SUBTASK 25-00-00-020-004

- (2) If the door or door lock was inoperative, do the appropriate step that follows:
 - (a) If you could open the door by the use of the override feature at the top of the door, replace the door lock.
 - (b) If you could not open the door by the use of the override feature, repair or replace the door or frame.

SUBTASK 25-00-00-350-004

- (3) If there was a problem other than with the door or door lock, repair or replace components as necessary.

————— **END OF TASK** —————

TASK 25-00-00-040-804

22. DDG 25-30-1 Preparation - Galley Waste Container Door/Cover Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when a galley waste container door/cover is inoperative

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Galley Waste Container Door/Cover Deactivation

SUBTASK 25-00-00-040-008

- (1) Empty the receptacle and secure the access door/cover in a manner that will prevent waste from being deposited in the waste compartment/receptacle.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 914
May 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-00-00-440-804

23. DDG 25-30-1 Restoration - Galley Waste Container Door/Cover Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).
- (2) This task puts the airplane back to its usual condition after operating with a galley waste container door/cover that is inoperative.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Galley Waste Container Door/Cover Reactivation

SUBTASK 25-00-00-910-001

- (1) Remove the tape or strap from the inoperative door/cover.

————— **END OF TASK** —————

TASK 25-00-00-040-818

24. DDG 25-40-1 Preparation - Interior Lavatory Ashtrays Inoperative (EASA)

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task gives the maintenance steps which prepare the airplane for flight when an interior lavatory ashtray is inoperative.
 - (a) This procedure is only for aircraft using the EASA MMEL. DDG Maintenance procedures with no regulatory authority identification in the procedure title apply to both FAA and EASA MMELs.
- (2) The lavatory ashtrays can be inoperative as long as the lavatory fire extinguishing system operates normally.

B. Prepare for the Deactivation

SUBTASK 25-00-00-040-029

- (1) Do these steps to prepare the lavatory for flight with the doors closed:
 - (a) Close and lock the lavatory door and placard "INOPERATIVE - DO NOT ENTER".

————— **END OF TASK** —————

TASK 25-00-00-440-817

25. DDG 25-40-1 Restoration - Interior Lavatory Ashtrays Inoperative (EASA)

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task gives the maintenance steps to put the airplane back to its usual condition after operation with an interior lavatory ashtray that was inoperative.
 - (a) This procedure is only for aircraft using the EASA MMEL. DDG Maintenance procedures with no regulatory authority identification in the procedure title apply to both FAA and EASA MMELs.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 915
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

B. Lavatory Activation

SUBTASK 25-00-00-440-007

- (1) Unlock the lavatory door and remove the "INOPERATIVE - DO NOT ENTER" placard.

SUBTASK 25-00-00-440-008

- (2) Repair/replace the interior ashtray if it is necessary.

————— END OF TASK —————

TASK 25-00-00-040-805

26. DDG 25-41-2 Preparation - Lavatory Waste Container Flapper/Access Door Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when a lavatory waste container flapper/access door is inoperative.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Lavatory Waste Container Flapper/Access Door Deactivation

SUBTASK 25-00-00-040-009

- (1) Make sure the container is empty.

SUBTASK 25-00-00-040-010

- (2) Secure the inoperative flapper/access door to prevent waste from being deposited into the container.

SUBTASK 25-00-00-040-011

- (3) Close and lock the lavatory door and placard "INOPERATIVE - DO NOT ENTER".

————— END OF TASK —————

TASK 25-00-00-440-805

27. DDG 25-41-2 Restoration - Lavatory Waste Container Flapper/Cover Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).
- (2) This task puts the airplane back to its usual condition after operating with a lavatory waste container flapper/cover that does not operate correctly.

B. References

Reference	Title
25-41-08-200-801	Lavatory Waste Compartment Inspection (P/B 601)
25-41-09-200-801	Lavatory Waste Flap Adjustment (P/B 501)

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 916
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Lavatory Waste Container Flapper/Cover Restoration

SUBTASK 25-00-00-902-001

- (1) Unlock the lavatory door and remove the "INOPERATIVE - DO NOT ENTER" placard.

SUBTASK 25-00-00-902-002

- (2) Check the operation of the flapper/cover:

These are the tasks:

Lavatory Waste Compartment Inspection, TASK 25-41-08-200-801
Lavatory Waste Flap Adjustment, TASK 25-41-09-200-801

SUBTASK 25-00-00-902-003

- (3) Repair/replace the flapper/cover.

————— END OF TASK —————

TASK 25-00-00-040-806

28. DDG 25-53-2 Preparation - Lower Lobe Cargo Compartment Restraint Systems Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG). This task prepares the airplane for flight when the lower lobe cargo compartment restraint systems are inoperative.

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Lower Lobe Cargo Compartment Restraint Systems Deactivation

SUBTASK 25-00-00-720-001

- (1) Can be inoperative if:
 - (a) An acceptable cargo loading limits from an approved source, i.e., an approved Cargo Loading Manual, Cargo Handling Manual, or Weight and Balance Document are observed.
NOTE: Refer to the Weight and Balance Manual for cargo loading limits.
 - (b) Repairs are made prior to completion of next heavy maintenance visit.

————— END OF TASK —————

TASK 25-00-00-440-820

29. DDG 25-53-2 Restoration - Lower Lobe Cargo Compartment Restraint Components Inoperative

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).
- (2) This task puts the airplane back to its usual condition after operation with a lower lobe cargo compartment restraint system inoperative.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 917
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

B. References

Reference	Title
25-52-00-210-802	Tiedown Fitting Inspection (P/B 601)

C. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

D. Lower Lobe Cargo Compartment Restraint Systems Activation

SUBTASK 25-00-00-210-001

- (1) Do an Inspection Check (Tiedown Fitting Inspection, TASK 25-52-00-210-802).

————— END OF TASK —————

TASK 25-00-00-040-819

30. DDG 25-63-3 Preparation - Portable Emergency Locator Transmitter Inoperative (EASA)

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviation Guide (DDG). These tasks prepare the airplane for flight with a portable emergency locator transmitter (ELT) that does not operate.
 - (a) This procedure is only for aircraft using the EASA MMEL. DDG Maintenance procedures with no regulatory authority identification in the procedure title apply to both FAA and EASA MMELs.

B. Prepare for Deactivation

SUBTASK 25-00-00-040-030

- (1) Do one of the steps that follow:
 - (a) Remove the emergency locator transmitter (ELT) that can not operate from the airplane.
 - (b) Put a placard with "INOPERATIVE" on the unit.
 - 1) Stow the equipment that can not operate in an approved location that can not be seen.
 - 2) Put a placard with "INOPERATIVE" on the stowage location.

SUBTASK 25-00-00-040-031

- (2) Make sure that the necessary distribution of operative equipment is kept in the airplane.

————— END OF TASK —————

TASK 25-00-00-440-818

31. DDG 25-63-3 Restoration - Portable Emergency Locator Transmitter Inoperative (EASA)

A. General

- (1) This procedure has a maintenance task for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviation Guide (DDG). These tasks return the airplane to its usual condition after operation with a portable emergency locator transmitter (ELT) that does not operate.

EFFECTIVITY
ARO ALL

25-00-00

D633W101-ARO

Page 918
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (a) This procedure is only for aircraft using the EASA MMEL. DDG Maintenance procedures with no regulatory authority identification in the procedure title apply to both FAA and EASA MMELs.

B. Portable Emergency Locator Transmitter (ELT) - Activation

SUBTASK 25-00-00-440-009

- (1) Install the ELT at the necessary locations.
 - (a) Make sure that the necessary quantity of portable emergency locator transmitters (ELT) is in the airplane.
 - (b) Remove the 'INOPERATIVE' placard.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-00-00

Page 919
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

FLIGHT COMPARTMENT SEATS - ADJUSTMENT/TEST

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks for the flight compartment seats:
 - (1) Operational Test - Powered (Captain and First Officer seats)
 - (2) Operational Test - Manual Adjustment, Vertical and Horizontal (Captain and First Officer seats)
 - (3) Operational Test - Restraint Harness and Inertia Reel (All Flight Deck Seats)
 - (4) Operational Test - Lock Mechanism (Captain, First Officer and First Observer Seats)
 - (5) An adjustment of the limit switches.

TASK 25-11-00-700-801

2. Flight Compartment Seats Operational Test - Powered

(Figure 501)

A. **General**

- (1) This task is an operational test of the powered adjustments for the flight compartment seats.

B. **Tools/Equipment**

Reference	Description
STD-1139	Timer - Stop Watch, Accurate to 1 Second

C. **Location Zones**

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

D. **Captain and First Officer Seats**

SUBTASK 25-11-00-860-003

- (1) Make sure that these circuit breakers are closed:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	18	C25323	CAPT SEAT

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	13	C25324	F/O SEAT

SUBTASK 25-11-00-710-001

- (2) Sit in the seat.

SUBTASK 25-11-00-710-002

- (3) Do the steps that follow to test the forward and aft travel:
 - (a) Make sure the POWER CUTOFF switch is in the ON position.
 - (b) Put the FORE-AFT POWER CONTROL switch in the FORWARD direction to move the seat to the full forward position.
 - (c) Release the FORE-AFT POWER CONTROL switch.
 - 1) Make sure the seat locks in the full forward position.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-11-00

Page 501
May 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- 2) Make sure the clearance between the roller swivel and the forward stop is between 0.03 and 0.30 inches.
- 3) Make sure the seat is free to move aft, by using the fore-aft manual control handles.
- (d) Put the FORE-AFT POWER CONTROL switch in the AFT direction to move the seat to the full aft and outboard position.
- (e) Release the FORE-AFT POWER CONTROL switch.
 - 1) Make sure the seat locks in the full aft and outboard position.
 - 2) Make sure the clearance between the roller swivel and the aft stop is between 0.03 and 0.30 inches.
- (f) Move the seat from the full aft and outboard position to the full forward position using the FORE-AFT POWER CONTROL switch.
 - 1) Use the stopwatch, STD-1139 to make sure the elapsed time to move from the full aft and outboard position to the full forward position is 5 to 9 seconds.
- (g) Move the seat from the full forward position to the full aft and outboard position using the FORE-AFT POWER CONTROL switch.
 - 1) Use the stopwatch, STD-1139 to make sure the elapsed time to move from the full forward position to the full aft and outboard position is 5 to 9 seconds.
- (h) Put the POWER CUTOFF switch in the OFF position.
 - 1) Make sure the seat will not move in the inboard and outboard or forward and aft direction when the FORE-AFT POWER CONTROL switch is operated.
- (i) Put the POWER CUTOFF switch in the ON position
 - 1) Make sure the seat will move in the inboard and outboard or forward and aft direction when the FORE-AFT POWER CONTROL switch is operated.

SUBTASK 25-11-00-710-003

- (4) Do the steps that follow to test the vertical travel:
 - (a) Make sure the POWER CUTOFF switch is in the ON position.
 - (b) Move the seat full down using the VERTICAL POWER CONTROL switch.
 - (c) Release the VERTICAL POWER CONTROL switch.
 - 1) Make sure the seat locks in the full down position.
 - (d) Move the seat to its highest position using the VERTICAL POWER CONTROL switch.
 - (e) Release the VERTICAL POWER CONTROL switch.
 - 1) Make sure the seat locks in its highest position.
 - 2) Use the stopwatch, STD-1139 to make sure the elapsed time to move from the full down position to the full up position is 5 to 9 seconds.
 - (f) Put the POWER CUTOFF switch to the OFF position.
 - 1) Make sure the seat will not move up or down when the VERTICAL POWER CONTROL switch is operated.
 - (g) Put the POWER CUTOFF switch to the ON position.
 - 1) Make sure the seat will move up or down when the VERTICAL POWER CONTROL switch is operated.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

25-11-00

D633W101-ARO

Page 502
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-11-00-700-802

3. Flight Compartment Seats Operational Test - Manual Adjustment (Vertical and Horizontal)

(Figure 501)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This task is an operational test of the manual adjustments for the flight compartment seats.

B. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

C. Captain and First Officer Seats

SUBTASK 25-11-00-860-005

- (1) Sit in the seat.

SUBTASK 25-11-00-710-023

- (2) Do the steps that follow to test the forward and aft travel:
 - (a) Use the fore-aft manual control handle to move the seat to the most aft and outboard position.
 - (b) Release the manual control handle.
 - 1) Make sure the seat locks in the most aft and outboard position.
 - (c) Use the fore-aft manual control handle to move the seat to the most forward position.
 - (d) Release the manual control handle.
 - 1) Make sure the seat locks in the most forward position.
 - (e) Use the fore-aft manual control handle to move the seat to a position approximately halfway aft.
 - (f) Release the fore-aft manual control handle.
 - 1) Make sure the seat locks in that position.

SUBTASK 25-11-00-710-024

- (3) Do the steps that follow to test the vertical travel:
 - (a) Remove the weight of the person from the seat.
 - (b) Pull the vertical manual control lever to move the seat to its highest position.
 - (c) Release the vertical manual control lever.
 - (d) Put the weight of the person on the seat.
 - 1) Make sure the seat locks in its highest position.
 - (e) Pull the vertical manual control lever and use the weight of the person to move the seat to its lowest position.
 - (f) Release the vertical manual control lever.
 - 1) Make sure the seat locks in the lowest position.
 - (g) Remove the weight of the person from the seat.
 - (h) Pull the vertical manual control lever to move the seat up to an intermediate position.
 - (i) Release the vertical manual control lever.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-11-00

Page 503
May 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- 1) Make sure the seat locks in that position.

———— **END OF TASK** ————

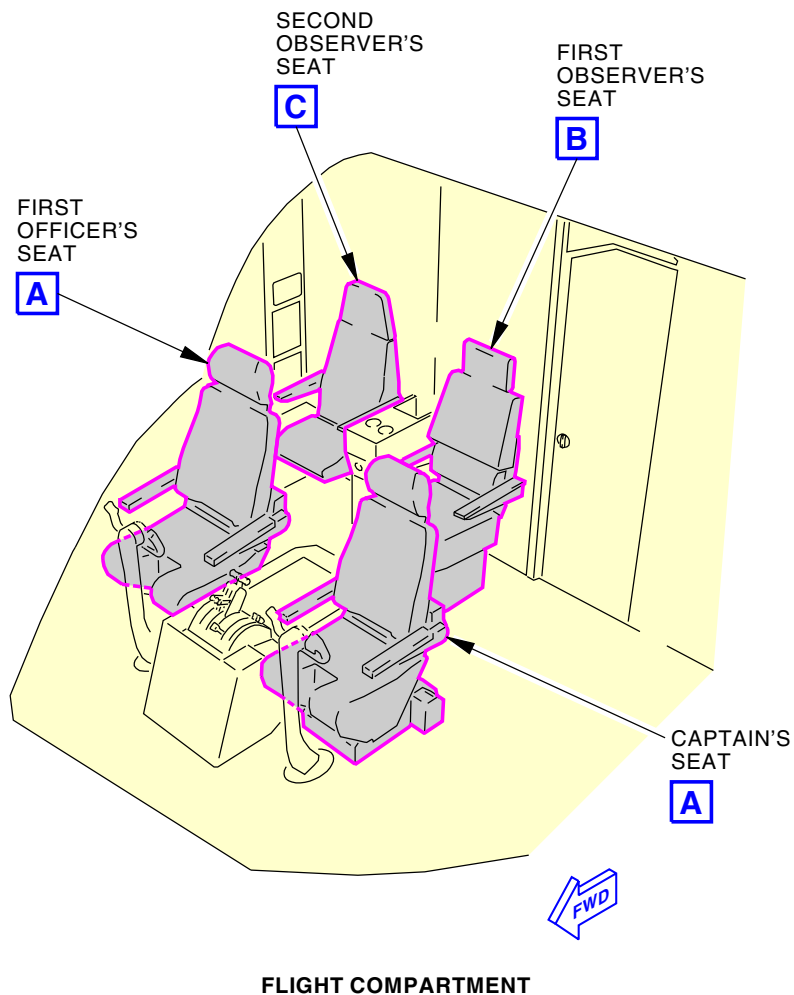
EFFECTIVITY
ARO ALL

D633W101-ARO

25-11-00

Page 504
Jan 05/2015

777-200/300
AIRCRAFT MAINTENANCE MANUAL



E16052 S0006408773_V2

Flight Compartment Seats - Test
Figure 501/25-11-00-990-804 (Sheet 1 of 3)

EFFECTIVITY
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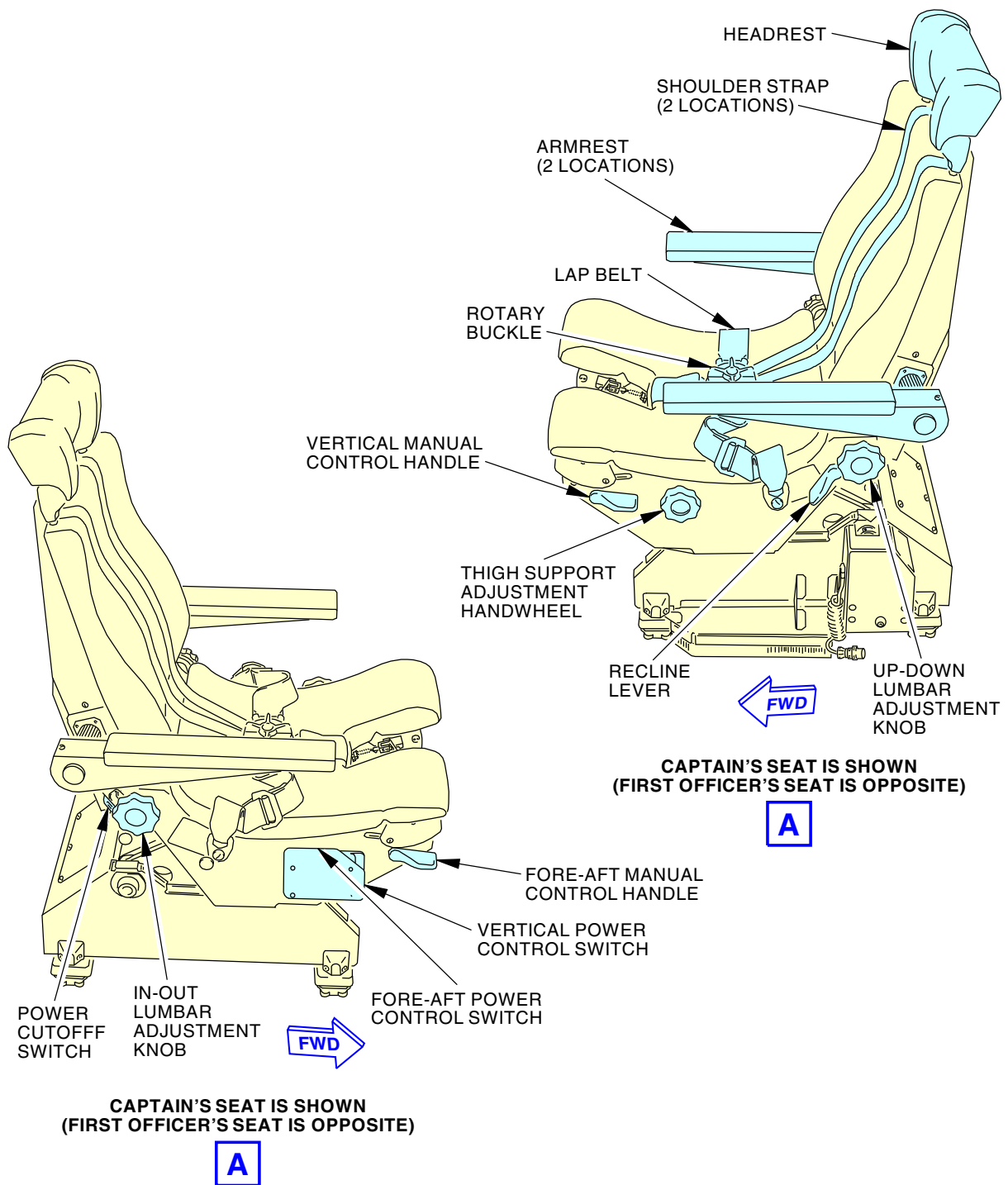
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25-11-00

Page 505
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



E16057 S0006408774_V2

Flight Compartment Seats - Test
Figure 501/25-11-00-990-804 (Sheet 2 of 3)

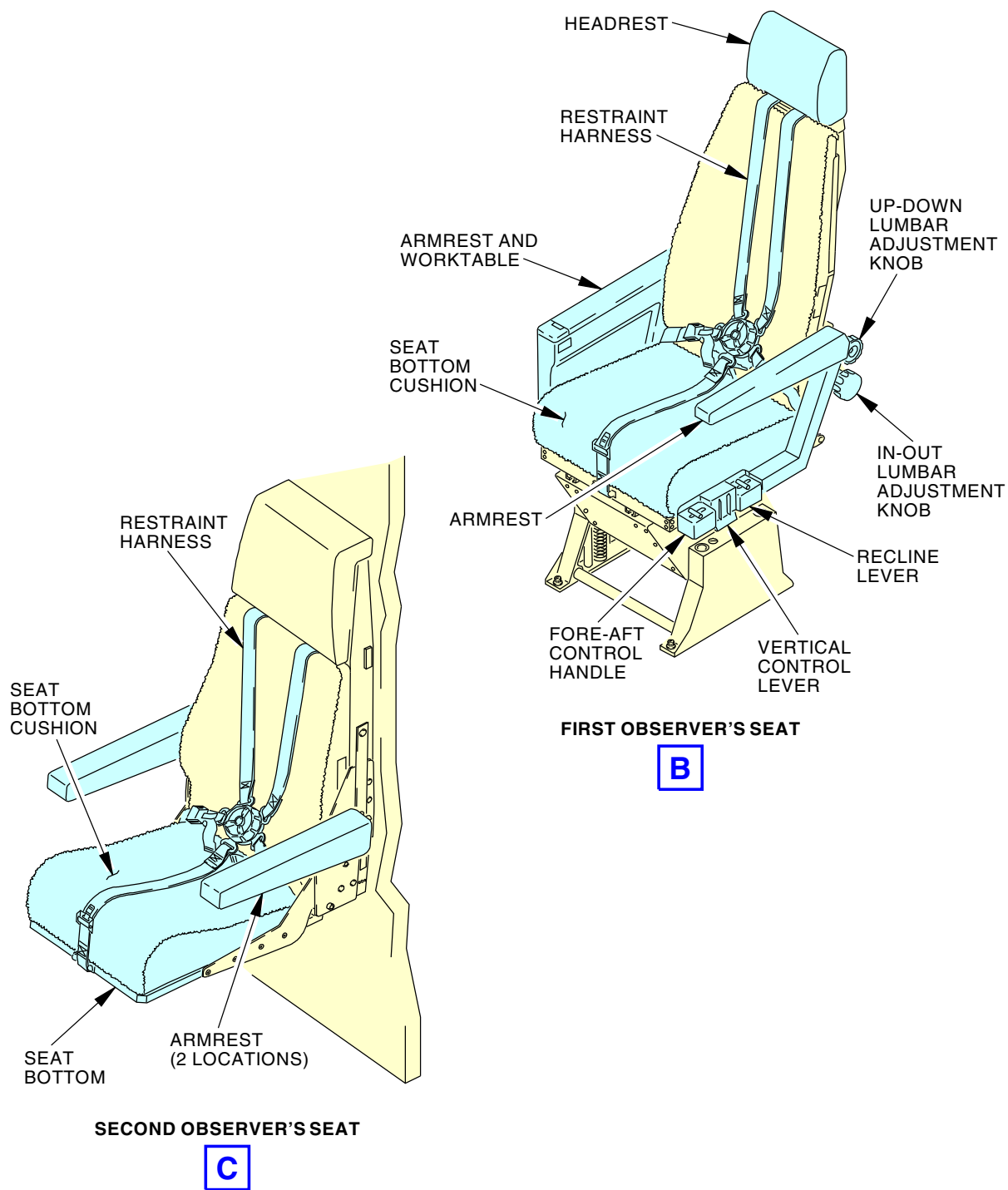
EFFECTIVITY
ARO ALL

25-11-00

D633W101-ARO

Page 506
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



E18064 S0006408775_V2

Flight Compartment Seats - Test
Figure 501/25-11-00-990-804 (Sheet 3 of 3)

EFFECTIVITY
ARO ALL

25-11-00

D633W101-ARO

Page 507
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-11-00-700-803

4. Flight Compartment Seats Operational Test - Restraint Harness Inertia Reel

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This task is an operational test of the manual adjustments for the flight compartment seats.

B. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

C. Flight Deck Seats

SUBTASK 25-11-00-710-025

- (1) Do the steps that follow to test the restraint harness and inertia reel:
- (a) Make sure the shoulder harness control, located on the inboard side of the seat back, is in the unlocked position. (Applicable to seats with Guide Lock)
 - (b) Pull to apply a sharp forward jerk on one shoulder strap.
 - 1) Make sure the strap locks.
 - (c) Release the pressure on the strap.
 - 1) Make sure the strap unlocks.
 - (d) Pull to apply a sharp forward jerk on the other shoulder strap.
 - 1) Make sure the strap locks.
 - (e) Release the pressure on the strap.
 - 1) Make sure the strap unlocks.
 - (f) Pull one shoulder strap slowly out of the seat back as far as possible.
 - 1) Make sure there is no sign of chafing or binding.
 - (g) Release the strap.
 - 1) Make sure the strap retracts fully in the seat back.
 - (h) Pull the other shoulder strap slowly out of the seat back as far as possible.
 - 1) Make sure there is no sign of chafing or binding.
 - (i) Release the strap.
 - 1) Make sure the strap retracts fully in the seat back.
 - (j) Pull one of the shoulder straps slowly out of the seat back as far as possible.
 - (k) Move the shoulder harness control to the locked position. (Applicable to seats with Guide Lock)
 - (l) Release the shoulder strap until it retracts approximately two inches.
 - 1) Pull on the shoulder strap to make sure the strap locks.
 - (m) Release the shoulder strap until it retracts approximately two inches at a time, until it is fully retracted.
 - 1) At each stage, pull on the shoulder strap to make sure the strap locks.
 - (n) Move the shoulder harness control to the unlocked position. (Applicable to seats with Guide Lock)

EFFECTIVITY
ARO ALL

25-11-00

D633W101-ARO

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Page 508
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (o) Pull the other shoulder strap slowly out of the seat back as far as possible.
- (p) Move the shoulder harness control to the locked position. (Applicable to seats with Guide Lock)
- (q) Release the shoulder strap until it retracts approximately two inches.
 - 1) Pull on the shoulder strap to make sure the strap locks.
- (r) Release the shoulder strap until it retracts approximately two inches at a time, until it is fully retracted.
 - 1) At each stage, pull on the shoulder strap to make sure the strap locks.
- (s) Put the shoulder harness control in the unlocked position. (Applicable to seats with Guide Lock)

————— END OF TASK —————

TASK 25-11-00-700-804

5. Flight Compartment Seats Operational Test - Lock Mechanism

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This task is an operational test of the lock mechanism for the flight compartment seats.

B. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

C. Captain, First Officer and First Observer Seats Horizontal Adjustment

SUBTASK 25-11-00-710-026

- (1) Sit in the seat.

SUBTASK 25-11-00-710-027

- (2) Do the steps that follow to test the forward and aft travel:
 - (a) Use the fore-aft manual control handle to move the seat to the most aft and outboard position.
 - (b) Release the manual control handle.
 - 1) Make sure the seat locks in the most aft and outboard position.
 - (c) Use the fore-aft manual control handle to move the seat to the most forward position.
 - (d) Release the manual control handle.
 - 1) Make sure the seat locks in the most forward position.
 - (e) Use the fore-aft manual control handle to move the seat to a position approximately halfway aft.
 - (f) Release the fore-aft manual control handle.
 - 1) Make sure the seat locks in that position.
 - 2) Make sure that the seat will not move from that position horizontally more than 0.5 in. (12.7 mm).

D. Captain and First Officer Seat Vertical Adjustment

SUBTASK 25-11-00-710-028

- (1) Do the steps that follow to test the vertical travel:

EFFECTIVITY
ARO ALL

25-11-00

D633W101-ARO

Page 509
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Remove the weight of the person from the seat.
- (b) Pull the vertical manual control lever to move the seat to its highest position.
- (c) Release the vertical manual control lever.
- (d) Put the weight of the person on the seat.
 - 1) Make sure the seat locks in its highest position.
- (e) Pull the vertical manual control lever and use the weight of the person to move the seat to its lowest position.
- (f) Release the vertical manual control lever.
 - 1) Make sure the seat locks in the lowest position.
- (g) Remove the weight of the person from the seat.
- (h) Pull the vertical manual control lever to move the seat up to an intermediate position.
- (i) Release the vertical manual control lever.
- (j) Put the weight of the person on the seat.
 - 1) Make sure that the seat locks in that position.
 - 2) Make sure that the seat will not move from that position vertically more than 0.5 in. (12.7 mm).

————— END OF TASK —————

TASK 25-11-00-820-801

6. Flight Compartment Seats Limit Switch Adjustment

(Figure 502)

A. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

B. Captain and First Officer Seats

SUBTASK 25-11-00-820-001

- (1) Do these steps to adjust the forward limit switch for the seat:
 - (a) Move the seat aft away from the stop.
 - (b) Make sure the power to the seat is disconnected.
 - (c) Loosen the two adjustment bolts and carefully lower the bracket on to the stop until you hear a click.

NOTE: The click indicates that the circuit has been made in the limit switch.
 - (d) Hold the bracket in this position and carefully tighten the two adjustment bolts.

ARO ALL; AIRPLANES WITH 3A258 SERIES SEATS

SUBTASK 25-11-00-820-003

- (2) Do these steps to adjust the forward limit switch for the seat:

EFFECTIVITY
ARO ALL

25-11-00

D633W101-ARO

Page 510
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

ARO ALL; AIRPLANES WITH 3A258 SERIES SEATS (Continued)



BE CAREFUL DURING OPERATION OF THE EMERGENCY CUT-OFF POWER SWITCH TO THE "OFF" POSITION. THE EMERGENCY CUT-OFF POWER SWITCH IN THE "OFF" POSITION DOES NOT ISOLATE THE SEAT FROM THE POWER SUPPLY.

- (a) Make sure the seat emergency cut-off power switch is in the "ON" position.
- (b) Operate "FWD"/"AFT" control switch then check for the following:
 - 1) The seat moves smoothly forward and aft on the tracks.



BE SURE THE SEAT SHOULD STOP BEFORE IT MAKES CONTACT WITH MECHANICAL STOP BLOCKS FITTED TO THE TRACKS.

- 2) The seat moves fully forward until it is stopped by the activation of the forward limit switch assembly.
- 3) Check that a gap between the limits 0.20 in. (5.08 mm) to 0.35 in. (8.89 mm) exists between the face of the forward bogie assembly and the forward manual stop.
- 4) If criteria in the steps 2) and 3) has not been attained adjust the forward limit switch assembly as follows:
 - a) Loosen the two adjustment lock nuts on the forward limit switch assembly.
 - b) Rotate the lock nuts to move the forward limit switch assembly up or down until the gap between the face of the forward bogie assembly and forward manual stop is 0.20 in. (5.08 mm) – 0.35 in. (8.89 mm).
 - c) Tighten the two lock nuts on the forward limit switch assembly.
- 5) After adjusting forward limit switch assembly move the seat rearwards and stop.
- 6) Move the seat forwards until it is brought to a stop by the action of the forward limit switch assembly then confirm the criterion in the step 3).

ARO ALL; AIRPLANES WITH 3A201 SERIES SEATS PRE SB 201-25-03

SUBTASK 25-11-00-820-005

- (3) Do these steps to adjust the forward limit switch for the seat:



BE CAREFUL DURING OPERATION OF THE EMERGENCY CUT-OFF POWER SWITCH TO THE "OFF" POSITION. THE EMERGENCY CUT-OFF POWER SWITCH IN THE "OFF" POSITION DOES NOT ISOLATE THE SEAT FROM THE POWER SUPPLY.

- (a) Make sure the seat emergency cut-off power switch is in the "ON" position.
- (b) Operate horizontal power switch and check that the seat passes the following criteria:
 - 1) The seat moves smoothly forward and aft on the tracks.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-11-00

Page 511
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

ARO ALL; AIRPLANES WITH 3A201 SERIES SEATS PRE SB 201-25-03 (Continued)



BE SURE THE SEAT SHOULD STOP BEFORE IT MAKES CONTACT WITH MECHANICAL STOP BLOCKS FITTED TO THE TRACKS.

- 2) The seat moves fully forward until it is stopped by the activation of the forward limit switch.
- 3) Check that a gap between the limits 0.15 in. (3.81 mm) to 0.35 in. (8.89 mm) exists between the face of the forward bogie assembly and forward manual stop.
- 4) If criteria in the steps 2) and 3) has not been attained adjust the forward limit switch as follows:
 - a) Loosen the two adjustment lock nuts on the forward limit switch assembly.
 - b) Move the forward switch assembly up or down until the gap between the face of the forward bogie assembly and forward manual stop is 0.15 in. (3.81 mm) – 0.35 in. (8.89 mm).
 - c) Tighten the two lock nuts on the forward limit switch assembly.
- 5) After adjusting forward limit switch move the seat rearwards and stop.
- 6) Move the seat forwards until it is brought to a stop by the action of the forward limit switch then confirm the criterion in the step 3).
- 7) The seat moves smoothly around the curved portion of the tracks and sideways to the “parked” position.

ARO ALL; AIRPLANES WITH 3A201 SERIES SEATS POST SB 201-25-03

SUBTASK 25-11-00-820-004

- (4) Do these steps to adjust the forward limit switch for the seat:



BE CAREFUL DURING OPERATION OF THE EMERGENCY CUT-OFF POWER SWITCH TO THE “OFF” POSITION. THE EMERGENCY CUT-OFF POWER SWITCH IN THE “OFF” POSITION DOES NOT ISOLATE THE SEAT FROM THE POWER SUPPLY.

- (a) Make sure the seat emergency cut-off power switch is in the “ON” position.
- (b) Operate horizontal power switch and check that the seat passes the following criteria:
 - 1) The seat moves smoothly forward and aft on the tracks.



BE SURE THE SEAT SHOULD STOP BEFORE IT MAKES CONTACT WITH MECHANICAL STOP BLOCKS FITTED TO THE TRACKS.

- 2) The seat moves fully forward until it is stopped by the activation of the forward limit switch.
- 3) Check that a gap between the limits 0.20 in. (5.08 mm) to 0.38 in. (9.65 mm) exists between the face of the forward bogie assembly and forward manual stop.
- 4) If criteria in the steps 2) and 3) has not been attained adjust the forward limit switch as follows:
 - a) Loosen the two adjustment lock nuts on the forward limit switch assembly.

EFFECTIVITY
ARO ALL

25-11-00



777-200/300 AIRCRAFT MAINTENANCE MANUAL

ARO ALL; AIRPLANES WITH 3A201 SERIES SEATS POST SB 201-25-03 (Continued)

- b) Move the forward switch assembly up or down until the gap between the face of the forward bogie assembly and forward manual stop is 0.20 in. (5.08 mm) – 0.38 in. (9.65 mm).
- c) Tighten the two lock nuts on the forward limit switch assembly.
- 5) After adjusting forward limit switch move the seat rearwards and stop.
- 6) Move the seat forwards until it is brought to a stop by the action of the forward limit switch then confirm the criterion in the step 3).
- 7) The seat moves smoothly around the curved portion of the tracks and sideways to the “parked” position.

ARO ALL

SUBTASK 25-11-00-820-002

- (5) Do these steps to adjust the aft limit switch for the seat:

- (a) Move the seat forward away from the seat.
- (b) Make sure the power to the seat is disconnected.
- (c) Loosen the two adjustment bolts and carefully lower the bracket until the gap between the actuator roller and the top surface of the seat track is 0.035 in. (0.89 mm).

NOTE: The 0.035 in. (0.89 mm) gap is the minimum to get the clearance of 0.05 in. (1.27 mm) between the bogie assembly and the aft manual stop. If you increase the gap it will decrease the clearance.

- (d) Hold the bracket in this position and carefully tighten the two adjustment bolts.

ARO ALL; AIRPLANES WITH 3A258 SERIES SEATS

SUBTASK 25-11-00-820-006

- (6) Do these steps to adjust the aft limit switch for the seat:



BE SURE THE SEAT SHOULD STOP BEFORE IT MAKES CONTACT WITH MECHANICAL STOP BLOCKS FITTED TO THE TRACKS.

- (a) The seat moves smoothly around the curved portion of the tracks and sideways to the “parked” position. Seat movement is stopped by the activation of the aft limit switch assembly.
- (b) Check that a gap between the limits 0.10 in. (2.54 mm) to 0.25 in. (6.35 mm) exists between the face of the aft bogie assembly and the aft manual stop.
- (c) If criteria in the steps (a) and (b) has not been attained adjust the aft limit switch assembly as follows:
 - 1) Make sure the seat emergency cut-off power switch is in the “ON” position.
 - 2) Loosen the two adjustment lock nuts on the aft limit switch assembly.
 - 3) Rotate the lock nuts to move the aft limit switch assembly up or down until the gap between the face of the aft bogie assembly and aft manual stop is 0.10 in. (2.54 mm) – 0.25 in. (6.35 mm).
 - 4) Tighten the two lock nuts on the aft limit switch assembly.
- (d) After adjusting aft limit switch assembly move the seat forwards and stop.

EFFECTIVITY
ARO ALL

25-11-00

D633W101-ARO

Page 513
Sep 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL

ARO ALL; AIRPLANES WITH 3A258 SERIES SEATS (Continued)

- (e) Move the seat towards the rear until it is brought to a stop by the action of the aft limit switch assembly then confirm the criterion in the step (b).
- (f) Check that the seat has smooth acceleration and deceleration in the fore, aft and lateral direction (parked position).

ARO ALL; AIRPLANES WITH 3A201 SERIES SEATS

SUBTASK 25-11-00-820-007

- (7) Do these steps to adjust the aft limit switch for the seat:



WARNING

BE CAREFUL DURING OPERATION OF THE EMERGENCY CUT-OFF POWER SWITCH TO THE "OFF" POSITION. THE EMERGENCY CUT-OFF POWER SWITCH IN THE "OFF" POSITION DOES NOT ISOLATE THE SEAT FROM THE POWER SUPPLY.

- (a) Make sure the seat emergency cut-off power switch is in the "ON" position.
- (b) Operate horizontal power switch and check that the seat passes the following criteria:
 - 1) The seat moves smoothly forward and aft on the tracks.



CAUTION

BE SURE THE SEAT SHOULD STOP BEFORE IT MAKES CONTACT WITH MECHANICAL STOP BLOCKS FITTED TO THE TRACKS.

- 2) The seat moves fully aft to the "parked" position until movement is stopped by the activation of the aft limit switch.
- 3) Check that a gap between the limits 0.03 in. (0.76 mm) to 0.20 in. (5.08 mm) exists between the face of the aft bogie assembly and the aft manual stop.
- 4) If criteria in the steps 2) and 3) has not been attained adjust the aft limit switch as follows:
 - a) Loosen the two pan hd screws on the aft switch assembly.
 - b) Move the limit switch up or down until the gap between the face of the aft bogie assembly and the aft manual stop is 0.03 in. (0.76 mm) – 0.20 in. (5.08 mm).
 - c) Tighten the two pan hd screws on the aft switch assembly.
- 5) After adjusting aft limit switch move the seat forwards and stop.
- 6) Move the seat towards the rear until it is brought to a stop by the action of the limit switch then confirm the criterion in the step 3).
- 7) Check that the seat has smooth acceleration and deceleration in the fore, aft and lateral direction (parked position).

ARO ALL

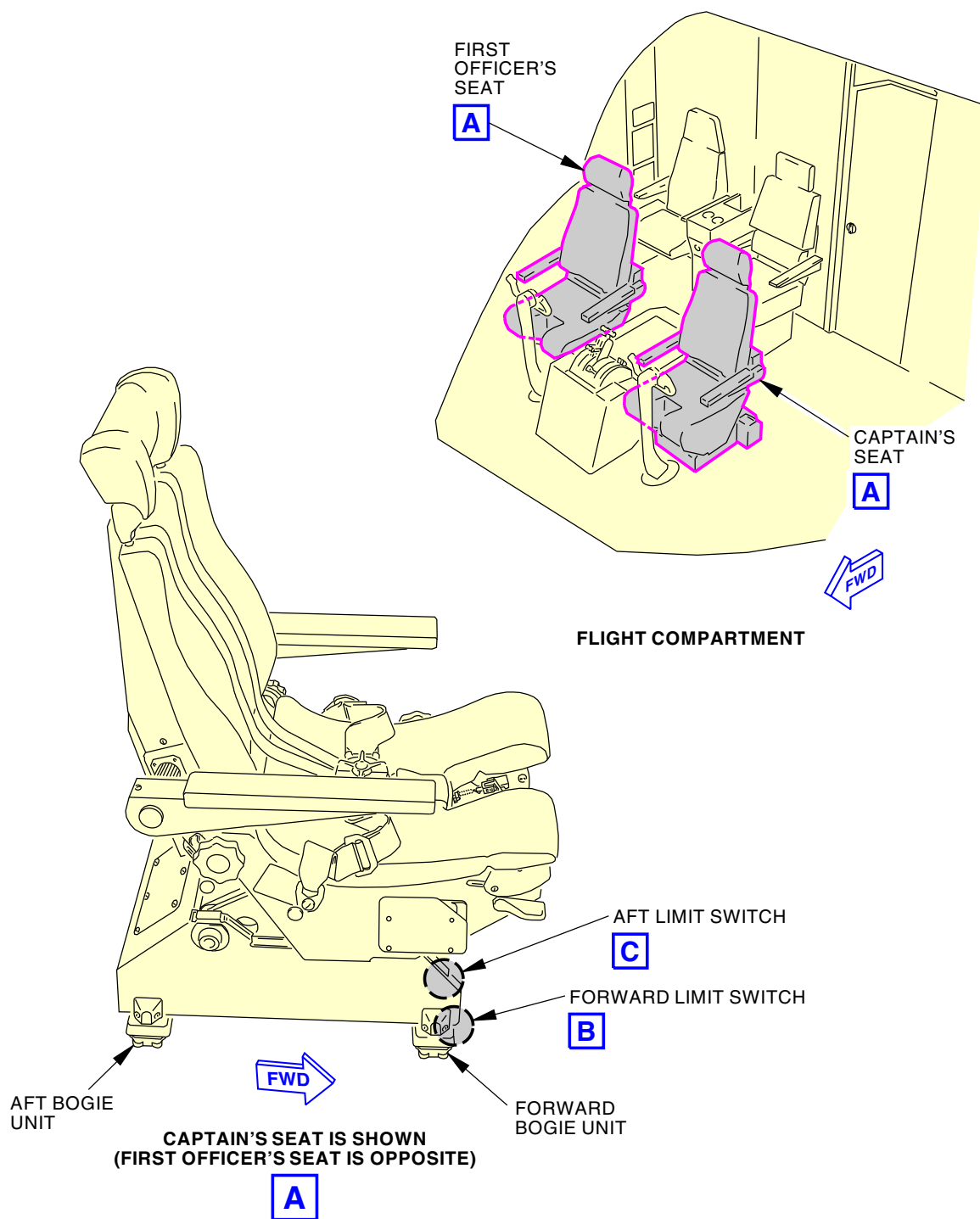
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EFFECTIVITY
ARO ALL

25-11-00

D633W101-ARO

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Flight Compartment Seats - Adjustment
Figure 502/25-11-00-990-803 (Sheet 1 of 6)

EFFECTIVITY
ARO ALL

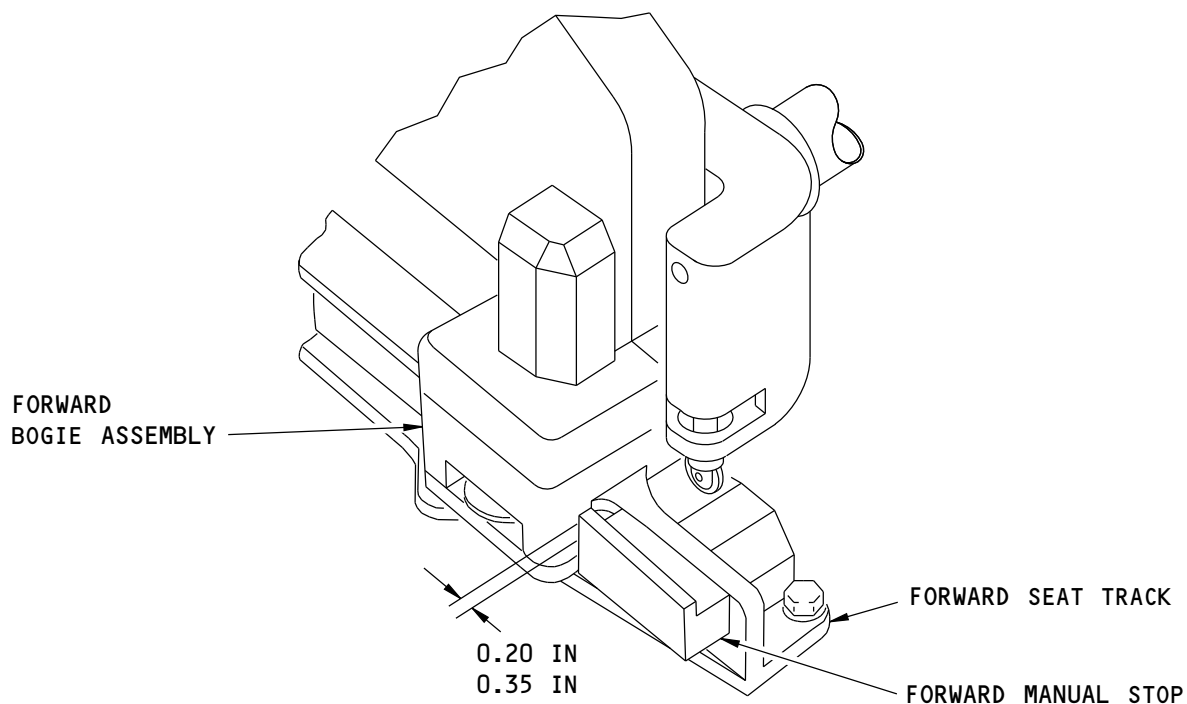
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D633W101-ARO

Page 515
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



FORWARD LIMIT SWITCH
(CAPTAIN'S SEAT IS SHOWN,
FIRST OFFICER'S SEAT IS OPPOSITE)

(B)

2466596 S0000575641_V1

Flight Compartment Seats - Adjustment
Figure 502/25-11-00-990-803 (Sheet 2 of 6)

EFFECTIVITY
ARO ALL; AIRPLANES WITH 3A258 SERIES SEATS

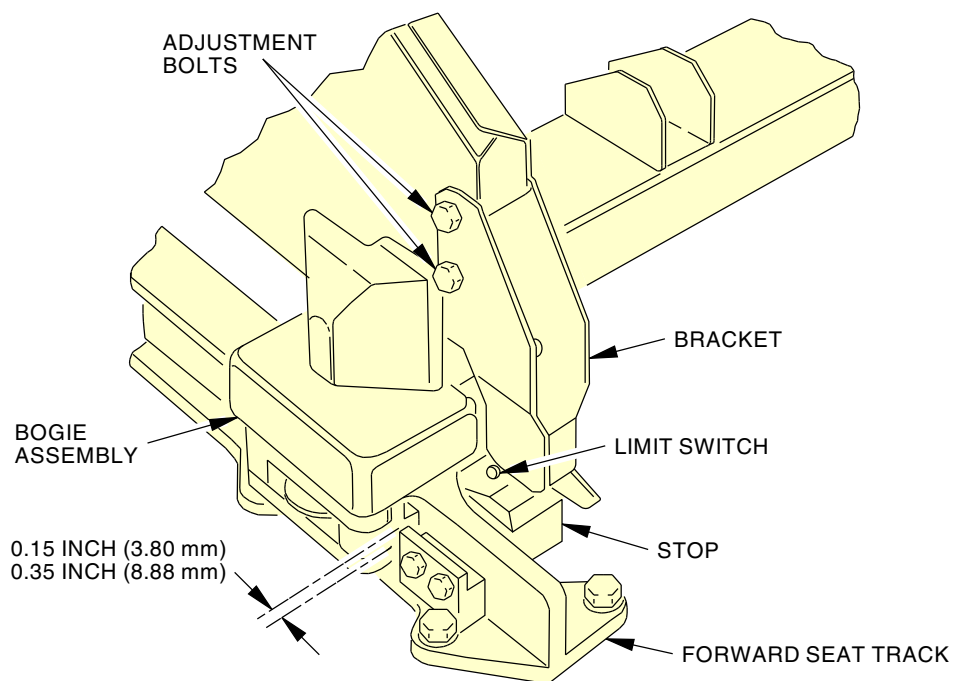
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D633W101-ARO

Page 516
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



FORWARD LIMIT SWITCH
(CAPTAIN'S SEAT IS SHOWN,
FIRST OFFICER'S SEAT IS OPPOSITE)

B

2588570 S0000625413_V2

Flight Compartment Seats - Adjustment
Figure 502/25-11-00-990-803 (Sheet 3 of 6)

EFFECTIVITY
ARO ALL; AIRPLANES WITH 3A201 SERIES SEATS
PRE SB 201-25-03

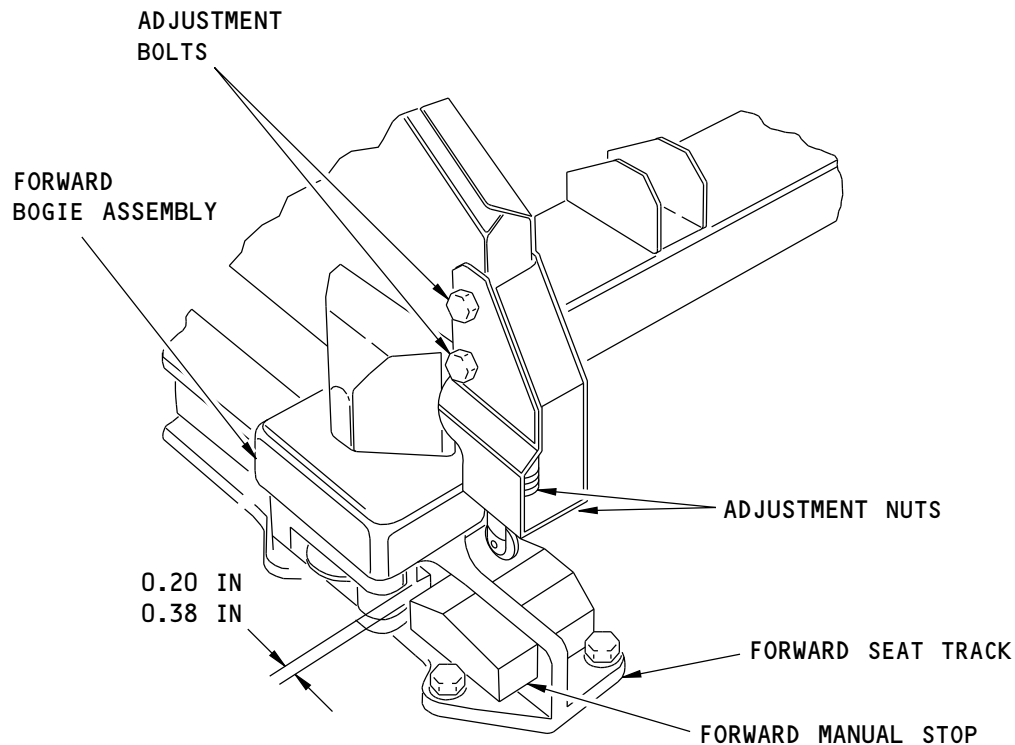
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D633W101-ARO

Page 517
Jul 25/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL



FORWARD LIMIT SWITCH
(CAPTAIN'S SEAT IS SHOWN,
FIRST OFFICER'S SEAT IS OPPOSITE)

B

2466578 S0000575642_V1

Flight Compartment Seats - Adjustment
Figure 502/25-11-00-990-803 (Sheet 4 of 6)

EFFECTIVITY
ARO ALL; AIRPLANES WITH 3A201 SERIES SEATS
POST SB 201-25-03

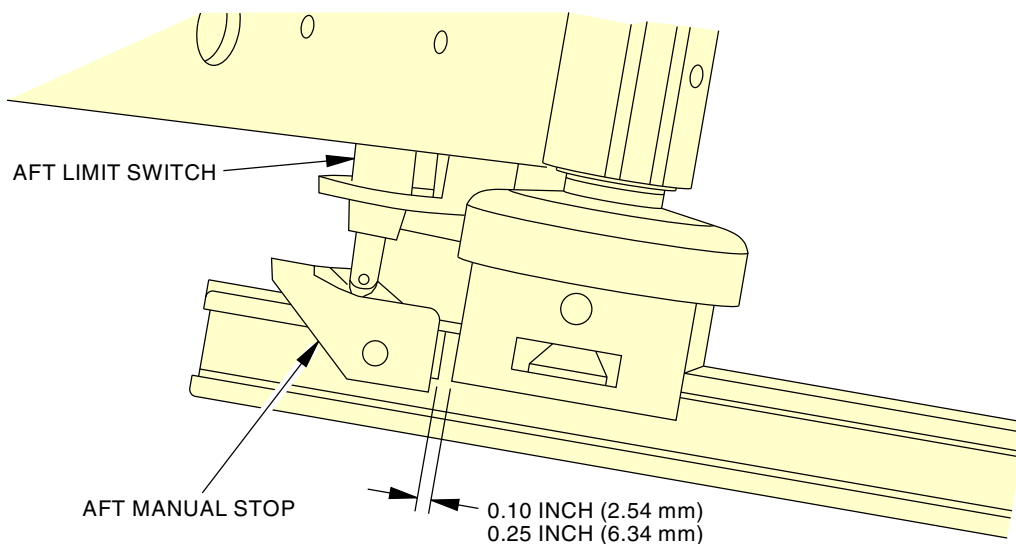
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25-11-00

Page 518
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



**AFT LIMIT SWITCH
(CAPTAIN'S SEAT IS SHOWN,
FIRST OFFICER'S SEAT IS OPPOSITE)**



2466465 S0000575643_V2

**Flight Compartment Seats - Adjustment
Figure 502/25-11-00-990-803 (Sheet 5 of 6)**

EFFECTIVITY
ARO ALL; AIRPLANES WITH 3A258 SERIES SEATS

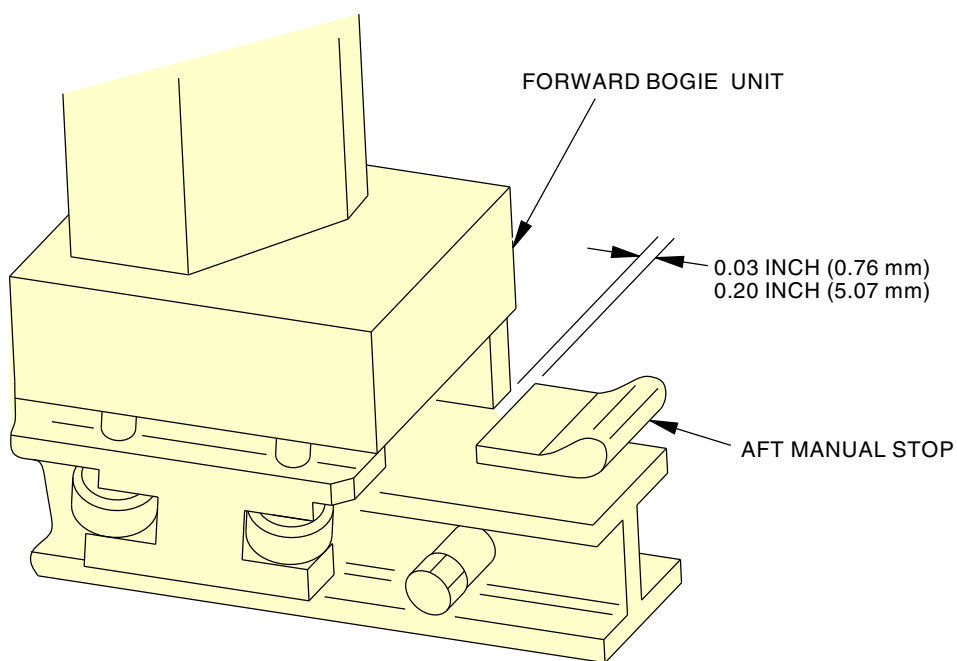
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D633W101-ARO

Page 519
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



AFT LIMIT SWITCH
(CAPTAIN'S SEAT IS SHOWN,
FIRST OFFICER'S SEAT IS OPPOSITE)



2466484 S0000575647_V2

Flight Compartment Seats - Adjustment
Figure 502/25-11-00-990-803 (Sheet 6 of 6)

EFFECTIVITY
ARO ALL; AIRPLANES WITH 3A201 SERIES SEATS

25-11-00

D633W101-ARO

Page 520
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

FLIGHT COMPARTMENT SEATS - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has an inspection of the attachments for the captain's and first officer's seat and an inspection of the seat belt and shoulder harnesses on flight compartment seats.
- C. This procedure has an inspection for foreign object debris (FOD) on or near the captain's and first officer's seat.

TASK 25-11-00-210-801

2. Seat Attachment Inspection

(Figure 601)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
211	Flight Compartment, Left
212	Flight Compartment, Right

B. Procedure

SUBTASK 25-11-00-860-001



REMOVE ELECTRICAL POWER FROM THE FIRST OFFICER'S AND CAPTAIN'S SEATS. IF YOU DO NOT REMOVE ELECTRICAL POWER, YOU CAN ACCIDENTALLY CAUSE A SEAT TO MOVE AND CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (1) Open these circuit breakers and install safety tags:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	18	C25323	CAPT SEAT

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	13	C25324	F/O SEAT

SUBTASK 25-11-00-210-001

- (2) Do this check to make sure the seat tracks for the captain's and first officer's seats are fully attached to the floor:

NOTE: Use the manual control handle (on the forward inboard corner of the seat) to move the seat forward and aft to examine all of the track.

- (a) Try to move the seat tracks to make sure they are satisfactorily tightened.

- 1) If you find loose bolts on the seat tracks, then tighten them.

NOTE: Tighten the 10-32 bolts to 30-35 pound-inches. Tighten the 1/4-28 bolts to 65-100 pound-inches.

- (b) Do a visual check for wear, cracks, and corrosion on the seat tracks.

SUBTASK 25-11-00-210-002

- (3) Do this check to make sure the captain and first officer's seats are fully attached to the seat tracks:

EFFECTIVITY
ARO ALL

25-11-00

D633W101-ARO

Page 601
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (a) Use the FORE-AFT MANUAL CONTROL switch to move the seat completely forward.
- (b) Do a visual check for the wear, cracks, and corrosion of the pinion on the seat and the pinion rack.
- (c) Try to push the seat from the left to the right to make sure it is tightly attached to the seat tracks.
- (d) Try to push the seat forward and aft to make sure it is tightly attached to the seat tracks.
- (e) Do a visual check for wear, cracks, and corrosion of the roller swivel.

SUBTASK 25-11-00-860-002

- (4) Remove the safety tags and close these circuit breakers:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	18	C25323	CAPT SEAT

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	13	C25324	F/O SEAT

————— **END OF TASK** —————

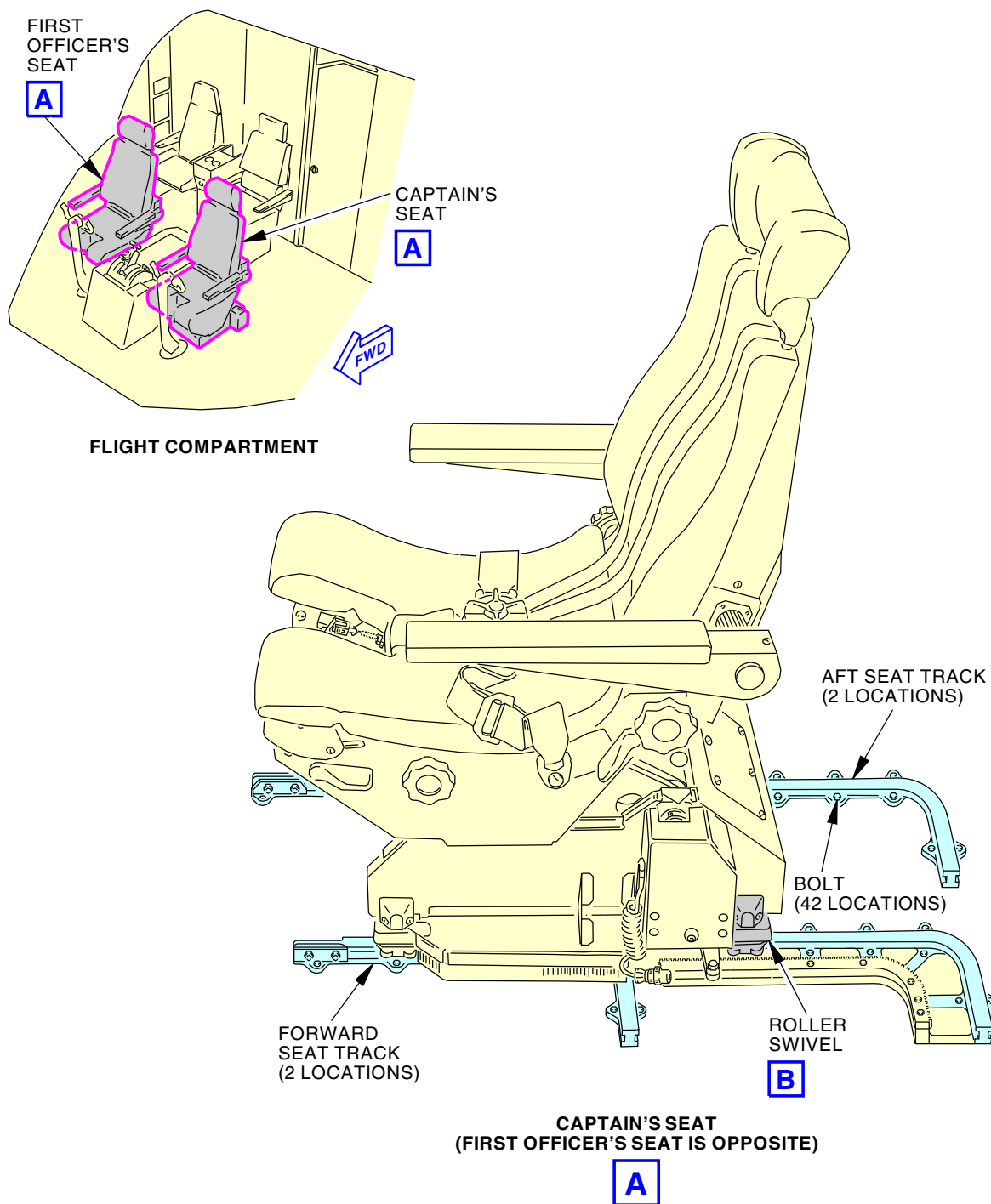
EFFECTIVITY
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25-11-00

D633W101-ARO

Page 602
Jan 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Flight Compartment Seats Inspection
Figure 601/25-11-00-990-801 (Sheet 1 of 2)**

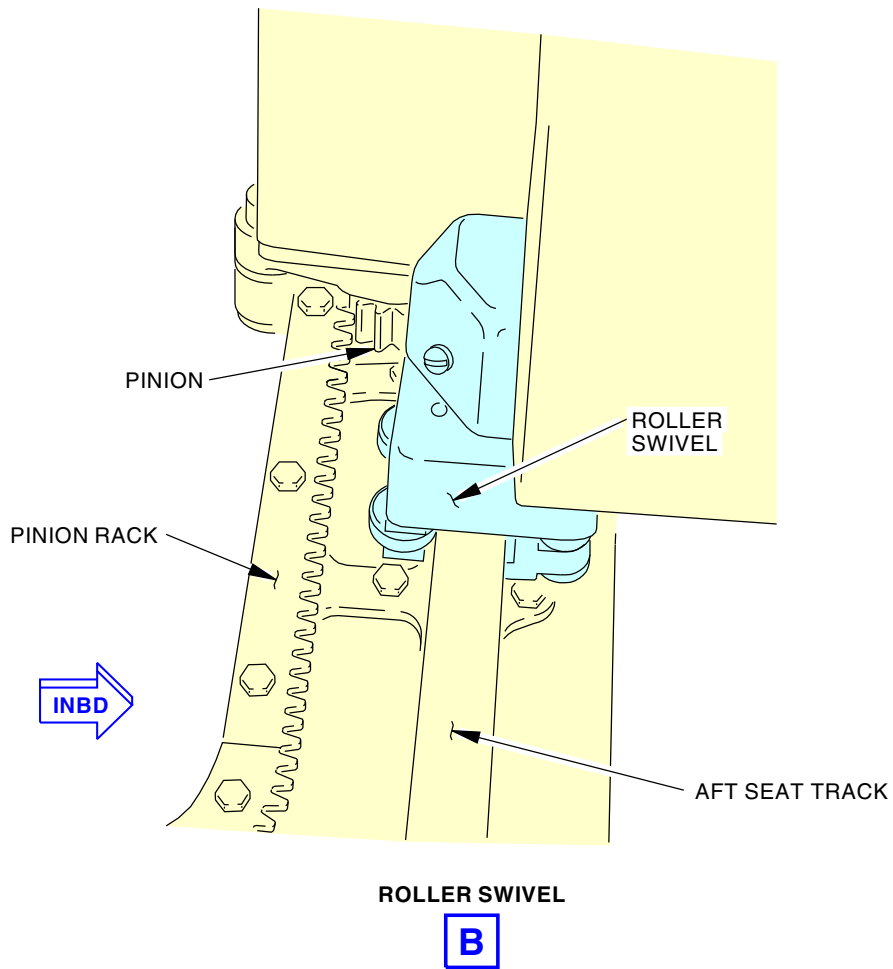
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25-11-00

D633W101-ARO

Page 603
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Flight Compartment Seats Inspection
Figure 601/25-11-00-990-801 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-11-00

Page 604
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-11-00-200-803

3. Seat Belt and Shoulder Harness - Inspection

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This task is a detailed inspection of the seat belt and shoulder harness for the flight compartment seats.

B. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

C. Captain, First Officer and Observer Seat Harness Inspection

SUBTASK 25-11-00-211-002

- (1) Do a detailed inspection of the seat harness straps to make sure they are not damaged.
 - (a) Inspect for loose stitching, cuts, tears, and fraying.

SUBTASK 25-11-00-211-003

- (2) Inspect the restraint harness fittings for damage.
 - (a) Inspect for loose, bent, dented, or corroded fittings.

SUBTASK 25-11-00-211-004

- (3) Inspect the seat belt hardware for damage.
 - (a) Inspect for loose, bent, dented, or corroded hardware.

————— **END OF TASK** —————

TASK 25-11-00-200-804

4. Flight Compartment Foreign Object Debris- Inspection

A. General

- (1) This task is a general visual inspection for foreign object debris (FOD) on or near the captain's and first officer's seat.

B. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

C. Prepare for the Inspection

SUBTASK 25-11-00-860-006



WARNING

REMOVE ELECTRICAL POWER FROM THE FIRST OFFICER'S AND CAPTAIN'S SEATS. YOU CAN ACCIDENTALLY CAUSE A SEAT TO MOVE AND CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (1) Open these circuit breakers and install safety tags:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	18	C25323	CAPT SEAT

EFFECTIVITY
ARO ALL

25-11-00

D633W101-ARO

Page 605
Sep 05/2017



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	13	C25324	F/O SEAT

D. Captain and First Officer Seat FOD Inspection

SUBTASK 25-11-00-210-003

- (1) Do a general visual inspection for foreign object debris on or near the captain's and first officer's seat tracks.
 - (a) Remove any FOD found.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-11-00-860-007

- (1) Remove the safety tags and close these circuit breakers:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	18	C25323	CAPT SEAT

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	13	C25324	F/O SEAT

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

25-11-00

D633W101-ARO

Page 606
Jan 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

CAPTAIN/FIRST OFFICER SEAT - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the captain/first officer seat.
 - (2) An installation of the captain/first officer seat.
- B. This procedure refers to the captain's or first officer's seat as the seat.

TASK 25-11-01-000-801

2. Captain and First Officer Seat Removal

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
52-51-20-020-801	Flight Compartment Door Armor Removal (P/B 401)

B. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

C. Prepare for the Removal

SUBTASK 25-11-01-860-001



WARNING

REMOVE ELECTRICAL POWER FROM THE FIRST OFFICER'S AND CAPTAIN'S SEATS. IF YOU DO NOT REMOVE ELECTRICAL POWER, YOU CAN ACCIDENTALLY CAUSE A SEAT TO MOVE AND CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (1) Open these circuit breakers and install safety tags:

Left Power Management Panel, P110

Row	Col	Number	Name
D	18	C25323	CAPT SEAT

Right Power Management Panel, P210

Row	Col	Number	Name
B	13	C25324	F/O SEAT

SUBTASK 25-11-01-010-001

- (2) Remove the flight deck door armor if necessary. (Flight Compartment Door Armor Removal, TASK 52-51-20-020-801)

D. Captain/First Officer Seat Removal

SUBTASK 25-11-01-020-001

- (1) Disconnect the electrical connector [5] from the forward console.

SUBTASK 25-11-01-020-011

- (2) Remove the life vest from the pouch found on the back of the seat.

SUBTASK 25-11-01-020-002

- (3) Remove the stops [15], [16] at the forward end of the forward seat tracks [6].

EFFECTIVITY
ARO ALL

25-11-01

D633W101-ARO

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Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-11-01-020-003

- (4) Use the FORE-AFT MANUAL CONTROL handle to move the seat [1] in the forward direction to release the pinion [9] from the pinion rack [3].

SUBTASK 25-11-01-020-004

- (5) Continue to move the seat [1] forward until the roller swivels [4] disengage from the seat tracks [2], [6].

SUBTASK 25-11-01-020-005

 CAUTION	MAKE SURE YOU TAKE CARE WHEN YOU REMOVE THE SEAT AND THEN PLACE IT ON THE FLOOR. IF THE SEAT IS AT AN ANGLE WHEN PLACED ON THE FLOOR AND NOT SET DOWN EVENLY ON ALL FOUR FEET, DAMAGE TO THE LIMIT SWITCH IS POSSIBLE.

- (6) Remove the seat [1].

SUBTASK 25-11-01-420-001

- (7) Install the stops [15], [16] to keep them for the subsequent installation task.

NOTE: The stop for the inboard seat track is different than the stop for the outboard seat track.

——— **END OF TASK** ———

TASK 25-11-01-400-801

3. Captain and First Officer Seat - Installation

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
25-11-00-200-804	Flight Compartment Foreign Object Debris- Inspection (P/B 601)
25-11-00-820-801	Flight Compartment Seats Limit Switch Adjustment (P/B 501)
52-51-20-420-801	Flight Compartment Door Armor Installation (P/B 401)

B. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

C. Captain/First Officer Seat Installation

SUBTASK 25-11-01-211-001

- (1) Do a detailed inspection of the seat tracks and the adjacent area for foreign object debris (FOD) and remove all FOD found.

SUBTASK 25-11-01-840-001

 CAUTION	DO NOT INSTALL THE SEAT IF THE FORWARD LIMIT SWITCH AND THE AFT LIMIT SWITCH ARE NOT ADJUSTED TO THE HIGHEST POSITION. IF YOU INSTALL THE SEAT WHEN THE LIMIT SWITCHES ARE NOT IN THE HIGHEST POSITION, YOU CAN DAMAGE THE LIMIT SWITCHES IF THEY TOUCH THE SEAT TRACKS.

- (2) Make sure the forward limit switch and the aft limit switch on the seat are adjusted to the highest position.

EFFECTIVITY
ARO ALL

25-11-01

D633W101-ARO

Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-11-01-020-006

- (3) Remove the stops [15], [16] from the forward seat tracks [6].

SUBTASK 25-11-01-820-001

- (4) Put the seat [1] forward of each pair of seat tracks [6].

SUBTASK 25-11-01-820-002

- (5) Align the front and rear roller swivels [4] so the tapered roller [11] is on the inboard side of the seat tracks [2], [6].

SUBTASK 25-11-01-420-002

- (6) Engage the roller swivels [4] on the seat tracks [2], [6].

NOTE: Some seats may have an arrow placard on all four roller swivels. To make loading easier, all four arrow labels are turned to point in the same direction to align the bogies with the track heads.

SUBTASK 25-11-01-420-003

- (7) Do these steps to engage the pinion [9] with the pinion rack [3]:
 - (a) Use the FORE-AFT MANUAL CONTROL handle to move the seat [1] in the aft direction until the pinion [9] touches the pinion rack [3].
 - (b) Use your hands to manually engage the pinion [9] with the pinion rack [3] on the aft, outboard seat track [2].
 - (c) Use the FORE-AFT MANUAL CONTROL handle to move the seat [1] in the aft direction until the pinion [9] engages with the pinion rack [3].
 - (d) Release the FORE-AFT MANUAL CONTROL handle.

SUBTASK 25-11-01-420-004

- (8) Install the stops [15], [16] on the forward end of the forward seat tracks [6].

NOTE: The stop for the inboard seat track is different than the stop for the outboard seat track. Make sure you install them on the correct seat track.

SUBTASK 25-11-01-820-003

- (9) Do these steps to adjust the roller swivels [4] if the seat [1] is too loose or too tight on the seat tracks [2], [6]:
 - (a) Loosen the adjustment nut [10] on each roller swivel [4].
 - (b) Tighten the adjustment nut [10] until the tapered roller [11] makes light contact with the seat track [2], [6].

SUBTASK 25-11-01-420-010

- (10) Put the flight crew's life vest into the pouch at the rear of the seat.

SUBTASK 25-11-01-420-005

- (11) Connect the electrical connector [5] at the forward console.

SUBTASK 25-11-01-820-004

- (12) Adjust the forward limit switch and the aft limit switch. Do this task: TASK 25-11-00-820-801

D. Captain/First Officer Seat Installation Test

SUBTASK 25-11-01-860-002

- (1) Sit in the seat [1].

SUBTASK 25-11-01-980-001

- (2) Make sure the FORE-AFT MANUAL CONTROL handle operates the seat fully forward and fully aft.

EFFECTIVITY
ARO ALL

25-11-01

D633W101-ARO

Page 403
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-11-01-980-002

- (3) Make sure the VERTICAL MANUAL CONTROL handle [8] operates the seat fully up and fully down.

SUBTASK 25-11-01-860-003

- (4) Remove the safety tags and close these circuit breakers:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	18	C25323	CAPT SEAT

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	13	C25324	F/O SEAT

SUBTASK 25-11-01-860-004

- (5) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-11-01-710-001

- (6) Make sure the FORE-AFT POWER CONTROL switch operates the seat fully forward and fully aft.

SUBTASK 25-11-01-710-002

- (7) Make sure the VERTICAL POWER CONTROL switch operates the seat fully up and fully down.

E. Put the Airplane Back to It's Usual Condition

SUBTASK 25-11-01-210-001

- (1) Do this task: Flight Compartment Foreign Object Debris- Inspection, TASK 25-11-00-200-804.

SUBTASK 25-11-01-410-001

- (2) Install the flight deck door armor if necessary. Do this task: Flight Compartment Door Armor Installation, TASK 52-51-20-420-801

————— END OF TASK —————

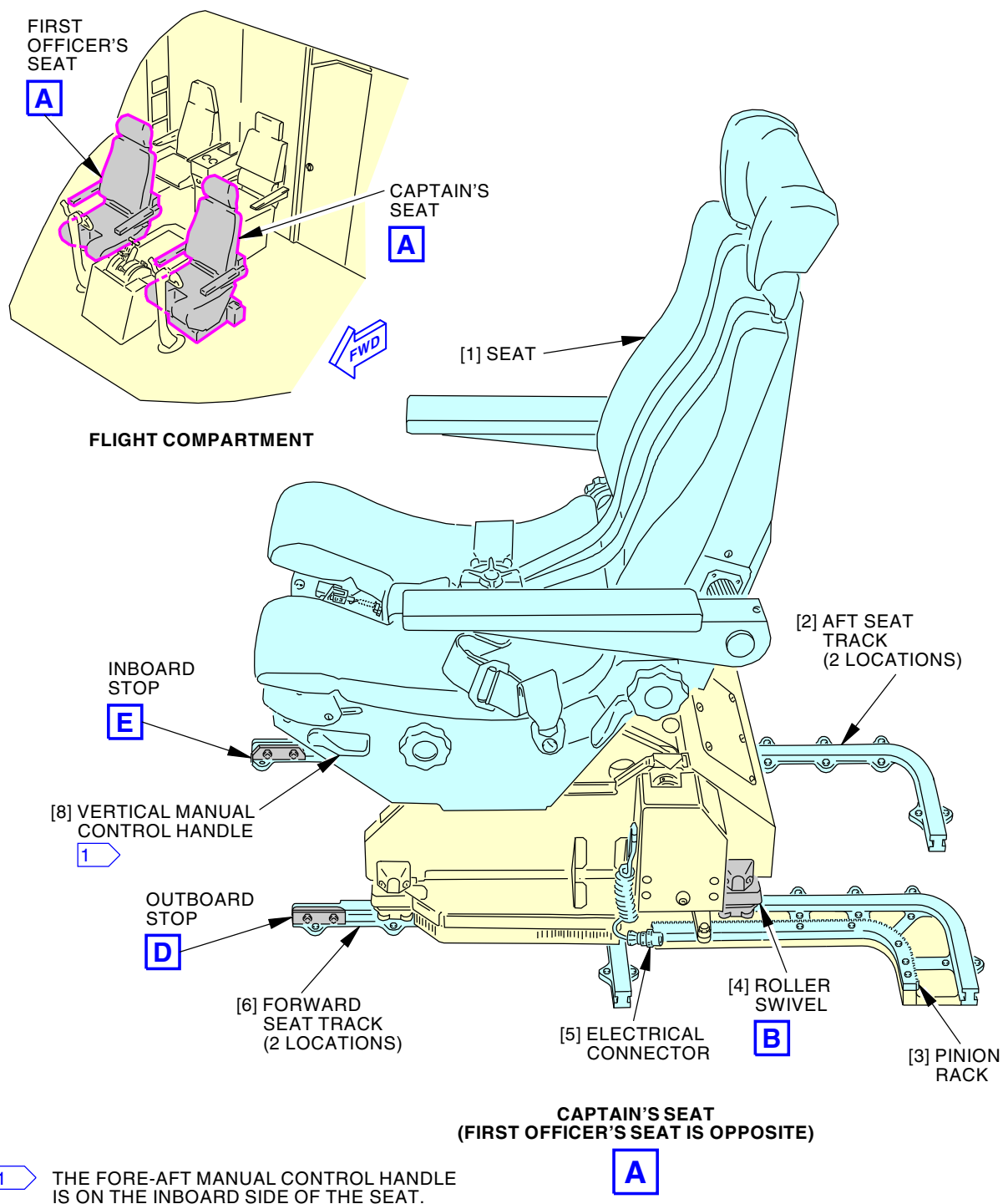
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Page 404
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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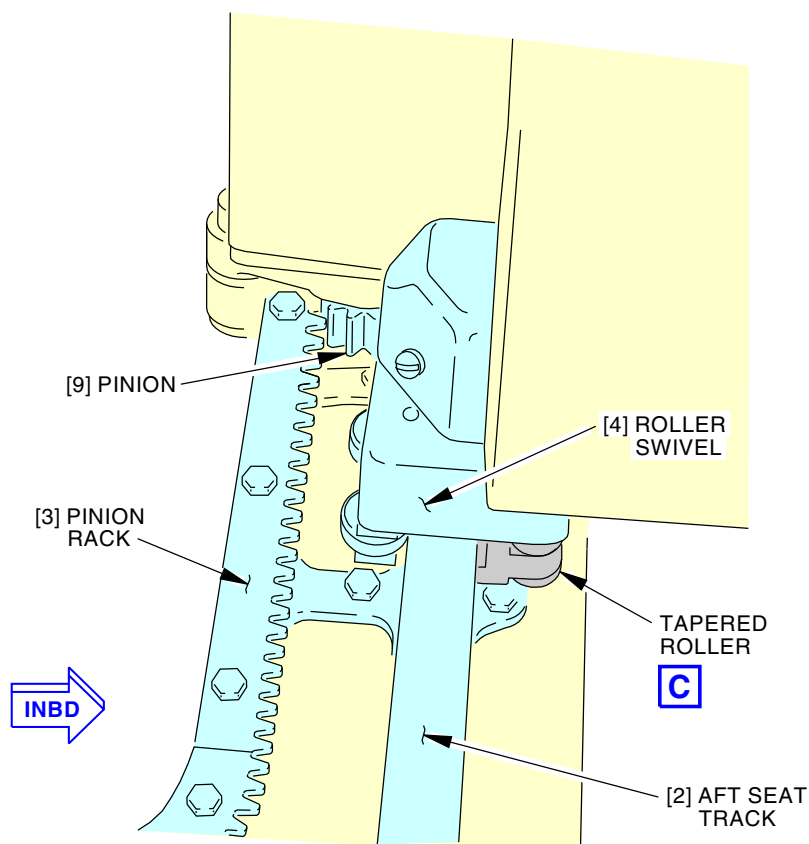
**Captain's/First Officer's Seat Installation
Figure 401/25-11-01-990-801 (Sheet 1 of 3)**

EFFECTIVITY
ARO ALL

25-11-01

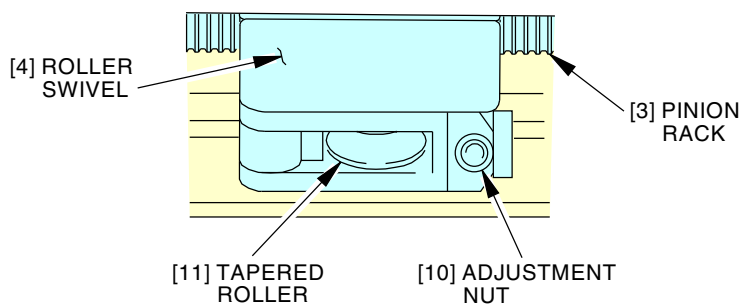
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Page 405
May 05/2017



ROLLER SWIVEL

B



TAPERED ROLLER

C

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**Captain's/First Officer's Seat Installation
Figure 401/25-11-01-990-801 (Sheet 2 of 3)**

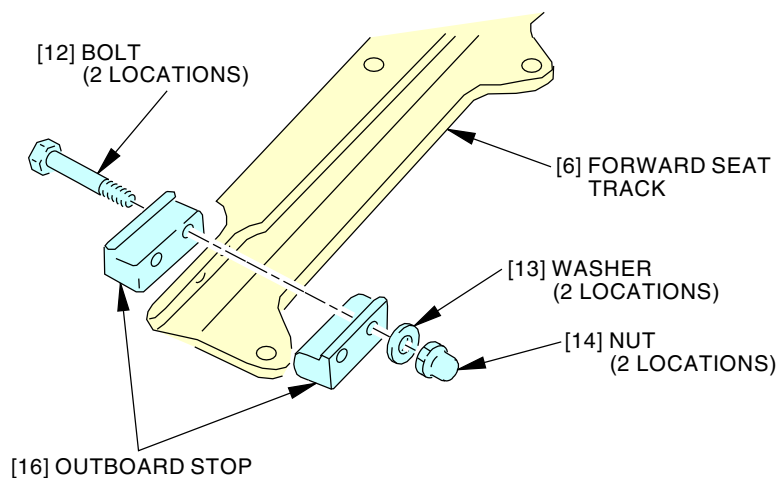
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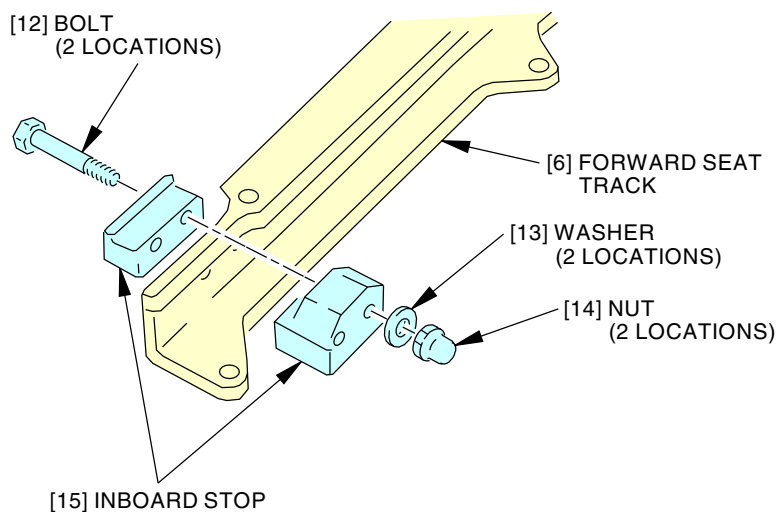
Page 406
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



OUTBOARD STOP

D



INBOARD STOP

E

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**Captain's/First Officer's Seat Installation
Figure 401/25-11-01-990-801 (Sheet 3 of 3)**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-11-01

Page 407
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
OBSERVER SEAT - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Removal of the first observer seat
 - (2) Removal of the second observer seat
 - (3) Installation of the first observer seat
 - (4) Installation of the second observer seat

TASK 25-11-03-000-801

2. First Observer Seat - Removal

A. Location Zones

Zone	Area
212	Flight Compartment, Right

B. First Observer Seat Removal

SUBTASK 25-11-03-020-009

- (1) Remove the cap nuts [6], the washers [5] the bolts [4], and the aft track stops [8] from the seat tracks [7].

NOTE: It is not necessary to remove the forward track stops [3].

SUBTASK 25-11-03-820-002

- (2) Operate the horizontal control lever [2] on the inboard side of the seat [1].

SUBTASK 25-11-03-440-001

- (3) Move the seat [1] in the forward direction on the seat tracks [7] until the forward and aft roller/claw assemblies [9] disengage from the seat tracks [7].

SUBTASK 25-11-03-020-010

- (4) To remove the seat [1], lift the aft roller/claw assemblies [9] through the notches in the seat tracks [7].

————— **END OF TASK** —————

TASK 25-11-03-000-802

3. Second Observer Seat - Removal

A. Location Zones

Zone	Area
212	Flight Compartment, Right

B. Remove the Second Observer Seat

SUBTASK 25-11-03-010-001

- (1) Remove the seat back cushion [4].

SUBTASK 25-11-03-020-005

- (2) Remove the washers [19] and nuts [18] that attach the back of the seat [15] to the wall fitting [16].

SUBTASK 25-11-03-020-006

- (3) Remove the seat assembly [1].

EFFECTIVITY
ARO ALL

25-11-03

D633W101-ARO

Page 401
May 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-11-03-860-001

- (4) Loosely tighten the washers [19] and nuts [18] on the bolts [20] to keep them for the subsequent installation task.

————— END OF TASK —————

TASK 25-11-03-400-801

4. First Observer Seat - Installation

A. Location Zones

Zone	Area

212	Flight Compartment, Right

B. First Observer Seat Installation

SUBTASK 25-11-03-410-002

- (1) Put the seat [1] on the seat tracks [7] while you lower the aft roller/claw assemblies [9] through the openings in the seat tracks [7].

SUBTASK 25-11-03-820-003

- (2) Operate the horizontal control lever [2] and do this step:
 - (a) Move the seat [1] in the aft direction on the seat tracks [7] until the roller/claw assemblies [9] engage the seat tracks [7].

SUBTASK 25-11-03-820-004

- (3) Release the horizontal control lever [2] to let the seat pins engage the track holes.

SUBTASK 25-11-03-420-007

- (4) Install the aft track stops [8] with the bolts [4], washers [5], and the cap nuts [6].
 - (a) Tighten the bolts to 45 ±5 in-lb (5 ±1 N·m).

————— END OF TASK —————

TASK 25-11-03-400-802

5. Second Observer Seat - Installation

A. Location Zones

Zone	Area

212	Flight Compartment, Right

B. Install the Second Observer Seat

SUBTASK 25-11-03-020-007

- (1) Remove the nuts [18] and washers [19] from the wall fitting [16].

SUBTASK 25-11-03-420-004

- (2) Put the bolts [20] through the holes in the seat back [15].

SUBTASK 25-11-03-420-005

- (3) Install the nuts [18] and washers [19] to attach the seat assembly [1] to the wall fitting [16].

SUBTASK 25-11-03-410-001

- (4) Install the seat back cushion [4].

————— END OF TASK —————

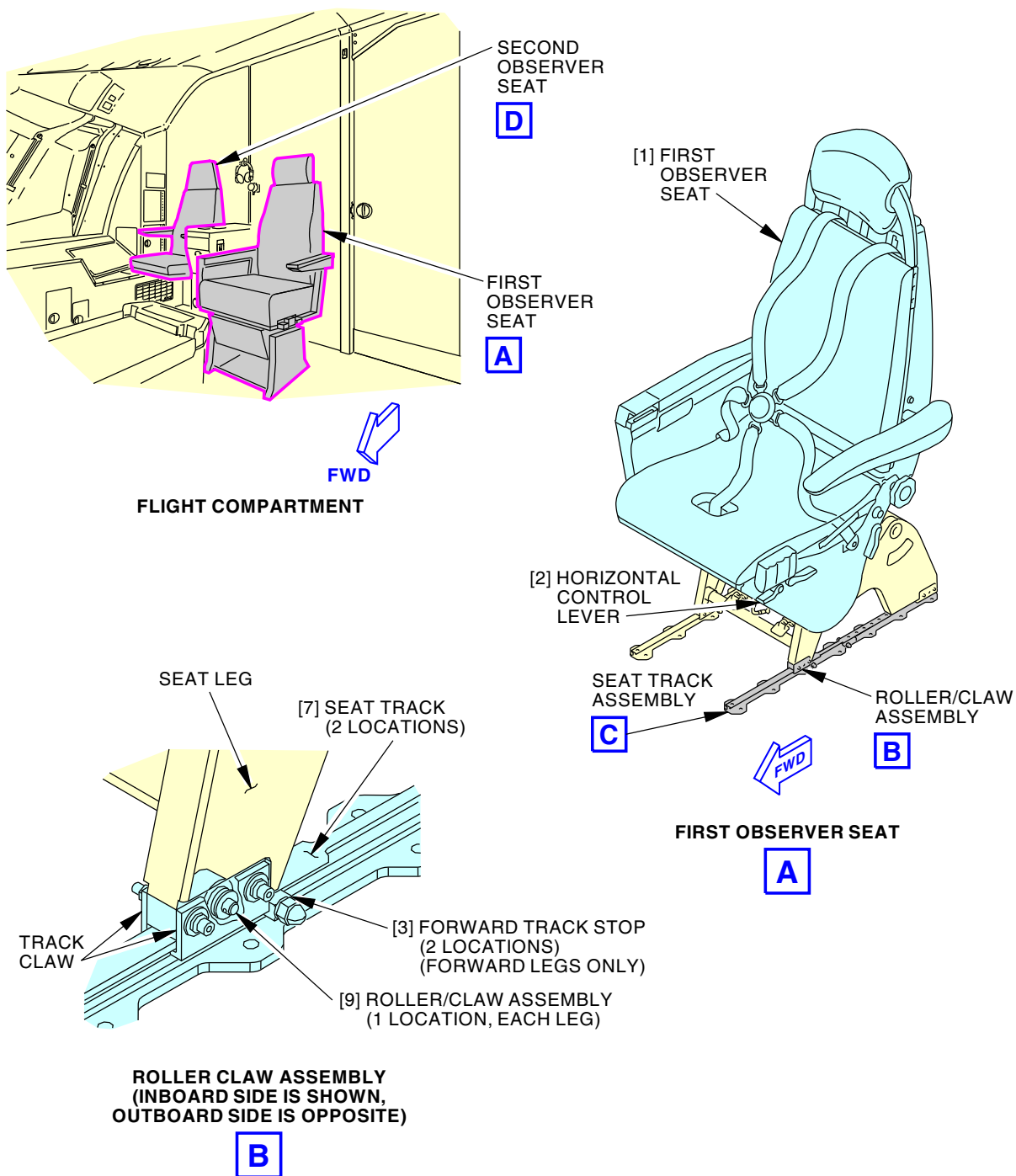
EFFECTIVITY
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25-11-03

D633W101-ARO

Page 402
Jan 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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Observer Seat Installation
Figure 401/25-11-03-990-802 (Sheet 1 of 2)

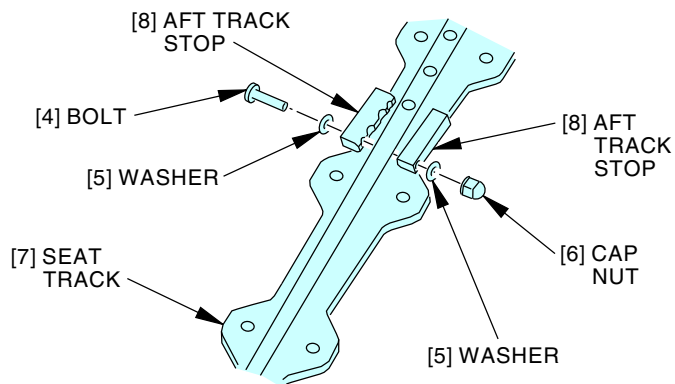
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25-11-03

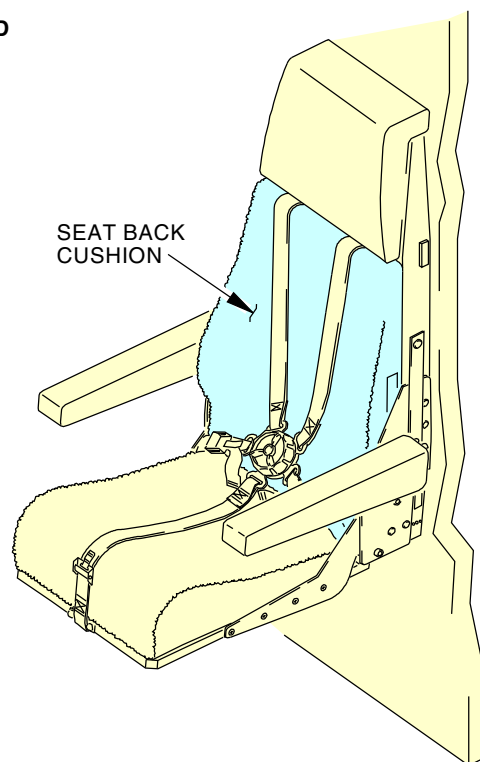
Page 403
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**SEAT TRACK ASSEMBLY
(INBOARD TRACK IS SHOWN, OUTBOARD
TRACK IS OPPOSITE)**

C



SECOND OBSERVER SEAT

D

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**Observer Seat Installation
Figure 401/25-11-03-990-802 (Sheet 2 of 2)**

**EFFECTIVITY
ARO ALL**

25-11-03

D633W101-ARO

Page 404
May 05/2017



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

OBSERVER SEAT - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has an inspection of the attachments for the first and second observer seats.

TASK 25-11-03-210-801

2. Observer Seat Attachment Inspection

A. Inspect the Seat Attachment

SUBTASK 25-11-03-210-001

- (1) If you are inspecting a wall mounted observer seat, do this check of the seat mounting bolts:
 - (a) Remove the seat cushion from the seat as necessary to see the seats mounting bolts.
 - (b) Try to move the seat.
 - 1) Make sure the mounting bolts are tight. If they are not tight, then tighten the bolts.
 - (c) Close the seat.

SUBTASK 25-11-03-210-002

- (2) If you are inspecting a floor mounted observer seat, do this check of the mounting bolts:
 - (a) Look at the mounting bolts to make sure they are tight.
 - (b) Try to move the seat.
 - 1) If the seat is not tight to the floor, then tighten the bolts.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-11-03

Page 601
May 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL
CHART HOLDER - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) The removal of the chart holder on the No. 2 window sill.
- (2) The installation of the chart holder on the No. 2 window sill.

TASK 25-13-01-000-801

2. Chart Holder Removal

(Figure 401)

A. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

B. Procedure

SUBTASK 25-13-01-020-001

- (1) Push the chart table assembly [1] forward.

SUBTASK 25-13-01-020-002

- (2) Slide a metal ruler or equivalent tool below the chart table assembly [1].

SUBTASK 25-13-01-020-003

- (3) Push up the spring [3] to disengage it from the block [2] while you slide the chart table assembly [1] aft.

SUBTASK 25-13-01-020-004

- (4) Remove the chart table assembly [1] from the tracks [4].

————— **END OF TASK** —————

TASK 25-13-01-400-801

3. Chart Holder Installation

(Figure 401)

A. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

B. Procedure

SUBTASK 25-13-01-420-001

- (1) Engage the forward end of the chart table assembly [1] to the aft end of the tracks [4].

SUBTASK 25-13-01-420-002

- (2) Slide the chart table assembly [1] along the tracks [4] until the spring [3] engages forward of the block [2].

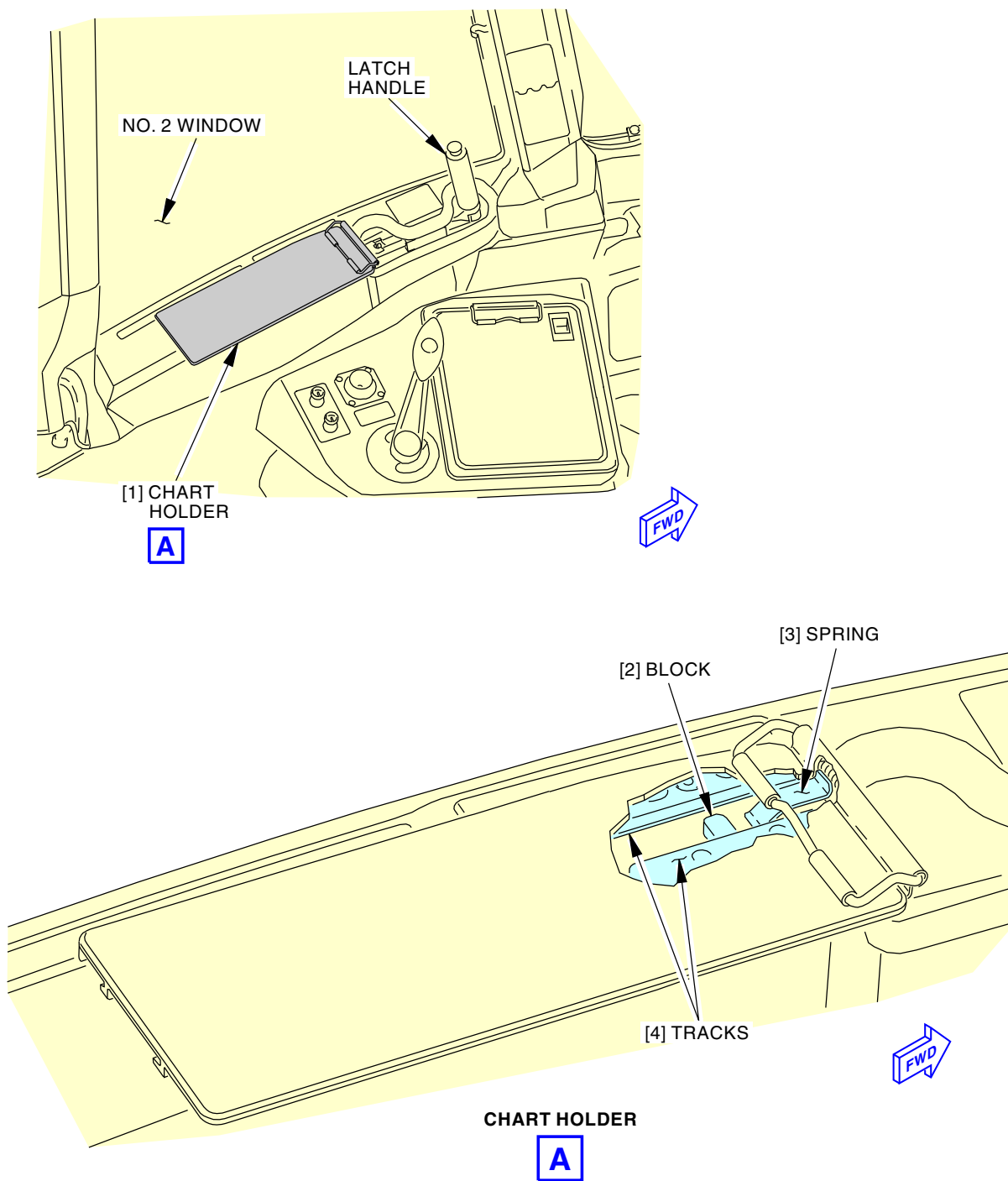
————— **END OF TASK** —————

EFFECTIVITY
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D633W101-ARO

25-13-01

Page 401
Jan 05/2015



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**Chart Holder Installation
Figure 401/25-13-01-990-801**

EFFECTIVITY
ARO ALL

25-13-01

D633W101-ARO

Page 402
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
SIDE CONSOLE - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) The removal for the top of the side console.
 - (2) The installation for the top of the side console.

TASK 25-15-01-000-801

2. Side Console - Removal

(Figure 401, Figure 402)

A. General

- (1) The top of the side console for the first officer is two panels. The top of the side console for the captain is only one panel.

B. References

<u>Reference</u>	<u>Title</u>
25-15-03-000-801	Forward Console Removal (P/B 401)
35-11-18 P/B 201	CREW OXYGEN MASK AND STOWAGE BOX - MAINTENANCE PRACTICES

C. Location Zones

<u>Zone</u>	<u>Area</u>
211	Flight Compartment, Left
212	Flight Compartment, Right

D. Prepare for the Removal

SUBTASK 25-15-01-860-003

- (1) Open these circuit breakers and install safety tags:

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
G	21	C33503	CHART, WORKTABLE & FLOOR LTS
G	22	C33501	UTIL & MAP LTS

SUBTASK 25-15-01-010-001

- (2) Do these steps to remove the No. 2 window crank handle [2], [31]:
 - (a) Remove the screws [3] to disconnect the window crank handle [2], [31] from the shaft.
 - (b) Remove the window crank handle [2], [31].

SUBTASK 25-15-01-020-001

- (3) Remove the reveal [4], [32].

SUBTASK 25-15-01-010-002

- (4) Do this task: Forward Console Removal, TASK 25-15-03-000-801.

E. Side Console Removal

SUBTASK 25-15-01-020-005

- (1) Remove the oxygen box assembly. Do the applicable task in this procedure: CREW OXYGEN MASK AND STOWAGE BOX - MAINTENANCE PRACTICES, PAGEBLOCK 35-11-18/201

SUBTASK 25-15-01-020-002

- (2) Do these steps to remove the top of the captain's side console [6]:

EFFECTIVITY
ARO ALL

25-15-01

D633W101-ARO

Page 401
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Remove the stowage compartment [12] for the survivor.
- (b) Remove the suitcases [1], if it is applicable, to get access to the heads of the screws [18], [19] below the side console top [6].
- (c) Remove the screws [18], [19].
NOTE: These screws attach the top of the side console to the brackets on the closet and side console base.
- (d) Remove the cupholder [13] to get access to additional screws [17].
- (e) Remove the screws [17] parallel to the top of the side console [6].
- (f) Remove the screws [16] around the edges that attach the side console top [6] to the base [5].
- (g) Remove the screws [10] that attach the bracket [11] to the side console top [6] forward of the oxygen box opening [7].
- (h) Remove the screws [15] that are below the bracket [11].
- (i) Remove the screw [14] that is aft of the oxygen box opening [7] and adjacent to the window track.
- (j) Remove the side console top [6].

SUBTASK 25-15-01-020-003

- (3) Do these steps to remove the top of the first officer's side console [34], [44]:
 - (a) Do these step to remove the upper part of the side console top [34]:
 - 1) Remove the screws [16] around the edge that attach the side console top [34] to the base [33].
 - 2) Remove the screws [40] that attach the top of the side console [34] to the support structure below the window structure.
 - 3) Remove the screws [38] that attach the bracket [37] to the side console top [34] forward of the oxygen box opening [7].
 - 4) Remove the screws [15] that are below the bracket [37].
 - 5) Remove the screw [39] that is aft of the oxygen box opening [7] and adjacent to the window track.
 - 6) Remove the upper part of the side console top [34].
 - (b) Do these steps to remove the lower part of the side console top [44]:
 - 1) Remove the screws [42] that attach the keyboard stowage [43] to the side console top [44].
 - 2) Remove the keyboard stowage [43].
 - 3) Remove the screws [41] that attach the side console top [44] to the base [33] and support structure.
 - 4) Remove the lower part of the side console top [44].

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-15-01

D633W101-ARO

Page 402
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-15-01-400-801

3. **Side Console - Installation**

(Figure 401, Figure 402)

A. References

Reference	Title
25-15-03-400-801	Forward Console Installation (P/B 401)
35-11-18 P/B 201	CREW OXYGEN MASK AND STOWAGE BOX - MAINTENANCE PRACTICES

B. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

C. Side Console Installation

SUBTASK 25-15-01-860-002

- (1) Make sure that these circuit breakers are open and have safety tags:

Right Power Management Panel, P210

Row	Col	Number	Name
G	21	C33503	CHART, WORKTABLE & FLOOR LTS
G	22	C33501	UTIL & MAP LTS

SUBTASK 25-15-01-420-001

- (2) Do these steps to install the top of the captain's side console [6]:
- Put the side console top [6] on the base [5].
 - Install the screws [15] forward of the oxygen box opening [7].
 - Install the screw [14] aft of the oxygen box opening [7] and adjacent to the window track.
 - Install the bracket [11] with the screws [10] forward of the oxygen box opening [7].
 - Install the screws [16] around the edges that attach the side console top [6] to the base [5].
 - Install the screws [17] parallel to the top of the side console [6] through the cupholder [13] opening.
 - Install the cupholder [13].
 - Install the screws [18], [19] through the bottom of the side console top [6] where the suitcases [1] are stowed.
NOTE: These screws attach the top of the side console to the brackets on the closet and side console base.
 - Put the suitcases [1] in the opening if you removed them to do the removal task.
 - Install the stowage compartment [12] for the survivor.

SUBTASK 25-15-01-420-002

- (3) Do these steps to install the top of the first officer's side console [34], [44]:
- Do these steps to install the lower part of the side console top [44]:
 - Put the side console top [44] on the base [33].
 - Install the screws [16], [41] that attach the side console top [44] to the base [33] and support structure.

EFFECTIVITY
ARO ALL

25-15-01

D633W101-ARO

Page 403
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 3) Put the keyboard stowage [43] on the side console top [44] and align the holes for the screws [42].
- 4) Install the screws [42] that attach the keyboard stowage [43] to the side console top [44].
- (b) Do these steps to install the upper part of the side console top [34]:
 - 1) Put the upper part of the side console top [34] on the base [33].
 - 2) Install the screws [15] forward of the oxygen box opening [7].
 - 3) Install the screw [39] aft of the oxygen box opening [7] and adjacent to the window track.
 - 4) Install the bracket [37] with the screws [38] forward of the oxygen box opening [7].
 - 5) Install the screws [16] around the edge that attach the side console top [34] to the base [33].
 - 6) Install the screws [40] that attach the top of the side console [34] to the support structure below the window structure.

SUBTASK 25-15-01-420-003

- (4) Install the oxygen box. Do the applicable task in this procedure: CREW OXYGEN MASK AND STOWAGE BOX - MAINTENANCE PRACTICES, PAGEBLOCK 35-11-18/201

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-15-01-860-001

- (1) Remove the safety tags and close these circuit breakers:

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
G	21	C33503	CHART, WORKTABLE & FLOOR LTS
G	22	C33501	UTIL & MAP LTS

SUBTASK 25-15-01-410-002

- (2) Install the window reveal [4], [32].

SUBTASK 25-15-01-410-001

- (3) Do these steps to install the No. 2 window crank handle [2], [31]:
 - (a) Put the window crank handle [2], [31] on the shaft.
 - (b) Install the window crank handle [2], [31] with the screws [3].

SUBTASK 25-15-01-420-004

- (4) Do this task: Forward Console Installation, TASK 25-15-03-400-801.

————— **END OF TASK** —————

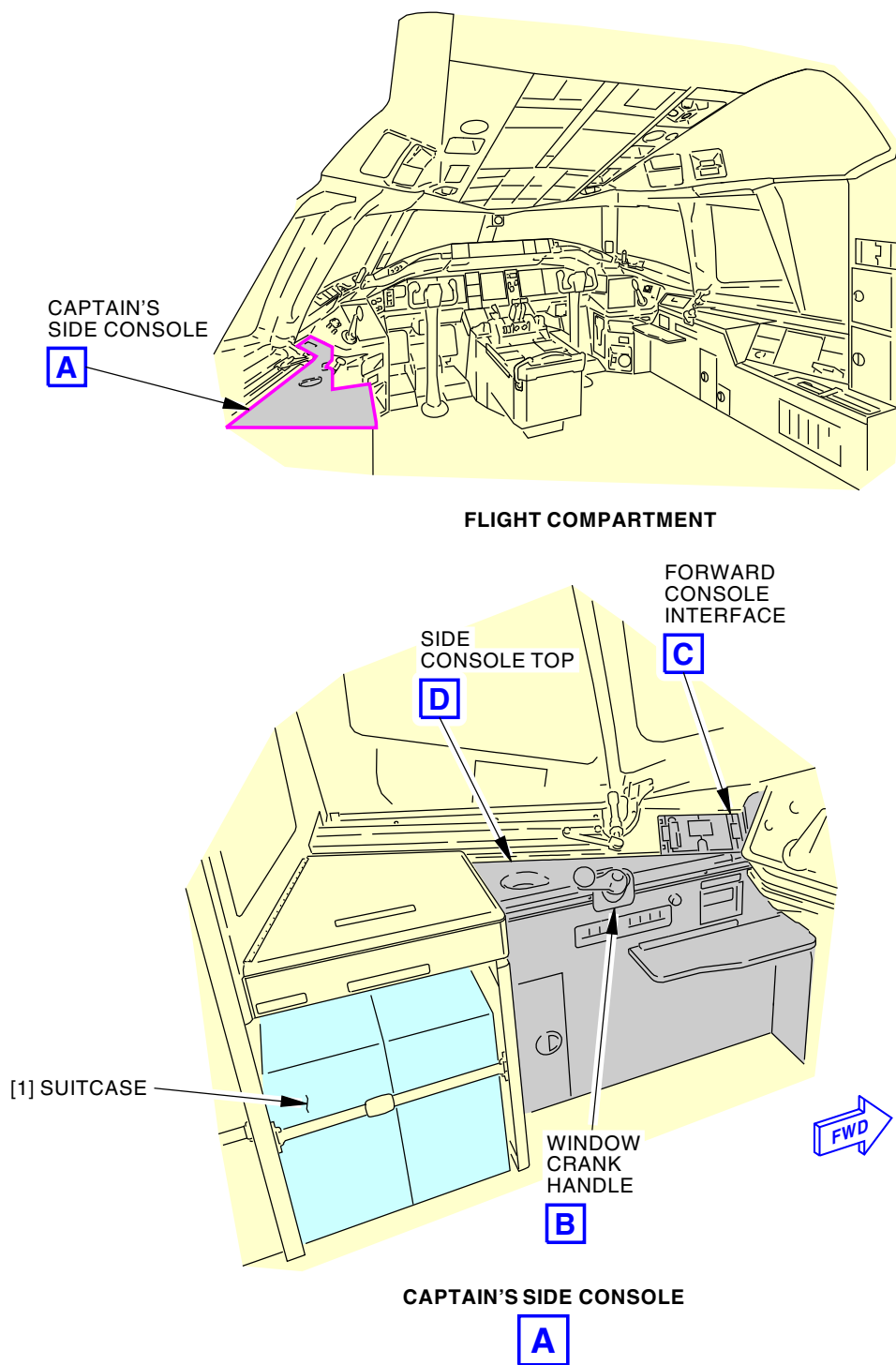
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D633W101-ARO

25-15-01

Page 404
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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Captain's Side Console Installation
Figure 401/25-15-01-990-801 (Sheet 1 of 3)

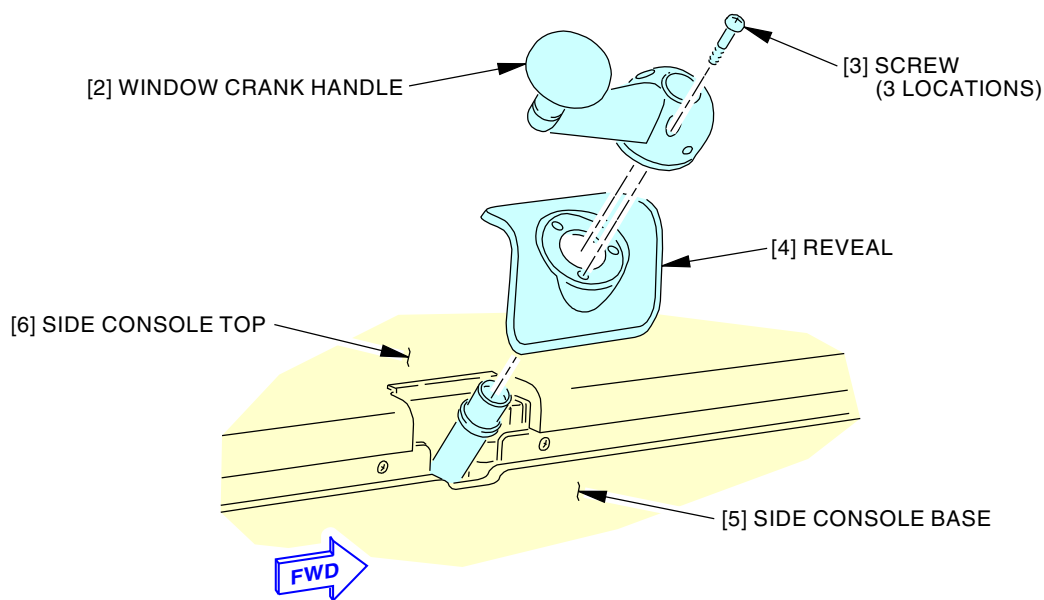
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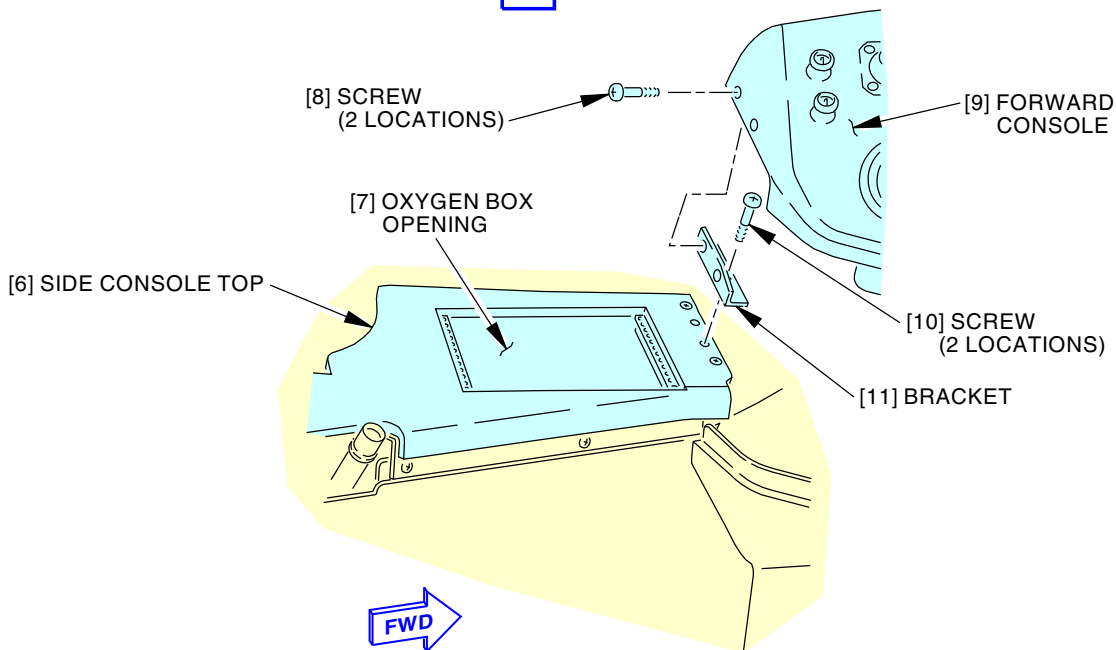
Page 405
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



WINDOW CRANK HANDLE

B



FORWARD CONSOLE INTERFACE

C

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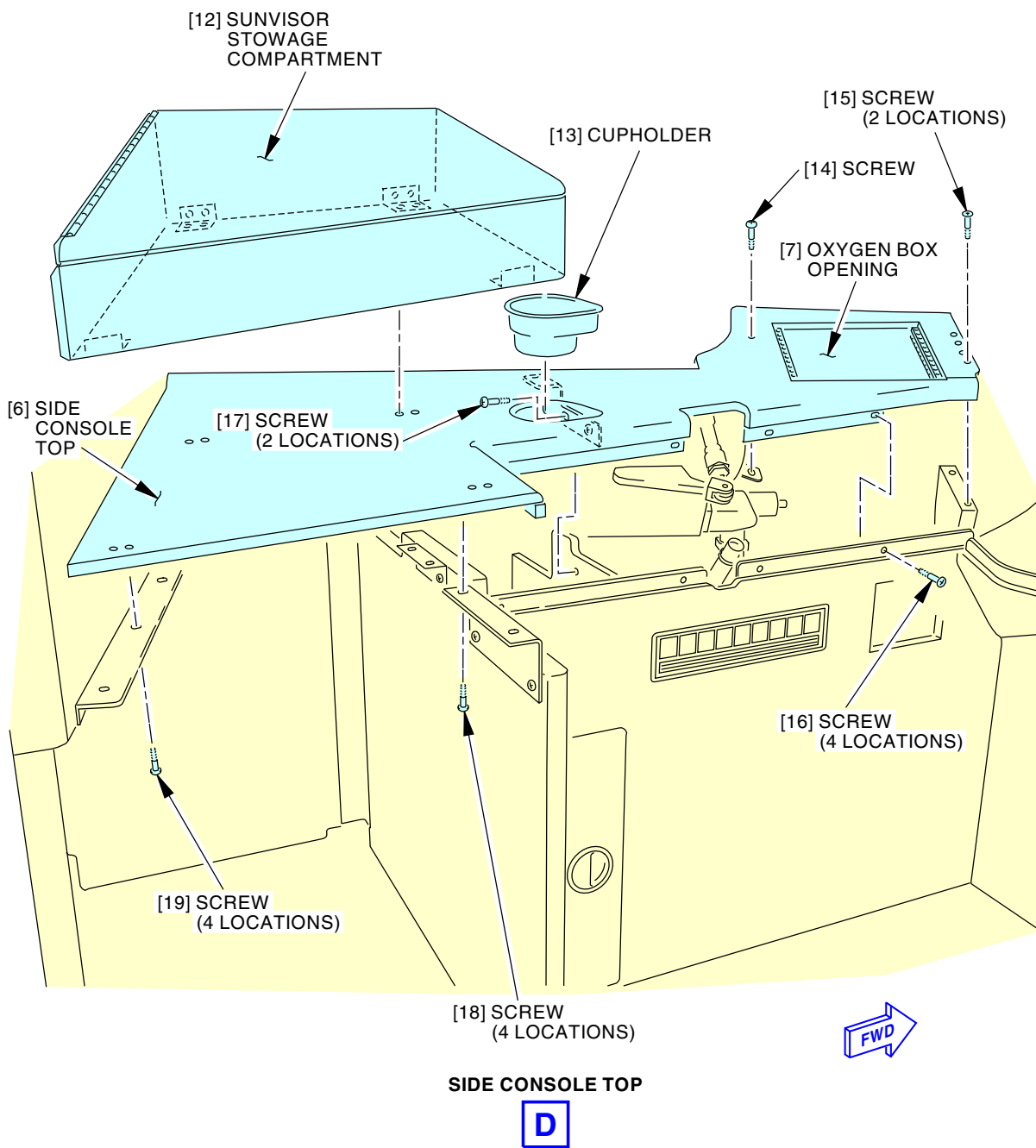
Captain's Side Console Installation
Figure 401/25-15-01-990-801 (Sheet 2 of 3)

EFFECTIVITY
ARO ALL

25-15-01

D633W101-ARO

Page 406
May 05/2017



E48142 S0006408822_V2

**Captain's Side Console Installation
Figure 401/25-15-01-990-801 (Sheet 3 of 3)**

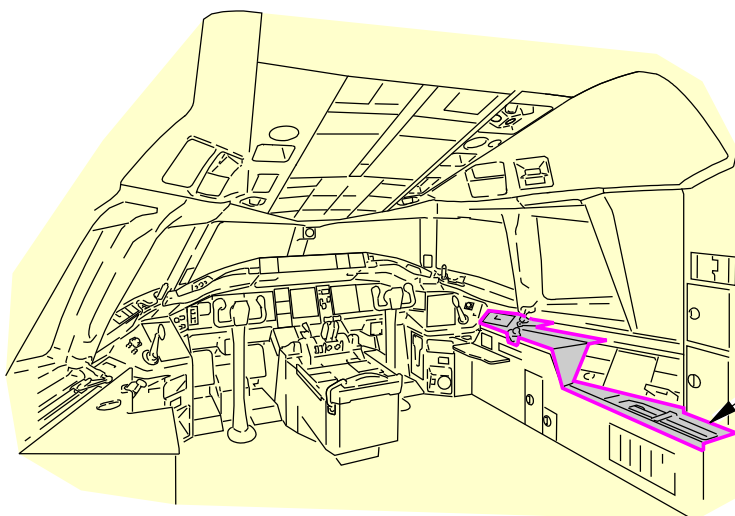
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ARO ALL

25-15-01

D633W101-ARO

Page 407
May 05/2017

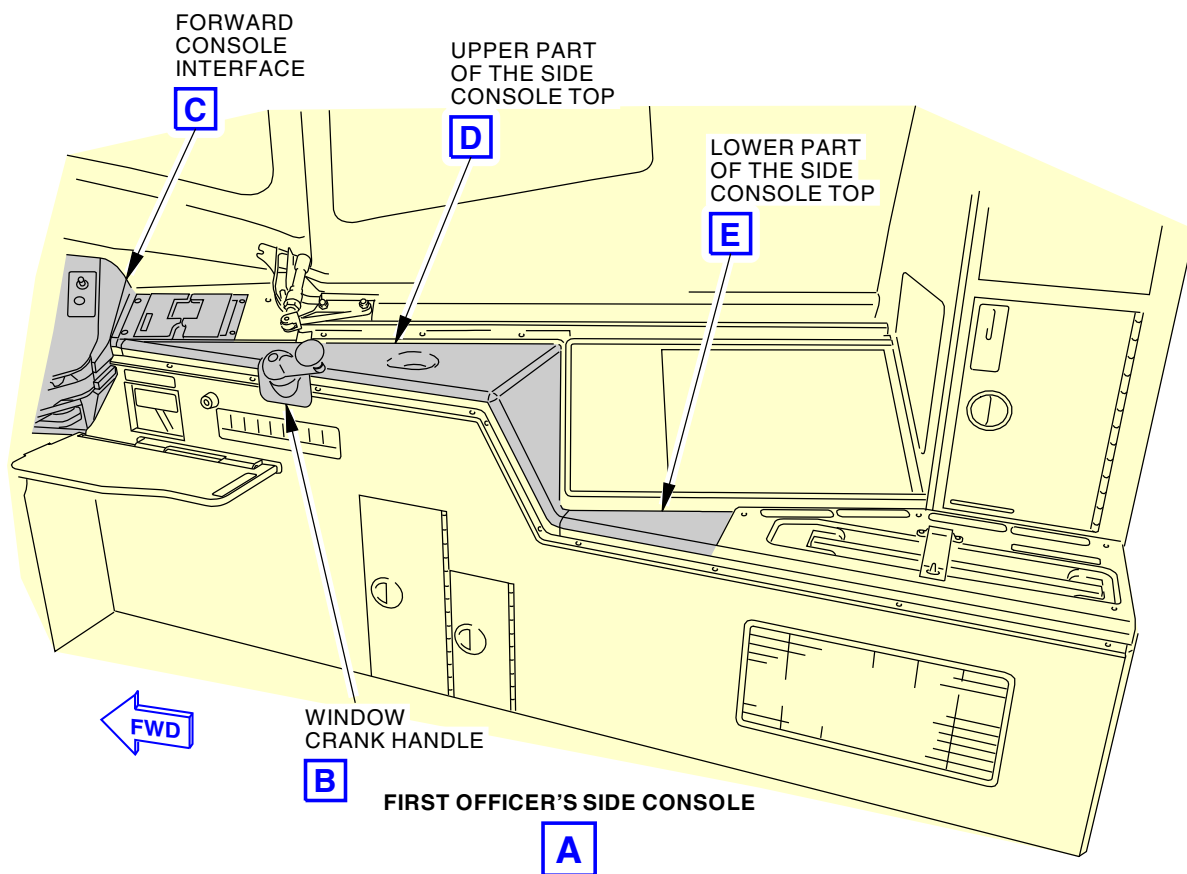
777-200/300
AIRCRAFT MAINTENANCE MANUAL



FIRST OFFICER'S
SIDE CONSOLE

A

FLIGHT COMPARTMENT



E01839 S0006408823_V2

First Officer's Side Console Installation
Figure 402/25-15-01-990-802 (Sheet 1 of 3)

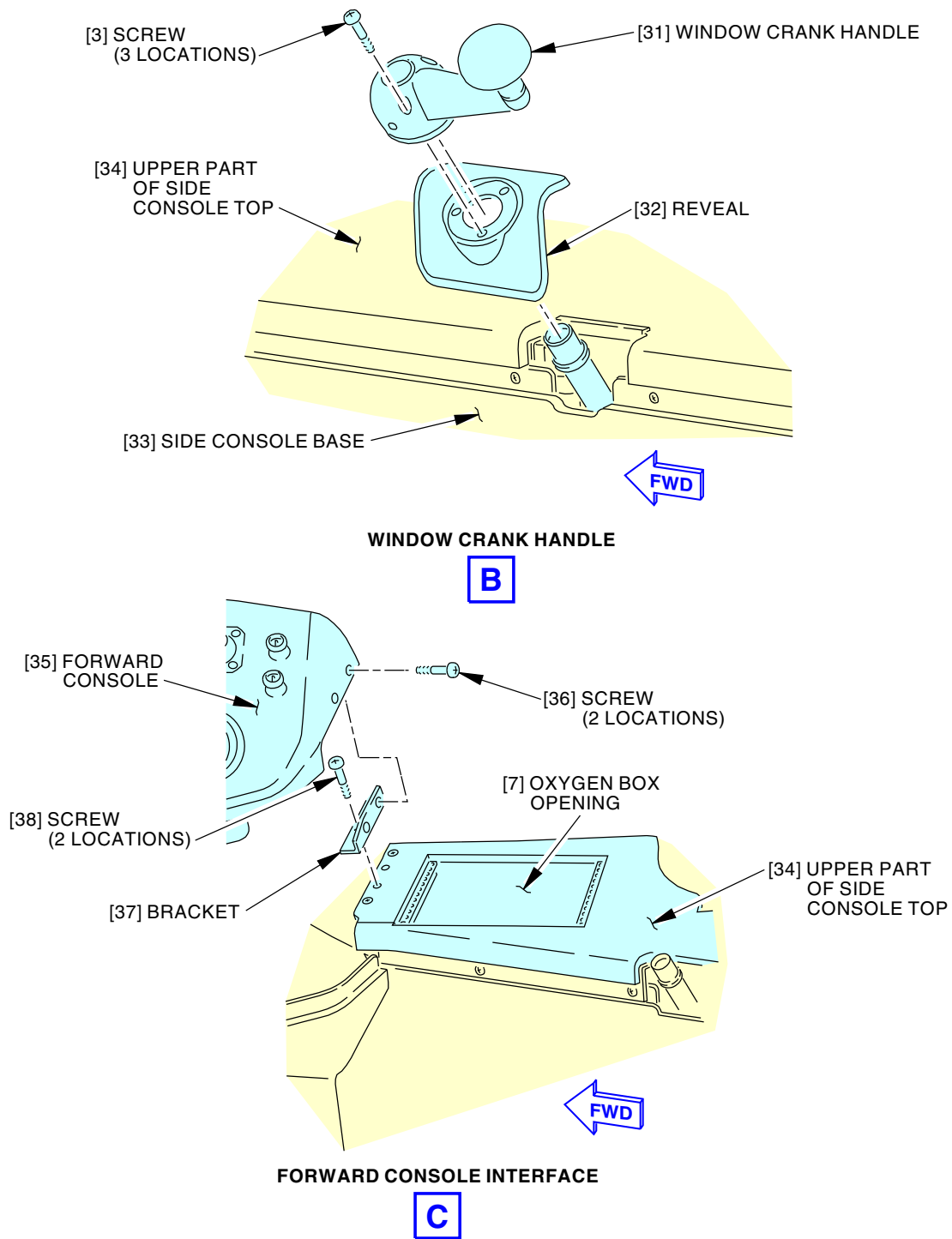
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25-15-01

D633W101-ARO

Page 408
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**First Officer's Side Console Installation
Figure 402/25-15-01-990-802 (Sheet 2 of 3)**

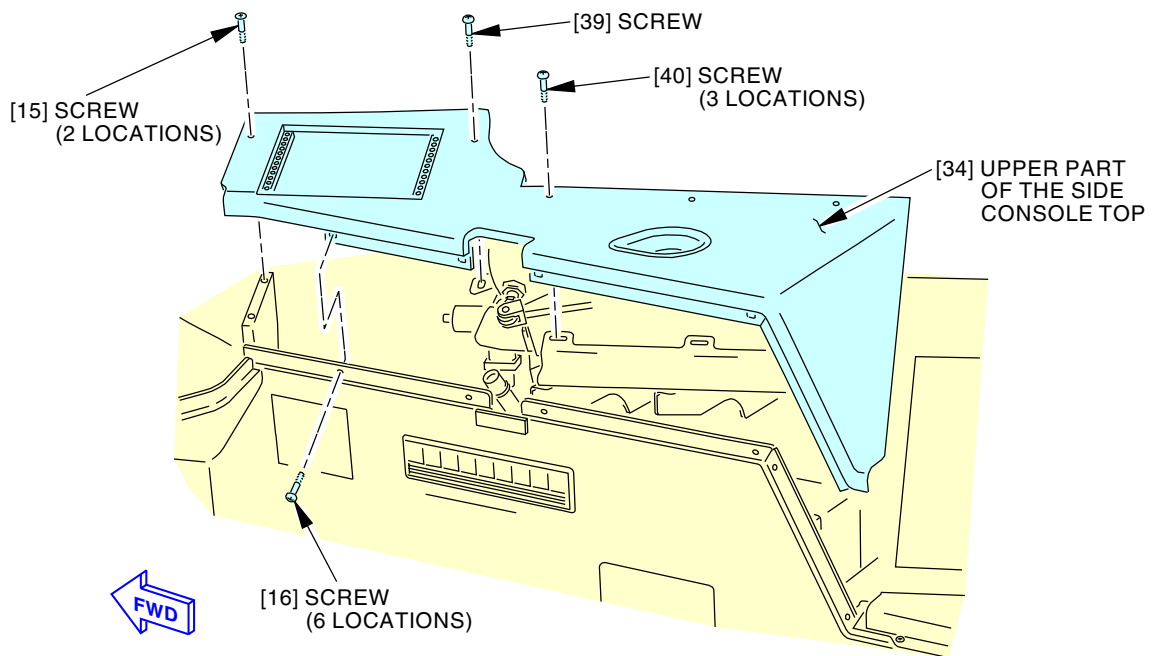
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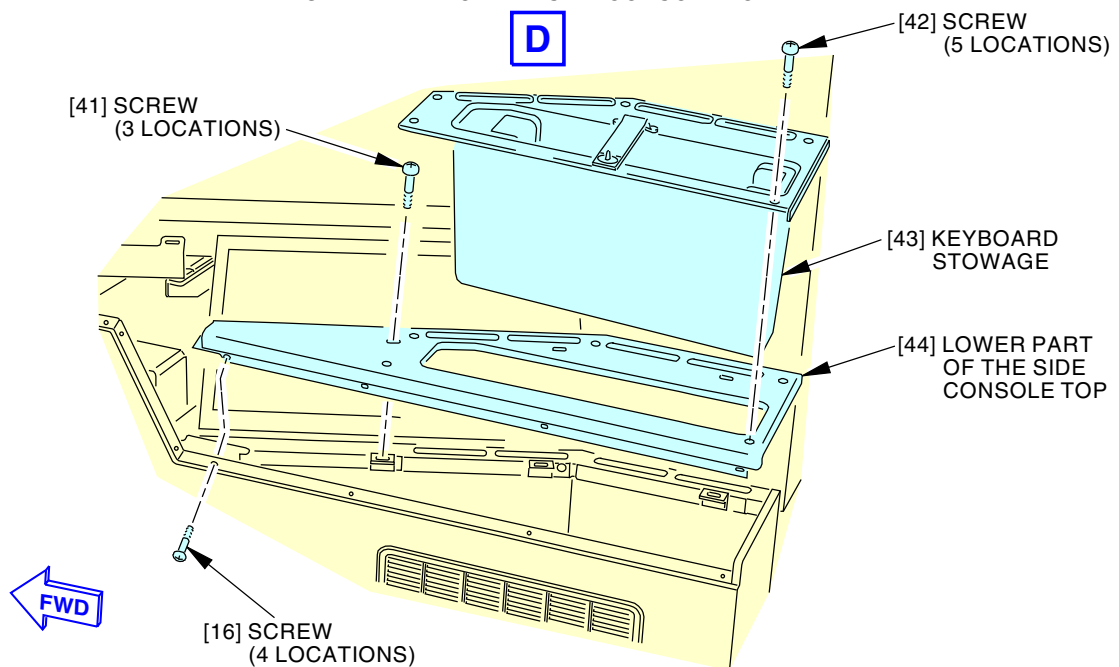
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Page 409
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



UPPER PART OF THE SIDE CONSOLE TOP



LOWER PART OF THE SIDE CONSOLE TOP

E

E48159 S0006408825_V2

First Officer's Side Console Installation
Figure 402/25-15-01-990-802 (Sheet 3 of 3)

EFFECTIVITY
ARO ALL

25-15-01

D633W101-ARO

Page 410
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

FLIGHT DECK STOWAGE CLOSET - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) The removal for the stowage closets.
- (2) The installation for the stowage closets.

TASK 25-15-02-010-801

2. Stowage Closet Removal

(Figure 401, Figure 402)

A. References

Reference	Title
25-11-03-000-802	Second Observer Seat - Removal (P/B 401)
25-15-01-000-801	Side Console - Removal (P/B 401)
35-11-18-000-801	Stowage Box Assembly Removal (P/B 201)

B. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

C. Prepare for the Removal

SUBTASK 25-15-02-010-001

- (1) Remove these items as applicable.
 - (a) Do this task: Stowage Box Assembly Removal, TASK 35-11-18-000-801.
 - (b) Do this task: Second Observer Seat - Removal, TASK 25-11-03-000-802.

D. Stowage Closet Removal

SUBTASK 25-15-02-020-001

- (1) CAPTAIN SIDE CLOSET;
Do these steps to remove the captains side stowage closet (Figure 401):
 - (a) Remove all installed emergency equipment [1].
 - (b) Remove the close out seal from around the closet.
 - (c) Remove flight deck spare bulb stowage unit [2].
 - (d) Remove the door from the flight manual stowage compartment [3].
 - (e) Remove the coat hangar bar [4].
 - (f) Remove the stowage closet back liner walls.
 - (g) Remove the shelf from the flight manual stowage compartment [3].
 - (h) Disconnect the forward wall assembly [5] from the flight deck wall.
 - (i) Disconnect the forward wall assembly [5] from the Captain side console installation (TASK 25-15-01-000-801).
 - (j) Disconnect the forward wall assembly [5] from the flight deck floor.
 - (k) Disconnect the closet inboard wall [6] from the aft flight deck wall.
 - (l) Remove the forward closet wall assembly [5], [6].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-15-02

Page 401
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-15-02-020-002

(2) FIRST OFFICER SIDE CLOSET;

Do these steps to remove the first officer's side stowage closet (Figure 402):

- (a) Remove any loose equipment [21] from the closet.
- (b) Remove the close out seal from around the closet.
- (c) Remove oxygen mask box [22] (TASK 35-11-18-000-801).
- (d) Remove First Officers lower side console [23] (TASK 25-15-01-000-801).
- (e) Remove the doors from flight manual stowage compartment [24] if necessary.
- (f) Remove the access panel from the rear of the upper flight manual stowage compartment [24].
- (g) Remove the back panels from the stowage compartments.
- (h) Disconnect the forward closet wall [25] from the flight deck side structure.
- (i) Disconnect the closet from the aft flight deck wall.
NOTE: Access lower attachments through the first officers side console.
- (j) Remove the stowage closet walls.

————— END OF TASK —————

TASK 25-15-02-400-801

3. Stowage Closet Installation

(Figure 401, Figure 402)

A. References

Reference	Title
25-15-01-000-801	Side Console - Removal (P/B 401)
25-15-01-400-801	Side Console - Installation (P/B 401)
35-11-18-000-801	Stowage Box Assembly Removal (P/B 201)
35-11-18-400-802	Stowage Box Assembly Installation (P/B 201)

B. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

C. Stowage Closet Installation

SUBTASK 25-15-02-020-003

(1) CAPTAIN SIDE CLOSET;

Do these steps to install the captains side stowage closet (Figure 401):

- (a) Position the forward closet wall assembly [5], [6] in the aft left area of the flight deck.
- (b) Connect the closet assembly to the aft flight deck wall.
- (c) Connect the forward wall assembly [6] to the flight deck floor.
- (d) Connect the forward wall assembly [5] to the Captains side console installation [7] (TASK 25-15-01-000-801).
- (e) Connect the forward wall assembly [5] to the flight deck wall.
- (f) Install the shelf in the flight manual stowage compartment [3].

EFFECTIVITY
ARO ALL

25-15-02

D633W101-ARO

Page 402
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (g) Install the stowage closet back liner walls.
- (h) Install the coat hangar bar [4].
 - (i) Install the door to the flight manual stowage compartment [3].
 - (j) Install the flight deck spare bulb stowage unit [2].
- (k) Install the close out seal around the closet.
- (l) Install the emergency equipment [1] in the closet as needed.

SUBTASK 25-15-02-020-004

(2) FIRST OFFICER SIDE CLOSET;

Do these steps to install the first officer's side stowage closet (Figure 402):

- (a) Position the First Officers closet assembly in the aft right corner of the flight deck.
- (b) Connect the closet to the aft flight deck wall.

NOTE: Access lower attachments through the first officers side console.
- (c) Connect the forward closet wall [25] to the flight deck side structure.
- (d) Install the back panels to the stowage compartments.
- (e) Install the access panel to the rear of the upper flight manual stowage compartment [24].
- (f) Install the door to the stowage compartment [24] if needed.
- (g) Install the First Officers lower side console [23] (TASK 25-15-01-000-801).
- (h) Install the oxygen mask box [22] (TASK 35-11-18-000-801).
- (i) Install loose equipment [21] in the closet as needed.
- (j) Install the close out seal around the closet.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-15-02-010-002

- (1) Do these tasks as necessary:
 - (a) Do this task: Side Console - Installation, TASK 25-15-01-400-801.
 - (b) Do this task: Stowage Box Assembly Installation, TASK 35-11-18-400-802.

————— **END OF TASK** —————

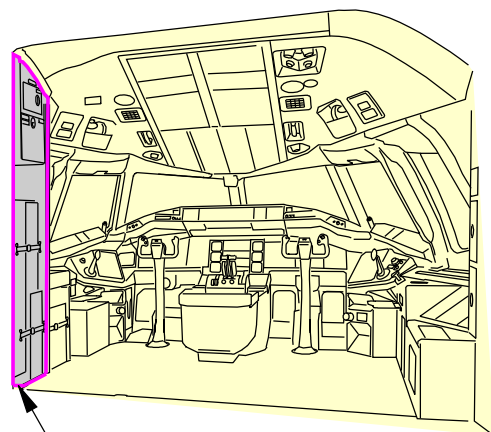
EFFECTIVITY
ARO ALL

25-15-02

D633W101-ARO

Page 403
Jan 05/2015

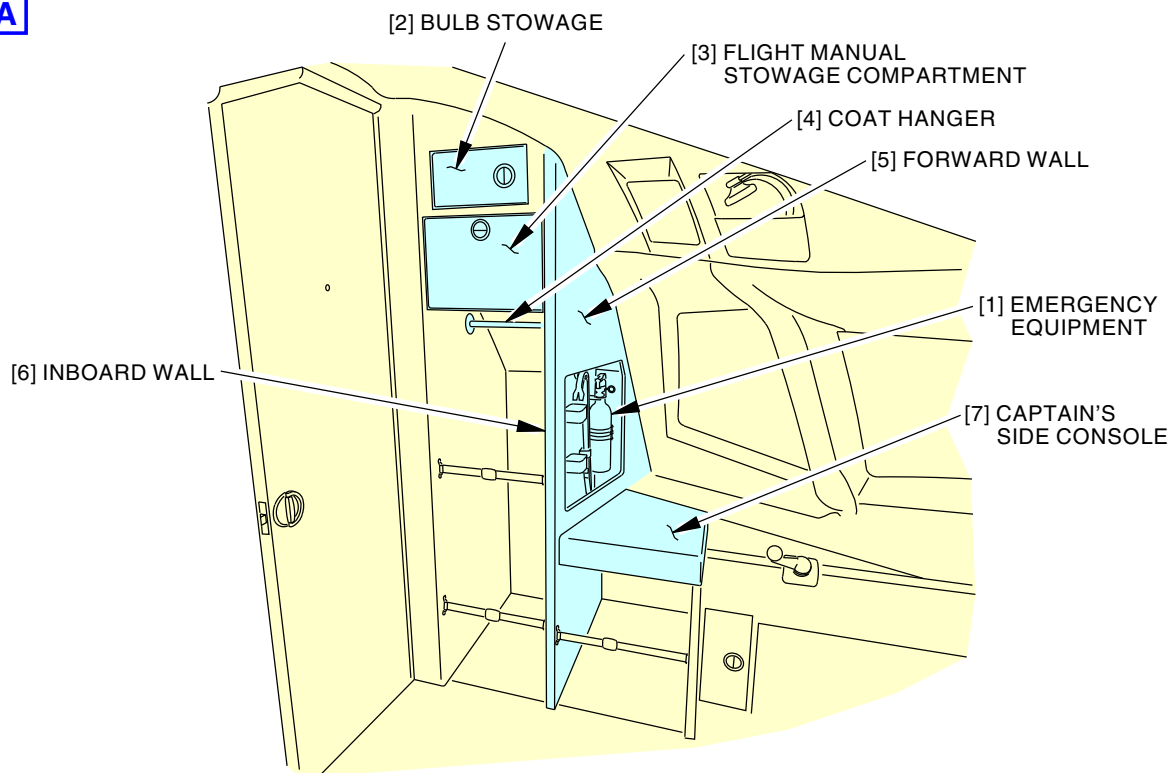
**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



FLIGHT COMPARTMENT

CAPTAIN'S
STOWAGE
CLOSET

A



CAPTAIN'S STOWAGE CLOSET

A

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**Flight Deck Closet Installation
Figure 401/25-15-02-990-801**

EFFECTIVITY
ARO ALL

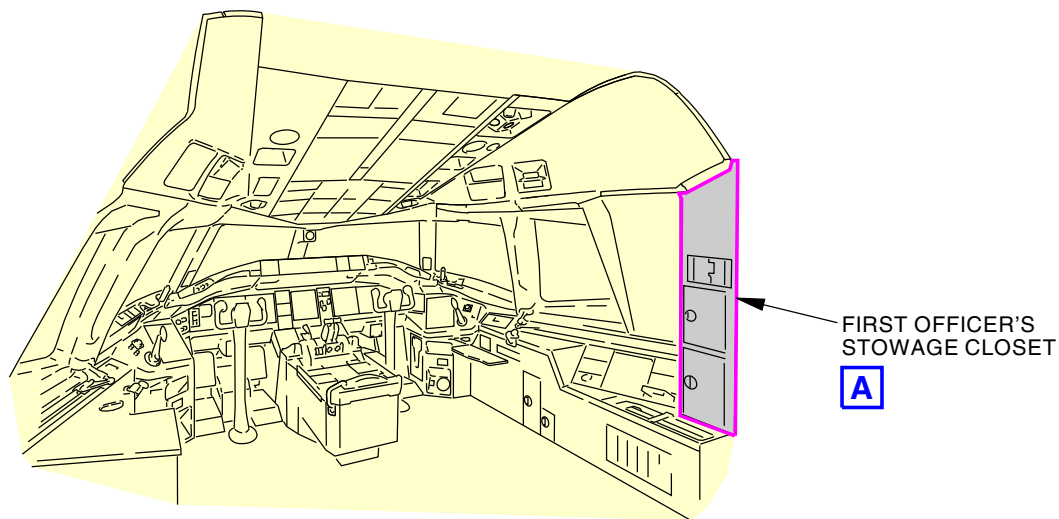
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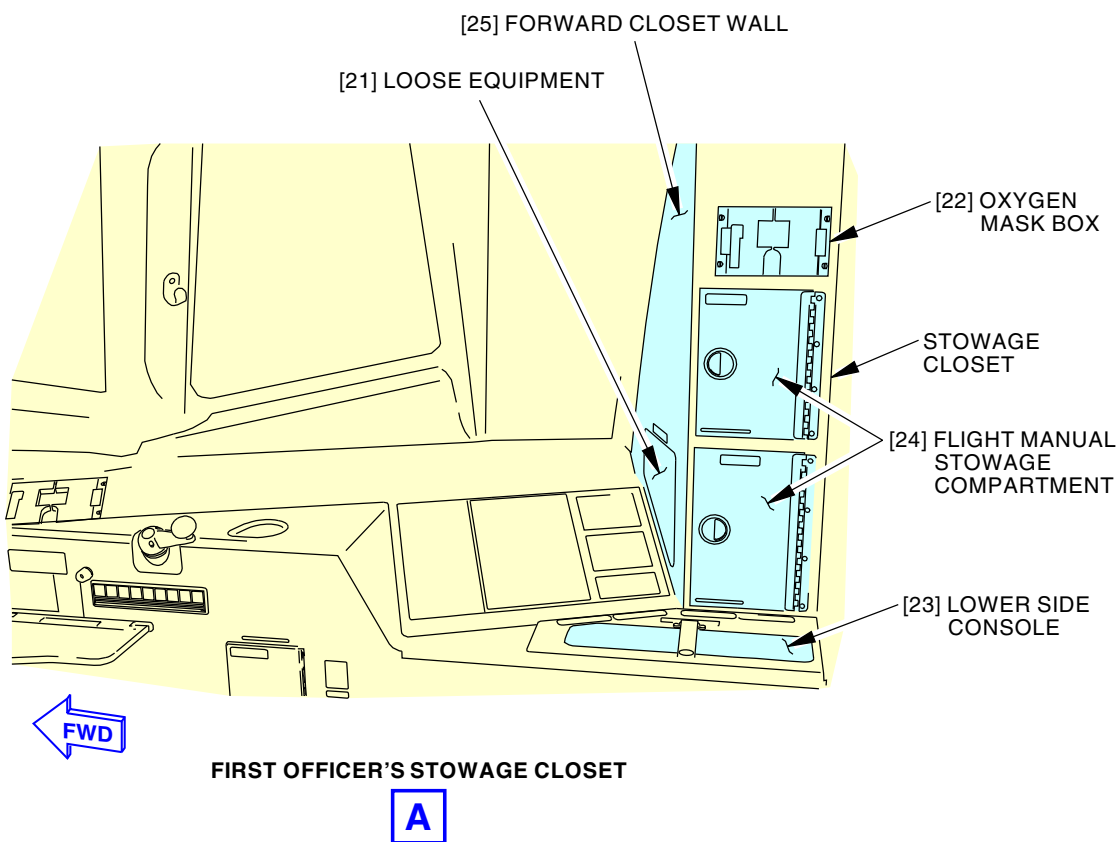
Page 404
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



FLIGHT COMPARTMENT



M19392 S0006408831_V2

Flight Deck Stowage Closet Installation
Figure 402/25-15-02-990-802

EFFECTIVITY
ARO ALL

25-15-02

D633W101-ARO

Page 405
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

FORWARD CONSOLE - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) A removal of the forward console.
 - (2) An installation of the forward console.
- B. The captain and first officer have a forward console. This procedure is applicable to the two forward consoles.
- C. The forward console has a top and a base. The top and base are removed and installed separately. It is necessary to remove the top before you remove the base.

TASK 25-15-03-000-801

2. Forward Console Removal

(Figure 401)

A. **References**

Reference	Title
32-51-10-000-801	Nose Landing Gear Steering Tiller Removal (P/B 401)
46-11-02-000-801	Display Unit Removal (P/B 401)

B. **Location Zones**

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

C. **Prepare for the Removal**

SUBTASK 25-15-03-860-001

- (1) Open these circuit breakers and install safety tags:

Overhead Circuit Breaker Panel, P11

Row	Col	Number	Name
B	25	C23627	INTERPHONE-CAPTAIN
C	25	C23628	INTERPHONE-F/O

Standby Power Management Panel, P310

Row	Col	Number	Name
A	2	C33407	STBY INST LTS

SUBTASK 25-15-03-020-004

- (2) Do this task: Display Unit Removal, TASK 46-11-02-000-801.

D. **Forward Console Removal**

SUBTASK 25-15-03-020-002

- (1) Do these steps to remove the forward console top [5]:
 - (a) Do these steps to remove the air outlet [13]:
 - 1) Remove the screws [12] to disconnect the air outlet [13] from the forward console top [5].
- NOTE:** The removal of the air outlet may allow the hose to fall into the console. Make sure you secure the hose before you remove the 4th screw.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-15-03

Page 401
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 2) Disconnect the hose from the air outlet [13].
- (b) Do these steps to remove the Brightness/Heater Control Module [14]:
 - 1) Turn the quarter-turn fasteners [15] to disconnect the module [14] from the support [18].
 - 2) Pull the module [14] away from the support [18] to get access to the electrical connectors [17].
 - 3) Disconnect the electrical connectors [17].
- (c) Do these steps to disconnect the light control knobs [11] from the forward console top [5]:
 - 1) Pull the knobs [11] off of the shaft.
 - 2) Loosen the nuts [9] and washers [10] that hold the knobs [11] on the shafts.
- (d) To remove the nose landing gear tiller handle [4] do this task: Nose Landing Gear Steering Tiller Removal, TASK 32-51-10-000-801.
- (e) Remove the screws [2] that attach the forward console top [5] to the bracket [33] along the top of the forward console base [26].
- (f) Remove the screws [16] that attach the support [18] for the Brightness/Heater Control Module [14] to the forward console base [26].
- (g) Do these steps to remove the clipboard [1]:
 - 1) Open the clipboard [1] and remove the screws from the bottom of the stowage box.
 - 2) Remove the clipboard [1] and stowage box as one unit.
- (h) Carefully lift the forward console top [5] up along the shaft for the nose landing gear tiller.

SUBTASK 25-15-03-020-003

- (2) Do these steps to remove the forward console base [26]:
 - (a) Remove the screw [23] from along the bottom of the forward console base [26].
 - (b) Remove the screws [30] [32] that attach the inner surface of the forward console base [26] to the support brackets [29] [34].
 - (c) Disconnect the electrical connector [31] for the work table light [3].
 - (d) Remove the screws [22] that attach the speaker [24] to the forward console base [26].
 - (e) Remove the screws [19] to disconnect the electrical connector [21] for the microphone jack [20].
 - (f) Remove the electrical connector [27] for the captain's or first officer's seat.
 - (g) Carefully lift and pull the forward console base [26] inboard to remove it.

————— END OF TASK —————

TASK 25-15-03-400-801

3. Forward Console Installation

(Figure 401)

A. References

Reference	Title
32-51-10-400-801	Nose Landing Gear Steering Tiller Installation (P/B 401)
46-11-02-400-801	Display Unit Installation (P/B 401)

EFFECTIVITY
ARO ALL

25-15-03

D633W101-ARO

Page 402
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

B. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
5	Forward console top	25-15-03-01-095 25-15-03-01-100	ARO ALL ARO ALL
26	Forward console base	25-15-03-05-010 25-15-03-05-015	ARO ALL ARO ALL

C. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

D. Forward Console Installation

SUBTASK 25-15-03-420-001

- (1) Do these steps to install the forward console base [26]:
 - (a) Carefully put the forward console base [26] in the correct position for the installation.
 - (b) Install the screws [23] that attach the bottom of the forward console base [26] to the brackets on the floor.
 - (c) Attach the speaker [24] to the forward console base [26] with the screws [22].
 - (d) Install the screws [30] [32] that attach the inner surface of the forward console base [26] to support brackets [29] [34].
 - (e) Install the electrical connector [21] for the microphone jack [20] with the screws [19].
 - (f) Install the electrical connector [31] for the work table light [3].
 - (g) Install the electrical connector [27] for the captain's or first officer's seat.

SUBTASK 25-15-03-420-002

- (2) Do these steps to install the forward console top [5]:
 - (a) Carefully put the forward console top [5] on the forward console base [26].
 - 1) Make sure the shaft [35] for the nose landing gear tiller goes through the hole in the forward console top [5].
 - 2) Make sure the shafts for the light control knobs [11] go through the holes in the forward console top [5].
 - (b) Install the screws that attach the forward console top [5] to the bracket [33] along the top of the forward console base [26].
 - (c) To install the nose landing gear tiller handle [4], do this task: Nose Landing Gear Steering Tiller Installation, TASK 32-51-10-400-801.
 - (d) Do these steps to connect the light control knobs [11] to the forward console top [5]:
 - 1) Tighten the nuts [9] and washers [10] that hold the shafts on the forward console top [5].
 - 2) Put the knobs [11] on the shafts.
 - (e) Do these steps to install the air outlet [13]:
 - 1) Connect the hose to the air outlet [13].
 - 2) Install the screws [12] to connect the air outlet [13] to the forward console top [5].
 - (f) Do these steps to install the Brightness/Heater Control Module [14]:
 - 1) Install the screws [16] that attach the support [18] to the forward console base [26].

EFFECTIVITY
ARO ALL

25-15-03

D633W101-ARO

Page 403
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 2) Connect the electrical connectors [17].
 - 3) Align the holes in the support [18] with the holes in the brightness/heater control module [14].
 - 4) Turn the quarter-turn fasteners [15] to connect the module [14] to the support [18].
- (g) Do these steps to install the clipboard [1].
- 1) Install the clipboard [1] and stowage box as one unit.
 - 2) Open the clipboard [1] and install the screws in the bottom of the stowage box.

SUBTASK 25-15-03-420-004

- (3) Do this task: Display Unit Installation, TASK 46-11-02-400-801

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-15-03-860-002

- (1) Remove the safety tags and close these circuit breakers:

Overhead Circuit Breaker Panel, P11

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	25	C23627	INTERPHONE-CAPTAIN
C	25	C23628	INTERPHONE-F/O

Standby Power Management Panel, P310

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	2	C33407	STBY INST LTS

————— END OF TASK —————

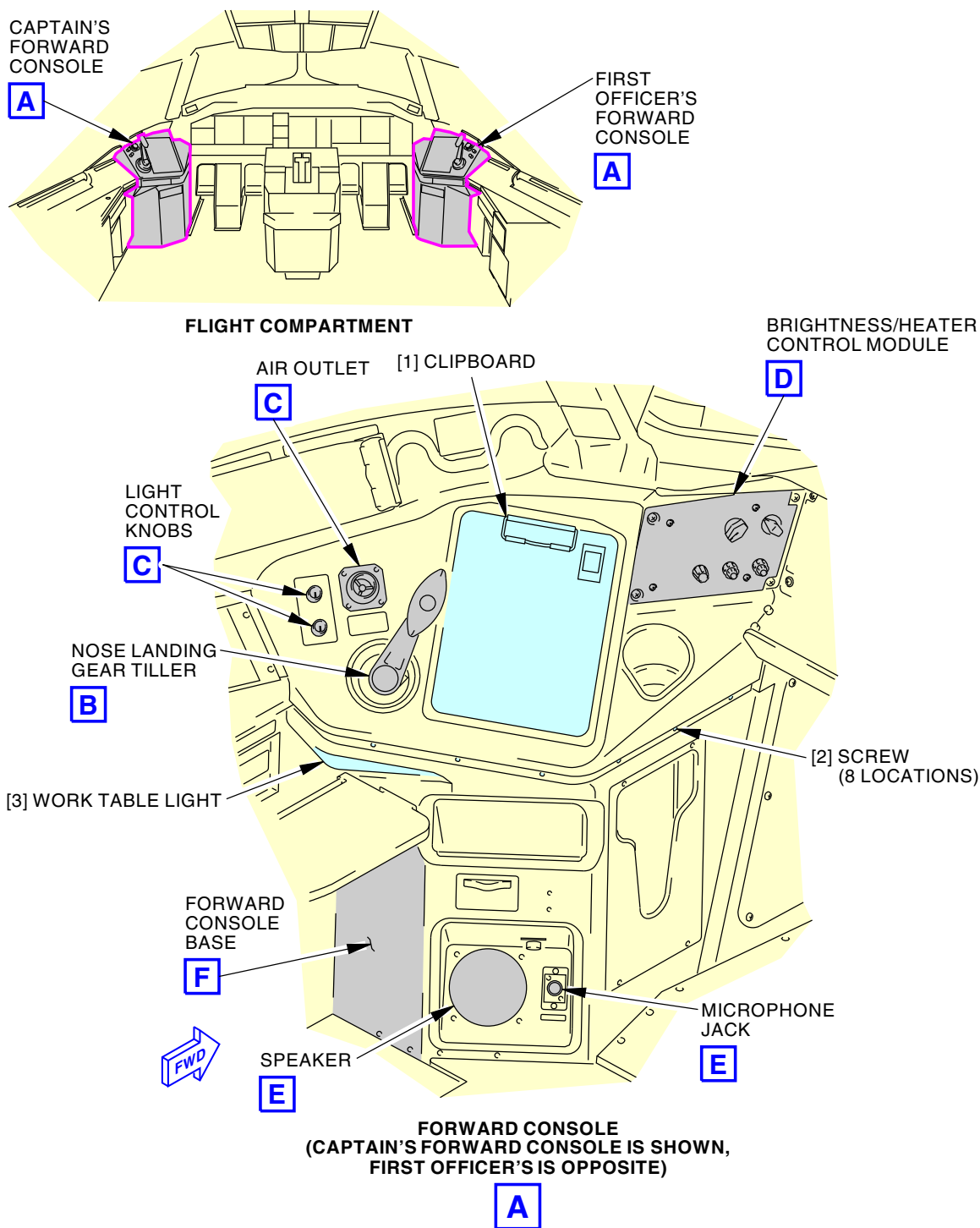
EFFECTIVITY
ARO ALL

25-15-03

D633W101-ARO

Page 404
Jan 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL



E23355 S0006408836_V2

Forward Console Installation
Figure 401/25-15-03-990-801 (Sheet 1 of 5)

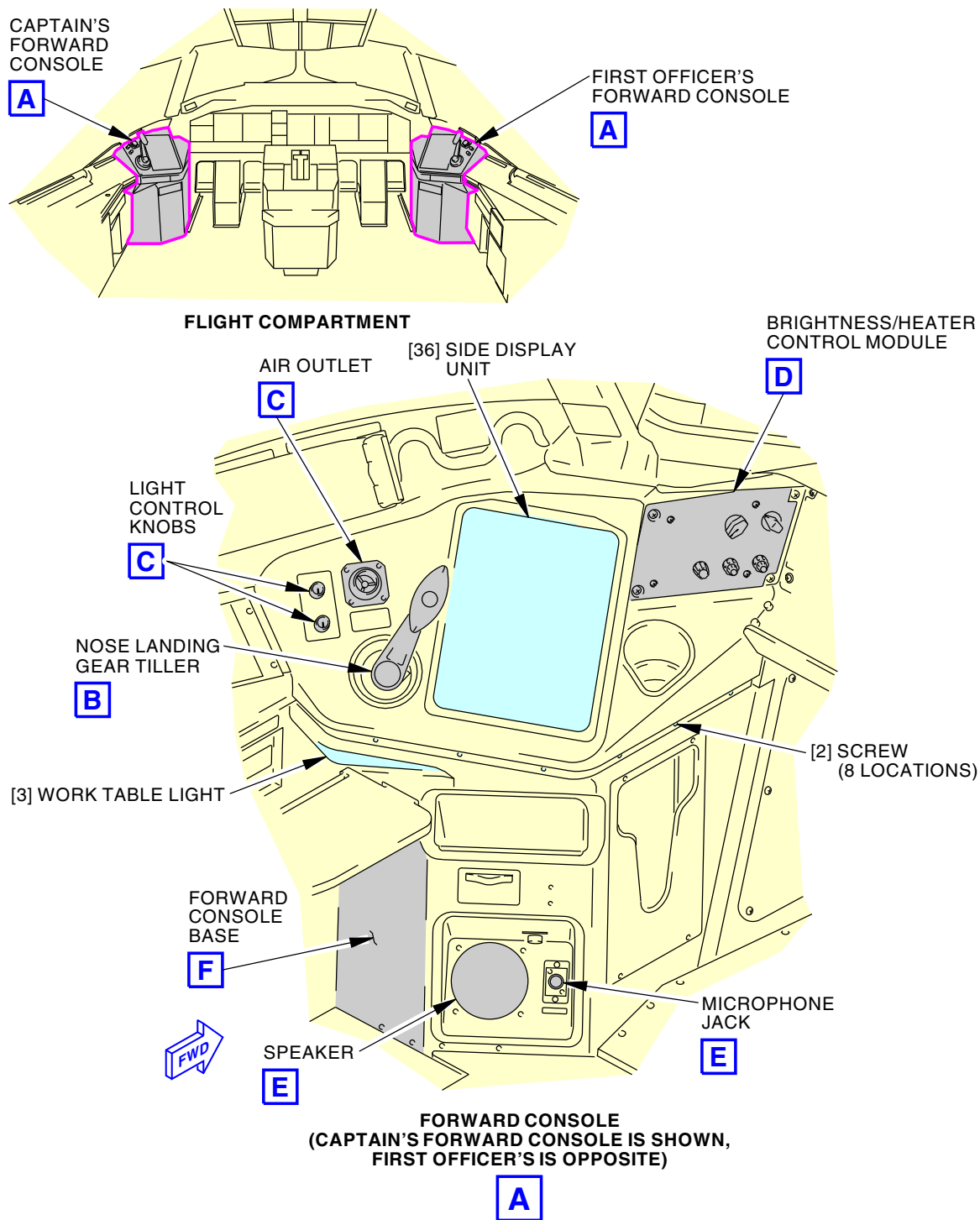
EFFECTIVITY
ARO ALL

25-15-03

Page 405
May 05/2017

D633W101-ARO

777-200/300 AIRCRAFT MAINTENANCE MANUAL



E68630 S0006408837_V2

Forward Console Installation
Figure 401/25-15-03-990-801 (Sheet 2 of 5)

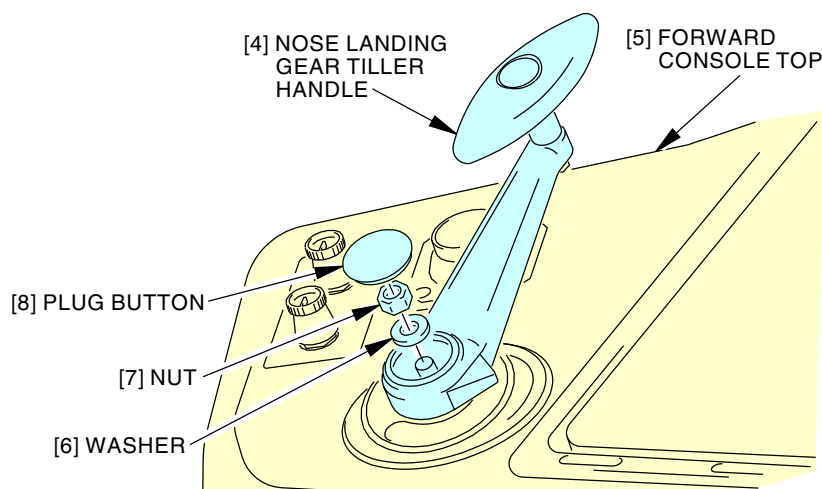
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25-15-03

D633W101-ARO

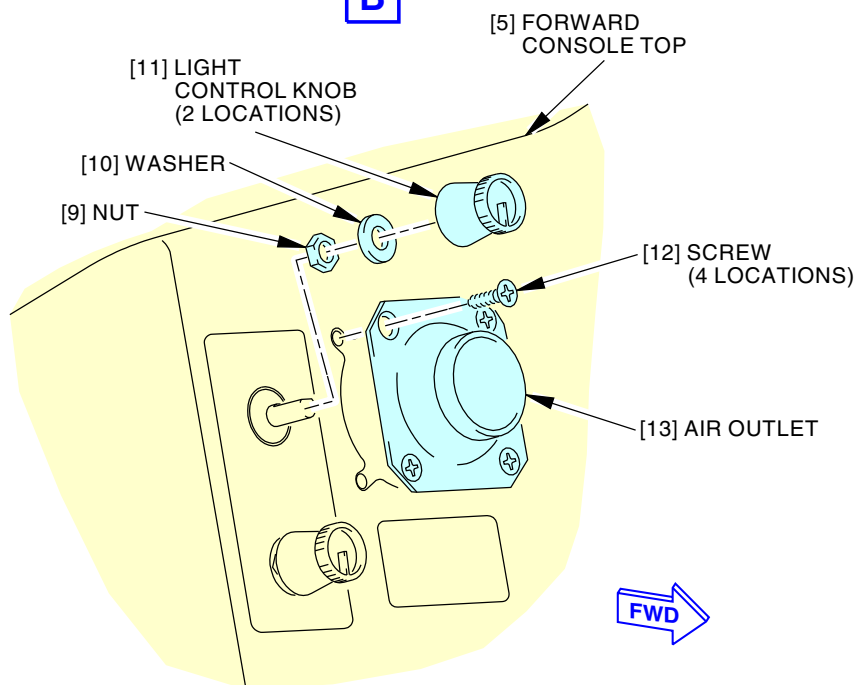
Page 406
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



NOSE LANDING GEAR TILLER

B



LIGHT CONTROL KNOBS AND AIR OUTLET

C

E23360 S0006408838_V2

Forward Console Installation
Figure 401/25-15-03-990-801 (Sheet 3 of 5)

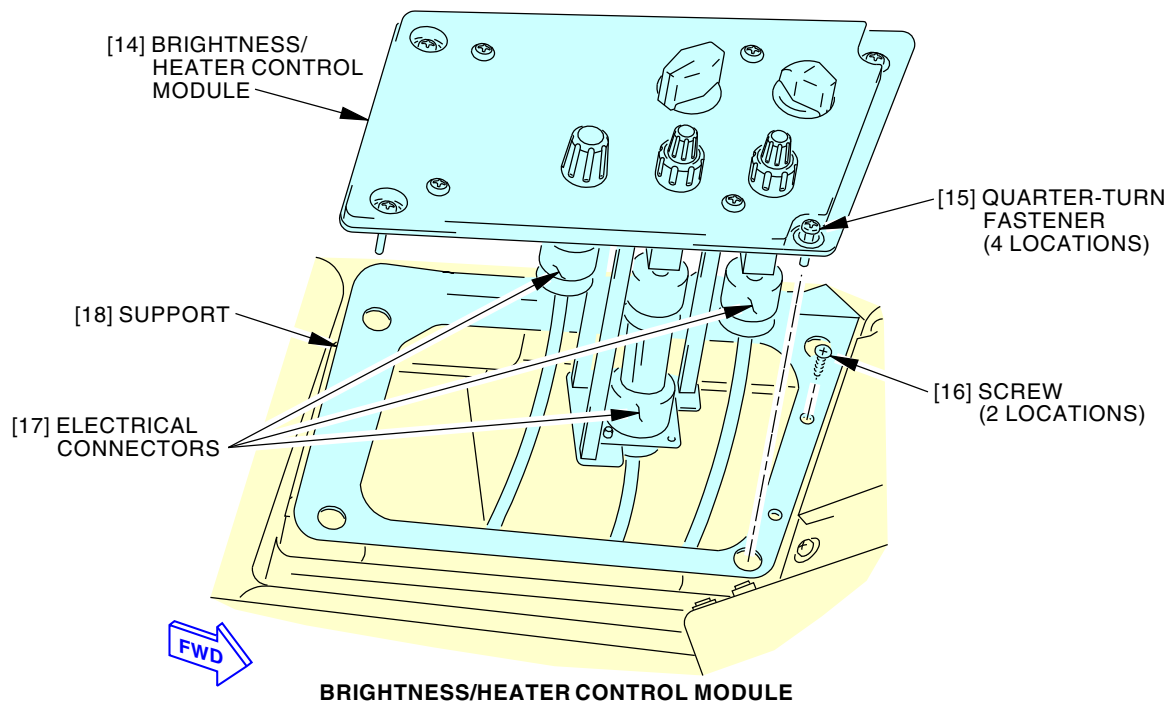
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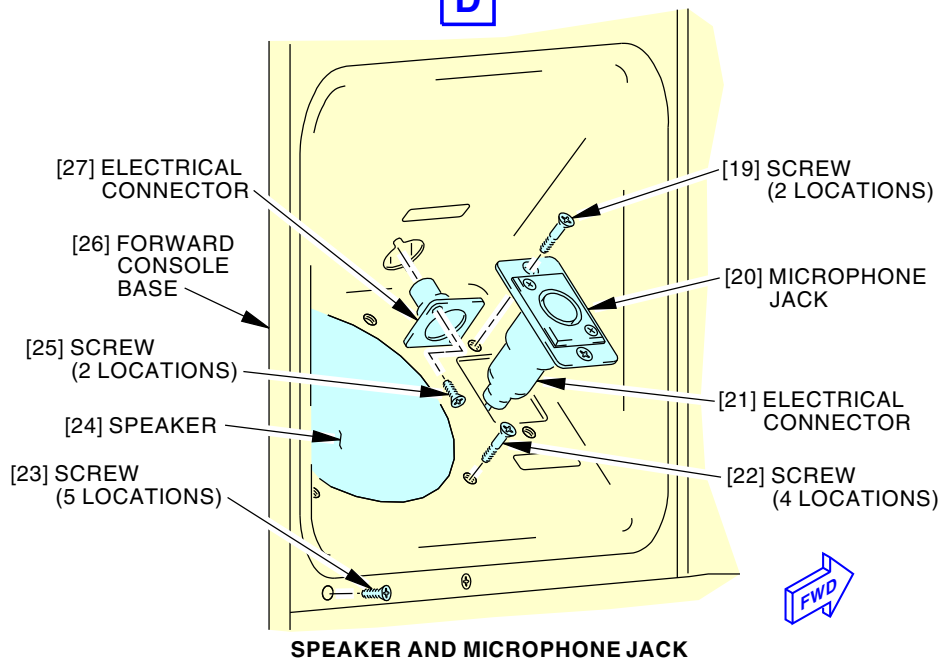
25-15-03

Page 407
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



D



E

E23357 S0006408839_V2

**Forward Console Installation
Figure 401/25-15-03-990-801 (Sheet 4 of 5)**

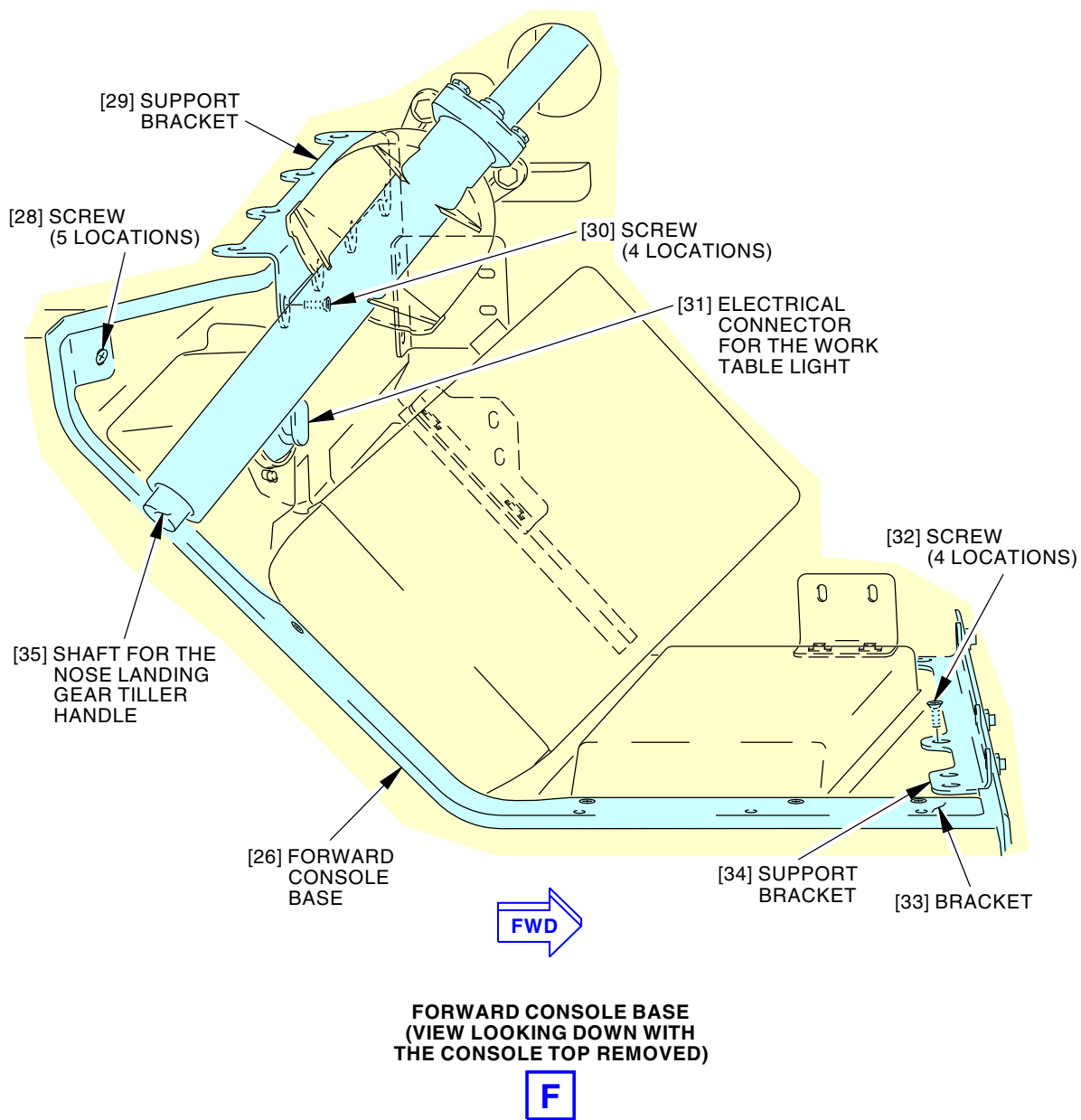
EFFECTIVITY
ARO ALL

D633W101-ARO

25-15-03

Page 408
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**FORWARD CONSOLE BASE
(VIEW LOOKING DOWN WITH
THE CONSOLE TOP REMOVED)**

F

E23359 S0006408840_V2

**Forward Console Installation
Figure 401/25-15-03-990-801 (Sheet 5 of 5)**

**EFFECTIVITY
ARO ALL**

25-15-03

D633W101-ARO

Page 409
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

OBSERVERS CONSOLE - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) The removal for the observers console.
- (2) The installation for the observers console.

TASK 25-15-05-010-801

2. Observers Console Removal

(Figure 401)

A. General

- (1) The observers console is located between the first and second observers seat and it is attached to the aft flight deck wall.

B. References

<u>Reference</u>	<u>Title</u>
23-51-01-000-801	Audio Control Panel (ACP) Removal (P/B 401)
25-11-03-000-801	First Observer Seat - Removal (P/B 401)
25-11-03-000-802	Second Observer Seat - Removal (P/B 401)
35-11-18-000-801	Stowage Box Assembly Removal (P/B 201)

C. Location Zones

<u>Zone</u>	<u>Area</u>
212	Flight Compartment, Right

D. Prepare for the Removal

SUBTASK 25-15-05-860-001

- (1) Open these circuit breakers and install safety tags:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
L	13	C25405	SVCE OUTLET F/D AC

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	8	C25600	SVCE OUTLET F/D DC

SUBTASK 25-15-05-010-001

- (2) Remove these items as applicable.
 - (a) Do this task: Audio Control Panel (ACP) Removal, TASK 23-51-01-000-801.
 - (b) Do this task: Stowage Box Assembly Removal, TASK 35-11-18-000-801.
 - (c) Do this task: First Observer Seat - Removal, TASK 25-11-03-000-801.
 - (d) Do this task: Second Observer Seat - Removal, TASK 25-11-03-000-802.

E. Observers Console Removal.

SUBTASK 25-15-05-000-001

- (1) Do these steps to remove the observers console:
 - (a) Remove the screws [3].
 - (b) Remove the observers console.

EFFECTIVITY
ARO ALL

25-15-05

D633W101-ARO

Page 401
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (c) Remove the attachment brackets [1] and clipnuts [2] from the flight deck wall.

————— **END OF TASK** —————

TASK 25-15-05-400-801

3. Observers Console Installation

(Figure 401)

A. References

Reference	Title
23-51-01-400-801	Audio Control Panel (ACP) Installation (P/B 401)
25-11-03-400-801	First Observer Seat - Installation (P/B 401)
25-11-03-400-802	Second Observer Seat - Installation (P/B 401)
35-11-18-400-802	Stowage Box Assembly Installation (P/B 201)

B. Location Zones

Zone	Area
211	Flight Compartment, Left

C. Observers Console Installation.

SUBTASK 25-15-05-400-001

- (1) Do these steps to install the observers console.
- (a) Install the brackets [1] and clipnuts [2].
 - (b) Put the observers console in position.
 - (c) Install the screws [3].

D. Put the Airplane Back to Its Usual Condition.

SUBTASK 25-15-05-860-003

- (1) Remove the safety tags and close these circuit breakers:

Ground Service/Handling Power Panel, P320

Row	Col	Number	Name
L	13	C25405	SVCE OUTLET F/D AC

Right Power Management Panel, P210

Row	Col	Number	Name
J	8	C25600	SVCE OUTLET F/D DC

SUBTASK 25-15-05-410-001

- (2) Install these items as applicable:
- (a) Do this task: Audio Control Panel (ACP) Installation, TASK 23-51-01-400-801.
 - (b) Do this task: Stowage Box Assembly Installation, TASK 35-11-18-400-802.
 - (c) Do this task: First Observer Seat - Installation, TASK 25-11-03-400-801.
 - (d) Do this task: Second Observer Seat - Installation, TASK 25-11-03-400-802.

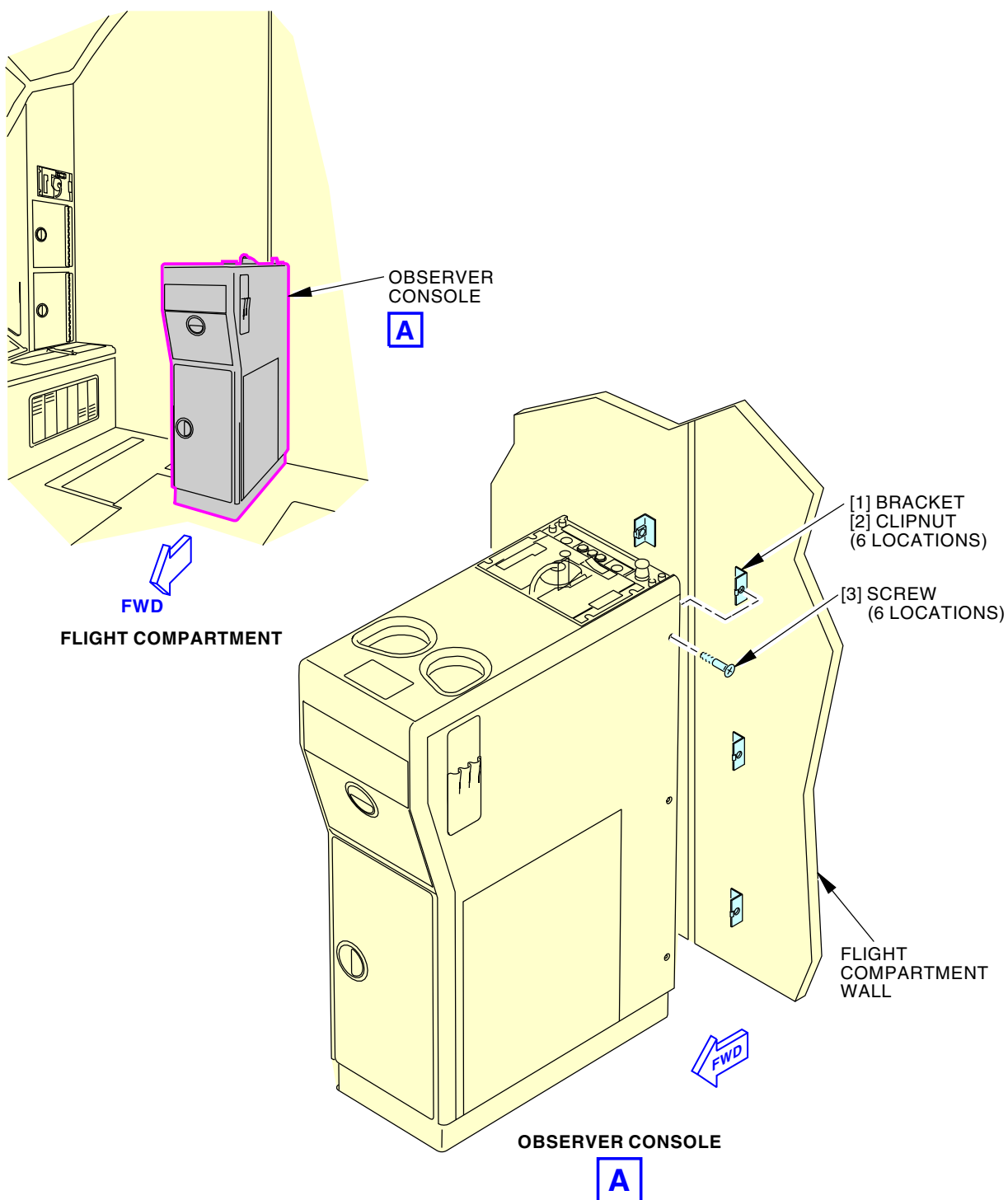
————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-15-05

D633W101-ARO

Page 402
Jan 05/2015



M17009 S0006408845_V2

**Observer's Console
Figure 401/25-15-05-990-801**

EFFECTIVITY
ARO ALL

25-15-05

D633W101-ARO

Page 403
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

OVERHEAD LINING - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Removal of the overhead lining
 - (2) Installation of the overhead lining
- B. There is an overhead lining on the left and right of the flight compartment. This procedure refers to the overhead lining as the lining.

TASK 25-15-06-000-801

2. Overhead Lining - Removal

(Figure 401)

A. General

- (1) This task removes one of the linings. Do the task again if it is necessary to remove the other lining.

B. Location Zones

<u>Zone</u>	<u>Area</u>
211	Flight Compartment, Left
212	Flight Compartment, Right

C. Prepare for the Removal

SUBTASK 25-15-06-860-001

- (1) Open these circuit breakers and install safety tags:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	2	C33403	DOMES LIGHTS

Overhead Circuit Breaker Panel, P11

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	1	C31001	WARNING SPEAKER-L
C	14	C31606	WARNING SPEAKER-R

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	22	C33402	DOMES LTS BACKUP
G	22	C33501	UTIL & MAP LTS

Standby Power Management Panel, P310

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	10	C27636	WARN SPKR/STICK SHAKER-L
F	3	C33612	STBY DOMES LTS

SUBTASK 25-15-06-010-001

- (2) Open the No. 2 window a small distance to get access to some of the screws [3].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-15-06

Page 401
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Overhead lining Removal

SUBTASK 25-15-06-020-001

- (1) Do these steps to remove the lining assembly [2], lining assembly [5]:
 - (a) Move the overhead pads and molding common to the lining assembly [2] or lining assembly [5] and adjacent support structure or parts.
NOTE: The overhead pads and molding are attached with hook-and-loop tape.
 - (b) Remove the screws [3] that attach the lining assembly [2] or lining assembly [5] to the supports [1] and No. 3 window lining.
 - (c) Pull the lining assembly [2] or lining assembly [5] from the ceiling.
 - (d) Disconnect the electrical connectors [4].
 - (e) Loosen the clamps [7].
 - (f) If it is necessary remove clamps [7].
 - (g) Disconnect the hose [6] from the lining assembly [5]
 - (h) Remove the overhead lining assembly [2] or lining assembly [5].

— END OF TASK —

TASK 25-15-06-400-801

3. Overhead Lining - Installation

(Figure 401)

A. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)

B. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

C. Overhead lining Installation

SUBTASK 25-15-06-420-001

- (1) Do these steps to install the lining assembly [2] or lining assembly [5]:
 - (a) Connect the electrical connectors [4].
 - (b) Attach clamps [7] if they were removed.
 - (c) Connect the hoses [6] to the overhead lining assembly [5].
 - (d) Tighten the clamps [7].
 - (e) Align the holes for the screws [3] in the lining assembly [2] or lining assembly [5] with the holes in the supports [1].
 - (f) Install the lining assembly [2] or lining assembly [5].
 - (g) Install the screws [3].

SUBTASK 25-15-06-420-002

- (2) Install the overhead pads and molding to the lining assembly [2] or lining assembly [5] and the adjacent support structure or parts.

EFFECTIVITY
ARO ALL

25-15-06

D633W101-ARO

Page 402
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Overhead Lining Installation Test

SUBTASK 25-15-06-860-002

- (1) Remove the safety tags and close these circuit breakers:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	2	C33403	DOMELIGHTS

Overhead Circuit Breaker Panel, P11

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	1	C31001	WARNING SPEAKER-L
C	14	C31606	WARNING SPEAKER-R

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	22	C33402	DOMELTS BACKUP
G	22	C33501	UTIL & MAP LTS

Standby Power Management Panel, P310

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	10	C27636	WARN SPKR/STICK SHAKER-L
F	3	C33612	STBY DOMELTS

SUBTASK 25-15-06-860-003

- (2) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-15-06-710-001

- (3) Do a check for the map lights and the dome lights:

- (a) Set the light switch to the on position.

- 1) Make sure the light comes on.

NOTE: The brightness of the light must agree with the dimmer.

- (b) Set the light switch to the usual position.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-15-06-410-001

- (1) Close the No. 2 window.

————— END OF TASK —————

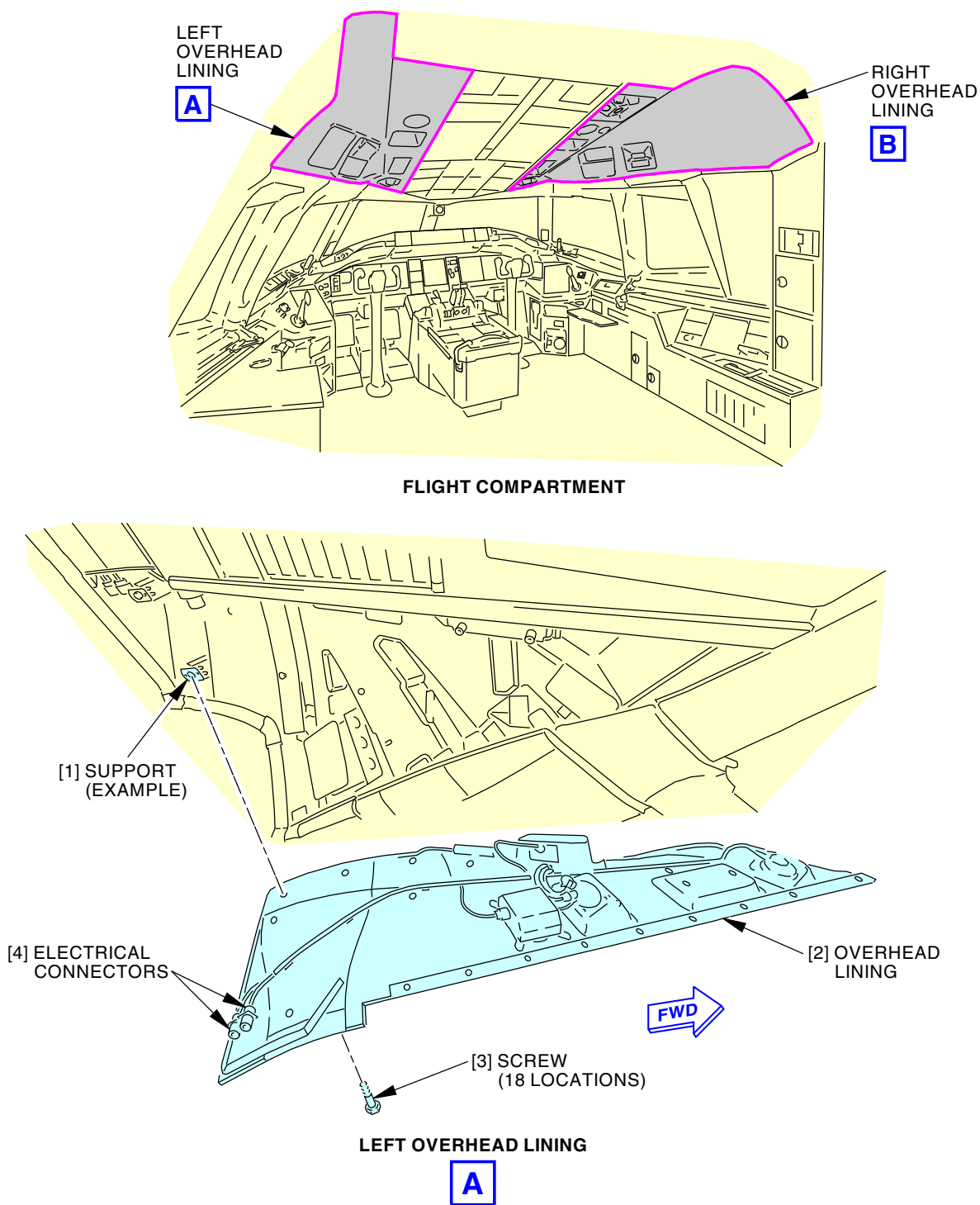
EFFECTIVITY
ARO ALL

D633W101-ARO

25-15-06

Page 403
Jan 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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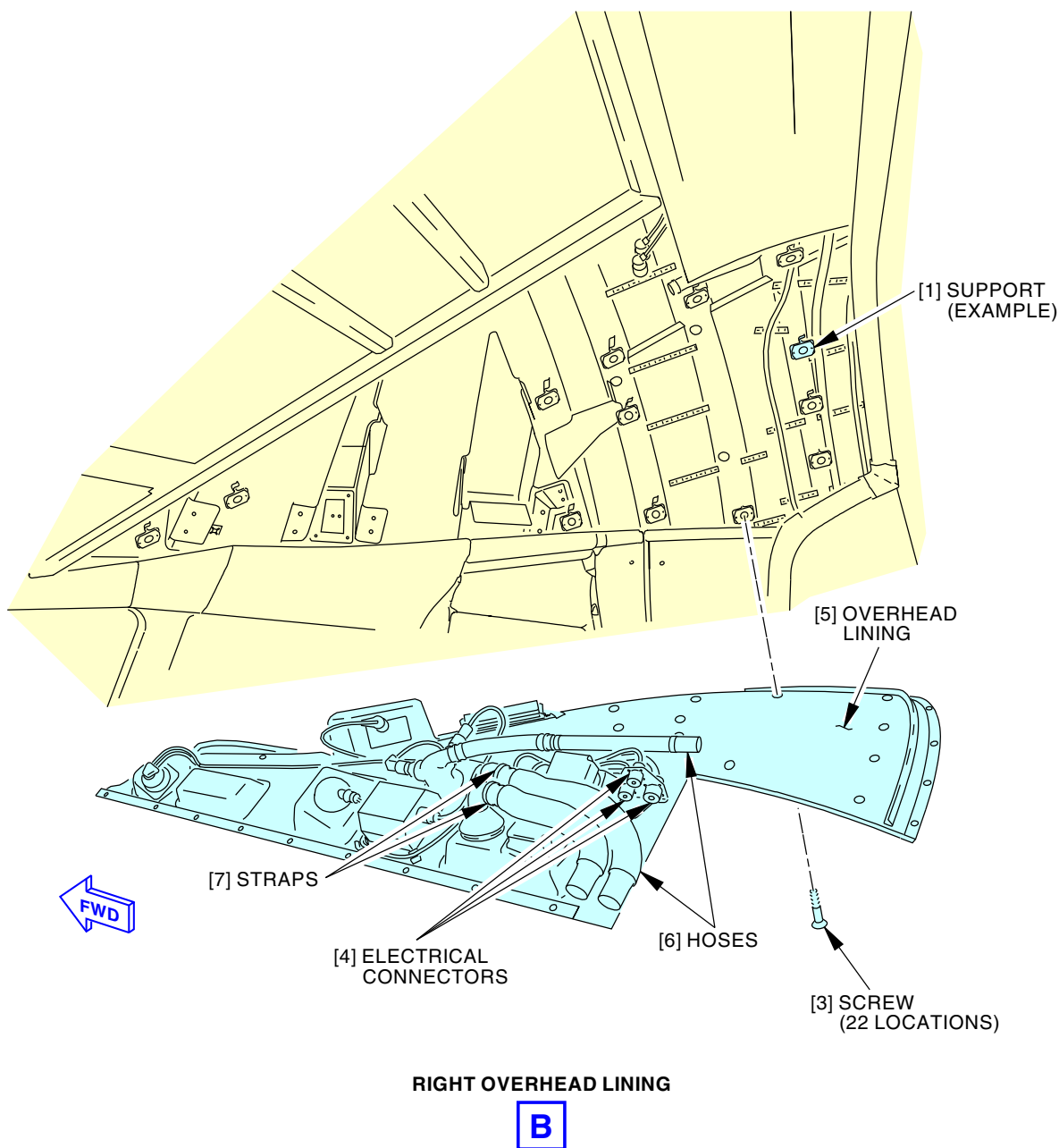
Overhead Lining Installation
Figure 401/25-15-06-990-801 (Sheet 1 of 2)

EFFECTIVITY
ARO ALL

25-15-06

D633W101-ARO

Page 404
May 05/2017



RIGHT OVERHEAD LINING

B

E43612 S0006408851_V3

Overhead Lining Installation
Figure 401/25-15-06-990-801 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

25-15-06

D633W101-ARO

Page 405
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

FLIGHT COMPARTMENT DRIPSHIELDS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) The removal of the dripshields.
 - (2) The installation of the dripshields.
- B. The dripshields are of different shapes and are installed over the structure in the flight deck. The dripshields help drain condensation, which collects on the structure, away from the occupied area of the flight deck. The dripshields are attached to the structure with screws.
- C. It is necessary to remove the ceiling panels, the pilots' overhead electrical panels, and applicable flight deck furnishings in order to remove the dripshields.

TASK 25-16-00-000-801

2. Remove the Dripshields

A. References

Reference	Title
24-22-00-860-806	Remove Electrical Power (P/B 201)
25-11-01-000-801	Captain and First Officer Seat Removal (P/B 401)
25-11-03-000-801	First Observer Seat - Removal (P/B 401)
25-15-06-000-801	Overhead Lining - Removal (P/B 401)
56-11-02-000-801	No. 2 Openable Window Removal (P/B 401)

B. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

C. Prepare for the Removal

SUBTASK 25-16-00-020-001

- (1) Do these tasks, when necessary:
 - (a) Remove Electrical Power, TASK 24-22-00-860-806.
 - (b) Captain and First Officer Seat Removal, TASK 25-11-01-000-801.
 - (c) First Observer Seat - Removal, TASK 25-11-03-000-801.
 - (d) Overhead Lining - Removal, TASK 25-15-06-000-801.

D. Remove the Dripshields

SUBTASK 25-16-00-020-002

- (1) Do this task: No. 2 Openable Window Removal, TASK 56-11-02-000-801.

SUBTASK 25-16-00-020-003

- (2) Remove the fasteners that remain.

SUBTASK 25-16-00-020-004

- (3) Remove the attachment screws that remain.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-16-00

Page 401
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-16-00-020-005



DO NOT GET SOLVENTS IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. PUT ON A RESPIRATOR, PROTECTIVE SPLASH GOGGLES, AND GLOVES WHEN YOU USE SOLVENTS. KEEP THE SOLVENTS AWAY FROM SPARKS, FLAME, AND HEAT. SOLVENTS ARE POISONOUS AND FLAMMABLE. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (4) Remove the sealant around the edges of the dripshields.

SUBTASK 25-16-00-020-006

- (5) Disconnect the wires, where necessary.

SUBTASK 25-16-00-020-007

- (6) Loosen the wire bundles, where necessary.

SUBTASK 25-16-00-020-008

- (7) Push the wire bundles through the grommets.

SUBTASK 25-16-00-020-009

- (8) Remove the grommets, if necessary.

SUBTASK 25-16-00-020-010

- (9) Remove the dripshields from the structure.

NOTE: Take notice of how each dripshield overlaps the others.

NOTE: Make sure that the Velcro stays on the structure.

————— **END OF TASK** —————

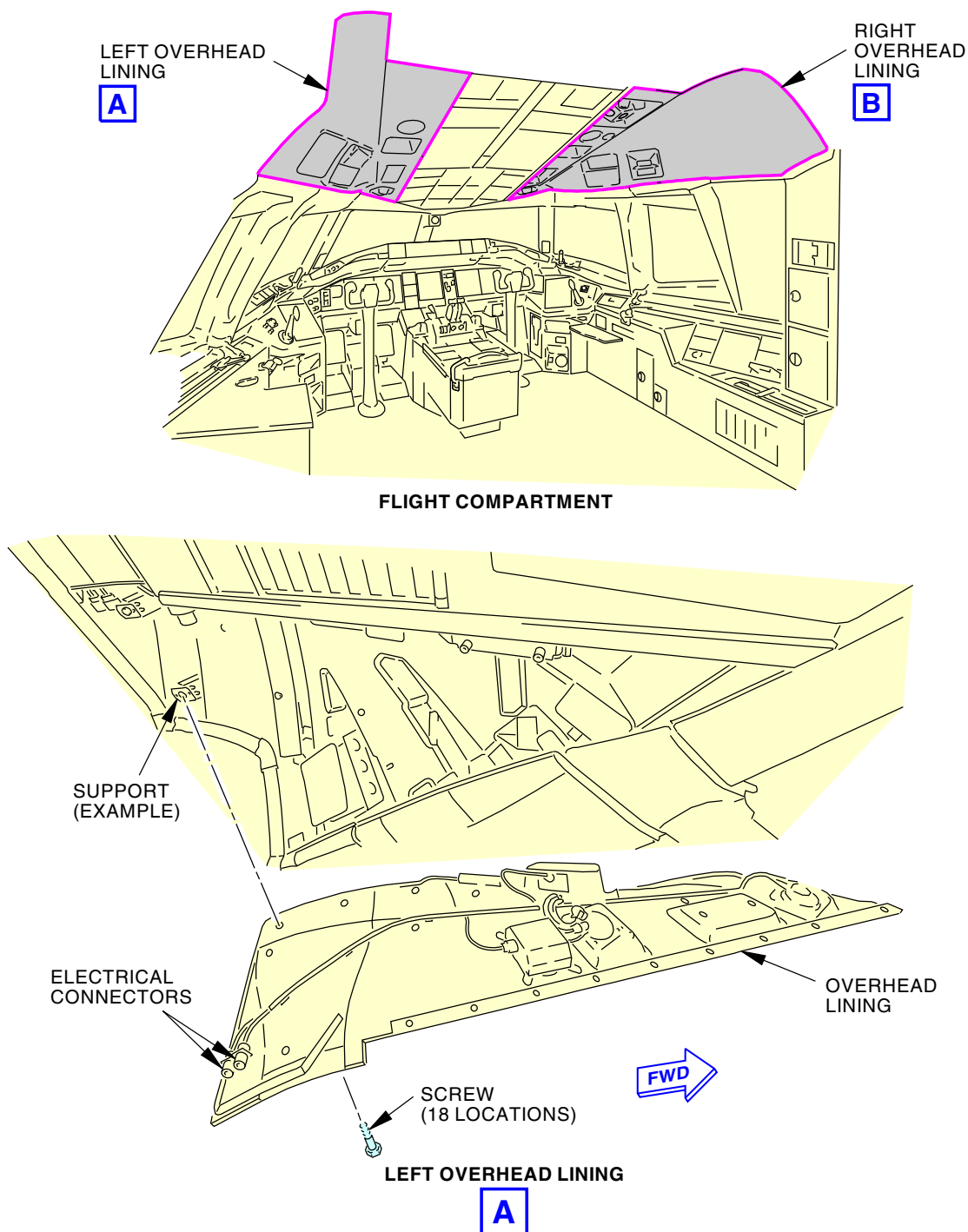
EFFECTIVITY
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25-16-00

D633W101-ARO

Page 402
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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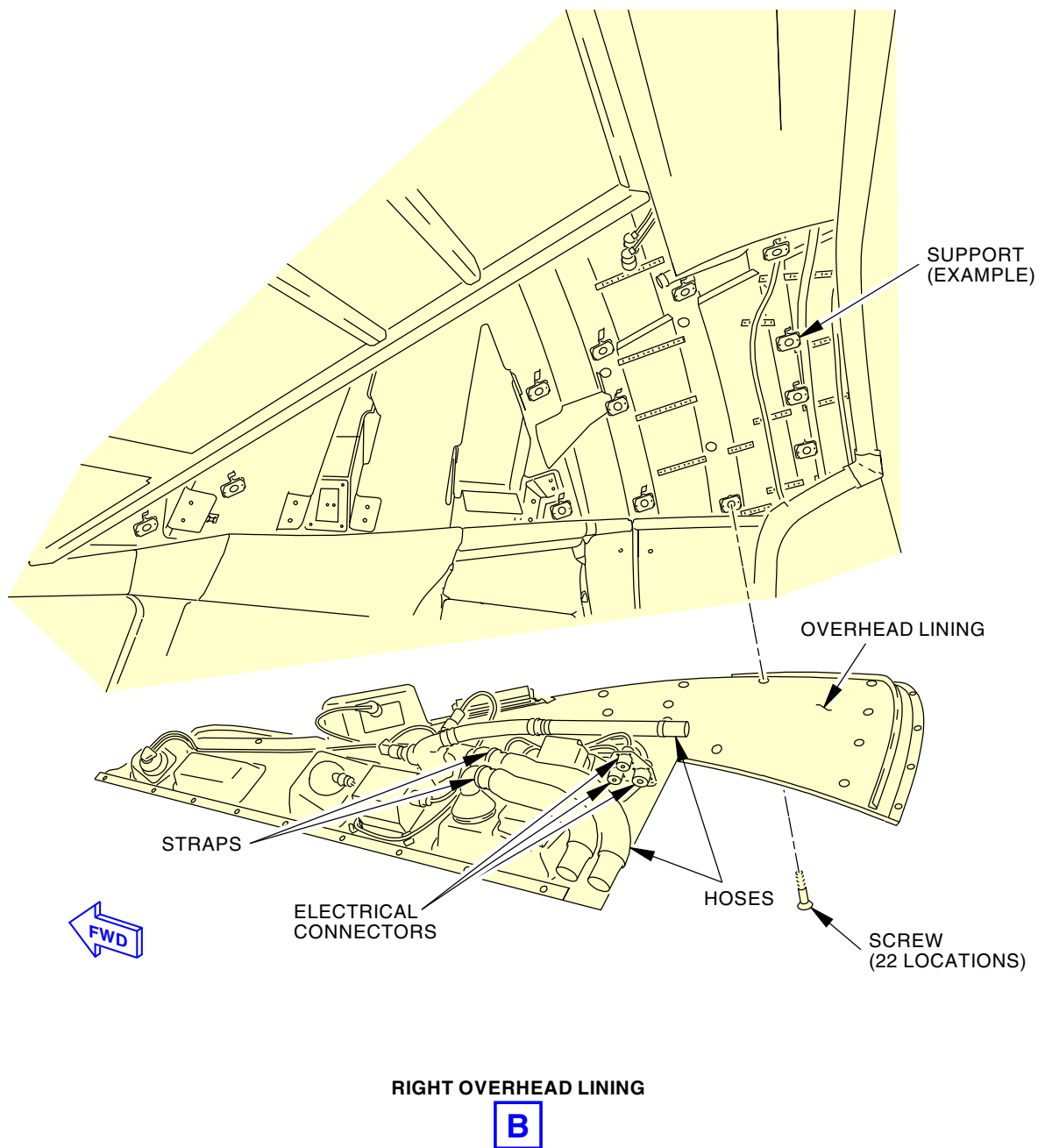
Flight Compartment Dripshields
Figure 401/25-16-00-990-801 (Sheet 1 of 2)

EFFECTIVITY
ARO ALL

25-16-00

D633W101-ARO

Page 403
May 05/2018



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**Flight Compartment Dripshields
Figure 401/25-16-00-990-801 (Sheet 2 of 2)**

EFFECTIVITY
ARO ALL

25-16-00

D633W101-ARO

Page 404
May 05/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-16-00-400-801

3. Install the Dripshields

(Figure 401)

A. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
25-11-01-400-801	Captain and First Officer Seat - Installation (P/B 401)
25-11-03-400-801	First Observer Seat - Installation (P/B 401)
25-15-06-400-801	Overhead Lining - Installation (P/B 401)
56-11-02-400-801	No. 2 Openable Window Installation (P/B 401)

B. Tools/Equipment

Reference	Description
STD-120	Bottle - Spray
STD-122	Brush
STD-7752	Roller - Paint (4-in)

C. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
G50262	Wiper - Cleaning	BMS15-5
G50381	Abrasive - Aluminum Oxide Paper, 180 Grit	

D. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

E. Install the Dripshields

SUBTASK 25-16-00-020-011

- (1) Use 180 grit abrasive paper, G50381 lightly to remove the unwanted materials from the mating surfaces of the dripshields.

SUBTASK 25-16-00-120-001

- (2) Use solvent, B00148 to clean the mating surfaces of the dripshield.

SUBTASK 25-16-00-120-002

- (3) Use wipers, G50262 to dry the mating surfaces.

SUBTASK 25-16-00-420-001

- (4) Attach the supplied Velcro to the rear side of the dripshields.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-16-00

Page 405
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-16-00-420-002



DO NOT GET SOLVENTS IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. PUT ON A RESPIRATOR, PROTECTIVE SPLASH GOGGLES, AND GLOVES WHEN YOU USE SOLVENTS. KEEP THE SOLVENTS AWAY FROM SPARKS, FLAME, AND HEAT. SOLVENTS ARE POISONOUS AND FLAMMABLE. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (5) Apply adhesive, A00027 to the mating surfaces of the dripshields with a brush, STD-122, spray bottle, STD-120, or roller, STD-7752.

SUBTASK 25-16-00-420-003

- (6) Hold the dripshields in the correct position on the structure.

NOTE: Make sure that the dripshields overlap each other correctly.

SUBTASK 25-16-00-420-004

- (7) Push the wire bundles through the grommets.

SUBTASK 25-16-00-420-005

- (8) Install the grommets, if necessary.

SUBTASK 25-16-00-420-006

- (9) Connect the wires, where necessary.

SUBTASK 25-16-00-420-007

- (10) Install the attachment screws.

SUBTASK 25-16-00-420-008

- (11) Install the fasteners.

SUBTASK 25-16-00-420-009

- (12) Do this task: No. 2 Openable Window Installation, TASK 56-11-02-400-801.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-16-00-420-010

- (1) Do these tasks, when necessary:
- (a) Overhead Lining - Installation, TASK 25-15-06-400-801.
 - (b) First Observer Seat - Installation, TASK 25-11-03-400-801.
 - (c) Captain and First Officer Seat - Installation, TASK 25-11-01-400-801.
 - (d) Supply Electrical Power, TASK 24-22-00-860-805.

————— END OF TASK —————

EFFECTIVITY
ARO ALL

25-16-00

D633W101-ARO

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Page 406
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

CLOSEOUT SEAL - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks:

- (1) The installation of the closeout seal.
- (2) The reinstallation of the closeout seal if it has come out of the retainer.

TASK 25-20-01-400-801

2. Installation of the Closeout Seal

A. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-20-01-020-001

- (1) If applicable, remove the installed foam seal.
 - (a) Remove the remaining adhesive.

SUBTASK 25-20-01-020-002

- (2) Where two seals connect, do the steps that follow:
 - (a) Do not use adhesive.
 - (b) Cut the end off one seal until the coupler on the other seal overlaps it.
 - (c) Where a coupler is not available at the end of a seal, install a coupler.

NOTE: The coupler dimensions must agree with the largest mating seal.

SUBTASK 25-20-01-420-001

- (3) Push the seal locking device into the installed retainer until the locking device engages.
 - (a) Push the seal tightly until a click is heard or you can feel it snapping into the retainer.
 - (b) Do not use adhesive.

SUBTASK 25-20-01-420-002

- (4) Apply adhesive, A00027 to fill spaces that stay after all other seals are installed.

SUBTASK 25-20-01-350-001

- (5) Trim the seal to fit.

SUBTASK 25-20-01-420-003

- (6) Bond one side of the seal and push the pointed end into the gap until only the decorative endcap can be seen.

SUBTASK 25-20-01-020-003

- (7) Where the seal turns a corner:
 - (a) Remove the non-decorative cross section if necessary to install the seal.

SUBTASK 25-20-01-020-004

- (8) Trim the seal to fit the installation space.

EFFECTIVITY
ARO ALL

25-20-01

D633W101-ARO

Page 201
Jan 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-20-01-020-005

(9) If there is interference between the seal and the wires or support structure:

(a) Trim the seal to remove the interference.

NOTE: Do not trim the seal so far that the relief can be seen in the cabin interior.

————— **END OF TASK** —————

TASK 25-20-01-400-802

3. Reinstallation of Closeout Seals

A. Consumable Materials

Reference	Description	Specification
A50055	Adhesive - Two-Part, RT Cure, Urethane	BAC5010 Type 89 (BMS5-105)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-20-01-210-001

(1) Make sure that the retainer is not damaged or missing.

SUBTASK 25-20-01-420-004

(2) Install the seal:

(a) Push the seal locking device into the installed retainer until the locking device engages.

1) Push the seal tightly until a click is heard or you can feel it snapping into the retainer.

2) Do not use adhesive.

(b) If necessary, add some urethane adhesive, A50055 to a few locations to the inside of the retainer only to assist with the seal staying in its position.

NOTE: During removal, this can cause damage to the seal or retainer. This is optional if the seal only needs to be removed at high time/cycle intervals.

NOTE: Do not add excess adhesive or fill the retainer as excess adhesive will prevent the seal locking device from engaging the locking device on the retainer.

NOTE: Do not apply adhesive to the outer surface of the seal and do not bond the seal to the adjacent part of the airplane.

NOTE: The seal should be locked securely to the retainer and the free edge of the seal must be free to move relative to the adjacent part of the airplane.

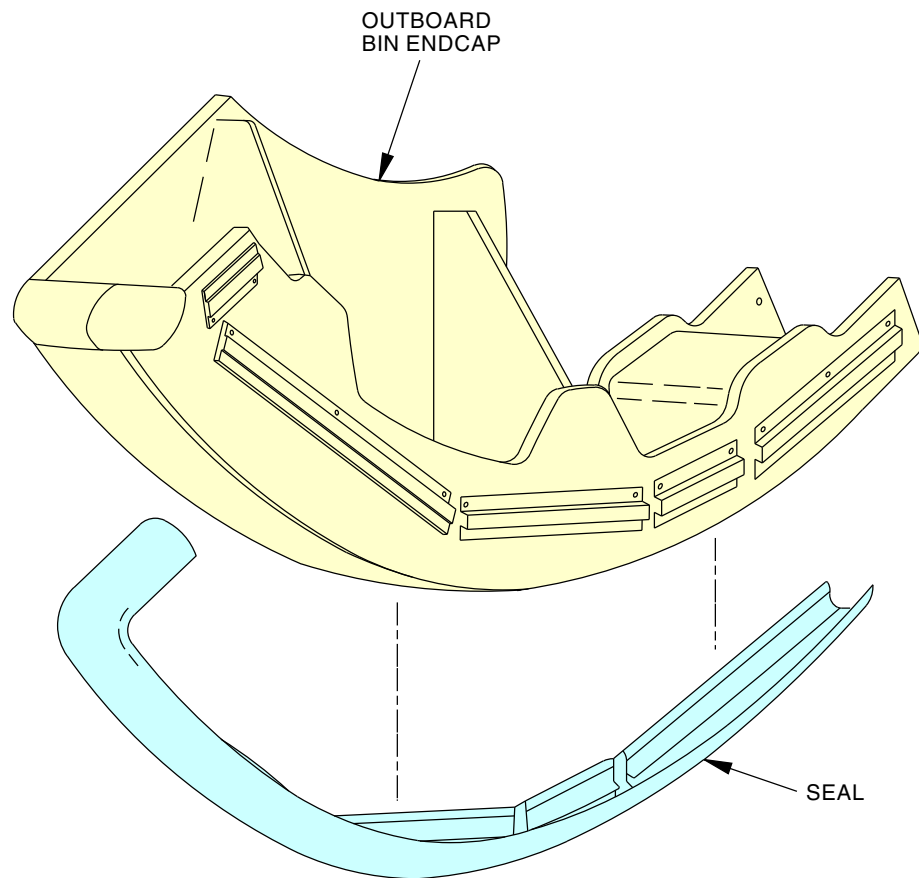
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EFFECTIVITY
ARO ALL

25-20-01

D633W101-ARO

Page 202
Sep 05/2016



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Closeout Seals
Figure 201/25-20-01-990-801

EFFECTIVITY
ARO ALL

D633W101-ARO

25-20-01

Page 203
Sep 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL
SIDEWALL PANEL - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the sidewall panel.
 - (2) An installation of the sidewall panel.
- B. This procedure removes and installs one sidewall panel. If it is necessary to remove more than one sidewall panel, do the removal task the applicable number of times.

TASK 25-21-01-000-801

2. Sidewall Panel - Removal

(Figure 401)

A. General

- (1) This procedure gives the steps to remove a sidewall panel from the passenger cabin.

B. References

Reference	Title
21-23-05-000-802	Return Air Grill Removal (P/B 201)
25-25-01 P/B 401	PASSENGER SEATS - REMOVAL/INSTALLATION
56-21-01-000-801	Passenger Compartment Window Removal (P/B 401)

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Prepare for the Removal

SUBTASK 25-21-01-010-001

- (1) Remove the passenger seat, or seat unit adjacent to your target sidewall panel.

NOTE: It is not always necessary to remove the seat from the airplane fully. It can be sufficient to disconnect the seat from the seat tracks and move it away from the wall. It may be possible to leave the electrical wires connected to the seat, but make sure you do not pull on, or cause damage to the wires.

- (a) Do the applicable task for the specific type of seat or seat unit (PASSENGER SEATS - REMOVAL/INSTALLATION, PAGEBLOCK 25-25-01/401).

SUBTASK 25-21-01-020-006

- (2) For windows with manually-operated shades, remove the window reveal assembly, refer to this task: Passenger Compartment Window Removal, TASK 56-21-01-000-801.

SUBTASK 25-21-01-020-001

- (3) To remove the return air grill from the sidewall, do this task: Return Air Grill Removal, TASK 21-23-05-000-802.

E. Sidewall Panel Removal

SUBTASK 25-21-01-020-002

- (1) Remove the decorative splines [1] from the area between the two sidewall panels [5].
 - (a) Pull the decorative splines [1] down and out of the sidewall panel [5] edge track.

SUBTASK 25-21-01-020-003

- (2) Remove the screws [4] that attach each edge of the sidewall panel [5] to the structure.

EFFECTIVITY
ARO ALL

25-21-01

D633W101-ARO

Page 401
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-21-01-020-004

- (3) Pull the lower edge of the sidewall panel [5] down and inboard to disengage its upper edge from behind the sidewall light [6].

SUBTASK 25-21-01-020-005

- (4) Remove the sidewall panel [5].

————— END OF TASK —————

TASK 25-21-01-400-801

3. Sidewall Panel - Installation

(Figure 401)

A. General

- (1) This procedure gives the steps to install a sidewall panel in the passenger cabin.

B. References

Reference	Title
20-11-00-910-801	Standard Torque Values (P/B 201)
21-23-05-400-804	Return Air Grill Installation (P/B 201)
25-25-01 P/B 401	PASSENGER SEATS - REMOVAL/INSTALLATION
56-21-01-400-801	Passenger Compartment Window Installation (P/B 401)

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Sidewall Panel Installation

SUBTASK 25-21-01-210-001

- (1) Make sure the inboard surface of the structural window is clean.

SUBTASK 25-21-01-420-001

- (2) Lift the upper edge of the sidewall panel [5] up behind the sidewall light [6].
 - (a) Move the sidewall panel [5] forward or aft until the latch hole at the bottom of the window reveal aligns with the small vent hole in the structural window pane.

SUBTASK 25-21-01-210-002

- (3) Do a visual check to make sure the foam spacer on the top of the sidewall panel [5] is flat against the sidewall light [6].

SUBTASK 25-21-01-210-004

- (4) Do a visual check to make sure the outboard seal for the window reveal touches the structural window pane and is not bent or damaged.

SUBTASK 25-21-01-210-005

- (5) Make sure the bottom edge of the sidewall panel [5] is aligned with the bottom edge of the adjacent panel.

SUBTASK 25-21-01-420-002

- (6) Install the screws [4] that attach each edge of the sidewall panel [5] to the structure.
 - (a) Tighten the screws (TASK 20-11-00-910-801).

NOTE: Tighten the 4 middle screws first.

SUBTASK 25-21-01-420-003

- (7) Install the decorative splines [1] for the area on the two sides of the sidewall panel [5].

EFFECTIVITY
ARO ALL

25-21-01

D633W101-ARO

Page 402
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Put the top end of the decorative splines [1] through the bottom of the edge track for the sidewall panel [5].
- (b) Push the decorative spline through the edge track from the bottom to the top of the sidewall panel [5].

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-21-01-420-006

- (1) For windows with manually-operated shades, install the window reveal assembly, refer to: Passenger Compartment Window Installation, TASK 56-21-01-400-801.

SUBTASK 25-21-01-410-001

- (2) Install the passenger seats or seat units adjacent to your target sidewall panel if they were removed, moved or disconnected.
 - (a) Do the applicable task for the specific type of seat or seat unit (PASSENGER SEATS - REMOVAL/INSTALLATION, PAGEBLOCK 25-25-01/401).

SUBTASK 25-21-01-420-004

- (3) To install the return air grills, do this task: Return Air Grill Installation, TASK 21-23-05-400-804.

————— **END OF TASK** —————

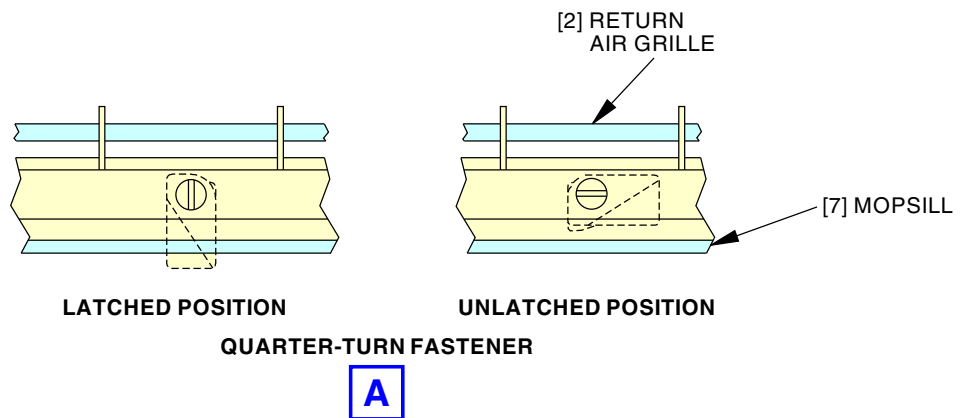
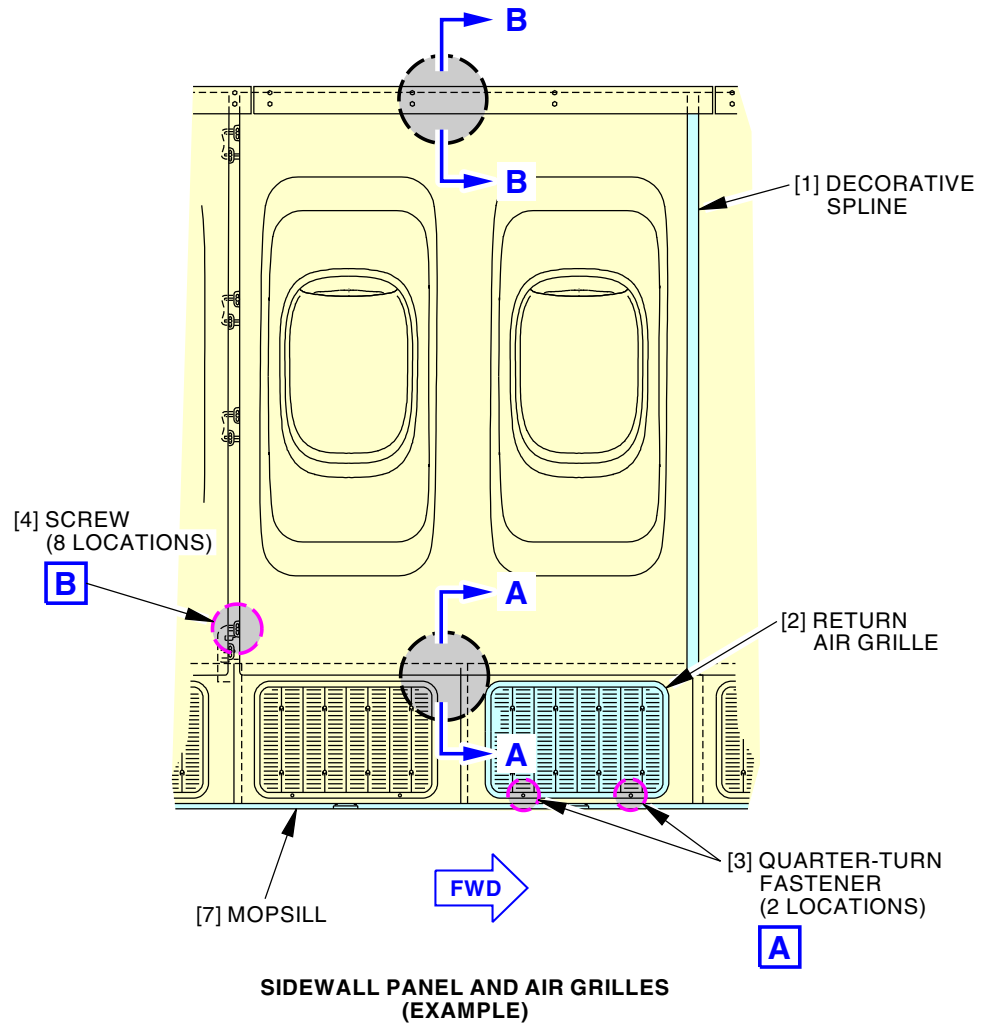
EFFECTIVITY
ARO ALL

25-21-01

D633W101-ARO

Page 403
Jul 25/2018

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Sidewall Panel Installation
Figure 401/25-21-01-990-801 (Sheet 1 of 2)

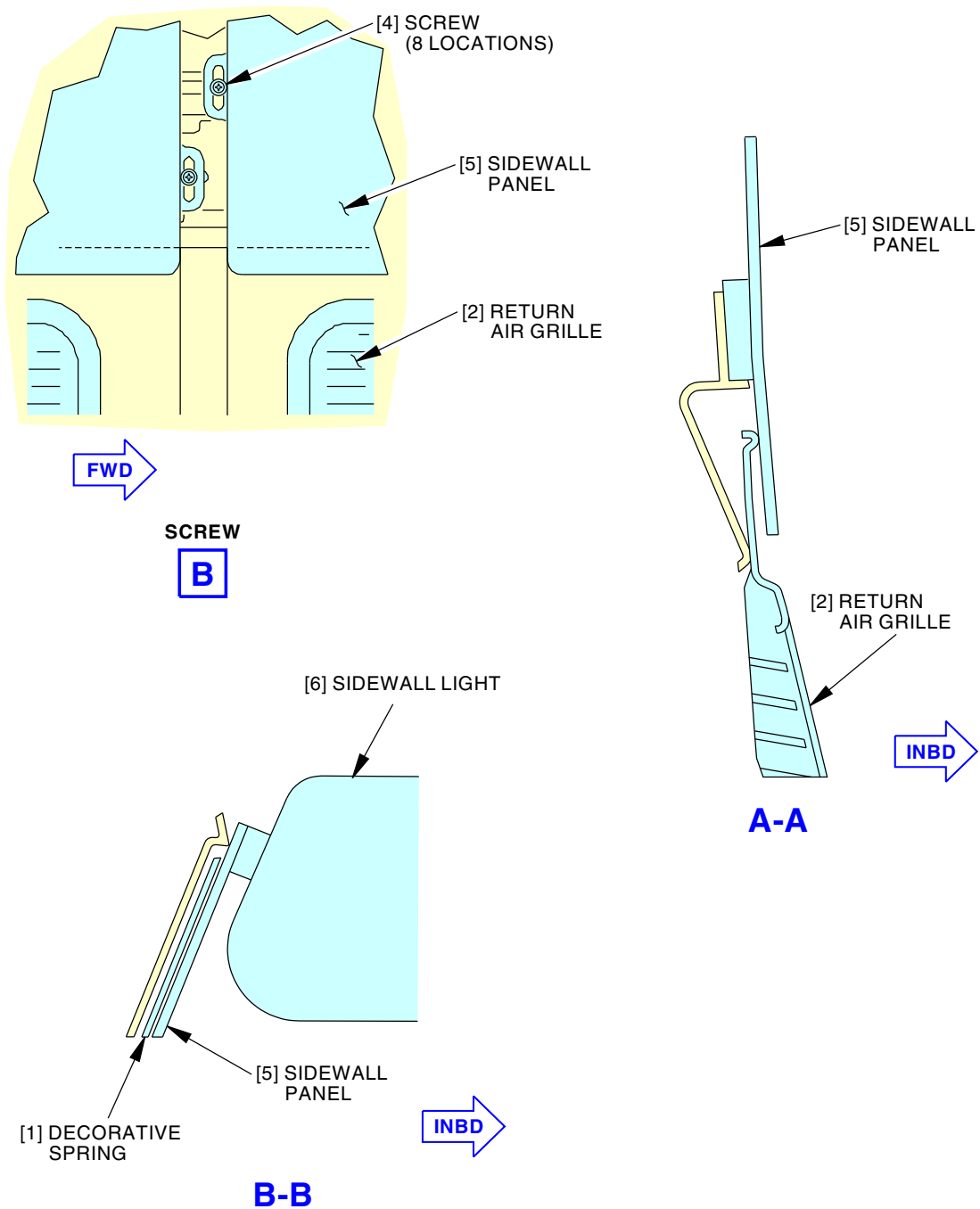
EFFECTIVITY
ARO ALL

25-21-01

D633W101-ARO

Page 404
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Sidewall Panel Installation
Figure 401/25-21-01-990-801 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-21-01

Page 405
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
DOORWAY LINING - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the doorway lining.
 - (2) An installation of the doorway lining.

TASK 25-21-02-000-801

2. Doorway Lining Removal

(Figure 401, Figure 402)

A. References

Reference	Title
25-25-01-000-801	Passenger Seat - Removal (P/B 401)
25-28-01-000-802	Outboard Stowage Bin Module Removal (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-21-02-010-001

- (1) Do the applicable steps that follow if it is necessary to get better access to the vertical linings [23], [24]:
 - (a) Remove the passenger seats if it is necessary. Do this task: Passenger Seat - Removal, TASK 25-25-01-000-801.
 - (b) Do this task: Outboard Stowage Bin Module Removal, TASK 25-28-01-000-802.

SUBTASK 25-21-02-860-001

- (2) Open these circuit breakers and install safety tags:

Ground Service/Handling Power Panel, P320

Row	Col	Number	Name
G	5	C25400	SVCE OUTLET DR 1L
G	6	C25403	SERVICE OUTLET DOOR 4
H	6	C25401	SVCE OUTLET DR 2L
H	12	C25402	SVCE OUTLET DR 3L

Overhead Circuit Breaker Panel, P11

Row	Col	Number	Name
H	16	C33621	EMERGENCY LIGHTS DOOR 3L
H	17	C33620	EMERGENCY LIGHTS DOOR 3R
H	18	C33619	EMERGENCY LIGHTS DOOR 4L & 4R

D. Doorway Lining Removal

SUBTASK 25-21-02-020-001

- (1) Do these steps to loosen the forward and aft vertical linings [23], [24]:
 - (a) Remove all of the access panels on the inner sides of the doorway as follows:
NOTE: There are split doorway linings where the galley, lavatory, closet etc. are installed within 10 inches of a doorway.

EFFECTIVITY
ARO ALL

25-21-02

D633W101-ARO

Page 401
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 1) Loosen the screws [8] but do not remove the screws [8] from the washers [9] on the back side of the access panels.
- 2) For the access panels [13] with the warning strap [14], do these steps:
 - a) Remove the retainer [15] for the warning strap [14].
 - b) Remove the access panel [13] off the end of the warning strap [14].
- 3) Remove each access panel, screws [8], and washers [9] as one unit.
- (b) Remove the nuts [4] and washers [5] from the full length of the vertical linings [23], [24] to disconnect the studs [7] from the doorway support.
- (c) Remove the nuts [11] and washers [12] to disconnect the assist handles [1] from the doorway support.
- (d) Pull the assist handles [1] through the inboard side of the vertical linings [23], [24].
- (e) Disconnect the electrical connectors [16] for the exit identifier signs [2].
- (f) Remove the exit identifier sign [2].
 - 1) Use an allen wrench to remove the lens for the exit identifier sign [2].
 - 2) Remove the screws to disconnect the exit identifier sign [2] from the doorway support.
- (g) Remove the screws [20] from the bottom of the vertical linings [23], [24].

SUBTASK 25-21-02-020-002

- (2) Do these steps to remove the upper lining [43]:
 - (a) Remove the screws [42] that attach the access panel [41] behind the upper lining [43].
 - (b) Remove the insulation blankets [45] to get access to the nuts [4] and washers [5] on the back of the upper lining [43].
 - (c) Disconnect the electrical connectors [46] for the exit sign [44].
 - (d) Remove the nuts [4] and washers [5] from the studs [7] on the back of the upper lining [43].
 - (e) Pull the bottom edge of the upper lining [43] inboard to clear the studs [7] from the holes.
 - (f) Pull the upper lining [43] down and out of the extrusion.

SUBTASK 25-21-02-020-003

- (3) Do these steps to remove the vertical linings [23], [24] forward and aft of the doorway:

NOTE: There are split doorway linings where the galley, lavatory, closet etc. are installed within 10 inches of a doorway.

- (a) Pull down to remove the decorative splines between the vertical lining [23] and the sidewall panel [21].
- (b) Remove the screws [22] that attach the side of the vertical lining [23] to the support brackets.

NOTE: The vertical lining installed behind a monument does not have screws along the side. The screws only attach the vertical lining when it is adjacent to a sidewall panel.

- (c) Disconnect the electrical connector [19] for the outlet [3] from the rear of the vertical lining [24].
- (d) Pull the vertical linings [23], [24] inboard and down while you remove the studs [7] from the holes in the doorway support.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-21-02

D633W101-ARO

Page 402
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-21-02-400-801

3. Doorway Lining Installation

(Figure 401, Figure 402)

A. References

Reference	Title
25-25-01-400-801	Passenger Seat - Installation (P/B 401)
25-28-01-400-802	Outboard Stowage Bin Module Installation (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Doorway Lining Installation

SUBTASK 25-21-02-420-001

- (1) Do these steps to install the vertical linings [23], [24] forward and aft of the doorway:
 - (a) Put the vertical linings [23], [24] up into the extrusions.
NOTE: There are split doorway linings where the galley, lavatory, closet etc. are installed within 10 inches of a doorway.
 - (b) If there is a monument adjacent to the doorway, put the vertical lining [24] in the support bracket [25] behind the monument.
 - (c) Put the studs [7] through the holes in the doorway support.
 - (d) Connect the electrical connector [19] to the outlet [3] on the rear of the vertical lining [24].
 - (e) Do these steps to the vertical lining [23] that is adjacent to a sidewall panel [21]:
 - 1) Install the screws [22] that attach the side of the vertical lining [23] to the support brackets.
 - 2) Push up to install the decorative splines between the vertical lining [23] and the sidewall panel [21].
 - (f) Install the screws [20] that attach the bottom of the vertical linings [23], [24] to the structure.
 - (g) Put the assist handles [1] through the inboard side of the vertical linings [23], [24].
 - (h) Do these steps to install the exit identifier signs [2]:
 - 1) Pull the electrical connectors [16] for the exit identifier signs [2] through the hole in the vertical lining [23], [24] and doorway support.
 - 2) Install the screws to attach the exit identifier sign [2] to the doorway support.
 - 3) Install the lens.
 - (i) Do these steps on the inner sides of the doorway:
 - 1) Install the nuts [11] and washers [12] that attach the assist handles [1] to the doorway support.
 - 2) Install the nuts [4] and washers [5] on the studs [7] to attach the vertical linings [23], [24] to the doorway support.
 - 3) Install the screws [8] and washers [9] that attach the access panels to the brackets for the doorway support.
 - 4) For the access panels [13] with the warning strap [14], do these steps:
 - a) Put the warning strap [14] through the cutout in the access panel [13].

EFFECTIVITY
ARO ALL

25-21-02

D633W101-ARO

Page 403
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- b) Install the retainer [15] for the warning strap [14] on the access panel [13] with the split end up.

SUBTASK 25-21-02-420-002

- (2) Do these steps to install the upper lining [43]:
- (a) If there is an access door, make sure it does not catch on the potable water valve.
 - (b) Put the upper lining [43] up behind the extrusion.
 - (c) Put the studs [7] through the holes in the doorway support.
 - (d) Connect the electrical connector [46] for the exit sign [44].
 - (e) Install the washers [5] and nuts [4] on the studs [7] on the back of the upper lining [43].
 - (f) Install the insulation blankets [45] over the nuts [4] and washers [5].
 - (g) Install the screws [42] that attach the access panel [41] to the brackets for the doorway support.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-21-02-860-002

- (1) Remove the safety tags and close these circuit breakers:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
G	5	C25400	SVCE OUTLET DR 1L
G	6	C25403	SERVICE OUTLET DOOR 4
H	6	C25401	SVCE OUTLET DR 2L
H	12	C25402	SVCE OUTLET DR 3L

Overhead Circuit Breaker Panel, P11

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	16	C33621	EMERGENCY LIGHTS DOOR 3L
H	17	C33620	EMERGENCY LIGHTS DOOR 3R
H	18	C33619	EMERGENCY LIGHTS DOOR 4L & 4R

SUBTASK 25-21-02-710-001

- (2) Push the test switch for the emergency lights on the applicable attendant switch panel.
- (a) Make sure the exit sign comes on.

SUBTASK 25-21-02-410-001

- (3) Do the applicable steps that follow if it is necessary:
- (a) Install the passenger seats if they were removed. Do this task: Passenger Seat - Installation, TASK 25-25-01-400-801.
 - (b) Do this task: Outboard Stowage Bin Module Installation, TASK 25-28-01-400-802.

————— **END OF TASK** —————

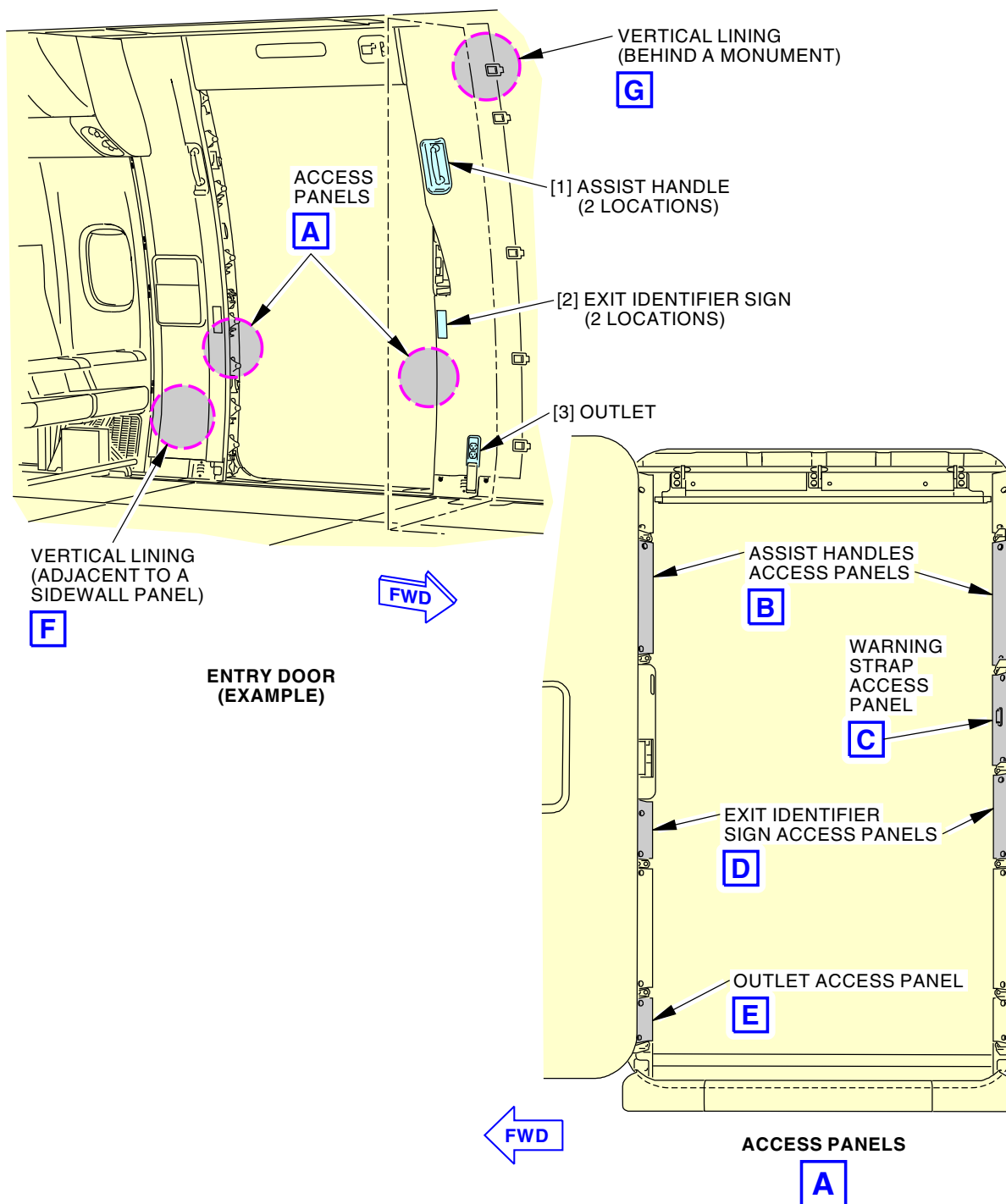
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25-21-02

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Page 404
Jan 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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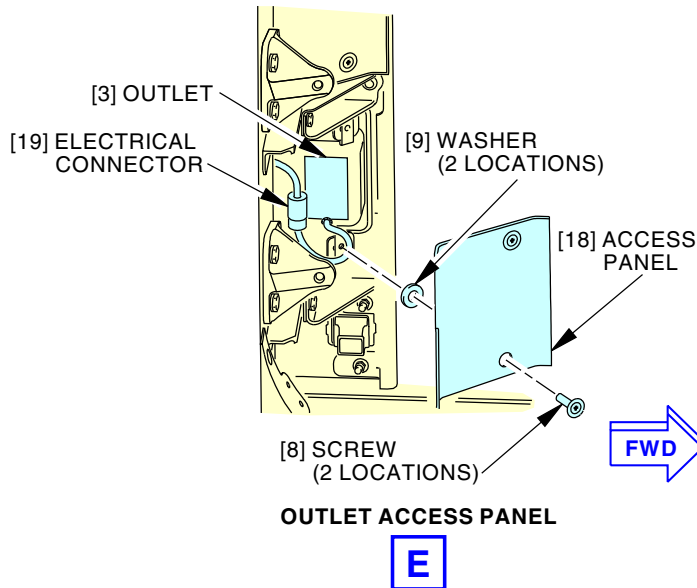
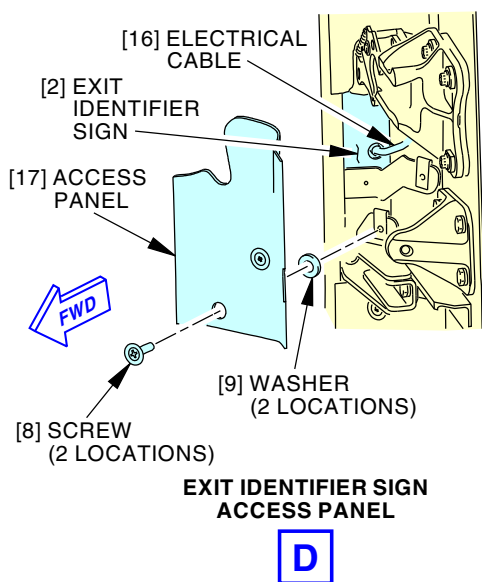
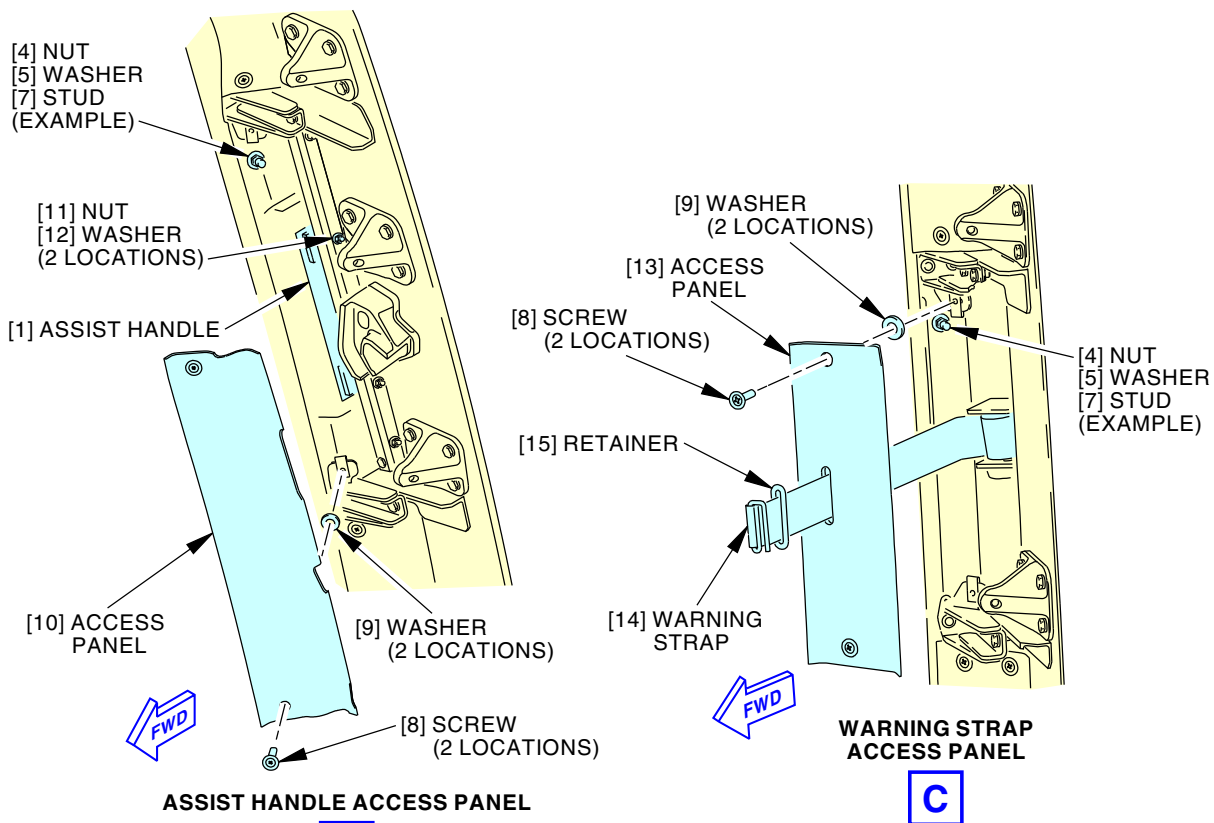
**Vertical Doorway Linings Installation
Figure 401/25-21-02-990-801 (Sheet 1 of 3)**

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Page 405
May 05/2017



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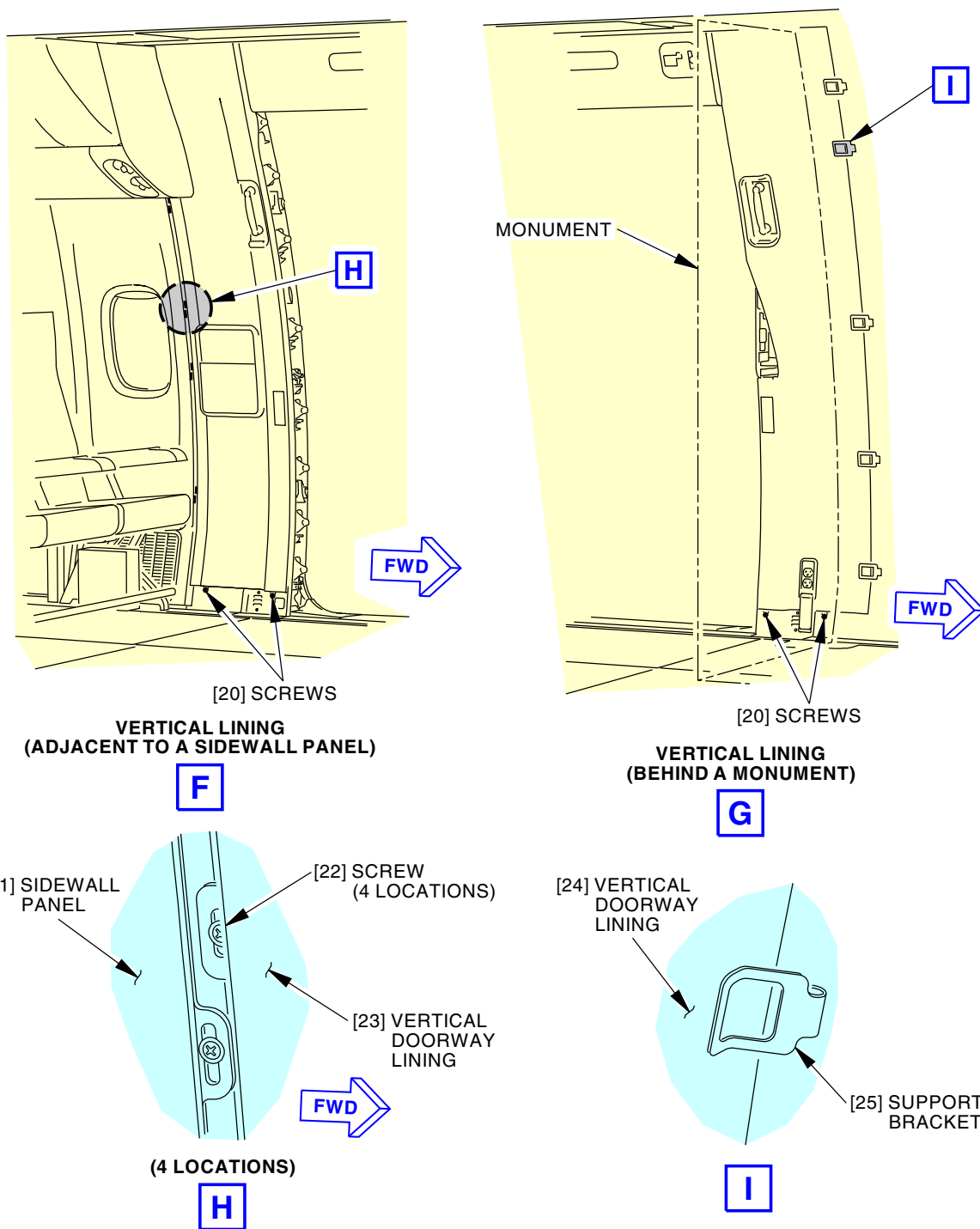
Vertical Doorway Linings Installation
Figure 401/25-21-02-990-801 (Sheet 2 of 3)

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D633W101-ARO

Page 406
May 05/2017



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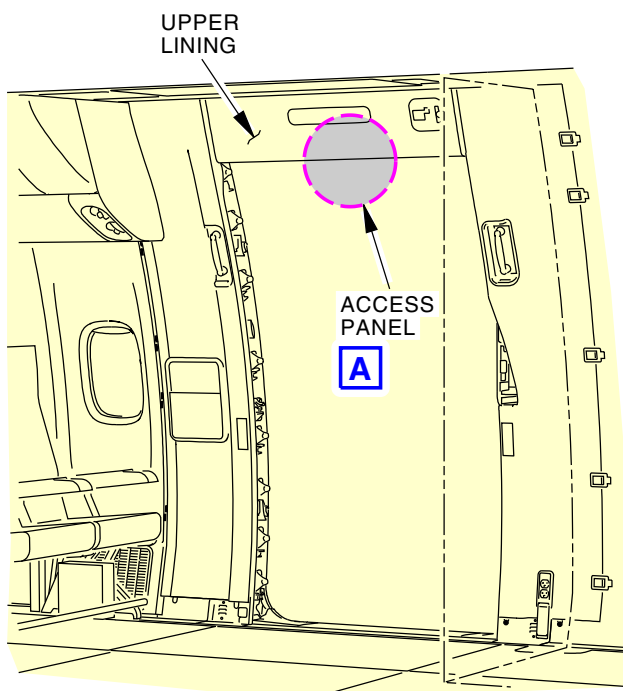
**Vertical Doorway Linings Installation
Figure 401/25-21-02-990-801 (Sheet 3 of 3)**

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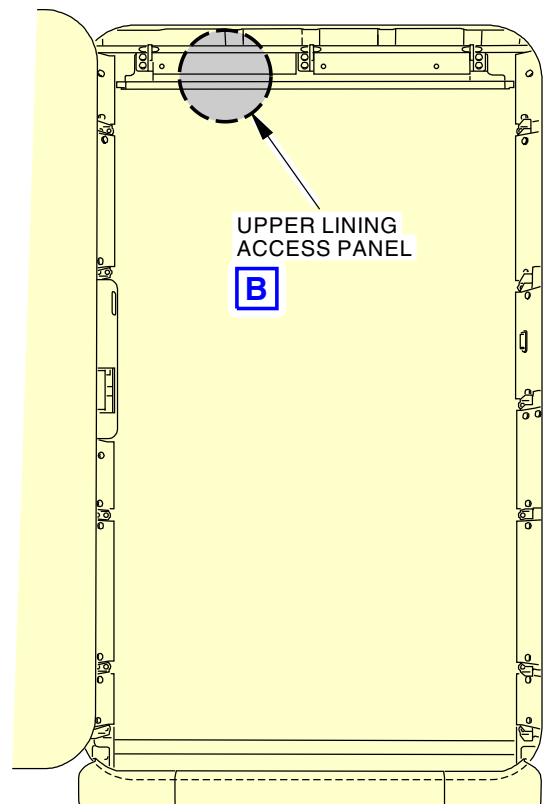
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Page 407
May 05/2017



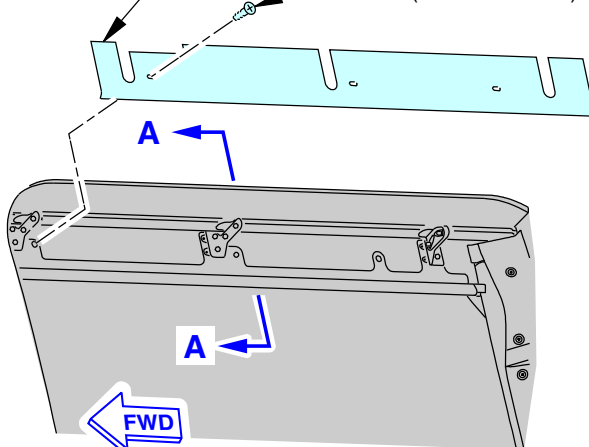
ENTRY DOOR
(EXAMPLE)



ACCESS PANELS

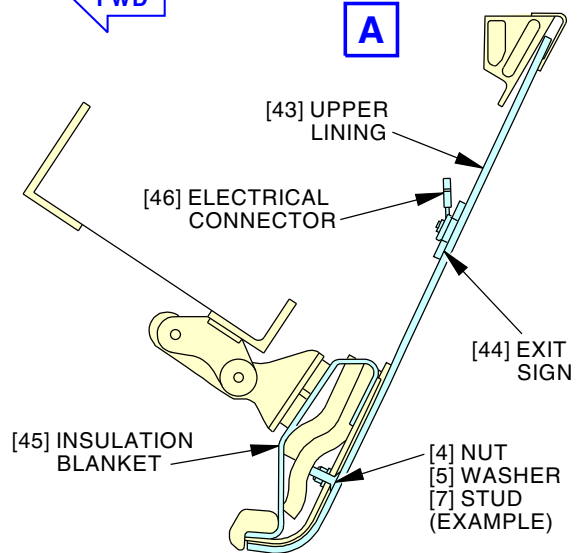
[41] ACCESS
PANEL

[42] SCREW
(3 LOCATIONS)



UPPER LINER ACCESS PANEL

B



A-A

D10086 S0006408925_V3

Upper Doorway Lining Installation
Figure 402/25-21-02-990-802

EFFECTIVITY
ARO ALL

25-21-02

D633W101-ARO

Page 408
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

MAIN CEILING PANEL - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the main ceiling panels.
 - (2) An installation of the main ceiling panels.
- B. The main ceiling is above the aisles between the passenger compartment seats. The main ceiling consists of inboard and outboard panels with two air grills between the panels.

TASK 25-21-06-000-801

2. Main Ceiling Panel - Removal

(Figure 401)

A. **Location Zones**

Zone	Area
200	Upper Half of Fuselage

B. **Main Ceiling Panel Removal**

SUBTASK 25-21-06-010-002

- (1) Do these steps to remove the aft air grill [8] first, then the forward air grill [8]:

NOTE: You must remove two air grills [8] to remove one ceiling panel.

- (a) Pull down the end of the latch [13] that you can see through the air grill [8].
- (b) Slide the air grill [8] aft approximately two inches to clear the latch [13].
- (c) Lower the air grill [8].

SUBTASK 25-21-06-020-005

- (2) Remove the emergency exit sign and the attached bar, if it is necessary.

SUBTASK 25-21-06-010-001

- (3) Do these steps to open the inboard panel [7] or outboard panel [1] of the main ceiling:

- (a) Turn the latches [9] on the panel [7], [1] while you hold it up.
- (b) Slowly lower the panel [7], [1] and let it hang by the lanyards [3].

SUBTASK 25-21-06-020-001

- (4) Disconnect the lanyards [3] from the latches [9] on the panel [7], [1].

SUBTASK 25-21-06-020-002

- (5) If there is electrical equipment mounted on the panel [7], do these steps to disconnect the electrical connector(s) [4]:

- (a) With your thumb and index finger, squeeze the serrated areas on the connector [4] to release the tabs.
- (b) Disconnect the electrical connector [4].

SUBTASK 25-21-06-020-003

- (6) Lift the panel [7], [1] out of the hinges [6].

SUBTASK 25-21-06-020-004

- (7) Remove the panel [7], [1].

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-21-06

Page 401
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-21-06-400-801

3. Main Ceiling Panel - Installation

(Figure 401)

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Install the Ceiling Panel

SUBTASK 25-21-06-420-001

- (1) Align the ceiling panel [1], [7] with the smaller of the two hinge halves [6], engage the hinge pins.

SUBTASK 25-21-06-420-002

- (2) Engage the hinge halves [6] of the ceiling panel [1], [7] to the mating halves on the center bin trough [15].

SUBTASK 25-21-06-420-003

- (3) Insert the most inboard hinge pin to the inboard slot, of the hinge half, on the trough [15].

SUBTASK 25-21-06-410-005

- (4) Move the ceiling panel [1], [7] up to engage the outboard hinge pin to its slot on the mating hinge half.

SUBTASK 25-21-06-410-006

- (5) When the hinge halves [6] are correctly engaged, the panel [1], [7] will be at the full down position.

NOTE: Be careful to not damage the hinge.

SUBTASK 25-21-06-410-007



DO NOT PUSH THE LATCH TOO HARD TO ENGAGE THE LATCH STRIKE.
DAMAGE TO THE PLENUM OR CEILING LATCHES CAN OCCUR.

- (6) Push with light force inboard and move the panel to its correct position.

SUBTASK 25-21-06-410-008

- (7) Roll excess gap seal [16] on the inboard edge, upward along the trough.

SUBTASK 25-21-06-410-009

- (8) Attach the end of the lanyard [3] on the ceiling panel [1], [7] latch half, to the hole in the plenum [11] latch half.

SUBTASK 25-21-06-410-010

- (9) Make sure these hinge pins align correctly to prevent damage to the hinge half.

NOTE: The latch will not lock if the hinge pins are not aligned.

SUBTASK 25-21-06-420-006

- (10) Install the outboard edge of the ceiling panel [1], [7] to the strongback.

SUBTASK 25-21-06-420-007

- (11) Let the ceiling panel hang by the lanyards [3] or move the panel to the down position.

SUBTASK 25-21-06-410-011

- (12) Connect the electrical connectors [4].

EFFECTIVITY
ARO ALL

25-21-06

D633W101-ARO

Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-21-06-420-008

- (13) Lift the panel [1], [7] into position against the nylon pad on the air grill support.

SUBTASK 25-21-06-420-009

- (14) Secure the panel by engaging the latch [9], [13] on the plenum [11] to the ceiling panel latch strike.

NOTE: Do not force latch to engage latch strike. Make sure the latch smoothly engages latch strike with light contact or else damage may occur to ECS plenum.

SUBTASK 25-21-06-410-012

- (15) Make sure the lanyards [3] and wire connectors [4] do not touch the latch [9], [13].

SUBTASK 25-21-06-410-013

- (16) Put the gap cover up on the adjacent panel [7], [1].

C. Latch and Hinge Adjustment

SUBTASK 25-21-06-700-001

- (1) Adjust the latch [9], [13] with adjustment screw [2] if necessary.

NOTE: Do not push the latch lever too hard on the latch strike or else damage may occur.

SUBTASK 25-21-06-700-002

- (2) Adjust the hinge [6] with adjustment screw [5] if necessary.

SUBTASK 25-21-06-212-001

- (3) Do a visual inspection of the gap seal [16].

SUBTASK 25-21-06-350-001

- (4) Interference can occur when the latch lever [9], [13] engages the panel strike. Use shims to decrease unwanted noise if necessary.

SUBTASK 25-21-06-420-005

- (5) Install the emergency exit sign and attached bar if they were removed.

SUBTASK 25-21-06-410-004

- (6) Put the gap cover up on the adjacent panel [7], [1].

SUBTASK 25-21-06-210-001

- (7) Do a visual check to make sure you cannot see the red flag on the latches [13].

D. Air Grill Installation

SUBTASK 25-21-06-410-002

- (1) Do these steps to install the air grills [8] between the inboard panel [7] and the outboard panel [1]:
 - (a) Install the forward air grill [8] first before you install the one with the emergency light [10].
 - (b) Put the forward hooks [14] for the air grill [8] outboard of the plenum walls [11], between the plenum walls [11] and lower angles.
 - (c) Lift the air grill [8] up and put the other hooks [14] outboard of the plenum walls [11].
 - (d) Push the air grill [8] forward.
 - (e) Push the end of the latch [13] up until you can not see the red flag.
 - (f) Do these steps again to install the aft grill [8].
 - (g) Put the gap cover up on the adjacent air grill [8].

————— END OF TASK —————

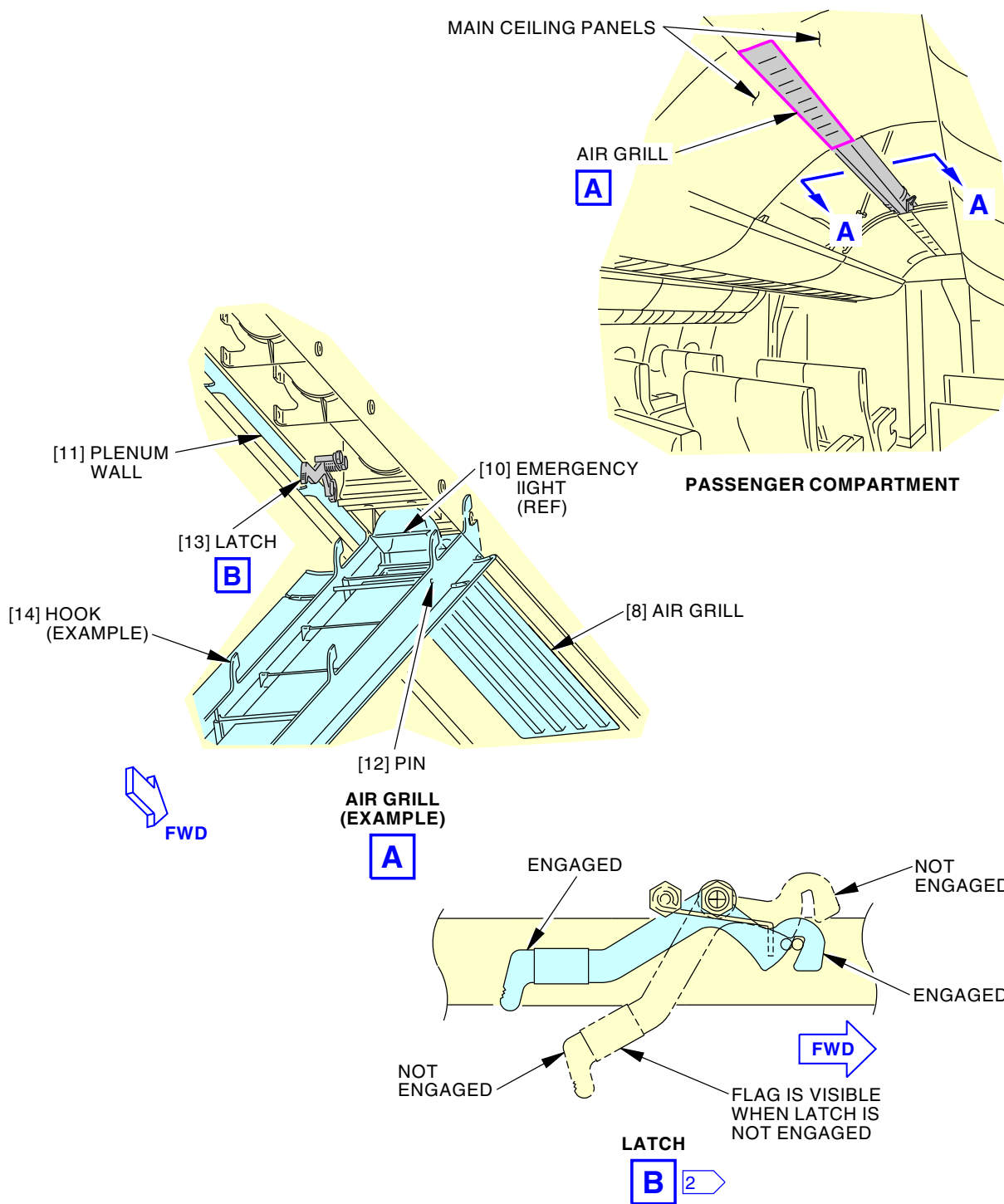
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25-21-06

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Page 403
Sep 05/2017



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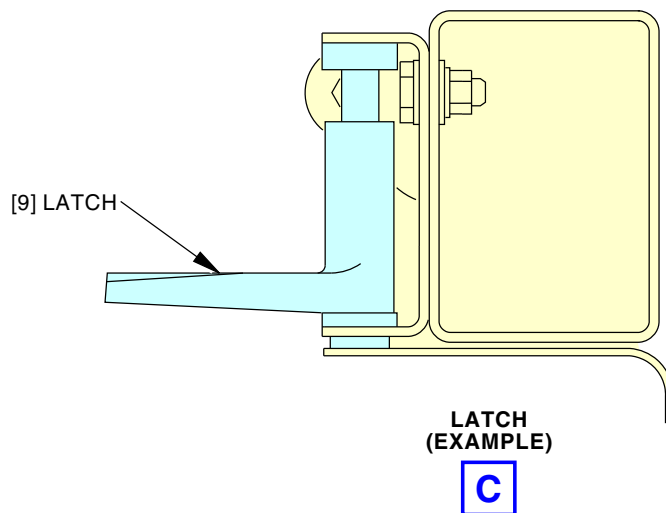
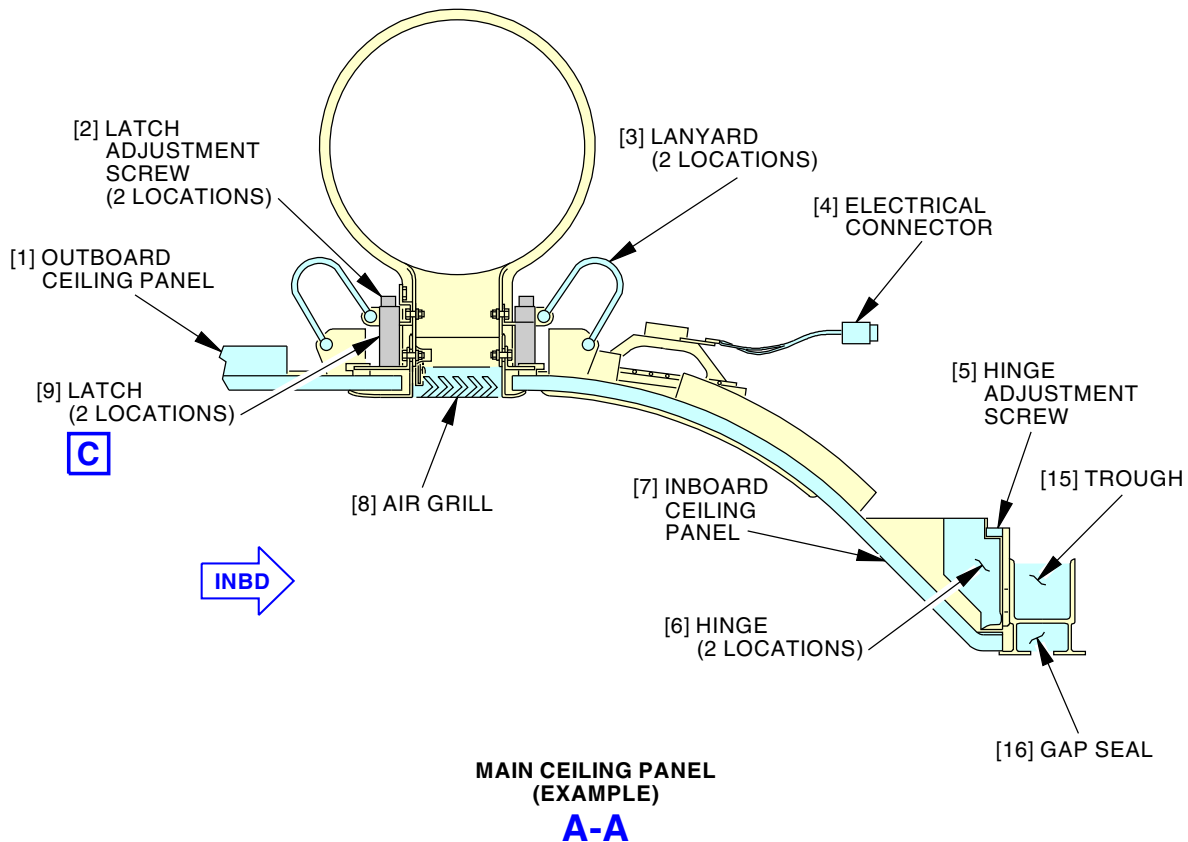
**Main Ceiling Panel Installation
Figure 401/25-21-06-990-801 (Sheet 1 of 2)**

EFFECTIVITY
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25-21-06

D633W101-ARO

Page 404
May 05/2017



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**Main Ceiling Panel Installation
Figure 401/25-21-06-990-801 (Sheet 2 of 2)**

EFFECTIVITY
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D633W101-ARO

25-21-06

Page 405
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

LOWERED CEILING PANEL - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Removal of the lowered ceiling panel
 - (2) Installation of the lowered ceiling panel
- B. The lowered ceiling areas are at passenger entry doors 1 and 4. These areas have many different panels.
- C. Different equipment is mounted on some of the panels such as speakers, environmental control systems (ECS) brackets, passenger seat provisions, dripshields, and lights.
- D. Some panels are the access for the equipment. It is necessary to use the access panels to get to the different attachments for removal and installation of a panel. Alternate access is through the main ceiling panels or the overdoor panels.

TASK 25-21-07-000-801

2. Lowered Ceiling Panel Removal

(Figure 401)

A. **Location Zones**

Zone	Area
223	Area Above Passenger Compartment Ceiling, Left - Section 41
224	Area Above Passenger Compartment Ceiling, Right - Section 41
263	Area Above Passenger Compartment Ceiling, Left - Section 47
264	Area Above Passenger Compartment Ceiling, Right - Section 47

B. **Prepare for the Removal**

SUBTASK 25-21-07-860-001

- (1) Open these circuit breakers and install safety tags:

Standby Power Management Panel, P310

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	9	C23634	SDM COL 1
F	10	C23635	SDM COL 2
F	11	C23636	SDM COL 3

SUBTASK 25-21-07-860-002

- (2) Make sure the call lights are off.

SUBTASK 25-21-07-860-003

- (3) Make sure the exit signs are off.

C. **Lowered Ceiling Panel Removal**

SUBTASK 25-21-07-010-001

- (1) Use an allen wrench to open the access panel [1] near the panel [7] you want to remove.

NOTE: If there is not an access panel near the panel you want to remove, it is necessary to remove sufficient panels to get access.

SUBTASK 25-21-07-010-002

- (2) Disconnect the lanyards for the access panel [1].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-21-07

Page 401
Jan 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-21-07-020-001

- (3) Disconnect the electrical connectors for the electrical equipment mounted on the panel [7].

SUBTASK 25-21-07-020-002

- (4) While one person holds up the panel [7], do these steps:
- (a) For the panels [7] with a bin rail [8] attachment near a bin arch, do these steps:
 - 1) Remove the screws [17] and washers [16].
 - 2) Disconnect the panel [7] from the bracket [6].
 - (b) For the panels [7] with a bin rail [8] attachment do these steps:
 - 1) Remove the bolts [2], washers [3], washer [4], and nuts [5].
 - 2) Disconnect the bracket [6] on the panel [7] from the bin rail [8].
 - (c) For the panels [7] with a structure [9] attachment, do these steps:
 - 1) Remove the bolts [14], washers [11], washer [13], and nuts [10].
 - 2) Disconnect the brackets [12] on the panel [7] from the structure [9].
 - (d) For the panels [7] with a vertical closeout attachment, do these steps:
 - 1) Remove the bolts [22], washers [20], washer [21], and nuts [19] that attach the panel [7] to the vertical closeout panel [18].
 - 2) Remove the screws [17] and washers [16] that attach the panel [7] to the vertical closeout panel [18].
 - (e) For the panels [7] with a secondary support attachment, remove the screws [17] and washers [16] that attach the panel [7] to the secondary support [15].

————— END OF TASK —————

TASK 25-21-07-400-801

3. Lowered Ceiling Panel Installation

(Figure 401)

A. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)

B. Location Zones

Zone	Area
223	Area Above Passenger Compartment Ceiling, Left - Section 41
224	Area Above Passenger Compartment Ceiling, Right - Section 41
263	Area Above Passenger Compartment Ceiling, Left - Section 47
264	Area Above Passenger Compartment Ceiling, Right - Section 47

C. Lowered Ceiling Panel Installation

SUBTASK 25-21-07-420-001

- (1) While one person holds up the panel [7], do these steps:
- (a) Connect the electrical connectors for the electrical equipment mounted on the panel [7].
 - (b) Install all fasteners with your fingers before you tighten each fastener to make sure the you can install all the fasteners easily.
 - (c) For the panels [7] with a bin rail [8] attachment near a bin arch, install the screws [17] and washers [16] to attach the panel [7] to the brackets [6].

EFFECTIVITY
ARO ALL

25-21-07

D633W101-ARO

Page 402
Jan 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (d) For the panels [7] with a bin rail [8] attachment, install the bolts [2], washers [3], washers [4], and nuts [5] to attach the brackets [6] on the panel [7], to the bin rail [8].
- (e) For the panels [7] with a structure [9] attachment, install the bolts [14], washers [11], washers [13], and nuts [10] to attach the bracket [12] on the panel [7], to the structure [9].
- (f) For the panels [7] with a vertical closeout attachment, do these steps:
 - 1) Install the bolts [22], washers [20], washers [21], and nuts [19], as applicable, to attach the panel [7] to the vertical closeout panel [18].
 - 2) Install the screws [17] and washers [16] to attach the panel [7] to the vertical closeout panel [18].
- (g) For the panels [7] with a secondary support [15] attachment, install the screws [17] and washers [16] to attach the panel [7] to the secondary support [17].

SUBTASK 25-21-07-210-001

- (2) Do these steps to make sure the panel [7] is installed correctly:
 - (a) Look at the panel [7] to make sure the edges are flush with the adjacent panels.
 - 1) If applicable, adjust the panel using the slotted brackets [6].
 - (b) Make sure the clearance between the panel [7] and adjacent panels is approximately 0.375 inch.

SUBTASK 25-21-07-410-001

- (3) Connect the lanyards to the access panel [1].

SUBTASK 25-21-07-410-002

- (4) Use an allen wrench to close the access panel [1].

D. Lowered Ceiling Panel Installation Test

SUBTASK 25-21-07-860-004

- (1) Remove the safety tags and close these circuit breakers:

Standby Power Management Panel, P310

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	9	C23634	SDM COL 1
F	10	C23635	SDM COL 2
F	11	C23636	SDM COL 3

SUBTASK 25-21-07-860-005

- (2) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-21-07-210-002

- (3) Make sure the exit signs come on.

SUBTASK 25-21-07-210-003

- (4) Make sure the call lights come on.

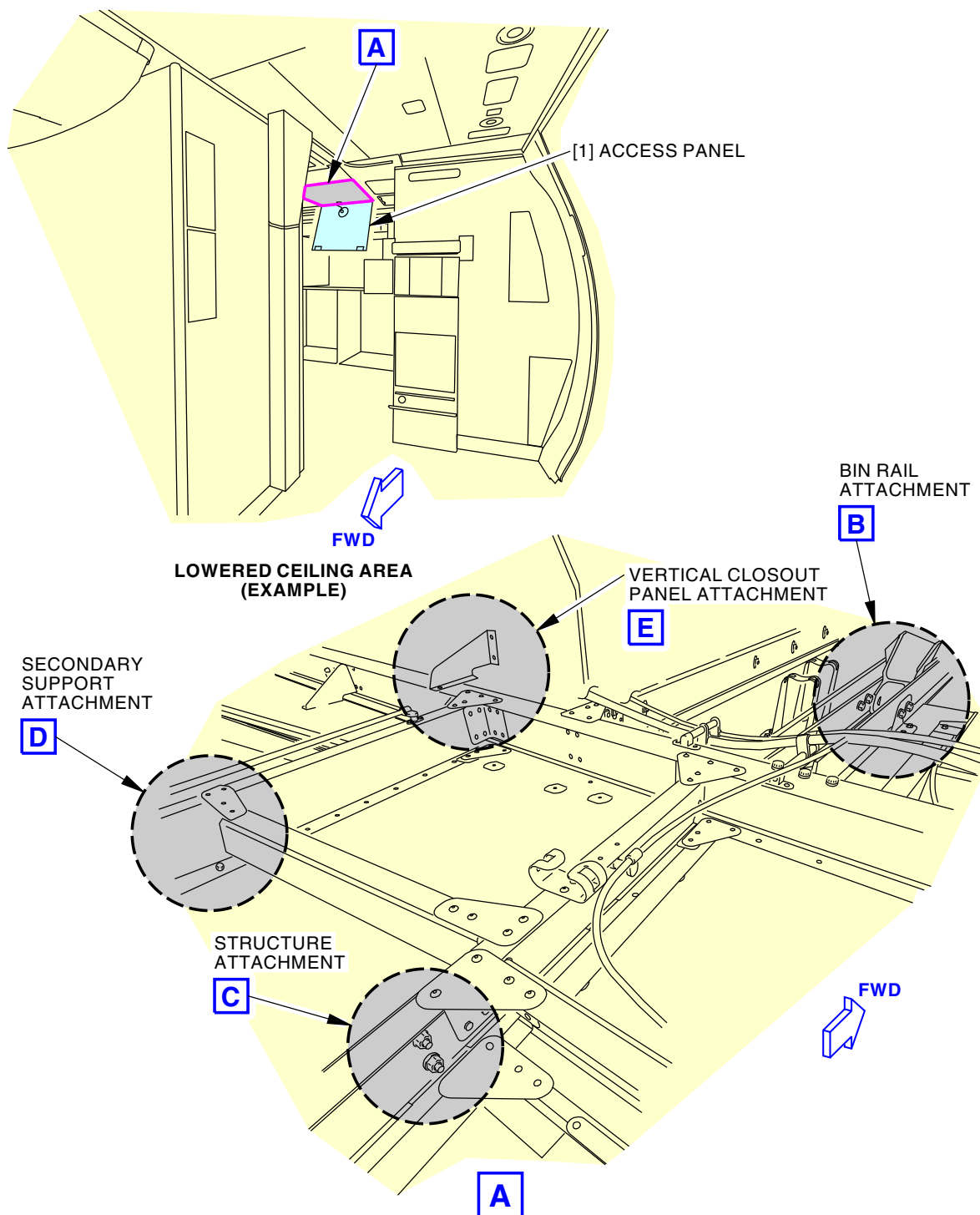
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EFFECTIVITY
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25-21-07

D633W101-ARO

Page 403
Jan 05/2017



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Lowered Ceiling Installation
Figure 401/25-21-07-990-801 (Sheet 1 of 3)

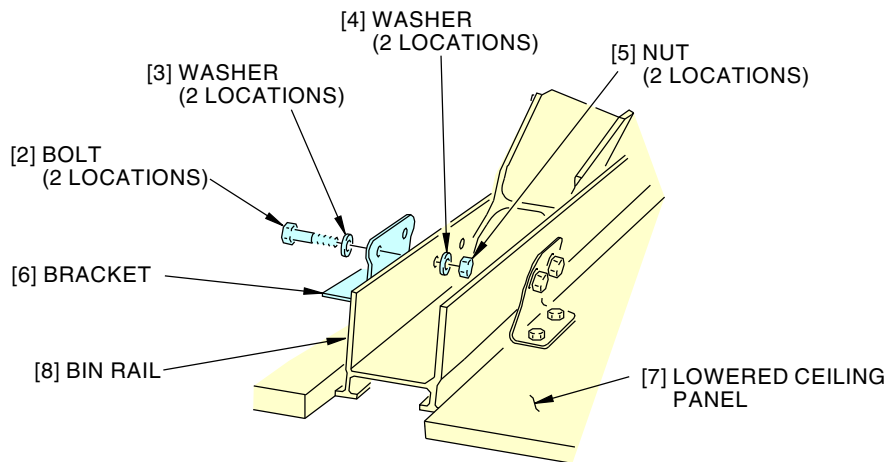
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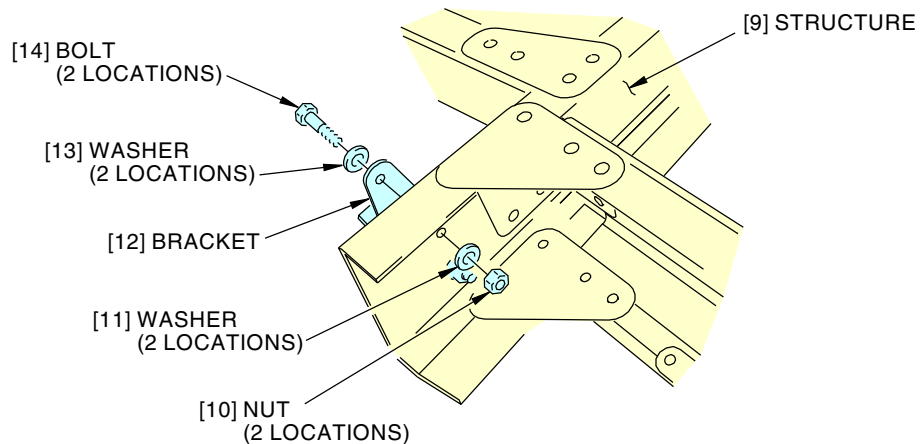
Page 404
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**BIN RAIL ATTACHMENT
(EXAMPLE)**

B



STRUCTURE ATTACHMENT

C

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**Lowered Ceiling Installation
Figure 401/25-21-07-990-801 (Sheet 2 of 3)**

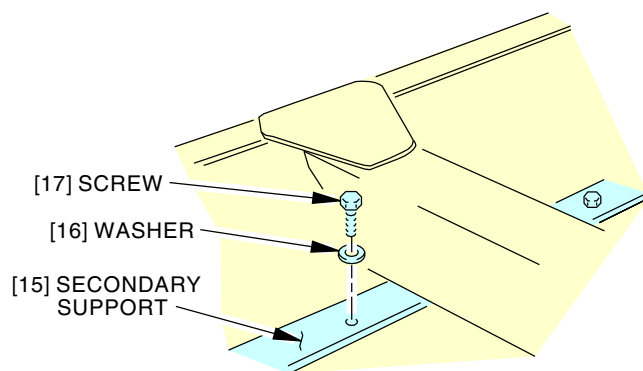
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25-21-07

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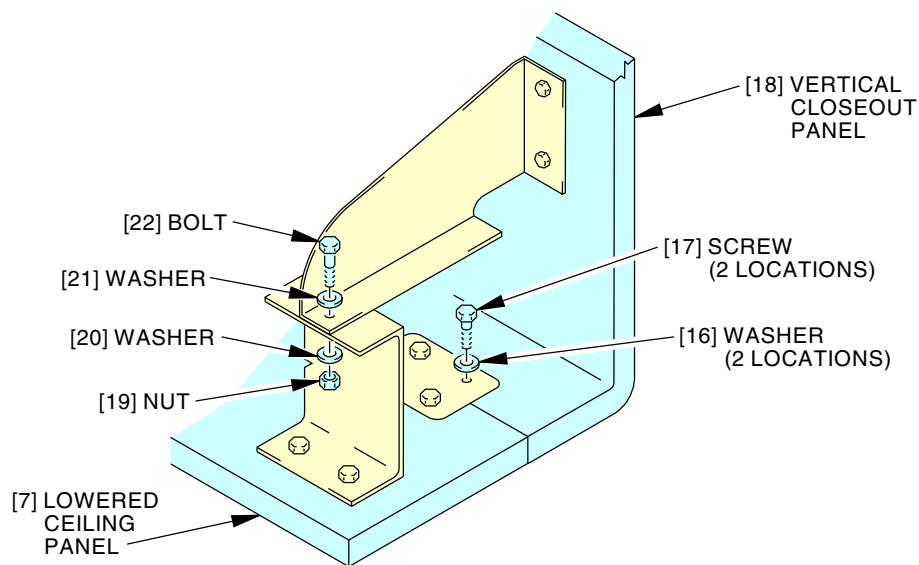
Page 405
Jan 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



SECONDARY SUPPORT ATTACHMENT

D



**VERTICAL CLOSEOUT
PANEL ATTACHMENT**

E

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Lowered Ceiling Installation
Figure 401/25-21-07-990-801 (Sheet 3 of 3)

EFFECTIVITY
ARO ALL

25-21-07

D633W101-ARO

Page 406
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

OVERDOOR PANEL - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) Overdoor Panel Opening.
 - (2) Overdoor Panel Closing.
- B. There is an overdoor panel above each passenger entry door. This procedure is applicable for all of the overdoor panels.

TASK 25-21-08-000-801

2. Overdoor Panel Opening/Removal

NOTE: Figure 201

A. **References**

Reference	Title
23-31-03-000-802	Overdoor Speaker Removal (P/B 401)
23-33-02-000-803	Overdoor Overhead Electronics Unit Removal (P/B 401)
25-65-00-040-801	Disarm the Off-Wing Escape System (P/B 201)
35-21-11-000-803	Attendant/Crew Rest/ Lavatory Oxygen PSU Removal (P/B 201)

B. **Location Zones**

Zone	Area
830	Subzone 830 - Passenger Compartment Doors, Left
840	Subzone 840 - Passenger Compartment Doors, Right

C. **Prepare for the Removal**

SUBTASK 25-21-08-080-001

- (1) Do this task: Disarm the Off-Wing Escape System, TASK 25-65-00-040-801.

D. **Overdoor Panel Opening**

SUBTASK 25-21-08-010-001

- (1) Do these steps to open the overpanel door [4]:
- (a) At passenger entry doors (PED) No. 1 and No. 5, turn the quarter-turn fasteners [5] on the inboard edge of the overdoor panel [4] counterclockwise with a 5/32 Allen wrench.
 - (b) At passenger entry door (PED) No. 2, No. 4, and overwing door No. 3, turn the quarter-turn fasteners [5] on the outboard edge of the overdoor panel [4] counterclockwise with a 5/32 Allen wrench.
 - (c) Open the overdoor panel [4].

NOTE: The overdoor panel [4] will hang on the lanyards [9].

E. **Overdoor Panel Removal**

SUBTASK 25-21-08-210-001

- (1) Make sure that the pilot's Emergency Lights Switch on the P5 panel is in the OFF position.

SUBTASK 25-21-08-010-003

- (2) Disconnect the inboard lanyards [9] to open the overdoor panel [4] .

SUBTASK 25-21-08-020-001

- (3) Do the applicable steps in these tasks:
- (a) Overdoor Speaker Removal, TASK 23-31-03-000-802.

EFFECTIVITY
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25-21-08

D633W101-ARO

Page 201
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (b) Overdoor Overhead Electronics Unit Removal, TASK 23-33-02-000-803.
- (c) Attendant/Crew Rest/ Lavatory Oxygen PSU Removal, TASK 35-21-11-000-803.

SUBTASK 25-21-08-010-004

- (4) If necessary, do these steps to remove the flex hose from the overdoor ceiling panel [4].
 - (a) Loosen the clamps on each of the flex hoses.
 - (b) Slide the clamps back from the vents.
 - (c) Remove the flex hoses from the vents.

SUBTASK 25-21-08-020-003

- (5) Disconnect the electrical connector [3].

SUBTASK 25-21-08-010-005

- (6) Disconnect the lanyards [1] from the overdoor panel [4].

SUBTASK 25-21-08-020-004

- (7) Remove the overdoor panel [4].

————— **END OF TASK** —————

TASK 25-21-08-400-801

3. Overdoor Panel Installation/Closing

NOTE: Figure 201

A. References

Reference	Title
23-31-00-730-801	Passenger Address System - System Test (P/B 501)
23-31-03-400-802	Overdoor Speaker Installation (P/B 401)
23-33-02-400-803	Overdoor Overhead Electronics Unit Installation (P/B 401)
24-22-00-860-805	Supply Electrical Power (P/B 201)
25-65-00-440-801	Arm the Off-Wing Escape System (P/B 201)
33-51-00-710-803	Emergency Lights - Operational Test with the Control Switches (P/B 501)
35-21-11-400-804	Attendant/Crew Rest/ Lavatory Oxygen PSU Installation (P/B 201)

B. Location Zones

Zone	Area
830	Subzone 830 - Passenger Compartment Doors, Left
840	Subzone 840 - Passenger Compartment Doors, Right

C. Overdoor Panel Installation

SUBTASK 25-21-08-410-001

- (1) Do these steps to install the overdoor panel [4]:
 - (a) Hold the overdoor panel [4] up to attach the lanyards [1] to the outboard side of the overdoor panel [4].
 - (b) Connect the electrical connector [3].

SUBTASK 25-21-08-410-002

- (2) If necessary, do these steps to install the flex hose to the overdoor panel [4].
 - (a) Install the flex hoses to the vents.
 - (b) Slide the clamps back over the vents.

EFFECTIVITY
ARO ALL

25-21-08

D633W101-ARO

Page 202
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (c) Tighten the clamps on each of the flex hoses.

SUBTASK 25-21-08-420-001

- (3) Do the applicable steps in these tasks:
- (a) Overdoor Speaker Installation, TASK 23-31-03-400-802.
 - (b) Overdoor Overhead Electronics Unit Installation, TASK 23-33-02-400-803.
 - (c) Attendant/Crew Rest/ Lavatory Oxygen PSU Installation, TASK 35-21-11-400-804.

SUBTASK 25-21-08-420-003

- (4) Connect the lanyards [9] to the inboard edge of the overdoor panel [4].

NOTE: The overdoor panel [4] will hang on the lanyards [9].

D. Overdoor Panel Closing

SUBTASK 25-21-08-420-004

- (1) Do these steps to close the overdoor panel [4]:
- (a) Do these steps at passenger entry doors (PED) No. 1 and No. 5:
 - 1) Put the outboard edge of the overdoor panel [4] in the spring clips.
 - 2) Push the inboard edge of the overdoor panel [4] to the closed position.
 - 3) Turn the quarter-turn fasteners [5] on the inboard edge of the overdoor panel [4] clockwise with a 5/32 Allen wrench.
 - a) Make sure that the quarter-turn fasteners [5] are fully engaged.
 - (b) Do these steps at passenger entry doors (PED) No. 2, No. 4, and overwing door No 3:
 - 1) Push the inboard edge of the overdoor panel [4] to engage the quarter-turn fasteners [5]
 - 2) Push the outboard edge of the overdoor panel [4] to the closed position.
 - 3) Turn the quarter-turn fasteners [5] on the outboard edge of the overdoor panel [4] clockwise with a 5/32 Allen wrench.
 - a) Make sure that the quarter-turn fasteners [5] are fully engaged.
 - (c) Do this task: Arm the Off-Wing Escape System, TASK 25-65-00-440-801.

E. Overdoor Panel Installation Test

SUBTASK 25-21-08-860-003

- (1) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-21-08-860-002

- (2) Do this task: Emergency Lights - Operational Test with the Control Switches, TASK 33-51-00-710-803.
- (a) Make sure that the lights connected to the power supply come on.

NOTE: Use this table:

EMERGENCY LIGHT POWER SUPPLY CONTROL TABLE					
ATTENDANT SWITCH	PILOT SWITCH	CONTROL INPUT		CHARGE INPUT	LIGHTS
		PIN 3	PIN 4	PIN 22	

EFFECTIVITY
ARO ALL

D633W101-ARO

25-21-08

Page 203
Jul 25/2018



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

(Continued)

EMERGENCY LIGHT POWER SUPPLY CONTROL TABLE					
NORMAL	OFF	GND	GND	ON	OFF
				*	
	ARM	OPEN	OPEN	ON	ON
				*	
	ON	OPEN	GND	ON	
				*	
	ON	OFF / ON / ARM	OPEN	GND	
*					
* UNDER 12V DC FOR 1 SECOND OR LONGER					

SUBTASK 25-21-08-710-001

(3) Do this task: Passenger Address System - System Test, TASK 23-31-00-730-801.

———— **END OF TASK** ————

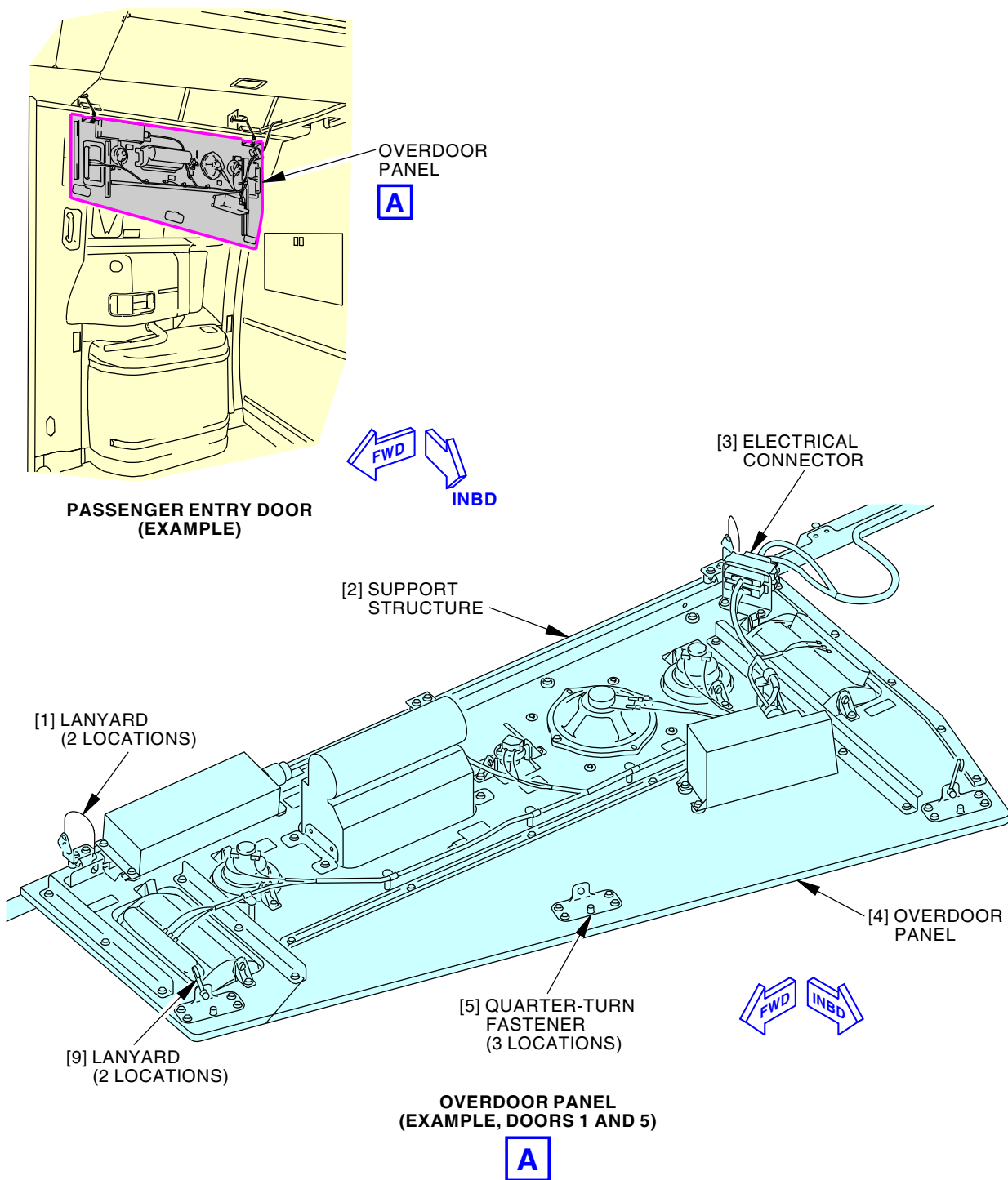
EFFECTIVITY
ARO ALL

25-21-08

D633W101-ARO

Page 204
Jan 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



K16462 S0006408951_V2

777-300 Overdoor Panel
Figure 201/25-21-08-990-802 (Sheet 1 of 2)

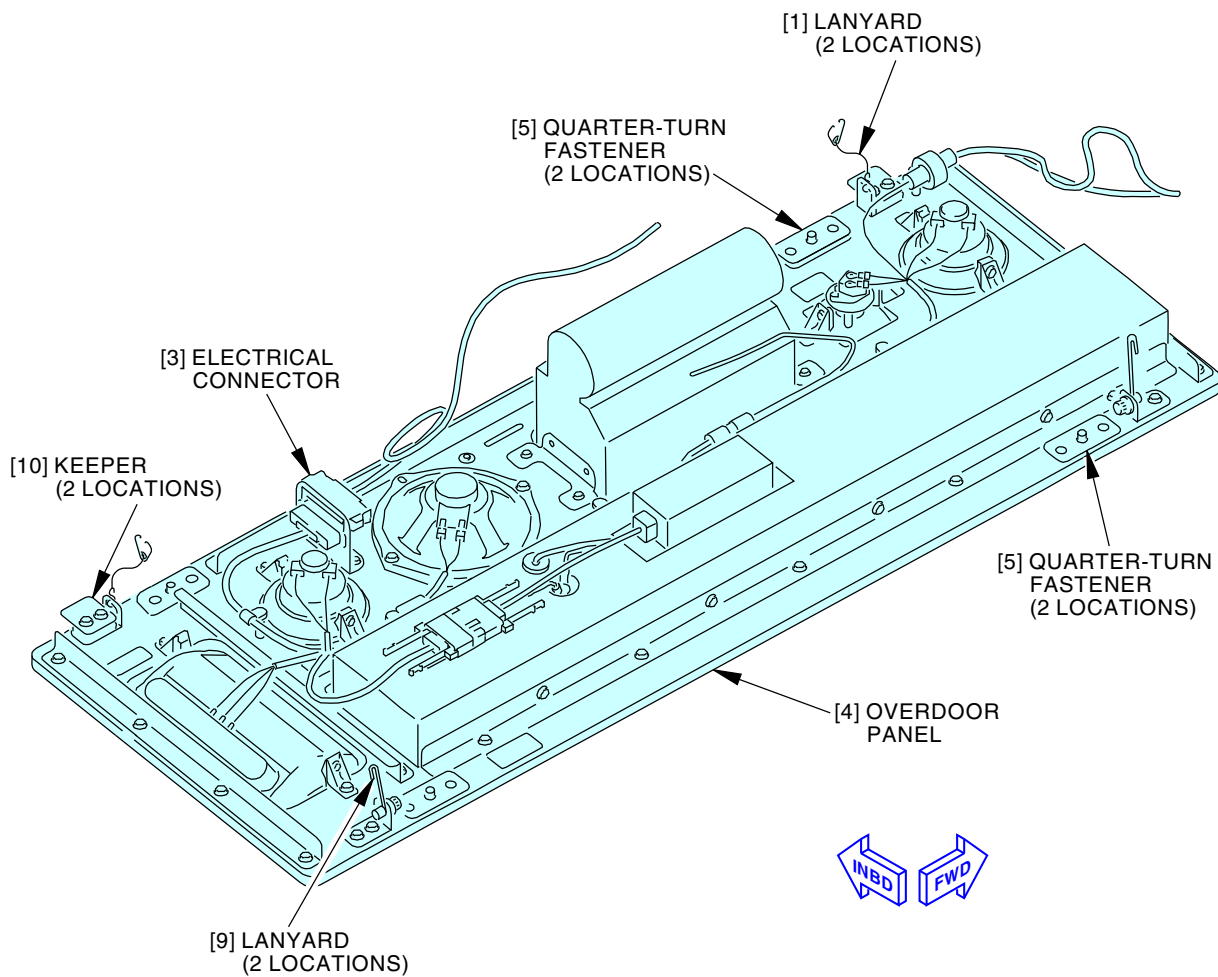
EFFECTIVITY
ARO ALL

D633W101-ARO

25-21-08

Page 205
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



OVERDOOR PANEL
(EXAMPLE, DOORS 2, 3 AND 4)

A

K16469 S0006408953_V2

777-300 Overdoor Panel
Figure 201/25-21-08-990-802 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-21-08

Page 206
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

PASSENGER SERVICE UNITS (PSU) - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
 - (1) Open the passenger service unit (PSU)
 - (2) Close the passenger service unit (PSU).
- B. These are different types of PSU panels:
 - (1) Spacer
 - (2) Temperature Sensor
 - (3) Ambient Noise Sensor
 - (4) Reading Light
 - (5) Gasper Air
 - (6) Passenger No Smoking/Fasten Seat Belt (NS/FSB) Information Sign
 - (7) Oxygen.
- C. This procedure is applicable for all types of PSU panels.
- D. Do not put the PSU panels in direct sunlight or strong artificial light. The PSU panels are made of Radel and direct sunlight or strong artificial light will change the color of the PSU panels.

TASK 25-23-01-010-801

2. Passenger Service Unit (PSU) Opening

(Figure 201)

A. Tools/Equipment

Reference	Description
STD-1153	Wire - Stiff, Single Strand, 16 Gauge

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Open the Passenger Service Unit (PSU)

SUBTASK 25-23-01-010-001

- (1) Do these steps to open an outboard Passenger Service Unit (PSU):
 - (a) Put an allen wrench between the inboard edge of the PSU and the PSU rail.
 - (b) Use the allen wrench to push the latch outboard.
 - (c) If there is more than one latch, do the same steps again to the other latch.
NOTE: Most of the PSUs have two latches. If the PSU has a small width, then it will probably only have one latch.
 - (d) READING LIGHT AND OXYGEN PANELS, disconnect the lanyard from the PSU rail.
 - (e) Let the PSU hang from the opposite end.

SUBTASK 25-23-01-010-002

- (2) Do these steps to open a center PSU:
 - (a) Put a 16 gauge wire, STD-1153 in the hole at the right side of the PSU.
 - (b) Use the rod to push the latch up.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-23-01

Page 201
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (c) If there is more than one latch, do the same steps again to the other latch.
- (d) READING LIGHT AND OXYGEN PANELS, disconnect the lanyard from the PSU rail.
- (e) Let the PSU hang from the opposite end.

———— **END OF TASK** ————

TASK 25-23-01-410-801

3. Passenger Service Unit (PSU) Closing

(Figure 201)

A. Location Zones

Zone	Area

200	Upper Half of Fuselage

B. Close the Passenger Service Unit (PSU)

SUBTASK 25-23-01-410-001

- (1) Do these steps to close an outboard or a center Passenger Service Unit (PSU):
 - (a) READING LIGHT AND OXYGEN PANELS, connect the lanyard to the PSU rail.
 - (b) Push the PSU up until you hear the latch or latches engage in the PSU rail.



WARNING

MAKE SURE THAT THE PSU LATCHES ARE ENGAGED. IF YOU DO NOT CORRECTLY ENGAGE THE LATCHES, THE PSU CAN FALL AND CAUSE INJURY TO PERSONNEL OR DAMAGE TO EQUIPMENT.

- (c) If there is more than one latch, lightly pull down on the edges of the PSU to make sure the latches are engaged.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

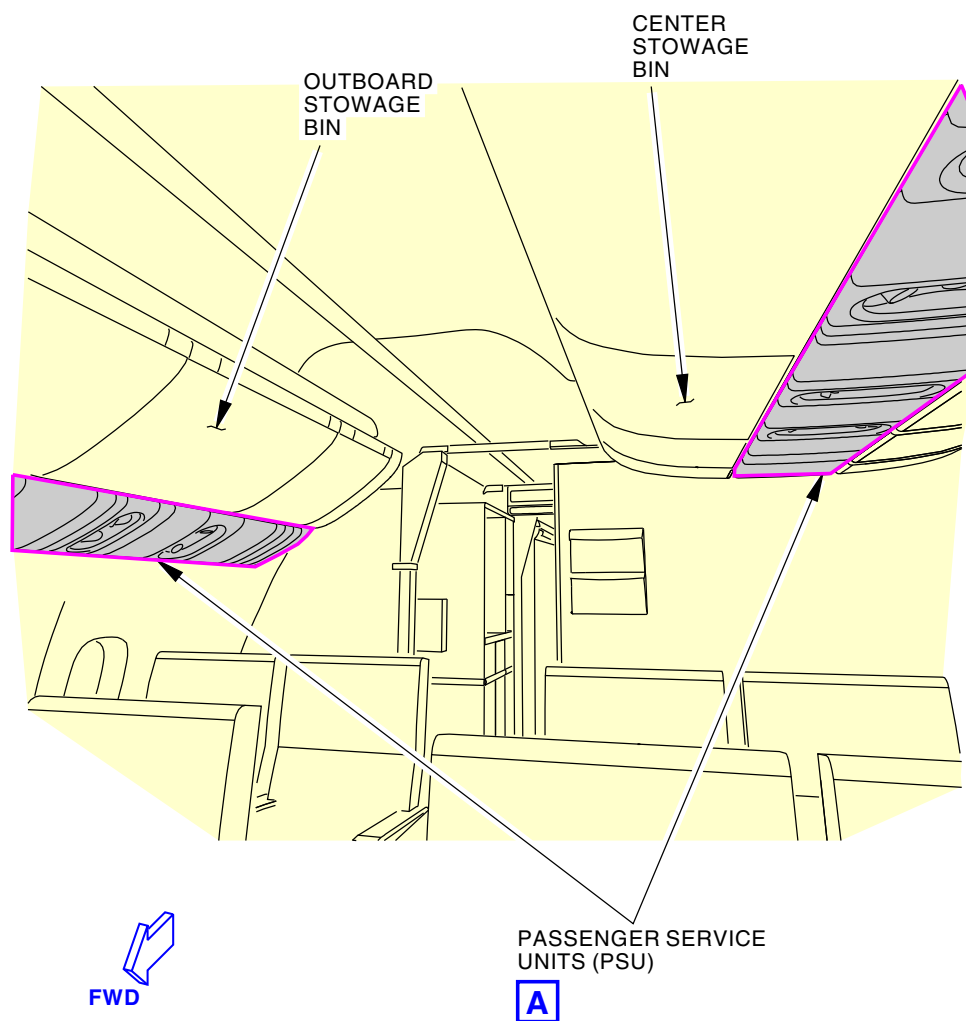
25-23-01

D633W101-ARO

Page 202
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT
(EXAMPLE)

M92771 S0006408982_V2

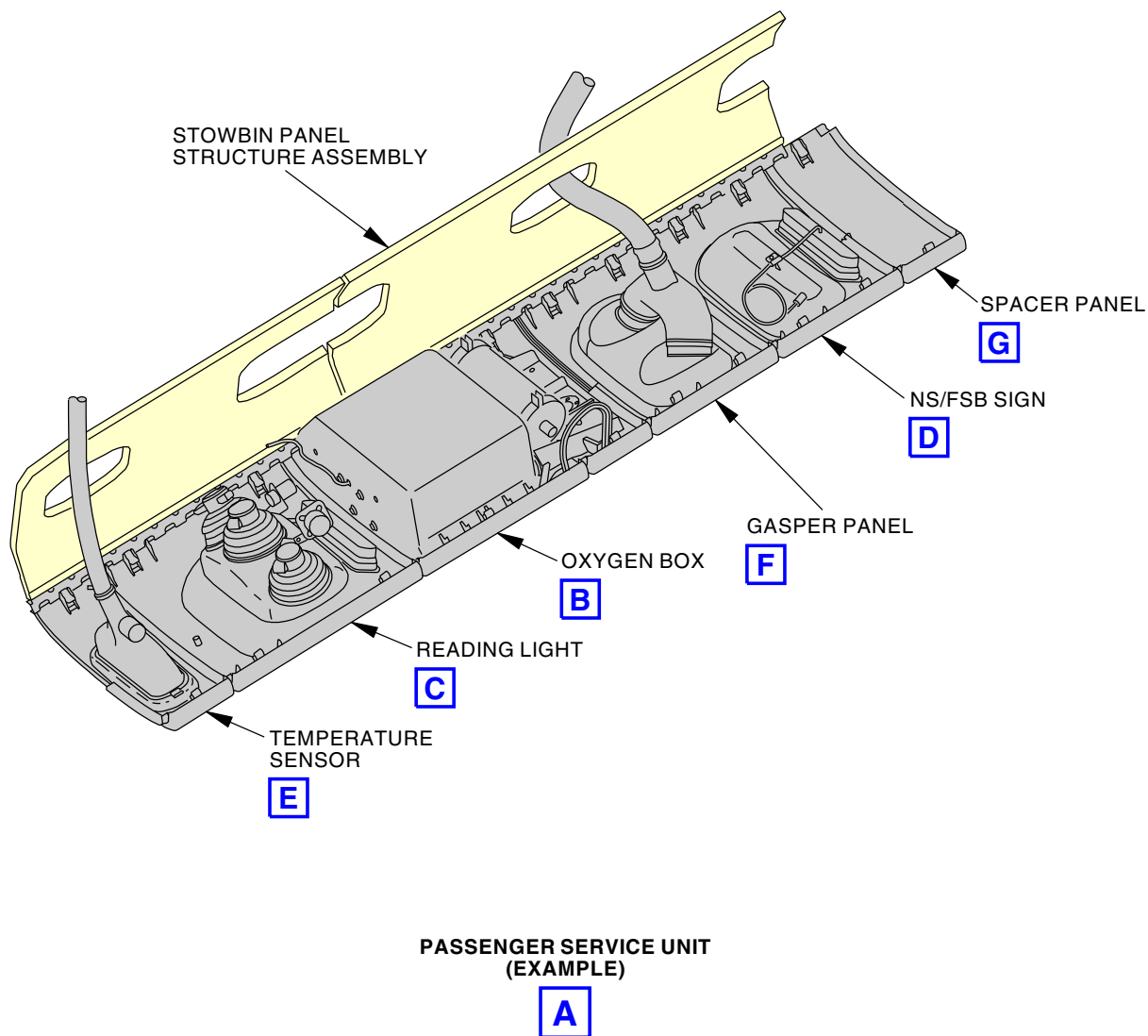
Passenger Service Units (PSUs)
Figure 201/25-23-01-990-801 (Sheet 1 of 6)

EFFECTIVITY
ARO ALL

25-23-01

D633W101-ARO

Page 203
May 05/2017



M92759 S0006408983_V2

Passenger Service Units (PSUs)
Figure 201/25-23-01-990-801 (Sheet 2 of 6)

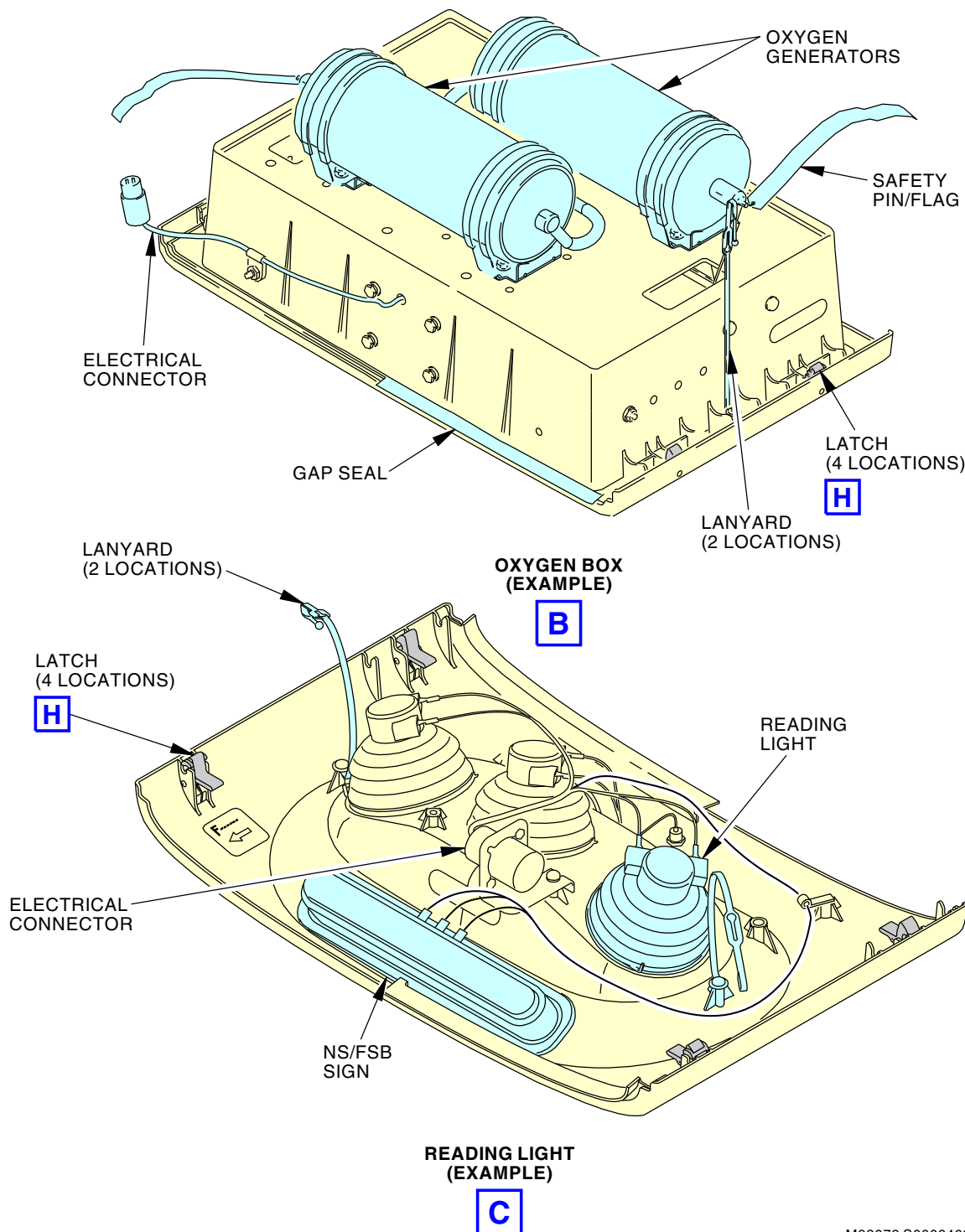
EFFECTIVITY
ARO ALL

25-23-01

D633W101-ARO

Page 204
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



M93078 S0006408984_V2

**Passenger Service Units (PSUs)
Figure 201/25-23-01-990-801 (Sheet 3 of 6)**

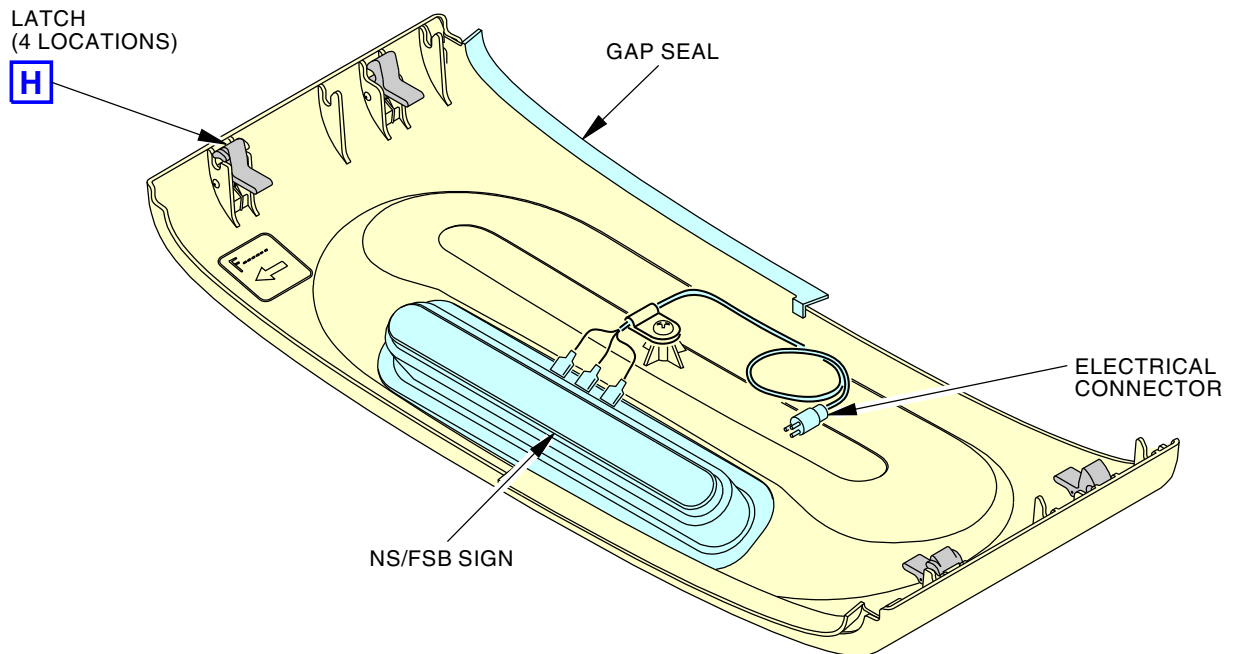
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ARO ALL

25-23-01

D633W101-ARO

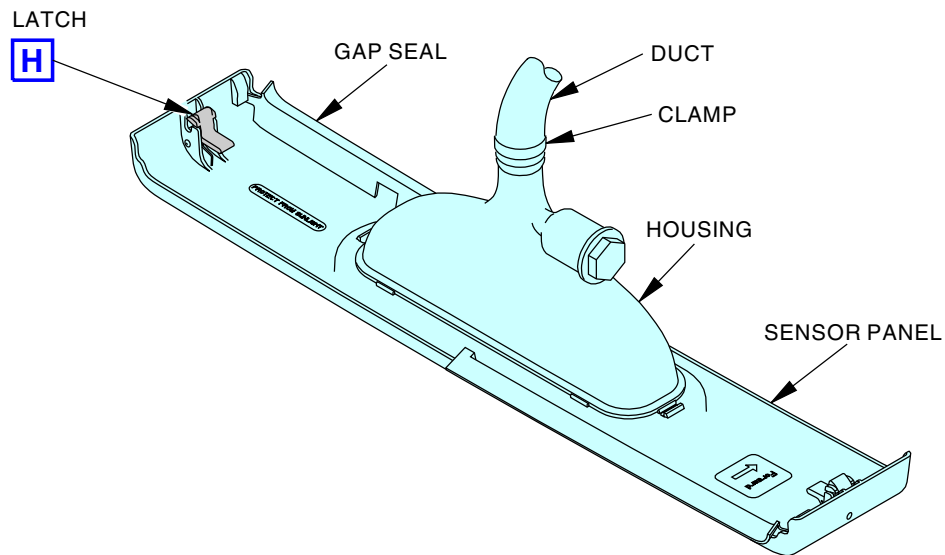
Page 205
May 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



NS/FSB SIGN
(EXAMPLE)

D



TEMPERATURE SENSOR
(EXAMPLE)

E

M94117 S0006408985_V2

Passenger Service Units (PSUs)
Figure 201/25-23-01-990-801 (Sheet 4 of 6)

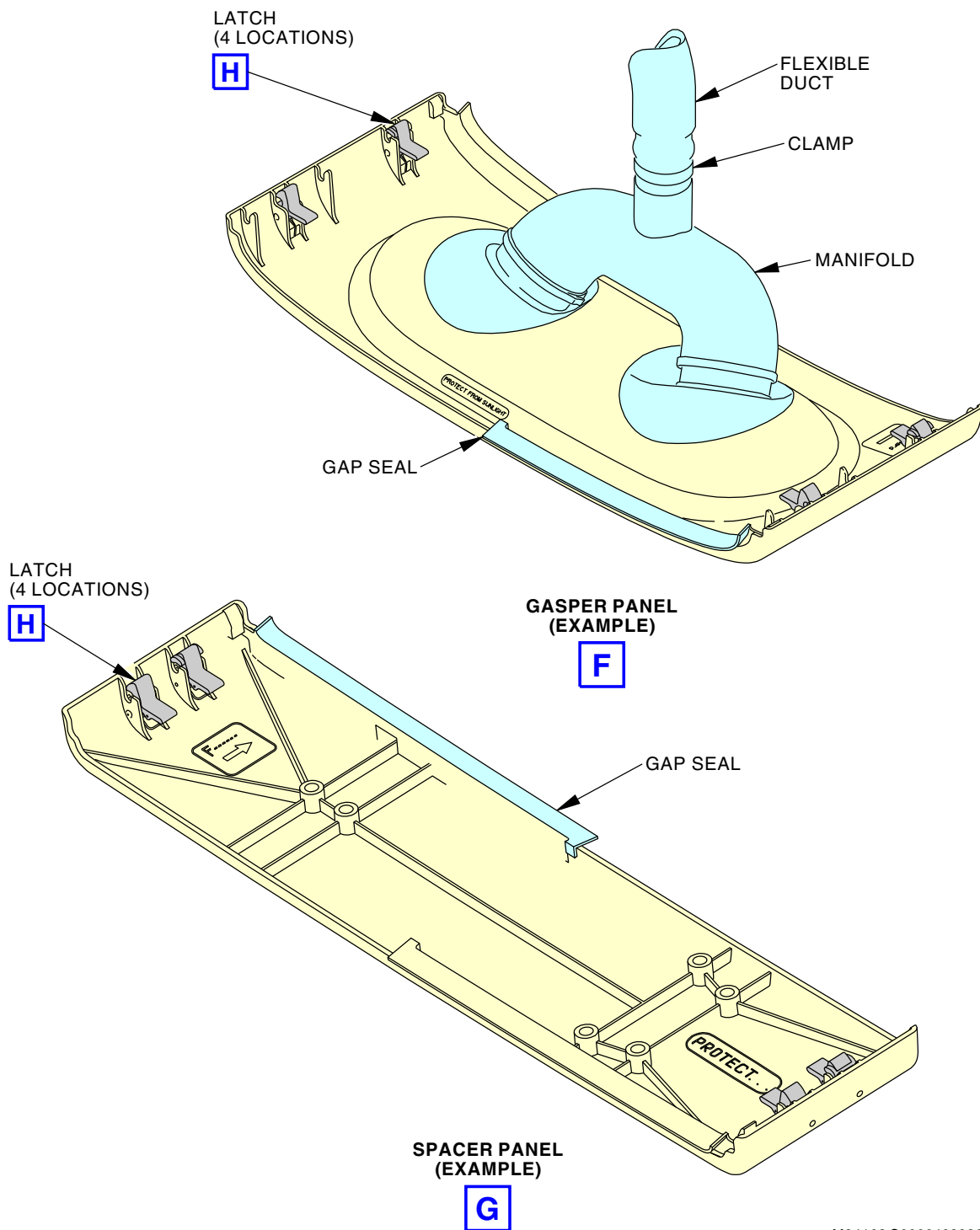
EFFECTIVITY
ARO ALL

D633W101-ARO

25-23-01

Page 206
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



M94163 S0006408986_V2

Passenger Service Units (PSUs)
Figure 201/25-23-01-990-801 (Sheet 5 of 6)

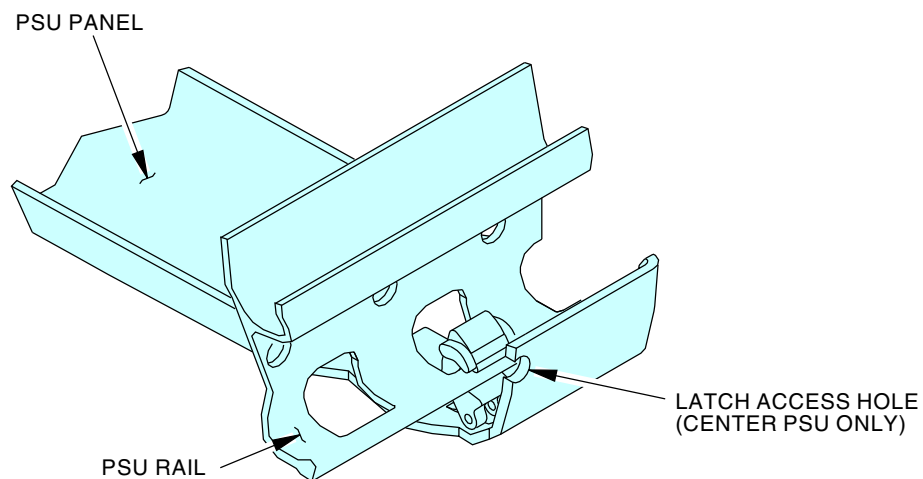
EFFECTIVITY
ARO ALL

25-23-01

D633W101-ARO

Page 207
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



LATCH
(EXAMPLE)



M94195 S0006408987_V2

Passenger Service Units (PSUs)
Figure 201/25-23-01-990-801 (Sheet 6 of 6)

EFFECTIVITY
ARO ALL

25-23-01

D633W101-ARO

Page 208
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

PASSENGER SERVICE UNITS (PSU) - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Remove the passenger service unit (PSU)
 - (2) Install the passenger service unit (PSU)
- B. These are the different types of PSU panels:
 - (1) Spacer
 - (2) Temperature Sensor
 - (3) Ambient Noise Sensor
 - (4) Reading Light
 - (5) Gasper Air
 - (6) Passenger No Smoking/Fasten Seat Belt (NS/FSB) Information Sign
 - (7) Oxygen Box
- C. This procedure is applicable for all types of PSU panels.
- D. The PSU panels are made of Radel and direct sunlight or strong artificial light will change the color of the PSU panels.

TASK 25-23-01-010-802

2. Passenger Service Unit (PSU) - Removal

(Figure 401), (Reference Not Currently Available)

A. **General**

- (1) The service units are installed for passengers and attendants. The Passenger Service Unit (PSU) are above each row of seats.

B. **References**

Reference	Title
25-23-01-010-801	Passenger Service Unit (PSU) Opening (P/B 201)
35-21-01-040-802	Oxygen Generator Firing Mechanism Deactivation (P/B 201)
35-21-11 P/B 201	ATTENDANT /CREW REST/ LAVATORY OXYGEN PSU - MAINTENANCE PRACTICES
35-21-12 P/B 201	MAIN CABIN CENTER OXYGEN PSU - MAINTENANCE PRACTICES
35-21-13 P/B 201	MAIN CABIN OUTBOARD OXYGEN PSU - MAINTENANCE PRACTICES

C. **Location Zones**

Zone	Area
200	Upper Half of Fuselage

D. **Remove the PSU**

SUBTASK 25-23-01-000-001

- (1) Open the PSU if it is not already open. Do this task: Passenger Service Unit (PSU) Opening, TASK 25-23-01-010-801.

EFFECTIVITY
ARO ALL

25-23-01

D633W101-ARO

Page 401
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-23-01-000-002

- (2) Disconnect the PSU systems as applicable.

NOTE: Refer to the following tasks for the appropriate system:

ATTENDANT /CREW REST/ LAVATORY OXYGEN PSU - MAINTENANCE PRACTICES, PAGEBLOCK 35-21-11/201

MAIN CABIN CENTER OXYGEN PSU - MAINTENANCE PRACTICES, PAGEBLOCK 35-21-12/201

MAIN CABIN OUTBOARD OXYGEN PSU - MAINTENANCE PRACTICES, PAGEBLOCK 35-21-13/201

- (a) Disconnect the electrical connectors.
- (b) Disconnect the gasper air ducts.
- (c) Disconnect the duct to the temperature sensor.

SUBTASK 25-23-01-000-003

- (3) Deactivate the chemical oxygen generators. Do this task: Oxygen Generator Firing Mechanism Deactivation, TASK 35-21-01-040-802.

SUBTASK 25-23-01-000-004

- (4) Do this step to remove an outboard or a center PSU:
- (a) Disconnect the remaining PSU latches to remove the PSU assembly.

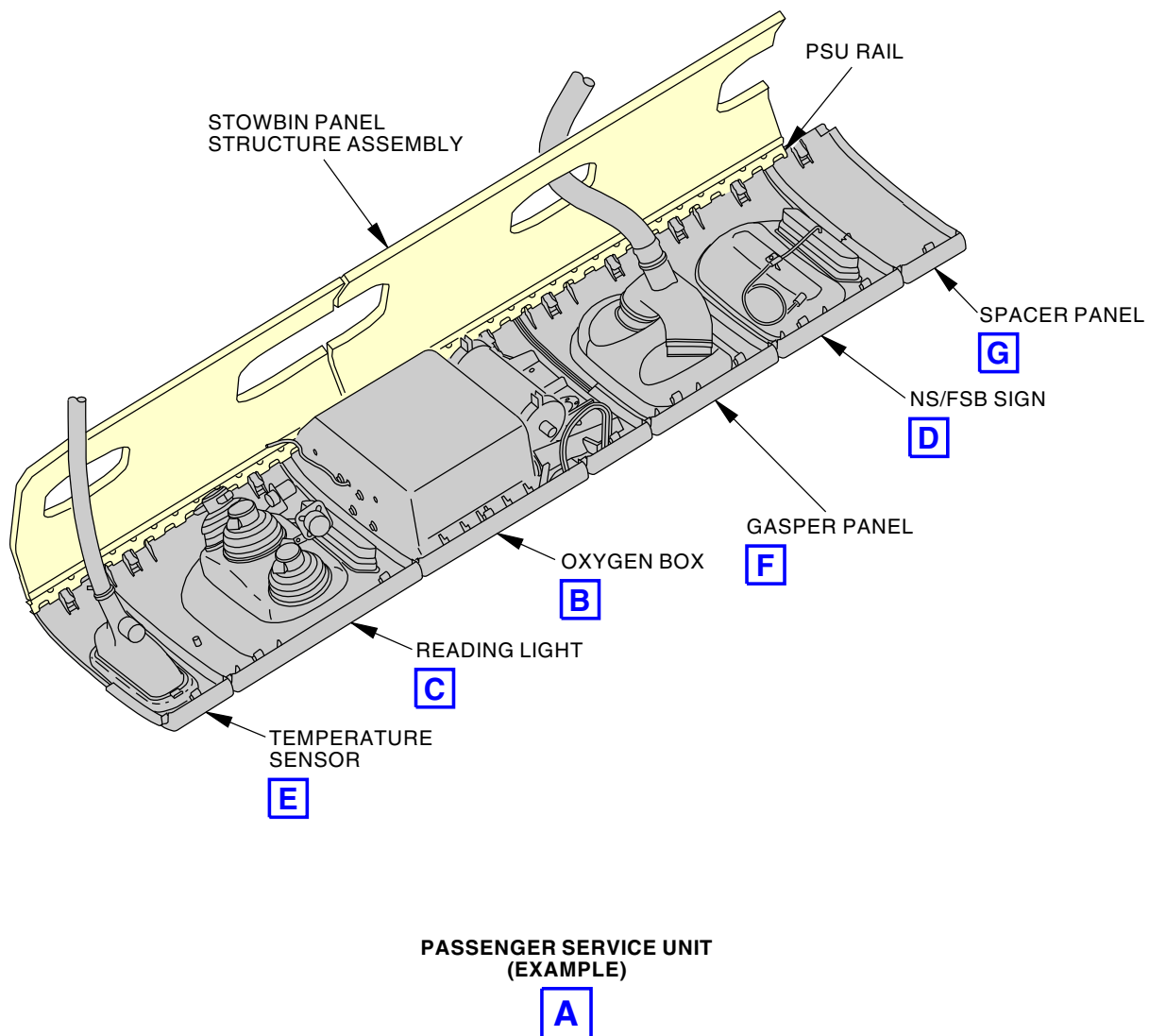
————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-23-01

D633W101-ARO

Page 402
Jul 25/2018



N28223 S0006408991_V2

Passenger Service Units (PSUs)
Figure 401/25-23-01-990-805 (Sheet 1 of 4)

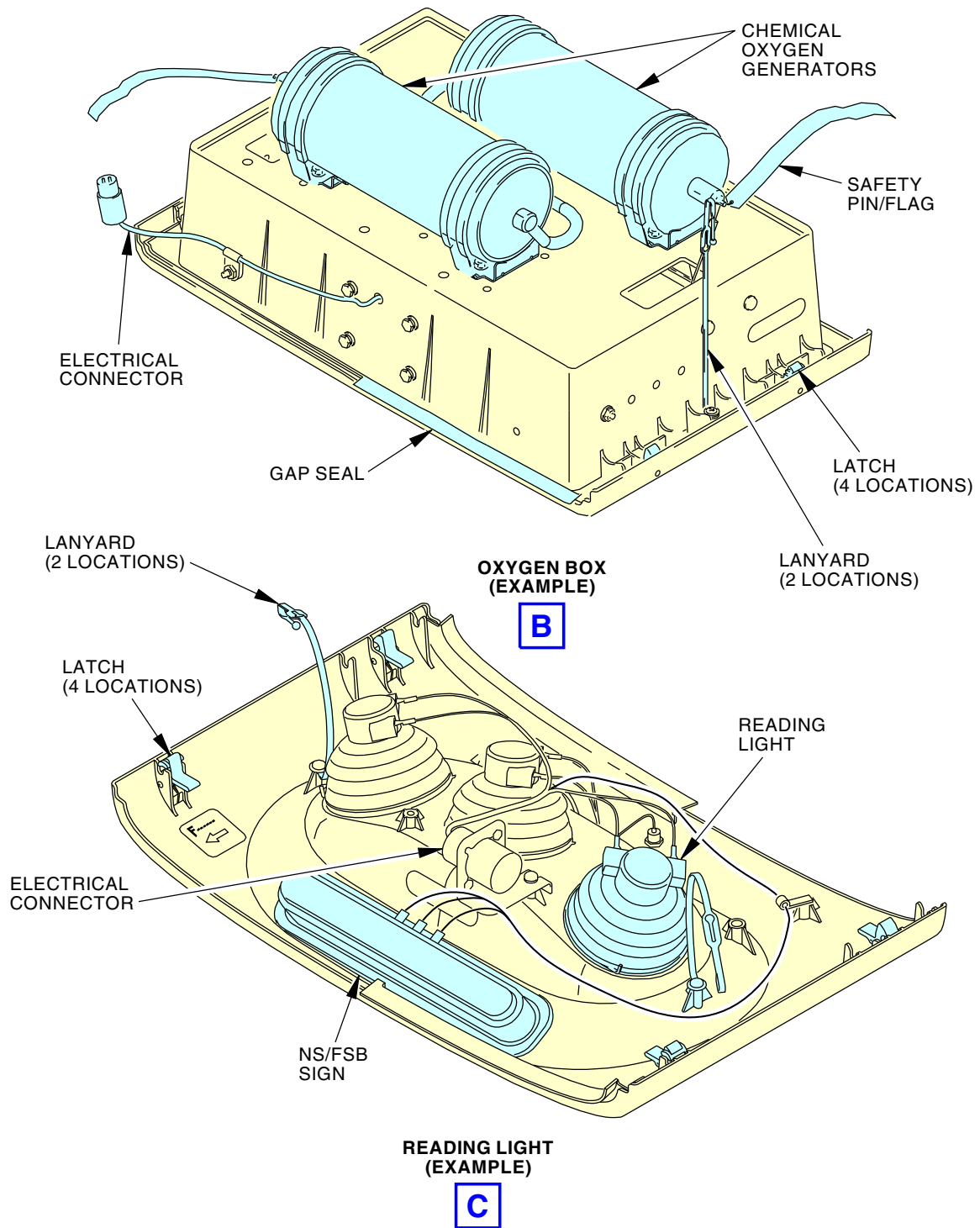
EFFECTIVITY
ARO ALL

25-23-01

D633W101-ARO

Page 403
Jul 25/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



N28256 S0006408992_V2

**Passenger Service Units (PSUs)
Figure 401/25-23-01-990-805 (Sheet 2 of 4)**

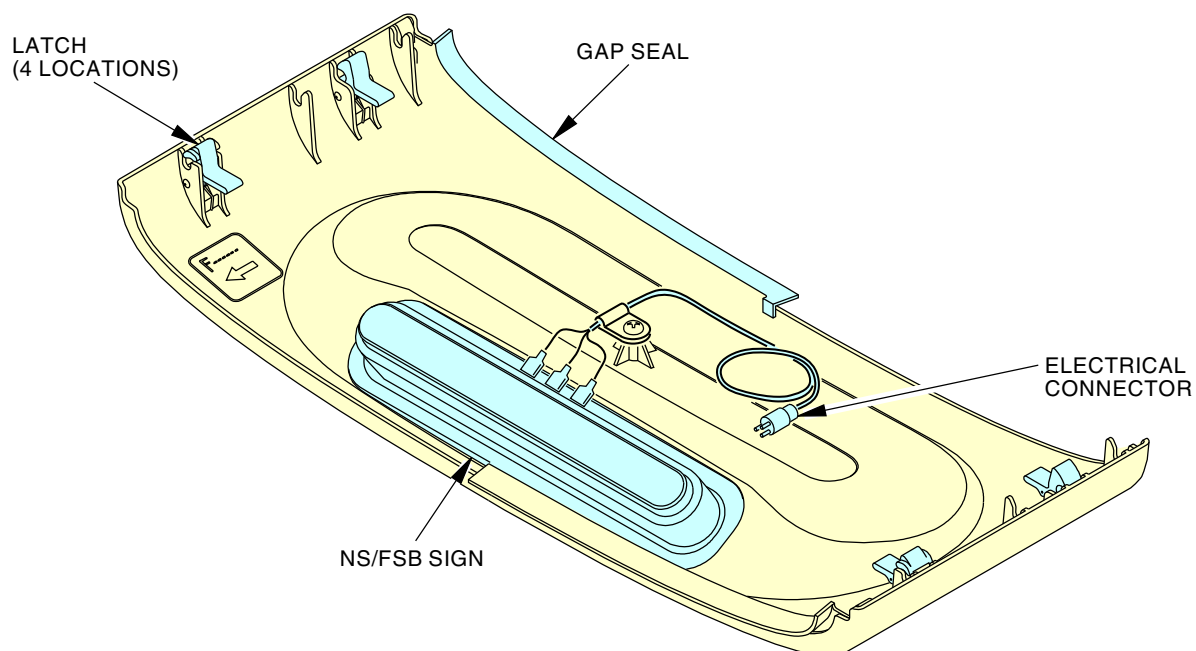
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ARO ALL

25-23-01

D633W101-ARO

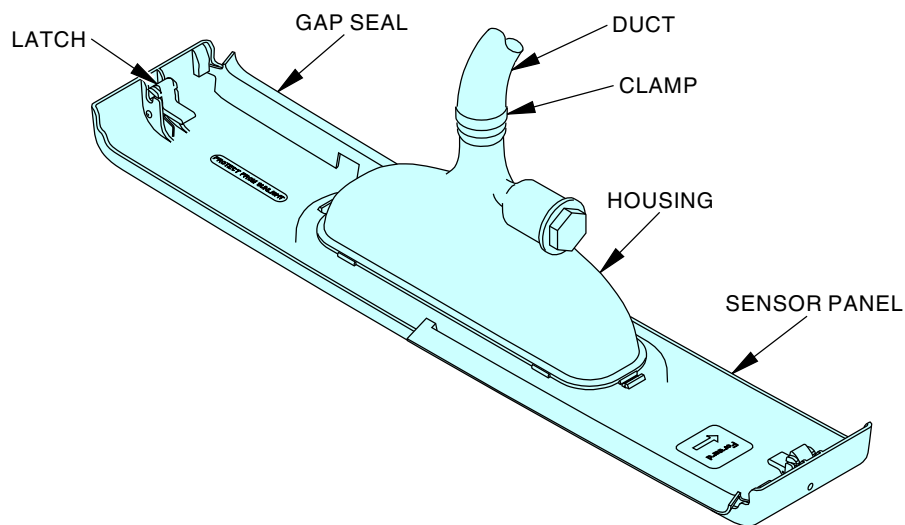
Page 404
Jul 25/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**NS/FSB SIGN
(EXAMPLE)**

D



**TEMPERATURE SENSOR
(EXAMPLE)**

E

N28305 S0006408993_V2

**Passenger Service Units (PSUs)
Figure 401/25-23-01-990-805 (Sheet 3 of 4)**

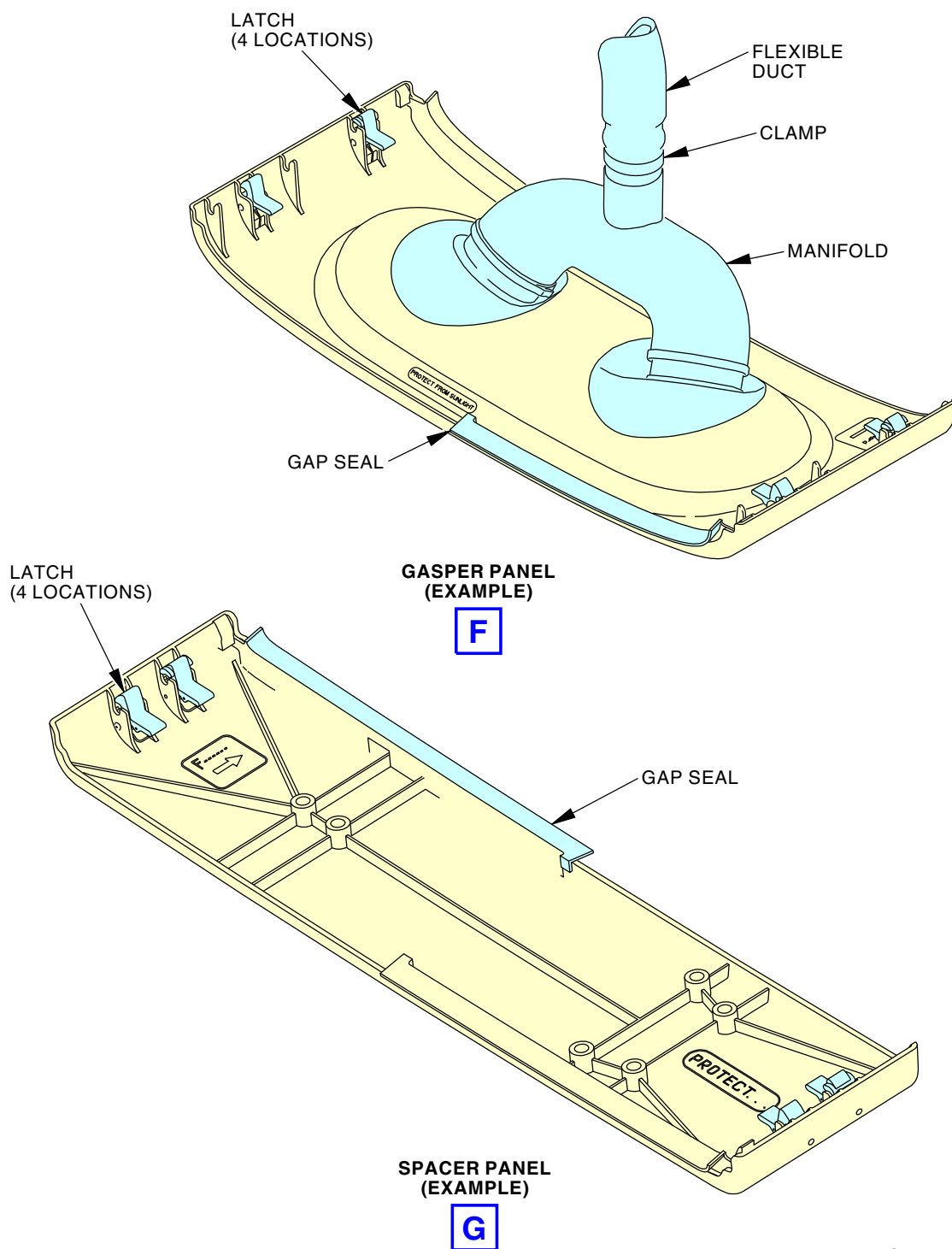
EFFECTIVITY
ARO ALL

25-23-01

D633W101-ARO

Page 405
Jul 25/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL



N28326 S0006408994_V2

Passenger Service Units (PSUs)
Figure 401/25-23-01-990-805 (Sheet 4 of 4)

EFFECTIVITY
ARO ALL

25-23-01

D633W101-ARO

Page 406
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-23-01-400-801

3. Passenger Service Unit (PSU) - Installation

(Figure 401, Reference Not Currently Available)

A. References

Reference	Title
25-23-01-410-801	Passenger Service Unit (PSU) Closing (P/B 201)
35-21-00-710-801	Oxygen Box Door Latch/Actuator Operational Test (P/B 501)
35-21-01-440-802	Oxygen Generator Firing Mechanism Activation (P/B 201)
35-21-11 P/B 201	ATTENDANT /CREW REST/ LAVATORY OXYGEN PSU - MAINTENANCE PRACTICES
35-21-12 P/B 201	MAIN CABIN CENTER OXYGEN PSU - MAINTENANCE PRACTICES
35-21-13 P/B 201	MAIN CABIN OUTBOARD OXYGEN PSU - MAINTENANCE PRACTICES

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Install the PSU

NOTE: Refer to the following tasks for the appropriate system:

ATTENDANT /CREW REST/ LAVATORY OXYGEN PSU - MAINTENANCE PRACTICES,
PAGEBLOCK 35-21-11/201

MAIN CABIN CENTER OXYGEN PSU - MAINTENANCE PRACTICES,
PAGEBLOCK 35-21-12/201

MAIN CABIN OUTBOARD OXYGEN PSU - MAINTENANCE PRACTICES,
PAGEBLOCK 35-21-13/201

SUBTASK 25-23-01-410-002

- (1) Locate the correct placement for the Passenger Service Unit (PSU) type.

NOTE: There are several types of PSU's. The location of the PSU types can be different on each airplane.

SUBTASK 25-23-01-410-003

- (2) Do this step to install an outboard or center PSU:

- (a) Connect the PSU latches to the PSU rail on one side. Let the PSU hang freely from one side.

SUBTASK 25-23-01-410-004

- (3) Do these steps to connect the PSU systems as applicable.

- (a) Connect the electrical connectors.
(b) Connect the gasper air ducts.
(c) Connect the temperature sensor duct.

ARO ALL; AIRPLANES WITH CHEMICAL PASSENGER OXYGEN SYSTEM

SUBTASK 25-23-01-410-005

- (4) Activate the chemical oxygen generators. Do this task: Oxygen Generator Firing Mechanism Activation, TASK 35-21-01-440-802.

ARO ALL

EFFECTIVITY
ARO ALL

25-23-01

D633W101-ARO

Page 407
Jul 25/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-23-01-410-006

(5) Close the PSU. Do this task: Passenger Service Unit (PSU) Closing, TASK 25-23-01-410-801.

SUBTASK 25-23-01-710-001

(6) Do this task: Oxygen Box Door Latch/Actuator Operational Test, TASK 35-21-00-710-801.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-23-01

Page 408
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

CLOSETS - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) A removal of the outboard closet.
- (2) An installation of the outboard closet.
- (3) Bulkhead closet removal.
- (4) Bulkhead closet installation.
- (5) A removal of the centerline closet.
- (6) An installation of the centerline closet.

TASK 25-24-01-000-802

2. Outboard Closet Removal

(Figure 401)

A. References

Reference	Title
25-21-06-000-801	Main Ceiling Panel - Removal (P/B 401)
25-25-01-000-801	Passenger Seat - Removal (P/B 401)
25-28-01-000-802	Outboard Stowage Bin Module Removal (P/B 401)
33-21-01-960-802	Indirect Ceiling Light - Light Assembly Replacement (P/B 201)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-24-01-860-003

- (1) Open the applicable circuit breakers for the electrical connectors mounted on the top of the closet.

SUBTASK 25-24-01-010-005

- (2) Do the applicable tasks that follow if it is necessary to get access to the closet:
 - (a) Main Ceiling Panel Removal TASK 25-21-06-000-801.
 - (b) Passenger Seat Removal TASK 25-25-01-000-801.
 - (c) Outboard Stowage Bin Module Removal TASK 25-28-01-000-802.

SUBTASK 25-24-01-010-006

- (3) Remove the closeout seal from the top and outboard side of the closet [1].

SUBTASK 25-24-01-010-023

- (4) Do the applicable tasks that follow if it is necessary to get access to the closet:
 - (a) Main Ceiling Panel Removal TASK 25-21-06-000-801.
 - (b) Passenger Seat Removal TASK 25-25-01-000-801.
 - (c) Outboard Stowage Bin Module Removal TASK 25-28-01-000-802.

D. Outboard Closet Removal

SUBTASK 25-24-01-010-025

- (1) Do the steps that follow to disconnect the top of the closet [1]:

EFFECTIVITY
ARO ALL

25-24-01

D633W101-ARO

Page 401
May 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) For Type 1 Mount, do these steps:
- 1) Disconnect the electrical connectors.
 - 2) Remove the indirect ceiling light, light shield, ballast, and light deflector bracket from the stowage bin fairing [9].
 - a) Do this task: TASK 33-21-01-960-802
 - 3) Remove the pin [22], washers [11] and [19], and cotter pin [21] to disconnect the tie rod [10] from the upper attachment bracket.
 - 4) Lift the tie rod [10] up and attach it to the structure or bracket temporarily to get it out of the way.
 - 5) Remove the screws [24] and nuts [23] from the forward end of the upper attachment bracket on the top of the closet [1].

NOTE: Open the top door of the closet to gain access to the underside of the top attachment bracket.
 - 6) Remove the screws [25] at the other end of the upper attachment bracket.
 - 7) Remove the stowage bin fairing [9] and the upper attachment bracket.
- (b) For Type 2 & Type 3 Mounts, do these steps:
- 1) Disconnect the electrical connectors.
 - 2) Remove the indirect ceiling light, light shield, ballast, and light deflector bracket from the stowage bin fairing [9].
 - a) Do this task: TASK 33-21-01-960-802
 - 3) Remove the bolt [28], bushing [27], washers [11] and [19], and nut [31] to disconnect the tie rod [10] from the upper attachment bracket.
 - 4) Lift the tie rod [10] up and attach it to the structure or bracket temporarily to get it out of the way.
 - 5) Remove the screws [29] and washers [30] from the upper attachment bracket on the top of the closet [1].
 - 6) Remove the stowage bin fairing [9] and the upper attachment bracket.
- (c) For Type 4 Mount, do these steps:
- 1) Disconnect the electrical connectors.
 - 2) Remove the indirect ceiling light, light shield, ballast, and light deflector bracket from the stowage bin fairing [9].
 - a) Do this task: TASK 33-21-01-960-802
 - 3) Remove the pin [22], washers [11] and [19], and cotter pin [21] to disconnect the tie rod [10] from the upper attachment bracket.
 - 4) Lift the tie rod [10] up and attach it to the structure or bracket temporarily to get it out of the way.
 - 5) Remove the screws [24] and washers [23] from the upper attachment bracket on the top of the closet [1].
 - 6) Remove the stowage bin fairing [9] and the upper attachment bracket.
- (d) For Type 5 Mount, do these steps:
- 1) Disconnect the electrical connectors.
 - 2) Remove the indirect ceiling light, light shield, ballast, and light deflector bracket from the stowage bin fairing [9].



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- a) Do this task: TASK 33-21-01-960-802
- 3) Remove the bolt [28], washers [11] and [19], and nut [31] to disconnect the tie rod [10] from the upper attachment bracket.
- 4) Lift the tie rod [10] up and attach it to the structure or bracket temporarily to get it out of the way.
- 5) If necessary to remove the upper attachment bracket, do these steps:
 - a) Remove the bolt [42], washers [43] and [44], and nut [45] to disconnect the side bracket support [46].
 - b) Loosen and remove the anti-rattle block [50].
 - c) Remove bolt [48], washers [43] and [49], and nut [45] to disconnect the bracket [47] from the lower bracket support.
- 6) Remove the stowage bin fairing [9] and the upper attachment bracket.
- (e) For Adjustable Type Mount, do these steps:
 - 1) Disconnect the electrical connectors.
 - 2) Remove the indirect ceiling light, light shield, ballast, and light deflector bracket from the stowage bin fairing [9].
 - a) Do this task: TASK 33-21-01-960-802
 - 3) Remove the bolt [28], washers [11] and [19], and nut [31] to disconnect the tie rod [10] from the triangular bracket [35].
 - 4) Lift the tie rod [10] up and attach it to the structure or bracket temporarily to get it out of the way.
 - 5) Remove the bolts [32], washers [33], nuts [34] and triangular brackets [35] from the upper attachment bracket on the top of the closet [1].
 - 6) Remove the stowage bin fairing [9] and the upper attachment bracket.

SUBTASK 25-24-01-010-026

- (2) Remove the coverplate or kickstrip [2] to get access to the floor attachments for the closet [1].

SUBTASK 25-24-01-030-003

- (3) Do the steps that follow to disconnect the bottom of the closet [1].
 - (a) For Type 1 Floor Attachment, do these steps:
 - 1) Remove the bolts [8] and fillers [7] that attach the closet [1] to the seat track fitting [4].
 - 2) Carefully remove the closet [1].
 - 3) Keep the bolts [8], fillers [7], washers [6], and fittings [5] for the installation of the closet [1].
 - (b) For Type 2 Floor Attachment, do these steps:
 - 1) Remove the bolts [8], washer [38] and fillers [7] that attach the closet [1] to the seat track fitting [4].
 - 2) Carefully remove the closet [1].
 - 3) Keep the bolts [8], [37], fillers [7], washers [6], [38], and fittings [5], [36] for the installation of the closet [1].
 - (c) For Type 3 or 4 Floor Attachment, do these steps:
 - 1) Remove the coverplates or kickstrip [2] on the bottom of the closet [1].

EFFECTIVITY
ARO ALL

25-24-01

D633W101-ARO

Page 403
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 2) Remove the bolts [8], washers [40], and shims [41] that attach the closet [1] to the seat track fitting [4].
- 3) Carefully remove the closet [1].
- 4) Keep the bolts [8], washers [40], and shims [41] for the installation of the closet [1].

SUBTASK 25-24-01-030-004

- (4) Do these steps, if it is necessary, to remove the seat track fittings [4]:
- (a) For Type 1 Floor Attachment, do these steps:
 - 1) Move the seat track fitting [4] forward or aft approximately 1/2 inch to align it with the circular openings in the seat track [3].
 - 2) Lift the seat track fitting [4] out of the seat track [3].
 - (b) For Type 2 Floor Attachment, do these steps:
 - 1) Remove the bolt [37] that attaches the fitting [36] to the seat track fitting [4].
 - 2) Move the seat track fitting [4] forward or aft approximately 1/2 inch to align it with the circular openings in the seat track [3].
 - 3) Lift the seat track fitting [4] out of the seat track [3].
 - (c) For Type 3 Floor Attachment, do these steps:
 - 1) Remove the nuts [44] on the seat track fitting [4].
 - 2) Move the seat track fitting [4] forward or aft approximately 1/2 inch to align it with the circular openings in the seat track [3].
 - 3) Lift the seat track fitting [4] and the stud [45] out of the seat track [3].
 - (d) For Type 4 Floor Attachment, do these steps:
 - 1) Remove the bolts [46] and the seat track fitting [4] from the saddle assembly [43].
 - 2) Move the saddle assembly [43] forward or aft approximately 1/2 inch to align it with the circular openings in the seat track [3].
 - 3) Lift the saddle assembly [43] out of the seat track [3].

————— END OF TASK —————

TASK 25-24-01-400-802

3. Outboard Closet Installation

(Figure 401)

A. References

Reference	Title
25-21-06-400-801	Main Ceiling Panel - Installation (P/B 401)
25-25-01-400-801	Passenger Seat - Installation (P/B 401)
25-28-01-400-802	Outboard Stowage Bin Module Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
G02304	Tape - Moisture Barrier, Adhesive One-side	BMS8-346

EFFECTIVITY
ARO ALL

25-24-01

D633W101-ARO

Page 404
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Outboard Closet Installation

SUBTASK 25-24-01-420-005

- (1) Do these steps if it is necessary to install the seat track fittings [4]:
- Remove the old moisture barrier tape, G02304 from the wet areas to install the seat track fittings [4].
 - Put the seat track fitting [4] in the circular opening in the seat track [3].
 - For Type 1 Floor Attachment, do this step:
 - Move the seat track fitting [4] forward or aft 1/2 inch to lock it in the correct position for the installation.
 - Install the fittings [5] and washers [6] on the seat track fittings [4].
 - Turn the fittings [5] until the closet [1] attaches to the seat track fittings [4] correctly.

NOTE: The fittings [5] are not symmetrical.
 - For Type 2 Floor Attachment, do these steps:
 - Move the seat track fitting [4] forward or aft 1/2 inch to put it in the correct position for the installation.
 - Install the fitting [36] with the bolt [37] to the seat track fitting [4].
 - Tighten the bolt [37] to 8 ± 1 in-lb (0.9 ± 0.1 N·m) to lock the seat track fitting in the correct position.
 - Install the fittings [5] and washers [6] on the seat track fittings [4].
 - Turn the fittings [5] until the closet [1] attaches to the seat track fittings [4] correctly.

NOTE: The fittings [5] are not symmetrical.
 - For Type 3 Floor Attachment, do these steps:
 - Move the seat track fitting [4] with the stud [45] forward or aft 1/2 inch to put it in the correct position for the installation.
 - Tighten the nuts [44] on the fitting stud [45] to 200 ± 40 in-lb (23 ± 5 N·m).

NOTE: If the torque value is more than 240 in-lb (27 N·m) replace the stud [45].
 - For Type 4 Floor Attachment, do these steps:
 - Install the saddle assembly [43] in the circular openings in the seat tracks [3].
 - Move the saddle assembly [43] forward or aft 1/2 inch to put it in the correct position for the installation.
 - Install the seat track fitting [4] onto the saddle assembly [43] with the bolts [46].
 - Do these steps in the wet areas to prevent corrosion:
 - Put corrosion preventive compound, C00308 in the seat track [3] around the seat track fitting [4].
 - Apply new moisture barrier tape, G02304 with a cutout for the seat track fittings [4] if it is necessary.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-24-01

Page 405
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-24-01-820-003

- (2) Do these steps to install the closet [1] on the seat track fittings:
- (a) Align the closet [1] with the seat track fittings [4].
 - (b) For Type 1 Floor Attachments, do these steps:
 - 1) Adjust the number of washers [6] to make the closet [1] level.
NOTE: You can use a maximum of three washers at each floor attach point.
 - 2) Make sure that the fittings [5] and washers [6] stay between the seat track fittings [4] and the closet [1].
 - 3) Install the filler [7] and bolts [8] down through the closet [1] into the seat track fittings [4].
 - 4) Install the coverplates or kickstrip [2] on the bottom of the closet [1].
 - (c) For Type 2 Floor Attachments, do these steps:
 - 1) Adjust the number of washers [6] to make the closet [1] level.
NOTE: You can use a maximum of three washers at each floor attach point.
 - 2) Make sure that the fittings [5] and washers [6] stay between the seat track fittings [4] and the closet [1].
 - 3) Install the filler [7], bolt [8] and washer [38] down through the closet [1] into the seat track fittings [4].
 - 4) Install the coverplates or kickstrip [2] on the bottom of the closet [1].
 - (d) For Type 3 and 4 Floor Attachment, do these steps:
 - 1) If there is clearance between the closet [1] and the seat track fitting [4], then fill this clearance with shims [41].
 - 2) Put the remaining shims [41] below the bolt [8] heads.
 - 3) Install the bolt [8] and washer [40] to attach the closet [1] to the seat track fittings [4].
 - 4) Install the coverplates or kickstrip [2] on the bottom of the closet [1].

SUBTASK 25-24-01-420-027

- (3) On closets with a tie rod attachments, do the steps that follow to attach the top of the closet [1] to the tie rod [10]:
- (a) For Type 1 Mount, do these steps:
 - 1) Do these steps to attach the upper attachment bracket on the top of the closet [1]:
 - a) Install the screws [24] and nuts [23] through the forward holes in the top of the closet and the forward holes in the upper attachment bracket.
NOTE: Open the top door of the closet to gain access to the underside of the attachment bracket.
 - b) Install the screws [25] through the other holes in the attachment bracket
 - 2) Release the tie rod [10] from the structure fitting [20] or attachment bracket.
NOTE: In the removal task the tie rod [10] was temporarily attached to the structure fitting [20] or upper attachment bracket to keep it out of the work area.
 - 3) Adjust the length of the tie rod [10] to align it with the upper attachment bracket.
 - 4) Install the pin [22], washers [11] and [19], and cotter pin [21] to attach the tie rod [10] to the upper attachment bracket.

EFFECTIVITY
ARO ALL

25-24-01

D633W101-ARO

Page 406
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 5) Install the stowage bin fairing [9].
 - 6) Connect the electrical connector.
- (b) For Type 2 & Type 3 Mounts, do these steps:
- 1) Install the screws [29] and washers [30] to attach the upper attachment bracket to the top of the closet [1]:
 - 2) Release the tie rod [10] from the structure fitting [20], [26] or attachment bracket.
NOTE: In the removal task the tie rod [10] was temporarily attached to the structure fitting [20] or upper attachment bracket to keep it out of the work area.
 - 3) Adjust the length of the tie rod [10] to align it with the upper attachment bracket.
 - 4) Install the bolt [28], bushing [27], washers [11] and [19], and nut [31] to attach the tie rod [10] to the upper attachment bracket.
 - 5) Install the stowage bin fairing [9].
 - 6) Connect the electrical connector.
- (c) For Type 4 Mount, do these steps:
- 1) Install the screws [24] and nuts [23] to attach the upper attachment bracket to the top of the closet [1]:
 - 2) Release the tie rod [10] from the structure fitting [20] or attachment bracket.
NOTE: In the removal task the tie rod [10] was temporarily attached to the structure fitting [20] or upper attachment bracket to keep it out of the work area.
 - 3) Adjust the length of the tie rod [10] to align it with the upper attachment bracket.
 - 4) Install the pin [22], washers [11] and [19], and cotter pin [21] to attach the tie rod [10] to the upper attachment bracket.
 - 5) Install the stowage bin fairing [9].
 - 6) Connect the electrical connector.
- (d) For Type 5 Mount, do these steps:
- 1) If necessary to install the upper attachment bracket [47], do these steps:
 - a) Install the bracket [47] with the bolt [48], washers [43], [49] and nut [45].
 - b) Install and tighten anti-rattle block [50].
 - c) Install the side bracket support [46] with the bolt [42], washers [43], [44] and nut [45].
 - 2) Release the tie rod [10] from the structure fitting [20] or attachment bracket.
NOTE: In the removal task the tie rod [10] was temporarily attached to the structure fitting [20] or upper attachment bracket to keep it out of the work area.
 - 3) Adjust the length of the tie rod [10] to align it with the upper attachment bracket [47].
 - 4) Install the bolt [28], washers [11] and [19], and nut [31] to attach the tie rod [10] to the upper attachment bracket [47].
 - 5) Install the stowage bin fairing [9].
 - 6) Connect the electrical connector.
- (e) For Adjustable Type Mount, do these steps:
- 1) Install the bolts [32], washers [33], and nuts [34] through the holes in each triangular bracket [35] and the holes in the brackets on the closet [1].



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 2) Release the tie rod [10] from the structure or bracket.

NOTE: In the removal task the tie rod [10] was temporarily attached to the structure or bracket to keep it out of the work area.

- 3) Adjust the length of the tie rod [10] to align it with the triangular brackets [35].
- 4) Loosely install the bolt [28], washers [11] and [19], and nut [31] to attach the tie rod [10] to the triangular brackets [35].
- 5) Tighten the bolt [28] to 165 ±35 in-lb (18.6 ±4.0 N·m).
- 6) Install the stowage bin fairing [9].
- 7) Connect the electrical connector.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-24-01-410-005

- (1) Install the closeout seal on the top and outboard sides of the closet [1] with adhesive, A00027.

SUBTASK 25-24-01-410-006

- (2) Do the applicable tasks that follow:

- (a) Main Ceiling Panel Installation (TASK 25-21-06-400-801).
- (b) Passenger Seat Installation (TASK 25-25-01-400-801).
- (c) Outboard Stowage Bin Module Installation (TASK 25-28-01-400-802).

SUBTASK 25-24-01-860-005

- (3) Close the circuit breakers for the electrical connectors that mount on the top of the closet [1].

————— END OF TASK —————

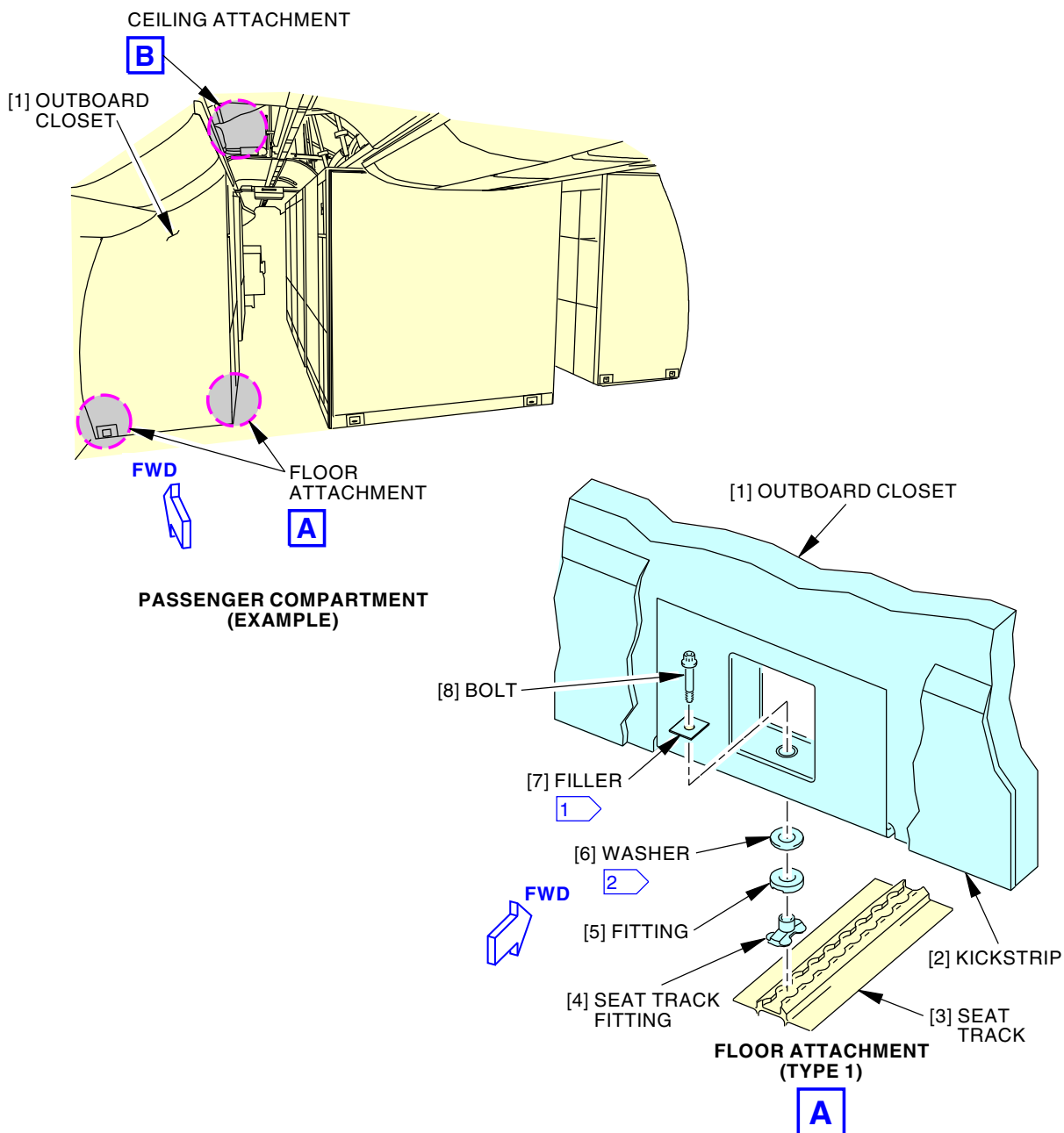
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ARO ALL

25-24-01

D633W101-ARO

Page 408
Jan 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



- 1** SOME CLOSET INSTALLATIONS MAY HAVE A WASHER AT THIS LOCATION.
- 2** WASHERS ARE NORMALLY INSTALLED UNDER THE HEAD OF THE BOLT. THE WASHERS CAN BE INSTALLED BETWEEN THE CLOSET AND THE FITTING TO ELIMINATE GAPS. A TOTAL OF 3 WASHERS ARE REQUIRED.

E05142 S0006408999_V5

**Outboard Closet Installation
Figure 401/25-24-01-990-807 (Sheet 1 of 7)**

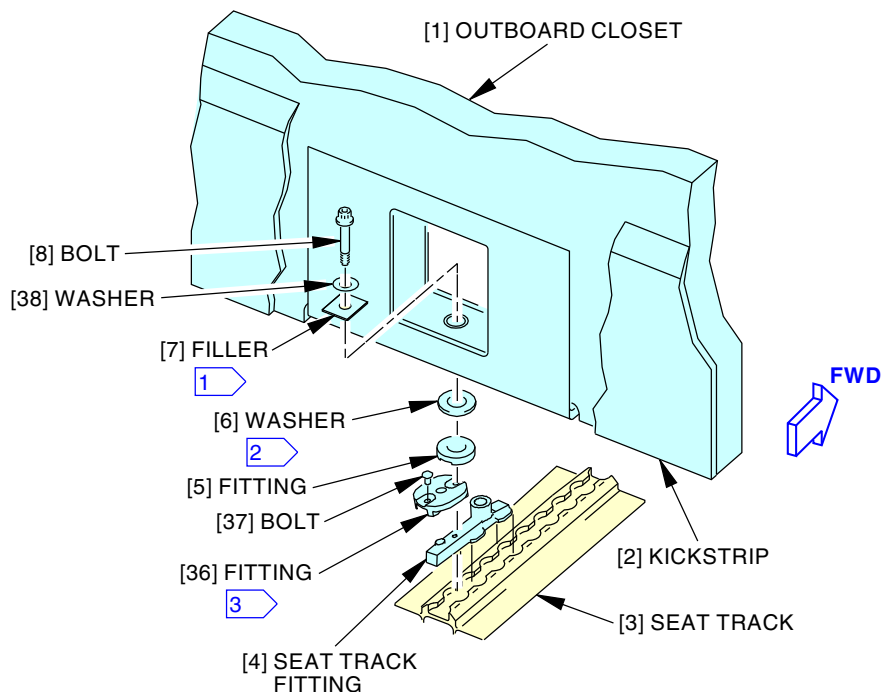
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ARO ALL

25-24-01

D633W101-ARO

Page 409
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



FLOOR ATTACHMENT (TYPE 2)

A

- 1** SOME CLOSET INSTALLATIONS MAY HAVE A WASHER AT THIS LOCATION IN PLACE OF A FILLER.
- 2** WASHERS ARE NORMALLY INSTALLED UNDER THE HEAD OF THE BOLT. THE WASHERS CAN BE INSTALLED BETWEEN THE CLOSET AND THE FITTING TO ELIMINATE GAPS. A TOTAL OF 3 WASHERS ARE REQUIRED.
- 3** FITTING IS NOT SYMMETRICAL AND MAY BE ROTATED 180 DEGREES TO ACCOMMODATE PROPER FIT OF CLOSET ON SEAT TRACKS.

U82789 S0000218783_V2

Outboard Closet Installation
Figure 401/25-24-01-990-807 (Sheet 2 of 7)

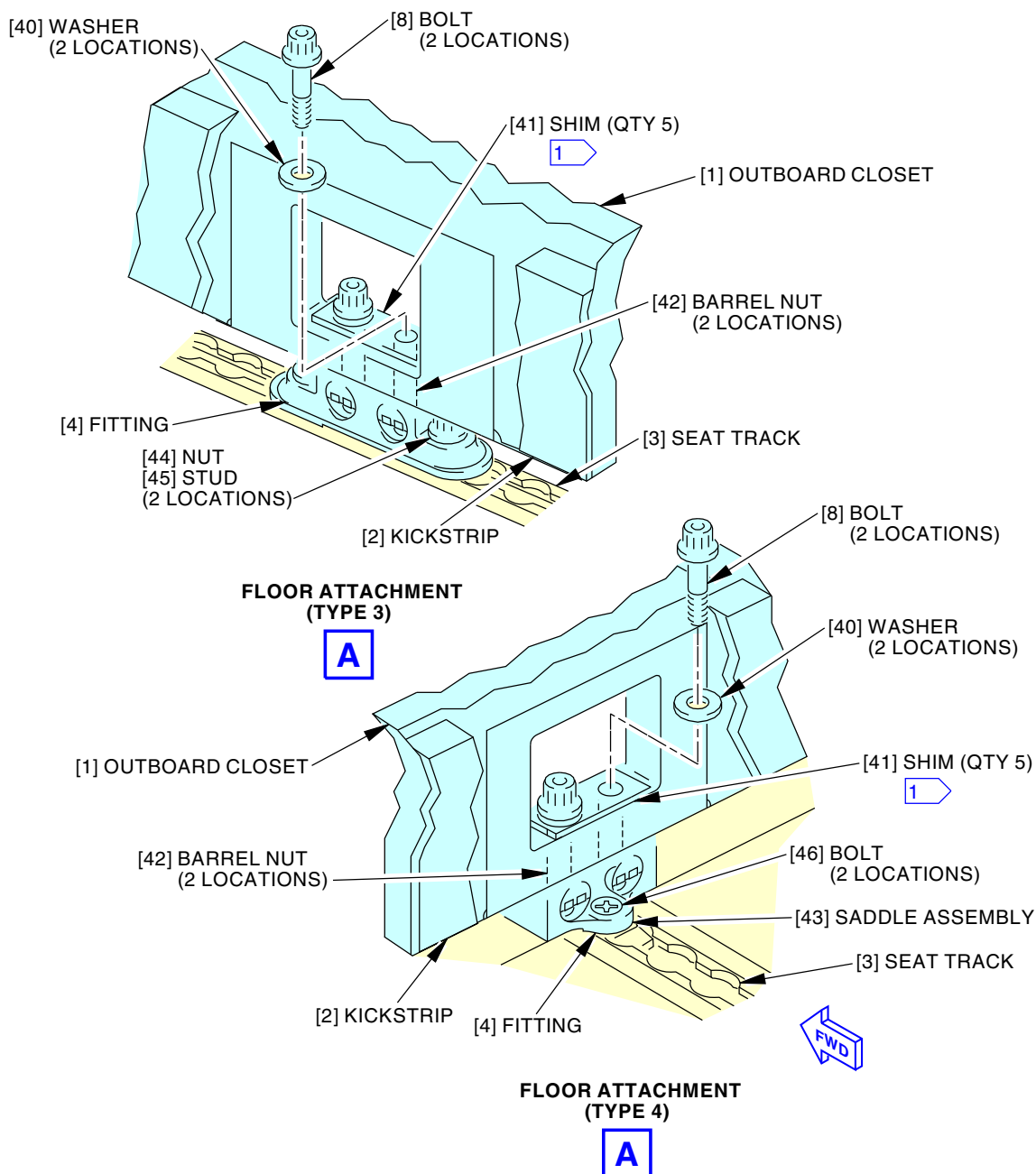
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ARO ALL

25-24-01

D633W101-ARO

Page 410
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



1315660 S0000229981_V2

Outboard Closet Installation
Figure 401/25-24-01-990-807 (Sheet 3 of 7)

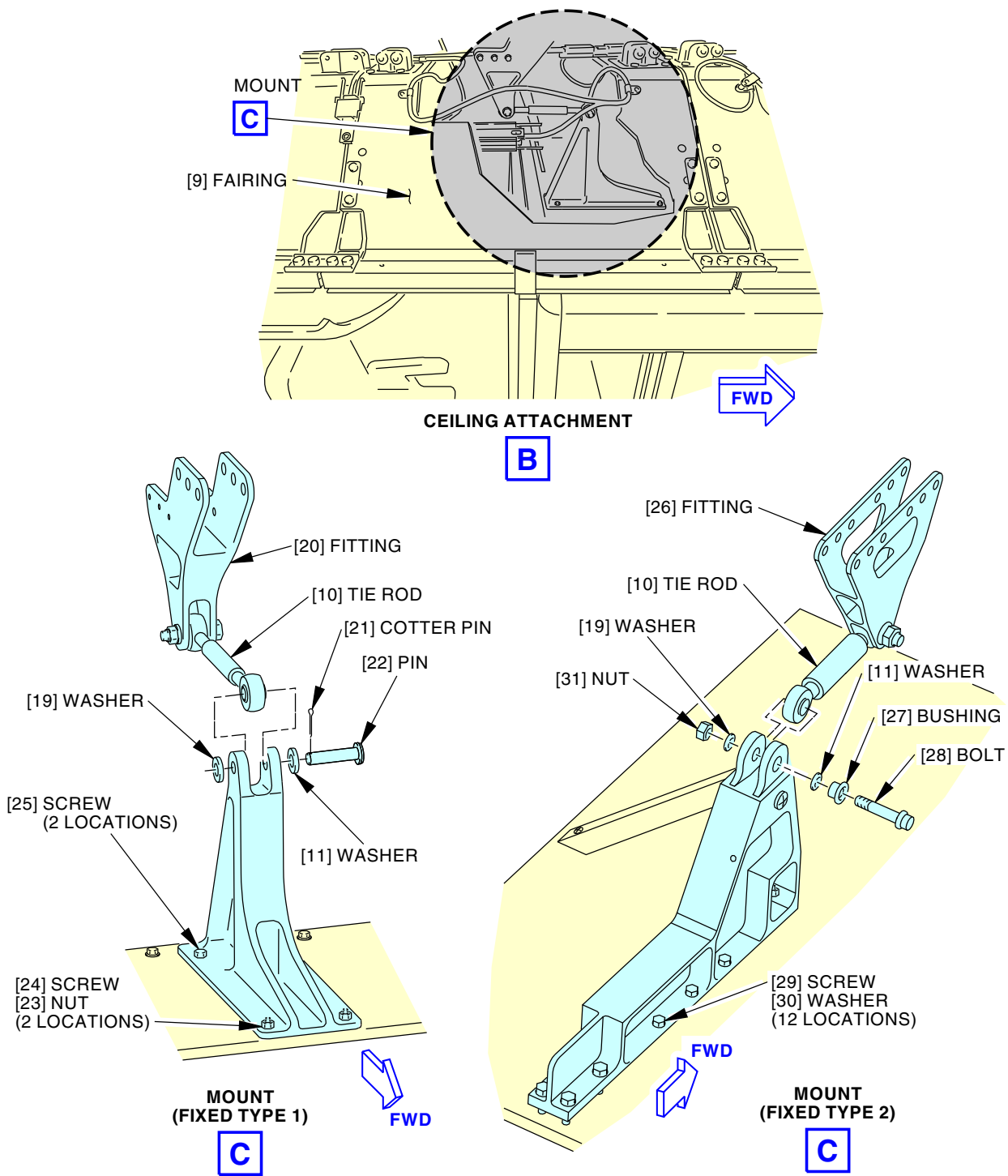
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D633W101-ARO

25-24-01

Page 411
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



W66846 S0000127290_V3

**Outboard Closet Installation
Figure 401/25-24-01-990-807 (Sheet 4 of 7)**

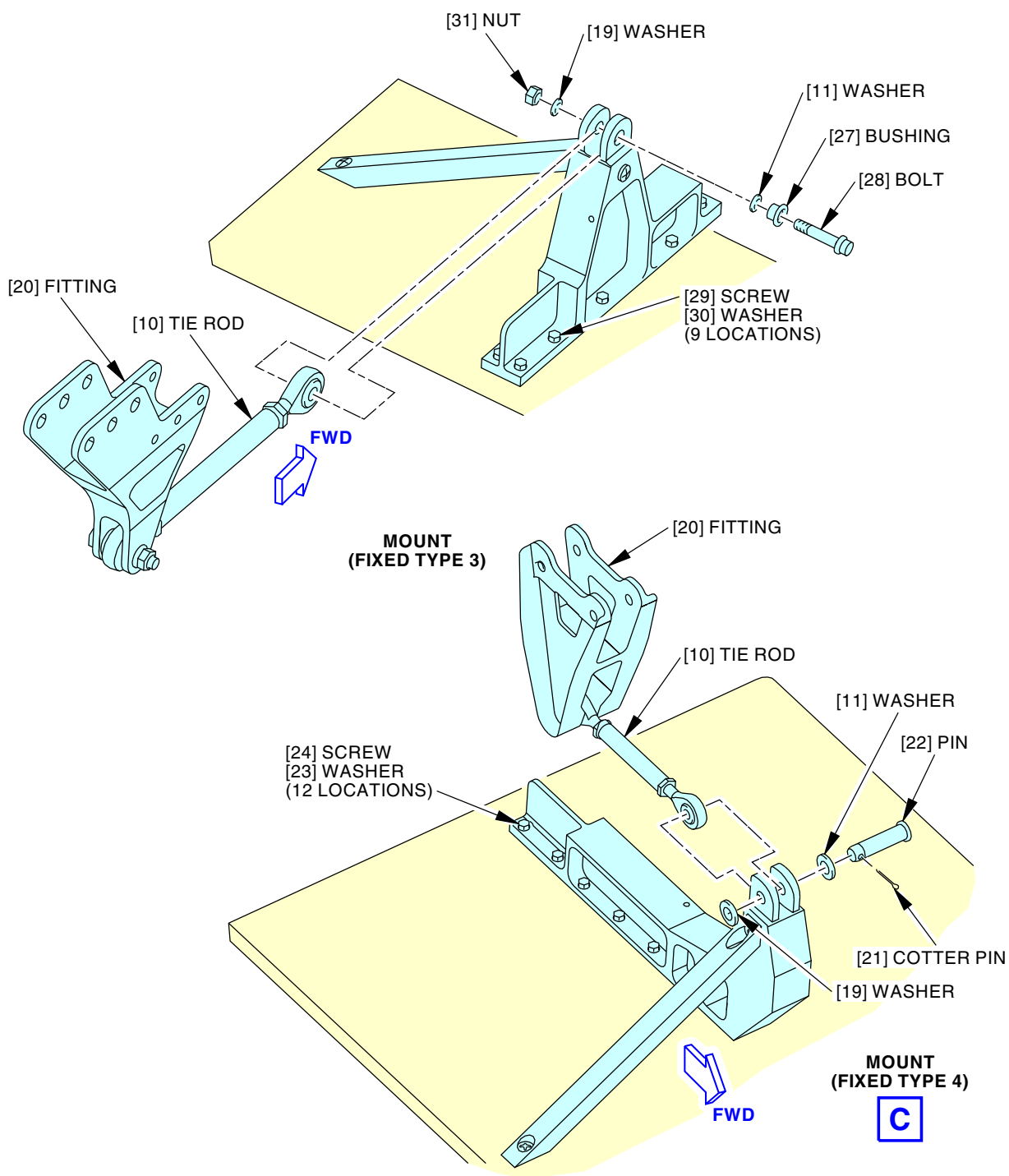
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ARO ALL

25-24-01

D633W101-ARO

Page 412
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



U43007 S0000195466_V2

Outboard Closet Installation
Figure 401/25-24-01-990-807 (Sheet 5 of 7)

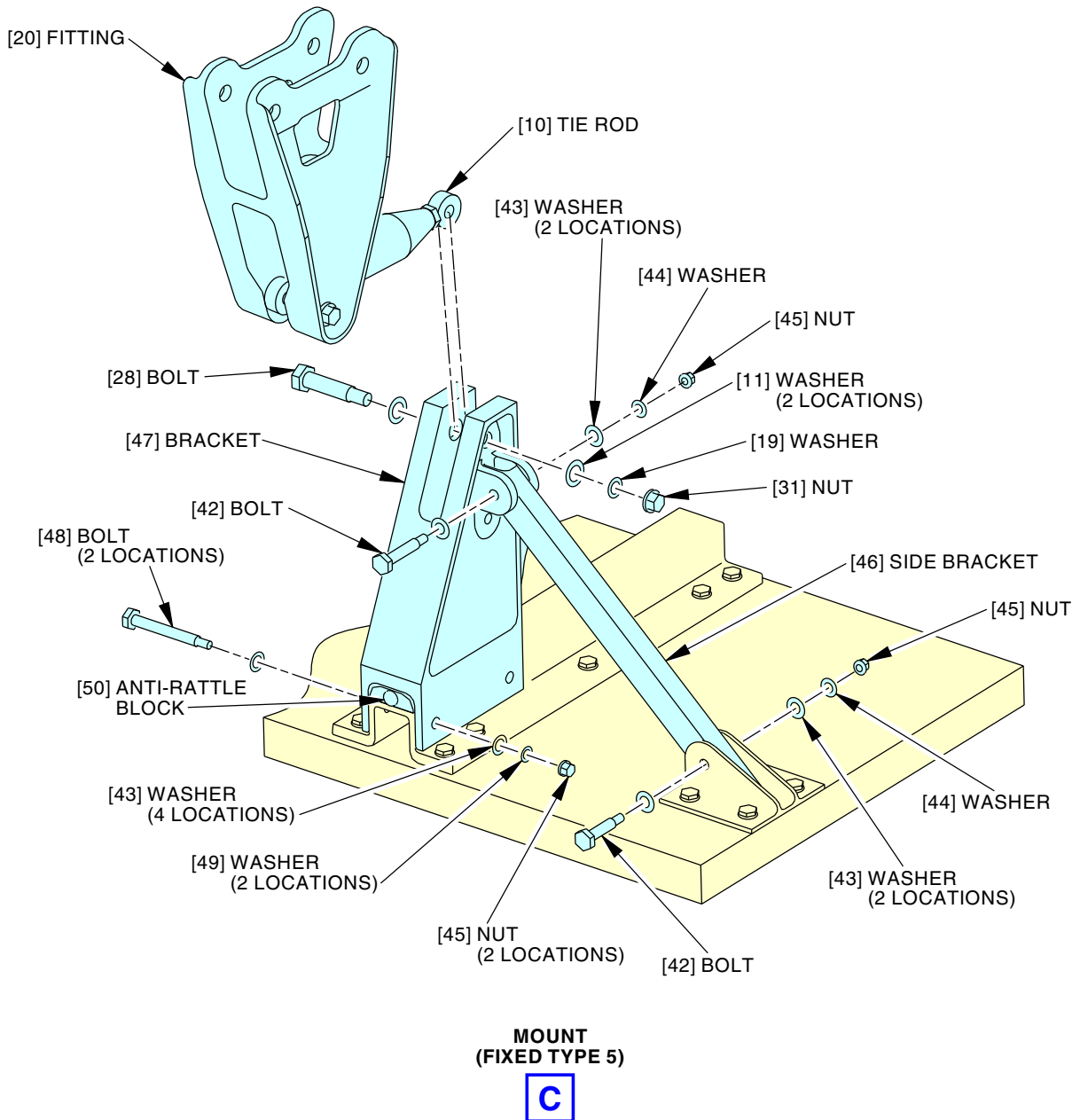
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ARO ALL

25-24-01

D633W101-ARO

Page 413
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



1326052 S0000233590_V2

**Outboard Closet Installation
Figure 401/25-24-01-990-807 (Sheet 6 of 7)**

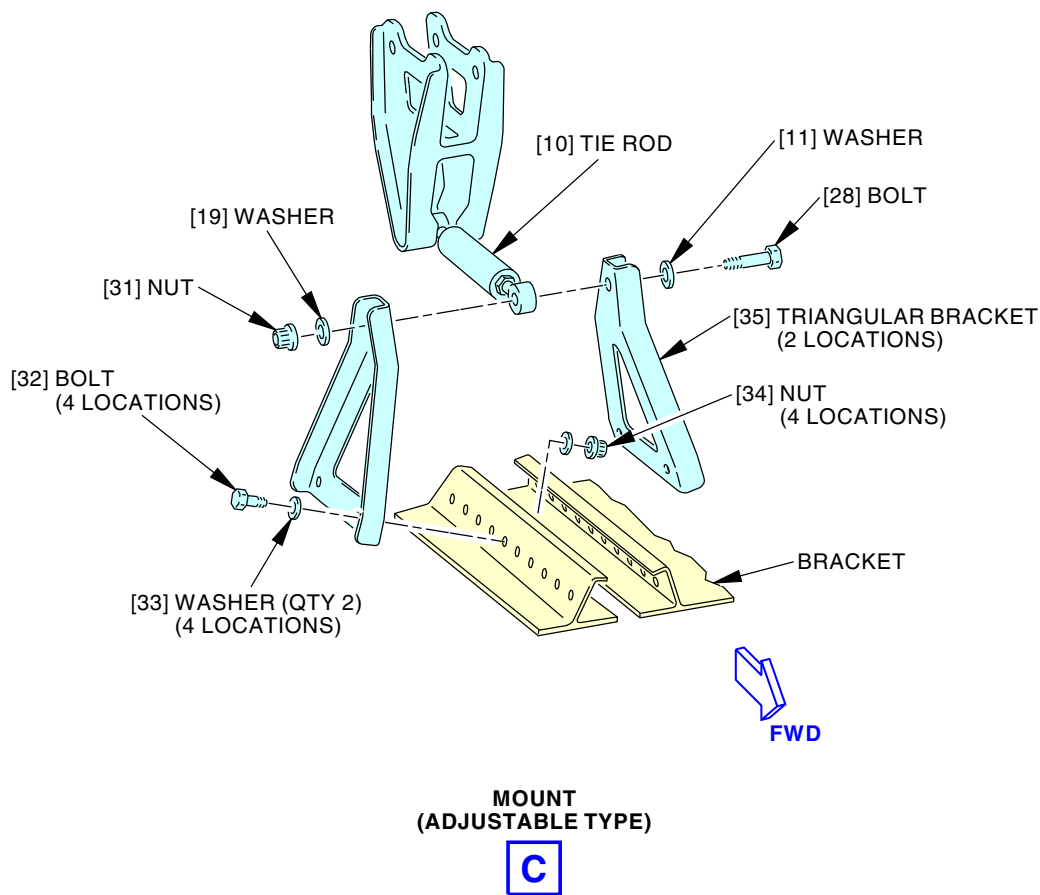
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ARO ALL

25-24-01

D633W101-ARO

Page 414
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



U83031 S0000218784_V2

**Outboard Closet Installation
Figure 401/25-24-01-990-807 (Sheet 7 of 7)**

EFFECTIVITY
ARO ALL

25-24-01

D633W101-ARO

Page 415
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-24-01-000-810

4. **Bulkhead Closet Removal**

Figure 402

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Prepare for the Removal

SUBTASK 25-24-01-860-018

- (1) Open the applicable circuit breakers for the electrical connectors mounted on the top of the closet (if installed).

C. Bulkhead Closet Removal

SUBTASK 25-24-01-010-029

- (1) Do the steps that follow to remove the bulkhead closet [1]:
 - (a) Disconnect the electrical connectors (if installed).
 - (b) Remove the bolts [2], washers [3] and busings [4] that attach the bulkhead closet [1] to the intercostal.
 - (c) Remove the coverplate [5] to get access to the floor attachments for the bulkhead closet [1].
 - (d) Remove the bolts [11] and fillers [10] that attach the bulkhead closet [1] to the seat track fitting [6].
 - (e) Remove the bulkhead closet [1].

NOTE: Keep the bolts [11], fillers [10], washers [9], and fittings [8] for the installation of the bulkhead closet [1].
 - (f) Remove the seat track fitting [6] that follows, if it is necessary:
 - 1) Move the seat track fitting [6] forward or aft approximately 1/2 inch to align it with the circular openings in the seat track [7].
 - 2) Lift the seat track fitting [6] out of the seat track [7].

————— **END OF TASK** —————

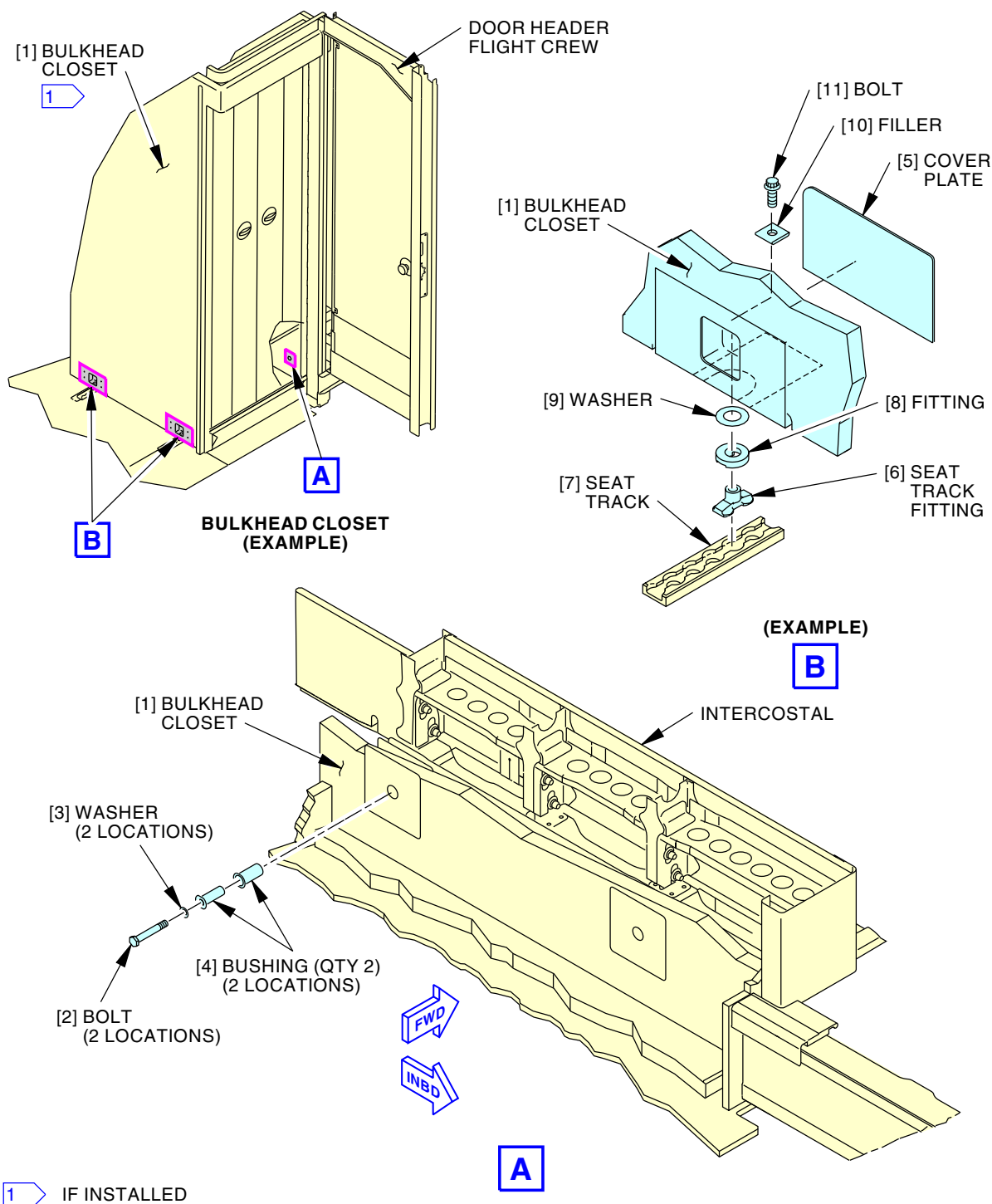
EFFECTIVITY
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D633W101-ARO

25-24-01

Page 416
Jan 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL



2122600 S0000457559_V2

Bulkhead Closet Installation
Figure 402/25-24-01-990-819

EFFECTIVITY
ARO ALL

25-24-01

D633W101-ARO

Page 417
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-24-01-400-811

5. Bulkhead Closet Installation

Figure 402

A. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
G02304	Tape - Moisture Barrier, Adhesive One-side	BMS8-346

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Bulkhead Closet Installation

SUBTASK 25-24-01-420-036

(1) Do the steps that follow to install the bulkhead closet [1]:

(a) Install the seat track fitting [6] that follows, if removed:

- 1) Remove the old moisture barrier tape, G02304 from the wet areas to install the seat track fittings [6].
- 2) Apply new moisture barrier tape, G02304 to the wet areas.
- 3) Put the seat track fitting [6] in the circular opening in the seat track [7].
NOTE: You can trim the seat track fittings [6] to a minimum amount to install the seat track fitting.
- 4) Put corrosion preventive compound, C00308 in the seat track [7] around the seat track fitting [6].

(b) Move the seat track fitting [6] forward or aft approximately 1/2 inch to lock it in the correct position for the installation.

(c) Install the fittings [8] and washers [9] on the seat track fittings [6].

NOTE: The fittings [8] are not symmetrical and can be rotated 180 degrees to accommodate proper fit of the bulkhead closet [1] on the seat track fitting [6].

(d) Align the bulkhead closet [1] with the seat track fittings [6].

(e) Adjust the number of washers [9] to level the bulkhead closet [1].

NOTE: You can use a maximum of three washers for each seat track fitting to level the bulkhead closet [1].

(f) Make sure that the fittings [8] and washers [9] stay between the seat track fittings [6] and the bulkhead closet [1].

(g) Install the filler [10] and bolts [11] down through the bulkhead closet [1] into the seat track fittings [6].

(h) Put corrosion preventive compound, C00308 on the surface of bushings [4].

(i) Install the bolts [2], washers [3] and bushings [4] that attach the bulkhead closet [1] to the intercostal.

NOTE: You can turn the bushings [4] individually to accommodate to the tolerance buildup, if it is necessary.

(j) Install the coverplates [5] on the bottom of the bulkhead closet [1].

EFFECTIVITY
ARO ALL

25-24-01

D633W101-ARO

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Page 418
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(k) Connect the electrical connectors, if installed.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-24-01-410-023

(1) Install the closeout seal to the bulkhead closet [1] with adhesive, A00027.

SUBTASK 25-24-01-860-019

(2) Close the circuit breakers for the electrical connectors that mount on the top of the bulkhead closet [1], if installed.

————— END OF TASK —————

TASK 25-24-01-000-803

6. Centerline Closet Removal

(Figure 403)

A. References

Reference	Title
25-21-06-000-801	Main Ceiling Panel - Removal (P/B 401)
25-25-01-000-801	Passenger Seat - Removal (P/B 401)
25-28-02-000-801	Center Stowage Bin Removal (P/B 401)
25-28-02-000-802	Center Stowage Bin Module Removal (P/B 401)
25-28-02-000-805	Center Stowage Bin Module Removal (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-24-01-000-005

(1) Open the applicable circuit breakers for the electrical connectors mounted on the top of the closet.

SUBTASK 25-24-01-010-008

(2) Do the applicable tasks that follow if it is necessary to get access to the closet:

- (a) Main Ceiling Panel Removal TASK 25-21-06-000-801.
- (b) Passenger Seat Removal TASK 25-25-01-000-801.
- (c) Center Stowage Bin Module Removal, TASK 25-28-02-000-802 or Center Stowage Bin Module Removal, TASK 25-28-02-000-805 or Center Stowage Bin Removal, TASK 25-28-02-000-801.

SUBTASK 25-24-01-010-009

(3) Remove the closeout seal [42] from the top and sides of the closet [41].

D. Centerline Closet Removal

SUBTASK 25-24-01-020-034

(1) Do the steps that follow to disconnect the top of the centerline closet [41]:

- (a) For Type 1 Mount, do these steps:
 - 1) Disconnect the electrical connector if it is necessary.
 - 2) Remove the pin [54], washers [52], [53], and [58], and cotter pin [59] to disconnect the tie rods [43] from the fittings [57] on the top of the closet [41].

EFFECTIVITY
ARO ALL

25-24-01

D633W101-ARO

Page 419
May 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 3) Lift the tie rods [43] out of the fittings [57] and attach them to the structure temporarily to get them out of the way.
- 4) Remove the nuts [55] and screws [56] to disconnect the fittings [57] from the top of the closet [41].

NOTE: Open the closet top door to gain access to the underside of the top attachment bracket.

(b) For Type 2 & Type 3 Mounts, do these steps:

- 1) Disconnect the electrical connector if it is necessary.
- 2) Remove the pin [54], washers [52], [53], and [58], and cotter pin [59] to disconnect the tie rods [43] from the fittings [57] on the top of the closet [41].
- 3) Lift the tie rods [43] out of the fittings [57] and attach them to the structure temporarily to get them out of the way.
- 4) Remove the bolts [55] and washers [56] to disconnect the fittings [57] from the top of the closet [41].

(c) For Type 4 Mounts, do these steps:

- 1) Disconnect the electrical connector if it is necessary.
- 2) Remove the pin [54], washers [53], [58] and cotter pin [59] to disconnect the tie rods [43] from the fittings [57] on the top of the closet [41].
- 3) Lift the tie rods [43] out of the fittings [57] and attach them to the structure temporarily to get them out of the way.
- 4) Remove the bolts [55] and washers [56] to disconnect the fittings [57] from the top of the closet [41].

SUBTASK 25-24-01-010-010

- (2) Remove the coverplates or kickstrip [2] to get access to the floor attachments for the closet [41].

SUBTASK 25-24-01-020-036

- (3) Remove the bolts [31], washers [32] and bushings [36] that attach the closet [41] to the seat track fitting [35].

SUBTASK 25-24-01-020-037

- (4) Do these steps if it is necessary to remove the seat track fitting [35]:
 - (a) Loosen the screws [33] that attach the seat track fitting [35] to the seat track [34].
 - (b) Move the seat track fitting [35] forward or aft approximately 1/2 inch to align it with the circular openings in the seat track [34].
 - (c) Lift the seat track fitting [35] out of the seat track [34].

SUBTASK 25-24-01-020-013

- (5) Remove the closet [41].

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-24-01

D633W101-ARO

Page 420
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-24-01-400-807

7. Centerline Closet Installation

(Figure 403)

A. References

Reference	Title
25-21-06-400-801	Main Ceiling Panel - Installation (P/B 401)
25-25-01-400-801	Passenger Seat - Installation (P/B 401)
25-28-02-400-801	Center Stowage Bin Installation (P/B 401)
25-28-02-400-802	Center Stowage Bin Module Installation (P/B 401)
25-28-02-400-805	Center Stowage Bin Module Installation (P/B 401)
33-22-00-710-801	Passenger Loading Lights - Operational Test (P/B 501)

B. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
G02304	Tape - Moisture Barrier, Adhesive One-side	BMS8-346

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Centerline Closet Installation

SUBTASK 25-24-01-420-029

- (1) Do these steps if it is necessary to install the seat track fitting [35]:
 - (a) Remove the old moisture barrier tape, G02304 from the wet areas to install the seat track fitting [35].
 - (b) Put the seat track fitting [35] into the circular opening in the seat track [34].
 - (c) Move the seat track fitting [35] forward or aft 1/2 inch to lock it in the correct position for the installation.
 - (d) Tighten the screws [33] on the seat track fittings [35] to 63 +12 / -13 in-lb (7 +1 / -2 N·m).
 - (e) Do these steps in the wet areas to prevent corrosion:
 - 1) Put corrosion preventive compound, C00308 in the seat track [34] around the seat track fitting [35].
 - 2) Apply new moisture barrier tape, G02304 with a cutout for the seat track fittings [35] if it is necessary.

SUBTASK 25-24-01-820-013

- (2) Align the closet [41] with the seat track fittings [4].

SUBTASK 25-24-01-420-030

- (3) Do these steps to connect the closet [41] to the seat track fittings [35]:
 - (a) Align the closet [41] to the seat track fittings [35].
 - (b) Install the bolts [31], washers [32] and the bushing [36] down through the closet [41] into the seat track fittings [35].

SUBTASK 25-24-01-410-019

- (4) Install the coverplates or kickstrip [2] on the bottom of the closet [41].

EFFECTIVITY
ARO ALL

25-24-01

D633W101-ARO

Page 421
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-24-01-020-032

- (5) Do the steps that follow to attach the top of the centerline closet [41] to the tie rod [43]:
- Install the bolts [49], washers [47] and [48], and nuts [46] to attach the brackets [45] to the top of the closet [41].
 - Lower the tie rods [43].
NOTE: In the removal task, the tie rods [43] were attached to the structure to keep them out of the way.
 - Adjust the length of the tie rods [43] to align them with the brackets [45].
 - Install the bolts [50], washers [47] and [48], and nuts [46] to attach the tie rods [43] to the brackets [45] on the top of the closet [41].
 - Connect the electrical connectors [44].

SUBTASK 25-24-01-420-031

- (6) Do the steps that follow to attach the top of the centerline closet [41]:
- For Type 1 Mount, do these steps:
 - Install the nuts [55] and screws [56] to attach the fittings [57] to the top of the closet [41].
NOTE: Open the closet top door to gain access to the underside of the top attachment bracket.
 - Lower the tie rods [43].
NOTE: In the removal task, the tie rods [43] were attached to the structure to keep them out of the way.
 - Adjust the length of the tie rods [43] to align them with the brackets [57].
 - Install the pin [54], washers [52], [53], and [58], and cotter pin [59] to attach the tie rods [43] to the brackets [57] on the top of the closet [41].
 - Connect the electrical connector if it is necessary.
 - For Type 2 & Type 3 Mounts, do these steps:
 - Install the bolts [55] and washers [56] to attach the fittings [57] to the top of the closet [41].
 - Lower the tie rods [43].
NOTE: In the removal task, the tie rods [43] were attached to the structure to keep them out of the way.
 - Adjust the length of the tie rods [43] to align them with the brackets [57].
 - Install the pin [54], washers [52], [53], and [58], and cotter pin [59] to attach the tie rods [43] to the brackets [57] on the top of the closet [41].
 - Connect the electrical connector if it is necessary.
 - For Type 4 Mounts, do these steps:
 - Install the bolts [55] and washers [56] to attach the fittings [57] to the top of the closet [41].
 - Lower the tie rods [43].
NOTE: In the removal task, the tie rods [43] were attached to the structure to keep them out of the way.
 - Adjust the length of the tie rods [43] to align them with the brackets [57].

EFFECTIVITY
ARO ALL

25-24-01

D633W101-ARO

Page 422
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- 4) Install the pin [54], washers [53], [58], and cotter pin [59] to attach the tie rods [43] to the brackets [57] on the top of the closet [41].
- 5) Connect the electrical connector if it is necessary.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-24-01-410-020

- (1) Install the closeout seal [42] on the top and sides of the closet [41] with adhesive, A00027.

SUBTASK 25-24-01-410-021

- (2) Do the applicable tasks that follow:
 - (a) Main Ceiling Panel Installation TASK 25-21-06-400-801.
 - (b) Passenger Seat Installation TASK 25-25-01-400-801.
 - (c) Center Stowage Bin Module Installation Center Stowage Bin Module Installation, TASK 25-28-02-400-805 or Center Stowage Bin Installation, TASK 25-28-02-400-801 or Center Stowage Bin Module Installation, TASK 25-28-02-400-802.

SUBTASK 25-24-01-860-013

- (3) Close the circuit breakers for the electrical connectors that mount on the top of the closet [41].

SUBTASK 25-24-01-710-007

- (4) Do this task: TASK 33-22-00-710-801.

———— **END OF TASK** ————

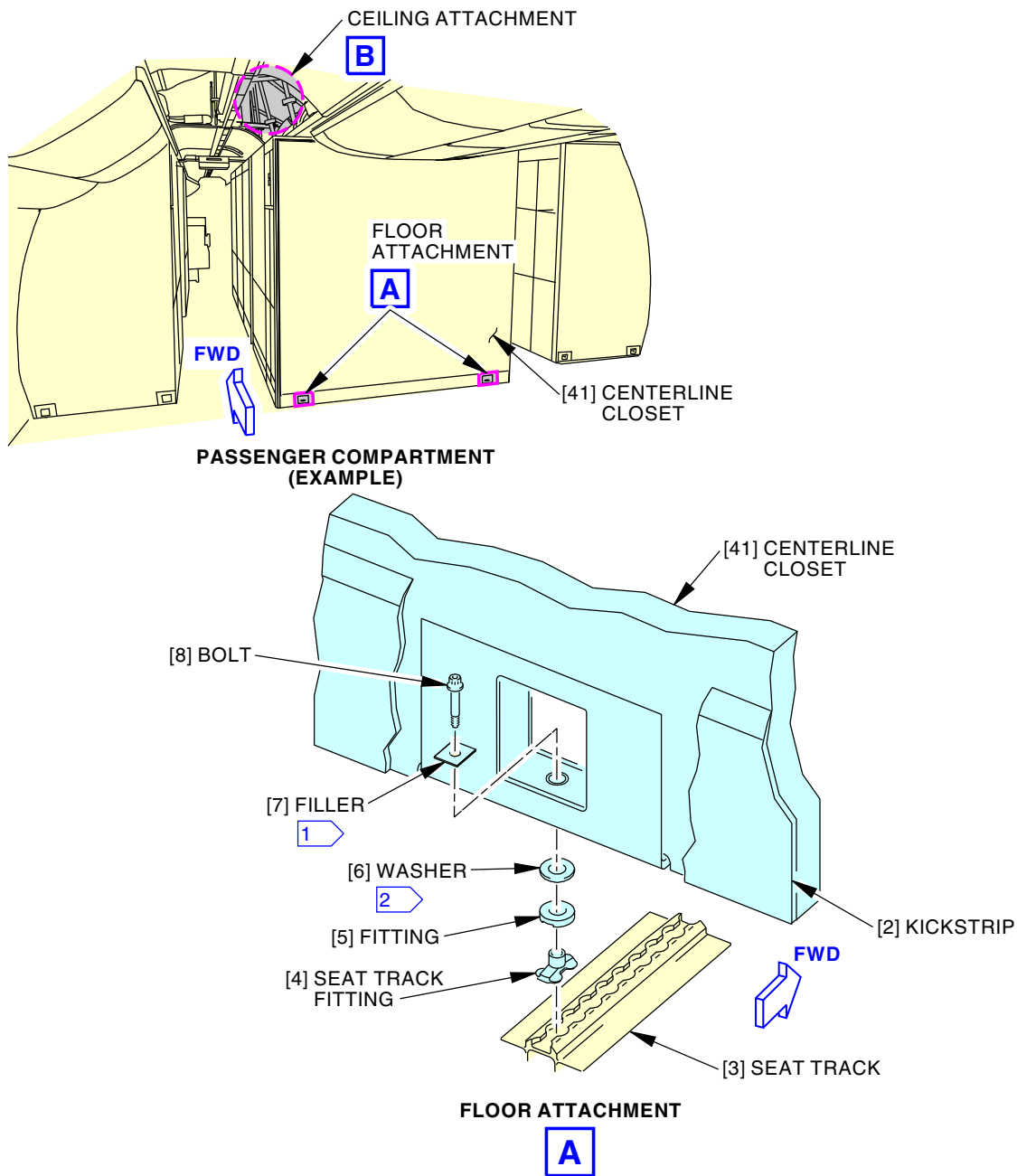
EFFECTIVITY
ARO ALL

25-24-01

D633W101-ARO

Page 423
Jan 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL



- 1 SOME CLOSET INSTALLATIONS MAY HAVE A WASHER AT THIS LOCATION IN PLACE OF A FILLER.
- 2 WASHERS ARE NORMALLY INSTALLED UNDER THE HEAD OF THE BOLT. THE WASHERS CAN BE INSTALLED BETWEEN THE CLOSET AND THE FITTING TO ELIMINATE GAPS. A TOTAL OF 3 WASHERS ARE REQUIRED.

E04934 S0006409002_V3

Centerline Closet Installation
Figure 403/25-24-01-990-808 (Sheet 1 of 6)

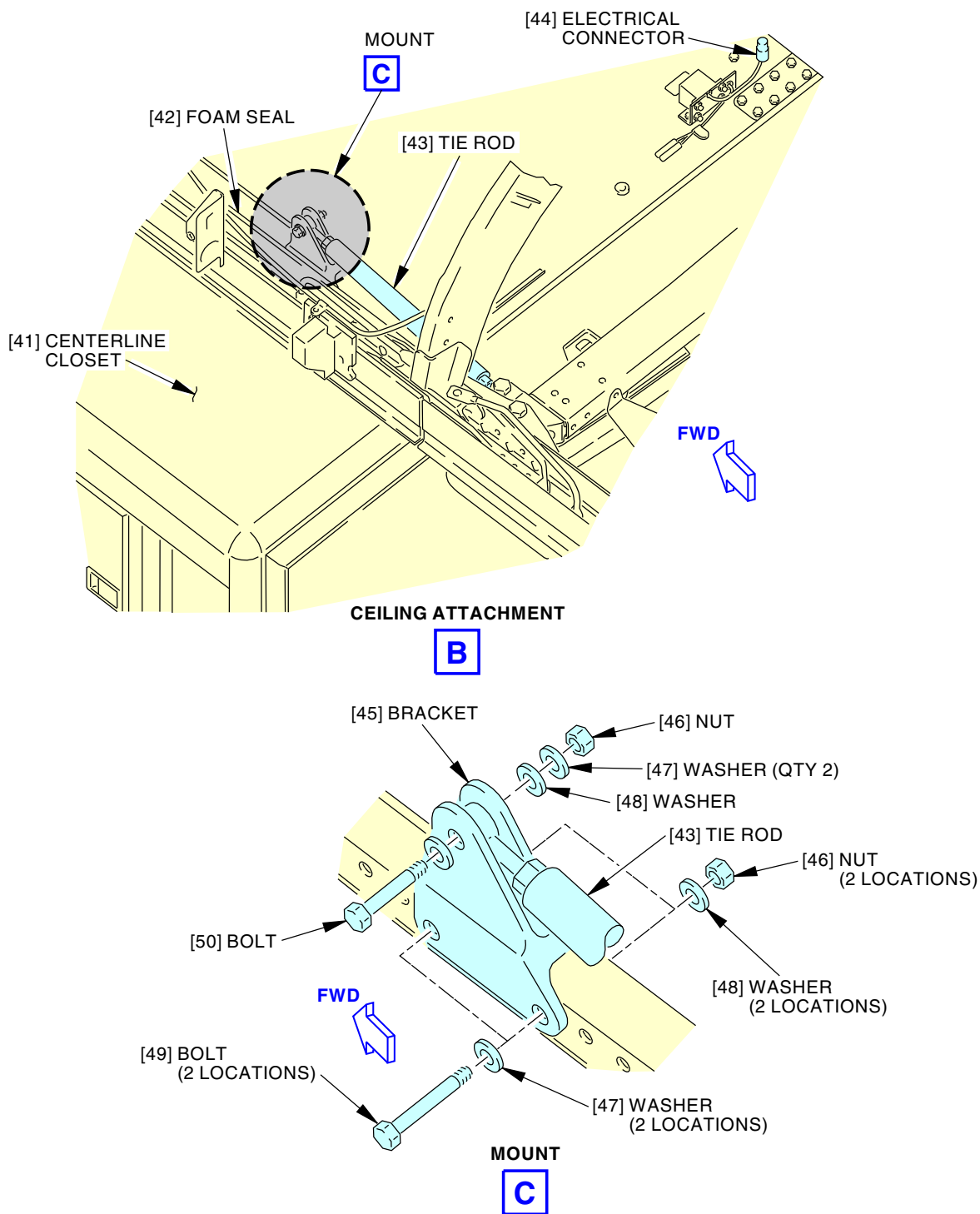
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ARO ALL

25-24-01

D633W101-ARO

Page 424
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



E04968 S0006409003_V2

Centerline Closet Installation
Figure 403/25-24-01-990-808 (Sheet 2 of 6)

EFFECTIVITY
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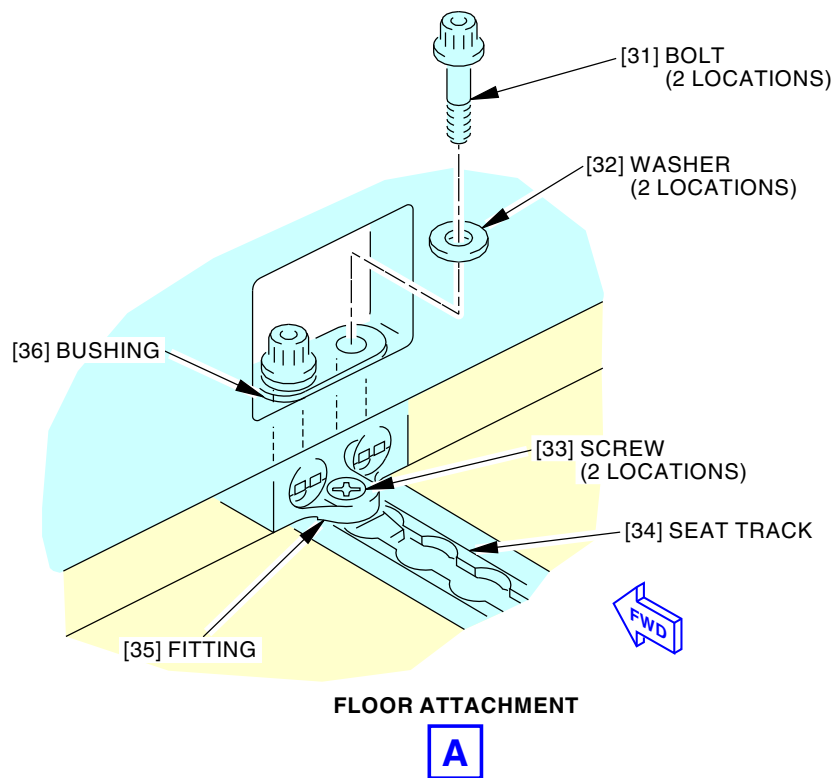
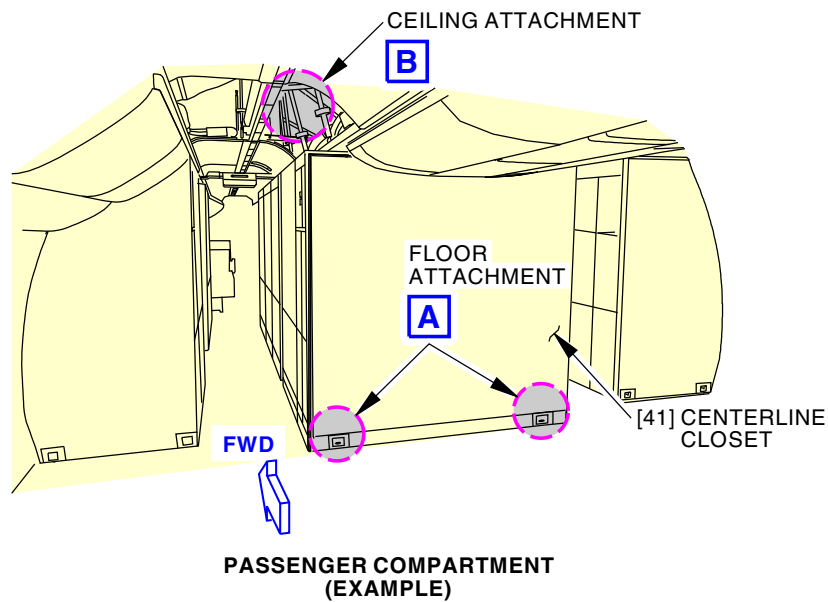
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D633W101-ARO

Page 425
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



W65254 S0000127328_V2

Centerline Closet Installation
Figure 403/25-24-01-990-808 (Sheet 3 of 6)

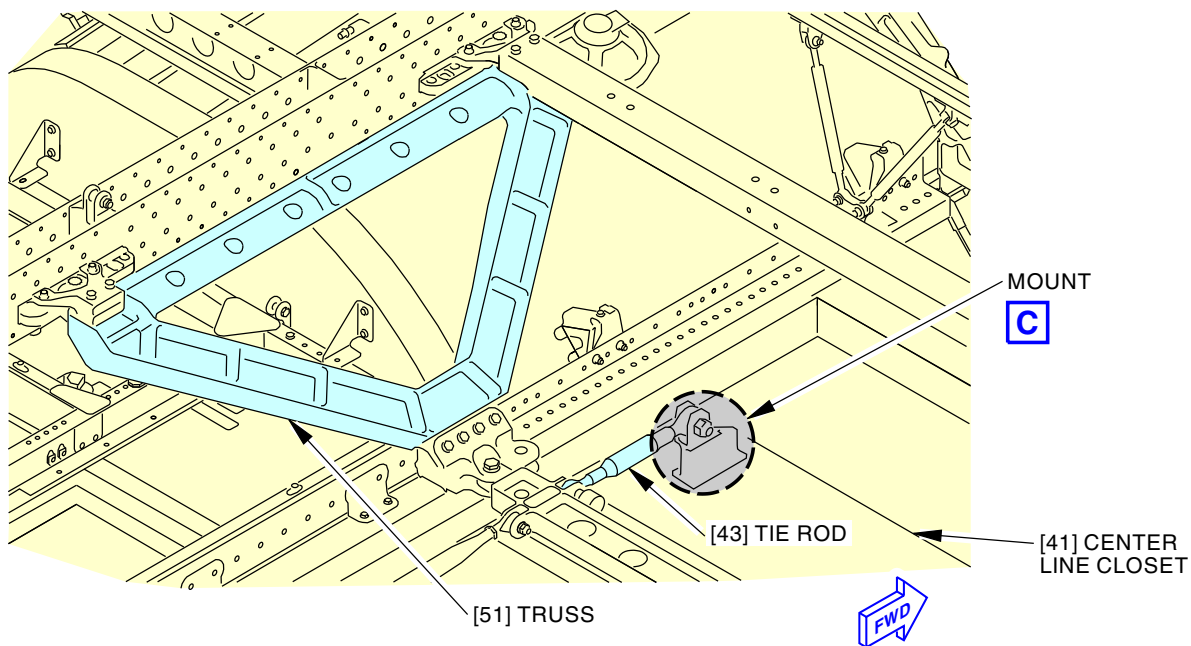
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25-24-01

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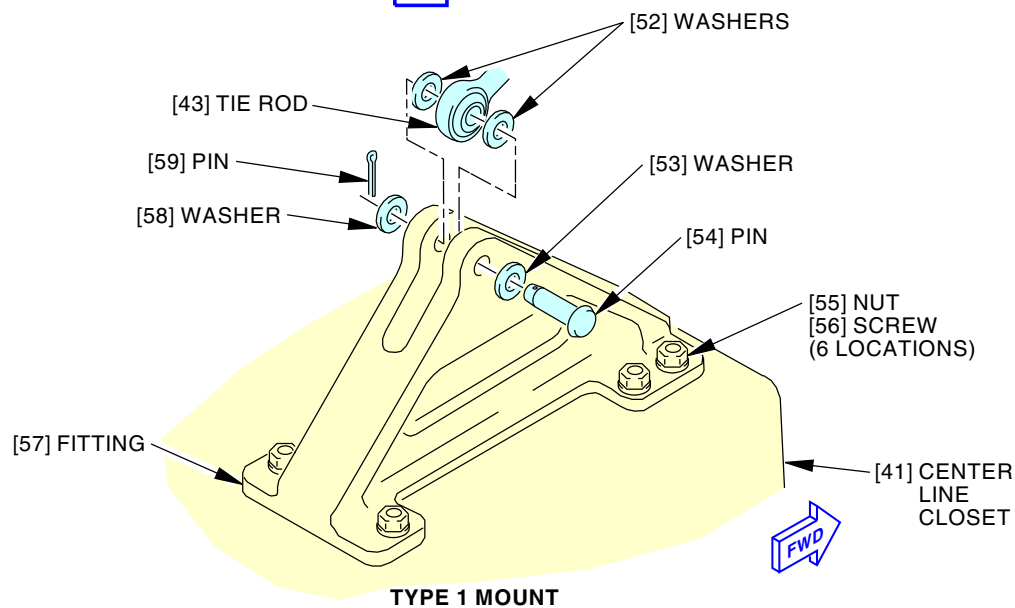
Page 426
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**CEILING ATTACHMENT
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)**

[B]



TYPE 1 MOUNT

[C]

W66617 S0000127330_V3

**Centerline Closet Installation
Figure 403/25-24-01-990-808 (Sheet 4 of 6)**

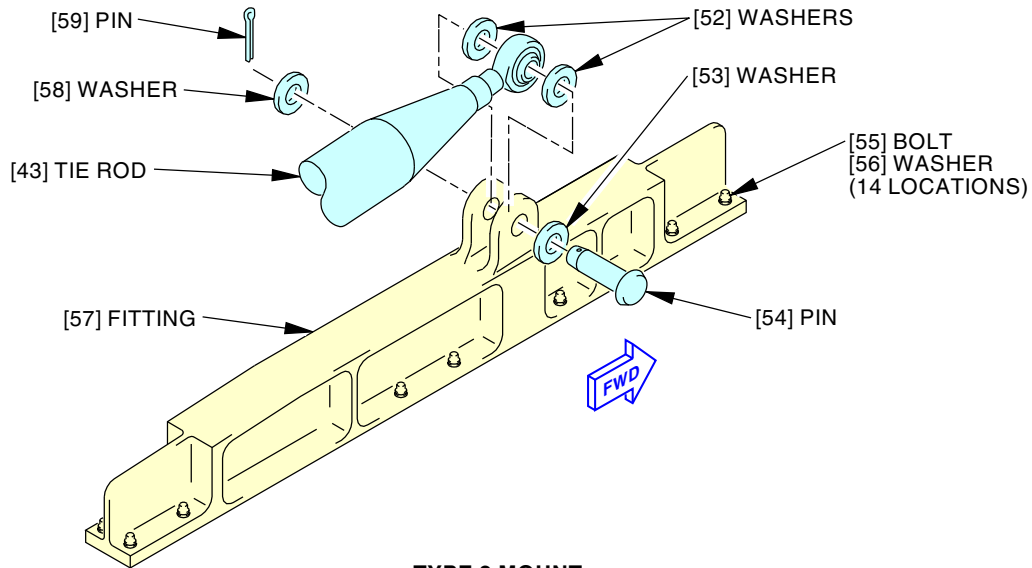
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25-24-01

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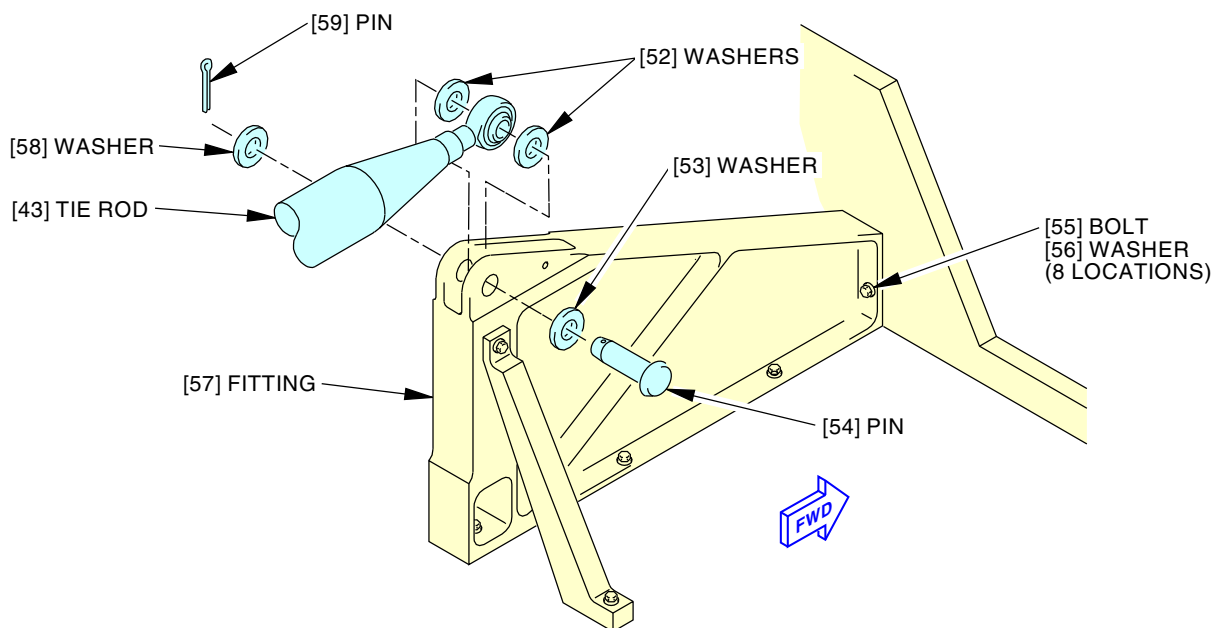
Page 427
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



TYPE 2 MOUNT

C



TYPE 3 MOUNT

C

U42367 S0000195689_V2

**Centerline Closet Installation
Figure 403/25-24-01-990-808 (Sheet 5 of 6)**

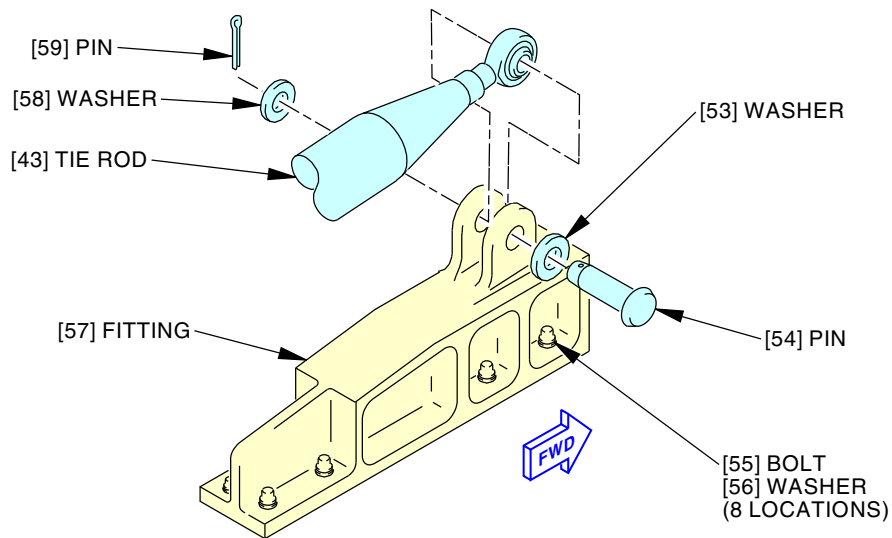
EFFECTIVITY
ARO ALL

25-24-01

D633W101-ARO

Page 428
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



TYPE 4 MOUNT

C

1317029 S0000230833_V2

Centerline Closet Installation
Figure 403/25-24-01-990-808 (Sheet 6 of 6)

EFFECTIVITY
ARO ALL

25-24-01

D633W101-ARO

Page 429
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

UNDERBIN CLOSETS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Removal of the Outboard Underbin Closet
 - (2) Installation of the Outboard Underbin Closet

TASK 25-24-03-000-801

2. Outboard Underbin Closet Removal

Figure 401

A. References

Reference	Title
25-23-01-410-801	Passenger Service Unit (PSU) Closing (P/B 201)
25-25-01-000-801	Passenger Seat - Removal (P/B 401)
25-28-01-000-802	Outboard Stowage Bin Module Removal (P/B 401)
25-28-05-000-801	Floor-Mounted Stowage Box Removal (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-24-03-860-001

- (1) Open the applicable circuit breakers for the electrical connector [11] mounted on the top of the closet [1].

SUBTASK 25-24-03-010-001

- (2) If necessary, remove the closeout seal from the top and sides of the closet [1].

SUBTASK 25-24-03-010-002

- (3) Do the applicable tasks that follow if it is necessary to get access to the closet [1]:
 - (a) Passenger Seat Removal (TASK 25-25-01-000-801).
 - (b) Passenger Service Unit Opening (TASK 25-23-01-410-801).
 - (c) Outboard Stowage Bin Removal (TASK 25-28-01-000-802).
 - (d) Floor Mounted Stowage Box Removal (TASK 25-28-05-000-801).

D. Outboard Closet Removal

SUBTASK 25-24-03-020-001

- (1) Do the steps that follow to disconnect the top of the closet [1]:
 - (a) Disconnect the electrical connector [11].

SUBTASK 25-24-03-010-003

- (2) Remove the coverplate [4] or kickstrip to get access to the floor attachments for the closet [1].

SUBTASK 25-24-03-020-002

- (3) Remove the bolt [2], the filler [3], the washer [10], and the fitting [9].

SUBTASK 25-24-03-010-007

- (4) Remove the screw [5] and fitting [6].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-24-03

Page 401
May 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-24-03-020-003

- (5) Carefully remove the closet [1].

SUBTASK 25-24-03-020-004

- (6) Keep the bolt [2], filler [3], washer [10], fitting [9], screw [5], fitting [6] and the seat track fitting [7] for the installation of the closet [1].

SUBTASK 25-24-03-020-005

- (7) Do these steps, if it is necessary, to remove the seat track fitting [7]:
- (a) Move the seat track fitting [7] forward or aft approximately 1/2 inch to align it with the circular openings in the seat track [8].
 - (b) Lift the seat track fitting [7] out of the seat track.

————— **END OF TASK** —————

TASK 25-24-03-400-801

3. Outboard Underbin Closet Installation

Figure 401

A. References

Reference	Title
25-25-01-400-801	Passenger Seat - Installation (P/B 401)
25-28-01-400-802	Outboard Stowage Bin Module Installation (P/B 401)
25-28-05-400-801	Floor-Mounted Stowage Box - Installation (P/B 401)
33-22-00-710-801	Passenger Loading Lights - Operational Test (P/B 501)

B. Consumable Materials

Reference	Description	Specification
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
G02304	Tape - Moisture Barrier, Adhesive One-side	BMS8-346

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Outboard Closet Installation

SUBTASK 25-24-03-420-001

- (1) Do these steps if it is necessary to install the seat track fittings [7]:
- (a) Remove the old moisture barrier tape, G02304 from the wet areas to install the seat track fitting [7].
 - (b) Put the seat track fitting [7] in the circular opening in the seat track.
 - (c) Move the seat track fitting [7] forward or aft 1/2 inch to lock it in the correct position for the installation.
 - (d) Do these steps in the wet areas to prevent corrosion:
 - 1) Put corrosion preventive compound, C00308 in the seat track around the seat track fitting [7]
 - 2) Apply new moisture barrier tape, G02304 with a cutout for the seat track fitting [7] if it is necessary.

EFFECTIVITY
ARO ALL

25-24-03

D633W101-ARO

Page 402
May 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-24-03-400-001

- (2) Install the screw [5] and fitting [6] into the seat track fitting [7].

SUBTASK 25-24-03-420-002

- (3) Install the fitting [9], the washer [10], the filler [3], and the bolt [2] on the seat track fitting [7].
 - (a) Turn the fitting [9] until the closet [1] attaches to the seat track [8] correctly.

NOTE: The fittings [9] are not symmetrical.

SUBTASK 25-24-03-820-001

- (4) Align the closet [1] with the seat track fittings [7].

SUBTASK 25-24-03-820-002

- (5) Adjust the number of washers [10] to make the closet [1] level.

NOTE: You can use a maximum of three washers at each floor attach point.

SUBTASK 25-24-03-210-001

- (6) Make sure the fitting [6] and screw [5] stay between the seat track fitting [7] and the closet [1].

SUBTASK 25-24-03-420-003

- (7) Install the filler [3] and the bolts [2] down through the closet [1] into the seat track fitting [7].

SUBTASK 25-24-03-410-001

- (8) Install the coverplate [4] or kickstrip on the bottom of the closet [1].

SUBTASK 25-24-03-420-004

- (9) Connect the electrical connector [11].

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-24-03-410-002

- (1) If necessary, install the closeout seal on the top and outboard sides of the closet [1].

SUBTASK 25-24-03-410-003

- (2) Do the applicable tasks that follow:
 - (a) Passenger Seat Installation (TASK 25-25-01-400-801).
 - (b) Outboard Stowage Bin Module Installation (TASK 25-28-01-400-802).
 - (c) Floor Mounted Stowage Box Installation (TASK 25-28-05-400-801).

SUBTASK 25-24-03-860-003

- (3) Close the circuit breakers for the electrical connectors [11] that mount on the top of the closet [1].

SUBTASK 25-24-03-710-001

- (4) Do the test for the closet lights in this task: Passenger Loading Lights - Operational Test (TASK 33-22-00-710-801).

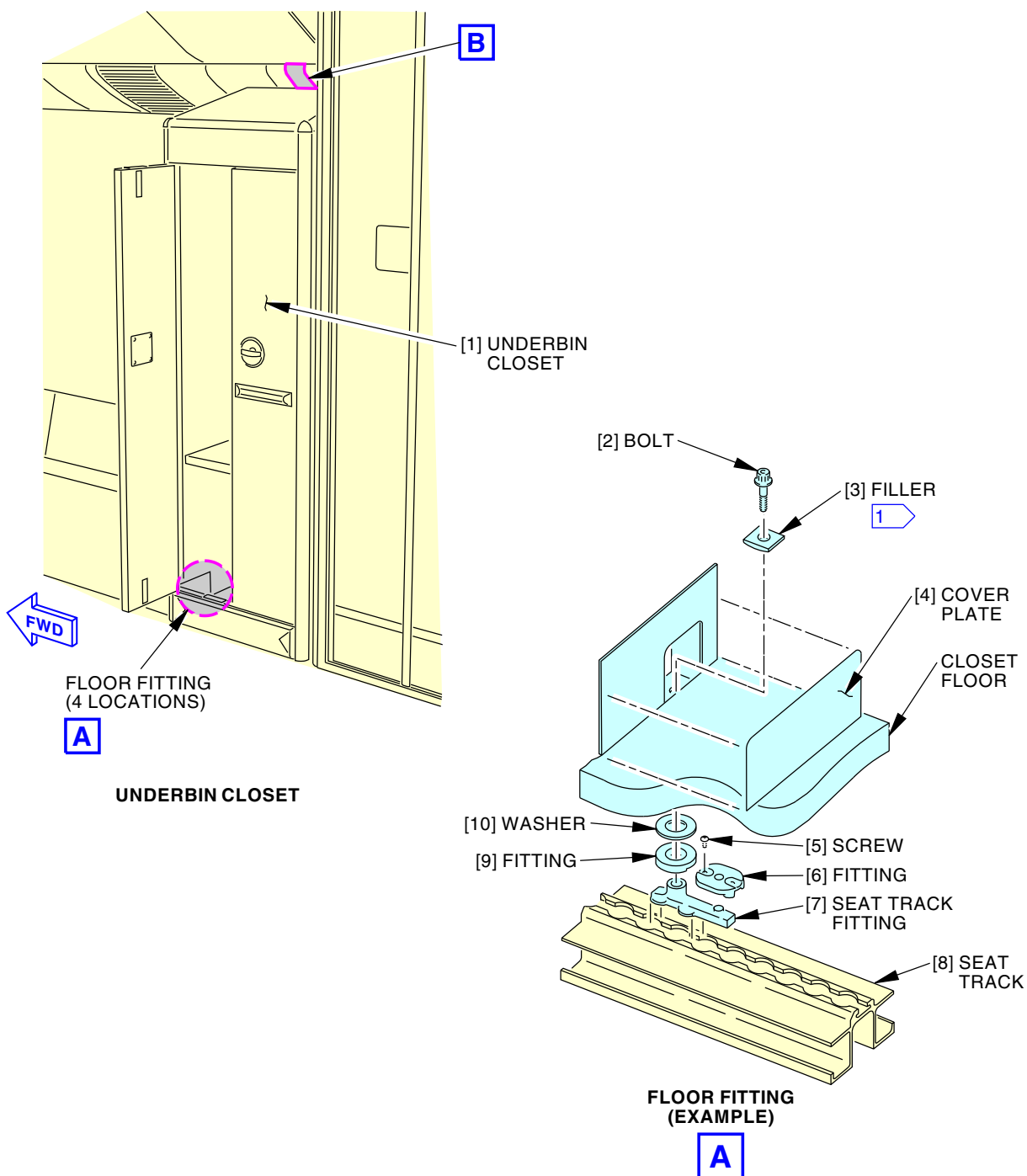
————— END OF TASK —————

EFFECTIVITY
ARO ALL

25-24-03

D633W101-ARO

Page 403
May 05/2016



1 SOME CLOSET INSTALLATIONS MAY HAVE A WASHER AT THIS LOCATION.

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**Underbin Closet Installation
Figure 401/25-24-03-990-803 (Sheet 1 of 2)**

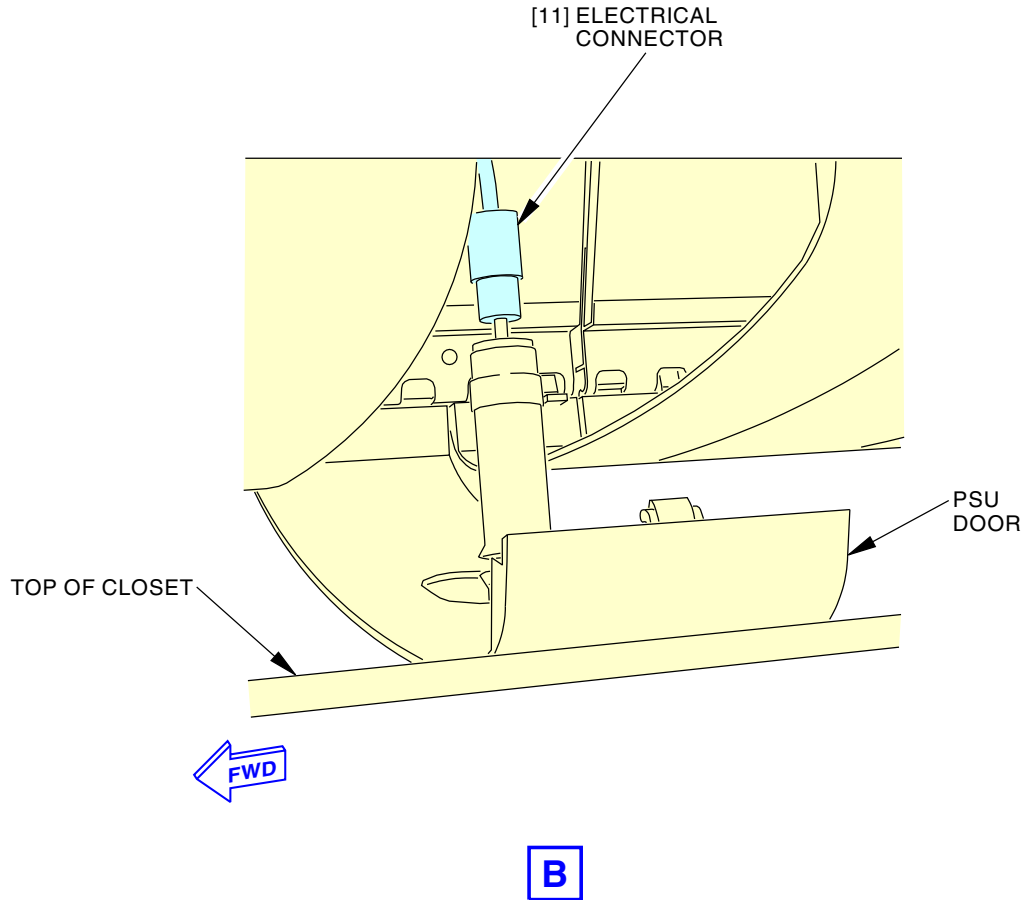
EFFECTIVITY
ARO ALL

D633W101-ARO

25-24-03

Page 404
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Underbin Closet Installation
Figure 401/25-24-03-990-803 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-24-03

Page 405
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

PARTITION - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) The removal of the partition
 - (2) The installation of the partition.
- B. This procedure is applicable to the outboard and center partitions in the passenger compartment.

TASK 25-24-06-000-801

2. Partition - Removal

A. References

Reference	Title
25-21-06-000-801	Main Ceiling Panel - Removal (P/B 401)
25-21-08-000-801	Overdoor Panel Opening/Removal (P/B 201)
25-25-06-000-801	Attendant Seat Removal (P/B 401)
25-25-06-000-802	Attendant Seat Removal (P/B 401)
25-25-06-000-806	Attendant Seat Removal (P/B 401)
25-28-05-000-801	Floor-Mounted Stowage Box Removal (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-24-06-860-001

- (1) Open the applicable circuit breakers for the electrical components that mount on the partition and attach DO-NOT-CLOSE tags.

SUBTASK 25-24-06-010-001

- (2) Do the applicable tasks that follow if it is necessary to get better access to the partition:
 - (a) Do this task: Main Ceiling Panel - Removal, TASK 25-21-06-000-801.
 - (b) Do this task: Overdoor Panel Opening/Removal, TASK 25-21-08-000-801.
 - (c) Do this task: Attendant Seat Removal, TASK 25-25-06-000-801 or Attendant Seat Removal, TASK 25-25-06-000-802 or Attendant Seat Removal, TASK 25-25-06-000-806.
 - (d) Do this task: Floor-Mounted Stowage Box Removal, TASK 25-28-05-000-801.

D. Remove the Partition

SUBTASK 25-24-06-020-001

- (1) Do these steps to remove the outboard partition [2]:

NOTE: The steps that follow are applicable for the outboard partitions with and without attendant seats.

 - (a) Do these steps to disconnect the bottom of the partition [2]:
 - 1) Remove the kickstrip [17], [20] to get access to the seat track attachments.
 - 2) FOR THE FIXED ATTACHMENTS; remove the bolts [14] and washers [19] that attach the partition [2] to the seat track fittings [16].
 - 3) FOR THE MOVEABLE ATTACHMENTS; remove the nut [25] and washer [24] to disconnect the seat track fitting [23] from the stud fitting [22].

EFFECTIVITY
ARO ALL

25-24-06

D633W101-ARO

Page 401
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (b) Do these steps to disconnect the top of the partition [2]:
- 1) Remove the bolt [5] and washer [6] to disconnect the support [7] and spring [8] from the ceiling closeout [9].
 - 2) Remove the support [7] and spring [8].
 - 3) Remove the ceiling closeout [9].
 - 4) Disconnect the electrical connector if it is necessary.
 - 5) Remove the bolt [13], washers [11] [12], and nut [10] to disconnect the tie rod [4] from the top of the partition [2].
 - 6) Carefully remove the partition [2].

SUBTASK 25-24-06-020-002

- (2) Do these steps to remove the center partition [42]:

NOTE: The steps that follow are applicable for the center partitions with and without attendant seats.

- (a) Do these steps to disconnect the bottom of the partition [42]:
- 1) Remove the kickstrip [17], [20] to get access to the seat track attachments.
 - 2) FOR THE FIXED ATTACHMENTS; do these steps:
 - a) Remove the screws [59] and washers [60] that attach the plunger fitting [61] to the seat track fittings [62].
 - b) Remove the plunger fitting [61].
 - 3) FOR THE MOVEABLE ATTACHMENTS; remove the nut [25] and washer [24] to disconnect the seat track fitting [23] from the stud fitting [22].
- (b) Carefully remove the partition [42].

NOTE: The inboard seat track fittings are not attached to the partition. When you move the partition, these seat track fittings will come out of the bottom of the partition.

————— **END OF TASK** —————

TASK 25-24-06-400-801

3. Partition - Installation

A. References

Reference	Title
25-21-06-400-801	Main Ceiling Panel - Installation (P/B 401)
25-21-08-400-801	Overdoor Panel Installation/Closing (P/B 201)
25-25-06-400-801	Attendant Seat Installation (P/B 401)
25-25-06-400-802	Attendant Seat Installation (P/B 401)
25-25-06-400-806	Attendant Seat Installation (P/B 401)
25-28-05-400-801	Floor-Mounted Stowage Box - Installation (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Install the Partition

SUBTASK 25-24-06-420-002

- (1) Do these steps to install the outboard partition [2]:

EFFECTIVITY
ARO ALL

25-24-06

D633W101-ARO

Page 402
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Put the electrical wires up through the ceiling panel if it is necessary.
- (b) Put the top of the partition [2] up through the ceiling panel.
- (c) Do these steps to connect the top of the partition [2]:
 - 1) If applicable put the ceiling closeout [9] around the top of the partition [2].
 - 2) If applicable Install the bolt [5] and washer [6] to attach the support [7] and spring [8] to the ceiling closeout [9].
 - 3) Install the bolts [13], washers [11], [12], and nuts [10] to connect the tie rod [4] to the top of the partition [2].
 - 4) Connect the electrical connector if it is applicable.
- (d) Do these steps to connect the bottom of the partition [2]:
 - 1) FOR THE FIXED ATTACHMENTS; install the bolts [14] and washers [19] that attach the partition [2] to the seat track fittings [16].
 - 2) FOR THE MOVEABLE ATTACHMENTS; install the nut [25] and washer [24] to attach the seat track fitting [23] to the stud fitting [22].
 - 3) Install the kickstrip [17], [20] to the bottom of the partition [2].
- (e) Do these steps if it is necessary to adjust the length of the tie rod [4]:
 - 1) Remove the lockwire [3] from the end of the tie rod [4] that attaches to the partition [2].
 - 2) Adjust the length of the tie rod [4] to make the partition [2] vertical.
 - 3) Install a new lockwire [3].

SUBTASK 25-24-06-420-001

- (2) Do these steps to install the center partition [42]:
 - (a) Put the electrical wires up through the ceiling panel if it is necessary.
 - (b) Put the top of the partition [42] up through the ceiling panel.
 - (c) Put the inboard seat track fittings [62] up in the partition [42] at the seat tracks.
NOTE: The inboard seat track fittings are not attached to the partition.
 - (d) For Type 1 attachment, do these steps to attach the top of the partition [42]:
 - 1) Put the ceiling closeout [50] around the top of the partition [42].
 - 2) Install the screw [47], bolt [57], washers [48] [56], and nuts [55] to attach the bracket [49] to the bin rail [58] and the ceiling panel.
 - 3) Install the bolt [5] and washer [6] to attach the support [46] and spring [51] to the ceiling closeout [50].
 - 4) Make sure the spring [51] touches the center of the teflon tape.
 - 5) Install the bolt [44], washers [45] [53], and nut [52] to connect the tie rod [54] to the top of the partition [42].
 - 6) Connect the electrical connectors [43] if it is applicable.
 - (e) For Type 2 attachment, do these steps to attach the top of the partition [42]:
 - 1) Put the ceiling closeout [43] around the top of the partition [42].
 - 2) Install the bolt [5] and washer [6] to attach the support [46] and spring [51] to the ceiling closeout [43].
 - 3) Install the bolt [44], washers [45] [53], and nut [52] to connect the tie rod [54] to the top of the partition [42].

EFFECTIVITY
ARO ALL

25-24-06

D633W101-ARO

Page 403
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 4) Connect the electrical connectors [43] if it is applicable.
- (f) Put the seat track fittings [62] or stud fittings [22] for the partition [42] in the circular openings in the seat track.
- (g) Do these steps to connect the bottom of the partition [42]:
 - 1) FOR THE FIXED ATTACHMENTS; do these steps:
 - a) Install the plunger fitting [61].
 - b) Install the screws [59] and washers [60] that attach the plunger fitting [61] to the seat track fittings [62].
 - 2) FOR THE MOVEABLE ATTACHMENTS; Install the nut [25] and washer [24] to attach the seat track fitting [23] to the stud fitting [22].
 - 3) Install the kickstrip [17], [20] to the bottom of the partition [42].
- (h) Do these steps if it is necessary to adjust the length of the tie rod [54]:
 - 1) Remove the lockwire [3] from the end of the tie rod [54] that attaches to the partition [42].
 - 2) Adjust the length of the tie rod [54] to make the partition [42] vertical.
 - 3) Install a new lockwire [3].

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-24-06-860-002

- (1) Close the applicable circuit breakers for the electrical components that mount on the partition and remove the DO-NOT-CLOSE tags.

SUBTASK 25-24-06-410-001

- (2) Do the applicable tasks that follow:
 - (a) Do this task: Main Ceiling Panel - Installation, TASK 25-21-06-400-801.
 - (b) Do this task: Overdoor Panel Installation/Closing, TASK 25-21-08-400-801.
 - (c) Install the attendant seat if it was removed. Do this task: Attendant Seat Installation, TASK 25-25-06-400-801 or Attendant Seat Installation, TASK 25-25-06-400-802 or Attendant Seat Installation, TASK 25-25-06-400-806.
 - (d) Do this task: Floor-Mounted Stowage Box - Installation, TASK 25-28-05-400-801.

————— **END OF TASK** —————

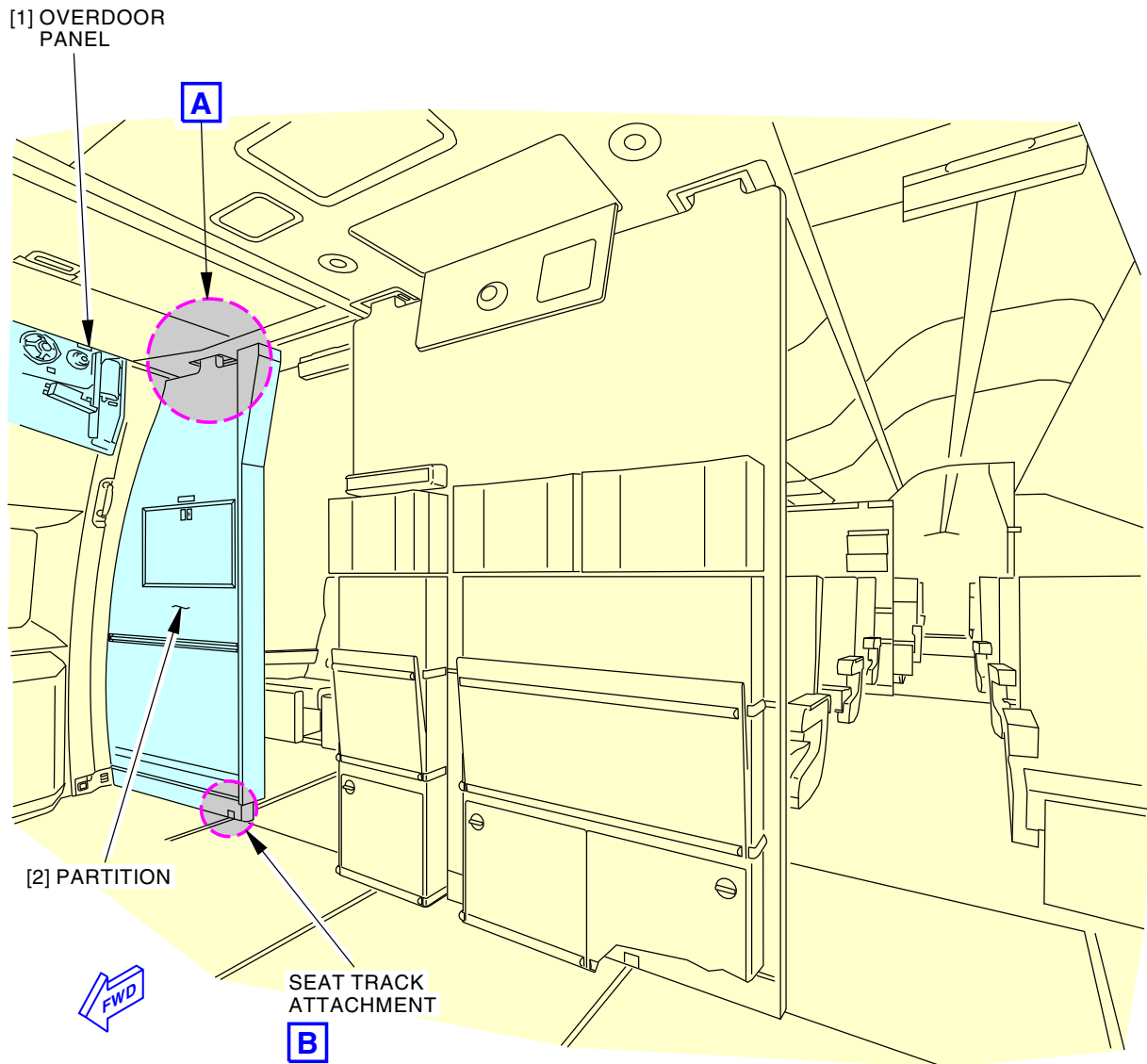
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25-24-06

D633W101-ARO

Page 404
Jan 05/2015

777-200/300
AIRCRAFT MAINTENANCE MANUAL



E09165 S0006409041_V2

Outboard Partition Installation
Figure 401/25-24-06-990-801 (Sheet 1 of 4)

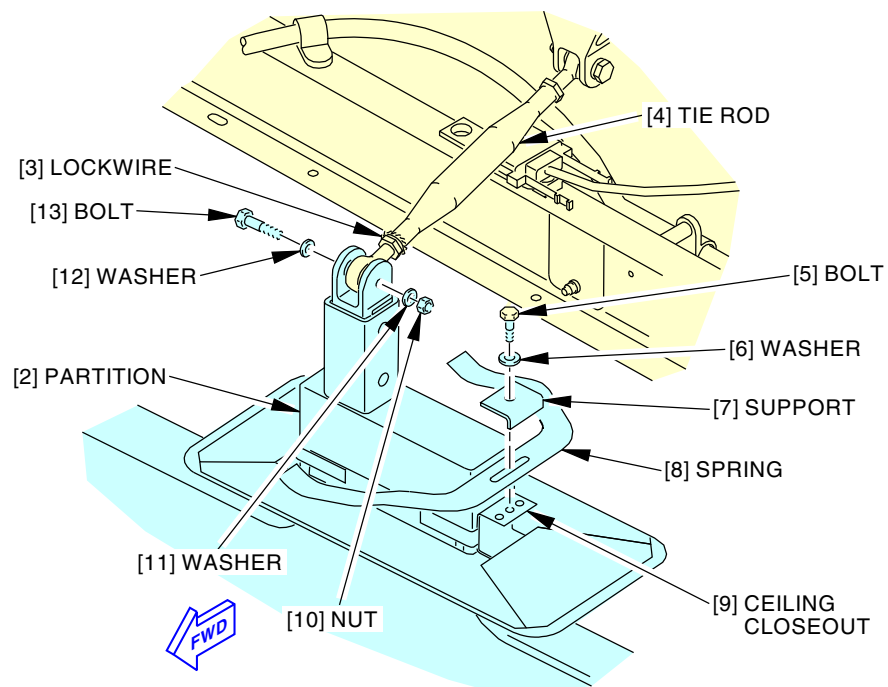
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25-24-06

D633W101-ARO

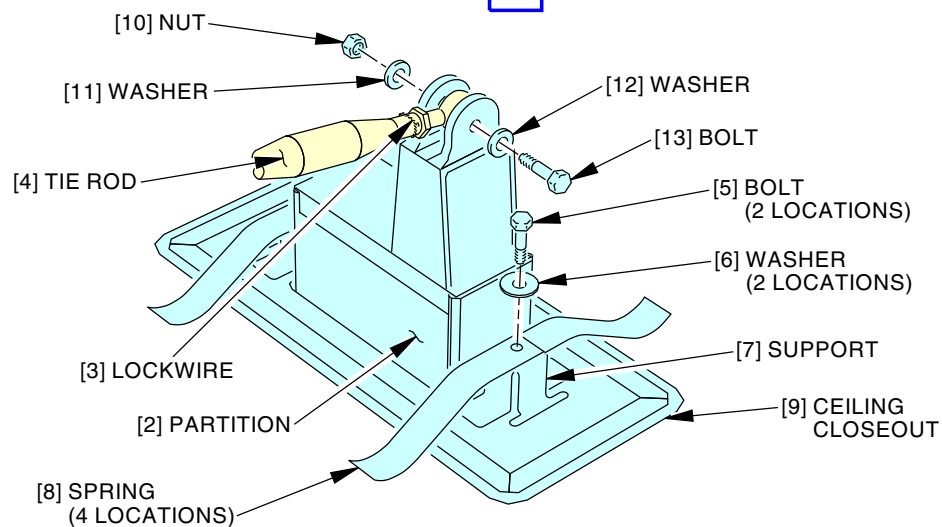
Page 405
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



**TOP ATTACHMENT
(EXAMPLE)**

A



**TOP ATTACHMENT
(EXAMPLE)**

A

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**Outboard Partition Installation
Figure 401/25-24-06-990-801 (Sheet 2 of 4)**

EFFECTIVITY
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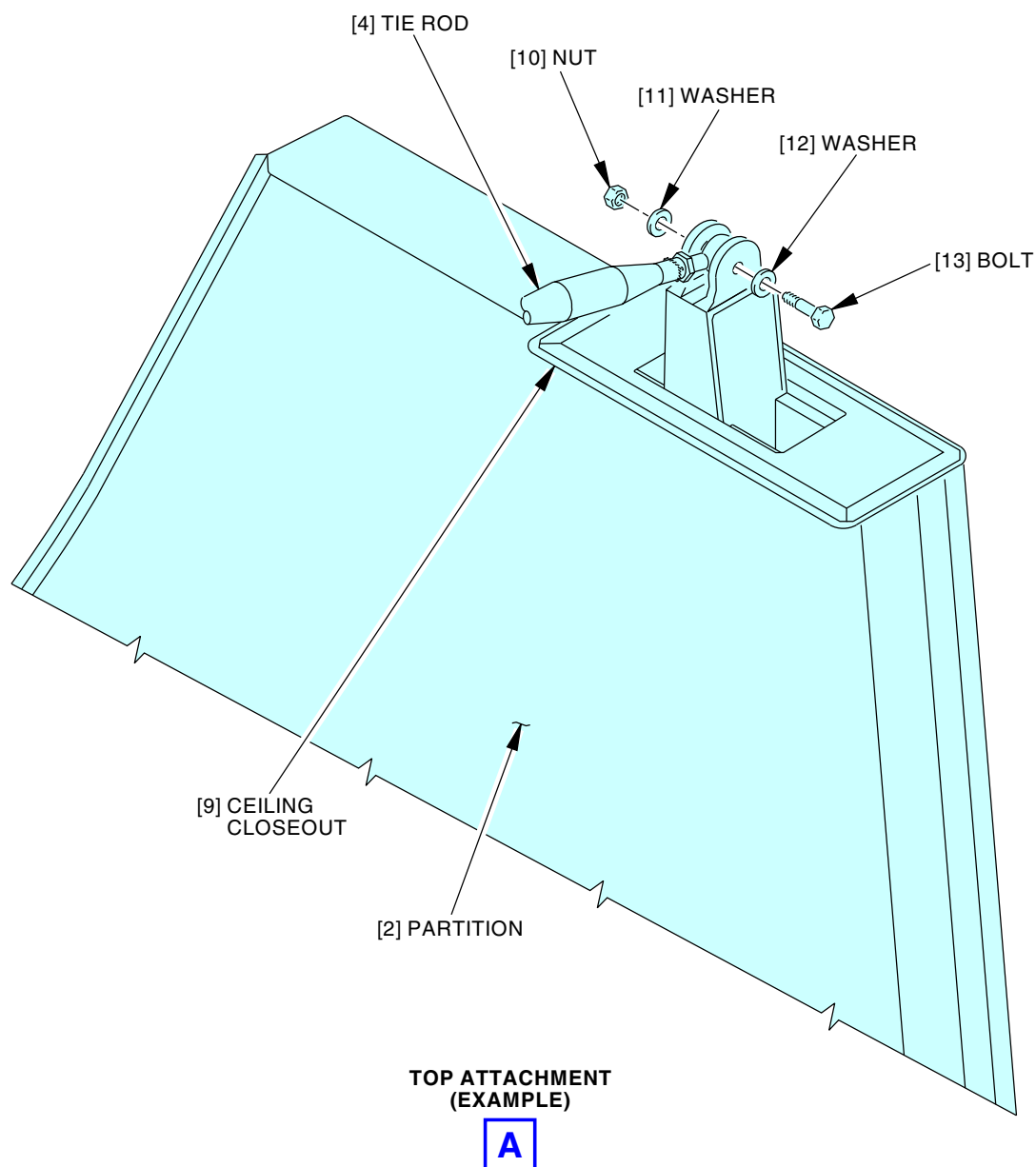
25-24-06

D633W101-ARO

Page 406
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



1423871 S0000256618_V2

Outboard Partition Installation
Figure 401/25-24-06-990-801 (Sheet 3 of 4)

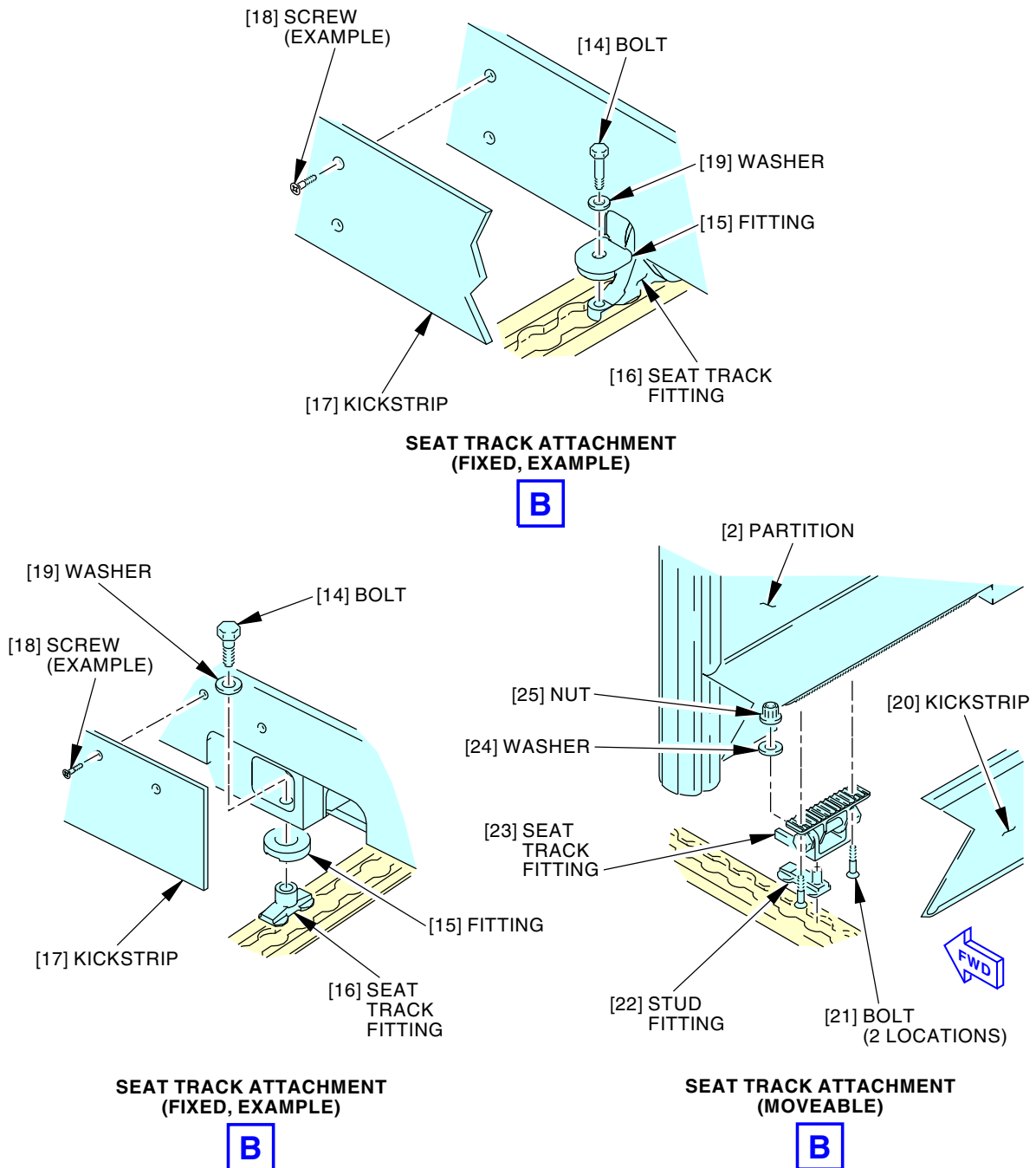
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25-24-06

D633W101-ARO

Page 407
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



U42970 S0000195768_V2

**Outboard Partition Installation
Figure 401/25-24-06-990-801 (Sheet 4 of 4)**

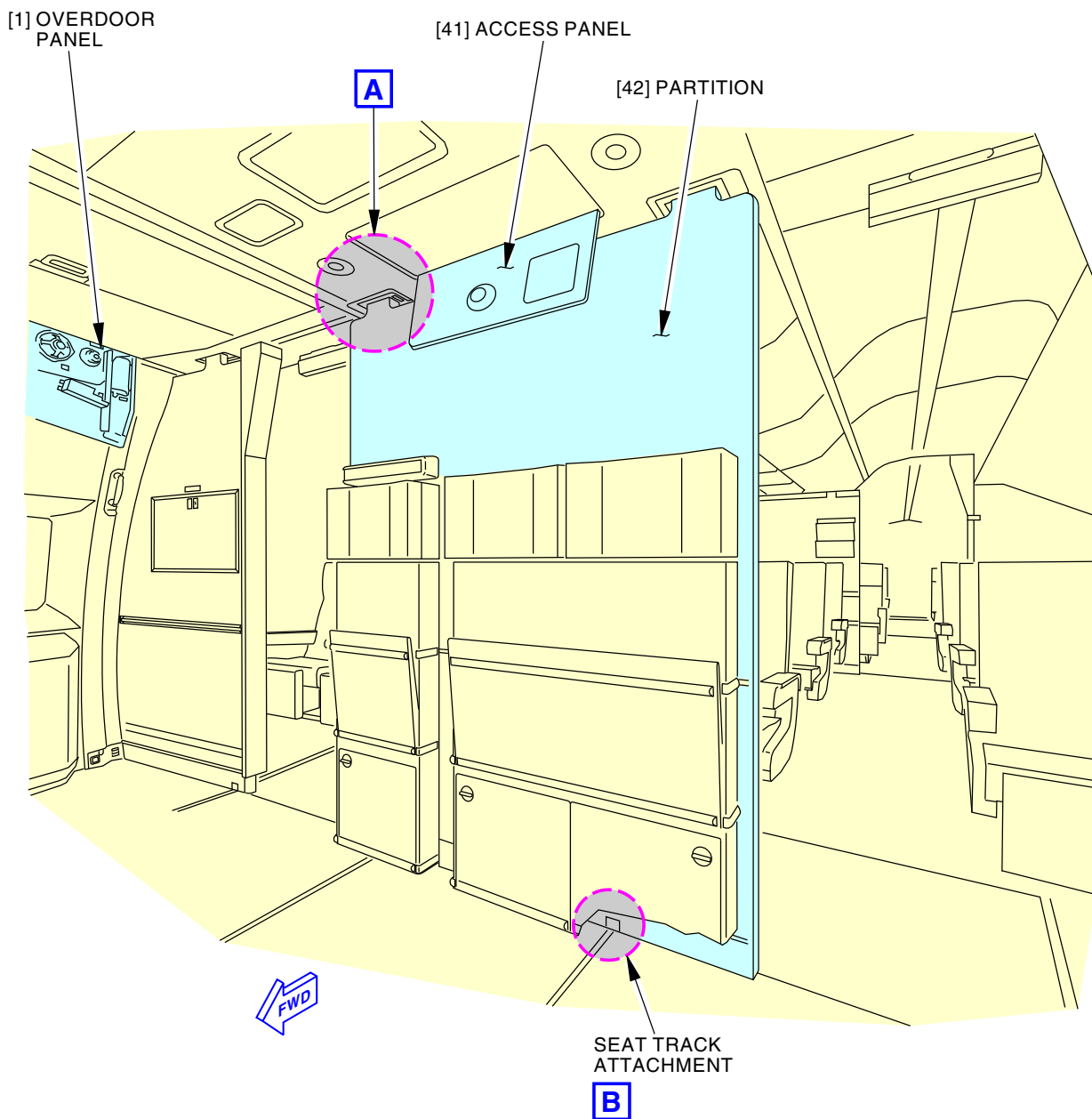
EFFECTIVITY
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D633W101-ARO

25-24-06

Page 408
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



E59935 S0006409043_V2

Center Partition Installation
Figure 402/25-24-06-990-802 (Sheet 1 of 3)

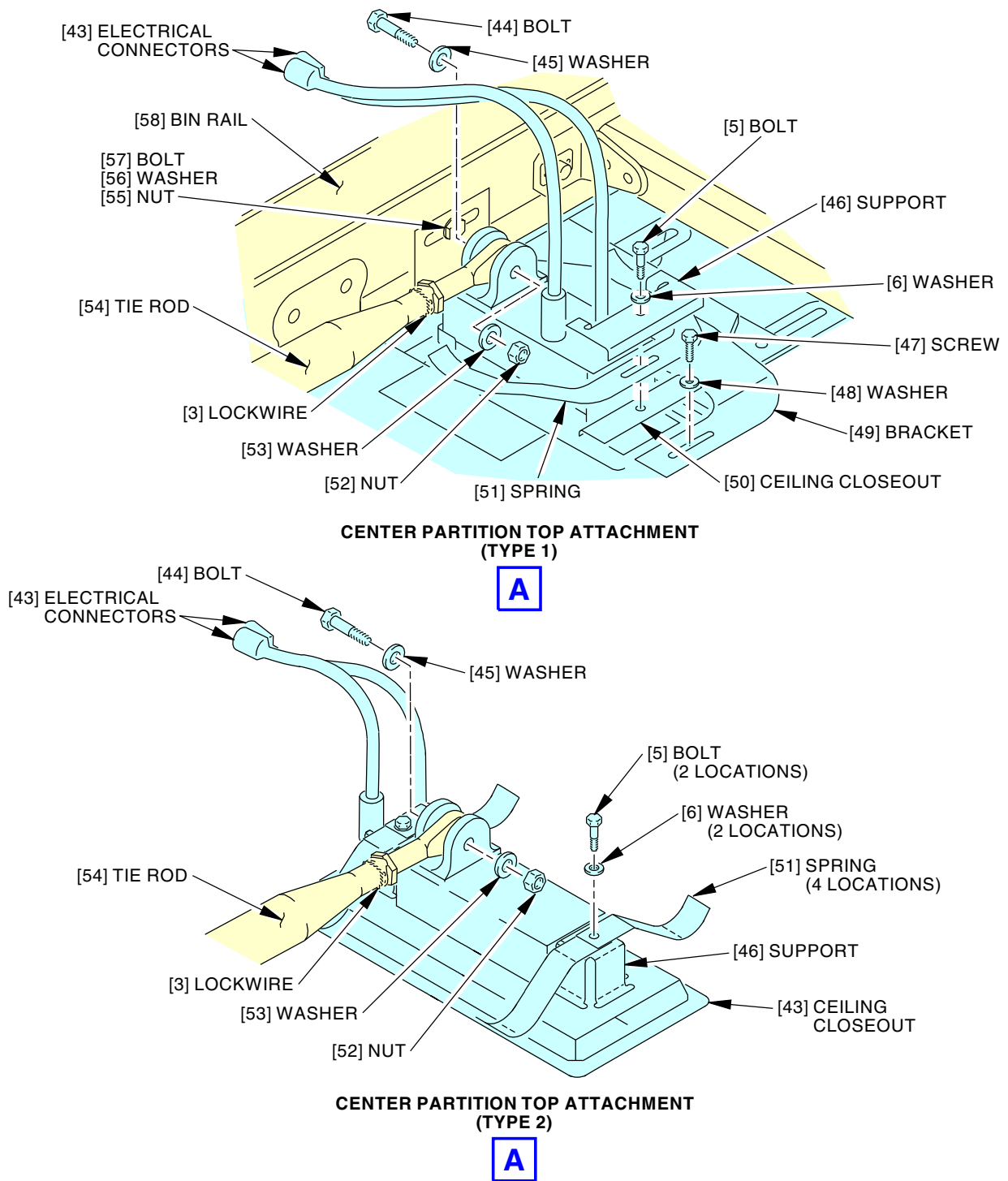
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25-24-06

D633W101-ARO

Page 409
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



E09719 S0006409044_V3

Center Partition Installation
Figure 402/25-24-06-990-802 (Sheet 2 of 3)

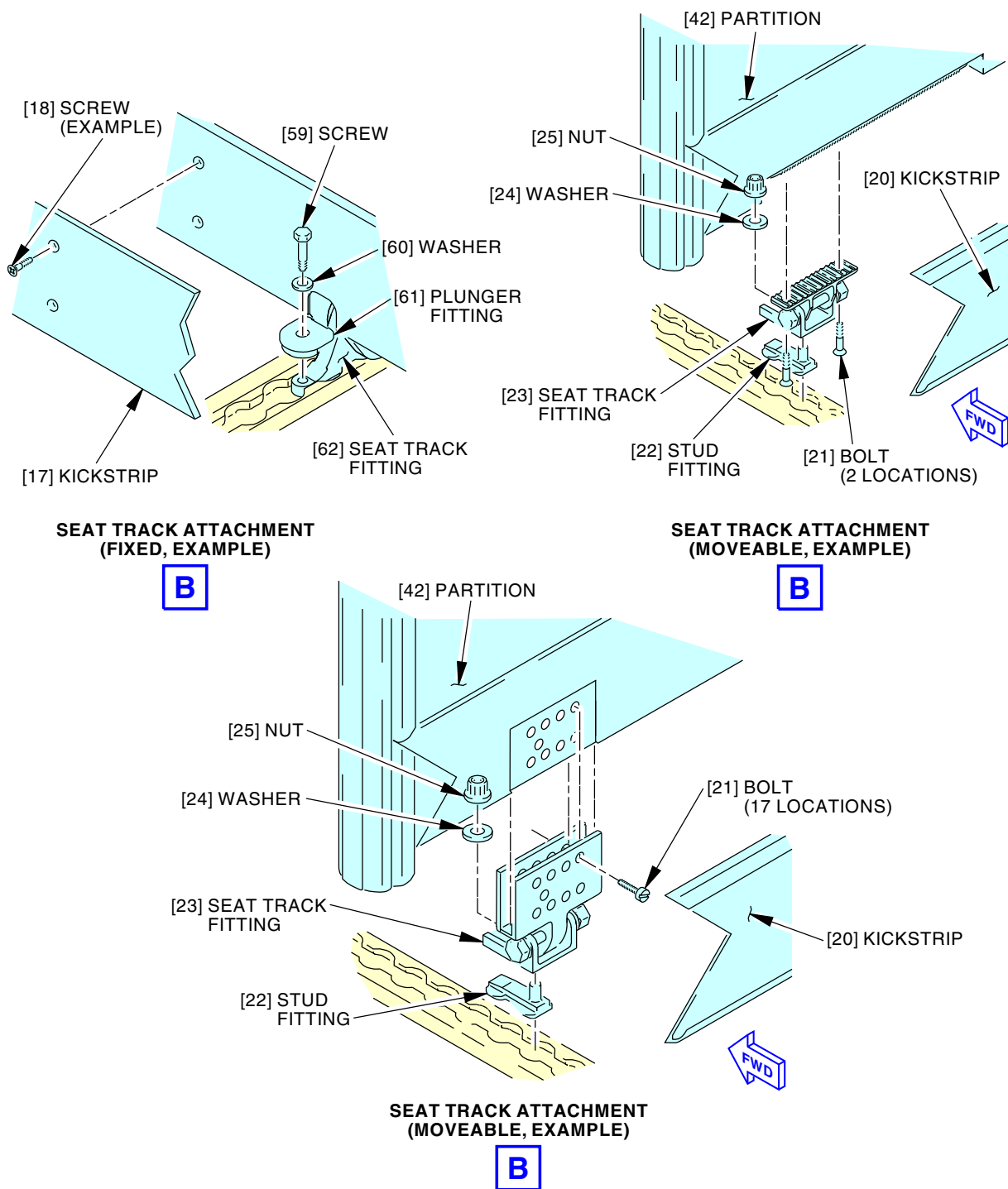
EFFECTIVITY
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25-24-06

D633W101-ARO

Page 410
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



U39430 S0000194926_V2

**Center Partition Installation
Figure 402/25-24-06-990-802 (Sheet 3 of 3)**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-24-06

Page 411
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
CLASS DIVIDERS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the class dividers
 - (2) An installation of the class dividers.
- B. This procedure is applicable to the center and outboard class dividers in the passenger compartment.

TASK 25-24-08-000-801

2. Class Divider Removal

A. References

Reference	Title
25-21-06-000-801	Main Ceiling Panel - Removal (P/B 401)
25-23-01-010-801	Passenger Service Unit (PSU) Opening (P/B 201)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-24-08-010-001

- (1) Remove the main ceiling panel adjacent to the class divider. Do this task:
TASK 25-21-06-000-801.

SUBTASK 25-24-08-010-002

- (2) Disconnect the curtain track [11] from the center and outboard class dividers [4], [41].

D. Center Class Divider Removal

SUBTASK 25-24-08-020-001

- (1) Do these steps to disconnect the bottom of the class divider [4]:
 - (a) Remove the kickstrip [7], [26] from the bottom of the class divider [4].
 - (b) For the Fixed Attachment:
 - 1) Remove the bolt [22] and washer [23] that attach the plunger fitting [24] to the seat track fitting [25].
 - 2) Remove the plunger fitting [24].
 - (c) For the Moveable Attachment:
 - 1) Remove the nuts [5] and washers [6] to disconnect the seat track fittings [9] from the stud fitting [10].

SUBTASK 25-24-08-020-002

- (2) Do these steps to disconnect the top of the class divider [4]:
 - (a) Do these steps if it is necessary to disconnect electrical connectors [1]:
 - 1) Open the PSU adjacent to the class divider [4]. Do this task:
TASK 25-23-01-010-801.
 - 2) Disconnect the electrical connectors [1] for the wires that go through the wire tower [2].

EFFECTIVITY
ARO ALL

25-24-08

D633W101-ARO

Page 401
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (b) Remove the bolts [19] and washers [20] that attach the blade [21] on the class divider [4] to the blade mount [18].

NOTE: The blade is loose in the class divider and could fall when it is disconnected from the blade mount.

- (c) Do these steps to remove the hardware that attaches the class divider [4] to the bin rail [14]:
 - 1) Remove the bolts [17] that attach the blade mount [18] to the bin rail [14].
 - 2) Remove the blade mount [18], rail clamp [15], and spacer [13] from the bin rail [14].
- (d) Push the blade [21] in the class divider [4] to get it out of the way for the removal.

SUBTASK 25-24-08-020-003

- (3) Carefully remove the class divider [4].

SUBTASK 25-24-08-020-004

- (4) Keep the hardware for the bin rail [14] attachment for the installation task.

E. Outboard Class Divider Removal

SUBTASK 25-24-08-020-005

- (1) Do these steps to disconnect the bottom of the class divider [41]:
 - (a) Remove the kickstrip [7] from the bottom of the class divider [41].
 - (b) Remove the nuts [5] and washers [6] to disconnect the seat track fittings [9] from the stud fitting [10].

SUBTASK 25-24-08-020-006

- (2) Do these steps to disconnect the top of the class divider [41]:
 - (a) Do these steps if it is necessary to disconnect electrical connectors:
 - 1) Open the PSU adjacent to the class divider [41]. Do this task:
TASK 25-23-01-010-801.
 - 2) Disconnect the electrical connectors for the wires that go through the wire tower.
 - (b) Remove the bolts [19] and washers [20] that attach the upper blade [46] to the blade mount [18].

NOTE: The blade is loose in the class divider and could fall when it is disconnected from the blade mount.
 - (c) Do these steps to remove the hardware that attaches the class divider [41] to the support track [47]:
 - 1) Remove the bolts [17] that attach the blade mount [18] to the support track [47].
 - 2) Remove the blade mount [18], rail clamp [15], and spacer [13] from the support track [47].
 - (d) Remove the bolts [43] and washers [20] that attach the lower blade [42] to the passenger service unit (PSU) rail.

NOTE: The blade is loose in the class divider and could fall when it is disconnected from the blade mount.
 - (e) Push the upper blade [46] and lower blade [42] in the class divider [41] to get them out of the way for the removal.

SUBTASK 25-24-08-020-007

- (3) Carefully remove the class divider [41].

EFFECTIVITY
ARO ALL

25-24-08

D633W101-ARO

Page 402
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-24-08-020-008

- (4) Keep the hardware for the support track [47] attachment with the class divider [41] for use during the installation task.

————— END OF TASK —————

TASK 25-24-08-400-801

3. Class Divider Installation

(Figure 401, Figure 402)

A. References

Reference	Title
25-21-06-400-801	Main Ceiling Panel - Installation (P/B 401)
25-23-01-410-801	Passenger Service Unit (PSU) Closing (P/B 201)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Center Class Divider Installation

(Figure 401)

SUBTASK 25-24-08-420-001

- (1) Do these steps to attach the class divider [4] to the bin rail [14]:
 - (a) Do these steps if the class divider has a wire tower [2] for the electrical wires:
 - 1) Pull the electrical connectors [1] from the wire tower [2] up through the PSU [3].
 - 2) Put the wire tower [2] up through the PSU [3].
 - 3) Connect the electrical connectors [1].
 - (b) If it is necessary to turn the blade [21] for a better attachment to the bin rail [14], do these steps:
 - 1) Remove the blade [21] from the class divider [4].
 - 2) Turn the blade [21] 180 degrees.
 - 3) Put the blade [21] in the class divider [4].
 - (c) Attach the blade mount [18], rail clamp [15], and spacer [13] to the bin rail [14] with the bolts [17].
 - (d) Make sure the serrations on the blades [21] are fully engaged.
 - (e) Loosely install the bolts [19] and washers [20] to attach the blade [21] on the class divider [4] to the bin rail [14].

SUBTASK 25-24-08-420-002

- (2) Do these steps to attach the bottom of the class divider [4] to the seat tracks:
 - (a) For the Fixed Attachment:
 - 1) Install the bolt [22] and washer [23] that attach the plunger fitting [24] to the seat track fitting [25].
 - (b) For the Moveable Attachment:
 - 1) Install the washers [6] and nuts [5] to connect the seat track fittings [9] to the stud fitting [10].
 - (c) Install the kickstrip [7], [26] to the bottom of the class divider [4].

EFFECTIVITY
ARO ALL

25-24-08

D633W101-ARO

Page 403
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-24-08-820-001

- (3) Do these steps to make sure the class divider [4] is vertical:
 - (a) Loosen the bolts [19] to disengage the serrations on the blade [21] and the blade mount [18].
 - (b) Move the blade [21] forward or aft until the class divider [4] is vertical.
 - (c) Engage the serrations on the blade [21] and the blade mount [18].
 - (d) Tighten the bolts [19].

D. Outboard Class Divider Installation

(Figure 402)

SUBTASK 25-24-08-420-003

- (1) Do these steps to attach the top of the class divider [41] to the support track [47] above the stowage bin:
 - (a) Do these steps if the class divider [41] has a wire tower [2] for the electrical wires:
 - 1) Pull the electrical connectors [1] from the wire tower [2] up through the PSU [3].
 - 2) Put the wire tower [2] up through the PSU [3].
 - 3) Connect the electrical connectors [1].
 - (b) Align the class divider [41] in the position for the installation.
 - (c) If it is necessary to turn the upper blade [46] and lower blade [42] for a better attachment to the support track [47], do these steps:
 - 1) Remove the upper blade [46] and lower blade [42] from the class divider [41].
 - 2) Turn the upper blade [46] and lower blade [42] 180 degrees.
 - 3) Put the upper blade [46] and lower blade [42] in the class divider [41].
 - (d) Attach the blade mount [18], rail clamp [15], and spacer [13] to the support track [47] with the bolts [17].
 - (e) Make sure the serrations on the upper blade [46] are fully engaged.
 - (f) Loosely install the bolts [19] and washers [20] to attach the upper blade [46] to the blade mount [18].

SUBTASK 25-24-08-420-004

- (2) Do these steps to attach the bottom of the class divider [41] to the seat tracks:
 - (a) For the Fixed Attachment:
 - 1) Install the bolt [22] and washer [23] that attach the plunger fitting [24] to the seat track fitting [25].
 - (b) For the Moveable Attachment:
 - 1) Install the washers [6] and nuts [5] to connect the seat track fittings [9] to the stud fitting [10].
 - (c) Install the kickstrip [7], [26] to the bottom of the class divider [41].

SUBTASK 25-24-08-820-002

- (3) Do these steps to make sure the class divider [41] is vertical:
 - (a) Loosen the bolts [19] to disengage the serrations on the upper blade [46] and the blade mount [18].
 - (b) Move the upper blade [46] forward or aft until the class divider [41] is vertical.
 - (c) Engage the serrations on the upper blade [46] and the blade mount [18].

EFFECTIVITY
ARO ALL

25-24-08

D633W101-ARO

Page 404
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(d) Tighten the bolts [19].

SUBTASK 25-24-08-420-005

(4) Install the bolts [20] and washers [15] to attach the lower blade [19] to the passenger service unit (PSU) rail.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-24-08-410-001

(1) Install the bolts [13] and washers [18] to attach the curtain track [17] to the center and outboard class dividers [2] [1].

SUBTASK 25-24-08-410-002

(2) Do this task: Main Ceiling Panel - Installation, TASK 25-21-06-400-801.

SUBTASK 25-24-08-410-003

(3) Do this task if it is necessary: PSU Closing TASK 25-23-01-410-801.

————— **END OF TASK** —————

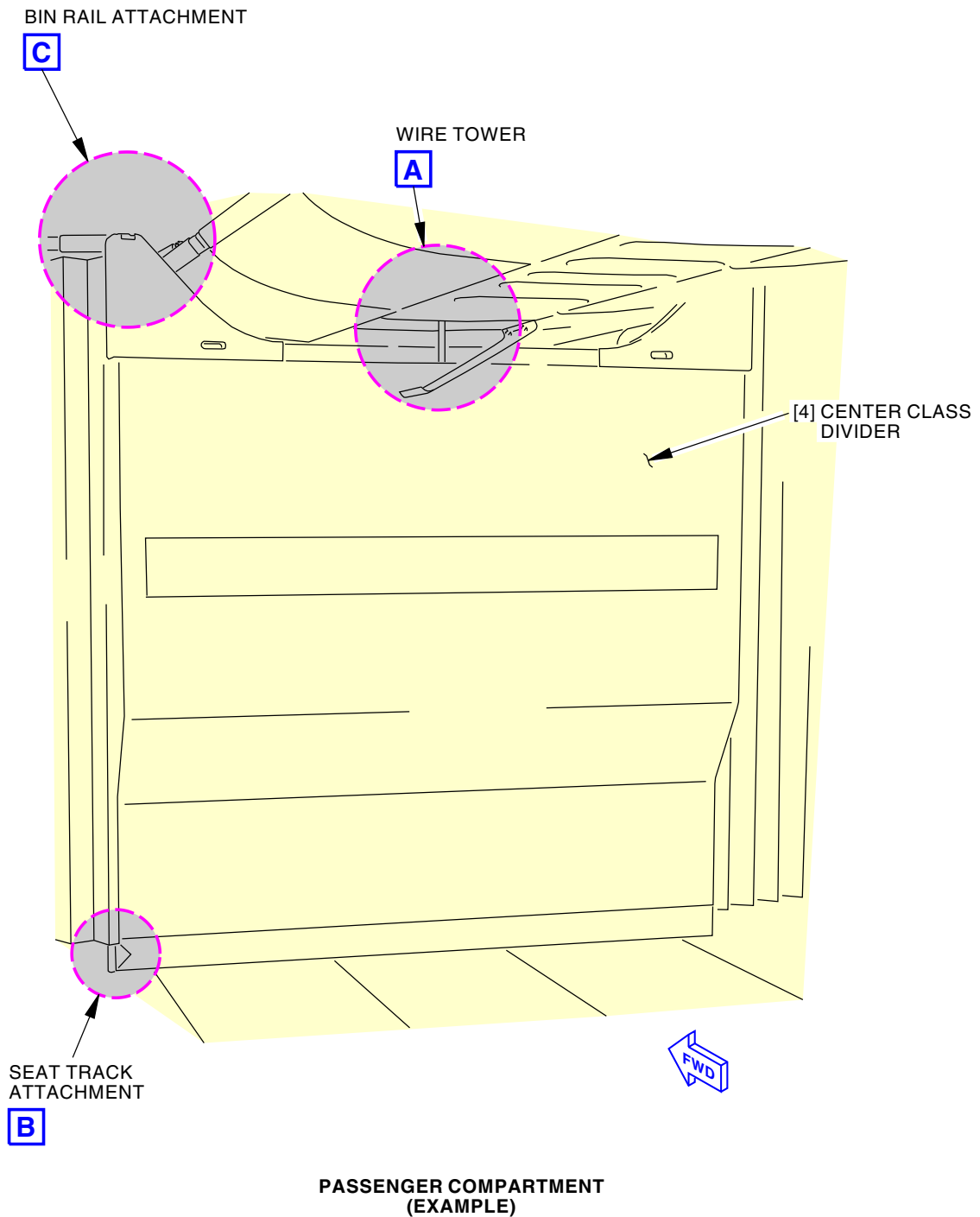
EFFECTIVITY
ARO ALL

25-24-08

D633W101-ARO

Page 405
Jan 05/2015

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777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Center Class Divider Installation
Figure 401/25-24-08-990-803 (Sheet 1 of 3)

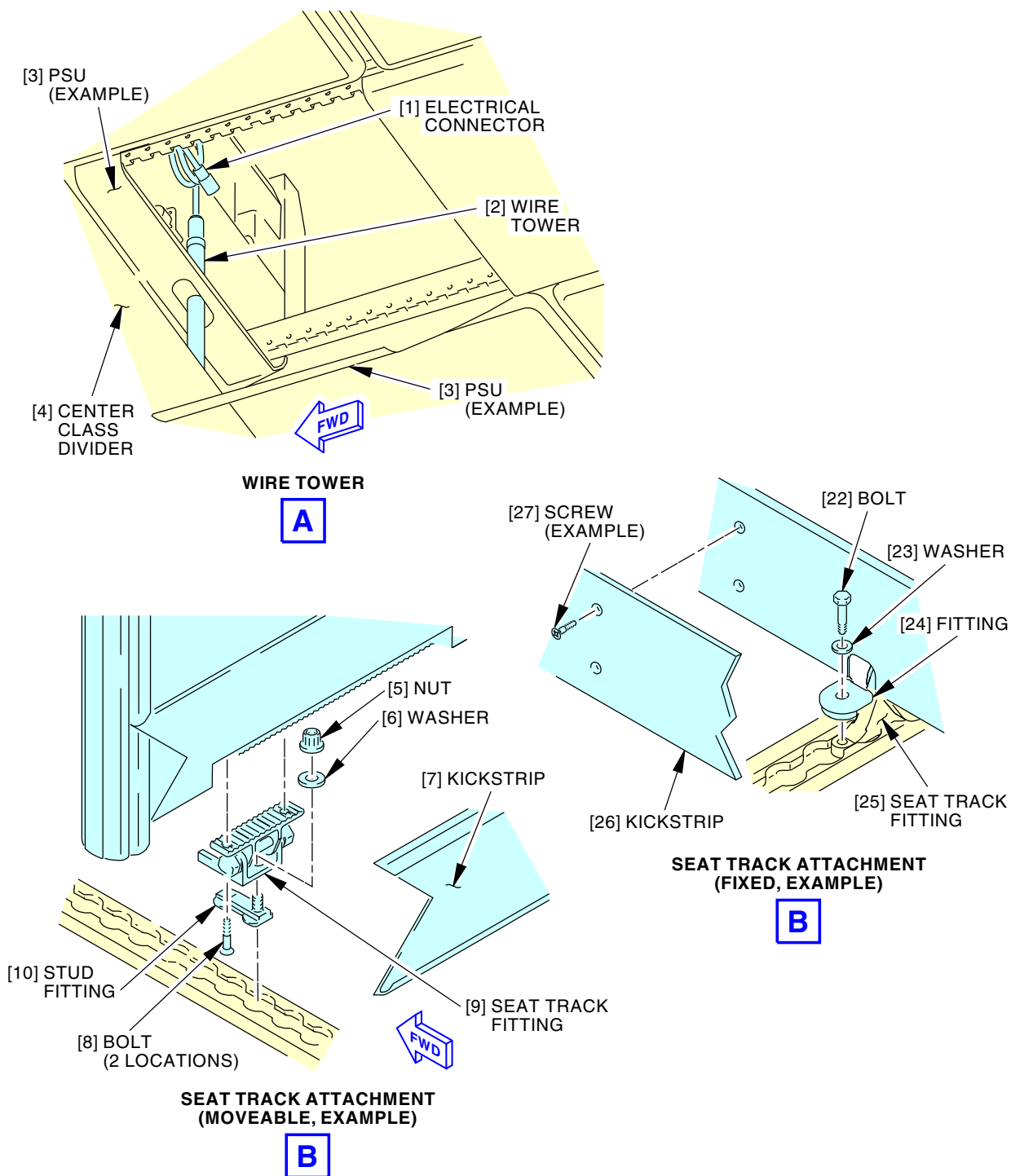
EFFECTIVITY
ARO ALL

D633W101-ARO

25-24-08

Page 406
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



E10322 S0006409055_V3

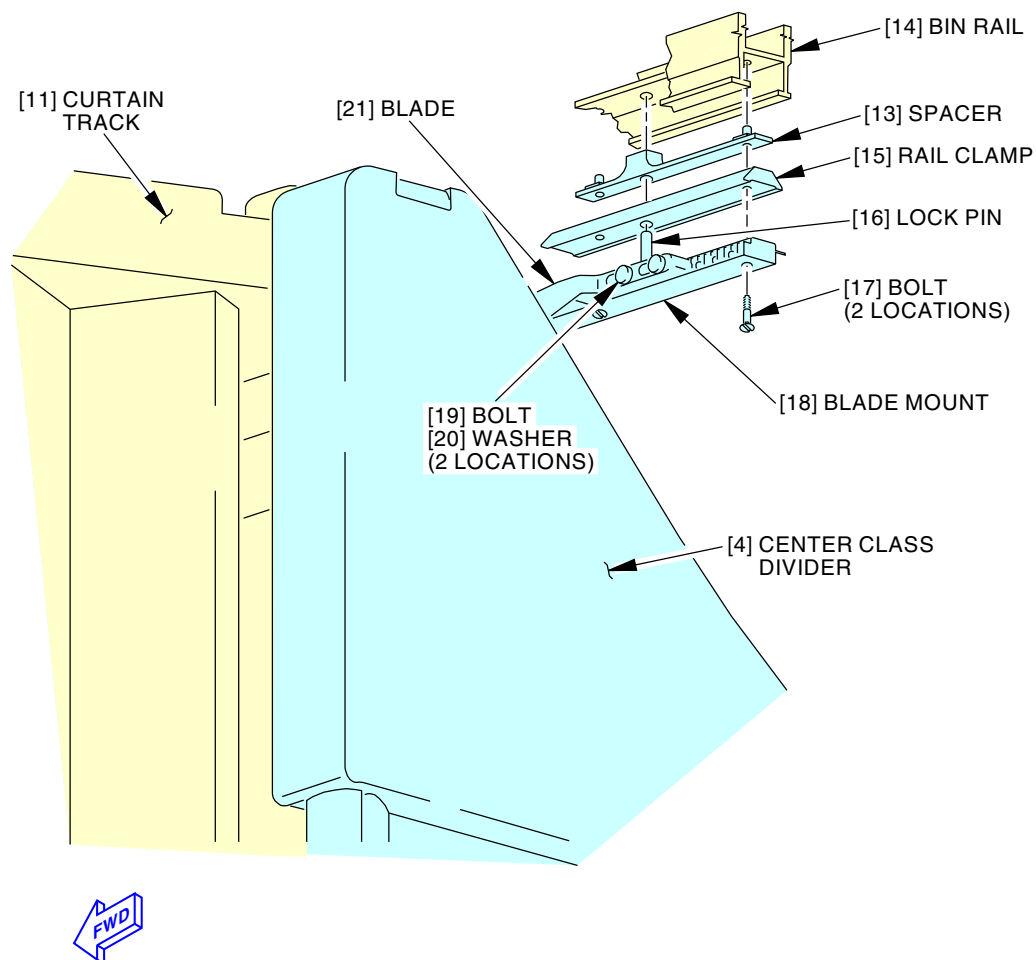
Center Class Divider Installation
Figure 401/25-24-08-990-803 (Sheet 2 of 3)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-24-08

Page 407
May 05/2017



BIN RAIL ATTACHMENT

C

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**Center Class Divider Installation
Figure 401/25-24-08-990-803 (Sheet 3 of 3)**

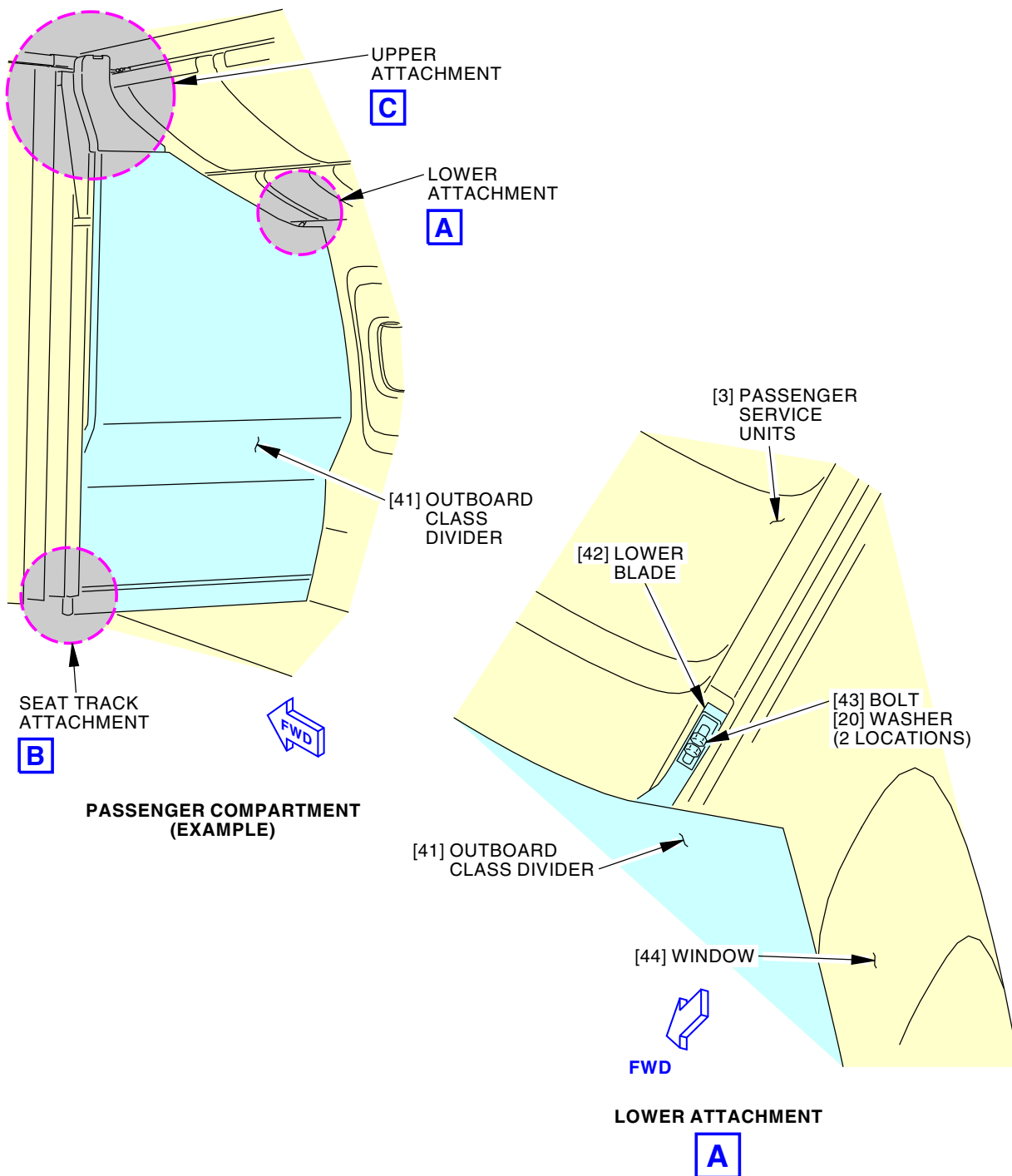
EFFECTIVITY
ARO ALL

25-24-08

D633W101-ARO

Page 408
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



E58784 S0006409057_V2

**Outboard Class Divider Installation
Figure 402/25-24-08-990-804 (Sheet 1 of 2)**

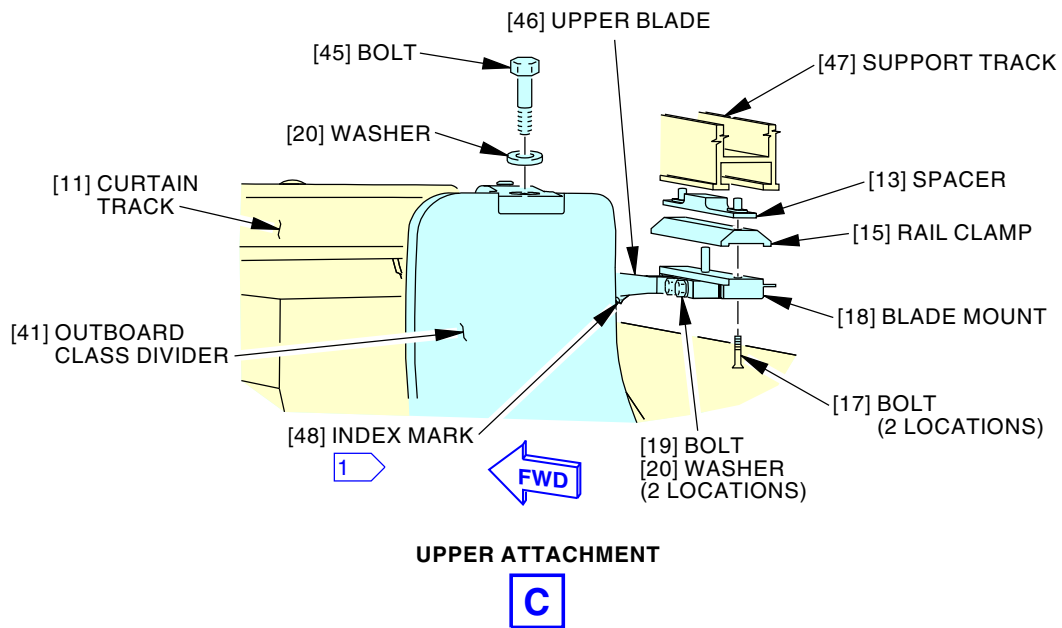
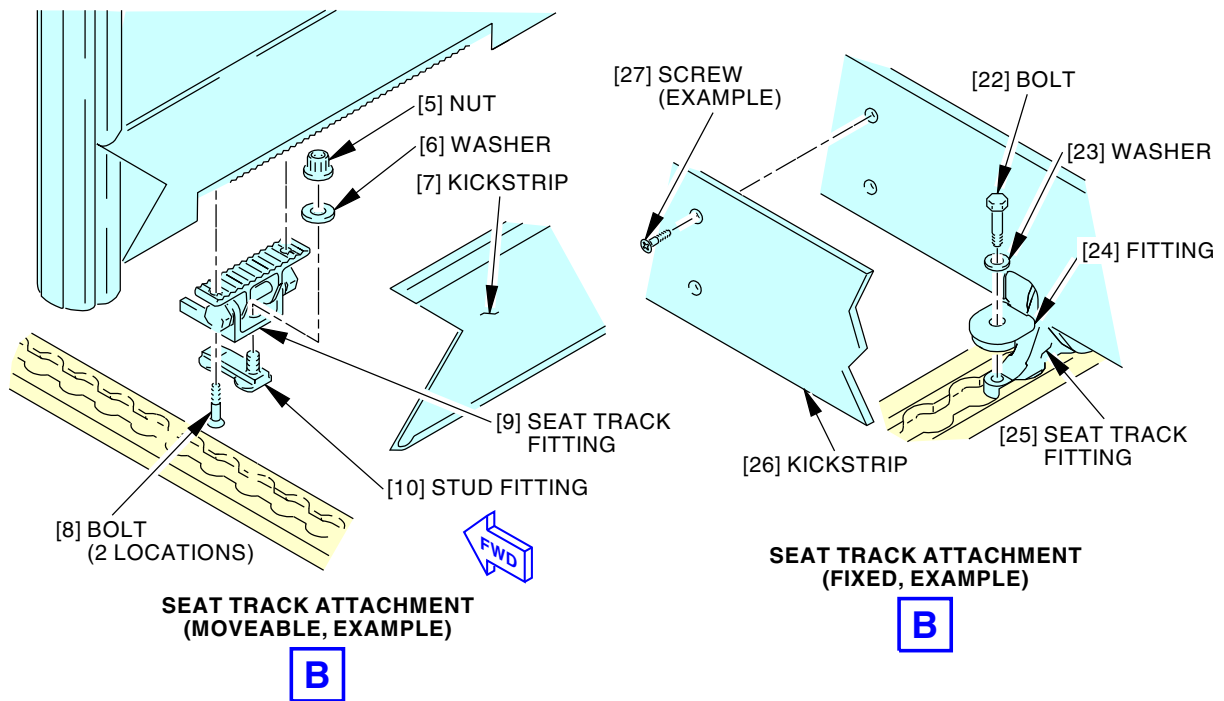
EFFECTIVITY
ARO ALL

D633W101-ARO

25-24-08

Page 409
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



1 THE INDEX MARK CAN BE ON THE BOTTOM OR TOP OF THE UPPER BLADE

E58783 S0006409058_V3

Outboard Class Divider Installation
Figure 402/25-24-08-990-804 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-24-08

Page 410
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

VIDEO CONTROL CENTER (VCC) - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Removal of the Video Control Center
 - (2) Installation of the Video Control Center

TASK 25-24-10-000-809

2. Video Control Center (VCC) Removal

A. References

Reference	Title
25-21-06-000-801	Main Ceiling Panel - Removal (P/B 401)
25-41-01-000-801	Lavatory Removal (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-24-10-860-019

- (1) Open the applicable circuit breakers for the electrical connectors mounted on the top of the VCC [1].

SUBTASK 25-24-10-010-027

- (2) Remove all loose items from the VCC [1].

SUBTASK 25-24-10-010-028

- (3) Do the applicable tasks that follow if it is necessary to get access to the VCC [1]:
 - (a) Main Ceiling Panel Removal (TASK 25-21-06-000-801).
 - (b) Lavatory Removal (TASK 25-41-01-000-801).

D. VCC Removal

Figure 401

SUBTASK 25-24-10-020-052

- (1) Do these steps to disconnect the top of the VCC [1]:
 - (a) Disconnect the ventilation ducts.
 - (b) Disconnect the ground wires from the aircraft structure.
 - (c) Disconnect the electrical connectors.
 - (d) Do one of the steps that follow to disconnect the tie rod [15]:
 - 1) Remove the bolt [13], washers [18], [16], bushing [12] and nut [17].
 - 2) Remove the quick-release pin.
 - (e) Move the tie rod [15] up and away from the VCC [1].
 - (f) Attach the tie rod [15] to the airplane structure with lockwire or a tie-wrap.

SUBTASK 25-24-10-020-053

- (2) For VCCs with bulkhead attachments, do this step:
 - (a) Remove the bolts [9], washers [8] and bushings [10] to disconnect the VCC [1] from the adjacent structure.

EFFECTIVITY
ARO ALL

25-24-10

D633W101-ARO

Page 401
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-24-10-020-054

- (3) Do these steps to disconnect the VCC [1] from the seat track fittings:
 - (a) Remove the cover plate if necessary to get access to the seat track fittings.
 - (b) Remove the bolts [2] and washers [4] from the seat track fittings [6].
 - (c) If applicable, remove the fillers [3] from the seat track fittings [6].

SUBTASK 25-24-10-860-020

- (4) Close and lock the VCC [1] doors.

SUBTASK 25-24-10-020-055

- (5) Carefully lift and remove the VCC [1].

SUBTASK 25-24-10-020-056

- (6) Remove the washers [4], fittings [5], and seat track fittings [6] from the seat tracks [7].

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E. VCC Removal

Figure 402

SUBTASK 25-24-10-020-064

- (1) Do these steps to disconnect the top of the VCC [1]:
 - (a) Disconnect the wire harness assembly [22] and straps [24] as necessary to remove the hose duct [23] from the VCC [1].
 - (b) Disconnect the ground wires from the VCC.
 - (c) Disconnect the electrical connectors from the VCC.
 - 1) Attach the ground wires and electrical connectors to the airplane structure with a tie-wrap.
 - (d) Do these steps to disconnect the tie rod [21]:
 - 1) Remove the nut [39], washers [38], bolt [37] and washers [36] from the lower VCC bracket.
 - 2) Move the tie rod [21] up and away from the VCC [1].
 - 3) Attach the tie rod [21] to the airplane structure with lockwire or a tie-wrap
 - (e) Do these steps if necessary to remove the bracket [28] for more VCC clearance:
 - 1) Remove the nut [34], washers [33], [32], and bolt [31] to remove the tie rod [29] from the bracket [28].
 - 2) Move the tie rod [29] up and away from the bracket [28].
 - 3) Attach the tie rod [29] to the airplane structure with lockwire or a tie-wrap
 - 4) Remove the bolts [25], washers [26], and nuts [27] to remove the bracket [28] with the tie rod [21] attached from the VCC [1].

SUBTASK 25-24-10-020-065

- (2) Do these steps to disconnect the VCC [1] from the seat track fittings:
 - (a) Remove the cover plate if necessary to get access to the seat track fittings.
 - (b) Remove the bolts [2], csk washers [3], and fillers [4] from the seat track fittings [7].

SUBTASK 25-24-10-860-024

- (3) Close and lock the VCC [1] doors.

EFFECTIVITY
ARO ALL

25-24-10

D633W101-ARO

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Page 402
Sep 05/2018



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

ARO 001-017 (Continued)

SUBTASK 25-24-10-020-066

- (4) Carefully lift and remove the VCC [1].

SUBTASK 25-24-10-020-067

- (5) Remove the washers [5], fittings [6], and seat track fittings [7] from the seat tracks.

———— **END OF TASK** ————

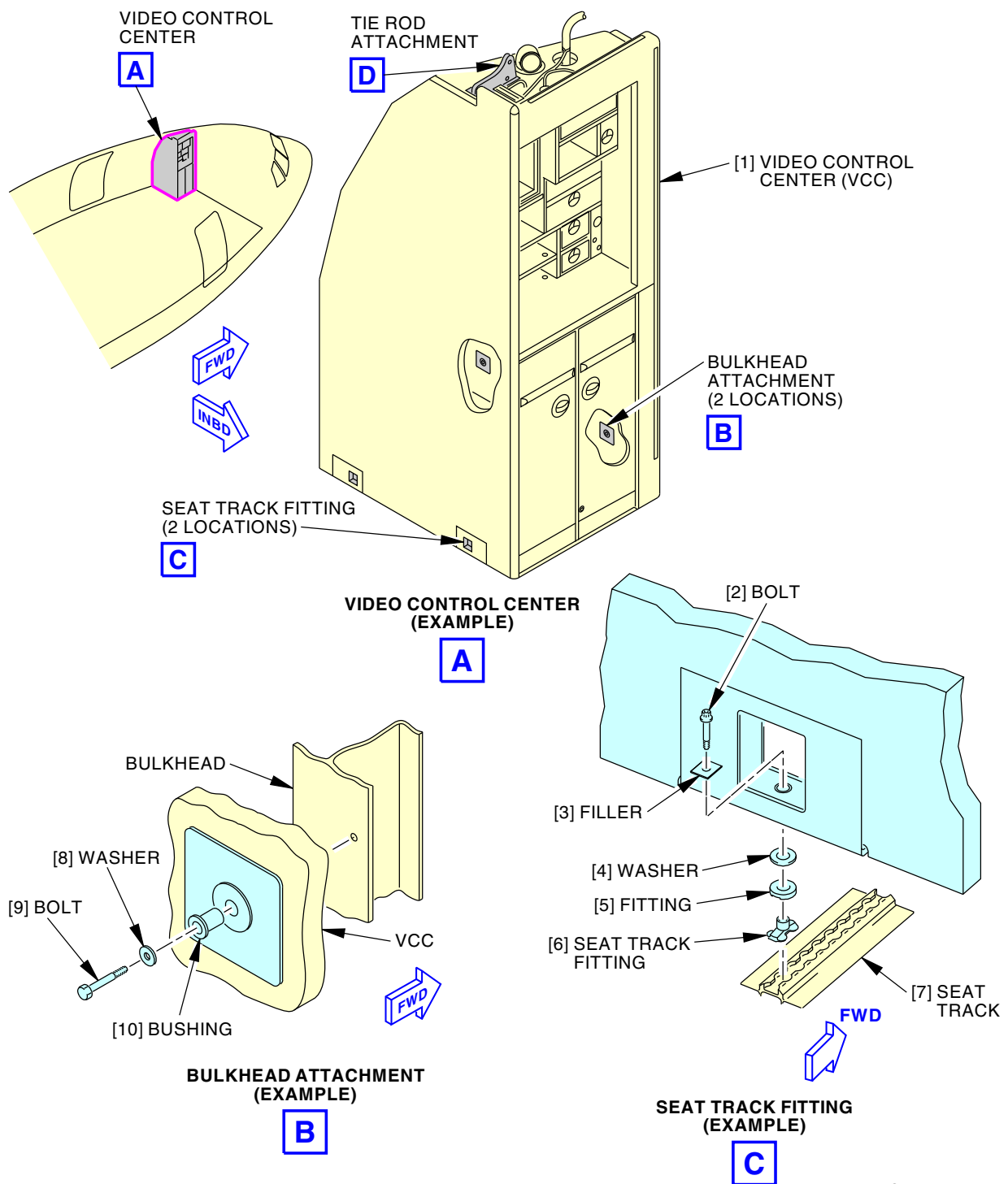
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ARO ALL

D633W101-ARO

25-24-10

Page 403
Sep 05/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL



1415911 S0000254662_V2

Video Control Center Installation
Figure 401/25-24-10-990-810 (Sheet 1 of 2)

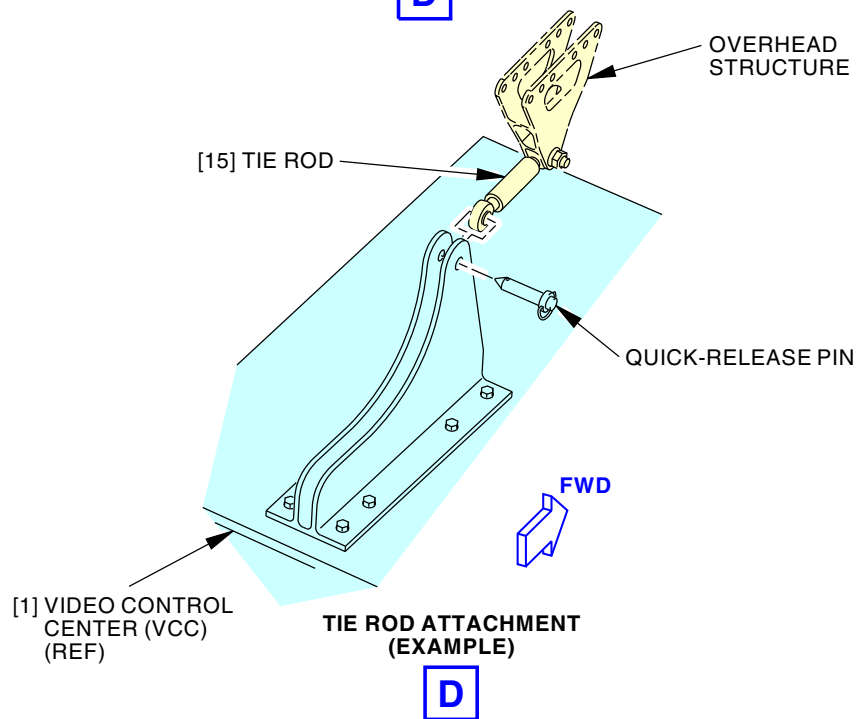
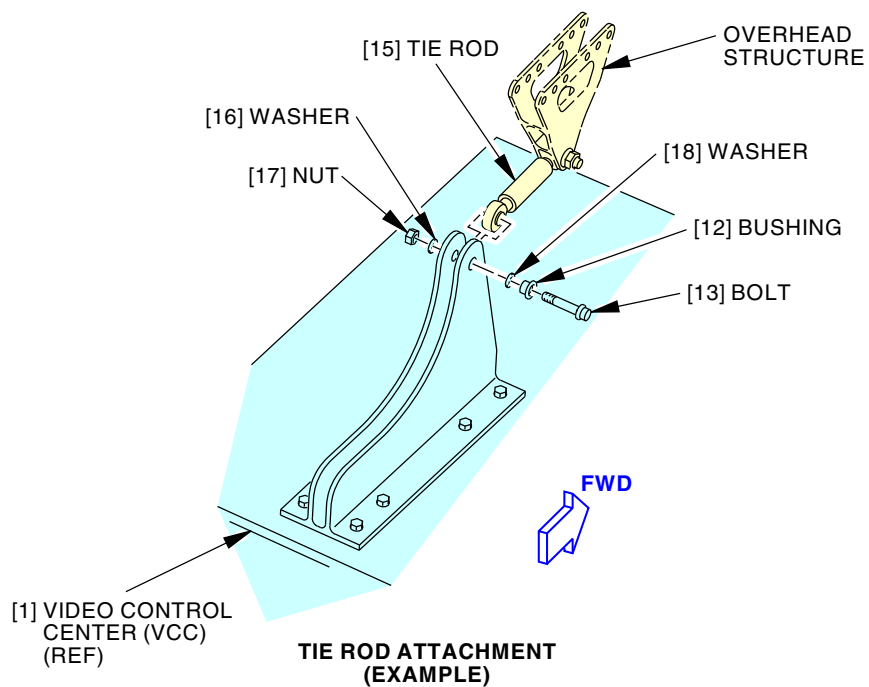
EFFECTIVITY
ARO ALL

25-24-10

D633W101-ARO

Page 404
Jan 05/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Video Control Center Installation
Figure 401/25-24-10-990-810 (Sheet 2 of 2)**

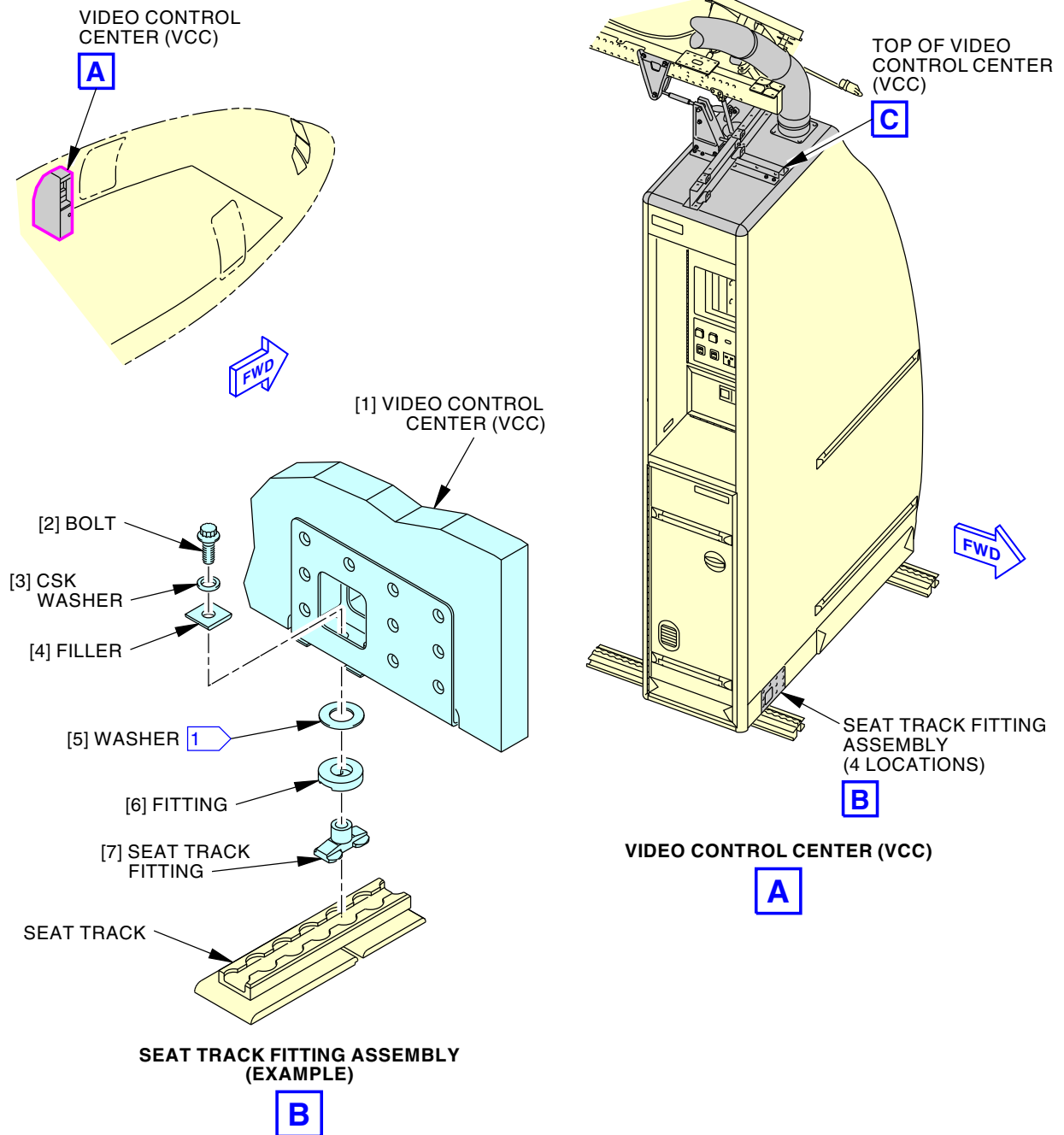
EFFECTIVITY
ARO ALL

D633W101-ARO

25-24-10

Page 405
Jan 05/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL



1 USE A MAXIMUM OF THREE WASHERS TO KEEP A LEVEL SURFACE BETWEEN THE FOUR SEAT TRACK POINTS. USE A MINIMUS NUMBER OF WASHERS TO PREVENT PRELOADING OF UPPER SUPPORT ATTACHMENT.

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Video Control Center Installation
Figure 402/25-24-10-990-815 (Sheet 1 of 2)

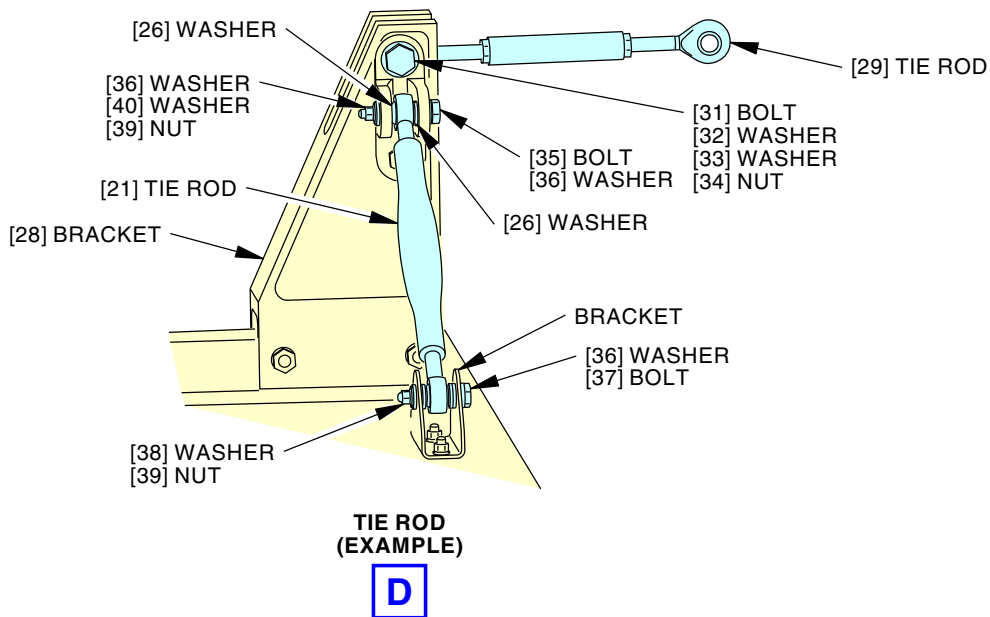
EFFECTIVITY
ARO 001-017

25-24-10

D633W101-ARO

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Page 406
Sep 05/2018



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Video Control Center Installation
Figure 402/25-24-10-990-815 (Sheet 2 of 2)

— EFFECTIVITY
ARO 001-017

25-24-10

Page 407
Sep 05/2018

D633W101-ARO



777-200/300 AIRCRAFT MAINTENANCE MANUAL

ARO ALL

TASK 25-24-10-400-808

3. Video Control Center (VCC) Installation

A. References

Reference	Title
25-21-06-400-801	Main Ceiling Panel - Installation (P/B 401)
25-41-01-400-801	Lavatory Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
G02304	Tape - Moisture Barrier, Adhesive One-side	BMS8-346

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. VCC Installation

Figure 401

SUBTASK 25-24-10-420-057

- (1) Do these steps to install the seat track fittings [6]:
 - (a) Do these steps in the areas that can get wet to prevent corrosion:
 - 1) Remove the used moisture barrier tape, G02304 from the area around the seat track fittings [6].
 - 2) Apply new moisture barrier tape, G02304 moisture barrier tape, G02304 with a cutout for the seat track fittings [6].
 - 3) Put corrosion preventive compound, C00308 in the seat track around the seat track fittings [6].
 - (b) Put the seat track fittings [6] in the circular opening in the seat track.
 - (c) Move the seat track fittings [6] forward or rearward 0.5 in. (1.3 cm) to lock it in the correct position for the installation.
 - 1) Install the fittings [5] on the seat track fittings [6] to lock it in place.
 - 2) If it is necessary, turn the fittings [5] to align them forward or rearward with the seat track fittings [6].

SUBTASK 25-24-10-860-021

- (2) Do this step to make sure the VCC [1] is perpendicular to the airplane floor:
 - (a) Install a maximum of three washers [4] on the top of the fittings [5] until the VCC [1] is perpendicular to the airplane floor.

SUBTASK 25-24-10-420-058

- (3) Align the VCC [1] with the seat track fittings.

SUBTASK 25-24-10-420-059

- (4) Lower the VCC [1] on the seat track fittings.

EFFECTIVITY
ARO ALL

25-24-10

D633W101-ARO

Page 408
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Make sure the fittings [5] and washers [4] stay between the seat track fittings and the VCC [1].

SUBTASK 25-24-10-420-060

- (5) Do these steps to attach each seat track fitting [6] to the airplane floor at the aft side of the VCC [1]:
 - (a) If applicable, install the filler [3] to the seat track fitting [6].
 - (b) Install the bolt [2] to attach the VCC [1] to the seat track fitting [6].
 - (c) Install the cover plate if applicable.

SUBTASK 25-24-10-420-061

- (6) For VCCs with bulkhead attachments, do this step:
 - (a) Install the bolts [9], washers [8] and bushings [10] which attach the VCC [1] to the adjacent structure.

SUBTASK 25-24-10-420-062

- (7) Do these steps to connect the top of the VCC [1]:
 - (a) Do one of the steps that follow to connect the tie rod [15]:
 - 1) Install the bolt [13], washers [18], [16], bushing [12] and nut [17] to attach the end of the tie rod [15] to the VCC truss.
 - 2) Install the quick-release pin to attach the end of the tie rod [15] to the VCC truss.
 - (b) Connect the electrical connectors in the VCC [1].
 - (c) Install the ground wires to the aircraft structure.
 - (d) Connect the ventilation ducts.

I ARO 001-017

E. VCC Installation

Figure 402

SUBTASK 25-24-10-420-070

- (1) Do these steps to install the seat track fittings [7]:
 - (a) Do these steps in the areas that can get wet to prevent corrosion:
 - 1) Remove the used tape and filler from the area around the seat track fittings.
 - 2) Apply new moisture barrier tape, G02304 with a cutout for the seat track fittings.
 - 3) Put compound, C00528 in the seat track and around the seat track fittings [7].
 - (b) Put the seat track fittings [7] in the circular opening in the seat track.
 - (c) Move the seat track fittings [7] forward or rearward 0.5 in. (1.3 cm) to lock it in the correct position for the installation.
 - 1) Install the fittings [6] and washers [5] on the seat track fittings [7] to lock it in place.
NOTE: Use a maximum of three washers [5] to keep a level surface between the seat track points. Use a minimum number of washers [5] to prevent preloading of upper support attachments.
 - 2) If necessary, turn the fittings [6] to align them forward or rearward with the seat track fittings [7].

SUBTASK 25-24-10-860-025

- (2) Align the VCC [1] with the seat track fittings.

EFFECTIVITY
ARO ALL

25-24-10

D633W101-ARO

Page 409
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

ARO 001-017 (Continued)

SUBTASK 25-24-10-420-071

- (3) Lower the VCC [1] on the seat track fittings.
 - (a) Make sure the fittings [6] and washers [5] stay between the seat track fittings and the VCC [1].

SUBTASK 25-24-10-420-072

- (4) Do these steps to attach the VCC [1] to each seat track fitting [7].
 - (a) If applicable, install the filler [4] to the seat track fitting [7].
 - (b) Install the csk washer [3] and bolt [2] to attach the VCC [1] to the seat track fitting [7].
 - 1) Tighten the bolt [2] to a torque value of 150 ± 5 in-lb (16.9 ± 0.6 N·m).
 - (c) Install the cover plate if applicable.

SUBTASK 25-24-10-420-073

- (5) Do these steps to connect the top of the VCC [1]:
 - (a) Remove the ground wires and electrical connectors from the airplane structure and bring to the VCC.
 - 1) Connect the ground wires to the VCC.
 - 2) Connect the electrical connectors to the VCC.
 - (b) Connect the wire harness assembly [22] and straps [24] as necessary to install the hose duct [23] to the VCC [1].
 - (c) Do these steps if necessary to install the bracket [28] and tie rod [21] to the VCC:
 - 1) Install the bolts [25], washers [26], and nuts [27] to install the bracket [28] with the tie rod [21] to the VCC [1].
 - 2) Position the tie rod [29] to the bracket [28].

NOTE: The tie rod [29] is adjustable to allow for the correct space between the brackets. Nominal tie rod length is 8.50 inches and adjustments of +/- 1.00 inch is permitted. There must be no preloading of the tie rod. Make sure that you can see the tie rod ends through the inspection holes.
 - 3) Install the nut [34], washers [33], [32], and bolt [31] to install the tie rod [29] to the bracket [28].
 - (d) Do these steps to connect the tie rod [21]:
 - 1) Position the tie rod [21] to the lower the lower VCC bracket.

NOTE: The tie rod [21] is adjustable to allow for the correct space between the brackets. Nominal tie rod length is 8.50 inches and adjustments of +/- 1.00 inch is permitted. There must be no preloading of the tie rod. Make sure that you can see the tie rod ends through the inspection holes.
 - 2) Install the nut [39], washers [38], bolt [37] and washers [36] to the lower VCC bracket.

ARO ALL

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-24-10-420-063

- (1) Do the following applicable tasks if necessary:
 - (a) Do this task: Main Ceiling Panel - Installation, TASK 25-21-06-400-801.

EFFECTIVITY
ARO ALL

25-24-10

D633W101-ARO

Page 410
Sep 05/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL

(b) Do this task: Lavatory Installation, TASK 25-41-01-400-801.

SUBTASK 25-24-10-430-003

(2) Close all applicable circuit breakers for the electrical connectors of the VCC [1].

SUBTASK 25-24-10-860-022

(3) If necessary, do the applicable tests to make sure that video systems are operational.

SUBTASK 25-24-10-860-023

(4) Do an operational test of the emergency or passenger info lights if applicable.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-24-10

Page 411
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

OUTLETS - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks:

- (1) Service outlets - deactivation.
- (2) Service outlets - activation.
- (3) Medical outlets - deactivation.
- (4) Medical outlets - activation.

TASK 25-24-15-040-801

2. Service Outlets - Deactivation

A. General

- (1) This task will deactivate the service outlets.

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-4355	Voltmeter
	Part #: 260-8XPI Supplier: 55026
	Opt Part #: 260 Supplier: 55026

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Procedure

SUBTASK 25-24-15-010-001

- (1) Open these circuit breakers and install safety tags:

Ground Service/Handling Power Panel, P320

Row	Col	Number	Name
---	---	C25432	SVCE OUTLET CEC
G	5	C25400	SVCE OUTLET DR 1L
G	6	C25403	SERVICE OUTLET DOOR 4
H	6	C25401	SVCE OUTLET DR 2L
H	12	C25402	SVCE OUTLET DR 3L
J	6	C25412	SVCE OUTLET DR 5
L	8	C25404	SVCE OUTLET E/E BAY
L	13	C25405	SVCE OUTLET F/D AC

Right Power Management Panel, P210

Row	Col	Number	Name
J	8	C25600	SVCE OUTLET F/D DC

E. Service Outlets - Tryout

NOTE: This tryout is to make sure that the service outlets are in a zero energy state.

EFFECTIVITY
ARO ALL

25-24-15

D633W101-ARO

Page 201
Jan 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-24-15-760-003

- (1) Use a voltmeter, COM-4355 to measure the voltage at these outlets:

Outlet	Location
D25030	DR1L, DR2L, DR3L, DR4L, DR5L, CEC
D25034	EE-Bay
D25035	Flight Compartment

- (a) Make sure that there is less than 15VAC across the terminals.

————— END OF TASK —————

TASK 25-24-15-440-801

3. Service Outlets - Activation

A. General

- (1) This task will activate the service outlets.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-24-15-410-001

- (1) Remove the safety tags and close these circuit breakers:

Ground Service/Handling Power Panel, P320

Row	Col	Number	Name
---	---	C25432	SVCE OUTLET CEC
G	5	C25400	SVCE OUTLET DR 1L
G	6	C25403	SERVICE OUTLET DOOR 4
H	6	C25401	SVCE OUTLET DR 2L
H	12	C25402	SVCE OUTLET DR 3L
J	6	C25412	SVCE OUTLET DR 5
L	8	C25404	SVCE OUTLET E/E BAY
L	13	C25405	SVCE OUTLET F/D AC

Right Power Management Panel, P210

Row	Col	Number	Name
J	8	C25600	SVCE OUTLET F/D DC

————— END OF TASK —————

TASK 25-24-15-040-803

4. Medical Outlets - Deactivation

A. General

- (1) This task will deactivate the medical outlets.

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

EFFECTIVITY
ARO ALL

25-24-15

D633W101-ARO

Page 202
Jan 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

Reference	Description
COM-4355	Voltmeter Part #: 260-8XPI Supplier: 55026 Opt Part #: 260 Supplier: 55026

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Procedure

SUBTASK 25-24-15-010-002

- (1) Open this circuit breaker and install safety tag:

Left Power Management Panel, P110

Row	Col	Number	Name
K	10	C25325	MED OUTLET FREQ CONV L

E. Medical Outlets - Tryout

NOTE: This tryout is to make sure that the medical outlets are in a zero energy state.

SUBTASK 25-24-15-760-002

- (1) Use a voltmeter, COM-4355 to measure the voltage at the applicable outlets.
(a) Make sure that there is less than 15VAC between the power and return contacts.

————— END OF TASK —————

TASK 25-24-15-440-803

5. Medical Outlets - Activation

A. General

- (1) This task will activate the medical outlets.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-24-15-410-003

- (1) Remove the safety tag and close this circuit breaker:

Left Power Management Panel, P110

Row	Col	Number	Name
K	10	C25325	MED OUTLET FREQ CONV L

————— END OF TASK —————

EFFECTIVITY
ARO ALL

25-24-15

D633W101-ARO

Page 203
Jan 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

Service Outlets - Removal/Installation

1. General

A. This procedure contains these tasks:

- (1) Removal of the service outlet
- (2) Installation of the service outlet

TASK 25-24-15-000-801

2. Service Outlet - Removal

A. Location Zones

<u>Zone</u>	<u>Area</u>
200	Upper Half of Fuselage

B. Prepare for the Removal

SUBTASK 25-24-15-860-001

- (1) Open these circuit breakers and install safety tags:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
G	5	C25400	SVCE OUTLET DR 1L
H	6	C25401	SVCE OUTLET DR 2L
H	12	C25402	SVCE OUTLET DR 3L
J	6	C25412	SVCE OUTLET DR 5
L	8	C25404	SVCE OUTLET E/E BAY
L	13	C25405	SVCE OUTLET F/D AC

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	8	C25600	SVCE OUTLET F/D DC

C. Remove the Outlet

SUBTASK 25-24-15-020-001

- (1) Remove the screws, washers, and bolts that attach the receptacle mounting plate to the structure.

SUBTASK 25-24-15-020-002

- (2) Remove the receptacle.

SUBTASK 25-24-15-020-003

- (3) Remove the screws, washers, and bolts that attach the outlet to the receptacle mounting plate.

SUBTASK 25-24-15-020-004

- (4) Disconnect the connectors.

SUBTASK 25-24-15-020-005

- (5) Remove the outlet.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-24-15

Page 401
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-24-15-400-801

3. Service Outlet - Installation

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Install the Outlet

SUBTASK 25-24-15-420-001

- (1) Put the outlet in its position on the receptacle mounting plate.

SUBTASK 25-24-15-420-002

- (2) Connect the connectors to the outlet.

SUBTASK 25-24-15-420-003

- (3) Install the screws, nuts and washers that attach the outlet to the receptacle mounting plate.

SUBTASK 25-24-15-420-004

- (4) Put the mounting plate in its correct position on the structure.

SUBTASK 25-24-15-420-005

- (5) Install the screws, nuts and washers that attach the receptacle mounting plate to the structure..

C. Return the Airplane to Its Usual Condition

SUBTASK 25-24-15-860-002

- (1) Remove the safety tags and close these circuit breakers:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
G	5	C25400	SVCE OUTLET DR 1L
H	6	C25401	SVCE OUTLET DR 2L
H	12	C25402	SVCE OUTLET DR 3L
J	6	C25412	SVCE OUTLET DR 5
L	8	C25404	SVCE OUTLET E/E BAY
L	13	C25405	SVCE OUTLET F/D AC

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	8	C25600	SVCE OUTLET F/D DC

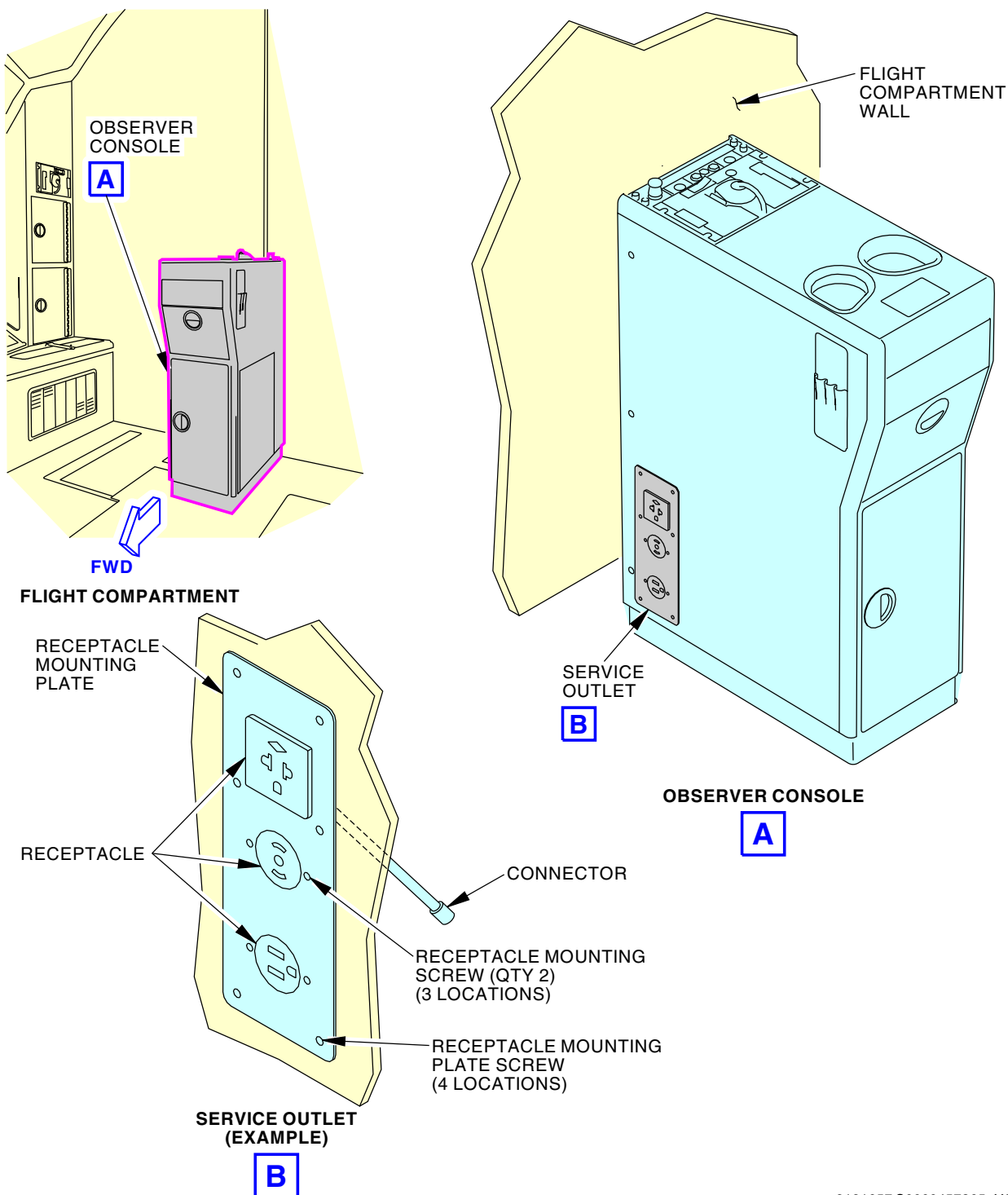
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EFFECTIVITY
ARO ALL

25-24-15

D633W101-ARO

Page 402
Jan 05/2015



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**Service Outlet Installation
Figure 401/25-24-15-990-801**

EFFECTIVITY
ARO ALL

25-24-15



777-200/300
AIRCRAFT MAINTENANCE MANUAL
CURTAIN TRACK - REMOVAL/INSTALLATION

1. General

A. This procedure contains these tasks:

- (1) Removal of the curtain track and header panel
- (2) Installation of the curtain track and header panel
- (3) Removal of the ceiling mounted curtain track
- (4) Installation of the ceiling mounted curtain track

B. The curtain track and the header panel are removed as a single component. Five screws attach the header panel to the track.

TASK 25-24-50-020-801

2. Curtain Track and Header Panel - Removal

A. Location Zones

Zone	Area

200	Upper Half of Fuselage

B. Remove the curtain track and panel header

SUBTASK 25-24-50-020-001

- (1) To remove the curtain track and panel header do the steps that follow:
 - (a) Remove the curtain from the track if it is necessary.
 - (b) Remove the two screws [1] from the curtain track end fitting [2].
 - (c) Remove the curtain track and header panel [3].

———— **END OF TASK** ————

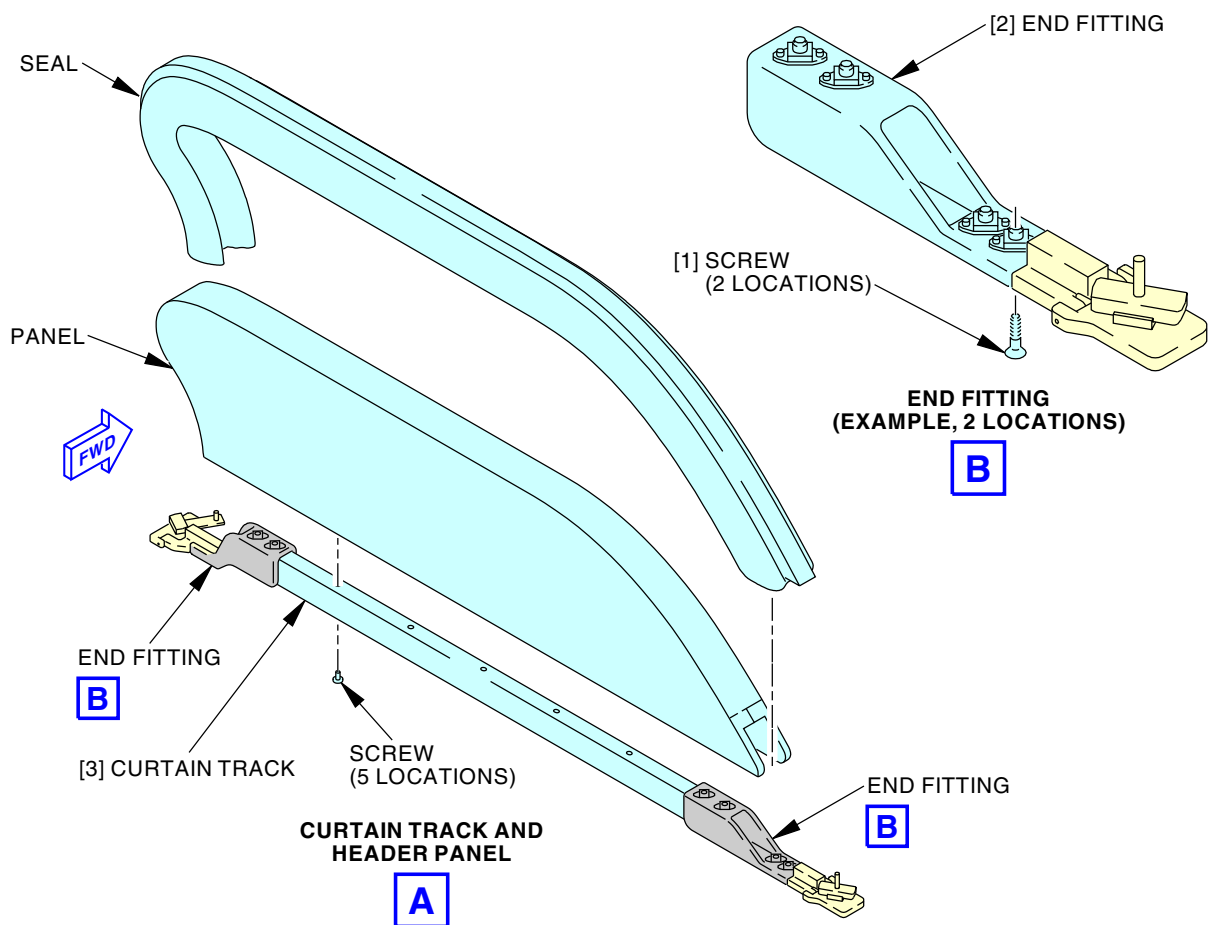
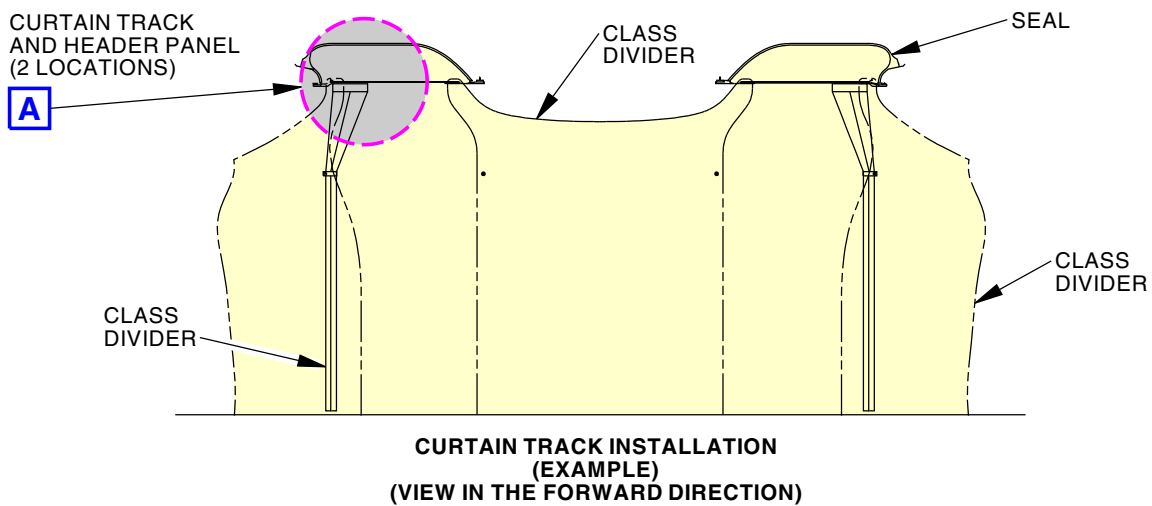
EFFECTIVITY
ARO ALL

D633W101-ARO

25-24-50

Page 401
Jan 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Curtain Track and Header Panel Installation
Figure 401/25-24-50-990-801**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-24-50

Page 402
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-24-50-420-801

3. Curtain Track and Header Panel - Installation

A. Location Zones

Zone	Area

200	Upper Half of Fuselage

B. Install the curtain track and header panel.

SUBTASK 25-24-50-420-001

- (1) To install the curtain track and header panel do the steps that follow:
 - (a) Put the curtain track and header panel in its correct position.
 - (b) Install the two screws to the track end fitting.
 - (c) Install the curtain if it was removed.

————— **END OF TASK** —————

TASK 25-24-50-000-801

4. Ceiling Mounted Curtain Track - Removal

A. General

- (1) This task includes the steps to remove the galley curtain track assembly from the passenger ceiling structure.

B. Location Zones

Zone	Area

200	Upper Half of Fuselage

C. Ceiling Curtain Track Removal

SUBTASK 25-24-50-020-002

- (1) To remove the curtain from the curtain track [1], do these steps:
 - (a) Loosen the curtain tie-back snap [6].
 - (b) Remove the end cap [10] at the end of the curtain track [1].
 - (c) Move the curtain sliders [4] off of the curtain track [1].
 - (d) Remove the curtain.

SUBTASK 25-24-50-020-003

- (2) Remove the screws [2] and [3] that attach the curtain track [1] to the ceiling structure.
 - (a) Remove the curtain track [1].

————— **END OF TASK** —————

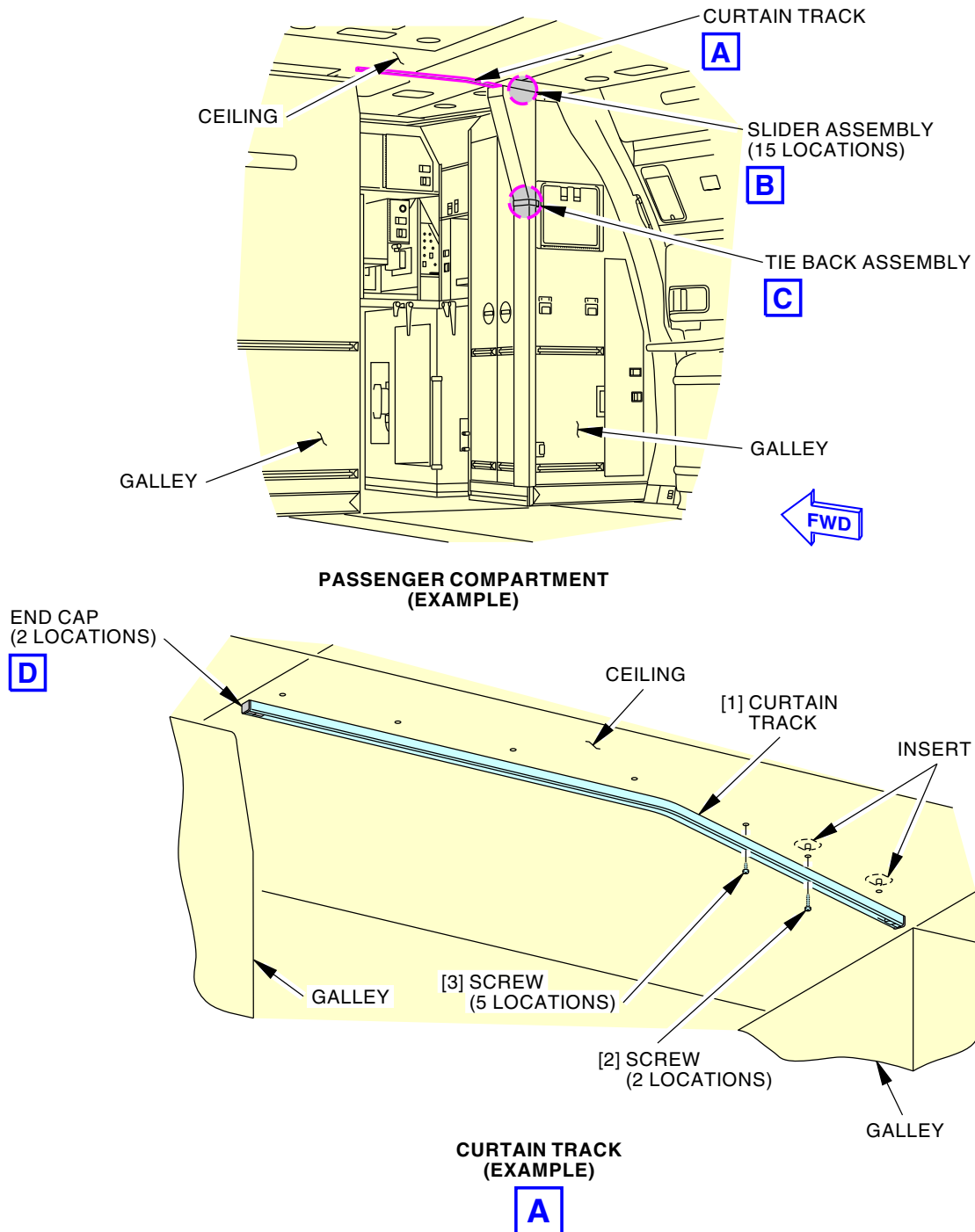
EFFECTIVITY
ARO ALL

25-24-50

D633W101-ARO

Page 403
Jan 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Ceiling Mounted Curtain Track Installation
Figure 402/25-24-50-990-802 (Sheet 1 of 3)**

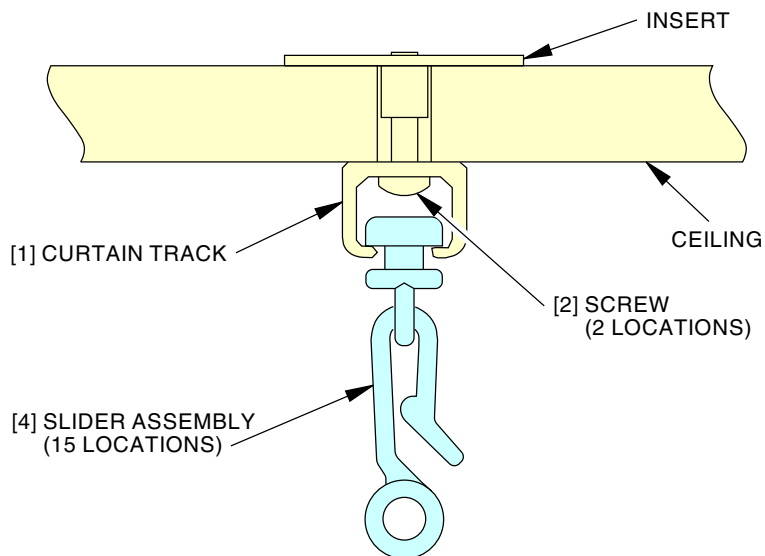
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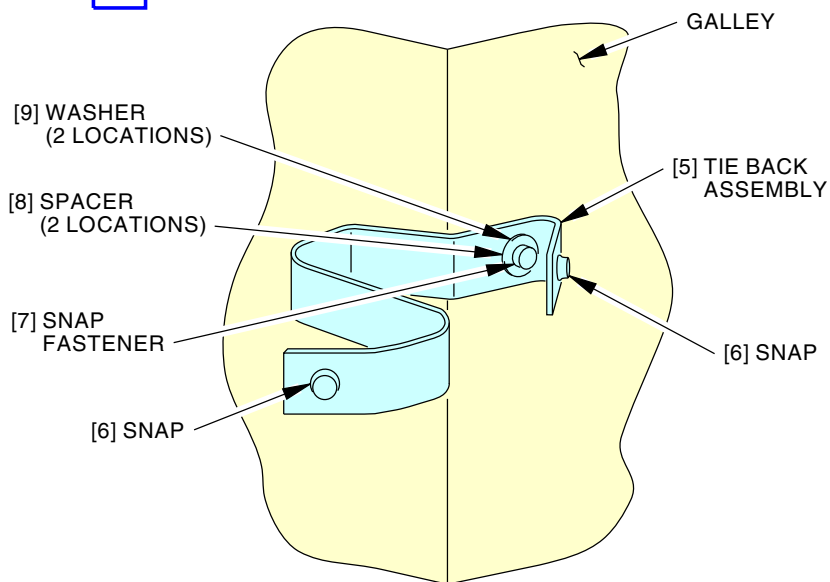
Page 404
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**SLIDER ASSEMBLY
(EXAMPLE)**

B



**TIE BACK ASSEMBLY
(CURTAIN NOT SHOWN)
(EXAMPLE)**

C

2187733 S0000475724_V2

**Ceiling Mounted Curtain Track Installation
Figure 402/25-24-50-990-802 (Sheet 2 of 3)**

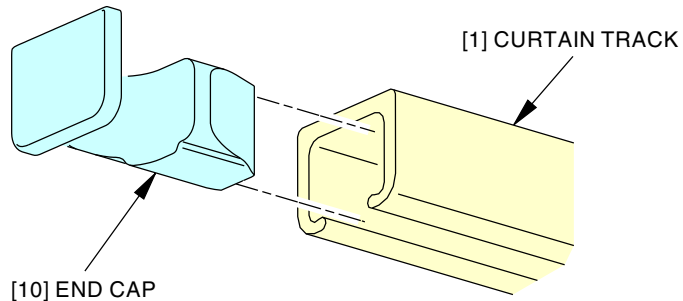
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25-24-50

D633W101-ARO

Page 405
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



END CAP
(EXAMPLE)

D

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Ceiling Mounted Curtain Track Installation
Figure 402/25-24-50-990-802 (Sheet 3 of 3)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-24-50

Page 406
May 05/2017



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

TASK 25-24-50-400-801

5. Ceiling Mounted Curtain Track - Installation

A. General

- (1) This task includes the steps to install the ceiling mounted curtain track assembly.

B. Location Zones

Zone	Area

200	Upper Half of Fuselage

C. Ceiling Mounted Curtain Track Installation

SUBTASK 25-24-50-420-002

- (1) Put the curtain track [1] into position
(a) Install the screws [2], [3].

D. Curtain Installation

SUBTASK 25-24-50-420-003

- (1) Put the curtain sliders [4] on to the curtain track [1].

SUBTASK 25-24-50-420-005

- (2) Install the end cap [10].

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-24-50

Page 407
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

PASSENGER SEATS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Removal of the passenger seat
 - (2) Installation of the passenger seat
- B. Observe and record the location of parts, routing of cables, etc. for all applicable seats to help installation.

TASK 25-25-01-000-801

2. Passenger Seat - Removal

(Figure 401 or Figure 402)

A. **General**

- (1) This procedure does not apply to pallet-mounted seat assemblies.

B. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-6916	Gantry - Seat Part #: G25010-167 Supplier: 81205 Part #: G25010-169 Supplier: 81205 Opt Part #: G25010-133 Supplier: 81205
SPL-6918	Cart - Passenger Seat Part #: J25008-1 Supplier: 81205
SPL-13693	Cart Equipment - Passenger Seats Part #: J25015-1 Supplier: 81205

C. **Location Zones**

Zone	Area
200	Upper Half of Fuselage

D. **Prepare for the Removal**

SUBTASK 25-25-01-860-018

- (1) Make sure that the switch for the emergency lighting is in the OFF position.

NOTE: The switch is on the P5 panel.

SUBTASK 25-25-01-020-065

- (2) Do these steps to remove power to the seats if needed:
 - (a) For the zones that you will remove electrically powered seats from:
Open these circuit breakers and install safety tags:

Left Power Management Panel, P110

Row	Col	Number	Name
A	24	C23357	IFE ZIA 2
F	16	C25311	PAX SEATS L

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-01

Page 401
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	5	C23356	IFE ZIA 1
F	10	C25312	PAX SEATS R
F	13	C25314	PAX SEATS C

- (b) FOR SEATS WITH IN-FLIGHT ENTERTAINMENT;

Set the switch for the in-flight entertainment system to the OFF position.

NOTE: The switch is in the purser station, purser work station, or the video control center.

- (c) FOR SEATS WITH IN-SEAT (PC) POWER;

Set the switch for the in-seat (PC) power system to the OFF position.

NOTE: The switch is in the purser station, purser work station, or the video control center.

- (d) FOR SEATS WITH POWERED ACTUATORS/MOTORS AND IN-SEAT READING LIGHTS;

Set the switch for the powered actuators/motors and in-seat reading lights to the OFF position.

NOTE: The switch is in the purser station, purser work station, or the video control center.

ARO ALL; SEATS WITH INFLATABLE SEAT BELTS

SUBTASK 25-25-01-840-012



DO NOT CONNECT THE BUCKLE OF THE SEAT BELT HALVES UNTIL THE SYSTEM, AND THE SEAT ARE CORRECTLY INSTALLED IN THE AIRCRAFT. IF YOU CONNECT THE SEAT BELT HALVES, THE AIRBAG CAN ACCIDENTALLY FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.



MAKE SURE THAT THE BUCKLE OF THE SEAT BELT IS OPEN (UNBUCKLED) BEFORE YOU REMOVE THE AIRBAG BELT ASSEMBLY. IF THE BUCKLE IS CONNECTED, THE AIRBAG CAN ACCIDENTALLY FIRE.

- (3) If necessary, do either of these steps:

- (a) Remove the buckle half of the seat belt to prevent possible deployment of the airbag.
- (b) Install a safety tie through the belt tongue to prevent buckling of the seat belt.

ARO ALL

E. Passenger Seat Removal

SUBTASK 25-25-01-020-001

- (1) Remove the forward and rear seat track cover [8], if applicable.

SUBTASK 25-25-01-020-002

- (2) Disconnect the electrical connectors [6] for the seat electronics box and emergency lights.

SUBTASK 25-25-01-020-300

- (3) For Business Class Seats, do these steps:

NOTE: This task applies to B/E Aerospace Diamond Business Class seats.

EFFECTIVITY
ARO ALL

25-25-01

D633W101-ARO

Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Loosen the forward anti-rattle device [3].
- (b) Loosen the aft track fitting screw [9].

SUBTASK 25-25-01-020-214

- (4) For Premium Economy class seats, do these steps:

NOTE: This task applies to the BE Aerospace Model 7.2 Icon premium economy class seat.

- (a) Loosen the set screw on the front fitting.

NOTE: This will loosen the plunger that attaches the studs to the seat tracks.

- (b) Loosen the anti-rattle clamp.
- (c) Loosen the screw on the top of the aft fitting.

NOTE: This will loosen the plunger that attaches the studs to the seat tracks.

- (d) Move the seat assembly forward or aft 0.5 in. (12.7 mm).
- (e) Lift seat off seat tracks.

SUBTASK 25-25-01-020-317

- (5) For Economy Class seats, do these steps:

NOTE: This task applies to B/E Aerospace Pinnacle Economy Class seats.

- (a) Loosen the front anti-rattle device [3].
- (b) Loosen the rear seat track fitting screw [9].

SUBTASK 25-25-01-820-001

- (6) Move the seat [1] forward or aft approximately 1/2 inch to align the flanges on the seat track fittings [10] with the holes in the seat tracks [2].

SUBTASK 25-25-01-020-005



CAREFULLY LIFT, LOWER, OR MOVE THE SEATS. INJURIES TO PERSONNEL CAN OCCUR BECAUSE SEATS CAN WEIGH AS MUCH AS 400 POUNDS.

- (7) Lift the seat [1] and remove it.

NOTE: If necessary, use four personnel to remove the seat. As an option to manual removal of seats, use these tools: seat gantry, SPL-6916, seat cart, SPL-6918 or, seat cart, SPL-13693.

————— END OF TASK —————

TASK 25-25-01-400-801

3. Passenger Seat - Installation

(Figure 401 or Figure 402)

A. General

- (1) This procedure does not apply to pallet-mounted seat assemblies.

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

EFFECTIVITY
ARO ALL

25-25-01

D633W101-ARO

Page 403
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

Reference	Description
SPL-6916	Gantry - Seat Part #: G25010-167 Supplier: 81205 Part #: G25010-169 Supplier: 81205 Opt Part #: G25010-133 Supplier: 81205
SPL-6918	Cart - Passenger Seat Part #: J25008-1 Supplier: 81205
SPL-13693	Cart Equipment - Passenger Seats Part #: J25015-1 Supplier: 81205

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Passenger Seat Installation

SUBTASK 25-25-01-820-002



WARNING

CAREFULLY LIFT, LOWER, OR MOVE THE SEATS. INJURIES TO PERSONNEL CAN OCCUR BECAUSE SEATS CAN WEIGH AS MUCH AS 400 POUNDS.

- (1) Put the seat [1] in the correct position in the seat tracks [2].

NOTE: If necessary, use four personnel to install the seat. As an option to the manual installation of seats, use these tools: seat gantry, SPL-6916, seat cart, SPL-6918 or, seat cart, SPL-13693.

SUBTASK 25-25-01-820-003

- (2) Move the seat [1] in the forward or aft direction to get the correct seat pitch.

SUBTASK 25-25-01-210-001

- (3) Make sure the flanges on the seat track fittings [10] engage between two circular cutouts in the seat track [2].

SUBTASK 25-25-01-420-319

- (4) For Business Class seats, do these steps:

NOTE: This task applies to the B/E Aerospace Diamond Business Class seats.

- (a) Tighten the aft screw [9] to 60 ±10 in-lb (6.78 ±1.13 N·m).

NOTE: The screw is installed correctly when the screw head is flush with the top of the seat track fitting.

- (b) Tighten the front anti-rattle device [3] manually plus 1/4 turn.

SUBTASK 25-25-01-420-154

- (5) For Premium Economy Class seats, do these steps:

NOTE: This task applies to B/E Aerospace Model Icon Economy Class seats.

- (a) Tighten the aft screw [9] to 60 ±10 in-lb (6.78 ±1.13 N·m).

NOTE: The screw is installed correctly when the screw head is flush with the top of the seat track fitting.

- (b) Tighten the front anti-rattle device [3] manually plus 1/4 turn.

EFFECTIVITY
ARO ALL

25-25-01

D633W101-ARO

Page 404
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-25-01-420-340

- (6) For Economy Class seats, do these steps:

NOTE: This task applies to the B/E Aerospace Pinnacle Economy Class seats.

- (a) Tighten the rear screw [9] to 60 ± 10 in-lb (6.78 ± 1.13 N·m).
- (b) Tighten the front anti-rattle [3] device manually plus 1/4 turn.

SUBTASK 25-25-01-210-002

- (7) Examine the seat track fittings [10] to make sure they are correctly installed in the seat tracks [2] (Figure 401 or Figure 402).

SUBTASK 25-25-01-210-011

- (8) Visually examine the cables to the seat electronics box for damaged sheathing, retention devices or connectors. If the cable is damaged, repair or replace the cable.

SUBTASK 25-25-01-420-004

- (9) Connect the electrical connectors [6] for the seat electronics box and emergency lights.

SUBTASK 25-25-01-860-017



WARNING INSTALL THE SEAT TRACK WIRING IN THE RACEWAY AND BELOW THE SEAT TRACK COVERS. IF THE WIRING IS NOT INSTALLED CORRECTLY, PASSENGERS AND MAINTENANCE PERSONNEL ARE EXPOSED TO SHOCK HAZARDS THAT COULD RESULT IN SERIOUS INJURY OR DEATH.

- (10) Make sure the seat wiring is correctly installed in the seat track raceway.

SUBTASK 25-25-01-420-005

- (11) Install the seat track cover [8] in front of and behind the seat [1].

E. Passenger Seat Installation Test

SUBTASK 25-25-01-860-025

- (1) Do these steps to restore power to the seats if it is necessary:
- (a) For the zones that you installed the electrically powered seats in:
Remove the safety tags and close these circuit breakers:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	24	C23357	IFE ZIA 2
F	16	C25311	PAX SEATS L

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	5	C23356	IFE ZIA 1
F	10	C25312	PAX SEATS R
F	13	C25314	PAX SEATS C

- (b) FOR SEATS WITH IN-FLIGHT ENTERTAINMENT;
Set the switch for the in-flight entertainment system to the ON position.
NOTE: The switch is in the purser station, purser work station, or the video control center.
- (c) FOR SEATS WITH IN-SEAT (PC) POWER;

EFFECTIVITY
ARO ALL

25-25-01

D633W101-ARO

Page 405
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

Set the switch for the in-seat (PC) power system to the ON position.

NOTE: The switch is in the purser station, purser work station, or the video control center.

- (d) FOR SEATS WITH POWERED ACTUATORS/MOTORS AND IN-SEAT READING LIGHTS;

Set the switch for the powered actuators/motors and in-seat reading lights to the ON position.

NOTE: The switch is in the purser station, purser work station, or the video control center.

ARO ALL; SEATS WITH INFLATABLE SEAT BELTS

SUBTASK 25-25-01-840-013



DO NOT CONNECT THE BUCKLE OF THE SEAT BELT HALVES UNTIL THE SYSTEM, AND THE SEAT ARE CORRECTLY INSTALLED IN THE AIRCRAFT. IF YOU CONNECT THE SEAT BELT HALVES, THE AIRBAG CAN ACCIDENTALLY FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.



MAKE SURE THAT THE BUCKLE OF THE SEAT BELT IS OPEN (UNBUCKLED) BEFORE YOU REMOVE THE AIRBAG BELT ASSEMBLY. IF THE BUCKLE IS CONNECTED, THE AIRBAG CAN ACCIDENTALLY FIRE.

- (2) If necessary, do either of these steps:
- (a) Install the buckle half of the seat belt to the passenger seat.
 - (b) Remove the safety tie from the seat belt tongue.

ARO ALL

SUBTASK 25-25-01-710-003

- (3) If you installed seats that have emergency lights, then do these steps:
- (a) At an applicable attendant switch panel, set the test switch for the emergency lights to the ON mode.

NOTE: Do not use the attendant emergency light switch.

- 1) Quickly make sure the lights on the seats you installed come on.
- 2) After one minute, make sure the lights go off automatically.

SUBTASK 25-25-01-710-050

- (4) FOR SEATS WITH IN-SEAT (PC) POWER;
- Make sure that there is power at the power outlet.

————— END OF TASK —————

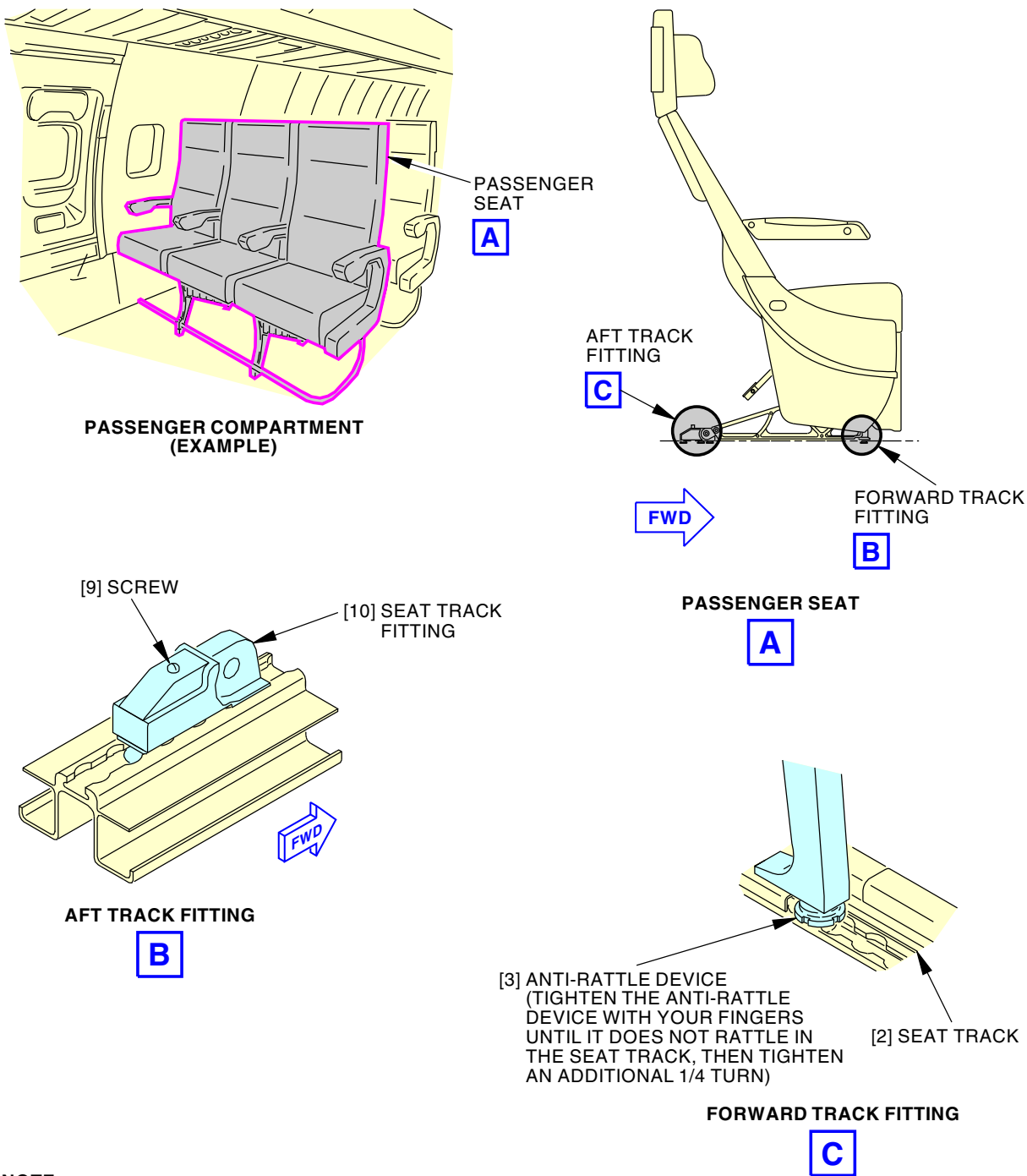
EFFECTIVITY
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D633W101-ARO

25-25-01

Page 406
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



NOTE:

MAKE SURE THAT THE FRONT STUD IS ENGAGED IN THE SEAT TRACK.

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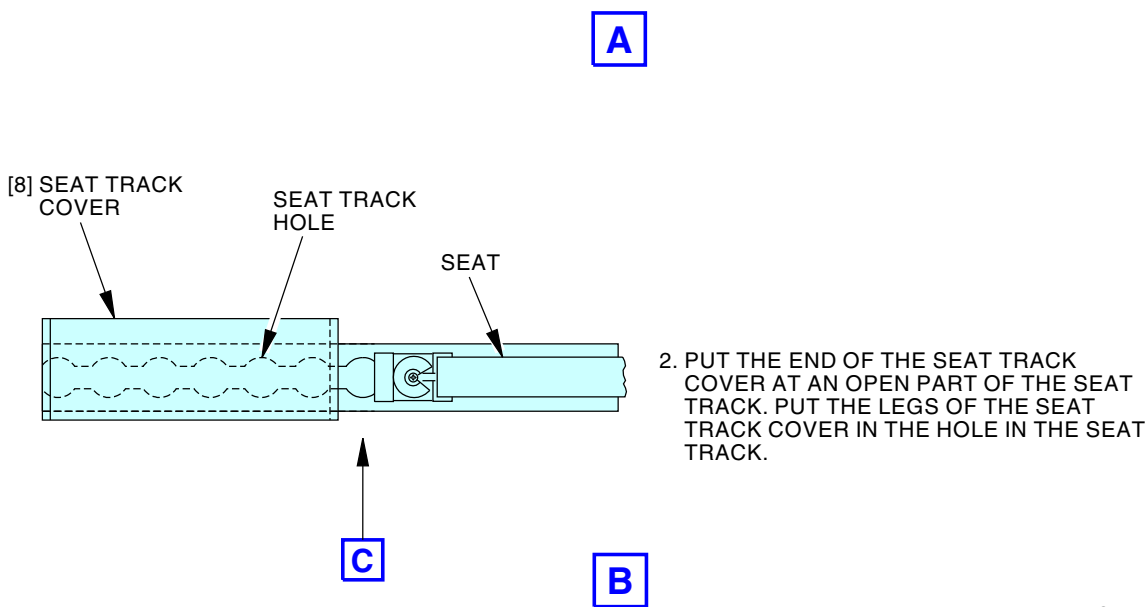
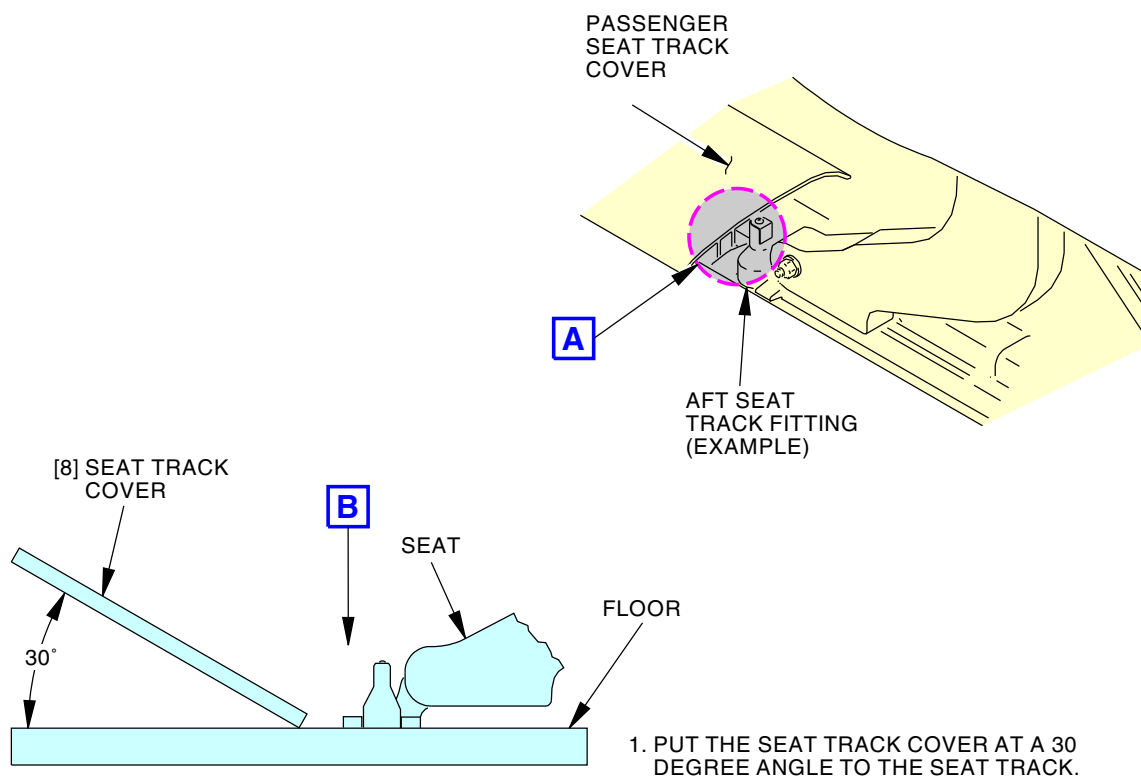
Passenger Seat Installation
Figure 401/25-25-01-990-801

EFFECTIVITY
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D633W101-ARO

25-25-01

Page 407
Jan 05/2018



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**Seat Track Cover Installation
Figure 402/25-25-01-990-838 (Sheet 1 of 3)**

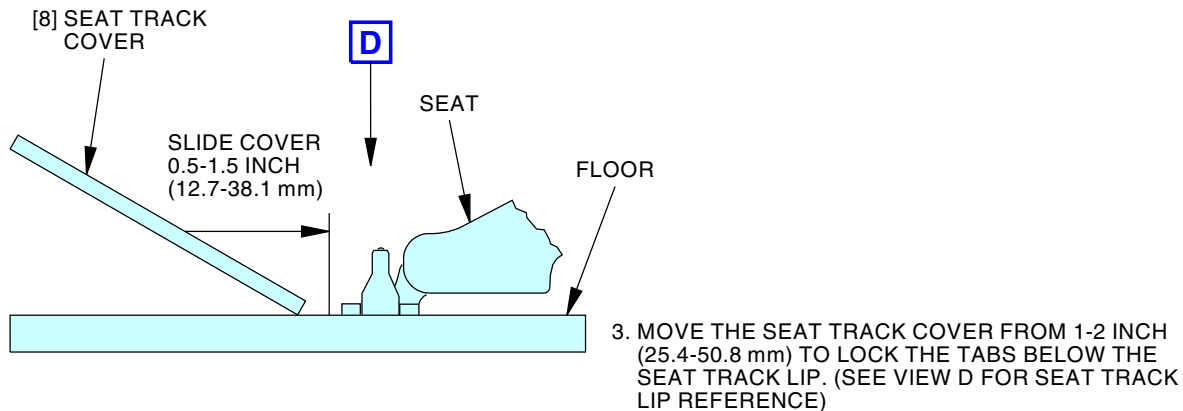
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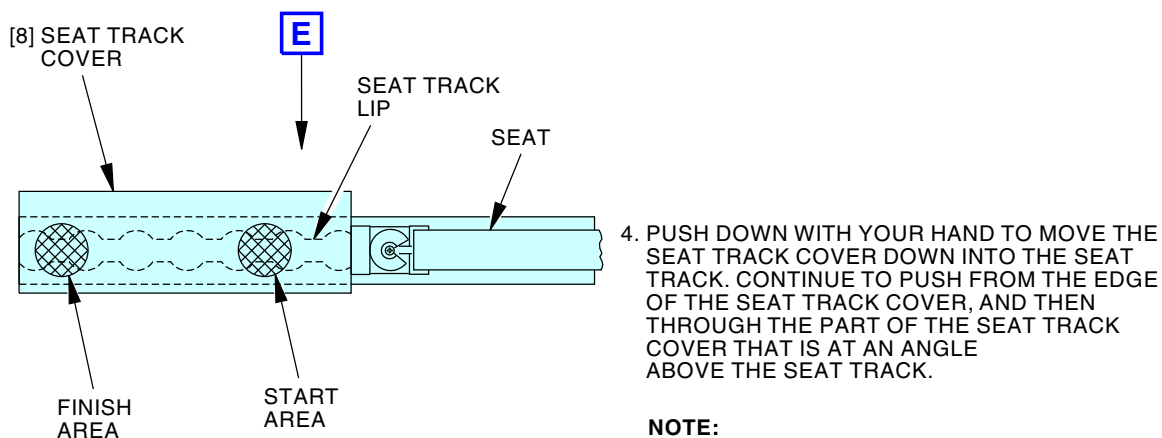
25-25-01

Page 408
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



C



NOTE:

WHEN YOU PUSH DOWN, MOVE ALONG THE SEAT TRACK COVER IN 4-6 INCH (101.6-152.4 mm) INCREMENTS.

CONTINUE TO DECREASE THE ANGLE ON THE PART OF THE SEAT TRACK COVER TO BE INSTALLED. YOU CAN TWIST OR USE A SMALL QUANTITY OF SIDE TO SIDE MOVEMENT TO HELP INSTALL THE SEAT TRACK COVER.

D

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**Seat Track Cover Installation
Figure 402/25-25-01-990-838 (Sheet 2 of 3)**

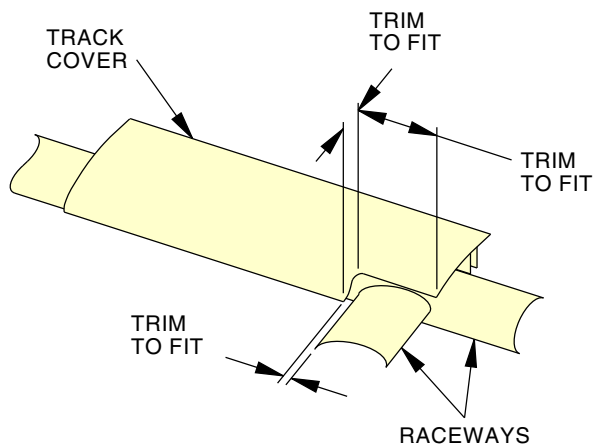
EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-01

Page 409
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



5. TRIM THE TRACK COVER AT RACEWAY INTERSECTIONS AS REQUIRED TO PREVENT TRACK COVER FROM ELEVATING FROM CARPET SURFACE AND TO ENSURE A HIGHER QUALITY FINAL INSTALLATION AND BEST APPEARANCE.

NOTE:

TRIM TRACK COVER LEGS AND EDGES, AROUND TRANSVERSE RACEWAY, AS NECESSARY, TO ALLOW TRACK COVER TO LIE FLAT. LEFT SIDE IS SHOWN, RIGHT SIDE IS ALMOST THE SAME.

E

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**Seat Track Cover Installation
Figure 402/25-25-01-990-838 (Sheet 3 of 3)**

EFFECTIVITY
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D633W101-ARO

25-25-01

Page 410
May 05/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL
PASSENGER SEATS - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) An inspection of the seat track fittings for the passenger seats
 - (2) A check of the passenger seat belt
 - (3) A check of the passenger seat back recline and breakover
 - (4) An Inspection of the Inflatable Seat Belt

TASK 25-25-01-200-801

2. Passenger Seat Attachment Inspection

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
25-25-01-400-801	Passenger Seat - Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
G01288	Tape - Carpet	BMS5-133

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Procedure

SUBTASK 25-25-01-210-007

- (1) Do the check that follows for the seat track fittings:
 - (a) Remove the seat track cover.
 - (b) Pull back the carpet.
 - (c) Look at the seat track fitting to make sure it is all the way down in the seat track.
 - 1) Make sure the shear plunger is fully engaged in the seat track.
 - (d) Try to move the seat track fitting.
 - 1) Make sure the seat track fitting is fully engaged in the seat track. If it is not fully engaged, tighten the fitting as shown in (TASK 25-25-01-400-801).

NOTE: Make sure you use the correct reference for the type of passenger seat to be installed.
 - 2) Make sure the anti-rattle device on the forward seat track fitting is fully engaged in the seat track. If it is not fully engaged tighten the fitting as shown in (TASK 25-25-01-400-801).

NOTE: Make sure you use the correct reference for the type of passenger seat to be installed.
 - (e) Put the carpet down against the seat track.
 - 1) If it is necessary, install new carpet tape, G01288, on the carpet.
 - 2) Visually examine the seat electronics box cable for damaged sheathing, retention devices or connectors. If the cable is damaged, repair or replace the cable.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-01

Config 1
Page 601
May 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (f) Install the seat track cover.

————— **END OF TASK** —————

TASK 25-25-01-200-802

3. Passenger Seat Belt Check

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-25-01-210-008

- (1) Do a visual check to make sure the seat belts are not worn, frayed, or damaged.

SUBTASK 25-25-01-280-001

- (2) Pull on the seat belts to make sure they are attached tightly to the seat.

SUBTASK 25-25-01-710-002

- (3) Do these steps to make sure the seat belt operates correctly:

- (a) Put the tongue end of the belt in the buckle.

NOTE: You can hear a click when the tongue is engaged in the buckle.

- 1) Pull on the belts to make sure the buckle is latched.

- (b) Lift the release handle on the buckle to disengage the belt halves.

————— **END OF TASK** —————

TASK 25-25-01-710-801

4. Passenger Seat Recline and Breakover Check

Figure 601 or Figure 602 or Figure 603

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-25-01-980-001

- (1) Make sure the passenger seats that are forward and aft of the emergency exit aisles do not recline or breakover into the emergency exit aisle.

————— **END OF TASK** —————

EFFECTIVITY
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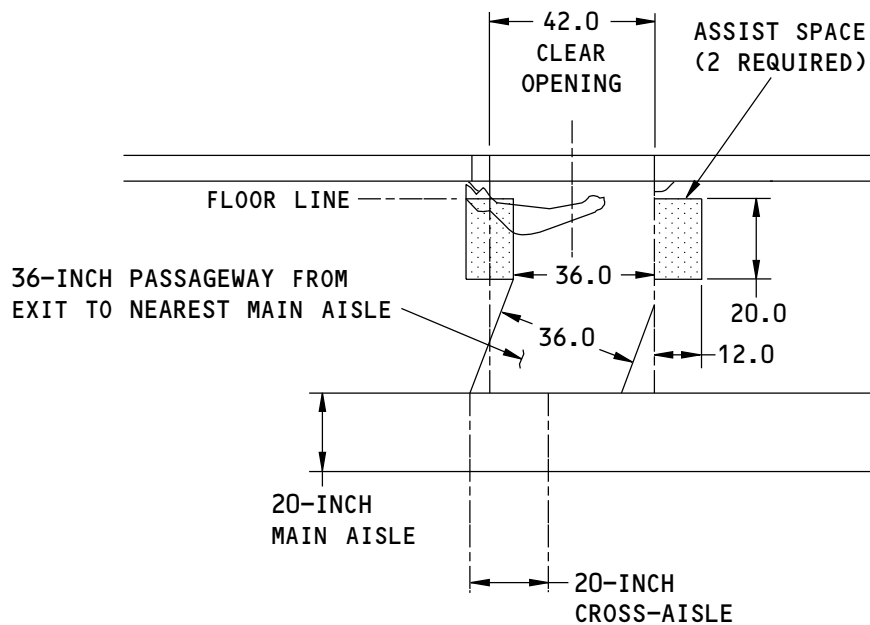
D633W101-ARO

25-25-01

Config 1
Page 602
May 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL



TYPE A EXIT

NOTE: ALL DIMENSIONS ARE IN INCHES.

EXIT PASSAGEWAY MUST BE NOT OBSTRUCTED OR ENCLOSED WITHIN THE PROJECTED DOOR OPENING. IT NEED NOT BE STRAIGHT AND PERPENDICULAR TO EXIT.

CROSS-AISLE, WHEN PROJECTED NORMALLY ACROSS MAIN AISLE MUST LEAD DIRECTLY TO EXIT PASSAGEWAY, WITH SOME PORTION WITHIN PROJECTED DOOR OPENING.

FOR MID-CABIN TYPE A EXITS, AS LITTLE AS 3 INCHES OF THE 20-INCH CROSS-AISLE MUST BE WITHIN THE PROJECTED DOOR OPENING. SUPPLEMENTAL EXIT SIGN MAY BE REQUIRED.

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Cross-Aisle and Passageway Requirements
Figure 601/25-25-01-990-859 (Sheet 1 of 2)

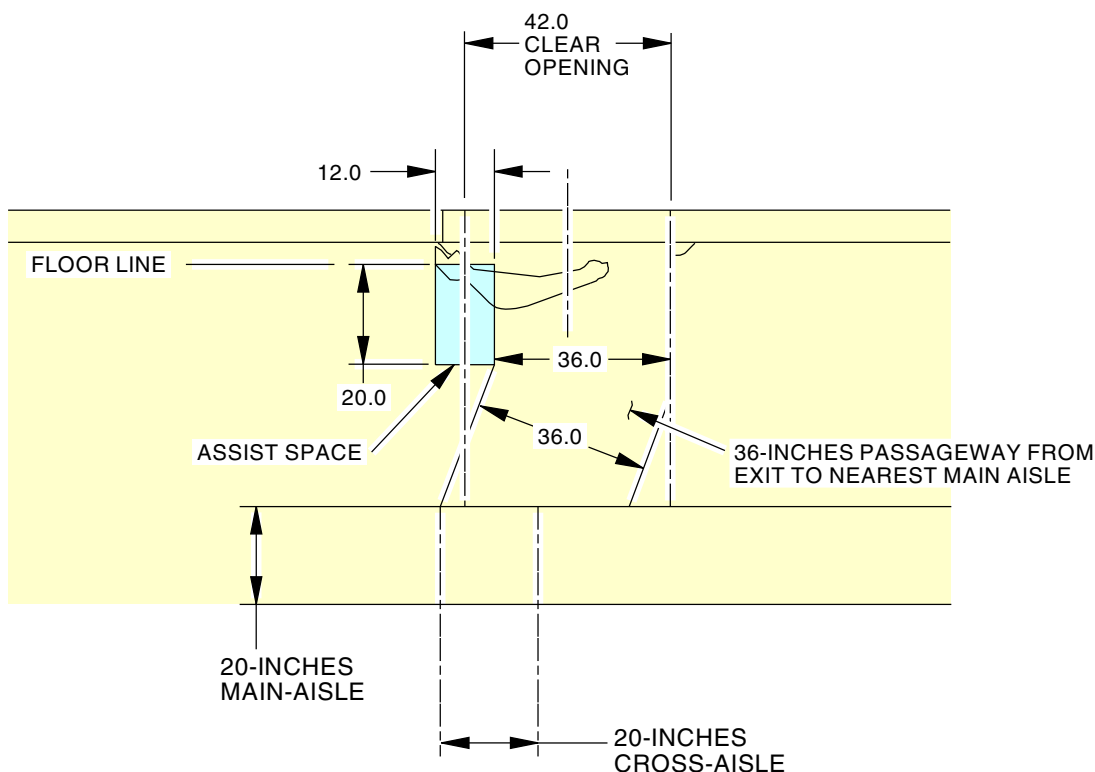
EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-01

Config 1
Page 603
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



**TYPE C EXIT
(RERATED FROM TYPE A EXIT)**

NOTE:

ALL DIMENSIONS ARE IN INCHES.

EXIT PASSAGEWAY MUST BE NOT OBSTRUCTED OR ENCLOSED WITHIN THE PROJECTED DOOR OPENING. IT NEED NOT BE STRAIGHT AND PERPENDICULAR TO EXIT.

CROSS-AISLE, WHEN PROJECTED NORMALLY ACROSS MAIN AISLE MUST LEAD DIRECTLY TO EXIT PASSAGEWAY, WITH SOME PORTION WITHIN PROJECTED DOOR OPENING.

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Cross-Aisle and Passageway Requirements Figure 601/25-25-01-990-859 (Sheet 2 of 2)

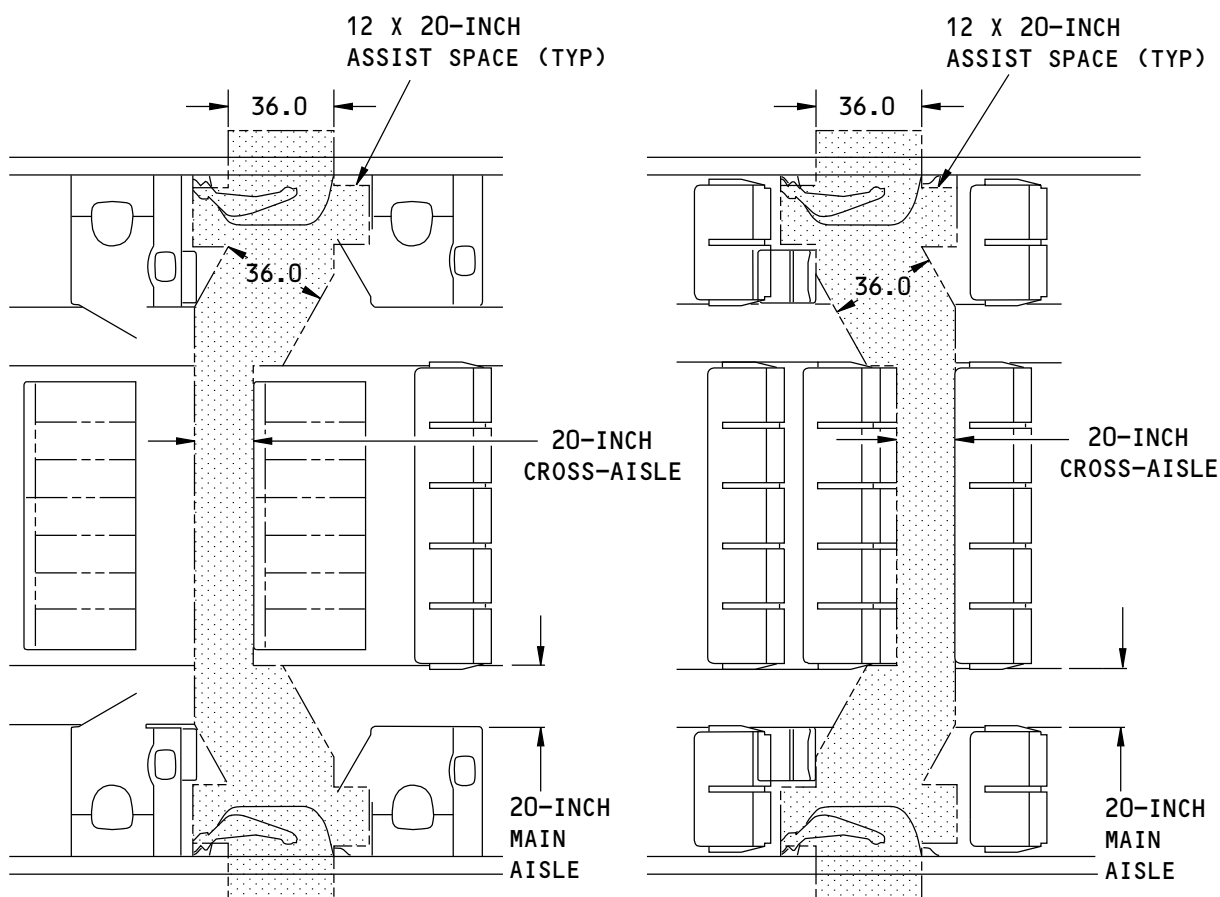
EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-01

Config 1
Page 604
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



CROSS-AISLE LOCATIONS

NOTE: FORWARD AND AFT LIMIT OF CROSS-AISLE DETERMINED BY INTERIOR MODULES FORWARD AND AFT OF DOOR SUCH THAT THE 20-INCH CROSS-AISLE, WHEN PROJECTED, MUST BE WITHIN THE 36-INCH ACCESS PASSAGEWAY, AND SOME PORTION (BOEING REQUIREMENT - 3 INCHES) CROSS-AISLE IS WITHIN THE PROJECTED DOOR OPENING.

LEGEND



A MINIMUM 36-INCH PASSAGEWAY (2 PARALLEL 12- X 20-INCH ASSIST SPACES ADJACENT TO THE DOOR) WITH A 20-INCH CROSS-AISLE PROJECTING DIRECTLY INTO EACH PASSAGEWAY. CROSS-AISLE, MAIN AISLE AND PASSAGEWAY MUST ALLOW FOR TWO "LANES" OF EVACUATION OUT OF EXIT.

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**Mid Cross-Aisle Requirements
Figure 602/25-25-01-990-860 (Sheet 1 of 2)**

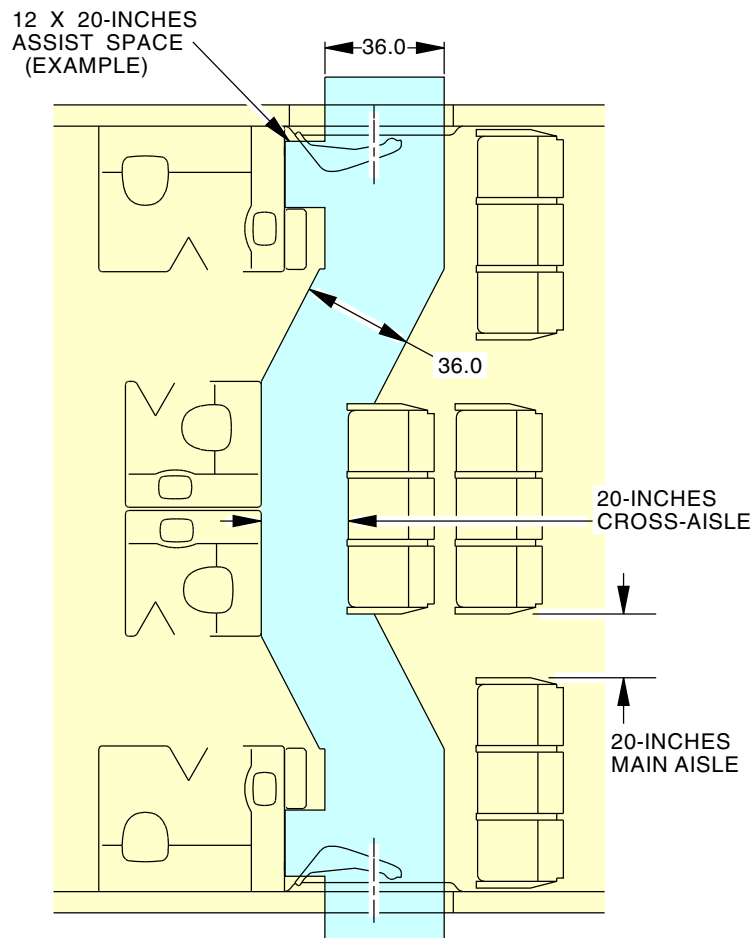
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25-25-01

Config 1
Page 605
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



CROSS-AISLE LOCATIONS

NOTE:

ALL DIMENSIONS ARE IN INCHES.

FORWARD AND AFT LIMIT OF CROSS-AISLE DETERMINED BY INTERIOR MODULES FORWARD AND AFT OF DOOR SUCH THAT THE 20-INCHES CROSS-AISLE, WHEN PROJECTED, MUST BE WITHIN THE 36-INCHES ACCESS PASSAGEWAY, AND SOME PORTION (BOEING REQUIREMENT - 3 INCHES) CROSS-AISLE IS WITHIN THE PROJECTED DOOR OPENING.

LEGEND:

- A MINIMUM 36-INCHES PASSAGEWAY (12- X 20-INCHES ASSIST SPACE ADJACENT TO THE DOOR) WITH A 20-INCH CROSS-AISLE PROJECTING DIRECTLY INTO EACH PASSAGEWAY. CROSS-AISLE, MAIN AISLE AND PASSAGEWAY MUST ALLOW FOR TWO "LANES" OF EVACUATION OUT OF EXIT.

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Mid Cross-Aisle Requirements
Figure 602/25-25-01-990-860 (Sheet 2 of 2)

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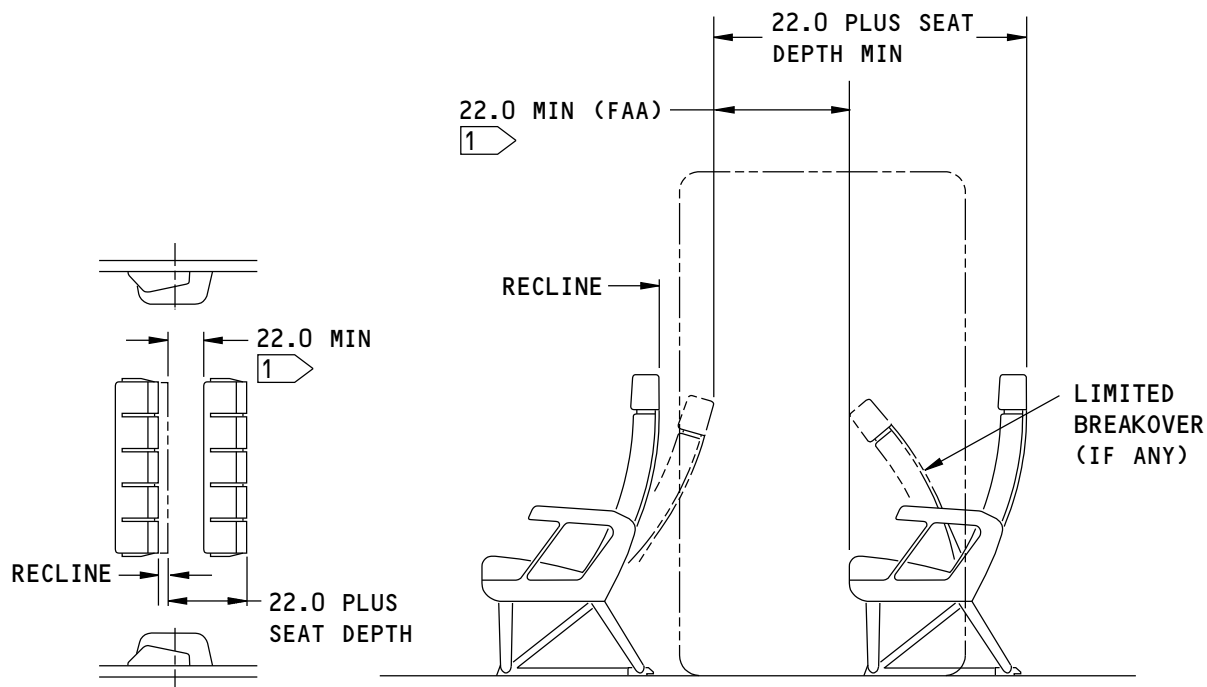
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25-25-01

Config 1
Page 606
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



TYPE A EXIT

NOTE: ALL DIMENSIONS ARE IN INCHES.

CROSS-AISLE MUST BE 20-INCHES CLEAR. RECLINE, BREAKOVER OR PROTRUSIONS ARE NOT ALLOWED INTO THE CROSS-AISLE ¹.

¹ FAA AC 25.562-1
ALLOWS FOR 3-INCH FORWARD SEAT DEFLECTION WITH 1.5-INCH ENCROACHMENT INTO THE REQUIRED 20-INCH CLEAR CROSS-AISLE.

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Center Cross-Aisle Requirements
Figure 603/25-25-01-990-861 (Sheet 1 of 2)

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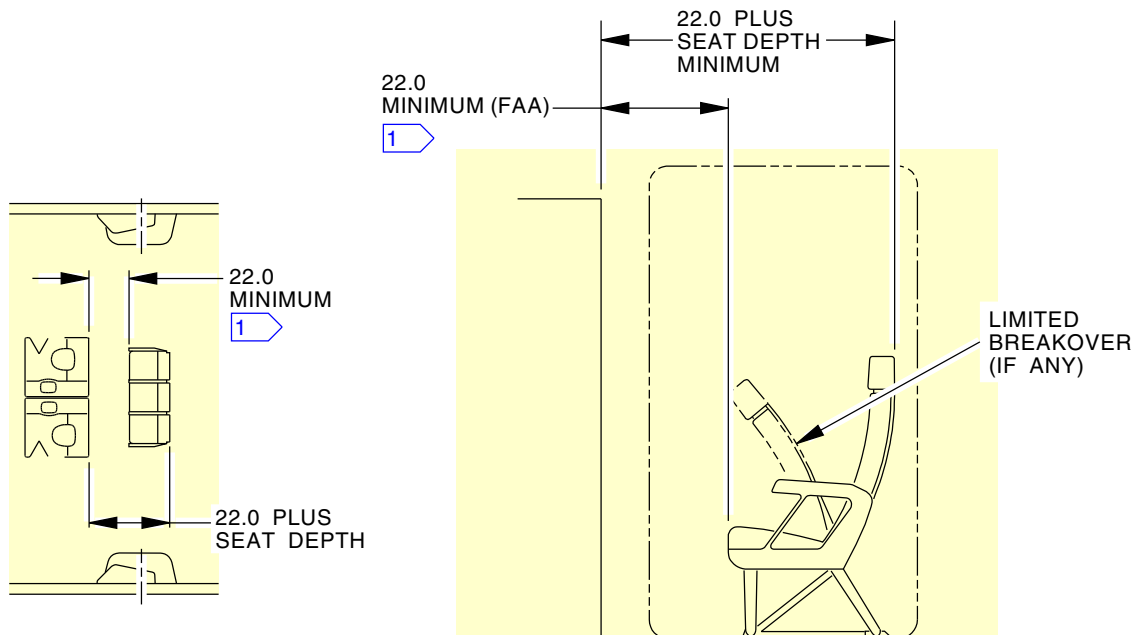
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25-25-01

Config 1
Page 607
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



TYPE C EXIT
(RERATED FROM TYPE A EXIT)

NOTE:

ALL DIMENSIONS ARE IN INCHES.

CROSS-AISLE MUST BE 20-INCHES CLEAR. RECLINE, BREAKOVER OR PROTRUSIONS ARE NOT ALLOWED INTO THE CROSS-AISLE ¹.

- ¹ FAA AC 25.562-1
ALLOWS FOR 3-INCHES FORWARD SEAT DEFLECTION WITH 1.5-INCHES ENCROACHMENT INTO THE REQUIRED 20-INCHES CLEAR CROSS-AISLE.

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Center Cross-Aisle Requirements
Figure 603/25-25-01-990-861 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-01

Config 1
Page 608
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-25-01-200-808

5. Inflatable Passenger Seat Belt and Airbag Cover Inspection/Check

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-25-01-210-077

(1) Do a visual check to make sure the seat belts are not worn, frayed, or damaged.

SUBTASK 25-25-01-210-078

(2) Do a visual inspection to make sure the seat belt hardware is not cracked, dented, or corroded.

SUBTASK 25-25-01-210-079

(3) Pull on the set belts to make sure they are attached tightly to the seat.

SUBTASK 25-25-01-210-080

(4) Do a visual inspection to make sure the airbag cover is not worn, frayed , or damaged.

(a) Excessive airbag cover wear such as cuts, worn edges, or holes in the airbag cover require replacement of the belt.

————— END OF TASK —————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-01

Config 1
Page 609
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

WALL-MOUNTED ATTENDANT SEATS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the attendant seat
 - (2) An installation of the attendant seat.
- B. This procedure is applicable for single and double attendant seats.

TASK 25-25-06-000-801

2. Attendant Seat Removal

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Wall-Mounted Attendant Seat Removal

SUBTASK 25-25-06-010-001

- (1) Do these steps to get access to all of the bolts [7], [9], [12], [15], [24] screws [17], and washers [1], [5], [8], [10], [13], [16], [23] (Figure 401):
 - (a) Open the access door [6] at the bottom of the attendant seat [3].
 - (b) Lift the headrest [2].
 - (c) Pull off the upper backrest cushion [11].

NOTE: It is attached with hook and loop tape.

SUBTASK 25-25-06-020-002

- (2) Do these steps to disconnect the attendant seat [3] from the monument:

NOTE: A monument can be a partition, closet, galley, or lavatory.

 - (a) Remove the bolts [7], [9] and washers [5], [8], [10] from the bottom of the attendant seat [3].
 - (b) Remove the bolts [12] and washers [13] to disconnect the upper backrest panel [14].
 - (c) Reach down behind the lower backrest cushion [4] and remove the bolts [15] and washers [16].
 - (d) Remove the bolts [15], [24] and washers [16], [23] from the attendants seat [3].
 - (e) Remove the screws [17] and washers [1] from the top of the attendant seat [3].

SUBTASK 25-25-06-020-010

- (3) Disconnect the electrical connector for the cabin interphone.

SUBTASK 25-25-06-020-003

- (4) Remove the attendant seat [3].

————— **END OF TASK** —————

TASK 25-25-06-400-801

3. Attendant Seat Installation

A. References

Reference	Title
23-42-00-710-801	Cabin Interphone System - Operational Test (P/B 501)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-06

Config 1
Page 401
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Wall-Mounted Attendant Seat Installation

SUBTASK 25-25-06-010-003

- (1) Do these steps to get access to install all of the bolts [7], [9], [12], [15], [24] screws [17], and washers [1], [5], [8], [10], [13], [16], [23] (Figure 401):
 - (a) Open the access door [6] at the bottom of the attendant seat [3].
 - (b) Lift the headrest [2].
 - (c) Pull off the upper backrest cushion [11].

NOTE: It is attached with hook and loop tape.

SUBTASK 25-25-06-420-001

- (2) Put the attendant seat [3] in position and hold it against the monument.

NOTE: A monument can be a partition, closet, galley, or lavatory.

SUBTASK 25-25-06-410-007

- (3) Connect the electrical connector for the cabin interphone.

SUBTASK 25-25-06-420-002

- (4) Do these steps to connect the attendant seat [3] to the monument:

NOTE: A monument can be a partition, closet, galley, or lavatory.

 - (a) Install the screws [17] and washers [1] in the top of the attendant seat [3].
 - (b) Reach down behind the lower backrest cushion [4] and install the bolts [15] and washers [16].
 - (c) Install the bolts [15], [23] and washers [16], [24] in the attendants seat.
 - (d) Install the bolts [12] and washers [13] in the upper backrest panel [14].
 - (e) Install the bolts [7], [9] and washers [5], [8], [10] in the bottom of the attendant seat [3].

SUBTASK 25-25-06-410-001

- (5) Install the upper backrest cushion [11].

SUBTASK 25-25-06-410-002

- (6) Close the access door [6] at the bottom of the attendants seat [3].

D. Attendant Seat Installation Test

SUBTASK 25-25-06-860-001

- (1) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-25-06-860-002

- (2) To make sure the attendant handset and the PA system operate correctly, dial 46 on the handset (Cabin Interphone System - Operational Test, TASK 23-42-00-710-801).

————— **END OF TASK** —————

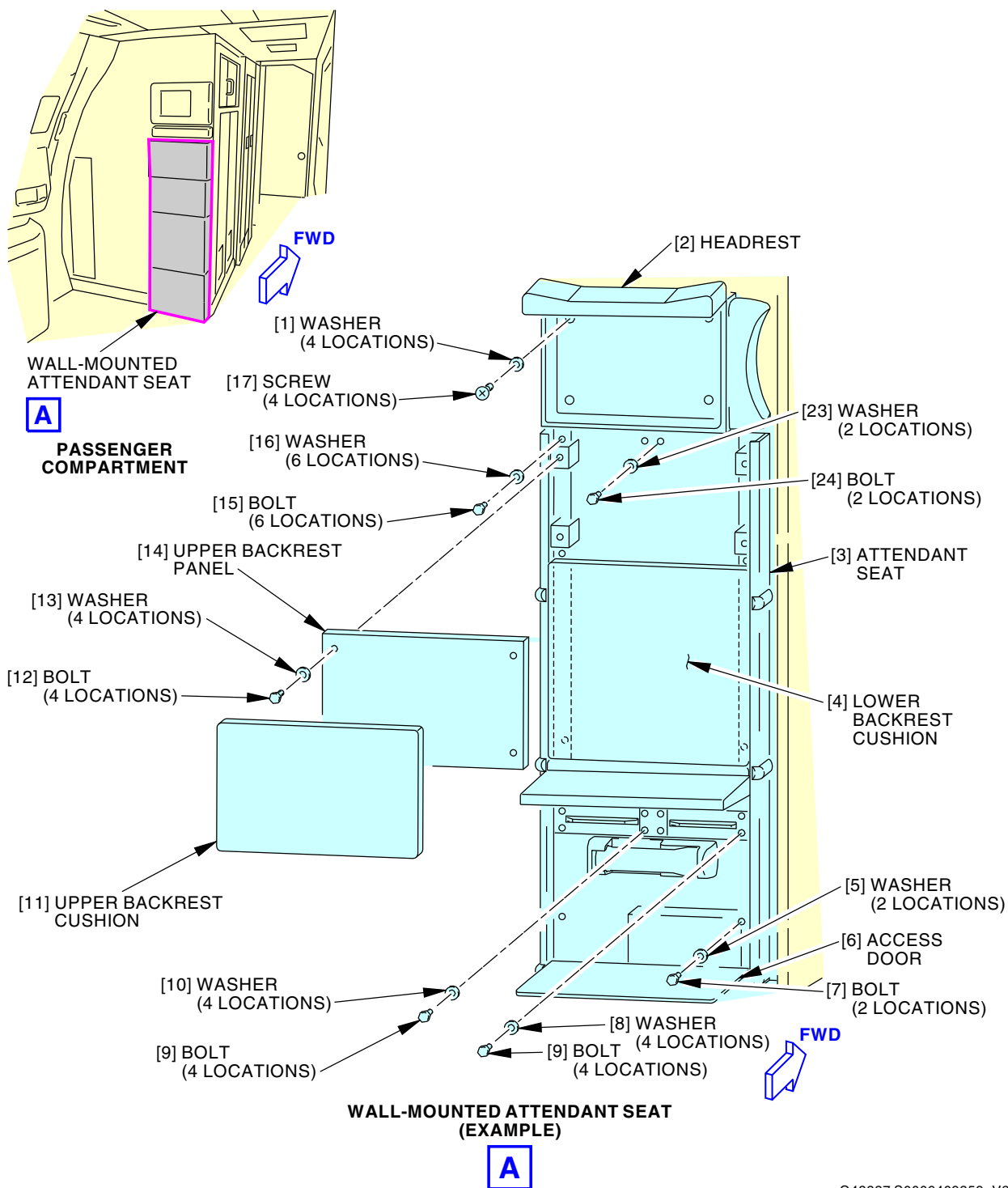
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25-25-06

Config 1
Page 402
Jan 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Attendant Seats Installation
Figure 401/25-25-06-990-801**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-06

Config 1
Page 403
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TRACK-MOUNTED ATTENDANT SEATS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the attendant seat
 - (2) An installation of the attendant seat.
- B. This procedure is applicable for single and double attendant seats.

TASK 25-25-06-000-802

2. Attendant Seat Removal

(Figure 401)

A. Location Zones

Zone	Area

200	Upper Half of Fuselage

B. Track-Mounted Attendant Seat Removal

SUBTASK 25-25-06-020-022

- (1) For Goodrich model 2113 Cabin Attendant Seats, do these steps:
- (a) Disconnect the electrical connector(s) for the seat wire bundle from the airplane behind the sidewall decompression panel.
 - (b) Remove the carpet that covers the electrical connector cable.
 - (c) Remove the electrical connector cable from the mounting tape.
 - (d) Open the access door [25] to get access to the seat track fittings.
 - (e) Remove the stowage cover screws [26].
 - (f) Remove the stowage covers [27].
 - (g) Remove the nuts [28].
 - (h) Lift the attendant seat [3] up to remove it.

SUBTASK 25-25-06-030-015

- (2) Do these steps to remove the seat track stud fittings:
- (a) Move the stud fittings forward or aft until they align with the cutouts in the seat track.
 - (b) Remove the stud fittings from the seat tracks.

SUBTASK 25-25-06-430-013

- (3) Attach the stud fittings to the attendant seat [3] with the nuts [28].

————— **END OF TASK** —————

TASK 25-25-06-400-802

3. Attendant Seat Installation

(Figure 401)

A. References

Reference	Title
23-42-00-710-801	Cabin Interphone System - Operational Test (P/B 501)
24-22-00-860-805	Supply Electrical Power (P/B 201)
25-27-01-400-801	Carpet (Without Adhesive Back) Installation (P/B 401)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-06

Config 2
Page 401
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

B. Consumable Materials

Reference	Description	Specification
G50119	Tape - Reinforced Polyester Double Backed Adhesive Tape - Orco-tape OT-40	BMS5-133 Type IV Class 1

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Track-Mounted Attendant Seat Installation

SUBTASK 25-25-06-420-010

- (1) Put the attendant seat [3] in its position on the seat track fittings.

SUBTASK 25-25-06-030-018

- (2) For Goodrich model 2113 Cabin Attendant Seats, do this step:
 - (a) Remove the stud fitting nuts [28] to disconnect the seat track fittings from the attendant seat [3].

SUBTASK 25-25-06-430-016

- (3) Do these steps to install the seat track fittings in the seat tracks:
 - (a) Install the track fittings in the seat tracks.
 - (b) Move the track fittings forward or aft until they are halfway between the cutouts in the seat track.

SUBTASK 25-25-06-010-033

- (4) Open the access door [25] to get access to the seat track fittings.

SUBTASK 25-25-06-430-015

- (5) Install the nuts [28].
 - (a) Tighten the nuts to 160 $\pm$ 20 in-lb (18.1 $\pm$ 2.3 N·m).

SUBTASK 25-25-06-410-018

- (6) Install the stowage covers [27] with the stowage cover screws [26].

SUBTASK 25-25-06-410-017

- (7) Close the access door [25].

SUBTASK 25-25-06-430-004

- (8) To connect the electrical connector(s) for the seat wire bundle to the airplane, do these steps:
 - (a) Install the tape Orco-tape OT-40 tape, G50119 on the floor panel along the routing of the electrical connector cable.
 - (b) Install the electrical connector cable on the centerline of the tape.
 - (c) Cover the electrical connector cable with the tape Orco-tape OT-40 tape, G50119.
 - (d) Connect the electrical connector(s) for the seat wire bundle to the airplane sidewall disconnect bracket.
 - (e) Coil and stow the excess cable, if applicable, in the sidewall.
 - (f) Install the carpet Carpet (Without Adhesive Back) Installation, TASK 25-27-01-400-801.

E. Attendant Seat Installation Test

SUBTASK 25-25-06-440-001

- (1) Do this task: Supply Electrical Power, TASK 24-22-00-860-805

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-06

Config 2
Page 402
Sep 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-25-06-710-002

- (2) Make sure the attendant handset, the dial 46, and the PA system operate correctly, if applicable:
 - (a) Cabin Interphone System - Operational Test, TASK 23-42-00-710-801

———— **END OF TASK** ————

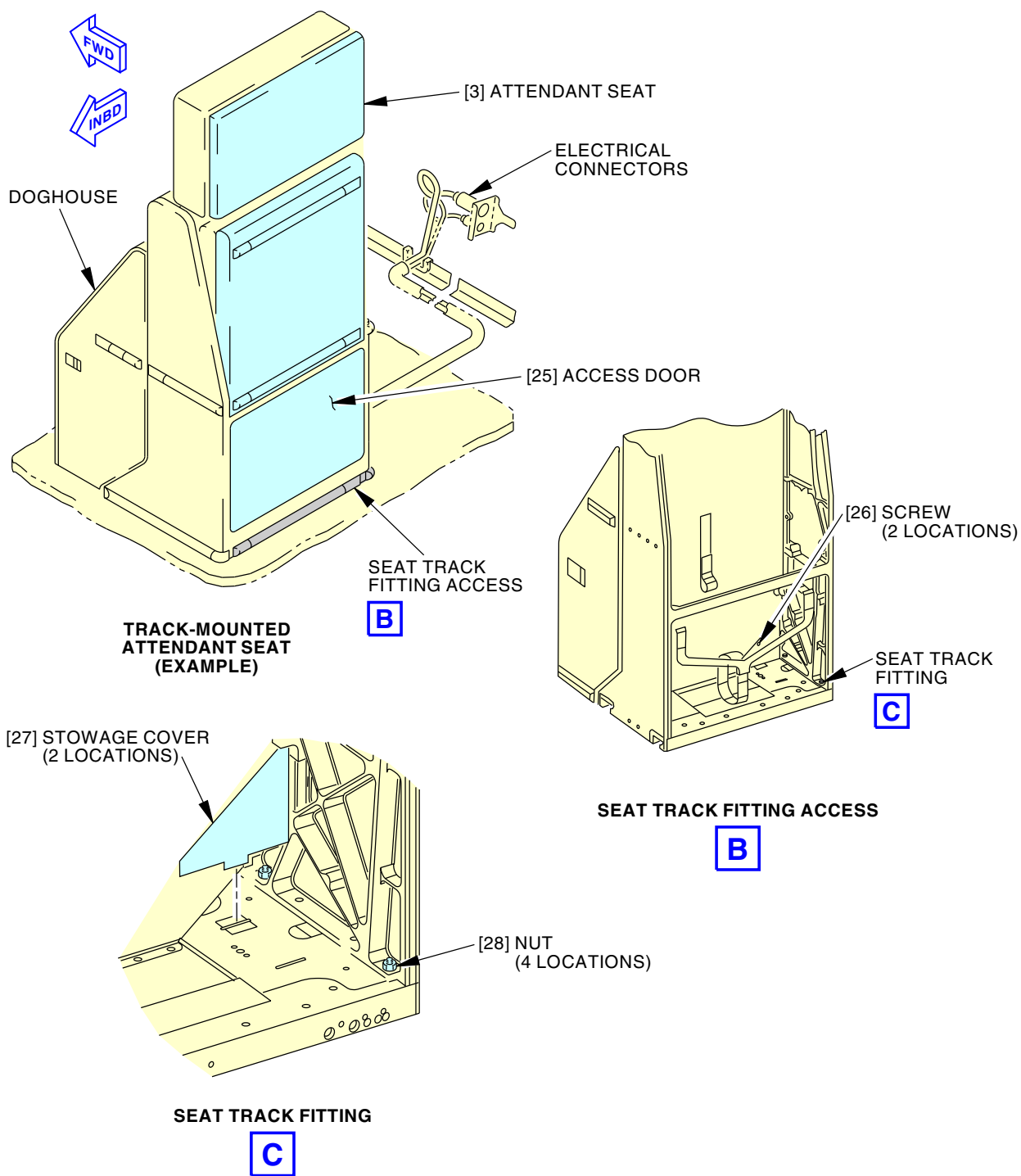
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25-25-06

Config 2
Page 403
Jan 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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Attendant Seats Installation
Figure 401/25-25-06-990-804

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-06

Config 2
Page 404
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

WALL-MOUNTED ATTENDANT SEAT - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the attendant seat
 - (2) An installation of the attendant seat.
- B. This procedure is applicable to AMI/Goodrich Model 2112.

TASK 25-25-06-000-806

2. Attendant Seat Removal

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Wall-Mounted Attendant Seat Removal

Figure 401

SUBTASK 25-25-06-410-043

- (1) If applicable, do the following to remove the headrest bracket [14].
 - (a) Remove the headrest cushion [7] from the headrest bracket [14].
 - (b) Remove the screws [19] and the washers [18] to remove the headrest bracket [14] from the monument surface [2].

SUBTASK 25-25-06-020-034

- (2) Remove the screws [3] and the washers [4] from the mounting brackets [5].

SUBTASK 25-25-06-410-050

- (3) If applicable, do the following to install the headrest cushion [7] to the headrest bracket [14].
 - (a) Insert headrest cushion [7] into the headrest bracket [14] and press firmly on velcro strips.

SUBTASK 25-25-06-020-035

- (4) Open the stowage box door [15] and remove the washers [16] and the screws [17].

SUBTASK 25-25-06-410-044

- (5) Open the seat by pulling down on the seat pan [5].
- (6) Lift up on the seat pan lever [6] located at the front right edge of the seat, and move the seat pan to the fully reclined (occupied) position.

NOTE: With the seat pan lever in this position, the seat will remain open when you release the seat pan.

SUBTASK 25-25-06-020-054

- (7) Do the following steps to remove the screws and washers on the upper mounting bracket:
 - (a) Pull the velcro away from beneath the upper backrest pan [6] to expose the lower backrest release knobs [8].
 - (b) Pull the release knobs [8] and slide the release knobs towards each other to disengage the lower backrest [10] from the backrest linkage arms [9].
 - (c) Fold the lower backrest [10] forward onto the seat pan [5] to expose the upper mounting bracket [11] on the sides.
 - (d) Remove the screws [12] and the washers [13]

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-06

Config 6
Page 401
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (e) Raise the lower backrest [10] to its original position and slide the two release knobs [8] outward and away from each other to engage the backrest linkage arms [9].
- (f) Attach the velcro to the upper backrest pan [6].

SUBTASK 25-25-06-020-056

- (8) Remove the electrical connector for the cabin interphone, if applicable.

SUBTASK 25-25-06-020-038

- (9) Remove the seat [1] from the monument surface [2].

————— END OF TASK —————

TASK 25-25-06-400-806

3. Attendant Seat Installation

A. References

Reference	Title
23-42-00-710-801	Cabin Interphone System - Operational Test (P/B 501)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Wall-Mounted Attendant Seat Installation

Figure 401

SUBTASK 25-25-06-410-042

NOTE: This task applies to AMI/Goodrich 2112 Attendant seats.

- (1) If applicable, do the following to install the headrest bracket [14].
 - (a) Remove headrest cushion [7] from headrest bracket [14].
 - (b) Align the mounting holes on the headrest bracket [14] with the mounting holes on the monument surface [2].
 - (c) Install the screws [19] and washers [18] to install the headrest bracket [14] to the monument surface [2].

SUBTASK 25-25-06-840-003

- (2) Place the seat [1] against the monument surface [2].

SUBTASK 25-25-06-840-004

- (3) Align the mounting holes on the seat [1] with the mounting holes on the monument surface [2].

SUBTASK 25-25-06-420-019

- (4) Connect the electrical connector for the cabin interphone, if applicable.

SUBTASK 25-25-06-410-035

- (5) Install the screws [3] and the washers [4] onto the mounting brackets [5].

SUBTASK 25-25-06-410-036

- (6) Open the stowage box door [15] and loosely install the washers [16] and the screws [17].

SUBTASK 25-25-06-410-037

- (7) Open the seat by pulling down on the seat pan [5].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-06

Config 6
Page 402
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (8) Lift up on the seat pan lever [6] located at the front right edge of the seat, and move the seat pan to the fully reclined (occupied) position.

NOTE: With the seat pan lever in this position, the seat will remain open when you release the seat pan.

SUBTASK 25-25-06-410-070

- (9) Do the following steps to install the screws and washers on the upper mounting bracket:
- (a) Pull the velcro away from beneath the upper backrest pan [6] to expose the lower backrest release knobs [8].
 - (b) Pull the release knobs [8] and slide the release knobs towards each other to disengage the lower backrest [10] from the backrest linkage arms [9].
 - (c) Fold the lower backrest [10] forward onto the seat pan [5] to expose the upper mounting bracket [11] on the sides.
 - (d) Install the screws [12] and washers [13]
 - (e) Torque all mounting screws to 60 ± 10 in-lb (7 ± 1 N·m).
 - (f) Raise the lower backrest [10] and slide the two release knobs [8] outward and away from each other to engage the backrest linkage arms [9].
 - (g) Attach the velcro to the upper backrest pan [6].

SUBTASK 25-25-06-410-041

- (10) If applicable, install the headrest cushion [7] to the headrest bracket [14] attached to the monument surface[2].

NOTE: The bottom of the headrest cushion should sit on top of the top cross member of the seat. The outer edges of the headrest should line up with the outside edges of the panels of the seat.

D. Attendant Seat Installation Test

SUBTASK 25-25-06-720-002

- (1) Make sure the attendant handset, the dial 46, and the PA system operate correctly, if installed:
- (a) Cabin Interphone System - Operational Test, TASK 23-42-00-710-801

————— **END OF TASK** —————

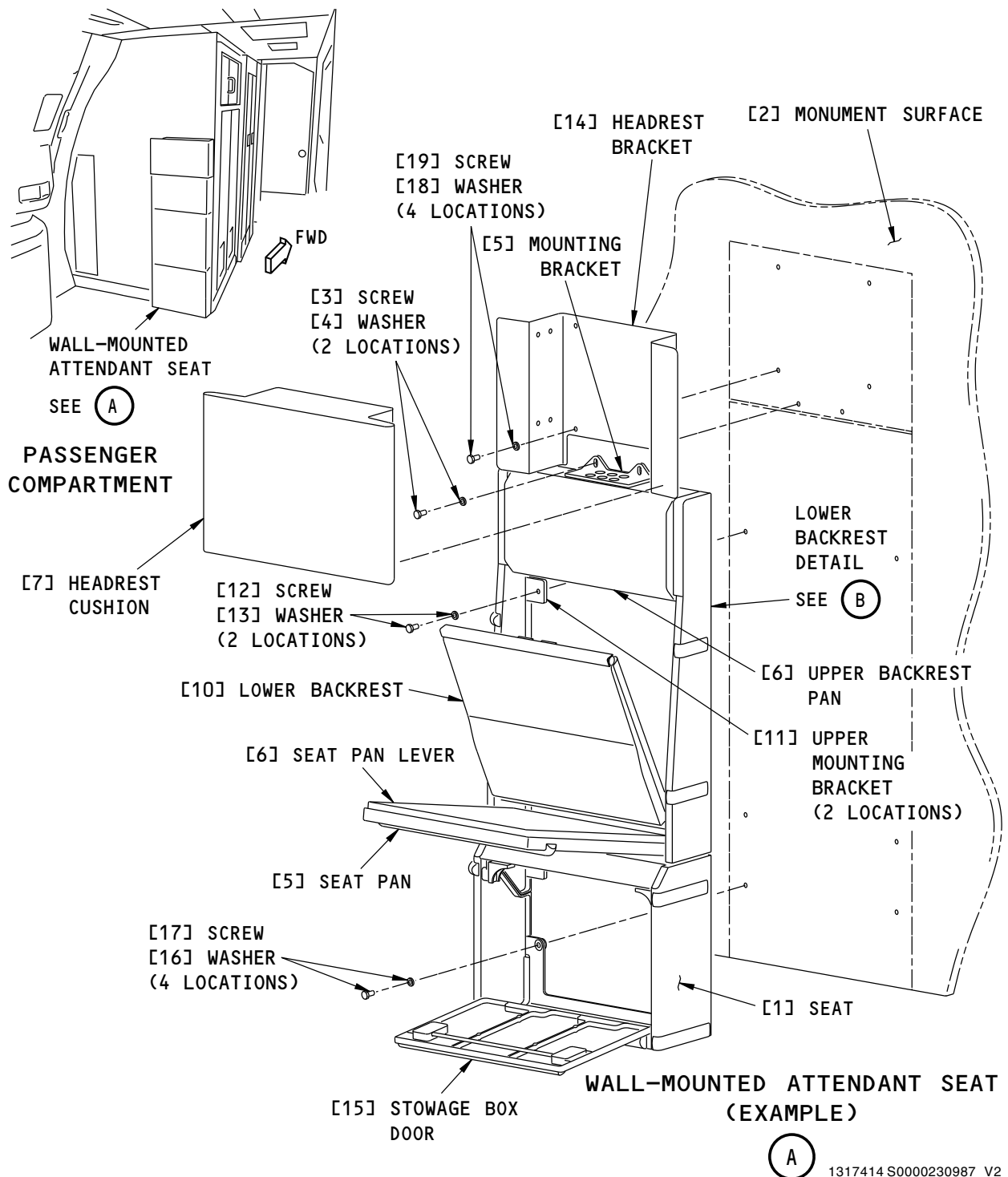
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25-25-06

Config 6
Page 403
Jan 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Attendant Seat Installation
Figure 401/25-25-06-990-808 (Sheet 1 of 2)**

EFFECTIVITY
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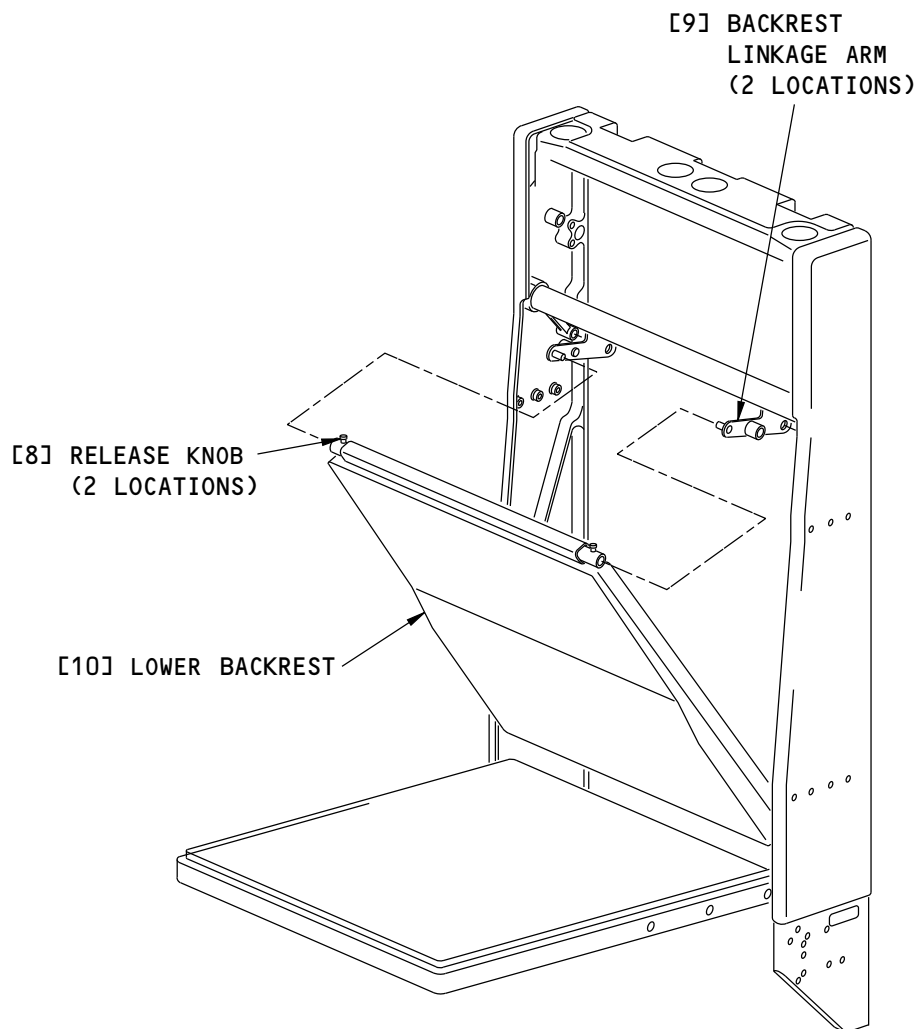
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Config 6
Page 404
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL



LOWER BACKREST DETAIL

B

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Attendant Seat Installation
Figure 401/25-25-06-990-808 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-06

Config 6
Page 405
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL
ATTENDANT SEATS - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) An inspection of the occupant restraint for the attendant seats.
 - (2) An inspection of the attachments for the attendant seats.

TASK 25-25-06-210-801

2. Attendant Seat Occupant Restraint Inspection

(Figure 601)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-25-06-200-001

- (1) Make sure the seat belts and the shoulder harness are not worn or damaged.

SUBTASK 25-25-06-210-002

- (2) Make sure the seat belts and the shoulder harness are tightly attached to the seat and monument.

NOTE: A monument can be a partition, closet, galley, or lavatory.

SUBTASK 25-25-06-710-001

- (3) FOR ATTENDANT SEATS WITH AN INERTIA REEL OCCUPANT RESTRAINT;
Do these steps to make sure the seat belts and shoulder harness operate correctly:
 - (a) Pull the shoulder harness away from the seat back smoothly.
 - (b) Release the shoulder harness and let it retract.
 - 1) Make sure the shoulder harness fully retracts.
 - (c) Pull the shoulder harness away from the seat back suddenly.
 - 1) Make sure the shoulder harness locks and does not extend the full length of the straps.
 - (d) Release the shoulder harness and let it retract.

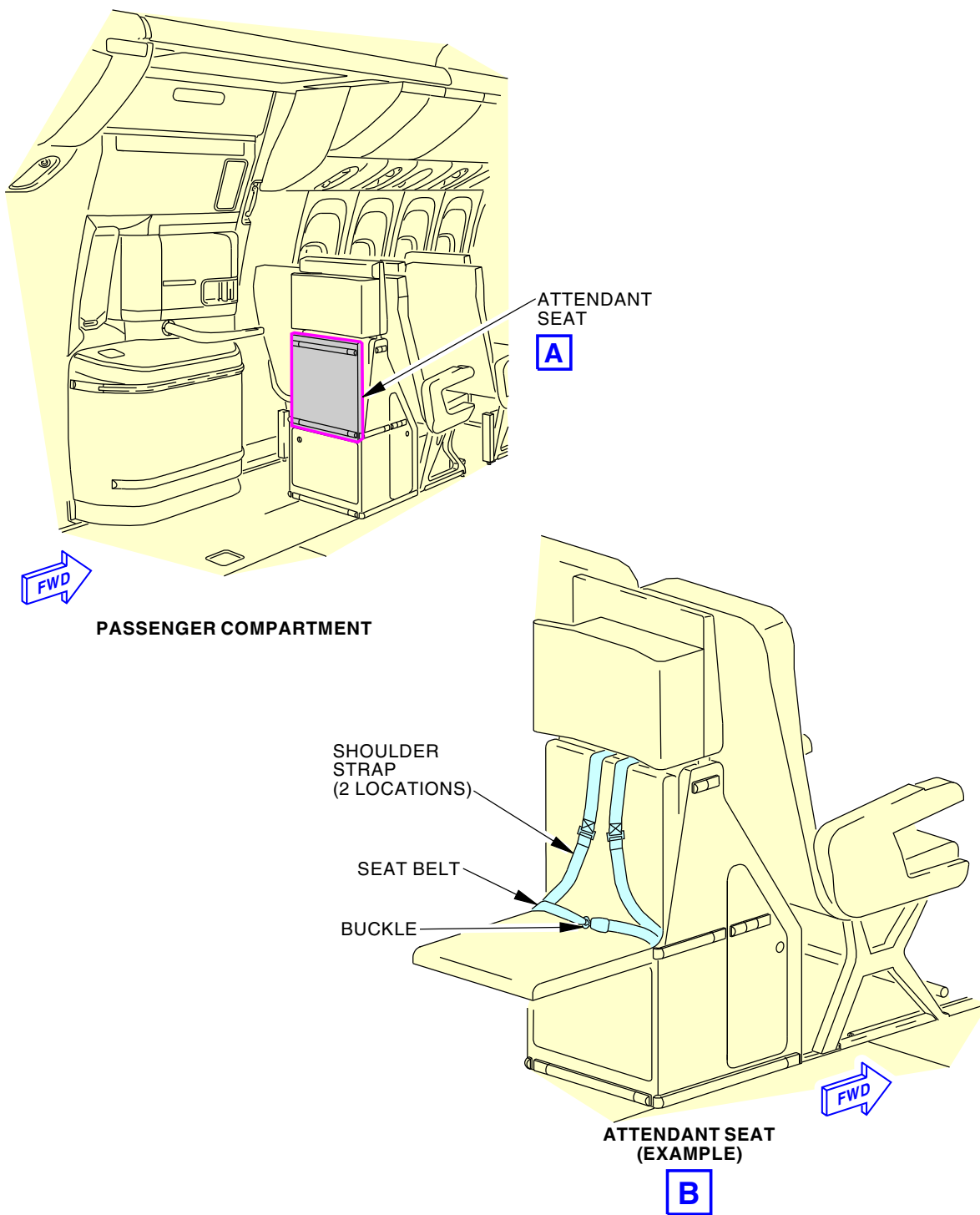
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EFFECTIVITY
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25-25-06

Page 601
May 05/2015



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Attendant Seats Inspection
Figure 601/25-25-06-990-802

EFFECTIVITY
ARO ALL

25-25-06

D633W101-ARO

Page 602
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-25-06-210-802

3. Attendant Seat Attachment Inspection

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-25-06-210-003

- (1) If you are inspecting a wall mounted attendant seat, do this check of the seat mounting bolts:
 - (a) Open the access door on the bottom of the seat and open other parts of the seat as necessary to see the seats mounting bolts.
 - (b) Try to move the seat.
 - 1) Make sure the mounting bolts are tight. If they are not tight, then tighten the bolts.
 - (c) Close the seat.

SUBTASK 25-25-06-210-004

- (2) If you are inspecting a floor mounted attendant seat, do this check of the seat track fittings:
 - (a) Open the access door on the side of the seat.
 - (b) Remove equipment so you can see the seat track fittings.
 - (c) Look at the shear lock of the seat track fitting to make sure it is all the way down in the seat track.
 - (d) Try to move the seat track fitting.
 - 1) If the seat track fitting is not tight in the seat track, then tighten the nut.
 - (e) Install all the equipment that you removed.
 - (f) Close the access door.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-06

Page 603
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

INFLATABLE PASSENGER SEAT BELT - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks:

- (1) V23 Inflatable Seatbelt Deactivation.
- (2) V23 Inflatable Seatbelt Activation.

TASK 25-25-86-040-802

2. V23 Inflatable Seatbelt Deactivation

(Figure 201)

A. **General**

- (1) This task gives the steps to deactivate the inflatable occupant restraint system on the passenger seat.
- (2) Deactivation of the airbag system will prevent unwanted deployment of the airbag.

B. **References**

Reference	Title
25-25-86-000-805	V23 Inflatable Seatbelt Airbag Assembly Removal (P/B 401)

C. **Location Zones**

Zone	Area
220	Subzone 220 - Section 41
230	Subzone 230 - Section 43
240	Subzone 240 - Section 44
250	Subzone 250 - Section 46
260	Subzone 260 - Section 47

D. **Inflatable Airbag System Deactivation**

SUBTASK 25-25-86-040-007

- (1) It is necessary to do one of these procedures to deactivate the airbag system:
 - (a) Safety tie, or tie strap, the belt tongue.
 - (b) Disconnect the Electronic Module Assembly (EMA [11]) connector.
 - (c) Remove the buckle half of the seatbelt from the seat assembly.

NOTE: The buckle half contains the airbag assembly.



MAKE SURE THAT A CABLE-TIE IS INSTALLED ON THE TONGUE OF THE SEAT BELT BUCKLE. THE AMSAFE AVIATION INFLATABLE RESTRAINT (AAIR) MUST BE DISARMED WHEN YOU MOVE THE CABIN ASSEMBLIES. YOU CONNECT OF THE INTERFACE HARNESS TO THE SEAT BELT/AIRBAG TO ARM THE AAIR. IF THE AAIR IS ARMED, INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT CAN OCCUR.



DO NOT CONNECT THE BUCKLE OF THE SEAT BELT HALVES UNTIL THE SYSTEM, AND THE SEAT ARE CORRECTLY INSTALLED IN THE AIRCRAFT. IF YOU CONNECT THE SEAT BELT HALVES, THE AIRBAG CAN ACCIDENTALLY FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (2) To safety the belt tongue, do this step:

EFFECTIVITY
ARO ALL

25-25-86

D633W101-ARO

Page 201
Sep 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (a) Install a safety tie, or tie strap, through the hole in the tongue of the seatbelt.
- (3) To disconnect the cable interface assembly from the EMA [11], do these steps:



WARNING

DISCONNECT THE EMA. IF THE EMA IS CONNECTED, THE AIRBAG CAN FIRE. INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT CAN OCCUR.



WARNING

KEEP THE ELECTRONICS MODULE ASSEMBLY AWAY FROM MAGNETIC FIELDS. MAGNETS AND ELECTRICAL CIRCUITS CAN CAUSE MAGNETIC FIELDS. MAGNETIC FIELDS CAN CAUSE THE SYSTEM TO FIRE. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.



WARNING

DO NOT CONNECT THE BUCKLE OF THE SEAT BELT HALVES UNTIL THE SYSTEM, AND THE SEAT ARE CORRECTLY INSTALLED IN THE AIRCRAFT. IF YOU CONNECT THE SEAT BELT HALVES, THE AIRBAG CAN ACCIDENTALLY FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.



CAUTION

DO NOT LET THE ELECTRONICS MODULE ASSEMBLY FALL. YOU CAN CAUSE DAMAGE TO THE ELECTRONICS, BATTERY, OR SENSOR.

- (a) Push the locking mechanism to release the connector.
- (b) Carefully pull the connector apart.



WARNING

DO NOT CONNECT THE BUCKLE OF THE SEAT BELT HALVES UNTIL THE SYSTEM, AND THE SEAT ARE CORRECTLY INSTALLED IN THE AIRCRAFT. IF YOU CONNECT THE SEAT BELT HALVES, THE AIRBAG CAN ACCIDENTALLY FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.



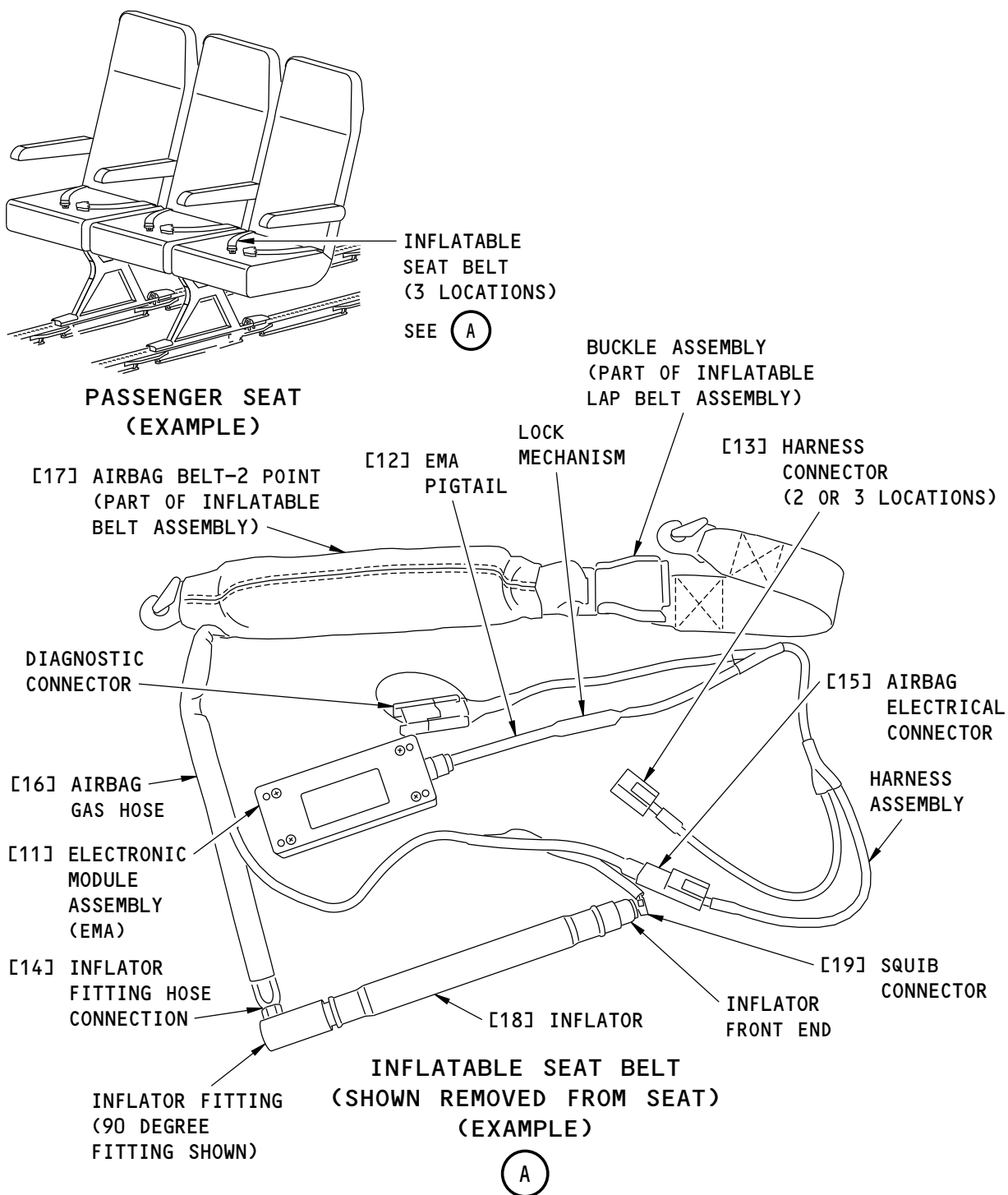
WARNING

MAKE SURE THAT THE BUCKLE OF SEAT BELT IS OPEN (UNBUCKLED) BEFORE YOU REMOVE THE AIRBAG BELT ASSEMBLY. IF THE BUCKLE IS CONNECTED, THE AIRBAG CAN ACCIDENTALLY FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (4) To remove the buckle half of the seatbelt assembly, do this task: V23 Inflatable Seatbelt Airbag Assembly Removal, TASK 25-25-86-000-805.

———— **END OF TASK** ————

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



2434890 S0000563802_V1

**V23 Inflatable Seatbelt Activation
Figure 201/25-25-86-990-814**

EFFECTIVITY
ARO ALL

25-25-86

D633W101-ARO

Page 203
Sep 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-25-86-440-802

3. V23 Inflatable Seatbelt Activation

(Figure 201)

A. General

- (1) This task gives the steps to activate the inflatable occupant restraint system on the passenger seat.

B. References

Reference	Title
25-25-86-400-805	V23 Inflatable Seatbelt Airbag Assembly Installation (P/B 401)
25-25-86-400-807	V23 Inflatable Seatbelt Electronic Module Assembly Installation (P/B 401)

C. Location Zones

Zone	Area
220	Subzone 220 - Section 41
230	Subzone 230 - Section 43
240	Subzone 240 - Section 44
250	Subzone 250 - Section 46
260	Subzone 260 - Section 47

D. Inflatable Airbag System Activation

SUBTASK 25-25-86-440-001

- (1) It is necessary to do these procedures to activate the airbag system:
 - (a) Install the buckle half of the seatbelt on the seat assembly.
NOTE: The buckle half contains the airbag assembly.
 - (b) Connect the Electronic Module Assembly (EMA [11]) connector.
 - (c) Enable the belt tongue.



WARNING

DO NOT CONNECT THE BUCKLE OF THE SEAT BELT HALVES UNTIL THE SYSTEM, AND THE SEAT ARE CORRECTLY INSTALLED IN THE AIRCRAFT. IF YOU CONNECT THE SEAT BELT HALVES, THE AIRBAG CAN ACCIDENTALLY FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (2) To install the buckle half of the seatbelt assembly, do this task: V23 Inflatable Seatbelt Airbag Assembly Installation, TASK 25-25-86-400-805.
- (3) To connect the EMA [11], do these steps:



WARNING

KEEP THE ELECTRONICS MODULE ASSEMBLY AWAY FROM MAGNETIC FIELDS. MAGNETS AND ELECTRICAL CIRCUITS CAN CAUSE MAGNETIC FIELDS. MAGNETIC FIELDS CAN CAUSE THE SYSTEM TO FIRE. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

EFFECTIVITY
ARO ALL

25-25-86

D633W101-ARO

Page 204
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

(WARNING PRECEDES)



DO NOT CONNECT THE BUCKLE OF THE SEAT BELT HALVES UNTIL THE SYSTEM, AND THE SEAT ARE CORRECTLY INSTALLED IN THE AIRCRAFT. IF YOU CONNECT THE SEAT BELT HALVES, THE AIRBAG CAN ACCIDENTALLY FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.



DO NOT LET THE ELECTRONICS MODULE ASSEMBLY FALL. YOU CAN CAUSE DAMAGE TO THE ELECTRONICS, BATTERY, OR SENSOR.

- (a) Do this task: V23 Inflatable Seatbelt Electronic Module Assembly Installation, TASK 25-25-86-400-807.
- (4) To enable use of the belt tongue, do this step:
 - (a) Remove the safety tie, or tie strap, from the hole in the tongue of the seatbelt.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Page 205
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

INFLATABLE PASSENGER SEAT BELT - REMOVAL/INSTALLATION

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) Removal of the V23 Seatbelt Airbag Assembly
 - (2) Installation of the V23 Seatbelt Airbag Assembly
 - (3) Removal of the V23 Inflator Assembly
 - (4) Installation of the V23 Inflator Assembly
 - (5) Removal of the V23 Electronic Module Assembly
 - (6) Installation of the V23 Electronic Module Assembly

TASK 25-25-86-000-805

2. V23 Inflatable Seatbelt Airbag Assembly Removal

(Figure 401)

A. **General**

- (1) This task includes steps to remove the seatbelt airbag (inflatable lap belt) assembly from the passenger seat.
- (2) This task applies to the Amsafe Aviation V23 seatbelt airbag assembly.
- (3) Each passenger seat has one seatbelt airbag assembly.
- (4) The seatbelt airbag has two subassemblies:
 - (a) The airbag belt (fixed length).
 - (b) The buckle belt (adjustable length).
- (5) The seatbelt airbag assembly connects to the seat structure.
- (6) The airbag, gas hose and seatbelt web are in a cover which has a tear seam that opens to deploy the airbag when gas pressure is applied.
- (7) The seatbelt airbag system operates on batteries. It does not connect to aircraft systems or the aircraft power supply.

B. **Consumable Materials**

Reference	Description	Specification
A00648	Compound - Retaining - Loctite 242	ASTM D5363 Grp 3 Cl 2 Gd 1 (SUPERSEDES MIL-S-46163)

C. **Location Zones**

Zone	Area
220	Subzone 220 - Section 41
230	Subzone 230 - Section 43
240	Subzone 240 - Section 44
250	Subzone 250 - Section 46
260	Subzone 260 - Section 47

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Config 1
Page 401
Sep 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Prepare for the Removal

SUBTASK 25-25-86-020-056-001



MAKE SURE THAT THE BUCKLE OF THE SEAT BELT IS OPEN (UNBUCKLED) BEFORE YOU REMOVE THE AIRBAG BELT ASSEMBLY. IF THE BUCKLE IS CONNECTED, THE AIRBAG CAN ACCIDENTALLY FIRE.

- (1) Before you remove a system component, disconnect the two halves of the seatbelt at the buckle.

E. Seatbelt Airbag Assembly Removal

NOTE: The seat manufacturer supplies the airbag gas hose routing. Before you remove a component of the seatbelt airbag system, record how the parts are attached to the hardware for reference during the installation.

SUBTASK 25-25-86-030-009



DO NOT CONNECT THE BUCKLE OF THE SEAT BELT HALVES UNTIL THE SYSTEM, AND THE SEAT ARE CORRECTLY INSTALLED IN THE AIRCRAFT. IF YOU CONNECT THE SEAT BELT HALVES, THE AIRBAG CAN ACCIDENTALLY FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.



MAKE SURE THAT THE BUCKLE OF THE SEAT BELT IS OPEN (UNBUCKLED) BEFORE YOU REMOVE THE AIRBAG BELT ASSEMBLY. IF THE BUCKLE IS CONNECTED, THE AIRBAG CAN ACCIDENTALLY FIRE.

- (1) Do these steps to remove the airbag gas hose [16] from the inflator [18] assembly:
 - NOTE: The inflator assembly is installed at the bottom of the seat.
 - (a) Disconnect the airbag electrical connector [15] from the harness connector [13].
 - 1) Move the red lock tab rearward to the unlocked position.
 - 2) Push the yellow tab and pull the two connector halves apart.
 - (b) Remove the squib connector [19] from the inflator [18].
 - 1) Squeeze two sides of the squib connector [19] and pull out the squib connector [19] from the inflator [18].
 - (c) Disconnect the airbag gas hose [16] from the inflator fitting [14] fitting.
 - 1) Use a second wrench to loosen the airbag gas hose [16] from the inflator [18] fitting.
 - NOTE: The airbag gas hose [16] barb and the inflator [18] fitting are attached with Loctite 242 compound, A00648. Use a second wrench to loosen the fitting.
 - 2) Disconnect the airbag gas hose [16] from the inflator [18] fitting.
 - NOTE: Do not damage the crimp end of the airbag gas hose [16] or the inflator [18] fitting.

SUBTASK 25-25-86-020-006

- (2) Disconnect the seatbelt airbag [17] from the seatbelt shackles.

SUBTASK 25-25-86-030-008

- (3) Carefully remove the airbag gas hose [16] through the seat to remove the seatbelt airbag [17].
 - NOTE: The seat manufacturer supplies the airbag gas hose [16] routing. Before you remove the airbag gas hose [16], record the hose routing and mounting for installation.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Config 1
Page 402
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-25-86-430-007

- (4) Install protective covers on the inflator hose connector and the nozzle.

———— **END OF TASK** ————

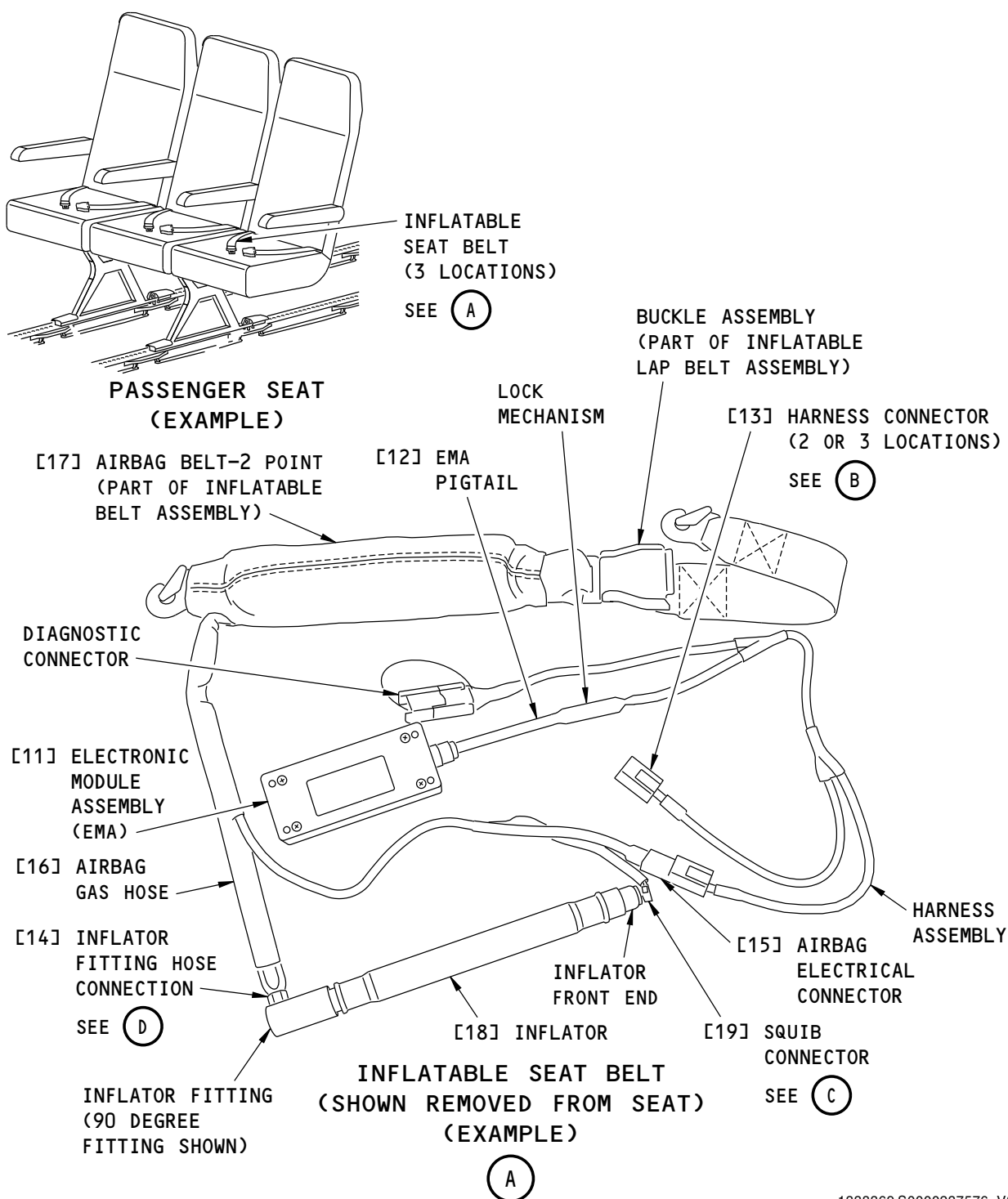
EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Config 1
Page 403
Sep 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**V23 Inflatable Seatbelt - Installation
Figure 401/25-25-86-990-808 (Sheet 1 of 2)**

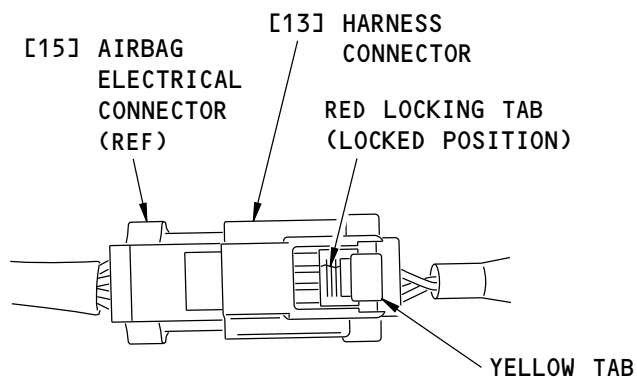
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ARO ALL

D633W101-ARO

25-25-86

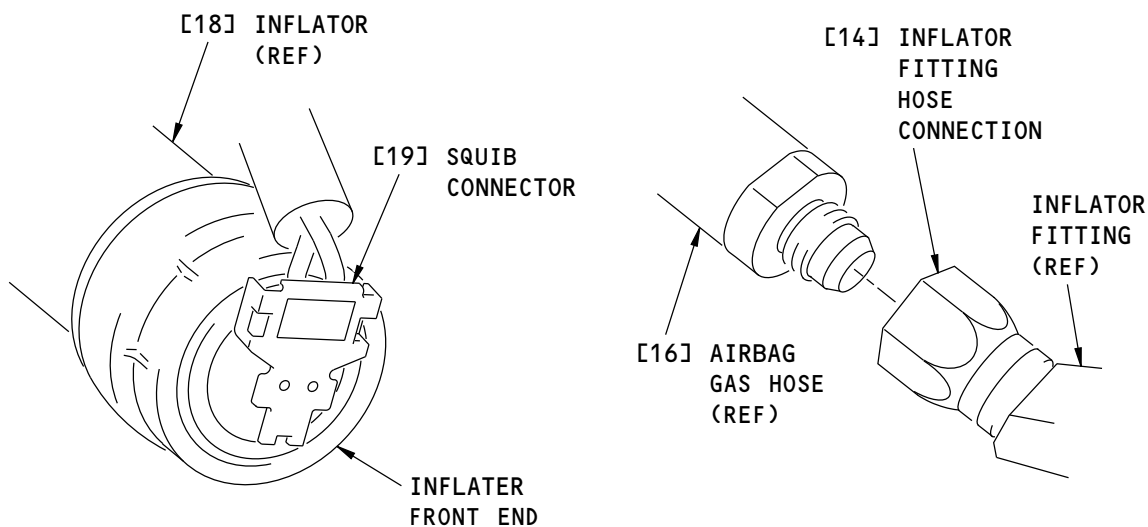
Config 1
Page 404
Sep 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**HARNESS CONNECTOR
(EXAMPLE)**

(B)



SQUIB CONNECTOR

(C)

**INFLATOR FITTING
HOSE CONNECTION**

(D)

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**V23 Inflatable Seatbelt - Installation
Figure 401/25-25-86-990-808 (Sheet 2 of 2)**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Config 1
Page 405
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-25-86-400-805

3. V23 Inflatable Seatbelt Airbag Assembly Installation

(Figure 401)

A. General

- (1) This task includes steps to install the seatbelt airbag (inflatable lap belt) assembly on the passenger seat.
- (2) This task applies to the Amsafe Aviation V23 seatbelt airbag assembly.
- (3) Each passenger seat has one seatbelt airbag assembly.
- (4) The seatbelt airbag has two subassemblies:
 - (a) The airbag belt (fixed length).
 - (b) The buckle belt (adjustable length).
- (5) The seatbelt airbag assembly connects to the seat structure.
- (6) The airbag, gas hose, and seatbelt web are in a cover which has a tear seam that opens to deploy the airbag when gas pressure is applied.
- (7) The seatbelt airbag system operates on batteries. It does not connect to aircraft systems or the aircraft power supply.
- (8) Install all AmSafe Seatbelt Airbag system components with the same part number as that of the removed assembly.

B. References

Reference	Title
25-25-86-710-805	V23 Inflatable Seatbelt Operational Test (P/B 501)

C. Consumable Materials

Reference	Description	Specification
A00648	Compound - Retaining - Loctite 242	ASTM D5363 Grp 3 Cl 2 Gd 1 (SUPERSEDES MIL-S-46163)

D. Location Zones

Zone	Area
220	Subzone 220 - Section 41
230	Subzone 230 - Section 43
240	Subzone 240 - Section 44
250	Subzone 250 - Section 46
260	Subzone 260 - Section 47

E. Seat Belt Airbag Assembly Installation

SUBTASK 25-25-86-420-006



DO NOT CONNECT THE BUCKLE OF THE SEAT BELT HALVES UNTIL THE SYSTEM, AND THE SEAT ARE CORRECTLY INSTALLED IN THE AIRCRAFT. IF YOU CONNECT THE SEAT BELT HALVES, THE AIRBAG CAN ACCIDENTALLY FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (1) Do these steps to install the seatbelt airbag [17] on the seat:

NOTE: To prevent contamination of the seatbelt airbag [17], do not fully remove its plastic bag until the installation is completed.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Config 1
Page 406
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Turn the two-point seatbelt airbag [17] so that the airbag cover is away from the occupant (the label must be on the side towards the occupant).
 - 1) Make sure that the orientation of the two-point seatbelt airbag [17] is correct before routing the airbag gas hose [16] to the inflator [18].

NOTE: Do not twist or kink the airbag gas hose [16].

SUBTASK 25-25-86-430-008

- (2) Do these steps to connect the airbag gas hose [16] to the inflator [18]:
 - (a) If you loosened the inflator fitting [14] from the inflator [18], do these steps:
 - 1) Clean the threaded ends of the inflator fitting [14] and the inflator [18].
 - 2) Apply a thin, even layer of Loctite 242 compound, A00648 on the threads of the inflator fitting [14] and the inflator [18].
 - 3) Connect the inflator fitting [14] to the inflator [18].
 - 4) Tighten the inflator fitting [14] with 60 ± 10 in-lb (7 ± 1 N·m) of torque.
 - (b) Remove and discard the end cap plug from the airbag gas hose [16].
 - (c) Apply a thin, smooth layer of Loctite 242 compound, A00648 on the threads of the airbag gas hose [16] barb.
 - (d) Connect the airbag gas hose [16] to the inflator fitting [14].
 - (e) Tighten the airbag gas hose [16] with 120 ± 10 in-lb (13.56 ± 1.13 N·m) of torque.
 - 1) Make sure that the inflator [18] hose connector fitting is fully installed (fitting fully extended) on the airbag gas hose [16] barb for an air-tight fit.

NOTE: The inflator hose connector fitting is a pressure fitting.
 - (f) Connect the squib connector [19] to the inflator [18].
 - 1) Install the squib connector [19] at the correct location on the front end of the inflator [18] until it locks in its position.

NOTE: Do not damage the serial number on the inflator [18].
 - (g) Connect the airbag electrical connector [15] to the harness connector [13].
 - 1) Move the red tab forward to the locked position.
 - (h) Remove the plastic bag from the seat belt.
 - (i) Connect the seatbelt airbag [17] clip to the seat frame shackle.
 - (j) Connect the buckle belt to the seat shackle.
 - (k) Remove the safety cable tie from the airbag buckle tongue.

SUBTASK 25-25-86-710-008

- (3) Do this task: V23 Inflatable Seatbelt Operational Test, TASK 25-25-86-710-805.

————— **END OF TASK** —————

TASK 25-25-86-000-806

4. V23 Inflatable Seatbelt Inflator Assembly Removal

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Config 1
Page 407
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

A. General

- (1) This task includes steps to remove the inflator assembly of the seatbelt airbag system from the passenger seat.
- (2) This task applies to the seatbelt airbag inflator of the Amsafe Aviation V23 system.
- (3) Each passenger seat has an inflator assembly.
- (4) The inflatable seatbelt assembly hose attaches to the inflator fitting after routing through the seat.
- (5) The inflator is installed at the bottom of the seat.
- (6) The inflator supplies inert helium-argon gas to inflate the airbag on command from the electronic module assembly (EMA).
- (7) The seatbelt airbag system operates on batteries. It does not connect to aircraft systems or the aircraft power supply.

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-2572	Wrench - Strap, Electrical Connector (for p/n's BT-BS-609/610 max dia 2.50"/1.50" with max part torque 200 in-lb; TG70 max dia 3.00" with max part torque 150 in-lb; BT-BS-611/ 618BSS max dia 4.00" with max part torque 200 in-lb) Part #: BT-BS-609 Supplier: 11851 Part #: BT-BS-610 Supplier: 11851 Part #: BT-BS-611 Supplier: 11851 Part #: BT-BS-618BSS Supplier: 11851 Part #: TG70 Supplier: 06324

C. Location Zones

Zone	Area
220	Subzone 220 - Section 41
230	Subzone 230 - Section 43
240	Subzone 240 - Section 44
250	Subzone 250 - Section 46
260	Subzone 260 - Section 47

D. Inflator Removal

SUBTASK 25-25-86-030-010



MAKE SURE THE YELLOW MALE AND FEMALE CONNECTORS ON THE CABLE ASSEMBLY ARE DISCONNECTED FOR EACH SEAT POSITION PRIOR TO ANY COMPONENT REPLACEMENT OR ELECTRICAL OR MECHANICAL SEAT MAINTENANCE. IF YOU DO NOT DISCONNECT THE CONNECTORS, IT CAN CAUSE DAMAGE TO EQUIPMENT AND INJURY TO PERSONNEL.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Config 1
Page 408
Jan 05/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL

(WARNING PRECEDES)



DO NOT CONNECT THE BUCKLE OF THE SEAT BELT HALVES UNTIL THE SYSTEM, AND THE SEAT ARE CORRECTLY INSTALLED IN THE AIRCRAFT. IF YOU CONNECT THE SEAT BELT HALVES, THE AIRBAG CAN ACCIDENTALLY FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.



MAKE SURE THAT THE BUCKLE OF THE SEAT BELT IS OPEN (UNBUCKLED) BEFORE YOU REMOVE THE AIRBAG BELT ASSEMBLY. IF THE BUCKLE IS CONNECTED, THE AIRBAG CAN ACCIDENTALLY FIRE.

- (1) Do the applicable steps from V23 Inflatable Seatbelt Airbag Assembly Removal, TASK 25-25-86-000-805 to remove the airbag gas hose [16] from the inflator [18] assembly.

SUBTASK 25-25-86-020-007



DO NOT TRY TO OPEN THE INFLATOR. DO NOT APPLY ELECTRICAL CURRENT TO THE ELECTRONICS CONNECTION. YOU CANNOT REPAIR OR REPLACE PARTS THAT ARE IN THE INFLATOR. MOVE THE INFLATOR CAREFULLY. IF YOU DO NOT OBEY THESE INSTRUCTIONS, AN EXPLOSION OF THE INFLATOR CAN OCCUR. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT WILL OCCUR.

- (2) Do these steps to remove the inflator [18] assembly:

NOTE: Before you remove the inflator [18] assembly, record the harness routing and mounting for installation.



KEEP THE INFLATOR AWAY FROM SPARKS, FLAMES, AND HEAT. DO NOT HIT IT, OR LET IT FALL. THESE CAN CAUSE INFLATOR FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (a) Remove the inflator [18] assembly from the mounting bracket at the bottom of the seat.
(b) Use a strap wrench, COM-2572 to remove the inflator fitting [14] from the inflator [18] assembly.

NOTE: The inflator fitting [14] and the inflator [18] are connected with loctite. Use a wrench to loosen.

- 1) Disconnect the inflator fitting [14] from the inflator [18].

NOTE: Do not damage the inflator fitting [14] or the inflator [18].

- a) Install protective covers on the inflator [18] hose connector.

SUBTASK 25-25-86-030-011

- (3) Do these steps to make the inflator [18] assembly safe for storage or shipping:
- (a) Only persons approved in handling dangerous goods must handle or store the inflator [18].
- (b) All local and relevant handling, shipping and transporting regulations must be followed.
- (c) Install the safety cap on the inflator nozzle.
- (d) Install the safety clamp around the safety cap.
- 1) Tighten the setscrews to 7.5 ±2.5 in-lb (0.85 ±0.29 N·m) of torque.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Config 1
Page 409
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (e) Install a tie strap around the safety cap and the clamp.
- (f) Store only in controlled area.
- (g) Protect inflator [18] from sunlight, dust, moisture and other contamination.
- (h) Protect inflator [18] from excessive EMI/RFI/ESD environments.
- (i) The storage temperature must not be more than 200°F (93°C).

END OF TASK

TASK 25-25-86-400-806

5. V23 Inflatable Seatbelt Inflator Assembly Installation

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This task includes steps to install the inflator assembly of the seatbelt airbag system on the passenger seat.
- (2) This task applies to the seatbelt airbag inflator of the Amsafe Aviation V23 system.
- (3) Each passenger seat has an inflator assembly.
- (4) The inflatable seatbelt assembly hose attaches to the inflator fitting after routing through the seat.
- (5) The inflator is installed at the bottom of the seat.
- (6) The inflator supplies inert helium-argon gas to inflate the airbag on command from the electronic module assembly (EMA).
- (7) The seatbelt airbag system operates on batteries. It does not connect to aircraft systems or the aircraft power supply.
- (8) Install all AmSafe Seatbelt Airbag system components with the same part number as that of the removed assembly.

B. References

Reference	Title
25-25-86-710-805	V23 Inflatable Seatbelt Operational Test (P/B 501)

C. Consumable Materials

Reference	Description	Specification
A00648	Compound - Retaining - Loctite 242	ASTM D5363 Grp 3 Cl 2 Gd 1 (SUPERSEDES MIL-S-46163)

D. Location Zones

Zone	Area
220	Subzone 220 - Section 41
230	Subzone 230 - Section 43
240	Subzone 240 - Section 44
250	Subzone 250 - Section 46
260	Subzone 260 - Section 47

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Config 1
Page 410
Jan 05/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL

E. Inflator Installation

SUBTASK 25-25-86-030-012



DO NOT TRY TO OPEN THE INFLATOR. DO NOT APPLY ELECTRICAL CURRENT TO THE ELECTRONICS CONNECTION. YOU CANNOT REPAIR OR REPLACE PARTS THAT ARE IN THE INFLATOR. MOVE THE INFLATOR CAREFULLY. IF YOU DO NOT OBEY THESE INSTRUCTIONS, AN EXPLOSION OF THE INFLATOR CAN OCCUR. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT WILL OCCUR.



DO NOT CONNECT THE BUCKLE OF THE SEAT BELT HALVES UNTIL THE SYSTEM, AND THE SEAT ARE CORRECTLY INSTALLED IN THE AIRCRAFT. IF YOU CONNECT THE SEAT BELT HALVES, THE AIRBAG CAN ACCIDENTALLY FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (1) Do these steps to remove the safety cap from the inflator [18] assembly:

- (a) Cut and discard the tie strap.
- (b) Loosen the setscrews on the safety clamp.
- (c) Remove the safety clamp and safety cap.

NOTE: Keep the safety clamp and safety cap for storing or shipping of the inflator [18] assembly.

SUBTASK 25-25-86-420-007



DO NOT TRY TO OPEN THE INFLATOR. DO NOT APPLY ELECTRICAL CURRENT TO THE ELECTRONICS CONNECTION. YOU CANNOT REPAIR OR REPLACE PARTS THAT ARE IN THE INFLATOR. MOVE THE INFLATOR CAREFULLY. IF YOU DO NOT OBEY THESE INSTRUCTIONS, AN EXPLOSION OF THE INFLATOR CAN OCCUR. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT WILL OCCUR.

- (2) Do these steps to install the inflator [18] assembly on the mounting bracket below the seat:
- (a) Apply a thin, smooth layer of Loctite 242 compound, A00648 on the thread ends of the inflator fitting [14] and the inflator [18].
 - (b) Connect the inflator fitting [14] to the inflator [18].
 - (c) Tighten the inflator fitting [14] with 60 ± 10 in-lb (7 ± 1 N·m) of torque.
 - (d) Set the inflator [18] assembly with the inflator fitting [14] on the mounting bracket in its initial position recorded during the removal.
 - (e) Safety the inflator [18] assembly on the mounting bracket.

SUBTASK 25-25-86-430-009



MAKE SURE THAT THE BUCKLE OF SEAT BELT IS OPEN (UNBUCKLED) BEFORE YOU REMOVE THE AIRBAG BELT ASSEMBLY. IF THE BUCKLE IS CONNECTED, THE AIRBAG CAN ACCIDENTALLY FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (3) Do these steps to connect the airbag gas hose [16] to the inflator [18] assembly:

NOTE: To prevent contamination of the seat belt airbag, do not fully remove the plastic bag from the airbag belt until the installation is completed.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Config 1
Page 411
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Remove and discard the end cap plug from the airbag gas hose [16].
- (b) Apply a thin, smooth layer of Loctite 242 compound, A00648 on the threads of the airbag gas hose [16] barb.
- (c) Connect the airbag gas hose [16] to the inflator fitting [14].
- (d) Tighten the airbag gas hose [16] to 120 ± 10 in-lb (13.56 ± 1.13 N·m) of torque.
 - 1) Make sure that the inflator fitting [14] is fully extended on the airbag gas hose [16] barb and makes an airtight fit.
NOTE: The inflator fitting [14] is a pressure fitting.
- (e) Connect the squib connector [19] to the inflator [18] assembly.
 - 1) Set and turn the squib connector [19] in the front end of the inflator [18] until it locks in its position.
NOTE: Do not damage the serial number on the inflator [18].
- (f) Connect the airbag electrical connector [15] to the harness connector [13].
 - 1) Move the red lock tab forward to the locked position.

F. Installation Test

SUBTASK 25-25-86-710-022-001

- (1) Do this task: V23 Inflatable Seatbelt Operational Test, TASK 25-25-86-710-805.

————— END OF TASK —————

TASK 25-25-86-000-807

6. V23 Inflatable Seatbelt Electronic Module Assembly Removal

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This task includes steps to remove the Amsafe Aviation V23 electronic module assembly (EMA) from the passenger seat.
- (2) The EMA is installed on the seat structure with the pigtail toward the rear of the airplane and the front end toward the forward of the airplane.
- (3) One EMA is installed for a two or three seat assembly.
- (4) The seatbelt airbag system operates on batteries. It does not connect to aircraft systems or the aircraft power supply.

B. Location Zones

Zone	Area
220	Subzone 220 - Section 41
230	Subzone 230 - Section 43
240	Subzone 240 - Section 44
250	Subzone 250 - Section 46
260	Subzone 260 - Section 47

C. Electronic Module Assembly Removal

SUBTASK 25-25-86-020-008

NOTE: The seat manufacturer supplies the cable routing. Before you remove the EMA [11], record the harness routing and mounting of the EMA [11] for installation.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Config 1
Page 412
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



KEEP THE ELECTRONICS MODULE ASSEMBLY AWAY FROM MAGNETIC FIELDS. MAGNETS AND ELECTRICAL CIRCUITS CAN CAUSE MAGNETIC FIELDS. MAGNETIC FIELDS CAN CAUSE THE SYSTEM TO FIRE. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.



DO NOT LET THE ELECTRONICS MODULE ASSEMBLY FALL. YOU CAN CAUSE DAMAGE TO THE ELECTRONICS, BATTERY, OR SENSOR.

- (1) Do these steps to disconnect the harness assembly from the EMA pigtail [12]:
 - (a) Push the locking mechanism to release the connector.
 - (b) Carefully pull the connector apart.

SUBTASK 25-25-86-010-003

- (2) Remove cable ties and other mounting accessories to remove the EMA [11] with the EMA pigtail [12].

SUBTASK 25-25-86-020-009

- (3) Remove the EMA [11] from the mounting bracket.

————— **END OF TASK** —————

TASK 25-25-86-400-807

7. V23 Inflatable Seatbelt Electronic Module Assembly Installation

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This task includes steps to install the Amsafe Aviation V23 electronic module assembly (EMA) on the passenger seat.
- (2) The EMA is installed on the seat structure with the EMA pigtail toward the rear of the airplane and the front of the EMA toward the forward of the airplane.
- (3) One EMA is installed for a two or three seat assembly.
- (4) The seatbelt airbag system operates on batteries. It does not connect to aircraft systems or the aircraft power supply.

B. References

Reference	Title
25-25-86-710-805	V23 Inflatable Seatbelt Operational Test (P/B 501)

C. Location Zones

Zone	Area
220	Subzone 220 - Section 41
230	Subzone 230 - Section 43
240	Subzone 240 - Section 44
250	Subzone 250 - Section 46
260	Subzone 260 - Section 47

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Config 1
Page 413
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Electronic Module Assembly Installation

SUBTASK 25-25-86-420-008



KEEP THE ELECTRONICS MODULE ASSEMBLY AWAY FROM MAGNETIC FIELDS. MAGNETS AND ELECTRICAL CIRCUITS CAN CAUSE MAGNETIC FIELDS. MAGNETIC FIELDS CAN CAUSE THE SYSTEM TO FIRE. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.



DO NOT LET THE ELECTRONICS MODULE ASSEMBLY FALL. YOU CAN CAUSE DAMAGE TO THE ELECTRONICS, BATTERY, OR SENSOR.

- (1) Install the EMA [11] in the initial location with the applicable mounting accessories.

SUBTASK 25-25-86-420-009



MAKE SURE THE WIRE ASSEMBLIES ARE FLEXIBLE. DO NOT BEND OR TWIST THEM DURING REMOVAL OR INSTALLATION. THIS CAN CAUSE DAMAGE TO THE WIRE HARNESES.

- (2) Use cable ties to attach the harness to the seat in its initial position recorded during the removal.

SUBTASK 25-25-86-420-010

- (3) Connect the cable harness to the EMA pigtail [12].

E. Installation Test

SUBTASK 25-25-86-710-021-001

- (1) Do this task: V23 Inflatable Seatbelt Operational Test, TASK 25-25-86-710-805.

————— END OF TASK —————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Config 1
Page 414
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

PASSENGER SEAT INFLATABLE SEATBELT - ADJUSTMENT/TEST

1. **General**

- A. This procedure gives the instructions to do an operational test of the AmSafe Aviation Inflatable Restraint (AAIR) seatbelt system (without seatbelt extenders).
- B. The seatbelt has built-in safety functions to prevent accidental deployments that can cause injury to persons.
- C. The Electronics Module Assembly (EMA) contains the system electronics, sensors, and battery.
- D. The EMA are connected to a maximum of three Seatbelt Airbag Assemblies (SAA) and has an interface for the System Diagnostic Tool (SDT).
- E. This procedure contains scheduled maintenance task data.

TASK 25-25-86-710-805

2. **V23 Inflatable Seatbelt Operational Test**

(Figure 501)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This procedure is for an operational test of the Amsafe Aviation V23 inflatable restraint system using the V23 System Diagnostic Tool.
- (2) The occupant restraint is also known as the seatbelt.

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-8374	System Diagnostic Tool - AAIR V23 Part #: 508668-201 Supplier: 35FB9

C. Location Zones

Zone	Area
221	Passenger Compartment, Left - Section 41
222	Passenger Compartment, Right - Section 41
231	Passenger Compartment, Left - Section 43
232	Passenger Compartment, Right - Section 43

D. Prepare for the test.

SUBTASK 25-25-86-212-003

- (1) Do a visual check for the correct condition and installation of the electrical cables between the Electronics Module Assembly (EMA) and the Seatbelt Airbag Assembly (SAA).

SUBTASK 25-25-86-212-004

- (2) Do a visual check of the Cable Interface Assembly for breaks or worn conditions.

SUBTASK 25-25-86-020-020

- (3) Replace worn or broken cables before conducting the test.

SUBTASK 25-25-86-860-007

- (4) Remove the safety tie from the seatbelt tongue if necessary.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Page 501
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-25-86-710-013

- (5) Do these steps to do a check of the System Diagnostic Tool, SPL-8374 before connecting the System Diagnostic Tool, SPL-8374 to the Cable Interface Assembly:
 - (a) Turn the ON/OFF switch on the System Diagnostic Tool, SPL-8374 to the ON position:
 - 1) Make sure that the Battery Test light is green.
 - 2) If the light is red, replace the 9-volt battery.
 - (b) Turn the ON/OFF switch on the System Diagnostic Tool, SPL-8374 to the OFF position.
 - (c) Make sure that all the buckles of the seatbelts to be tested are disconnected.

E. Inflatable Seatbelt Operational Test.

SUBTASK 25-25-86-710-014

- (1) Do these steps to do the Seatbelt Operational Test:
 - (a) Make sure that all the buckles of the seatbelts to be tested are disconnected.
 - (b) Remove the protective cap located on the diagnostic connector of the Cable Interface Assembly.
 - (c) Connect the connector of the System Diagnostic Tool, SPL-8374 to the diagnostic connector on the Cable Interface Assembly.
 - (d) Turn the System Diagnostic Tool, SPL-8374 ON/OFF switch to the ON position:
 - 1) Make sure all three Seat LED indicator lights are amber for a "pass" condition.
NOTE: An amber indication verifies the buckle activation/enabling switches are open.
 - 2) A "fail" condition is indicated if the Seat LED indicator lights are green, red, or do not come on.
 - 3) Do these steps if a "fail" condition is found:
 - a) Make sure that all the electrical connections are secure.
 - b) Replace and retest each part in the following list until all three seat LED indicator lights test amber:
 - <1> Electronics Module Assembly (EMA).
 - <2> Inflator.
 - <3> Cable Interface Assembly.
 - c) When the "pass" condition is met, go to the subsequent step.
- (2) Buckle and test each seatbelt, one seatbelt at a time.
- (3) A single seat LED will come on green to indicate a "pass" condition.
 - (a) All other seat LEDs will not come on.
- (4) All amber LEDs, all red LEDs, or all LEDs not on is a "fail" condition.
- (5) If a "fail" condition is found, then do these steps:
 - (a) Replace and retest each part in the following list until a green single seat "pass" condition is met:
 - 1) Seat Airbag Assembly (SAA).
 - 2) Electronics Module Assembly (EMA).
 - 3) Cable Interface Assembly.
 - (b) When the "pass" condition is met for each seat to be tested, go to the subsequent step.

EFFECTIVITY
ARO ALL

25-25-86

D633W101-ARO

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Page 502
Sep 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (6) Make sure that all the buckles of the seatbelts are disconnected.
- (7) Turn the System Diagnostic Tool, SPL-8374 ON/OFF switch to the OFF position.
- (8) Disconnect the connector on the System Diagnostic Tool, SPL-8374 from the diagnostic connector on the Cable Interface Assembly.
- (9) Install the safety tie on the seat belt tongue if necessary.
- (10) The AAIR System test is complete.

———— **END OF TASK** ————

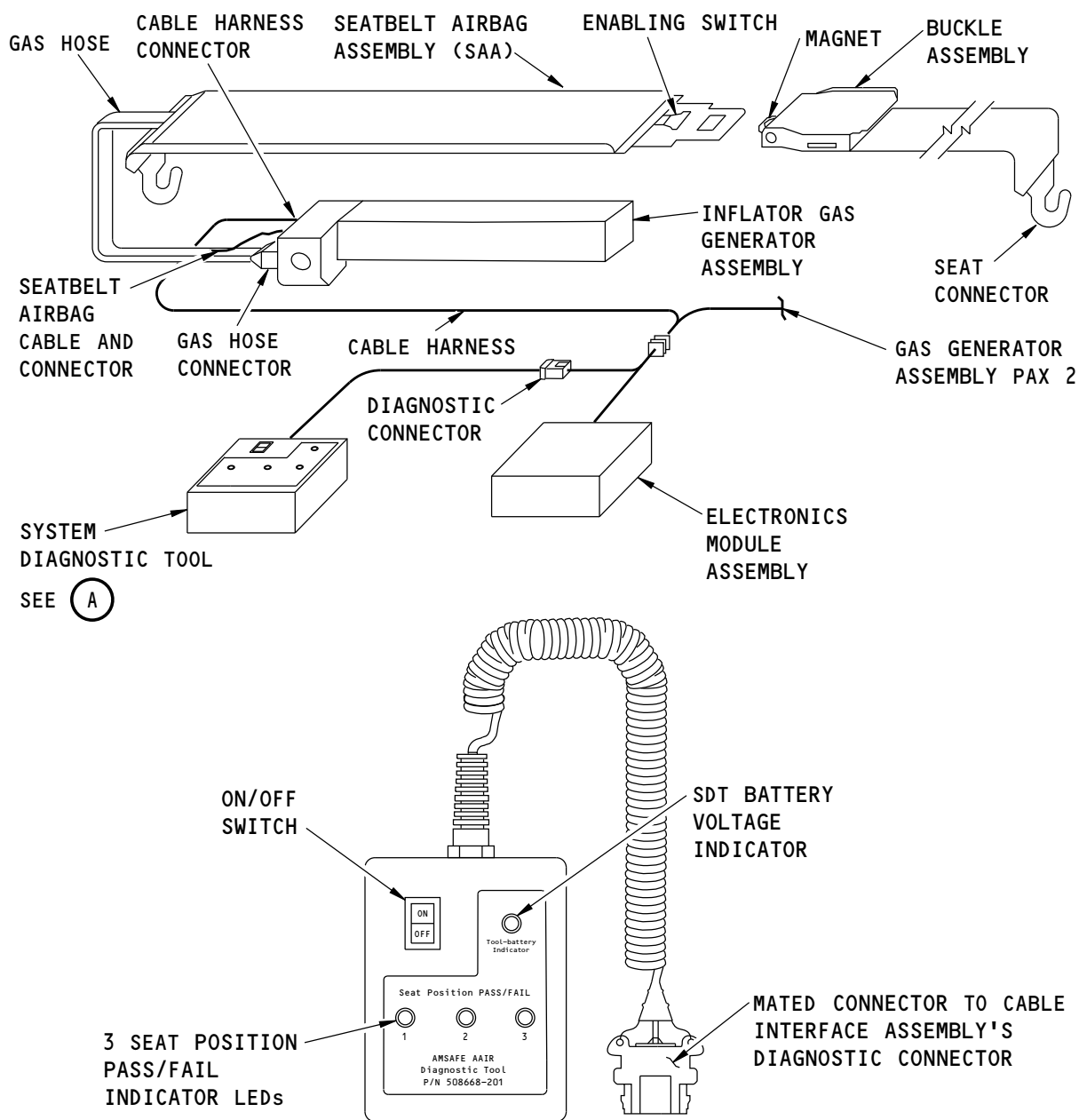
EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Page 503
Sep 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL



SYSTEM DIAGNOSTIC TOOL

(A)

1399017 S0000253407_V2

**V23 Inflatable Seatbelt Operational Test
Figure 501/25-25-86-990-804**

EFFECTIVITY
ARO ALL

25-25-86

D633W101-ARO

Page 504
Sep 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

PASSENGER SEAT INFLATABLE SEAT BELT - INSPECTION

1. **General**

- A. This procedure has these tasks:
- (1) An inspection of the V23 inflatable seat belt system
- B. This procedure contains scheduled maintenance task data.

TASK 25-25-86-200-802-001

2. **V23 Inflatable Seatbelt Detailed Inspection**

(Figure 601)

A. General

- (1) This task gives the steps to do a visual inspection of the inflatable airbag restraint system on the passenger seat assemblies.
- (2) This task applies to the Amsafe V23 seatbelt airbag system.

B. Location Zones

Zone	Area
220	Subzone 220 - Section 41
230	Subzone 230 - Section 43
240	Subzone 240 - Section 44
250	Subzone 250 - Section 46
260	Subzone 260 - Section 47

C. Prepare for the Inspection/Check

SUBTASK 25-25-86-010-019-001

- (1) Remove the bottom cushion assembly from the passenger seat.

D. Visual Inspection

SUBTASK 25-25-86-210-022-001

- (1) Do a check of the lap belt attach points on the seat frame:
 - (a) Make sure that the lap belt is correctly installed to the seatbelt mount points.

SUBTASK 25-25-86-210-023-001

- (2) Do a check of the seatbelt web material for these conditions:
 - (a) Cut or worn edges.
 - (b) Damage to the stitching.
 - (c) Broken fabric threads.
 - (d) Holes or tears.
 - (e) Excessive chafe marks.
 - (f) Excessive worn areas.

NOTE: A small quantity of worn areas on the web is permitted.

 - (g) Excessive fraying.

SUBTASK 25-25-86-210-024-001

- (3) Do a check of the airbag cover for these conditions:
 - (a) Damage to the stitching.
 - (b) Broken fabric threads.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Config 1
Page 601
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (c) Holes or tears.
- (d) Excessive chafe marks.
- (e) Excessive worn areas.
- (f) Excessive fraying.
- (g) Holes in the airbag cover or the tear-away seam.
- (h) The airbag cover connector endtack stitching is broken.
- (i) You cannot read the cover label.

SUBTASK 25-25-86-210-025-001

- (4) Do a check of the belt assembly for dirt, oil, grease, or other unwanted contamination.

SUBTASK 25-25-86-210-026-001

- (5) Do a check of the end fittings, the buckle, and the connector for cracks, dents and corrosion:
 - (a) If cracks are seen, then replace the seatbelt assembly.
 - (b) Dents or corrosion on the metal components must not affect the function of parts:
 - 1) If the function of the components is affected, then replace the affected component.

SUBTASK 25-25-86-210-027-001

- (6) Do a check of the hoses and cables for these conditions:
 - (a) Fraying.
 - (b) Excessive worn areas.
 - (c) Tears:
 - 1) Holes in the hoses are not permitted.

SUBTASK 25-25-86-210-028-001

- (7) Do a check of the cable interface assembly for these conditions:
 - (a) A broken cable tie.
 - (b) A cable tie with worn areas.
 - (c) Exposed sharp seat edges:
 - 1) If it is necessary to install protection from the sharp edges, then refer to the seat supplier instructions.
 - (d) Loose cable connections:
 - 1) Tighten or loosen the connections, if necessary.

SUBTASK 25-25-86-210-029-001

- (8) Do a check of the inflator for these conditions:
 - (a) A loose squib connector.
 - (b) Loose parts.
 - (c) Corrosion from rust:
 - 1) A light coating of rust is permitted.

SUBTASK 25-25-86-210-030-001

- (9) Do a check of the Electronic Module Assembly (EMA) for these conditions:
 - (a) Loose connections to the EMA.
 - (b) Loose parts on the EMA bracket.

EFFECTIVITY
ARO ALL

D633W101-ARO

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25-25-86

Config 1
Page 602
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-25-86-210-031-001

- (10) Do a check of the system diagnostic tool for these conditions:
- (a) Loose connections to the tool.
 - (b) Loose connectors on the tool.
 - (c) Missing or broken parts.
 - (d) A re-calibration date on the aft face of the unit:
 - 1) If it is necessary to calibrate the unit, then send the unit to the supplier for maintenance.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-25-86-410-009-001

- (1) Install the bottom cushion assembly on the passenger seat.

————— **END OF TASK** —————

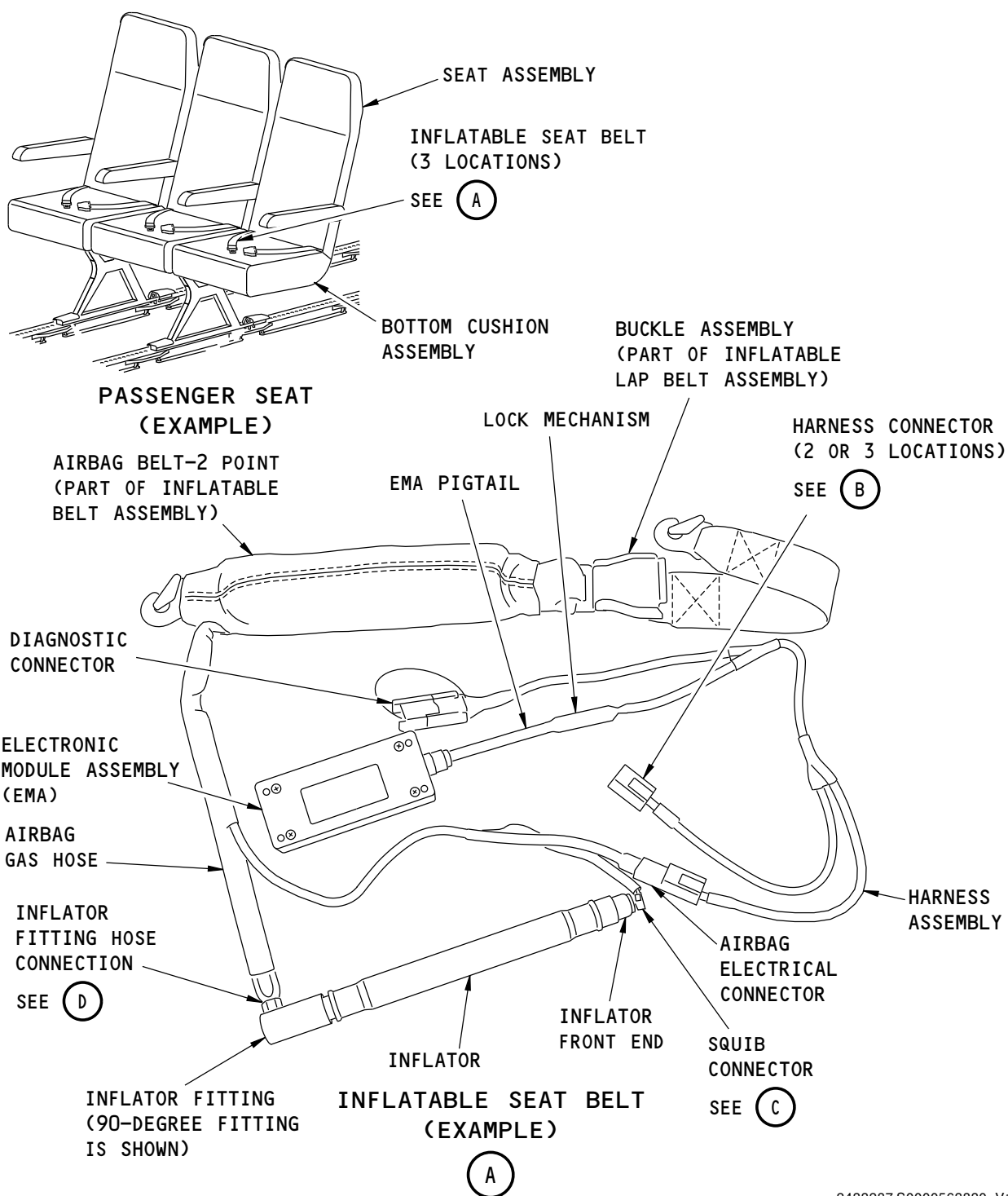
EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Config 1
Page 603
Sep 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**V23 Inflatable Seatbelt Detailed Inspection
Figure 601/25-25-86-990-820-001 (Sheet 1 of 2)**

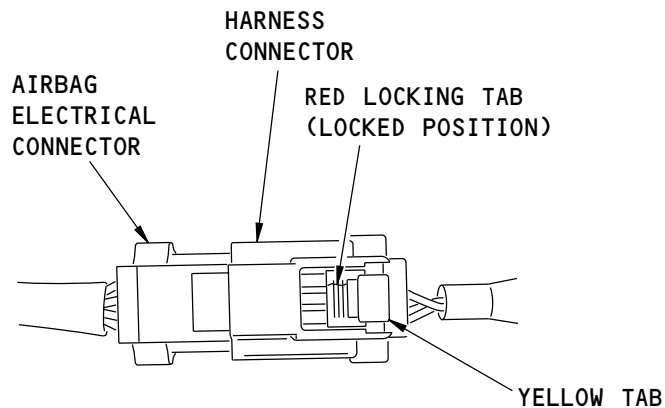
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ARO ALL

D633W101-ARO

25-25-86

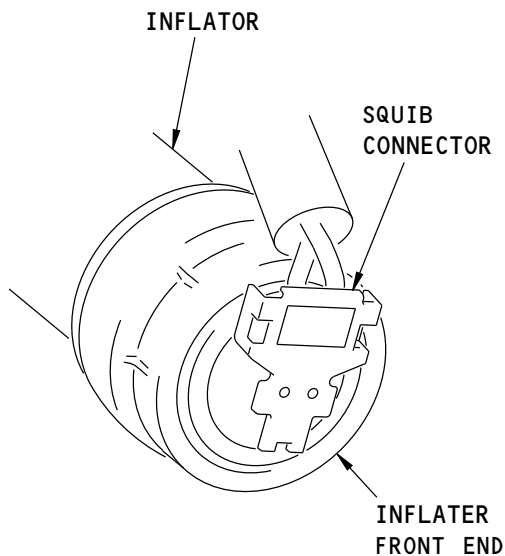
Config 1
Page 604
Sep 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



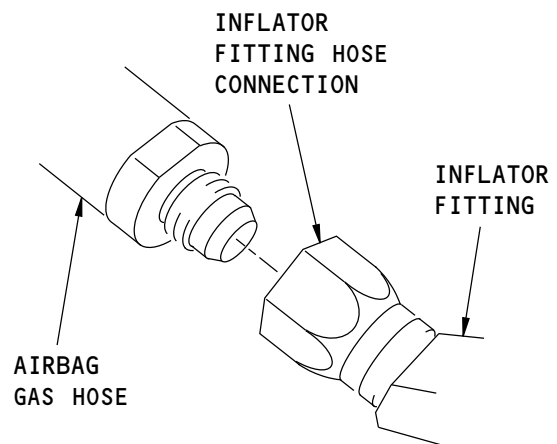
**HARNESS CONNECTOR
(EXAMPLE)**

(B)



SQUIB CONNECTOR

(C)



**INFLATOR FITTING HOSE CONNECTION
(EXAMPLE)**

(D)

2433288 S0000563834_V1

**V23 Inflatable Seatbelt Detailed Inspection
Figure 601/25-25-86-990-820-001 (Sheet 2 of 2)**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-25-86

Config 1
Page 605
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

CARPET - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the carpet
 - (2) An installation of the carpet.

TASK 25-27-01-000-801

2. Carpet (Without Adhesive Back) Removal

(Figure 401)

A. Consumable Materials

Reference	Description	Specification
B00130	Alcohol - Isopropyl	TT-I-735
B00634	Solvent - Stabilized Limonene Cleaner	BMS11-10 Type 1, 2, or 3
B50003	Solvent - Cleaning - HFE 71DE	BAC5402
B50005	Solvent - Cleaning - Vertrel MCA	BAC5402
G01288	Tape - Carpet	BMS5-133

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Carpet (Without Adhesive Back) Removal

SUBTASK 25-27-01-020-001

- (1) Remove the applicable items that follow depending on the location in the aircraft:
 - (a) the threshold for the lavatory
 - (b) the galley entryway ramp
 - (c) the seat track covers.

SUBTASK 25-27-01-020-002

- (2) Pull up on the carpet [1] edges to release the carpet [1] from the carpet tape, G01288 [3].

SUBTASK 25-27-01-020-003

- (3) Remove and discard the old carpet tape, G01288 [3] from the floor.

SUBTASK 25-27-01-020-018



CAUTION

BE CAREFUL WHEN YOU REMOVE ADHESIVE FROM THE FLOOR PANEL SURFACES. DAMAGE TO THE FLOOR PANEL CAN OCCUR.

- (4) If adhesive stays on the floor, use a scraper to remove most of the adhesive.

SUBTASK 25-27-01-100-002

- (5) Remove the remaining adhesive with one of these solvents:
 - (a) Vertrel MCA solvent, B50005 or HFE 71DE solvent, B50003

NOTE: These solvents are not flammable.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-27-01

Page 401
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



DO NOT GET ALCOHOL IN YOUR MOUTH, EYES, OR ON YOUR SKIN. PUT ON A RESPIRATOR, GOGGLES, AND GLOVES. DO NOT BREATHE THE FUMES. KEEP ALCOHOL AWAY FROM SPARKS, FLAME, AND HEAT. MAKE SURE THAT THERE IS SUFFICIENT AIR FLOW IN THE WORK AREA. ALCOHOL IS POISONOUS AND FLAMMABLE. YOU CAN ABSORB POISONOUS MATERIALS FROM THE ALCOHOL THROUGH YOUR SKIN. IT CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

(b) Isopropyl alcohol, B00130 (IPA):

- 1) Make sure that where the area you will use this solvent has good airflow and remove ignition sources.

NOTE: This solvent has a high flash point and is a lower risk. It can be safely used with the usual precautions with electrical power on the airplane.

SUBTASK 25-27-01-100-003

(6) Clean the floor panel surfaces with Limonene solvent, B00634 before you apply the new tape.

END OF TASK

TASK 25-27-01-400-801

3. Carpet (Without Adhesive Back) Installation

(Figure 401)

A. Consumable Materials

Reference	Description	Specification
G01288	Tape - Carpet	BMS5-133
G50036	Tape - Carpet, Double-sided, 5 oz/sq yd., Black on side 2. Differential Tack. Storage Life 36 Months.	BMS5-133 Type IV Class 1
G50069	Tape - Carpet, Double-backed, Adhesive - BMS5-133, Type IV, Class 1	BMS5-133 Type IV Class 1
G50119	Tape - Reinforced Polyester Double Backed Adhesive Tape - Orco-tape OT-40	BMS5-133 Type IV Class 1
G50155	Tape - Carpet, Double-sided, 16 oz/sq. yd., White. Storage Life 18 Months.	BMS5-133 Type II Class 1
G50156	Tape - Carpet, Double-sided, 16 oz/sq. yd., Black. Storage Life 18 Months.	BMS5-133 Type II Class 2
G50242	Fluid - Anti-Static, Nilodor Anti-Stat Static Relief (P/N C275-005)	

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

EFFECTIVITY
ARO ALL

25-27-01

D633W101-ARO

Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

C. Carpet (Without Adhesive Back) Installation

SUBTASK 25-27-01-420-001



CAUTION

DO NOT USE NITTO P-55 (A BRAND OPTION FOR G50155) OR P-55B (A BRAND OPTION OF G50156) DIRECTLY ON FLOOR PANEL SURFACES. THESE TAPES WILL DELAMINATE FLOOR PANEL SURFACES WHEN THEY ARE REMOVED.

- (1) Apply one layer of the optional double backed tapes, carpet tape, G01288, tape, G50036, carpet tape, G50069, Orco-tape OT-40 tape, G50119, tape, G50155, tape, G50156[3] to the applicable items that follow:
 - (a) threshold face that interfaces with the carpet [1]
 - (b) top of the raceways

SUBTASK 25-27-01-400-001



CAUTION

DO NOT USE NITTO P-55 (A BRAND OPTION FOR G50155) OR P-55B (A BRAND OPTION OF G50156) DIRECTLY ON FLOOR PANEL SURFACES. THESE TAPES WILL DELAMINATE FLOOR PANEL SURFACES WHEN THEY ARE REMOVED.

- (2) Install one new layer of the optional double backed tapes, carpet tape, G01288, tape, G50036, carpet tape, G50069, Orco-tape OT-40 tape, G50119, tape, G50155, tape, G50156[3] to the floor [4].

SUBTASK 25-27-01-400-002



CAUTION

DO NOT USE NITTO P-55 (A BRAND OPTION FOR G50155) OR P-55B (A BRAND OPTION OF G50156) DIRECTLY ON FLOOR PANEL SURFACES. THESE TAPES WILL DELAMINATE FLOOR PANEL SURFACES WHEN THEY ARE REMOVED.

- (3) Attach the carpet [1] to the floor [4] with one new layer of the optional double backed tapes, carpet tape, G01288, tape, G50036, carpet tape, G50069, Orco-tape OT-40 tape, G50119, tape, G50155, tape, G50156[3].

SUBTASK 25-27-01-100-001

- (4) Use a vacuum to clean the carpet.

SUBTASK 25-27-01-800-001

- (5) Apply the antistatic spray Nilodor Anti-Stat Fluid, G50242 to the carpet per the manufacturer's instructions as required.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-27-01-410-006

- (1) Install the seat track covers if necessary.

SUBTASK 25-27-01-410-007

- (2) Install the threshold for the lavatory if necessary.

SUBTASK 25-27-01-410-008

- (3) Install the galley entryway if necessary.

————— **END OF TASK** —————

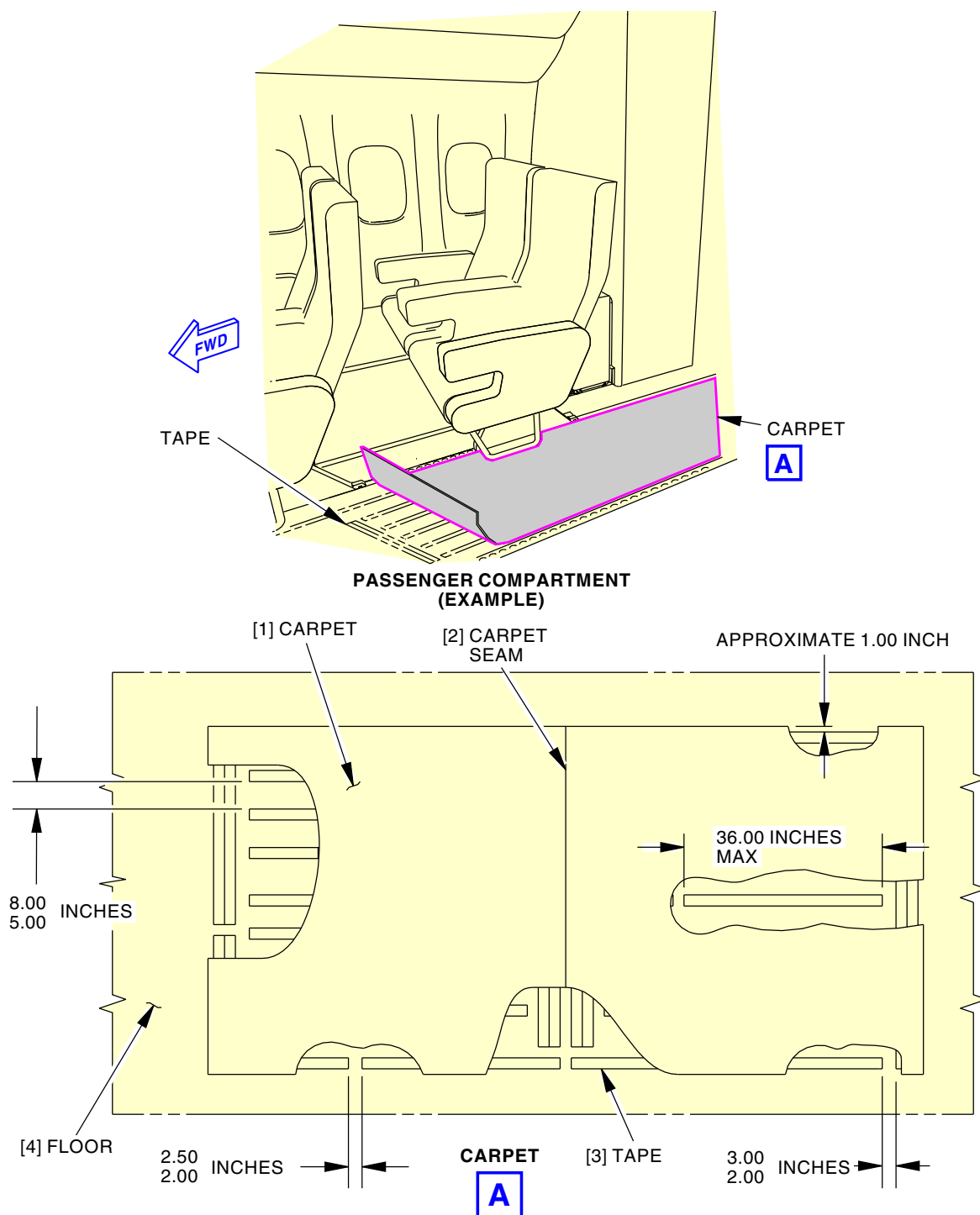
EFFECTIVITY
ARO ALL

25-27-01

D633W101-ARO

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Page 403
Sep 05/2017



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**Carpet (Without Adhesive Back) Installation
Figure 401/25-27-01-990-801**

EFFECTIVITY
ARO ALL

25-27-01

D633W101-ARO

Page 404
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-27-01-000-811

4. Carpet (Adhesive Back) Removal

Figure 402

A. General

- (1) This task applies to carpets with adhesive backing.
- (2) For detailed instruction on the removal, installation, and cleaning procedures, refer to the carpet supplier data.

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-2618	Cleaner - Vacuum Part #: 106542 Supplier: 03FQ4 Part #: 98606 Supplier: 08531 Part #: AVQ250-2 Supplier: 03FQ4 Part #: BP80 Supplier: \$0373 Part #: RSV130 Supplier: \$1291 Opt Part #: 02146A Supplier: 0A5X2 Opt Part #: 44SPEC Supplier: 0Y8U0 Opt Part #: 655406-7M Supplier: 0Y8U0 Opt Part #: C-39485-41 Supplier: 16893 Opt Part #: C-39485-42 Supplier: 16893 Opt Part #: R80 Supplier: \$0373 Opt Part #: WD80 Supplier: \$0373
STD-764	Scraper - Non-metallic

C. Consumable Materials

Reference	Description	Specification
B00130	Alcohol - Isopropyl	TT-I-735
B50005	Solvent - Cleaning - Vertrel MCA	BAC5402

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Carpet (Adhesive Back) Removal

SUBTASK 25-27-01-020-021

- (1) Remove the applicable items that follow depending on the location in the aircraft:
 - (a) the threshold for the lavatory
 - (b) the galley entryway ramp
 - (c) the seat track covers.

SUBTASK 25-27-01-020-022

- (2) Pull up the carpet edge to release the carpet from the airplane floor.

SUBTASK 25-27-01-100-004

- (3) To remove the unwanted carpet adhesive from the floor panels, do these steps:
 - (a) Use a non-metallic scraper, STD-764 and a vacuum cleaner, COM-2618 to remove the unwanted adhesive.

EFFECTIVITY
ARO ALL

25-27-01

D633W101-ARO

Page 405
Jul 25/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (b) To remove the remaining adhesive, use one of these solvents:

NOTE: Use of solvents is only recommended when a thin layer of adhesive remains after scraping.

- 1) Vertrel MCA solvent, B50005

NOTE: The solvent is non-flammable.



WARNING

DO NOT GET ALCOHOL IN YOUR MOUTH, EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM ALCOHOL. PUT ON GOGGLES, AND GLOVES WHEN YOU USE ALCOHOL. KEEP ALCOHOL AWAY FROM SPARKS, FLAME, AND HEAT. ALCOHOL IS POISONOUS AND FLAMMABLE, AND CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- 2) Isopropyl alcohol, B00130

- a) Make sure that the applicable area has good airflow, and that all ignition sources are removed.

NOTE: The solvent has a high flash point and is at low risk for ignition. If you apply standard safety precautions, this solvent is usable with electrical power supplied to the airplane.

———— **END OF TASK** ————

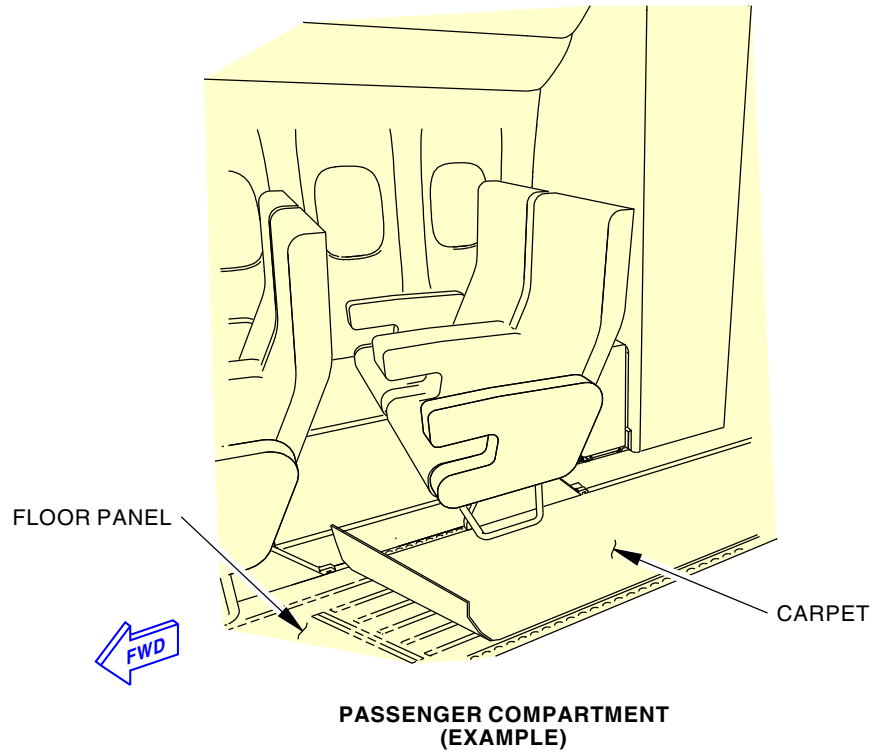
EFFECTIVITY
ARO ALL

25-27-01

D633W101-ARO

Page 406
Sep 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Carpet (Adhesive Back) Installation
Figure 402/25-27-01-990-803

EFFECTIVITY
ARO ALL

D633W101-ARO

25-27-01

Page 407
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-27-01-400-811

5. Carpet (Adhesive Back) Installation

Figure 402

A. General

- (1) The task applies to carpets with adhesive backing.
- (2) For detailed instructions on the removal, installation, and cleaning procedures, refer to the carpet supplier's data.

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-2618	Cleaner - Vacuum Part #: 106542 Supplier: 03FQ4 Part #: 98606 Supplier: 08531 Part #: AVQ250-2 Supplier: 03FQ4 Part #: BP80 Supplier: \$0373 Part #: RSV130 Supplier: \$1291 Opt Part #: 02146A Supplier: 0A5X2 Opt Part #: 44SPEC Supplier: 0Y8U0 Opt Part #: 655406-7M Supplier: 0Y8U0 Opt Part #: C-39485-41 Supplier: 16893 Opt Part #: C-39485-42 Supplier: 16893 Opt Part #: R80 Supplier: \$0373 Opt Part #: WD80 Supplier: \$0373

C. Consumable Materials

Reference	Description	Specification
G50156	Tape - Carpet, Double-sided, 16 oz/sq. yd., Black. Storage Life 18 Months.	BMS5-133 Type II Class 2
G51165	Tape - Carpet, double-coated cloth tape, flame retardant	BMS5-133 Type II Class 1

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Carpet (Adhesive Back) Installation

SUBTASK 25-27-01-020-023

- (1) Remove the release lining from the carpet adhesive.

SUBTASK 25-27-01-420-033

- (2) Attach the carpet to the floor panels.

SUBTASK 25-27-01-420-034

- (3) Manually push the carpet tightly on the floor panels.
 - (a) If the adhesive force of the carpet adhesive is not sufficient to tightly attach the carpet to the floor panels, then do these steps:
 - 1) Apply the Polyken 108FR tape, G51165 to the carpet backing.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-27-01

Page 408
Jul 25/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL



CAUTION

DO NOT USE NITTO P-55 (A BRAND OPTION FOR G50155) OR P-55B (A BRAND OPTION OF G50156) DIRECTLY ON FLOOR PANEL SURFACES. THESE TAPES WILL DELAMINATE FLOOR PANEL SURFACES WHEN THEY ARE REMOVED.

- a) It is acceptable to use the tape, G50156.
- 2) Install the carpet tightly on the floor panels.

SUBTASK 25-27-01-100-005

- (4) Use a vacuum cleaner, COM-2618 to clean the carpet.

F. Post Installation Inspection

SUBTASK 25-27-01-210-004

- (1) Make sure that there is no curling of the carpet edges and the carpet corners.

SUBTASK 25-27-01-210-005

- (2) Make sure that there is no rounding of the carpet corners.

SUBTASK 25-27-01-210-006

- (3) Make sure that there is no buckling of the carpet.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 25-27-01-420-035

- (1) Install the seat track covers if necessary.

SUBTASK 25-27-01-420-036

- (2) Install the threshold for the lavatory if necessary.

SUBTASK 25-27-01-420-037

- (3) Install the galley entryway if necessary.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

25-27-01

D633W101-ARO

Page 409
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

GALLEY AREA FLOOR MATS - REMOVAL/INSTALLATION

1. **General**

- A. This procedure contains these tasks:
- (1) Galley Area Floor Mat Removal,
 - (2) Galley Area Floor Mat Installation.

TASK 25-27-03-000-801

2. **Galley Area Floor Mat Removal**

(Figure 401)

A. **General**

- (1) The galley area floor mats attach to the floor with 2-inch-wide double-back tape. The edges of the mat are sealed and attached with edge retainers in some areas and galley trim in other areas.

B. **Location Zones**

Zone	Area
200	Upper Half of Fuselage

C. **Prepare for the Procedure**

SUBTASK 25-27-03-010-001

- (1) Loosen or remove the lavatory thresholds to release the mats if it is necessary.

SUBTASK 25-27-03-010-002

- (2) Loosen or remove the galley trim to release the mats if it is necessary.

D. **Procedure**

SUBTASK 25-27-03-020-001

- (1) Release the mat from the edge retainers.

SUBTASK 25-27-03-160-001

- (2) Remove the sealant.

SUBTASK 25-27-03-020-002

- (3) Pull up on the edges of the mat to release it from the tape that holds the mat to the floor.

NOTE: You may have to pry up the edges of the mat to release it.

SUBTASK 25-27-03-020-003

- (4) Pull the strips of old tape from the floor.

SUBTASK 25-27-03-020-004

- (5) Discard the old tape.

———— **END OF TASK** ————

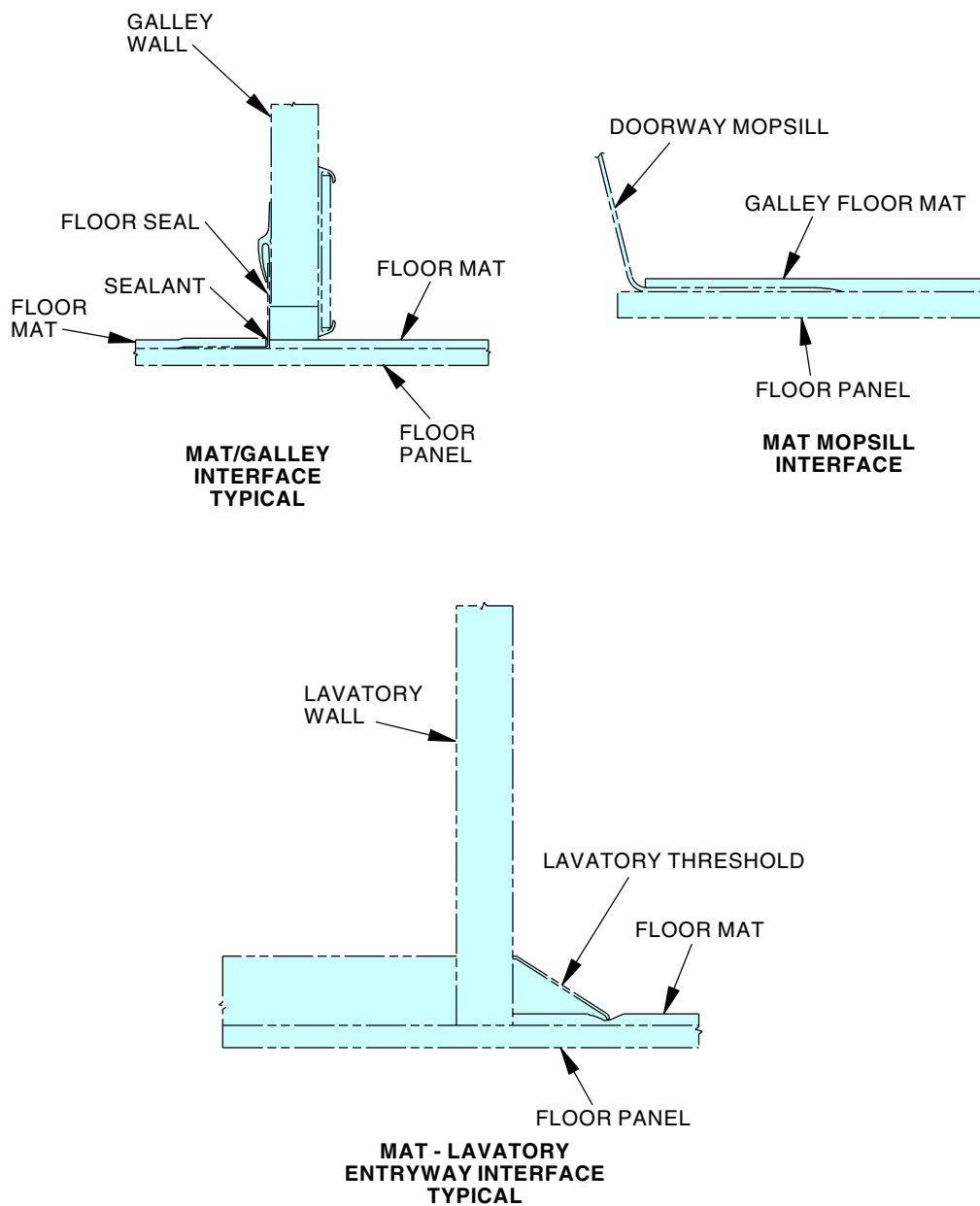
EFFECTIVITY
ARO ALL

25-27-03

D633W101-ARO

Page 401
Jan 05/2015

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Galley Area Mat Installation
Figure 401/25-27-03-990-801

EFFECTIVITY
ARO ALL

25-27-03

D633W101-ARO

Page 402
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-27-03-400-801

3. Galley Area Floor Mat Installation.

(Figure 401)

A. General

- (1) The galley area floor mats, attach to the floor with 2-inch-wide double-back tape. The edges of the mat are sealed and attached with edge retainers in some areas and galley trim in other areas.

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
G01288	Tape - Carpet	BMS5-133
G51207	Tape - Moisture Barrier, Adhesive One-side, Clear Polyurethane	BMS8-346 Type I Class 1

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Procedure

SUBTASK 25-27-03-940-001

- (1) Apply new moisture barrier tape, G51207 if necessary. Make sure to cut out around fittings.

SUBTASK 25-27-03-420-001

- (2) Clean the area with solvent, B00083.

SUBTASK 25-27-03-420-002

- (3) If you are installing a new mat, trim the mat around the galley drain plumbing.

NOTE: Make sure you have a maximum of 0.15 in. (3.81 mm) gap between the plumbing and the mat.

SUBTASK 25-27-03-420-003



CAUTION DO NOT USE NITTO P-55 (A BRAND OPTION FOR G50155) OR P-55B (A BRAND OPTION OF G50156) DIRECTLY ON FLOOR PANEL SURFACES. THESE TAPES WILL DELAMINATE FLOOR PANEL SURFACES WHEN THEY ARE REMOVED.

- (4) Apply carpet tape, G01288 across the back of the mat in a inboard / outboard direction.
 - (a) Apply the tape all the way to the edge of the mat, keeping the tape spaced up to 0.125 in. (0.318 cm) apart. Do not allow the ends and sides of the tape to touch each other.

NOTE: Do not allow the tape to show beyond the edge of the mat. If necessary, fold the tape over itself to a 1.0 inch width. This will make sure that the edge of the galley floor seal is open for air flow.
 - (b) For areas where thresholds interface with the mat, apply the tape at least 1.5 in. (3.81 cm) and no more than 4.0 in. (10.16 cm) from the edges of the mat.

SUBTASK 25-27-03-390-001

- (5) Put sealant, A00247 into the edge retainers.

EFFECTIVITY
ARO ALL

25-27-03

D633W101-ARO

Page 403
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-27-03-420-004

- (6) Put the mat in the correct location and push firmly on the tape.

SUBTASK 25-27-03-420-005

- (7) Put the edges in the edge retainers before the sealant starts to get hard.

SUBTASK 25-27-03-420-006

- (8) Install or tighten the thresholds.

SUBTASK 25-27-03-390-002

- (9) Seal the joints at the corners of the edge retainers and around the edges of the mat, plumbing, splashguard, and doorway mopsill with sealant, A00247 to make sure there is a water-tight surface.

————— END OF TASK —————

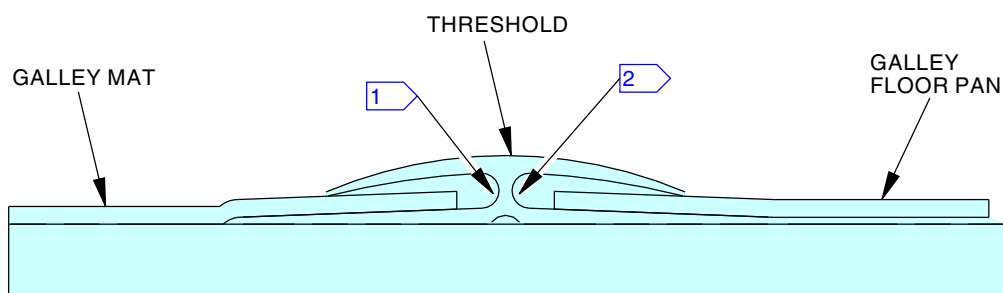
EFFECTIVITY
ARO ALL

D633W101-ARO

25-27-03

Page 404
Jan 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**MAT/THRESHOLD/GALLEY PAN INTERFACE
(EXAMPLE)**

- 1** APPLY SEALANT TO THE INNER RADIUS TO FILL THE GAP BETWEEN THE THRESHOLD AND MAT. SQUEEZE OUT ON VISIBLE MAT SURFACE NOT ALLOWED.
- 2** APPLY SEALANT TO THE INNER RADIUS TO FILL THE GAP BETWEEN THE THRESHOLD AND GALLEY PAN. SQUEEZE OUT ON VISIBLE SURFACE NOT ALLOWED.

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**Galley Area Floor Mat
Figure 402/25-27-03-990-802 (Sheet 1 of 2)**

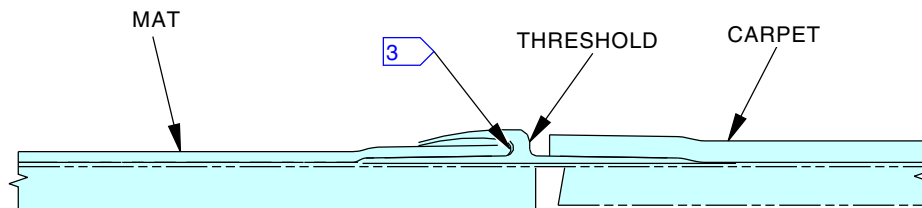
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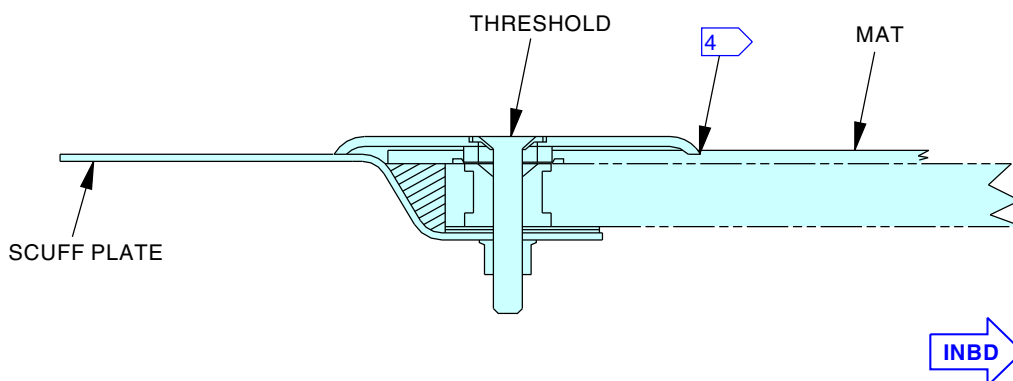
25-27-03

Page 405
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



**MAT/THRESHOLD/CARPET INTERFACE
(EXAMPLE)**



**MAT/DOORWAY SCUFF PLATE INTERFACE
(EXAMPLE)**

3 APPLY SEALANT TO THE INNER RADIUS TO FILL THE GAP BETWEEN THE THRESHOLD AND MAT. SQUEEZE OUT ON VISIBLE MAT SURFACE NOT ALLOWED.

4 SEAL MAT TO INBOARD EDGE OF THRESHOLD WITH SEALANT. CLEAN EXCESS SEALANT MAINTAINING A DECORATIVE APPEARANCE.

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**Galley Area Floor Mat
Figure 402/25-27-03-990-802 (Sheet 2 of 2)**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-27-03

Page 406
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

ENTRYWAY FLOOR COVERING - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Removal of the entryway floor covering.
 - (2) Installation of the entryway floor covering.

TASK 25-27-07-000-801

2. Entryway Floor Covering - Removal

A. Consumable Materials

Reference	Description	Specification
B00068	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002, MIL-E-51454 Type II
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
B00130	Alcohol - Isopropyl	TT-I-735
B00666	Solvent - Methyl Propyl Ketone	BMS11-9
G02163	Sheet - Fire Resistant Glass Fiber Reinforced Phenolic Laminate Cargo Liner	BMS8-223

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-27-07-010-001



DO NOT GET SOLVENTS IN YOUR MOUTH, YOUR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. SOLVENTS ARE DANGEROUS MATERIALS. SOLVENTS CAN BE FLAMMABLE. OBEY THE MATERIAL SAFETY DATA SHEETS (MSDS) FOR SOLVENTS. OBEY LOCAL REGULATIONS FOR THE CORRECT PROCEDURES TO USE OR DISCARD SOLVENTS. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (1) Remove the retainer plate from the edge of the mat if necessary.

SUBTASK 25-27-07-010-002

- (2) Remove the thresholds around the edge of the vinyl mat if necessary.

SUBTASK 25-27-07-160-001

- (3) If the vinyl mat has the adhesive, use solvent, B00666, solvent, B00083, alcohol, B00130 or alcohol, B00068 to loosen the adhesive from the vinyl mat.

SUBTASK 25-27-07-020-001

- (4) Pull up on the vinyl mat at the edges to release it from the tape that holds the mat to the sheet, G02163.

NOTE: Make sure that you do not damage the water barrier.

SUBTASK 25-27-07-010-003

- (5) Remove the vinyl mat.

EFFECTIVITY
ARO ALL

25-27-07

D633W101-ARO

Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-27-07-020-002

- (6) Remove the sheet, G02163.

NOTE: Make sure that you do not damage the water barrier.

SUBTASK 25-27-07-010-004

- (7) Do the following steps to remove the water barrier if you replace the entire area:
- (a) Pull the strips of tape off the floor.
 - (b) Remove the fillet seal from the edges of the sidewall if necessary.

————— **END OF TASK** —————

TASK 25-27-07-400-801

3. Entryway Floor Covering - Installation

A. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
B00068	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002, MIL-E-51454 Type II
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
B00130	Alcohol - Isopropyl	TT-I-735
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
G02163	Sheet - Fire Resistant Glass Fiber Reinforced Phenolic Laminate Cargo Liner	BMS8-223
G50155	Tape - Carpet, Double-sided, 16 oz/sq. yd., White. Storage Life 18 Months.	BMS5-133 Type II Class 1
G51340	Tape - Moisture Barrier, Adhesive One-side	BMS8-346 Type II Class 4

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Entryway Floor Covering - Installation

SUBTASK 25-27-07-160-002



DO NOT GET SOLVENTS IN YOUR MOUTH, YOUR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. SOLVENTS ARE DANGEROUS MATERIALS. SOLVENTS CAN BE FLAMMABLE. OBEY THE MATERIAL SAFETY DATA SHEETS (MSDS) FOR SOLVENTS. OBEY LOCAL REGULATIONS FOR THE CORRECT PROCEDURES TO USE OR DISCARD SOLVENTS. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (1) Remove the dirt from the moisture barrier and the vinyl mat bottom.

SUBTASK 25-27-07-160-003

- (2) Clean the moisture barrier surface and the surface of the vinyl mat bottom with solvent, B00148, solvent, B00083, alcohol, B00130, or alcohol, B00068.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-27-07

Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-27-07-160-004

- (3) Remove the dried adhesive from the moisture barrier surface and the surface of the vinyl mat bottom.

NOTE: Use a rag, soft brush or sponge to remove the dried adhesive.

SUBTASK 25-27-07-160-005

- (4) Dry the surfaces with a clean cloth.

SUBTASK 25-27-07-420-001

- (5) Install the sheet, G02163.

NOTE: Make sure that the sheet, G02163 is installed face down.

NOTE: Make sure that you do not damage the water barrier.

SUBTASK 25-27-07-400-001

- (6) Repair or install the moisture barrier tape, G51340, if it is necessary.

NOTE: The necessary overlap at the splice locations is four inches.

SUBTASK 25-27-07-400-002



DO NOT USE NITTO P-55 (A BRAND OPTION FOR G50155) OR P-55B (A BRAND OPTION OF G50156) DIRECTLY ON FLOOR PANEL SURFACES. THESE TAPES WILL DELAMINATE FLOOR PANEL SURFACES WHEN THEY ARE REMOVED.

- (7) Install the tape, G50155 to the sheet, G02163.

NOTE: Make sure the tape is 2.0 inches away from the mat edge where thresholds will be installed. For all other areas the tape may go to the outer edge of the mat.

SUBTASK 25-27-07-400-003

- (8) Install the vinyl mat to the entryway areas.

SUBTASK 25-27-07-400-004

- (9) Install the thresholds if it is necessary.

NOTE: Apply the sealant, A00247 below the joints and along the vinyl mat perimeter.

SUBTASK 25-27-07-160-006

- (10) Remove the excess sealant.

————— **END OF TASK** —————

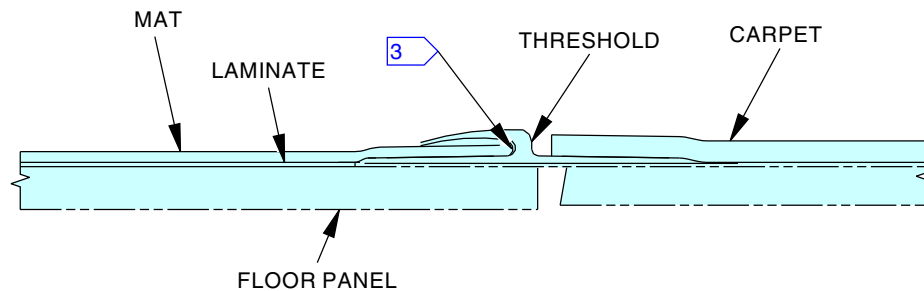
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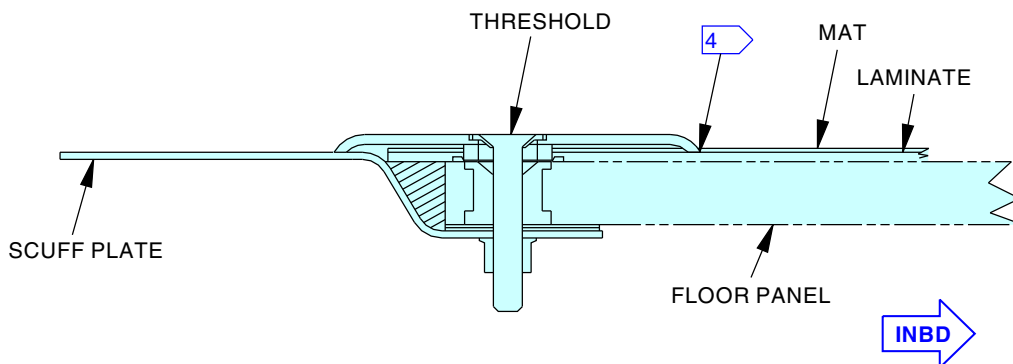
D633W101-ARO

Page 403
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



**MAT/THRESHOLD/CARPET INTERFACE
(EXAMPLE)**



**MAT/DOORWAY SCUFF PLATE INTERFACE
(EXAMPLE)**

3 APPLY SEALANT TO THE INNER RADIUS TO FILL THE GAP BETWEEN THE THRESHOLD AND MAT. SQUEEZE OUT ON VISIBLE MAT SURFACE NOT ALLOWED.

4 SEAL MAT TO INBOARD EDGE OF THRESHOLD WITH SEALANT. CLEAN EXCESS SEALANT MAINTAINING A DECORATIVE APPEARANCE.

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**Entryway Area Floor Mat
Figure 401/25-27-07-990-802**

EFFECTIVITY
ARO ALL

25-27-07

D633W101-ARO

Page 404
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

PASSENGER SEAT RACEWAYS - REMOVAL/INSTALLATION

1. General

- A. Wires are routed to the passenger seats through raceways. The raceways protect the wires from damage.
- B. Wires go to the seats for the following electrical systems:
 - (1) On some airplanes, power for the seat adjustments.
 - (2) On some airplanes, Seat Electronic Units or SEU's.
- C. When new seats are installed or when airplane seats are repitched the raceways and wires should be relocated.
- D. Double back tape attaches the raceways to the airplane deck.

TASK 25-27-09-000-801

2. RACEWAY REMOVAL

Figure 401

A. References

Reference	Title
25-21-01	SIDEWALL PANEL
25-25-01-000-801	Passenger Seat - Removal (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-27-09-030-006

- (1) Disconnect any applicable circuit breakers for the power seats or SEU equipment.

SUBTASK 25-27-09-030-001

- (2) Remove the seat track covers between the seats.

SUBTASK 25-27-09-030-002

- (3) Open the SEU shroud and disconnect the cables from the SEU below each seat.
 - (a) Push the connector latch and disconnect the cable from J1 and J2 SEU connectors.
 - (b) Install a cap on the cable and SEU connectors.

SUBTASK 25-27-09-030-003

- (4) Disconnect power seat electrical connectors.

SUBTASK 25-27-09-030-004

- (5) Remove the applicable passenger seats, if it is necessary.

NOTE: See Passenger Seat - Removal, TASK 25-25-01-000-801 for additional information.

SUBTASK 25-27-09-820-001

- (6) Determine the new raceway layout applicable for the new seat configuration.
 - (a) Length of the longitudinal raceways
 - 1) The forward most edge of the raceway is determined by the forward most edge of the front leg fitting on the first seat.
- NOTE: Exception to the above occurs when a transverse raceway is at the front of a raceway run.

EFFECTIVITY
ARO ALL

25-27-09

D633W101-ARO

Page 401
Jan 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- 2) The aft most edge is determined by the rear most edge of the rear leg fitting on the last seat.

NOTE: Exception to the above occurs when a transverse raceway is at the rear of a raceway run.

(b) Locating transverse raceways

- 1) Transverse raceways are located .75 inches forward of the centerline of the front seat stud (measured to the aft edge of the raceway). See (Figure 401).
- 2) In some cases the transverse raceways run aft of the aft seat leg. These transverse raceways are usually located behind the last seat. The distance from the last seat leg to the raceway may vary.

(c) Locating longitudinal raceways next to the sidewall

- 1) From the transverse raceway, run forward or aft to the dado panel gap/break nearest to the sidewall disconnect to which the electrical cables will be connected.

NOTE: Avoid dado panel gaps at station 1000 and station 1480 due to extra large body structure at major body join locations.

SUBTASK 25-27-09-030-005

- (7) Remove applicable sidewall panel (SIDEWALL PANEL, SUBJECT 25-21-01).

———— **END OF TASK** ————

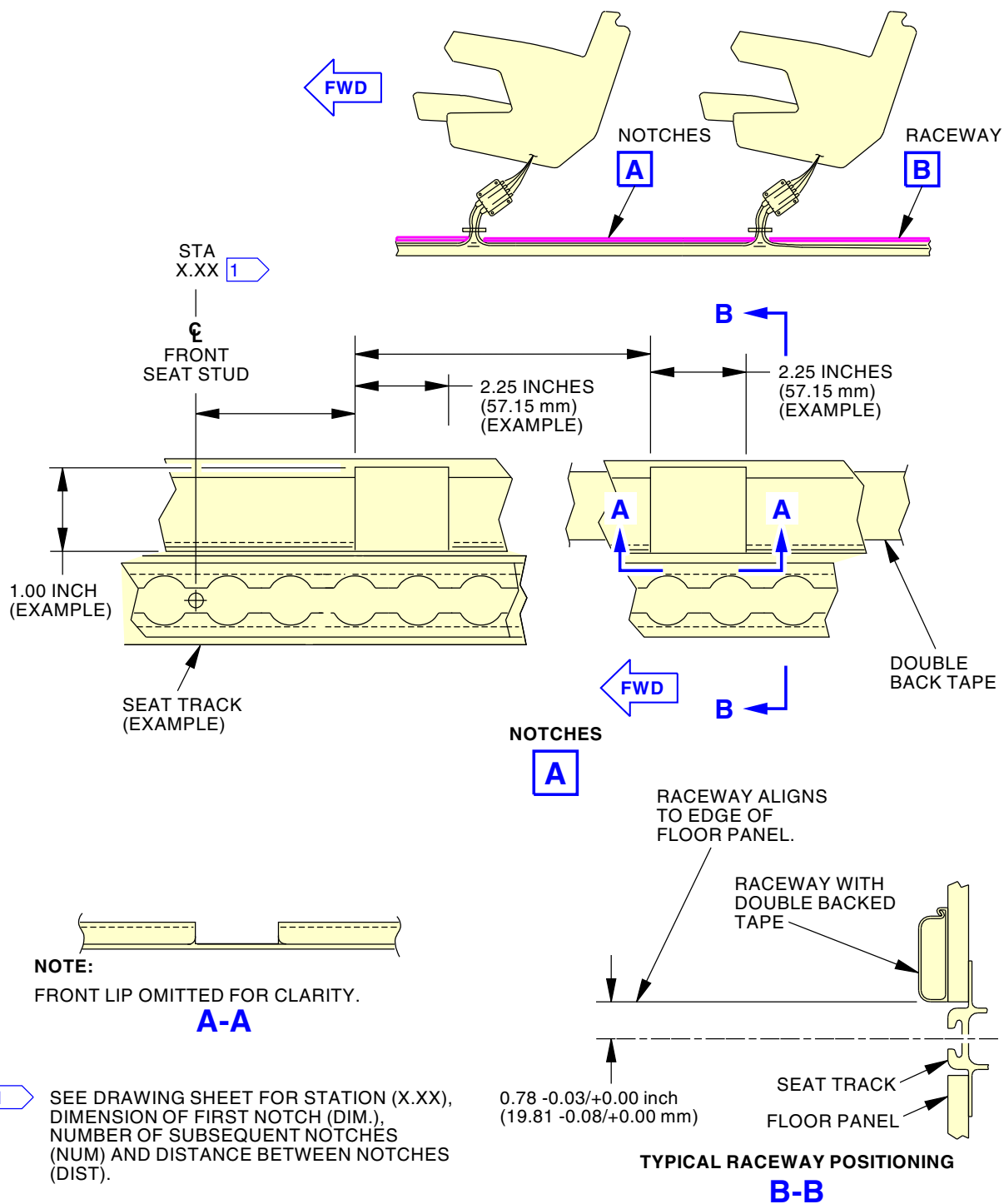
EFFECTIVITY
ARO ALL

25-27-09

D633W101-ARO

Page 402
Jan 05/2016

777-200/300 AIRCRAFT MAINTENANCE MANUAL



Raceway Location
Figure 401/25-27-09-990-801 (Sheet 1 of 2)

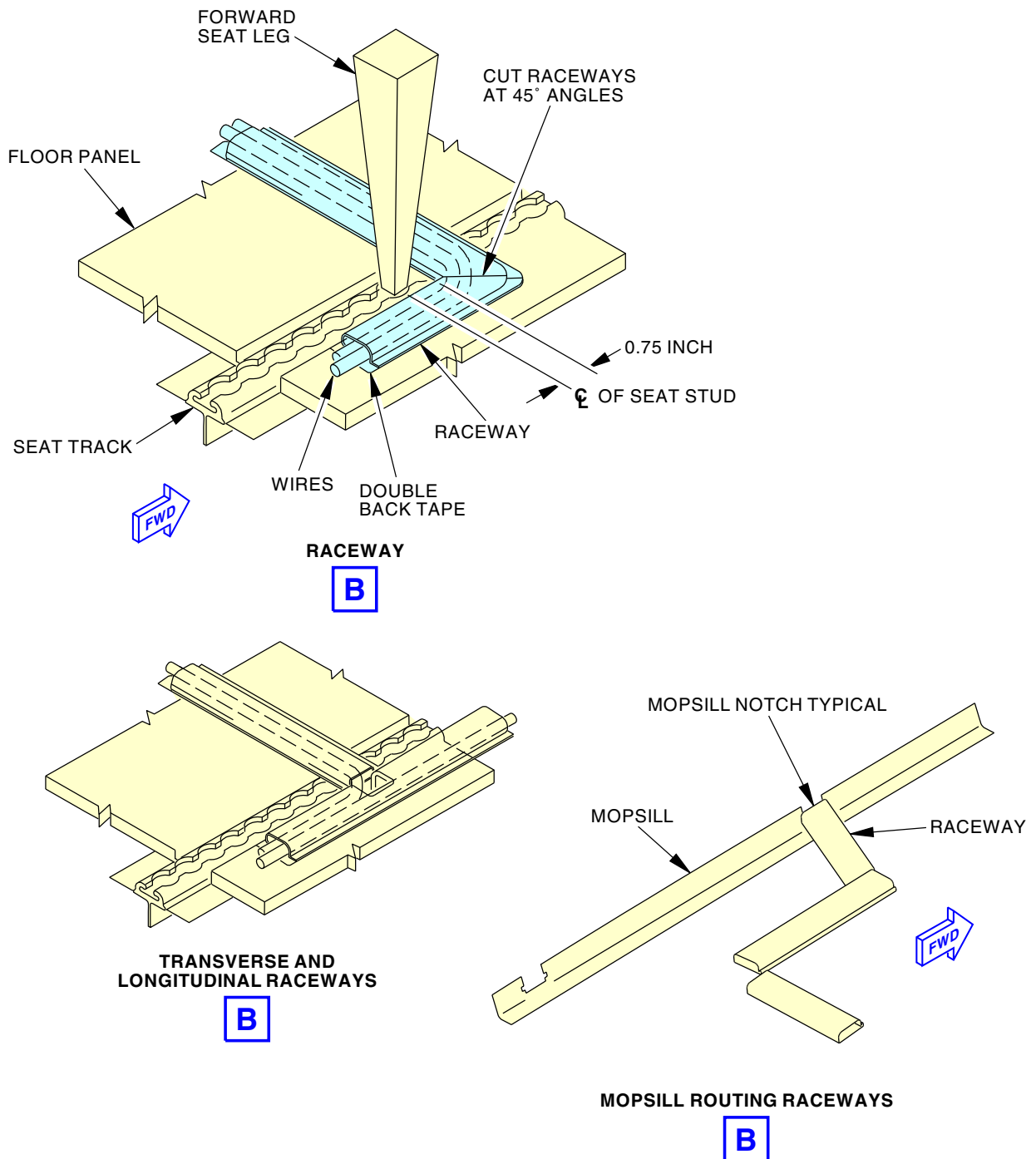
EFFECTIVITY
ARO ALL

D633W101-ARO

25-27-09

Page 403
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



Raceway Location
Figure 401/25-27-09-990-801 (Sheet 2 of 2)

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EFFECTIVITY
 ARO ALL

25-27-09

D633W101-ARO

Page 404
 May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-27-09-400-801

3. RACEWAY INSTALLATION

Figure 401

A. References

Reference	Title
24-22-00 P/B 201	AC GENERATION AND BUS CONTROL - MAINTENANCE PRACTICES
25-21-01 P/B 401	SIDEWALL PANEL - REMOVAL/INSTALLATION
25-25-01-400-801	Passenger Seat - Installation (P/B 401)
25-27-01 P/B 401	CARPET - REMOVAL/INSTALLATION

B. Consumable Materials

Reference	Description	Specification
G50156	Tape - Carpet, Double-sided, 16 oz/sq. yd., Black. Storage Life 18 Months.	BMS5-133 Type II Class 2

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Procedure

SUBTASK 25-27-09-160-001

- (1) Clean the floor in the area of the new raceway installation.

SUBTASK 25-27-09-430-001

- (2) Apply new tape, G50156.

SUBTASK 25-27-09-420-001

- (3) Put the new raceway sections on the tape.

SUBTASK 25-27-09-820-002

- (4) Cut the raceway sections for the new seat configuration as follows:
 - (a) Locating raceway notches
 - 1) The first notch is located "DIM" inches from indicated station (Center line of the front seat stud). This distance is measured to the front of the notch. The notches are centered under the opening in the SEU shroud.
 - a) See (Figure 401)
 - 2) Subsequent notches are measured aft to whatever seat pitch is being used (measured from front of notch to front of next notch).
 - 3) A change in seat pitch could result in a change in the notch locations.
 - a) See Figure 401 for cutout views when raceways cross each other.
 - b) See Figure 401 for cutout view when transverse raceway meets longitudinal raceway, not at the end of a run.

SUBTASK 25-27-09-410-002

- (5) Change the raceways for the floor proximity path lighting for the new seat configuration, if it is necessary.

SUBTASK 25-27-09-410-003

- (6) Install the applicable sidewall panels (SIDEWALL PANEL - REMOVAL/INSTALLATION, PAGEBLOCK 25-21-01/401).

EFFECTIVITY
ARO ALL

25-27-09

D633W101-ARO

Page 405
Jan 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-27-09-410-004

- (7) Change the floor covers for the new seat configuration (CARPET - REMOVAL/INSTALLATION, PAGEBLOCK 25-27-01/401).

SUBTASK 25-27-09-410-005

- (8) Recut new seat track covers if it is necessary.

SUBTASK 25-27-09-410-006

- (9) Install the applicable passenger seats for the new seat configuration if it is necessary.

NOTE: See Passenger Seat - Installation, TASK 25-25-01-400-801 for additional information.

SUBTASK 25-27-09-410-007

- (10) Connect the SEU cables to the SEU and close the SEU shroud.
(a) Connect the SEU cables to the SEU J1 and J2 connectors below each seat.

SUBTASK 25-27-09-410-008

- (11) Connect the power seat electrical connectors.

SUBTASK 25-27-09-410-009

- (12) Install the seat track covers between the seats.

SUBTASK 25-27-09-410-010

- (13) Install the life vests below the new passenger seats.

SUBTASK 25-27-09-410-011

- (14) Change the configuration of the identification placards for the passenger seats.

SUBTASK 25-27-09-430-002

- (15) Close any circuit breakers that were opened for the power seats or SEU equipment.

SUBTASK 25-27-09-861-001

- (16) Supply the electrical power (AC GENERATION AND BUS CONTROL - MAINTENANCE PRACTICES, PAGEBLOCK 24-22-00/201).

SUBTASK 25-27-09-710-001

- (17) Test the seats and systems for proper operation.

SUBTASK 25-27-09-862-001

- (18) Remove the electrical power if it is not necessary (AC GENERATION AND BUS CONTROL - MAINTENANCE PRACTICES, PAGEBLOCK 24-22-00/201).

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-27-09

D633W101-ARO

Page 406
Jan 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

EPOXY WALKWAY COATING - REMOVAL/INSTALLATION

1. General

A. This procedure contains these tasks:

- (1) Removal of the epoxy walkway coating on the overhead flight crew rest (OFCR) stairs.
- (2) Installation of the epoxy walkway coating on the overhead flight crew rest (OFCR) stairs.

TASK 25-27-11-000-801

2. Epoxy Walkway Coating - Removal

A. General

- (1) This topic includes steps to remove the epoxy walkway coating on the stairs of the overhead flight crew rest (OFCR).

B. Consumable Materials

Reference	Description	Specification
B50079	Solvent - Aliphatic Naphtha (For Acrylic Plastics)	TT-N-95 Type II (Supersedes BMS3-2 Type II)
B50225	Solvent - Citra-Safe (Deodorized)	
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00219	Cloth - Tack Rag	
G50220	Pad - Abrasive, Scotch- Brite 7447	

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Epoxy Walkway Coating Removal

SUBTASK 25-27-11-940-003

- (1) Remove all loose materials.

SUBTASK 25-27-11-940-002

- (2) Scuff sand with Scotch-Brite 7447 pad, G50220.

NOTE: Do not use pads with silicon. Use of abrasive with silicon can cause adhesion problems with the coating or tape.

NOTE: Do not use stearate sandpaper. Stearates can cause loss of adhesion problems or an unacceptable appearance of the coating or tape.

SUBTASK 25-27-11-940-001

- (3) Do these steps to clean the area:
 - (a) Wipe the area with cotton wiper, G00034.
 - (b) Clean the area with aliphatic naphtha, B50079 or citra-safe solvent, B50225.
 - (c) Wipe the area clean again with a tack cloth, G00219.
 - 1) Discard the tack cloth after use.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

25-27-11

D633W101-ARO

Page 401
May 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-27-11-400-801

3. Epoxy Walkway Coating - Installation

A. General

- (1) This task includes the steps to install the epoxy walkway coating on the steps of the overhead flight crew rest (OFCR).

B. Tools/Equipment

Reference	Description
STD-447	Gun - Pressure Sprayer

C. Consumable Materials

Reference	Description	Specification
B50079	Solvent - Aliphatic Naphtha (For Acrylic Plastics)	TT-N-95 Type II (Supersedes BMS3-2 Type II)
B50225	Solvent - Citra-Safe (Deodorized)	
C50069	Coating - Chemical And Solvent Resistant Finish - (BAC 702 White Color, Gloss)	BMS10-11 Type II
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00219	Cloth - Tack Rag	
G50124	Compound - Pumice, Grade 1/2 - Navajo Brand	
G50220	Pad - Abrasive, Scotch- Brite 7447	

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Prepare for the Installation

NOTE: Make sure surface preparation, mixing, application and drying/curing areas are adequately ventilated and protected from uncontrolled spray, dust, fumes, and particulate matter.

SUBTASK 25-27-11-840-001

- (1) Remove all loose materials.

SUBTASK 25-27-11-120-001

- (2) Scuff sand with Scotch-Brite 7447 pad, G50220.

NOTE: Do not use pads with silicon. Use of abrasive with silicon can cause adhesion problems with the coating or tape.

NOTE: Do not use stearate sandpaper. Stearates can cause loss of adhesion problems or an unacceptable appearance of the coating or tape.

SUBTASK 25-27-11-940-004

- (3) Do these steps to clean the area:
- Wipe the area with cotton wiper, G00034.
 - Clean the area with aliphatic naphtha, B50079 or citra-safe solvent, B50225.
 - Wipe the area clean again with a tack cloth, G00219.
 - Discard the tack cloth after use.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-27-11

Page 402
May 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

F. Epoxy Walkway Coating Installation

SUBTASK 25-27-11-400-001

(1) Do one of these two methods to apply new epoxy coating:

(a) Method I - epoxy and pumice mixture:

- 1) Pour the desired amount needed for spray application of epoxy coating, C50069 and Navajo Brand compound, G50124 pumice into a container.
 - a) Use 1 ± 0 lb (0.5 ± 0.1 kg) of pumice per gallon of epoxy coating.
- 2) Apply this mixture when the temperature is between 50°F (10°C) and 100°F (38°C) and the humidity is less than 85 percent.

NOTE: Make sure that this mixture is continuously agitated or the pumice can settle and cause insufficient slip resistance.

- 3) Use a pressure sprayer gun, STD-447 or equivalent, to apply one cross coat of this mixture to the walkway.
- 4) Apply 1-1/2 cross coats (three wet passes) of epoxy coating, C50069 without the pumice.

(b) Method II - separate epoxy coating and pumice application

- 1) Apply the epoxy when the temperature is between 50°F (10°C) and 100°F (38°C) and the humidity is less than 85 percent.
- 2) Use a pressure sprayer gun, STD-447 or equivalent, to apply one cross coat of the epoxy walkway coating.
- 3) When you complete the epoxy layer, use a pressure sprayer gun, STD-447 tool with the applicable tip to apply Navajo Brand compound, G50124 pumice to the epoxy.

NOTE: Make sure that the epoxy layer is not too dry. If the epoxy is too dry, the pumice adhesion to the epoxy can be unsatisfactory and durability problem can occur.

- 4) Apply two more layers of epoxy coating over the pumice.

(c) Air dry at a minimum of 70°F (21°C) for a minimum of 24 hours.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-27-11

D633W101-ARO

Page 403
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

OUTBOARD STOWAGE BIN - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the outboard stowage bin.
 - (2) An installation of the outboard stowage bin.
 - (3) A removal of the outboard stowage bin module.
 - (4) An installation of the outboard stowage bin module.
- B. The outboard stowage bin module consists of the stowage bin, snubbers, and the strongback assembly. The module is removable as one unit.

TASK 25-28-01-000-801

2. Outboard Stowage Bin - Removal

(Figure 401)

A. References

Reference	Title
25-25-01-000-801	Passenger Seat - Removal (P/B 401)
25-28-03-000-801	Stowage Bin Snubber Removal (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-28-01-010-001

- (1) Remove the passenger seats if it is necessary. Do this task: Passenger Seat - Removal, TASK 25-25-01-000-801

SUBTASK 25-28-01-010-002

- (2) Open the stowage bin [5].

SUBTASK 25-28-01-010-003

- (3) At an expansion joint, remove the seal from the space between the stowage bins [5].

D. Outboard Stowage Bin Removal

SUBTASK 25-28-01-020-001

- (1) Disconnect the lower end of the snubber [8] from each side of the stowage bin [5]
 - (a) Do this task: TASK 25-28-03-000-801.

SUBTASK 25-28-01-020-002

- (2) Remove the screws [7] from the pivot attachments [6] on the inner surface of the stowage bin [5].

SUBTASK 25-28-01-020-003

- (3) While you hold the stowage bin [5], pull the pivot attachments [6] to the center of the stowage bin [5].

NOTE: The damper will stay on the pivot attachment. The washer may stay on the pivot attachment but can fall off.

EFFECTIVITY
ARO ALL

25-28-01

D633W101-ARO

Page 401
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-28-01-020-004



DO NOT PUT THE STOWAGE BIN IN DIRECT SUNLIGHT OR STRONG ARTIFICIAL LIGHT. DIRECT SUNLIGHT OR STRONG ARTIFICIAL LIGHT WILL CHANGE THE COLOR OF SOME OF THE PARTS ON THE STOWAGE BIN.

(4) Carefully remove the stowage bin [5].

SUBTASK 25-28-01-550-001

(5) Keep the washers [2] and dampers [3] for the subsequent installation task.

————— **END OF TASK** —————

TASK 25-28-01-400-801

3. Outboard Stowage Bin Installation

(Figure 401)

A. References

Reference	Title
25-25-01-400-801	Passenger Seat - Installation (P/B 401)
25-28-03-400-801	Stowage Bin Snubber Installation (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Outboard Stowage Bin Installation

SUBTASK 25-28-01-210-001

(1) Make sure the bushings [1] stay in the strongback assembly [4].

SUBTASK 25-28-01-420-011

(2) Install the damper [3] and washer [2] on the pivot attachment [6].

SUBTASK 25-28-01-820-002

(3) Do these steps to put the stowage bin [5] in the position for the installation:

- (a) Turn the back of the stowage bin [5] outboard and up.
- (b) Make sure the strongback pivot is between the brackets and stop on the stowage bin.

NOTE: There is a tight clearance between the stowage bin and the strongback pivot attachment. The position of the stowage bin is important because the strongback pivot can interfere with the stowage bin stop or the brackets on the back of the stowage bin.

- (c) Turn the stowage bin [5] to align the pivot attachments when you get the stowage bin [5] in the opening.

SUBTASK 25-28-01-420-001

(4) Put one of the pivot attachments [6] through the inner surface of the stowage bin [5].

SUBTASK 25-28-01-420-002

(5) Push the pivot attachment [6] fully through the stowage bin [5] and the strongback assembly [4].

SUBTASK 25-28-01-420-003

(6) Do these steps while you hold the stowage bin [5] up:

- (a) Install the damper [3] and washer [2] on the other pivot attachment [6].

EFFECTIVITY
ARO ALL

25-28-01

D633W101-ARO

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Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (b) Put the pivot attachment [6] through the inner surface of the stowage bin [5].
- (c) Align the pivot attachment [6] on the outer surface of the stowage bin [5] with the strongback assembly [4].
- (d) Push the pivot attachment [6] fully through the strongback assembly [4].

SUBTASK 25-28-01-420-012

- (7) Install the screws [7] that attach the two pivot attachments [6] to the stowage bin [5].

SUBTASK 25-28-01-820-001

- (8) Align the snubber [8] with the pin on each side of the stowage bin [5].

SUBTASK 25-28-01-420-004

- (9) Attach the lower end of the snubber [8] to the stowage bin [5].
 - (a) Do this task: TASK 25-28-03-400-801.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-28-01-410-001

- (1) Close the stowage bin [5].

SUBTASK 25-28-01-410-002

- (2) At an expansion joint, install the seal from the space between the stowage bins [5].

SUBTASK 25-28-01-410-003

- (3) Install the passenger seats if they were removed. Do this task: Passenger Seat - Installation, TASK 25-25-01-400-801.

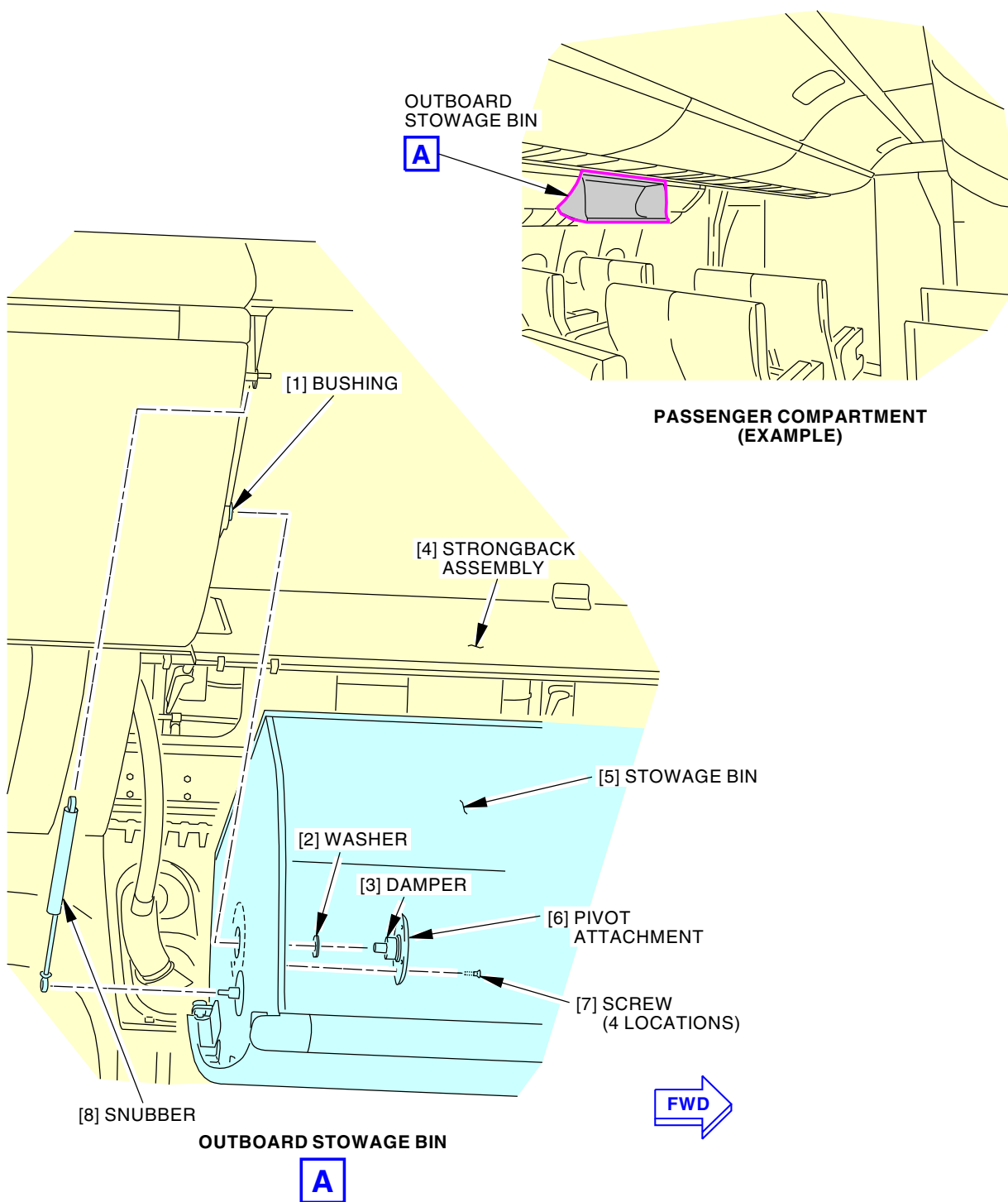
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EFFECTIVITY
ARO ALL

25-28-01

D633W101-ARO

Page 403
Sep 05/2017



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**Outboard Stowage Bin Installation
Figure 401/25-28-01-990-801**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-28-01

Page 404
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-28-01-000-802

4. Outboard Stowage Bin Module Removal

(Figure 402)

A. References

Reference	Title
24-22-00-860-806	Remove Electrical Power (P/B 201)
25-21-06-000-801	Main Ceiling Panel - Removal (P/B 401)
25-23-01-010-801	Passenger Service Unit (PSU) Opening (P/B 201)
25-25-01-000-801	Passenger Seat - Removal (P/B 401)
33-21-01-960-802	Indirect Ceiling Light - Light Assembly Replacement (P/B 201)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-28-01-860-001

- (1) Do this task: Remove Electrical Power, TASK 24-22-00-860-806.

SUBTASK 25-28-01-010-008

- (2) At an expansion joint, remove the seal from the space between the stowage bin modules [21].

SUBTASK 25-28-01-010-004

- (3) Remove the passenger seats if it is necessary (TASK 25-25-01-000-801).

SUBTASK 25-28-01-010-005

- (4) Do this task: Main Ceiling Panel - Removal, TASK 25-21-06-000-801.

SUBTASK 25-28-01-010-009

- (5) Remove the indirect ceiling light, light shield [30], light deflector bracket, and ballast from the stowage bin module [21].

- (a) Refer to this task if it is necessary: Indirect Ceiling Light - Light Assembly Replacement (TASK 33-21-01-960-802).

SUBTASK 25-28-01-010-006

- (6) Open the PSU (TASK 25-23-01-010-801).

D. Outboard Stowage Bin Module Removal

SUBTASK 25-28-01-010-007

- (1) Do these steps to remove the PSUs [22] at the ends of the stowage bin module [21]:

NOTE: It is only necessary to remove the PSUs [22] that are installed on two adjacent stowage bin modules [21].

- (a) Disconnect the hoses and electrical connectors from the PSUs [22].
(b) Remove the PSUs [22].

SUBTASK 25-28-01-020-005

- (2) Do these steps on top of the stowage bin module [21]:

- (a) Disconnect the electrical connectors from the ships wiring.
1) Look outboard of the bin rail to make sure all of the electrical connectors are disconnected.

EFFECTIVITY
ARO ALL

25-28-01

D633W101-ARO

Page 405
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-28-01-020-009

- (3) Put the hoses and electrical wires back through the holes in the strongback assembly [4].

SUBTASK 25-28-01-020-010

- (4) Remove the bolt [30] and washer [29] to disconnect the bracket [31] from the strongback assembly [4].

SUBTASK 25-28-01-020-006

- (5) Remove the bolts [28], washers [25], [27], and nuts [24] if it is necessary to disconnect the lower tie rods [26] from the bracket [31].

SUBTASK 25-28-01-020-007

- (6) While one person holds the stowage bin module [21], remove the quick-release pins [23] from the brackets on the top of the strongback assembly [4].

NOTE: Two people may be necessary to hold the large stowage bin modules.

SUBTASK 25-28-01-020-008

- (7) Carefully remove the stowage bin module [21].

NOTE: You do not need to remove all of the PSUs [22] from the strongback assembly [4] when you remove the stowage bin module [21].

————— **END OF TASK** —————

TASK 25-28-01-400-802

5. Outboard Stowage Bin Module Installation

(Figure 402)

A. References

Reference	Title
21-61-04-400-801	Zone Air Temperature Sensor Installation (P/B 401)
23-33-02-700-801	Overhead Electronics Unit Installation Test (P/B 401)
24-22-00-860-805	Supply Electrical Power (P/B 201)
25-21-06-400-801	Main Ceiling Panel - Installation (P/B 401)
25-23-01-410-801	Passenger Service Unit (PSU) Closing (P/B 201)
25-25-01-400-801	Passenger Seat - Installation (P/B 401)
33-21-00-710-801	Passenger Compartment Illumination - Operational Test (P/B 501)
33-21-01-960-802	Indirect Ceiling Light - Light Assembly Replacement (P/B 201)
33-23-00-710-801	Reading Lights - Operational Test (P/B 501)
33-28-00-710-801	Passenger Call Light - Operational Test (P/B 501)
35-21-00-710-801	Oxygen Box Door Latch/Actuator Operational Test (P/B 501)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Outboard Stowage Bin Module Installation

SUBTASK 25-28-01-420-005

- (1) While one person holds the stowage bin module [21] up in the position for the installation, do these steps:
 - (a) Put the lower tie rods [26] through the cutouts in the strongback assembly [4].
 - (b) Push the button on the top of the quick-release pin [23] to disengage the ball locks.

EFFECTIVITY
ARO ALL

25-28-01

D633W101-ARO

Page 406
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (c) Put the quick-release pin [23] through the bracket on the top of the strongback assembly [4] and the support rail [31].

NOTE: The head of the quick-release pin [23] must touch the bracket to make sure it is fully engaged.

- (d) If the lower tie rods [26] were disconnect from the brackets [31] during the removal, install the bolts [28], washers [25], [27], and nuts [24] to attach the lower tie rods [26] to the brackets [31].
- (e) Install the bolts [30] and washers [29] to attach the bracket [31] to the strongback assembly [4].

SUBTASK 25-28-01-420-006

- (2) Connect the electrical connectors to the ships wiring.

SUBTASK 25-28-01-420-010

- (3) Install the PSUs [22] at the ends of the stowage bin module [21].
 - (a) Connect the hoses and electrical connectors for the PSUs.

D. Outboard Stowage Bin Module Installation Test

SUBTASK 25-28-01-860-002

- (1) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-28-01-710-001

- (2) Do the applicable tests that follow for the systems or components disconnected during the removal:
 - (a) Overhead Electronics Unit Installation Test. Do this task: TASK 23-33-02-700-801
 - (b) Passenger Compartment Illumination - Operational Test. Do this task: TASK 33-21-00-710-801
 - (c) Reading Lights - Operational Test. Do this task: TASK 33-23-00-710-801
 - (d) Do this task: Passenger Call Light - Operational Test, TASK 33-28-00-710-801.
 - (e) Do this task: Oxygen Box Door Latch/Actuator Operational Test, TASK 35-21-00-710-801.

SUBTASK 25-28-01-740-001

- (3) Do the Installation Test in this task: Zone Air Temperature Sensors Installation TASK 21-61-04-400-801.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-28-01-410-004

- (1) Do this task: Passenger Service Unit (PSU) Closing, TASK 25-23-01-410-801.

SUBTASK 25-28-01-410-005

- (2) At an expansion joint, install the seal in the space between the stowage bin modules [21].

SUBTASK 25-28-01-410-008

- (3) Install the indirect ceiling light, light shield [30], light deflector bracket, and ballast on the stowage bin module [21].
 - (a) D this task: TASK 33-21-01-960-802

SUBTASK 25-28-01-410-006

- (4) Do this task: Main Ceiling Panel - Installation, TASK 25-21-06-400-801.

EFFECTIVITY
ARO ALL

25-28-01

D633W101-ARO

Page 407
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-28-01-410-007

(5) Do this task: Passenger Seat - Installation, TASK 25-25-01-400-801.

———— **END OF TASK** ————

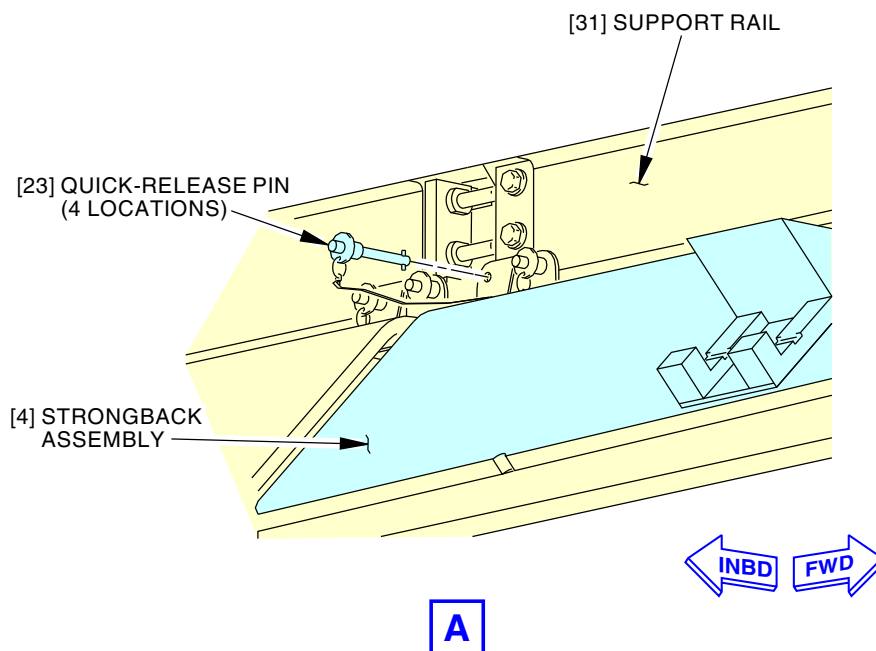
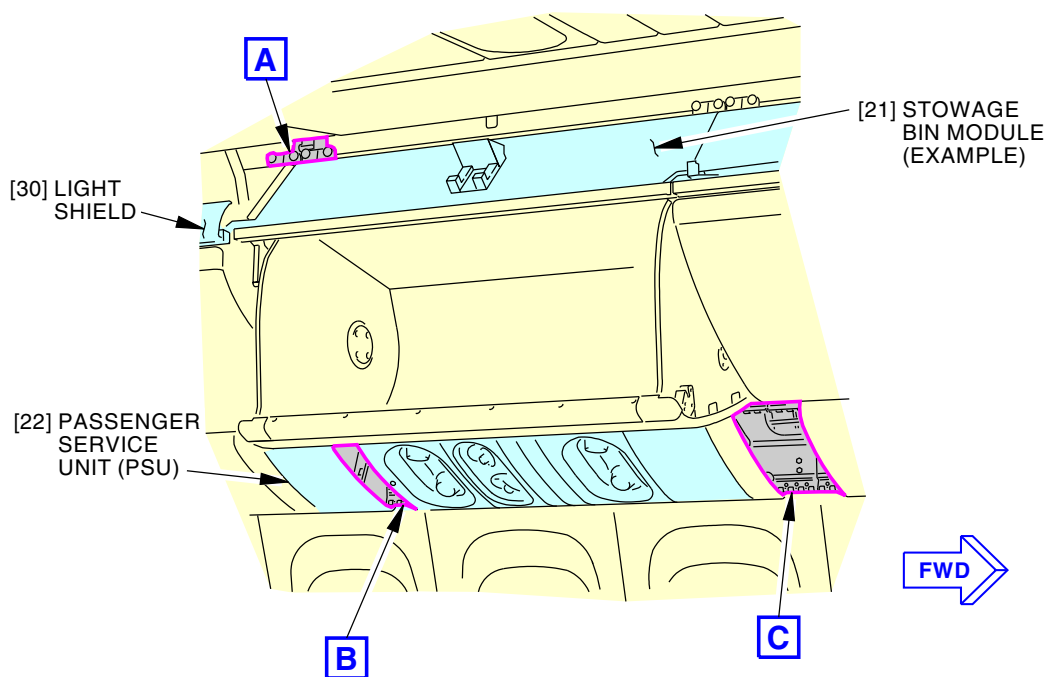
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D633W101-ARO

25-28-01

Page 408
Jan 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Outboard Stowage Bin Module Installation
Figure 402/25-28-01-990-802 (Sheet 1 of 2)**

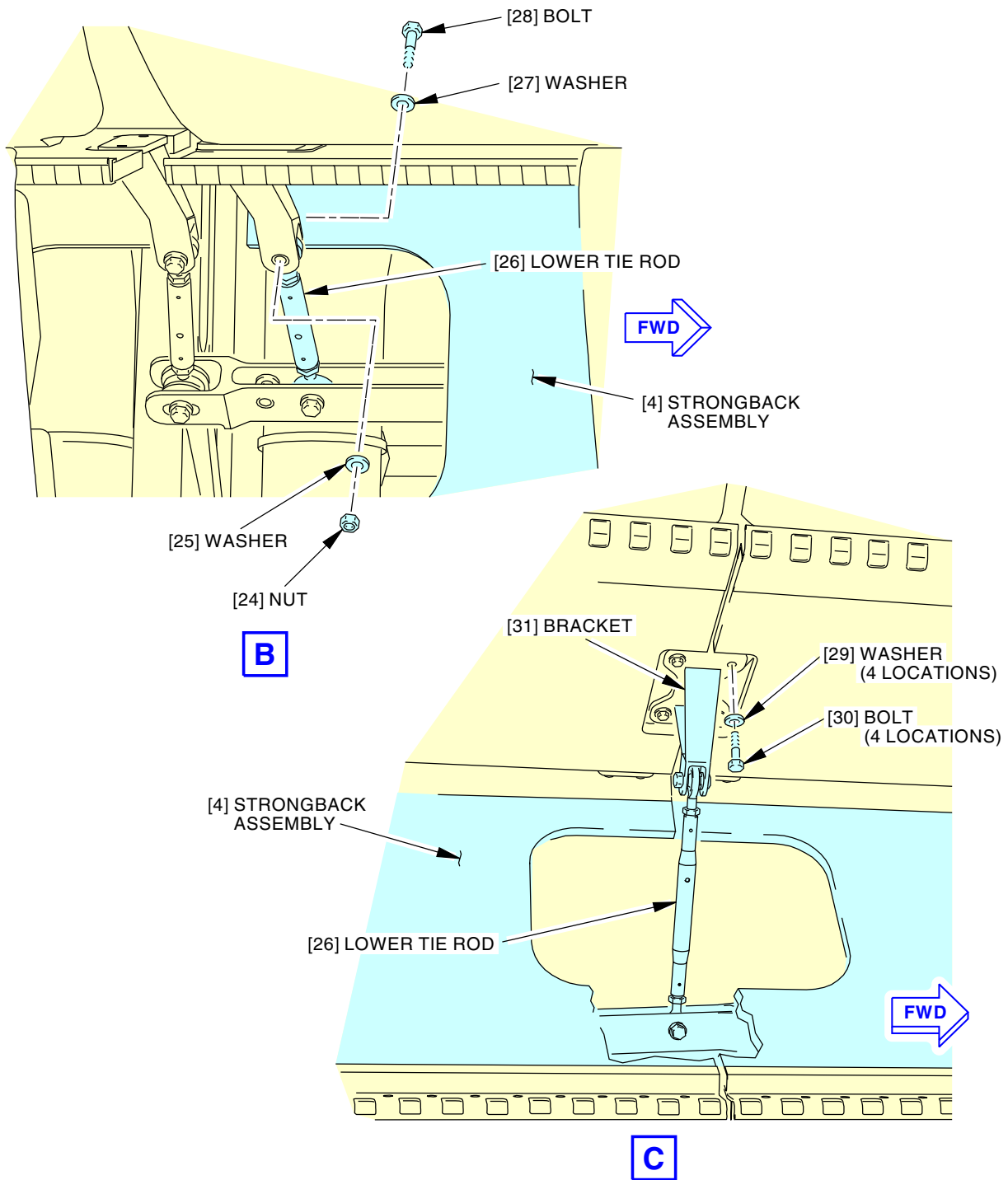
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25-28-01

D633W101-ARO

Page 409
May 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



D10153 S0006409822_V2

Outboard Stowage Bin Module Installation
Figure 402/25-28-01-990-802 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

25-28-01

D633W101-ARO

Page 410
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

CENTER STOWAGE BIN - MAINTENANCE PRACTICES

1. General

- A. This procedure has a task to change the operation mode for the center stowage bin.
- B. These are the two operation modes for the center stowage bins:
 - (1) Horizontal Translation
 - (2) Vertical Translation.
- C. The horizontal translation mode is the basic operation of the center stowage bin and is used for these seat groups: 1-3-1, 2-3-2, 2-4-2, 2-5-2, 3-4-3, and 2-4-3. In the horizontal translation mode the stowage bin moves outboard as it opens.
- D. The vertical translation mode of operation limits the bin to a vertical motion as it opens. It is used for these seat groups: 2-2-2, 3-3-3, and 2-4-3.
- E. You can change the operation mode of the center stowage bins between the passenger doors No. 1 and No. 2. The provisions necessary to change the operation mode are optional for the remaining center stowage bins in the airplane. Thus, it is possible that not all center stowage bins on the aircraft can change operation modes.

TASK 25-28-02-860-802

2. Change the Operation Mode

(Figure 201)

A. General

- (1) To change the operation mode of a center stowage bin it is necessary to have two different snubbers.
 - (a) You also need two each drive links and idler links for each overhead stowage bin bucket.

B. References

Reference	Title
25-25-01 P/B 401	PASSENGER SEATS - REMOVAL/INSTALLATION

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Prepare for the Change

SUBTASK 25-28-02-010-021

- (1) Remove the passenger seats if it is necessary. Do the applicable task in this procedure: PASSENGER SEATS - REMOVAL/INSTALLATION, PAGEBLOCK 25-25-01/401.

E. Procedure for Horizontal Translating Mode to Vertical Mode

SUBTASK 25-28-02-010-022

- (1) Open the stowage bin.

SUBTASK 25-28-02-860-011

- (2) Do the steps that follow to change the stowage bin from the horizontal translation mode to vertical translation:

NOTE: The steps that follow should be done to the two ends of the stowage bin.

- (a) Align the rigging holes between mechanism linkages.
- (b) Put a 0.25 in. (6.35 mm) maximum diameter X 2.5 in. (63.5 mm) long pin through the rigging hole to lock the stowage bin in place.

EFFECTIVITY
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D633W101-ARO

25-28-02

Page 201
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (c) Turn the stowage bin bucket clockwise.
- (d) Remove the cotter pin and washers from the pivot pin.
- (e) Pull the linkage arms away from the bin to disengage the pivot pins.
- (f) Remove the bin.
- (g) Carefully remove the alignment pins from the rigging hole.
- (h) Carefully push on the lower linkage arms to close the mechanism.
- (i) Remove the horizontal drive link.
- (j) Remove the rate control spring from the idler pin.
- (k) Remove the horizontal idler link.
- (l) Install the vertical idler link.
- (m) Install the rate control spring to the idler pin.
NOTE: The spring must be compressed approximately 2 in. (51 mm).
- (n) Install the vertical drive link.
- (o) Remove the horizontal snubber assembly.
- (p) Install the vertical snubber assembly.
- (q) Move the bin stop from the horizontal to the vertical position.
- (r) Move the lower pivot boss on the bin from the horizontal to the vertical position.
- (s) Pull the linkage arms down and install the rigging pin.

SUBTASK 25-28-02-410-010

- (3) Close the stowage bin.
 - (a) Make sure that there is sufficient clearance between the latch bolt and the latch.
 - (b) Manually move the bin in a forward and aft direction. The latch boss and latch can touch. Washers can be added or removed to adjust contact.
 - (c) Look to see that the upper mechanism pins are flush or extend through the end of the pin and bearings.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-28-02-410-012

- (1) Install the passenger seats if they were removed. Do the applicable task in this procedure:
PASSENGER SEATS - REMOVAL/INSTALLATION, PAGEBLOCK 25-25-01/401

G. Procedure for Vertical Translating Mode to Horizontal Mode

SUBTASK 25-28-02-010-023

- (1) Remove the passenger seats if it is necessary. Do the applicable task in this procedure:
PASSENGER SEATS - REMOVAL/INSTALLATION, PAGEBLOCK 25-25-01/401.

SUBTASK 25-28-02-010-024

- (2) Open the stowage bin.

SUBTASK 25-28-02-860-012

- (3) Do the steps that follow to change the stowage bin from the vertical translation mode to horizontal translation:

NOTE: The steps that follow should be done to the two ends of the stowage bin.

- (a) Align the rigging holes between mechanism linkages.



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (b) Put a 0.25 in. (6.35 mm) maximum diameter X 2.5 in. (63.5 mm) long pin through the rigging hole to lock the stowage bin in place.
- (c) Turn the stowage bin bucket clockwise.
- (d) Remove the cotter pin and washers from the pivot pin.
- (e) Pull the linkage arms away from the bin to disengage the pivot pins.
- (f) Remove the bin.
- (g) Carefully remove the alignment pins from the rigging hole.
- (h) Carefully push on the linkage arms to close the mechanism.
- (i) Remove the vertical drive link.
- (j) Remove the rate control spring from the idler pin.

NOTE: The spring must be compressed slightly for removal. It will extend approximately 2 in. (51 mm) when removed.

- (k) Remove the vertical idler link.
- (l) Install the horizontal idler link.
- (m) Install the rate control spring to the idler pin.
- (n) Install the horizontal drive link.
- (o) Remove the vertical snubber assembly.
- (p) Install the horizontal snubber assembly.
- (q) Move the bin stop from the vertical to the horizontal position.
- (r) Move the lower pivot boss on the bin from the vertical to the horizontal position.
- (s) Carefully pull the linkage arms down and install the rigging pin.

SUBTASK 25-28-02-400-009

- (4) Close the stowage bin.
 - (a) Make sure that there is sufficient clearance between the latch bolt and the latch.
 - (b) Manually move the bin in a forward and aft direction. The latch boss and latch can touch. Washers can be added or removed to adjust contact.
 - (c) Look to see that the upper mechanism pins are flush or extend through the end of the pin and bearings.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 25-28-02-410-011

- (1) Install the passenger seats if they were removed. Do the applicable task in this procedure: PASSENGER SEATS - REMOVAL/INSTALLATION, PAGEBLOCK 25-25-01/401

————— **END OF TASK** —————

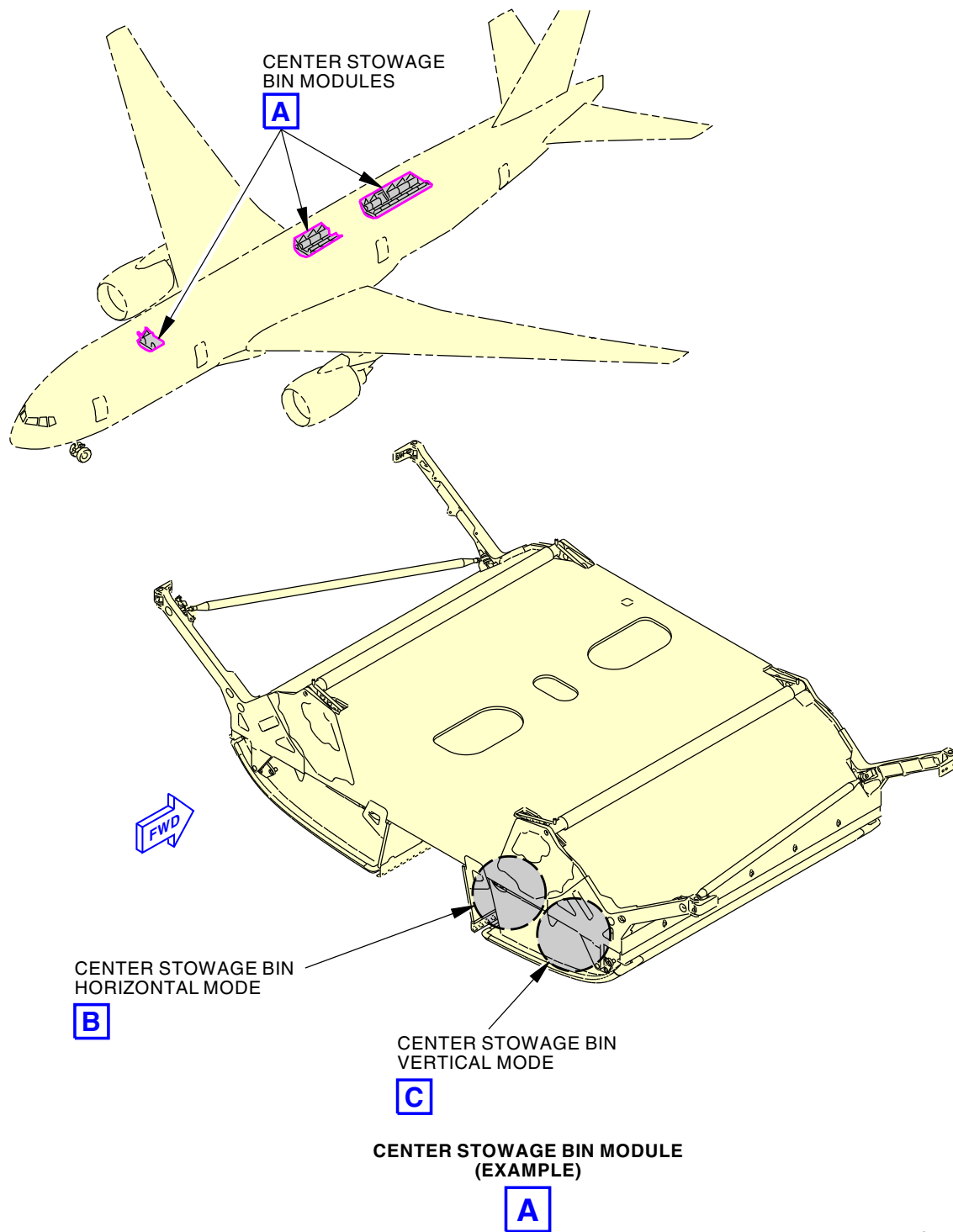
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25-28-02

Page 203
May 05/2015

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Center Stowage Bin Translation Mode
Figure 201/25-28-02-990-808 (Sheet 1 of 3)

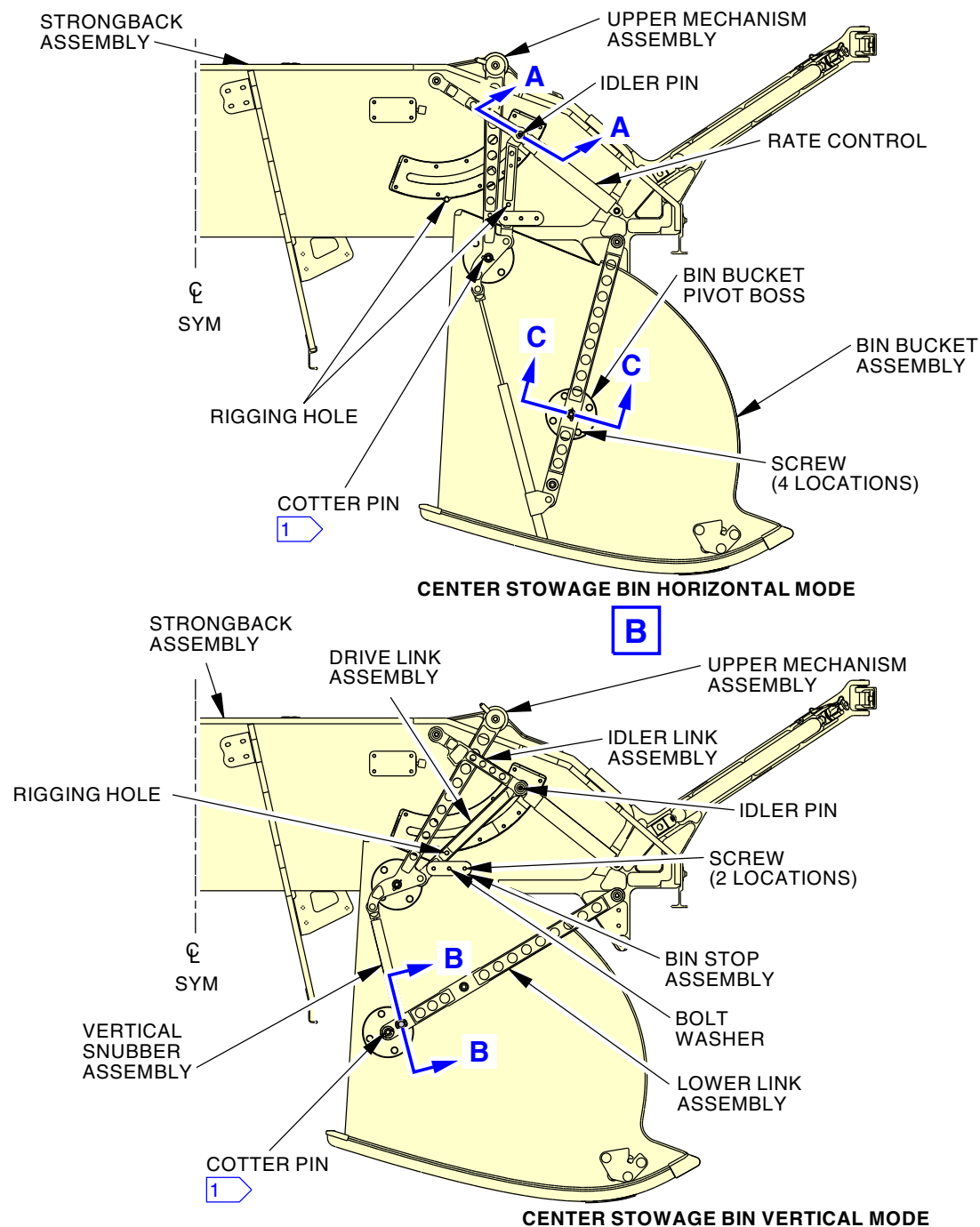
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25-28-02

D633W101-ARO

Page 204
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



1858466 S0000333331_V2

Center Stowage Bin Translation Mode
Figure 201/25-28-02-990-808 (Sheet 2 of 3)

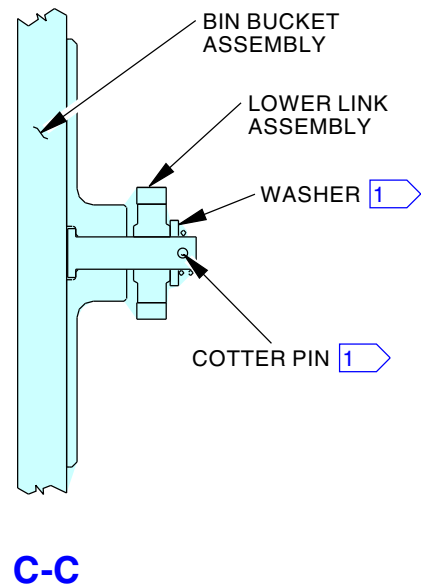
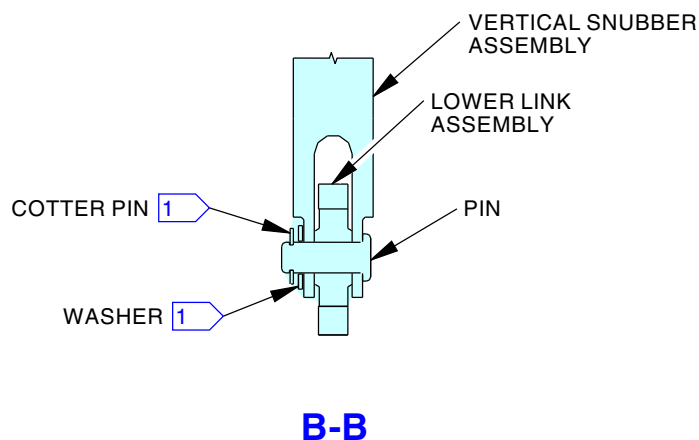
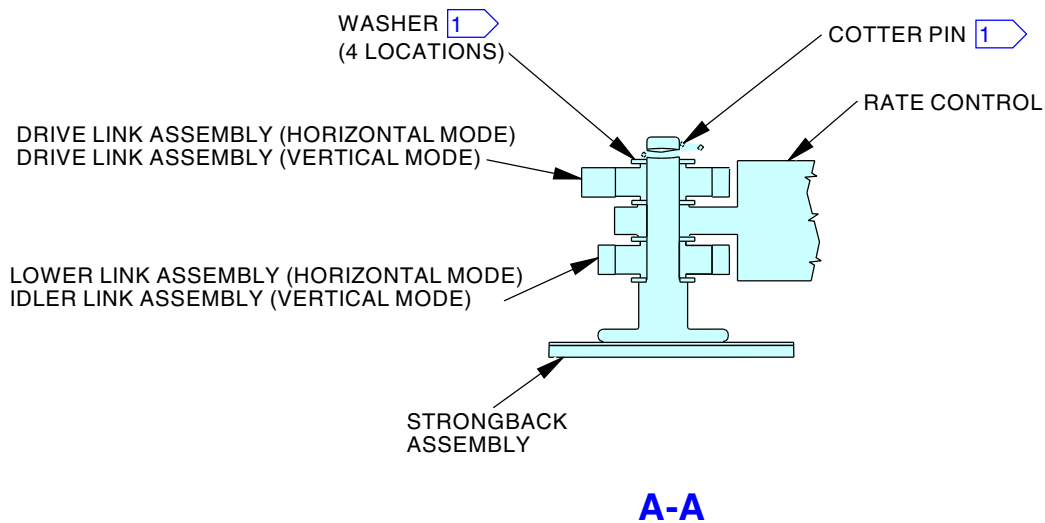
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25-28-02

D633W101-ARO

Page 205
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



1858467 S0000333703_V2

**Center Stowage Bin Translation Mode
Figure 201/25-28-02-990-808 (Sheet 3 of 3)**

EFFECTIVITY
ARO ALL

25-28-02

D633W101-ARO

Page 206
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

CENTER STOWAGE BIN - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) A removal of the center stowage bin.
- (2) An installation of the center stowage bin.
- (3) A removal of the center stowage bin module.
- (4) An installation of the center stowage bin module.
- (5) A removal of the center stowage bin module.
- (6) An installation of the center stowage bin module.

B. The center stowage bin module consists of two stowage bins, mechanisms, troughs, end frames, and passenger service unit (PSU) rails. It is necessary to remove and install the center stowage bin module to change the configuration in the flexibility zones.

TASK 25-28-02-000-801

2. Center Stowage Bin Removal

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-2537	Pin - Rig (J20003-6 Assembly Included in Kit J20003-34) Part #: J20003-34 Supplier: 81205

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-28-02-010-001

- (1) For improved access to the stowage bins you can remove the passenger seats below the stowage bins.
 - (a) If necessary, do this task: Passenger Seat Removal, Task 25-25-01-000-801 or Passenger Seat with Pallet Removal, Task 25-25-01-00-802.

D. Center Stowage Bin Removal

SUBTASK 25-28-02-010-002

- (1) Open the stowage bin [4].

SUBTASK 25-28-02-020-001

- (2) Do the steps that follow to the each end of the stowage bin [4]:
 - (a) Align the rigging holes [2] on the drive link assembly [1] and the end frame [6].
 - (b) Put the rig pin (Included in Kit J20003-34), SPL-2537 through the holes to lock the stowage bin [4] in the open position.
 - (c) Remove the stud nut [7] and washer [8] or spacer [9] that attach the lower link [3] to the stowage bin [4].

EFFECTIVITY
ARO ALL

25-28-02

D633W101-ARO

Page 401
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (d) Turn the stowage bin [4] if it is necessary to get access to the upper pivot attachment.
- (e) Remove the stud nut [7] and washer [8] that attach the drive link assembly [1] to the stowage bin [4].

SUBTASK 25-28-02-020-002



DO NOT PUT THE STOWAGE BIN IN DIRECT SUNLIGHT OR STRONG ARTIFICIAL LIGHT. DIRECT SUNLIGHT OR STRONG ARTIFICIAL LIGHT WILL CHANGE THE COLOR OF SOME OF THE PARTS ON THE STOWAGE BIN.

- (3) Remove the stowage bin [4].

————— END OF TASK —————

TASK 25-28-02-400-801

3. Center Stowage Bin Installation

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-2537	Pin - Rig (J20003-6 Assembly Included in Kit J20003-34) Part #: J20003-34 Supplier: 81205

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Center Stowage Bin Installation

SUBTASK 25-28-02-420-001

- (1) Do the steps that follow to the two ends of the stowage bin [4]:
 - (a) Make sure the rig pin (Included in Kit J20003-34), SPL-2537 is in the holes through the drive link assembly [1] and end frame [6].
 - (b) Hold the stowage bin [4] up while you attach the drive link assembly [1] to the stowage bin [4] with the stud nut [7] and washer [8].
 - (c) Install the stud nut [7] and washer [8] or spacer [9] that attach the lower link [3] to the stowage bin [4].
 - 1) Tighten the stud nut [7] to 30 ±3 in-lb (3 ±1 N·m).

NOTE: Threadlocking compound such as Loctite 222 or Loctite 242 can be used on stud nut [7] threads, if your airline policy permits its use on the stowage bin.

- (d) Carefully remove the rig pin (Included in Kit J20003-34), SPL-2537 while you hold the stowage bin [4] in the open position.

SUBTASK 25-28-02-410-001

- (2) Close all of the stowage bins that are open.

D. Center Stowage Bin Installation Test

SUBTASK 25-28-02-280-001

- (1) Do these steps to make sure the stowage bin [4] is correctly installed:

EFFECTIVITY
ARO ALL

25-28-02

D633W101-ARO

Page 402
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (a) Open and close the stowage bin [4].
- (b) While the stowage bin [4] is closed, pull down at the ends to make sure the latch is fully engaged.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-28-02-410-002

- (1) If you removed the seats for access, then, do this task: Passenger Seat Installation, Task 25-25-01-400-801 or Passenger Seat with Pallet Installation, Task 25-25-01-400-802.

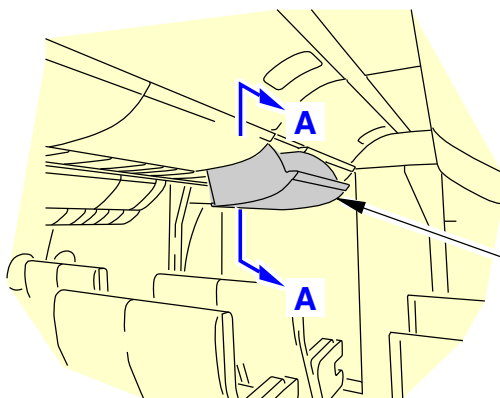
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D633W101-ARO

25-28-02

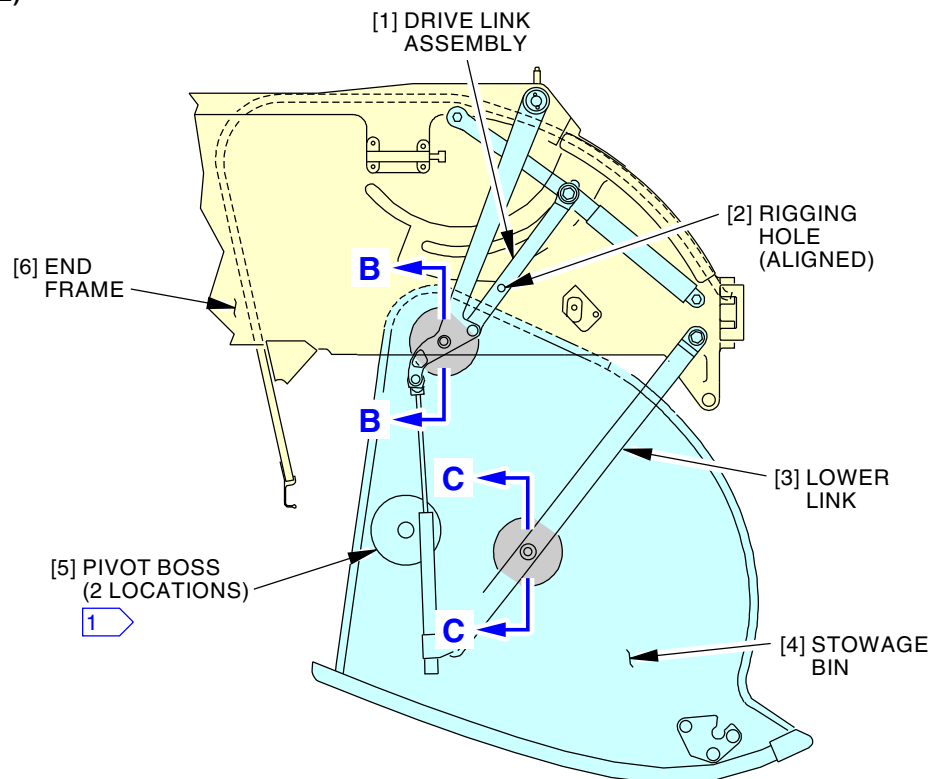
Page 403
Sep 05/2017



CENTER STOWAGE
BIN (OPEN)



**PASSENGER COMPARTMENT
(EXAMPLE)**



**CENTER STOWAGE BIN
(HORIZONTAL TRANSLATION
OR STANDARD MODE)**

A-A

1 IF THE STOWAGE BIN HAS TWO PIVOT
BOSSES FOR THE LOWER LINK, THEN YOU
CAN CHANGE THE MODE OF OPERATION.

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**Center Stowage Bin Installation
Figure 401/25-28-02-990-801 (Sheet 1 of 2)**

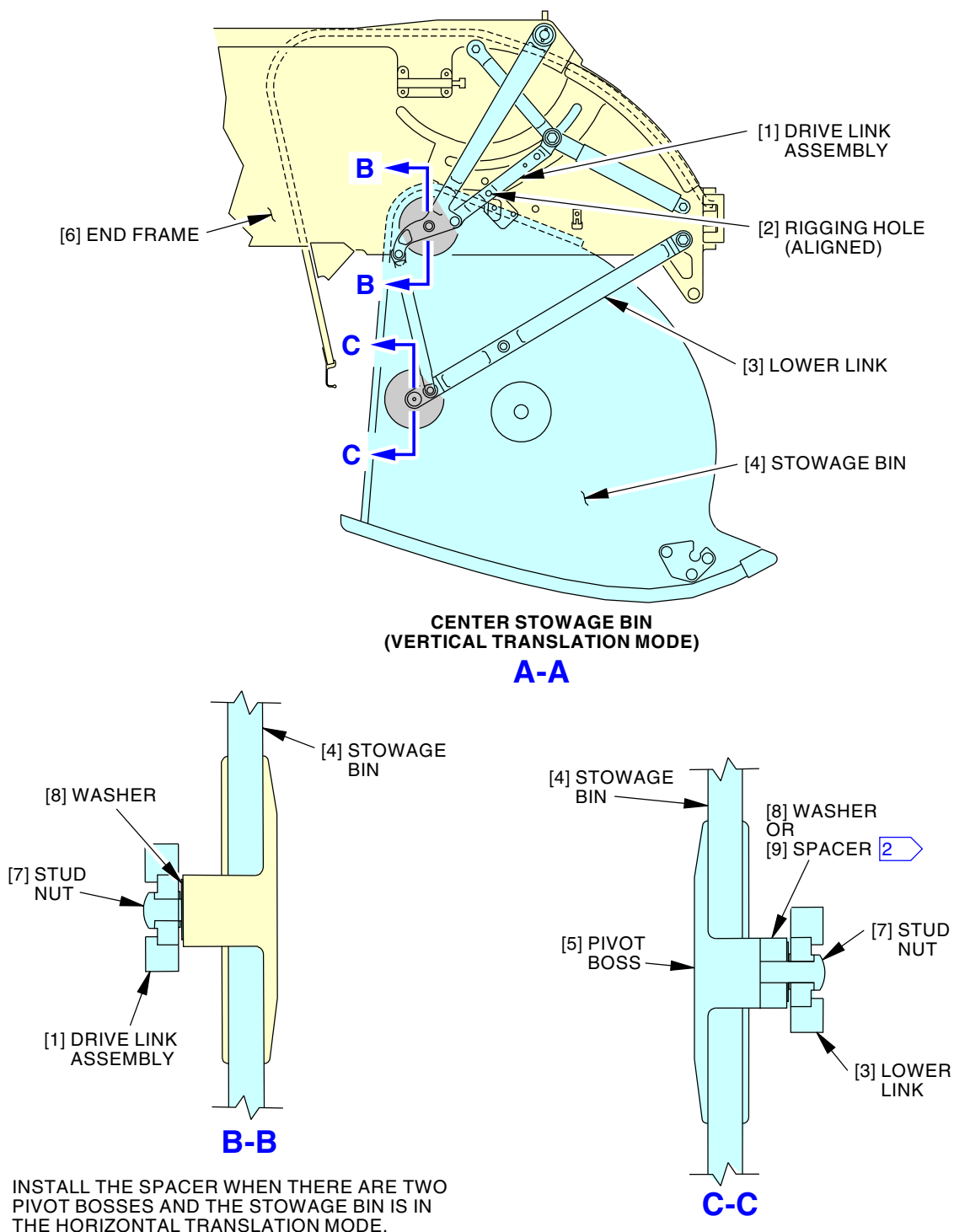
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D633W101-ARO

25-28-02

Page 404
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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Center Stowage Bin Installation
Figure 401/25-28-02-990-801 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

25-28-02

D633W101-ARO

Page 405
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-28-02-000-802

4. Center Stowage Bin Module Removal

(Figure 402)

A. General

- (1) The stowage bin module includes 2 stowage bins. One to the left and one to the right of the center of the airplane.

B. References

Reference	Title
24-22-00-860-806	Remove Electrical Power (P/B 201)
25-21-06-000-801	Main Ceiling Panel - Removal (P/B 401)
25-23-01-010-801	Passenger Service Unit (PSU) Opening (P/B 201)

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Prepare for the Removal

SUBTASK 25-28-02-010-010

- (1) For improved access to the stowage bins you can remove the passenger seats below the stowage bins.
 - (a) If necessary, do this task: Passenger Seat Removal, Task 25-25-01-000-801 or Passenger Seat with Pallet Removal, Task 25-25-01-00-802.

SUBTASK 25-28-02-860-001

- (2) Do this task: Remove Electrical Power, TASK 24-22-00-860-806.

SUBTASK 25-28-02-010-004

- (3) If the stowage bin you will remove is adjacent to an expansion joint, then remove the seal from the space between the stowage bin modules.

NOTE: The seals are attached with loop and hook fasteners (Velcro).

SUBTASK 25-28-02-010-006

- (4) Open the ceiling panels adjacent to the applicable stowage bin module [22]. To open the ceiling panels, do this task: Main Ceiling Panel - Removal, TASK 25-21-06-000-801.

SUBTASK 25-28-02-010-011

- (5) If the stowage bin you will remove is adjacent to an end cap, then remove the gap cover from the space between the stowage bin module [22] and the end cap.

NOTE: The gap cover is attached with screws that you access from above the ceiling.

SUBTASK 25-28-02-010-007

- (6) Open the passenger service units adjacent to the applicable stowage bin module [22]. To open the passenger service units, do this task: Passenger Service Unit (PSU) Opening, TASK 25-23-01-010-801

E. Center Stowage Bin Module Removal

SUBTASK 25-28-02-020-003

- (1) Do these steps to disconnect the different system interfaces from the stowage bin module [22]:
 - (a) Do these steps to disconnect the electrical connectors:
 - 1) Remove the hold-down clamp at the top of the stowage bin module [22].

EFFECTIVITY
ARO ALL

25-28-02

D633W101-ARO

Page 406
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 2) Remove the hold-down clamp on the front or aft end of the stowage bin module [22] if it is necessary.
- 3) Disconnect electrical connectors from the PSU.
- 4) Disconnect the electrical connector from the overhead electronics unit (OEU).
- 5) Pull the wire bundles through the top of the trough [24].

SUBTASK 25-28-02-020-004



MAKE SURE THERE IS A SUFFICIENT NUMBER OF PERSONS TO HANDLE THE STOWAGE BIN MODULE. THE STOWAGE BIN MODULE IS LARGE AND HEAVY. INCORRECT HANDLING CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

- (2) Remove the bolts [26] and spacers [27] that attach the stowage bin module [22] to the support structure [21].

NOTE: The bolts in different areas of the airplane are different lengths. If you move the stowage bin module to a different area of the airplane, do not move the bolts with it. Keep the bolts in the same location in the airplane.

NOTE: The bolts on the right side of the stowage bin module are larger (in diameter) than the bolts on the left side.

SUBTASK 25-28-02-020-005

- (3) Carefully lower and remove the stowage bin module [22].

————— END OF TASK —————

TASK 25-28-02-400-802

5. Center Stowage Bin Module Installation

(Figure 402)

A. References

Reference	Title
23-33-02-700-801	Overhead Electronics Unit Installation Test (P/B 401)
24-22-00-860-805	Supply Electrical Power (P/B 201)
25-21-06-400-801	Main Ceiling Panel - Installation (P/B 401)
25-23-01-410-801	Passenger Service Unit (PSU) Closing (P/B 201)
35-21-00-710-801	Oxygen Box Door Latch/Actuator Operational Test (P/B 501)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

EFFECTIVITY
ARO ALL

25-28-02

D633W101-ARO

Page 407
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

C. Center Stowage Bin Module Installation

SUBTASK 25-28-02-820-001



MAKE SURE THERE IS A SUFFICIENT NUMBER OF PERSONS TO HANDLE THE STOWAGE BIN MODULE. THE STOWAGE BIN MODULE IS LARGE AND HEAVY. INCORRECT HANDLING CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

- (1) Hold the stowage bin module [22] up.

NOTE: Look for the forward arrow on the top of the stowage bin module. You must install the stowage bin module in the correct direction.

NOTE: Fold the hinges [28] in to give more clearance to install the stowage bin module.

SUBTASK 25-28-02-420-002

- (2) Put the wire bundles through the top of the trough [24].

SUBTASK 25-28-02-420-003

- (3) Install the bolts [26] and spacers [27] that attach the stowage bin module [22] to the support structure [21].

NOTE: The larger diameter bolts go on the right side of the stowage bin module.

SUBTASK 25-28-02-420-006

- (4) Do these steps to attach the different system interfaces to the stowage bin module [22]:
 - (a) Do these steps to connect the electrical connectors:
 - 1) Connect electrical connectors to the PSU.
 - 2) Connect the electrical connector to the OEU.
 - 3) Attach the hold-down clamp to the top of the stowage bin module [22].
 - 4) Attach the hold-down clamp to the front or aft end of the stowage bin module [22] if it is necessary.

SUBTASK 25-28-02-410-003

- (5) Do this task: Passenger Service Unit (PSU) Closing, TASK 25-23-01-410-801.

SUBTASK 25-28-02-420-004

- (6) If the stowage bin is adjacent to an expansion joint, then install the seal over the expansion joint.

SUBTASK 25-28-02-420-007

- (7) If the stowage bin is adjacent to an end cap, then install the gap cover with the 6 screws. Adjust the gap cover until it touches the stowage bin module [22].

SUBTASK 25-28-02-410-008

- (8) Close the ceiling panels. To close them, do this task: Main Ceiling Panel - Installation, TASK 25-21-06-400-801.

D. Center Stowage Bin Module Installation Test

SUBTASK 25-28-02-860-002

- (1) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-28-02-760-001

- (2) Do a check to make sure the lights come on.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-28-02

Page 408
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-28-02-710-001

- (3) Do the applicable installation tests that follow for the different systems that interface with the stowage bin module:
 - (a) Overhead Electronics Unit Installation Test (TASK 23-33-02-700-801)
 - (b) Oxygen Box Door Latch Actuator - Operational Test (TASK 35-21-00-710-801)

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-28-02-410-005

- (1) If you removed the seats for access, then, do this task: Passenger Seat Installation, Task 25-25-01-400-801 or Passenger Seat with Pallet Installation, Task 25-25-01-400-802.

————— **END OF TASK** —————

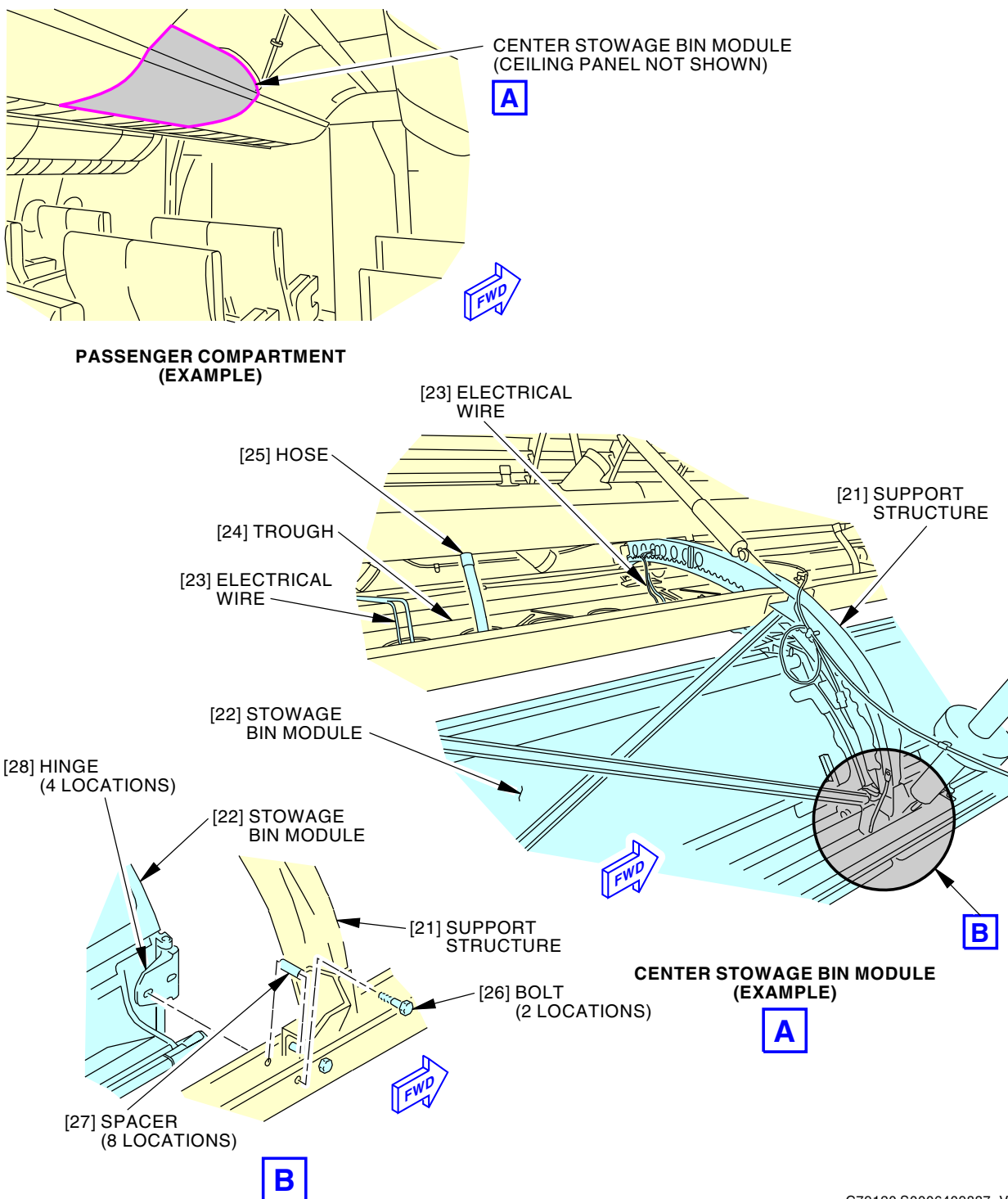
EFFECTIVITY
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25-28-02

D633W101-ARO

Page 409
Jul 25/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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Center Stowage Bin Module Installation
Figure 402/25-28-02-990-802

EFFECTIVITY
ARO ALL

25-28-02

D633W101-ARO

Page 410
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-28-02-000-805

6. Center Stowage Bin Module Removal

(Figure 403)

A. General

- (1) The stowage bin module includes 2 stowage bins. One to the left and one to the right of the center of the airplane.

B. References

Reference	Title
25-21-06-000-801	Main Ceiling Panel - Removal (P/B 401)
25-23-01-010-801	Passenger Service Unit (PSU) Opening (P/B 201)
25-25-01-000-801	Passenger Seat - Removal (P/B 401)

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Prepare for the Removal

SUBTASK 25-28-02-865-001

- (1) Open these circuit breakers and install safety tags:

Ground Service/Handling Power Panel, P320

Row	Col	Number	Name
G	2	C33416	CABIN LTS FWD R
G	3	C33422	CABIN LTS AFT R
H	4	C33418	CABIN LTS MID FWD R
H	9	C33420	CABIN LTS MED AFT R
L	2	C33417	CABIN LTS FWD L
L	6	C33419	CABIN LTS MID FWD L
L	7	C33423	CABIN LTS AFT L
L	10	C33421	CABIN LTS MID AFT L

Standby Power Management Panel, P310

Row	Col	Number	Name
A	3	C35403	L PAX OXY
A	4	C35405	C PAX OXY
A	5	C35404	R PAX OXY
E	9	C23652	SDM COL 5
F	9	C23634	SDM COL 1
F	10	C23635	SDM COL 2
F	11	C23636	SDM COL 3
H	3	C35606	CHAN A OXY DEPLOY
H	4	C35607	CHAN B OXY DEPLOY

SUBTASK 25-28-02-840-001

- (2) For better access to the stowage bins you can remove the passenger seats below stowage bins. Passenger Seat - Removal, TASK 25-25-01-000-801.

EFFECTIVITY
ARO ALL

25-28-02

D633W101-ARO

Page 411
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-28-02-020-008

- (3) If the stowage bin you will remove is adjacent to an expansion joint, then remove the seal from the space between the stowage bin modules.

NOTE: The seals are attached with loop and hook fasteners (Velcro).

SUBTASK 25-28-02-020-009

- (4) Open the ceiling panels adjacent to the applicable stowage bin module [22]. (Main Ceiling Panel - Removal, TASK 25-21-06-000-801).

SUBTASK 25-28-02-020-010

- (5) For stowage bin adjacent to an end cap, remove the gap cover from the space between the stowage bin module [22] and the end cap.

NOTE: The gap cover is attached with screws that you access from above the ceiling.

SUBTASK 25-28-02-020-011

- (6) Open the passenger service units adjacent to the applicable stowage bin module [22]. Do this task: Passenger Service Unit (PSU) Opening, TASK 25-23-01-010-801

E. Center Stowage Bin Module Removal

SUBTASK 25-28-02-030-001

- (1) Disconnect the electrical connectors [27] from the forward end of the stowage bin module.

SUBTASK 25-28-02-030-002

- (2) Disconnect the electrical connectors [27] from the aft end of the stowage bin module.

SUBTASK 25-28-02-490-001

- (3) Hold the stowage bin module [22] in its position.

SUBTASK 25-28-02-000-003

- (4) Remove the bolts [24] and the spacers [23] that attach the stowage bin module [22] to the support lattice [21].

NOTE: The bolts [24] and the spacers [23] are installed in four positions.

SUBTASK 25-28-02-000-004

- (5) Lower the stowage bin module [22].

SUBTASK 25-28-02-000-005

- (6) Remove the stowage bin module [22] from the airplane if necessary.

————— **END OF TASK** —————

TASK 25-28-02-400-805

7. Center Stowage Bin Module Installation

(Figure 403)

A. References

Reference	Title
23-33-02-700-801	Overhead Electronics Unit Installation Test (P/B 401)
25-21-06-400-801	Main Ceiling Panel - Installation (P/B 401)
25-23-01-410-801	Passenger Service Unit (PSU) Closing (P/B 201)
33-20-00-710-801	Passenger Compartment Lights - Operational Test Using the Cabin/Utility Switch (P/B 501)
35-21-00-710-801	Oxygen Box Door Latch/Actuator Operational Test (P/B 501)

EFFECTIVITY
ARO ALL

25-28-02

D633W101-ARO

Page 412
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Center Stowage Bin Module Installation

SUBTASK 25-28-02-490-002

- (1) Hold the stowage bin module [22] in the correct position.

NOTE: Look for the forward arrow on the top of the stowage bin module. You must install the stowage bin module in the correct direction.

NOTE: Fold the hinges [28] in to give more clearance to install the stowage bin module.

SUBTASK 25-28-02-400-004

- (2) Install the bolts [24] and spacers [23] that attach the stowage bin module [22] to the support lattice [21].

SUBTASK 25-28-02-430-001

- (3) Connect the electrical connectors [27] at the forward end of the center stowage bin module [22].

SUBTASK 25-28-02-430-002

- (4) Connect the electrical connectors [27] at the aft end of the center stowage bin module [22].

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-28-02-400-005

- (1) Close the PSUs. Passenger Service Unit (PSU) Closing, TASK 25-23-01-410-801.

SUBTASK 25-28-02-400-006

- (2) For the stowage bin adjacent to an expansion joint, install the seal over the expansion joint.

SUBTASK 25-28-02-400-007

- (3) For the stowage bin is adjacent to an end cap, then install the gap cover with the 6 screws. Adjust the gap cover until it touches the stowage bin module [22].

SUBTASK 25-28-02-400-008

- (4) Close the ceiling panels. Main Ceiling Panel - Installation, TASK 25-21-06-400-801.

SUBTASK 25-28-02-865-002

- (5) Remove the safety tags and close these circuit breakers:

Ground Service/Handling Power Panel, P320

Row	Col	Number	Name
G	2	C33416	CABIN LTS FWD R
G	3	C33422	CABIN LTS AFT R
H	4	C33418	CABIN LTS MID FWD R
H	9	C33420	CABIN LTS MED AFT R
L	2	C33417	CABIN LTS FWD L
L	6	C33419	CABIN LTS MID FWD L
L	7	C33423	CABIN LTS AFT L
L	10	C33421	CABIN LTS MID AFT L

Standby Power Management Panel, P310

Row	Col	Number	Name
A	3	C35403	L PAX OXY
A	4	C35405	C PAX OXY

EFFECTIVITY
ARO ALL

25-28-02

D633W101-ARO

Page 413
Sep 05/2017



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

(Continued)

Standby Power Management Panel, P310

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	5	C35404	R PAX OXY
E	9	C23652	SDM COL 5
F	9	C23634	SDM COL 1
F	10	C23635	SDM COL 2
F	11	C23636	SDM COL 3
H	3	C35606	CHAN A OXY DEPLOY
H	4	C35607	CHAN B OXY DEPLOY

E. Center Stowage Bin Module Installation Test

SUBTASK 25-28-02-710-004

- (1) Do a test of the passenger lights. Passenger Compartment Lights - Operational Test Using the Cabin/Utility Switch, TASK 33-20-00-710-801

SUBTASK 25-28-02-710-005

- (2) Do a test of the overhead electronics unit. (Overhead Electronics Unit Installation Test, TASK 23-33-02-700-801)

SUBTASK 25-28-02-710-006

- (3) Do a test of the oxygen box door latch actuator. (Oxygen Box Door Latch/Actuator Operational Test, TASK 35-21-00-710-801)

———— **END OF TASK** ————

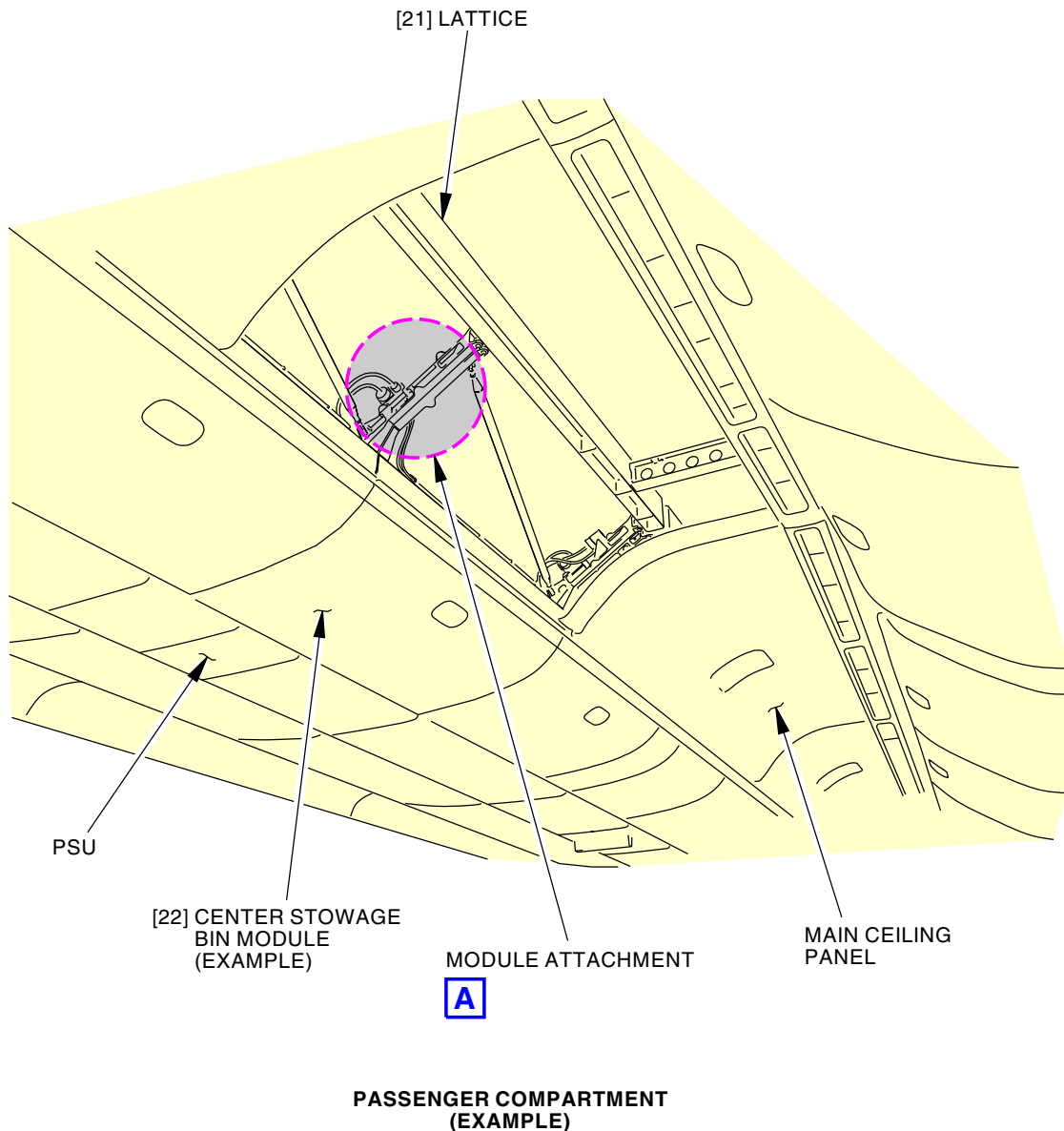
EFFECTIVITY
ARO ALL

25-28-02

D633W101-ARO

Page 414
Sep 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Center Stowage Bin Module Installation
Figure 403/25-28-02-990-806 (Sheet 1 of 2)

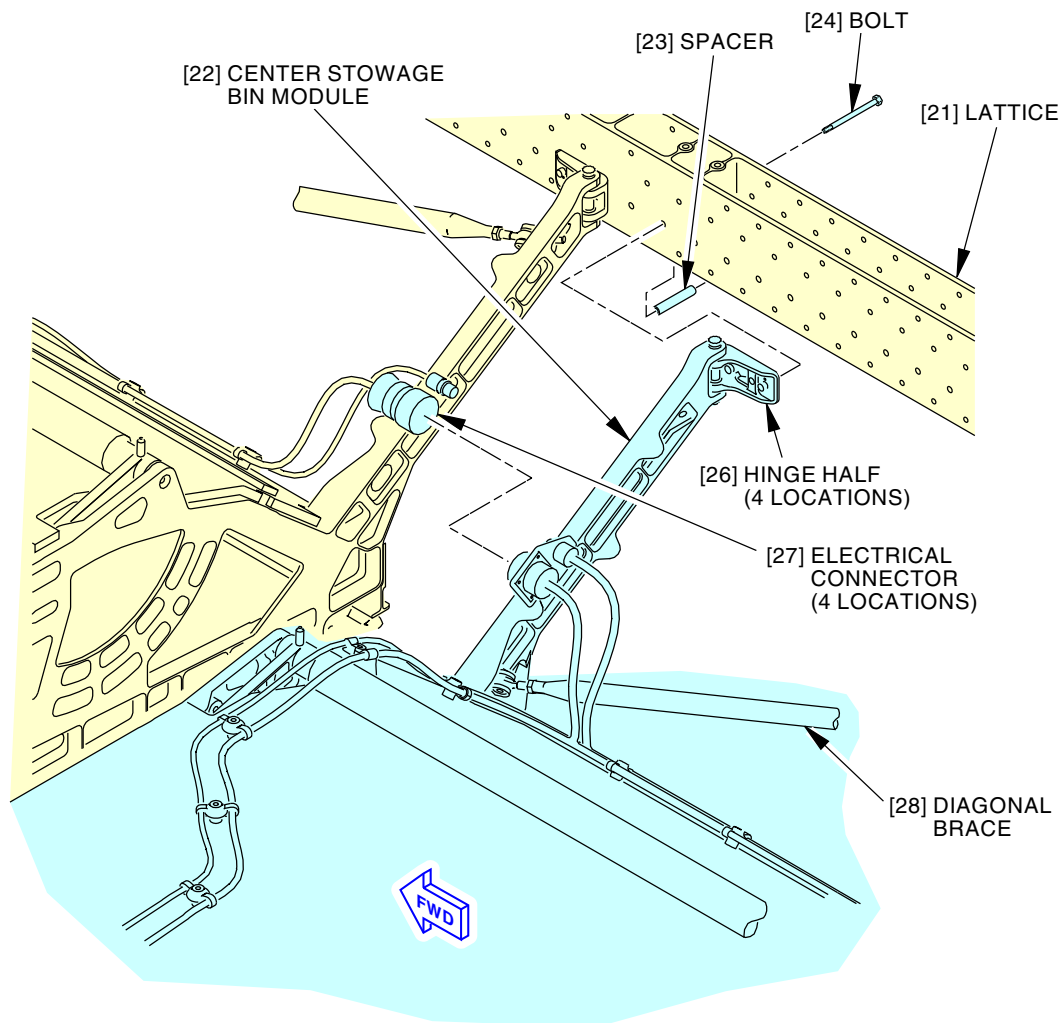
EFFECTIVITY
ARO ALL

25-28-02

D633W101-ARO

Page 415
 Sep 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



**MODULE ATTACHMENT
(EXAMPLE)**

A

N78340 S0000122060_V2

Center Stowage Bin Module Installation
Figure 403/25-28-02-990-806 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

25-28-02

D633W101-ARO

Page 416
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

STOWAGE BIN SNUBBER - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) A removal of the snubber for the outboard and center stowage bins.
- (2) An installation of the snubber for the outboard and center stowage bins.

TASK 25-28-03-000-801

2. Stowage Bin Snubber Removal

(Figure 401, Figure 402)

A. References

Reference	Title
25-23-01-010-801	Passenger Service Unit (PSU) Opening (P/B 201)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-28-03-010-001

- (1) Open the stowage bin.

SUBTASK 25-28-03-010-002

- (2) Open the adjacent stowage bin if it is necessary to get better access.

D. Outboard Stowage Bin Snubber Removal

(Figure 401)

SUBTASK 25-28-03-010-003

- (1) AT AN EXPANSION JOINT; do these steps to get access to the snubber [9]:
 - (a) Do this task near the expansion joint: Passenger Service Unit (PSU) Opening (TASK 25-23-01-010-801).
 - (b) Disconnect the hook-and-loop tape to remove the seal for the gap cover.
 - (c) Remove the bolts [5] to disconnect the slip joint panel [4] from the strongback assembly [1].
 - (d) Remove the slip joint panel [4].
NOTE: There are spacers between the slip joint panel and the strongback assembly.
 - (e) Make sure you do not lose the spacers when you remove the slip joint panel [4].

SUBTASK 25-28-03-020-003

- (2) Do these steps to remove the snubber [9] from each end of the stowage bin:
 - (a) Remove the cotter pin [3] and washers [7], [8] that attach the lower end of the snubber [9] to the stowage bin.
 - (b) Remove the cotter pin [3], washers [2], [7], and pin [10] to disconnect the upper end of the snubber [9] from the strongback assembly [1].
 - (c) Remove the snubber [9].

EFFECTIVITY
ARO ALL

25-28-03

D633W101-ARO

Page 401
Jan 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL

E. Center Stowage Bin Snubber Removal

(Figure 402)

NOTE: There are three different snubbers for the center stowage bins. A large snubber or a medium snubber is installed if the center stowage bin is in the standard or horizontal translation mode. A small snubber is installed if the center stowage bin is in the vertical translation mode.

SUBTASK 25-28-03-020-004



HAVE ONE PERSON HOLD AND CONTROL THE STOWAGE BIN AT ALL TIMES DURING THIS PROCEDURE. IF ONE PERSON DOES NOT HOLD AND CONTROL THE STOWAGE BIN, IT CAN SWING AND CAUSE INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.

- (1) Disconnect the two ends of the lower link [33] from the stowage bin and end frame, if installed.
 - (a) Remove the nut [40] and spacer [39] to disconnect the lower end of the lower link [33] from the stowage bin.

NOTE: The spacer between the lower link and the stowage bin can fall when you pull the stud nut away from the lower link.



HOLD THE LOWER LINK WHEN YOU DISCONNECT THE TOP END OF THE LOWER LINK FROM THE END FRAME. IF ONE PERSON DOES NOT HOLD THE LOWER LINK, THE LOWER LINK WILL FALL AND CAUSE INJURY TO PERSONS.

- (b) Remove the bolt [42] to disconnect the top end of the lower link [33] from the end frame.

SUBTASK 25-28-03-010-004

- (2) Do these steps to hold the stowage bin open:
 - (a) Pull the stowage bin down as far as possible.
 - (b) Remove the mechanism down stop [31] from the end frame.
 - (c) Pull and hold the stowage bin down again as far as possible.
 - (d) Align the rigging hole in the upper mechanism arm [37] with the rigging hole [38] in the end frame.
 - (e) Put a pin (0.25 inch diameter by 2.5 inches long) through the rigging hole [38] to hold the stowage bin down.

SUBTASK 25-28-03-010-005

- (3) AT AN EXPANSION JOINT; do this step if it is necessary to get better access to the top end of the snubber [45]:
 - (a) Remove the screw [47] to disconnect the inboard end of the slip joint panel [41] from the trough panel.

SUBTASK 25-28-03-020-001

- (4) FOR THE LARGE SNUBBER [35] ; do these steps to remove the snubber [35] from each end of the center stowage bin:
 - (a) Remove the spring retainer clip [32], washer [34], and pin [10] to disconnect the upper end of the snubber [35] from the upper mechanism arm [37].
 - (b) Remove the snubber [35] and lower link [33] together.
 - (c) Remove the spring retainer clip [32], washer [34], and pin [10] to disconnect the lower end of the snubber [35] from the lower link [33].

EFFECTIVITY
ARO ALL

25-28-03

D633W101-ARO

Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-28-03-020-002

- (5) FOR THE SMALL SNUBBER [45] ; do these steps to remove the snubber [45] from each end of the center stowage bin:
- (a) Remove the spring retainer clip [32], washer [34], and pin [10] to disconnect the upper end of the snubber [45] from the upper mechanism arm [37].
 - (b) Remove the snubber [45] and lower link [33] together.
 - (c) Remove the spring retainer clip [32], washer [34], and pin [10] to disconnect the lower end of the snubber [45] from the lower link [33].

SUBTASK 25-28-03-020-005

- (6) FOR THE MEDIUM SNUBBER [48] ; do these steps to remove the snubber [48], if installed:
- (a) Remove the locking cotter pin [49], washers [34], and pin [10] to disconnect the upper end of the snubber [48] from upper mechanism bracket [50].
 - (b) Remove the locking cotter pin [49], washers [34] to disconnect the lower end of the snubber [48] from fixed pin [51].
 - (c) Remove the snubber [48] from the bin bucket.

————— END OF TASK —————

TASK 25-28-03-400-801

3. Stowage Bin Snubber Installation

(Figure 401, Figure 402)

A. References

Reference	Title
25-23-01-410-801	Passenger Service Unit (PSU) Closing (P/B 201)

B. Consumable Materials

Reference	Description	Specification
A00270	Compound - Threadlocking, Low-strength - Loctite 222	
A00648	Compound - Retaining - Loctite 242	ASTM D5363 Grp 3 Cl 2 Gd 1 (SUPERSEDES MIL-S-46163)

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Outboard Stowage Bin Snubber Installation

(Figure 401)

SUBTASK 25-28-03-420-001

- (1) Do these steps to install the snubber [9] at each end of the outboard stowage bin:
- (a) Align the upper end of the snubber [9] in the correct position for the installation.
NOTE: The direction to install the snubber is important. The adjustable end of the snubber is down.
 - (b) Install the washers [2], [7], pin [10], and cotter pin [3] that attach the upper end of the snubber [9] to the strongback assembly [1].
 - 1) To make the installation of the snubber [9] and washer [7] easier, use very small pieces of double back tape to attach the washer [7] to the snubber [9].

EFFECTIVITY
ARO ALL

25-28-03

D633W101-ARO

Page 403
Sep 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (c) Install the washers [7], [8] and cotter pin [3] that attach the lower end of the snubber [9] to the stowage bin.

SUBTASK 25-28-03-410-002

- (2) Do these steps to install the slip joint panel [4] at an expansion joint:
 - (a) Put the spacers and slip joint panel [4] in the correct position for the installation.
NOTE: The spacers are between the slip joint panel and the strongback assembly.
 - (b) Install the bolts [5] to attach the slip joint panel [4] to the strongback assembly [1].
 - (c) Install the gap cover seal with the hook-and-loop tape.
 - (d) Do this task near the expansion joint: PSU Closing TASK 25-23-01-410-801.

E. Center Stowage Bin Snubber Installation

(Figure 402)

NOTE: There are three different snubbers for the center stowage bins. A large snubber or medium snubber is installed if the center stowage bin is in the standard or horizontal translation mode. A small snubber is installed if the center stowage bin is in the vertical translation mode.

SUBTASK 25-28-03-420-005



HOLD THE STOWAGE BIN BUCKET TIGHTLY. IF IT TURNS, IT WILL DISENGAGE FROM THE PIVOT FITTING. INJURIES TO PERSONNEL CAN OCCUR.

- (1) FOR THE MEDIUM SNUBBER [48]; do these steps below to install the snubber [35]:
 - (a) Install the locking cotter pin [49], washers [34] to attach the lower end of the snubber [48] to fixed pin [51].
 - (b) Install the pin [10], washers [34], and locking cotter pin [49] that attach the upper end of the snubber [48] to the upper mechanism bracket [50].

SUBTASK 25-28-03-420-002



HAVE ONE PERSON HOLD AND CONTROL THE STOWAGE BIN AT ALL TIMES DURING THIS PROCEDURE. IF ONE PERSON DOES NOT HOLD AND CONTROL THE STOWAGE BIN, IT CAN SWING AND CAUSE INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.

- (2) FOR THE LARGE SNUBBER [35]; do these steps to install the snubber [35] at each end of the center stowage bin:
 - (a) Install the pin [10], washer [34], and spring retainer clip [32] that attach the lower end of the snubber to the lower link [33].
 - (b) Install the pin [10], washer [34], and spring retainer clip [32] that attach the upper end of the snubber [35] to the upper mechanism arm [37].
 - (c) AT AN EXPANSION JOINT; install the screw [47] to attach the inboard end of the slip joint panel [41] to the trough panel if it is necessary.
 - (d) Remove the pin from the rigging holes [38] in the upper mechanism arm and end frame.
 - (e) Install the mechanism down stop [31] in the inboard location on the end frame.



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-28-03-420-003



WARNING

HAVE ONE PERSON HOLD AND CONTROL THE STOWAGE BIN AT ALL TIMES DURING THIS PROCEDURE. IF ONE PERSON DOES NOT HOLD AND CONTROL THE STOWAGE BIN, IT CAN SWING AND CAUSE INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.

- (3) FOR THE SMALL SNUBBER [45]; do these steps to install the snubber [45] on each end of the center stowage bin:
 - (a) Install the pin [10], washer [34], and spring retainer clip [32] that attach the lower end of the snubber [45] to the lower link [33].
 - (b) Install the pin [10], washer [34], and spring retainer clip [32] that attach the upper end of the snubber [45] to the upper mechanism arm [37].
 - (c) AT AN EXPANSION JOINT; install the screw [47] to attach the inboard end of the slip joint panel [41] to the trough panel if it is necessary.
 - (d) Remove the pin from the rigging holes [38] in the upper mechanism arm and end frame.
 - (e) Install the mechanism down stop [31] in the outboard location on the end frame.

SUBTASK 25-28-03-420-004

- (4) Connect the lower [33] to the stowage bin and end frame:
 - (a) Install the bolt [42] to attach the top end of the lower link [33] to the end frame.
 - (b) Install the spacer [39] and stud nut [40] to attach the lower link [33] to the stowage bin.

NOTE: Threadlocking compound such as Loctite 222 compound, A00270 or Loctite 242 compound, A00648 can be used on stud nut [40] threads, if your airline policy permits its use on the stowage bin.
- 1) Tighten the stud nut [40] to 30 ±3 in-lb (3 ±1 N·m).

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-28-03-410-001

- (1) Close all of the stowage bins.

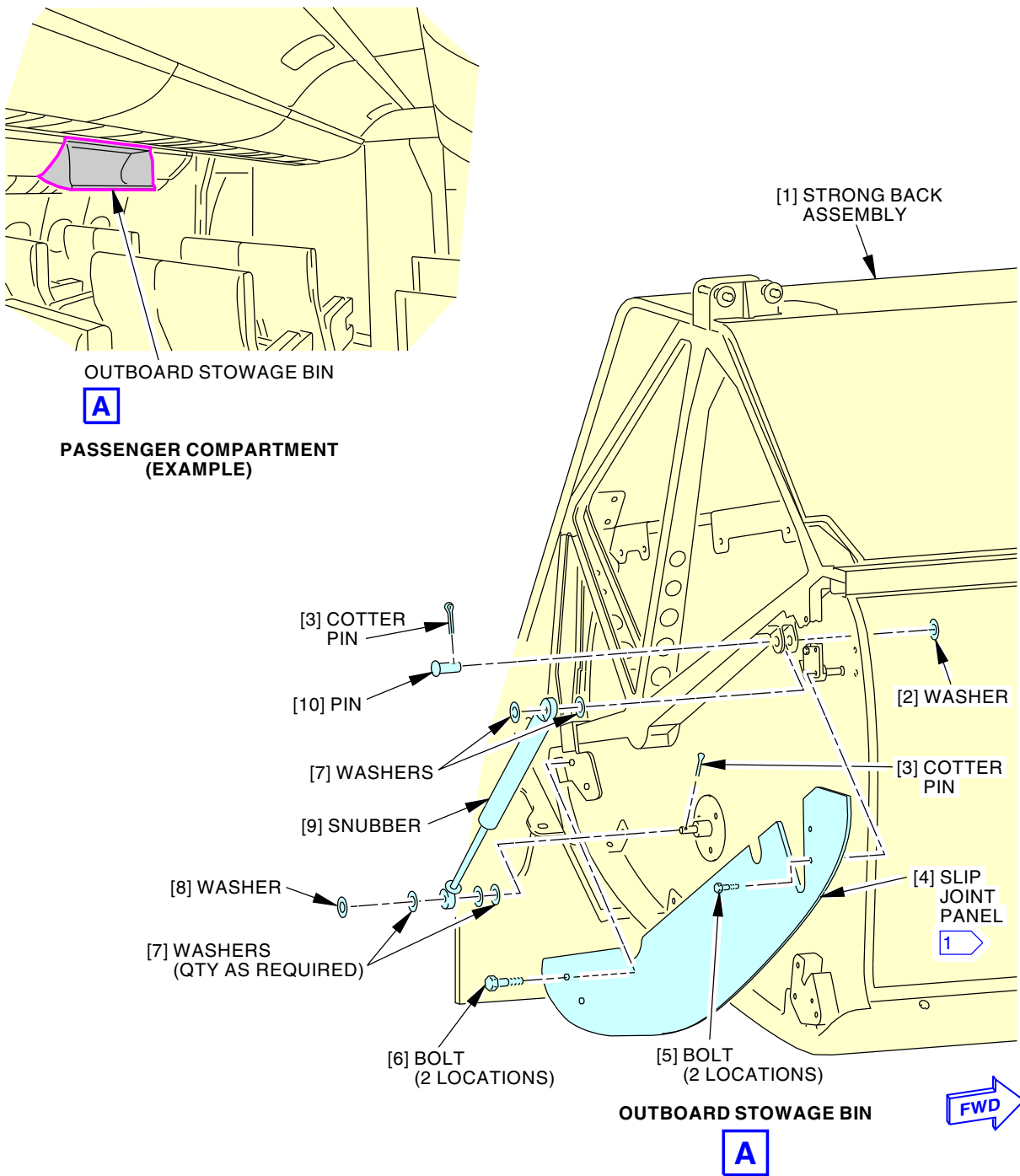
————— END OF TASK —————

EFFECTIVITY
ARO ALL

25-28-03

D633W101-ARO

Page 405
Sep 05/2017



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**Outboard Stowage Bin Snubber Installation
Figure 401/25-28-03-990-801**

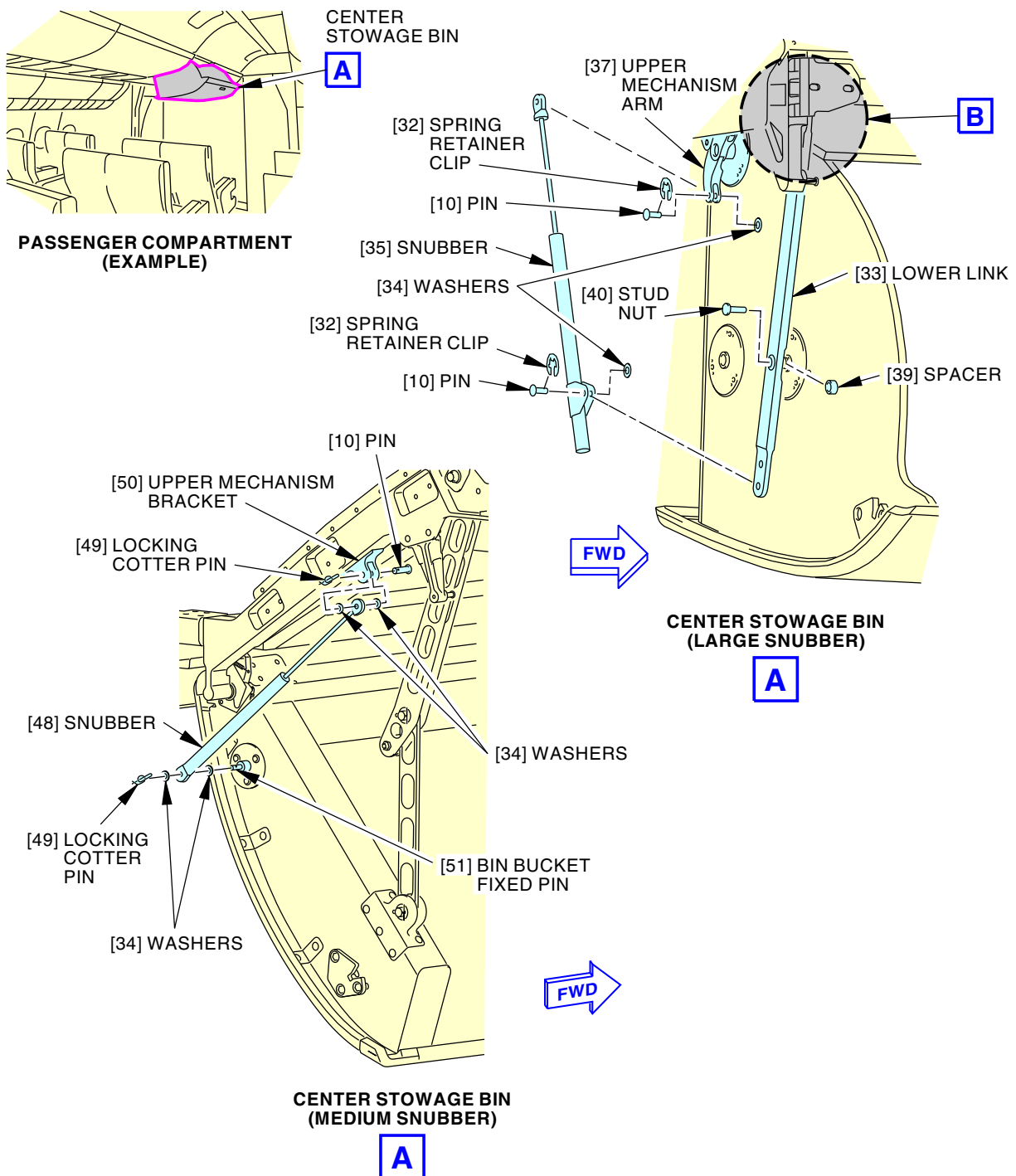
EFFECTIVITY
ARO ALL

25-28-03

D633W101-ARO

Page 406
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Center Stowage Bin Snubber Installation
Figure 402/25-28-03-990-802 (Sheet 1 of 3)**

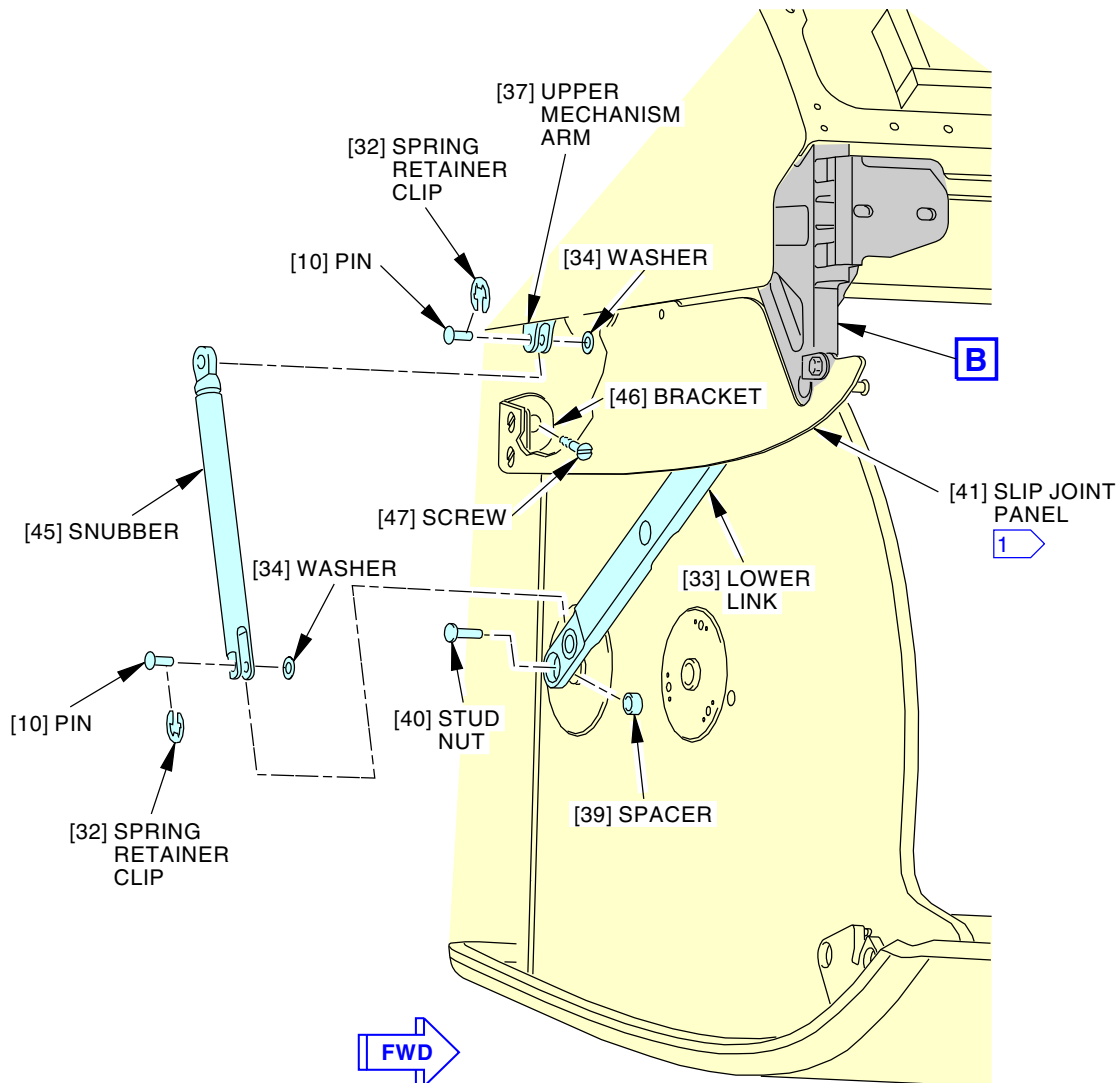
EFFECTIVITY
ARO ALL

D633W101-ARO

25-28-03

Page 407
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



**CENTER STOWAGE BIN
(SMALL SNUBBER)**

A

1 THE SLIP JOINT PANEL IS ONLY INSTALLED AT AN EXPANSION JOINT.

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**Center Stowage Bin Snubber Installation
Figure 402/25-28-03-990-802 (Sheet 2 of 3)**

EFFECTIVITY
ARO ALL

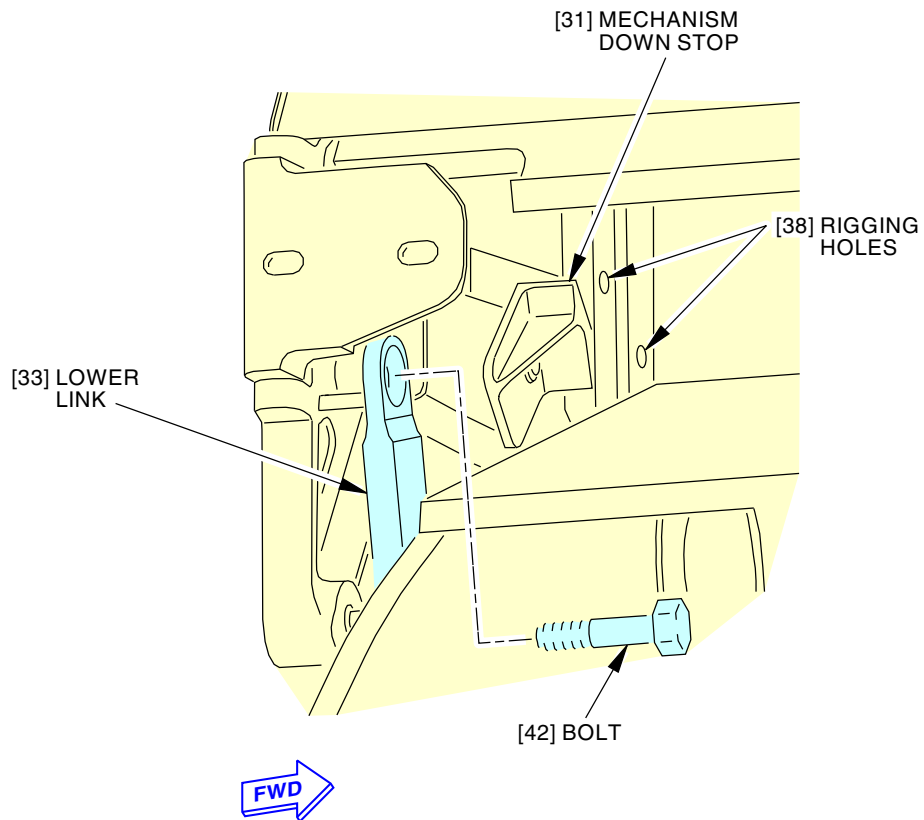
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25-28-03

Page 408
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



B

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Center Stowage Bin Snubber Installation
Figure 402/25-28-03-990-802 (Sheet 3 of 3)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-28-03

Page 409
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

STOWAGE BIN LATCH - MAINTENANCE PRACTICES

1. General

- A. This procedure is to release the stowage bin latch if the center or outboard stowage bin latch does not open with the stowage bin handle.

TASK 25-28-04-820-802

2. Stowage Bin Latch - Release

(Figure 201)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1641	Lever - Stowage Bin Release Part #: J25001-5 Supplier: 81205

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Stowage Bin Latch Release

SUBTASK 25-28-04-820-006

- (1) If you can not open the stowage bin with the stowage bin handle, then do these steps to move the emergency release lever to release the stowage bin latch.

NOTE: Usually the stowage bin handle will release one of the two latches. Use the emergency release lever to release the other latch. Pull down lightly at each end of the stowage bin, while you pull on the handle, to find which end is not released.

- (a) Procedure 1 (For center stowage bins with access to latch)

- 1) Open the stowage bin that is adjacent to the latch that will not release.

NOTE: If you cannot open a stowage bin adjacent to the latch you want to release (for example bins adjacent to an end cap or slip joint), then do the Procedure 2 below.

- 2) Push up and outboard on the emergency release lever with your finger. At the same time, pull on the stowage bin handle (to release the other latch) and pull down on the stowage bin to open it.

NOTE: You must hold the emergency release lever until you open the bin. Usually the latch will close again if you release the emergency release lever before you open the bin.

- (b) Procedure 2 (For center stowage bins without access to latch)

NOTE: You must use this procedure if there is not a bin you can open adjacent to the latch you want to release. You must also use this procedure if the latch you want to release is adjacent to a slip joint. This procedure requires the lever, SPL-1641. If this tool is not available, then you can make a temporary tool (Figure 202).

EFFECTIVITY
ARO ALL

25-28-04

D633W101-ARO

Page 201
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 1) Put the lever, SPL-1641 in position below the latch.

NOTE: Look at a different stowage bin to see where the latch is located.

NOTE: If you use the lever, SPL-1641 at a slip joint be careful not to damage the seal (make sure the lever, SPL-1641 does not have sharp edges).

- 2) Use the lever, SPL-1641 to push outboard on the emergency release lever. At the same time, pull on the stowage bin handle (to release the other latch) and pull down on the stowage bin to open it.

NOTE: It can be difficult to find the emergency release lever with the lever, SPL-1641. Make sure you (or someone) keeps the stowage bin handle released and continues to pull down on the bin so you will know when you release the latch.

- (c) Procedure 3 (For outboard stowage bins using the lever, SPL-1641)

- 1) Put the lever, SPL-1641 between the stowage bins above the latch.

NOTE: Two to three inches below the top edge of the stowage bin is a good location to start.

NOTE: The lever, SPL-1641 should work at all latch locations, but it is a tight fit at the slip joint locations. If you use it at a slip joint be careful not to damage the seal (make sure the lever, SPL-1641 does not have sharp edges). If this tool is not available, then you can make a temporary tool (Figure 202).

- 2) Turn the lever, SPL-1641 to point toward the stowage bin you want to open.
- 3) Move the lever, SPL-1641 down and outboard, keeping it in contact with the lip of the stowage bin. At the same time, pull on the stowage bin handle (to release the other latch) and pull down on the stowage bin to open it.

NOTE: You will feel the lever, SPL-1641 hit the emergency release lever. Push on the lever, SPL-1641 until the latch opens.

NOTE: You must hold the emergency release lever until you open the bin. Usually the latch will close again if you release the emergency release lever before you open the bin.

- (d) Procedure 4 (For outboard stowage bins when the lever, SPL-1641, is not available)

NOTE: If the lever, SPL-1641, is available use it. It is the easier way to open the bin.

- 1) Open the stowage bin that is adjacent to the latch that will not release.

NOTE: If you cannot open a stowage bin adjacent to the latch you want to release then you cannot use this procedure. You must use Procedure 3 above that uses the lever, SPL-1641.

- 2) Put your finger (not all fingers will fit) or a small object (such as a 1/4 inch drive deep socket or a Chapstick) in the channel at the edge of the stowage bin. Move it down the channel behind the latch and push down on the emergency release lever with it. At the same time, pull on the stowage bin handle (to release the other latch) and pull down on the stowage bin to open it.

NOTE: You must hold the emergency release lever until you open the bin. Usually the latch will close again if you release the emergency release lever before you open the bin.



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-28-04-410-003

- (1) Close the stowage bin.

————— **END OF TASK** —————

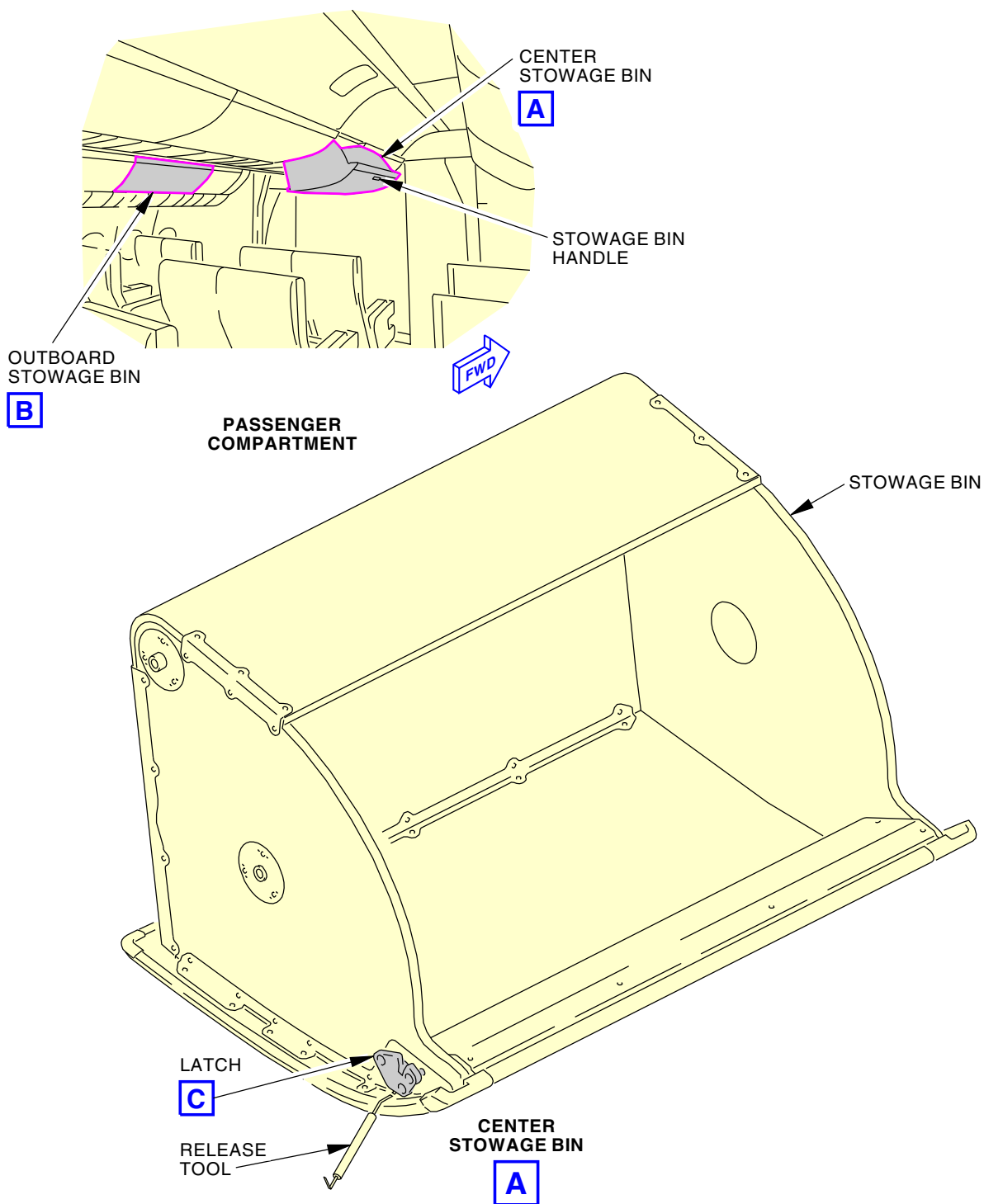
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25-28-04

Page 203
Jan 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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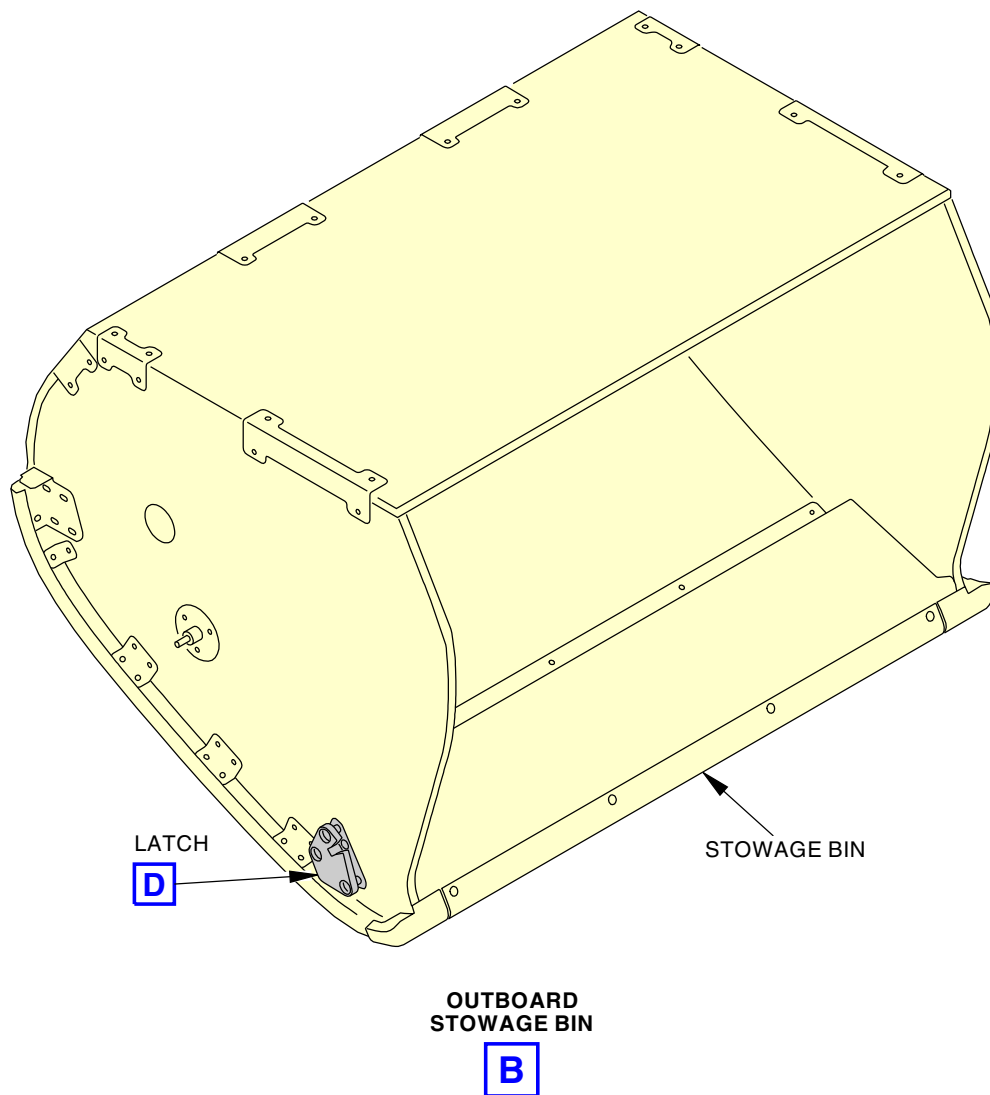
**Stowage Bin Latch Release
Figure 201/25-28-04-990-802 (Sheet 1 of 3)**

**EFFECTIVITY
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25-28-04

D633W101-ARO

Page 204
May 05/2017



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Stowage Bin Latch Release
Figure 201/25-28-04-990-802 (Sheet 2 of 3)

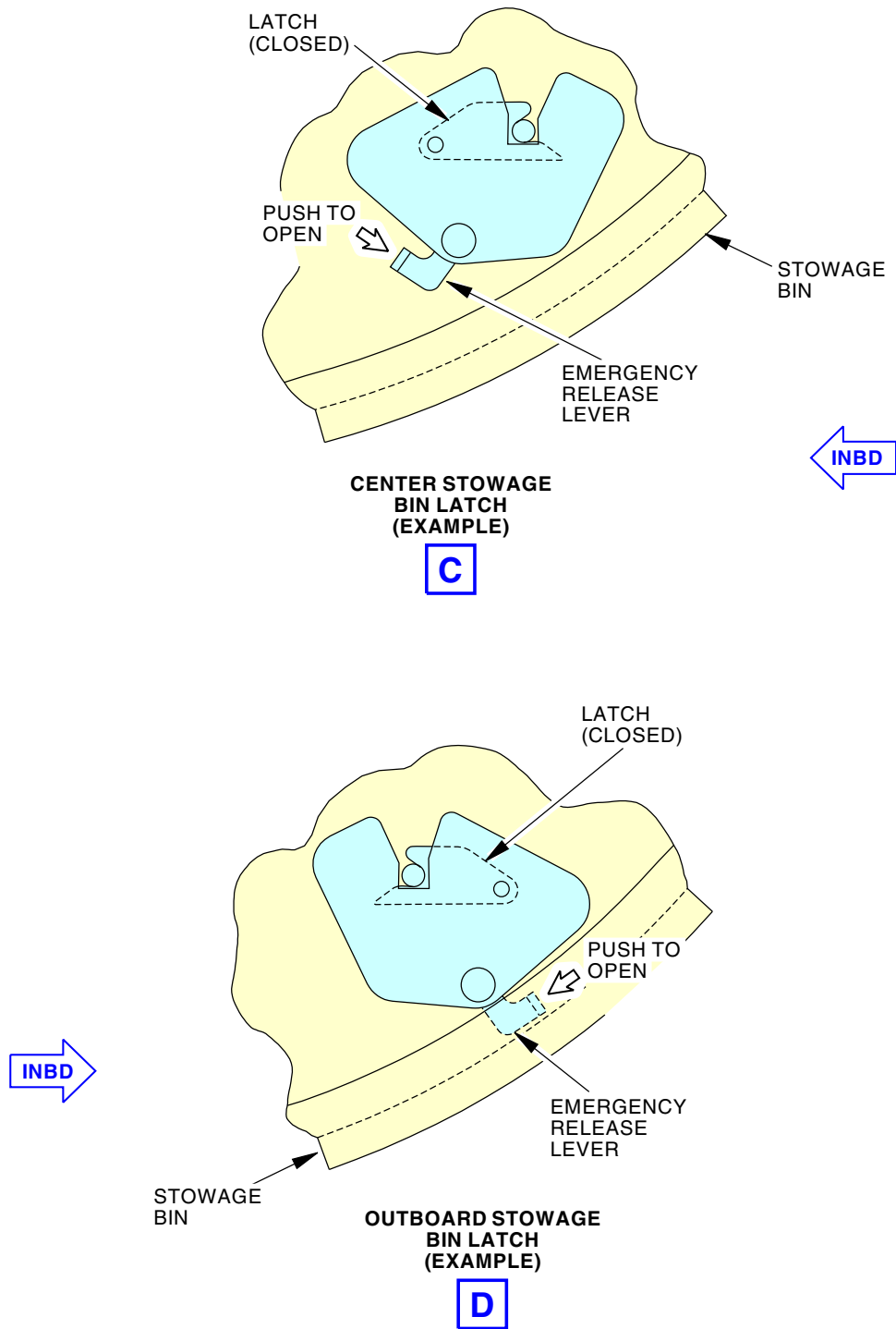
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25-28-04

D633W101-ARO

Page 205
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



Stowage Bin Latch Release
Figure 201/25-28-04-990-802 (Sheet 3 of 3)

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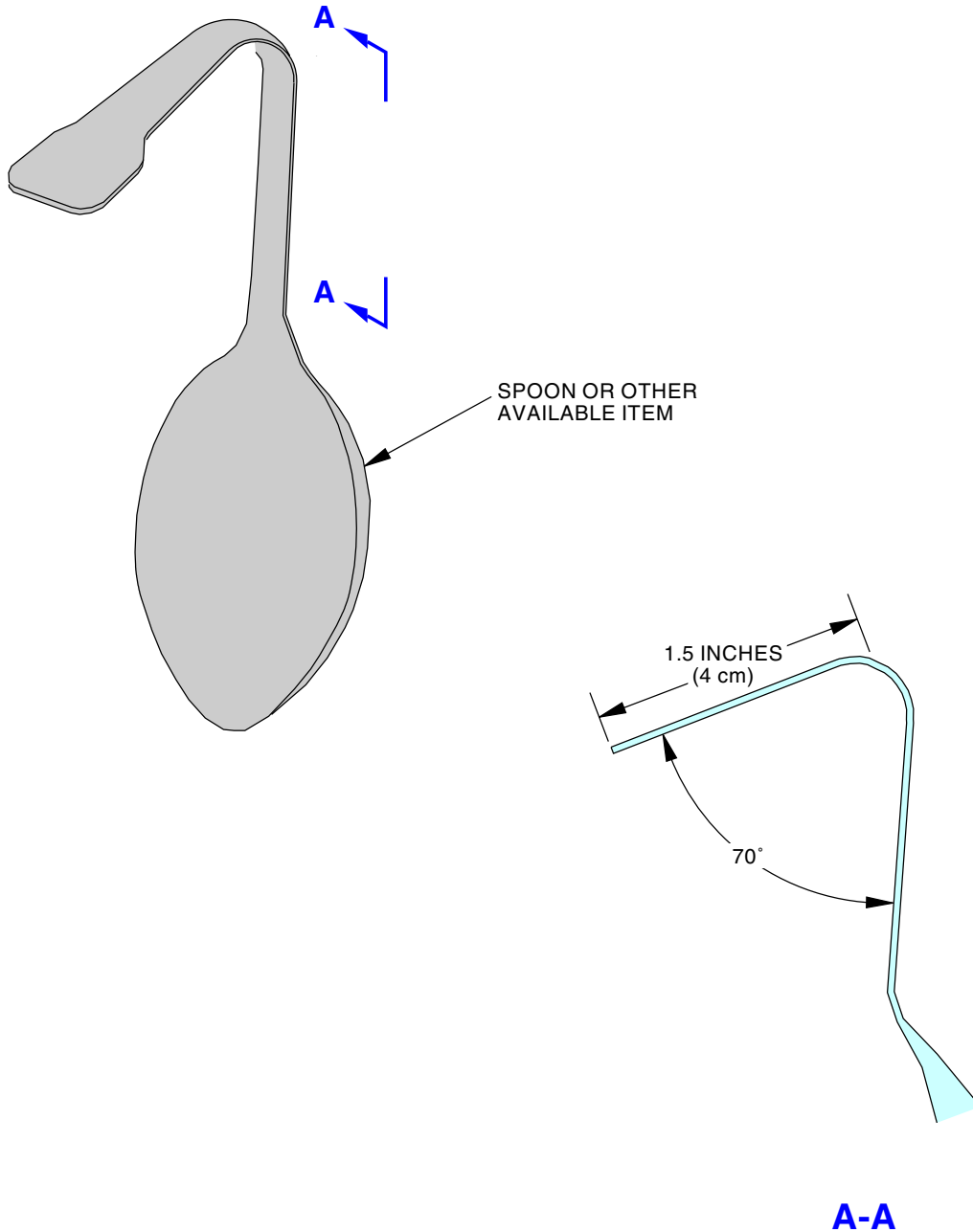
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D633W101-ARO

25-28-04

Page 206
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Temporary Latch Release Tool
Figure 202/25-28-04-990-803

EFFECTIVITY
ARO ALL

D633W101-ARO

25-28-04

Page 207
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
STOWAGE BIN LATCH - ADJUSTMENT/TEST

1. General

- A. This procedure is an adjustment of the latch for the center and outboard stowage bins.

TASK 25-28-04-820-801

2. Stowage Bin Latch - Adjustment

(Figure 501)

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Prepare for the Adjustment

SUBTASK 25-28-04-010-001

- (1) Open the stowage bin [15].

SUBTASK 25-28-04-010-002

- (2) Remove the screws [1] that attach the torque tube cover [5] in the stowage bin [15].

C. Stowage Bin Latch Adjustment

SUBTASK 25-28-04-020-002

- (1) Loosen the set screws [13] in the receptacle ends [14] of the actuator housing [17] until they clear the inner wall of the actuator ends [14].

SUBTASK 25-28-04-210-003

- (2) Use a screwdriver to push the striker pawl [18] to the closed position to move the end latches [2] to the latched position.

NOTE: The stowage bin [15] is in the open position.

- (a) Make sure the striker pawl [18] is in the fully closed position.

SUBTASK 25-28-04-480-001

- (3) Install a rigging screw [7] (Figure 501 (Sheet 2)) in both the left end latch [2] and the right end latch [2] to make sure they remain in the closed position.

SUBTASK 25-28-04-210-004

- (4) Make sure the stowage bin handle stops flush with the bezel when it is in the fully closed position.

NOTE: This is shown when the handle is flush with the bezel and you cannot see the red finish on the ends.

SUBTASK 25-28-04-820-001

- (5) If the stowage bin handle does not stop flush with the bezel, then use the screws [12] on the outer corners of the handle housing [17] to adjust the gap of the handle to the bezel.

SUBTASK 25-28-04-820-005

- (6) Push the handle to the closed position. Hold the handle in this closed position while you do these steps:

- (a) Turn the top of the torque tube [10] inboard, until it stops, so the socket pawl [8] touches the pin [9] on the end latch link [6].

NOTE: On a center stowage bin you will turn the torque tube towards the back of the bin. On an outboard stowage bin you will turn the torque tube towards the front of the bin.

EFFECTIVITY
ARO ALL

25-28-04

D633W101-ARO

Page 501
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (b) With the torque tubes in the rotated position, do the following steps to install the set screws [13] in the receptacle ends [14] of the actuator housing [17]:
- 1) Put loctite on the set screws [13].
 - 2) On the center stowage bin, first install the two set screws [13] nearest to the rear of the bin.
 - 3) On the outboard stowage bin, first install the two set screws [13] nearest to the front of the bin.
 - 4) Adjust these two set screws [13] so that they just contact the vertical tabs of the torque tubes [10].
NOTE: Do not pre-load the torque tube tabs by adjusting the set screws too much.
 - 5) Next, install the other two set screws [13] and tighten them against the vertical tabs of the torque tubes [10].

SUBTASK 25-28-04-820-004

- (7) Remove rigging screw [7] (Figure 501 (Sheet 2)) from each end latch [2].

SUBTASK 25-28-04-210-002

- (8) Do these steps to make sure the adjustment of the end latches [2] is correct:
- (a) Pull the emergency release lever [20] down and outboard to unlatch the end latches [2].
NOTE: On a center stowage bin you will pull the emergency release lever down and towards you. On an outboard stowage bin you will pull the emergency release lever down and away from you.
 - (b) Close the stowage bin [15].
 - (c) Make sure the stowage bin handle is in the fully closed position.
NOTE: This is shown when the handle is flush with the bezel and you cannot see the red finish on the ends.
 - (d) Pull down on the outer edges of the stowage bin [15] to make sure it is fully latched.
 - (e) If the end latches [2] are not adjusted correctly, open the stowage bin [15] and do the stowage bin latch adjustment again.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-28-04-410-001

- (1) Install the screws [1] that attach the torque tube cover [5] in the stowage bin [15].

SUBTASK 25-28-04-410-002

- (2) Close the stowage bin [15].

————— END OF TASK —————

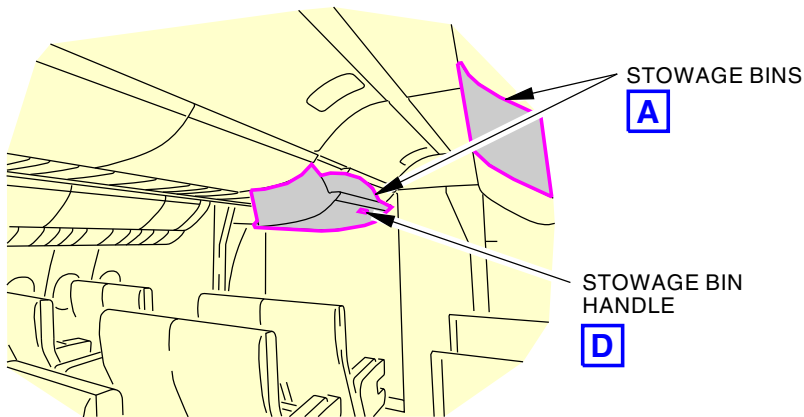
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25-28-04

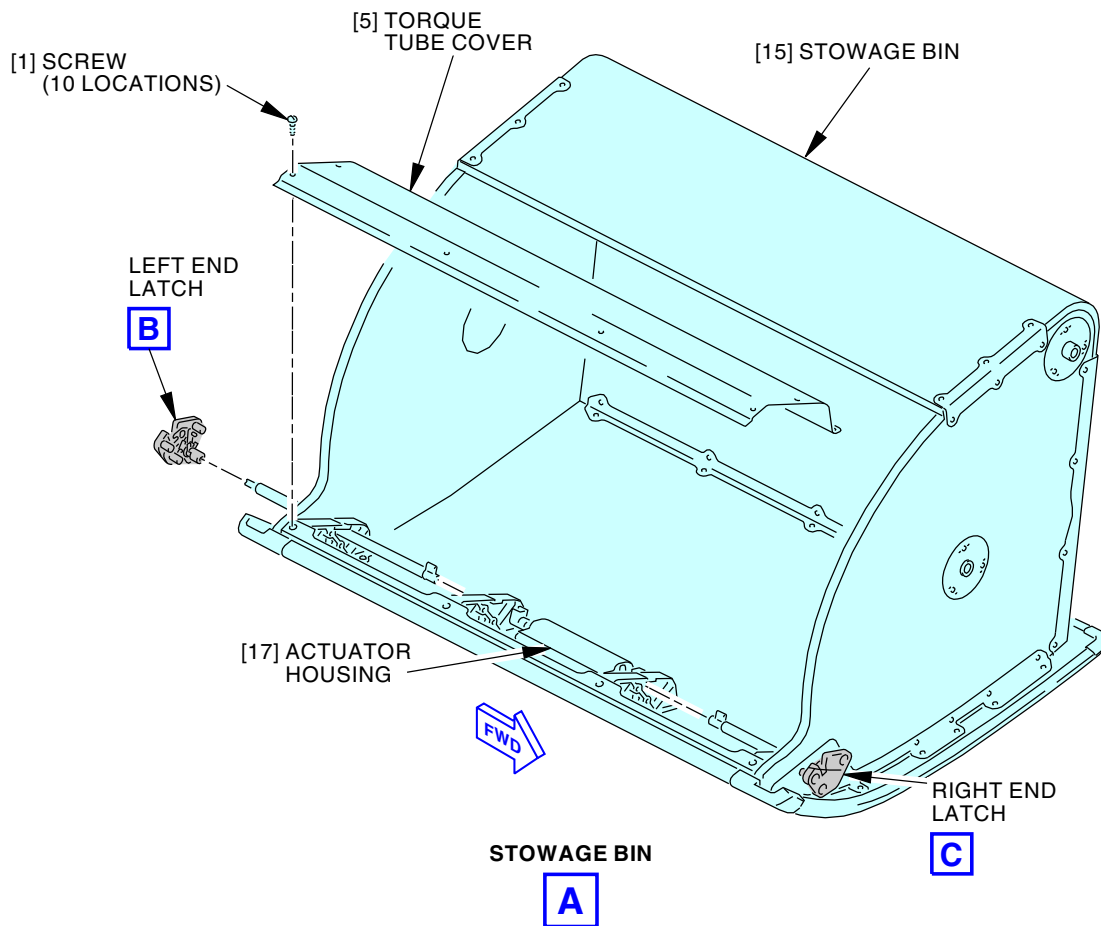
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Page 502
Jan 05/2015

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT



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Stowage Bin Latch Adjustment
Figure 501/25-28-04-990-801 (Sheet 1 of 2)

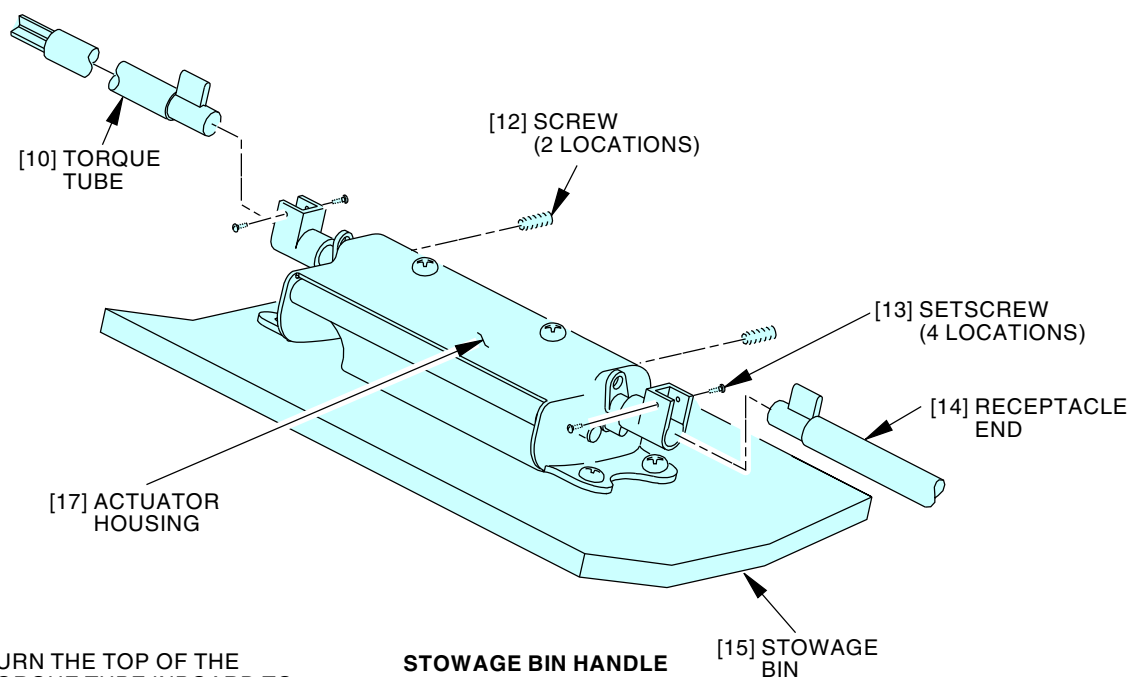
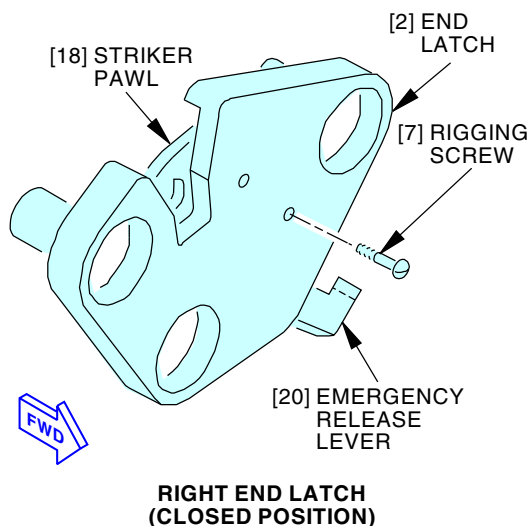
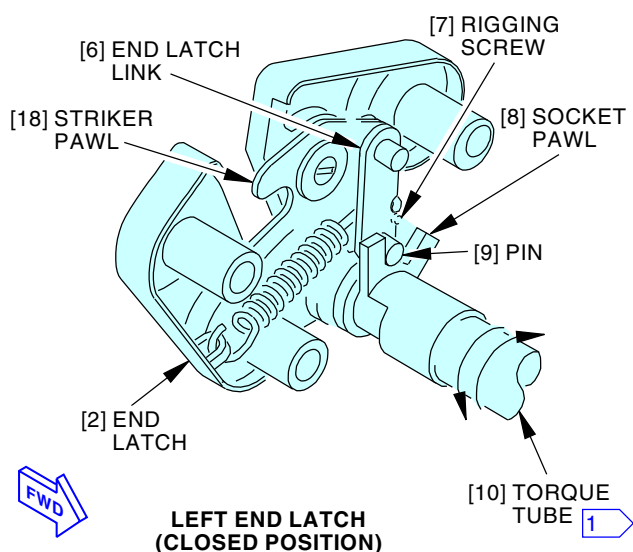
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25-28-04

D633W101-ARO

Page 503
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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Stowage Bin Latch Adjustment
Figure 501/25-28-04-990-801 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

25-28-04

D633W101-ARO

Page 504
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

FLOOR-MOUNTED STOWAGE BOX - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) A removal of the floor-mounted stowage box.
- (2) An installation of the floor-mounted stowage box.

B. There is more than one type of floor-mounted stowage box. This procedure gives instructions to remove and install the type with bifold doors, the type with a drawer, the type with an aisle-hinged door, and the type with multiple hinged doors.

NOTE: The configuration of the stowage boxes can vary from airplane to airplane.

TASK 25-28-05-000-801

2. Floor-Mounted Stowage Box Removal

(Figure 401)

A. References

Reference	Title
25-25-01-000-801	Passenger Seat - Removal (P/B 401)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-28-05-010-001

- (1) Remove the passenger seats if it is necessary. Do this task: Passenger Seat - Removal, TASK 25-25-01-000-801.

D. Floor-Mounted Stowage Box Removal

ARO ALL; AIRPLANES WITH STANDARD FLOOR MOUNTED STOWAGE

SUBTASK 25-28-05-020-003

- (1) Do these steps to remove a stowage box [1]:
 - (a) Loosen the lock-down screw [13].
 - (b) Move the stowage box [1] forward or aft approximately 1/2 inch to align the fitting with circular opening in the seat track [8].
 - (c) Lift the stowage box [1] out of the seat track [8].

————— **END OF TASK** —————

ARO ALL

TASK 25-28-05-400-801

3. Floor-Mounted Stowage Box - Installation

(Figure 401)

A. References

Reference	Title
25-25-01-400-801	Passenger Seat - Installation (P/B 401)

EFFECTIVITY
ARO ALL

25-28-05

D633W101-ARO

Page 401
Jul 25/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL

B. Consumable Materials

Reference	Description	Specification
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
G02304	Tape - Moisture Barrier, Adhesive One-side	BMS8-346

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Floor-Mounted Stowage Box Installation

ARO ALL; AIRPLANES WITH STANDARD FLOOR MOUNTED STOWAGE

SUBTASK 25-28-05-420-003

- (1) Do these steps to install a stowage box [1]:
 - (a) Do these steps in the wet areas to prevent corrosion:
 - 1) Put corrosion preventive compound, C00308 in the seat track [8] around the seat track fitting.
 - 2) Apply new moisture barrier tape, G02304 with a cutout for the seat track fittings if it is necessary.
 - (b) Align the fittings on the stowage box [1] with the circular openings in the seat track [8].
 - (c) Lower the stowage box [1] until the fittings are in the seat track [8].
 - (d) Move the stowage box [1] forward or aft approximately 1/2 inch to lock the fittings in the seat track [8].
 - (e) Turn the adjustment screw [14] clock-wise to move the stowage box [1] in the aft direction to touch the closeout seal.
 - (f) Tighten the lock-down screw [13] to 50-80 inch-pounds.

ARO ALL

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-28-05-410-002

- (1) Install the seats if they were removed. Do this task: Passenger Seat - Installation, TASK 25-25-01-400-801.

————— **END OF TASK** —————

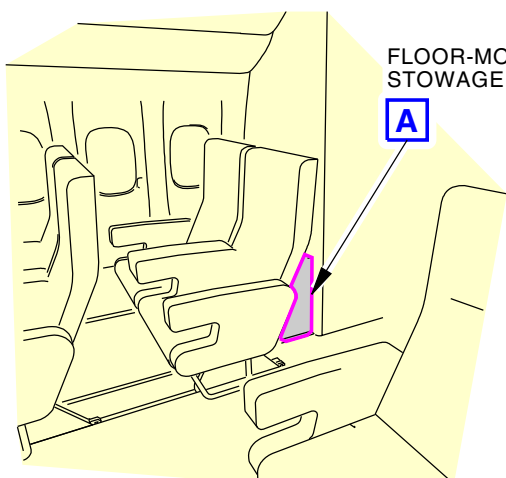
EFFECTIVITY
ARO ALL

D633W101-ARO

25-28-05

Page 402
Jul 25/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

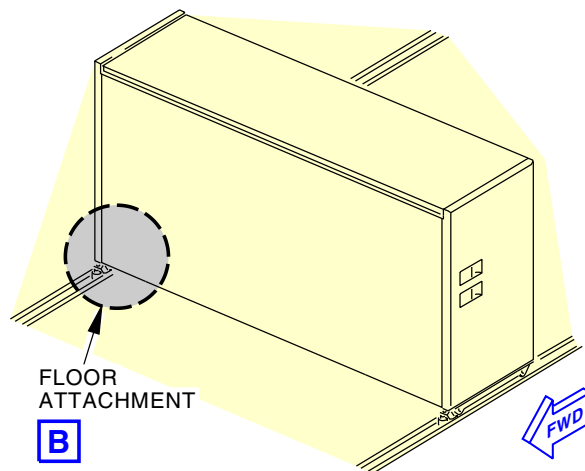


FLOOR-MOUNTED
STORAGE BOX

A



PASSENGER COMPARTMENT

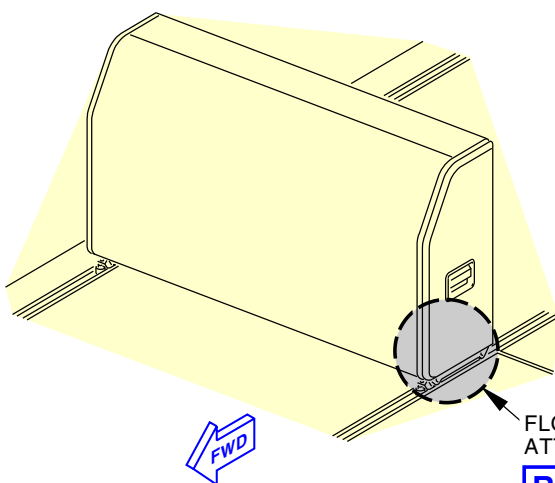


FLOOR
ATTACHMENT

B

**FLOOR-MOUNTED STORAGE BOX
WITH AISLE-HINGED DOOR
(EXAMPLE)**

A



FLOOR
ATTACHMENT

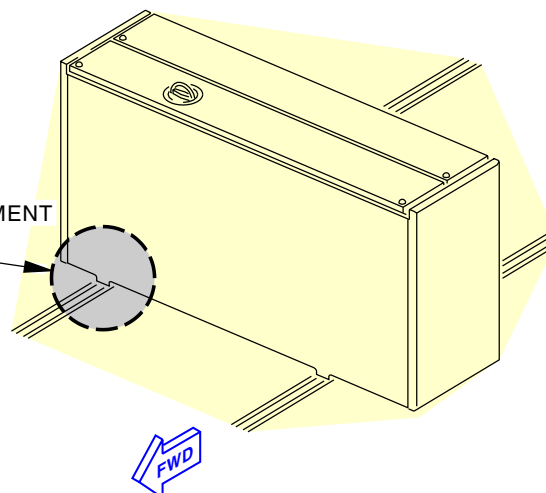
C

FLOOR
ATTACHMENT

B

**FLOOR-MOUNTED STORAGE BOX
WITH A DRAWER
(EXAMPLE)**

A



FLOOR
ATTACHMENT

C

FLOOR
ATTACHMENT

B

**FLOOR-MOUNTED STORAGE BOX
WITH BIFOLD DOORS
(EXAMPLE)**

A

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**Floor-Mounted Storage Box Installation
Figure 401/25-28-05-990-801 (Sheet 1 of 2)**

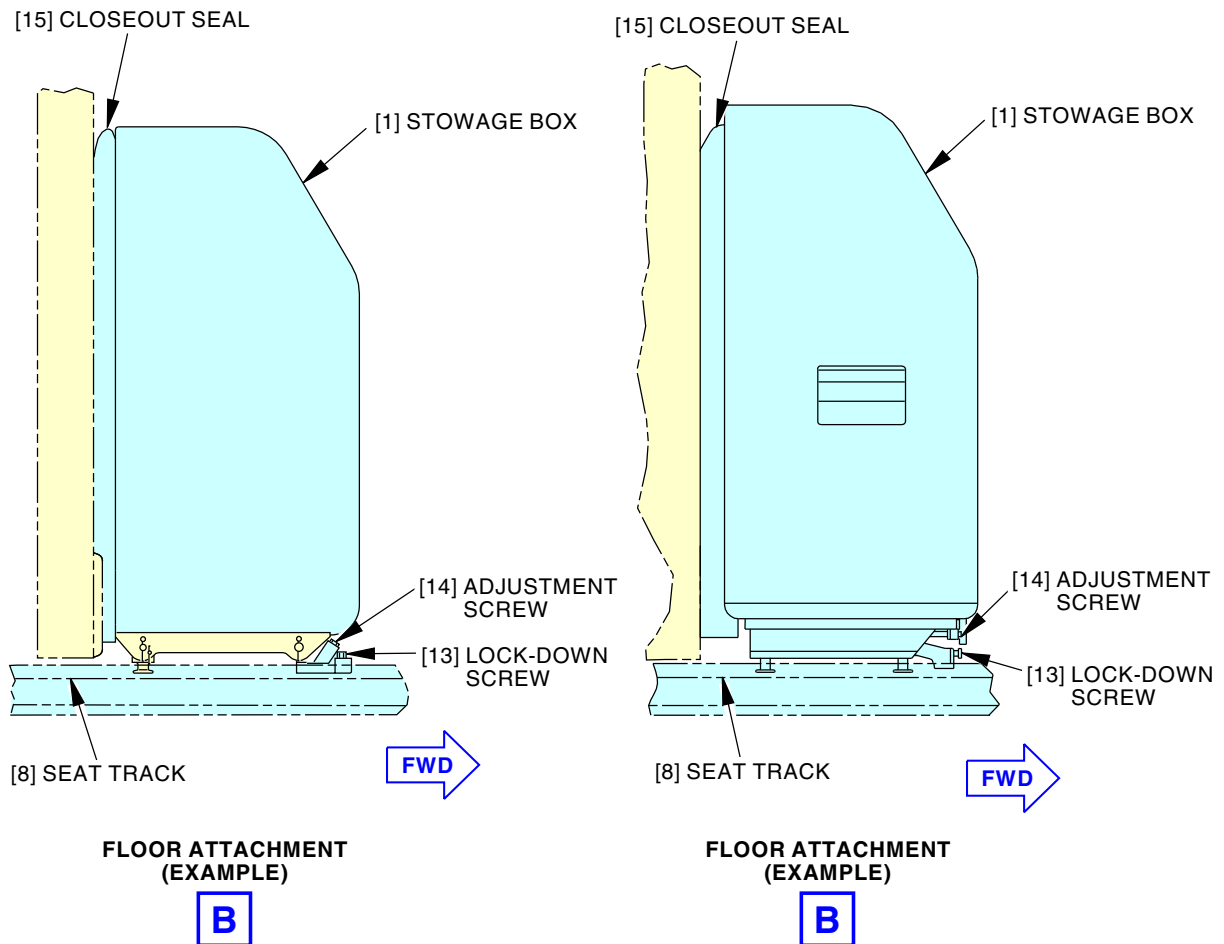
EFFECTIVITY
ARO ALL

D633W101-ARO

25-28-05

Page 403
Jul 25/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Floor-Mounted Stowage Box Installation
Figure 401/25-28-05-990-801 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

25-28-05

D633W101-ARO

Page 404
Jul 25/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL
CENTER STOWAGE BIN DIAGONAL BRACE

1. General

A. This procedure has these tasks:

- (1) Removal of the center stowage bin diagonal brace.
- (2) Installation of the center stowage bin diagonal brace.

TASK 25-28-06-000-801

2. Center Stowage Bin Diagonal Brace Removal

(Figure 401)

A. References

Reference	Title
25-21-06-000-801	Main Ceiling Panel - Removal (P/B 401)

B. Location Zones

Zone	Area
233	Area Above Passenger Compartment Ceiling, Left - Section 43
234	Area Above Passenger Compartment Ceiling, Right - Section 43
243	Area Above Passenger Compartment Ceiling, Left - Section 44
244	Area Above Passenger Compartment Ceiling, Right - Section 44
253	Area Above Passenger Compartment Ceiling, Left - Section 46
254	Area Above Passenger Compartment Ceiling, Right - Section 46
263	Area Above Passenger Compartment Ceiling, Left - Section 47
264	Area Above Passenger Compartment Ceiling, Right - Section 47

C. Prepare for the Removal

SUBTASK 25-28-06-000-001

- (1) Remove the main ceiling panels that are below the diagonal brace [1]. (Main Ceiling Panel - Removal, TASK 25-21-06-000-801)

D. Diagonal Brace Removal

SUBTASK 25-28-06-030-001

- (1) Disconnect the quick-release pin [3] at the two ends of the diagonal brace [1].

SUBTASK 25-28-06-000-002

- (2) Remove the diagonal brace [1].

————— **END OF TASK** —————

TASK 25-28-06-400-801

3. Center Stowage Bin Diagonal Brace Installation

(Figure 401)

A. References

Reference	Title
25-21-06-400-801	Main Ceiling Panel - Installation (P/B 401)

B. Location Zones

Zone	Area
233	Area Above Passenger Compartment Ceiling, Left - Section 43

EFFECTIVITY
ARO ALL

D633W101-ARO

25-28-06

Page 401
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Zone	Area
234	Area Above Passenger Compartment Ceiling, Right - Section 43
243	Area Above Passenger Compartment Ceiling, Left - Section 44
244	Area Above Passenger Compartment Ceiling, Right - Section 44
253	Area Above Passenger Compartment Ceiling, Left - Section 46
254	Area Above Passenger Compartment Ceiling, Right - Section 46
263	Area Above Passenger Compartment Ceiling, Left - Section 47
264	Area Above Passenger Compartment Ceiling, Right - Section 47

C. Diagonal Brace Installation

SUBTASK 25-28-06-700-001

- (1) Do a check of the quick-release pin [3] to make sure that it is in a serviceable condition.

SUBTASK 25-28-06-430-001

- (2) Make sure that the rod ends [5] are adjusted to the same length.

SUBTASK 25-28-06-400-001

- (3) Put the diagonal brace [1] in the correct position.

SUBTASK 25-28-06-430-002

- (4) Install the quick-release pin [3], at the two ends of the diagonal brace [1].

NOTE: The quick-release pins [3] can be installed in the up or down direction if necessary.

SUBTASK 25-28-06-700-002

- (5) Do these steps to adjust the diagonal brace [1] if the quick-release pins [3] cannot be installed easily:
 - (a) Loosen the two jam nuts [2] at the ends of the diagonal brace [1].
 - (b) Adjust the rod ends [55] to align with the center stowage bin fittings on the stowage bin end frame [4].
 - (c) Make sure that the rod ends [5] are adjusted to same lengths.



CAUTION

MAKE SURE THE DIAGONAL BRACE IS ADJUSTED CORRECTLY. INCORRECT ADJUSTMENT COULD RESULT IN FAILURE OF THE DIAGONAL BRACE AND DAMAGE TO EQUIPMENT COULD OCCUR.

- (d) Adjust the diagonal brace [1] to apply light inner tension

NOTE: Use finger pressure only.

- (e) Do these steps to make sure that the rod ends [55] are attached to the diagonal brace [1]:
 - 1) Put a wire into the inspection hole in the diagonal brace [1].
 - 2) Make sure that the wire is stopped by the rod end [5].
- (f) Tighten the jam nuts [2].

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-28-06-400-002

- (1) Install the main ceiling panels if necessary. (Main Ceiling Panel - Installation, TASK 25-21-06-400-801)

————— END OF TASK —————

EFFECTIVITY
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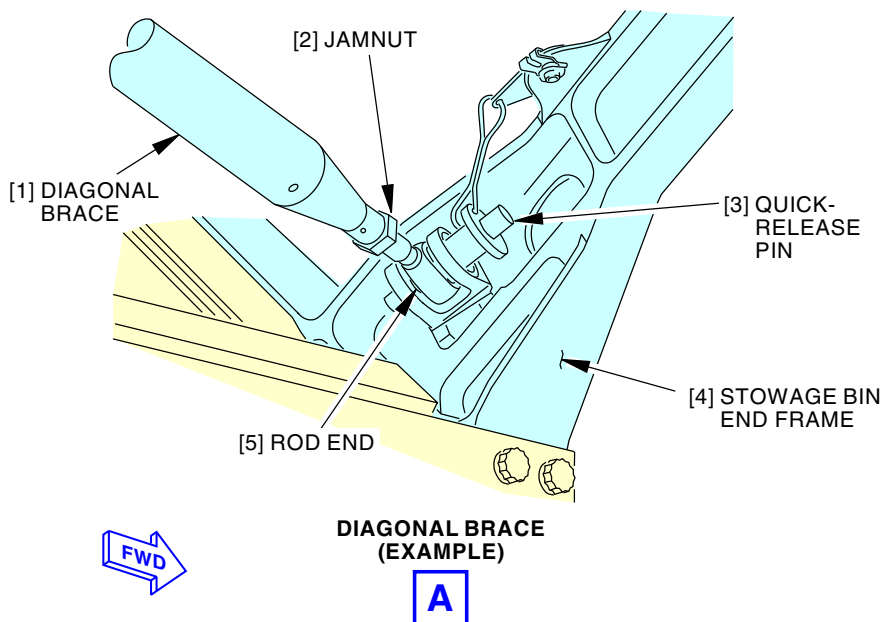
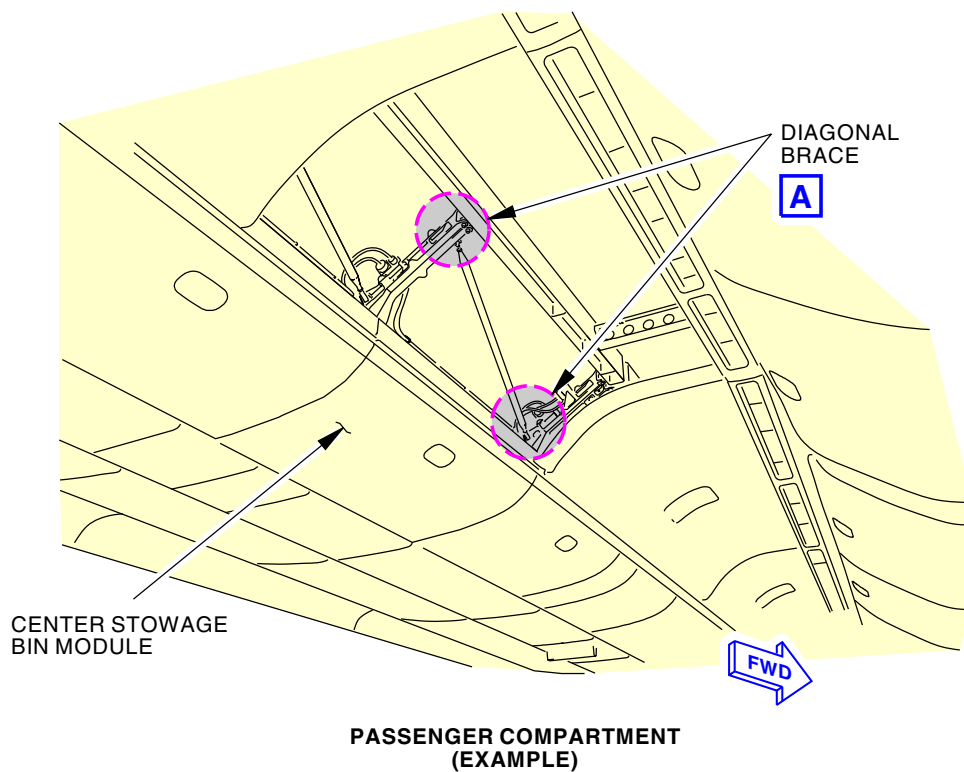
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Page 402
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Center Storage Bin Diagonal Brace Installation
Figure 401/25-28-06-990-801**

EFFECTIVITY
ARO ALL

25-28-06

D633W101-ARO

Page 403
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

OVERHEAD STOWAGE BOX - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the overhead stowage box.
 - (2) An installation of the overhead stowage box.
 - (3) A removal of the overhead stowage box module.
 - (4) An installation of the overhead stowage box module.
- B. The overhead stowage box module consists of the trough, upper and lower mechanism arms, snubbers, and the stowage box.
- C. This procedure refers to the overhead stowage box as the stowage box and the overhead stowage box module as the module.

TASK 25-28-07-000-801

2. Overhead Stowage Box Removal

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-2532	Pin Set - Rigging
	Part #: J20003-34 Supplier: 81205

B. Location Zones

Zone	Area
221	Passenger Compartment, Left - Section 41
222	Passenger Compartment, Right - Section 41
261	Passenger Compartment, Left - Section 47
262	Passenger Compartment, Right - Section 47

C. Overhead Stowage Box Removal

SUBTASK 25-28-07-010-001

- (1) Open the stowage box [6].

SUBTASK 25-28-07-020-001

- (2) Do these steps at the two ends of the stowage box [6] :
- (a) Align the hole in the upper mechanism arm [3] with the hole in the lower mechanism arm [4].
 - (b) Install a rigging pin set, SPL-2532 [1] through the holes.
 - (c) While one person holds the stowage box [6], do these steps:
 - 1) Disengage the lower stud nuts [5] that are captive in the lower bosses [2].
 - 2) Disengage the upper stud nuts [5] that are captive in the upper mechanism arms [3].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-28-07

Page 401
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-28-07-020-002

- (3) Remove the stowage box [6].

————— END OF TASK —————

TASK 25-28-07-400-801

3. Overhead Stowage Box Installation

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-2532	Pin Set - Rigging
	Part #: J20003-34 Supplier: 81205

B. Location Zones

Zone	Area
221	Passenger Compartment, Left - Section 41
222	Passenger Compartment, Right - Section 41
261	Passenger Compartment, Left - Section 47
262	Passenger Compartment, Right - Section 47

C. Overhead Stowage Box Installation

SUBTASK 25-28-07-860-001

- (1) Make sure the upper mechanism arms [3] and the lower mechanism arms [4] are locked together with the rigging pin set, SPL-2532 [1].

SUBTASK 25-28-07-420-001

- (2) While one person holds the stowage box [6] up in the opening, do these steps to the two ends of the stowage box:
 - (a) Engage the upper stud nut [5] into the upper mechanism arm [3].
 - (b) Engage the lower stud nut [5] into the lower boss [2] on the stowage box [6].
 - (c) Install the stowage box [6].
 - (d) Tighten the stud nuts [5], then back them off one click.

SUBTASK 25-28-07-080-001

- (3) Remove the rigging pin set, SPL-2532 [1].

D. Overhead Stowage Box Installation Test

SUBTASK 25-28-07-710-001

- (1) Open and close the stowage box [6] to make sure it operates without binding or scraping.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-28-07-410-001

- (1) Close the stowage box [6].

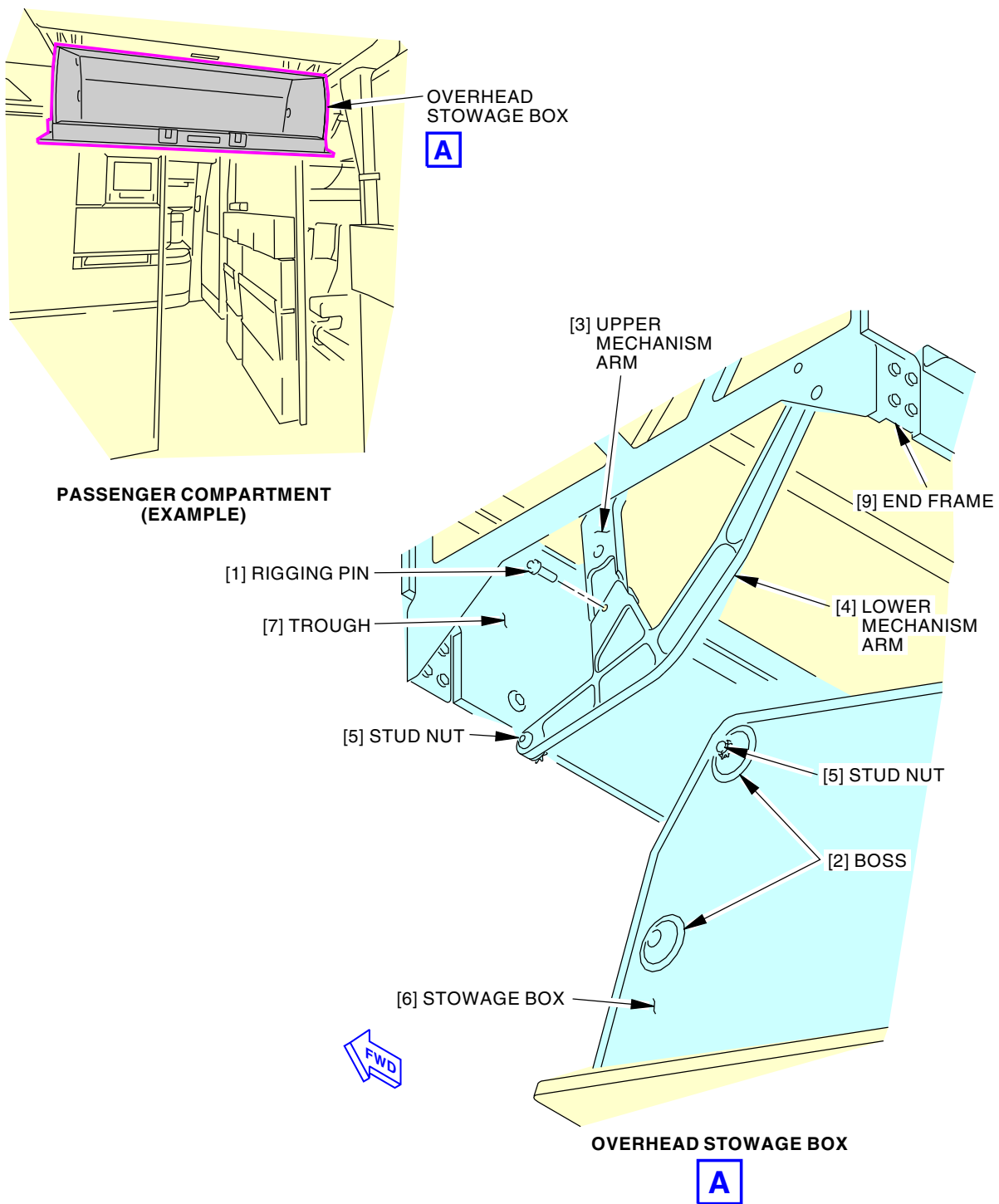
————— END OF TASK —————

EFFECTIVITY
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25-28-07

D633W101-ARO

Page 402
May 05/2015



D07821 S0006409875_V2

**Overhead Stowage Box Installation
Figure 401/25-28-07-990-801**

EFFECTIVITY
ARO ALL

25-28-07

D633W101-ARO

Page 403
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-28-07-000-802

4. Overhead Stowage Box Module Removal

(Figure 402)

A. References

Reference	Title
25-21-08-000-801	Overdoor Panel Opening/Removal (P/B 201)

B. Location Zones

Zone	Area
221	Passenger Compartment, Left - Section 41
222	Passenger Compartment, Right - Section 41
261	Passenger Compartment, Left - Section 47
262	Passenger Compartment, Right - Section 47

C. Prepare for the Removal

SUBTASK 25-28-07-010-002

- (1) Do this task: Overdoor Panel Opening/Removal, TASK 25-21-08-000-801.

D. Overhead Stowage Box Module Removal

SUBTASK 25-28-07-000-001

- (1) Remove the screws [24], bolts [21] and washers [22] from the outboard side of the outboard installation bracket [8].

SUBTASK 25-28-07-000-002

- (2) Remove the bolts [26] and washers [22] from the top side of the outboard installation bracket [8].

SUBTASK 25-28-07-000-003

- (3) Remove the outboard installation bracket [8].

SUBTASK 25-28-07-010-003

- (4) Open the stowage box [6].

SUBTASK 25-28-07-020-003

- (5) Do these steps while one person holds the stowage box [6]:
- (a) Remove the bolts [26] and washers [25] from the inboard side of the trough [7].
NOTE: These bolts are behind the opened stowage box.
 - (b) Remove the bolts [23] and washers [22] from the inboard side of the end frames [9].
NOTE: These bolts are behind the opened stowage box.
 - (c) Remove the bolts [23] and washers [22] from the outboard side of the support structure.

SUBTASK 25-28-07-020-004

- (6) Remove the module assembly [28].

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-28-07

D633W101-ARO

Page 404
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-28-07-400-802

5. Overhead Stowage Box Module Installation

(Figure 402)

A. References

Reference	Title
25-21-08-400-801	Overdoor Panel Installation/Closing (P/B 201)

B. Location Zones

Zone	Area
221	Passenger Compartment, Left - Section 41
222	Passenger Compartment, Right - Section 41
261	Passenger Compartment, Left - Section 47
262	Passenger Compartment, Right - Section 47

C. Overhead Stowage Box Module Installation

SUBTASK 25-28-07-420-002

- (1) Do these steps while one person holds the module assembly [28] up in the opening:
 - (a) Install the module assembly [28].
 - (b) Loosely install the bolts [23] and washers [22] from the outboard side of the support structure into the end frames [9].
 - (c) Install the bolts [23] and washers [22] from the inboard side of the end frames [9] into the support structure.
 - (d) Install the bolts [26] and washers [25] from the inboard side of the trough [7] into the support structure.
 - (e) Close the stowage box [6].
 - (f) Tighten the bolts [23] and washers [22] installed from the outboard side of the support structure into the end frames [9].
 - (g) Install the bolts [27] and washers [22] from the top side of the bracket [8] into the support structure.
 - (h) Install the screws [24], bolts [21] and washers [22] from the outboard side of the bracket [8] into the trough [7].

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-28-07-410-002

- (1) Do this task: Overdoor Panel Installation/Closing, TASK 25-21-08-400-801.

————— **END OF TASK** —————

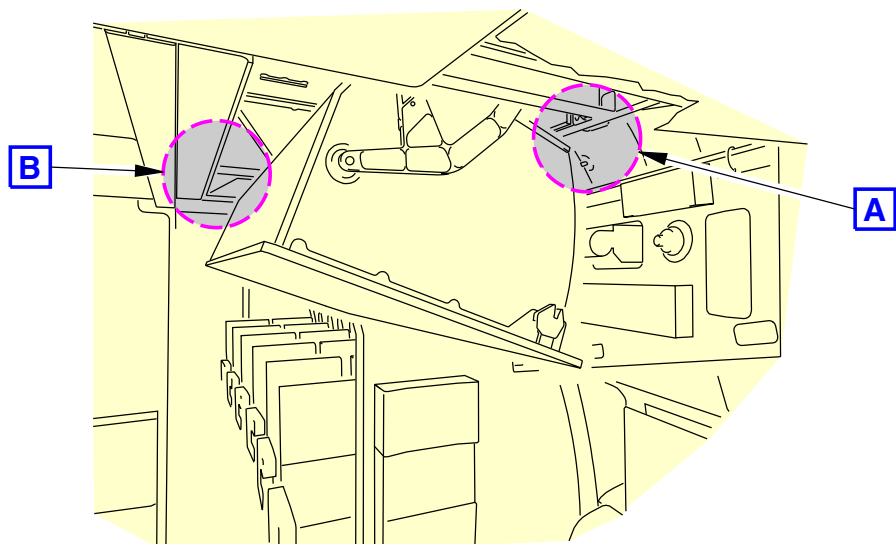
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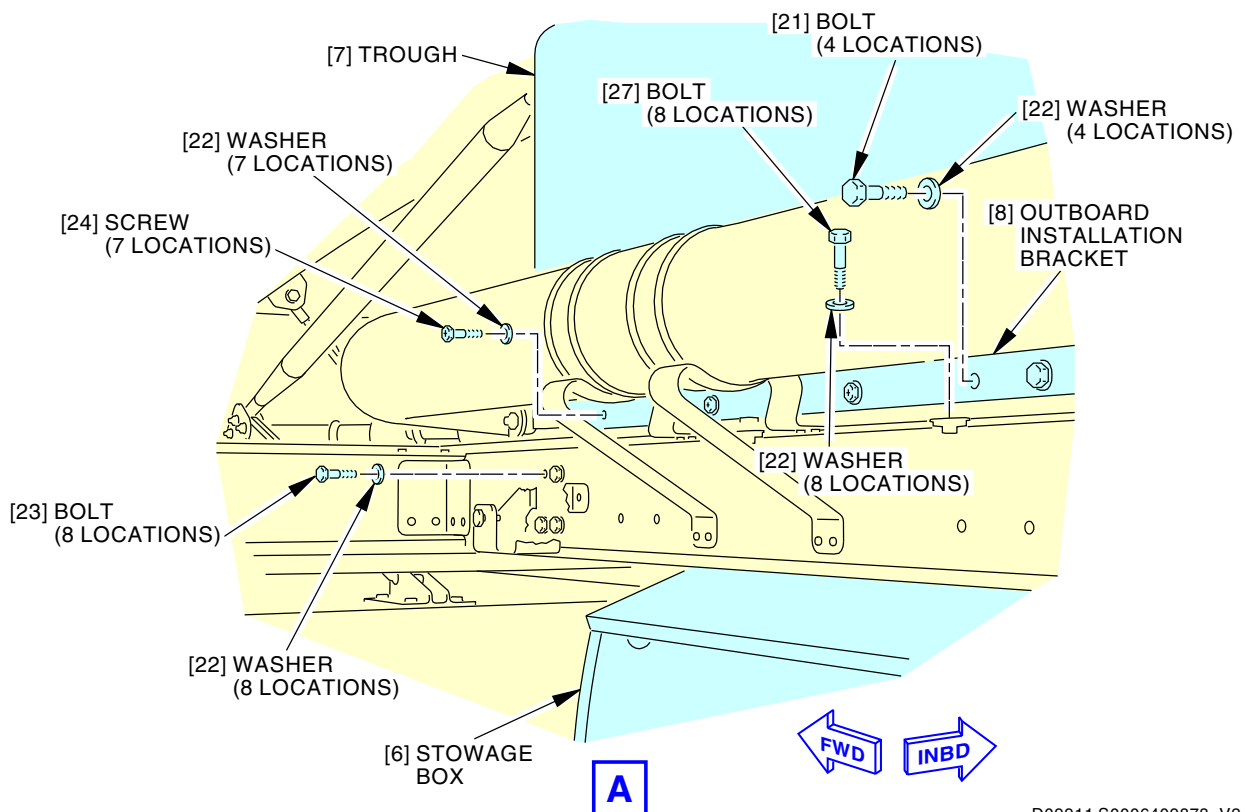
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Page 405
Jan 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL



**PASSENGER COMPARTMENT
(EXAMPLE)**



D09911 S0006409878_V2

**Overhead Stowage Box Module Installation
Figure 402/25-28-07-990-802 (Sheet 1 of 2)**

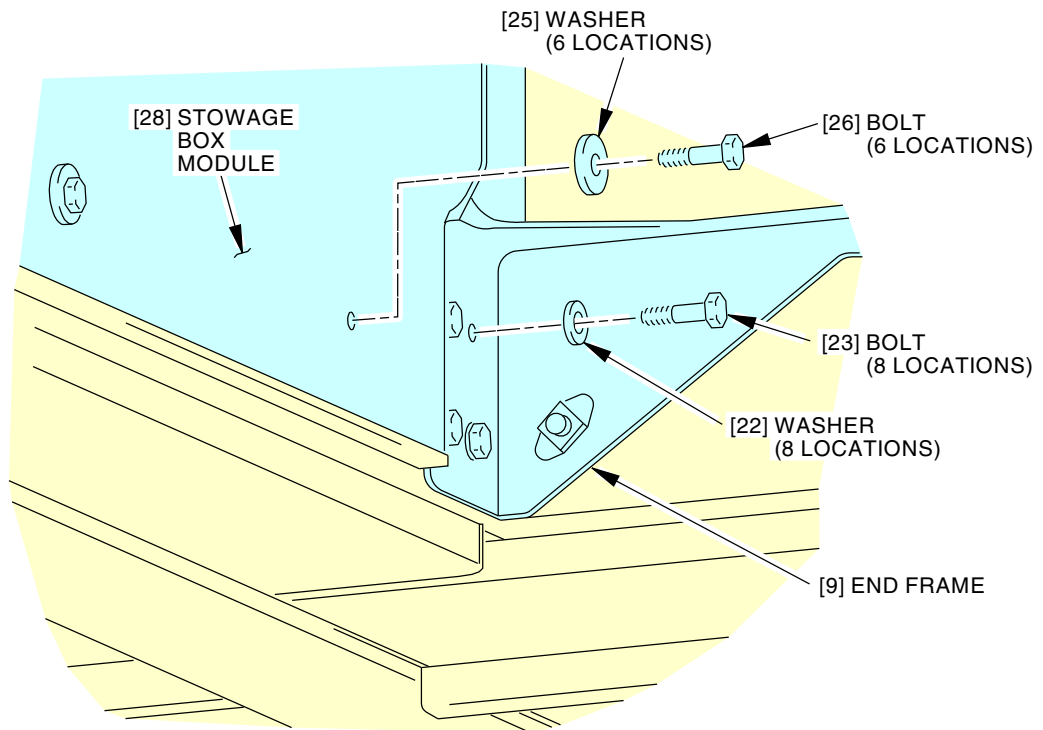
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25-28-07

D633W101-ARO

Page 406
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



B

D09906 S0006409879_V2

Overhead Stowage Box Module Installation
Figure 402/25-28-07-990-802 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

25-28-07

D633W101-ARO

Page 407
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

CREW REST/ATTENDANT REST DOOR LATCH - REMOVAL/INSTALLATION

1. General

- A. This procedure is for all crew rest/attendant rest door installations with key locks.
- B. The strike plate may be either floor mounted or top mounted.



DO NOT ATTEMPT TO DISASSEMBLE LATCH ASSEMBLIES FOR THE PURPOSE OF REPAIRING IT ON-AIRCRAFT. DISASSEMBLE ONLY AS REQUIRED TO REMOVE AND REPLACE THE PART(S). THE ASSEMBLIES ARE TO BE REPLACED IN THEIR ENTIRETY, WITH THE REMOVED ASSEMBLIES SENT TO THE HOME SHOP FOR ANALYSIS AND DISPOSITION. LATCH ASSEMBLIES ARE RECOVERABLE AND TAMPERING WITH THEIR CONSTRUCTION WILL VIOLATE WARRANTY COVERAGE.

- C. This procedure has these tasks.
 - (1) Keyed Crew Rest Door/Attendant Rest Door Latch Removal.
 - (2) Keyed Crew Rest Door/Attendant Rest Door Latch Installation.

TASK 25-29-01-000-801

2. Keyed Crew Rest/Attendant Rest Door Latch Removal

(Figure 401)

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Crew Rest/Attendant Rest Door Latch Removal Procedure

SUBTASK 25-29-01-020-001

- (1) Do these steps to remove the door handle:
 - (a) Open the crew rest/attendant rest door to gain access to the inner side and outer side handle assemblies.
 - (b) Secure both the inner side and outer side door handle assemblies [12] and [8] in place.
 - (c) Do these steps to loosen the screws [7] on the side handle assembly [8]:
 - 1) Remove the plug [2] from the knob [5].
 - 2) Remove the screw [3] and washer [4] from the knob [5].
 - 3) Remove the knob [5].
 - 4) Remove the cover [6].
 - 5) Loosen the screws [7].

NOTE: Do not remove the screws [7] from the handle assembly [8].
 - (d) Remove the inner side handle assembly [8], screws [7] and spacers [11] from the door [1].

NOTE: Some doors may not have spacers [3] between the inner and outer door handle.

 - 1) Replace the handle assembly [8] if it is necessary.
 - (e) Remove the outer side handle assembly [12] from the door [1].
 - 1) Replace the handle assembly [12] if it is necessary.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-29-01

Page 401
May 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-29-01-020-002

- (2) Do these steps to disconnect and remove the door latch assembly [9]:

NOTE: Some door assemblies have the latch and rod assemblies at the top of the door and others at the bottom.

- (a) Remove the screws [17] and cover [18] from the latch mechanism.
- (b) Remove the locknut [14] from the bottom end of the rod assembly [10].
- (c) Remove the screws [16] from the lower latch assembly [9].
- (d) Remove the lower latch assembly [9].

SUBTASK 25-29-01-020-003

- (3) Do these steps to remove the rod assembly [10]:

- (a) Remove the crew rest/attendant rest door [1] if necessary.
- (b) Remove the rod assembly [10].

- 1) Before you remove the rod, mark the rod where the rod meets the lock nut.

NOTE: The exposed threads of the rod length should be 2 to 4 threads past the lock nut.

————— **END OF TASK** —————

TASK 25-29-01-400-802

3. Keyed Crew Rest/Attendant Rest Door Latch Installation

(Figure 401)

A. References

Reference	Title
25-29-01-700-801	Crew / Attendant Rest Door Latch Adjustment (P/B 501)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Crew Rest/Attendant Rest Door Latch Installation Procedure

SUBTASK 25-29-01-420-001

- (1) Do these steps to install the rod assembly [10]:

NOTE: Some entry doors have the latch and rod assembly the top of the door, and others at the bottom.

- (a) Remove the door [1] if it is necessary.
- (b) Install the rod assembly [10].

SUBTASK 25-29-01-420-002

- (2) Do these steps to install the door latch assembly [9]:

- (a) Put the latch assembly [9] in the correct position.
- (b) Put the rod assembly [10] through the adjustment plate [13].
- (c) Install the latch assembly [9] with the screws [16].
- (d) Install the nut [14] on the rod assembly [10].

NOTE: The exposed thread of the rod length should be 2 to 4 threads past the lock nut.

SUBTASK 25-29-01-420-003

- (3) Do these steps to install the handle assemblies [12] and [8]:

EFFECTIVITY
ARO ALL

25-29-01

D633W101-ARO

Page 402
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (a) Put the inner side handle assembly [8] in the door [1].
NOTE: This step must be done at the same time as the next step.
- (b) Put the pin on the rod assembly [10] in the hole on the inner side handle assembly [8].
- (c) Put the screws [7] in the handle assembly [8].
- (d) Put the spacers [11] on the screws [7] if necessary.
- (e) Put the handle assembly [12] in the correct position.
- (f) Tighten the screws [7].
- (g) Do these steps to install the knob [5] on the handle assembly [8]:
 - 1) Put the cover [6] on the handle assembly [8].
 - 2) Install the knob [5] on the handle assembly [8] with the screw [3] and washer [4].
 - 3) Install the plug [2] in the knob [5].

SUBTASK 25-29-01-420-004

- (4) Install the crew rest/attendant rest door [1] if previously removed.

SUBTASK 25-29-01-820-024

- (5) Adjust the latch assembly [9].
 - (a) Do this task: Crew / Attendant Rest Door Latch Adjustment, TASK 25-29-01-700-801

SUBTASK 25-29-01-420-005

- (6) Install the cover [18] with screws [17].

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

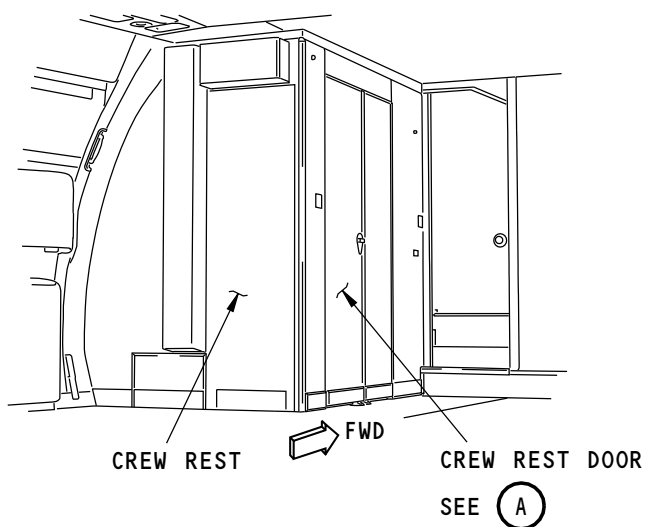
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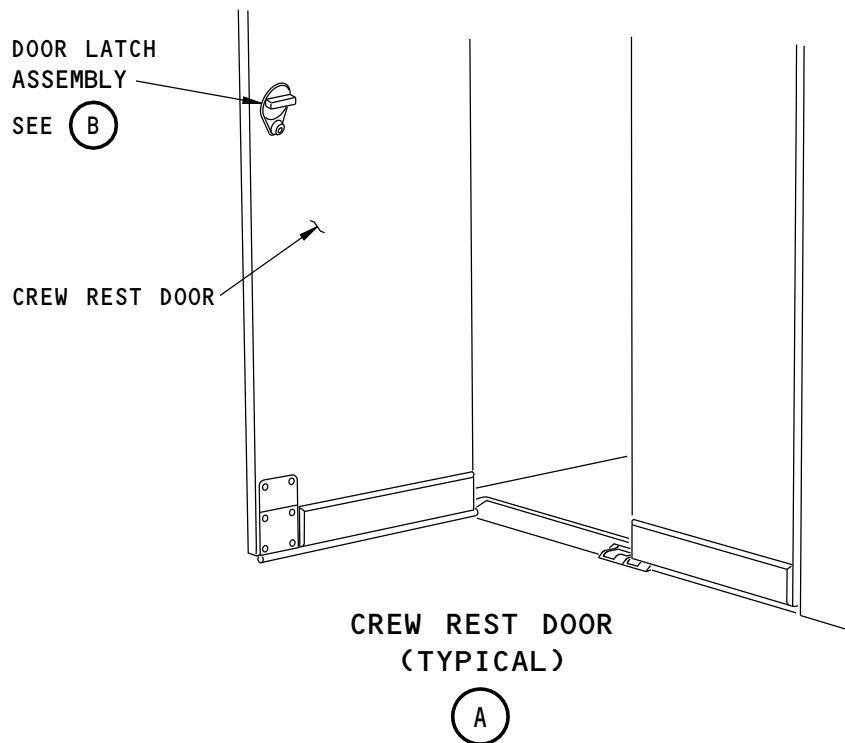
Page 403
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL



FLIGHT CREW REST
(TYPICAL)



M51973 S0006409893_V2

Keyed Crew Rest/Attendant Rest Door Latch Installation
Figure 401/25-29-01-990-801 (Sheet 1 of 3)

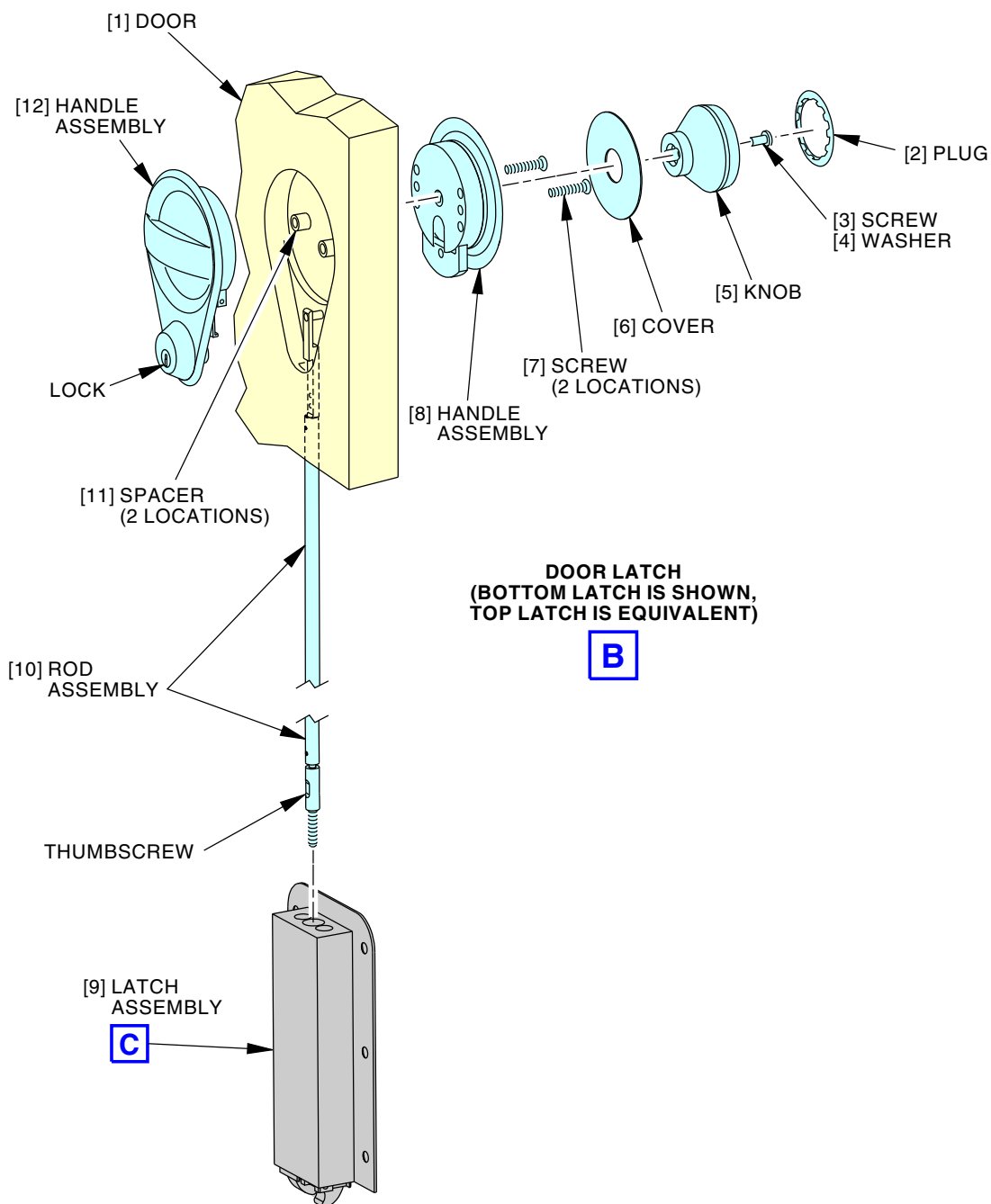
EFFECTIVITY
ARO ALL

D633W101-ARO

25-29-01

Page 404
Jan 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



M51969 S0006409894_V4

**Keyed Crew Rest/Attendant Rest Door Latch Installation
Figure 401/25-29-01-990-801 (Sheet 2 of 3)**

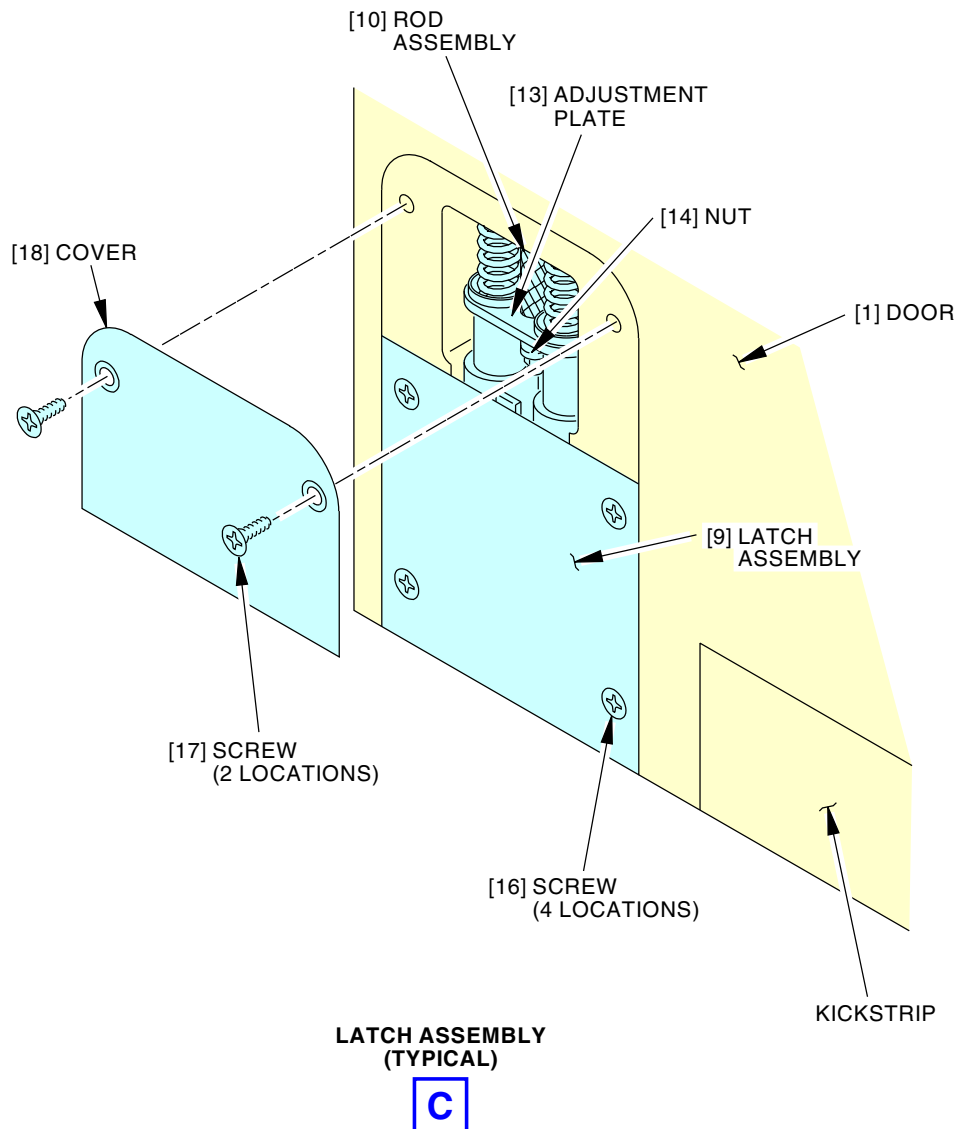
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ARO ALL

25-29-01

D633W101-ARO

Page 405
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



W61972 S0000126850_V4

Keyed Crew Rest/Attendant Rest Door Latch Installation
Figure 401/25-29-01-990-801 (Sheet 3 of 3)

EFFECTIVITY
ARO ALL

25-29-01

D633W101-ARO

Page 406
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

CREW/ATTENDANT REST DOOR LATCH - ADJUSTMENT/TEST

1. General

- A. This section contains the procedure to adjust the crew or attendant rest door latches at the bottom or top of the door.
- B. There are these types of strike plates:
 - (1) Disk type: This type of strike plate has a round disk shaped fitting that is mounted to the airplane floor.
 - (2) Ramp type: This type of strike plate has a triangle (ramp) shaped fitting that is mounted to crew rest module.

TASK 25-29-01-700-801

2. Crew / Attendant Rest Door Latch Adjustment

(Figure 501)

A. Location Zones

<u>Zone</u>	<u>Area</u>
200	Upper Half of Fuselage

B. Door Latch Adjustment

SUBTASK 25-29-01-700-001

- (1) Do these steps to adjust the door latch height:

NOTE: The door latch assembly may be at the top or bottom of the door. The adjustment procedure is the same for either location.

- (a) Remove the coverplate with two retaining screws from the latch assembly.
- (b) Adjust the tube assemblies [4] until they are flush with the edge of the door.

NOTE: The edge of the door does not include the trim that is installed.

- 1) Loosen the lock nut [1].
- 2) Turn thumb screw [2] as necessary to adjust tube assemblies [4].
- 3) Tighten the lock nut [1].

NOTE: Hold the thumb screw [2] in position to prevent binding of the latch assembly

- (c) Make sure the springs [3] are installed.
- (d) Make sure that the adjustment plate is square in the latch assembly.
- (e) Install the coverplate on the latch mechanism.

SUBTASK 25-29-01-700-003

- (2) Do these steps to adjust the disk type strike plate:

NOTE: This type of strike plate consists of a round disk fitting, mounted directly to the airplane floor structure. This type of strike plate uses shims for adjustment.

- (a) Do these steps to adjust the strike plate height.
 - 1) Adjust the strike plate shims to provide 0.20 ±0.03 in. (5.08 ±0.76 mm) gap between the top of the strike plate and bottom edge of the door.
- (b) Do these steps to install and adjust the door strike position:

EFFECTIVITY
ARO ALL

25-29-01

D633W101-ARO

Page 501
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 1) loosely install the strike plate and shims with one bolt.

NOTE: Tighten bolt sufficiently to prevent free motion of the strike plate, but sufficiently loose to permit turning of the strike plate with moderate force.

- a) Loosely install the second bolt in the strike plate.
 - b) Turn the strike plate until the two vertical faces of the strike plate touch the door latch pawls when the door is in engaged in the strike plate.
 - c) Tighten the bolts.
- 2) Install the door sill.

SUBTASK 25-29-01-700-004

- (3) Do these steps to adjust the ramp type strike plate [7]:

NOTE: The ramp type of strike plate is installed at the monument structure and is used to hold the door in the closed position.

- (a) Loosely install strike mount [8] with screws [9].
- (b) Loosely install strike plate [7] on mount [8] with screws [5] and washers [6].
- (c) Adjust the strike to provide 0.20 ± 0.03 in. (5.08 ± 0.76 mm) gap between the top face of the strike plate and the door.
- (d) Elongate the mount angle and strike plate holes as necessary.

NOTE: Shims may be used to achieve this adjustment.

- 1) For bottom latches, cut the carpet as necessary to provide clearance to the door and the strike plate.
- (e) Tighten the screws [5], [9].
 - (f) Install the door sill if it was removed.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

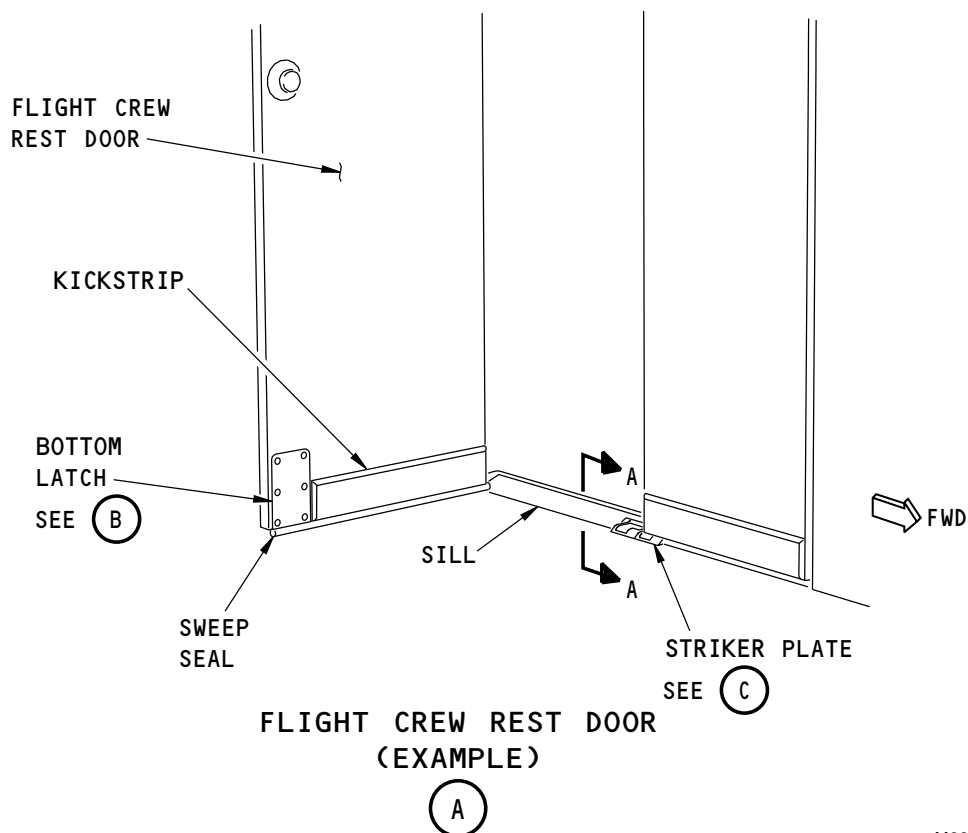
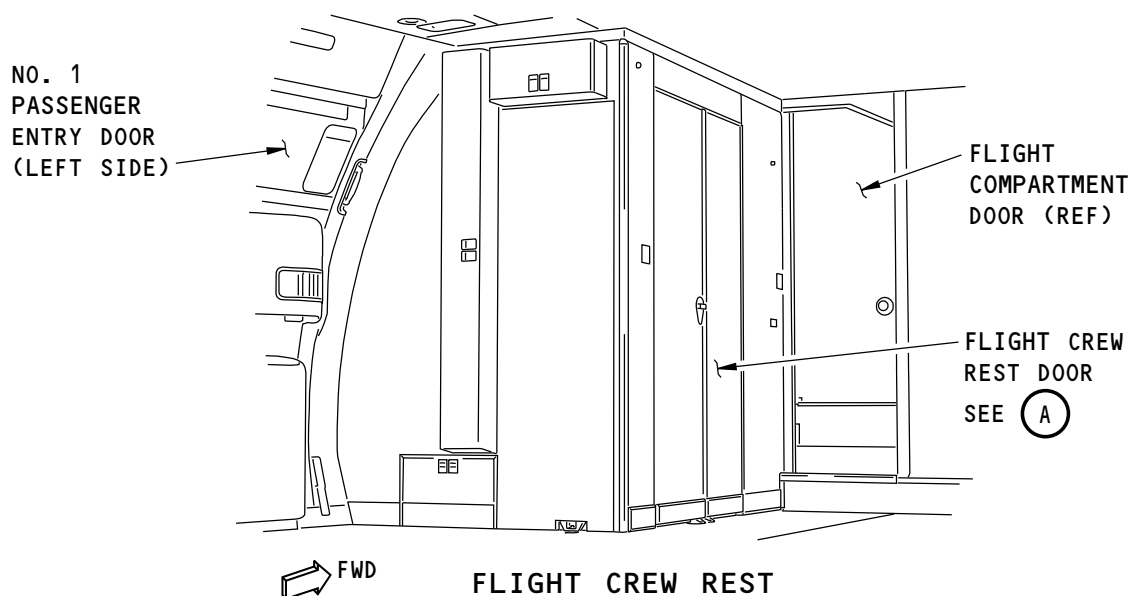
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D633W101-ARO

Page 502
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL



M28924 S0006409912_V3

Crew Rest Door Adjustment
Figure 501/25-29-01-990-803 (Sheet 1 of 3)

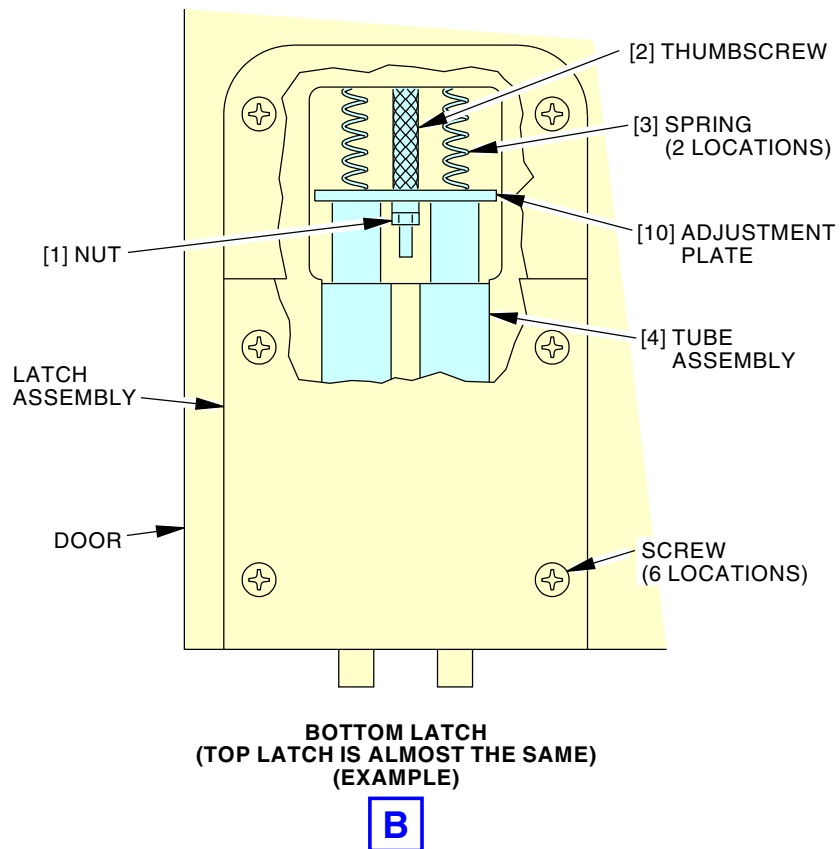
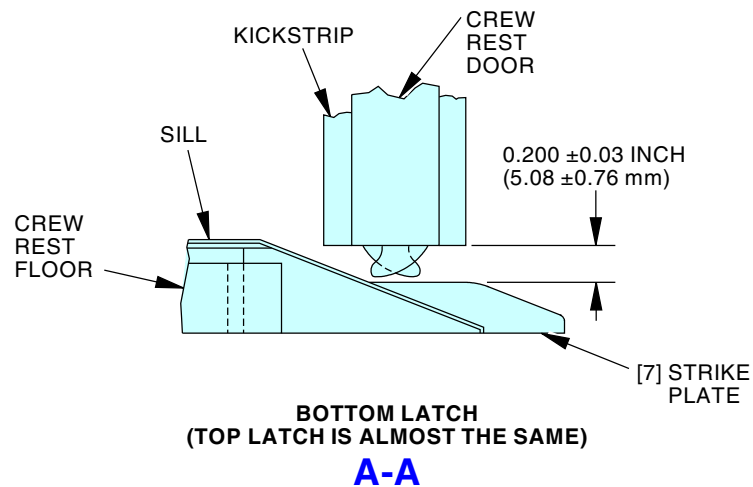
EFFECTIVITY
ARO ALL

25-29-01

D633W101-ARO

Page 503
Jan 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



M29708 S0006409913_V5

**Crew Rest Door Adjustment
Figure 501/25-29-01-990-803 (Sheet 2 of 3)**

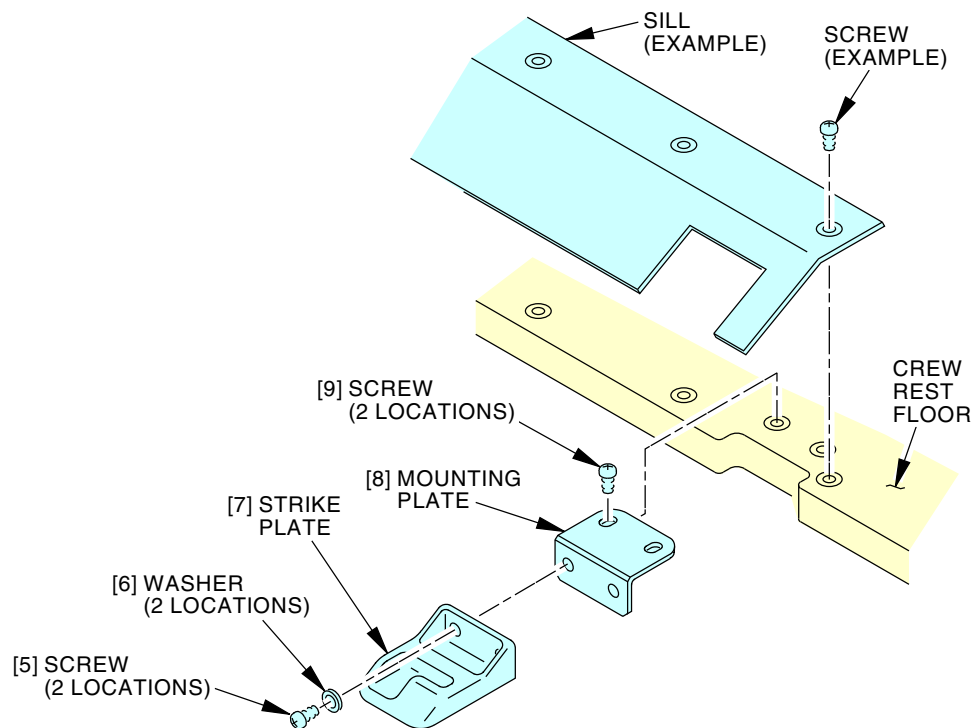
EFFECTIVITY
ARO ALL

D633W101-ARO

25-29-01

Page 504
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



FLOOR STRIKER PLATE
(TOP STRIKER PLATE IS ALMOST THE SAME)
(EXAMPLE)

C

M29819 S0006409914_V3

Crew Rest Door Adjustment
Figure 501/25-29-01-990-803 (Sheet 3 of 3)

EFFECTIVITY
ARO ALL

25-29-01

D633W101-ARO

Page 505
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

DOOR 1 LEFT FLIGHT CREW REST - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Flight Crew Rest Removal.
 - (2) Flight Crew Rest Installation.
 - (3) Flight Crew Rest Disassemble
 - (4) Flight Crew Rest Assemble

TASK 25-29-03-000-801

2. Flight Crew Rest Removal

(Figure 401)

A. **References**

Reference	Title
25-21-02-000-801	Doorway Lining Removal (P/B 401)
25-21-06-000-801	Main Ceiling Panel - Removal (P/B 401)
25-21-07-000-801	Lowered Ceiling Panel Removal (P/B 401)
25-25-01-000-801	Passenger Seat - Removal (P/B 401)
25-25-06-000-801	Attendant Seat Removal (P/B 401)
25-25-06-000-802	Attendant Seat Removal (P/B 401)
25-25-06-000-806	Attendant Seat Removal (P/B 401)
25-31-01-000-821	Forward Fixed Galley Removal (P/B 401)
25-31-03-000-804	Aft Fixed Galley Removal (P/B 401)
35-21-07-000-804	Flight Crew Rest Oxygen Box Removal (P/B 401)

B. **Location Zones**

Zone	Area
221	Passenger Compartment, Left - Section 41

C. **Prepare for the Removal**

SUBTASK 25-29-03-010-001

- (1) Open these circuit breakers and install safety tags:

Left Power Management Panel, P110

Row	Col	Number	Name
A	15	C23437	OEU ZONE1 MAIN BUS
F	2	C23439	OEU ZONE1 XFER BUS
J	26	C26621	LAV SMOKE DETECT-L

Standby Power Management Panel, P310

Row	Col	Number	Name
A	3	C35403	L PAX OXY
A	5	C35404	R PAX OXY
H	4	C35607	CHAN B OXY DEPLOY

SUBTASK 25-29-03-860-001

- (2) If necessary, do this task: Doorway Lining Removal, TASK 25-21-02-000-801.

EFFECTIVITY
ARO ALL

25-29-03

D633W101-ARO

Page 401
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-29-03-860-002

- (3) If necessary, do this task: Main Ceiling Panel - Removal, TASK 25-21-06-000-801.

SUBTASK 25-29-03-860-003

- (4) If necessary, do this task: Lowered Ceiling Panel Removal, TASK 25-21-07-000-801.

SUBTASK 25-29-03-860-004

- (5) If necessary, do this task: Attendant Seat Removal, TASK 25-25-06-000-801 or Attendant Seat Removal, TASK 25-25-06-000-802 or Attendant Seat Removal, TASK 25-25-06-000-806.

SUBTASK 25-29-03-860-005

- (6) If necessary, do this task: Passenger Seat - Removal, TASK 25-25-01-000-801.

SUBTASK 25-29-03-860-006

- (7) If necessary, do this task: Forward Fixed Galley Removal, TASK 25-31-01-000-821.

SUBTASK 25-29-03-860-021

- (8) If necessary, do this task: Aft Fixed Galley Removal, TASK 25-31-03-000-804

SUBTASK 25-29-03-020-001

- (9) Remove the upper bunk, the lower bunk and the loose equipment from the flight crew rest [1].

SUBTASK 25-29-03-020-002

- (10) Remove the stowage drawer [34].

D. Remove the Flight Crew Rest

SUBTASK 25-29-03-010-002

- (1) Disconnect the electrical connectors [20].
- (a) If the emergency lights come ON, quickly install a jumper wire between pins 8 and 20 of the electrical connector D6310P.

NOTE: Make sure the emergency lights go OFF. Do this step in less than one minute to keep the batteries sufficiently charged to operate the emergency lights.

SUBTASK 25-29-03-010-003

- (2) Disconnect the applicable duct [18] and duct [19].

SUBTASK 25-29-03-010-014

- (3) Disconnect the oxygen box, do this task: Flight Crew Rest Oxygen Box Removal, TASK 35-21-07-000-804.

SUBTASK 25-29-03-010-005

- (4) Disconnect the rear tie rod assembly:
- (a) Remove the bolt [40], washer [41], washer [43], bushing [42], and nut [44].
- (b) Remove the bolt [24], washer [22], washer [23] and nut [21].
- (c) Remove the clips [45], washers [46], and pins [47].
- (d) Retain the fittings for installation.

SUBTASK 25-29-03-010-006

- (5) Disconnect the forward tie rod [31].
- (a) Do these steps to disconnect the upper and the lower tie rod [31] attachment:
- 1) Remove the bolt [29], washer [30], washer [32], bushing [28], and nut [33].
- 2) Retain the fittings for installation.

SUBTASK 25-29-03-860-007

- (6) Do these steps to disconnect the bottom of the Flight Crew Rest:

EFFECTIVITY
ARO ALL

25-29-03

D633W101-ARO

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Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Remove the screws [38] for the threshold [37].
- (b) FOR AIRPLANES WITH FLOOR ATTACH FITTINGS; remove the screws [6], cover plate [5], bolts [3], washers [4], shims [2], cylindrical nuts [39], and radius filler [7].
- (c) Remove the cover plate or the kickstrip [8] to access the seat track fitting [10] of the flight crew rest [1].
- (d) Remove the bolt [14], filler [13], washer [12], fitting [11], and seat track fitting [10].
 - 1) Mark the location of the seat track fitting.
- (e) Remove the bulk head bolts [16] and sleeve [17].
- (f) Retain the fittings for installation.

SUBTASK 25-29-03-020-003

- (7) Remove the flight crew rest [1].

————— END OF TASK —————

TASK 25-29-03-400-801

3. Flight Crew Rest Installation

(Figure 401)

A. References

Reference	Title
25-21-02-400-801	Doorway Lining Installation (P/B 401)
25-21-06-400-801	Main Ceiling Panel - Installation (P/B 401)
25-21-07-400-801	Lowered Ceiling Panel Installation (P/B 401)
25-25-01-400-801	Passenger Seat - Installation (P/B 401)
25-25-06-400-801	Attendant Seat Installation (P/B 401)
25-25-06-400-802	Attendant Seat Installation (P/B 401)
25-25-06-400-806	Attendant Seat Installation (P/B 401)
25-31-01-400-821	Forward Fixed Galley Installation (P/B 401)
25-31-03-400-804	Aft Fixed Galley Installation (P/B 401)
33-29-00-710-812	Flight Crew Rest (FCR) Lights - Operational Test (P/B 501)
35-21-00-710-801	Oxygen Box Door Latch/Actuator Operational Test (P/B 501)
35-21-07-400-804	Flight Crew Rest Oxygen Box Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
G02304	Tape - Moisture Barrier, Adhesive One-side	BMS8-346

C. Location Zones

Zone	Area
221	Passenger Compartment, Left - Section 41

D. Prepare for the Installation.

SUBTASK 25-29-03-820-001

- (1) Do these steps if it is necessary to install the seat track fitting [10]:
 - (a) Remove the old moisture barrier tape, G02304 from the wet areas to install the seat track fitting [10].

EFFECTIVITY
ARO ALL

25-29-03

D633W101-ARO

Page 403
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (b) Put the seat track fitting [10], in the circular opening in the seat track [9].
- (c) Move the seat track fitting [10] forward or aft 1/2 inch to lock it in the correct position that was marked during the removal.
- (d) Do these steps in the wet areas to prevent corrosion:
 - 1) Put corrosion preventive compound, C00308 in the seat track [9] around the seat track fitting [10].
 - 2) Apply new moisture barrier tape, G02304 with a cutout for the seat track fitting [10] if it is necessary.
 - 3) Install the flat washer [12], and the machined fitting [11] to the seat track fitting [10].

E. Procedure

SUBTASK 25-29-03-420-001

- (1) Put the flight crew rest [1] in position.

SUBTASK 25-29-03-820-002

- (2) FOR AIRPLANES WITH FLOOR ATTACH FITTINGS; align the floor attach fitting with the flight crew rest [1].
 - (a) Install the bolts [3], washers [4], shims [2], cylindrical nuts [39], radius filler [7] for the floor attach fitting.
 - (b) Attach the plate [5] and the screws [6].

SUBTASK 25-29-03-410-001

- (3) Install the bolt [14] and the filler [13] to the seat track fitting [10].

SUBTASK 25-29-03-410-002

- (4) Install the cover plate or the kickstrip [8].

SUBTASK 25-29-03-420-002

- (5) Install the sleeves [17] and the bolts [16] into the bulk head.

SUBTASK 25-29-03-420-003

- (6) Install the screws [38] in the threshold [37].

SUBTASK 25-29-03-420-004

- (7) Connect the forward tie rod [31].
 - (a) Install the bolt [29], washer [30], washer [32], bushing [28], and nut [33].

SUBTASK 25-29-03-420-005

- (8) Connect the rear tie rod assembly:
 - (a) Install the clips [45], washers [46] and pins [47].
 - (b) Install the bolt [40], washer [41], washer [43], bushing [42] and nut [44].
 - (c) Install the bolt [24], washer [22], washer [23] and nut [21].

SUBTASK 25-29-03-420-013

- (9) Connect the oxygen box, do this task: Flight Crew Rest Oxygen Box Installation, TASK 35-21-07-400-804.

SUBTASK 25-29-03-420-007

- (10) Connect the applicable duct [18] and duct [19].

SUBTASK 25-29-03-860-008

- (11) Connect the electrical connectors [20].

EFFECTIVITY
ARO ALL

25-29-03

D633W101-ARO

Page 404
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Remove the jumper wire from the electrical connector.

NOTE: The emergency lights will come ON.

- (b) Quickly connect the electrical connector.

NOTE: Do this step in less than one minute to keep the batteries sufficiently charged to operate the emergency lights.

F. Put the Airplane Back to its Usual Condition.

SUBTASK 25-29-03-960-001

- (1) Install the upper bunk, the lower bunk and the loose equipment that was removed from the flight crew rest [1].

SUBTASK 25-29-03-410-003

- (2) Replace the stowage drawer [34].

SUBTASK 25-29-03-010-007

- (3) Remove the safety tags and close these circuit breakers:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	15	C23437	OEU ZONE1 MAIN BUS
F	2	C23439	OEU ZONE1 XFER BUS
J	26	C26621	LAV SMOKE DETECT-L

Standby Power Management Panel, P310

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	3	C35403	L PAX OXY
A	5	C35404	R PAX OXY
H	4	C35607	CHAN B OXY DEPLOY

SUBTASK 25-29-03-860-009

- (4) If necessary, do this task: Doorway Lining Installation, TASK 25-21-02-400-801.

SUBTASK 25-29-03-860-010

- (5) If necessary, do this task: Main Ceiling Panel - Installation, TASK 25-21-06-400-801.

SUBTASK 25-29-03-860-011

- (6) If necessary, do this task: Lowered Ceiling Panel Installation, TASK 25-21-07-400-801.

SUBTASK 25-29-03-860-012

- (7) If necessary, do this task: Attendant Seat Installation, TASK 25-25-06-400-801 or Attendant Seat Installation, TASK 25-25-06-400-802 or Attendant Seat Installation, TASK 25-25-06-400-806.

SUBTASK 25-29-03-860-013

- (8) If necessary, do this task: Passenger Seat - Installation, TASK 25-25-01-400-801.

SUBTASK 25-29-03-860-014

- (9) If necessary, do this task: Forward Fixed Galley Installation, TASK 25-31-01-400-821 or Aft Fixed Galley Installation, TASK 25-31-03-400-804.

SUBTASK 25-29-03-410-004

- (10) Make sure the electrical components in the Crew Rest operate correctly.
- (a) For the lights, do this task: Flight Crew Rest (FCR) Lights - Operational Test, TASK 33-29-00-710-812.

EFFECTIVITY
ARO ALL

25-29-03

D633W101-ARO

Page 405
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (b) Do a check of a cabin interphone handset or jack if installed in or on the FCR.
- (c) Do a check that all outlets and ports are operable.
- (d) Do this task: Oxygen Box Door Latch/Actuator Operational Test, TASK 35-21-00-710-801.

————— **END OF TASK** —————

TASK 25-29-03-000-802

4. Flight Crew Rest Disassemble

(Figure 402)

A. Location Zones

Zone	Area

221	Passenger Compartment, Left - Section 41

B. Do these steps to remove the flight crew rest from the airplane.

SUBTASK 25-29-03-020-004

- (1) Do these steps to remove the top panel [50] of the flight crew rest [1]:
 - (a) Remove the bolts [60] and washers [61] from the forward bracket [59].
 - (b) Support the top panel [50] of the flight crew rest [1].
 - (c) Remove the bolts [58] from the perimeter of the top panel [50].
 - (d) Remove the top panel [50].

SUBTASK 25-29-03-020-005

- (2) Do these steps to remove the aft panel [55] of the flight crew rest [1]:
 - (a) Remove the corner trim on the flight crew rest [1].
 - 1) Remove the rub strip [64].
 - 2) Remove the cap [62].
 - 3) Remove the corner trim holder [63].
 - a) Remove the screws [65].
 - (b) Remove the bolts [67] from the outboard, inboard, and bottom edges of the aft panel [55].
 - (c) Remove the aft panel [55].

SUBTASK 25-29-03-020-006

- (3) Do these steps to remove the inboard panel [52] of the flight crew rest:
 - (a) Remove the doors [54] from the inboard panel [52].
 - (b) Remove the bolts [68] from the inboard panel [52].
 - (c) Remove the inboard panel [52].

SUBTASK 25-29-03-020-007

- (4) Do these steps to remove the outboard top panel [57] of the flight crew rest:
 - (a) Remove the bolts [70] from the outboard top panel [57] and the upper bunk bracket [71].
 - (b) Remove the bolts [69] where the forward panel [51] attaches to the outboard top panel [57].
 - (c) Remove the outboard top panel [57].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-29-03

Page 406
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-29-03-020-008

- (5) Remove the outboard bottom panel [56], forward panel [51], and floor panel [53] of the flight crew rest [1] from the airplane.

————— END OF TASK —————

TASK 25-29-03-400-802

5. Flight Crew Rest Assemble

(Figure 402)

A. Location Zones

Zone	Area
221	Passenger Compartment, Left - Section 41

B. Prepare to assemble the flight crew rest.

SUBTASK 25-29-03-980-001

- (1) Make sure the correct amount of clearance is available to assemble the flight crew rest [1].

C. Do these steps to assemble the flight crew rest [1].

NOTE: The flight crew rest must be assembled on the airplane.

SUBTASK 25-29-03-410-005

- (1) Assemble the outboard bottom panel [56], forward panel [51], and floor panel [53] of the flight crew rest [1].

SUBTASK 25-29-03-410-006

- (2) Do these steps to install the outboard top panel [57] of the flight crew rest:
 - (a) Install the outboard top panel [57].
 - (b) Install the bolts [70] in the outboard top panel [57] and the upper bunk bracket [71].
 - (c) Install the bolts [69] where the forward panel [51] attaches to the outboard top panel [57].

SUBTASK 25-29-03-020-009

- (3) Do these steps to install the inboard panel [52] of the flight crew rest:
 - (a) Install the inboard panel [52].
 - (b) Install the bolts [68] in the inboard panel [52].
 - (c) Install the doors [54] in the inboard panel [52].

SUBTASK 25-29-03-020-010

- (4) Do these steps to install the aft panel [55] of the flight crew rest [1]:
 - (a) Install the aft panel [55].
 - (b) Install the bolts [67] in the outboard, inboard, and bottom edges of the aft panel [55].
 - (c) Install the corner trim on the flight crew rest [1].
 - 1) Install the corner trim holder [63].
 - a) Install the screws [65].
 - 2) Install the rub strip [64].
 - 3) Install the cap [62].

SUBTASK 25-29-03-020-011

- (5) Do these steps to install the top panel [50] of the flight crew rest [1]:
 - (a) Install the top panel [50].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-29-03

Page 407
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (b) Support the top panel [50] of the flight crew rest [1].
- (c) Install the bolts [58] in the perimeter of the top panel [50].
- (d) Install the bolts [60] and washers [61] in the forward bracket [59].

———— **END OF TASK** ————

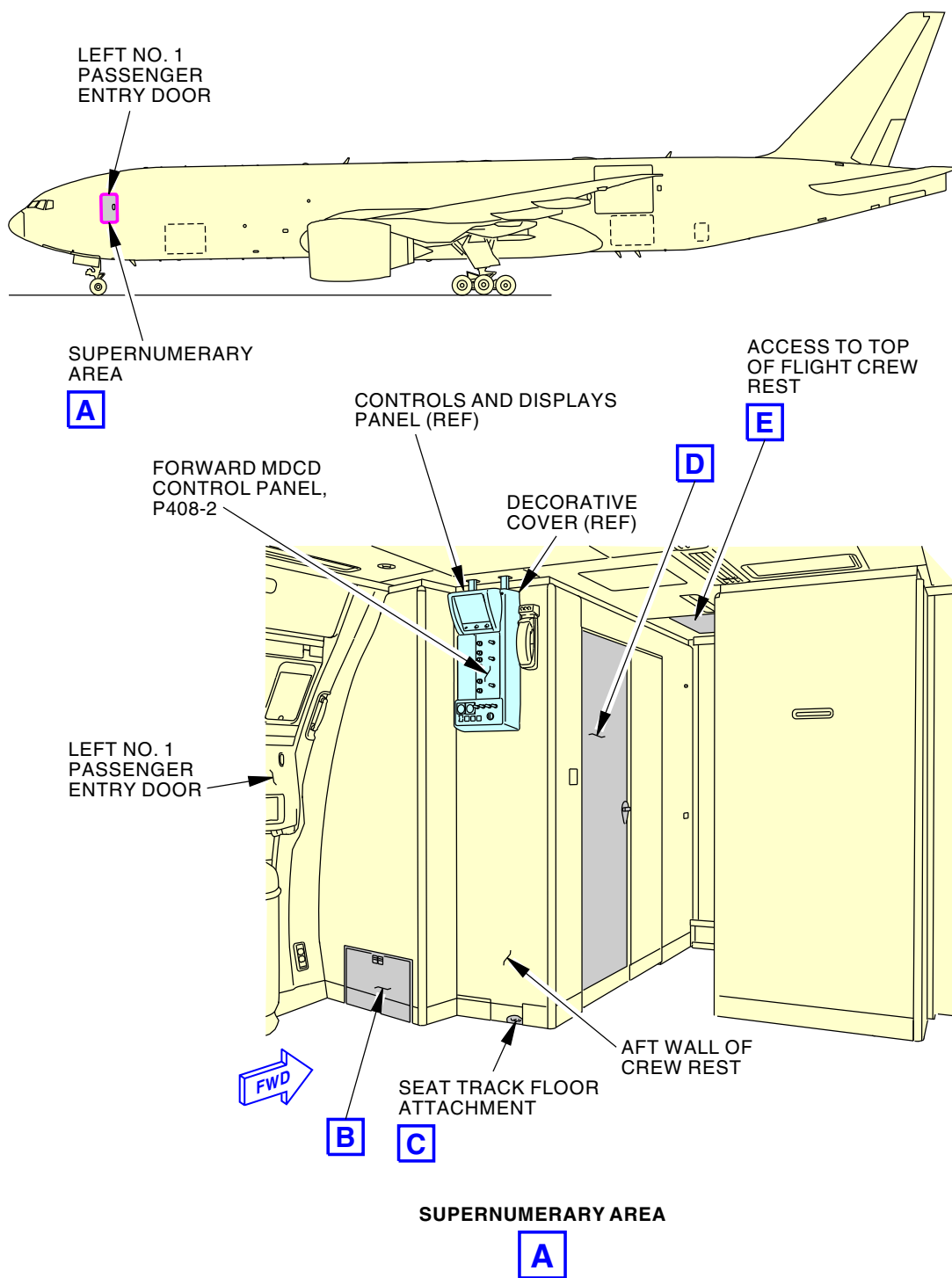
EFFECTIVITY
ARO ALL

D633W101-ARO

25-29-03

Page 408
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



1551018 S0000285195_V3

Flight Crew Rest Installation
Figure 401/25-29-03-990-801 (Sheet 1 of 5)

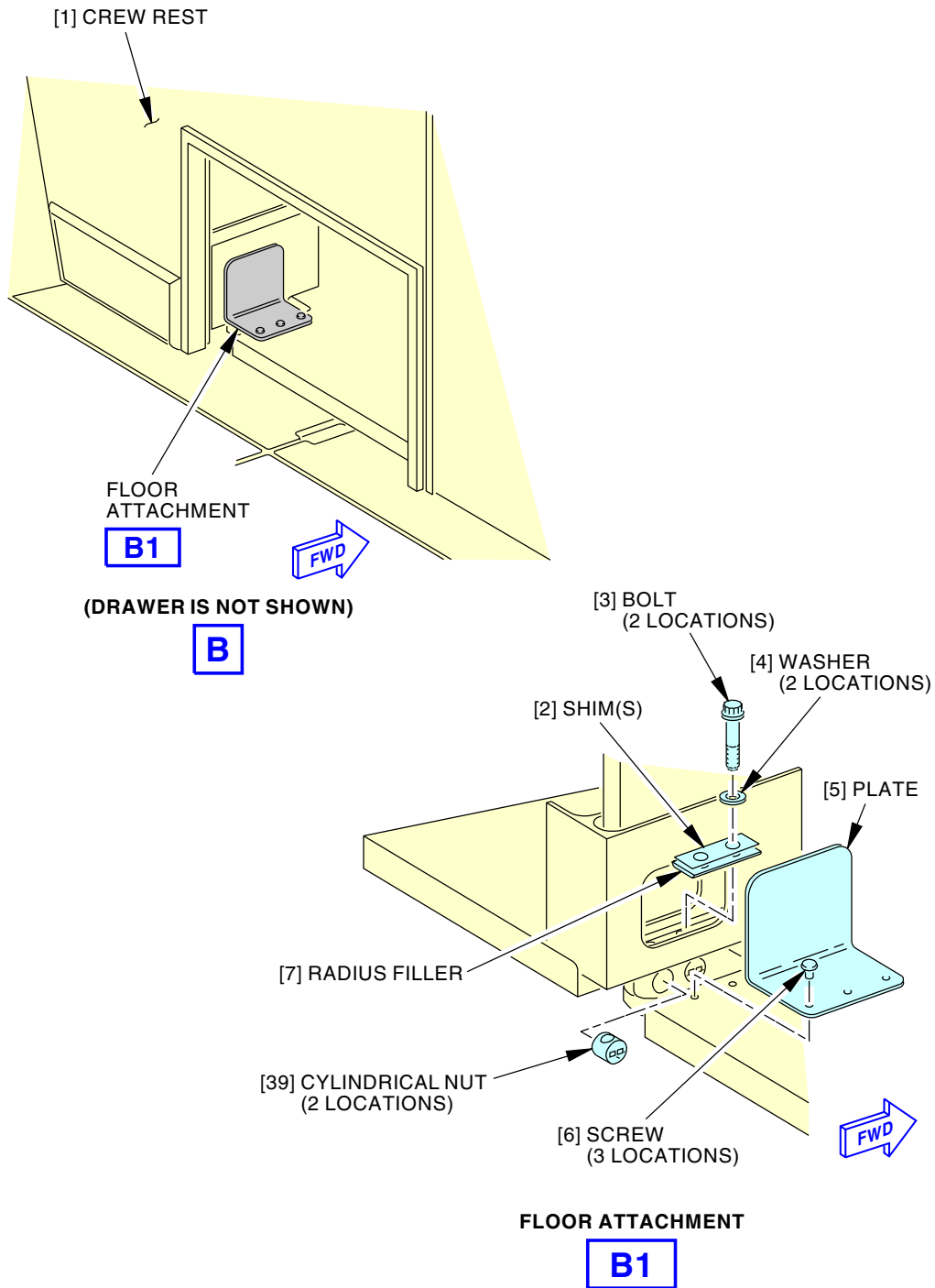
EFFECTIVITY
ARO ALL

25-29-03

D633W101-ARO

Page 409
Jan 05/2018

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



H86451 S0006409901_V3

Flight Crew Rest Installation
Figure 401/25-29-03-990-801 (Sheet 2 of 5)

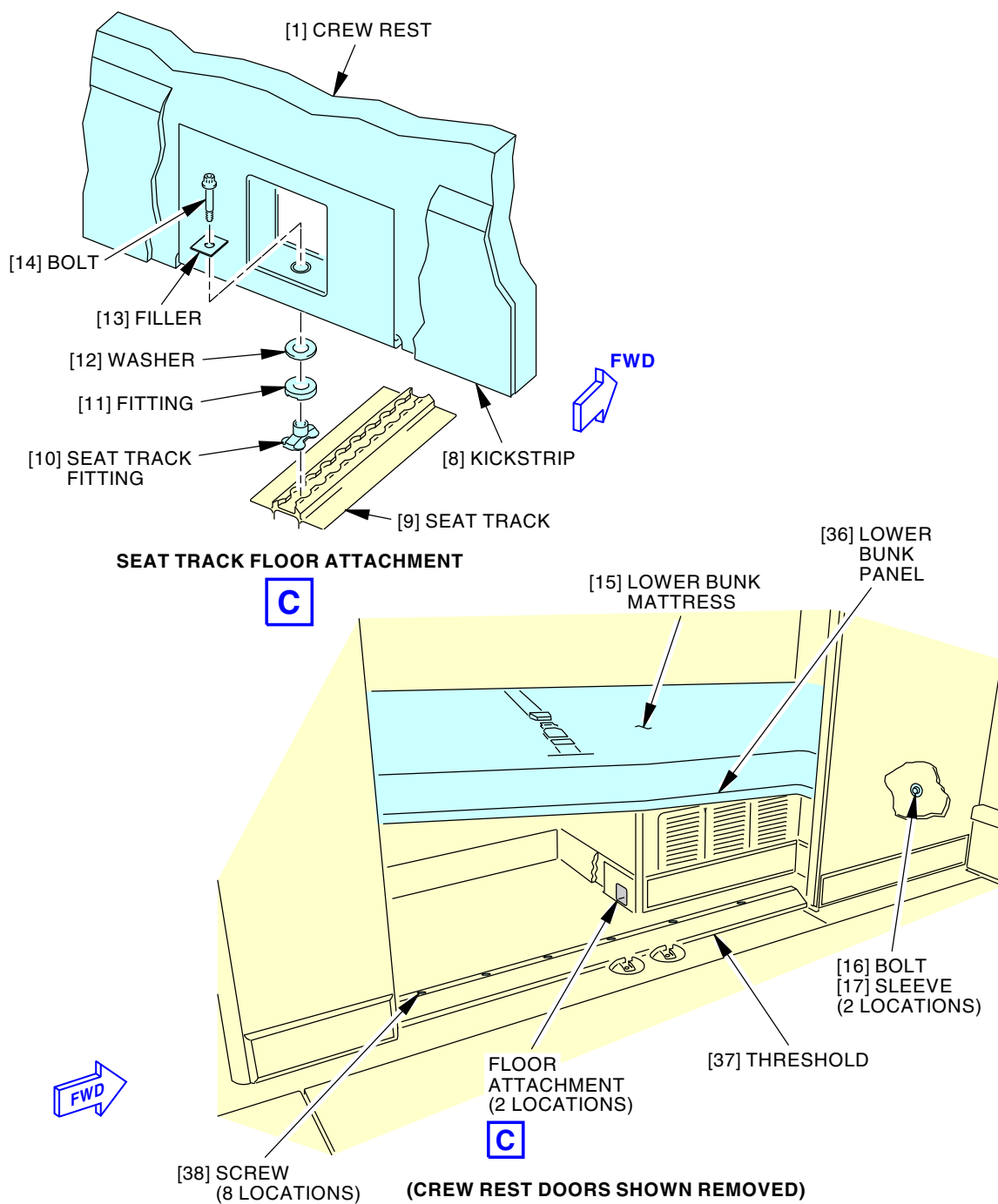
EFFECTIVITY
ARO ALL

25-29-03

D633W101-ARO

Page 410
Jan 05/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL



H86690 S0006409902_V2

Flight Crew Rest Installation
Figure 401/25-29-03-990-801 (Sheet 3 of 5)

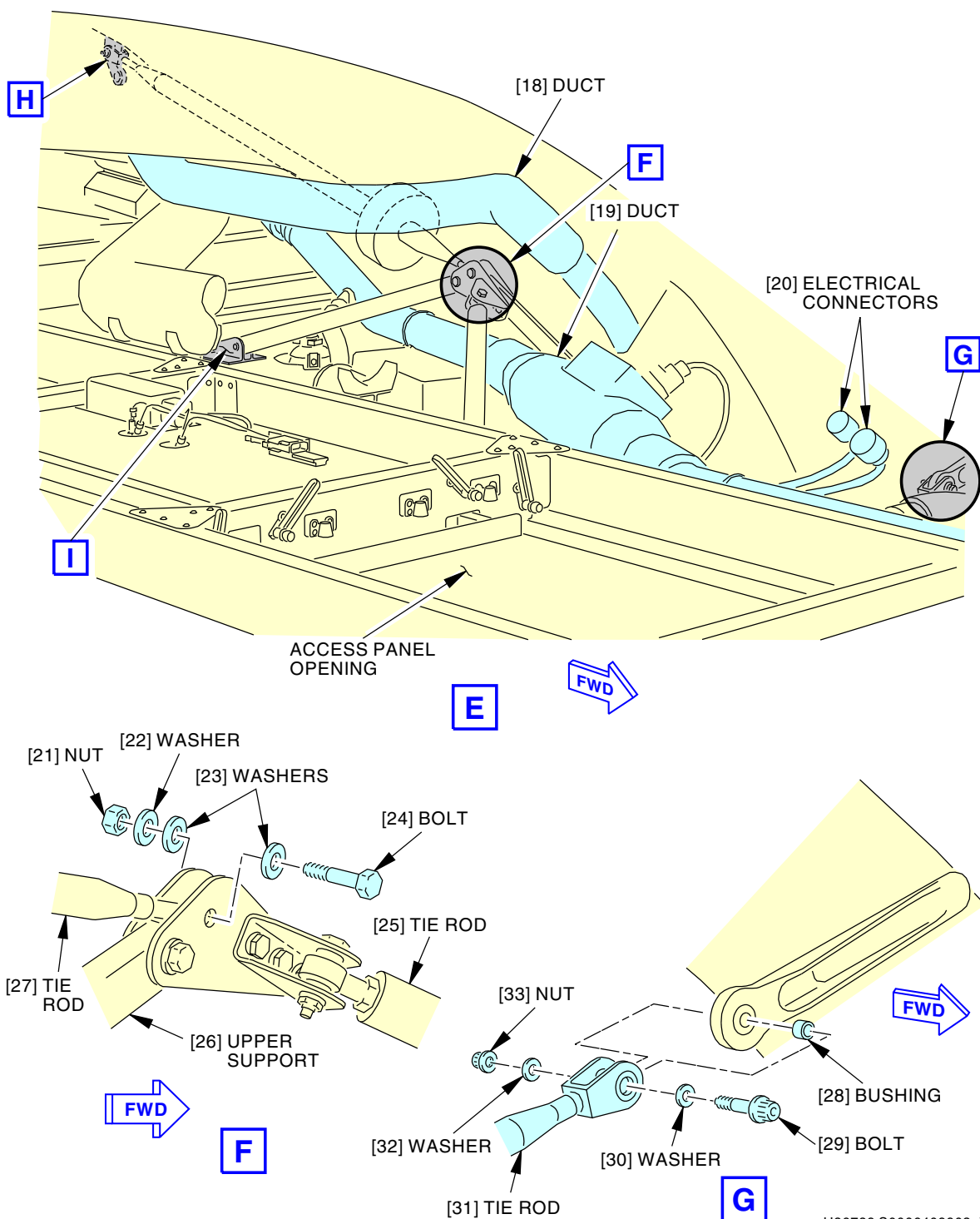
EFFECTIVITY
ARO ALL

25-29-03

D633W101-ARO

Page 411
Jan 05/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



H86789 S0006409903_V2

**Flight Crew Rest Installation
Figure 401/25-29-03-990-801 (Sheet 4 of 5)**

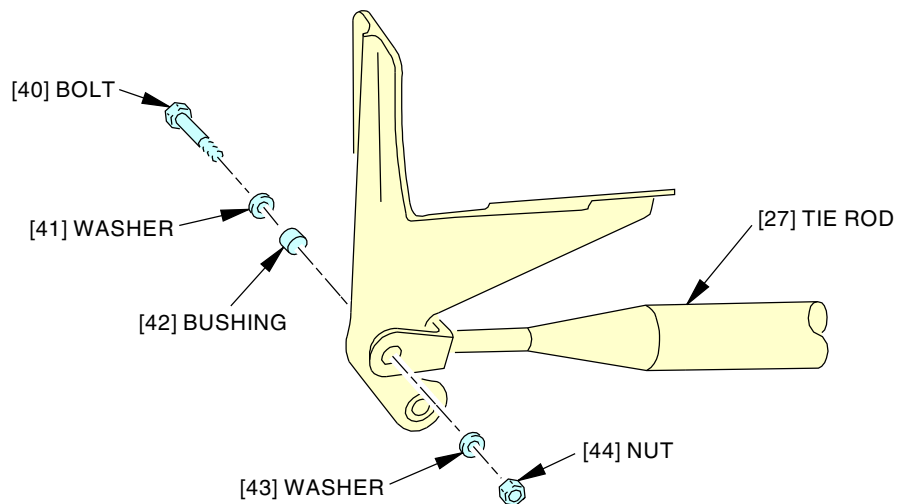
EFFECTIVITY
ARO ALL

25-29-03

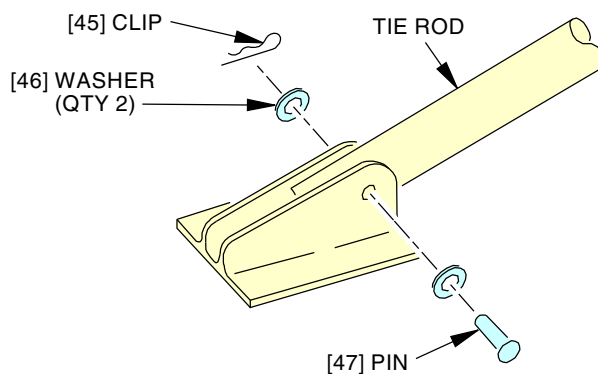
D633W101-ARO

Page 412
Jan 05/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



H



(EXAMPLE, 3 LOCATIONS)

I

L31210 S0006409904_V2

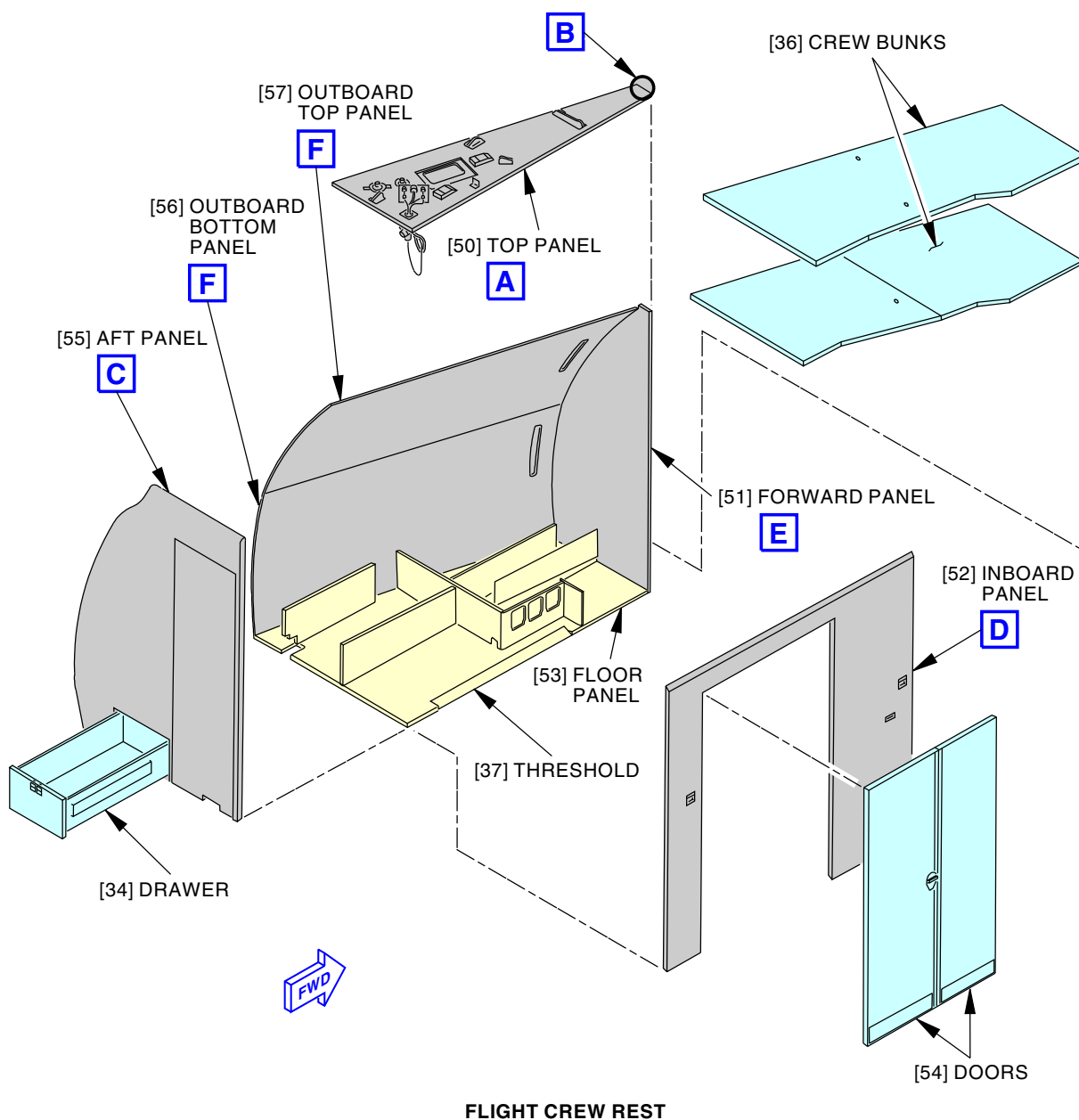
**Flight Crew Rest Installation
Figure 401/25-29-03-990-801 (Sheet 5 of 5)**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-29-03

Page 413
Jan 05/2018



L37084 S0006409905_V2

Flight Crew Rest Assemble
Figure 402/25-29-03-990-802 (Sheet 1 of 5)

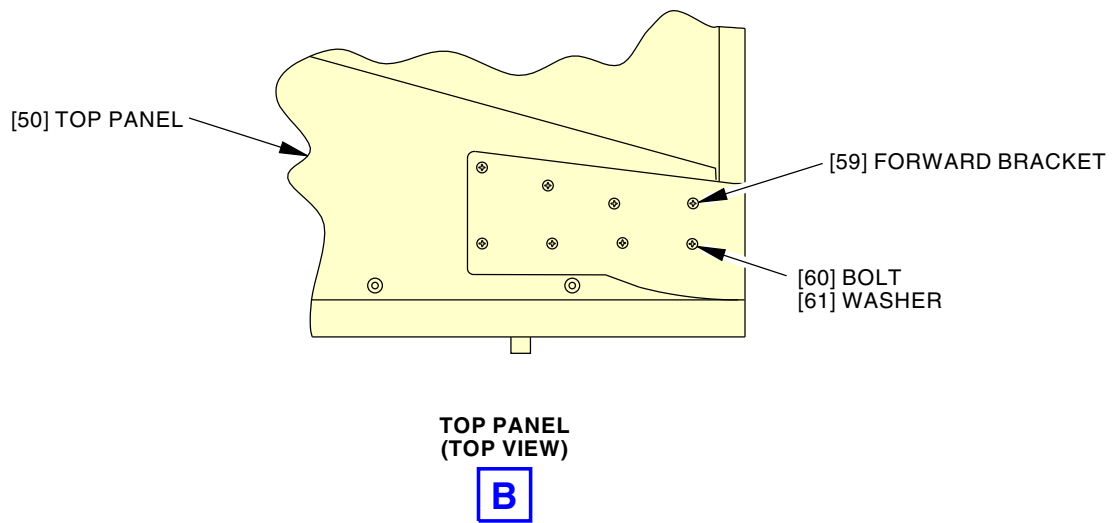
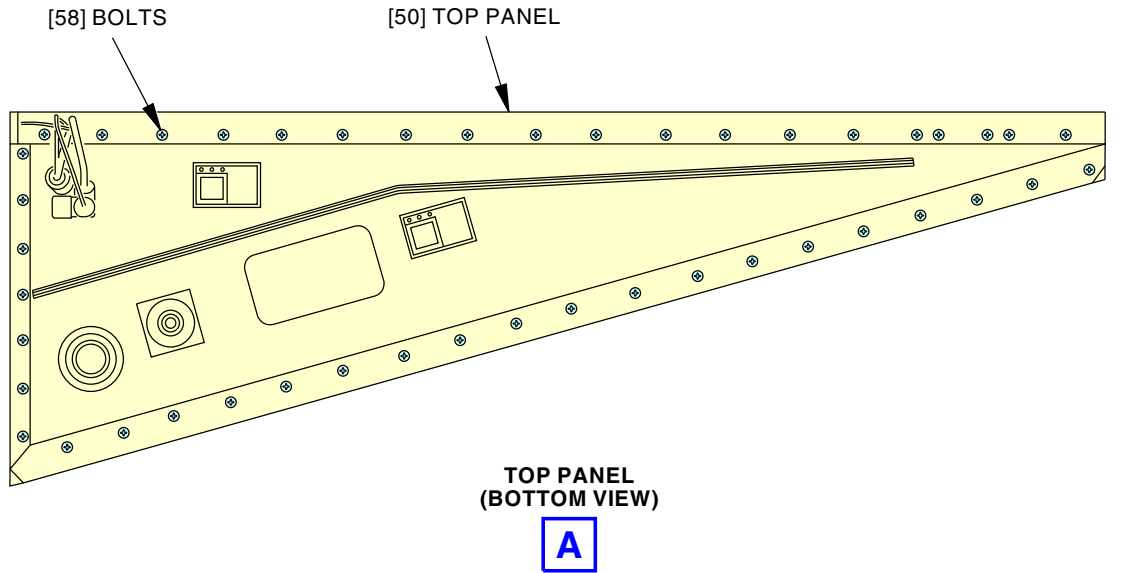
EFFECTIVITY
ARO ALL

25-29-03

D633W101-ARO

Page 414
Jan 05/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL



L37095 S0006409906_V2

Flight Crew Rest Assemble
Figure 402/25-29-03-990-802 (Sheet 2 of 5)

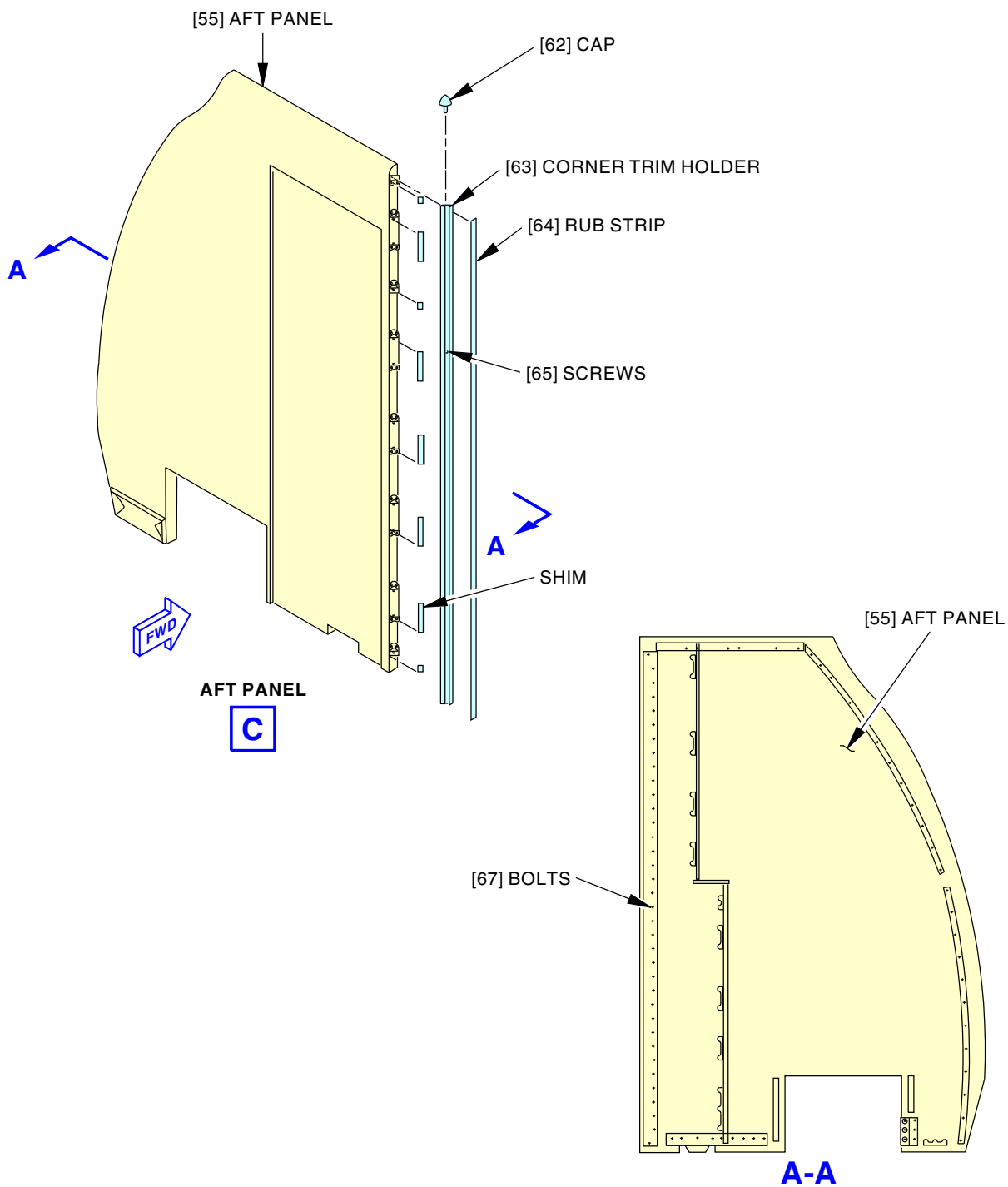
EFFECTIVITY
ARO ALL

D633W101-ARO

25-29-03

Page 415
Jan 05/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



L30609 S0006409907_V2

**Flight Crew Rest Assemble
Figure 402/25-29-03-990-802 (Sheet 3 of 5)**

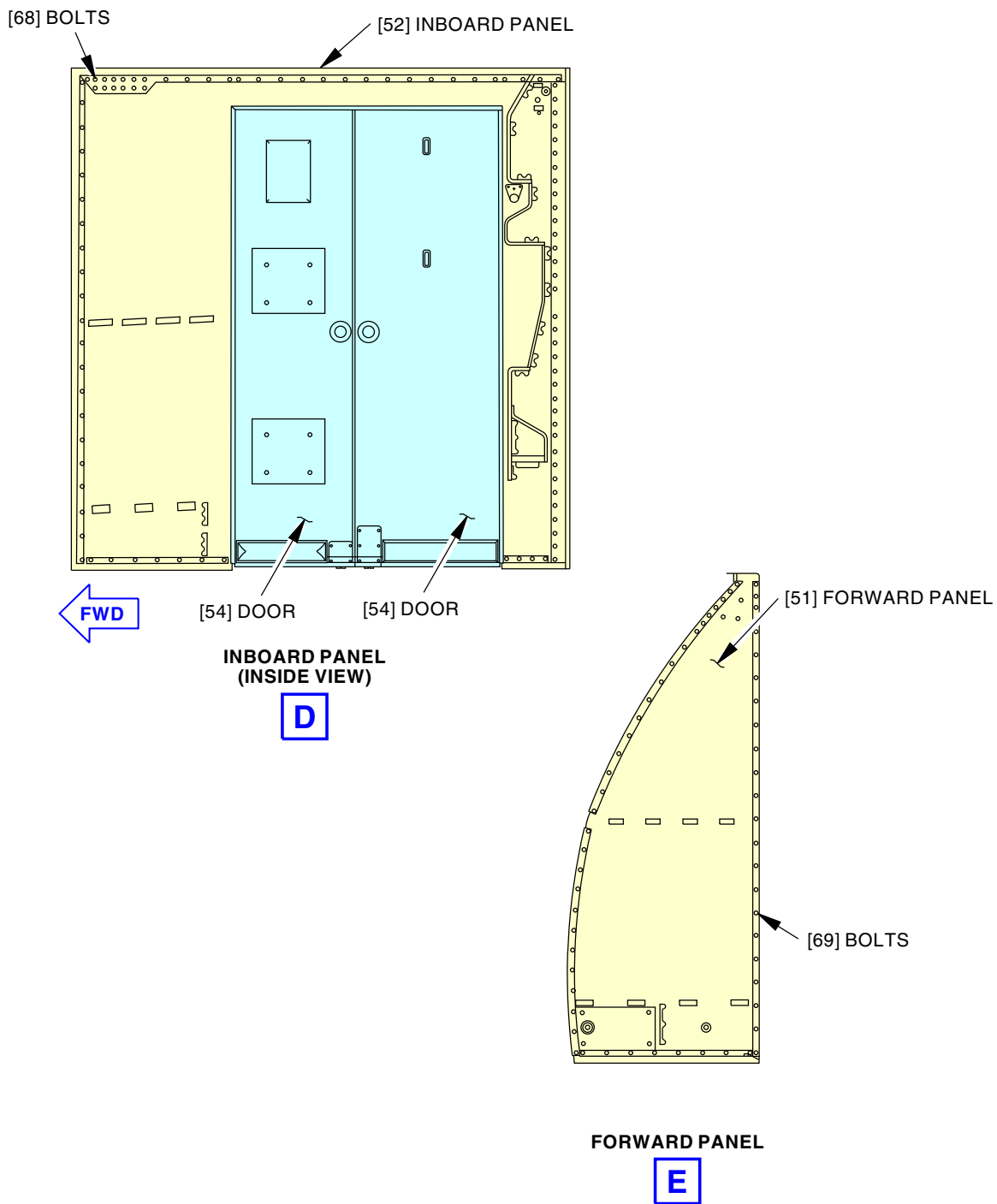
EFFECTIVITY
ARO ALL

D633W101-ARO

25-29-03

Page 416
Jan 05/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



L30415 S0006409908_V2

**Flight Crew Rest Assemble
Figure 402/25-29-03-990-802 (Sheet 4 of 5)**

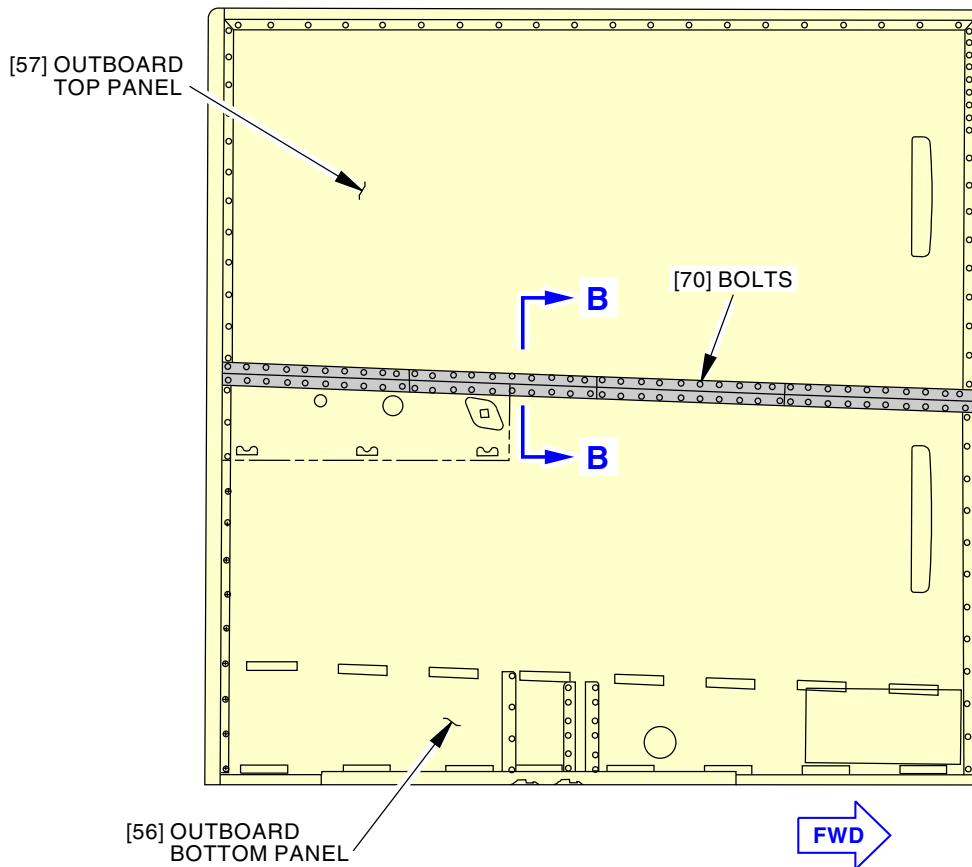
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25-29-03

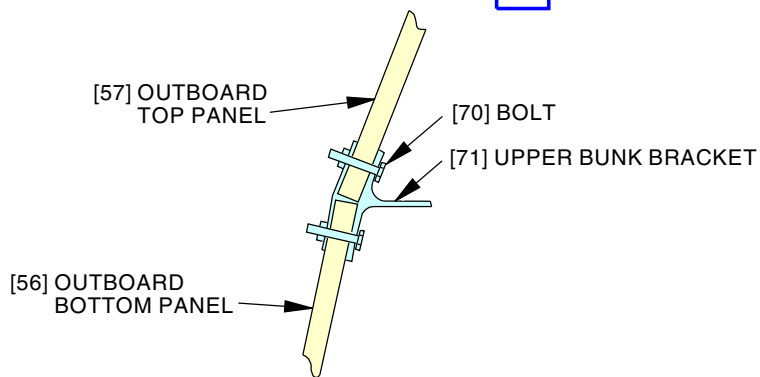
Page 417
Jan 05/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



OUTBOARD PANEL

F



OUTBOARD PANEL SPLIT LINE

B-B

L30238 S0006409909_V2

**Flight Crew Rest Assemble
Figure 402/25-29-03-990-802 (Sheet 5 of 5)**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-29-03

Page 418
Jan 05/2018



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

CREW REST-BUNKS AND FURNISHING-INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.

TASK 25-29-25-210-801

2. Crew Rest-Bunks and Furnishings- Inspection/Check

A. Procedure

SUBTASK 25-29-25-210-001

- (1) If bunks are installed, do a check of crew rest bunks:
- (a) Pull on each bunk restraint belt to ensure it is attached correctly.
 - (b) Make sure each bunk restraint belt operates correctly.
 - (c) Make sure the attachment fittings for each bunk are correctly attached.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-29-25

Page 601
May 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL
GALLEY SYSTEMS - ADJUSTMENT/TEST

1. General

A. This procedure contains these tasks:

- (1) A leak test for the galley potable water.
- (2) An operational test of the galley lights.

TASK 25-31-00-700-810

2. Galley Potable Water - Leak Test

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Galley Potable Water - Leak Test

SUBTASK 25-31-00-710-013

- (1) Do these steps to make sure there are no leaks in the galley potable water system:
 - (a) Put the shut-off valve for the potable water to the ON position.
 - (b) Put a water drain bucket below the applicable drain mast.
 - (c) Turn on the cold water spigots or faucets.
 - 1) Make sure there are no leaks in the water tubes and fittings, and supply connection in the galley.
 - a) If you can not see the tubes, fittings, or connections look for water or signs of water in the galley area.
 - 2) Run water through the drains and make sure there are no leaks in the drain connection.
 - a) If you can not see the drains, look for water or signs of water in the galley area.
 - (d) Turn off the cold water spigots or faucets.
 - (e) Remove the water drain bucket.

———— **END OF TASK** ————

TASK 25-31-00-700-811

3. Galley Light Operational Test

A. Operational test of the galley lights.

NOTE: This task provides a basic operational test of the galley lights. Specific installations may be different.

SUBTASK 25-31-00-710-014

- (1) Do these steps to perform the operational check of the galley lights.
 - (a) Make sure the POWER SOURCE ON light is ON.
 - (b) Put the light switch in the DIM position.
 - (c) Make sure the lights are dim.
 - (d) Put the light switch in the BRIGHT position.
 - (e) Make sure the lights are bright.

EFFECTIVITY
ARO ALL

25-31-00

D633W101-ARO

Page 501
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (f) Put the light switch in the OFF position.
- (g) Make sure the lights are off.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-00

Page 502
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL
GALLEY SYSTEMS - INSPECTION/CHECK

1. General

- A. This procedure is for inspections and checks of the galley.

TASK 25-31-00-200-802

2. Inspect the Galley

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Do these steps to inspect the galley:

SUBTASK 25-31-00-200-003

- (1) Do a check of the refrigeration system for condition, leakage and correct installation.

SUBTASK 25-31-00-200-004

- (2) Do a check of the galley panels for separations from the metal surface, cracks and other visible damage.

SUBTASK 25-31-00-200-005

- (3) Do a check of the galley structure for loose rivets, loose equipment, broken spotwelds, corrosion, worn areas and other damage.

SUBTASK 25-31-00-200-006

- (4) Do a check of all the hinges for free movement.

SUBTASK 25-31-00-200-007

- (5) Do a check of the waste containment compartment for damage from fire, corrosion and punctures through the fire containment lining.

SUBTASK 25-31-00-200-008

- (6) Do a check of all the latch assemblies for correct operation and condition.

SUBTASK 25-31-00-200-009

- (7) Do a check of the devices that hold the doors open above the head for condition and correct operation.

SUBTASK 25-31-00-200-010

- (8) Do a check of all the galley module safety devices for condition and correct operation.

SUBTASK 25-31-00-200-011

- (9) Clean the galley module safety devices as necessary.

SUBTASK 25-31-00-200-012

- (10) Do a check of the removable galley tops for condition and correct operation.

SUBTASK 25-31-00-200-013

- (11) Do a check of the galley seal between the galley module and the airplane floor.

C. Repair or replace any unserviceable components as necessary.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

25-31-00

D633W101-ARO

Page 601
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

FORWARD GALLEY - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) Forward galley - deactivation.
 - (2) Forward galley - activation.

TASK 25-31-01-040-801-001

2. Forward Galley - Deactivation

A. **General**

- (1) This task will deactivate the power to the forward galleys.

B. **References**

Reference	Title
38-10-00-040-801	Potable Water System - Deactivation (P/B 201)

C. **Location Zones**

Zone	Area
221	Passenger Compartment, Left - Section 41
222	Passenger Compartment, Right - Section 41

D. **Procedure**

SUBTASK 25-31-01-020-120-001

- (1) Do this task: Potable Water System - Deactivation, TASK 38-10-00-040-801.

SUBTASK 25-31-01-020-121-001

- (2) Do these steps to drain the galley water system:
 - (a) Open the galley water shutoff valve.
 - (b) Open the galley faucets.
 - (c) Open the galley supply system drain valves.
 - (d) Drain the water from all galley equipment.

SUBTASK 25-31-01-020-122-001



KEEP PERSONNEL, EQUIPMENT, AND OTHER ITEMS OUT OF THE HAZARDOUS ENERGY ZONES. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.



BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

NOTE: There are components installed on the galley that will not power down when these circuit breakers are open.

- (3) Open these circuit breakers and install safety tags:

Ground Service/Handling Power Panel, P320

Row	Col	Number	Name
G	4	C33460	FWD & DR 2 GLY LTS

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-01

Config 1
Page 201
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	16	C25639	DR 1 GLY

E. Forward Galley - Tryout

NOTE: This tryout is to make sure that the forward galleys are in a zero energy state.

SUBTASK 25-31-01-420-077-001

- (1) Put the Emergency Power switch on the galley control panel and the upper deck control panel to the ON position.

- (a) Make sure that a worklight or galley insert does not operate.

SUBTASK 25-31-01-020-123-001

- (2) Put the Emergency Power switch on the galley control panel to the OFF position.

SUBTASK 25-31-01-420-078-001

- (3) Put the Area Light switch on the galley control panel to the DIM or BRT position.

- (a) Make sure that the lights stay off.

SUBTASK 25-31-01-020-124-001

- (4) Put the Area Light switch on the galley control panel to OFF position.

————— END OF TASK —————

TASK 25-31-01-440-801-001

3. Forward Galley - Activation

A. General

- (1) This task will activate the power to the forward galleys.

B. Location Zones

<u>Zone</u>	<u>Area</u>
221	Passenger Compartment, Left - Section 41
222	Passenger Compartment, Right - Section 41

C. Procedure

SUBTASK 25-31-01-420-079-001

- (1) Do these steps to turn on the galley water system:

- (a) Open the galley water shutoff valve.
 - (b) Close the galley faucets.
 - (c) Close the galley supply system drain valves.

SUBTASK 25-31-01-420-080-001

- (2) Remove the safety tags and close these circuit breakers:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
G	4	C33460	FWD & DR 2 GLY LTS

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	16	C25639	DR 1 GLY

————— END OF TASK —————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-01

Config 1
Page 202
Jan 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

FORWARD GALLEY - REMOVAL/INSTALLATION

1. General

A. This procedure contains these tasks:

- (1) Removal of the forward fixed galleys.
- (2) Installation of the forward fixed galleys.

B. The F1, F2, F3, and F4 forward galleys are fixed galleys and you can NOT move them to a different location in the passenger compartment.

NOTE: There are several configurations of the fixed galleys. The F2 and F4 galleys are not on all airplanes.

C. The F5 forward galleys are center flexible galleys and can be moved in one inch increments in the flexibility zone.

NOTE: The F5 galleys are not on all airplanes.

- (1) The center flexible galleys are located along the centerline of the aircraft.

D. The F6 and F8 forward galleys are outboard flexible galleys and can be moved in one inch increments in the flexibility zone.

NOTE: The F6 and F8 galleys are not on all airplanes.

- (1) The outboard flexible galleys are located along the outboard sides of the aircraft.

TASK 25-31-01-000-821

2. Forward Fixed Galley Removal

A. General

- (1) This procedure is for the removal of the forward fixed galleys.

| ARO 001-017

NOTE: Galley F1/F2/F3: Figure 401

| ARO ALL

B. References

Reference	Title
12-14-01-616-802	Potable Water System - Drain (P/B 301)
25-21-06-000-801	Main Ceiling Panel - Removal (P/B 401)
25-21-07-000-801	Lowered Ceiling Panel Removal (P/B 401)
25-24-01 P/B 401	CLOSETS - REMOVAL/INSTALLATION
25-24-10 P/B 401	VIDEO CONTROL CENTER (VCC) - REMOVAL/INSTALLATION
25-25-01-000-801	Passenger Seat - Removal (P/B 401)
25-25-06-000-801	Attendant Seat Removal (P/B 401)
25-25-06-000-802	Attendant Seat Removal (P/B 401)
25-25-06-000-806	Attendant Seat Removal (P/B 401)
25-28-05-000-801	Floor-Mounted Stowage Box Removal (P/B 401)
25-33-01-000-801	Overhead Galley Air Chiller Removal (P/B 401)
25-41-01-000-801	Lavatory Removal (P/B 401)

EFFECTIVITY
ARO ALL

25-31-01

D633W101-ARO

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Page 401
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-5259	Cup - Vacuum
	Part #: N4950 Supplier: 0SL88

D. Location Zones

Zone	Area
221	Passenger Compartment, Left - Section 41
222	Passenger Compartment, Right - Section 41

E. Prepare for Removal

SUBTASK 25-31-01-865-022

- (1) Open these circuit breakers and install safety tags:

Ground Service/Handling Power Panel, P320

Row	Col	Number	Name
G	4	C33460	FWD & DR 2 GLY LTS

Right Power Management Panel, P210

Row	Col	Number	Name
F	16	C25639	DR 1 GLY

SUBTASK 25-31-01-010-055

- (2) Remove these items as applicable:

- (a) Do this task: Attendant Seat Removal, TASK 25-25-06-000-801 or Attendant Seat Removal, TASK 25-25-06-000-802 or Attendant Seat Removal, TASK 25-25-06-000-806.
- (b) Do this task: Floor-Mounted Stowage Box Removal, TASK 25-28-05-000-801.
- (c) Do this task: Lavatory Removal, TASK 25-41-01-000-801.
- (d) Do this task: Passenger Seat - Removal, TASK 25-25-01-000-801.
- (e) Closet Removal. (CLOSETS - REMOVAL/INSTALLATION, PAGEBLOCK 25-24-01/401)
- (f) Video Control Center (VCC) Removal. (VIDEO CONTROL CENTER (VCC) - REMOVAL/INSTALLATION, PAGEBLOCK 25-24-10/401)
- (g) Do this task adjacent to the galley: Lowered Ceiling Panel Removal, TASK 25-21-07-000-801 or Main Ceiling Panel - Removal, TASK 25-21-06-000-801.

SUBTASK 25-31-01-616-001

- (3) If the galley has potable water connections, do this task: Potable Water System - Drain, TASK 12-14-01-616-802.

SUBTASK 25-31-01-030-040

- (4) Remove the closeout seals from the top and sides of the applicable galley.

SUBTASK 25-31-01-010-056

- (5) Remove the galley ceiling panels Main Ceiling Panel - Removal, TASK 25-21-06-000-801.

SUBTASK 25-31-01-010-057

- (6) Remove the carts and all of the other equipment from the galley.

EFFECTIVITY
ARO ALL

25-31-01

D633W101-ARO

Page 402
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

F. Galley F1, F2, F3, or F4 Removal

SUBTASK 25-31-01-030-041

- (1) Do these applicable steps to disconnect the top of the galley:
 - (a) Disconnect the galley cables [36] from the galley electrical interface bracket [35] mounted on top of the galley.
 - 1) Leave the galley cables [36] on top of the galley.
 - (b) Remove the galley electrical interface bracket [35] from the top of the galley.
 - (c) Carefully tie the galley electrical interface bracket [35] with the overhead cables to the overhead structure to allow clearance for the galley.
 - (d) Disconnect the galley cables [36] from the overhead electrical interface bracket.
 - 1) Remove the wire wraps and clamps as necessary from the cable bundles and put these galley cables [36] on top of the galley.
 - (e) Disconnect the ground wire [32] from the overhead support structure at the ground stud.
 - (f) Do these steps to disconnect the refrigeration system from the galley:

NOTE: Galleys F1 and F2 are the only galleys that can have a chiller installed on the top.

 - 1) Do this task: Overhead Galley Air Chiller Removal, TASK 25-33-01-000-801.
 - 2) Disconnect the chiller exhaust hose [24] from the chiller rack [23].
 - 3) Remove the chiller rack [23] from the top of the galley.
 - 4) Remove the plenum [22] from the top of the galley.
 - (g) Remove all the tie rod support rods [33] or mounts [34] from the top of the galley.
 - (h) Carefully tie all the tie rod support rods [33], mounts [34], and tie rods [31] to the overhead structure to allow clearance for the galley.
 - 1) Disconnect the tie rods [31] as needed to move these assemblies.

SUBTASK 25-31-01-010-058

- (2) If necessary, disconnect the potable water hose [21].

SUBTASK 25-31-01-030-042

- (3) Do these steps to disconnect the galley from the floor:
 - (a) Remove the kickstrips [1] and cover plates [2] to get access to the galley fittings.
 - (b) Remove the floor mats [82].
 - (c) Remove the floor seals [81].

NOTE: The floor seals [81] are attached to the floor with carpet tape.
 - (d) Remove the bolts [41], washers [42], and shims [43] to disconnect the galley from the hardpoint fittings [44].
 - (e) On the F2 and F4 galleys, remove the bolts [51], washers [52], shims [53], and bushings [54] or [58] to disconnect the galley from the transverse fitting [57].
 - (f) If necessary, remove the drain hose clamp [72] from the applicable drain hose [71].
 - 1) Carefully pull the drain hose [71] from the drain.

NOTE: Catch water that is still in the drain hose [71] with a cup.

EFFECTIVITY
ARO ALL

25-31-01

D633W101-ARO

Page 403
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-31-01-020-117

- (4) If necessary, use the vacuum cup, SPL-5259 to carefully remove the galley.

NOTE: Use of the vacuum cup is optional.

SUBTASK 25-31-01-030-043

- (5) If necessary, do these steps to remove the stabilizer fittings [64] from the floor:

NOTE: The location and number of dividers and stabilizer assemblies vary from galley to galley.

- (a) Remove the bolts [62] and washers [63] from the stabilizer fitting [64].
- (b) Remove the divider [61] and the stabilizer fitting [64].

SUBTASK 25-31-01-030-044

- (6) If necessary, do these steps to remove the transverse fittings [57]:

NOTE: The transverse fitting is only used on the F2 and F4 galleys.

- (a) Remove the bolts [55] that hold the transverse fittings [57] to the saddle fittings [56].
- (b) Lift the transverse fittings [57] from the saddle fitting [56].

SUBTASK 25-31-01-030-045

- (7) If necessary, do these steps to remove the saddle fitting [56]:

- (a) Move the saddle fitting [56] left or right approximately 0.5 in. (13 mm) to align it with the circular openings in the seat track.
- (b) Lift the saddle fitting [56] out of the seat track.

- (8) Remove the tape and filler from the seat track immediately left and right of the saddle fitting location.

SUBTASK 25-31-01-030-046

- (9) If necessary, remove the hardpoint fittings [44] from the floor.

————— **END OF TASK** —————

TASK 25-31-01-400-821

3. Forward Fixed Galley Installation

A. General

- (1) This procedure is for the installation of the forward fixed galleys.

| ARO 001-017

NOTE: Galley F1/F2/F3: Figure 401

| ARO ALL

B. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
25-21-06-400-801	Main Ceiling Panel - Installation (P/B 401)
25-21-07-400-801	Lowered Ceiling Panel Installation (P/B 401)
25-24-01 P/B 401	CLOSETS - REMOVAL/INSTALLATION
25-24-10 P/B 401	VIDEO CONTROL CENTER (VCC) - REMOVAL/INSTALLATION
25-25-01-400-801	Passenger Seat - Installation (P/B 401)
25-25-06-400-801	Attendant Seat Installation (P/B 401)

EFFECTIVITY
ARO ALL

25-31-01

D633W101-ARO

ECCN 9E991 BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

Page 404
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Title
25-25-06-400-802	Attendant Seat Installation (P/B 401)
25-25-06-400-806	Attendant Seat Installation (P/B 401)
25-28-05-400-801	Floor-Mounted Stowage Box - Installation (P/B 401)
25-33-01-400-801	Overhead Galley Air Chiller Installation (P/B 401)
25-33-97-700-801	Galley Air Chiller Operational Test (P/B 501)
25-41-01-400-801	Lavatory Installation (P/B 401)
38-10-00-600-801	Potable Water System - Disinfectant (P/B 201)
38-10-00-790-801	Potable Water System - Leak Test (P/B 201)
SWPM 20-20-00	Standard Wiring Practices Manual

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-1550	Bonding Meters - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: T477W Supplier: 01014 Opt Part #: M1B Supplier: 3AD17
SPL-5259	Cup - Vacuum Part #: N4950 Supplier: 0SL88

D. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
G01288	Tape - Carpet	BMS5-133
G02304	Tape - Moisture Barrier, Adhesive One-side	BMS8-346
G02482	Seal - Extruded (Skyflex GUA1072, 1073, 1082, 1083, or 1092)	
G50042	Filler, Seat Track, Polycarbonate Extrusion	BAC1522-275 from BMS8-251

E. Location Zones

Zone	Area
221	Passenger Compartment, Left - Section 41

F. Galley F1, F2, F3, or F4 Installation

SUBTASK 25-31-01-430-057

- (1) If necessary, install the hardpoint fittings [44] to the floor.

EFFECTIVITY
ARO ALL

25-31-01

D633W101-ARO

Page 405
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-31-01-430-058

- (2) If necessary, do these steps to install the saddle fitting [56] to the seat track:

NOTE: The saddle fitting is only used on the F2 and F4 galleys.

- (a) Remove the tape and filler from the seat track.
- (b) Put compound, C00528, on the saddle fitting [56].
- (c) Put the saddle fitting [56] in the circular opening in the seat track.
- (d) Move the saddle fitting [56] left or right 0.5 in. (13 mm) to lock it in the correct position for the installation.
- (e) Apply new filler, G50042 in the seat track on each end of the saddle fitting.
- (f) Apply new moisture barrier tape, G02304, with a cutout for the seat track fittings.

SUBTASK 25-31-01-430-059

- (3) If necessary, do these steps to install the transverse fittings [57]:

- (a) Apply corrosion preventive compound, C00308 to the transverse fittings [57] and the bolts [55].
- (b) Install the transverse fittings [57] with the bolts [55] to the saddle fittings [56].

NOTE: The transverse fitting is only used on the F2 and F4 galleys.

- 1) Tighten the bolts [55].
- 2) Torque the bolts [55] to 70.5 ±2.5 in-lb (7.97 ±0.29 N·m).

SUBTASK 25-31-01-430-060

- (4) If necessary, do these steps to install the stabilizer fitting [64] to the floor:

NOTE: The location and number of dividers and stabilizer assemblies vary from galley to galley.

- (a) Apply a new moisture barrier seal, G02482 to make a seal around the stabilizer fitting [64] and the bolt [62] heads.
- (b) Install the bolts [62] and washers [63] through the stabilizer fitting [64] and into the floor.
 - 1) Tighten the bolts [62].

Table 401/25-31-01-993-801 Stabilizer Bolts

Part Number	Type	Where Used
BACB30NM3K13	Hex Head	Eight Hole Stabilizers at the Floor Beams
BACB30NT3K13	Pan Head	Eight Hole Stabilizers at the Floor Panels
BACB30NN3K13	100 Degree	Large 18 Hole Stabilizers
BACB30NT3K3	Pan Head	Stabilizers at the Floor Panels

SUBTASK 25-31-01-430-061

- (5) During installation of the galley, put the divider [61] with the galley bearing block on the stabilizer fitting [64].

NOTE: Remove and replace the stabilizer fitting stop as needed to help the installation of the galley bearing block.

SUBTASK 25-31-01-430-062

- (6) Do these steps to connect the galley to the floor:

EFFECTIVITY
ARO ALL

25-31-01

D633W101-ARO

Page 406
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Make sure there is an isolator plate on the bottom of the galley at each floor fitting.
NOTE: The isolator plate is a piece of stainless steel. It is necessary to prevent corrosion between the galley and the transverse and longitudinal floor fittings.
- (b) If necessary, use the vacuum cup, SPL-5259 to align the galley on top of the floor fittings.
NOTE: Use of the vacuum cup is optional.
- (c) For the fittings that have shims [43] and [53], do these steps:
 - 1) Apply a layer of corrosion preventive compound, C00308 on the shims [43] and [53].
 - 2) If there is a clearance between the galley and the floor then fill this clearance with shims [43] or [53].
NOTE: This will provide a proper fit and avoid interference with adjacent furnishings.
 - 3) Put all the remaining shims [43] or [53] below the bolt [41] or [51] heads.
- (d) For fittings that have bushings [54] and [58], do these steps:
 - 1) Apply a layer of corrosion preventive compound, C00308 to the bushing before you install them.
 - 2) Install bushing [54] and [58] at all applicable fittings.
- (e) Install the bolts [41], [51] and washers [42], [52].
 - 1) Tighten the bolts [41] and [51] to 200 ±40 in-lb (22.6 ±4.5 N·m).

SUBTASK 25-31-01-430-063

- (7) If necessary, do these steps to install the drain hose [71]:
 - (a) Install the drain hose clamp [72] on the drain hose [71] but do not tighten.
 - (b) Install the drain hose [71] on the drain with sufficient space for the drain hose clamp [72].
 - (c) Move the drain hose clamp [72] down on the drain and tighten.

SUBTASK 25-31-01-430-064

- (8) If necessary, connect the potable water hose [21].

SUBTASK 25-31-01-430-065

- (9) Do these steps to install the floor seal:
 - (a) If necessary, apply new sealant, A02315 under the retainer strip.
 - (b) If necessary, apply new carpet tape, G01288 on the floor seal [81] base.
NOTE: Keep a 4 in. (10 cm) space in the carpet tape, G01288, in the center of the floor seal [81] on the back wall of the galley.
 - (c) Push the base of the floor seal [81] to the floor.
 - (d) Install the top of the floor seal [81] into the retainer strip.

SUBTASK 25-31-01-430-066

- (10) Do these steps to install the floor mats [82]:
 - (a) Apply new carpet tape, G01288 to the floor mats [82] in the forward and aft direction with 1 in. (3 cm) between each piece.
 - (b) Keep the carpet tape, G01288, approximately 1 in. (3 cm) from the edge of the floor mats [82].
 - (c) Cover the floor seal [81] with the floor mats [82].
 - (d) Apply the sealant, A02315, to make a fillet seal around the edges of the floor mats [82].

EFFECTIVITY
ARO ALL

25-31-01

D633W101-ARO

Page 407
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-31-01-430-067

- (11) Install the kickstrips [1] and cover plates [2] to the galley.
- (a) Apply sealant, A02315 to make a seal around the cover plates [2] for the galley fittings.

SUBTASK 25-31-01-430-068

- (12) Do these applicable steps to connect the top of the galley:
- (a) Carefully untie all the tie rod support rods [33], mounts [34], and tie rods [31] from the overhead structure.
- (b) Install the tie rods [31] as needed to the applicable tie rod support rods [33] or mounts [34].
- NOTE: The tie rods [31] should have no pre-load on it when you install it.
- (c) Adjust the tie rod end fittings as required to help install the tie rod [31].
- NOTE: Do not adjust either end fitting past the witness hole.
- (d) Remove the lockwire on either end of the tie rod [31] if more adjustment is necessary.
- (e) Tighten the tie rod jam nuts when adjustments are complete.
- (f) If necessary, install a lockwire to the ends of the tie rod [31].
- (g) If necessary do these steps to connect the refrigeration system to the galley:
- NOTE: Galleys F1 and F2 are the only galleys that can have a chiller installed on the top.
- 1) Install the plenum [22] to the top of the galley.
- 2) Install the chiller rack [23] to the top of the galley.
- 3) Connect the exhaust hose [24] to the chiller rack [23].
- 4) Do this task: Overhead Galley Air Chiller Installation, TASK 25-33-01-400-801.
- (h) Connect the galley cables [36] to the overhead electrical interface bracket.
- (i) Carefully untie the galley electrical interface bracket [35] with the overhead cables from the overhead structure and put them on top of the galley.
- (j) Install the galley electrical interface bracket [35] with the cables to top of the galley.
- (k) Connect the galley cables [36] to the galley electrical interface bracket [35].
- (l) Connect the ground wire [32] to the overhead support structure at the ground stud.
- 1) Do a resistance check of the static ground from the ground stud to the aircraft static ground stud with a intrinsically safe approved bonding meter, COM-1550 (SWPM 20-20-00).
- a) Make sure the resistance is a maximum of 0.0025 Ohms.
- (m) Install the wire wraps and clamps as necessary to the cable bundles above the galley.

G. Forward Fixed Galley Installation Test

SUBTASK 25-31-01-410-145

- (1) Install the carts and the other equipment in the galley.

SUBTASK 25-31-01-710-039

- (2) If necessary, do this test: Passenger Entertainment System (PES) Video - Adjustment/Tests, 23-32-00-5-x or 44-2x-00-5.

EFFECTIVITY
ARO ALL

25-31-01

D633W101-ARO

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Page 408
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-31-01-865-023

- (3) Remove the safety tags and close these circuit breakers:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
G	4	C33460	FWD & DR 2 GLY LTS

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	16	C25639	DR 1 GLY

SUBTASK 25-31-01-861-010

- (4) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-31-01-790-002

- (5) Do this task: Potable Water System - Leak Test, TASK 38-10-00-790-801.

SUBTASK 25-31-01-670-002

- (6) Do this task: Potable Water System - Disinfectant, TASK 38-10-00-600-801.

SUBTASK 25-31-01-710-040

- (7) Do a check to make sure the galley lights come on.

SUBTASK 25-31-01-710-041

- (8) Do a test of the galley equipment.

- (a) If necessary, do this task: Galley Air Chiller Operational Test, TASK 25-33-97-700-801.

SUBTASK 25-31-01-430-069

- (9) Install the closeout seals to the top and sides of the galleys.

SUBTASK 25-31-01-410-147

- (10) Install the galley ceiling panels Main Ceiling Panel - Installation, TASK 25-21-06-400-801.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 25-31-01-410-148

- (1) Install these items as applicable:
- (a) Do this task adjacent to the galley: Lowered Ceiling Panel Installation, TASK 25-21-07-400-801 or Main Ceiling Panel - Installation, TASK 25-21-06-400-801.
 - (b) Video Control Center (VCC) Installation. (VIDEO CONTROL CENTER (VCC) - REMOVAL/INSTALLATION, PAGEBLOCK 25-24-10/401)
 - (c) Closet Installation. (CLOSETS - REMOVAL/INSTALLATION, PAGEBLOCK 25-24-01/401)
 - (d) Do this task: Passenger Seat - Installation, TASK 25-25-01-400-801.
 - (e) Do this task: Lavatory Installation, TASK 25-41-01-400-801.
 - (f) Do this task: Floor-Mounted Stowage Box - Installation, TASK 25-28-05-400-801.
 - (g) Do this task: Attendant Seat Installation, TASK 25-25-06-400-801 or Attendant Seat Installation, TASK 25-25-06-400-802 or Attendant Seat Installation, TASK 25-25-06-400-806.

————— END OF TASK —————

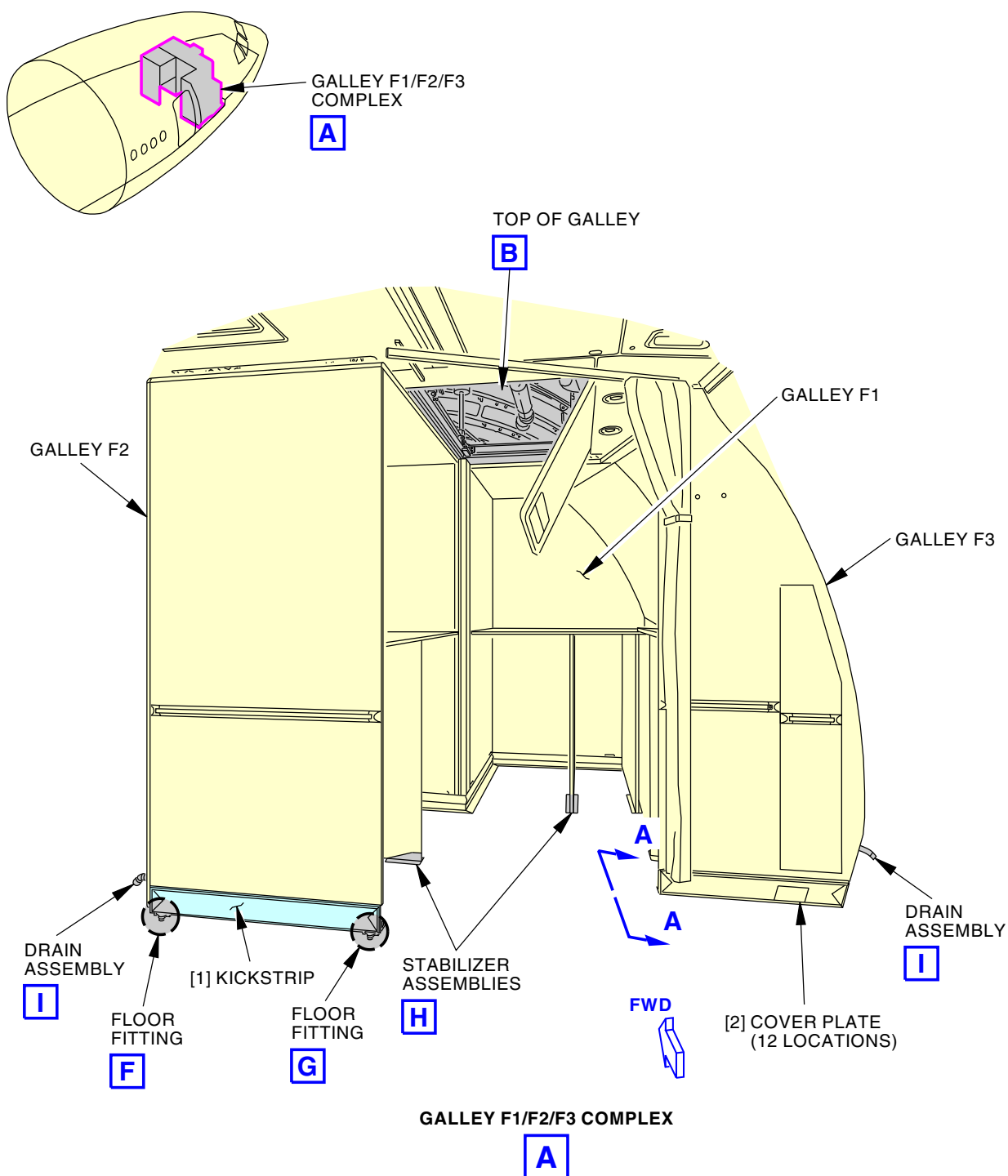
EFFECTIVITY
ARO ALL

25-31-01

D633W101-ARO

Page 409
Sep 05/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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Galley F1/F2/F3 Installation
Figure 401/25-31-01-990-831 (Sheet 1 of 8)

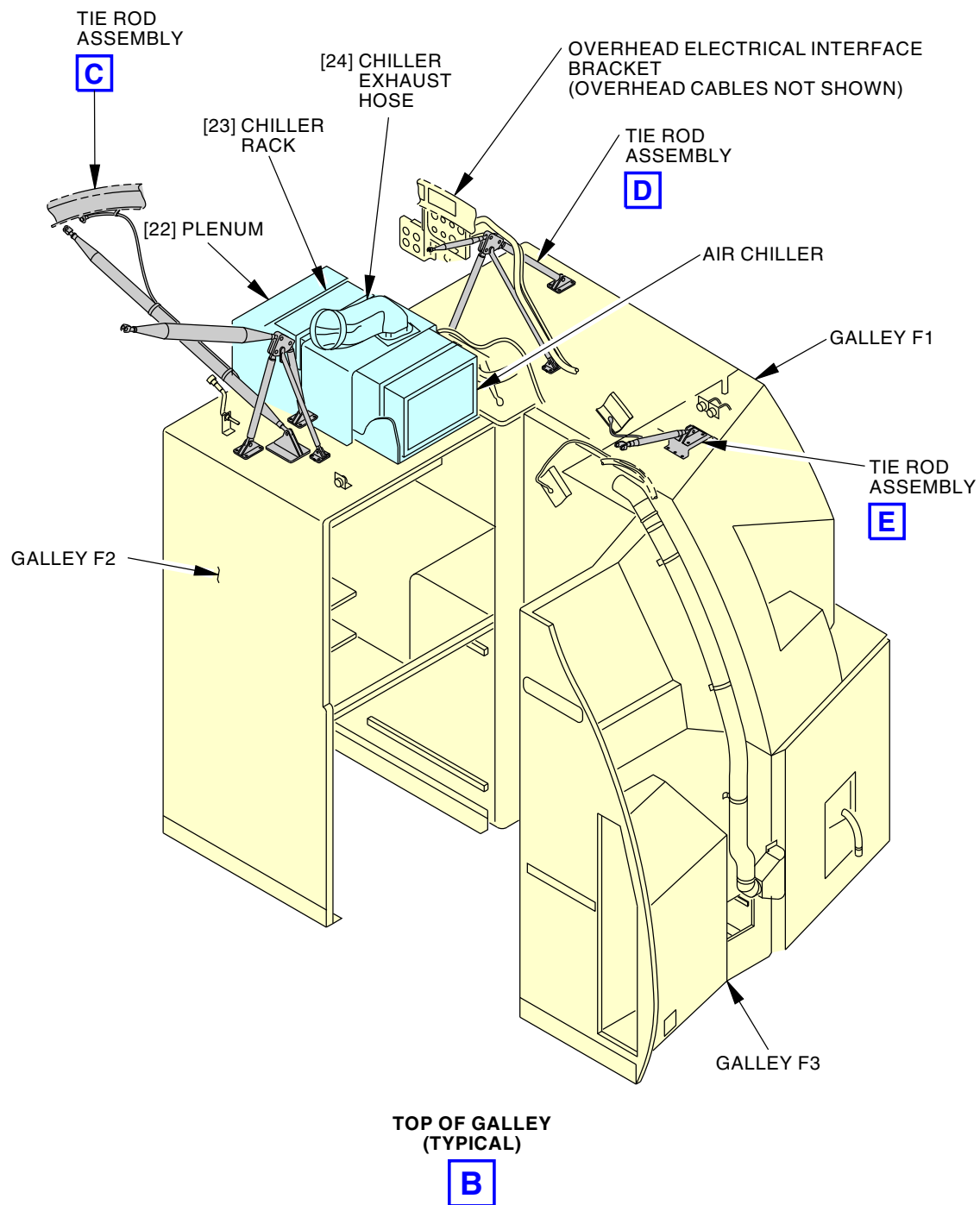
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ARO 001-017

25-31-01

D633W101-ARO

Page 410
Sep 05/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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Galley F1/F2/F3 Installation
Figure 401/25-31-01-990-831 (Sheet 2 of 8)

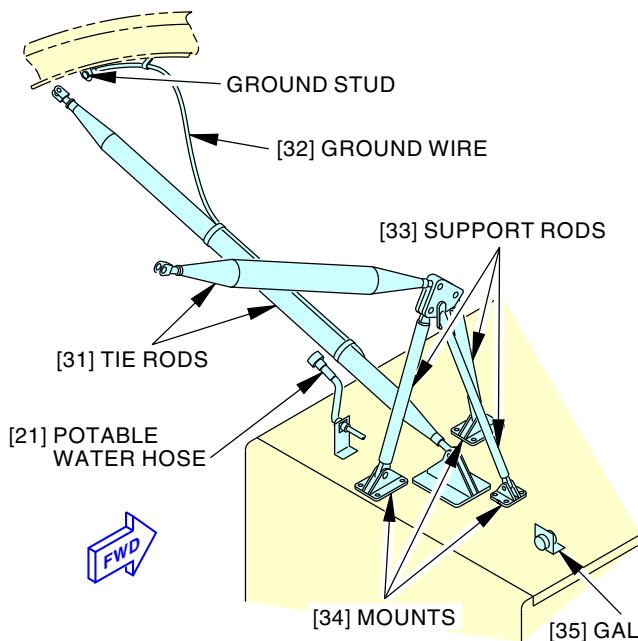
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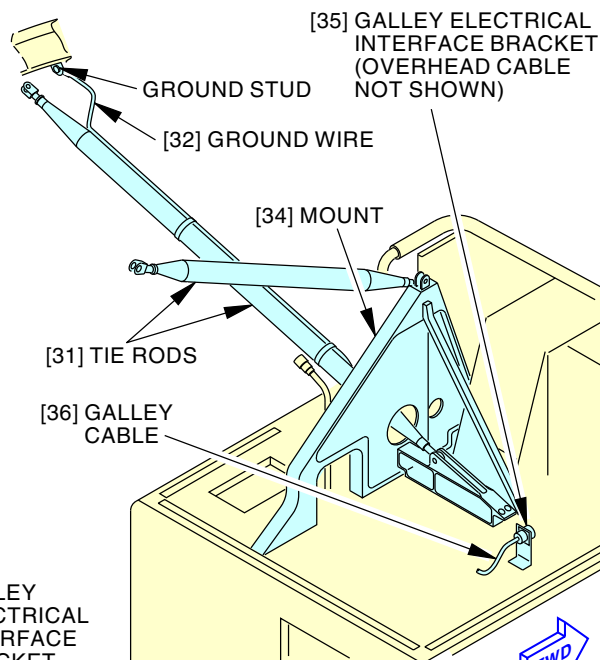
Page 411
Sep 05/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



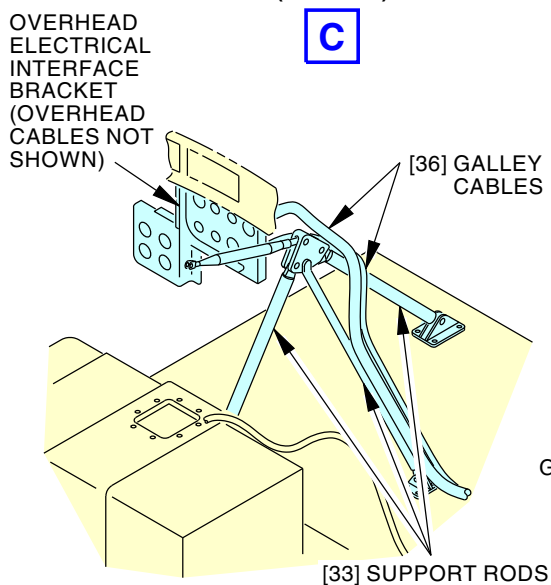
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(TYPICAL)**

C



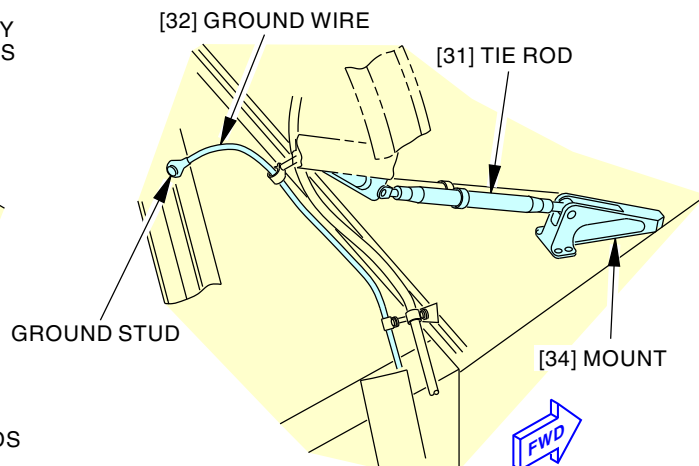
**TIE ROD ASSEMBLY
(TYPICAL)**

C



**TIE ROD ASSEMBLY
(TYPICAL)**

D



**TIE ROD ASSEMBLY
(TYPICAL)**

E

1455486 S0000264879_V3

**Galley F1/F2/F3 Installation
Figure 401/25-31-01-990-831 (Sheet 3 of 8)**

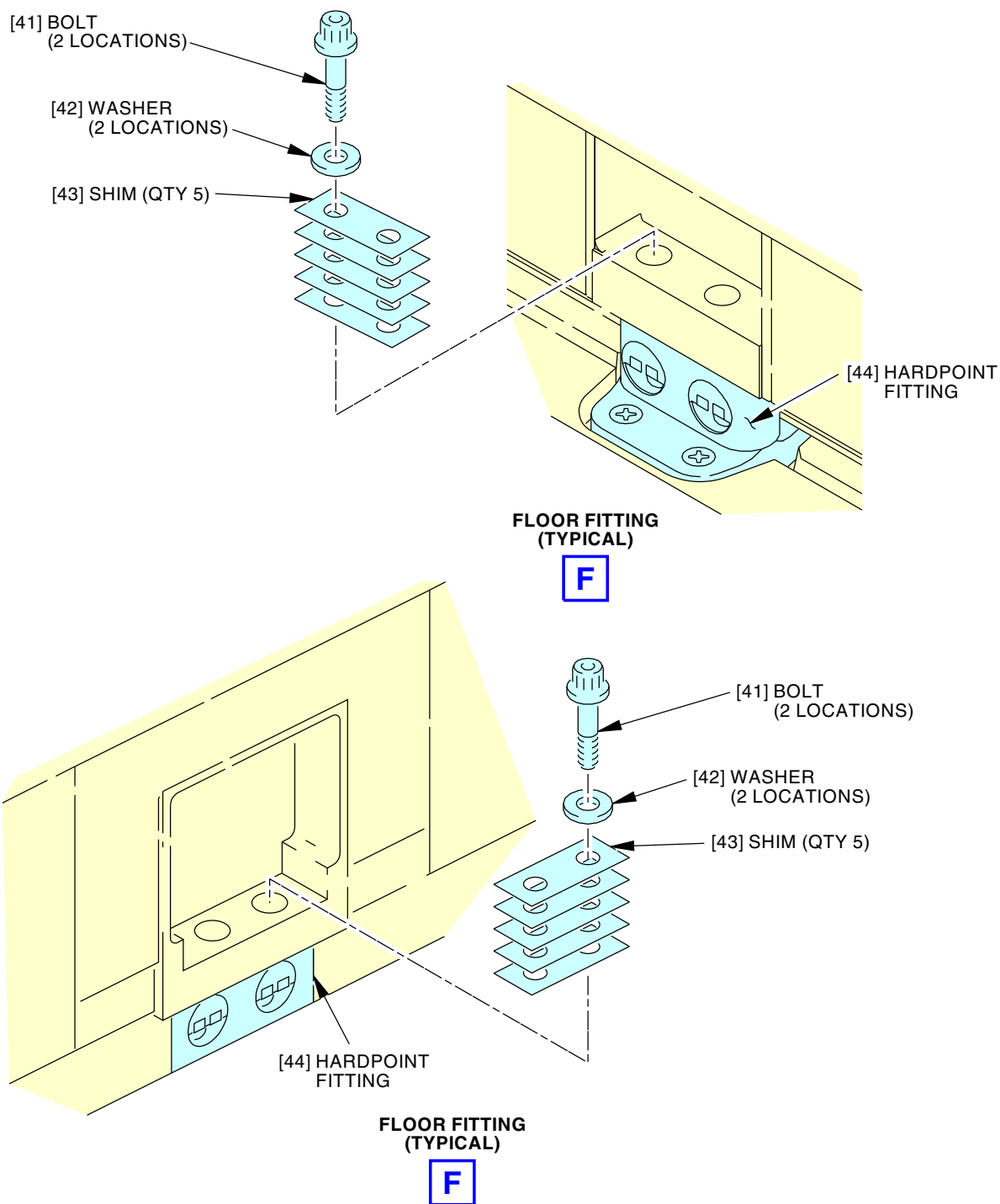
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D633W101-ARO

Page 412
Sep 05/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



1455620 S0000264882_V3

**Galley F1/F2/F3 Installation
Figure 401/25-31-01-990-831 (Sheet 4 of 8)**

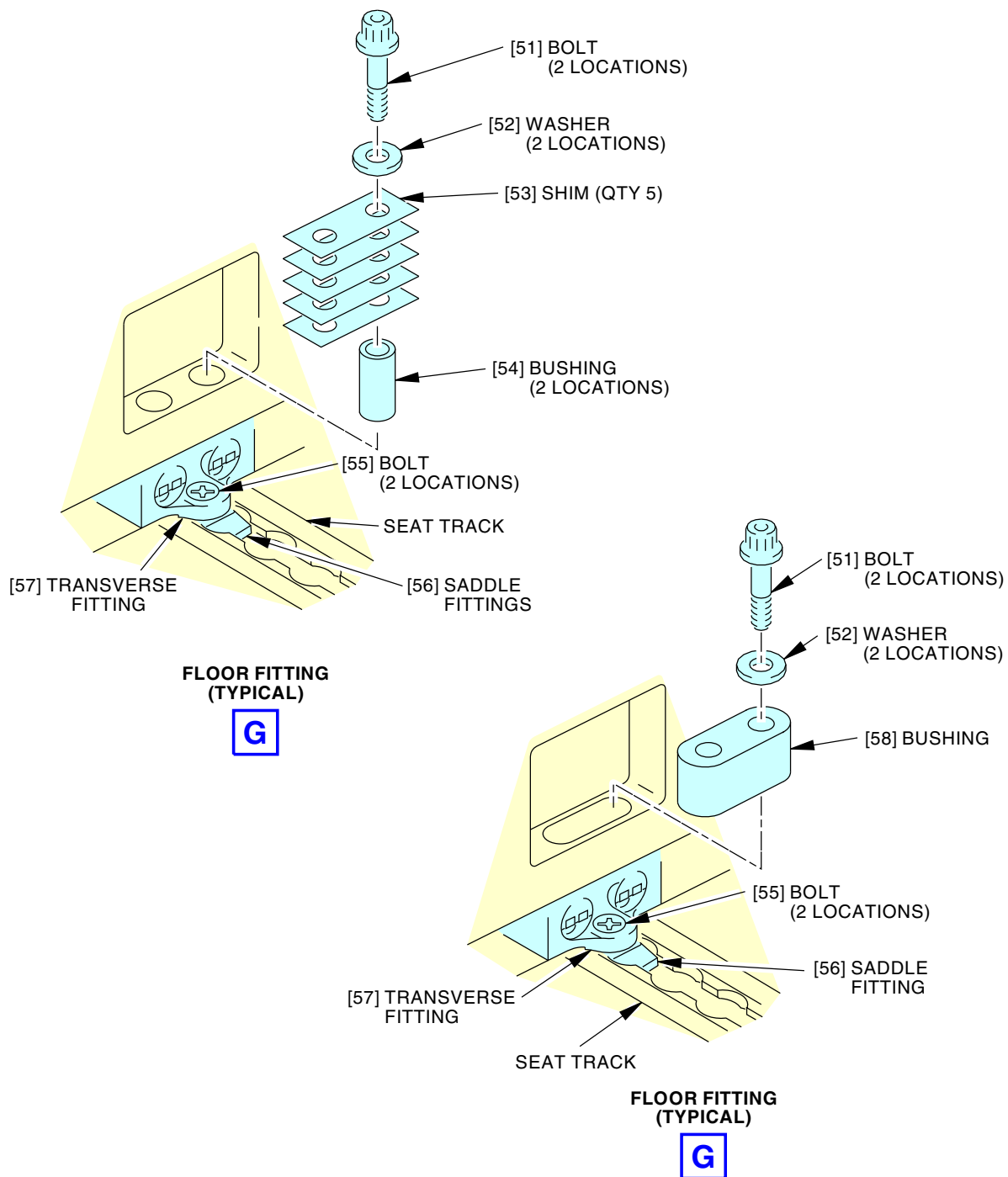
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25-31-01

D633W101-ARO

Page 413
Sep 05/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL



1455737 S0000264883_V2

Galley F1/F2/F3 Installation
Figure 401/25-31-01-990-831 (Sheet 5 of 8)

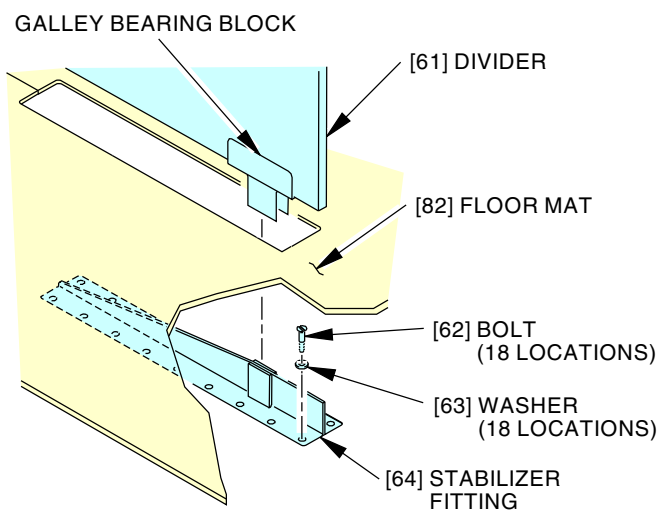
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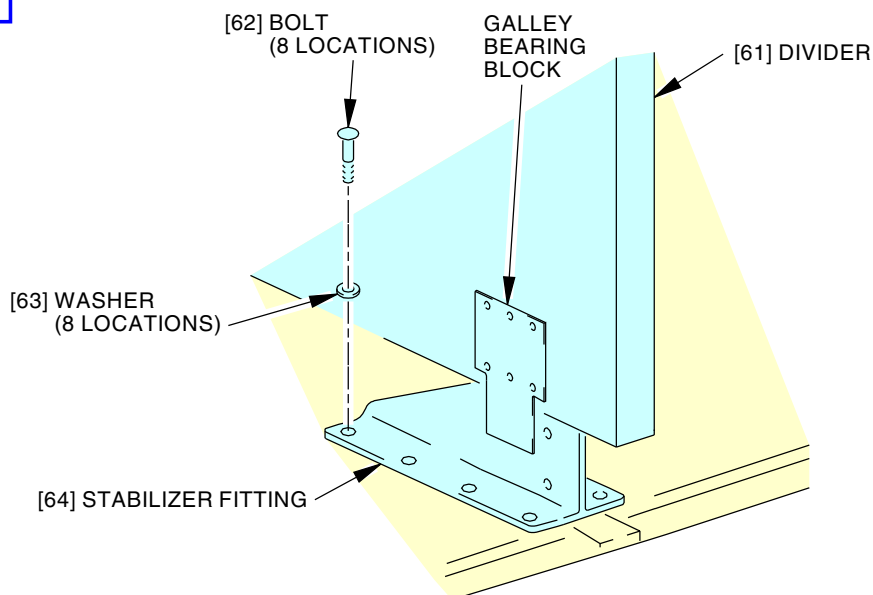
Page 414
Sep 05/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**STABILIZER ASSEMBLY
(TYPICAL)**

H



**STABILIZER ASSEMBLY
(TYPICAL)**

H

1455826 S0000264884_V3

**Galley F1/F2/F3 Installation
Figure 401/25-31-01-990-831 (Sheet 6 of 8)**

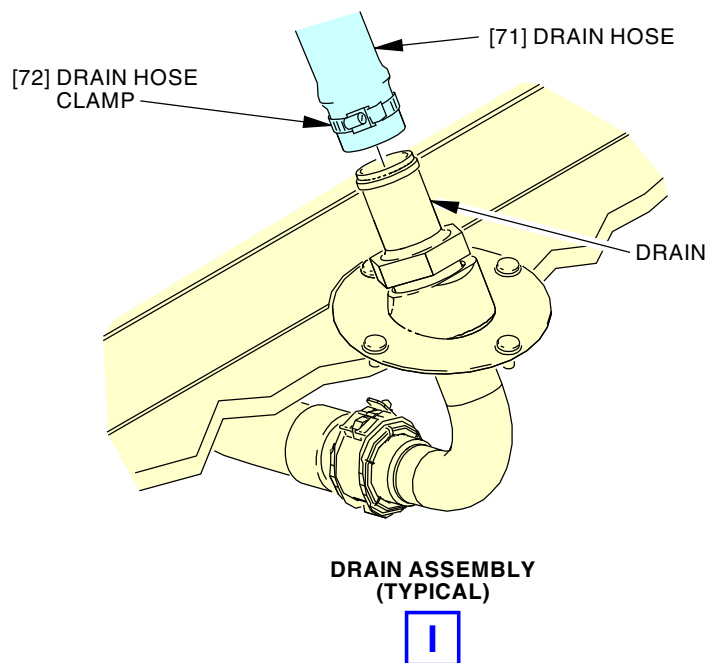
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25-31-01

Page 415
Sep 05/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL



1455831 S0000264885_V3

Galley F1/F2/F3 Installation
Figure 401/25-31-01-990-831 (Sheet 7 of 8)

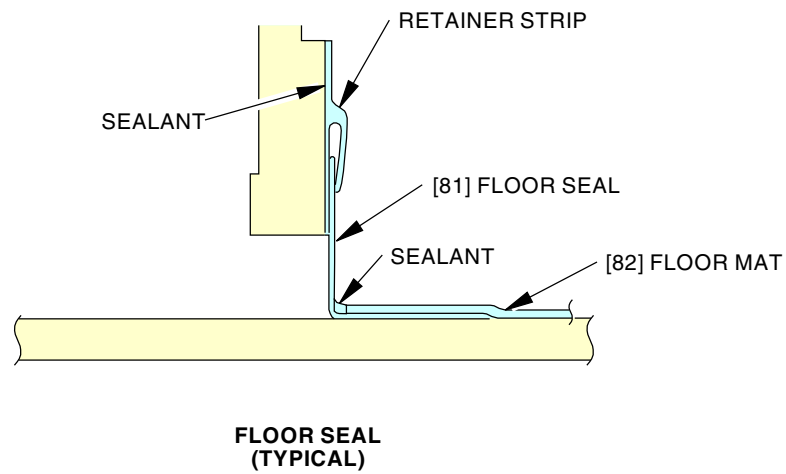
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D633W101-ARO

25-31-01

Page 416
Sep 05/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL



1476884 S0000265687_V2

Galley F1/F2/F3 Installation
Figure 401/25-31-01-990-831 (Sheet 8 of 8)

EFFECTIVITY
ARO 001-017

D633W101-ARO

25-31-01

Page 417
Sep 05/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL
MID GALLEY - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks:

- (1) Mid galley - deactivation.
- (2) Mid galley - activation.

TASK 25-31-02-040-801-001

2. Mid Galley - Deactivation

A. General

- (1) This task will deactivate the power to the mid galleys.

B. References

Reference	Title
38-10-00-040-801	Potable Water System - Deactivation (P/B 201)

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Procedure

SUBTASK 25-31-02-020-018-001

- (1) Do this task: Potable Water System - Deactivation, TASK 38-10-00-040-801.

SUBTASK 25-31-02-020-019-001

- (2) Do these steps to drain the galley water system:
 - (a) Open the galley water shutoff valve.
 - (b) Open the galley faucets.
 - (c) Open the galley supply system drain valves.
 - (d) Drain the water from all galley equipment.

SUBTASK 25-31-02-020-020-001



KEEP PERSONNEL, EQUIPMENT, AND OTHER ITEMS OUT OF THE HAZARDOUS ENERGY ZONES. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.



BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

NOTE: There are components installed on the galley that will not power down when these circuit breakers are open.

- (3) Open these circuit breakers and install safety tags:

Ground Service/Handling Power Panel, P320

Row	Col	Number	Name
G	2	C33416	CABIN LTS FWD R
G	4	C33460	FWD & DR 2 GLY LTS

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-02

Config 1
Page 201
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	4	C33418	CABIN LTS MID FWD R
L	2	C33417	CABIN LTS FWD L
L	6	C33419	CABIN LTS MID FWD L

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	21	C25606	DR 2 GLY

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	9	C23444	AREA CONTROL PANELS

SUBTASK 25-31-02-020-022-001



KEEP PERSONNEL, EQUIPMENT, AND OTHER ITEMS OUT OF THE HAZARDOUS ENERGY ZONES. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.



BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

NOTE: There are components installed on the galley that will not power down when these circuit breakers are open.

- (4) Open these circuit breakers and install safety tags:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
G	3	C33422	CABIN LTS AFT R
H	3	C33459	AFT GLY LTS
H	4	C33418	CABIN LTS MID FWD R
H	9	C33420	CABIN LTS MED AFT R
L	6	C33419	CABIN LTS MID FWD L
L	7	C33423	CABIN LTS AFT L
L	10	C33421	CABIN LTS MID AFT L

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	20	C25607	DR 4L GLY
J	21	C25606	DR 2 GLY

E. Mid Galley - Tryout

NOTE: This tryout is to make sure that the mid galleys are in a zero energy state.

SUBTASK 25-31-02-420-016-001

- (1) Put the Emergency Power switch on the galley control panel and the upper deck control panel to the ON position.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-02

Config 1
Page 202
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Make sure that a worklight or galley insert does not operate.

SUBTASK 25-31-02-020-023-001

- (2) Put the Emergency Power switch on the galley control panel to the OFF position.

SUBTASK 25-31-02-420-017-001

- (3) Put the Area Light switch on the galley control panel to the DIM or BRT position.

- (a) Make sure that the lights stay off.

SUBTASK 25-31-02-020-024-001

- (4) Put the Area Light switch on the galley control panel to OFF position.

————— **END OF TASK** —————

TASK 25-31-02-440-801-001

3. Mid Galley - Activation

A. General

- (1) This task will activate the power to the mid galleys.

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Procedure

SUBTASK 25-31-02-420-018-001

- (1) Do these steps to turn on the galley water system:

- (a) Open the galley water shutoff valve.
- (b) Close the galley faucets.
- (c) Close the galley supply system drain valves.

SUBTASK 25-31-02-420-019-001

- (2) Remove the safety tags and close these circuit breakers:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
G	2	C33416	CABIN LTS FWD R
G	4	C33460	FWD & DR 2 GLY LTS
H	4	C33418	CABIN LTS MID FWD R
L	2	C33417	CABIN LTS FWD L
L	6	C33419	CABIN LTS MID FWD L

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	21	C25606	DR 2 GLY

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	9	C23444	AREA CONTROL PANELS

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-02

Config 1
Page 203
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-31-02-420-021-001

- (3) Remove the safety tags and close these circuit breakers:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
G	3	C33422	CABIN LTS AFT R
H	3	C33459	AFT GLY LTS
H	4	C33418	CABIN LTS MID FWD R
H	9	C33420	CABIN LTS MED AFT R
L	6	C33419	CABIN LTS MID FWD L
L	7	C33423	CABIN LTS AFT L
L	10	C33421	CABIN LTS MID AFT L

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	20	C25607	DR 4L GLY
J	21	C25606	DR 2 GLY

————— END OF TASK —————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-02

Config 1
Page 204
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
MID GALLEY - REMOVAL/INSTALLATION

1. General

A. This procedure contains these tasks:

- (1) Removal of the mid galleys.
- (2) Installation of the mid galleys.

B. There are several configurations of the mid galleys:

NOTE: The configuration of the galleys can vary from airplane to airplane.

(1) Door 2, 3, 4 galleys

(a) These galleys are mounted on the airplane centerline and can be facing forward or aft.

- 1) Most galleys are in pairs.
- 2) Some airplanes also have an extra galley connected forward or aft of the dual galleys or as a bar unit.

(b) Many of these galleys can have attachments that need to be removed. These attachments include:

- 1) Partitions
- 2) Closets
- 3) Underbin galleys
- 4) Stowage boxes
- 5) Bustle stowage
- 6) Integral storage.

(2) Outboard galleys

NOTE: Outboard galleys are not on all airplanes.

(a) These galleys are installed on the left and right side of the airplane.

(b) They can face inboard, forward, or aft.

(3) Centerline galleys that face outboard.

(a) They are installed back-to-back with another galley or a different monument (lavatory or vestibule).

TASK 25-31-02-000-805

2. Mid Galley Removal

A. General

(1) This procedure is for the removal of the mid galleys.

- (a) Door 2, 3, and 4 Galleys, (Figure 401)
- (b) Outboard Facing Galleys, (Figure 402)

B. References

Reference	Title
12-14-01-616-802	Potable Water System - Drain (P/B 301)
25-21-06-000-801	Main Ceiling Panel - Removal (P/B 401)
25-21-07-000-801	Lowered Ceiling Panel Removal (P/B 401)
25-24-01 P/B 401	CLOSETS - REMOVAL/INSTALLATION

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-02

Page 401
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Title
25-25-01-000-801	Passenger Seat - Removal (P/B 401)
25-25-06-000-801	Attendant Seat Removal (P/B 401)
25-25-06-000-802	Attendant Seat Removal (P/B 401)
25-25-06-000-806	Attendant Seat Removal (P/B 401)
25-28-05-000-801	Floor-Mounted Stowage Box Removal (P/B 401)
25-33-01-000-801	Overhead Galley Air Chiller Removal (P/B 401)
25-41-01-000-801	Lavatory Removal (P/B 401)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-5259	Cup - Vacuum Part #: N4950 Supplier: OSL88

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Prepare for Removal

SUBTASK 25-31-02-865-001

- (1) Open these circuit breakers and install safety tags as needed:

Ground Service/Handling Power Panel, P320

Row	Col	Number	Name
G	4	C33460	FWD & DR 2 GLY LTS

Left Power Management Panel, P110

Row	Col	Number	Name
J	20	C25607	DR 4L GLY
J	21	C25606	DR 2 GLY

SUBTASK 25-31-02-010-002

- (2) If necessary, remove the curtains [3] and the curtain tracks [4] from the galley.

SUBTASK 25-31-02-010-003

- (3) Remove these items as applicable:

- (a) Do this task: Attendant Seat Removal, TASK 25-25-06-000-801 or Attendant Seat Removal, TASK 25-25-06-000-802 or Attendant Seat Removal, TASK 25-25-06-000-806.
- (b) Do this task: Floor-Mounted Stowage Box Removal, TASK 25-28-05-000-801.
- (c) Do this task: Lavatory Removal, TASK 25-41-01-000-801.
- (d) Do this task: Passenger Seat - Removal, TASK 25-25-01-000-801.
- (e) Remove the closet if it is necessary. Do the applicable task in this procedure: CLOSETS - REMOVAL/INSTALLATION, PAGEBLOCK 25-24-01/401.
- (f) Do this task adjacent to the galley: Lowered Ceiling Panel Removal, TASK 25-21-07-000-801 or Main Ceiling Panel - Removal, TASK 25-21-06-000-801.

EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

Page 402
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-31-02-616-001

- (4) If the galley has potable water connections, do this task: Potable Water System - Drain, TASK 12-14-01-616-802.

(a) Drain the water from the applicable galley equipment.

SUBTASK 25-31-02-030-018

- (5) If necessary, remove the closeout seals from the top and sides of the applicable galley.

SUBTASK 25-31-02-010-004

- (6) Remove the galley ceiling panels Main Ceiling Panel - Removal, TASK 25-21-06-000-801.

SUBTASK 25-31-02-010-005

- (7) Remove the carts and all of the other equipment from the galley.

SUBTASK 25-31-02-030-019

- (8) Do these steps when necessary to prepare the bottom of the monument for the removal:

NOTE: Some of the different monuments can be the bar or buffet units, galleys, closets, partitions, or integral stowage units.

(a) Remove the floor mats [62] or [82].

(b) Remove the floor seals [61] or [81].

NOTE: The floor seals [61] or [81] are attached to the floor with carpet tape.

(c) Remove the kickstrips [1] from the bottom of the monument.

(d) If necessary, remove the cover plates [2] from the bottom of the monument.

F. Door 2, 3, and 4 Galley Removal

SUBTASK 25-31-02-030-023

NOTE: This procedure also applies to centerline galleys that face outboard.

- (1) Do these applicable steps to disconnect the top of the galley:

(a) If necessary, do these steps to disconnect the galley electrical interface brackets [16]:

NOTE: Some galleys have overhead electrical interface brackets, some have galley electrical interface brackets [16], and some have both.

- 1) Disconnect the galley electrical cables [18] from the galley electrical interface bracket [16] mounted on top of the galley.

NOTE: Disconnect the galley electrical connectors from the sockets and plugs on the galley electrical interface bracket [16], not from the terminal boards.

- 2) Remove the galley electrical interface bracket [16] from the top of the galley.

NOTE: It is not necessary to disconnect the overhead electrical connectors from the galley electrical interface bracket [16].

- 3) Carefully tie the galley electrical interface bracket [16] with the overhead cables to the overhead structure to allow clearance for the galley.

EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

Page 403
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (b) If necessary, do these steps to disconnect the galley electrical cables [18] from the overhead electrical interface brackets:

NOTE: Two galleys at both door 2 and door 4 are common in most 777-300 model airplanes. The M1 and M2 usually face each other in the door 2 area with the M1 at the forward stations. The M5 and M7 usually face each other in the door 4 area with the M5 at the forward stations.

NOTE: Airplanes with two galleys at door 2 and door 4 usually have the overhead electrical interface bracket above only one of the galleys at each door.

NOTE: Some airplanes also have an M3 or M4 galley or both.

NOTE: Some airplanes can also have a single stand alone galley.

NOTE: Some airplanes can also have three galleys connected by curtain tracks.

- 1) Disconnect the galley electrical cables [18] from the overhead electrical interface bracket.

NOTE: Disconnect the galley electrical connectors [18] from the sockets and plugs on the overhead electrical interface bracket, not from the terminal boards.

- 2) Remove the wire wraps and clamps as necessary from the galley electrical cable bundles and wiring bridge [13] and put these cables [18] on top of the appropriate galley.

- 3) If necessary, remove the wiring bridge [13] from the top of the galleys.

- (c) Disconnect the ground wire [19] from the overhead support structure at the ground stud.

- (d) Do these steps to disconnect the refrigeration system from the galley:

NOTE: Not all of the mid galleys have a chiller installed on the top.

- 1) Do this task: Overhead Galley Air Chiller Removal, TASK 25-33-01-000-801.
- 2) Disconnect the chiller exhaust hose [14] from the chiller rack [12].
- 3) Remove the chiller rack [12] from the top of the galley.
- 4) Remove the plenum [11] from the top of the galley.

- (e) Remove the quick release pins [25] that hold the tie rods [21] to the airplane support structure.

- (f) Remove the washers [26] from the quick release pins [25].

- (g) Remove the screws [23] and washers [24] that hold the mounts [22] to the top of the galley.

- (h) Remove the mount [22] and the tie rod [21] together as a unit.

- (i) If necessary, disconnect the potable water hose [17] from the galley.

NOTE: A small quantity of water can drain from the line. Make sure that the drain procedure Potable Water System - Drain, TASK 12-14-01-616-802 is complete.

- (2) Remove the lower multipurpose rail from the galley and the asymmetrical truss.

SUBTASK 25-31-02-030-024

- (3) Do these steps to disconnect the galley or monument from the floor:

- (a) Do this step to remove the galley from the floor fittings:

EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

Page 404
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 1) Remove the bolts [31], washers [32], shims [33], bushings [34], and bushings [38] to disconnect the galley from the transverse fittings [37] and the longitudinal fittings [41].

NOTE: The inboard transverse seat track fitting [37] has a single bushing [38] and no shims.

The aft longitudinal fitting seat track [41] has two bushings [34].

NOTE: Most of the center mounted galleys that face outboard only have transverse seat track fittings.

SUBTASK 25-31-02-030-025

- (4) If necessary, do these steps to remove the drain hose [71]:
 - (a) If necessary, remove the drain hose clamp [72] from the applicable drain hose [71].
 - (b) Carefully pull the drain hose [71] from the drain.

NOTE: Catch water that is still in the drain hose [71] with a cup.

SUBTASK 25-31-02-020-005

- (5) If necessary, use the vacuum cup, SPL-5259 to carefully remove the galley.

NOTE: Use of the vacuum cup is optional.

SUBTASK 25-31-02-030-027

- (6) If necessary, do these steps to remove the stabilizer fittings [64] from the floor:

NOTE: The location and number of dividers and stabilizer assemblies vary from galley to galley.

 - (a) Remove the bolts [62] and washers [63] from the stabilizer fitting [64].
 - (b) Remove the divider [61] and the stabilizer fitting [64].

SUBTASK 25-31-02-030-028

- (7) If necessary, do these steps to remove the longitudinal fittings [41]:
 - (a) Remove the nuts [40] from the studs [39].
 - (b) Remove the longitudinal fittings [41] from the studs [39].

SUBTASK 25-31-02-030-029

- (8) If necessary, do these steps to remove the transverse fittings [37]:
 - (a) Remove the bolts [35] that hold the transverse fittings [37] to the saddle fittings [36].
 - (b) Lift the transverse fittings [37] from the saddle fitting [36].

SUBTASK 25-31-02-030-030

- (9) If necessary, do these steps to remove the saddle fittings [36] or the seat track studs [39]:
 - (a) Remove the tape and filler from the seat track immediately left or right of the saddle fittings [36] or seat track studs [39].
 - (b) Move the saddle fittings [36] or seat track studs [39] left or right approximately 0.5 in. (13 mm) to align it with the circular openings in the seat track.
 - (c) Lift the saddle fittings [36] or seat track studs [39] out of the seat track.

G. Outboard Galley Removal

SUBTASK 25-31-02-030-035

- (1) Do these applicable steps to disconnect the top of the galley:

EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

Page 405
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Remove the bolt [15], washers [16] and [19], bushing [17], and nut [18] to disconnect the tie rod [11] from the support bracket [22].
- (b) If necessary, remove the bolt [12], washers [14] and [20], and nut [21] to disconnect the support bracket [22] from the bin rail.
- (c) Disconnect the electrical connectors.
- (d) Disconnect the ground strap from the ground stud at the top of the galley.
- (e) If necessary, disconnect the potable water hose from the galley.

NOTE: A small quantity of water can drain from the line. Make sure that the drain procedure Potable Water System - Drain, TASK 12-14-01-616-802 is complete.

SUBTASK 25-31-02-030-036

- (2) Do these steps to disconnect the galley from the floor:
 - (a) If necessary, do this step to remove the double attachments used on most of the galleys:
 - 1) Remove the bolts [31], washers [32], shims [33], and bushings [34] to disconnect the galley from the transverse fittings [37] and longitudinal fittings [41].
 - (b) If necessary, do this step to remove the single attachments used on some of the galleys:
 - 1) Remove the bolt [45] and filler [42] from the saddle fitting [36].

NOTE: Some galley installations can have a washer [43] at this location in addition to a filler [42].

SUBTASK 25-31-02-030-037

- (3) If necessary, do these steps to remove the drain hose:
 - (a) Remove the drain hose clamp from the applicable drain hose.
 - (b) Carefully pull the drain hose from the drain.

NOTE: Catch water that is still in the drain hose with a cup.

SUBTASK 25-31-02-020-006

- (4) If necessary, use the vacuum cup, SPL-5259 to carefully remove the galley.

NOTE: Use of the vacuum cup is optional.

SUBTASK 25-31-02-030-038

- (5) If necessary, do this task to remove the stabilizer fittings [64] from the floor: SUBTASK 25-31-02-030-027.

SUBTASK 25-31-02-030-039

- (6) If necessary, do this task to remove the longitudinal fittings [41]: SUBTASK 25-31-02-030-028.

SUBTASK 25-31-02-030-040

- (7) If necessary, do this task to remove the transverse fittings [37]: SUBTASK 25-31-02-030-029.

SUBTASK 25-31-02-030-041

- (8) If necessary, do this task to remove the saddle fittings [36] or the seat track studs [39]: SUBTASK 25-31-02-030-030.

SUBTASK 25-31-02-030-042

- (9) If necessary, do these steps to remove the single attachment saddle fittings [36]:
 - (a) Remove the washers [43] and fitting [44] from the saddle fitting [36].
 - (b) Move the seat track fitting [36] left or right approximately 0.5 in. (13 mm) to align it with the circular openings in the seat track.

EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

Page 406
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (c) Lift the seat track fitting [36] from the seat track.

— END OF TASK —

TASK 25-31-02-400-805

3. Mid Galley Installation

A. General

- (1) This procedure is for the installation of the mid galleys.
- (a) Door 2, 3, and 4 Galleys, (Figure 401)
 - (b) Outboard Facing Galleys, (Figure 402)

B. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
25-21-06-400-801	Main Ceiling Panel - Installation (P/B 401)
25-21-07-400-801	Lowered Ceiling Panel Installation (P/B 401)
25-24-01 P/B 401	CLOSETS - REMOVAL/INSTALLATION
25-25-01-400-801	Passenger Seat - Installation (P/B 401)
25-25-06-400-801	Attendant Seat Installation (P/B 401)
25-25-06-400-802	Attendant Seat Installation (P/B 401)
25-25-06-400-806	Attendant Seat Installation (P/B 401)
25-28-05-400-801	Floor-Mounted Stowage Box - Installation (P/B 401)
25-33-01-400-801	Overhead Galley Air Chiller Installation (P/B 401)
25-33-97-700-801	Galley Air Chiller Operational Test (P/B 501)
25-41-01-400-801	Lavatory Installation (P/B 401)
38-10-00-600-801	Potable Water System - Disinfectant (P/B 201)
38-10-00-790-801	Potable Water System - Leak Test (P/B 201)
SWPM 20-20-00	Standard Wiring Practices Manual

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-1550	Bonding Meters - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: T477W Supplier: 01014 Opt Part #: M1B Supplier: 3AD17
SPL-5259	Cup - Vacuum Part #: N4950 Supplier: 0SL88

D. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II

EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

Page 407
May 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description	Specification
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
G01288	Tape - Carpet	BMS5-133
G02092	Tape - Flexible Foam Sound Damping And Sealing Tape	BMS8-283
G02304	Tape - Moisture Barrier, Adhesive One-side	BMS8-346
G02482	Seal - Extruded (Skyflex GUA1072, 1073, 1082, 1083, or 1092)	
G50042	Filler, Seat Track, Polycarbonate Extrusion	BAC1522-275 from BMS8-251

E. Location Zones

Zone	Area
200	Upper Half of Fuselage

F. Outboard Galley Installation

SUBTASK 25-31-02-430-016

- (1) If necessary, do these steps to install the single attachments used on some of the galleys:
 - (a) Remove the tape and filler from the seat track.
 - (b) Put compound, C00528, on the saddle fitting [36], fitting [44], and washers [43].
 - (c) Put the saddle fitting [36] in the circular opening in the seat track.
 - (d) Move the saddle fitting [36] left or right 0.5 in. (13 mm) to lock it in the correct position for the installation.
 - (e) Apply new filler, G50042 in the seat track on each end of the saddle fitting [36].
 - (f) Install the fitting [44] on the on saddle fitting [36].

NOTE: The fittings [44] are not symmetrical. Rotate the fitting [44] for the correct fit on the saddle fitting [36].
 - (g) Install the washers [43] on the fitting [44].

NOTE: Install the washers [43] between the galley and the fitting [44] to remove gaps. A total of three washers are necessary.
 - (h) Apply new moisture barrier tape, G02304, with a cutout for the saddle fitting [36], fitting [44], and washers [43].

SUBTASK 25-31-02-430-017

- (2) If necessary, do this task to install the seat track studs [39] or saddle fittings [36]: SUBTASK 25-31-02-430-031.

SUBTASK 25-31-02-430-018

- (3) If necessary, do this task to install the transverse fittings [37]: SUBTASK 25-31-02-430-032.

SUBTASK 25-31-02-430-019

- (4) If necessary, do this task to install the longitudinal fittings [41]: SUBTASK 25-31-02-430-033.

SUBTASK 25-31-02-430-020

- (5) If necessary, do this task to install the stabilizer fitting [64] to the floor: SUBTASK 25-31-02-430-034.

EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

Page 408
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-31-02-430-021

- (6) Do this task to connect the outboard galley to the floor: SUBTASK 25-31-02-430-035.

SUBTASK 25-31-02-430-022

- (7) If necessary, do these steps to install the drain hose [71]:
- (a) Install the drain hose clamp [72] on the drain hose [71] but do not tighten.
 - (b) Install the drain hose [71] on the drain with sufficient space for the drain hose clamp [72].
 - (c) Move the drain hose clamp [72] down on the drain and tighten.

SUBTASK 25-31-02-430-024

- (8) Do these steps to connect the top of the galley:
- (a) If necessary, install the support bracket [22] on the bin rail.
 - (b) Install tape, G02092 between the clevis of the support bracket [22] and the bin rail.
 - (c) Install the bolts [12], washers [14] and [20], and nuts [21] to attach the support bracket [22] to the bin rail.
 - (d) Install the bolt [15], washers [16] and [19], bushing [17], and nut [18] to attach the tie rod [11] to the support bracket [22].
NOTE: Install the tie rod [11] so that the bushing [17] is outboard.
 - (e) Adjust the tie rod end fittings as required to help install the tie rod [11].
NOTE: Do not adjust either end fitting past the witness hole.
 - (f) Remove the lockwire on either end of the tie rod [11] if more adjustment is necessary.
 - (g) Tighten the tie rod jam nuts when adjustments are complete.
 - (h) If necessary, install a lockwire to the ends of the tie rod [11].
NOTE: Repeat this procedure for galleys with more than one support bracket and tie rod assemblies.
 - (i) Connect the electrical connectors.
 - (j) Connect the ground wire to the overhead support structure at the ground stud.
 - 1) Do a resistance check of the static ground from the ground stud to the aircraft static ground stud with a intrinsically safe approved bonding meter, COM-1550 (SWPM 20-20-00).
 - a) Make sure the resistance is a maximum of 0.0025 Ohms.
 - (k) Install the wire wraps and clamps as necessary to the cable bundles above the galley.
 - (l) If necessary, connect the potable water hose to the galley.

G. Door 2, 3, and 4 Galley Installation

SUBTASK 25-31-02-430-031

NOTE: This procedure also applies to centerline galleys that face outboard.

- (1) If necessary, do these steps to install the seat track studs [39] or saddle fitting [36]:
- (a) Remove the tape and filler from the seat track.
 - (b) Put compound, C00528, on the seat track studs [39] or saddle fitting [36].
 - (c) Put the seat track studs [39] or saddle fitting [36] in the circular opening in the seat track.
 - (d) Move the seat track studs [39] or saddle fitting [36] left or right 0.5 in. (13 mm) to lock it in the correct position for the installation.

EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

Page 409
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (e) Apply new filler, G50042 in the seat track on each end of the seat track studs [39] or saddle fitting [36].
- (f) Apply new moisture barrier tape, G02304, with a cutout for the seat track fittings.

SUBTASK 25-31-02-430-032

- (2) If necessary, do these steps to install the transverse fittings [37]:
 - (a) Apply corrosion preventive compound, C00308 to the transverse fittings [37] and the bolts [35].
 - (b) Install the transverse fittings [37] with the bolts [35] to the saddle fittings [36].
 - 1) Tighten the bolts [35].
 - 2) Torque the bolts [35] to 70.5 ±2.5 in-lb (7.97 ±0.29 N·m).

SUBTASK 25-31-02-430-033

- (3) If necessary, do these steps to install the longitudinal fittings [41]:
 - (a) Apply corrosion preventive compound, C00308 to the seat track, studs [39], longitudinal fittings [41], and the nuts [40].
 - (b) Install the longitudinal fittings [41] with the nuts [40] on the studs [39].
 - (c) Tighten the nuts [40] to 200 ±40 in-lb (22.6 ±4.5 N·m).
 - 1) If the torque value is more than 240 in-lb (27 N·m) replace the studs [39].

SUBTASK 25-31-02-430-034

- (4) If necessary, do these steps to install the stabilizer fitting [64] to the floor:

NOTE: The location and number of dividers and stabilizer assemblies vary from galley to galley.

 - (a) Apply a new moisture barrier seal, G02482 to make a seal around the stabilizer fitting [64] and the bolt heads.
 - (b) Install the bolts [62] and washers [63] through the stabilizer fitting [64] and into the floor.
 - 1) Tighten the bolts [62].

Table 401/25-31-02-993-801 Stabilizer Bolts

Part Number	Type	Where Used
BACB30NM3K13	Hex Head	Eight Hole Stabilizers at the Floor Beams
BACB30NT3K13	Pan Head	Eight Hole Stabilizers at the Floor Panels
BACB30NN3K13	100 Degree	Large 18 Hole Stabilizers
BACB30NT3K3	Pan Head	Stabilizers at the Floor Panels

- (c) If necessary, during installation of the galley, use the vacuum cup, SPL-5259 to put the divider [61] with the galley bearing block on the stabilizer fitting [64].

NOTE: Use of the vacuum cup is optional.

NOTE: Remove and replace the stabilizer fitting stop as needed to help the installation of the galley bearing block.

SUBTASK 25-31-02-430-035

- (5) Do these steps to connect the galley or monument to the floor:
 - (a) Make sure there is an isolator plate on the bottom of the galley at each floor fitting.

NOTE: The isolator plate is a piece of stainless steel. It is necessary to prevent corrosion between the galley and the seat track fitting.

EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

Page 410
Sep 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (b) If necessary, for the outboard galleys with single attachments, use the vacuum cup, SPL-5259 to align the galley on top of the washers [43], fitting [44], and saddle fitting [36].

NOTE: Use of the vacuum cup is optional.

- 1) Install the bolt [45] and filler [42] to attach the galley to the saddle fittings [36].
- 2) If necessary, relocate the washers [43] from above the fitting [44] to the bolt [45].

NOTE: Use zero to three washers [43] to keep a flat surface between the galley floor and the seat track attach points.

NOTE: To prevent pre-loading of the upper support attachment use the minimum number of washers [43] above the fitting [44] as possible.

- 3) Tighten the all the bolts [45] to 215 ±35 in-lb (24.3 ±4.0 N·m).

- (c) For the galley with double attachments do these steps:

- 1) Align the galley on top of the seat track longitudinal fittings [41] and transverse fittings [37].
- 2) Apply a layer of corrosion preventive compound, C00308 on the shims [33] and then install them at the bolt holes.
- 3) If there is clearance between the galley and the floor then fill this clearance with shims [33].
- 4) Temporarily install the hinged ceiling panel so you can measure the clearance between it and the galley.
- 5) Install the shims [33] (between the galley and the seat track longitudinal fittings [41] or transverse fittings [37]) until there is a minimum of 0.5 in. (13 mm) clearance between the hinged ceiling panel and the galley.

NOTE: If this clearance is too small, then the ceiling panel can hit the galley when you open the ceiling panel.

- 6) Put the remaining shims [33] below the head of the bolts [31].
- 7) Apply corrosion preventive compound, C00308 on the bushings [34] and bushings [38].
- 8) Install the bushings [34] and bushings [38] to the appropriate seat track fitting.

NOTE: Install a single bushing [38] on each of the inboard seat track fittings and bushings [34] on each of the outboard seat track fittings.

NOTE: Bushings are not necessary on some smaller monuments or partitions.

- 9) Apply corrosion preventive compound, C00308 on the bolts [31] and washers [32].
- 10) Install the bolts [31] and washers [32] to attach the galley to the seat track longitudinal fittings [41] and transverse fittings [37].
- 11) Tighten all the bolts [31] to 200 ±50 in-lb (22.6 ±5.7 N·m).

- (d) For the bar/buffet units or monuments with hardpoint attachments do these steps:

- 1) If necessary, use the vacuum cup, SPL-5259 to align the monument on the hardpoint fittings [44].

NOTE: Use of the vacuum cup is optional.

- 2) Apply a layer of corrosion preventive compound, C00308 on the shims [33] and then install them at the bolt holes.

EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

Page 411
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 3) If there is clearance between the monument and the floor then fill this clearance with shims [33].

NOTE: This will provide a proper fit and avoid interference with adjacent furnishings.

- 4) Temporarily install the hinged ceiling panel so you can measure the clearance between it and the monument.
- 5) Install the shims [33] (between the monument and the seat track hardpoint fittings [44]) until there is a minimum of 0.5 in. (13 mm) clearance between the hinged ceiling panel and the monument.

NOTE: If this clearance is too small, then the ceiling panel can hit the monument when you open the ceiling panel.

- 6) Put the remaining shims [33] below the head of the bolts [31].
- 7) Apply corrosion preventive compound, C00308 on the bushings [34].
- 8) Install the bushings [34] to the appropriate seat track fitting.
- 9) Apply corrosion preventive compound, C00308 on the bolts [31] and washers [32].
- 10) Install the bolts [31] and washers [32] to attach the monument to the seat track hardpoint fittings [44].
- 11) Tighten all the bolts [31] to 200 ±50 in-lb (22.6 ±5.7 N·m).

SUBTASK 25-31-02-430-036

- (6) If necessary, do these steps to install the drain hose [71]:
 - (a) Install the drain hose clamp [72] on the drain hose [71] but do not tighten.
 - (b) Install the drain hose [71] on the drain with sufficient space for the drain hose clamp [72].
 - (c) Move the drain hose clamp [72] down on the drain and tighten.

SUBTASK 25-31-02-430-037

- (7) Do these applicable steps to connect the top of the galley:
 - (a) Connect the tie rod [21] to the support structure with the quick release pins [25] and washers [26].

NOTE: The tie rods [21] should have no pre-load on it when you install it.

- 1) Adjust the tie rod end fittings as required to help install the tie rod [21].

NOTE: Do not adjust either end fitting past the witness hole.
- 2) Remove the lockwire on either end of the tie rod [21] if more adjustment is necessary.
- 3) Tighten the tie rod [21] jam nuts when adjustments are complete.
- 4) If necessary, install a lockwire to the ends of the tie rod [21].

- (b) Do these steps to connect the refrigeration system to the galley:

NOTE: Not all of the mid galleys have a chiller installed on the top.

- 1) Install the plenum [11] to the top of the galley.
- 2) Install the chiller rack [12] to the top of the galley.
- 3) Connect the chiller exhaust hose [14] to the chiller rack [12].
- 4) Do this task: Overhead Galley Air Chiller Installation, TASK 25-33-01-400-801.

- (c) If necessary, connect the potable water hose [17] to the galley.

EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

Page 412
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (d) If necessary, do these steps to connect the galley electrical cables [18] to the overhead electrical interface brackets:

NOTE: Some galleys have overhead electrical interface brackets, some have galley electrical interface brackets [16], and some have both.

NOTE: Two galleys at both door 2 and door 4 are common in most 777-300 model airplanes. The M1 and M2 usually face each other in the door 2 area with the M1 at the forward stations. The M5 and M7 usually face each other in the door 4 area with the M5 at the forward stations.

NOTE: Airplanes with two galleys at door 2 and door 4 usually have the overhead electrical interface bracket above only one of the galleys at each door.

NOTE: Some airplanes also have an M3 or M4 galley or both.

NOTE: Some airplanes can also have a single stand alone galley.

NOTE: Some airplanes can also have three galleys connected by curtain tracks.

- 1) If necessary, install the wiring bridge [13] to the top of the galleys.
- 2) Connect the galley electrical cables [18] to the appropriate overhead electrical interface bracket.

NOTE: Connect the galley electrical connectors to the sockets and plugs on the overhead electrical interface bracket, not to the terminal boards.

- 3) Install the wire wraps and clamps as necessary to the cable bundles and wiring bridge [13].

- (e) If necessary, do these steps to connect the galley electrical interface brackets [16]:

- 1) Carefully untie the galley electrical interface bracket [16] with the overhead cables from the overhead structure.
- 2) Install the electrical interface bracket [16] to the top of the galley.
- 3) Connect the galley electrical cables [18] to the galley electrical interface bracket [16] mounted on top of the galley.

NOTE: Connect the galley electrical connectors to the sockets and plugs on the galley electrical interface bracket [16], not to the terminal boards.

- (f) Connect the ground wire [19] to the overhead support structure at the ground stud.

SUBTASK 25-31-02-760-001

- (8) Do a resistance check of the static ground from the ground stud to the aircraft static ground stud with a intrinsically safe approved bonding meter, COM-1550 (SWPM 20-20-00).

- (a) Make sure the resistance is a maximum of 0.0025 Ohms.

- (9) Install the wire wraps and clamps as necessary to the cable bundles and wiring bridge [13] above the galley.

H. Mid Galley Installation Test

SUBTASK 25-31-02-410-008

- (1) Install the carts and all of the other equipment in the galley.

SUBTASK 25-31-02-865-002

- (2) Remove the safety tags and close these circuit breakers:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	20	C25607	DR 4L GLY

EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

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Page 413
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	21	C25606	DR 2 GLY

SUBTASK 25-31-02-861-001

- (3) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-31-02-790-001

- (4) If necessary, do this task: Potable Water System - Leak Test, TASK 38-10-00-790-801.

SUBTASK 25-31-02-670-001

- (5) If necessary, do this task: Potable Water System - Disinfectant, TASK 38-10-00-600-801.

SUBTASK 25-31-02-710-001

- (6) Do a check to make sure the galley lights come on.

SUBTASK 25-31-02-710-002

- (7) Do a test of the galley equipment.

- (a) If necessary, do this task: Galley Air Chiller Operational Test, TASK 25-33-97-700-801.

SUBTASK 25-31-02-430-039

- (8) Install the closeout seals to the top and sides of the galleys.

SUBTASK 25-31-02-410-009

- (9) Install the galley ceiling panels Main Ceiling Panel - Installation, TASK 25-21-06-400-801.

SUBTASK 25-31-02-430-040

- (10) Do these steps to install the floor seal [61] or [81]:

- (a) If necessary, apply new sealant, A02315 under the retainer strip.

- (b) If necessary, apply new carpet tape, G01288 on the floor seal [61] or [81] base.

NOTE: Keep a 4 in. (10 cm) space in the carpet tape, G01288, in the center of the floor seal [81] on the back wall of the monument.

- (c) Push the base of the floor seal [61] or [81] to the floor.

- (d) Install the top of the floor seal [61] or [81] into the floor seal retainer.

SUBTASK 25-31-02-430-041

- (11) Do these steps to install the floor mats [62] or [82]:

- (a) Apply the new carpet tape, G01288 to the floor mats [62] or [82] in the forward and aft direction with 1 in. (3 cm) between each piece.

- (b) Keep the carpet tape, G01288, approximately 1 in. (3 cm) from the edge of the floor mats [62] or [82].

- (c) Cover the floor seal [61] or [81] with the floor mats [62] or [82].

- (d) Apply the sealant, A02315, to make a fillet seal around the edges of the floor mats [62] or [82].

SUBTASK 25-31-02-430-042

- (12) Install the cover plates [2] and kickstrips [1] to the galley.

- (a) Apply sealant, A02315 to make a seal around the cover plates [2] for the galley fittings.

I. Put the Airplane Back to Its Usual Condition

SUBTASK 25-31-02-410-010

- (1) Install these items as applicable:

EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

Page 414
Sep 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (a) Do this task adjacent to the galley: Lowered Ceiling Panel Installation, TASK 25-21-07-400-801 or Main Ceiling Panel - Installation, TASK 25-21-06-400-801.
- (b) Install the closet if applicable. Do the applicable task in this procedure: CLOSETS - REMOVAL/INSTALLATION, PAGEBLOCK 25-24-01/401.
- (c) Do this task: Passenger Seat - Installation, TASK 25-25-01-400-801.
- (d) Do this task: Lavatory Installation, TASK 25-41-01-400-801.
- (e) Do this task: Floor-Mounted Stowage Box - Installation, TASK 25-28-05-400-801.
- (f) Do this task: Attendant Seat Installation, TASK 25-25-06-400-801 or Attendant Seat Installation, TASK 25-25-06-400-802 or Attendant Seat Installation, TASK 25-25-06-400-806.

SUBTASK 25-31-02-410-011

- (2) If necessary, install the curtains [3] and the curtain tracks [4] to the galley.

———— **END OF TASK** ————

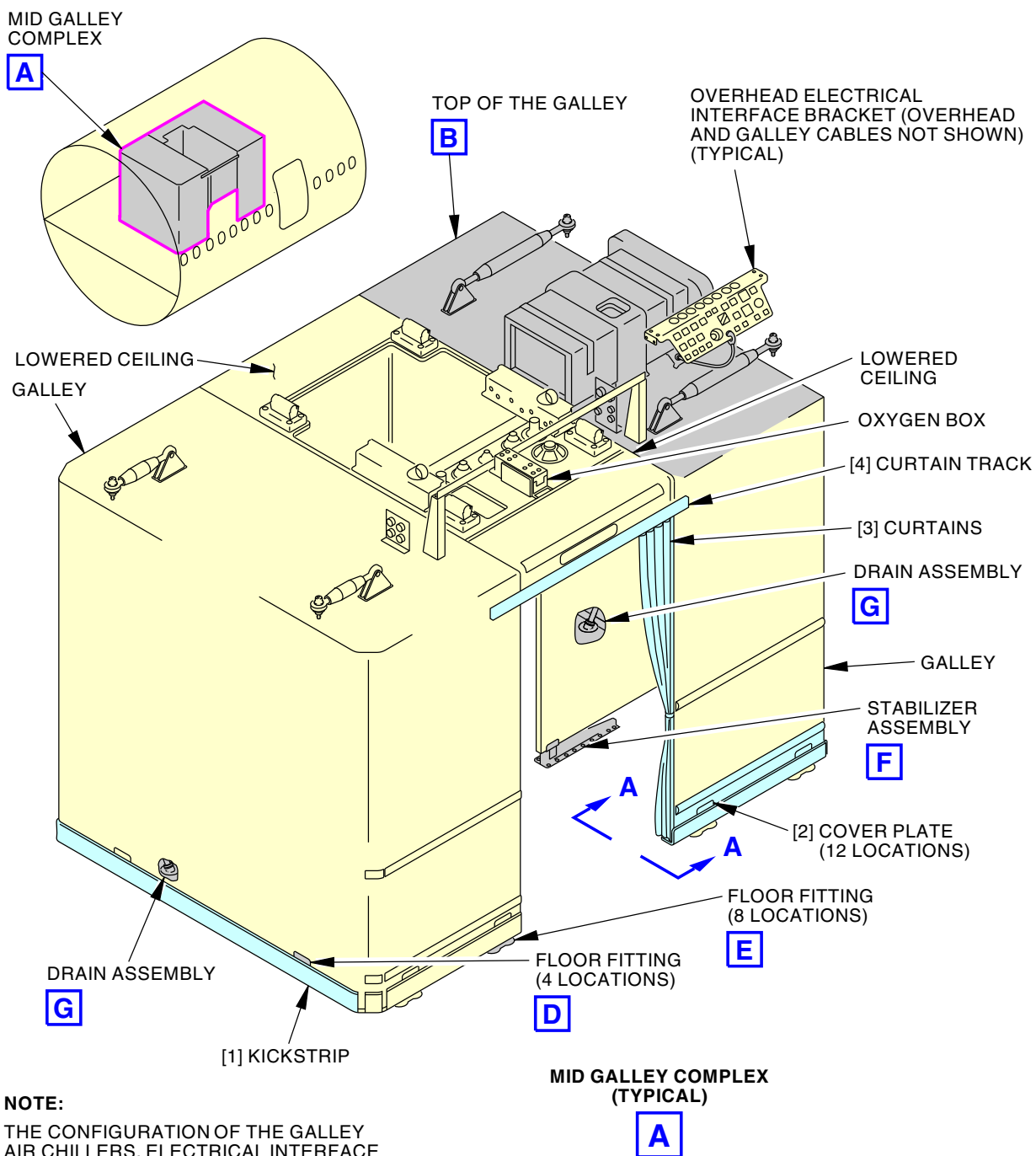
EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

Page 415
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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Door 2, 3, and 4 Galley Installation
Figure 401/25-31-02-990-806 (Sheet 1 of 9)

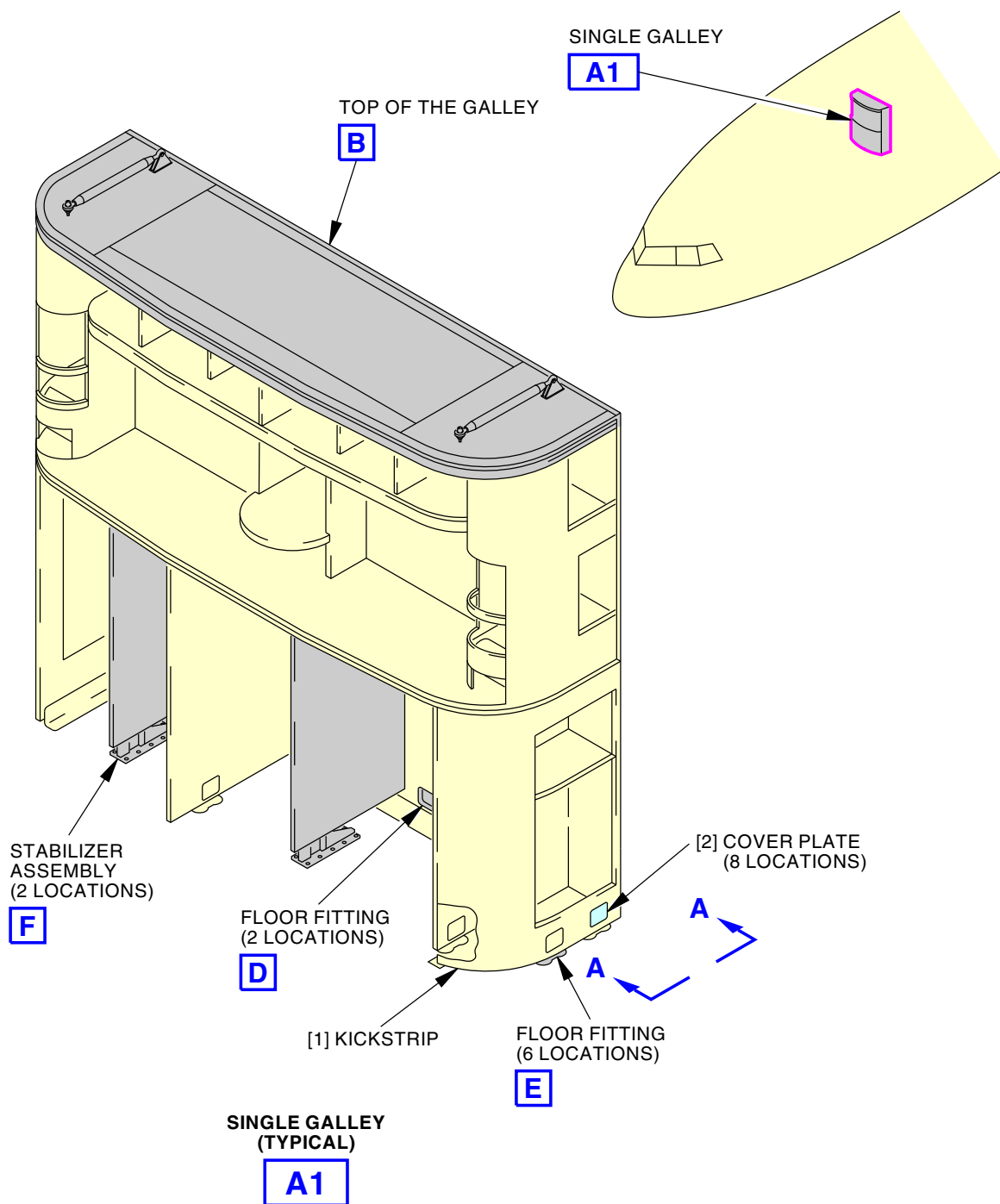
EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

Page 416
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Door 2, 3, and 4 Galley Installation
Figure 401/25-31-02-990-806 (Sheet 2 of 9)

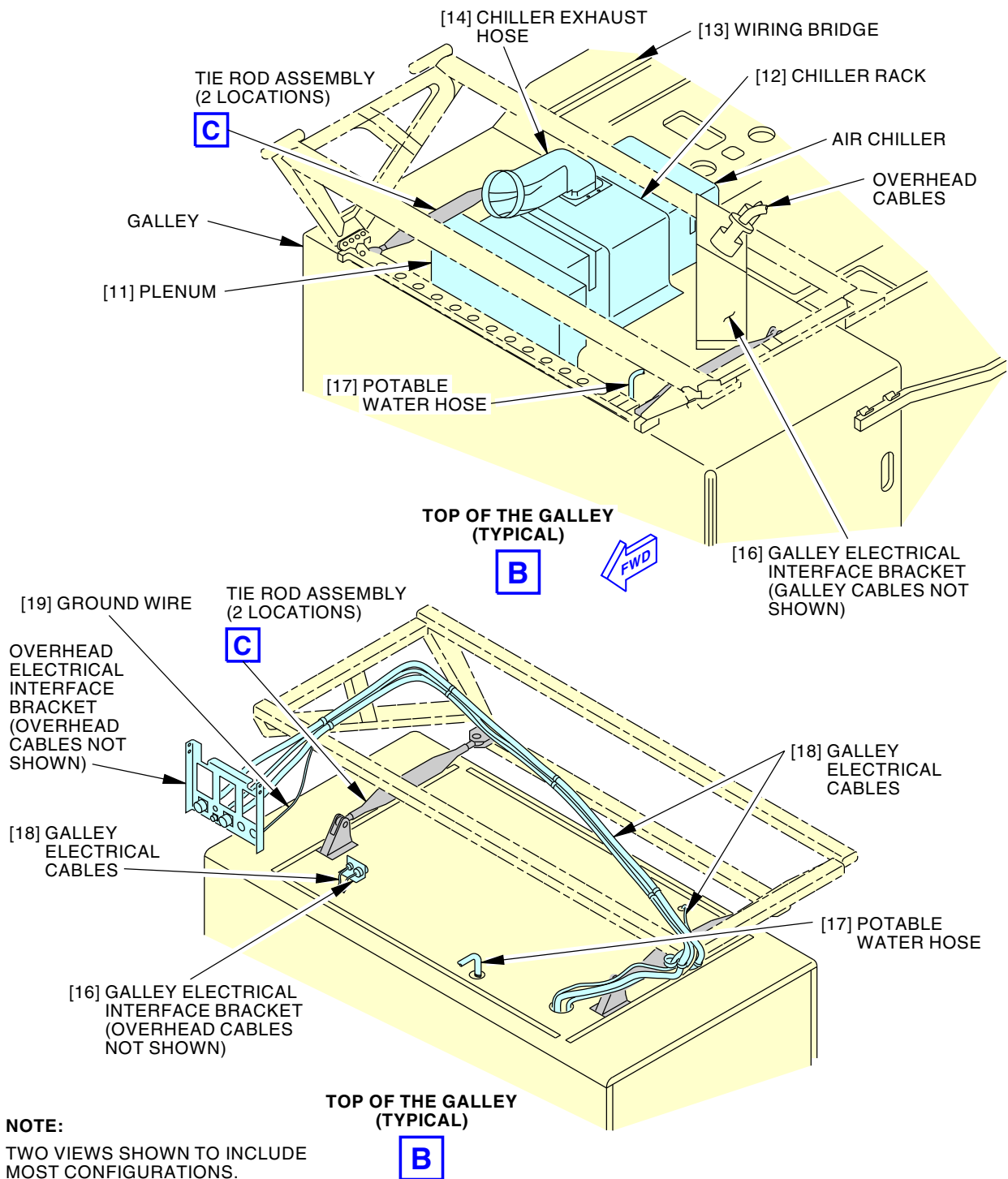
EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

Page 417
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



1495471 S0000271239_V2

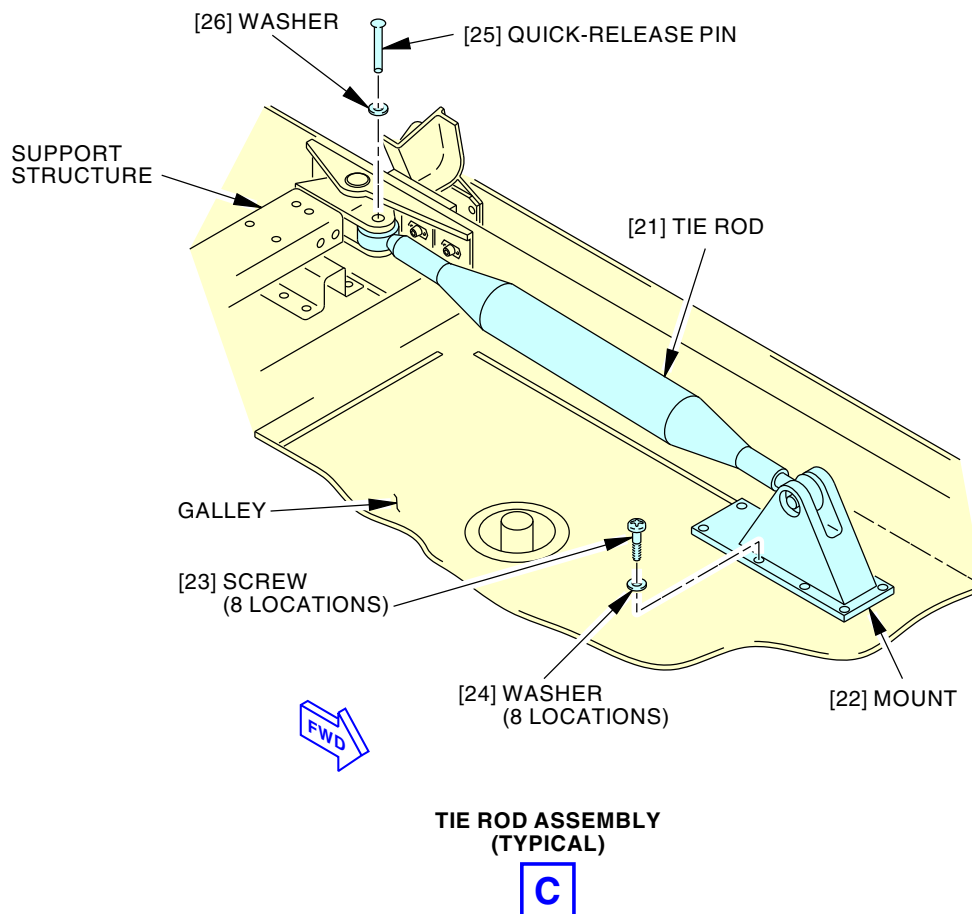
Door 2, 3, and 4 Galley Installation
Figure 401/25-31-02-990-806 (Sheet 3 of 9)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-02

Page 418
May 05/2017



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**Door 2, 3, and 4 Galley Installation
Figure 401/25-31-02-990-806 (Sheet 4 of 9)**

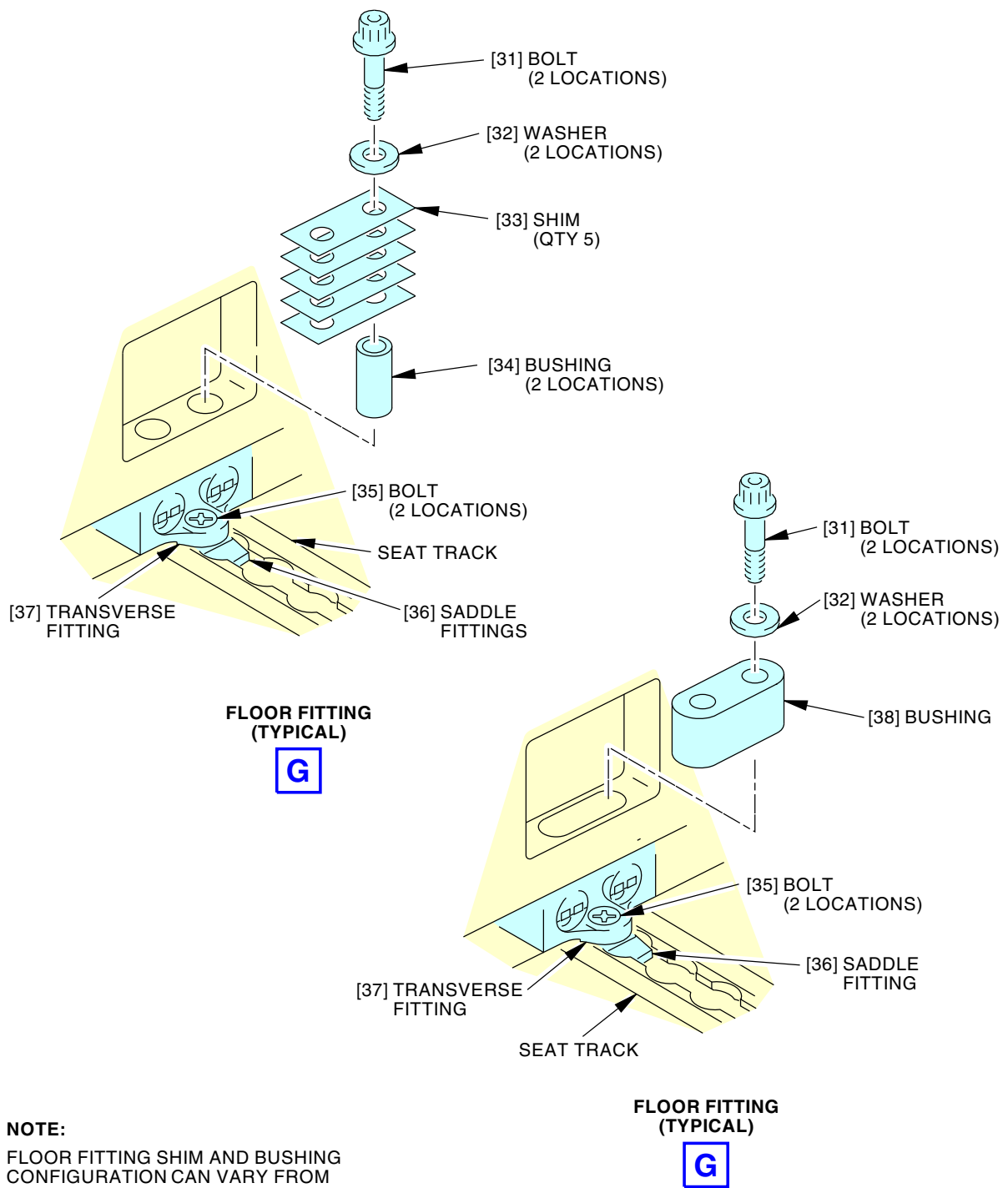
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25-31-02

D633W101-ARO

Page 419
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



1496616 S0000271243_V2

Door 2, 3, and 4 Galley Installation
Figure 401/25-31-02-990-806 (Sheet 5 of 9)

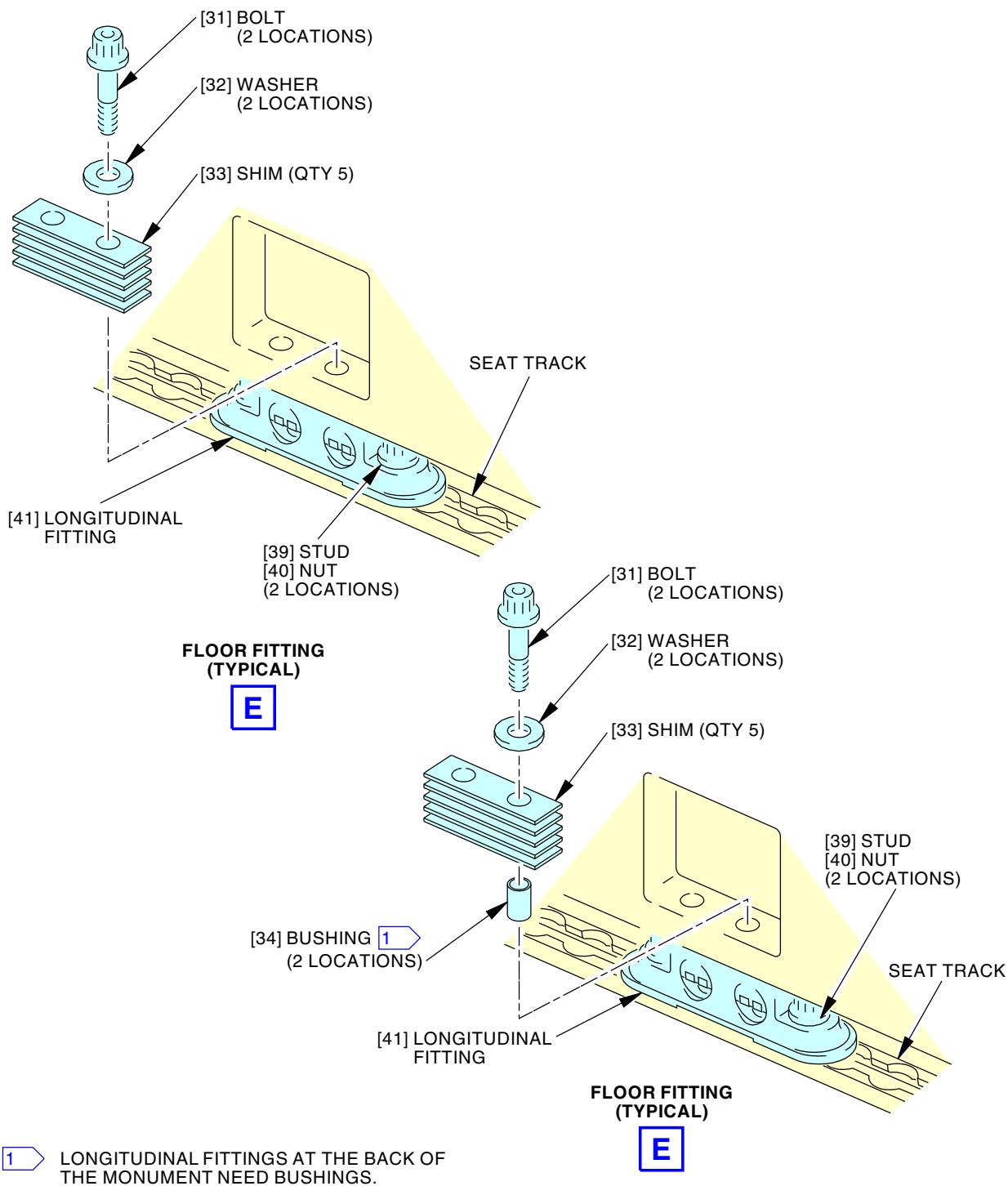
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25-31-02

Page 420
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



1496624 S0000271244_V2

Door 2, 3, and 4 Galley Installation
Figure 401/25-31-02-990-806 (Sheet 6 of 9)

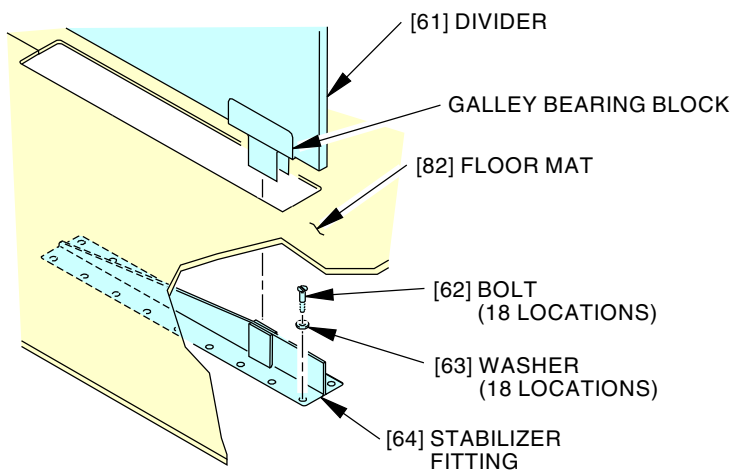
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25-31-02

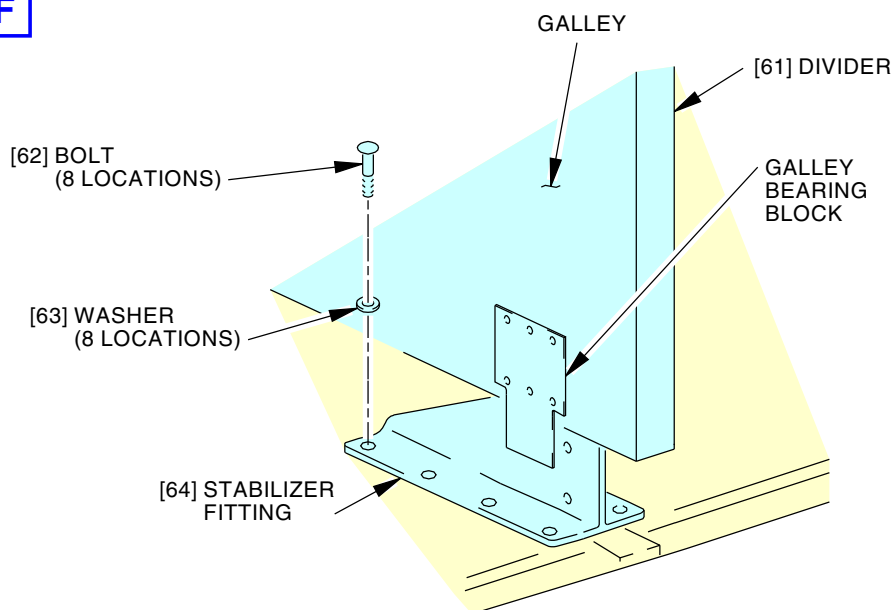
Page 421
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**STABILIZER ASSEMBLY
(TYPICAL)**

F



**STABILIZER ASSEMBLY
(TYPICAL)**

F

1476845 S0000269114_V2

**Door 2, 3, and 4 Galley Installation
Figure 401/25-31-02-990-806 (Sheet 7 of 9)**

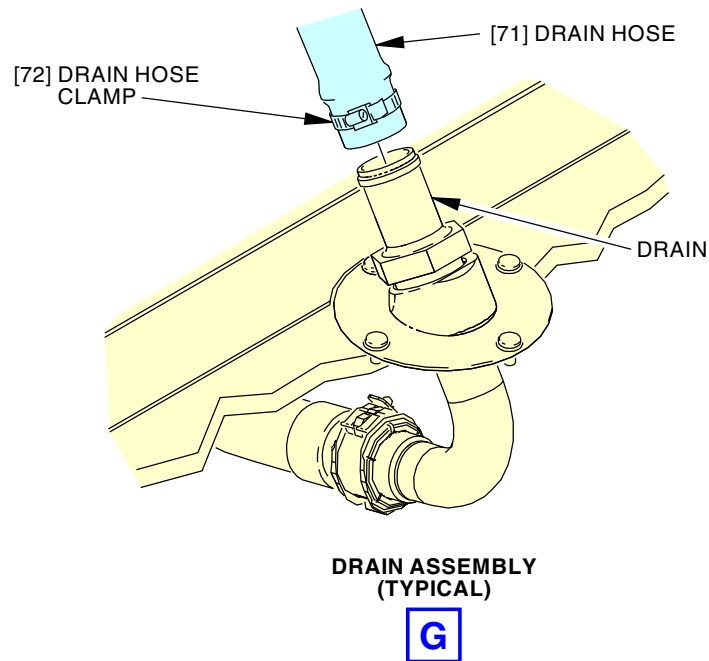
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25-31-02

D633W101-ARO

Page 422
May 05/2017

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777-200/300
AIRCRAFT MAINTENANCE MANUAL



1495218 S0000271656_V2

Door 2, 3, and 4 Galley Installation
Figure 401/25-31-02-990-806 (Sheet 8 of 9)

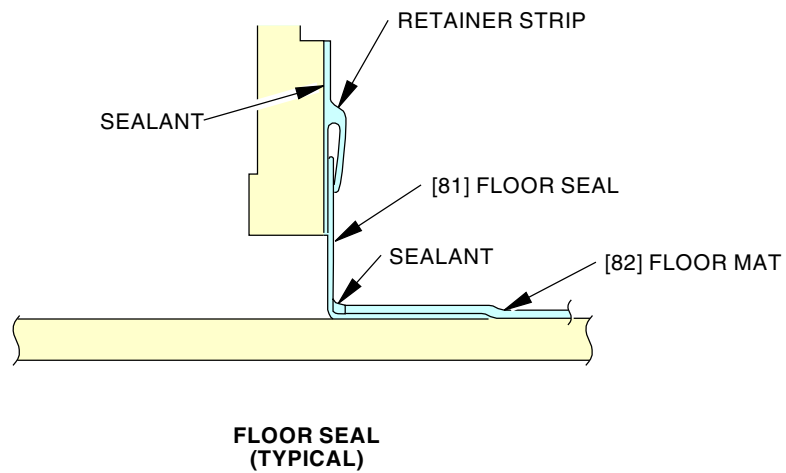
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D633W101-ARO

25-31-02

Page 423
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



1476884 S0000265687_V2

Door 2, 3, and 4 Galley Installation
Figure 401/25-31-02-990-806 (Sheet 9 of 9)

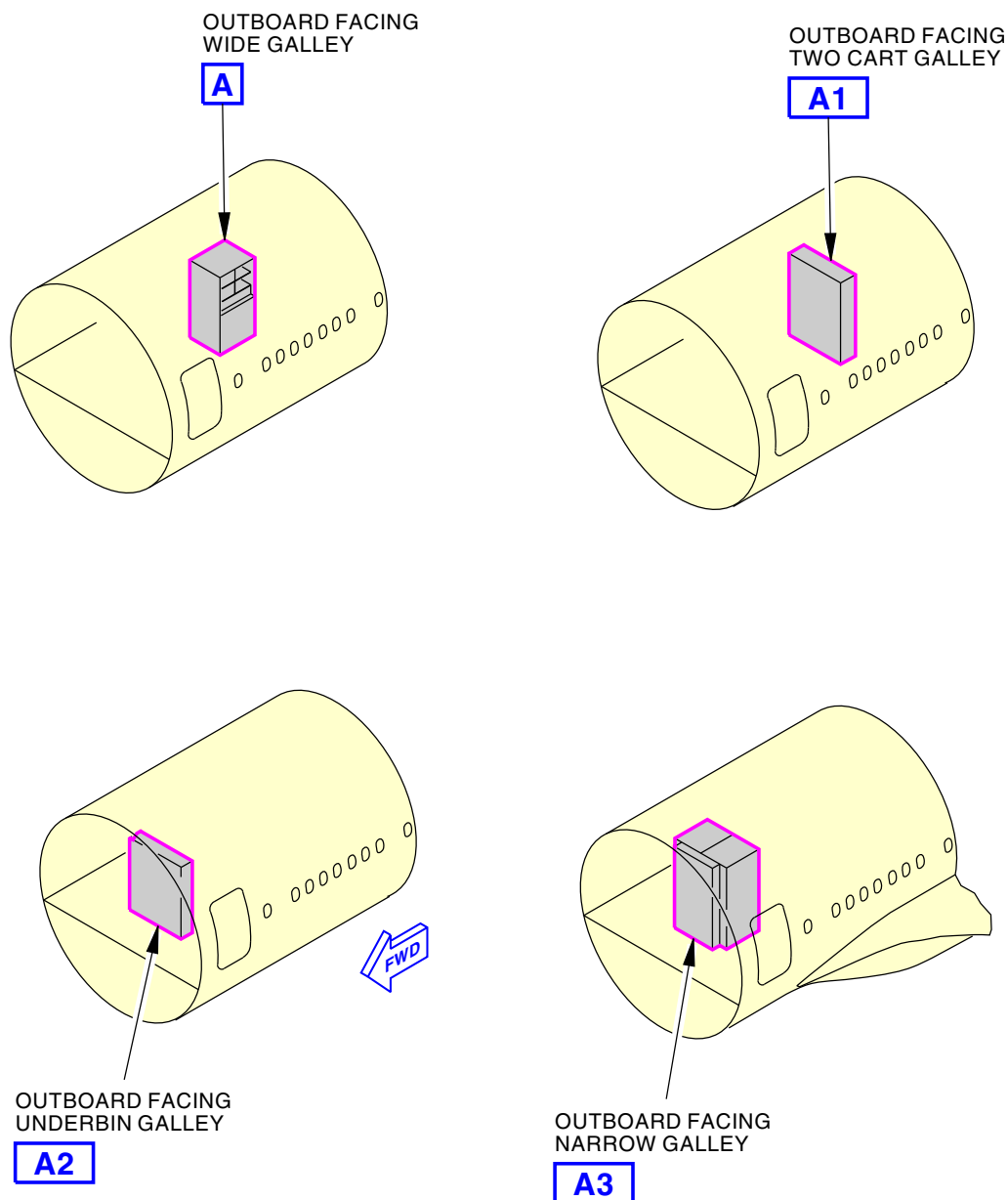
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D633W101-ARO

25-31-02

Page 424
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



1496146 S0000271309_V2

Outboard Facing Galley Installation
Figure 402/25-31-02-990-811 (Sheet 1 of 8)

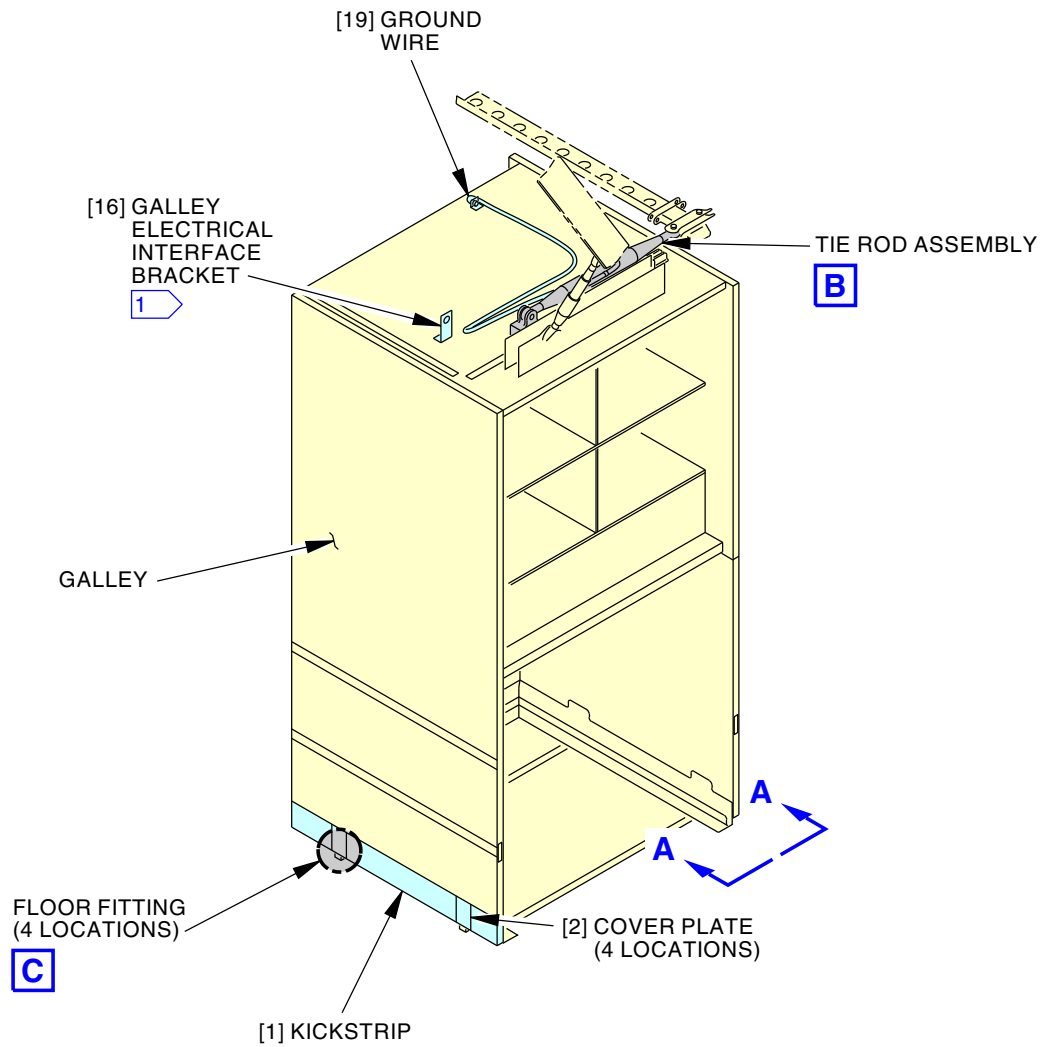
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D633W101-ARO

25-31-02

Page 425
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



1 OVERHEAD AND GALLEY CABLES NOT SHOWN.

1496113 S0000271310_V2

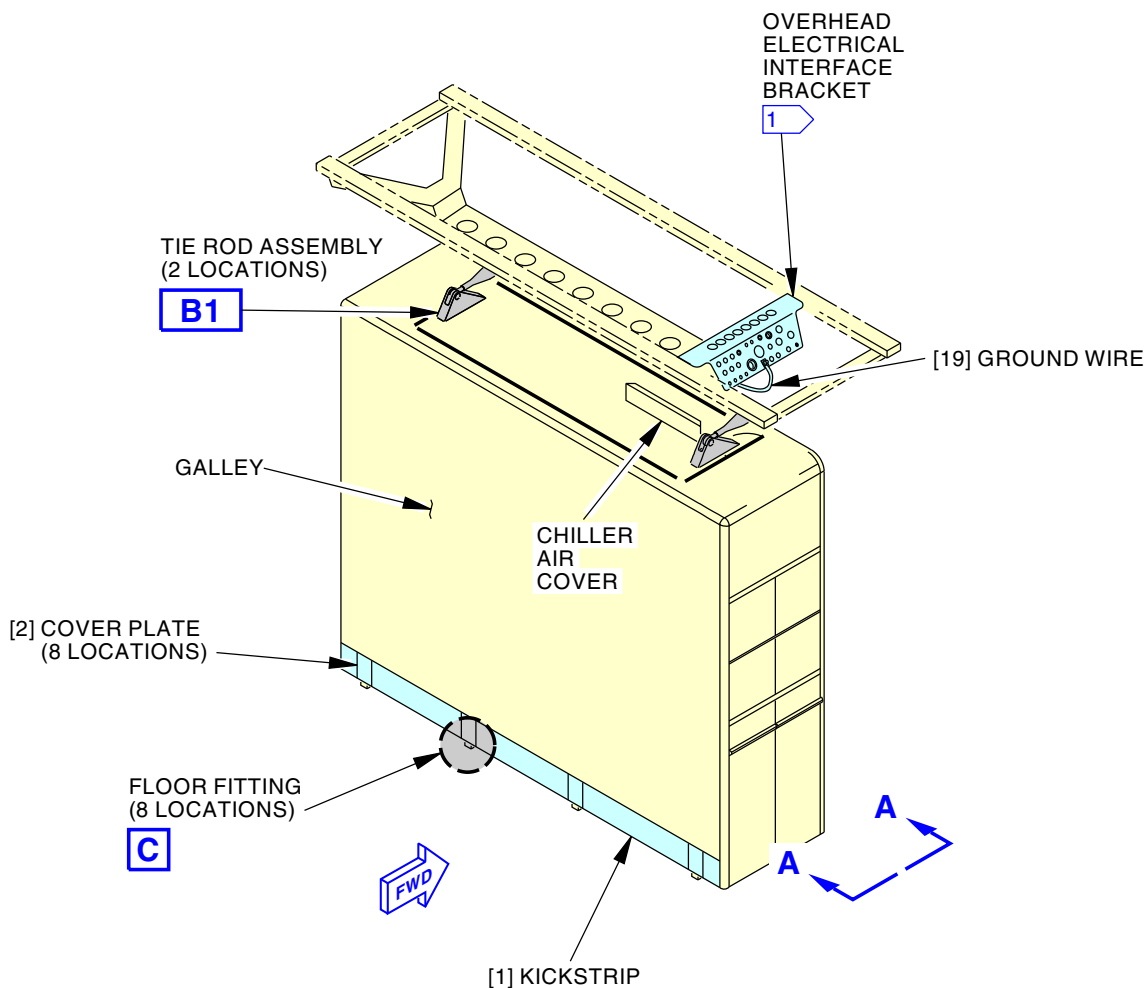
Outboard Facing Galley Installation
Figure 402/25-31-02-990-811 (Sheet 2 of 8)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-02

Page 426
May 05/2017



**OUTBOARD FACING TWO CART GALLEY
(TYPICAL)**

A1

1496249 S0000271311_V2

**Outboard Facing Galley Installation
Figure 402/25-31-02-990-811 (Sheet 3 of 8)**

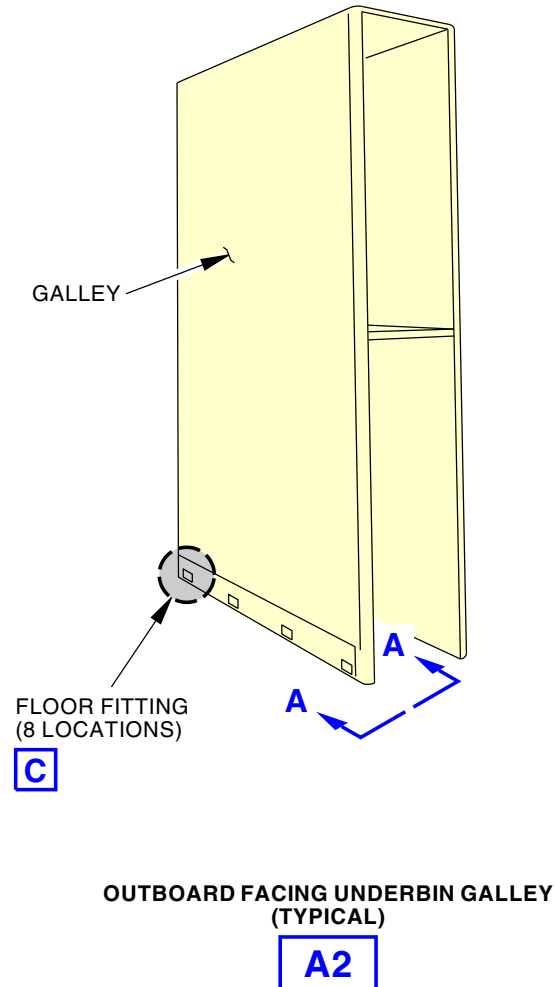
EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-02

Page 427
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



1496335 S0000271312_V2

Outboard Facing Galley Installation
Figure 402/25-31-02-990-811 (Sheet 4 of 8)

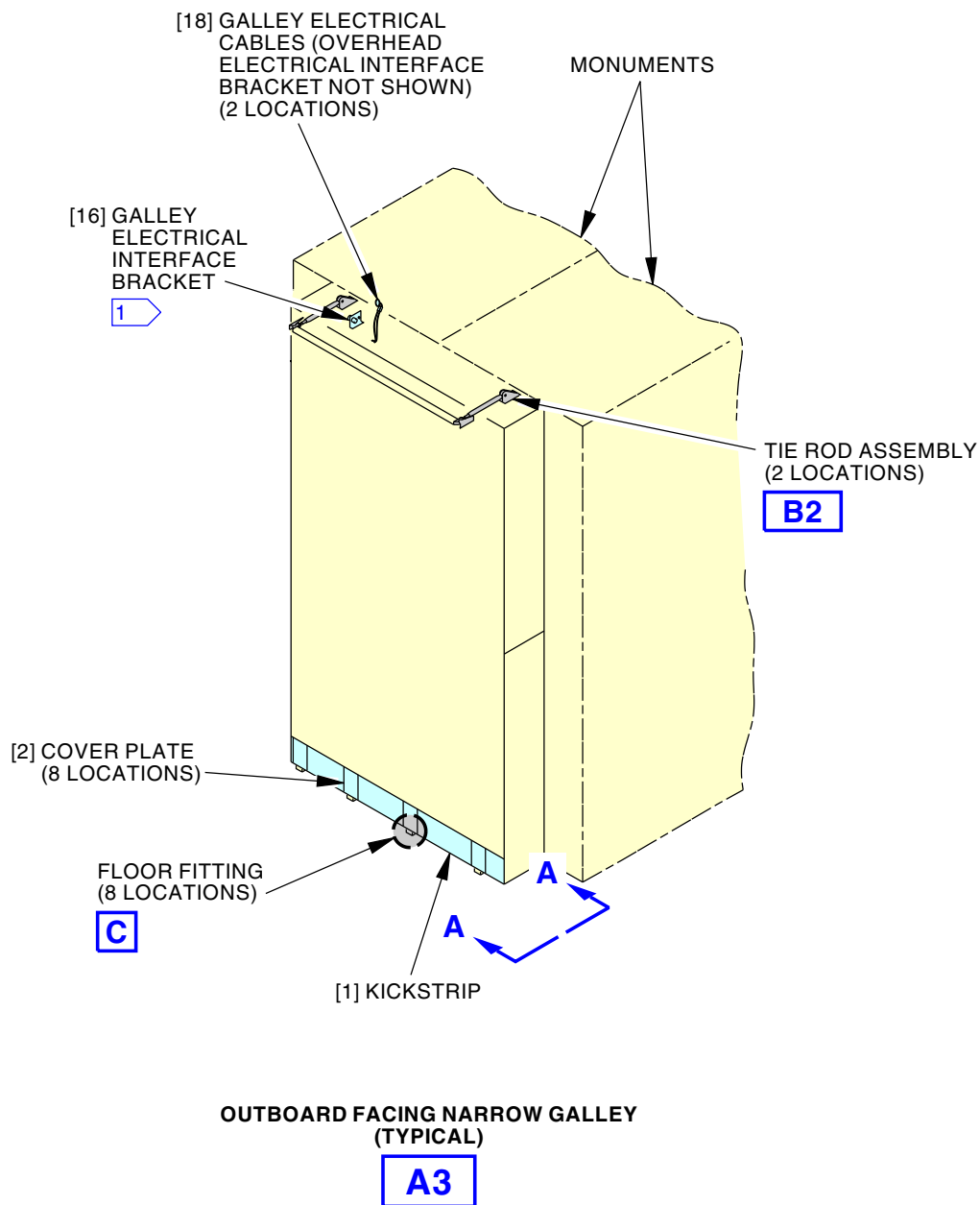
EFFECTIVITY
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D633W101-ARO

25-31-02

Page 428
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



1496324 S0000271313_V2

**Outboard Facing Galley Installation
Figure 402/25-31-02-990-811 (Sheet 5 of 8)**

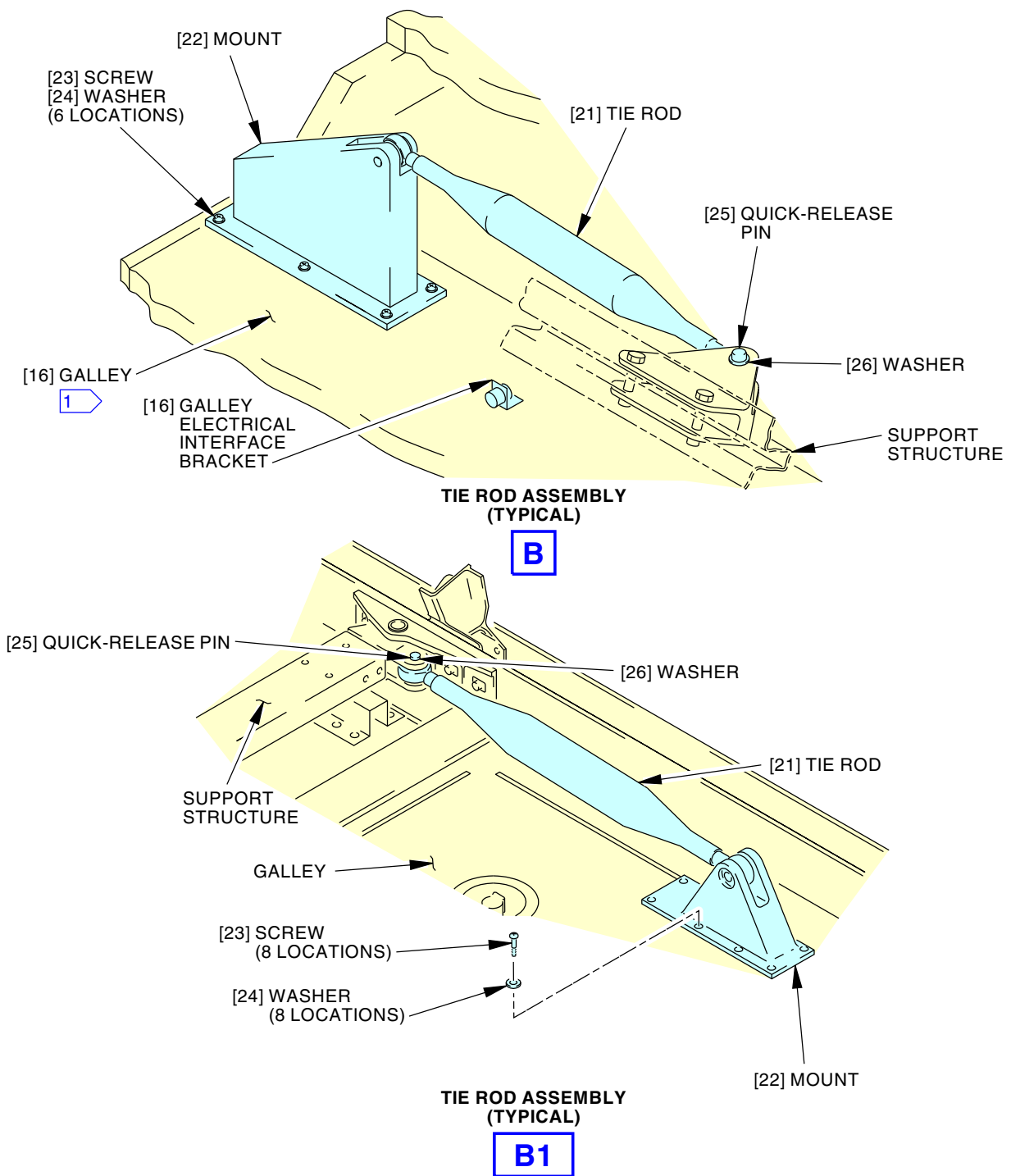
EFFECTIVITY
ARO ALL

25-31-02

D633W101-ARO

Page 429
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



1496356 S0000271314_V2

**Outboard Facing Galley Installation
Figure 402/25-31-02-990-811 (Sheet 6 of 8)**

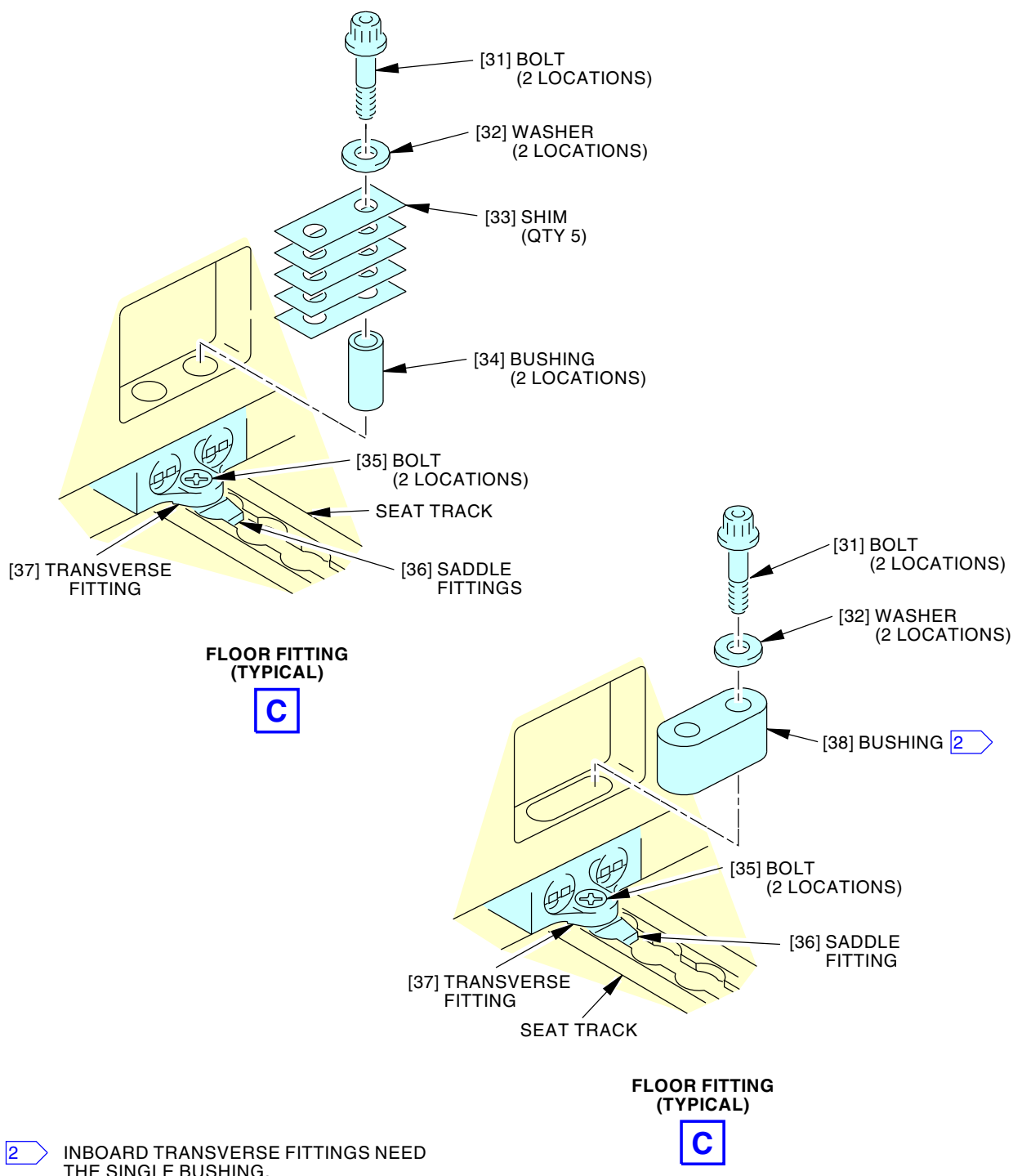
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25-31-02

D633W101-ARO

Page 430
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



1496429 S0000271315_V2

Outboard Facing Galley Installation
Figure 402/25-31-02-990-811 (Sheet 7 of 8)

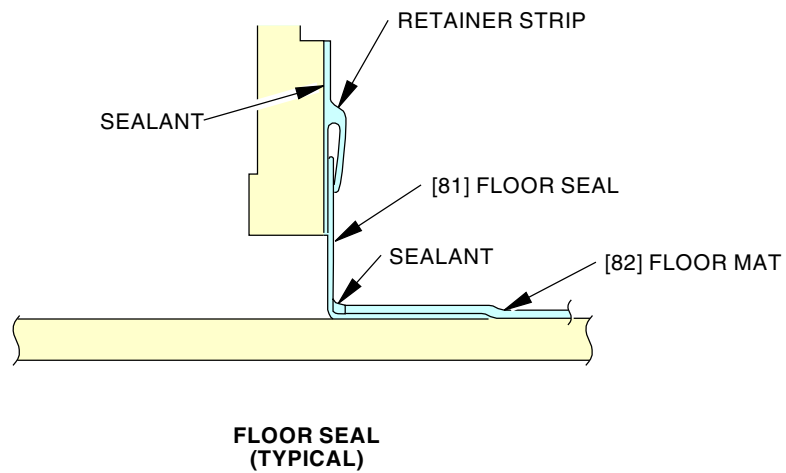
EFFECTIVITY
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D633W101-ARO

25-31-02

Page 431
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Outboard Facing Galley Installation
Figure 402/25-31-02-990-811 (Sheet 8 of 8)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-02

Page 432
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
AFT GALLEY - MAINTENANCE PRACTICES

1. General

- A. This procedure contains these tasks:
- (1) Aft galley - deactivation.
 - (2) Aft galley - activation.
 - (3) The disassembly of an aft galley.
 - (4) The assembly of an aft galley.

TASK 25-31-03-040-801

2. Aft Galley - Deactivation

A. General

- (1) This task will deactivate the power to the aft galleys.

B. References

Reference	Title
38-10-00-040-801	Potable Water System - Deactivation (P/B 201)

C. Location Zones

Zone	Area
261	Passenger Compartment, Left - Section 47
262	Passenger Compartment, Right - Section 47

D. Procedure

SUBTASK 25-31-03-020-038

- (1) Do this task: Potable Water System - Deactivation, TASK 38-10-00-040-801.

SUBTASK 25-31-03-020-039

- (2) Do these steps to drain the galley water system:
- (a) Open the galley water shutoff valve.
 - (b) Open the galley faucets.
 - (c) Open the galley supply system drain valves.
 - (d) Drain the water from all galley equipment.

SUBTASK 25-31-03-020-041



WARNING

KEEP PERSONNEL, EQUIPMENT, AND OTHER ITEMS OUT OF THE HAZARDOUS ENERGY ZONES. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.



WARNING

BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

NOTE: There are components installed on the galley that will not power down when these circuit breakers are open.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-03

Page 201
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (3) Open these circuit breakers and install safety tags:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
G	3	C33422	CABIN LTS AFT R
H	3	C33459	AFT GLY LTS
L	7	C33423	CABIN LTS AFT L

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	20	C25607	DR 4L GLY

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	9	C23444	AREA CONTROL PANELS
F	15	C25640	R AFT GALLEY POWER

E. Aft Galley - Tryout

NOTE: This tryout is to make sure that the aft galleys are in a zero energy state.

SUBTASK 25-31-03-420-022

- (1) Put the Emergency Power switch on the galley control panel and the upper deck control panel to the ON position.
- (a) Make sure that a worklight or galley insert does not operate.

SUBTASK 25-31-03-020-042

- (2) Put the Emergency Power switch on the galley control panel to the OFF position.

SUBTASK 25-31-03-420-023

- (3) Put the Area Light switch on the galley control panel to the DIM or BRT position.
- (a) Make sure that the lights stay off.

SUBTASK 25-31-03-020-043

- (4) Put the Area Light switch on the galley control panel to OFF position.

————— **END OF TASK** —————

TASK 25-31-03-440-801

3. Aft Galley - Activation

A. General

- (1) This task will activate the power to the mid galleys.

B. Location Zones

<u>Zone</u>	<u>Area</u>
261	Passenger Compartment, Left - Section 47
262	Passenger Compartment, Right - Section 47

C. Procedure

SUBTASK 25-31-03-420-024

- (1) Do these steps to turn on the galley water system:
- (a) Open the galley water shutoff valve.
- (b) Close the galley faucets.

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 202
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (c) Close the galley supply system drain valves.

SUBTASK 25-31-03-420-026

- (2) Remove the safety tags and close these circuit breakers:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
G	3	C33422	CABIN LTS AFT R
H	3	C33459	AFT GLY LTS
L	7	C33423	CABIN LTS AFT L

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	20	C25607	DR 4L GLY

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	9	C23444	AREA CONTROL PANELS
F	15	C25640	R AFT GALLEY POWER

————— END OF TASK —————

TASK 25-31-03-000-803

4. Aft Galley Disassembly

(Figure 201)

A. Procedure

SUBTASK 25-31-03-030-001

- (1) Do these steps to separate the A2 and A3 galleys from the A1 galley:
- Remove the screws [24] and washers [11] below the counter panel of the trash compartment.
 - Remove the plates [23] and screws [10] that attach the counter of the A1 galley to the counters of the A2 and A3 galleys.
 - Remove the screws [10] that attach the trim [17] between the A1 and A2 galleys and the A1 and A3 galleys.
 - Remove the trim [17].
 - Remove the angles [22] from the back corners between the A1 galley and the A2 and A3 galleys.
 - Remove the bolts [18] and washers [11] that attach the vertical angle [9] and vertical angle [21] to the back corners of the A1 galley.
 - Remove the vertical angle [9] and vertical angle [21].
 - Remove the screws [20] and washers [11] to attach the A1 galley to the A2 and A3 galleys below the counter and the top.
 - Remove the plates [16] from the top of the A1 galley.
 - Remove the screws [19] that attach the A1 galley to the A2 and A3 galleys above the counter.
 - Remove the screws [10] and washers [11] that attach the A1 galley to the A2 and A3 galleys below the counter.

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 203
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-31-03-020-032

- (2) For the A2 and A3 galleys; Do these steps to separate the upper galley structure from the lower galley structure:
- (a) Disconnect the bracket from the refrigeration duct.
 - (b) Disconnect the air supply duct from the galley.
 - (c) Disconnect the air return duct from the galley.
 - (d) Remove the cart panel [14] from the galley.
 - (e) Separate the water hose [26] at the split line.
 - (f) Separate the drain hose [27] at the split line.
 - (g) Remove the split line doublers [12] on the back of the galley.
 - (h) Remove the side panel [25] from the galley.
 - (i) Carefully separate the lower galley structure from the upper galley structure.

SUBTASK 25-31-03-020-033

- (3) For the A1 galley; Do these steps to separate the upper galley structure from the lower galley structure:
- (a) Disconnect the bracket from the refrigeration duct.
 - (b) Disconnect the air supply duct from the galley.
 - (c) Disconnect the air return duct from the galley.
 - (d) Remove the cart panel [3] from the galley.
 - (e) Remove the split line doublers [12] from the galley.
 - (f) Remove the bolts [6], washers [7] and nuts [8] from the sides to disconnect the lower galley structure from the upper galley structure.
 - (g) Carefully separate the lower galley structure from the upper galley structure.

————— **END OF TASK** —————

TASK 25-31-03-400-803

5. Aft Galley Assembly

(Figure 201)

A. Procedure

SUBTASK 25-31-03-420-019

- (1) For the A1 galley; Do these steps to attach the upper galley structure to the lower galley structure:
- (a) Carefully put the upper galley structure on the lower galley structure.
 - (b) Align the attach points.
 - (c) Install the bolts [6], washers [7] and nuts [8] to attach the sides of the upper galley structure to the lower galley structure.
 - (d) Install the split line doublers [12] on the back of the galley.
 - (e) Install the cart panel [3] on the galley.
 - (f) Connect the air supply duct to the galley.
 - (g) Connect the air return duct to the galley.
 - (h) Connect the bracket to the refrigeration duct.

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 204
Jan 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-31-03-420-018

- (2) For the A2 and A3 galleys; Do these steps to attach the upper galley structure to the lower galley structure:
- (a) Carefully put the upper galley structure on the lower galley structure.
 - (b) Install the split line doublers [12] to the back of the galley to connect the lower galley structure to the upper galley structure.
 - (c) Install the side panel [25] on the galley with the screws and washers.
 - (d) Connect the water hose [26] at the split line.
 - (e) Connect the drain hose [27] at the split line.
 - (f) Install the cart panel [3] on the galley.
 - (g) Connect the air supply duct to the galley.
 - (h) Connect the air return duct to the galley.
 - (i) Attach the bracket to the refrigeration duct.

SUBTASK 25-31-03-430-001

- (3) Do these steps to connect the A1 galley to the A2 and A3 galleys:
- (a) Install the screws [10] and washers [11] to attach the A1 galley to the A2 and A3 galleys below the counter.
 - (b) Install the screws [19] to attach the A1 galley to the A2 and A3 galleys above the counter.
 - (c) Install the plates [16] to the top of the galley with the screws and washers.
 - (d) Install the screws [20] and washers [11] to attach the A1 galley to the A2 and A3 galleys below the counter and the top.
 - (e) Install the vertical angles [9] and vertical angles [21] with the bolts [18] and washers [11] to the back corners of the A1 galley and the A2 and A3 galleys.
 - (f) Install the angles [22] to the A1 galley and the A2 and A3 galleys.
 - (g) Install the trim [17] and screws [10] to attach the A1 galley to the A2 and A3 galleys.
 - (h) Install the plate [23] with the screws [10].
 - (i) Install the screws [24] and washers [11] below the counter panel of the trash compartment.

————— **END OF TASK** —————

EFFECTIVITY
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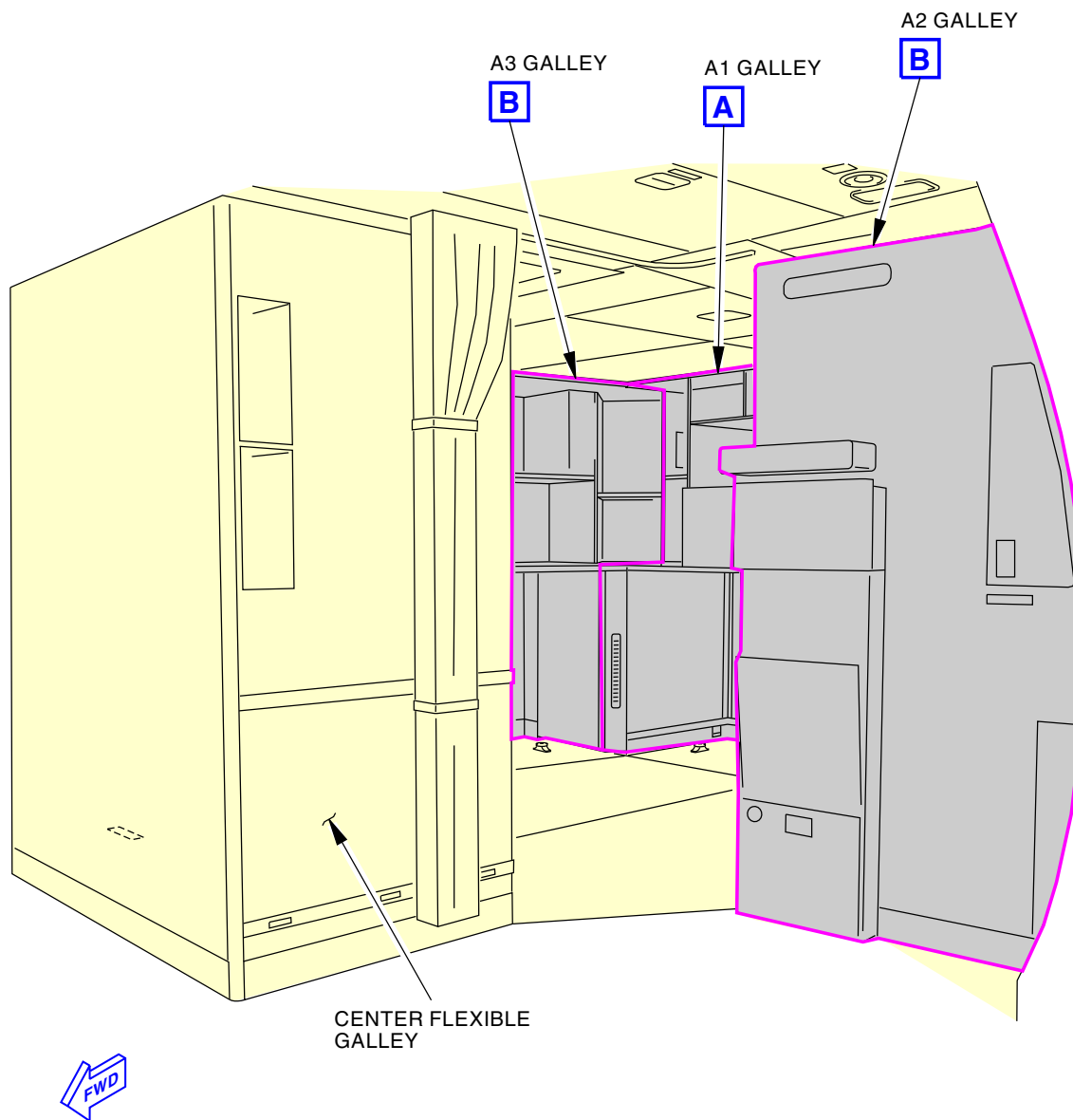
25-31-03

D633W101-ARO

Page 205
Jan 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



**AFT GALLEY COMPLEX
(GALLEY EQUIPMENT IS NOT SHOWN)**

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**Aft Galley Complex Separation
Figure 201/25-31-03-990-804 (Sheet 1 of 3)**

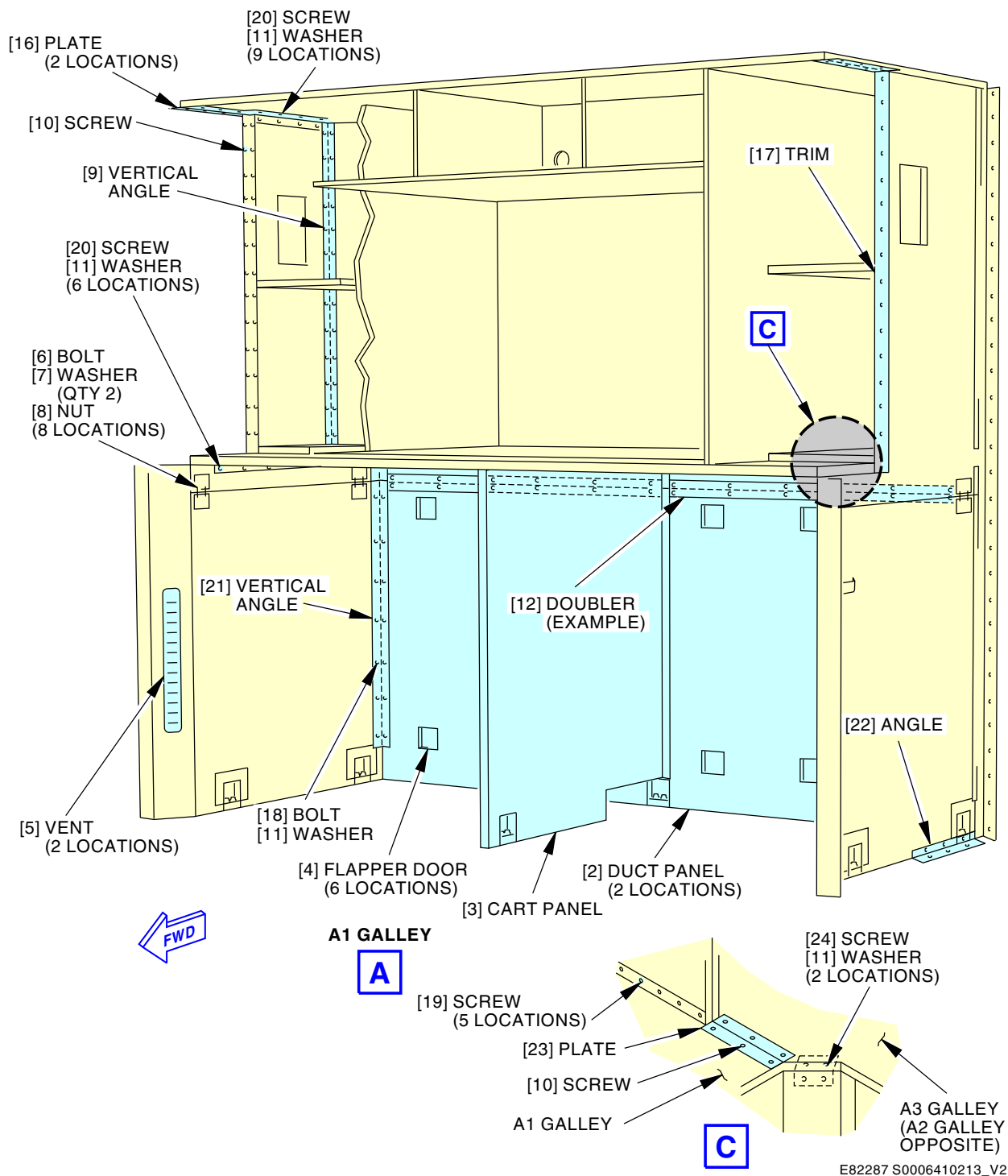
EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 206
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



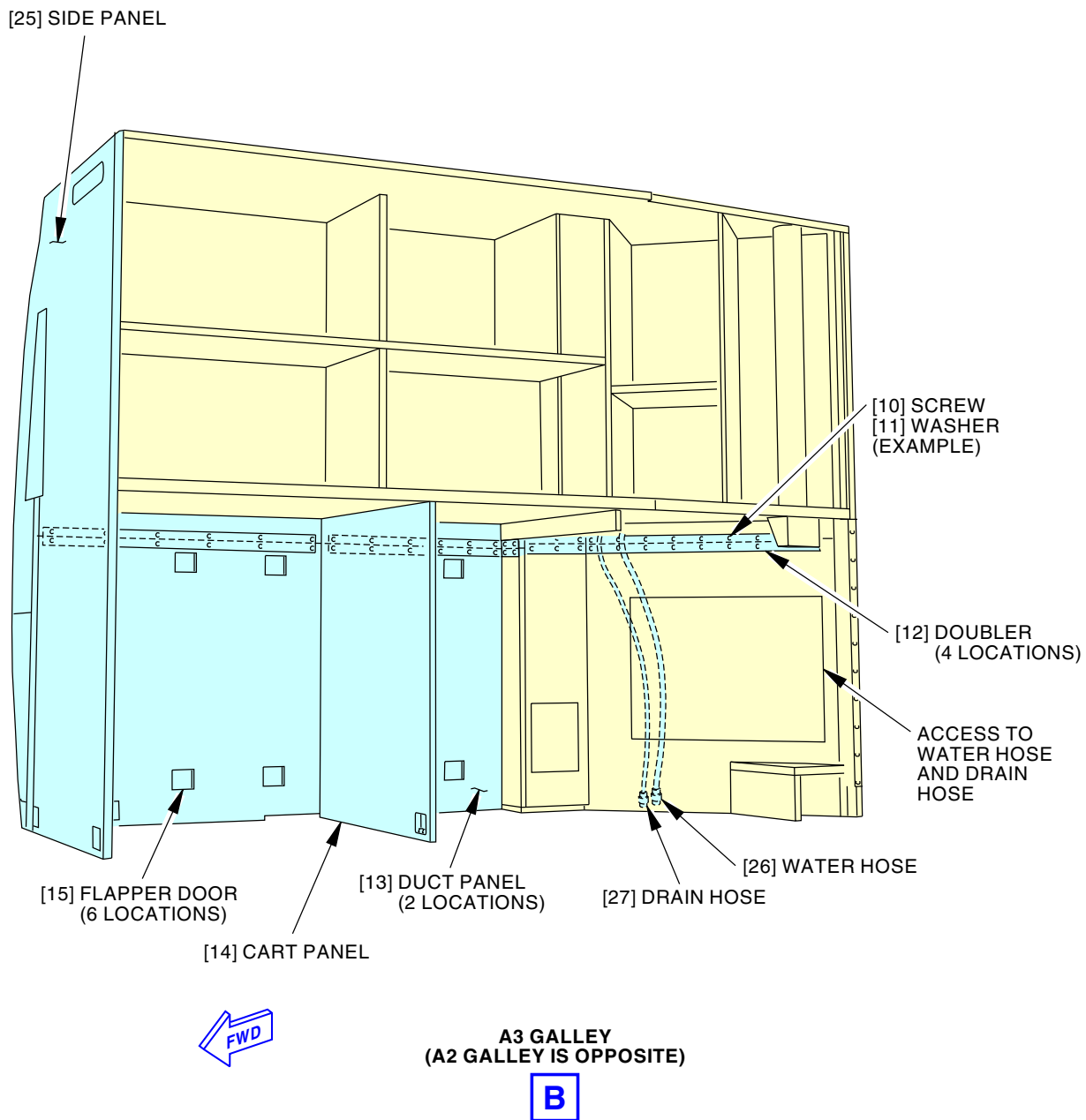
**Aft Galley Complex Separation
Figure 201/25-31-03-990-804 (Sheet 2 of 3)**

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 207
May 05/2017



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**Aft Galley Complex Separation
Figure 201/25-31-03-990-804 (Sheet 3 of 3)**

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 208
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
AFT GALLEY - REMOVAL/INSTALLATION

1. General

A. This procedure contains these tasks:

- (1) Removal of the aft fixed galleys.
- (2) Installation of the aft fixed galleys.
- (3) Removal of the aft flexible galleys.
- (4) Installation of the aft flexible galleys.

B. The A1, A2, A3, AS-1 and AS-2 aft galleys are fixed galleys and you can NOT move them to a different location in the passenger compartment.

NOTE: There are several configurations of the fixed galleys. The A1, AS-1 and AS-2 galleys are not on all airplanes.

- (1) Some airplanes have transverse A1, A2, and A3 galleys.
- (2) Some airplanes have longitudinal A2 and A3 galleys.

C. The A4 and A5 aft galleys are center flexible galleys and can be moved in one inch increments in the flexibility zone.

NOTE: There are several configurations of the A4 and A5 center flexible galleys. The A4 and A5 galleys are not on all airplanes.

- (1) The A4 and A5 aft center flexible galleys are located on the centerline of the aircraft just forward of the transverse or longitudinal galleys.

TASK 25-31-03-000-804

2. Aft Fixed Galley Removal

(Figure 401)

A. References

Reference	Title
12-14-01-616-802	Potable Water System - Drain (P/B 301)
25-21-06-000-801	Main Ceiling Panel - Removal (P/B 401)
25-21-07-000-801	Lowered Ceiling Panel Removal (P/B 401)
25-24-01 P/B 401	CLOSETS - REMOVAL/INSTALLATION
25-25-01-000-801	Passenger Seat - Removal (P/B 401)
25-25-06-000-801	Attendant Seat Removal (P/B 401)
25-25-06-000-802	Attendant Seat Removal (P/B 401)
25-25-06-000-806	Attendant Seat Removal (P/B 401)
25-28-05-000-801	Floor-Mounted Stowage Box Removal (P/B 401)
25-41-01-000-801	Lavatory Removal (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-5259	Cup - Vacuum Part #: N4950 Supplier: OSL88

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-03

Page 401
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

C. Location Zones

Zone	Area
261	Passenger Compartment, Left - Section 47
262	Passenger Compartment, Right - Section 47

D. Prepare for the Removal

SUBTASK 25-31-03-865-001

- (1) Open these circuit breakers and install safety tags:

Ground Service/Handling Power Panel, P320

Row	Col	Number	Name
H	3	C33459	AFT GLY LTS

Left Power Management Panel, P110

Row	Col	Number	Name
J	20	C25607	DR 4L GLY

SUBTASK 25-31-03-010-014

- (2) Remove these items as applicable:

- (a) Do this task: Attendant Seat Removal, TASK 25-25-06-000-801 or Attendant Seat Removal, TASK 25-25-06-000-802 or Attendant Seat Removal, TASK 25-25-06-000-806.
- (b) Do this task: Floor-Mounted Stowage Box Removal, TASK 25-28-05-000-801.
- (c) Do this task: Lavatory Removal, TASK 25-41-01-000-801.
- (d) Do this task: Passenger Seat - Removal, TASK 25-25-01-000-801.
- (e) Remove the closet if it is necessary. Do the applicable task in this procedure: CLOSETS - REMOVAL/INSTALLATION, PAGEBLOCK 25-24-01/401.
- (f) Do this task adjacent to the galley: Lowered Ceiling Panel Removal, TASK 25-21-07-000-801 or Main Ceiling Panel - Removal, TASK 25-21-06-000-801.

SUBTASK 25-31-03-616-001

- (3) If the galley has potable water connections, do this task: Potable Water System - Drain, TASK 12-14-01-616-802.

SUBTASK 25-31-03-030-002

- (4) If necessary, remove the closeout seals from the top and sides of the applicable galley.

SUBTASK 25-31-03-010-015

- (5) Remove the galley ceiling panels Main Ceiling Panel - Removal, TASK 25-21-06-000-801.

SUBTASK 25-31-03-010-016

- (6) If necessary, remove the carts and all of the other equipment from the galley.

SUBTASK 25-31-03-010-017

- (7) If necessary, remove the curtains and curtain tracks from the galley complex.

SUBTASK 25-31-03-030-003

- (8) Do these steps when necessary to prepare the bottom of the galley for the removal:
- (a) Remove the floor mats [82].
 - (b) Remove the floor seals [81].
NOTE: The floor seals [81] are attached to the floor with carpet tape.
 - (c) Remove the kickstrips [1] from the bottom of the galley.

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 402
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 1) If necessary, remove the cart panels [3] to get access to the cover plates [2].
- (d) Remove the cover plates [2] from the bottom of the galley.

E. Aft Fixed Galley Removal

SUBTASK 25-31-03-030-004

- (1) Do these applicable steps to disconnect the top of the galley:

NOTE: Most galleys have an overhead electrical interface bracket and two galley electrical interface brackets [14].

- (a) If necessary, do these steps to disconnect the galley electrical interface brackets [14]:

- 1) Disconnect the galley electrical cables [12] from the galley electrical interface bracket [14] mounted on top of the galley.
- 2) Remove the galley electrical interface bracket [14] from the top of the galley.

NOTE: It is not necessary to disconnect the overhead electrical connectors from the galley electrical interface bracket [14].

- 3) Carefully tie the galley electrical interface bracket [14] with the overhead cables to the overhead structure to allow clearance for the galley.

- (b) Do these steps to disconnect the galley electrical cables [12] from the overhead electrical interface brackets:

- 1) Disconnect the galley electrical cables [12] from the overhead electrical interface bracket.

NOTE: Disconnect the galley electrical connectors from the sockets and plugs on the overhead electrical interface bracket, not from the terminal boards.

- 2) Remove the wire wraps and clamps as necessary from the galley electrical cable bundles and put these cables [12] on top of the appropriate galley.

- (c) Remove the nuts [71] and washers [72] from the stud to remove the ground wire [73] from the overhead support structure.

- (d) Disconnect the two A1 galley conditioned air ducts [11] from the A2 and A3 galleys.

- (e) Remove the bolts [25], washers [24], bushings [23], washers [22], and nuts [21] to disconnect the tie rods [26] from the airplane structure.

NOTE: Some tie rod assemblies may not have the bushings [23].

- (f) Remove the bolts [32] and washers [33] from the tie rod mounts [31].

- (g) Remove the mount [31] and tie rod [26] together as a unit.

- (h) Remove the bolts [27], washers [28], washers [29], and nuts [30] to disconnect the support rods [13] from the mounts [31].

- (i) Carefully tie all the support rods [13] to the overhead structure to allow clearance for the galley.

- (j) If necessary, remove the support rod mounts [31] from the top of the galley.

SUBTASK 25-31-03-030-005

- (2) Remove the bolts [41], washers [42], and shims [43] to disconnect the galley from the hardpoint fittings [44].

SUBTASK 25-31-03-030-006

- (3) If necessary, do these steps to remove the stabilizer fittings [64] from the floor:

NOTE: The location and number of cart panels and stabilizer assemblies vary from galley to galley.

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 403
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (a) Remove the cart panels [3] from the stabilizer fittings [64].
- (b) Remove the bolts [62] and washers [63] from the A1 galley stabilizer fittings [64].
NOTE: Longitudinal galleys do not have an A1 galley.
- (c) Remove the bolts [62], washers [63], pan head bolts [67], and washers [68] from the A2 and A3 galley stabilizer fittings [64].
NOTE: Not all A2 or A3 galleys have stabilizer fittings.
- (d) Remove the stabilizer fitting [64].

SUBTASK 25-31-03-010-018

- (4) Remove the water and drain access panels on the transverse A2 and A3 galleys.

SUBTASK 25-31-03-030-007

- (5) Disconnect the potable water hoses [52] at the two floor disconnects for the longitudinal A2 and A3 galleys or the right hand side for the transverse A1 galley.

NOTE: A small quantity of water can drain from the line. Make sure that the drain procedure Potable Water System - Drain, TASK 12-14-01-616-802 is complete.

SUBTASK 25-31-03-030-008

- (6) Do these steps to remove the drain hose [51]:

NOTE: A small quantity of water can drain from the line. Make sure that the drain procedure Potable Water System - Drain, TASK 12-14-01-616-802 is complete.

- (a) Remove the drain hose clamp [53] from the applicable drain hose [51].
- (b) Carefully pull the drain hose [51] from the drain.

NOTE: Catch water that is still in the drain hose [51] with a cup.

SUBTASK 25-31-03-030-009

- (7) If necessary, disconnect the air distribution ducts for the floor heat from the aircraft structure.

SUBTASK 25-31-03-980-001



LIFT THE AFT GALLEY STRAIGHT UP APPROXIMATELY 2 - 3 INCHES ABOVE THE FLOOR. IF YOU DO NOT LIFT THE GALLEY STRAIGHT UP, YOU WILL DAMAGE THE DUCT FOR THE GALLEY CHILLER.

- (8) If necessary, use the vacuum cup, SPL-5259 to lift the galley straight up approximately 2 - 3 inches above the floor.

NOTE: Use of the vacuum cup is optional.

NOTE: This disconnects the galley chiller duct from the floor chiller duct.

SUBTASK 25-31-03-020-036

- (9) Carefully remove the galley.

SUBTASK 25-31-03-030-010

- (10) If necessary, remove the floor mounted hardpoint fitting [44].

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 404
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-31-03-400-804

3. Aft Fixed Galley Installation

(Figure 401)

A. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
25-21-06-400-801	Main Ceiling Panel - Installation (P/B 401)
25-21-07-400-801	Lowered Ceiling Panel Installation (P/B 401)
25-24-01 P/B 401	CLOSETS - REMOVAL/INSTALLATION
25-25-01-400-801	Passenger Seat - Installation (P/B 401)
25-25-06-400-801	Attendant Seat Installation (P/B 401)
25-25-06-400-802	Attendant Seat Installation (P/B 401)
25-25-06-400-806	Attendant Seat Installation (P/B 401)
25-28-05-400-801	Floor-Mounted Stowage Box - Installation (P/B 401)
25-41-01-400-801	Lavatory Installation (P/B 401)
38-10-00-600-801	Potable Water System - Disinfectant (P/B 201)
38-10-00-790-801	Potable Water System - Leak Test (P/B 201)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-5259	Cup - Vacuum Part #: N4950 Supplier: OSL88

C. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
G01288	Tape - Carpet	BMS5-133
G02482	Seal - Extruded (Skyflex GUA1072, 1073, 1082, 1083, or 1092)	

D. Location Zones

Zone	Area
261	Passenger Compartment, Left - Section 47
262	Passenger Compartment, Right - Section 47

E. Aft Fixed Galley Installation

SUBTASK 25-31-03-430-002

(1) If necessary, install the floor mounted hard point fittings [44].

SUBTASK 25-31-03-430-003

(2) Do these steps to connect the galley to the hard point fittings [44] on the floor:

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 405
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Make sure there is an isolator plate on the galley at each hard point fitting [44].

NOTE: The isolator plate is a piece of stainless steel. It is necessary to prevent corrosion between the galley and the hard point fitting [44].

- (b) If necessary, use the vacuum cup, SPL-5259 to align the galley with the hard point fitting [44].

NOTE: Use of the vacuum cup is optional.



LOWER THE AFT GALLEY STRAIGHT DOWN. IF YOU DO NOT LOWER THE GALLEY STRAIGHT DOWN, YOU WILL DAMAGE THE DUCT FOR THE GALLEY CHILLER.

- (c) Lower the galley straight down on the hard point fittings [44].

NOTE: This connects the galley chiller duct to the floor chiller duct.

- (d) If there is clearance between the galley and the hard point fitting [44] then fill this clearance with shims [43]. This will give a good fit and prevent interference with adjacent furnishings.

- (e) Install the remaining shims [43], washers [42], and bolts [41] with corrosion preventive compound, C00308 to connect the galley to the hard point fitting [44].

- (f) Tighten all the bolts [41] to 200 ±50 in-lb (22.6 ±5.7 N·m).

SUBTASK 25-31-03-430-004

- (3) If necessary, connect the air distribution ducts for the floor heat to the aircraft structure.

SUBTASK 25-31-03-430-005

- (4) If necessary, do these steps to install the drain hose [51]:

- (a) Install the drain hose clamp [53] on the applicable drain hose [51] but do not tighten.
(b) Install the drain hose [51] on the drain with sufficient space for the drain hose clamp [53].
(c) Move the drain hose clamp [53] down on the drain and tighten.

SUBTASK 25-31-03-430-006

- (5) If necessary, connect the potable water hoses [52] at the two floor connects for the longitudinal A2 and A3 galleys or the right hand side for the transverse A1 galley.

SUBTASK 25-31-03-430-007

- (6) If necessary, do these steps to install the stabilizer fitting [64] to the floor:

NOTE: The location and number of cart panels and stabilizer assemblies vary from galley to galley.

- (a) Apply a new moisture barrier seal, G02482 to make a seal around the stabilizer fittings [64] and the bolts [62], washers [63], pan head bolts [67], and washers [68] for the A2 and A3 galleys.

NOTE: Not all A2 or A3 galleys have stabilizer fittings.

- 1) Install the bolts [62], washers [63], pan head bolts [67], and washers [68] for the A2 and A3 galley stabilizers through the stabilizer fittings [64] and into the floor.

NOTE: The pan head bolts [67] and washers [68] must be installed at the four inboard stabilizer fitting holes.

- (b) Apply a new moisture barrier seal, G02482 to make a seal around the stabilizer fittings [64] and the bolts [62] and washers [63] for the A1 galley.

NOTE: Longitudinal galleys do not have an A1 galley.

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

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Page 406
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- 1) Install the bolts [62], washers [63] for the A1 galley stabilizers through the stabilizer fittings [64] and into the floor.
- (c) Tighten the bolts [62].

Table 401/25-31-03-993-801 Stabilizer Bolts

Part Number	Type	Where Used
BACB30NM3K13	Hex Head	Eight Hole Stabilizers at the Floor Beams
BACB30NT3K13	Pan Head	Eight Hole Stabilizers at the Floor Panels
BACB30NN3K13	100 Degree	Large 18 Hole Stabilizers
BACB30NT3K3	Pan Head	Stabilizers at the Floor Panels

- (d) Install the cart panel [3] with the galley bearing block [66] on the stabilizer fitting [64].

NOTE: Remove and replace the stabilizer fitting stop [65] as needed to help the installation of the galley bearing block [66].

SUBTASK 25-31-03-430-008

- (7) If necessary, do the steps that follow to connect the top of the galley:
 - (a) Connect the two A1 galley conditioned air ducts [11] to the A2 and A3 galleys.
 - (b) Install the galley mounts [31] with the tie rods [26] to the top of the galley with the bolts [32] and washers [33].
 - (c) Install the bolts [25], washers [24], bushings [23], washers [22], and nuts [21] to connect the tie rods [26] to the support structure.

NOTE: Some tie rod assemblies may not have the bushings [23].

NOTE: The tie rods [26] should have no pre-load on it when you install it.
 - (d) Adjust the tie rod end fittings as required to help install the tie rod [26].

NOTE: Do not adjust either end fitting past the witness hole.
 - (e) Remove the lockwire on either end of the tie rod [26] if more adjustment is necessary.
 - (f) Tighten the tie rod jam nuts when adjustments are complete.
 - (g) If necessary, install a lockwire to the ends of the tie rod [26].
 - (h) If necessary, install the support mounts [31] to the top of the galley.
 - (i) Carefully untie all the support rods [13] from the overhead structure.
 - (j) Install the bolts [27], washers [28], washers [29], and nuts [30] to connect the support rods [13] to the mounts [31].
 - (k) Connect the galley electrical cables [12] to the overhead electrical interface brackets.

NOTE: Connect the galley electrical connectors to the sockets and plugs on the overhead electrical interface bracket, not to the terminal boards.
 - (l) If necessary, do these steps to connect the galley electrical interface brackets [14]:
 - 1) Carefully untie the galley electrical interface bracket [14] with the overhead cables from the overhead structure and put them on top of the galley.
 - 2) Install the galley electrical interface bracket [14] with the cables to the top of the galley.
 - 3) Connect the galley electrical cables [12] to the galley electrical interface bracket [14].
 - (m) Install the nut [71] and washer [72] to connect the ground wire [73] to the stud.

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 407
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 1) Do a resistance check of the static grounds from the galley ground stud to the aircraft static ground stud.
 - a) Make sure the resistance is a maximum of 0.0025 Ohms.
- (n) Install the wire wraps and clamps as necessary to the cable bundles above the galley.

F. Aft Fixed Galley Installation Test

SUBTASK 25-31-03-410-024

- (1) Install the carts and all of the other equipment in the galley.

SUBTASK 25-31-03-865-002

- (2) Remove the safety tags and close these circuit breakers:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	3	C33459	AFT GLY LTS

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	20	C25607	DR 4L GLY

SUBTASK 25-31-03-861-001

- (3) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-31-03-790-001

- (4) Do this task: Potable Water System - Leak Test, TASK 38-10-00-790-801.

SUBTASK 25-31-03-670-001

- (5) Do this task: Potable Water System - Disinfectant, TASK 38-10-00-600-801.

SUBTASK 25-31-03-410-025

- (6) Install the water and drain access panels on the transverse A2 and A3 galleys.

SUBTASK 25-31-03-710-002

- (7) Do a check to make sure the galley lights come on.

SUBTASK 25-31-03-710-003

- (8) If necessary, do a test of the galley equipment.

SUBTASK 25-31-03-430-009

- (9) Install the closeout seals to the top and sides of the galleys.

SUBTASK 25-31-03-410-026

- (10) Install the galley ceiling panels Main Ceiling Panel - Installation, TASK 25-21-06-400-801.

SUBTASK 25-31-03-430-010

- (11) If necessary, do these steps to install the floor seal [81]:
 - (a) If necessary, apply new sealant, A02315 under the retainer strip.
 - (b) If necessary, apply new carpet tape, G01288 on the floor seal [81] base.

NOTE: Keep a 4 in. (10 cm) space in the carpet tape, G01288, in the center of the floor seal [81] on the back wall of the galley.
 - (c) Push the base of the floor seal [81] to the floor.
 - (d) Install the top of the floor seal [81] into the floor seal retainer.

SUBTASK 25-31-03-430-011

- (12) If necessary, do these steps to install the floor mats [82]:

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 408
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Apply the new carpet tape, G01288 to the floor mats [82] in the forward and aft direction with 1 in. (3 cm) between each piece.
- (b) Keep the carpet tape, G01288, approximately 1 in. (3 cm) from the edge of the floor mats [82].
- (c) Cover the floor seal [81] with the floor mats [82].
- (d) Apply the sealant, A02315, to make a fillet seal around the edges of the floor mats [82].

SUBTASK 25-31-03-430-012

- (13) Install the cover plates [2] and kickstrips [1] to the galley.
 - (a) Apply sealant, A02315 to make a seal around the cover plates [2] for the galley fittings.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 25-31-03-410-027

- (1) Install these items as applicable:
 - (a) Do this task adjacent to the galley: Lowered Ceiling Panel Installation, TASK 25-21-07-400-801 or Main Ceiling Panel - Installation, TASK 25-21-06-400-801.
 - (b) Install the closet if applicable. Do the applicable task in this procedure: CLOSETS - REMOVAL/INSTALLATION, PAGEBLOCK 25-24-01/401.
 - (c) Do this task: Passenger Seat - Installation, TASK 25-25-01-400-801.
 - (d) Do this task: Lavatory Installation, TASK 25-41-01-400-801.
 - (e) Do this task: Floor-Mounted Stowage Box - Installation, TASK 25-28-05-400-801.
 - (f) Do this task: Attendant Seat Installation, TASK 25-25-06-400-801 or Attendant Seat Installation, TASK 25-25-06-400-802 or Attendant Seat Installation, TASK 25-25-06-400-806.

SUBTASK 25-31-03-410-028

- (2) If necessary, install the curtain tracks and curtains to the galley complex.

————— **END OF TASK** —————

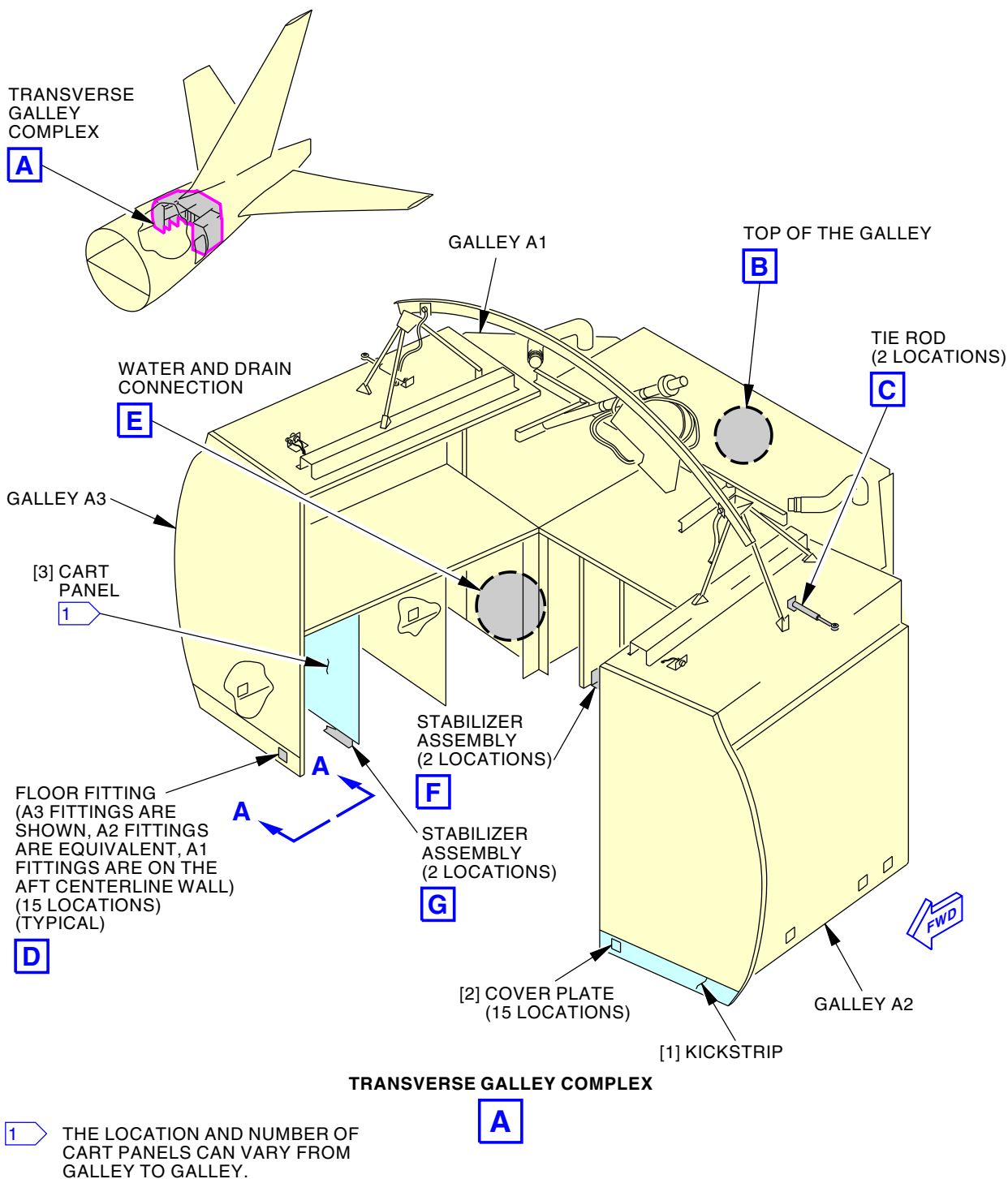
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25-31-03

D633W101-ARO

Page 409
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



1507046 S0000272530_V2

Aft Fixed Galley Installation
Figure 401/25-31-03-990-805 (Sheet 1 of 12)

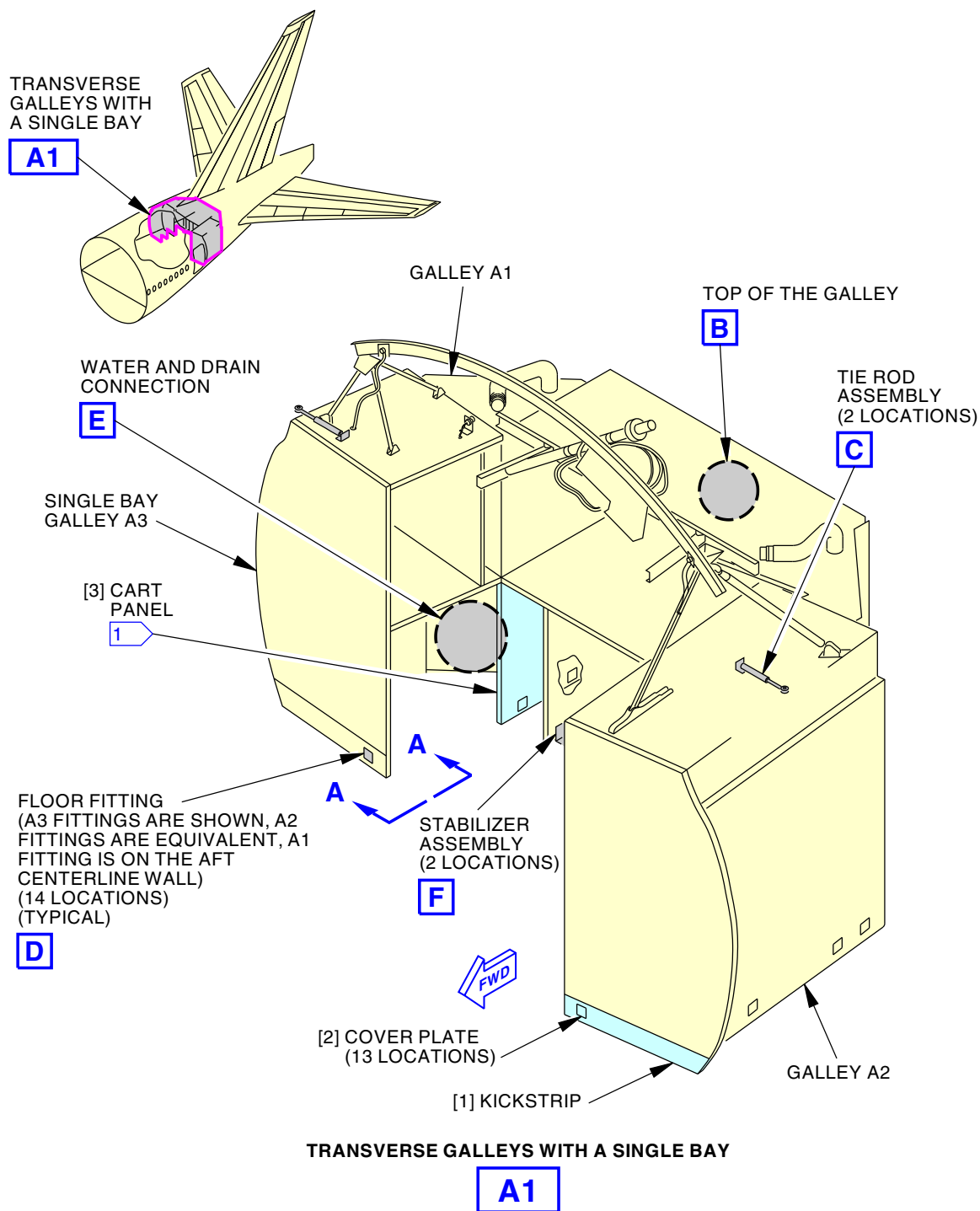
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ARO ALL

25-31-03

D633W101-ARO

Page 410
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



1507055 S0000272531_V2

Aft Fixed Galley Installation
Figure 401/25-31-03-990-805 (Sheet 2 of 12)

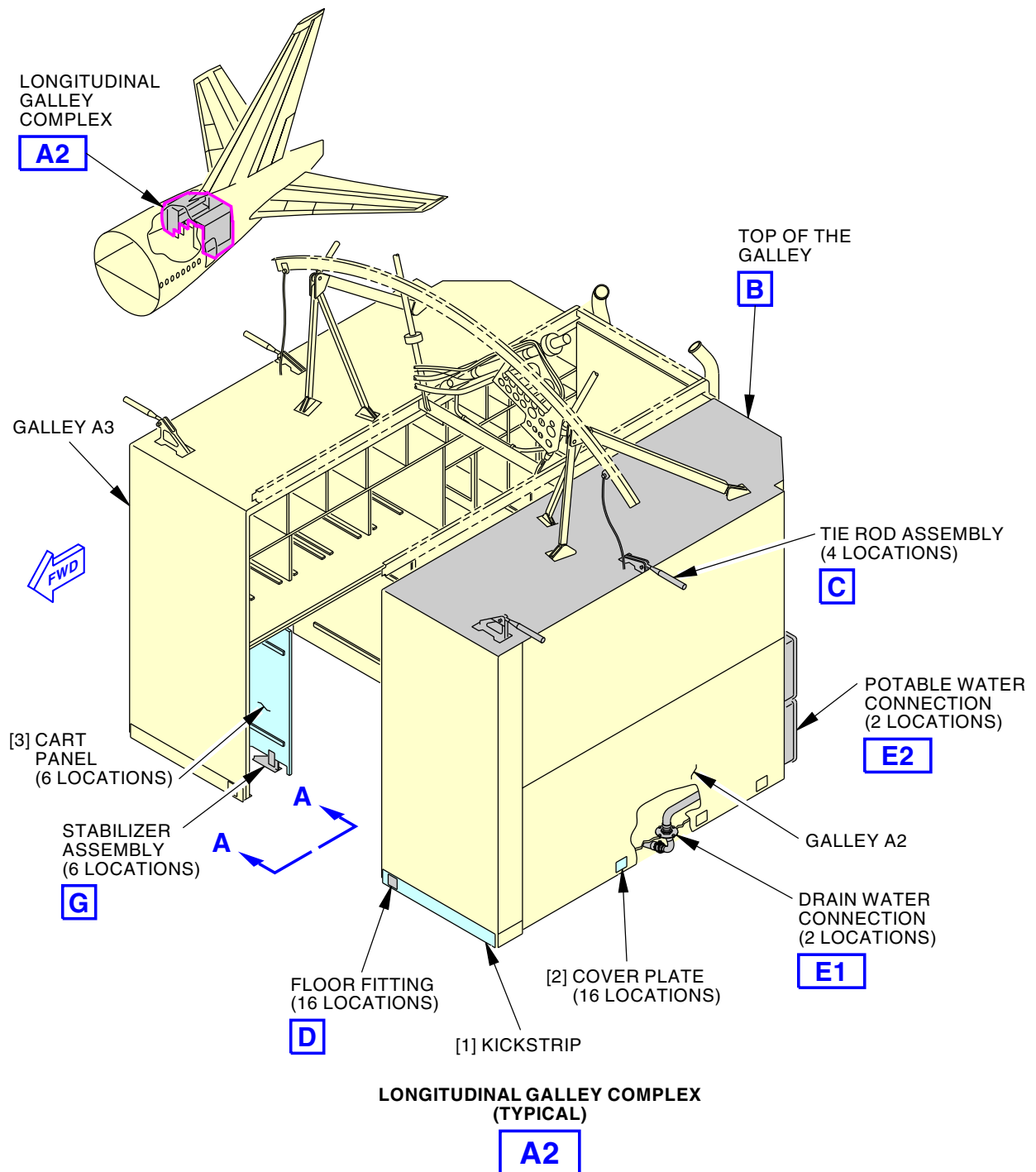
EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 411
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



1507096 S0000272532_V2

Aft Fixed Galley Installation
Figure 401/25-31-03-990-805 (Sheet 3 of 12)

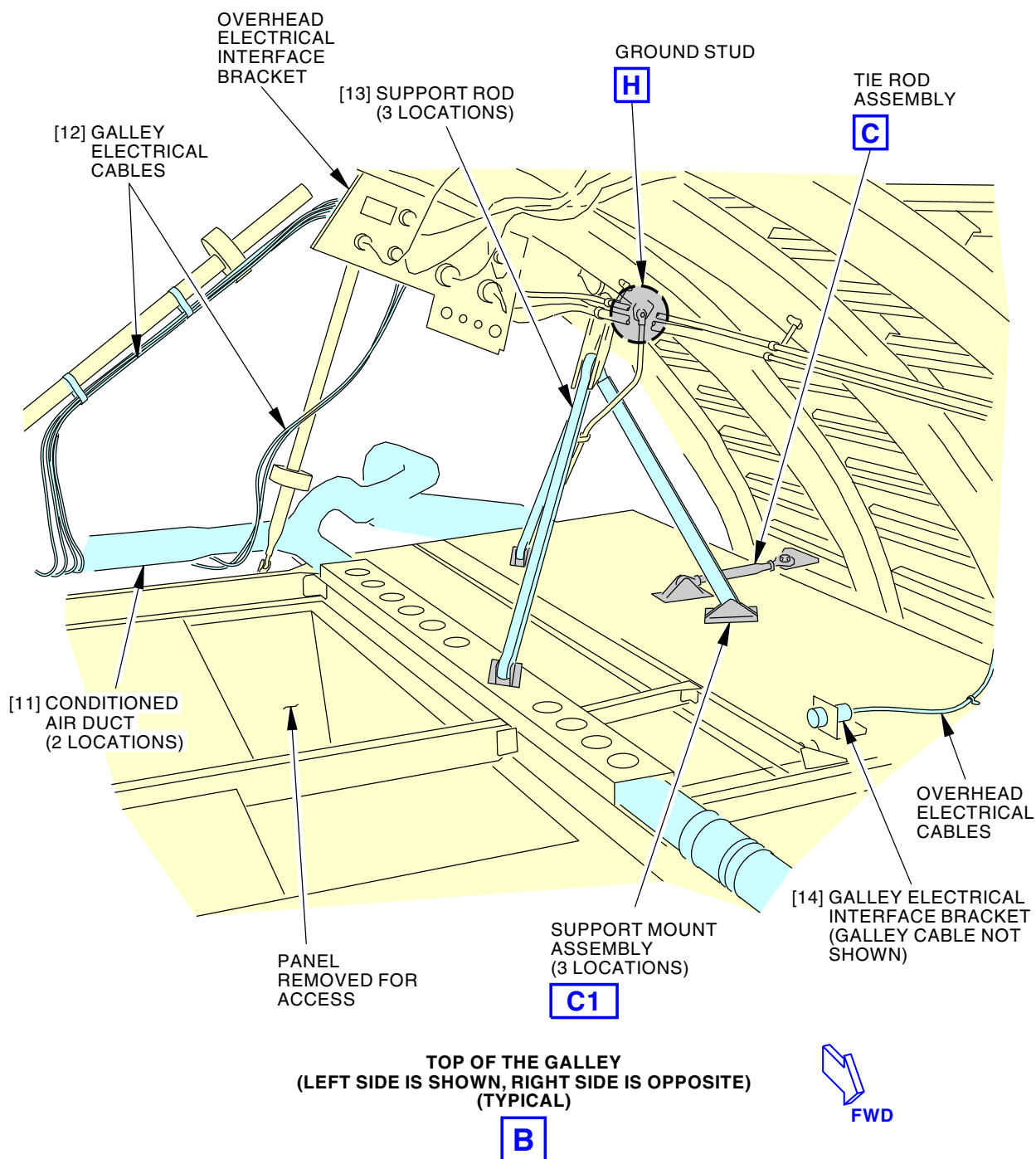
EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 412
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



1507885 S0000272533_V2

**Aft Fixed Galley Installation
Figure 401/25-31-03-990-805 (Sheet 4 of 12)**

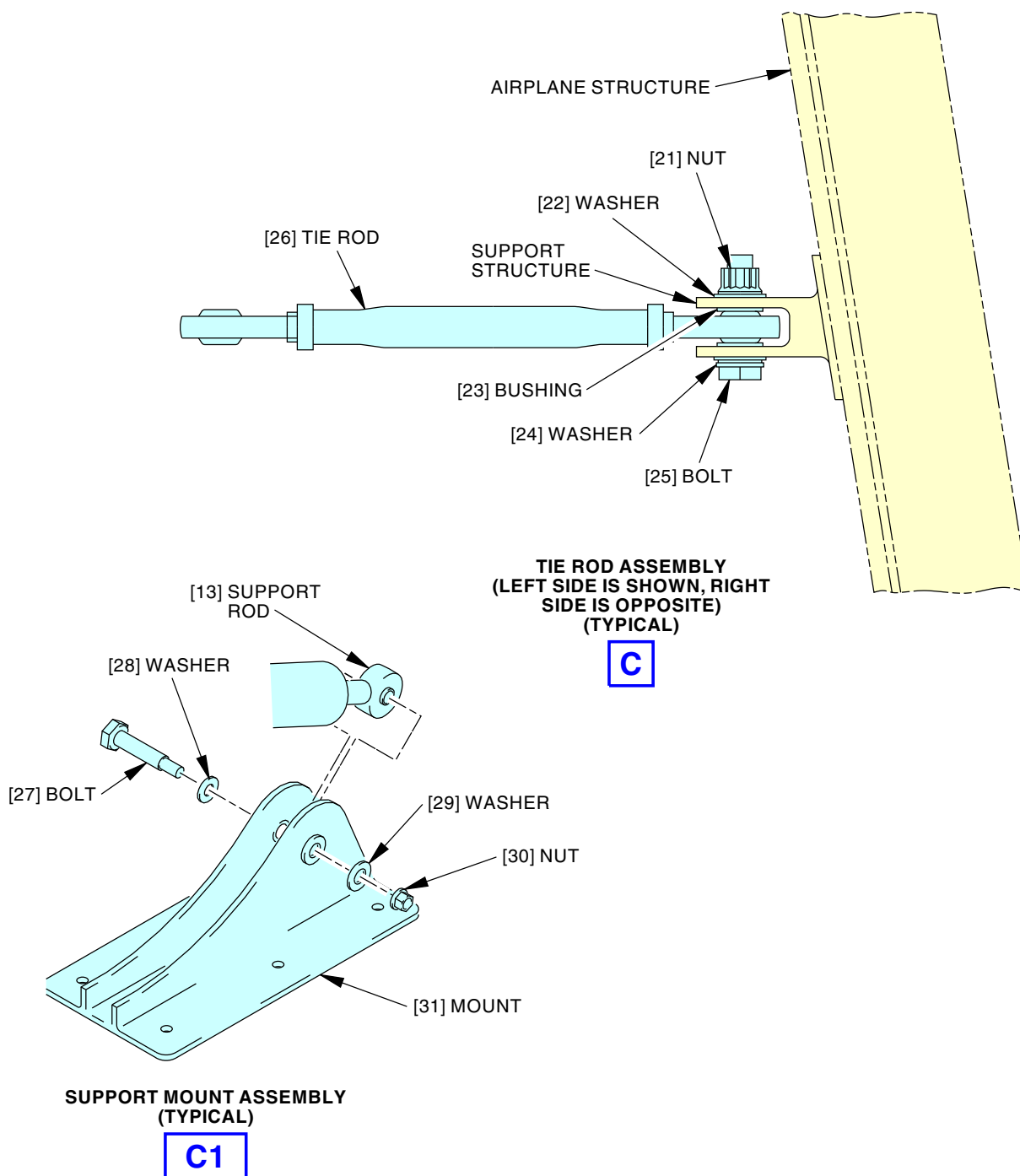
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25-31-03

D633W101-ARO

Page 413
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



1507941 S0000272534_V2

Aft Fixed Galley Installation
Figure 401/25-31-03-990-805 (Sheet 5 of 12)

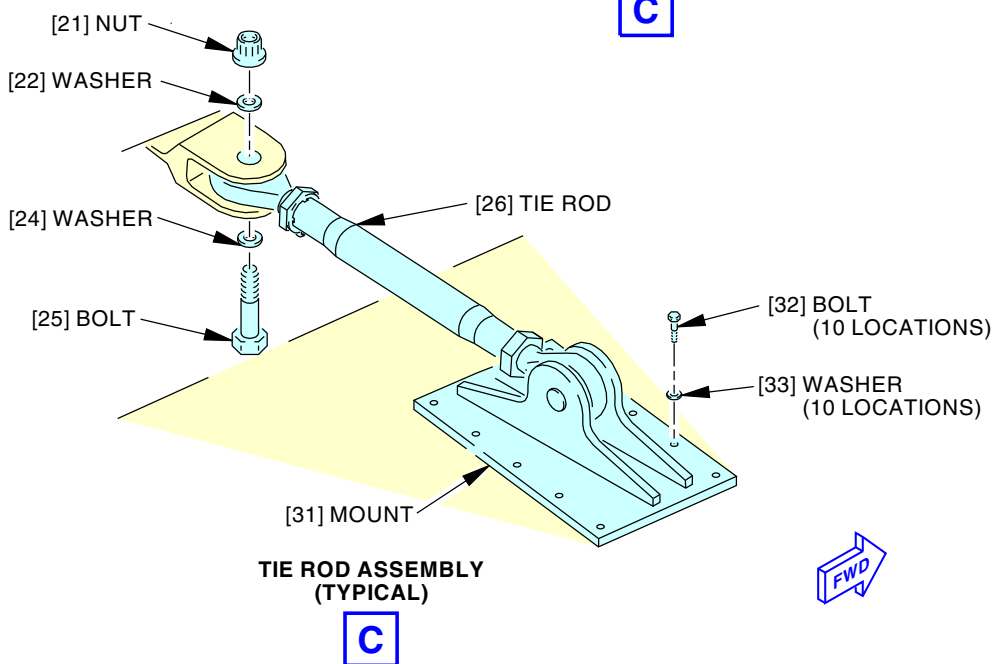
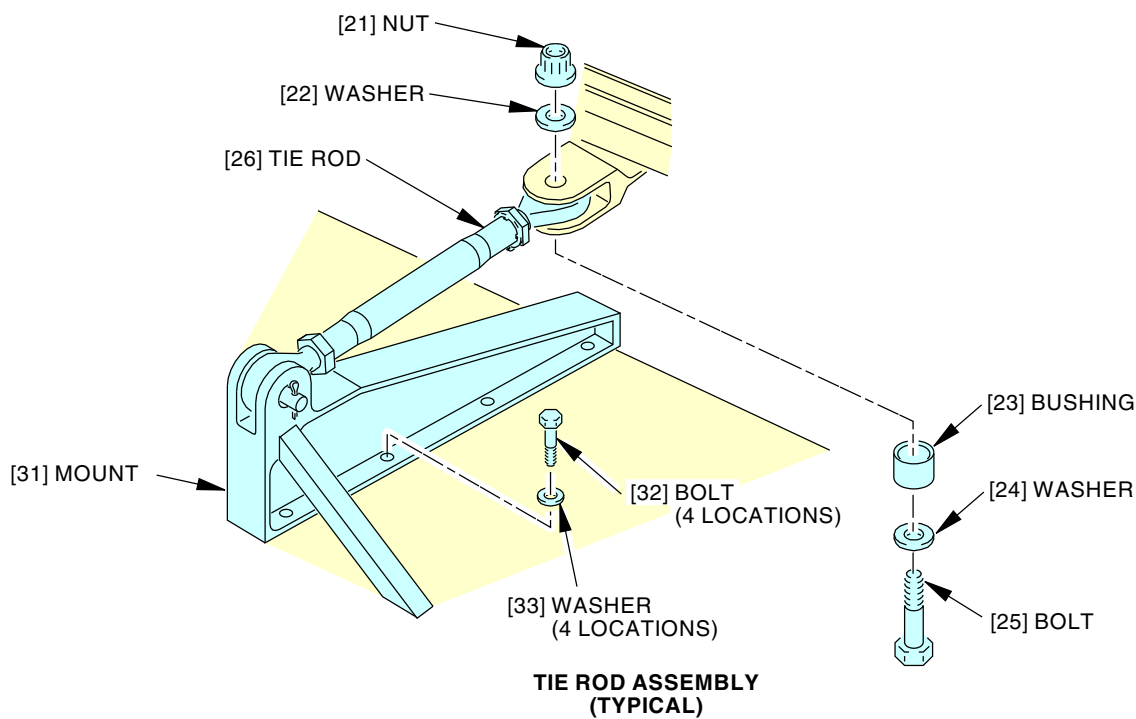
EFFECTIVITY
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D633W101-ARO

25-31-03

Page 414
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



1508046 S0000272535_V2

Aft Fixed Galley Installation
Figure 401/25-31-03-990-805 (Sheet 6 of 12)

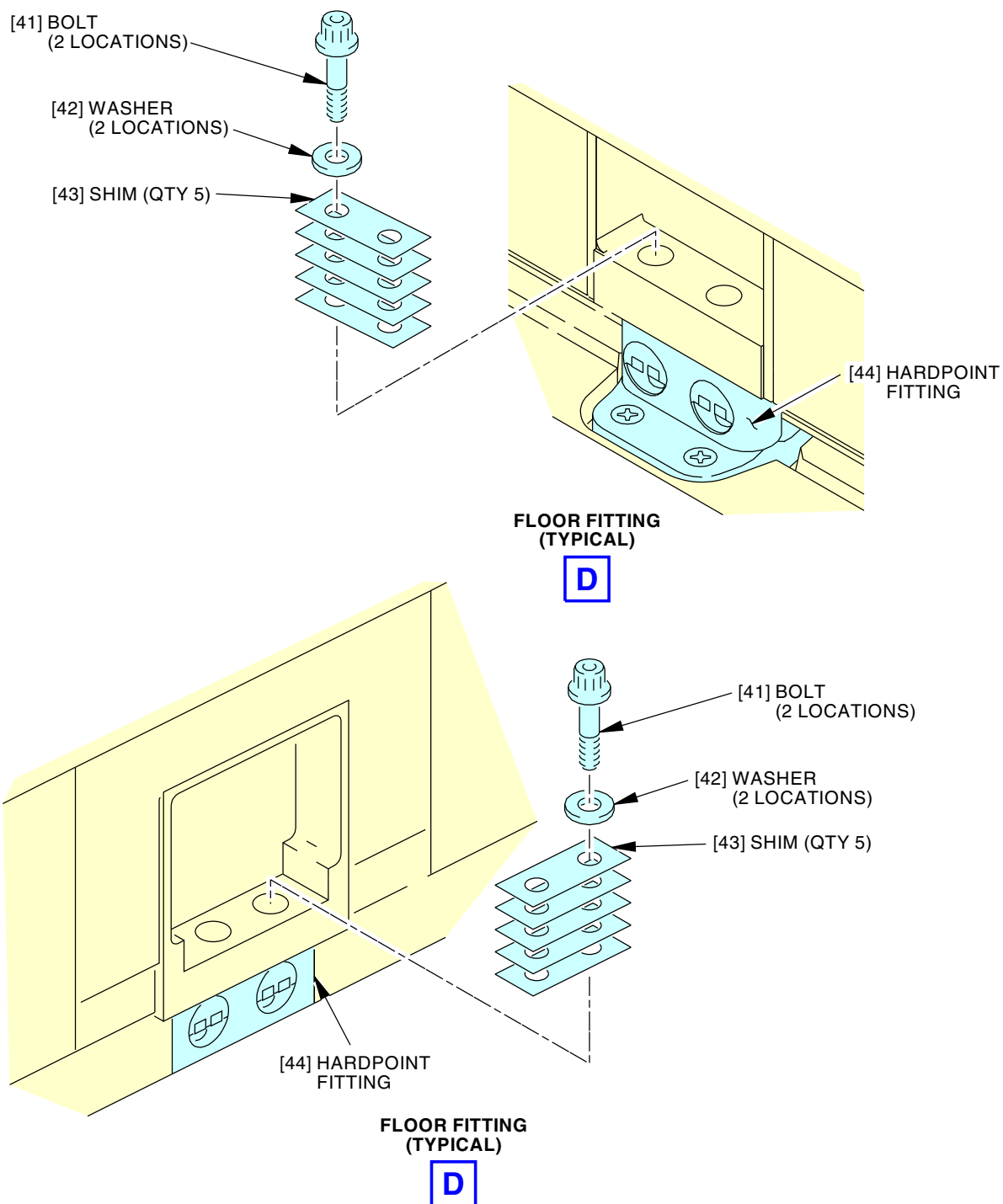
EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-03

Page 415
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



1508070 S0000272536_V2

**Aft Fixed Galley Installation
Figure 401/25-31-03-990-805 (Sheet 7 of 12)**

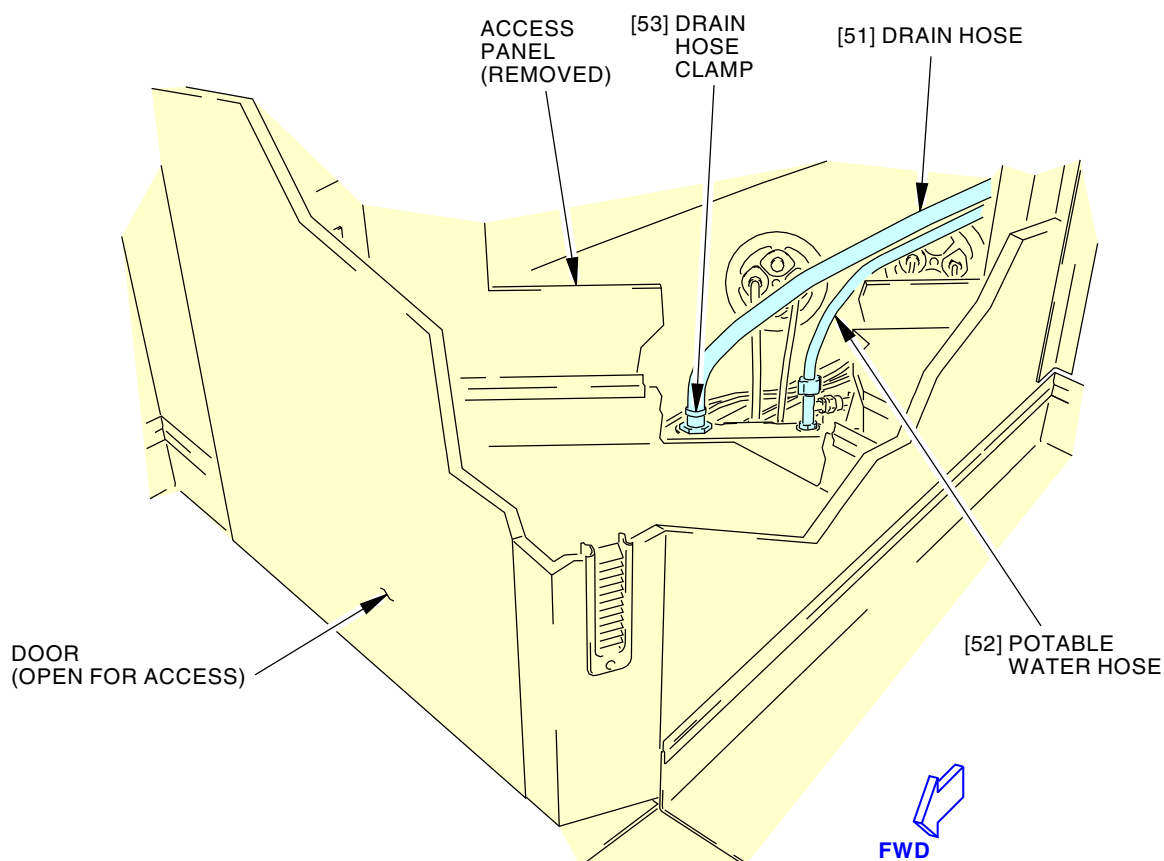
EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 416
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**WATER AND DRAIN CONNECTIONS
(TYPICAL)**

E

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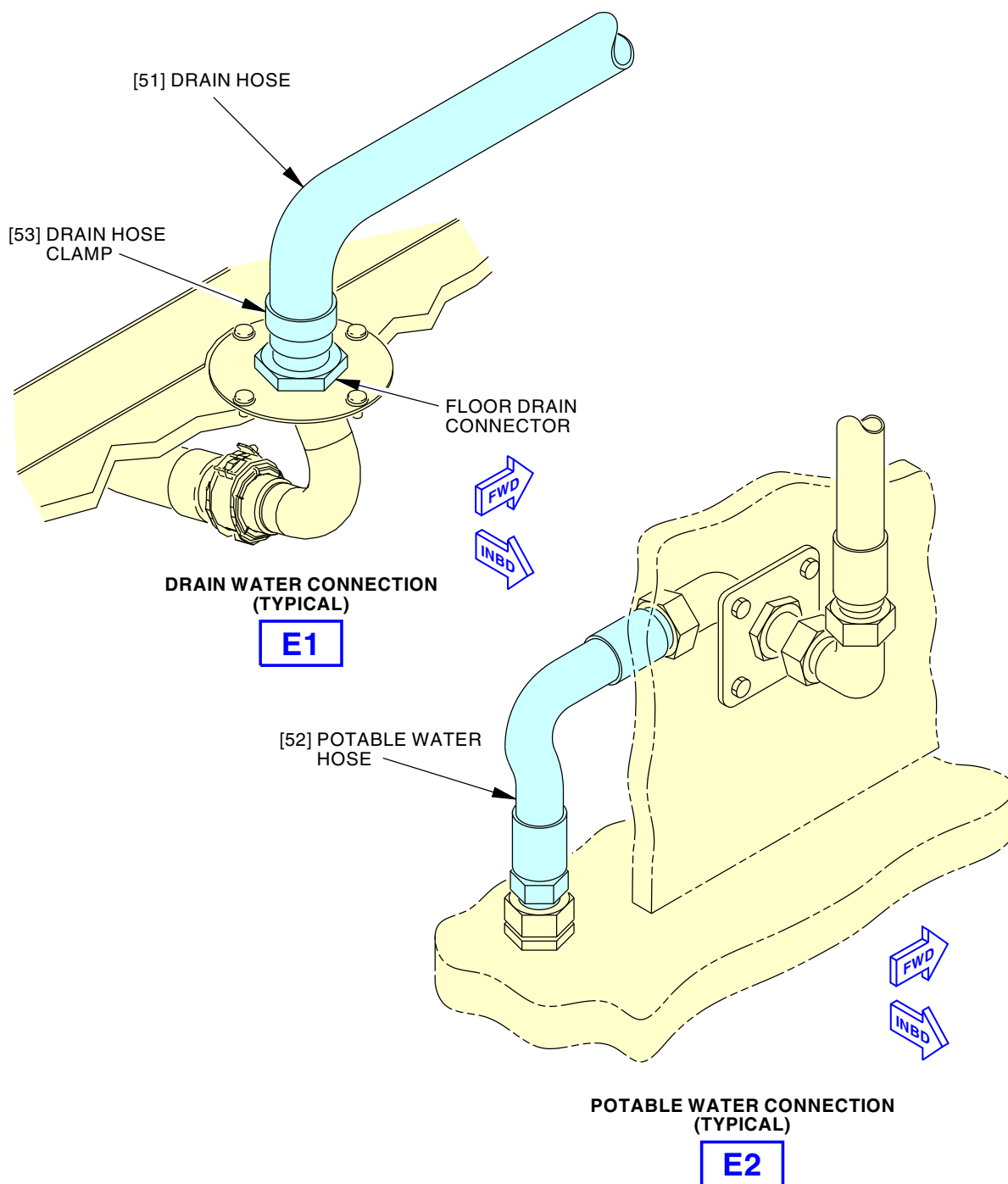
**Aft Fixed Galley Installation
Figure 401/25-31-03-990-805 (Sheet 8 of 12)**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-03

Page 417
May 05/2017



1508123 S0000272538_V2

**Aft Fixed Galley Installation
Figure 401/25-31-03-990-805 (Sheet 9 of 12)**

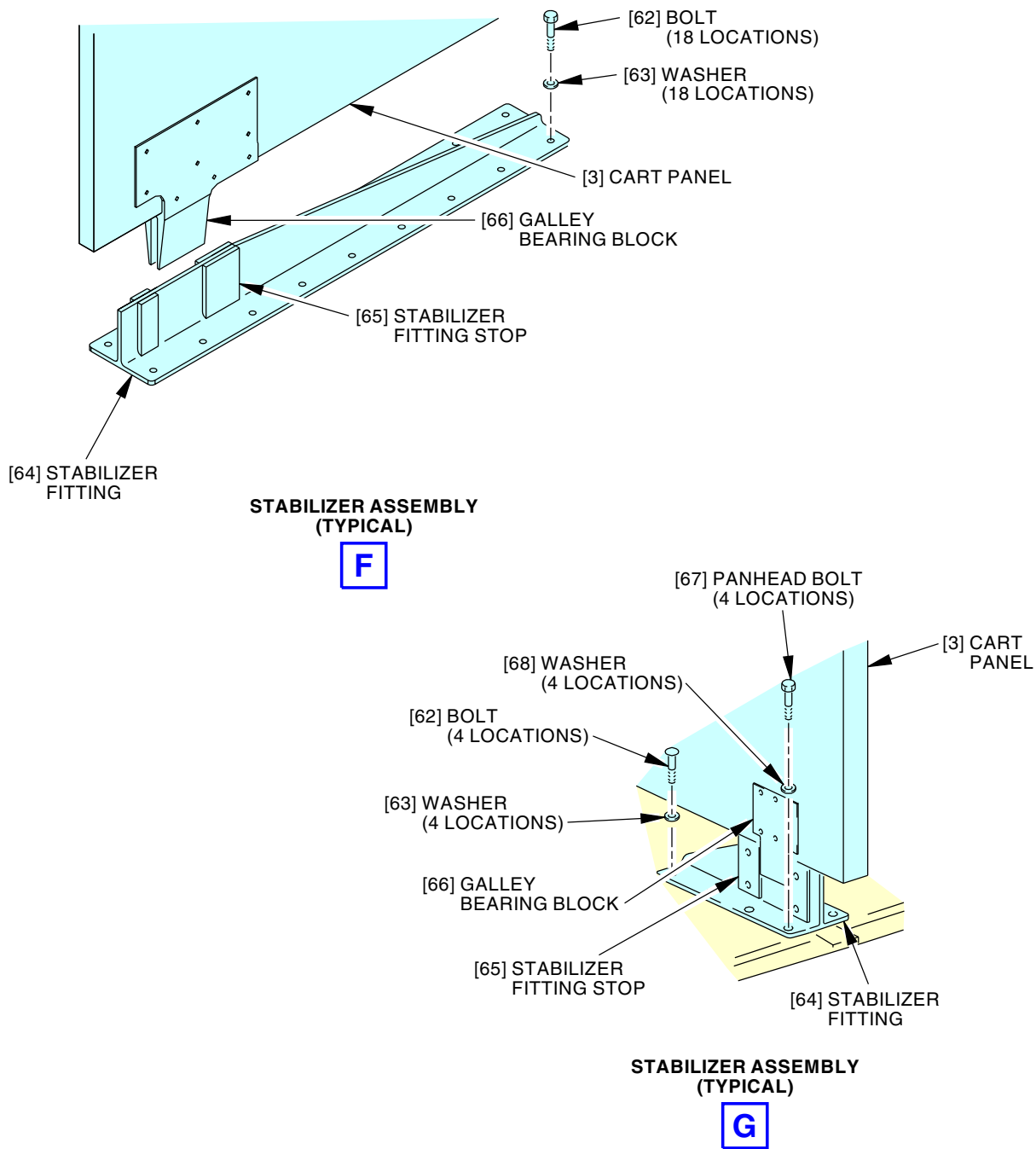
EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-03

Page 418
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



1508188 S0000272539_V2

**Aft Fixed Galley Installation
Figure 401/25-31-03-990-805 (Sheet 10 of 12)**

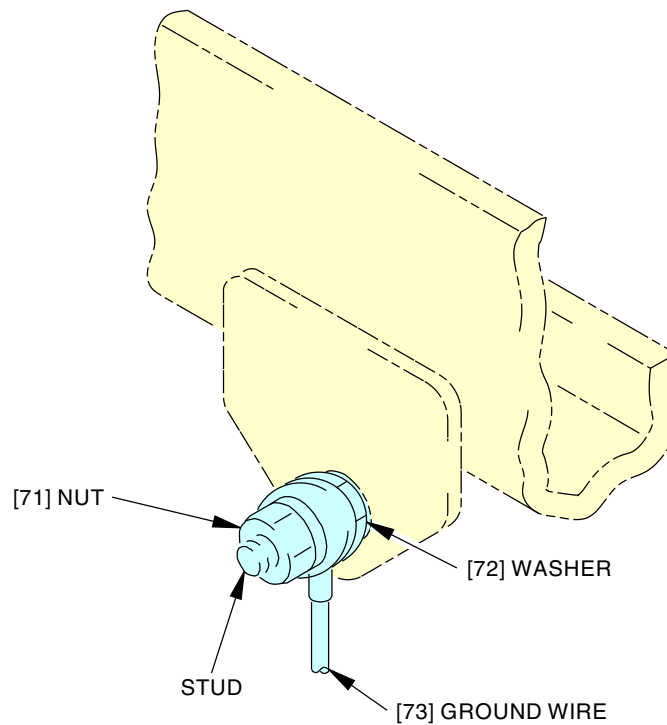
EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 419
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



GROUND STUD
(TYPICAL)



1508259 S0000272540_V2

Aft Fixed Galley Installation
Figure 401/25-31-03-990-805 (Sheet 11 of 12)

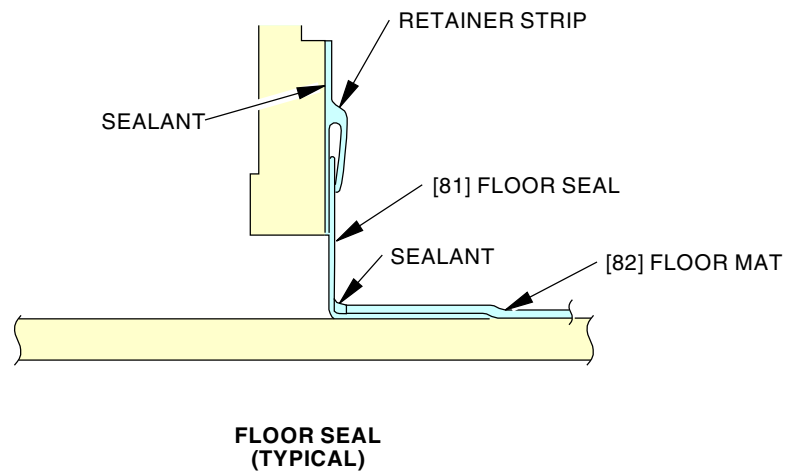
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D633W101-ARO

25-31-03

Page 420
May 05/2017

 BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



1476884 S0000265687_V2

Aft Fixed Galley Installation
Figure 401/25-31-03-990-805 (Sheet 12 of 12)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-03

Page 421
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-31-03-000-805

4. Aft Flexible Galley - Removal

(Figure 402)

A. References

Reference	Title
12-14-01-616-802	Potable Water System - Drain (P/B 301)
25-21-06-000-801	Main Ceiling Panel - Removal (P/B 401)
25-21-07-000-801	Lowered Ceiling Panel Removal (P/B 401)
25-24-01 P/B 401	CLOSETS - REMOVAL/INSTALLATION
25-25-01-000-801	Passenger Seat - Removal (P/B 401)
25-25-06-000-801	Attendant Seat Removal (P/B 401)
25-25-06-000-802	Attendant Seat Removal (P/B 401)
25-25-06-000-806	Attendant Seat Removal (P/B 401)
25-28-05-000-801	Floor-Mounted Stowage Box Removal (P/B 401)
25-41-01-000-801	Lavatory Removal (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-5259	Cup - Vacuum Part #: N4950 Supplier: OSL88

C. Location Zones

Zone	Area
261	Passenger Compartment, Left - Section 47
262	Passenger Compartment, Right - Section 47

D. Prepare for the Removal

SUBTASK 25-31-03-865-003

- (1) Open these circuit breakers and install safety tags:

Ground Service/Handling Power Panel, P320

Row	Col	Number	Name
H	3	C33459	AFT GLY LTS

Left Power Management Panel, P110

Row	Col	Number	Name
J	20	C25607	DR 4L GLY

SUBTASK 25-31-03-010-019

- (2) Remove these items as applicable:
- (a) Do this task: Attendant Seat Removal, TASK 25-25-06-000-801 or Attendant Seat Removal, TASK 25-25-06-000-802 or Attendant Seat Removal, TASK 25-25-06-000-806.
 - (b) Do this task: Floor-Mounted Stowage Box Removal, TASK 25-28-05-000-801.
 - (c) Do this task: Lavatory Removal, TASK 25-41-01-000-801.
 - (d) Do this task: Passenger Seat - Removal, TASK 25-25-01-000-801.

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 422
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (e) Remove the closet if it is necessary. Do the applicable task in this procedure: CLOSETS - REMOVAL/INSTALLATION, PAGEBLOCK 25-24-01/401.
- (f) Do this task adjacent to the galley: Lowered Ceiling Panel Removal, TASK 25-21-07-000-801 or Main Ceiling Panel - Removal, TASK 25-21-06-000-801.

SUBTASK 25-31-03-616-002

- (3) If the galley has potable water connections, do this task: Potable Water System - Drain, TASK 12-14-01-616-802

SUBTASK 25-31-03-030-011

- (4) If necessary, remove the closeout seals from the top and sides of the applicable galley.

SUBTASK 25-31-03-010-020

- (5) Remove the galley ceiling panels Main Ceiling Panel - Removal, TASK 25-21-06-000-801.

SUBTASK 25-31-03-010-021

- (6) Remove the carts and all of the other equipment from the galley.

SUBTASK 25-31-03-030-012

- (7) Do these steps when necessary to prepare the bottom of the galley for the removal:
 - (a) Remove the floor mats [82].
 - (b) Remove the floor seals [81].
NOTE: The floor seals [81] are attached to the floor with carpet tape.
 - (c) Remove the kickstrips [1] from the bottom of the galley.
 - (d) Remove the cover plates [2] from the bottom of the galley.
 - (e) If necessary, remove the access plate to get access to the drain hose.
 - 1) Disconnect the drain hose from the galley drain fitting.

E. Aft Flexible Galley Removal

SUBTASK 25-31-03-030-013

- (1) Do the steps that follow to disconnect the top of the galley:
 - (a) Remove the quick release pins [25] that hold the tie rods [21] to the airplane support structure.
 - (b) Remove the washers [26] from the quick release pins [25].
 - (c) Remove the screws [23] and washers [24] that hold the mounts [22] to the top of the galley.
 - (d) Remove the mount [22] and the tie rod [21] together as a unit.
 - (e) If necessary, disconnect the potable water hose from the galley.
NOTE: A small quantity of water can drain from the line. Make sure that the drain procedure Potable Water System - Drain, TASK 12-14-01-616-802 is complete.
 - (f) If necessary, do these steps to disconnect the galley electrical interface brackets [4]:
NOTE: Some galleys have overhead electrical interface brackets, some have galley electrical interface brackets [4], and some have both.
 - 1) Disconnect the galley electrical cables [5] from the galley electrical interface bracket [4] mounted on top of the galley.
NOTE: Disconnect the galley electrical connectors from the sockets and plugs on the galley electrical interface bracket [4], not from the terminal boards.



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 2) Remove the galley electrical interface bracket [4] from the top of the galley.

NOTE: It is not necessary to disconnect the overhead electrical connectors from the galley electrical interface bracket [4].

- 3) Carefully tie the galley electrical interface bracket [4] with the overhead cables to the overhead structure to allow clearance for the galley.
- (g) If necessary, disconnect the galley electrical cables [5] from the overhead electrical interface bracket.
 - 1) Remove the wire wraps and clamps as necessary from the galley electrical cable bundles and put these cables [5] on top of the galley.
- (h) Disconnect the ground wire [3] from the overhead support structure at the ground stud.
- (i) If necessary, do these steps to disconnect the refrigeration hoses:
 - 1) Disconnect the refrigeration hose from the galley air inlet.
 - 2) Disconnect the outlet or ventilation hose from the galley air outlet.
 - 3) Carefully tie the hoses to the overhead structure to allow clearance for the galley.

SUBTASK 25-31-03-030-014

- (2) Do these steps to disconnect the galley from the floor:
 - (a) Remove the applicable bolts [31], washers [32], shims [33], bushings [34], and bushings [38] to disconnect the galley from the transverse fittings [37] and the longitudinal fittings [41] or [42].

SUBTASK 25-31-03-020-037

- (3) If necessary, use the vacuum cup, SPL-5259 to carefully remove the galley.

NOTE: Use of the vacuum cup is optional.

SUBTASK 25-31-03-030-015

- (4) If necessary, do these steps to remove the longitudinal fittings [41] or [42]:
 - (a) Remove the nuts [40] from the studs [39].
 - (b) Remove the longitudinal fittings [41] or [42] from the studs [39].

SUBTASK 25-31-03-030-016

- (5) If necessary, do these steps to remove the transverse fittings [37]:
 - (a) Remove the bolts [35] that hold the transverse fittings [37] to the saddle fittings [36].
 - (b) Lift the transverse fittings [37] from the saddle fitting [36].

SUBTASK 25-31-03-030-017

- (6) If necessary, do these steps to remove the saddle fittings [36] or the seat track studs [39]:
 - (a) Remove the tape and filler from the seat track immediately left or right of the saddle fittings [36] or seat track studs [39].
 - (b) Move the saddle fittings [36] or seat track studs [39] left or right approximately 0.5 in. (13 mm) to align it with the circular openings in the seat track.
 - (c) Lift the saddle fittings [36] or seat track studs [39] out of the seat track.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 424
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-31-03-400-805

5. Aft Flexible Galley Installation

(Figure 402)

A. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
25-21-06-400-801	Main Ceiling Panel - Installation (P/B 401)
25-21-07-400-801	Lowered Ceiling Panel Installation (P/B 401)
25-24-01 P/B 401	CLOSETS - REMOVAL/INSTALLATION
25-25-01-400-801	Passenger Seat - Installation (P/B 401)
25-25-06-400-801	Attendant Seat Installation (P/B 401)
25-25-06-400-802	Attendant Seat Installation (P/B 401)
25-25-06-400-806	Attendant Seat Installation (P/B 401)
25-28-05-400-801	Floor-Mounted Stowage Box - Installation (P/B 401)
25-41-01-400-801	Lavatory Installation (P/B 401)
38-10-00-600-801	Potable Water System - Disinfectant (P/B 201)
38-10-00-790-801	Potable Water System - Leak Test (P/B 201)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-5259	Cup - Vacuum Part #: N4950 Supplier: OSL88

C. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
G01288	Tape - Carpet	BMS5-133
G02304	Tape - Moisture Barrier, Adhesive One-side	BMS8-346
G50042	Filler, Seat Track, Polycarbonate Extrusion	BAC1522-275 from BMS8-251

D. Location Zones

Zone	Area
261	Passenger Compartment, Left - Section 47
262	Passenger Compartment, Right - Section 47

E. Aft Flexible Galley Installation

SUBTASK 25-31-03-430-013

- (1) If necessary, do these steps to install the seat track studs [39] or saddle fitting [36]:
 - (a) Remove the tape and filler from the seat track.

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 425
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (b) Put compound, C00528, on the seat track studs [39] or saddle fitting [36].
- (c) Put the seat track studs [39] or saddle fitting [36] in the circular opening in the seat track.
- (d) Move the seat track studs [39] or saddle fitting [36] left or right 0.5 in. (13 mm) to lock it in the correct position for the installation.
- (e) Apply new filler, G50042 in the seat track on each end of the seat track studs [39] or saddle fitting [36].
- (f) Apply new moisture barrier tape, G02304, with a cutout for the seat track fittings.

SUBTASK 25-31-03-430-014

- (2) If necessary, do these steps to install the transverse fittings [37]:
 - (a) Apply corrosion preventive compound, C00308 to the transverse fittings [37] and the bolts [35].
 - (b) Install the transverse fittings [37] with the bolts [35] to the saddle fittings [36].
 - (c) Tighten the bolts [35] to 70.5 $\pm$ 2.5 in-lb (7.97 $\pm$ 0.29 N·m).

SUBTASK 25-31-03-430-015

- (3) If necessary, do these steps to install the longitudinal fittings [41] or [42]:
 - (a) Apply corrosion preventive compound, C00308 to the seat track, studs [39], longitudinal fittings [41] or [42], and the nuts [40].
 - (b) Install the longitudinal fittings [41] or [42] with the nuts [40] on the studs [39].
 - (c) Tighten the nuts [40] to 200 $\pm$ 40 in-lb (22.6 $\pm$ 4.5 N·m).
 - 1) If the torque value is more than 240 in-lb (27 N·m) replace the studs [39].

SUBTASK 25-31-03-430-016

- (4) Do these steps to connect the galley to the floor:
 - (a) Make sure there is an isolator plate on the bottom of the monument at each floor fitting.
NOTE: The isolator plate is a piece of stainless steel. It is necessary to prevent corrosion between the galley and the seat track fitting.
 - (b) If necessary, use the vacuum cup, SPL-5259 to align the galley on top of the seat track longitudinal fittings [41] or [42] and transverse fittings [37].
NOTE: Use of the vacuum cup is optional.
 - (c) Apply a layer of corrosion preventive compound, C00308 on the shims [33] and then install them at the bolt holes.
 - (d) If there is clearance between the galley and the floor then fill this clearance with shims [33].
NOTE: This will provide a proper fit and avoid interference with adjacent furnishings.
NOTE: The shims [33] are only installed on the outboard floor fittings to keep the galley aligned.
 - (e) Temporarily install the hinged ceiling panel so you can measure the clearance between it and the galley.
 - (f) Install the shims [33] between the galley and the seat track transverse fittings [37] until there is a minimum of 0.5 in. (13 mm) clearance between the hinged ceiling panel and the galley.
NOTE: If this clearance is too small, then the ceiling panel can hit the galley when you open the ceiling panel.
 - (g) Put the remaining shims [33] below the head of the bolts [31].

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 426
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (h) Apply corrosion preventive compound, C00308 on the bushings [34] and bushings [38].
- (i) Install the bushings [34] and bushings [38] to the appropriate seat track fitting.
NOTE: Install a single bushing [38] on each of the inboard seat track fittings and bushings [34] on each of the outboard seat track fittings.
NOTE: Aft facing galleys need bushings [34] on the forward longitudinal fittings (back of the galley) and no bushings on the aft longitudinal fittings (front of the galley).
- (j) Apply corrosion preventive compound, C00308 on the bolts [31] and washers [32].
- (k) Install the bolts [31] and washers [32] to attach the galley to the seat track longitudinal fittings [41] or [42] and transverse fittings [37].
- (l) Tighten all the bolts [31] to 200 ±50 in-lb (22.6 ±5.7 N·m).

SUBTASK 25-31-03-430-017

- (5) If necessary, connect the drain hose to its drain fittings.
 - (a) Install the drain hose access plate.

SUBTASK 25-31-03-430-018

- (6) Do these steps to connect the top of the galley:
 - (a) Install the mount [22] and the tie rod [21] together as a unit with the screws [23] and washers [24] to the top of the galley.
 - (b) Connect the tie rod [21] to the support structure with the quick release pins [25] and washers [26].
NOTE: The tie rods [21] should have no pre-load on it when you install it.
 - 1) Adjust the tie rod end fittings as required to help install the tie rod [21].
NOTE: Do not adjust either end fitting past the witness hole.
 - 2) Remove the lockwire on either end of the tie rod [21] if more adjustment is necessary.
 - 3) Tighten the tie rod [21] jam nuts when adjustments are complete.
 - 4) If necessary, install a lockwire to the ends of the tie rod [21].
 - (c) If necessary, connect the potable water hose to the galley.
 - (d) If necessary, do these steps to connect the galley electrical cables [5] to the overhead electrical interface brackets:

NOTE: Some galleys have overhead electrical interface brackets, some have galley electrical interface brackets [4], and some have both.

- 1) Connect the galley electrical cables [5] to the appropriate overhead electrical interface bracket.
NOTE: Connect the galley electrical connectors to the sockets and plugs on the overhead electrical interface bracket, not to the terminal boards.
 - (e) If necessary, do these steps to connect the galley electrical interface brackets [4]:
 - 1) Carefully untie the galley electrical interface bracket [4] with the overhead cables from the overhead structure and put them on top of the galley.
 - 2) Install the electrical interface bracket [4] with the cables to the top of the galley.
 - 3) Connect the galley electrical cables [5] to the galley electrical interface bracket [4].
 - (f) Connect the ground wire [3] to the overhead support structure at the ground stud.



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 1) Do a resistance check of the static grounds from the galley ground stud to the aircraft static ground stud.
 - a) Make sure the resistance is a maximum of 0.0025 Ohms.
- (g) Install the wire wraps and clamps as necessary to the cable bundles above the galley.

F. Aft Flexible Galley Installation Test

SUBTASK 25-31-03-410-029

- (1) Install the carts and all of the other equipment in the galley.

SUBTASK 25-31-03-865-004

- (2) Remove the safety tags and close these circuit breakers:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	3	C33459	AFT GLY LTS

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	20	C25607	DR 4L GLY

SUBTASK 25-31-03-861-002

- (3) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-31-03-790-002

- (4) If the galley has potable water connections, do this task: Potable Water System - Leak Test, TASK 38-10-00-790-801.

SUBTASK 25-31-03-670-002

- (5) If the galley has potable water connections, do this task: Potable Water System - Disinfectant, TASK 38-10-00-600-801.

SUBTASK 25-31-03-710-004

- (6) Do a check to make sure the galley lights come on.

SUBTASK 25-31-03-710-005

- (7) Do a test of the galley equipment.

SUBTASK 25-31-03-430-019

- (8) Install the closeout seals to the top and sides of the galleys.

SUBTASK 25-31-03-410-030

- (9) Install the galley ceiling panels Main Ceiling Panel - Installation, TASK 25-21-06-400-801.

SUBTASK 25-31-03-430-020

- (10) Do these steps to install the floor seal [81]:
 - (a) If necessary, apply new sealant, A02315 under the retainer strip.
 - (b) If necessary, apply new carpet tape, G01288 on the floor seal [81] base.

NOTE: Keep a 4 in. (10 cm) space in the carpet tape, G01288, in the center of the floor seal [81] on the back wall of the galley.
 - (c) Push the base of the floor seal [81] to the floor.
 - (d) Install the top of the floor seal [81] into the floor seal retainer.

SUBTASK 25-31-03-430-021

- (11) Do these steps to install the floor mats [82]:

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-03

Page 428
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (a) Apply the new carpet tape, G01288 to the floor mats [82] in the forward and aft direction with 1 in. (3 cm) between each piece.
- (b) Keep the carpet tape, G01288, approximately 1 in. (3 cm) from the edge of the floor mats [82].
- (c) Cover the floor seal [81] with the floor mats [82].
- (d) Apply the sealant, A02315, to make a fillet seal around the edges of the floor mats [82].

SUBTASK 25-31-03-430-022

- (12) Install the cover plates [2] and kickstrips [1] to the galley.
 - (a) Apply sealant, A02315 to make a seal around the cover plates [2] for the galley fittings.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 25-31-03-410-031

- (1) Install these items as applicable:
 - (a) Do this task adjacent to the galley: Lowered Ceiling Panel Installation, TASK 25-21-07-400-801 or Main Ceiling Panel - Installation, TASK 25-21-06-400-801.
 - (b) Install the closet if applicable. Do the applicable task in this procedure: CLOSETS - REMOVAL/INSTALLATION, PAGEBLOCK 25-24-01/401.
 - (c) Do this task: Passenger Seat - Installation, TASK 25-25-01-400-801.
 - (d) Do this task: Lavatory Installation, TASK 25-41-01-400-801.
 - (e) Do this task: Floor-Mounted Stowage Box - Installation, TASK 25-28-05-400-801.
 - (f) Do this task: Attendant Seat Installation, TASK 25-25-06-400-801 or Attendant Seat Installation, TASK 25-25-06-400-802 or Attendant Seat Installation, TASK 25-25-06-400-806.

———— **END OF TASK** ————

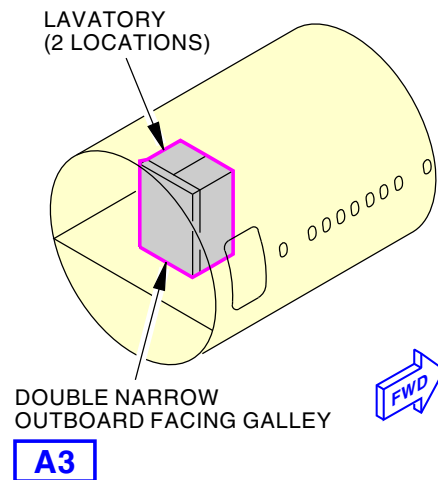
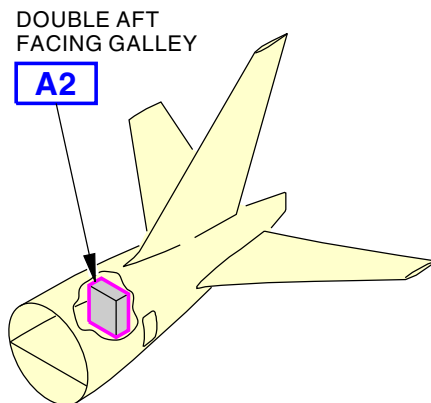
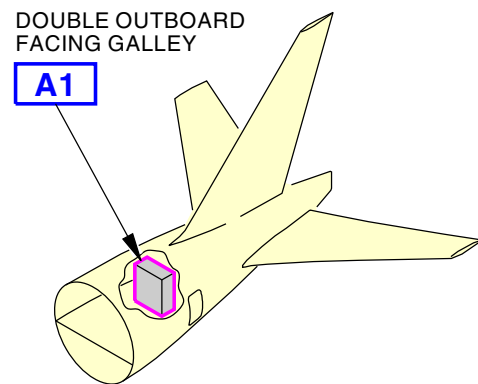
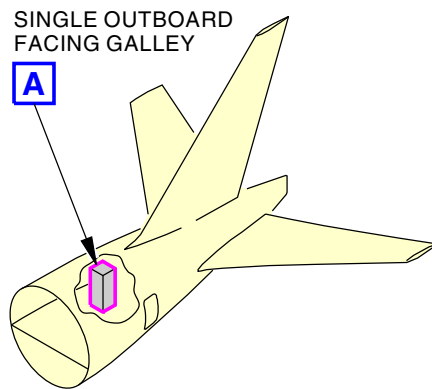
EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 429
May 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



1506748 S0000275574_V2

Aft Flexible Galley Installation
Figure 402/25-31-03-990-806 (Sheet 1 of 14)

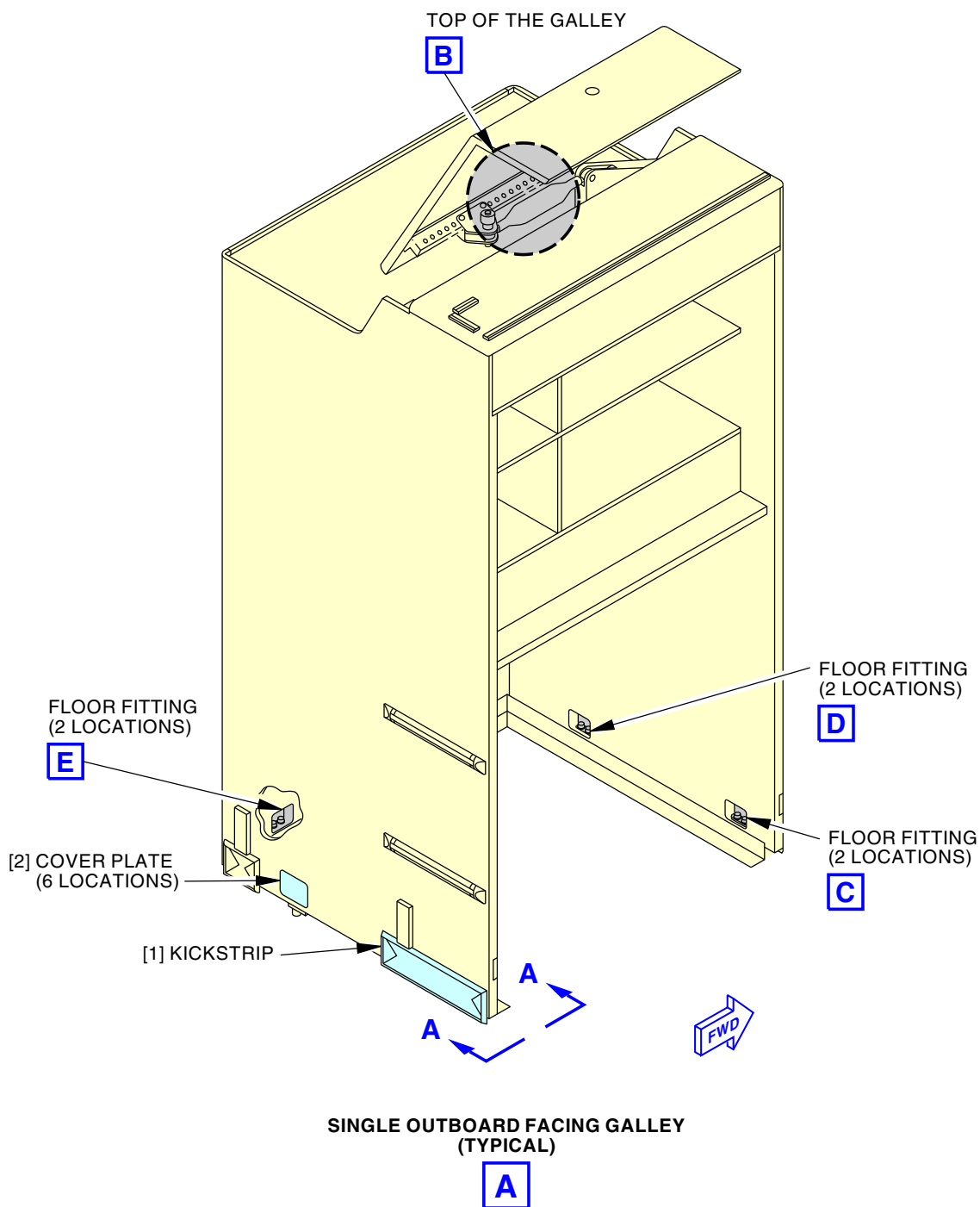
EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-03

Page 430
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



1506758 S0000275576_V2

Aft Flexible Galley Installation
Figure 402/25-31-03-990-806 (Sheet 2 of 14)

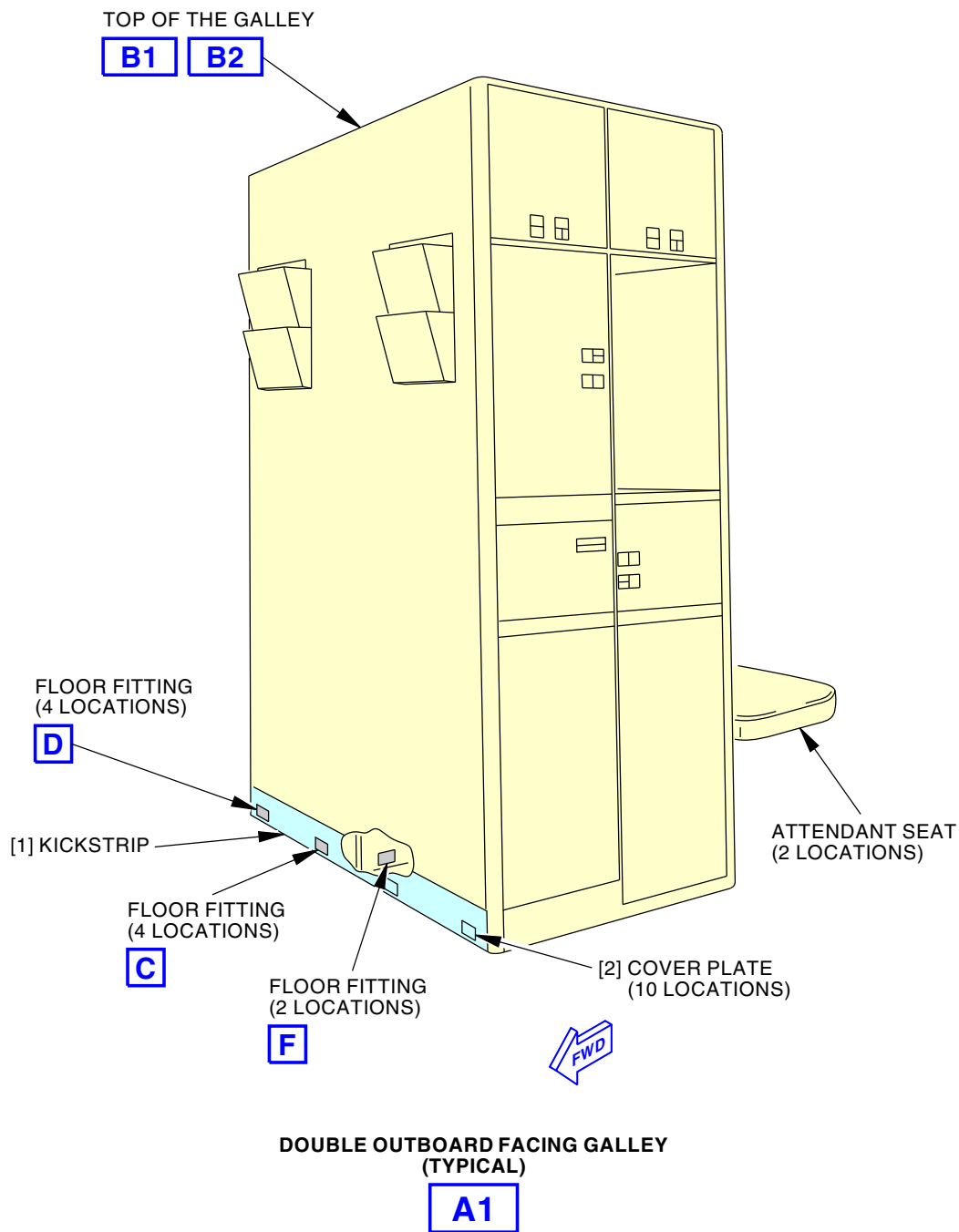
EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 431
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



1506914 S0000275578_V2

Aft Flexible Galley Installation
Figure 402/25-31-03-990-806 (Sheet 3 of 14)

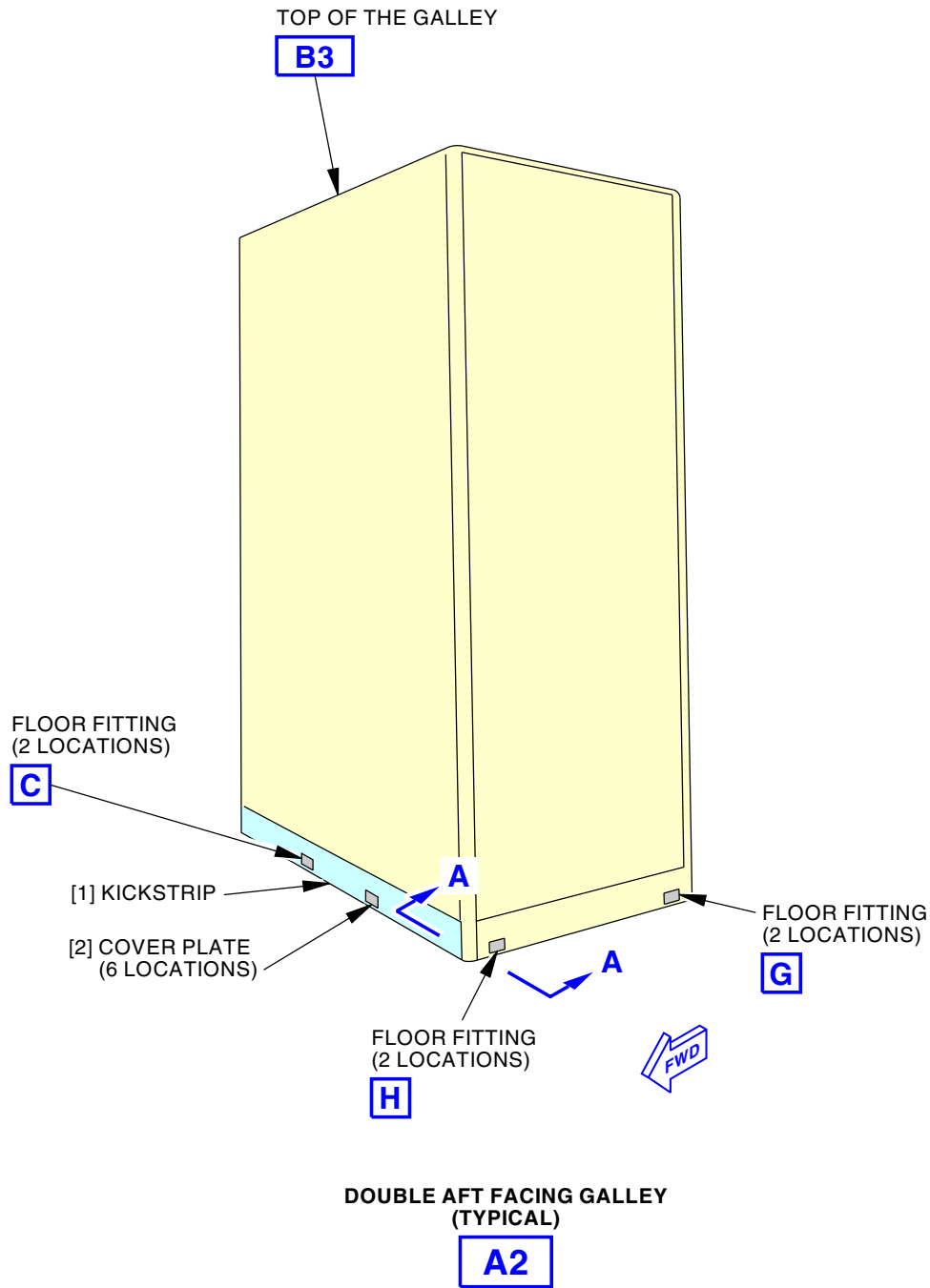
EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-03

Page 432
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



1506969 S0000275579_V2

Aft Flexible Galley Installation
Figure 402/25-31-03-990-806 (Sheet 4 of 14)

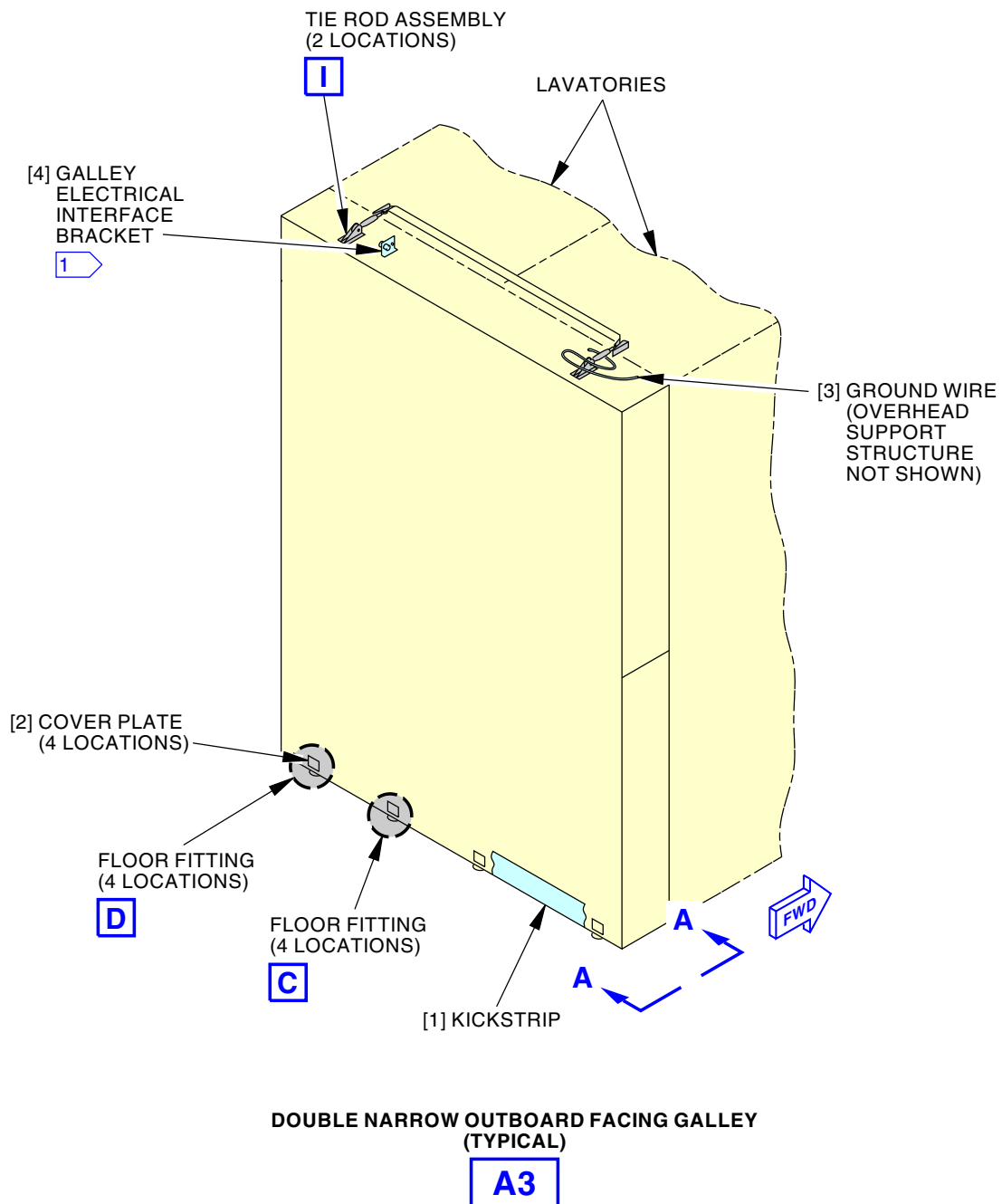
EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 433
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



1 OVERHEAD AND GALLEY CABLES NOT SHOWN

1507065 S0000275580_V2

Aft Flexible Galley Installation
Figure 402/25-31-03-990-806 (Sheet 5 of 14)

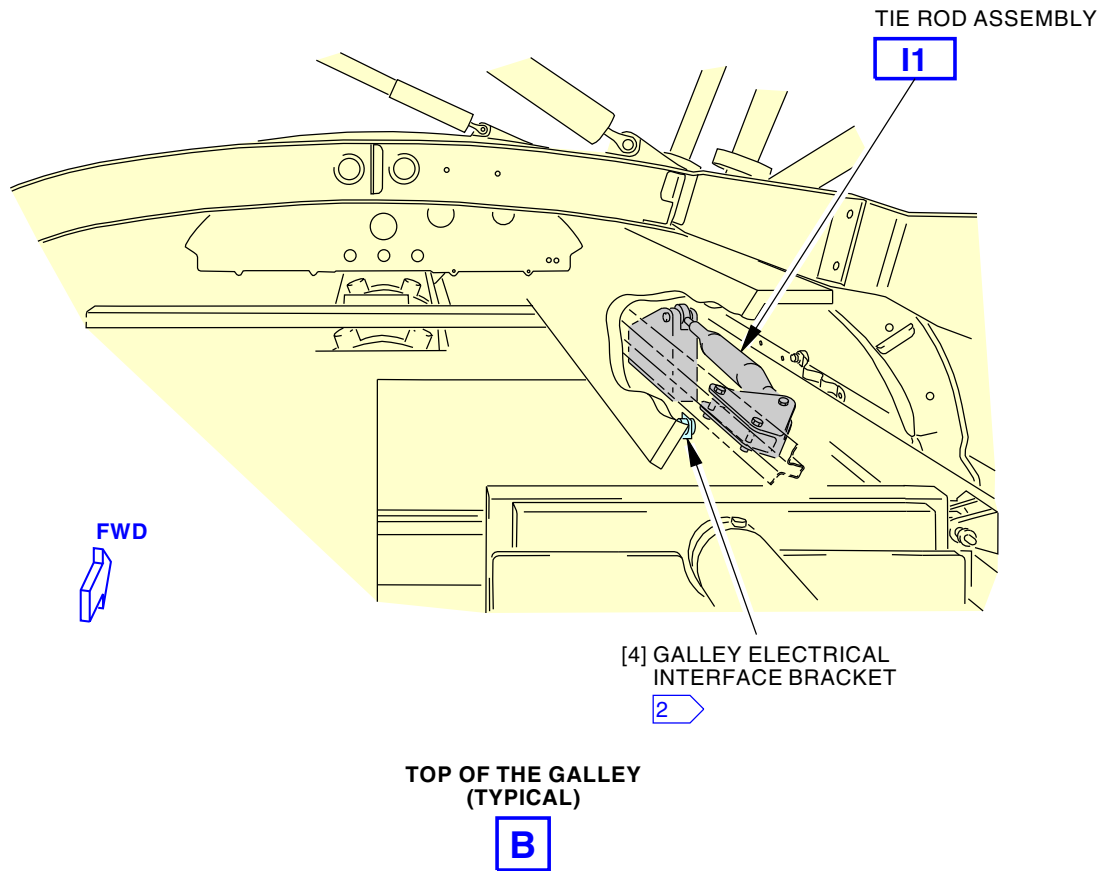
EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-03

Page 434
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



2 OVERHEAD CABLES NOT SHOWN

1507091 S0000275581_V2

Aft Flexible Galley Installation
Figure 402/25-31-03-990-806 (Sheet 6 of 14)

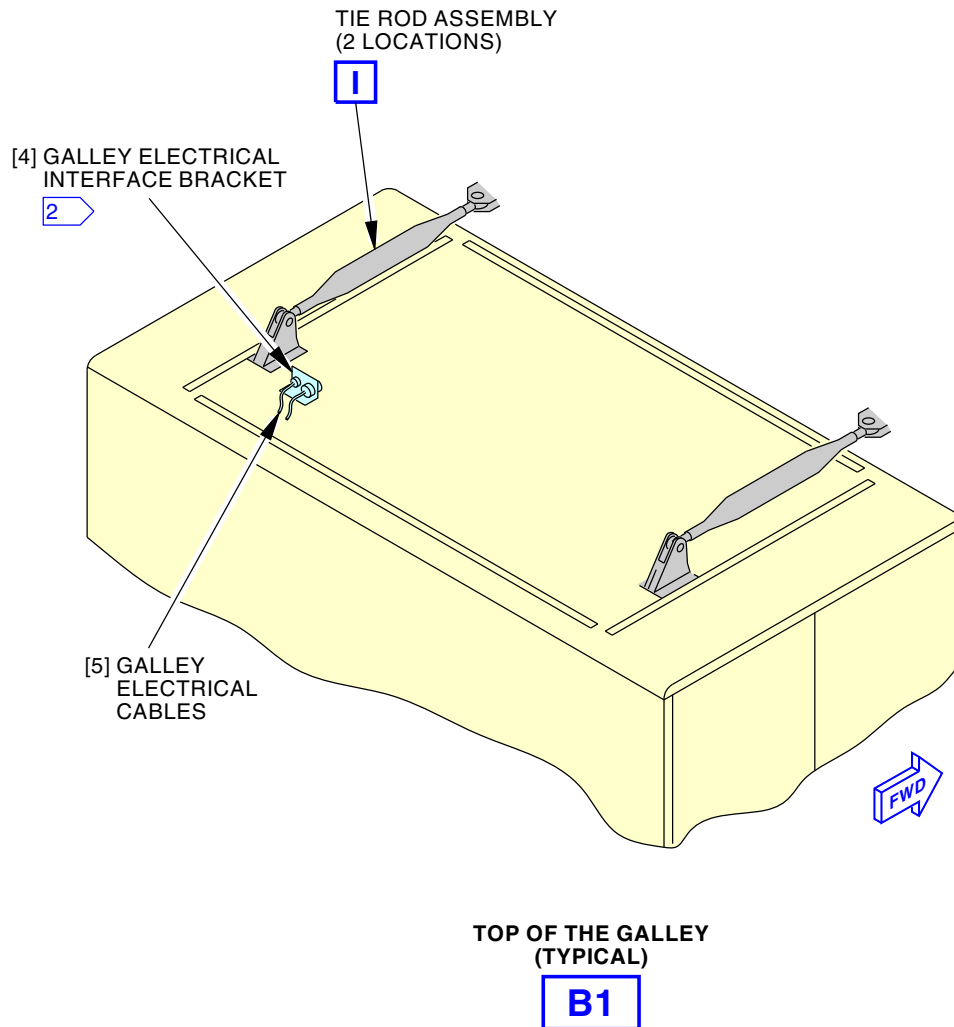
EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-03

Page 435
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



1507122 S0000275582_V2

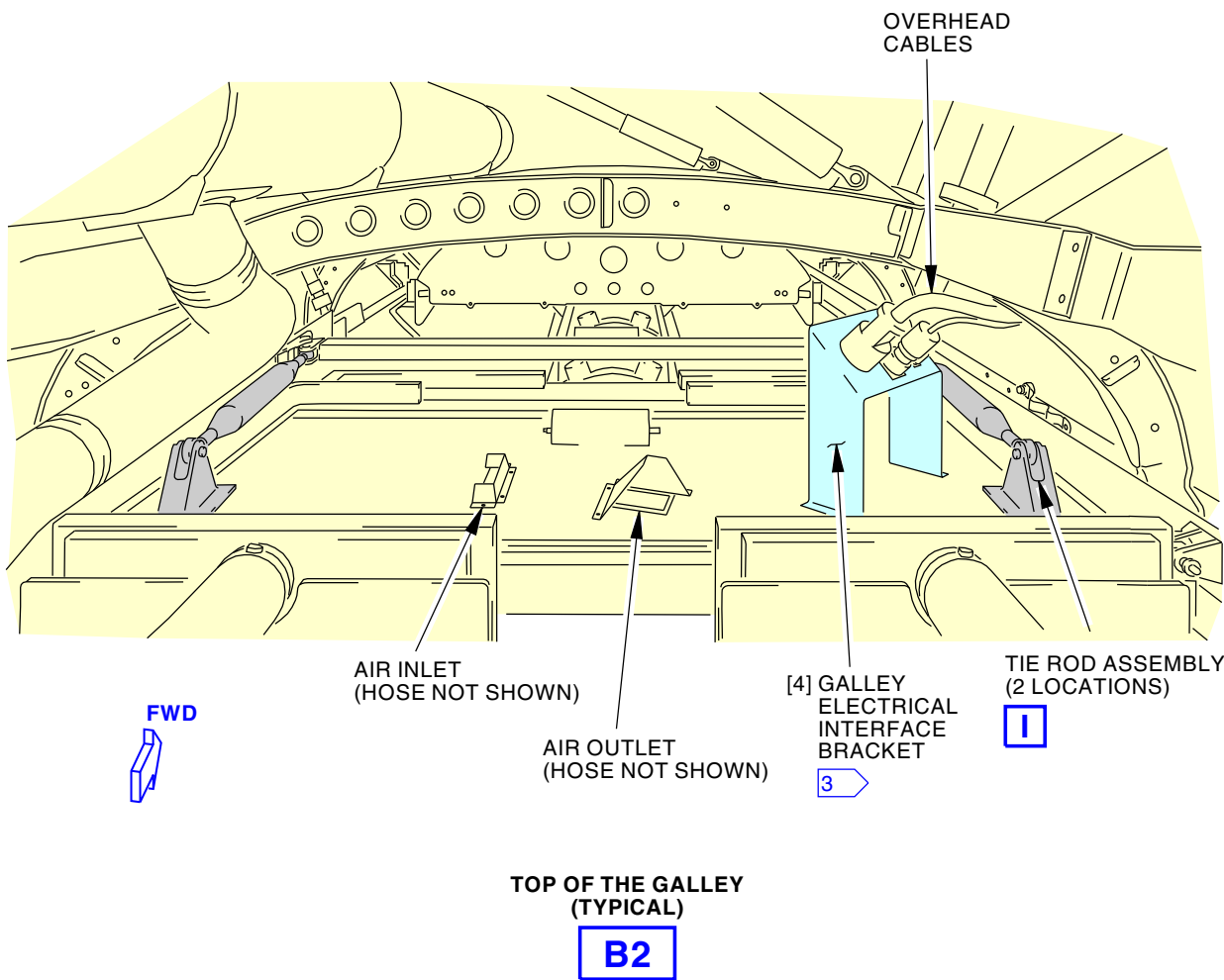
Aft Flexible Galley Installation
Figure 402/25-31-03-990-806 (Sheet 7 of 14)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-03

Page 436
May 05/2017



3 GALLEY CABLES NOT SHOWN

1507129 S0000275583_V2

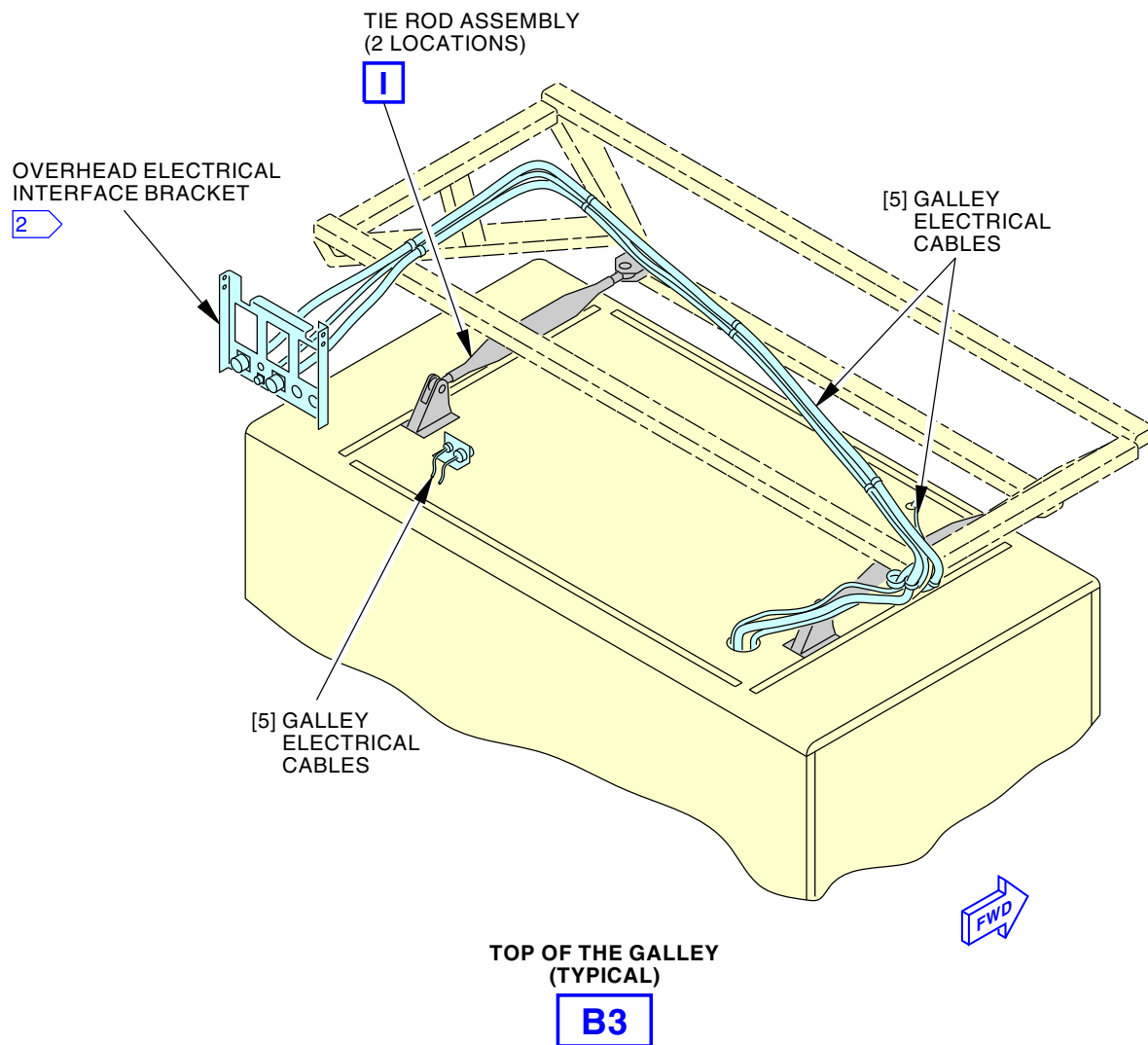
**Aft Flexible Galley Installation
Figure 402/25-31-03-990-806 (Sheet 8 of 14)**

EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 437
May 05/2017



1507156 S0000275584_V2

Aft Flexible Galley Installation
Figure 402/25-31-03-990-806 (Sheet 9 of 14)

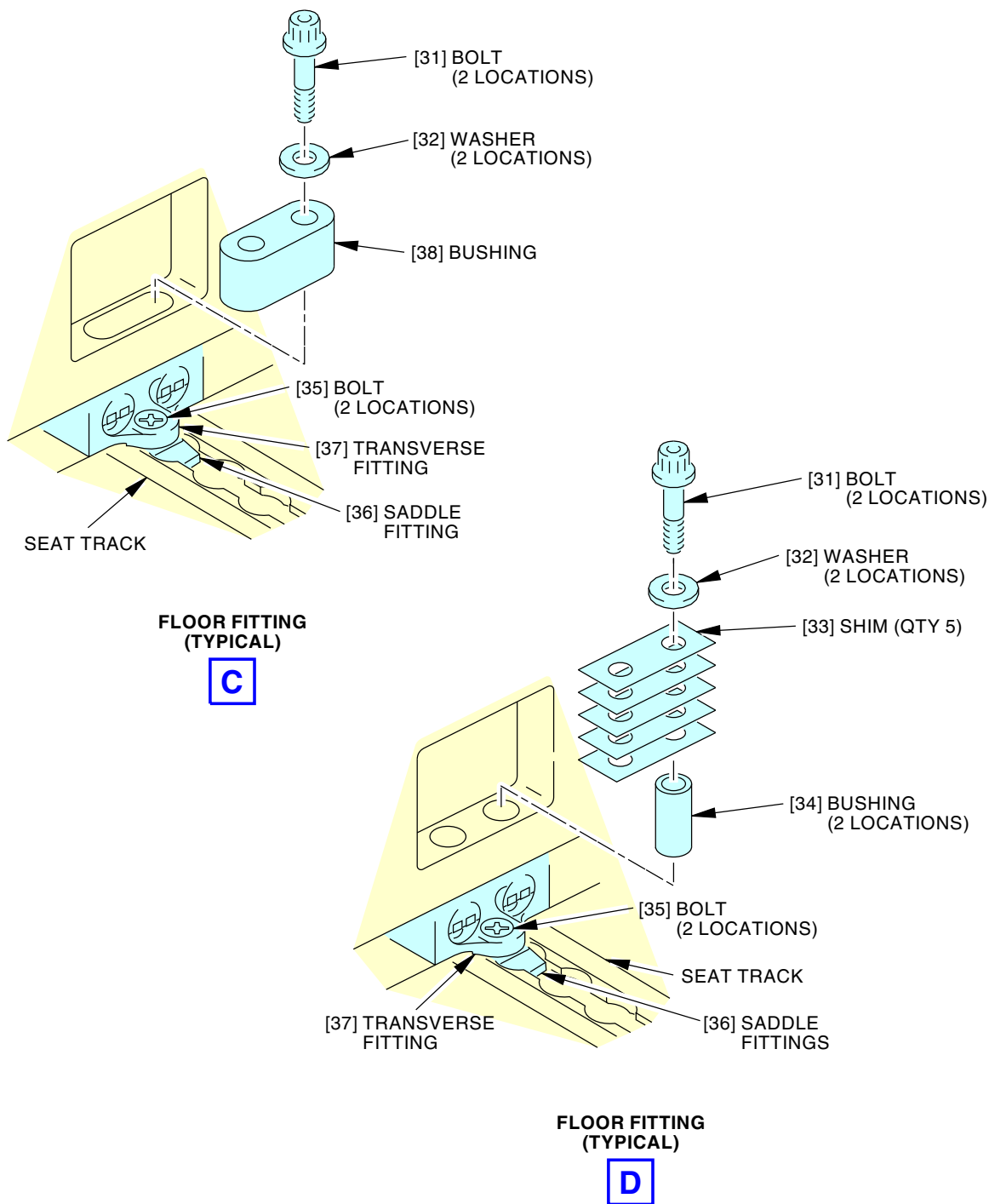
EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 438
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



1507160 S0000275585_V2

**Aft Flexible Galley Installation
Figure 402/25-31-03-990-806 (Sheet 10 of 14)**

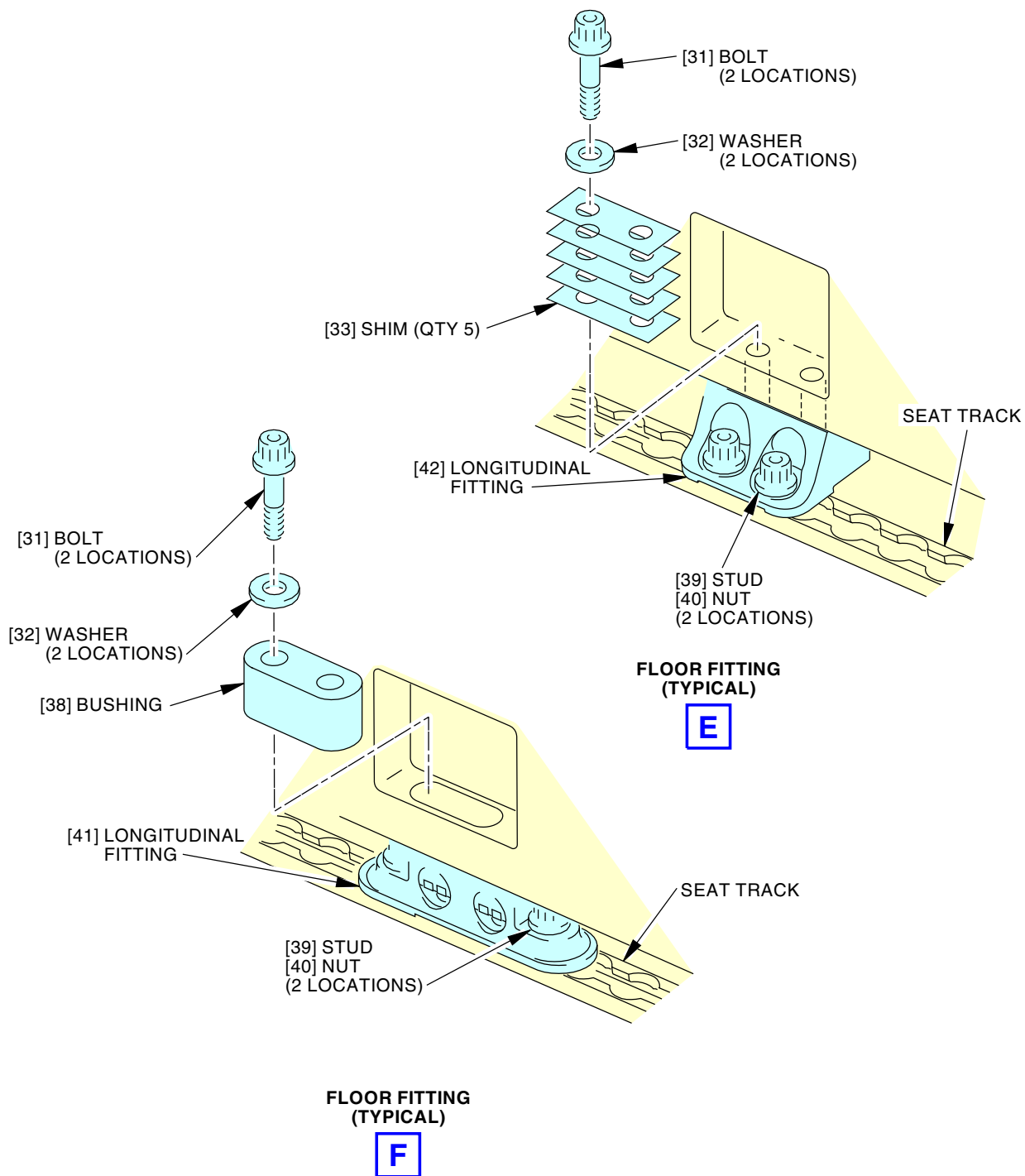
EFFECTIVITY
ARO ALL

25-31-03

D633W101-ARO

Page 439
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



1507161 S0000275586_V2

**Aft Flexible Galley Installation
Figure 402/25-31-03-990-806 (Sheet 11 of 14)**

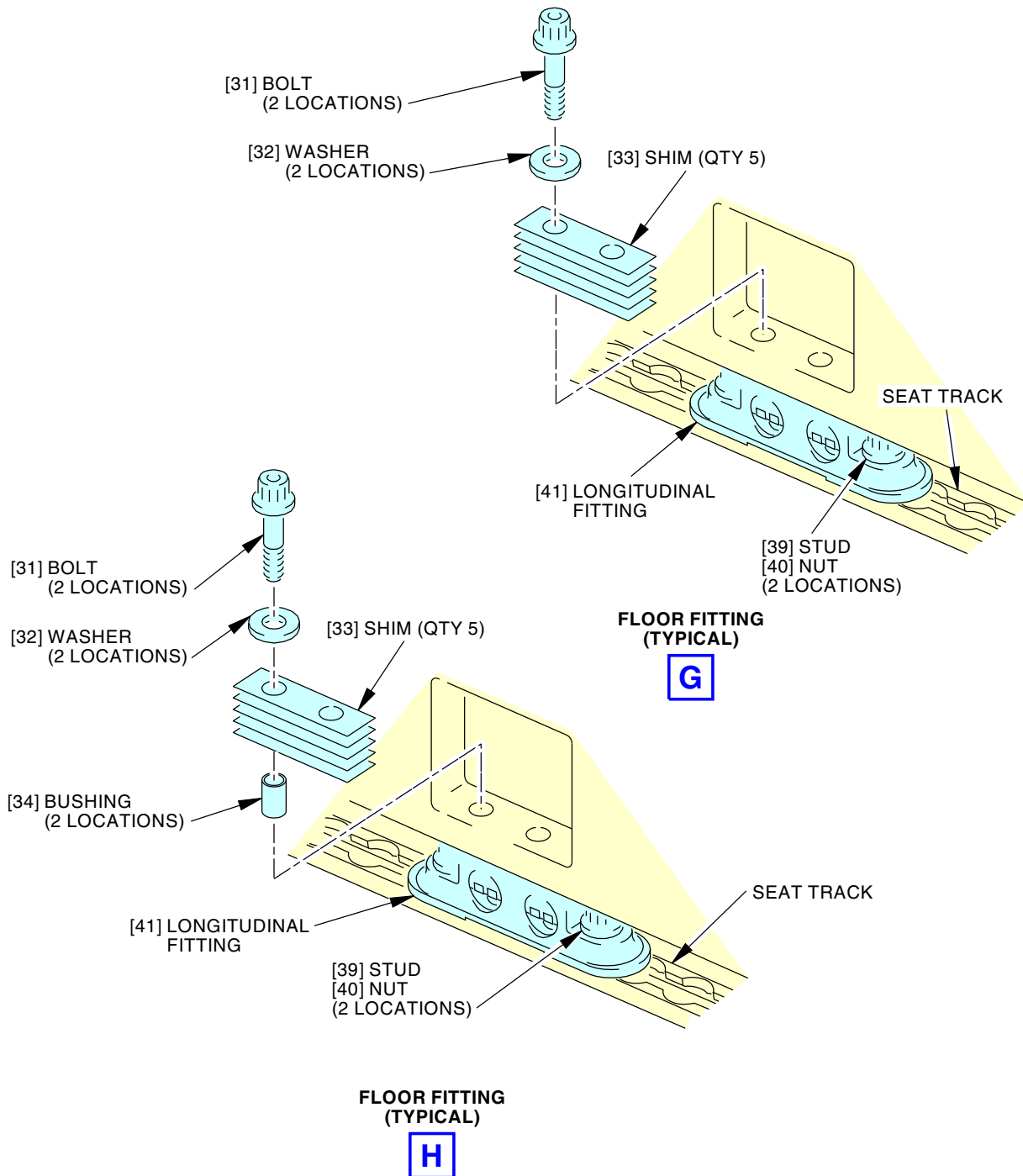
EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-03

Page 440
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



1507294 S0000275587_V2

**Aft Flexible Galley Installation
Figure 402/25-31-03-990-806 (Sheet 12 of 14)**

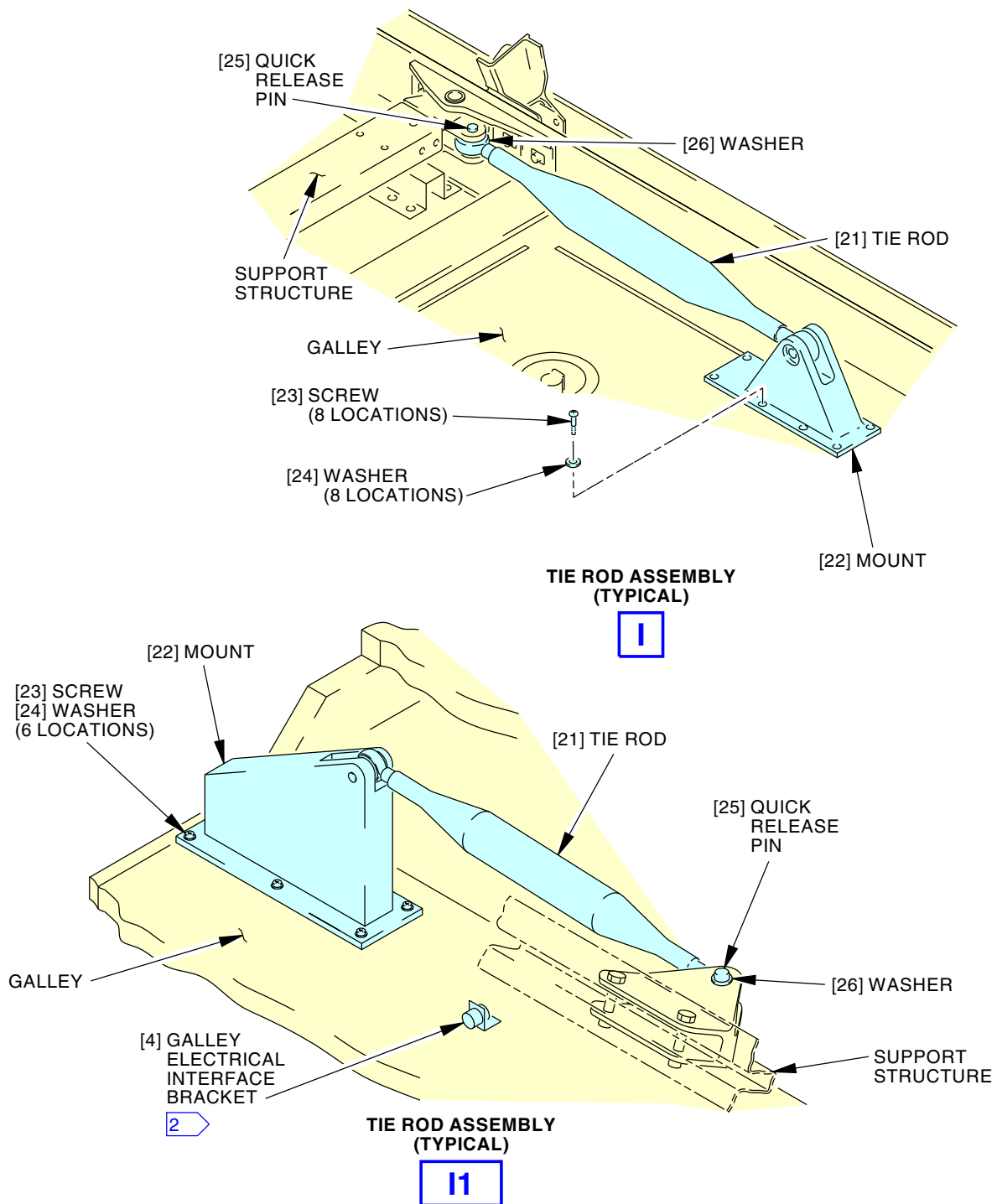
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25-31-03

D633W101-ARO

Page 441
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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Aft Flexible Galley Installation
Figure 402/25-31-03-990-806 (Sheet 13 of 14)

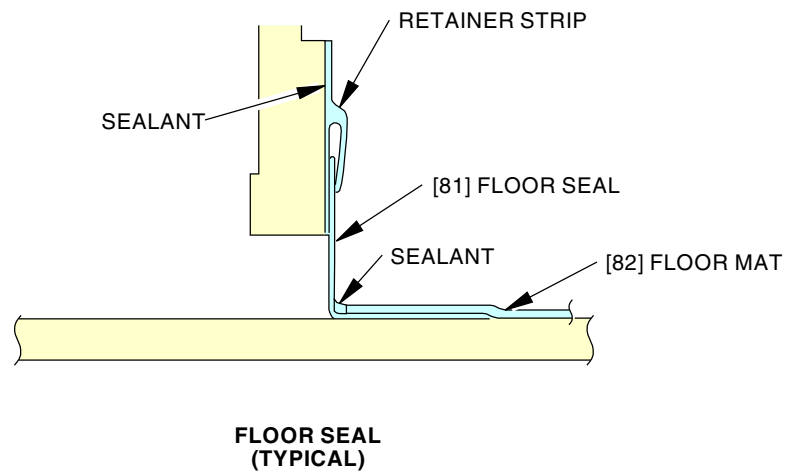
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25-31-03

D633W101-ARO

Page 442
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Aft Flexible Galley Installation
Figure 402/25-31-03-990-806 (Sheet 14 of 14)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-03

Page 443
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

GALLEY SEALANT - REMOVAL/INSTALLATION

1. General

- A. This procedure gives instructions to apply a sealant in and below all galley complexes.
- B. It is necessary to apply a sealant to contain the fluid leakage in the galleys. Use the sealants to fill the holes, slots and low areas to make a smooth contour.

TASK 25-31-09-390-801

2. Main Deck Galley Sealing

(Figure 401)

A. **Consumable Materials**

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A00930	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 109

B. **Location Zones**

Zone	Area
200	Upper Half of Fuselage

C. **Galley Sealing Procedure.**

SUBTASK 25-31-09-100-001

- (1) Clean the floor, galley walls, seat track slots and other surfaces to be sealed.

SUBTASK 25-31-09-390-001

- (2) Apply sealant with the procedure that is applicable to the area to be sealed.

NOTE: Make sure that you have a good flow of air during the dry time when you use the RTV 109 sealant.

- (a) Use adhesive, A00930, adhesive, A00027 or sealant, A00247 to seal the galley as required.

SUBTASK 25-31-09-390-002

- (3) Let sealant dry for 24 hours at 70 to 80 degrees F (21 to 27 degrees C).

———— **END OF TASK** ————

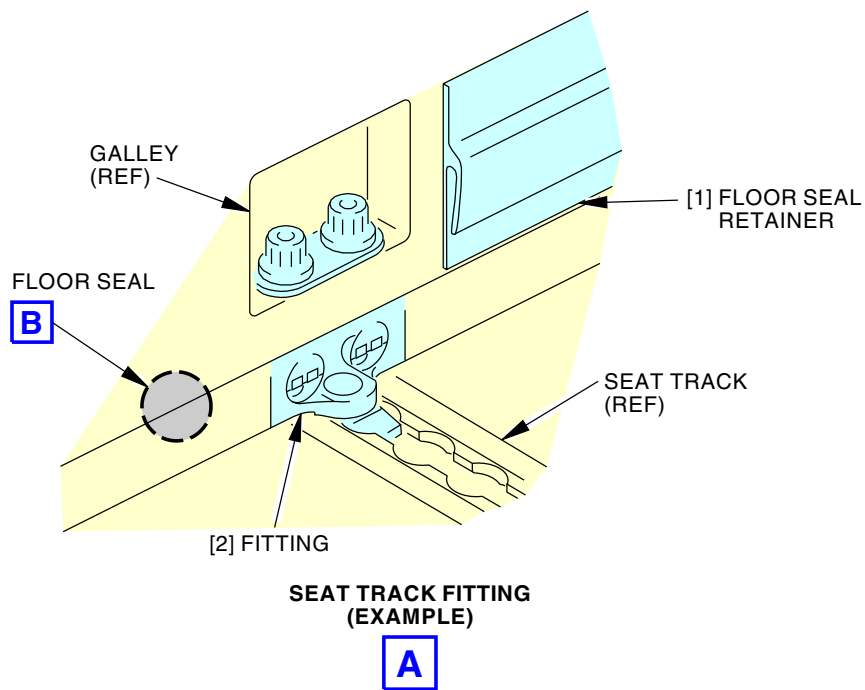
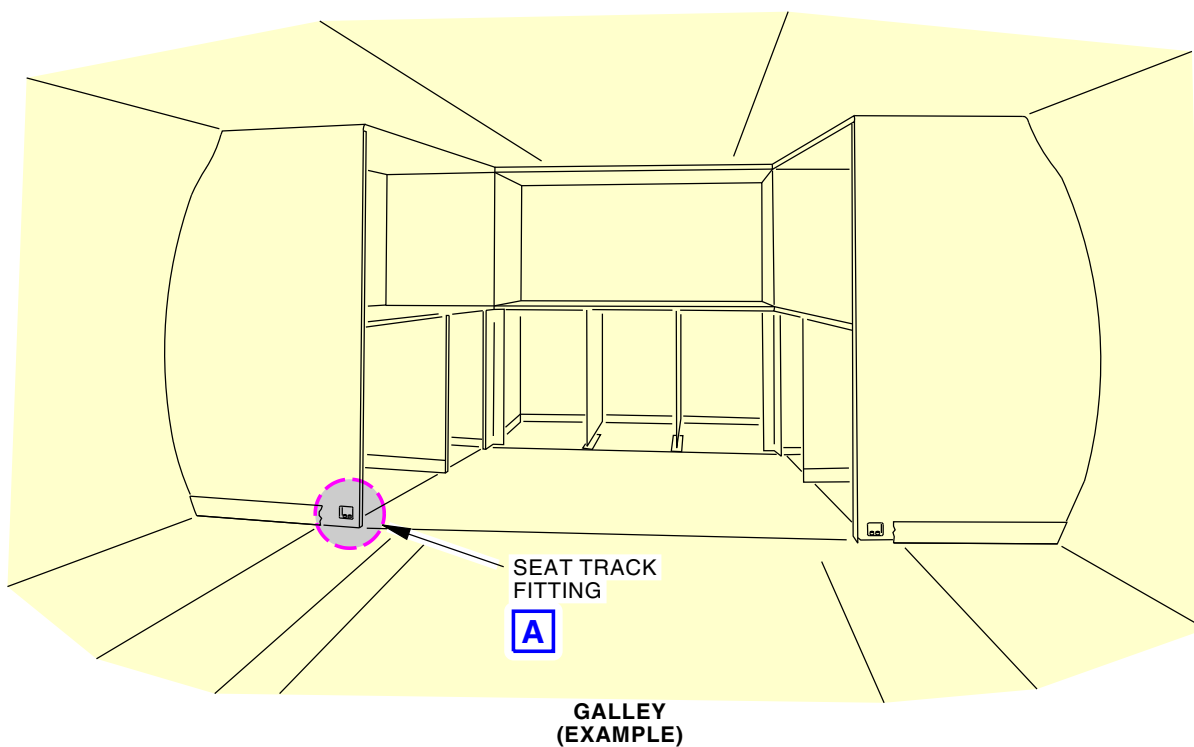
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25-31-09

D633W101-ARO

Page 401
May 05/2016

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Galley Sealing Installation
Figure 401/25-31-09-990-801 (Sheet 1 of 2)**

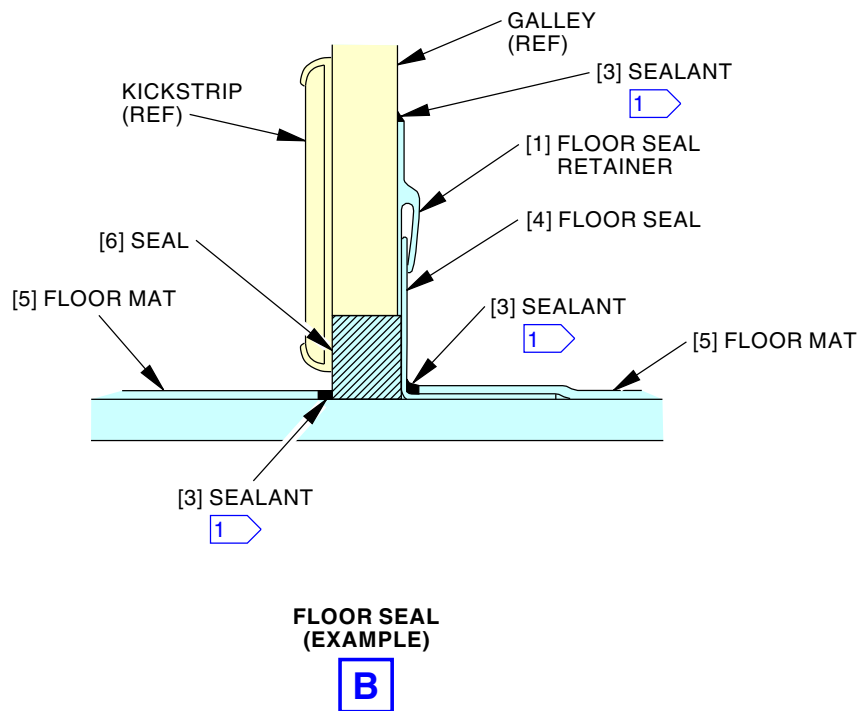
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D633W101-ARO

25-31-09

Page 402
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



1 FILLET SEAL WITH BAC 5010, TYPE 60 (RTV 102)
OR BAC 5010, TYPE 109 (RTV 6702)

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Galley Sealing Installation
Figure 401/25-31-09-990-801 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-09

Page 403
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

GALLEY WASTE ENCLOSURE - INSPECTION/CHECK

1. General

- A. This is a procedure to examine the galley waste enclosures on the airplane to make sure that each galley waste enclosure can contain a fire.
- B. The galley waste enclosure is referred to as the enclosure in this procedure.

TASK 25-31-11-200-801

2. Inspect the Galley Waste Enclosure

A. Location Zones

Zone	Area

200	Upper Half of Fuselage

B. Galley waste enclosure inspection.

SUBTASK 25-31-11-210-002

- (1) Do these steps to check the waste compartment and door.
 - (a) Make sure the door hinge is not loose or worn too much.
 - (b) Make sure the door edges do not have damage.
 - (c) Make sure the door latch operates smoothly.
 - (d) Make sure the door is tight when the door is closed and latched.
 - (e) Make sure the door operates smoothly and closes correctly.
 - (f) Make sure the floor fittings have seals.
 - (g) Make sure the floor fitting seals are not damaged.
 - (h) Make sure the WASTE CONTAINER MUST BE INSTALLED placard is installed.
 - (i) Make sure the clearance is not more than 0.03 in. (0.762 mm) between the closed and latched door and the enclosure.
 - (j) Make sure the door latch bolt engages at least 0.14 in. (3.56 mm) into the enclosure.
 - (k) Make sure the waste container is in good structural condition.
 - (l) For the installed galley and galley waste carts, make sure the interface boot is sealed fully against the galley enclosure.

SUBTASK 25-31-11-210-001

- (2) Do these steps to do a check of the waste container.
 - (a) Make sure the door hinge is tight.
 - (b) Make sure the door and enclosure edges do not have damage.
 - (c) Make sure the door operates smoothly and closes correctly.
 - (d) Make sure the door latch operates smoothly.
 - (e) Make sure the door is tight when it is closed and latched.
 - (f) Make sure the latch bolt engages into the enclosure a minimum of 0.5 in. (12.7 mm).
 - (g) Make sure the thickness of the seal is not decreased more than 0.06 in. (1.52 mm) when the door is closed and latched.
 - (h) Make sure there is no clearance between the seal and the enclosure.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-11

Page 601
May 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (i) Make sure the ENGAGE LATCHES BEFORE DISPATCH placard is installed on the hatch.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-31-11

Page 602
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

ESPRESSO MACHINE - REMOVAL/INSTALLATION

1. General

- A. This procedure is for the BE Aerospace espresso machine.
- B. The BE Aerospace espresso machine is installed on galley(s).
- C. This procedure contains these tasks:
 - (1) Espresso Machine Removal
 - (2) Espresso Machine Installation

NOTE: This is un-maintained data and subject to COC charges for any future revisions.

TASK 25-32-03-000-804-002

2. Espresso Machine Removal

Figure 401

A. **Location Zones**

Zone	Area
200	Upper Half of Fuselage

B. **Prepare for the Removal**

SUBTASK 25-32-03-860-007-002

- (1) Open these circuit breakers and install safety tags:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	20	C25607	DR 4L GLY
J	21	C25606	DR 2 GLY

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	15	C25640	R AFT GALLEY POWER
F	16	C25639	DR 1 GLY

SUBTASK 25-32-03-870-001-002

- (2) Do these steps to bleed water pressure from the espresso machine [13]:
 - (a) Turn off the galley water supply.
 - (b) Push the espresso machine [13] ON/OFF switch [3] to the ON position.
 - (c) Push the rotating frother nozzle [7] down until the water stops.
NOTE: Use a cup or container to collect the water.
 - (d) Push the espresso machine [13] ON/OFF switch [3] to the OFF position.

C. **Espresso Machine Removal**

SUBTASK 25-32-03-820-001-002

- (1) Move the brew arm [2] up.

SUBTASK 25-32-03-020-007-002

- (2) Loosen the captive screw [8] on the lock down clamp [9].

SUBTASK 25-32-03-820-002-002

- (3) Swivel the lock down clamp [9] to the side.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-32-03

Config 2
Page 401
May 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-32-03-020-008-002

- (4) Pull the espresso machine [13] out from the galley rail assembly [12] until the handle is seen.

NOTE: Pull the espresso machine [13] out gently. It must disconnect from the water supply drain and electrical connector [11] on the back of the galley rail assembly [12].

SUBTASK 25-32-03-020-009-002

- (5) Support the espresso machine [13] with the handle and remove.

————— **END OF TASK** —————

TASK 25-32-03-400-803-002

3. Espresso Machine Installation

Figure 401

A. References

Reference	Title
25-32-03-700-802-002	Espresso Machine Operational Test (P/B 501)
38-10-00-863-801	Potable Water System - Pressurization (P/B 201)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Espresso Machine Installation

SUBTASK 25-32-03-420-007-002

- (1) Support the espresso machine [13] with the handle and install onto the galley rail assembly [12].

NOTE: Make sure the espresso machine [13] water supply drain and electrical connector [10] align with the water supply drain and electrical connector [11] on the galley rail assembly [12].

SUBTASK 25-32-03-820-003-002

- (2) Push the espresso machine [13] in gently.

SUBTASK 25-32-03-420-008-002

- (3) Make sure that the espresso machine [13] connects to the water supply drain and electrical connector [11] on the back of the galley rail assembly [12].

SUBTASK 25-32-03-820-004-002

- (4) Swivel the lock down clamp [9] to the right.

SUBTASK 25-32-03-420-009-002

- (5) Tighten the captive screw [7] on the lock down clamp [6] finger tight.

SUBTASK 25-32-03-420-010-002

- (6) Turn the captive screw [7] 1/8 of a turn more clockwise.

SUBTASK 25-32-03-820-005-002

- (7) Lower the brew arm [2] down over the pod brew cup [1].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-32-03

Config 2
Page 402
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Put the Airplane Back To Its Usual Condition

SUBTASK 25-32-03-860-008-002

- (1) Remove the safety tags and close these circuit breakers:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	20	C25607	DR 4L GLY
J	21	C25606	DR 2 GLY

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	15	C25640	R AFT GALLEY POWER
F	16	C25639	DR 1 GLY

SUBTASK 25-32-03-860-009-002

- (2) Do this task: Potable Water System - Pressurization, TASK 38-10-00-863-801.

SUBTASK 25-32-03-870-002-002

- (3) Do these steps to bleed air from the espresso machine [13] water lines:
- (a) Push the espresso machine [13] ON/OFF switch [3] to the ON position.
 - (b) Push the rotating frother nozzle [7] down until a steady stream of water is obtained to purge the air from the espresso machine system.
NOTE: Use a cup or container to collect the water.
 - (c) Push the espresso machine [13] ON/OFF switch [3] to the OFF position.

SUBTASK 25-32-03-710-002-002

- (4) Do this task: Espresso Machine Operational Test, TASK 25-32-03-700-802-002.

————— **END OF TASK** —————

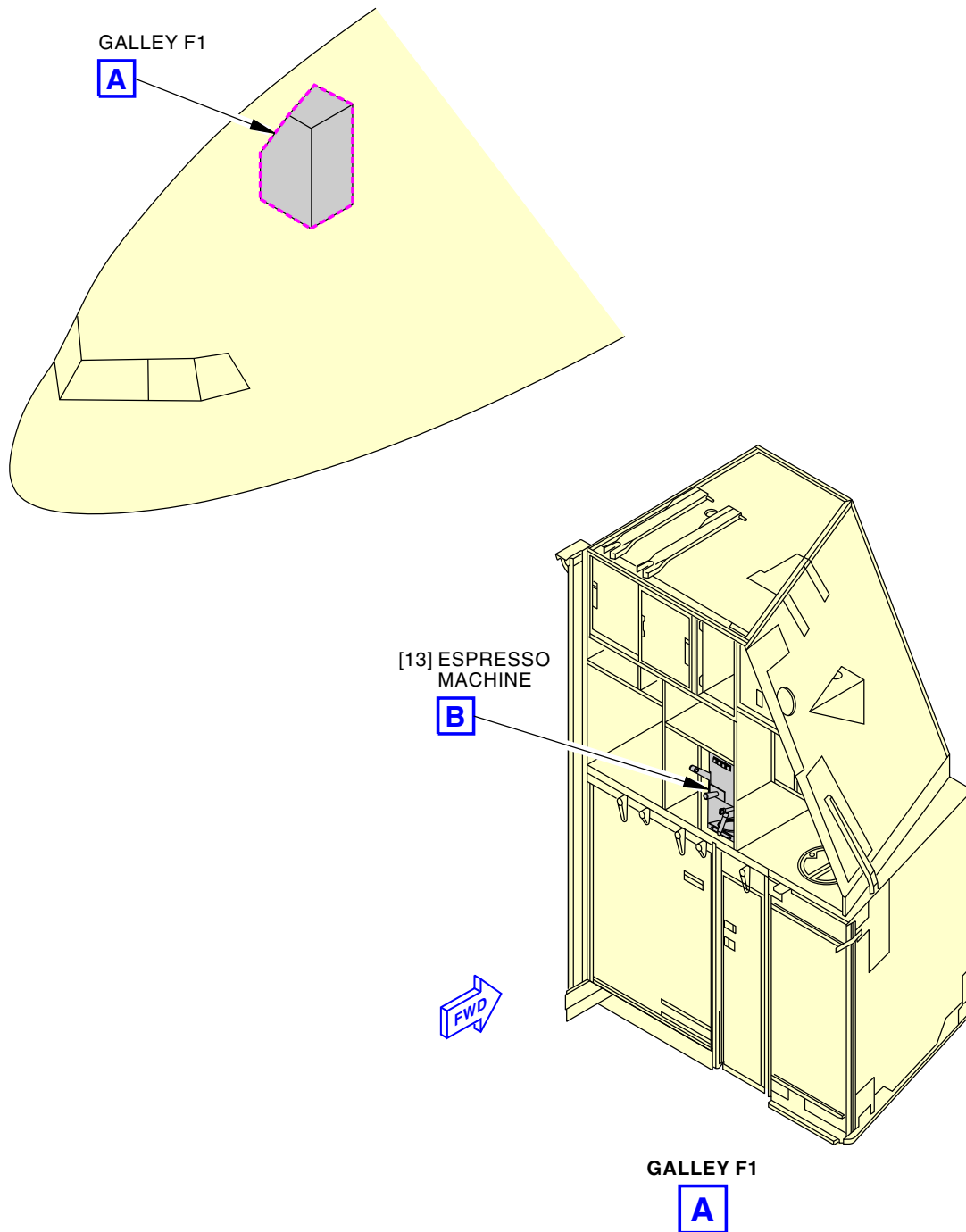
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25-32-03

Config 2
Page 403
Sep 05/2015

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777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Espresso Machine Installation
Figure 401/25-32-03-990-802 (Sheet 1 of 2)

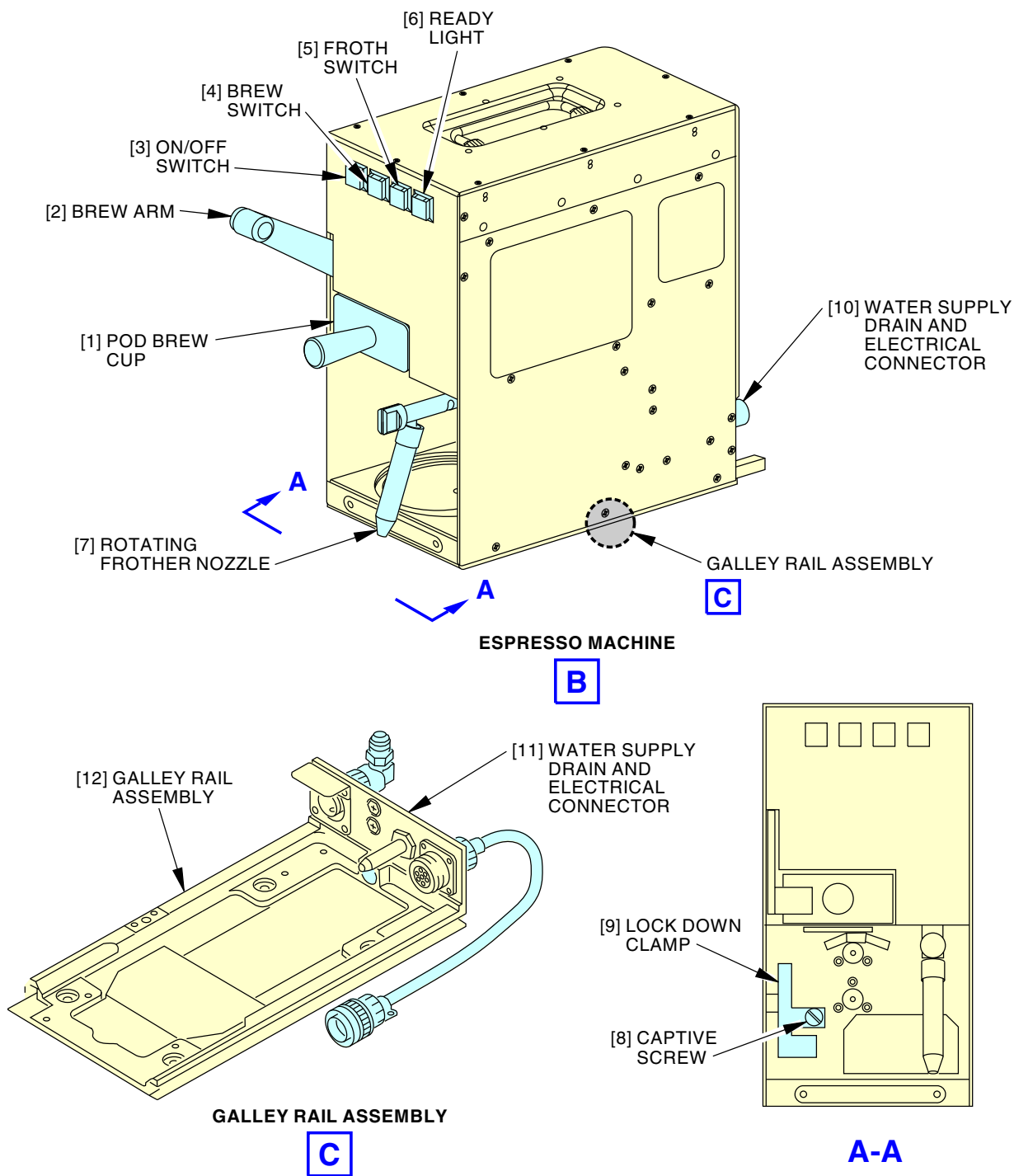
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D633W101-ARO

25-32-03

Config 2
Page 404
May 05/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Espresso Machine Installation
Figure 401/25-32-03-990-802 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-32-03

Config 2
Page 405
May 05/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL
ESPRESSO MACHINE - ADJUSTMENT/TEST

1. General

- A. This procedure is for the BE Aerospace espresso machine P/N 3510-0066-XX.
- B. The BE Aerospace espresso machine is installed on the F1 galley.
- C. This procedure contains this task:

- (1) Espresso machine operational test.

NOTE: This is un-maintained data and subject to COC charges for any future revisions.

TASK 25-32-03-700-802-002

2. Espresso Machine Operational Test

A. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
24-22-00-860-806	Remove Electrical Power (P/B 201)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the test

SUBTASK 25-32-03-860-030-002

- (1) Make sure the water system is pressurized.

SUBTASK 25-32-03-860-031-002

- (2) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-32-03-865-003-002

- (3) Remove the safety tag and close this circuit breaker:

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	16	C25639	DR 1 GLY

D. Espresso Machine Operational Test

SUBTASK 25-32-03-480-002-002

- (1) Put the pod brew cup into the espresso machine.

SUBTASK 25-32-03-860-032-002

- (2) Lower the brew arm to the down position over the pod brew cup.

NOTE: The espresso machine will not operate with the brew arm in the up position.

SUBTASK 25-32-03-860-033-002

- (3) Push the ON/OFF switch to the ON position.

SUBTASK 25-32-03-860-034-002

- (4) Push the BREW switch to the ON position.

NOTE: The unit will not brew until the READY light comes on.

SUBTASK 25-32-03-210-004-002

- (5) When the BREW light goes out the espresso is complete.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-32-03

Config 2
Page 501
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-32-03-860-035-002

- (6) Put the frother nozzle into a container or cup.

SUBTASK 25-32-03-860-036-002

- (7) Push the FROTH switch to the ON position.

NOTE: The unit will not froth until the READY light comes on.

SUBTASK 25-32-03-212-001-002

- (8) When the FROTH light goes out the milk is ready to serve.

SUBTASK 25-32-03-860-037-002

- (9) Push the ON/OFF switch to the OFF position.

SUBTASK 25-32-03-862-001-002

- (10) Do this task: Remove Electrical Power, TASK 24-22-00-860-806.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-32-03

Config 2
Page 502
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

OVERHEAD GALLEY AIR CHILLER - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) The removal of the air chiller above the galley.
- (2) The installation of the air chiller above the galley.

B. This procedure applies to the air chillers for the forward galley, center flexible galley, and aft galley.

NOTE: There might not be a chiller at each location.

TASK 25-33-01-000-801

2. Overhead Galley Air Chiller Removal

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. **Location Zones**

Zone	Area
200	Upper Half of Fuselage

B. **Prepare for the Removal**

SUBTASK 25-33-01-860-001



WARNING

REMOVE ELECTRICAL POWER FROM THE CHILLER. IF YOU DO NOT REMOVE ELECTRICAL POWER FROM THE CHILLER, YOU CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (1) Open these circuit breakers and install safety tags:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	20	C25607	DR 4L GLY
J	21	C25606	DR 2 GLY

SUBTASK 25-33-01-010-001

- (2) Open the ceiling access panel [1] for the chiller [7] adjacent to the galley.

SUBTASK 25-33-01-010-002

- (3) If necessary, remove the ceiling support or crossbar to get access to the chiller [7].

C. **Overhead Galley Air Chiller Removal**

SUBTASK 25-33-01-020-001

- (1) Disconnect the electrical connector [5] from the chiller [7].

SUBTASK 25-33-01-020-002

- (2) Remove the screws [4] and washers [3] that attach the carriage [11] to the outer rails [6].

SUBTASK 25-33-01-020-003

- (3) Pull the handle [2] to move the carriage [11] and chiller [7] together until the carriage wheels drop in a detent [8] in the inner rails [9].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-33-01

Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-33-01-020-004



WARNING

BE CAREFUL WHEN YOU MOVE THE CARRIAGE AND CHILLER. THE CHILLER WEIGHS APPROXIMATELY 60 POUNDS AND INJURIES TO PERSONS CAN OCCUR.

- (4) Lift and pull the carriage [11] and chiller [7] until the wheels move out of the detent [8].

SUBTASK 25-33-01-020-005

- (5) Slowly lower the carriage [11] and chiller [7] to a vertical position.

SUBTASK 25-33-01-020-006

- (6) Lift the carriage [11] and chiller [7] up and off of the inner rails [9].

SUBTASK 25-33-01-020-007

- (7) Remove the screws [10] and washers [3] from the bottom of the carriage [11] to disconnect the carriage [11] from the chiller [7].

END OF TASK

TASK 25-33-01-400-801

3. Overhead Galley Air Chiller Installation

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
25-33-97-700-801	Galley Air Chiller Operational Test (P/B 501)

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Prepare for the Installation

SUBTASK 25-33-01-210-001

- (1) Visually examine the chiller to verify the condenser exhaust configuration.

NOTE: There are different configurations to exhaust condenser cooling air. These configurations are chiller model specific. Use only the applicable configuration for that chiller.

SUBTASK 25-33-01-940-001

- (2) Make sure the top exhaust port is open using the applicable hardware.



CAUTION

INSTALL THE COVERPLATE ON THE SIDE EXHAUST PORT. IF YOU INSTALL THE COVERPLATE IN AN INCORRECT POSITION, THE AIR CHILLER WILL BECOME TOO HOT.

- (a) If a cover plate is used to direct airflow, install the cover plate [12] and screws [13] over the side exhaust port

EFFECTIVITY
ARO ALL

25-33-01

D633W101-ARO

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Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL



MAKE SURE THAT THE INTERNAL DUCT IS INSTALLED IN THE TOP EXHAUST PORT FOR THIS INSTALLATION. AN INCORRECTLY INSTALLED INTERNAL DUCT WILL CAUSE DAMAGE TO THE AIR CHILLER.

- (b) If a removable internal duct is used to direct airflow, install the duct [14] in the top exhaust port.

D. Overhead Galley Air Chiller Installation

NOTE: Do not invert the galley chiller during the installation procedure. Inverting the chiller will cause oil to migrate out of the compressor.

SUBTASK 25-33-01-420-001

- (1) Install the screws [10] and washers [3] to attach the carriage [11] to the chiller [7].

SUBTASK 25-33-01-420-002

- (2) Lift the carriage [11] and chiller [7] up so the wheels near the center of the chiller [7] sit in the outer indentations on the inner rails [9].

SUBTASK 25-33-01-420-003

- (3) Push the carriage [11] and chiller [7] up to a horizontal position.

SUBTASK 25-33-01-420-004

- (4) Push the carriage [11] and chiller [7] in the inner rails [9] and allow the inner rails [9] to slide in the outer rails [6].

SUBTASK 25-33-01-420-005

- (5) Install the screws [4] and washers [3] through the carriage [11] and the outer rails [6].

NOTE: This will move the chiller to the galley interface gasket.

SUBTASK 25-33-01-420-006

- (6) Connect the electrical connector [5] to the chiller [7].

NOTE: Some chillers have two possible receptacles for the electrical connector.

NOTE: Some chillers with two receptacles have an interconnecting cable. The side receptacle is the primary receptacle. If you use the side receptacle, make sure that the interconnecting cable is attached to the side dummy receptacle. If you use the top receptacle, you must attach the interconnecting cable to the side receptacle.

E. Overhead Galley Air Chiller Installation Test

SUBTASK 25-33-01-860-002

- (1) Remove the safety tags and close these circuit breakers:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	20	C25607	DR 4L GLY
J	21	C25606	DR 2 GLY

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	16	C25639	DR 1 GLY

SUBTASK 25-33-01-860-003

- (2) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

EFFECTIVITY
ARO ALL

25-33-01

D633W101-ARO

Page 403
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-33-01-710-001

(3) Do this task: Galley Air Chiller Operational Test, TASK 25-33-97-700-801.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-33-01-410-002

(1) Install the ceiling support or crossbar if removed.

SUBTASK 25-33-01-410-001

(2) Close the ceiling access panel [1].

———— **END OF TASK** ————

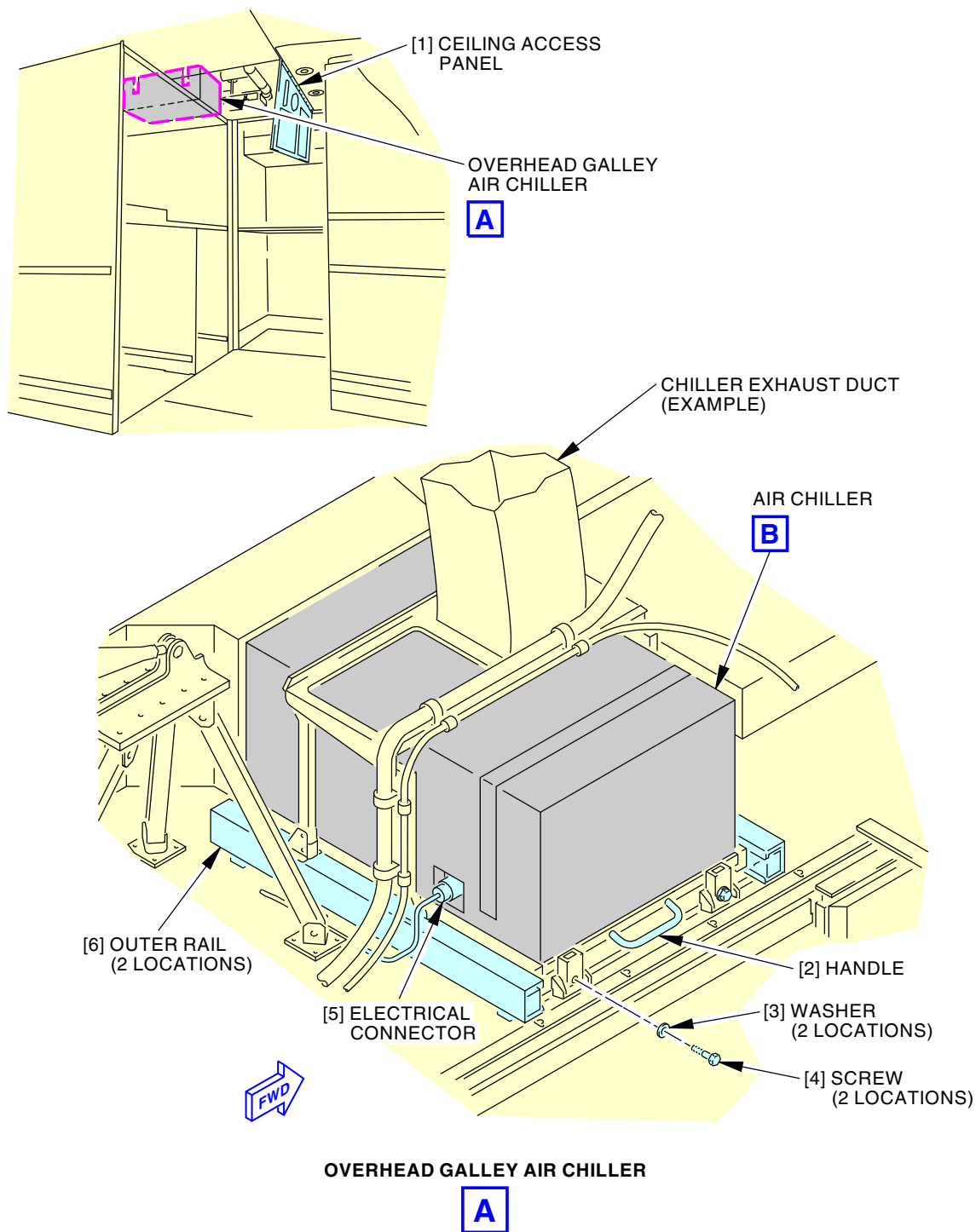
EFFECTIVITY
ARO ALL

D633W101-ARO

25-33-01

Page 404
Sep 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Overhead Galley Air Chiller Installation
Figure 401/25-33-01-990-801 (Sheet 1 of 4)

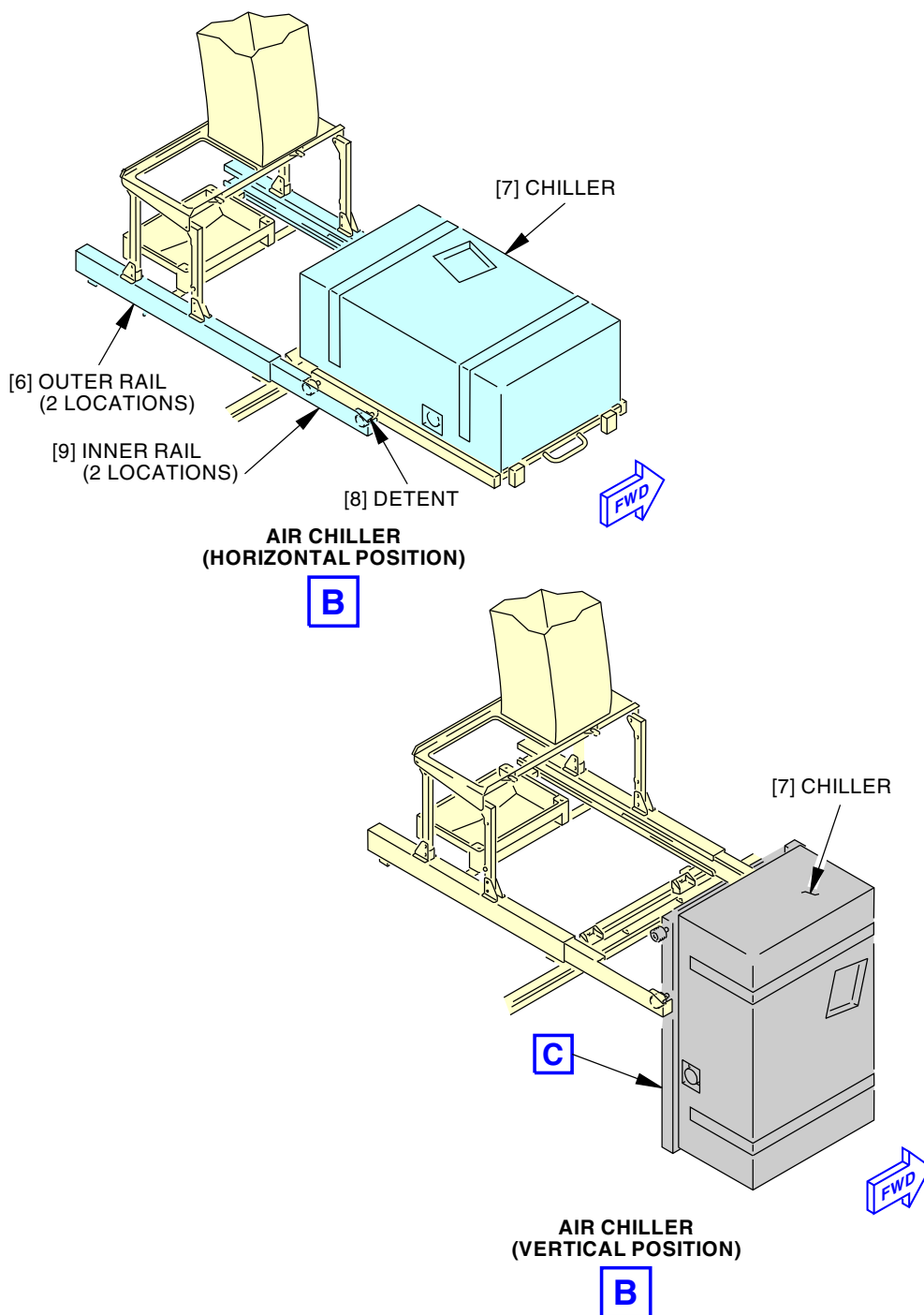
EFFECTIVITY
ARO ALL

25-33-01

D633W101-ARO

Page 405
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Overhead Galley Air Chiller Installation
Figure 401/25-33-01-990-801 (Sheet 2 of 4)**

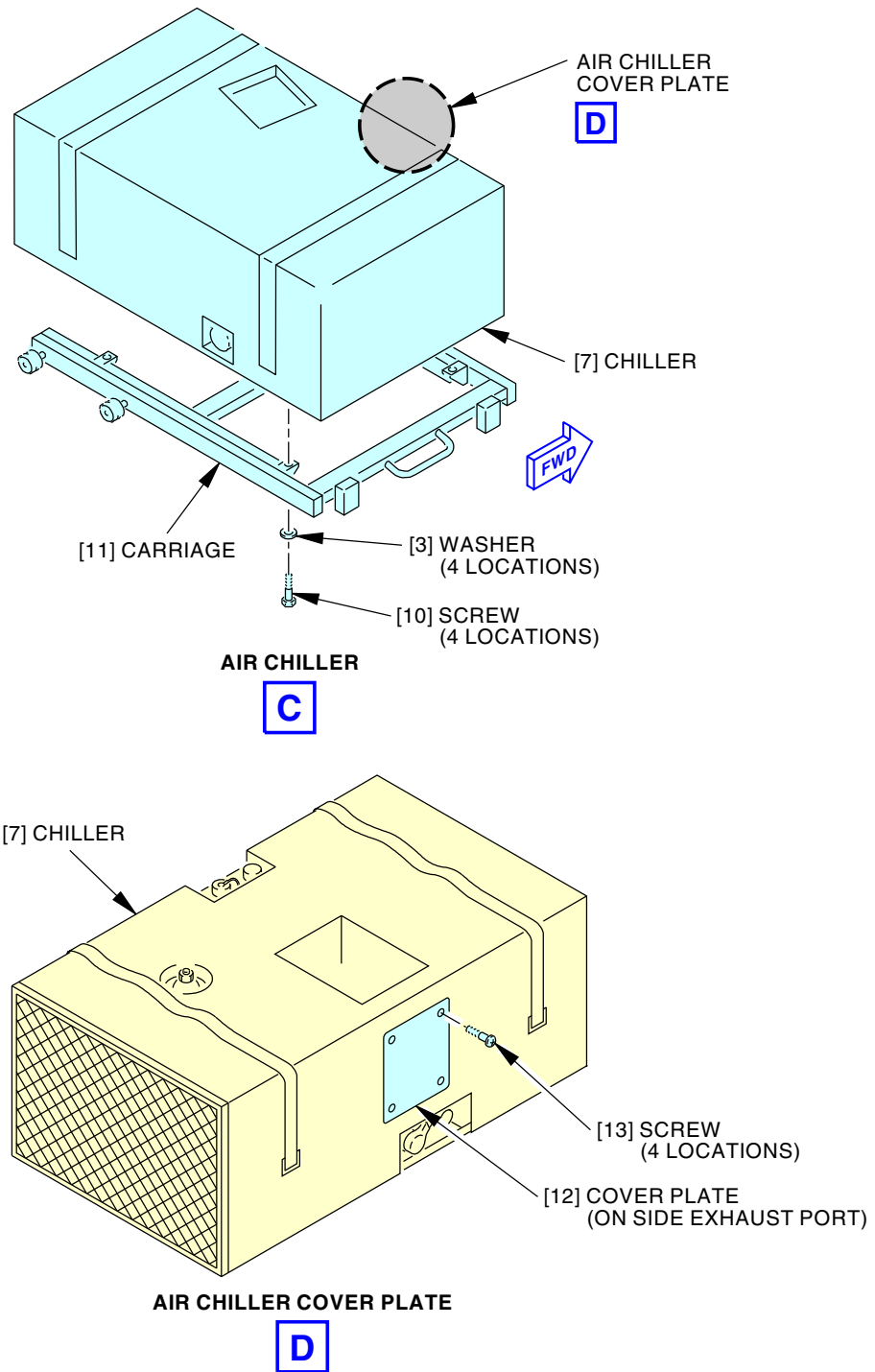
EFFECTIVITY
ARO ALL

D633W101-ARO

25-33-01

Page 406
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Overhead Galley Air Chiller Installation
Figure 401/25-33-01-990-801 (Sheet 3 of 4)

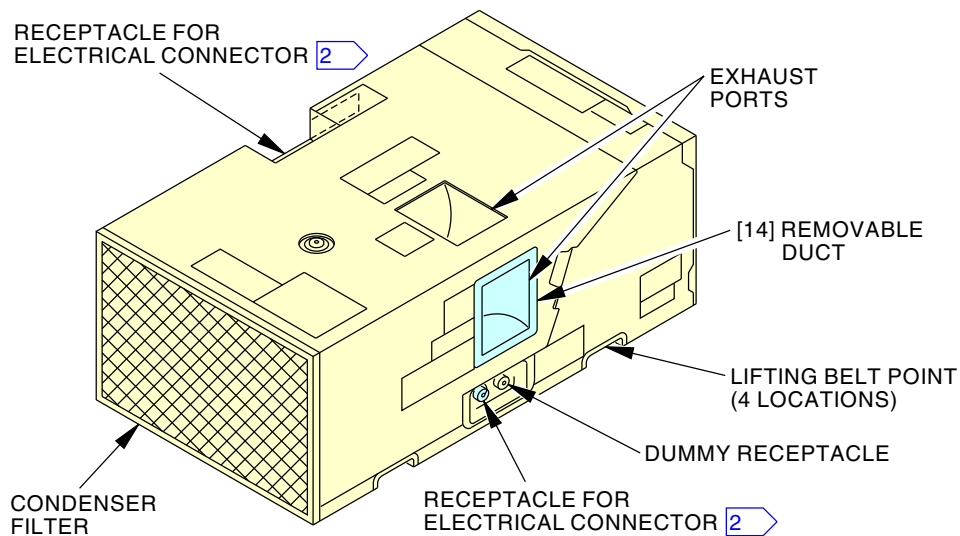
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ARO ALL

25-33-01

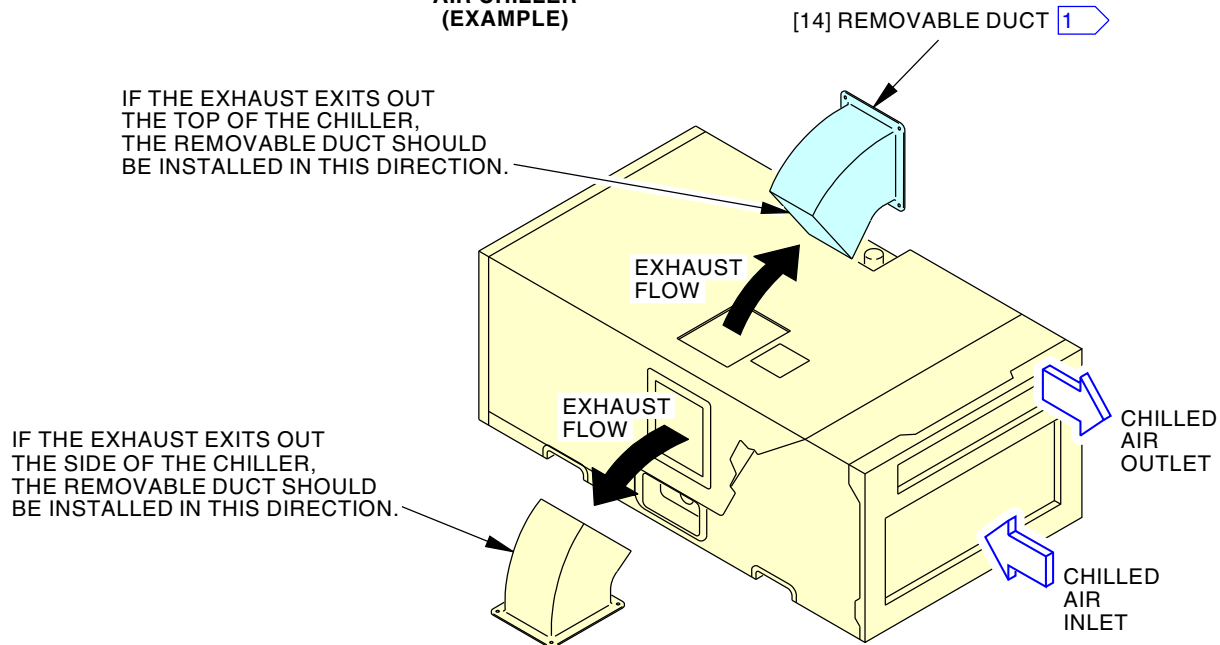
D633W101-ARO

Page 407
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



AIR CHILLER (EXAMPLE)



- 1 THERE IS ONLY ONE REMOVABLE DUCT PER CHILLER ASSEMBLY, IF EQUIPPED. ENSURE THE DUCT IS INSTALLED PROPERLY FOR THE PRESENT CONFIGURATION.
- 2 SOME CHILLERS HAVE AN INTERCONNECTING CABLE. IF YOU USE THE SIDE RECEPTACLE, MAKE SURE THAT THE INTERCONNECTING CABLE IS ATTACHED TO THE SIDE DUMMY RECEPTACLE. IF YOU USE THE TOP RECEPTACLE, YOU MUST ATTACH THE INTERCONNECTING CABLE TO THE SIDE RECEPTACLE.

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Overhead Galley Air Chiller Installation Figure 401/25-33-01-990-801 (Sheet 4 of 4)

EFFECTIVITY
ARO ALL

25-33-01

D633W101-ARO

Page 408
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

LOWER LOBE AIR CHILLER (FOR THE AFT GALLEY) - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the lower lobe air chiller.
 - (2) An installation of the lower lobe air chiller.
- B. The lower lobe air chiller supplies chilled air to the aft galley. This procedure refers to the lower lobe air chiller as the chiller.

TASK 25-33-03-000-801

2. Lower Lobe Air Chiller Removal

(Figure 401 and Figure 402)

A. **References**

Reference	Title
25-52-19-000-801	Bulk Cargo Compartment Aft End Wall Removal (P/B 401)

B. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

C. **Location Zones**

Zone	Area
165	Area Aft of Bulk Cargo Compartment, Left
166	Area Aft of Bulk Cargo Compartment, Right

D. **Prepare for the Removal**

SUBTASK 25-33-03-860-001

- (1) Open these circuit breakers and install safety tags:

Left Power Management Panel, P110

Row	Col	Number	Name
J	20	C25607	DR 4L GLY

Right Power Management Panel, P210

Row	Col	Number	Name
F	15	C25640	R AFT GALLEY POWER

SUBTASK 25-33-03-480-002



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (2) Install the safety barrier, SPL-2006 across the cargo door opening.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-33-03

Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-33-03-010-001

(3) Do this task: Bulk Cargo Compartment Aft End Wall Removal, TASK 25-52-19-000-801.

E. Lower Lobe (Aft Galley) Air Chiller Removal

SUBTASK 25-33-03-020-001

(1) Disconnect the electrical connector [2] from the power receptacle on the top of the chiller [1].

SUBTASK 25-33-03-020-004

(2) Put a cap on the power receptacle.

SUBTASK 25-33-03-020-002

(3) Remove the screw [3] and washer [4] that attach the rails [5] for the chiller [1] to the rack [13].

SUBTASK 25-33-03-020-003

(4) Pull the chiller [1] out of the rack [13] while the rails [5] remain attached to the chiller [1].

SUBTASK 25-33-03-020-005

(5) Remove the screw [6], washer [8] and washer [7] to disconnect the rail [5] from the chiller [1].

(a) Make a note of the positions for the rail [5] on the chiller [1] for the installation task.

NOTE: The rails are opposite parts and must be installed on the chiller correctly.

————— END OF TASK —————

TASK 25-33-03-400-801

3. Lower Lobe Air Chiller Installation

(Figure 401 and Figure 402)

A. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
25-52-19-400-801	Bulk Cargo Compartment Aft End Wall Installation (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363

C. Location Zones

Zone	Area
165	Area Aft of Bulk Cargo Compartment, Left
166	Area Aft of Bulk Cargo Compartment, Right

EFFECTIVITY
ARO ALL

25-33-03

D633W101-ARO

Page 402
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Prepare for the Installation

SUBTASK 25-33-03-210-006



MAKE SURE THAT THE INTERNAL DUCT IS INSTALLED IN THE SIDE EXHAUST PORT FOR THIS INSTALLATION. THIS CHILLER UNIT HAS A REMOVABLE INTERNAL DUCT THAT PREVENTS AIRFLOW TO THE OTHER EXHAUST OUTLET. AN INCORRECTLY INSTALLED INTERNAL DUCT WILL CAUSE DAMAGE TO THE AIR CHILLER.

- (1) If the chiller uses a removeable internal duct that lets the air flow out of only one exhaust port, make sure that it is installed in the side exhaust port.

NOTE: The Installation of the cover plate [14] at the top exhaust port is not necessary for this type of exhaust duct.

SUBTASK 25-33-03-210-004



MAKE SURE TO INSTALL THE COVER PLATE ON THE TOP EXHAUST PORT. FAILURE TO INSTALL THE COVER PLATE IN THE CORRECT POSITION WILL CAUSE THE AIR CHILLER TO OVERHEAT.

- (2) If the internal exhaust duct lets air flow out of the top and side exhaust ports, make sure the side exhaust port is open; and, install the cover plate [14], screw [15] and washer [16] at the top condenser exhaust port.

SUBTASK 25-33-03-210-005

- (3) Do these steps to prepare the rack [3] for the chiller [1] installation:
 - (a) Make sure the flapper valve in the supply ducts can move free inside the duct.
 - (b) Make sure the seal is clean and free of defects which would allow air leaks.

E. Lower Lobe (Aft Galley) Air Chiller Installation

SUBTASK 25-33-03-420-003

- (1) Install the screw [6], washer [8] and washer [7] to attach the rails [5] to the chiller [1].

SUBTASK 25-33-03-820-001

- (2) Put the rails [5] that are attached to the chiller [1] on the rack [13].

SUBTASK 25-33-03-820-002

- (3) Push the chiller [1] until the openings at the end of the rail [5] go below the washers [11] on the aft end of the rack [13].

SUBTASK 25-33-03-210-003

- (4) Make sure the seal touches the back of the chiller [1] and the rack [13].

SUBTASK 25-33-03-420-001

- (5) Install the screw [3] and washer [4] that attach the rail [5] to the forward end of the rack [13].

SUBTASK 25-33-03-420-002

- (6) Connect the electrical connector [2] to the power receptacle on the chiller [1].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-33-03

Page 403
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

F. Lower Lobe (Aft Galley) Air Chiller Installation Test

SUBTASK 25-33-03-860-002

- (1) Remove the safety tags and close these circuit breakers:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	20	C25607	DR 4L GLY

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
F	15	C25640	R AFT GALLEY POWER

SUBTASK 25-33-03-860-003

- (2) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-33-03-710-001

- (3) Put the chiller ON/OFF switch in the ON position.

NOTE: The chiller controls and lights are on the galley in the passenger compartment. The chiller no. 1 is the top chiller and chiller no. 2 is the bottom chiller.

- (a) Make sure the chiller ON light comes on.
- (b) Make sure the air moves in the chiller compartment.

SUBTASK 25-33-03-710-002

- (4) Put the chiller ON/OFF switch in the OFF position.

- (a) Make sure the chiller ON light goes off.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 25-33-03-410-001

- (1) Do this task: Bulk Cargo Compartment Aft End Wall Installation, TASK 25-52-19-400-801.

SUBTASK 25-33-03-080-001

- (2) Remove the large cargo door safety barrier, SPL-1988.

————— **END OF TASK** —————

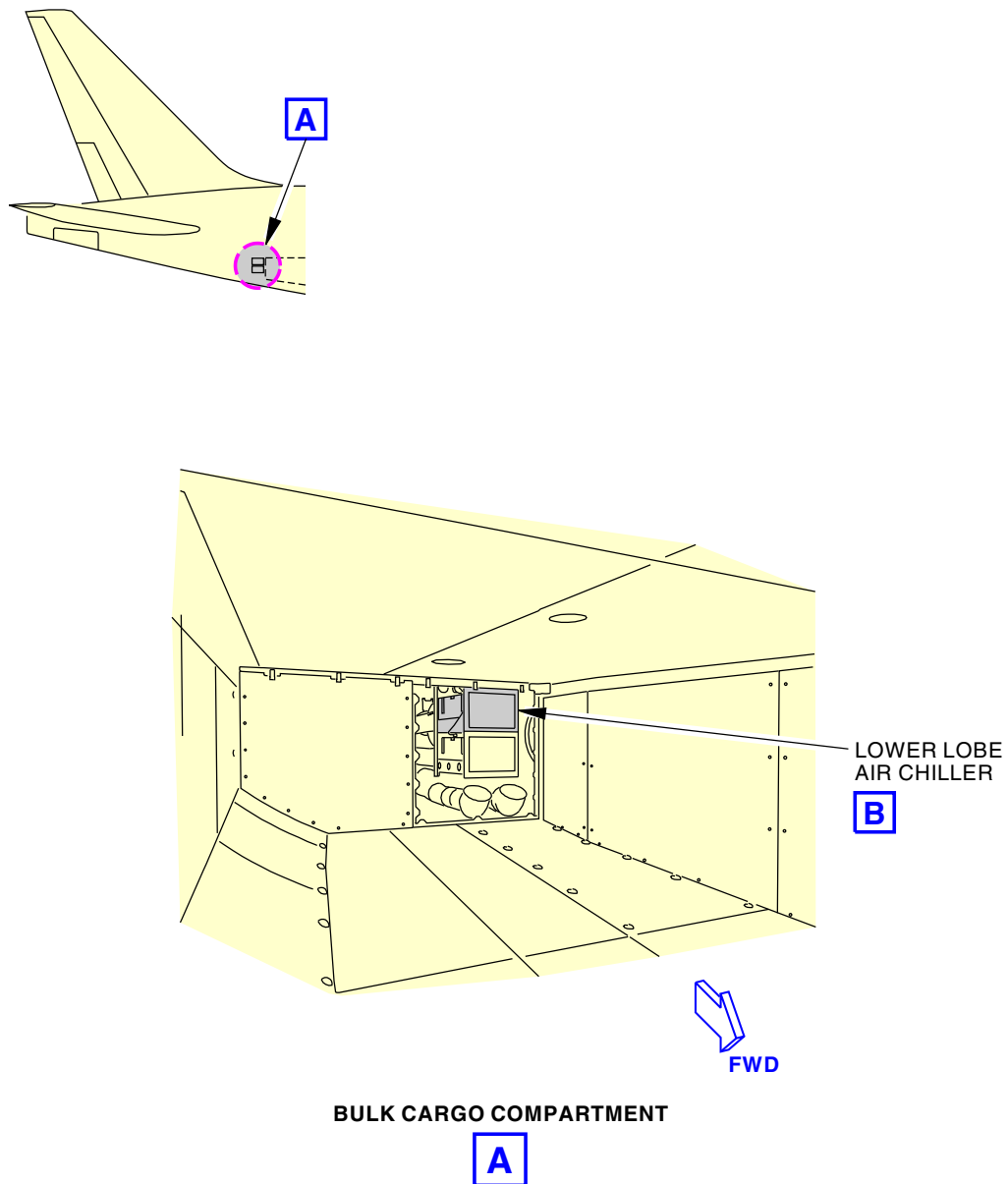
EFFECTIVITY
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D633W101-ARO

25-33-03

Page 404
Sep 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Lower Lobe Air Chiller Installation
Figure 401/25-33-03-990-801 (Sheet 1 of 2)

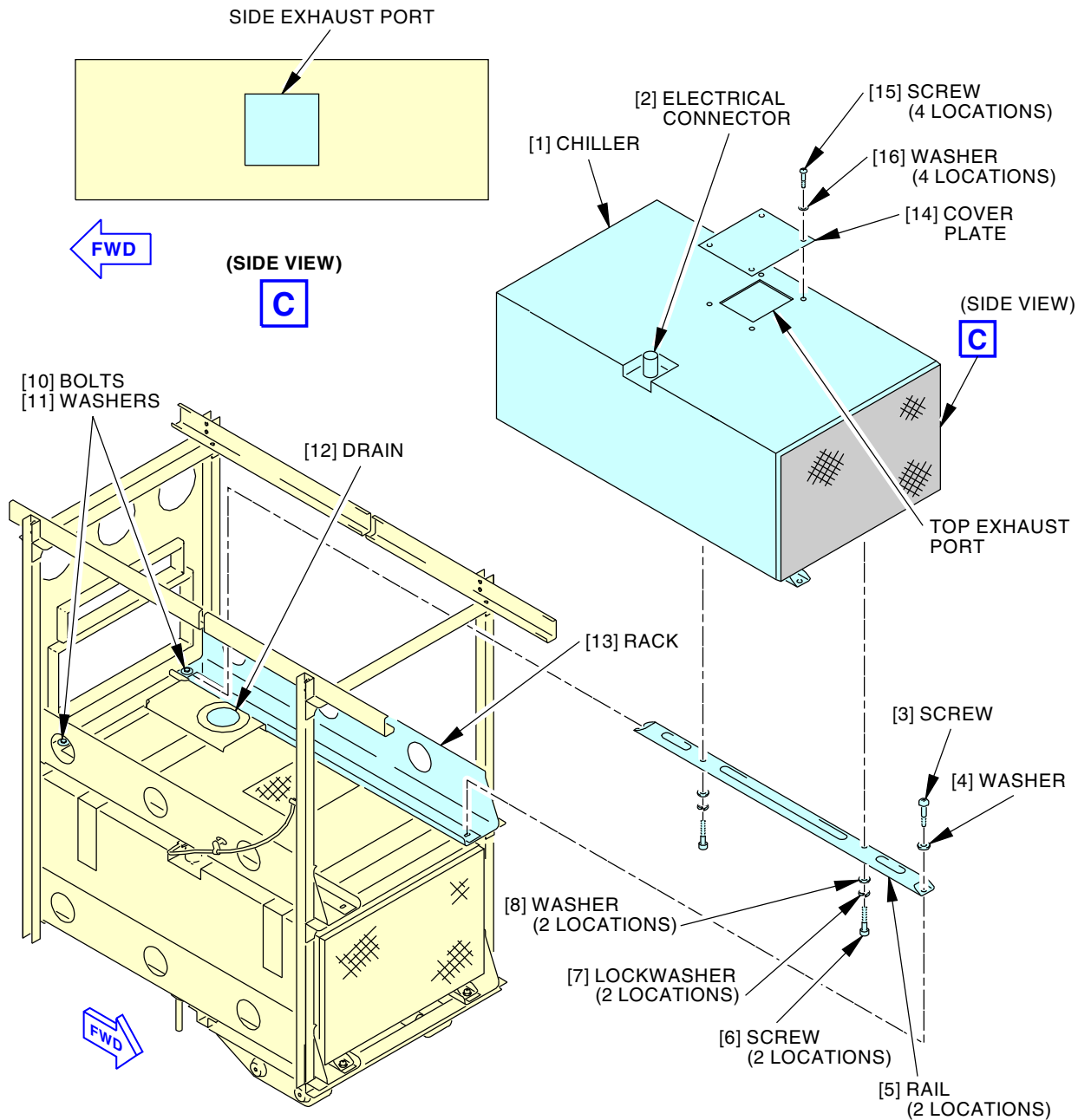
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D633W101-ARO

25-33-03

Page 405
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



LOWER LOBE AIR CHILLER

B

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**Lower Lobe Air Chiller Installation
Figure 401/25-33-03-990-801 (Sheet 2 of 2)**

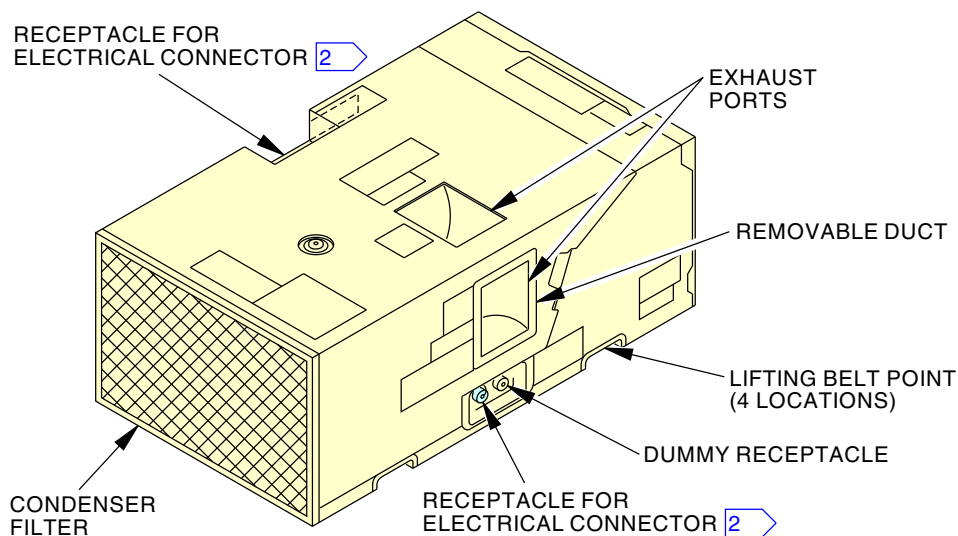
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25-33-03

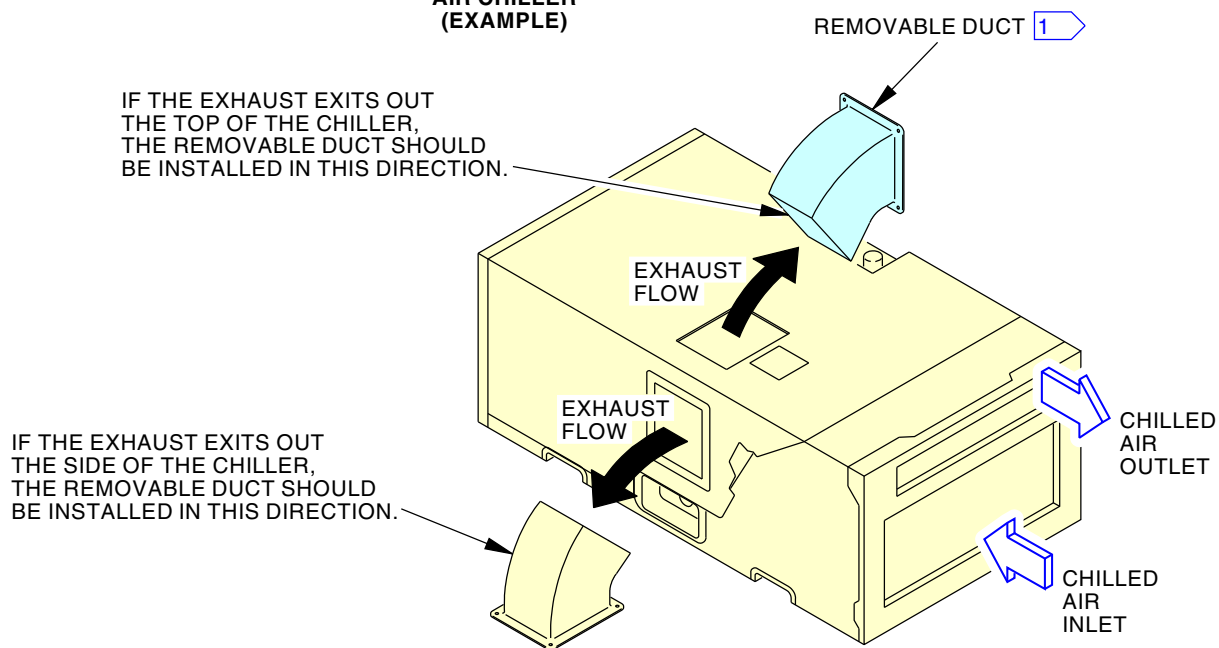
D633W101-ARO

Page 406
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



AIR CHILLER (EXAMPLE)



- 1** THERE IS ONLY ONE REMOVABLE DUCT PER CHILLER ASSEMBLY, IF EQUIPPED. ENSURE THE DUCT IS INSTALLED PROPERLY FOR THE PRESENT CONFIGURATION.
- 2** SOME CHILLERS HAVE AN INTERCONNECTING CABLE. IF YOU USE THE SIDE RECEPTACLE, MAKE SURE THAT THE INTERCONNECTING CABLE IS ATTACHED TO THE SIDE DUMMY RECEPTACLE. IF YOU USE THE TOP RECEPTACLE, YOU MUST ATTACH THE INTERCONNECTING CABLE TO THE SIDE RECEPTACLE.

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Galley Air Chiller
Figure 402/25-33-03-990-802

EFFECTIVITY
ARO ALL

D633W101-ARO

25-33-03

Page 407
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
CHILLER AIR FILTER - CLEANING/PAINTING

1. General

- A. This procedure gives instructions to clean the air filters for the chillers in the forward, mid and aft galley areas.

TASK 25-33-09-100-801

2. Chiller Air Filter Cleaning

(Figure 701)

A. References

Reference	Title
25-52-19-000-801	Bulk Cargo Compartment Aft End Wall Removal (P/B 401)
25-52-19-400-801	Bulk Cargo Compartment Aft End Wall Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
B00541	Cleaner - General Purpose Household Detergent	

C. Location Zones

Zone	Area
165	Area Aft of Bulk Cargo Compartment, Left
166	Area Aft of Bulk Cargo Compartment, Right
200	Upper Half of Fuselage
260	Subzone 260 - Section 47

D. Prepare to Clean the Chiller Air Filter

NOTE: Check the overall condition of the filter before cleaning. If the filter is damaged or too dirty it should be replaced instead of cleaned.

SUBTASK 25-33-09-010-001

- (1) Do this task to get access to the lower lobe chillers: Bulk Cargo Compartment Aft End Wall Removal, TASK 25-52-19-000-801.

SUBTASK 25-33-09-010-002

- (2) Open the applicable access panels in the ceiling for the forward and mid galley chillers, or, if installed in the aft galley, open the placarded chiller access panels.

E. Procedure

SUBTASK 25-33-09-020-001

- (1) Remove the air filter from the chiller.

SUBTASK 25-33-09-160-001

- (2) Prepare a solution of the general purpose household detergent cleaner, B00541 and warm water.

SUBTASK 25-33-09-160-002

- (3) Soak the air filter in the general purpose household detergent cleaner, B00541 solution to loosen the unwanted material.

SUBTASK 25-33-09-160-003

- (4) Flush the air filter with clean water.

EFFECTIVITY
ARO ALL

25-33-09

D633W101-ARO

Page 701
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-33-09-160-004

- (5) Dry the air filter with low pressure air.

SUBTASK 25-33-09-420-001

- (6) Install the air filter on the chiller.

SUBTASK 25-33-09-420-004

- (7) Install the bulk cargo compartment aft end wall by doing the following task: (Bulk Cargo Compartment Aft End Wall Installation, TASK 25-52-19-400-801).

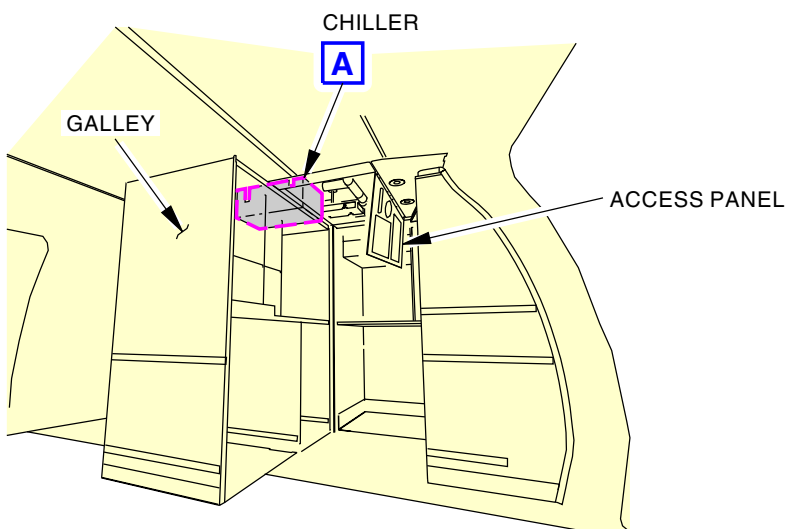
———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

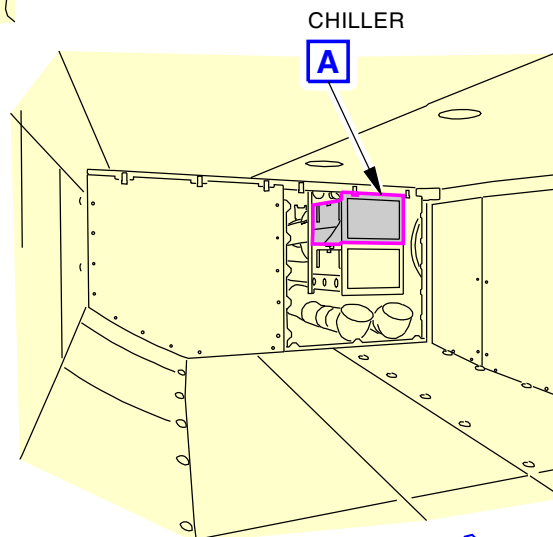
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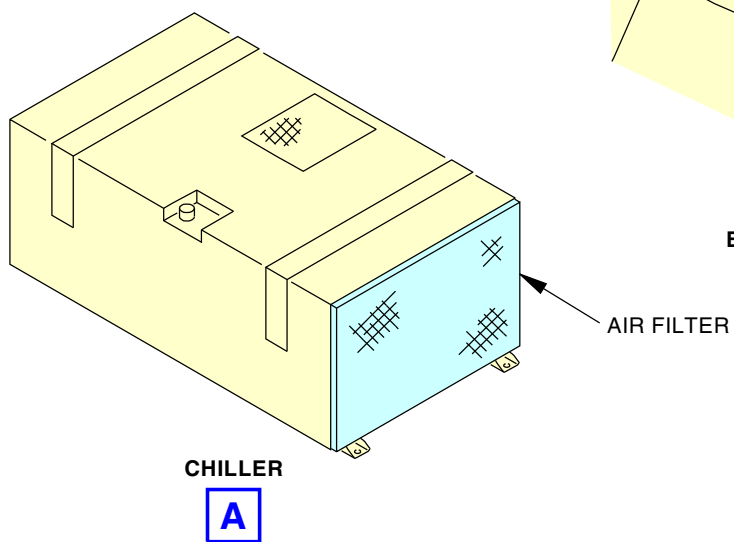
Page 702
Jan 05/2015



**PASSENGER COMPARTMENT
(EXAMPLE)**



BULK CARGO COMPARTMENT



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**Chiller Air Filter Cleaning
Figure 701/25-33-09-990-801**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-33-09

Page 703
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
GALLEY AIR CHILLER - ADJUSTMENT/TEST

1. General

- A. This procedure has this task:
- (1) An operational test of the galley chiller.

TASK 25-33-97-700-801

2. Galley Air Chiller Operational Test

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Galley Chiller - Operational Test

SUBTASK 25-33-97-861-001

- (1) Do this task: Supply electrical power task 24-22-000-860-805.

SUBTASK 25-33-97-865-002

- (2) Make sure the chiller power and control circuit breakers on the Galley Electrical Control Panel are closed.

SUBTASK 25-33-97-710-001

- (3) Do the test that follows for each chiller:

NOTE: Complete one chiller test before you do the next chiller test.

- (a) Put the ON/OFF switch for the chiller in the ON position.
 - 1) Make sure the ON light for the chiller comes on.
 - 2) Make sure the air moves in the chiller compartment.
- (b) Put the ON/OFF switch for the chiller in the OFF position.
 - 1) Make sure the ON light for the chiller goes off.

SUBTASK 25-33-97-212-001

- (4) Make sure that the ambient temperature range for the chiller is +150 / -5 degrees F (+66 / -3 degrees C).

SUBTASK 25-33-97-212-002

- (5) Make sure that the cooling air from the chiller is approximately 40 ±5°F (4 ±3°C) at the galley carts or refrigerators.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

25-33-97

D633W101-ARO

Page 501
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

LAVATORY - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Removal of the lavatory
 - (2) Installation of the lavatory
- B. This procedure is applicable to the center and outboard lavatories in the passenger compartment.

TASK 25-41-01-000-801

2. Lavatory Removal

Figure 401

A. References

<u>Reference</u>	<u>Title</u>
12-14-01-616-802	Potable Water System - Drain (P/B 301)
21-21-02-000-801	Overhead Distribution Duct Removal (P/B 401)
25-25-01-000-801	Passenger Seat - Removal (P/B 401)
25-25-06	ATTENDANT SEATS
WDM 33-26-1X	Wiring Diagram Manual

B. Location Zones

<u>Zone</u>	<u>Area</u>
200	Upper Half of Fuselage

C. Prepare for the Removal

SUBTASK 25-41-01-860-001

- (1) Open the applicable circuit breakers:

NOTE: Because there are many lavatory configurations, some circuit breakers have names that do not fit the location of the lavatories, as examples:

C33496 LAV LTS R

C33497 LAV LTS L

“L” does not necessarily refer to the left and “R” does not necessarily refer to the right. There will be some left side lavatories connected to LAV LTS R and some right side lavatories connected to LAV LTS L. To find the lavatories that are connected to their lavatory lights and signs circuit breakers, see WDM 33-26-1X.

Open these circuit breakers and install safety tags:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	9	C38604	FL CTRL LAV SYS 1 GND
D	10	C38605	FL CTRL LAV SYS 2 GND
D	11	C38606	FL CTRL LAV SYS 3 GND
H	10	C33433	ENTRY/DIR CLG LTS
J	7	C33497	LAV LTS L
J	8	C33496	LAV LTS R

EFFECTIVITY
ARO ALL

25-41-01

D633W101-ARO

Page 401
Jan 05/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	8	C38401	LAV WTR HTR 1
A	15	C23437	OEU ZONE1 MAIN BUS
B	8	C38403	LAV WTR HTR 2
C	20	C23464	OEU ZONE 4 R MAIN BUS
D	7	C38407	LAV WTR HTR 7
D	15	C23445	OEU ZONE3 RIGHT MAIN BUS
D	16	C23441	OEU ZONE3 LEFT MAIN BUS
E	16	C23443	OEU ZONE3 CENTER MAIN BUS
E	22	C23465	OEU ZONE 4 CTR MAIN BUS
F	2	C23439	OEU ZONE1 XFER BUS
F	24	C23466	OEU ZONE 4 L MAIN BUS
G	6	C23467	OEU ZONE 4 XFER BUS
H	7	C23447	OEU ZONE3 XFER BUS
J	26	C26621	LAV SMOKE DETECT-L
L	4	C25617	LAV ELEC FAUCET
N	17	C38608	FL CTRL LAV SYS 1 FLT
Z	1	C38306	VAC BLO LAV SYS 1

Overhead Circuit Breaker Panel, P11

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	16	C33621	EMERGENCY LIGHTS DOOR 3L
H	17	C33620	EMERGENCY LIGHTS DOOR 3R
H	18	C33619	EMERGENCY LIGHTS DOOR 4L & 4R

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	10	C23414	OEU ZONE2 LEFT MAIN BUS
D	10	C23416	OEU ZONE2 CENTER MAIN BUS
D	24	C38406	LAV WTR HTR 6
D	25	C38404	LAV WTR HTR 5
D	26	C38402	LAV WTR HTR 4
D	27	C38400	LAV WTR HTR 3
E	10	C23418	OEU ZONE2 RIGHT MAIN BUS
E	24	C23420	OEU ZONE2 XFER BUS
J	11	C25615	LAV ELEC FAUCET
K	3	C26619	LAV SMOKE DETECTOR RIGHT
M	5	C33628	PAX MASTER CALL LT
N	6	C38610	FL CTRL LAV SYS 2 FLT
N	7	C38612	FL CTRL LAV SYS 3 FLT
Z	1	C38307	VAC BLO LAV SYS 2 & 3

Standby Power Management Panel, P310

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	4	C35405	C PAX OXY
E	7	C23653	CAB INTPH ZMU 1 & 3
E	8	C23654	CAB INTPH ZMU 2 & 4

EFFECTIVITY
ARO ALL

25-41-01

D633W101-ARO

Page 402
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Standby Power Management Panel, P310

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	9	C23652	SDM COL 5
F	6	C23632	PAX ADRS CTRL PRI
F	7	C23633	PAX ADRS CTRL SEC
F	9	C23634	SDM COL 1
F	10	C23635	SDM COL 2
F	11	C23636	SDM COL 3
F	12	C23638	CAB INTPH PRI
F	13	C23639	CAB INTPH SEC
H	3	C35606	CHAN A OXY DEPLOY
H	4	C35607	CHAN B OXY DEPLOY
K	4	C25604	EMER EVAC SIG

This circuit breaker is inoperative and should remain open:

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	7	C23462	VIDEO DISTR 1A (INOP)

SUBTASK 25-41-01-010-001

- (2) Do this task: Overhead Distribution Duct Removal, TASK 21-21-02-000-801.

SUBTASK 25-41-01-010-003

- (3) Do this task: Attendant Seat Removal (ATTENDANT SEATS, SUBJECT 25-25-06) if it is necessary.

SUBTASK 25-41-01-010-002

- (4) If necessary, remove one or more passenger seats (Passenger Seat - Removal, TASK 25-25-01-000-801).

SUBTASK 25-41-01-680-001

- (5) Do this task: Potable Water System - Drain, TASK 12-14-01-616-802.

SUBTASK 25-41-01-680-002

- (6) Drain the applicable lavatory water system.
- (a) Turn the water shutoff valve at the airplane to CLOSE.
- (b) Open the faucets and drain the lavatory system.

SUBTASK 25-41-01-860-003

- (7) Remove the loose items from the lavatory.

SUBTASK 25-41-01-860-006

- (8) Close and lock the lavatory door.

D. Lavatory Removal

SUBTASK 25-41-01-020-001

- (1) Do these steps to disconnect the top of the lavatory:
- (a) Remove the fairing, if it is necessary, to get access on the top of the lavatory.
- (b) Disconnect the electrical connectors [4].

EFFECTIVITY
ARO ALL

25-41-01

D633W101-ARO

Page 403
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 1) If the emergency lights come ON, quickly install a jumper wire between pins 8 and 20 of the electrical connector D6310P.

NOTE: Make sure the emergency lights go OFF. Do this step in less than one minute to keep the batteries sufficiently charged to operate the emergency lights.

- (c) Disconnect the air conditioning duct [2].
- (d) Disconnect the environmental control system (ECS) vent duct [3].
- (e) Disconnect the water supply fitting [1].
- (f) FOR LAVATORIES WITH THE TRIPOD ATTACHMENT; do these steps to disconnect the tie rod [5] from the top of the lavatory:
 - 1) Remove the bolt [6], washers [7] and [8], and nut [9] to disconnect the tie rod [5] from the tripod [10] on the lavatory.
 - 2) Do these steps to remove the tripod [10] from the top of the lavatory:
 - a) Remove the screws [11] to disconnect two legs of the tripod [10] from the lavatory.
 - b) Remove the bolt [15], washers [13] and [14], and nut [12] to disconnect the other leg of the tripod [10] from the lavatory.
 - c) Remove and keep the bushing [31] for the installation task.
 - 3) Do these steps to remove the bracket [33] from the top of the lavatory:
 - a) Remove the screws [32] to disconnect the bracket [33] from the lavatory.
 - b) Remove the bracket [33] from the top of the lavatory.
- (g) FOR :LAVATORIES WITH THE BRACKET ATTACHMENT; do these steps to disconnect the tie rod [16] from the top of the lavatory:
 - 1) Push down on the foam seal if it is necessary, for access to the bolt [20], washers [18] and [19], and nut [17].
 - 2) Remove the bolt [20], washers [18] and [19], and nut [17] to disconnect the tie rod [16] from the bracket [21] on the lavatory.

SUBTASK 25-41-01-020-002

- (2) Do these steps to disconnect the water and waste interfaces for the lavatory:
 - (a) Open the access door for the junction box [22].

NOTE: The junction box is usually in the corner below the sink or toilet shroud.
 - (b) Disconnect the gray water line [23].
 - (c) Disconnect the potable water line [24].

NOTE: On some center lavatories, get access to the potable water line from below in the cargo compartment.
 - (d) Disconnect the vacuum waste system [25].

SUBTASK 25-41-01-020-003

- (3) Do these steps to disconnect the lavatory from the seat track fittings [29].

NOTE: The access to the seat track fittings is through the inner side of the lavatory if there are monuments adjacent to the lavatory.

 - (a) Remove the floor pan cover in the inner side of the lavatory, if necessary.
 - (b) Remove the tiedown cover to get access to the seat track fittings [29].

EFFECTIVITY
ARO ALL

25-41-01

D633W101-ARO

Page 404
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (c) Remove the bolts [26] and washers [27] to disconnect the lavatory from the fittings [28] and seat track fittings [29].

SUBTASK 25-41-01-020-004

- (4) Carefully lift and remove the lavatory.

SUBTASK 25-41-01-020-005

- (5) Remove the washers [27] and fittings [28] from the seat track fittings [29].

SUBTASK 25-41-01-860-004

- (6) Keep the washers [27] and fittings [28] for the installation of the lavatory.

SUBTASK 25-41-01-020-006

- (7) Do these steps if it is necessary to remove the seat track fittings [29]:
- (a) Move the seat track fitting [29] forward or rearward approximately 1/2 inch to align it with the circular openings in the seat track [30].
 - (b) Lift the seat track fitting [29] out of the seat track [30].

————— END OF TASK —————

TASK 25-41-01-400-801

3. Lavatory Installation

(Figure 401)

A. References

Reference	Title
21-21-02-400-801	Overhead Distribution Duct Installation (P/B 401)
23-31-00-710-801	Passenger Address System - Operational Test (P/B 501)
23-33-02-700-801	Overhead Electronics Unit Installation Test (P/B 401)
24-22-00-860-805	Supply Electrical Power (P/B 201)
25-25-06	ATTENDANT SEATS
26-13-00-710-801	Lavatory Smoke Detection - Operational Test (P/B 501)
33-26-00 P/B 501	LAVATORY LIGHTS AND SIGNS - ADJUSTMENT/TEST
35-21-00-710-801	Oxygen Box Door Latch/Actuator Operational Test (P/B 501)
38-10-00-600-801	Potable Water System - Disinfectant (P/B 201)
38-10-00-790-801	Potable Water System - Leak Test (P/B 201)
WDM 33-26-1X	Wiring Diagram Manual

B. Consumable Materials

Reference	Description	Specification
A00635	Adhesive - RTV 108 Translucent Silicone Rubber RTV Paste, One-part	BAC5010 Type 60 Class A Grade 2 / MIL-A-46106 Type 1
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
G02304	Tape - Moisture Barrier, Adhesive One-side	BMS8-346

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

EFFECTIVITY
ARO ALL

25-41-01

D633W101-ARO

Page 405
May 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Lavatory Installation

SUBTASK 25-41-01-420-006

- (1) Do these steps, if it is necessary, to install the seat track fittings [29]:
 - (a) Do these steps in the wet areas to prevent corrosion:
 - 1) Remove the used moisture barrier tape, G02304 from the wet areas to install the seat track fittings [29].
 - 2) Apply new moisture barrier tape, G02304 with a cutout for the seat track fittings [29].
 - 3) Put corrosion preventive compound, C00308 in the seat track [30] around the seat track fittings [29].
 - (b) Put the seat track fittings [29] in the circular opening in the seat track [30].
 - (c) Move the seat track fittings [29] forward or rearward 0.5 in. (12.7 mm) to lock it in the correct position for the installation.

SUBTASK 25-41-01-420-001

- (2) Install the fittings [28] on the seat track fittings [29].
 - (a) If it is necessary, turn the fittings [28] to align them forward or rearward with the seat track fittings [29].

NOTE: The fittings [28] are not symmetrical. If no adjustment is necessary, all four fittings must be in the same direction.

SUBTASK 25-41-01-820-001

- (3) Do these steps to make sure the lavatory is perpendicular to the airplane floor:
 - (a) Install the washers [27], with the tab down, on the top of the fittings [28] until the lavatory is perpendicular to the airplane floor.
 - (b) If all of the washers [27] are not necessary to make the lavatory perpendicular to the airplane floor, keep the remaining washers [27] for installation below the heads of the bolts [26].

NOTE: To make sure that the threads of the bolt correctly engage, all of the washers must be used at each seat track fitting location.

SUBTASK 25-41-01-820-002

- (4) Align the lavatory with the seat track fittings [29].

SUBTASK 25-41-01-210-001

- (5) Lower the lavatory on the seat track fitting [29].
 - (a) Make sure the fittings [28] and washers [27] stay between the fittings [28] and the lavatory.

SUBTASK 25-41-01-420-002

- (6) Put the remaining washers [27], with the tabs up, below the heads of the bolts [26].

SUBTASK 25-41-01-420-003

- (7) Install the bolts [26] to attach the lavatory to the seat track fittings [29].
 - (a) Tighten the bolts [26] to 145 in-lb (16 N·m) to 155 in-lb (18 N·m).

SUBTASK 25-41-01-410-001

- (8) Install the cover for the opening to the bolts [26] and washers [27].
 - (a) Fillet seal the cover with RTV 108 adhesive, A00635.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-41-01

Page 406
May 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-41-01-420-007

- (9) Install the floor pan cover in the inner side of the lavatory, if necessary.

SUBTASK 25-41-01-420-004

- (10) Do these steps to connect the water and waste interfaces for the lavatory:
- Open the access door for the junction box [22].
NOTE: The junction box is usually in the corner below the sink or toilet shroud.
 - Connect the gray water line [23].
 - Connect the potable water line [24].
 - Connect the vacuum waste system [25].
 - Install the cover of the junction box.
 - Close the access door.

SUBTASK 25-41-01-420-005

- (11) Do these steps to attach the top of the lavatory:
- Connect the water supply fitting [1].
 - Connect the electrical connectors [4].
 - Remove the jumper wire from the electrical connector.
NOTE: The emergency lights will come ON.
 - Quickly connect the electrical connector.
NOTE: Do this step in less than one minute to keep the batteries sufficiently charged to operate the emergency lights.
 - Connect the air conditioning duct [2].
 - Connect the ECS vent duct [3].
 - FOR LAVATORIES WITH THE TRIPOD ATTACHMENT; do these steps to install the tripod [10] to the top of the lavatory:
 - Do these steps to install the bracket [33] on the top of the lavatory:
 - Install the bracket [33] on the top of the lavatory.
 - Install the screws [32] to attach the bracket [33] to the lavatory.
 - Install the bushing [31] in the correct leg of the tripod [10].
 - Install the screws [11] to attach two legs of the tripod [10] to the lavatory.
 - Install the bolt [15], washer [13], washer [14], and nut [12] to attach the other leg of the tripod [10] to the lavatory.
 - FOR LAVATORIES WITH THE BRACKET ATTACHMENT; do these steps to connect the tie rod [16] to the bracket [21]:
 - Push down on the foam seal if it is necessary to install the bolt [20], washer [18], washers [19] and nut [17].
 - If it is necessary to adjust the length of the tie rod [5] or tie rod [16], do these steps:
 - Remove the lockwire.
 - Adjust the end of the tie rod [5] or tie rod [16] to align it with the tripod [10] or bracket [21] on the lavatory.
NOTE: There must be no preload on the tie rod.
 - Install a new lockwire.

EFFECTIVITY
ARO ALL

25-41-01

D633W101-ARO

Page 407
May 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 4) FOR LAVATORIES WITH THE TRIPOD ATTACHMENT; install the bolt [6], washers [7], washer [8], and nut [9] to connect the tie rod [5] to the tripod [10] on the lavatory.
- 5) FOR LAVATORIES WITH THE BRACKET ATTACHMENT; install the bolt [20], washers [19], washer [18] and nut [17] to connect the tie rod [16] to the bracket [21] on the lavatory.

(h) Install the fairing if it is necessary.

E. Lavatory Installation Test

SUBTASK 25-41-01-410-006

(1)

Close the applicable circuit breakers:

NOTE: Because there are many lavatory configurations, some circuit breakers have names that do not fit the location of the lavatories, as examples:

C33496 LAV LTS R

C33497 LAV LTS L

“L” does not necessarily refer to the left and “R” does not necessarily refer to the right. There will be some left side lavatories connected to LAV LTS R and some right side lavatories connected to LAV LTS L. To find the lavatories that are connected to their lavatory lights and signs circuit breakers, see WDM 33-26-1X.

Remove the safety tags and close these circuit breakers:

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	9	C38604	FL CTRL LAV SYS 1 GND
D	10	C38605	FL CTRL LAV SYS 2 GND
D	11	C38606	FL CTRL LAV SYS 3 GND
H	10	C33433	ENTRY/DIR CLG LTS
J	7	C33497	LAV LTS L
J	8	C33496	LAV LTS R

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	8	C38401	LAV WTR HTR 1
A	15	C23437	OEU ZONE1 MAIN BUS
B	8	C38403	LAV WTR HTR 2
C	20	C23464	OEU ZONE 4 R MAIN BUS
D	7	C38407	LAV WTR HTR 7
D	15	C23445	OEU ZONE3 RIGHT MAIN BUS
D	16	C23441	OEU ZONE3 LEFT MAIN BUS
E	16	C23443	OEU ZONE3 CENTER MAIN BUS
E	22	C23465	OEU ZONE 4 CTR MAIN BUS
F	2	C23439	OEU ZONE1 XFER BUS
F	24	C23466	OEU ZONE 4 L MAIN BUS
G	6	C23467	OEU ZONE 4 XFER BUS
H	7	C23447	OEU ZONE3 XFER BUS
J	26	C26621	LAV SMOKE DETECT-L
L	4	C25617	LAV ELEC FAUCET

EFFECTIVITY
ARO ALL

25-41-01

D633W101-ARO

Page 408
May 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
N	17	C38608	FL CTRL LAV SYS 1 FLT
Z	1	C38306	VAC BLO LAV SYS 1

Overhead Circuit Breaker Panel, P11

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	16	C33621	EMERGENCY LIGHTS DOOR 3L
H	17	C33620	EMERGENCY LIGHTS DOOR 3R
H	18	C33619	EMERGENCY LIGHTS DOOR 4L & 4R

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	10	C23414	OEU ZONE2 LEFT MAIN BUS
D	10	C23416	OEU ZONE2 CENTER MAIN BUS
D	24	C38406	LAV WTR HTR 6
D	25	C38404	LAV WTR HTR 5
D	26	C38402	LAV WTR HTR 4
D	27	C38400	LAV WTR HTR 3
E	10	C23418	OEU ZONE2 RIGHT MAIN BUS
E	24	C23420	OEU ZONE2 XFER BUS
J	11	C25615	LAV ELEC FAUCET
K	3	C26619	LAV SMOKE DETECTOR RIGHT
M	5	C33628	PAX MASTER CALL LT
N	6	C38610	FL CTRL LAV SYS 2 FLT
N	7	C38612	FL CTRL LAV SYS 3 FLT
Z	1	C38307	VAC BLO LAV SYS 2 & 3

Standby Power Management Panel, P310

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	4	C35405	C PAX OXY
E	7	C23653	CAB INTPH ZMU 1 & 3
E	8	C23654	CAB INTPH ZMU 2 & 4
E	9	C23652	SDM COL 5
F	6	C23632	PAX ADRS CTRL PRI
F	7	C23633	PAX ADRS CTRL SEC
F	9	C23634	SDM COL 1
F	10	C23635	SDM COL 2
F	11	C23636	SDM COL 3
F	12	C23638	CAB INTPH PRI
F	13	C23639	CAB INTPH SEC
H	3	C35606	CHAN A OXY DEPLOY
H	4	C35607	CHAN B OXY DEPLOY
K	4	C25604	EMER EVAC SIG

EFFECTIVITY
ARO ALL

25-41-01

D633W101-ARO

Page 409
May 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

This circuit breaker is inoperative and should remain open:

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	7	C23462	VIDEO DISTR 1A (INOP)

SUBTASK 25-41-01-860-005

- (2) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-41-01-210-002

- (3) Make sure the lavatory lights come on.

SUBTASK 25-41-01-710-003

- (4) Do this task: Overhead Electronics Unit Installation Test, TASK 23-33-02-700-801.

SUBTASK 25-41-01-710-007

- (5) Do this task: LAVATORY LIGHTS AND SIGNS - ADJUSTMENT/TEST, PAGEBLOCK 33-26-00/501

SUBTASK 25-41-01-710-004

- (6) Do this task: Lavatory Smoke Detection - Operational Test, TASK 26-13-00-710-801.

SUBTASK 25-41-01-710-005

- (7) Flush the toilet to make sure the vacuum waste system operates correctly.

SUBTASK 25-41-01-710-006

- (8) Do this check for the door latch/actuator of the oxygen box:

- (a) Open these circuit breakers and install safety tags:

Standby Power Management Panel, P310

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	3	C35403	L PAX OXY
A	5	C35404	R PAX OXY

- (b) Make sure that this circuit breaker is closed:

Standby Power Management Panel, P310

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	4	C35405	C PAX OXY

- (c) Put a door restraint tool in all oxygen boxes of the center passenger service units (PSUs).
- (d) Put a door restraint tool in all oxygen boxes of the lavatory service units and overdoor panels.
- (e) Do the part of this task for the passenger oxygen manual deploy for the center PSUs: Oxygen Box Door Latch/Actuator Operational Test (TASK 35-21-00-710-801).
- (f) Remove the door restraint tool from all of the oxygen boxes in the center PSUs, lavatory service units, and the overdoor panels.
- (g) Remove the safety tags and close these circuit breakers:

Standby Power Management Panel, P310

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	3	C35403	L PAX OXY
A	5	C35404	R PAX OXY

EFFECTIVITY
ARO ALL

25-41-01

D633W101-ARO

Page 410
May 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-41-01-710-001

- (9) Make sure that the lavatory speakers operate correctly (Passenger Address System - Operational Test, TASK 23-31-00-710-801).

SUBTASK 25-41-01-790-001

- (10) Do this task: Potable Water System - Leak Test, TASK 38-10-00-790-801.

SUBTASK 25-41-01-670-001

- (11) Do this task: Potable Water System - Disinfectant, TASK 38-10-00-600-801.

SUBTASK 25-41-01-710-002

- (12) Do these steps for a lavatory water check:
- (a) Turn the water shutoff valve to OPEN.
 - (b) Open the faucet to make sure that the water comes out.
 - (c) Do a visual check to make sure that there are no leaks at the water connections.
 - (d) After 5 minutes, open the hot water faucet to make sure that the water is hot.
 - 1) If the water is not at the correct temperature, move the temperature select switch to a higher or lower temperature position.

SUBTASK 25-41-01-410-002

- (13) Do this task: Overhead Distribution Duct Installation, TASK 21-21-02-400-801.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-41-01-410-004

- (1) Do this task: Attendant Seat Installation (ATTENDANT SEATS, SUBJECT 25-25-06) if it is necessary.

SUBTASK 25-41-01-410-009

- (2) If you removed the seats for access, then, do this task: Passenger Seat Installation, Task 25-25-01-400-801 or Passenger Seat with Pallet Installation, Task 25-25-01-400-802.

————— **END OF TASK** —————

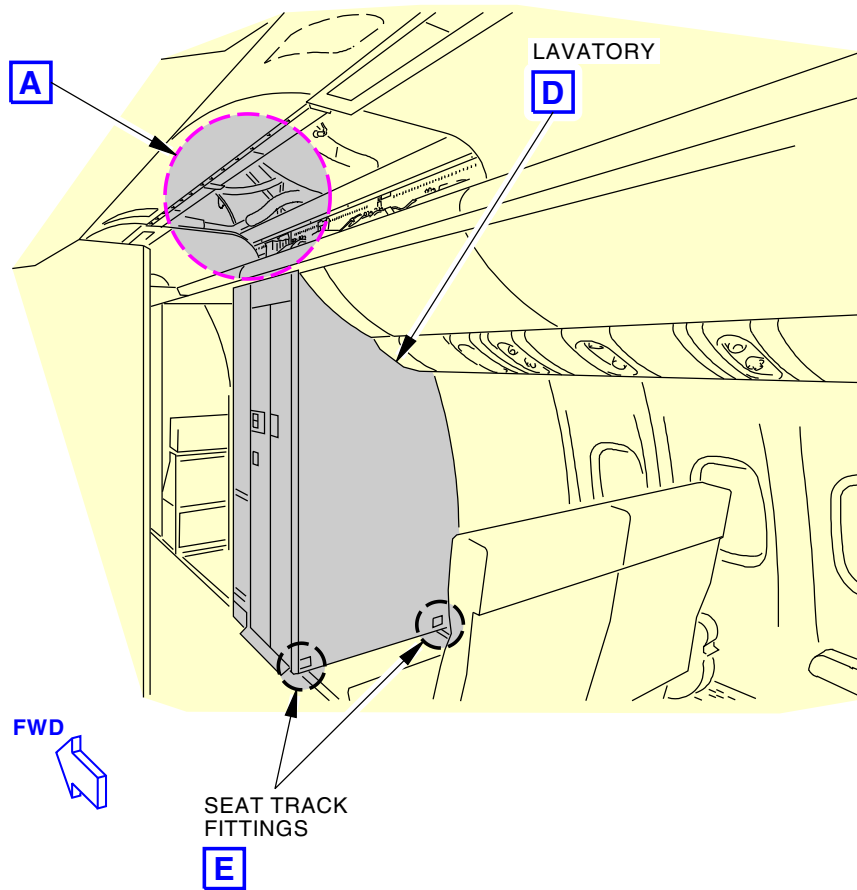
EFFECTIVITY
ARO ALL

25-41-01

D633W101-ARO

Page 411
May 05/2018

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



**PASSENGER COMPARTMENT
(LAVATORY INSTALLATION EXAMPLE)**

E05867 S0006410561_V2

Lavatory Installation
Figure 401/25-41-01-990-801 (Sheet 1 of 4)

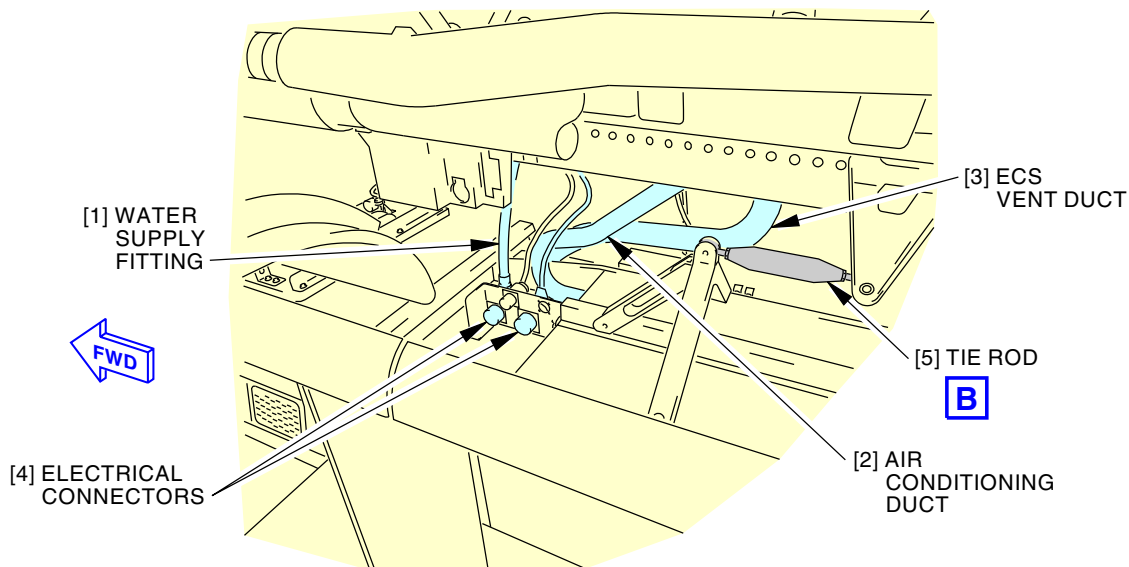
EFFECTIVITY
ARO ALL

D633W101-ARO

25-41-01

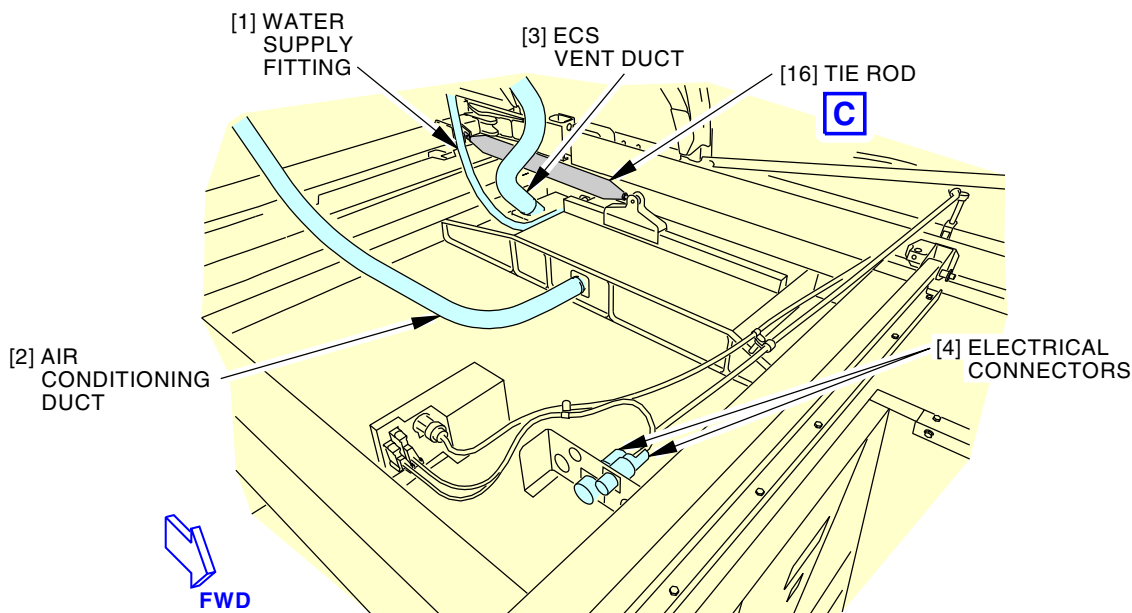
Page 412
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



**TRIPOD ATTACHMENT
(FAIRING NOT SHOWN)**

A



BRACKET ATTACHMENT

A

E06435 S0006410562_V2

Lavatory Installation
Figure 401/25-41-01-990-801 (Sheet 2 of 4)

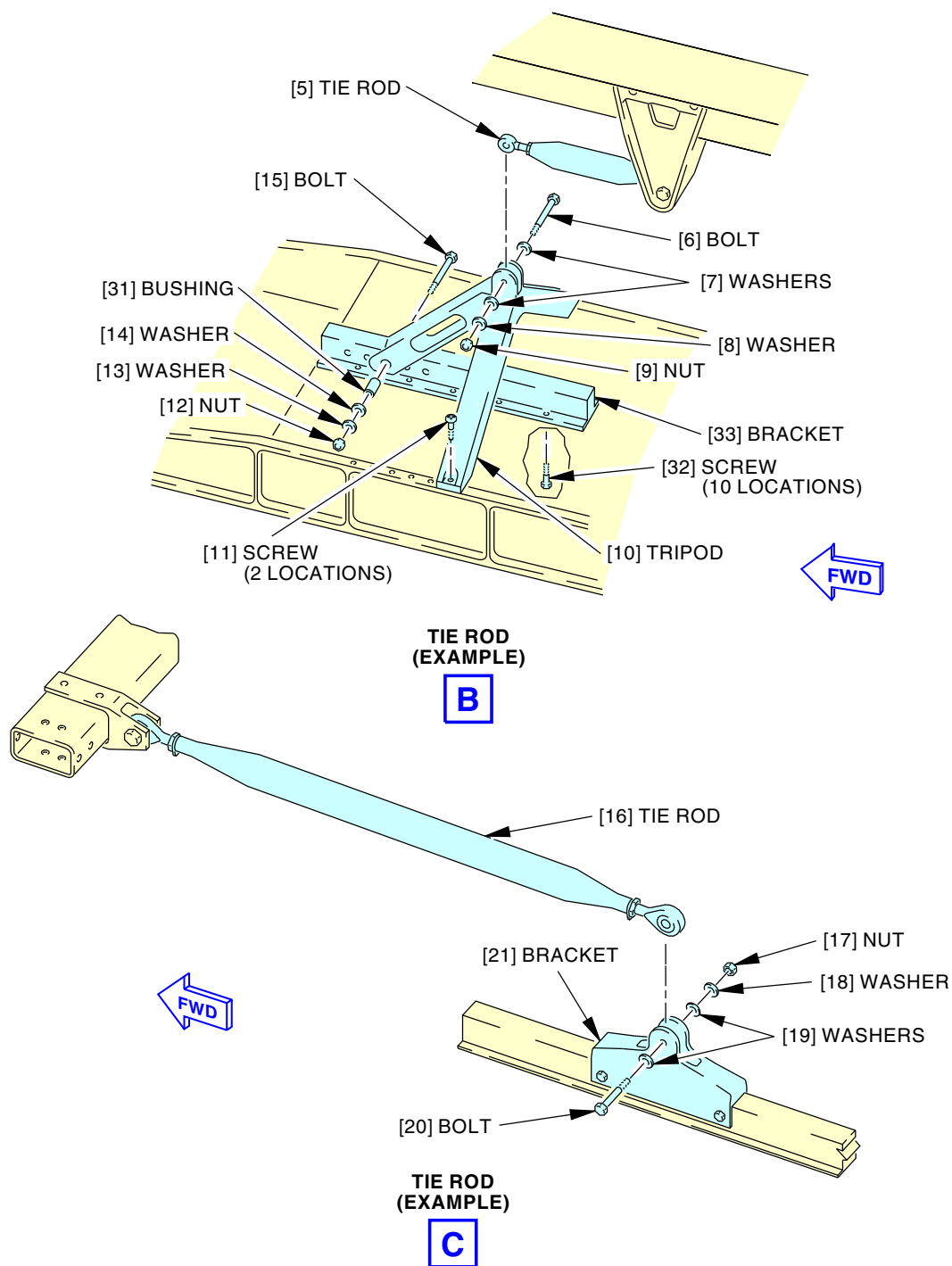
EFFECTIVITY
ARO ALL

25-41-01

D633W101-ARO

Page 413
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



E06606 S0006410563_V2

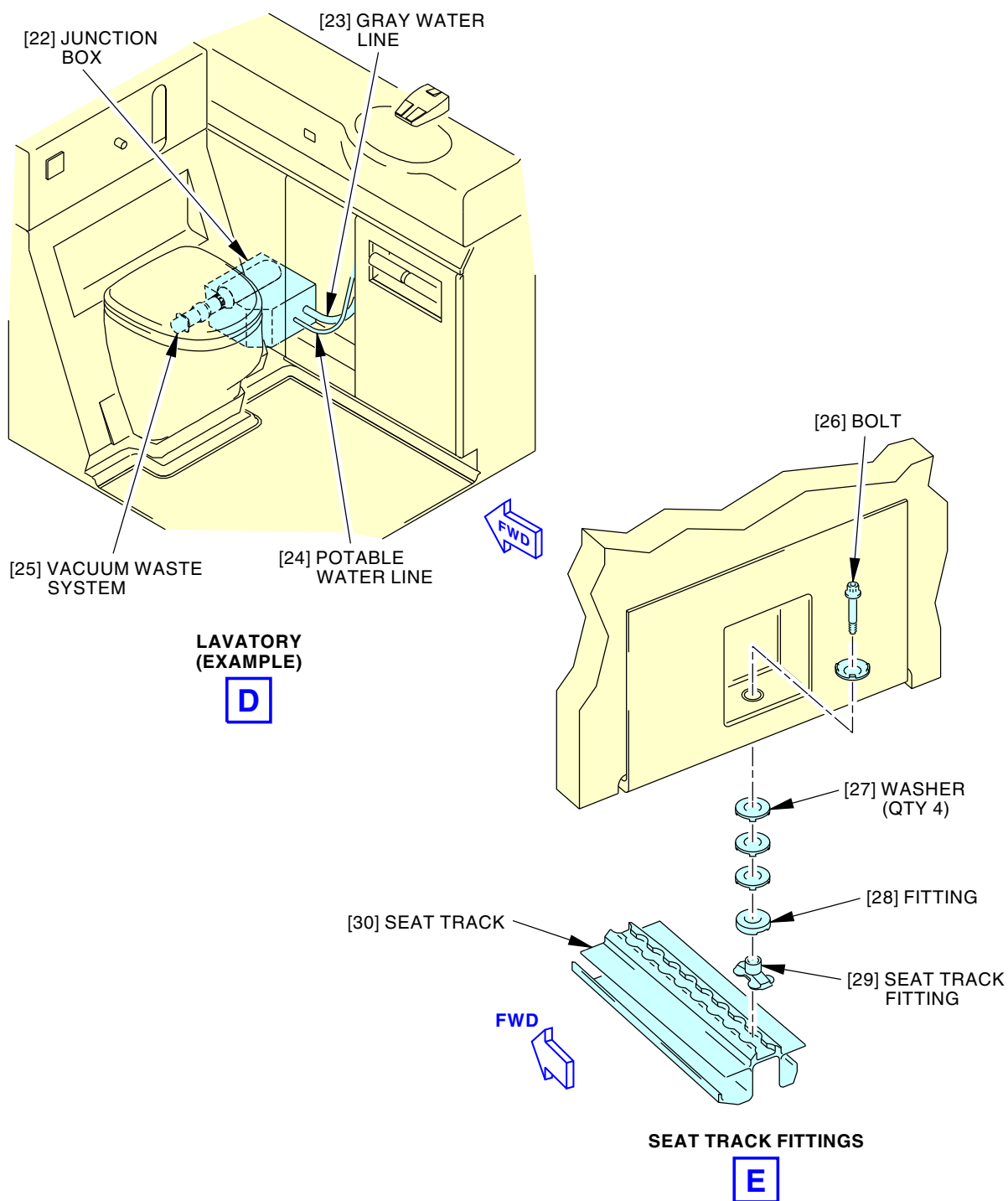
**Lavatory Installation
Figure 401/25-41-01-990-801 (Sheet 3 of 4)**

EFFECTIVITY
ARO ALL

25-41-01

D633W101-ARO

Page 414
May 05/2017



E09366 S0006410564_V2

**Lavatory Installation
Figure 401/25-41-01-990-801 (Sheet 4 of 4)**

EFFECTIVITY
ARO ALL

25-41-01

D633W101-ARO

Page 415
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

LAVATORY WASTE COMPARTMENT - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has this task:
 - (1) An inspection of the flap and door for the waste compartment in the lavatory.
 - (2) This procedure is required by AD 74-08-09R2.

TASK 25-41-08-200-801

2. Lavatory Waste Compartment Inspection

(Figure 601)

NOTE: This procedure is a scheduled maintenance task.

A. **Consumable Materials**

Reference	Description	Specification
A50047	Sealant - Silicone Sealant - JMS0906-4W	
A50067	Adhesive - Silicone Rubber - RTV 102 (White)	MIL-A-46106, BAC5010 Type 60, Grade 1

B. **Location Zones**

Zone	Area
200	Upper Half of Fuselage

C. **Lavatory Waste Compartment Inspection**

SUBTASK 25-41-08-210-001

- (1) Do these steps to make sure the door closes tightly:
 - (a) Pull the latch at the bottom of the door to open the door.
 - (b) Push around the edge of the door plate on the inner side of the door.
 - 1) Make sure the door plate moves smoothly back to its initial position in less than one second.
- NOTE: There are springs behind the door plate. These springs compress when the door is closed.
- (c) Close the door.
 - (d) Make sure the edges of the waste compartment door do not have any gaps.
 - 1) To check for gaps do the following:
 - a) Open waste compartment door and put a flashlight in the compartment.
 - b) Check around edge of the door for light leaks.
 - c) If light leaks are found do the following:
 - <1> Use a 0.02 in. (0.51 mm) feeler gage from the inside of the compartment to check for excessive gaps around the edge of the door (access inside through the waste flap).
 - <2> Gaps must not be more than 0.02 in. (0.51 mm) anywhere around the edge of the waste compartment door.
 - (e) If gaps larger than 0.02 in. (0.51 mm) exist, adjust the door.
 - (f) Do these steps to make sure the latches are fully engaged:
 - 1) Push the door in the upper and lower latch area.

EFFECTIVITY
ARO ALL

25-41-08

D633W101-ARO

Page 601
Jan 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 2) Make sure the lower latch is parallel to the door.
- 3) Look for red on the lower latch. If you can easily see red on the lower latch, the latch or latches are not fully engaged.

NOTE: If you see red on the lower latch push on the door with a little more force. If you can still see red the door or latch must be adjusted.

SUBTASK 25-41-08-210-002

- (2) Do these steps to make sure the flap is installed correctly:
 - (a) Do a visual check to make sure the bottom of the flap is parallel with the surface around it.
 - (b) Feel around the edges of the chute lip with your hand for smoothness.
 - (c) Push on the flap. Make sure the flap moves back to its initial position in less than one second when you move your hand away from the flap.
 - (d) Make sure the screws that attach the flap are tight.
 - (e) The gap all around the waste flap must be less than 0.02 inch (0.51 mm).

NOTE: Gap can be checked with a feeler gauge. If gap is larger than 0.02 in. (0.51 mm) you must adjust the flap until the gap is gone or less than 0.02 in. (0.51 mm).

NOTE: Overlap and gap can be adjusted by loosening the four screws holding the flap in place and then moving the flap slightly and retightening screws.

SUBTASK 25-41-08-210-003

- (3) Make sure the inside of the waste compartment is completely sealed.

SUBTASK 25-41-08-210-004

- (4) Do an inspection of the lavatory paper and waste compartment door, waste flap, and waste chute:
 - (a) Make sure that the waste compartment door, waste flap, and waste chute are installed correctly.
 - (b) Make sure that the waste compartment door, waste flap, and waste chute operate correctly.
 - (c) Make sure that the waste compartment door, waste flap, and waste chute seal correctly. These are the applicable dimensional requirements:
 - 1) The overlap around the waste flap must be 0.06 in. (1.52 mm) minimum.

NOTE: The amount of overlap can be more than these minimum dimensions.

NOTE: Overlap and gap can be adjusted by loosening the four screws holding the flap in place and then moving the flap slightly and retightening screws.

NOTE: If the waste flap is centered the overlap will be correct.

SUBTASK 25-41-08-210-005

- (5) Make sure that the waste flap is correctly installed and the hinge retaining pins are fully extended (if flap without damper).

NOTE: If the flap is on the top of the counter, look through the waste compartment from the bottom to see the retaining pins.

NOTE: You will not see the extended hinge retaining pins if the flap has a damper.

SUBTASK 25-41-08-210-006

- (6) Make sure that there is no visible damage or cracks in general.
 - (a) Make sure that there is no damage caused by trash fires.

EFFECTIVITY
ARO ALL

25-41-08

D633W101-ARO

Page 602
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (b) Make sure that the edges of the waste bin are completely flat and are not damaged.

SUBTASK 25-41-08-210-010

- (7) Make sure that all seals are not damaged in these areas:
 - (a) At the interface of the waste flap mount and the waste chute.
 - (b) At the interface of the waste chute with the waste compartment.

SUBTASK 25-41-08-210-011

- (8) Make sure there are no gaps in the corners of the waste compartment.
 - (a) If there are gaps in any access plates, make sure that they are not more than 0.01 in. (0.25 mm) before they are sealed.
 - (b) Apply sealant to these gaps with RTV 102 adhesive, A50067 or JMS0906-4W silicone sealant, A50047.
 - (c) Seal all access plates in the waste compartment.

————— **END OF TASK** —————

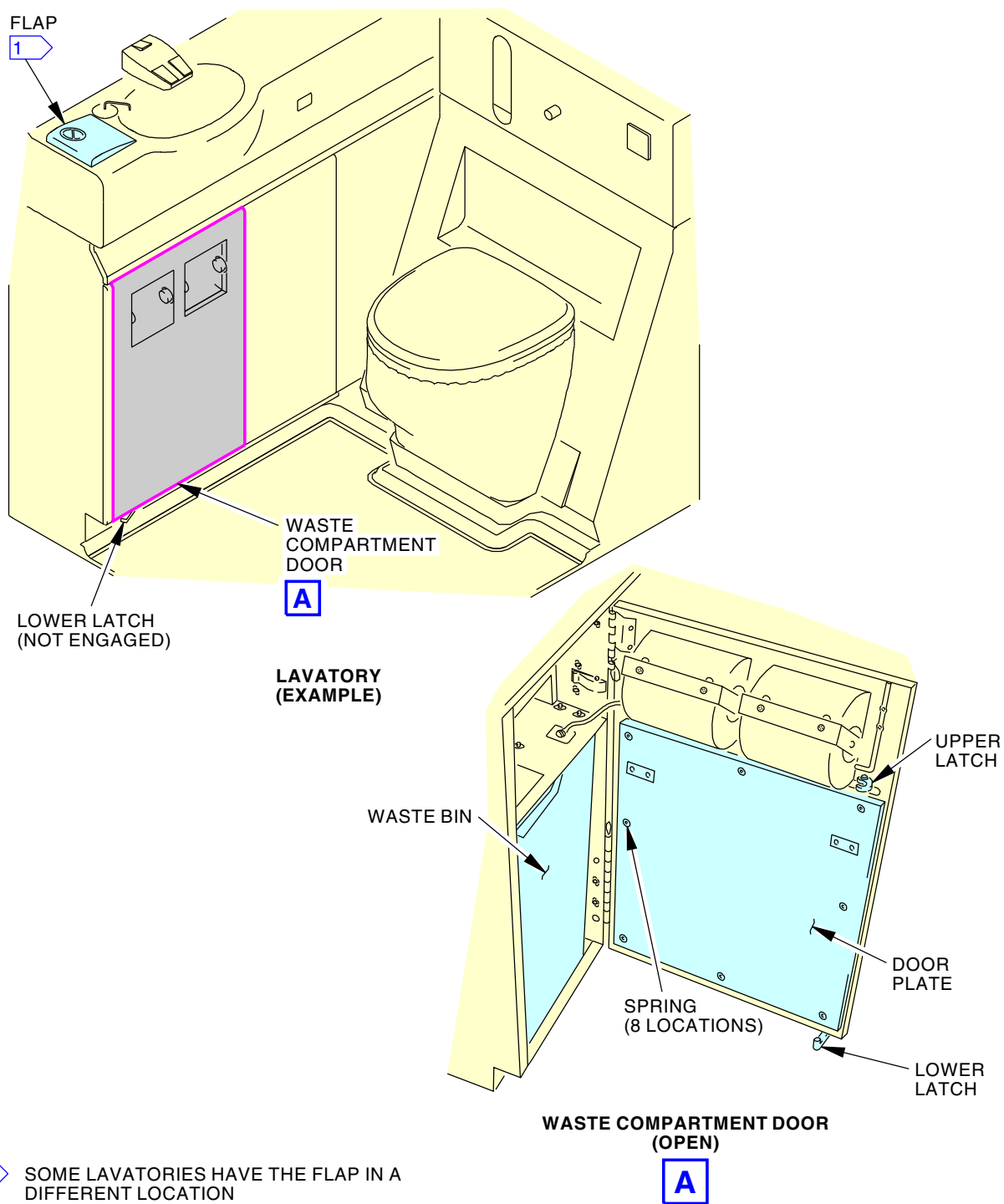
EFFECTIVITY
ARO ALL

D633W101-ARO

25-41-08

Page 603
Sep 05/2015

777-200/300
AIRCRAFT MAINTENANCE MANUAL



E17568 S0006410580_V4

Lavatory Waste Compartment Inspection
Figure 601/25-41-08-990-801

EFFECTIVITY
ARO ALL

D633W101-ARO

25-41-08

Page 604
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

LAVATORY WASTE COMPARTMENT FLAP - ADJUSTMENT/TEST

1. General

A. This procedure has this task:

- (1) An adjustment of the flap for the waste compartment in the lavatory.

TASK 25-41-09-200-801

2. Lavatory Waste Flap Adjustment

(Figure 501)

A. **Location Zones**

Zone	Area
200	Upper Half of Fuselage

B. **Procedure**

SUBTASK 25-41-09-020-001

- (1) Do these steps to remove the waste flap:

- (a) Push and hold the waste flap open.
(b) Remove the four screws that attach the waste flap hinge to the lavatory.
(c) Remove the waste flap.

SUBTASK 25-41-09-820-001

- (2) Do these steps to adjust the damper:

- (a) Loosen the nuts on the damper.
(b) Hold the damper hinge approximately in the position shown (Figure 501).
(c) Adjust the damper to the position shown (Figure 501).

NOTE: Make sure the damper does not touch the hinge while the waste flap moves through its usual travel. If the damper touches the hinge, adjust the damper until there is a small clearance between the damper and the hinge.

SUBTASK 25-41-09-420-001

- (3) Install the waste flap in the lavatory.

———— **END OF TASK** ————

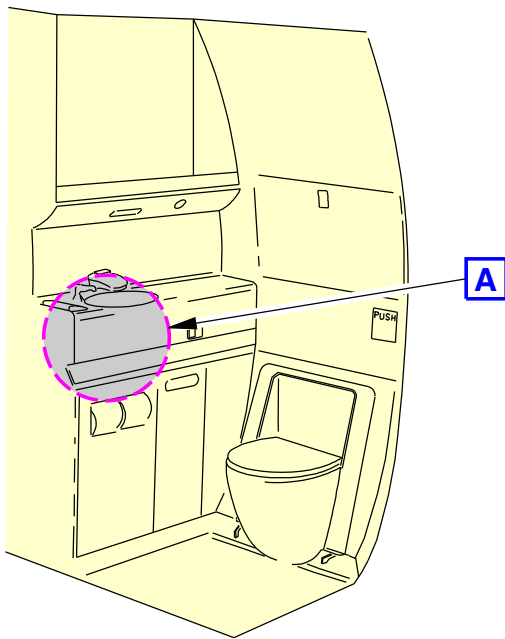
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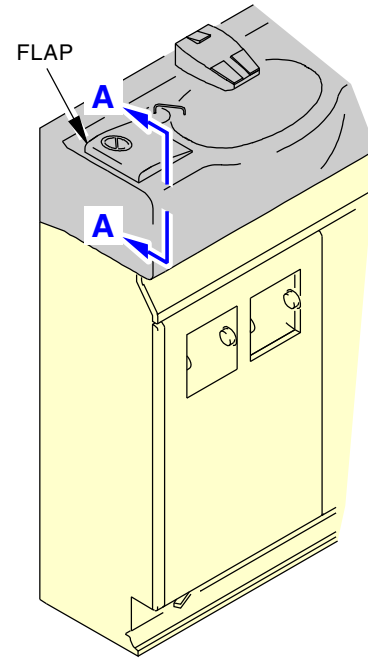
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Page 501
Jan 05/2015

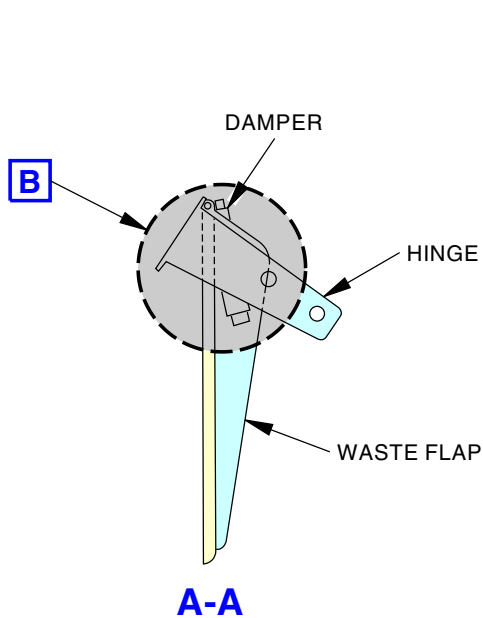
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777-200/300
AIRCRAFT MAINTENANCE MANUAL



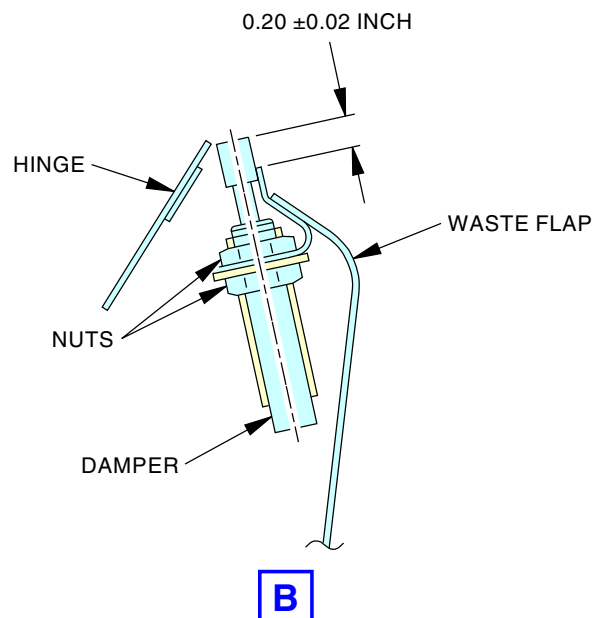
LAVATORY
(EXAMPLE)



A



A-A



B

G16454 S0006410584_V2

Waste Flap Adjustment
Figure 501/25-41-09-990-801

EFFECTIVITY
ARO ALL

D633W101-ARO

25-41-09

Page 502
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

LOWER LOBE CARGO COMPARTMENT - INSPECTION/CHECK

1. General

- A. This procedure has these tasks for the forward, aft, and bulk cargo compartments:
- (1) Liner Inspection
 - (2) Tiedown Fitting Inspection
- B. These liners are made of flexible neoprene-coated fiberglass:
- (1) Forward Cargo Compartment aft end wall
 - (2) Containment barriers.
- C. These liners are made of rigid fiberglass:
- (1) Sidewalls, vertical and sloping
 - (2) Ceiling
 - (3) Firestops
 - (4) Door liners
 - (5) Station 1437 end wall.
- D. These liners are nomex honeycomb sandwich panels:
- (1) Aft Cargo Compartment aft end wall
 - (2) Main equipment center bulkhead liner
 - (3) Waste tank enclosure.

TASK 25-52-00-210-801

2. Liner Inspection

A. References

Reference	Title
25-00-00-340-803	Nomex Honeycomb Sandwich Panels with a Decorative Tedlar Cover Repair (P/B 801)
25-52-01-300-801	Fiberglass Liner Repair (P/B 801)
25-52-02-340-801	Neoprene-Coated Liner Repair (P/B 801)
25-52-04-300-801	Honeycomb Panel Repair (P/B 801)
25-52-06-000-801	Sidewall Liner Removal (P/B 401)
25-52-06-400-801	Sidewall Liner Installation (P/B 401)
25-52-09-000-801	Ceiling Liner Removal (P/B 401)
25-52-09-400-801	Ceiling Liner - Installation (P/B 401)
25-52-17-000-801	Forward Cargo Compartment Aft End Wall Removal (P/B 401)
25-52-17-400-801	Forward Cargo Compartment Aft End Wall Installation (P/B 401)
25-52-18-000-801	Aft Cargo Compartment Forward End Wall Removal (P/B 401)
25-52-18-400-801	Aft Cargo Compartment Forward End Wall Installation (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

EFFECTIVITY
ARO ALL

25-52-00

D633W101-ARO

Page 601
May 05/2016

777-200/300 AIRCRAFT MAINTENANCE MANUAL

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363

C. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

D. Prepare for the Inspection

SUBTASK 25-52-00-480-001



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the cargo door safety barrier across the cargo door opening. large cargo door safety barrier, SPL-1988

E. Procedure - Liner Inspection

SUBTASK 25-52-00-210-006

- (1) Check the liner for any missing or damaged parts.
 - (a) Replace any missing or damaged parts.

SUBTASK 25-52-00-210-005



THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT MUST ALWAYS BE INSTALLED. THIS IS TO PREVENT DAMAGE TO THE HYDRAULIC LINES OF THE NOSE LANDING GEAR. THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT CAN ONLY BE REMOVED FOR MAINTENANCE. AFTER YOU DO THE MAINTENANCE, INSTALL THE FLOOR PANELS. BE CAREFUL IF YOU DO WORK IN THE FORWARD CARGO COMPARTMENT WITH THE FLOOR PANELS REMOVED.

- (2) Make sure the liner does not have any cuts, tears, or holes.
 - (a) If the liner does have any of the above damage, do the remaining steps in this task to repair or replace the liner.

SUBTASK 25-52-00-210-001

- (3) Examine the fiberglass and neoprene-coated fiberglass liners in the lower lobe for these damage limits:
 - (a) Cuts that are 12-inches long
 - (b) "L" shaped tears that are 9-inches long on the two sides
 - (c) Holes with a 1.5-inches diameter.

EFFECTIVITY
ARO ALL

25-52-00

D633W101-ARO

Page 602
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-52-00-340-001

- (4) If the damage is less than or equal to the limits, do the applicable tasks that follow:
- (a) Do this task: Fiberglass Liner Repair, TASK 25-52-01-300-801.
 - (b) Do this task: Neoprene-Coated Liner Repair, TASK 25-52-02-340-801.
 - (c) Do this task: Honeycomb Panel Repair, TASK 25-52-04-300-801.

SUBTASK 25-52-00-960-001

- (5) If the damage is greater than the limits, do the applicable tasks that follow:
- (a) Replace the sidewall liner.
These are the tasks:
Sidewall Liner Removal, TASK 25-52-06-000-801,
Sidewall Liner Installation, TASK 25-52-06-400-801.
 - (b) Replace the ceiling liner.
These are the tasks:
Ceiling Liner Removal, TASK 25-52-09-000-801,
Ceiling Liner - Installation, TASK 25-52-09-400-801.
 - (c) Replace the forward cargo compartment aft end wall.
These are the tasks:
Forward Cargo Compartment Aft End Wall Removal, TASK 25-52-17-000-801,
Forward Cargo Compartment Aft End Wall Installation, TASK 25-52-17-400-801.
 - (d) Replace the aft cargo compartment forward end wall.
These are the tasks:
Aft Cargo Compartment Forward End Wall Removal, TASK 25-52-18-000-801,
Aft Cargo Compartment Forward End Wall Installation, TASK 25-52-18-400-801.

SUBTASK 25-52-00-210-003

- (6) Refer to this task for the damage limits and repairs for the nomex honeycomb sandwich panels: Nomex Honeycomb Sandwich Panels with a Decorative Tedlar Cover Repair, TASK 25-00-00-340-803.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-00-080-001

- (1) Remove the cargo door safety barrier. large cargo door safety barrier, SPL-1988

————— END OF TASK —————

TASK 25-52-00-210-802

3. Tiedown Fitting Inspection

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

EFFECTIVITY
ARO ALL

25-52-00

D633W101-ARO

Page 603
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

C. Prepare for the Inspection

SUBTASK 25-52-00-480-002



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 across the cargo door opening.

D. Procedure - Tiedown Fitting Inspection

SUBTASK 25-52-00-210-004



THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT MUST ALWAYS BE INSTALLED. THIS IS TO PREVENT DAMAGE TO THE HYDRAULIC LINES OF THE NOSE LANDING GEAR. THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT CAN ONLY BE REMOVED FOR MAINTENANCE. AFTER YOU DO THE MAINTENANCE, INSTALL THE FLOOR PANELS. BE CAREFUL IF YOU DO WORK IN THE FORWARD CARGO COMPARTMENT WITH THE FLOOR PANELS REMOVED.

- (1) Do a visual check of the tiedown fittings in the forward, aft, and bulk cargo compartments.
 - (a) Make sure the tiedown fittings in the forward, aft, and bulk cargo compartments are installed satisfactorily.
 - (b) Make sure the tiedown fittings are not worn.
 - (c) Make sure the tiedown fittings can hold the nets or straps and give sufficient restraint.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-00-080-002

- (1) Remove the large cargo door safety barrier, SPL-1988.

————— END OF TASK —————

EFFECTIVITY
ARO ALL

25-52-00

D633W101-ARO

Page 604
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

CARGO COMPARTMENT - CLEANING/PAINTING

1. General

- A. This procedure contains one task:
(1) Cargo Compartment Cleaning.

TASK 25-52-00-100-801

2. Cargo Compartment Cleaning

A. References

Reference	Title
20-41-00-910-801	Static Grounding (P/B 201)
24-22-00-860-805	Supply Electrical Power (P/B 201)
24-22-00-860-806	Remove Electrical Power (P/B 201)
25-80-00-000-801	Insulation Blanket Removal (P/B 401)
25-80-00-400-801	Insulation Blanket - Installation (P/B 401)
51-03-01-000-801	Drain Valve Removal (P/B 401)
51-03-01-400-801	Drain Valve Installation (P/B 401)
51-24-09-620-802	Apply the Corrosion Inhibiting Compound (P/B 701)
52-34-00-860-801	Open the Door Electrically with the External Cargo Door Control Switch (P/B 201)
52-34-00-860-803	Close the Door Electrically with the External Cargo Door Control Switch (P/B 201)
52-35-00-860-805	Open the Aft Small Cargo Door (P/B 201)
52-35-00-860-806	Close the Aft Small Cargo Door (P/B 201)
52-36-00-860-801	Open the Door (P/B 201)
52-36-00-860-802	Close the Door (P/B 201)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-2618	Cleaner - Vacuum Part #: 106542 Supplier: 03FQ4 Part #: 98606 Supplier: 08531 Part #: AVQ250-2 Supplier: 03FQ4 Part #: BP80 Supplier: \$0373 Part #: RSV130 Supplier: \$1291 Opt Part #: 02146A Supplier: 0A5X2 Opt Part #: 44SPEC Supplier: 0Y8U0 Opt Part #: 655406-7M Supplier: 0Y8U0 Opt Part #: C-39485-41 Supplier: 16893 Opt Part #: C-39485-42 Supplier: 16893 Opt Part #: R80 Supplier: \$0373 Opt Part #: WD80 Supplier: \$0373
STD-122	Brush
STD-6391	Mop - long handle (4 - 5 foot), or long wooden stick with shop cloth attached to one end

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-00

Page 701
Jul 25/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description
STD-6638	Air Source - Compressed, Clean, Filtered, and Dry, 0 - 100 psi
STD-7714	Broom - Bristle

C. Consumable Materials

Reference	Description	Specification
B00003	Cleaner - Emulsion Alkaline - GMC 528B	
B00005	Cleaner - Alkaline - Cee Bee 280	
B00008	Cleaner - Alkaline - Oakite 204	
B00012	Cleaner - Alkaline - Turco Jet Clean C	
B00013	Cleaner - Alkaline - Dubois C-1102	
B00014	Cleaner - Zip-Chem Products Calla 301 Heavy Duty Cleaner	
B00016	Cleaner - Alkaline - TEC Formula No. 1	
B00017	Cleaner - Alkaline - Pace B-82 (Formerly Pacific B-82)	BMS11-12
B00325	Cleaner - Alkaline - Turco Jet Clean E	
B00335	Cleaner - Alkaline - TEC 86-2	
B00432	Solvent - Alkaline - Cee Bee A-410B	
B00433	Solvent - Alkaline - Hydrex 09	
B00434	Solvent - Alkaline - Metaclean AC	
B50093	Soap - Liquid - Kelite Spraywhite	BAC5507
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00116	Sponge - Synthetic	
G00253	Material - Barrier Materials, Greaseproofed, Waterproof, Flexible, Heat-Sealable	MIL-PRF-121 (Supersedes MIL-B-121)
G00258	Paper - Moisture Resistant, Laminated - Angier 30	
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G50140	Gloves - Protective, Latex or Nitrile	
G50305	Sheeting - Plastic, Polyethylene	

D. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
141	Area Above Main Landing Gear Wheel Well, Left
142	Area Above Main Landing Gear Wheel Well, Right
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-00

Page 702
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

E. Prepare to Clean

SUBTASK 25-52-00-010-001

- (1) Remove the fuselage drain valves. To remove the fuselage drain valves, do this task: Drain Valve Removal, TASK 51-03-01-000-801

NOTE: Make a note of the locations of the drain valves. The drain valves are different lengths and must be re-installed in their initial locations.

SUBTASK 25-52-00-860-003

- (2) Do this task: Supply Electrical Power, TASK 24-22-00-860-805

SUBTASK 25-52-00-010-002

- (3) Open the door for the cargo compartment(s) to be cleaned. To open a cargo door, do the applicable tasks that follow:
 - (a) Do this task: Open the Door Electrically with the External Cargo Door Control Switch, TASK 52-34-00-860-801.
 - (b) Do this task: Open the Aft Small Cargo Door, TASK 52-35-00-860-805.
 - (c) Do this task: Open the Door, TASK 52-36-00-860-801.

SUBTASK 25-52-00-860-001

- (4) Do this task: Remove Electrical Power, TASK 24-22-00-860-806.

SUBTASK 25-52-00-910-001

- (5) Do this task: Static Grounding, TASK 20-41-00-910-801.

SUBTASK 25-52-00-020-001

- (6) Remove the insulation blankets below the floor of the cargo compartment to be cleaned. To remove the blankets do this task: Insulation Blanket Removal, TASK 25-80-00-000-801.

SUBTASK 25-52-00-020-002



REMOVE ALL COMPONENTS THAT ARE NOT RESISTANT TO DAMAGE FROM THE WATER. DAMAGE TO SOME COMPONENTS CAN OCCUR IF THEY GET WET WITH THE WATER.

- (7) Remove all of the insulation blankets, cargo system components and, the electronic equipment which may be damaged by the cleaner or water.

SUBTASK 25-52-00-950-001

- (8) Install the plastic sheeting, G50305, grease proof barrier material, G00253, and/or waterproof Angier 30 paper, G00258 over those areas that you will not clean.
 - (a) Use Scotch Flatback Masking Tape 250, G00270 to hold the sheet and/or paper in place as necessary.

NOTE: Make sure you install the sheet and/or paper over all the lubricated or waxed surfaces. This includes bearings, cables, pulleys, cargo door latches, fittings, etc.

F. Clean the Cargo Compartment

SUBTASK 25-52-00-160-001

- (1) Remove the dirt, fluids, and other loose materials from the floor, seat tracks, floor fittings, and the conveyor system equipment.

NOTE: Use a vacuum cleaner, COM-2618, broom, STD-7714, brush, STD-122, cotton wiper, G00034, mop, STD-6391 and/or sponge, G00116 to remove as much loose material as possible. Use an air source, STD-6638 to remove unwanted materials which are caught in hard to reach areas if it is necessary.

EFFECTIVITY
ARO ALL

25-52-00

D633W101-ARO

Page 703
Jul 25/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-52-00-100-002



DO NOT GET THESE MATERIALS IN YOUR MOUTH, EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM THESE MATERIALS. PUT ON A RESPIRATOR, GOGGLES, AND GLOVES WHEN YOU USE THESE MATERIALS. KEEP THESE MATERIALS AWAY FROM SPARKS, FLAME, AND HEAT. THESE MATERIALS ARE POISONOUS AND FLAMMABLE. THEY CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (2) Put on the protective gloves, G50140 and mix one of these cleaners with water as necessary.
- (a) GMC 528B cleaner, B00003
 - (b) Cee Bee 280 cleaner, B00005
 - (c) Oakite 204 cleaner, B00008
 - (d) Turco Jet Clean C cleaner, B00012
 - (e) Dubois C-1102 cleaner, B00013
 - (f) Calla 301 cleaner, B00014
 - (g) TEC Formula No. 1 cleaner, B00016
 - (h) Pace B-82 alkaline cleaner, B00017
 - (i) Turco Jet Clean E cleaner, B00325
 - (j) TEC 86-2 cleaner, B00335
 - (k) Cee Bee A-410B solvent, B00432
 - (l) Hydrex 09 solvent, B00433
 - (m) Metaclean AC solvent, B00434
 - (n) Kelite Spraywhite, B50093

SUBTASK 25-52-00-110-001

- (3) Apply the solution of alkaline cleaner and water with a mop, STD-6391, brush, STD-122, cotton wiper, G00034 and/or sponge, G00116 as necessary.
- (a) Let the solution soak for five minutes, but do not let it dry.
- NOTE: Apply more solution as necessary to keep the surfaces wet. Do not let the solution dry on the surface before you can flush the surface with clean water. The solution can cause a stain on the surface if the solution is let to dry.

SUBTASK 25-52-00-160-002

- (4) Remove all the solution and the materials loosened by the solution with the vacuum cleaner, COM-2618, cotton wiper, G00034 and /or sponge, G00116 as necessary.

SUBTASK 25-52-00-160-003

- (5) Do steps (3) and (4) again until the compartment and/or conveyor system equipment are clean.

SUBTASK 25-52-00-170-001

- (6) Flush the compartment with warm, clean water.
- NOTE: Apply the water with a mop, cloth wiper, and/or sponge, as necessary.

SUBTASK 25-52-00-160-004

- (7) Remove the water with the vacuum cleaner, COM-2618, mop, STD-6391 and/or sponge, G00116 as necessary.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-00

Page 704
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-52-00-160-005

- (8) Dry all of the surfaces clean with a cotton wiper, G00034 as necessary.

NOTE: Use compressed air to remove water which is caught in hard to reach areas.

SUBTASK 25-52-00-620-001

- (9) Do this task: Apply the Corrosion Inhibiting Compound, TASK 51-24-09-620-802.

SUBTASK 25-52-00-160-006

- (10) Permit sufficient time for the water to drain from the lower fuselage.

G. Put the Airplane in its Usual Condition

SUBTASK 25-52-00-950-002

- (1) Remove all of the masking tape, sheets and, paper that were installed.

SUBTASK 25-52-00-020-003

- (2) Install the insulation blankets that were removed. To install the blankets do this task: Insulation Blanket - Installation, TASK 25-80-00-400-801.

SUBTASK 25-52-00-410-001

- (3) Install the cargo system equipment you removed.

SUBTASK 25-52-00-910-002

- (4) Remove the static ground TASK 20-41-00-910-801 if it is not necessary.

SUBTASK 25-52-00-860-002

- (5) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-52-00-010-003

- (6) Close the door for the cargo compartment(s) that was cleaned. To close a cargo door, do the applicable tasks that follow:

- (a) Do this task: Close the Door Electrically with the External Cargo Door Control Switch, TASK 52-34-00-860-803.
- (b) Do this task: Close the Aft Small Cargo Door, TASK 52-35-00-860-806.
- (c) Do this task: Close the Door, TASK 52-36-00-860-802.

SUBTASK 25-52-00-860-004

- (7) Do this task: Remove Electrical Power, TASK 24-22-00-860-806

SUBTASK 25-52-00-010-004

- (8) Install the fuselage drain valves. To install the fuselage drain valves do this task: Drain Valve Installation, TASK 51-03-01-400-801

NOTE: Use the note you made of the locations of the drain valves. The drain valves are different lengths and must be installed in their initial locations.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-52-00

D633W101-ARO

Page 705
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

FIBERGLASS LINER - REPAIRS

1. General

- A. This procedure has instructions to repair the fiberglass liners in the lower lobe cargo compartments, which includes cargo door liner tape repairs, cargo compartment ceiling and sidewall liner tape repairs, and fiberglass liner repairs.
- B. The fiberglass liners are installed on the doors, firestops, ceilings and sidewalls, and station 1437 end wall of the cargo compartment.
- C. There are several different repair methods for the fiberglass liners in the lower lobe cargo compartments:

NOTE: It is necessary to remove the liners from the airplane for these repairs.

- (1) The use of rivets - Cherry Monel - Blind, P/N CR8M83-6-2 with a bonded fiberglass patch.
 - (2) The use of screws - Steel Sheet Metal, 0.164 inch diameter (US size Number 8) x 3/16 inch long (commercially available) with a bonded fiberglass patch.
 - (3) The use of screws - Steel Sheet Metal (US size Number 10), or 0.19 +/-0.005 CRES rivets or CRES screw, washer, and nut combination and a bonded fiberglass patch.
 - (4) The use of an approved vendor-supplied patch.
- D. Refer to this task for the damage limits: (TASK 25-52-00-210-801).
 - E. Replacement liners may be manufactured to pattern if it is necessary, using an approved liner material meeting the requirements of sheet, G02163. Replacement liners shall be of the same type/gauge as liner removed.

TASK 25-52-01-300-803

2. Cargo Door Liner Tape Repairs

A. General

- (1) This procedure has instructions to replace the loose or damaged tape on the cargo door liner.
- (2) It is important to replace the loose or damaged tape to seal the edges of the cargo door liner to prevent water damage, and also to prevent possible cuts or injuries to personnel caused by the rough edges on the cargo door liner.
- (3) This procedure uses a solvent to clean the cargo door liner before you install the new tape. A clean surface is necessary for the new tape to bond correctly to the cargo door liner. There must be sufficient air flow in the area where you use the solvents. You must not get the solvents in your mouth or eyes, or on your skin.

B. Consumable Materials

Reference	Description	Specification
B00065	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002 (Supersedes O-A-396)
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
B00130	Alcohol - Isopropyl	TT-I-735
G01043	Cloth - Lint-free	

C. Location Zones

Zone	Area
100	Lower Half of Fuselage

EFFECTIVITY
ARO ALL

25-52-01

D633W101-ARO

Page 801
Jan 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Procedure

SUBTASK 25-52-01-030-001

- (1) Remove the loose or damaged tape and discard it.

NOTE: The loose or damaged tape must not be used again. The tape will not bond correctly to the cargo door liner, if you use it again.

SUBTASK 25-52-01-110-001



DO NOT GET SOLVENTS IN YOUR MOUTH, YOUR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. SOLVENTS ARE DANGEROUS MATERIALS. SOLVENTS CAN BE FLAMMABLE. OBEY THE MATERIAL SAFETY DATA SHEETS (MSDS) FOR SOLVENTS. OBEY LOCAL REGULATIONS FOR THE CORRECT PROCEDURES TO USE OR DISCARD SOLVENTS. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (2) Use a piece of lint-free cloth, G01043, and alcohol, B00130, alcohol, B00065 or solvent, B00083 to remove any oil, grease, dirt or stain from the area to be taped on the cargo door liner.
 - (a) Make sure the area is clean and dry before you apply new tape on the cargo door liner.

————— **END OF TASK** —————

TASK 25-52-01-300-804

3. Cargo Compartment Ceiling and Sidewall Liner Tape Repairs

A. General

- (1) This procedure has instructions to replace the loose or damaged tape on the cargo ceiling and sidewall liners.
- (2) To repair the cargo door liner tape, refer to Cargo Door Liner Tape Repairs, TASK 25-52-01-300-803.
- (3) The tape is used to prevent the leakage of the fire retardant (halon gas) out of the cargo compartment. Therefore, it is important to replace the loose or damaged tape.
- (4) This procedure uses a solvent to clean the cargo liner before you install the new tape. A clean surface is necessary for the tape to bond correctly to the cargo liner. There must be sufficient air flow in the area where you use the solvents. You must not get the solvents in your mouth or eyes, or on your skin.

B. Consumable Materials

Reference	Description	Specification
B00065	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002 (Supersedes O-A-396)
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
B00130	Alcohol - Isopropyl	TT-I-735
G01043	Cloth - Lint-free	
G02361	Tape - Cargo Lining Joint Seal	BMS5-146

C. Location Zones

Zone	Area
100	Lower Half of Fuselage

EFFECTIVITY
ARO ALL

25-52-01

D633W101-ARO

Page 802
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Procedure

SUBTASK 25-52-01-030-002

- (1) Remove the loose or damaged tape and discard it.

NOTE: The loose or damaged tape must not be used again. The tape will not bond correctly to the cargo lining, if you use it again.

SUBTASK 25-52-01-350-004



DO NOT GET SOLVENTS IN YOUR MOUTH, YOUR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. SOLVENTS ARE DANGEROUS MATERIALS. SOLVENTS CAN BE FLAMMABLE. OBEY THE MATERIAL SAFETY DATA SHEETS (MSDS) FOR SOLVENTS. OBEY LOCAL REGULATIONS FOR THE CORRECT PROCEDURES TO USE OR DISCARD SOLVENTS. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (2) Use a piece of lint-free cloth, G01043, and alcohol, B00130 or alcohol, B00065 or solvent, B00083 to remove any oil, grease, dirt or stain from the area to be taped on the cargo liner.
 - (a) Make sure the area is clean and dry before you apply new tape on the cargo liner.

SUBTASK 25-52-01-350-005

- (3) Do these steps to install new tape, G02361 (BMS5-146) on the cargo liner.
 - (a) Apply the new tape, G02361 (BMS5-146) over the applicable area on the cargo liner.
 - (b) Make sure the tape, G02361 (BMS5-146) extends equally around the top of the fasteners, joints and edges on the cargo liner.
 - (c) Make sure the tape, G02361 (BMS5-146) bonds fully to the cargo liner.
 - (d) Make sure there are no bubbles under the tape, G02361 (BMS5-146).
 - (e) Make sure the tape, G02361 (BMS5-146) is flat on the surface the cargo liner.

————— **END OF TASK** —————

TASK 25-52-01-300-801

4. Fiberglass Liner Repair (Figure 801, Figure 802)

A. General

- (1) It is only necessary to use one of the methods in this procedure.
- (2) Use the applicable consumable materials that are necessary for the repair procedure you use.

B. References

Reference	Title
25-52-06-000-801	Sidewall Liner Removal (P/B 401)
25-52-06-400-801	Sidewall Liner Installation (P/B 401)
25-52-09-000-801	Ceiling Liner Removal (P/B 401)
25-52-09-400-801	Ceiling Liner - Installation (P/B 401)
25-52-18-000-801	Aft Cargo Compartment Forward End Wall Removal (P/B 401)
25-52-18-400-801	Aft Cargo Compartment Forward End Wall Installation (P/B 401)

EFFECTIVITY
ARO ALL

25-52-01

D633W101-ARO

Page 803
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
STD-551	Knife - Razor
STD-761	Scissors

D. Consumable Materials

Reference	Description	Specification
A00016	Adhesive - Pressure Sensitive Film For Interior Non-Structural Bonding	BMS5-91
B00065	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002 (Supersedes O-A-396)
B00137	Abrasive - Garnet Coated Paper	
G02163	Sheet - Fire Resistant Glass Fiber Reinforced Phenolic Laminate Cargo Liner	BMS8-223
G02361	Tape - Cargo Lining Joint Seal	BMS5-146
G51338	Cargo Liner - Glass Reinforced, Phenolic Rigid, High Impact, Fire Resistant	BMS8-223 Type 13, Class 4, Grade B
G51339	Fabric, General Purpose, Rigid, Fire Retarded, Glass Fabric Reinforced Plastic Sheeting	BMS8-2 Type 13, Class 1, Grade A
G51518	Cargo Liner - Glass Reinforced, Phenolic Rigid, High Impact, Fire Resistant	BMS8-223 Type 13, Class 2, Grade B

E. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

F. Prepare for the Repair

SUBTASK 25-52-01-480-001



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 across the cargo door opening.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-01

Page 804
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

G. Repair the Cargo Liners with a Riveted and Bonded Fiberglass Patch (Figure 801)

SUBTASK 25-52-01-020-001

- (1) Do the applicable task:
 - (a) Do this task: Sidewall Liner Removal, TASK 25-52-06-000-801.
 - (b) Do this task: Ceiling Liner Removal, TASK 25-52-09-000-801.
 - (c) Do this task: Aft Cargo Compartment Forward End Wall Removal, TASK 25-52-18-000-801.

SUBTASK 25-52-01-340-001

- (2) Make a fiberglass sheet, G02163 patch the same thickness as the liner you will repair.

NOTE: The patch must make a minimum overlap of 2.0 in. (5.08 cm) on the area that is not damaged. For example, the minimum patch dimension that is necessary for a 1.5 in. (3.81 cm) diameter hole would be 5.5 in. (13.97 cm) diameter.

SUBTASK 25-52-01-120-001

- (3) Rub the back of the fiberglass sheet, G02163 patch with 80 grit abrasive, B00137 paper.

SUBTASK 25-52-01-160-001

- (4) Use alcohol, B00065 to remove the loose particles from all surfaces.

SUBTASK 25-52-01-340-002

- (5) Apply adhesive, A00016 to the back of the fiberglass sheet, G02163 patch.

SUBTASK 25-52-01-340-003

- (6) Put the fiberglass sheet, G02163 patch over the center of the damaged area.

SUBTASK 25-52-01-340-004

- (7) Apply pressure to the fiberglass sheet, G02163 patch to make sure there is a good, continuous bond.

NOTE: The patch surface is smooth when there is a good, continuous bond.

SUBTASK 25-52-01-340-005

- (8) Put the tape around the edges of the fiberglass sheet, G02163 patch to protect the edges of the patch.

SUBTASK 25-52-01-330-001

- (9) Drill 0.2 in. (5 mm) diameter holes through the fiberglass sheet, G02163 patch and the liner at approximately 1.5 in. (3.81 cm) apart and 0.5 in. (12.70 mm) from the edges of the patch.

NOTE: Control the depth of the drill to the thickness of the patch plus the liner.

SUBTASK 25-52-01-340-006

- (10) Attach the fiberglass sheet, G02163 patch permanently with cherry monel blind rivets or equivalent heat resistant fasteners.

SUBTASK 25-52-01-420-001



SEAL THE CARGO COMPARTMENT WITH THE LINERS. IF YOU INSTALL THE LINERS INCORRECTLY, THE FIRE WILL NOT HAVE CONTAINMENT AND THE EXTINGUISHING AGENT OR SMOKE CAN GO INTO THE PASSENGER COMPARTMENT DURING A FIRE. IF YOU DO NOT OBEY THE INSTRUCTIONS IN THE SPECIFIED PROCEDURE, INJURY TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (11) Do the applicable task:

EFFECTIVITY
ARO ALL

25-52-01

D633W101-ARO

Page 805
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Do this task: Sidewall Liner Installation, TASK 25-52-06-400-801.
- (b) Do this task: Ceiling Liner - Installation, TASK 25-52-09-400-801.
- (c) Do this task: Aft Cargo Compartment Forward End Wall Installation, TASK 25-52-18-400-801.

H. Repair the Cargo Liners with Screws and a Bonded Patch

(Figure 801)

NOTE: This procedure is for BMS8-223 fiberglass patches with 2.0 in. (50.8 mm) spacing from edge or damage.

SUBTASK 25-52-01-020-002

- (1) Do the applicable task:
 - (a) Do this task: Sidewall Liner Removal, TASK 25-52-06-000-801.
 - (b) Do this task: Ceiling Liner Removal, TASK 25-52-09-000-801.
 - (c) Do this task: Aft Cargo Compartment Forward End Wall Removal, TASK 25-52-18-000-801.

SUBTASK 25-52-01-340-007

- (2) Make a fiberglass sheet, G02163 patch the same thickness as the liner you will repair.

NOTE: The patch must make a minimum overlap of 2.0 in. (5.08 cm) on the area that is not damaged. For example, the minimum patch dimension that is necessary for a 1.5 in. (3.81 cm) diameter hole would be 5.5 in. (13.97 cm) diameter.

SUBTASK 25-52-01-120-002

- (3) Rub the back of the fiberglass sheet, G02163 patch with 80 grit abrasive, B00137 paper.

SUBTASK 25-52-01-160-002

- (4) Use alcohol, B00065 to remove the loose particles from all surfaces.

SUBTASK 25-52-01-340-008

- (5) Apply adhesive, A00016 to the back of the fiberglass sheet, G02163 patch.

SUBTASK 25-52-01-340-009

- (6) Put the fiberglass sheet, G02163 patch over the center of the damaged area.

SUBTASK 25-52-01-340-010

- (7) Apply pressure to the fiberglass sheet, G02163 patch to make sure there is a good, continuous bond.

NOTE: The patch surface is smooth when there is a good, continuous bond.

SUBTASK 25-52-01-340-011

- (8) Attach the fiberglass sheet, G02163 patch permanently with screws at approximately 1.25 in. (31.8 mm) apart and 0.5 in. (12.7 mm) from the edges of the patch.

SUBTASK 25-52-01-340-012

- (9) Apply tape, G02361 (BMS5-146) to the screw heads.

NOTE: The tape on the screw heads will keep the screws from coming loose.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-01

Page 806
Sep 05/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-52-01-420-002



SEAL THE CARGO COMPARTMENT WITH THE LINERS. IF YOU INSTALL THE LINERS INCORRECTLY, THE FIRE WILL NOT HAVE CONTAINMENT AND THE EXTINGUISHING AGENT OR SMOKE CAN GO INTO THE PASSENGER COMPARTMENT DURING A FIRE. IF YOU DO NOT OBEY THE INSTRUCTIONS IN THE SPECIFIED PROCEDURE, INJURY TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (10) Do the applicable task:
 - (a) Do this task: Sidewall Liner Installation, TASK 25-52-06-400-801.
 - (b) Do this task: Ceiling Liner - Installation, TASK 25-52-09-400-801.
 - (c) Do this task: Aft Cargo Compartment Forward End Wall Installation, TASK 25-52-18-400-801.

I. Repair the Cargo Liners with Screws and a Bonded Patch

(Figure 802)

NOTE: This procedure is for BMS8-223 Type 13, Class 4, Grade B or BMS8-2 Type 13, Class 1, Grade A or BMS8-223 Type 13, Class 2, Grade B fiberglass patches with 1.5 in. (38.1 mm) spacing from edge or damage.

SUBTASK 25-52-01-020-004

- (1) Do the applicable task:
 - (a) Do this task: Sidewall Liner Removal, TASK 25-52-06-000-801.
 - (b) Do this task: Ceiling Liner Removal, TASK 25-52-09-000-801.
 - (c) Do this task: Aft Cargo Compartment Forward End Wall Removal, TASK 25-52-18-000-801.

SUBTASK 25-52-01-340-022

- (2) Cut a repair patch from the fiberglass fabric, G51338 or fabric, G51339 or fabric, G51518 material. Dimension the patch to keep a minimum of 1.5 in. (38.1 mm) of overlap with the area that is not damaged. Use a razor knife, STD-551 or scissors, STD-761 if it is necessary.

NOTE: You can cover a smaller patch with a larger patch, if the smaller patch is fully covered. No other type of partial overlap (for example shingling of patches) is permitted.

SUBTASK 25-52-01-120-005

- (3) Rub the back of the fiberglass fabric, G51338 or fabric, G51339 or fabric, G51518 patch with 80 grit abrasive, B00137 paper.
- (4) Use alcohol, B00065 to remove the loose particles from all surfaces.

SUBTASK 25-52-01-340-023

- (5) Apply adhesive, A00016 to the back of the fiberglass fabric, G51338 or fabric, G51339 or fabric, G51518 patch.

SUBTASK 25-52-01-340-024

- (6) Put the fiberglass fabric, G51338 or fabric, G51339 or fabric, G51518 patch over the center of the damaged area. Apply pressure to the fiberglass fabric, G51338 or fabric, G51339 or fabric, G51518 patch to make sure there is a good, continuous bond.

NOTE: The patch surface is smooth when there is a good, continuous bond.

EFFECTIVITY
ARO ALL

25-52-01

D633W101-ARO

Page 807
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-52-01-330-002



CAUTION

DO NOT CAUSE DAMAGE TO THE COMPONENTS BEHIND THE LINING. THE DRILL BIT OR FASTENERS CAN MAKE HOLES IN THE WIRE BUNDLES, STRUCTURE, TUBING, AND OTHER ITEMS.

- (7) Drill 0.125 in. (3.175 mm) diameter holes through the patch and lining for the sheet metal screws, or as appropriate for the metallic fastener types.
 - (a) The maximum distance between fasteners is 2.0 in. (50.8 mm).
 - (b) The minimum distance from the centers of holes to the edges of the patch is 0.75 in. (19.05 mm).
- (8) Install size #10 or larger steel sheet metal screws through the patch and lining. As an option, you may install 0.19 +/- .005 CRES rivets or CRES screw, washer, and nut combination.
- (9) Apply tape, G02361 (BMS5-146) on the edges of the patch and on the fasteners used for the repair.

SUBTASK 25-52-01-420-003



WARNING

SEAL THE CARGO COMPARTMENT WITH THE LINING. OBEY THE INSTRUCTIONS IN THE SPECIFIED PROCEDURE WHEN YOU INSTALL THE LINING. IF YOU INSTALL THE LINING INCORRECTLY, THE SMOKE CAN GET INTO THE PASSENGER COMPARTMENT DURING A FIRE.

- (10) If the liner was fully or partially removed, reinstall using the applicable task:
 - (a) Do this task: Sidewall Liner Installation, TASK 25-52-06-400-801.
 - (b) Do this task: Ceiling Liner - Installation, TASK 25-52-09-400-801.
 - (c) Do this task: Aft Cargo Compartment Forward End Wall Installation, TASK 25-52-18-400-801.

J. Repair Rigid Lining with a Vendor-Supplied Patch

SUBTASK 25-52-01-350-006

- (1) You can repair the rigid linings with an FAA (or regulatory agency) approved, vendor-supplied repair kit for rigid linings. Follow the approved instructions and repair limits in the kit.

SUBTASK 25-52-01-350-007

- (2) These vendors may be able to supply repair patches for the repair of rigid cargo linings:
 - (a) Permaglass 100 Series Patch
Permal Gloucester Limited
Bristol Road
Gloucester GL1 5TT
United Kingdom
PHONE: +44 (0) 1452 528282
FAX: +44 (0) 1452 507409
WEBSITE: <http://www.permali.co.uk>
 - (b) AF800-series Speed Patch
Akro Fireguard
9001 Rosehill Rd
Lenexa, KS 66215

EFFECTIVITY
ARO ALL

25-52-01

D633W101-ARO

Page 808
Sep 05/2018



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

USA

PHONE: +1 913-888-7172

FAX: +1 913-888-7372

EMAIL: sales@arkrofire.com

WEBSITE: <http://www.akrofire.com>

(c) Gillpatch Series

M.C. Gill Corporation

4056 Easy Street

El Monte, CA 91731

USA

PHONE: +1 626-443-4022

FAX: +1 626-350-5880

EMAIL: info@mcgillcorp.com

WEBSITE: <http://www.mcgillcorp.com>

(d) Pionite products

Pionite Decorative Surfaces

One Pionite Road

Auburn, ME 04210

USA

PHONE: +1 800-746-6483

WEBSITE: <http://www.pionite.com>

K. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-01-080-001

- (1) Remove the large cargo door safety barrier, SPL-1988.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

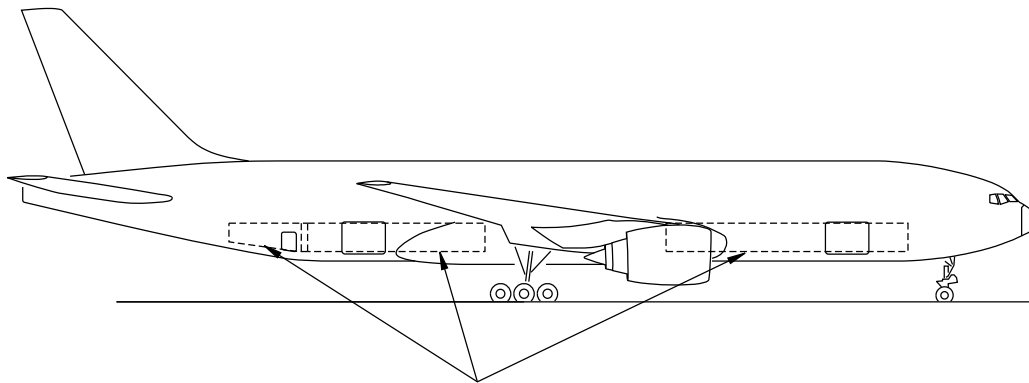
D633W101-ARO

25-52-01

Page 809
Sep 05/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL

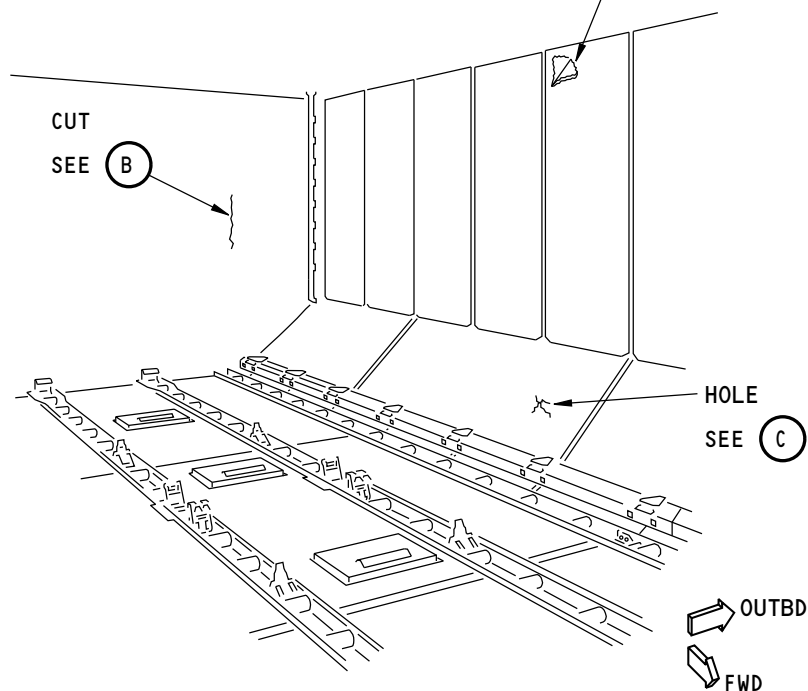


FIBERGLASS LINER
(CARGO COMPARTMENT)

SEE (A)

L-SHAPE TEAR

SEE (D)



FIBERGLASS LINER

(A)

C54374 S0006410644_V1

Fiberglass Liner Repair
Figure 801/25-52-01-990-801 (Sheet 1 of 2)

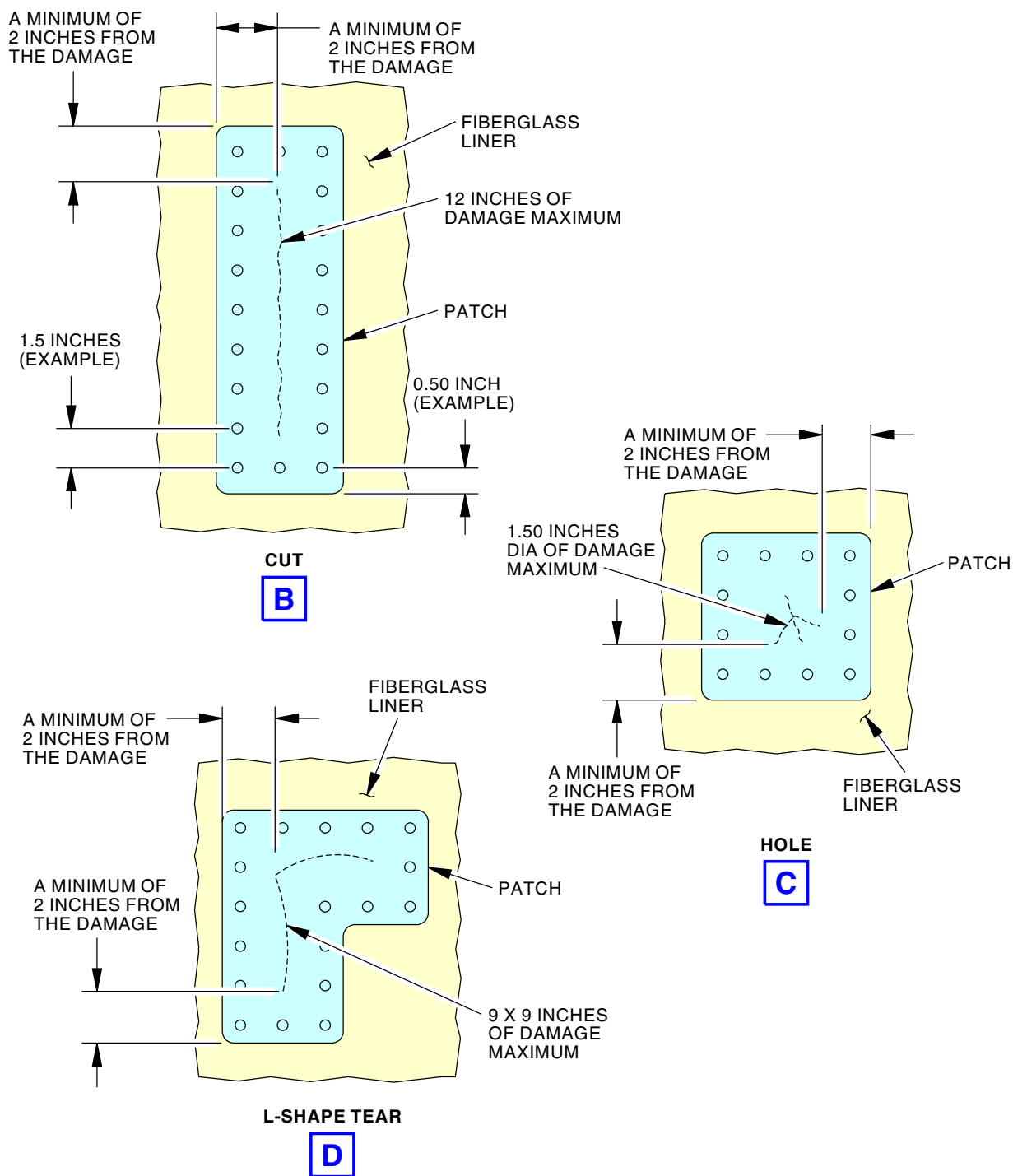
EFFECTIVITY
ARO ALL

25-52-01

D633W101-ARO

Page 810
Jan 05/2016

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



C58013 S0006410645_V2

**Fiberglass Liner Repair
Figure 801/25-52-01-990-801 (Sheet 2 of 2)**

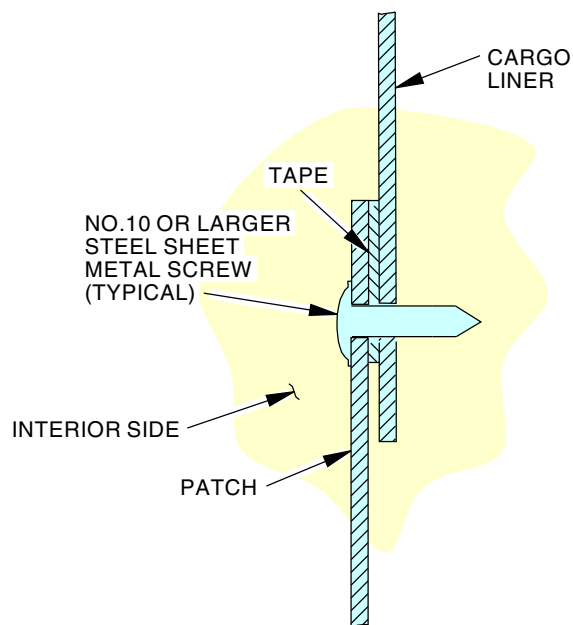
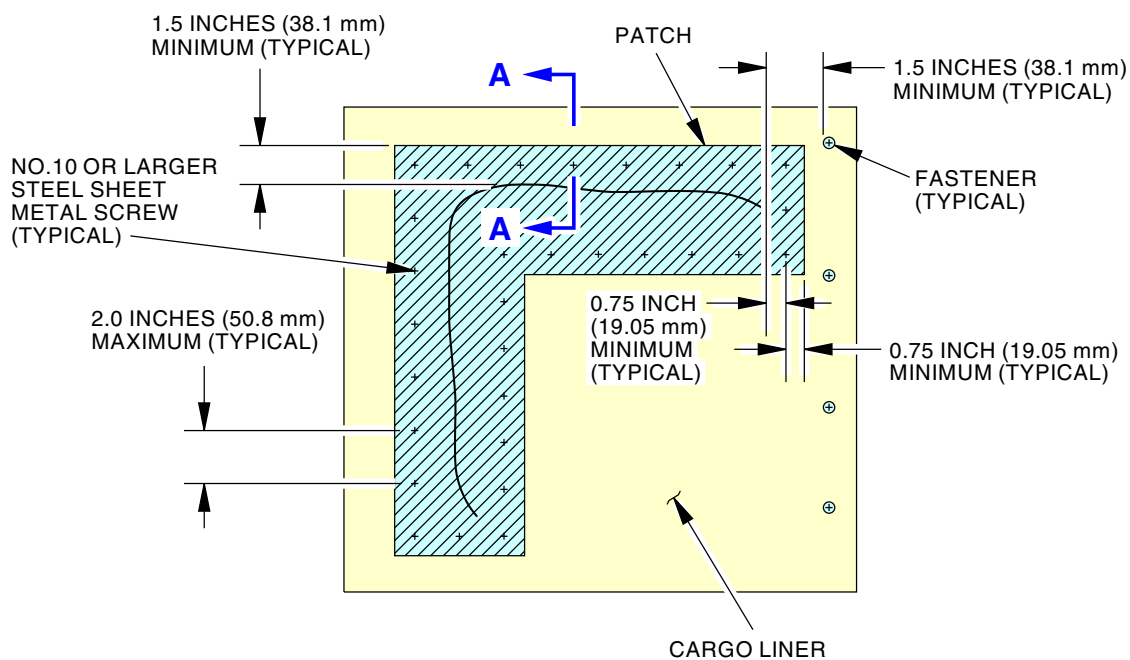
EFFECTIVITY
ARO ALL

25-52-01

D633W101-ARO

Page 811
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



**RIGID CARGO LINING
MECHANICAL FASTENER REPAIR**

A-A

2457471 S0000572006_V2

**Rigid Cargo Lining Mechanical Fastener Repair
Figure 802/25-52-01-990-802 (Sheet 1 of 2)**

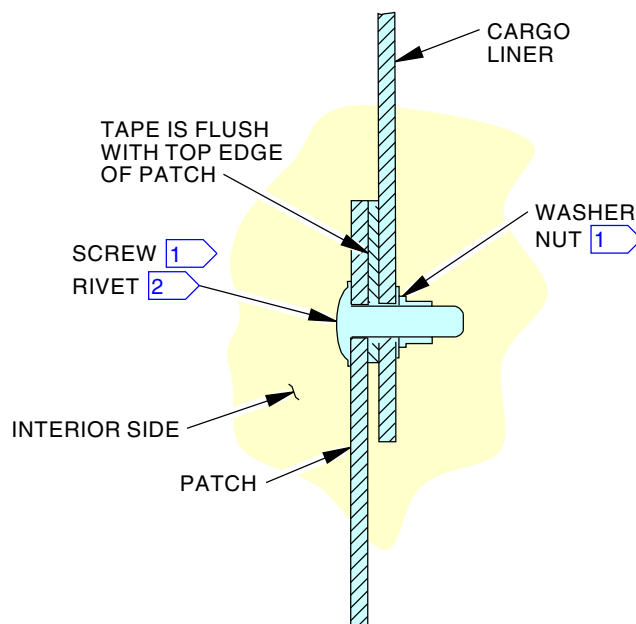
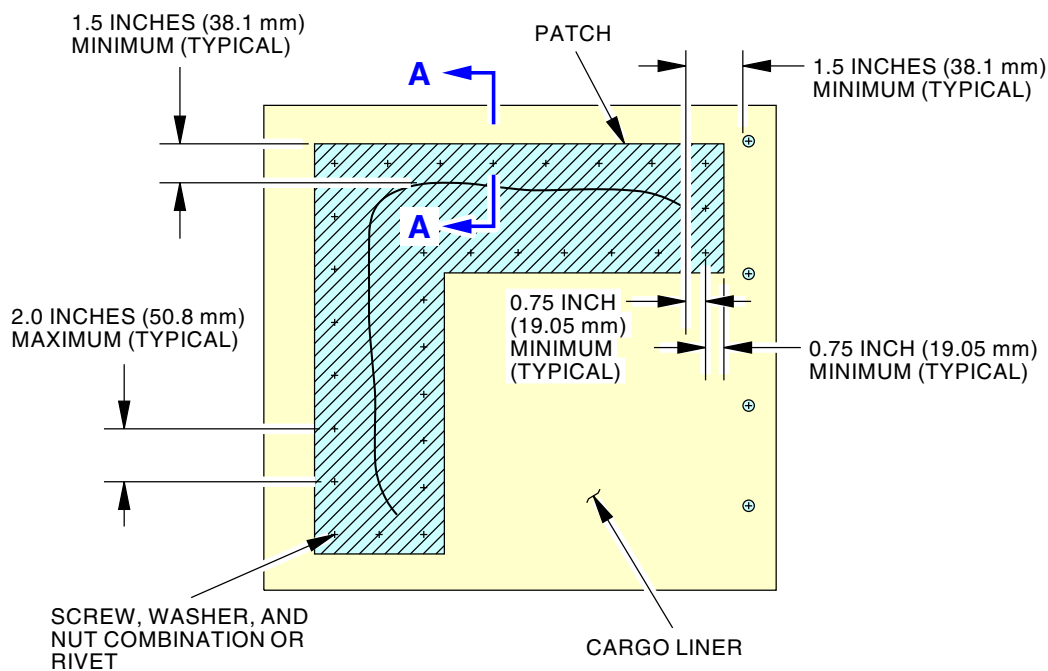
EFFECTIVITY
ARO ALL

25-52-01

D633W101-ARO

Page 812
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



- 1 .19 +/- .005 CRES SCREW,
WASHER, AND NUT
- 2 .19 +/- .005 CRES RIVET

RIGID CARGO LINING MECHANICAL FASTENER REPAIR A-A

2457472 S0000572007_V2

Rigid Cargo Lining Mechanical Fastener Repair
Figure 802/25-52-01-990-802 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

25-52-01

D633W101-ARO

Page 813
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

NEOPRENE-COATED LINER - REPAIRS

1. General

- A. This procedure give instructions to repair the neoprene-coated fiberglass liners in the lower lobe cargo compartments.
- B. This procedure is applicable for these neoprene-coated fiberglass liners:
 - (1) Forward cargo compartment aft end wall
 - (2) Containment barriers.
- C. Refer to this task for cargo liner damage limits: TASK 25-52-00-210-801.
- D. Replacement liners may be manufactured to pattern if it is necessary, using an approved liner material meeting the requirements of BMS8-343. Replacement liners shall be of the same type as liner removed, and must be manufactured per the same drawing or an acceptable replacement drawing as the liner removed to include, but not limited to, stitching, edge seals, grommets, etc.

TASK 25-52-02-340-801

2. Neoprene-Coated Liner Repair

(Figure 801)

A. General

- (1) This task is for the repair of the neoprene-coated fiberglass liners. There are four repair methods. It is only necessary to use one of the methods.
- (2) Use these fasteners for the first method of repair:
 - (a) Bolts, NAS603-5P
 - (b) Washers, AN960JD10L
 - (c) Nuts, MS21042L3

B. References

Reference	Title
25-52-06-000-801	Sidewall Liner Removal (P/B 401)
25-52-06-400-801	Sidewall Liner Installation (P/B 401)
25-52-17-000-801	Forward Cargo Compartment Aft End Wall Removal (P/B 401)
25-52-17-400-801	Forward Cargo Compartment Aft End Wall Installation (P/B 401)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363

D. Consumable Materials

Reference	Description	Specification
A00016	Adhesive - Pressure Sensitive Film For Interior Non-Structural Bonding	BMS5-91
A50144	Adhesive - Neoprene (Fire Retardant)	BMS5-7 Type II

EFFECTIVITY
ARO ALL

25-52-02

D633W101-ARO

Page 801
Jan 05/2016

777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description	Specification
B00065	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002 (Supersedes O-A-396)
G01498	Thread - Fiberglass - 11002 BC18 Glass Lube	BAC5437
G02163	Sheet - Fire Resistant Glass Fiber Reinforced Phenolic Laminate Cargo Liner	BMS8-223
G02361	Tape - Cargo Lining Joint Seal	BMS5-146
G50018	Fabric - Polymer Coated, Flame Resistant, Flexible Cargo Liner	BMS8-343 Type I
G50592	Fabric - Polymer Coated, Flame Resistant, Flexible Cargo Liner	BMS8-343 Type III
G51121	Fabric - Polymer Coated, Flame Resistant, Flexible Cargo Liner	BMS8-343 Type II

E. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

F. Prepare for the Repair

SUBTASK 25-52-02-480-001



WARNING INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 across the cargo door opening.

SUBTASK 25-52-02-210-001

- (2) Do a visual check to make sure the liner fasteners do not touch any adjacent systems behind the liners and that the liners do not sag.
 - (a) If the liner fasteners touch any adjacent system behind the liner or if the liner sags, do the applicable step to replace the liner:
 - 1) These are the tasks:
Sidewall Liner Removal, TASK 25-52-06-000-801,
Sidewall Liner Installation, TASK 25-52-06-400-801.
 - 2) These are the tasks:
Forward Cargo Compartment Aft End Wall Removal, TASK 25-52-17-000-801,
Forward Cargo Compartment Aft End Wall Installation, TASK 25-52-17-400-801.
- (3) Measure the distance between the damaged area and all fasteners and other repairs that are near.

EFFECTIVITY
ARO ALL

25-52-02

D633W101-ARO

Page 802
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) If the damaged area is less than 2.0 in. (50.8 mm) away from a fastener or other damage, you cannot repair the lining. You must replace the lining.

NOTE: For repair of the neoprene-coated liners with BMS8–223 patch and mechanical fasteners, or repair of the neoprene-coated liners with BMS8–343 patch and fiberglass thread only.

- (b) If the damage area is less than 1.5 in. (38.1 mm) away from a fastener or other damage, you cannot repair the lining. You must replace the lining.

NOTE: For repair of the neoprene-coated liners with BMS8–343 patch and mechanical fasteners only.

G. Repair of the Neoprene-Coated Liners with Mechanical Fasteners

(Figure 801)

NOTE: This procedure is for a BMS8–223 patch on neoprene-coated liners.

SUBTASK 25-52-02-020-001

- (1) Remove the fasteners that attach the liner to the structure.

SUBTASK 25-52-02-020-002

- (2) Do the applicable task:

- (a) Do this task: Sidewall Liner Removal, TASK 25-52-06-000-801.
(b) Do this task: Forward Cargo Compartment Aft End Wall Removal, TASK 25-52-17-000-801.

SUBTASK 25-52-02-340-001

- (3) Make two fiberglass sheet, G02163 patches.

NOTE: The patch must make a minimum of a 2-inch overlap on the area that is not damaged. For example, the patch dimension that is necessary for a 1.5-inch diameter hole would be a 5.5-inch diameter.

SUBTASK 25-52-02-110-001

- (4) Clean all of the surfaces with alcohol, B00065 to remove the loose particles.

SUBTASK 25-52-02-340-002

- (5) Apply adhesive, A00016 or adhesive, A50144 to the back of the fiberglass sheet, G02163 patches.

SUBTASK 25-52-02-340-003

- (6) Put the fiberglass sheet, G02163 patches over the center of the damaged area on the front and the back of the liner.

SUBTASK 25-52-02-340-004

- (7) Apply pressure to the fiberglass sheet, G02163 patches to make sure there is a good, continuous bond.

NOTE: The patch has a smooth surface when there is a good, continuous bond.

SUBTASK 25-52-02-340-005

- (8) Do the steps that follow to permanently attach the fiberglass sheet, G02163 patches:
- (a) Install the bolts, NAS603-5P or equivalent, washers, AN960JD10L, and nuts, MS21042L3, at a maximum of 2 inches apart and 0.5 inch from the edges of the fiberglass sheet, G02163 patches.
- (b) Make sure there is sufficient clearance between the bolts and the adjacent systems behind the liner.
- (c) Grind or cut the ends of the bolts smooth with the nuts to get sufficient clearance.

EFFECTIVITY
ARO ALL

25-52-02

D633W101-ARO

Page 803
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-52-02-420-001



SEAL THE CARGO COMPARTMENT WITH THE LINERS. OBEY THE INSTRUCTIONS IN THE SPECIFIED PROCEDURE WHEN YOU INSTALL THE LINERS. IF YOU INSTALL THE LINERS INCORRECTLY, THE FIRE WILL NOT BE CONTAINED AND THE EXTINGUISHING AGENT OR SMOKE CAN GET INTO THE PASSENGER COMPARTMENT DURING A FIRE.

- (9) Do the applicable task:
 - (a) Do this task: Sidewall Liner Installation, TASK 25-52-06-400-801.
 - (b) Do this task: Forward Cargo Compartment Aft End Wall Installation, TASK 25-52-17-400-801.

SUBTASK 25-52-02-960-001

- (10) Replace the damaged liner if sufficient clearance is still not obtained.

H. Repair of the Neoprene-Coated Liners with Fiberglass Thread

NOTE: This procedure is for a BMS8-343 Type I, or Type III patch on neoprene-coated liners.

SUBTASK 25-52-02-020-003

- (1) Remove the fasteners that attach the liner to the structure.

SUBTASK 25-52-02-020-004

- (2) Do the applicable task:
 - (a) Do this task: Sidewall Liner Removal, TASK 25-52-06-000-801.
 - (b) Do this task: Forward Cargo Compartment Aft End Wall Removal, TASK 25-52-17-000-801.

SUBTASK 25-52-02-340-006

- (3) Make a fiberglass cargo liner, G50018 or cargo liner, G50592 patch.

NOTE: The patch must make a minimum of a 2-inch overlap on the area that is not damaged. For example, the patch dimension that is necessary for a 1.5-inch diameter hole would be a 5.5-inch diameter.

SUBTASK 25-52-02-110-002

- (4) Clean all of the surfaces using alcohol, B00065 to remove the loose particles.

SUBTASK 25-52-02-340-007

- (5) Apply adhesive, A00016 or adhesive, A50144 to the back of the fiberglass cargo liner, G50018 or cargo liner, G50592 patch.

SUBTASK 25-52-02-340-008

- (6) Put the fiberglass cargo liner, G50018 or cargo liner, G50592 patch over the center of the damaged area on the front of the liner.

SUBTASK 25-52-02-340-009

- (7) Apply pressure to the fiberglass cargo liner, G50018 or cargo liner, G50592 patch to make sure there is a good, continuous bond.

NOTE: The patch has a smooth surface when there is a good, continuous bond.

SUBTASK 25-52-02-340-010

- (8) Use Lubricated Thread, G01498 to stitch two lines around the edge of the fiberglass cargo liner, G50018 or cargo liner, G50592 patch.

NOTE: There must be approximately seven stitches in each inch of material. Also, the stitches must be 1/8 to 1/2 inch from the edge of the patch.

EFFECTIVITY
ARO ALL

25-52-02

D633W101-ARO

Page 804
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-52-02-420-002



SEAL THE CARGO COMPARTMENT WITH THE LINERS. OBEY THE INSTRUCTIONS IN THE SPECIFIED PROCEDURE WHEN YOU INSTALL THE LINERS. IF YOU INSTALL THE LINERS INCORRECTLY, THE FIRE WILL NOT BE CONTAINED AND THE EXTINGUISHING AGENT OR SMOKE CAN GET INTO THE PASSENGER COMPARTMENT DURING A FIRE.

- (9) Do the applicable task:
- (a) Do this task: Sidewall Liner Installation, TASK 25-52-06-400-801.
 - (b) Do this task: Forward Cargo Compartment Aft End Wall Installation, TASK 25-52-17-400-801.

I. Repair of the Neoprene-Coated Liners with Mechanical Fasteners

(Figure 802)

NOTE: This procedure is for a BMS8-343 Type I, Type II, or Type III patch on neoprene-coated liners.

SUBTASK 25-52-02-110-003

- (1) Clean the inboard side of the damaged area with alcohol, B00065, or equivalent cleaning agent.

SUBTASK 25-52-02-340-012

- (2) Cut a repair patch from the same type of material as the lining. Dimension the patch to keep a minimum of 1.5 in. (38 mm) of overlap with the area that is not damaged.
- (a) Use cargo liner, G50018 or cargo liner, G50592 to repair damaged Type I liners, and cargo liner, G51121 to repair damaged Type II liners.

NOTE: You can cover a smaller patch with a larger patch, if the smaller patch is fully covered. No other type of patch overlap (for example, shingling) is permitted.

- (3) Apply adhesive, A00016 to the inboard side of the lining, around the center of the damage.
- (4) Install the repair patch on the inboard side of the damaged lining.

SUBTASK 25-52-02-320-001

- (5) Drill 3/16 in. (4.8 mm) diameter holes through the patch and the lining for the fasteners. You must use #10 or larger steel bolts, washer and nut, or use #10 or larger steel rivets with backup washers to do this repair. The use of sheet metal screws is not acceptable for soft liner repairs.
- (a) The maximum distance between fasteners is 2.0 in. (51 mm).
 - (b) The minimum distance from the centers of holes to the edge of the patch is 0.75 in. (19 mm).
 - (c) The minimum distance from the centers of holes to the edge of the damaged area is 0.75 in. (19 mm).

SUBTASK 25-52-02-410-001

- (6) Install the fasteners through the fastener holes.

SUBTASK 25-52-02-410-002

- (7) Install tape, G02361 on the edges of the patch and on the fasteners used for the repair.

J. Vendor-Supplied Patch Repair for Flexible Linings

NOTE: These repairs apply to cargo liner, G50018 Type I linings only. Use the Mechanical Fastener Repair for Flexible Linings when repairing cargo liner, G51121 Type II linings.

EFFECTIVITY
ARO ALL

25-52-02

D633W101-ARO

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Page 805
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-52-02-350-001

- (1) You can repair the flexible cargo linings with an FAA (or regulatory agency) approved, vendor-supplied repair kit for flexible linings. Follow the approved instructions and repair limits in the kit.

SUBTASK 25-52-02-350-002

- (2) These vendors may be able to supply repair patches for the repair of flexible cargo linings:

- (a) Permaglass 300 Series Patch
Permal Gloucester Limited
Bristol Road Gloucester GL1 5TT
United Kingdom
PHONE: +44 (0) 1452 528282
FAX: +44 (0) 1452 507409
WEBSITE: <http://www.permali.co.uk>
- (b) AF450 Speed Patch
Akro Fireguard
9001 Rosehill Rd
Lenexa, KS 66215
USA
PHONE: +1 913-888-7172
FAX: +1 913-888-7372
EMAIL: sales@akrofire.com
WEBSITE: <http://www.akrofire.com>
- (c) Gillpatch Series
M.C. Gill Corporation
4056 Easy Street
El Monte, CA 91731
USA
PHONE: +1 626-443-4022
FAX: +1 626-350-5880
EMAIL: info@mcgillcorp.com
WEBSITE: <http://www.mcgillcorp.com>
- (d) Pionite products
Pionite Decorative Surfaces
One Pionite Road
Auburn, ME 04210
USA
PHONE: +1 800-746-6483
WEBSITE: <http://www.pionite.com>

EFFECTIVITY
ARO ALL

25-52-02

D633W101-ARO

Page 806
Jan 05/2016



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

K. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-02-080-001

- (1) Remove the large cargo door safety barrier, SPL-1988.

———— **END OF TASK** ————

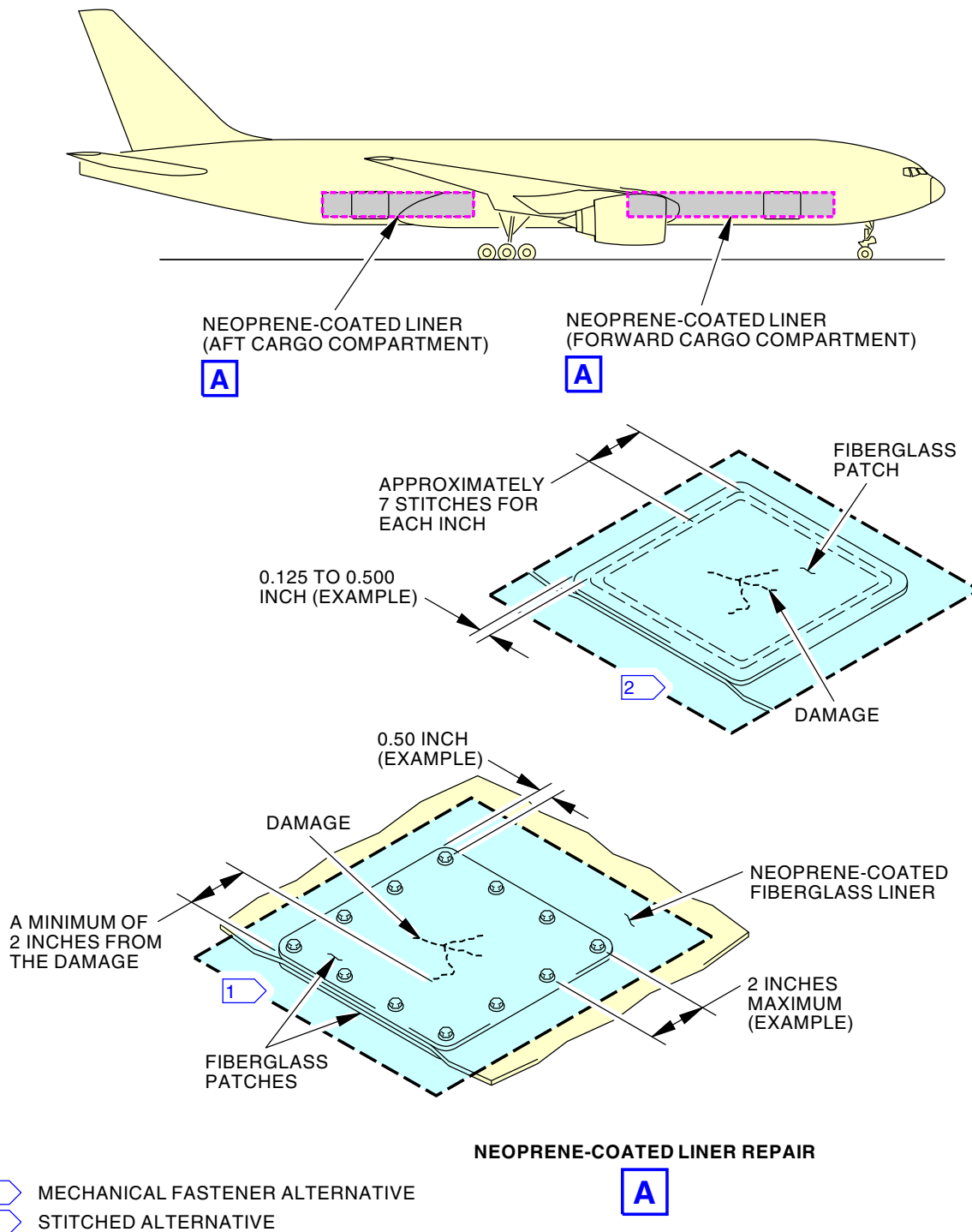
EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-02

Page 807
Jan 05/2016

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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Neoprene-Coated Liner Repair
Figure 801/25-52-02-990-801

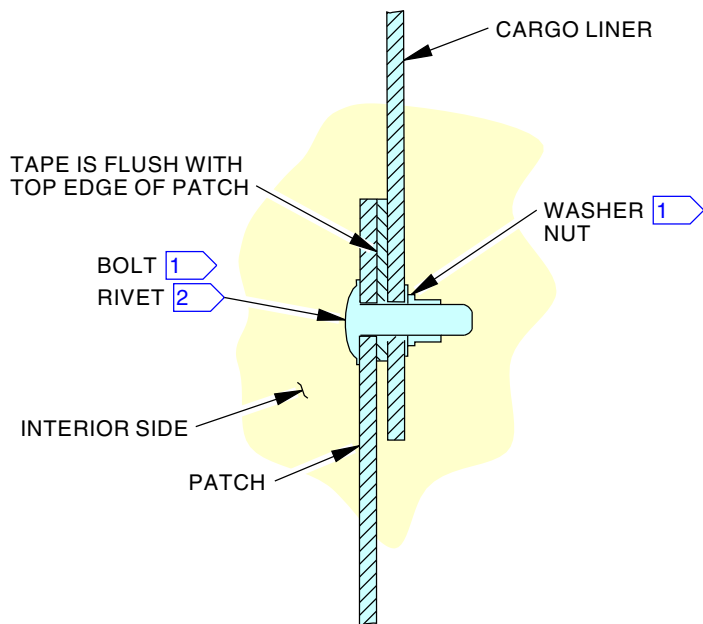
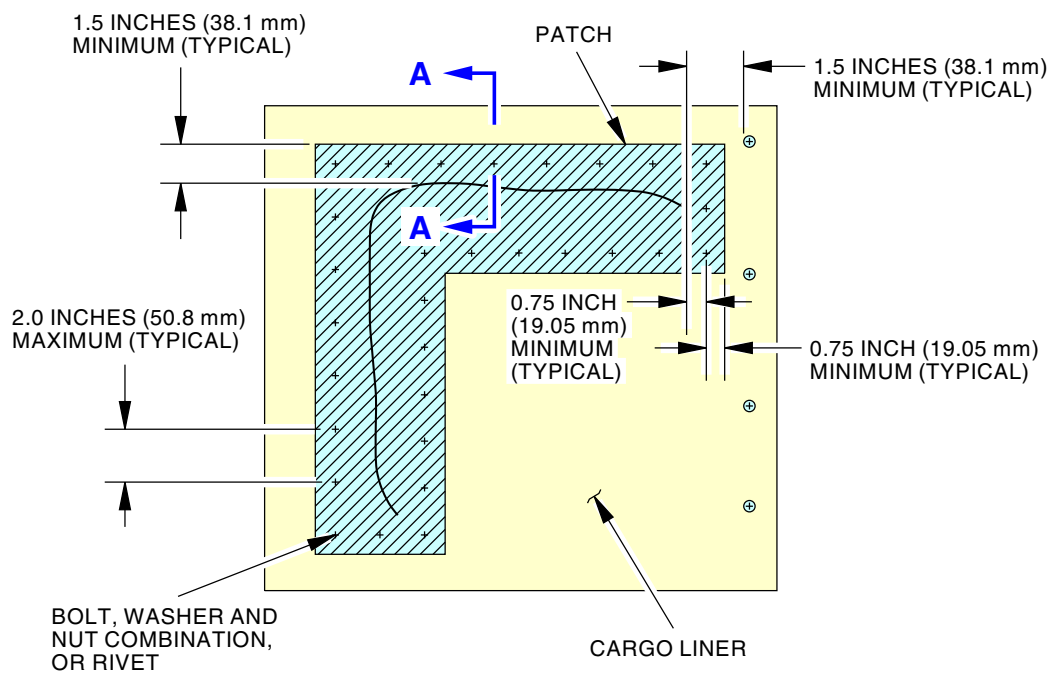
EFFECTIVITY
ARO ALL

25-52-02

D633W101-ARO

Page 808
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



NEOPRENE-COATED LINER REPAIR WITH MECHANICAL FASTENERS

A-A

- 1 .19 +/- .005 BOLT WITH WASHER AND NUT
- 2 .19 +/- .005 RIVET

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Neoprene-Coated Liner Repair with Mechanical Fasteners
Figure 802/25-52-02-990-802

EFFECTIVITY
ARO ALL

25-52-02

D633W101-ARO

Page 809
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

BULK CARGO COMPARTMENT CARGO NET - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) The removal of the bulk cargo compartment cargo net.
- (2) The installation of the bulk cargo compartment cargo net

TASK 25-52-03-000-801

2. Bulk Cargo Compartment Cargo Net - Removal

A. References

Reference	Title
52-36-00-860-801	Open the Door (P/B 201)

B. Location Zones

Zone	Area
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

C. Remove the Cargo Net

SUBTASK 25-52-03-860-001

- (1) Open the bulk cargo compartment door(Open the Door, TASK 52-36-00-860-801)

SUBTASK 25-52-03-020-001

- (2) Loosen the net strap buckles to release the tension in the net straps.

SUBTASK 25-52-03-020-002

- (3) Disconnect the snap latches from the nets which attach to each other.

SUBTASK 25-52-03-020-003

- (4) Disconnect the tiedown fittings from the anchor plates at the bottom of the net.

SUBTASK 25-52-03-020-004

- (5) Disconnect the tiedown fittings from the anchor plates in the ceiling.

SUBTASK 25-52-03-020-005

- (6) Remove the net.

————— **END OF TASK** —————

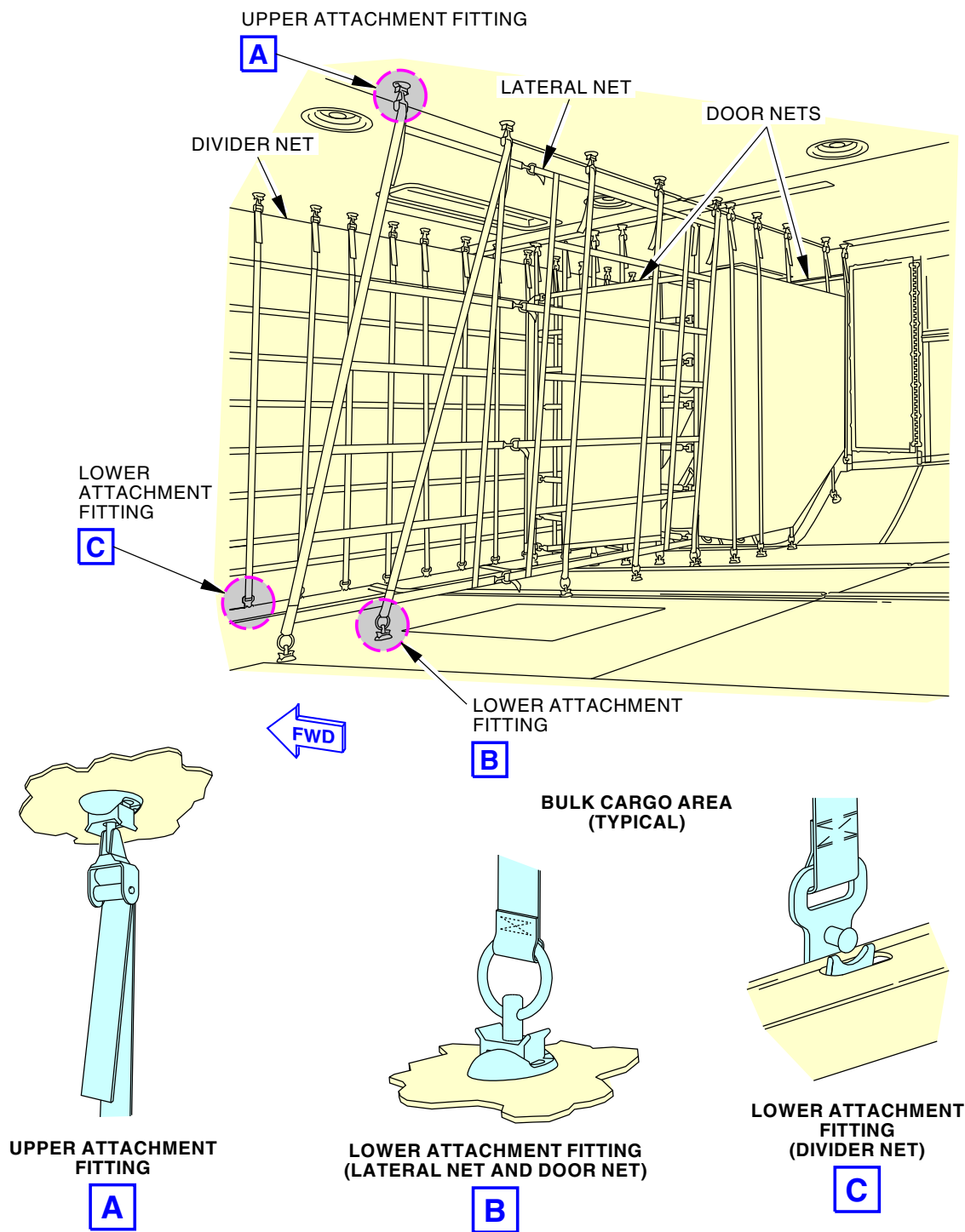
EFFECTIVITY
ARO ALL

25-52-03

D633W101-ARO

Page 401
Jan 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Bulk Cargo Compartment Cargo Nets
Figure 401/25-52-03-990-801**

EFFECTIVITY
ARO ALL

25-52-03

D633W101-ARO

Page 402
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-52-03-400-801

3. Bulk Cargo Compartment Cargo Net - Installation

A. References

Reference	Title
52-36-00-860-802	Close the Door (P/B 201)

B. Location Zones

Zone	Area
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

C. Install the Bulk Cargo Compartment Cargo Net

SUBTASK 25-52-03-420-001

- (1) Connect the tiedown fittings to the anchor plates in the ceiling.

SUBTASK 25-52-03-420-002

- (2) Connect the net straps to the fittings in the floor.

SUBTASK 25-52-03-420-003

- (3) Tighten the net straps to increase tension in the net straps.

SUBTASK 25-52-03-860-002

- (4) Close the bulk cargo compartment door (Close the Door, TASK 52-36-00-860-802)

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-03

Page 403
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

HONEYCOMB PANEL - REPAIRS

1. General

A. This procedure is for honeycomb panels in the cargo compartments only.

TASK 25-52-04-300-801

2. Honeycomb Panel Repair

(Figure 801)

A. General

- (1) This task gives instructions to repair the honeycomb panels in the cargo compartments. This task is applicable to the honeycomb panels installed in the cargo compartments that follow:
 - (a) The forward containerized cargo compartment
 - (b) The aft containerized cargo compartment
 - (c) The bulk cargo compartment
- (2) Use this procedure in these conditions:
 - (a) If the panel's core is damaged, or
 - (b) If the inboard and outboard skins are damaged, or
 - (c) If the outboard skin is not damaged, but the inboard skin damage is less than 5 in. (13 cm) from the edge of the panel.
 - (d) You do not have to repair the panel if the outboard skin is not damaged and the inboard skin damage is more than 5 in. (13 cm) away from the panel edge. A repair with compound, A01018, for small damages to the inboard skin is permitted, but it is not necessary.
- (3) You must use fabric, G51338 or fabric, G51339 or fabric, G51518.
- (4) There are two alternatives for the repair of honeycomb panels. It is only necessary to use one of the repairs that follow:
 - (a) Mechanical Fastener Repair for Honeycomb Panels.
 - (b) Vendor-Supplied Patch Repair for Honeycomb Panels.

B. References

Reference	Title
25-52-06-000-801	Sidewall Liner Removal (P/B 401)
25-52-06-400-801	Sidewall Liner Installation (P/B 401)
25-52-09-000-801	Ceiling Liner Removal (P/B 401)
25-52-09-400-801	Ceiling Liner - Installation (P/B 401)
25-52-18-000-801	Aft Cargo Compartment Forward End Wall Removal (P/B 401)
25-52-18-400-801	Aft Cargo Compartment Forward End Wall Installation (P/B 401)

C. Tools/Equipment

Reference	Description
STD-551	Knife - Razor
STD-761	Scissors

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-04

Page 801
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Consumable Materials

Reference	Description	Specification
A00016	Adhesive - Pressure Sensitive Film For Interior Non-Structural Bonding	BMS5-91
A01018	Compound - Honeycomb Edge Filling & Potting	BMS5-28 Type 28
A50042	Compound - Honeycomb Edge Filling & Potting, Epoxy Based, 2 Part, RT Cure (20-40 Min Gel)	BMS5-28 Type 19
A50145	Resin - Self-Extinguishing Laminating - Epocast 50-A1 with Epocast 946	BMS8-201 Type IV (Short work life)
B00065	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002 (Supersedes O-A-396)
B00102	Abrasive - Aluminum Oxide Coated Cloth	
B01027	Solvent - Butyl Carbitol (Dow Chemical - E-Series Glycol Ethers)	
D00147	Compound - Interior Surface Filling, Polyester Resin	BMS5-136
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00077	Foam - Flame Retardant Rigid Urethane	BMS8-133
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G00278	Core Material - Nonmetallic Honeycomb Core	BMS8-124
G00288	Material - Release Sheet	BMS15-3
G00316	Fabric - Woven Glass Reinforcements For Laminating Plastics	BMS9-3
G00335	Fiber - Carbon Fiber Reinforcements, Yarn And Fabric	BMS9-8
G02361	Tape - Cargo Lining Joint Seal	BMS5-146
G51338	Cargo Liner - Glass Reinforced, Phenolic Rigid, High Impact, Fire Resistant	BMS8-223 Type 13, Class 4, Grade B
G51339	Fabric, General Purpose, Rigid, Fire Retarded, Glass Fabric Reinforced Plastic Sheeting	BMS8-2 Type 13, Class 1, Grade A
G51518	Cargo Liner - Glass Reinforced, Phenolic Rigid, High Impact, Fire Resistant	BMS8-223 Type 13, Class 2, Grade B

E. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-04

Page 802
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

F. Prepare for the Repair

SUBTASK 25-52-04-210-001

- (1) Find the shape and dimensions of the damaged area. If the damage is not within all of the limits that follow, you cannot repair the lining. You must replace the lining.
 - (a) The damaged area must be less than or equal to 100 in² (645 cm²).
 - (b) The damage area must be a minimum of 1.5 in. (3.8 cm) away from all edge fasteners.
 - (c) If the honeycomb core is damaged, the damage must be within these additional limits:
 - 1) The damage must be a minimum of 8 fastener diameters from the center of all fastener holes.
 - 2) The damage must be a minimum of 4 in. (10 cm) from any cutout.

SUBTASK 25-52-04-010-001

- (2) Remove the damaged lining. Do the applicable task:
 - (a) For lower lobe cargo compartment: Sidewall Liner Removal, TASK 25-52-06-000-801.
 - (b) For the bulk cargo compartment: Ceiling Liner Removal, TASK 25-52-09-000-801.
 - (c) For the aft cargo compartment: Aft Cargo Compartment Forward End Wall Removal, TASK 25-52-18-000-801.

G. Mechanical Fastener Repair for Honeycomb Panels

SUBTASK 25-52-04-110-001

- (1) Clean the inboard side of the damaged area with alcohol, B00065 (or an equivalent cleaning agent).

SUBTASK 25-52-04-340-001

- (2) Cut a repair patch from fabric, G51338 or fabric, G51339 or fabric, G51518. Dimension the patch to keep a minimum 1.5 in. (3.8 cm) of overlap with the area that is not damaged. Use a razor knife, STD-551, or scissors, STD-761, if it is necessary.

SUBTASK 25-52-04-340-002

- (3) Install the repair patch on the inboard side of the damaged panel. Use adhesive, A00016 if needed as an assembly aid.

SUBTASK 25-52-04-320-001



DO NOT CAUSE DAMAGE TO THE COMPONENTS BEHIND THE LINING. THE DRILL BIT OR FASTENERS CAN MAKE HOLES IN THE WIRE BUNDLES, STRUCTURE, TUBING, AND OTHER ITEMS.

- (4) Drill 0.187 in. (4.75 mm) diameter holes through the patch and lining for the fasteners.
 - (a) The maximum distance between fasteners is 2.0 in. (5.1 cm).
 - (b) The minimum distance from the centers of holes to the edges of the patch is 0.75 in. (1.90 cm).

SUBTASK 25-52-04-420-001

- (5) Install size #10 steel sheet metal screws through the fastener holes.

SUBTASK 25-52-04-340-003

- (6) Install tape, G02361 on the edges of the patch and on the fasteners used for the repair.

EFFECTIVITY
ARO ALL

25-52-04

D633W101-ARO

Page 803
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

H. Repair Honeycomb Panels with a Vendor-Supplied Patch

SUBTASK 25-52-04-350-001

- (1) You can repair the honeycomb panels with an FAA (or regulatory agency) approved vendor-supplied repair kit for honeycomb panels. Follow the approved instructions and repair limits in the kit.

SUBTASK 25-52-04-350-002

- (2) These vendors may be able to supply repair patches for the repair of honeycomb panels:

- (a) Permaglass 100 Series Patch
Permal Gloucester Limited
Bristol Road
Gloucester GL1 5TT
United Kingdom
PHONE: +44 (0) 1452 528282
FAX: +44 (0) 1452 507409
WEBSITE: <http://www.permali.co.uk>
- (b) AF800-series Speed Patch
Akro Fireguard
9001 Rosehill Rd
Lenexa, KS 66215
USA
PHONE: +1 913-888-7172
FAX: +1 913-888-7372
EMAIL: sales@arkrofire.com
WEBSITE: <http://www.arkrofire.com>
- (c) Gillpatch Series
M.C. Gill Corporation
4056 Easy Street
El Monte, CA 91731
USA
PHONE: +1 626-443-4022
FAX: +1 626-350-5880
EMAIL: info@mcgillcorp.com
WEBSITE: <http://www.mcgillcorp.com>
- (d) Pionite products
Pionite Decorative Surfaces
One Pionite Road
Auburn, ME 04210
USA
PHONE: +1 800-746-6483
WEBSITE: <http://www.pionite.com>

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-04

Page 804
Sep 05/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL

I. Small Scratches and Dents Repair

SUBTASK 25-52-04-940-001

- (1) The following limitations apply to the final repairs:
 - (a) The final width of the compound, D00147 must not be more than 3.0 in. (7.6 cm).
 - (b) The total area coverage of the compound, D00147 must not be more than 100 in² (645 cm²) for each panel.
- (2) Use this procedure to repair panels that have damage that does not go into the fiberglass or carbon skins.
- (3) Use this procedure to repair scratches and small surface dents for panels that are less than 0.25 in. (6.35 mm) thick with a maximum depth of 0.005 in. (0.127 mm).
- (4) Use this procedure to repair scratches and small surface dents for panels that are 0.25 in. (6.35 mm) thick or more, that are not more than 0.01 in. (0.25 mm) deep.



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- (5) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.

SUBTASK 25-52-04-110-002

- (6) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-52-04-350-003

- (7) Use the manufacturer's instructions to mix the compound, D00147.

SUBTASK 25-52-04-340-004

- (8) Apply the compound, D00147 to the necessary contour and smoothness of the panel.

SUBTASK 25-52-04-340-005

- (9) After the compound, D00147 has cured, do these steps:
 - (a) Apply Scotch Flatback Masking Tape 250, G00270 to the area around the repair that you do not want to damage during the sanding.
 - (b) Rub the compound, D00147 with abrasive cloth, B00102 to the same level as the surface of the panel.
 - (c) Remove the Scotch Flatback Masking Tape 250, G00270.

J. Small Holes and Gouges Repair

SUBTASK 25-52-04-340-006

- (1) Use this task for damage that is less than 0.5 in² (3.2 cm²) and damages to the core by less than 0.5 in. (1.3 cm).

SUBTASK 25-52-04-010-003

- (2) Remove the loose and broken pieces, contamination, and other unwanted material from the hole.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-04

Page 805
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-52-04-110-003



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- (3) Clean the area with a cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.

SUBTASK 25-52-04-160-001

- (4) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-52-04-340-009

- (5) Use the manufacturer's instructions to mix the compound, A01018, or compound, A50042.

SUBTASK 25-52-04-340-010

- (6) Fill the hole or gouge with the compound, A01018, or compound, A50042.

SUBTASK 25-52-04-860-001

- (7) Let the compound, A01018, or compound, A50042 cure for 7 days at 75°F (24°C) to 79°F (26°C) or 5 hours at 120°F (49°C) to 130°F (54°C).

SUBTASK 25-52-04-340-011

- (8) Do the above procedure to resurface the panel: Small Scratches and Dents Repair.

K. Large Holes and Gouges in the Laminates Repair

SUBTASK 25-52-04-340-012

- (1) Use this task to repair the panels that have between 0.5 in² (3.2 cm²) and 100 in² (645 cm²) of damage but no core damage.
- (2) Remove the damaged area plies from the panel

SUBTASK 25-52-04-340-013

- (3) Rub the damaged area to a taper of 0.5 in. (1.3 cm) to 1 in. (3 cm) per ply.

SUBTASK 25-52-04-110-004



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- (4) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.

SUBTASK 25-52-04-160-002

- (5) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-52-04-340-015

- (6) Use the manufacturer's instructions to mix the resin, A50145.

SUBTASK 25-52-04-340-016

- (7) Do these steps to replace the plies of fabric, G00316, or carbon fiber, G00335:

EFFECTIVITY
ARO ALL

25-52-04

D633W101-ARO

Page 806
Sep 05/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (a) Cut the same number of plies of fabric, G00316, or carbon fiber, G00335 to fit the taper sanded area.

NOTE: The weave of the replacement fabric should be the same as the weave of the original fabric.

- (b) Apply the resin, A50145 to the taper sanded area and the smallest ply of fabric, G00316, or carbon fiber, G00335.
- (c) Put the smallest ply of fabric, G00316, or carbon fiber, G00335 on the taper sanded area.
- (d) Continue the above steps with each ply until the patch is complete.

NOTE: All of the overlaps should be at least 0.5 in. (1.3 cm).

SUBTASK 25-52-04-340-017

- (8) Apply a release sheet, G00288 and 10 psi (69 kPa) to cure the part.

NOTE: The pressure may be applied with positive weights and a caul plate or vacuum. The minimum weight is 10 lb (5 kg) multiplied by the repair area. If a vacuum is used to apply the pressure, cover the entire area with a vacuum bag and apply 20 in. (51 cm) of mercury.

SUBTASK 25-52-04-340-018

- (9) Cure at 70°F (21°C) to 80°F (27°C) for 8 to 16 hours.

SUBTASK 25-52-04-340-019

- (10) Do the above procedure to resurface the panel: Small Scratches and Dents Repair.

L. Repair the Panels that have Core Damage

NOTE: There are two alternative tasks for this repair.

SUBTASK 25-52-04-340-020

- (1) Use this task to repair the panels that have more than 0.5 in² (3.2 cm²) of damage and a damaged core.
- (2) Remove the damaged skin until you can see a minimum of 0.5 in. (1.3 cm) of the core without damage.

SUBTASK 25-52-04-010-002

- (3) Remove the damaged part of the core.
- (a) Make sure there is a minimum of 0.5 in. (1.3 cm) of the core without damage shown on all sides of the damaged area.

SUBTASK 25-52-04-340-021

- (4) Rub the skin around the damaged area to taper out 2.0 in. (5.1 cm) around the edge of the cut out area.

SUBTASK 25-52-04-110-005



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- (5) Clean the area with a clean cotton wiper, G00034 that is wet with Butyl Carbitol solvent, B01027.

EFFECTIVITY
ARO ALL

25-52-04

D633W101-ARO

Page 807
Sep 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-52-04-160-003

- (6) Dry the area with a clean cotton wiper, G00034.

SUBTASK 25-52-04-340-022

- (7) Use this task to repair panels with a damaged core with a diameter of less than 3.0 in. (7.6 cm) and less than 100 in² (645 cm²) of damaged surface area.

- (8) Do these steps for the first alternative repair:

- (a) Bond a piece of foam, G00077, or nonmetallic honeycomb core, G00278 with resin, A50145 to the area where the damaged core was removed.

NOTE: The foam or core thickness must be the same thickness as the honeycomb core that was removed from the damaged area.

- (b) Apply a release sheet, G00288 and 10 psi (69 kPa) to cure the part.

NOTE: The pressure may be applied with positive weights and a caul plate or vacuum. The minimum weight is 10 lb (5 kg) multiplied by the repair area. If a vacuum is used to apply the pressure, cover the entire area with a vacuum bag and apply 20 in. (51 cm) of mercury.

- (c) Cure at 70°F (21°C) to 80°F (27°C) for 8 to 16 hours.

- (d) Do the above task to repair the skin: Large Holes and Gouges in the Laminates Repair.

SUBTASK 25-52-04-340-023

- (9) Use this task to repair panels with damage to the core of more than 3.0 in. (7.6 cm) and less than 100 in² (645 cm²) of damaged surface area.

- (10) Do these steps for the second alternative repair:

- (a) Cut and replace the damaged core with the same thickness, type, class, and grade of the nonmetallic honeycomb core, G00278.

- (b) Apply resin, A50145 around the edge if it is necessary to bond the core.

NOTE: The core must have the same ribbon direction and bonded the same as on the engineering drawing.

- (c) Do the above task to repair the skin: Large Holes and Gouges in the Laminates Repair.

M. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-04-410-001

- (1) Install the repaired lining. Do the applicable task:

- (a) For the lower lobe cargo compartment: Ceiling Liner - Installation, TASK 25-52-09-400-801.

- (b) For the bulk cargo compartment: Sidewall Liner Installation, TASK 25-52-06-400-801.

- (c) For the aft cargo compartment: Aft Cargo Compartment Forward End Wall Installation, TASK 25-52-18-400-801.

————— END OF TASK —————

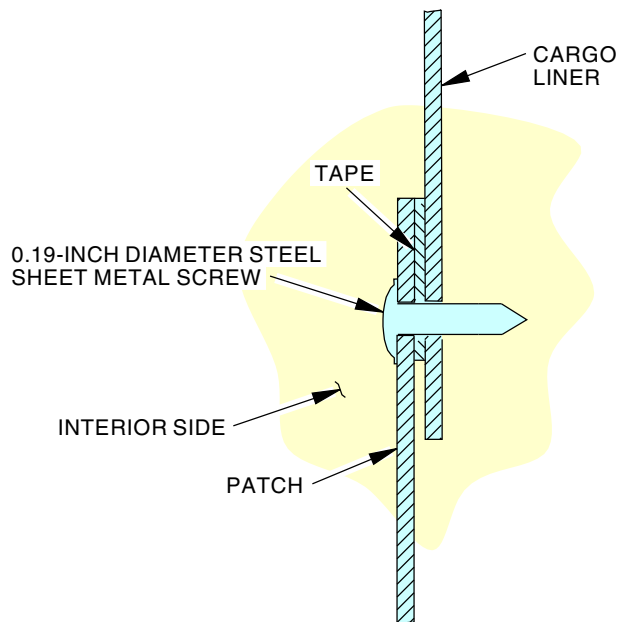
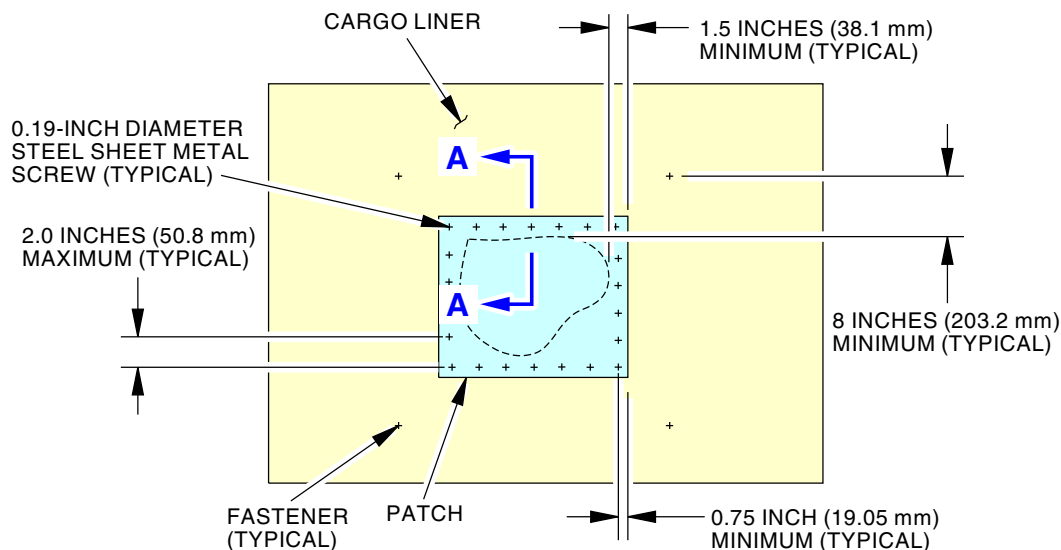
EFFECTIVITY
ARO ALL

25-52-04

D633W101-ARO

Page 808
Sep 05/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**HONEYCOMB CARGO LINER REPAIR
(WITH PATCH)**

A-A

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**Honeycomb Cargo Panel Repair
Figure 801/25-52-04-990-801**

EFFECTIVITY
ARO ALL

25-52-04

D633W101-ARO

Page 809
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SIDEWALL LINERS - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) Removal of the vertical and sloping sidewall liners
- (2) Installation of the vertical and sloping sidewall liners
- (3) Replacement liners may be manufactured to pattern, using an approved liner material meeting the requirements of sheet, G02163. Replacement liners shall be of the same type/gauge as liner removed.

B. This procedure refers to the vertical and sloping sidewall liners as the liners.

TASK 25-52-06-000-801

2. Sidewall Liner Removal

(Figure 401, Figure 402, Figure 403)

A. **References**

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
52-34-00 P/B 201	FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES
52-35-00 P/B 201	AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES
52-36-00 P/B 201	BULK CARGO DOOR - MAINTENANCE PRACTICES

B. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1640	Tool - Removal, Scrivet Fastener Part #: ST991A-2 Supplier: 81205
SPL-1996	Barrier - Safety, Bulk Cargo Door Part #: J52020-1 Supplier: 81205
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205
SPL-2007	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205

C. **Consumable Materials**

Reference	Description	Specification
G02361	Tape - Cargo Lining Joint Seal	BMS5-146
G50788	Tape - Textile Hook And Loop Fasteners Tape (Polyester Hook & Polyester Loop)	BMS8-285 Type IV

D. **Location Zones**

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-06

Page 401
Sep 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Zone	Area
152	Aft Cargo Compartment, Right
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

E. Prepare for the Removal

SUBTASK 25-52-06-860-001

- (1) Do this task: Supply Electrical Power, TASK 24-22-00-860-805

SUBTASK 25-52-06-010-001

- (2) To open the applicable cargo door do the applicable tasks in the procedures that follow:
 - (a) Forward Cargo Door: FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-34-00/201
 - (b) Aft standard cargo door: AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-35-00/201
 - (c) Bulk cargo door: BULK CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-36-00/201

SUBTASK 25-52-06-420-001



WARNING

INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (3) Install the applicable safety barrier across the cargo door opening:
 - (a) For the forward cargo door: cargo door safety barrier, SPL-2007
 - (b) For the aft standard cargo door: safety barrier, SPL-2006
 - (c) For the bulk cargo door: bulk cargo door safety barrier, SPL-1996

F. Sidewall Liner Removal



WARNING

IN THE FORWARD CARGO COMPARTMENT, PUT A WARNING SIGN NEAR THE TORQUE TUBES IF YOU REMOVE THE AFT SIDEWALL LINER. THE TORQUE TUBES TURN QUICKLY WHEN THE LEADING EDGE SLATS OPERATE. YOUR HAIR OR LOOSE CLOTHING CAN GET CAUGHT WHEN THE TORQUE TUBES OPERATE. THE TORQUE TUBES CAN PULL OFF YOUR HAIR OR CAUSE OTHER INJURIES.



CAUTION

THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT MUST ALWAYS BE INSTALLED. THIS IS TO PREVENT DAMAGE TO THE HYDRAULIC LINES OF THE NOSE LANDING GEAR. THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT CAN ONLY BE REMOVED FOR MAINTENANCE. AFTER YOU DO THE MAINTENANCE, INSTALL THE FLOOR PANELS. BE CAREFUL IF YOU DO WORK IN THE FORWARD CARGO COMPARTMENT WITH THE FLOOR PANELS REMOVED.

SUBTASK 25-52-06-020-001

- (1) Remove and discard the tape, G02361 [3] from the edges of the liner [1], [22], [26], [43].

EFFECTIVITY
ARO ALL

25-52-06

D633W101-ARO

Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-52-06-020-002

- (2) Do the steps that follow to remove a liner [1] in the forward or aft cargo compartment (Figure 401):
- (a) Do the steps that follow to remove the pin [5] fasteners:
- 1) Put the scrivet fastener tool, SPL-1640 between the pin [5] and grommet [6].
 - 2) Pull the scrivet fastener tool, SPL-1640 away from the liner [1].
- NOTE: The pin [5] and grommet [6] come out of the liner [1] at the same time.
- (b) Do these steps if the liner [1] is immediately forward or aft of the doorway area:
- 1) Remove the screws [7] that attach the post cover [4] and liner [1] to the support structure [2].
 - 2) Remove the post cover [4].
- (c) Remove the liner [1].

SUBTASK 25-52-06-020-003

- (3) Do the steps that follow to remove a liner [22], [26], [43] in the bulk cargo compartment (Figure 402, Figure 403):
- (a) For the vertical liners [22]; remove the screws [23] that attach the liner [22] to the support structure [21].
- (b) For the sloping sidewall liners [26]; remove the bolts [24] and washers [25] that attach the liner [26] to the support structure [21].
- (c) For the doorway liners [43], do these steps:
- 1) Remove the bolts [41] and washers [42] from the liners [43] on the sides of the doorway.
 - 2) Remove the screws from the liner above the doorway.
 - 3) Pull the liner [43] from the edge of the doorway to disconnect the hook and loop fastener tape, G50788 [44].
- (d) Remove the liner [43].

SUBTASK 25-52-06-210-001

- (4) After you remove the cargo liner check the airplane structure for damaged or missing parts.
- (a) Replace any of the damaged or missing parts as necessary.

————— **END OF TASK** —————

TASK 25-52-06-400-801

3. Sidewall Liner Installation

(Figure 401, Figure 402, Figure 403)

A. References

Reference	Title
20-30-80-910-801	General Cleaning of Metal (Series 80) (P/B 201)
52-34-00 P/B 201	FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES
52-35-00 P/B 201	AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES
52-36-00 P/B 201	BULK CARGO DOOR - MAINTENANCE PRACTICES

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-06

Page 403
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1996	Barrier - Safety, Bulk Cargo Door Part #: J52020-1 Supplier: 81205
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205
SPL-2007	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
G02186	Seal - Closed Cell Silicone Foam Rubber, Hydraulic Fluid Resistant	BMS1-68 Form III
G50088	Seal - Closed Cell Silicone Foam Rubber, Hydraulic Fluid Resistant (Non-Adhesive)	BMS1-68 Grade A Form II
G50360	Seal - Closed Cell Silicone Foam Rubber, Hydraulic Fluid Resistant (with Adhesive)	BMS1-68 Grade A Form III
G50428	Tape - Nitto P-629 (Formerly Permacel) Cargo Pit Seam Tape	BMS5-146
G50788	Tape - Textile Hook And Loop Fasteners Tape (Polyester Hook & Polyester Loop)	BMS8-285 Type IV

D. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

E. Sidewall Liner Installation

SUBTASK 25-52-06-210-002

(1) Before you install the sidewall liner check for missing or damaged parts.

(a) Replace the missing or damaged parts as necessary.

SUBTASK 25-52-06-400-001

(2) It can be necessary to remove and replace the Nitto P-629 tape, G50428 [8] and the seal, G02186, seal, G50088 or, seal, G50360 seal [9].

(a) Make sure the tape [8], is tightly attached to the support structure [2] and is clean with a smooth, continuous surface.

(b) If you see a space between the tape [8] and the support structure [2], remove the damaged tape [8].

1) Clean the support structure [2] surface (TASK 20-30-80-910-801).

2) Cut the new Nitto P-629 tape, G50428 [8] to the necessary length.

EFFECTIVITY
ARO ALL

25-52-06

D633W101-ARO

Page 404
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 3) Attach the Nitto P-629 tape, G50428 [8] to the support structure [2].
- (c) Make sure the seal, G02186, seal, G50088 or, seal, G50360 [9] is tightly attached to the support structure [2]
- (d) If you see a space between the seal, G02186, seal, G50088 or, seal, G50360 [9] and the support structure [2] or damage to the foam, remove the foam.
 - 1) Clean the support structure [2] surface (TASK 20-30-80-910-801).
 - 2) Cut the new seal, G02186, seal, G50088 or, seal, G50360 [9] to the necessary length.
 - 3) Attach the new seal, G02186, seal, G50088 or, seal, G50360 [9] to the support structure [2].

SUBTASK 25-52-06-820-001

- (3) Hold the liner [1], [22], [26], [43] up against the support structure.

SUBTASK 25-52-06-420-002

- (4) Do the steps that follow to install the liner [1] in the forward or aft cargo compartment (Figure 401):
 - (a) For the sloping sidewall liners, install hook and loop fastener tape, G50788 at the support structure nearest to the endwall.
 - (b) Do these steps if the liner [1] is immediately forward or aft of the doorway area:
 - 1) Put the post cover [4] around the liner [1] and support structure [2].
 - 2) Install the screws [7] that attach the post cover [4] and liner [1] to the support structure [2].
 - (c) Do the steps that follow to install the pin [5] fasteners:

NOTE: The pin [5] fastener goes into a grommet [6].

 - 1) Put the grommet [6] in the hole.
 - 2) Push or lightly hit the pin [5] into the grommet [6].
 - 3) If the old pin [5] does not hold the liner [1], use a new pin [5] and grommet [6] fastener.
 - (d) Make sure the inboard and outboard deformation of the liner [1] is not more than 0.5 in. (12.7 mm).

SUBTASK 25-52-06-420-003

- (5) Do the steps that follow to install the liner [22], [26], [43] in the bulk cargo compartment (Figure 402):
 - (a) For the vertical liners [22]; install the screws [23] that attach the liner [22] to the support structure [21].
 - (b) For the sloping sidewall liners [26]; install the bolts [24] and washers [25] that attach the liner [26] to the support structure [21].
 - (c) For the doorway liners [43], do these steps:
 - 1) Align the hook and loop fastener tape, G50788 [44] that attaches the liner [43] to the support structure [21].
 - 2) Install the bolts [41] and washers [42] that attach the liner [43] on the side of the doorway.
 - 3) Install the screws that attach the liner above the doorway.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-06

Page 405
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-52-06-420-004

- (6) Apply new Nitto P-629 tape, G50428 [3] to all of the joints, overlaps, and liner perimeter fasteners as one continuous piece.

NOTE: It is not necessary to install tape to seal fasteners in the middle of the liners.

NOTE: It is not necessary to install tape to the bottom edge of the sloping sidewall liners except for a minimum of 21 inches at the forward and aft ends of each cargo compartment on both the left and right sides.

- (a) If it is necessary to use short pieces of Nitto P-629 tape, G50428 [3], make a minimum overlap of 0.5 in. (12.7 mm).

SUBTASK 25-52-06-420-005

- (7) Push the Nitto P-629 tape, G50428 [3] firmly to make sure there is a good bond.

NOTE: There is a good bond if the surface of the tape is smooth and does not have air bubbles.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-06-080-001

- (1) Remove the applicable safety barrier from the cargo door opening:
- (a) For the forward cargo door: cargo door safety barrier, SPL-2007
 - (b) For the aft standard cargo door: safety barrier, SPL-2006
 - (c) For the bulk cargo door: bulk cargo door safety barrier, SPL-1996

SUBTASK 25-52-06-860-002

- (2) To close the applicable cargo door, do the applicable tasks in the procedures that follow:
- (a) For the forward cargo door: FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-34-00/201
 - (b) For the aft standard cargo door: AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-35-00/201
 - (c) For the bulk cargo door: BULK CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-36-00/201

————— **END OF TASK** —————

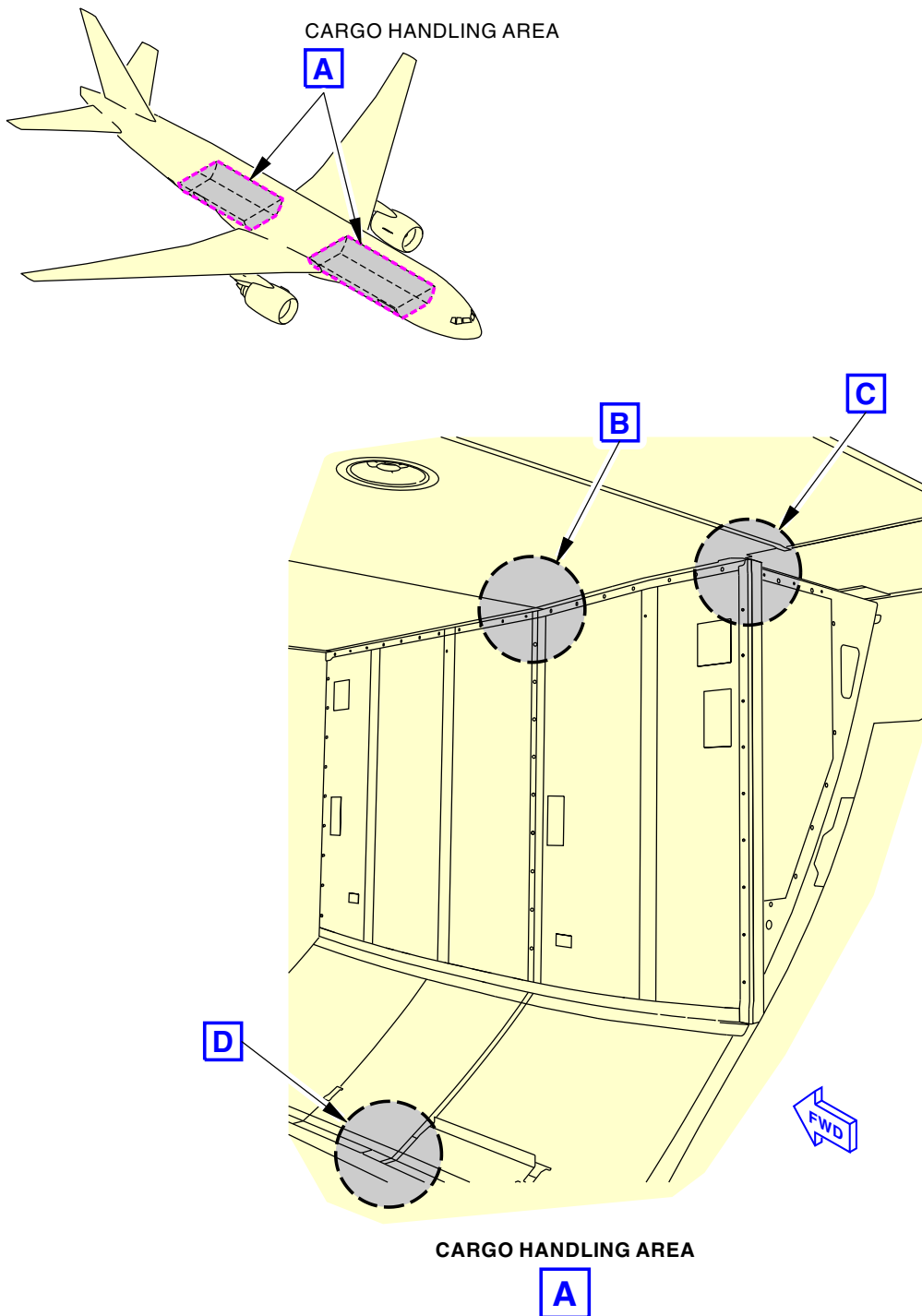
EFFECTIVITY
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25-52-06

D633W101-ARO

Page 406
May 05/2016

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777-200/300
AIRCRAFT MAINTENANCE MANUAL



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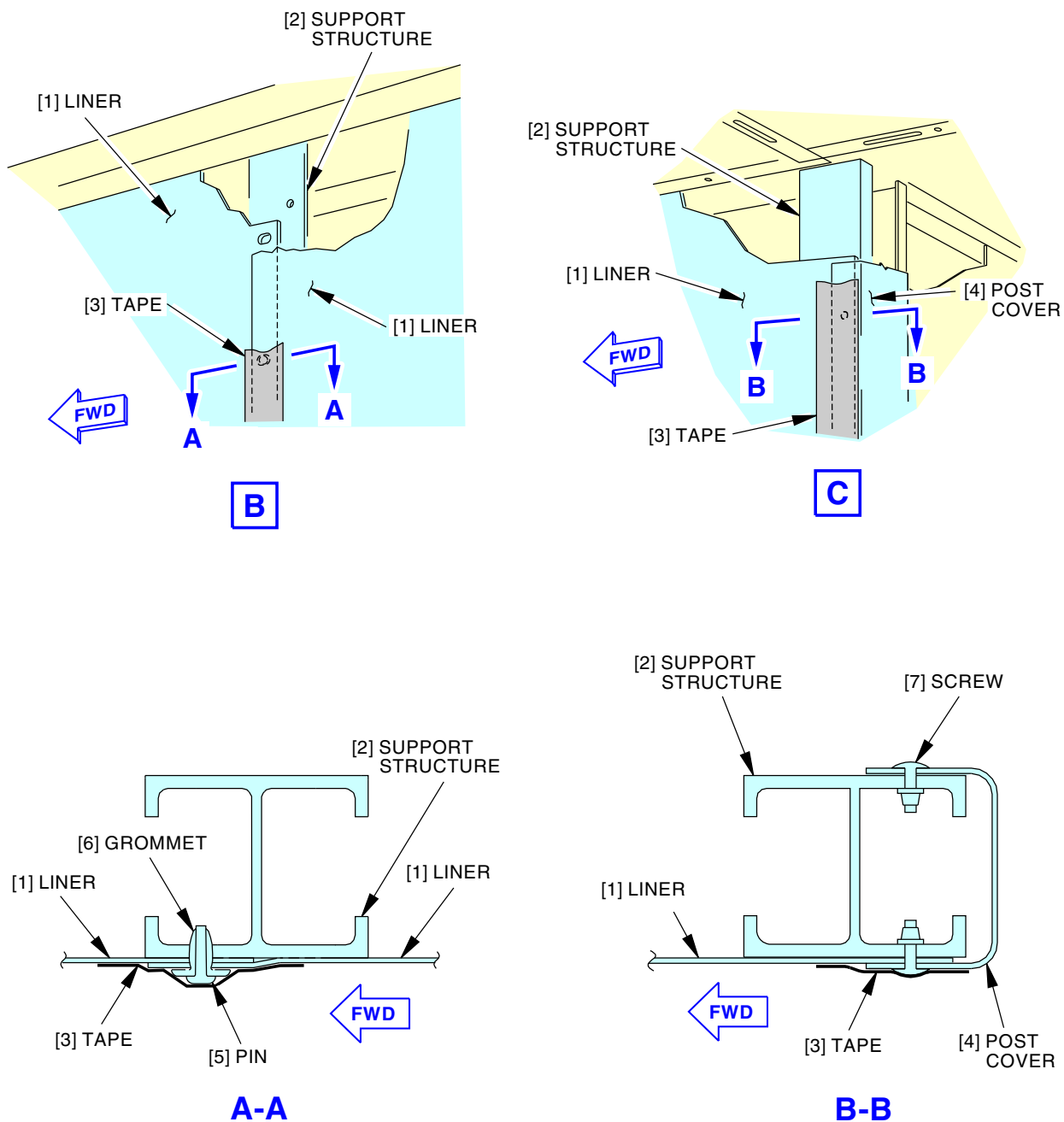
Sidewall Liner Installation
Figure 401/25-52-06-990-801 (Sheet 1 of 3)

EFFECTIVITY
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D633W101-ARO

25-52-06

Page 407
May 05/2017



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**Sidewall Liner Installation
Figure 401/25-52-06-990-801 (Sheet 2 of 3)**

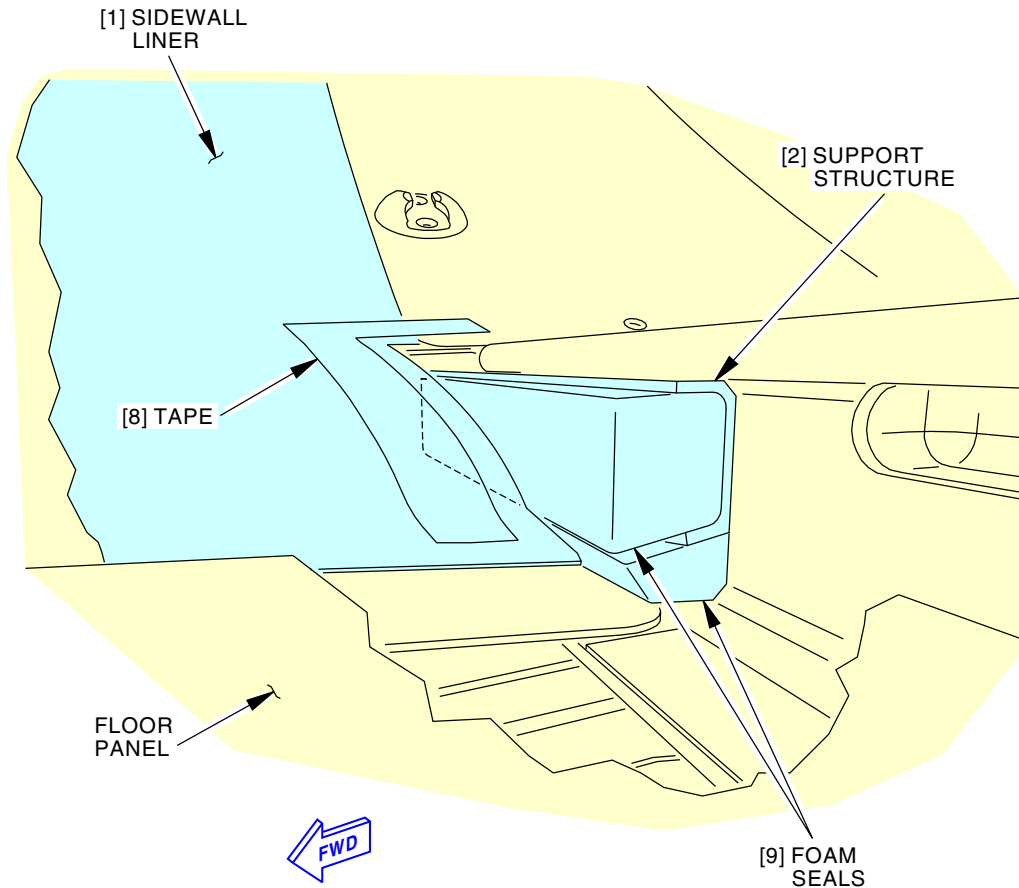
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25-52-06

D633W101-ARO

Page 408
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



**FOAM SEAL INSTALLATION
(EXAMPLE)**

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Sidewall Liner Installation
Figure 401/25-52-06-990-801 (Sheet 3 of 3)

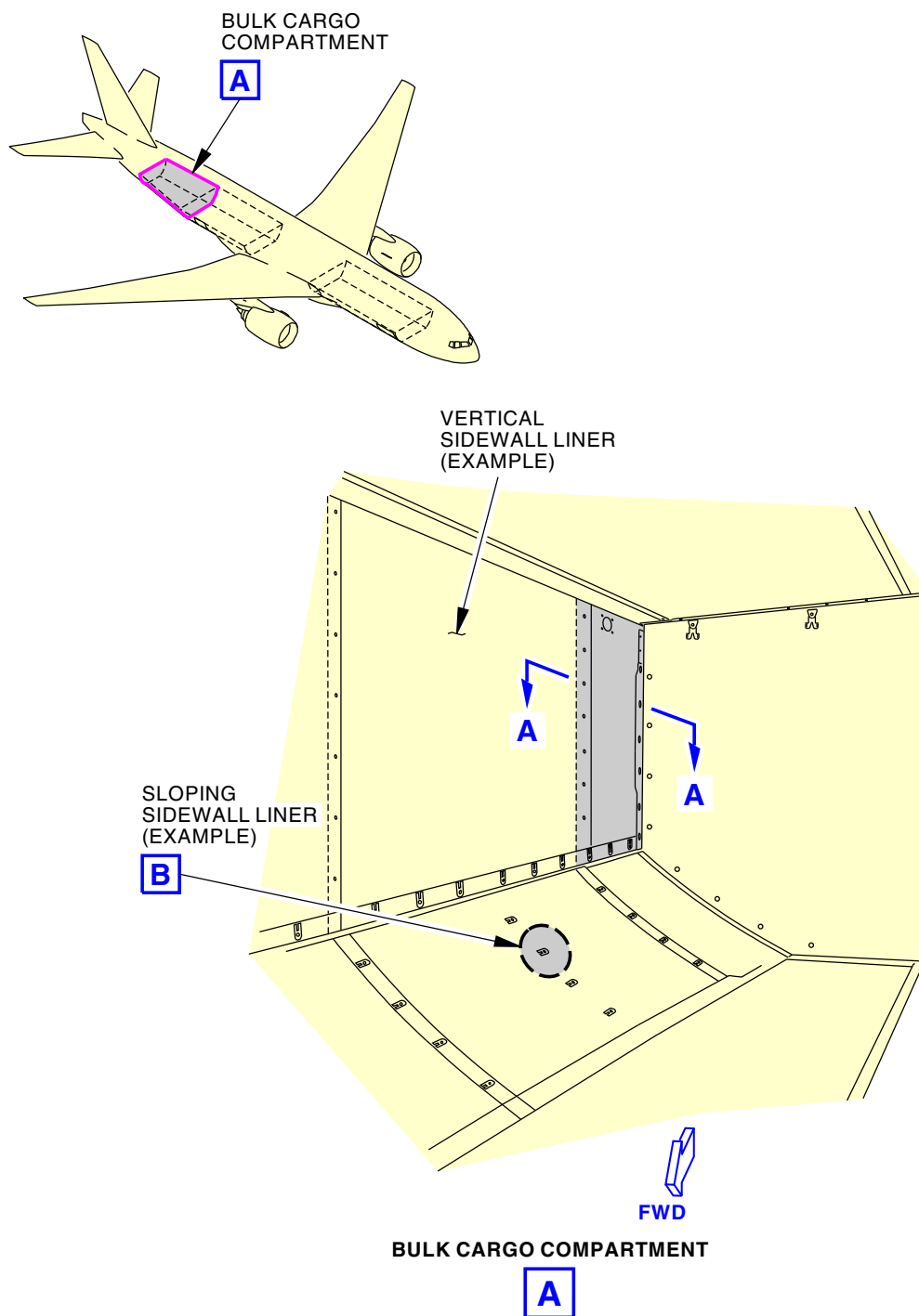
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25-52-06

D633W101-ARO

Page 409
 May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Bulk Compartment Sidewall Liner Installation
Figure 402/25-52-06-990-802 (Sheet 1 of 2)**

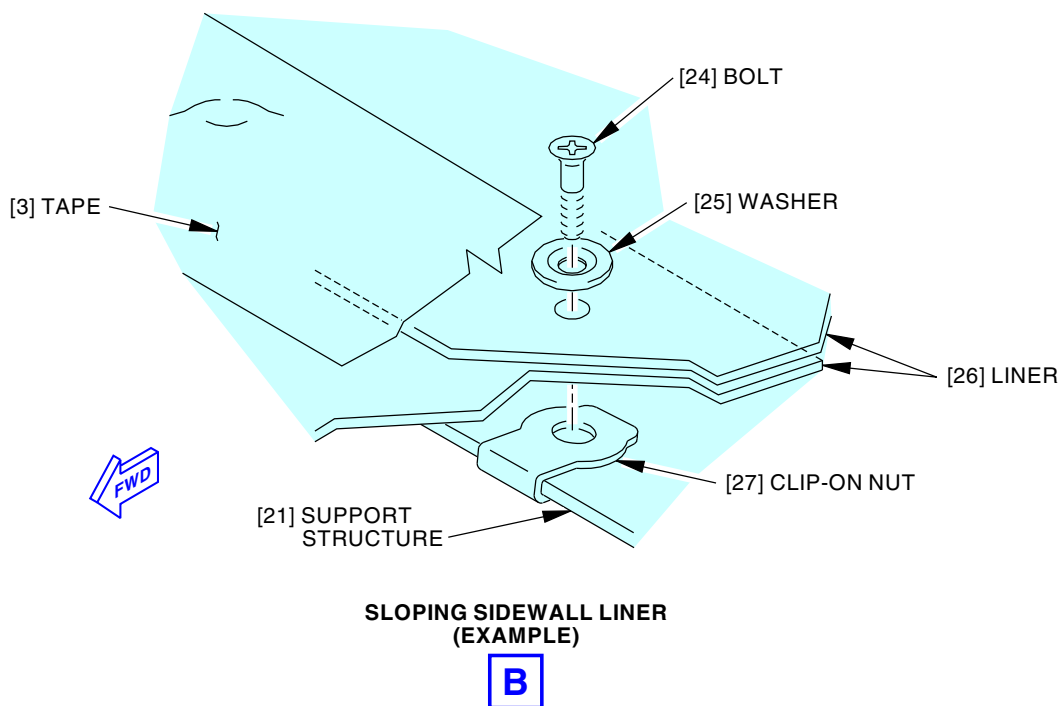
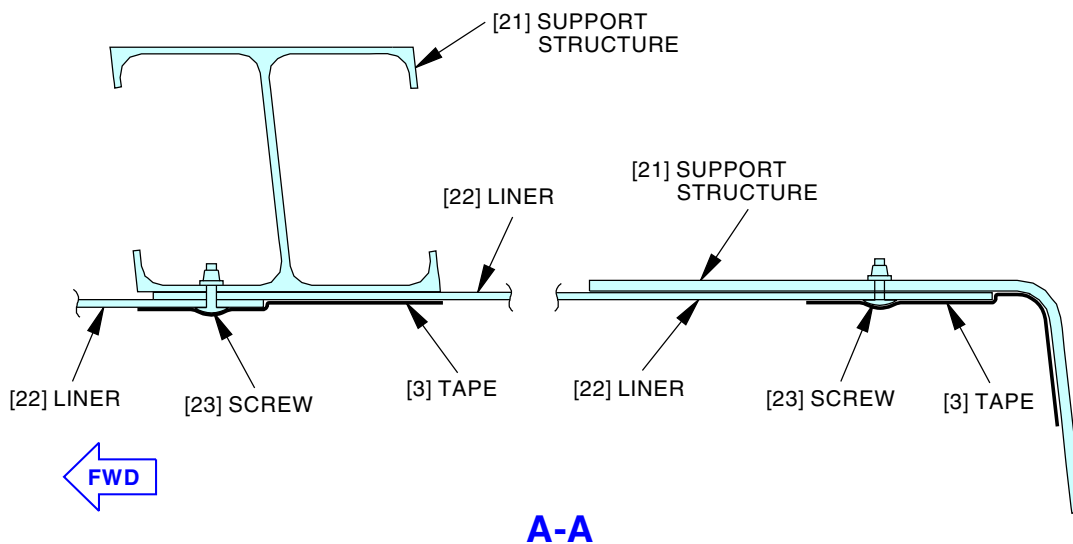
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25-52-06

D633W101-ARO

Page 410
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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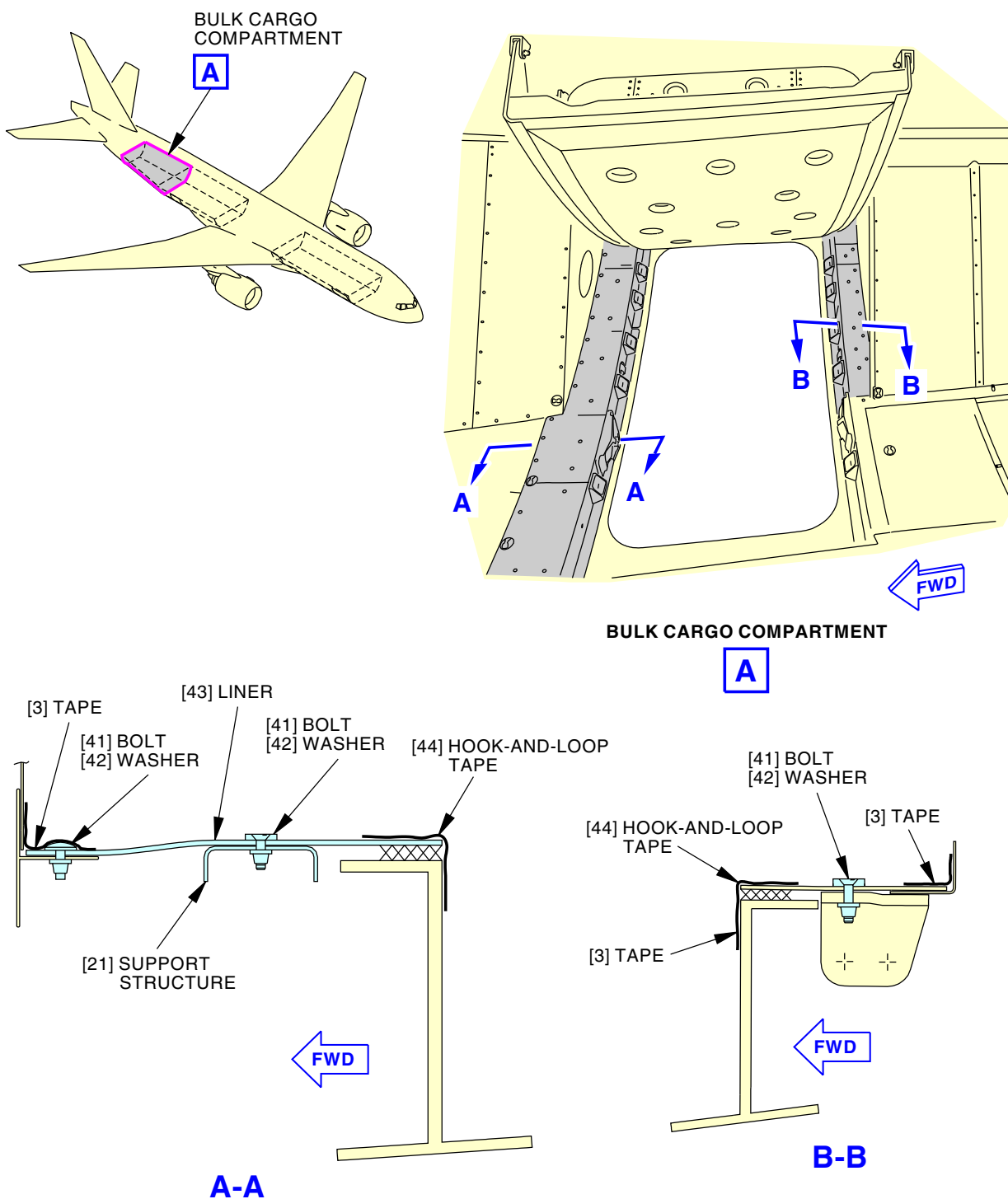
**Bulk Compartment Sidewall Liner Installation
Figure 402/25-52-06-990-802 (Sheet 2 of 2)**

EFFECTIVITY
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25-52-06

D633W101-ARO

Page 411
May 05/2017



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**Bulk Compartment Doorway Liner Installation
Figure 403/25-52-06-990-803**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-06

Page 412
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

DECOMPRESSION PANEL - INSPECTION/CHECK

1. General

- A. This procedure contains an inspection of the decompression panels in the lower lobe cargo compartments.
- B. The decompression panels provide vents for a rapid decompression on the main deck through the use of blowout panels.

TASK 25-52-08-200-801

2. Decompression Panel Inspection

(Figure 601)

A. **References**

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
24-22-00-860-806	Remove Electrical Power (P/B 201)
52-34-00 P/B 201	FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES
52-35-00 P/B 201	AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES

B. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2007	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205

C. **Location Zones**

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left

D. **Prepare for the Inspection**

SUBTASK 25-52-08-860-001

- (1) Do this task: Supply Electrical Power, TASK 24-22-00-860-805

SUBTASK 25-52-08-010-001

- (2) To open the applicable cargo door, do the applicable task in the procedures that follow:
- (a) FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-34-00/201
 - (b) AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-35-00/201

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-08

Page 601
May 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-52-08-480-001



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (3) Install the applicable safety barrier across the cargo door opening.
 - (a) For the forward cargo door: large cargo door safety barrier, SPL-1988
 - (b) For the aft standard cargo door: cargo door safety barrier, SPL-2007

SUBTASK 25-52-08-860-004

- (4) Turn on the cargo compartment lights if it is necessary.

E. Decompression Panel Inspection

SUBTASK 25-52-08-210-001



THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT MUST ALWAYS BE INSTALLED. THIS IS TO PREVENT DAMAGE TO THE HYDRAULIC LINES OF THE NOSE LANDING GEAR. THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT CAN ONLY BE REMOVED FOR MAINTENANCE. AFTER YOU DO THE MAINTENANCE, INSTALL THE FLOOR PANELS. BE CAREFUL IF YOU DO WORK IN THE FORWARD CARGO COMPARTMENT WITH THE FLOOR PANELS REMOVED.

- (1) Make sure the blowout panel is fully engaged between the capstrip and the bulb seal.
 - (a) Do these steps to put the blowout panel in the correct position if it is not fully engaged:
 - 1) Remove the screws that attach the vent to the frame.
 - 2) Remove the vent.
 - 3) Loosen the applicable bolts that attach the capstrips to the frame in the area where the blowout panel came out.
 - 4) Make sure the blowout panel is not torn, punctured, or creased.
 - a) Replace the blowout panel if it is necessary.
 - 5) Put the blowout panel in the position between the capstrip and the bulb seal.
 - 6) Tighten the bolts that attach the capstrips to the frame.
 - 7) Install the screws to attach the vent to the frame.

SUBTASK 25-52-08-210-002

- (2) Make sure the vent is firmly attached and is inboard of the blowout panel.

SUBTASK 25-52-08-960-001

- (3) Replace the decompression panel if it is necessary:

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-08-840-001

- (1) Remove the applicable safety barrier.

SUBTASK 25-52-08-860-002

- (2) Turn off the cargo compartment lights if it is necessary.

SUBTASK 25-52-08-410-001

- (3) To close the applicable cargo door, do the applicable task in the procedures that follow:

EFFECTIVITY
ARO ALL

25-52-08

D633W101-ARO



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (a) FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES,
PAGEBLOCK 52-34-00/201
- (b) AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES,
PAGEBLOCK 52-35-00/201

SUBTASK 25-52-08-860-003

- (4) Remove electrical power if it is no longer required. Do this task: Remove Electrical Power,
TASK 24-22-00-860-806

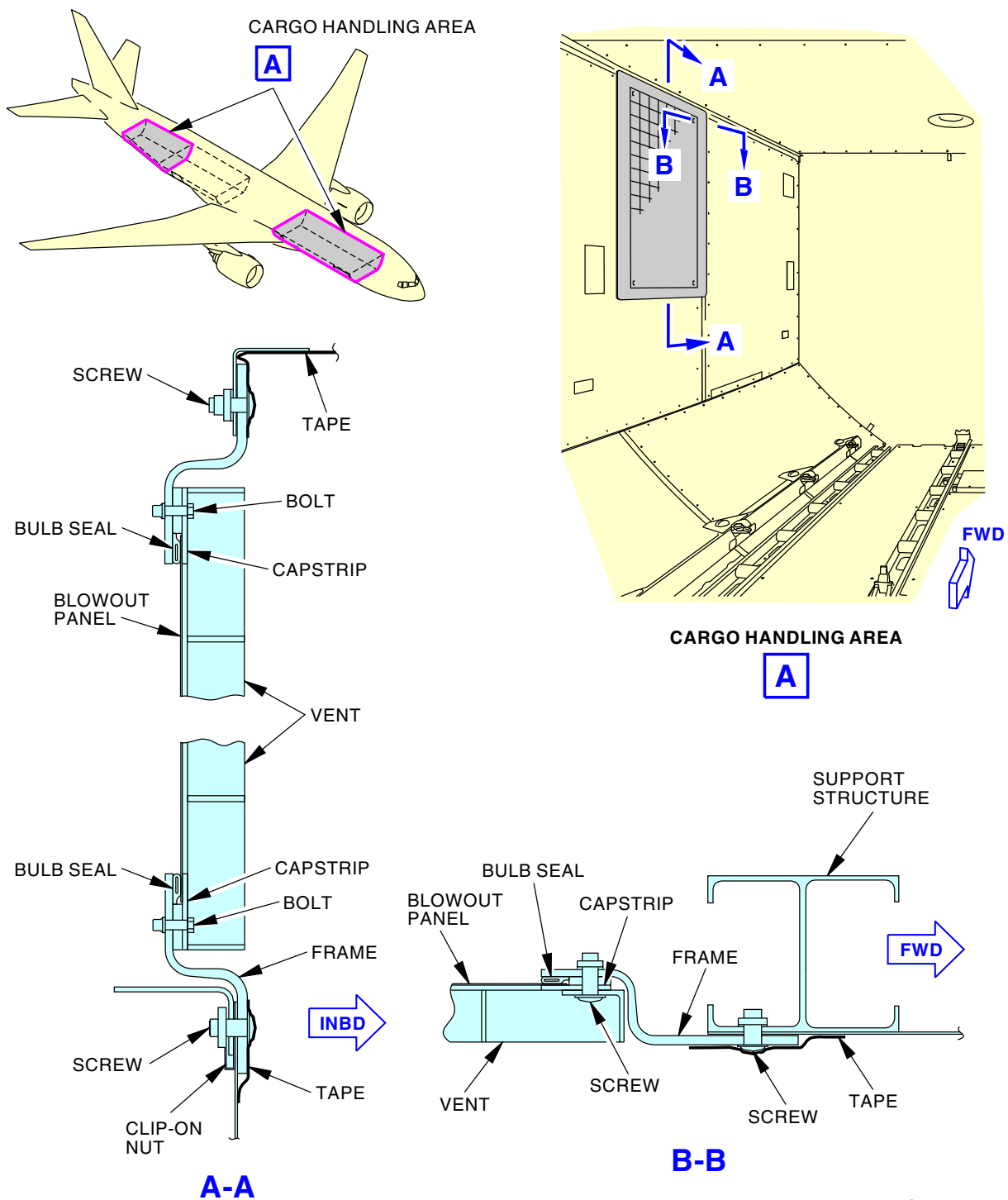
———— **END OF TASK** ————

EFFECTIVITY
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D633W101-ARO

25-52-08

Page 603
Sep 05/2017



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Decompression Panel Inspection
Figure 601/25-52-08-990-801

EFFECTIVITY
ARO ALL

25-52-08

D633W101-ARO

Page 604
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
CEILING LINER - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Removal of the ceiling liners
 - (2) Installation of the ceiling liners.
- B. Replacement liners may be manufactured to pattern, using an approved liner material meeting the requirements of sheet, G02163. Replacement liners shall be of the same type/gauge as liner removed.
- C. This procedure refers to the ceiling liners in the forward, aft, and bulk cargo compartments as the liners.

TASK 25-52-09-000-801

2. Ceiling Liner Removal

(Figure 401)

A. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
52-34-00 P/B 201	FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES
52-35-00 P/B 201	AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES
52-36-00 P/B 201	BULK CARGO DOOR - MAINTENANCE PRACTICES

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-2007	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205

C. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

D. Prepare for the Removal

SUBTASK 25-52-09-860-001

- (1) Do this task: Supply Electrical Power, TASK 24-22-00-860-805

SUBTASK 25-52-09-010-001

- (2) To open the applicable cargo door, do the applicable tasks in the procedures that follow:
 - (a) For the forward cargo door: FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-34-00/201

EFFECTIVITY
ARO ALL

25-52-09

D633W101-ARO

Page 401
May 05/2015

777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (b) For the aft standard cargo door: AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-35-00/201
- (c) For the bulk cargo door: BULK CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-36-00/201

SUBTASK 25-52-09-480-001



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (3) Install the applicable safety barrier across the cargo door opening:
 - (a) For the standard cargo door: cargo door safety barrier, SPL-2007

E. Ceiling Liner Removal

SUBTASK 25-52-09-020-001



IN THE FORWARD CARGO COMPARTMENT, PUT A WARNING SIGN NEAR THE TORQUE TUBES IF YOU REMOVE THE AFT CEILING LINER. THE TORQUE TUBES TURN QUICKLY WHEN THE LEADING EDGE SLATS OPERATE. YOUR HAIR OR LOOSE CLOTHING CAN GET CAUGHT WHEN THE TORQUE TUBES OPERATE. THE TORQUE TUBES CAN PULL OFF YOUR HAIR OR CAUSE OTHER INJURIES.



THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT MUST ALWAYS BE INSTALLED. THIS IS TO PREVENT DAMAGE TO THE HYDRAULIC LINES OF THE NOSE LANDING GEAR. THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT CAN ONLY BE REMOVED FOR MAINTENANCE. AFTER YOU DO THE MAINTENANCE, INSTALL THE FLOOR PANELS. BE CAREFUL IF YOU DO WORK IN THE FORWARD CARGO COMPARTMENT WITH THE FLOOR PANELS REMOVED.

- (1) Remove and discard the tape [8] around the edges of the liner [2].

SUBTASK 25-52-09-020-002

- (2) Do the applicable steps that follow to disconnect the other equipment from the liner [2]:
 - (a) Do these steps to disconnect the liner [2] from the discharge pan for the fire extinguishing system:
 - 1) Remove and discard the tape [8] around the discharge pan for the fire extinguisher [6] to get access to the screws [7].
 - 2) Remove the screws [7] that attach the liner [2] to the fire extinguisher [6].
 - (b) Remove the screws [4] that attach the ring [5] for the ceiling light [3] to the liner [2] and remove the ring [5].

SUBTASK 25-52-09-020-003

- (3) Remove the screws [10] that hold the liner [2] to the support structure [9].

SUBTASK 25-52-09-020-004

- (4) Remove the liner [2].

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-52-09

D633W101-ARO

Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-52-09-400-801

3. Ceiling Liner - Installation

(Figure 401)

A. References

Reference	Title
24-22-00-860-806	Remove Electrical Power (P/B 201)
52-34-00 P/B 201	FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES
52-35-00 P/B 201	AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES
52-36-00 P/B 201	BULK CARGO DOOR - MAINTENANCE PRACTICES

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-1996	Barrier - Safety, Bulk Cargo Door Part #: J52020-1 Supplier: 81205
SPL-2007	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
G50428	Tape - Nitto P-629 (Formerly Permacel) Cargo Pit Seam Tape	BMS5-146
G50821	Tape - Nitto P-629SL (Formerly Permacel) Cargo Pit Seam Tape	BMS5-146

D. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

E. Ceiling Liners Installation

SUBTASK 25-52-09-820-001

- (1) Hold the ceiling liner [2] in the position for the installation.
 - (a) Make sure the smoke detector port [1] goes through the hole in the ceiling liner [2].

SUBTASK 25-52-09-420-001

- (2) Install the screws [10] to attach the ceiling liner [2] to the support structure [9].

EFFECTIVITY
ARO ALL

25-52-09

D633W101-ARO

Page 403
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-52-09-420-005

- (3) Install the rubstrip to the liner with the screws.
 - (a) Apply Nitto P-629SL tape, G50821 tape [8] over the rubstrip in the cargo door area if it is necessary.

NOTE: Apply the tape to the part of the rub strip that is near the compartment entrance.

SUBTASK 25-52-09-420-002

- (4) Do the applicable steps that follow to attach the ceiling liner [2] to the other equipment:
 - (a) Do these steps to attach the ceiling liner [2] to the discharge pan for the fire extinguishing system:
 - 1) Install the eight screws [7] to attach the ceiling liner [2] to the fire extinguisher [6].
 - 2) Apply the new Nitto P-629 tape, G50428 tape [8] on the screws [7] and around the edge of the ceiling liner [2].
 - (b) Put the ring [5] into position and install the four screws [4] that attach the ring [5] for the ceiling light [3] to the ceiling liner [2].

SUBTASK 25-52-09-420-003

- (5) Apply the new Nitto P-629 tape, G50428 tape [8] on the screws [10] and edges of the ceiling liner [2] as one continuous piece.

NOTE: No tape is installed at the smoke detector ports [1].

NOTE: It is not necessary to install tape [8] to seal fasteners in the middle of the liners.

- (a) If it is necessary to use short pieces of tape [8], make a minimum overlap of 0.50 in. (12.70 mm).

SUBTASK 25-52-09-420-004

- (6) Push the Nitto P-629 tape, G50428 tape [8] firmly to make sure there is a good bond.

NOTE: There is a good bond when the tape is smooth and flat against the liner.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-09-080-001

- (1) Remove the applicable safety barrier from the cargo door opening:
 - (a) For the forward cargo door: large cargo door safety barrier, SPL-1988
 - (b) For the aft standard cargo door: cargo door safety barrier, SPL-2007
 - (c) For the bulk cargo door: bulk cargo door safety barrier, SPL-1996

SUBTASK 25-52-09-410-001

- (2) To close the applicable cargo door, do the applicable task in the procedures that follow:
 - (a) For the forward cargo door: FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-34-00/201
 - (b) For the aft standard cargo door: AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-35-00/201
 - (c) For the bulk cargo door: BULK CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-36-00/201

SUBTASK 25-52-09-860-002

- (3) Do this task if it is necessary: Remove Electrical Power, TASK 24-22-00-860-806

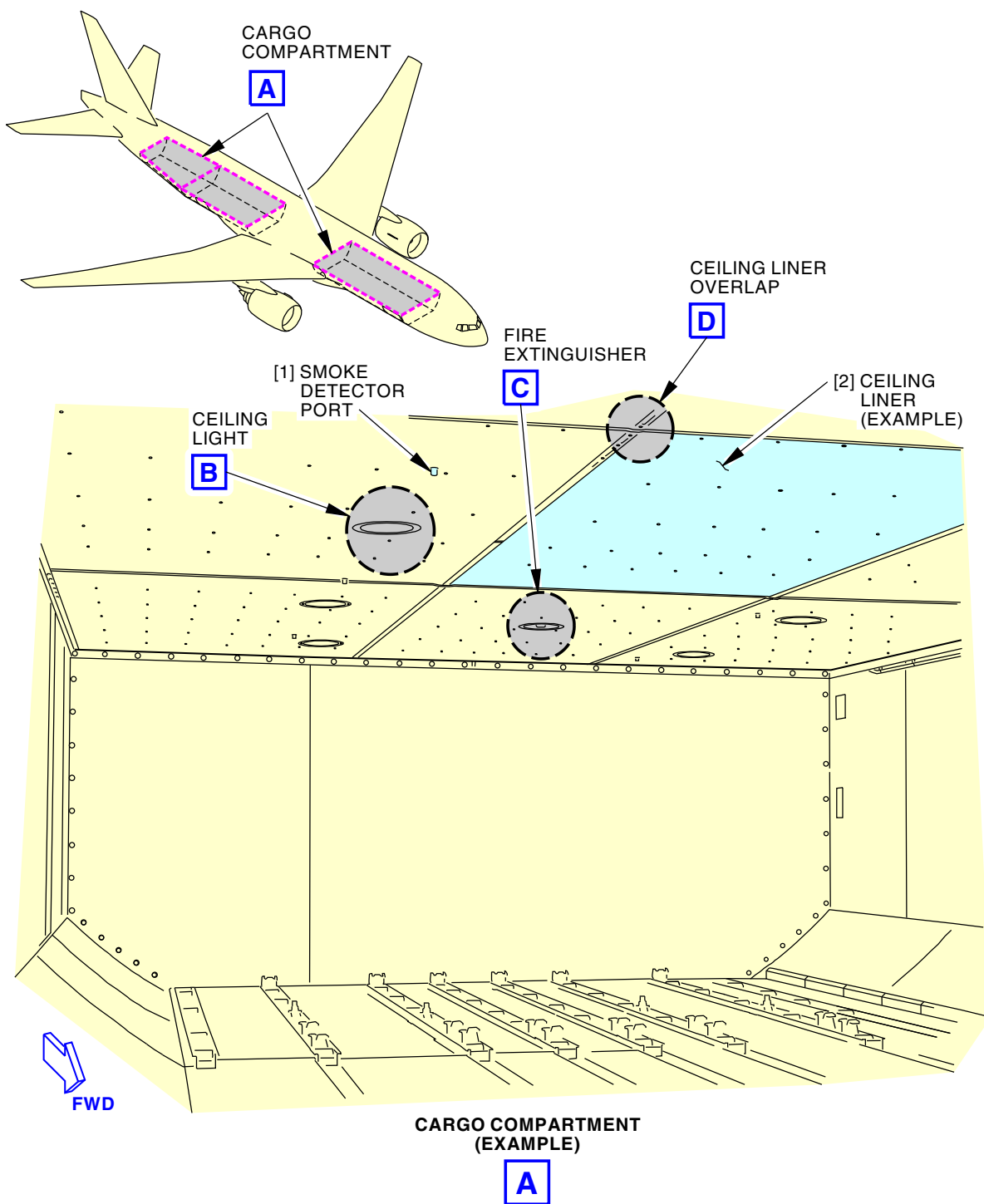
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EFFECTIVITY
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25-52-09

D633W101-ARO

Page 404
May 05/2017



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Ceiling Liner Installation
Figure 401/25-52-09-990-801 (Sheet 1 of 2)

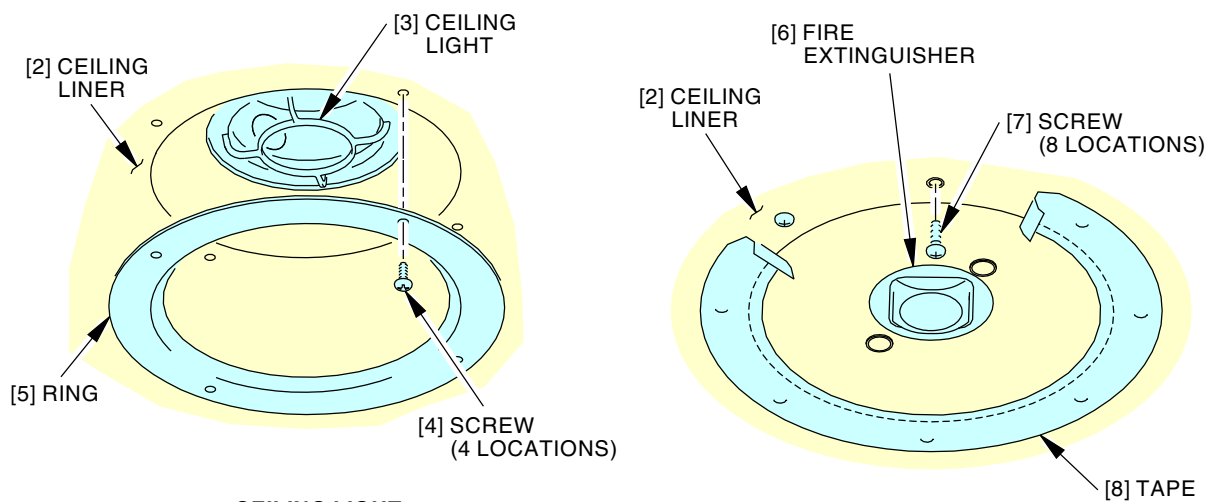
EFFECTIVITY
ARO ALL

25-52-09

D633W101-ARO

Page 405
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

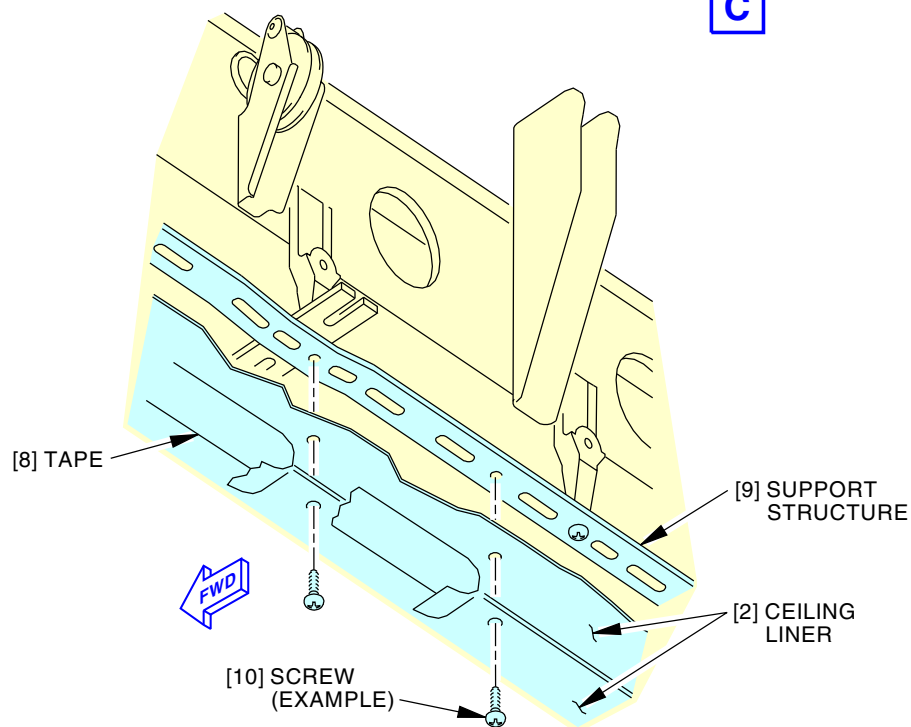


CEILING LIGHT

B

FIRE EXTINGUISHER

C



CEILING LINER OVERLAP

D

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**Ceiling Liner Installation
Figure 401/25-52-09-990-801 (Sheet 2 of 2)**

EFFECTIVITY
ARO ALL

25-52-09

D633W101-ARO

Page 406
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

FLOOR PANELS AND WALKWAYS - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) A removal of the floor panels and walkways in the forward and aft cargo compartments
- (2) An installation of the floor panels and walkways in the forward and aft cargo compartments.

B. The installation for the floor panels is the same as the walkways. The name depends on the location of the panels. This procedure refers to the floor panels and the walkways as the floor panels.

TASK 25-52-10-000-801

2. Floor Panels and Walkways Removal

(Figure 401, Figure 402)

A. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
52-34-00 P/B 201	FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES
52-35-00 P/B 201	AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES
52-36-00 P/B 201	BULK CARGO DOOR - MAINTENANCE PRACTICES

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-1996	Barrier - Safety, Bulk Cargo Door Part #: J52020-1 Supplier: 81205
SPL-2007	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205

C. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

D. Prepare for the Removal

SUBTASK 25-52-10-860-001

- (1) Do this task: Supply Electrical Power, TASK 24-22-00-860-805

SUBTASK 25-52-10-010-001

- (2) To open the applicable cargo compartment door, do the applicable task in the procedures that follow:

EFFECTIVITY
ARO ALL

25-52-10

D633W101-ARO

Page 401
May 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Forward cargo door: FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-34-00/201
- (b) Aft standard door: AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-35-00/201
- (c) Bulk door: BULK CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-36-00/201

SUBTASK 25-52-10-480-001

 WARNING	INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (3) Install the applicable safety barrier across the cargo door opening:
 - (a) For the forward cargo door: large cargo door safety barrier, SPL-1988
 - (b) For the standard cargo door: cargo door safety barrier, SPL-2007
 - (c) For the bulk cargo door: bulk cargo door safety barrier, SPL-1996

E. Floor Panels and Walkways Removal

SUBTASK 25-52-10-020-001

 CAUTION	THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT MUST ALWAYS BE INSTALLED. THIS IS TO PREVENT DAMAGE TO THE HYDRAULIC LINES OF THE NOSE LANDING GEAR. THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT CAN ONLY BE REMOVED FOR MAINTENANCE. AFTER YOU DO THE MAINTENANCE, INSTALL THE FLOOR PANELS. BE CAREFUL IF YOU DO WORK IN THE FORWARD CARGO COMPARTMENT WITH THE FLOOR PANELS REMOVED.

- (1) Remove the screws [2], [8] and washers [9] that attach the floor panel [1] to the support structure [6], [11].

SUBTASK 25-52-10-020-002

- (2) Remove the floor panel [1].

————— END OF TASK —————

TASK 25-52-10-400-801

3. Floor Panels and Walkways Installation

(Figure 401, Figure 402)

A. References

Reference	Title
24-22-00-860-806	Remove Electrical Power (P/B 201)
52-34-00 P/B 201	FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES
52-35-00 P/B 201	AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES
52-36-00 P/B 201	BULK CARGO DOOR - MAINTENANCE PRACTICES

EFFECTIVITY
ARO ALL

25-52-10

D633W101-ARO

Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-1996	Barrier - Safety, Bulk Cargo Door Part #: J52020-1 Supplier: 81205
SPL-2007	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
G00150	Tape - Nitto P-421 NAT (Formerly Permacel) PTFE Film Tape	

D. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

E. Floor Panels and Walkways Installation

SUBTASK 25-52-10-210-001

- (1) Make sure the tape on the support structure [6], [11] and the shear web [4] is smooth.

SUBTASK 25-52-10-960-001

- (2) If it is necessary to replace the tape, do the steps that follow:



CAUTION

BE CAREFUL WHEN YOU REMOVE THE TAPE. DO NOT CUT OR SCRATCH THE SUPPORT STRUCTURE OR SHEAR WEB. CUTS AND SCRATCHES IN THE SUPPORT STRUCTURE OR SHEAR WEB CAN INCREASE THE RISK OF CORROSION.

- (a) Remove the tape from the support structure [6], [11] or the shear web [4].
- (b) Use the solvent, B00083 to remove the remaining tape or adhesive from the support structure [6], [11] or shear web [4].
- (c) Install the Nitto P-421 tape, G00150 on the support structure [6], [11] or shear web [4] with a length the same as the width of the floor panel [1].

SUBTASK 25-52-10-820-001

- (3) Put the floor panel [1] in the correct location.

SUBTASK 25-52-10-210-002

- (4) For AFT Cargo Compartment floor and walkway panels at station 1885.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-10

Page 403
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Make sure the bulb seal [31] at the panel [1] edges is tucked under the protruding fasteners [32] on the side of the roller trays [30]. (Figure 402)

SUBTASK 25-52-10-420-001

- (5) Install the screws [2], [8] and washers [9] that attach the floor panel [1] to the support structure [6], [11] or shear web [4].

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-10-080-001

- (1) Remove the applicable safety barrier from the cargo door opening:
 - (a) For the forward cargo door: large cargo door safety barrier, SPL-1988
 - (b) For the standard aft cargo door: cargo door safety barrier, SPL-2007
 - (c) For the bulk cargo door: bulk cargo door safety barrier, SPL-1996

SUBTASK 25-52-10-860-002

- (2) To close the applicable cargo door, do the applicable task in the procedures that follow:
 - (a) For the forward cargo door: FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-34-00/201
 - (b) For the aft standard cargo door: AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-35-00/201
 - (c) For the bulk cargo door: BULK CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-36-00/201

SUBTASK 25-52-10-860-003

- (3) Do this task: Remove Electrical Power, TASK 24-22-00-860-806 if it is no longer necessary.

————— **END OF TASK** —————

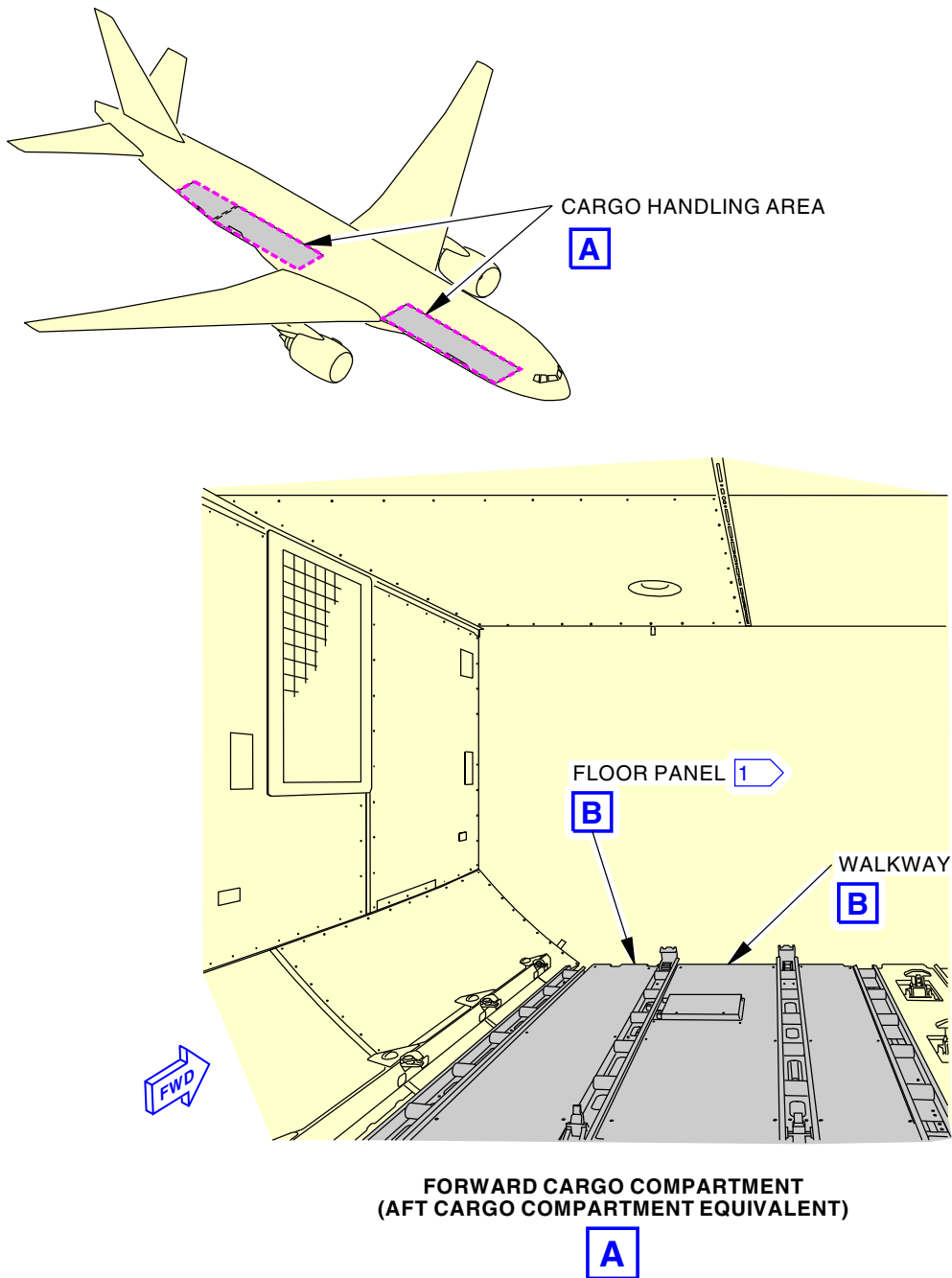
EFFECTIVITY
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25-52-10

D633W101-ARO

Page 404
Sep 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



1 THE INSTALLATION OF THE FLOOR PANELS AND WALKWAYS IS THE SAME.

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Floor Panel Installation
Figure 401/25-52-10-990-801 (Sheet 1 of 2)

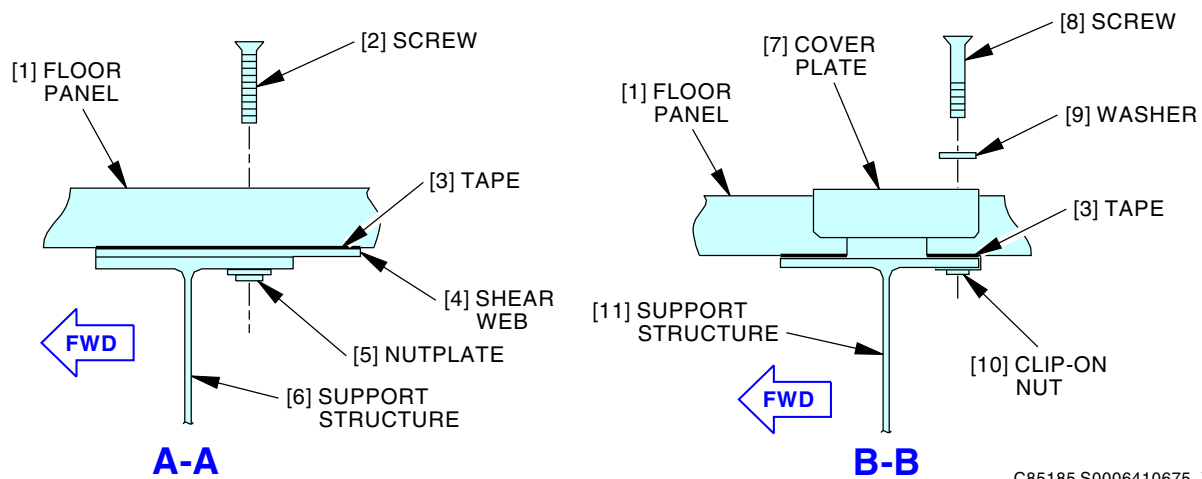
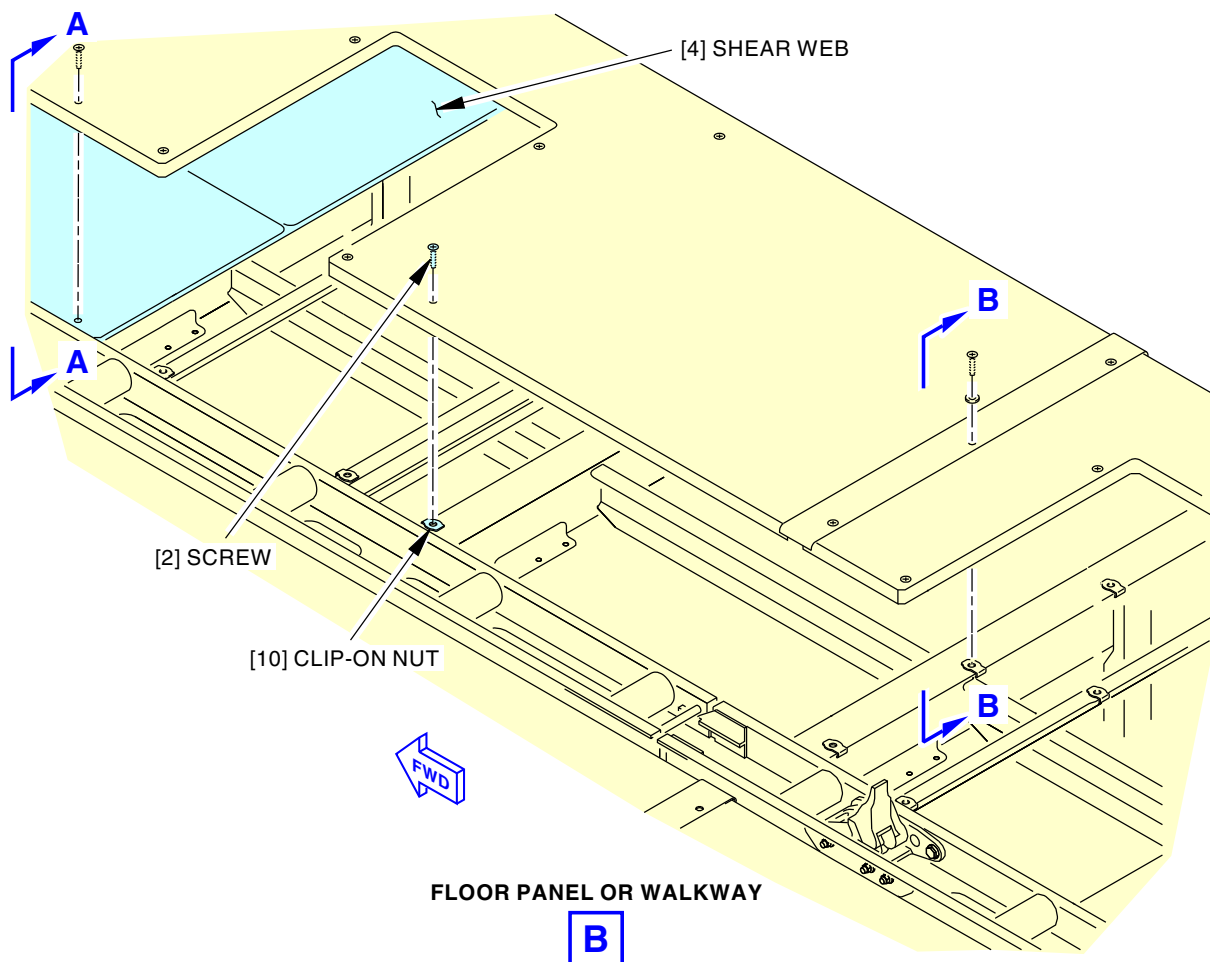
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25-52-10

Page 405
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Floor Panel Installation
Figure 401/25-52-10-990-801 (Sheet 2 of 2)**

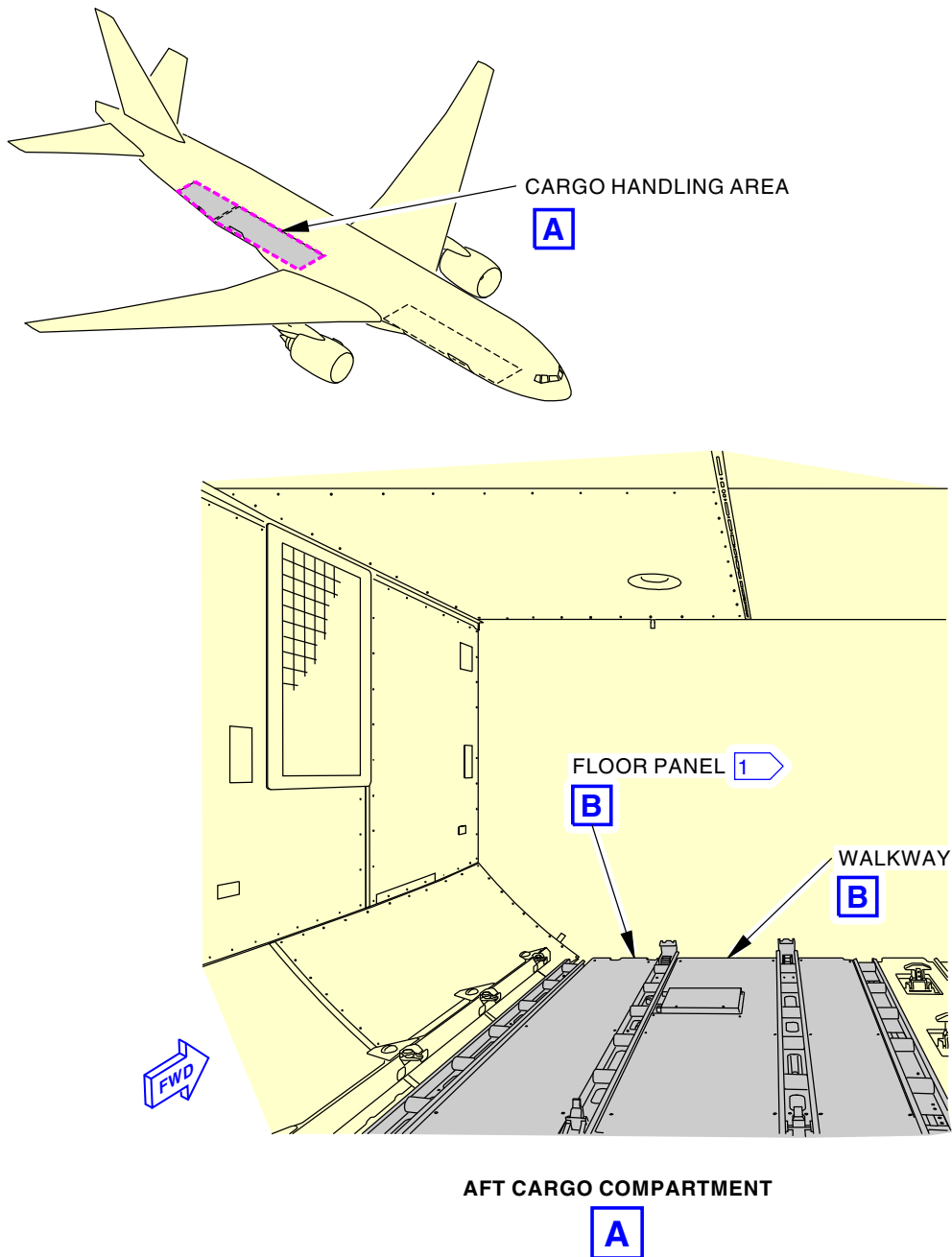
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25-52-10

D633W101-ARO

Page 406
May 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



1 THE INSTALLATION OF THE FLOOR PANELS AND WALKWAYS IS THE SAME.

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Floor and Walkway Panel - Bulb Seal, Aft Cargo Compartment Installation
Figure 402/25-52-10-990-802 (Sheet 1 of 6)

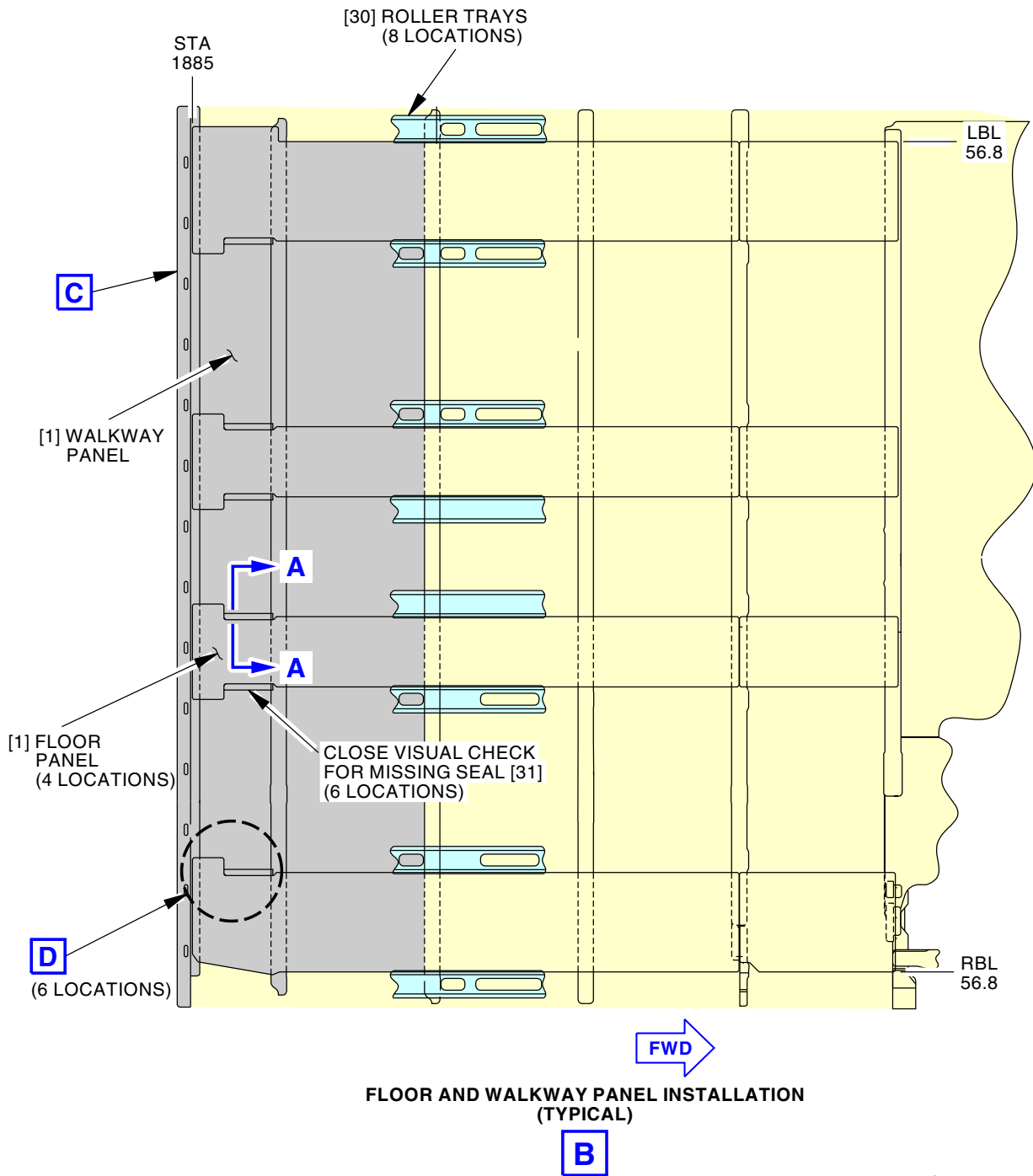
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25-52-10

Page 407
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



K97169 S0006410678_V2

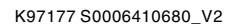
Floor and Walkway Panel - Bulb Seal, Aft Cargo Compartment Installation
Figure 402/25-52-10-990-802 (Sheet 2 of 6)

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25-52-10

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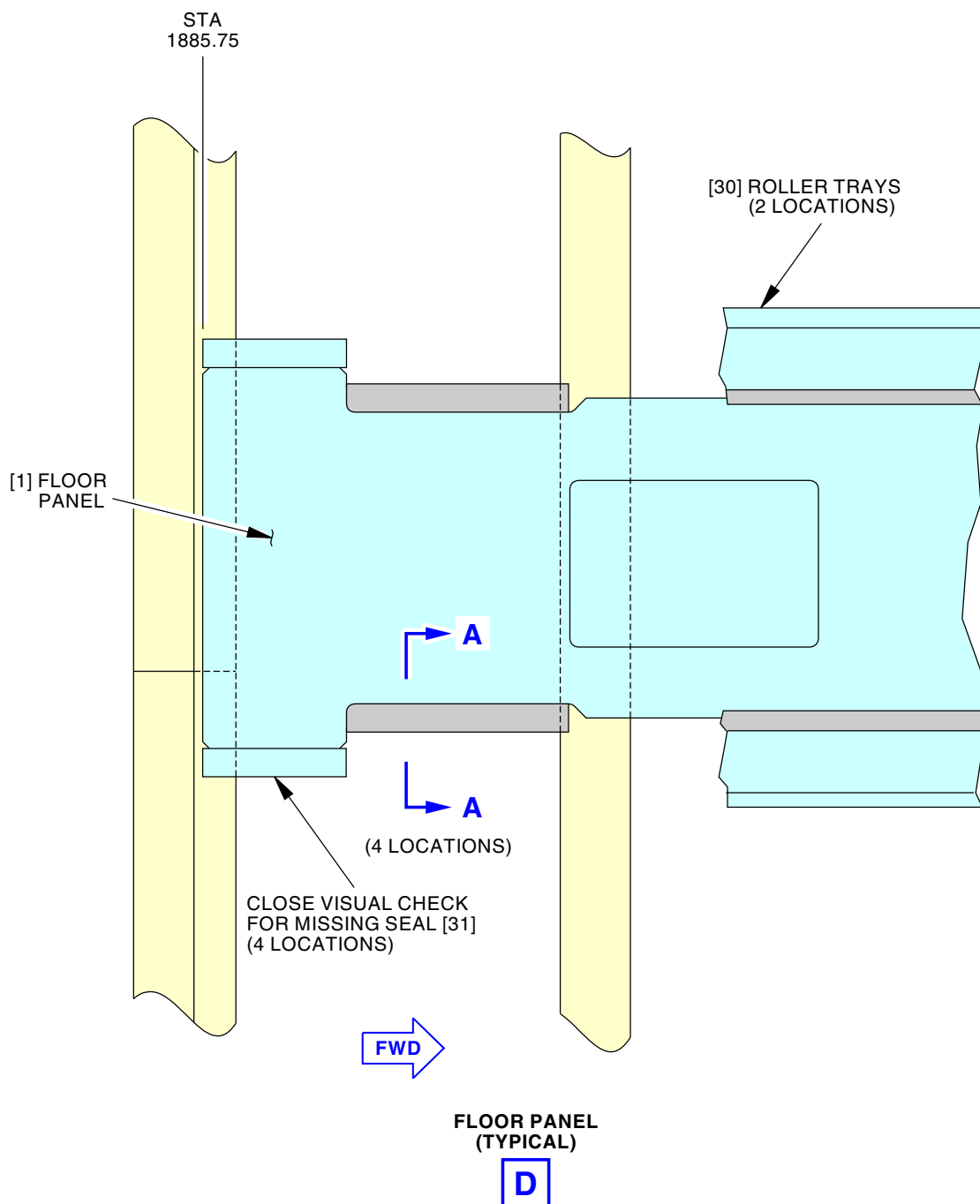
Page 408
May 05/2017



Floor and Walkway Panel - Bulb Seal, Aft Cargo Compartment Installation
Figure 402/25-52-10-990-802 (Sheet 3 of 6)

25-52-10

D633W101-ARO



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**Floor and Walkway Panel - Bulb Seal, Aft Cargo Compartment Installation
Figure 402/25-52-10-990-802 (Sheet 4 of 6)**

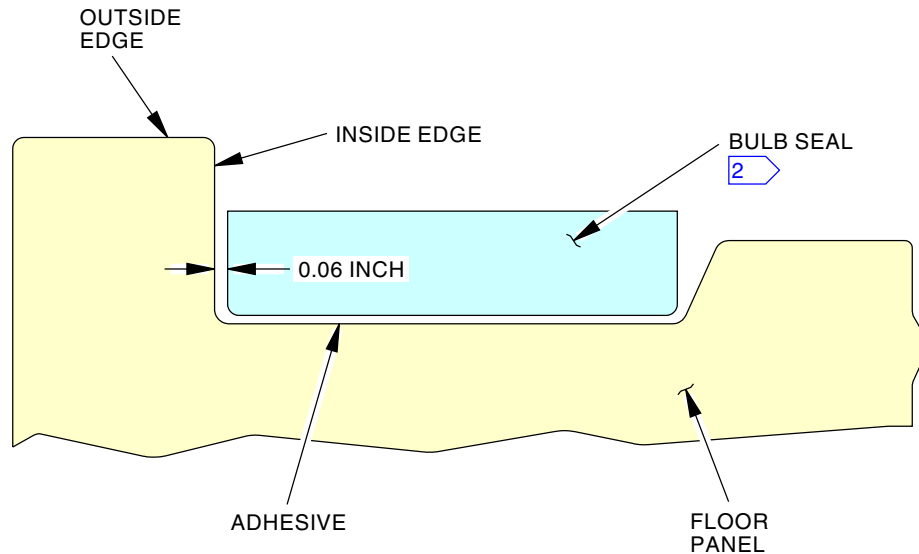
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25-52-10

D633W101-ARO

Page 410
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



**BULB SEAL
(TYPICAL)**

F

- 2** TRIM THE BULB SEAL FLUSH TO THE PANEL INSIDE EDGES.
THE MAXIMUM GAP BETWEEN THE BULB SEAL AND THE
FLOOR PANEL INSIDE EDGE IS 0.06 INCH

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Floor and Walkway Panel - Bulb Seal, Aft Cargo Compartment Installation
Figure 402/25-52-10-990-802 (Sheet 5 of 6)

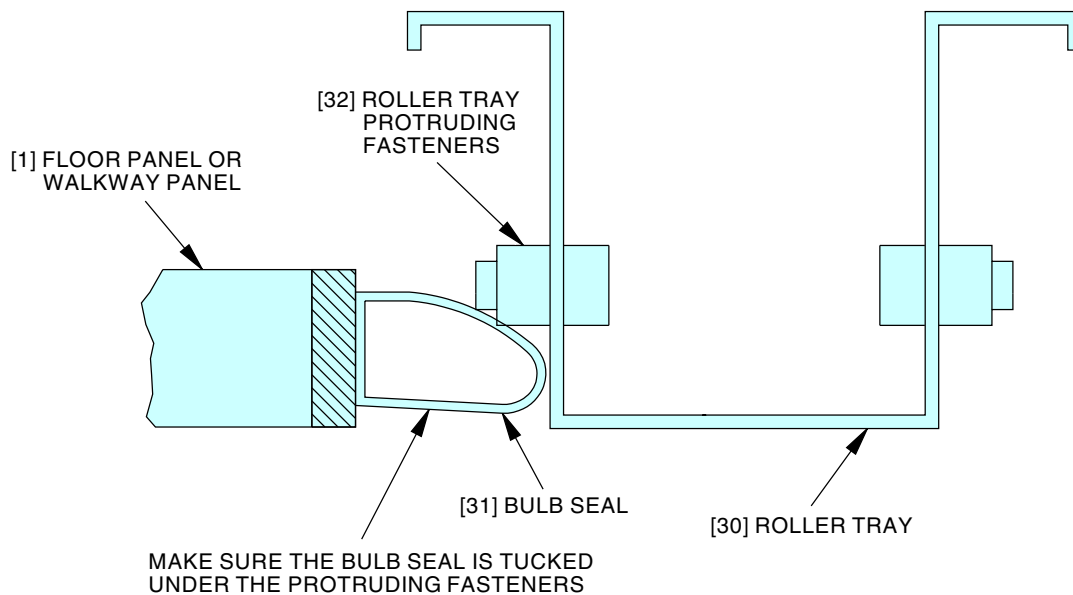
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25-52-10

D633W101-ARO

Page 411
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



BULB SEAL INSTALLATION

A-A

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Floor and Walkway Panel - Bulb Seal, Aft Cargo Compartment Installation
Figure 402/25-52-10-990-802 (Sheet 6 of 6)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-10

Page 412
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

BULK CARGO FLOOR - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the bulk cargo floor.
 - (2) An installation of the bulk cargo floor.

TASK 25-52-11-000-801

2. Bulk Cargo Floor Removal

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1996	Barrier - Safety, Bulk Cargo Door Part #: J52020-1 Supplier: 81205

B. Location Zones

Zone	Area
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

C. Prepare for the Removal

SUBTASK 25-52-11-480-001



WARNING

INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the bulk cargo door safety barrier, SPL-1996 across the cargo door opening.

D. Bulk Cargo Floor Removal

SUBTASK 25-52-11-020-001

- (1) Remove the bolts [5] that attach the anchor fittings [2] to the floor panel [6] and the floor structure [7].

SUBTASK 25-52-11-020-002

- (2) Remove the bolts [4] that attach the rub strip [1] to the floor panel [3] and the floor structure [7].

SUBTASK 25-52-11-020-003

- (3) Remove the bolts [9] and washers [8] that attach the floor panel [6] to the floor structure [10] and the adjacent floor panel.

SUBTASK 25-52-11-020-004

- (4) Remove the floor panel [6].

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

25-52-11

D633W101-ARO

Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-52-11-400-801

3. Bulk Cargo Floor Installation

(Figure 401)

A. References

Reference	Title
20-30-80-910-801	General Cleaning of Metal (Series 80) (P/B 201)
20-30-83-910-801	General Cleaning of Composites (Series 83) (P/B 201)
52-36-00 P/B 201	BULK CARGO DOOR - MAINTENANCE PRACTICES

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1996	Barrier - Safety, Bulk Cargo Door Part #: J52020-1 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
A00156	Adhesive - For Bonding Mylar And Nylon, 2 Part, RT Cure	BMS5-31
G02092	Tape - Flexible Foam Sound Damping And Sealing Tape	BMS8-283
G50007	Seal - Extruded Silicone Rubber, Fire Retardant	BAC1521-728 from BMS1-72

D. Location Zones

Zone	Area
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

E. Bulk Cargo Floor Installation

SUBTASK 25-52-11-210-001

- (1) Make sure the bulb seal [11] is bonded tightly to the floor panel [6], spaces are not permitted.
 - (a) If you see a space between the floor panel [6] and the sidewall support [12] replace the damaged bulb seal [11].
 - 1) Clean the floor panel [6] surface (TASK 20-30-80-910-801) (TASK 20-30-83-910-801).
 - 2) Cut the new bulb seal [7] seal, G50007, to the necessary length.
 - 3) Bond the bulb seal [11] to the floor panel [6] surface with adhesive, A00156.

SUBTASK 25-52-11-210-002

- (2) Make sure the foam tape [13], is tightly attached to the support [14] and is clean with a smooth, continuous surface.
 - (a) If you see a space between the foam tape [13] and the support [14], remove the damaged foam tape [13].
 - 1) Clean the support [14] surface. Refer to AMM 20-30-80.
 - 2) Cut the new foam tape, G02092 [13] to the necessary length.

EFFECTIVITY
ARO ALL

25-52-11

D633W101-ARO

Page 402
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 3) Remove the backing material from the foam tape and attach the tape to the support [14].

SUBTASK 25-52-11-820-001

- (3) Put the floor panel [6] on the floor structure [7], [10].

SUBTASK 25-52-11-420-001

- (4) Install the bolts [9] and washers [8] that attach the floor panel [6] to the floor structure [7], [10].

SUBTASK 25-52-11-420-002

- (5) Install the bolts [4] that attach the rub strip [1] to the floor panel [3] and the floor structure [7].

SUBTASK 25-52-11-420-003

- (6) Install the bolts [5] that attach the anchor fittings [2] to the floor panel [6] and the floor structure [7].

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-11-080-001

- (1) Remove the bulk cargo door safety barrier, SPL-1996.

SUBTASK 25-52-11-860-001

- (2) Close the cargo compartment door BULK CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-36-00/201.

————— END OF TASK —————

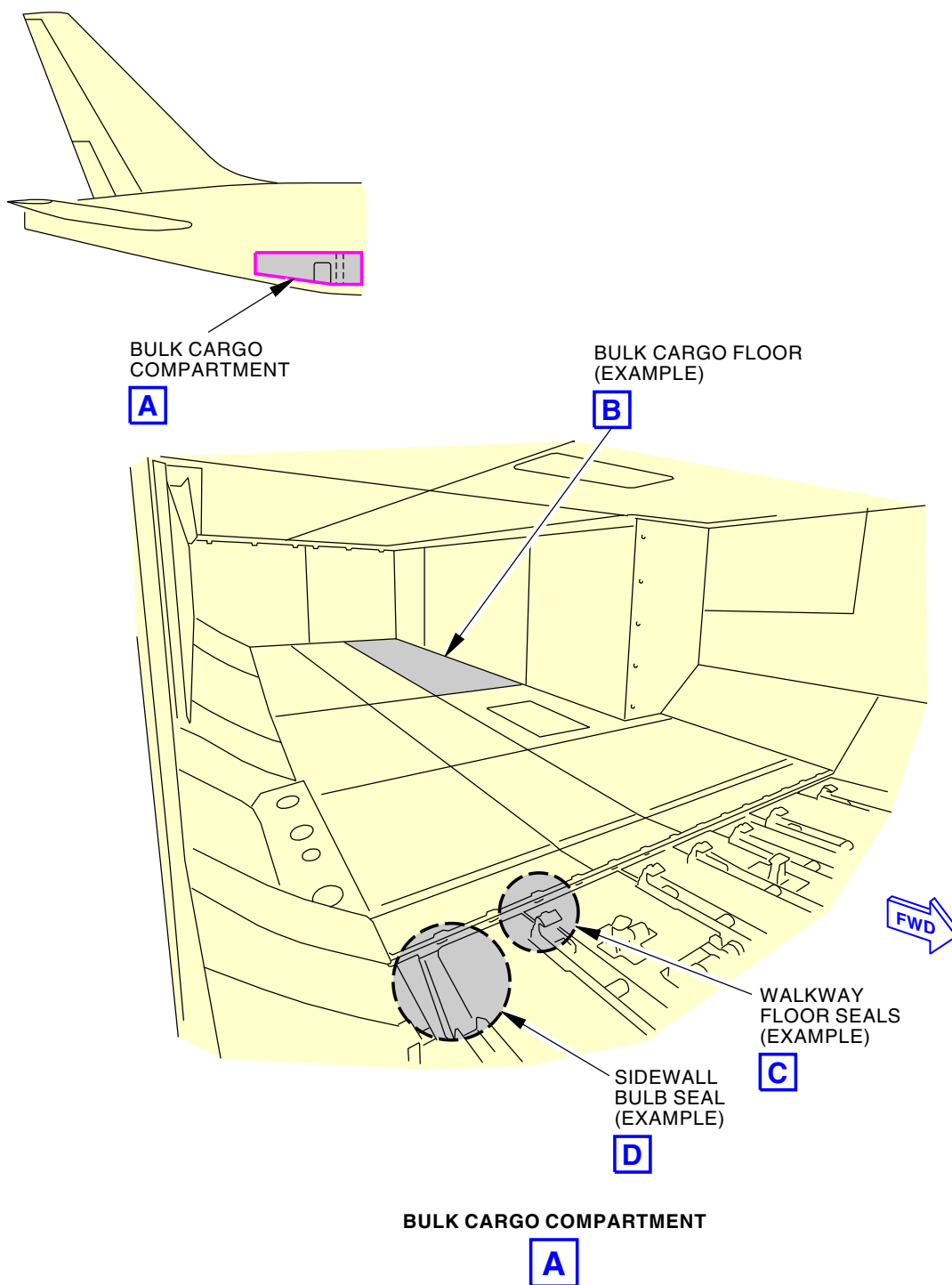
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25-52-11

D633W101-ARO

Page 403
Jan 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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Bulk Cargo Floor Installation
Figure 401/25-52-11-990-801 (Sheet 1 of 4)

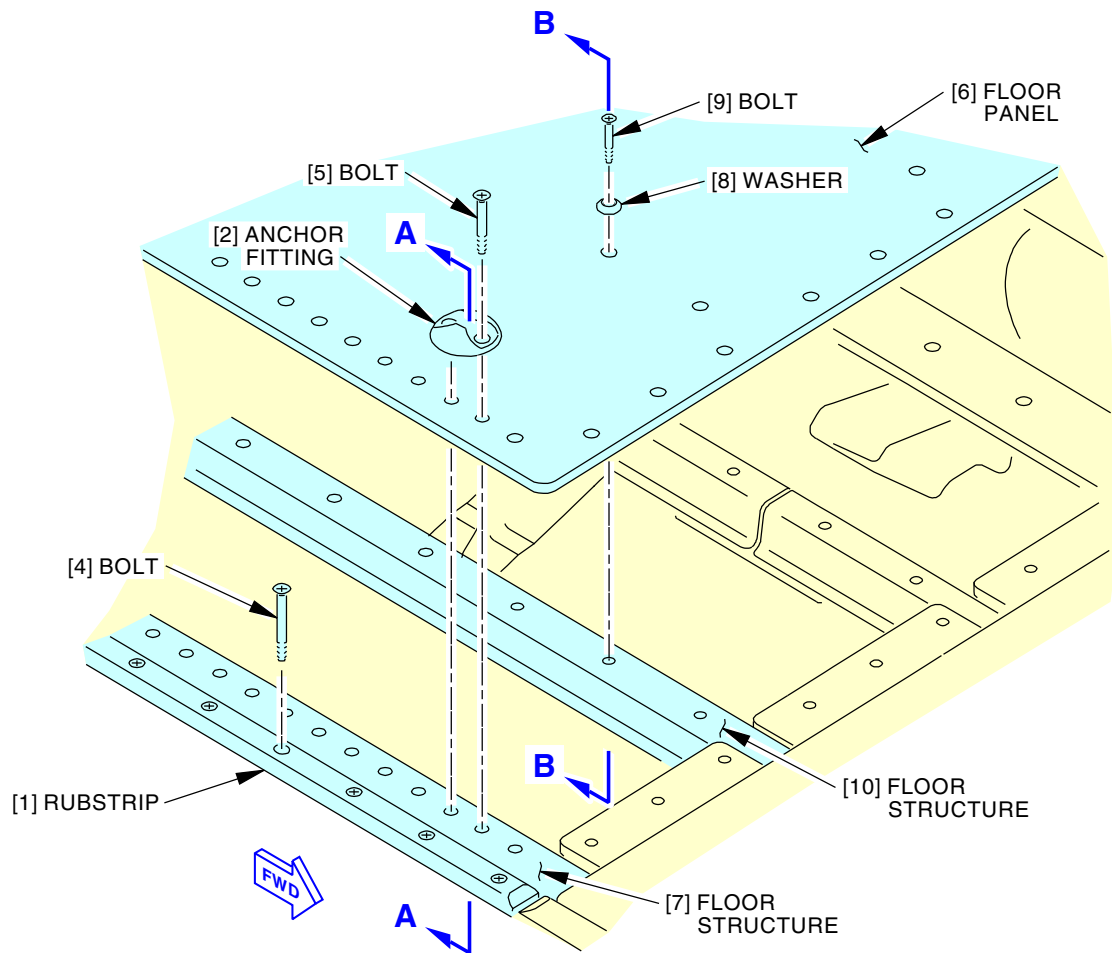
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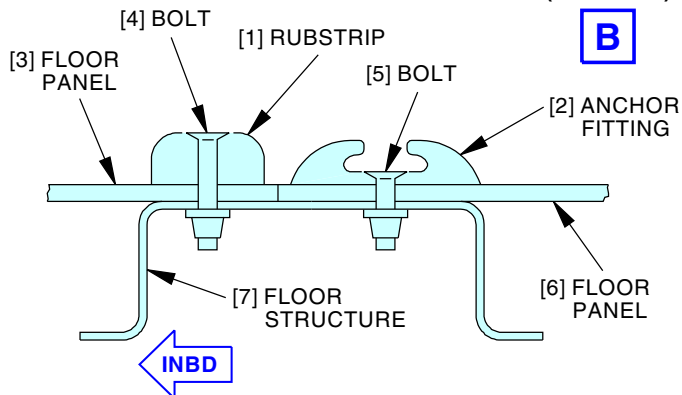
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Page 404
May 05/2017

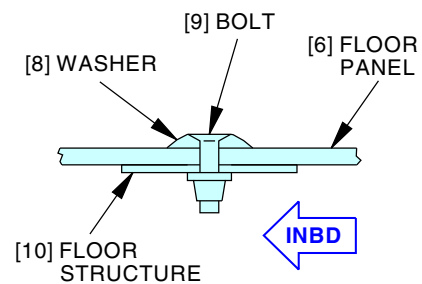
**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**BULK CARGO FLOOR
(EXAMPLE)**



A-A



B-B

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**Bulk Cargo Floor Installation
Figure 401/25-52-11-990-801 (Sheet 2 of 4)**

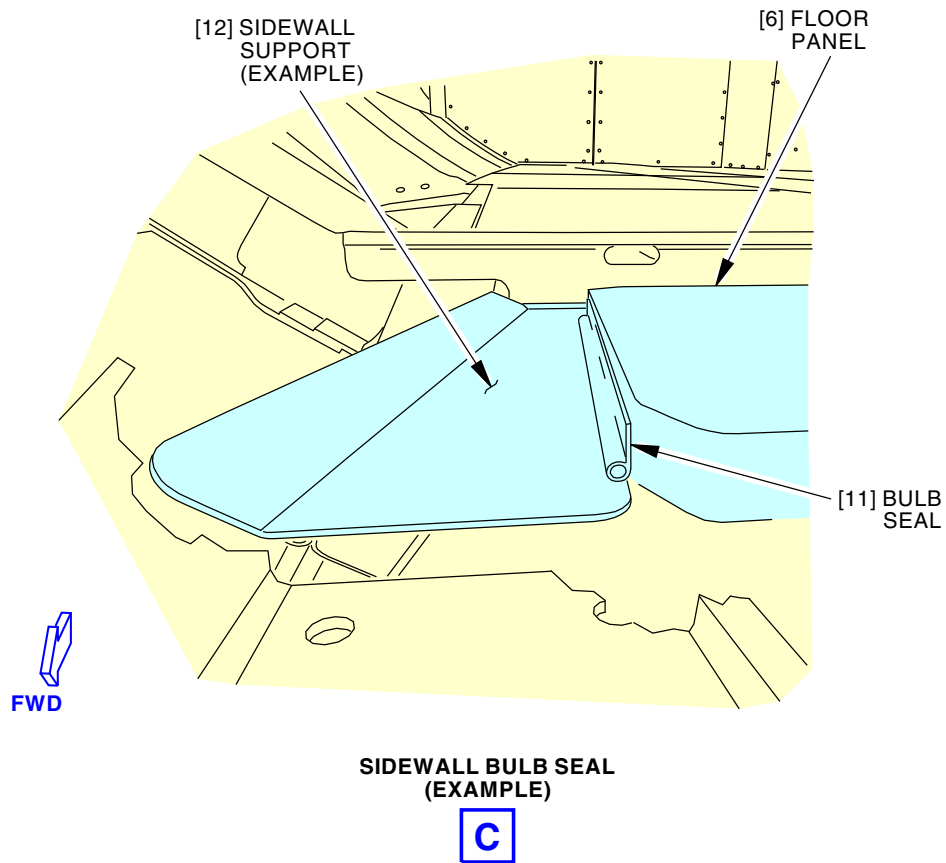
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25-52-11

Page 405
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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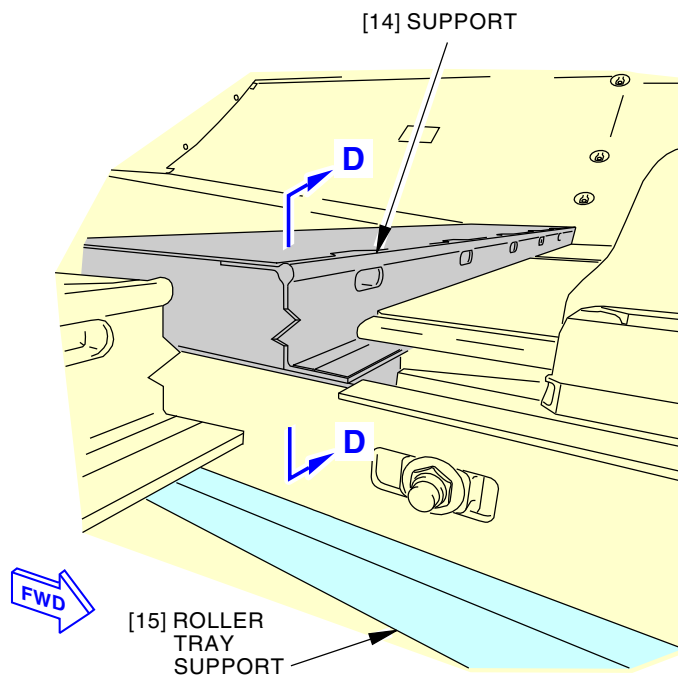
Bulk Cargo Floor Installation
Figure 401/25-52-11-990-801 (Sheet 3 of 4)

EFFECTIVITY	
ARO ALL	

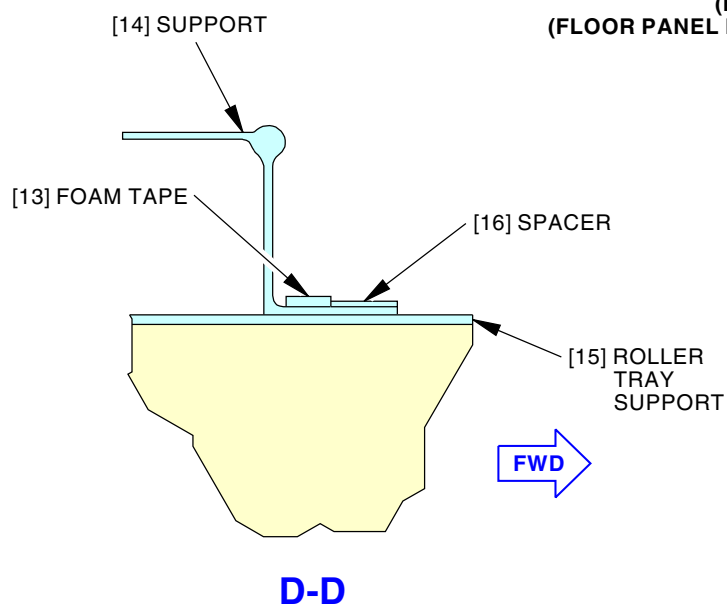
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25-52-11

Page 406
 May 05/2017



**WALKWAY FLOOR SEAL
(EXAMPLE)
(FLOOR PANEL REMOVED FOR CLARITY)**



K39711 S0006410697_V2

Bulk Cargo Floor Installation
Figure 401/25-52-11-990-801 (Sheet 4 of 4)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-11

Page 407
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

MAIN EQUIPMENT CENTER BULKHEAD LINER - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the access door for the main equipment center.
 - (2) An installation of the access door for the main equipment center.
 - (3) The removal of a panel that divides the main equipment center and the forward cargo compartment.
 - (4) The installation of a panel that divides the main equipment center and the forward cargo compartment.
- B. The main equipment center bulkhead liner is made of honeycomb panels. The hinged door in the upper left corner is to get access to the main equipment center.

TASK 25-52-16-000-801

2. Access Door Removal

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left

C. Prepare for the Removal

SUBTASK 25-52-16-480-001



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 across the cargo door opening.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-16

Page 401
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Access Door Removal

SUBTASK 25-52-16-010-001



CAUTION

THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT MUST ALWAYS BE INSTALLED. THIS IS TO PREVENT DAMAGE TO THE HYDRAULIC LINES OF THE NOSE LANDING GEAR. THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT CAN ONLY BE REMOVED FOR MAINTENANCE. AFTER YOU DO THE MAINTENANCE, INSTALL THE FLOOR PANELS. BE CAREFUL IF YOU DO WORK IN THE FORWARD CARGO COMPARTMENT WITH THE FLOOR PANELS REMOVED.

(1) Turn the latches [8] to open the access door [1].

SUBTASK 25-52-16-020-001

(2) Remove the screws [5] to disconnect the restraint [4] from the support.

SUBTASK 25-52-16-020-002

(3) Remove the screws [3] that attach the hinge [10] and the sidewall liner to the support structure.

SUBTASK 25-52-16-020-003

(4) Remove the access door [1].

————— **END OF TASK** —————

TASK 25-52-16-400-801

3. Access Door Installation

(Figure 401)

A. References

Reference	Title
52-34-00 P/B 201	FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Access door	25-17-51-05-005	ARO ALL

D. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left

E. Access Door Installation

SUBTASK 25-52-16-820-001

(1) Put the hinge [10] on the access door [1] against the support structure and the sidewall liner.

EFFECTIVITY
ARO ALL

25-52-16

D633W101-ARO

Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-52-16-420-005

- (2) Install the access door [1].

SUBTASK 25-52-16-420-001

- (3) Install the screws [3] that attach the hinge [10] and the sidewall liner to the support structure.
 - (a) Make sure the screws [3] go through the sidewall liner.

NOTE: The sidewall liner needs to be attached to the support structure for the cargo compartment to remain sealed.

SUBTASK 25-52-16-420-002

- (4) Install the screws [5] that attach the restraint [4] to the support.

SUBTASK 25-52-16-410-001

- (5) Close the access door [1].

SUBTASK 25-52-16-410-002

- (6) Turn the latches [8] to lock the access door [1] in the closed position.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-16-480-002

- (1) Remove the large cargo door safety barrier, SPL-1988 from the cargo door opening:

SUBTASK 25-52-16-860-002

- (2) Close the cargo compartment door FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-34-00/201.

————— END OF TASK —————

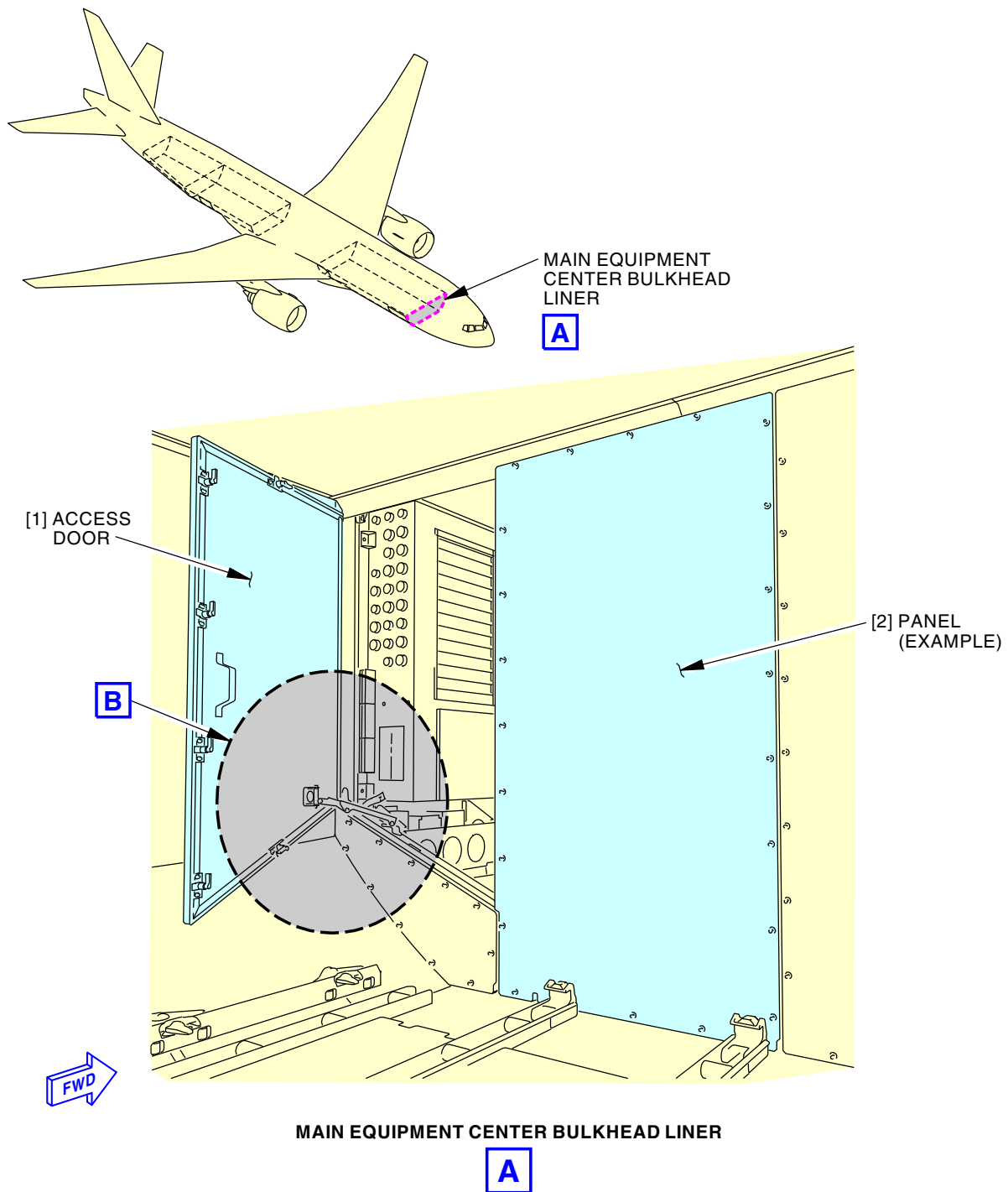
EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-16

Page 403
Sep 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Main Equipment Center Bulkhead Liner Installation
Figure 401/25-52-16-990-801 (Sheet 1 of 2)

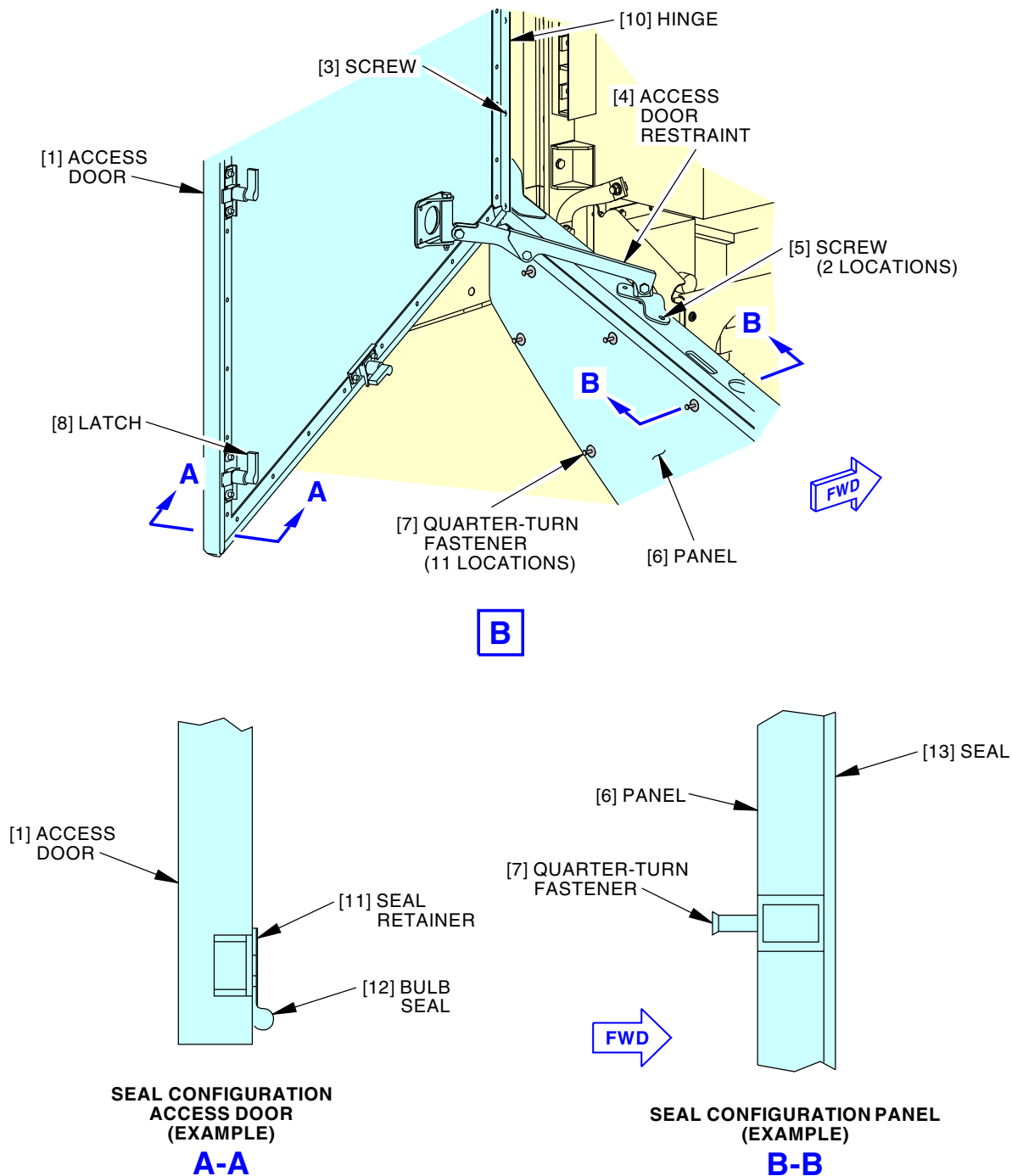
EFFECTIVITY
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25-52-16

D633W101-ARO

Page 404
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Main Equipment Center Bulkhead Liner Installation
Figure 401/25-52-16-990-801 (Sheet 2 of 2)**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-16

Page 405
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-52-16-000-802

4. Panel Removal

(Figure 401)

A. General

- (1) The main equipment center bulkhead liner consists of more than one panel. This task removes one of the panels. If it is necessary to remove the full bulkhead liner, do this task again for the remaining panels.

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363

C. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right

D. Prepare for the Removal

SUBTASK 25-52-16-420-003



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 across the cargo door opening.

E. Panel Removal

SUBTASK 25-52-16-020-004



ALWAYS INSTALL THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT IMMEDIATELY AFTER YOU DO MAINTENANCE. IF YOU DO NOT INSTALL THE FLOOR PANELS, DAMAGE TO THE HYDRAULIC LINES OF THE NOSE LANDING GEAR CAN OCCUR.

- (1) Turn the quarter-turn fasteners [7] counterclockwise.

SUBTASK 25-52-16-020-005

- (2) Remove the panel [2] or panel [6].

————— END OF TASK —————

EFFECTIVITY
ARO ALL

25-52-16

D633W101-ARO

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Page 406
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-52-16-400-802

5. Panel Installation

(Figure 401)

A. References

Reference	Title
52-34-00 P/B 201	FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
2	Panel	25-17-51-05-550	ARO ALL
		25-17-51-05-600	ARO ALL
		25-17-51-05-640	ARO ALL
		25-17-51-05-700	ARO ALL
6	Panel	25-17-51-05-505	ARO ALL

D. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right

E. Panel Installation

SUBTASK 25-52-16-820-002

- (1) Put the panel [2] or panel [6] in the correct location with the seal [13] against the support structure.

SUBTASK 25-52-16-420-004

- (2) Turn the quarter-turn fasteners [7] clockwise.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-16-080-001

- (1) Remove the large cargo door safety barrier, SPL-1988 from the cargo door opening:

SUBTASK 25-52-16-860-001

- (2) Close the cargo door FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-34-00/201.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-52-16

D633W101-ARO

Page 407
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

FORWARD CARGO COMPARTMENT AFT END WALL - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Removal of the forward cargo compartment aft end wall
 - (2) Installation of the forward cargo compartment aft end wall
- B. The forward cargo compartment aft end wall is an access to the ECS Mix Bay.
- C. The forward cargo compartment aft end wall is made of a neoprene-coated fiberglass panel. This procedure refers to the end wall as the panel.

TASK 25-52-17-000-801

2. Forward Cargo Compartment Aft End Wall Removal

(Figure 401)

A. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
52-34-00 P/B 201	FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363

C. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right

D. Prepare for the Removal

SUBTASK 25-52-17-860-001

- (1) Do this task: Supply Electrical Power, TASK 24-22-00-860-805

SUBTASK 25-52-17-860-002

- (2) Open the cargo compartment door FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-34-00/201

SUBTASK 25-52-17-480-001



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (3) Install the large cargo door safety barrier, SPL-1988 across the cargo door opening:

EFFECTIVITY
ARO ALL

25-52-17

D633W101-ARO

Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

E. Forward Cargo Compartment Aft End Wall Removal

SUBTASK 25-52-17-020-001



ALWAYS INSTALL THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT IMMEDIATELY AFTER YOU DO MAINTENANCE. IF YOU DO NOT INSTALL THE FLOOR PANELS, DAMAGE TO THE HYDRAULIC LINES OF THE NOSE LANDING GEAR CAN OCCUR.

- (1) Pull the panel [2] away from the support structure [1] to disconnect the snaps [3].

————— END OF TASK —————

TASK 25-52-17-400-801

3. Forward Cargo Compartment Aft End Wall Installation

(Figure 401)

A. References

Reference	Title
24-22-00-860-806	Remove Electrical Power (P/B 201)
52-34-00 P/B 201	FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363

C. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right

D. Forward Cargo Compartment Aft End Wall Installation

SUBTASK 25-52-17-420-001

- (1) Push the snaps [3] to attach the panel [2] to the support structure [1].

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-17-080-001

- (1) Remove the large cargo door safety barrier, SPL-1988 from the cargo door opening.

SUBTASK 25-52-17-410-001

- (2) Close the cargo compartment door FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-34-00/201.

SUBTASK 25-52-17-860-003

- (3) Do this task if it is necessary: Remove Electrical Power, TASK 24-22-00-860-806

————— END OF TASK —————

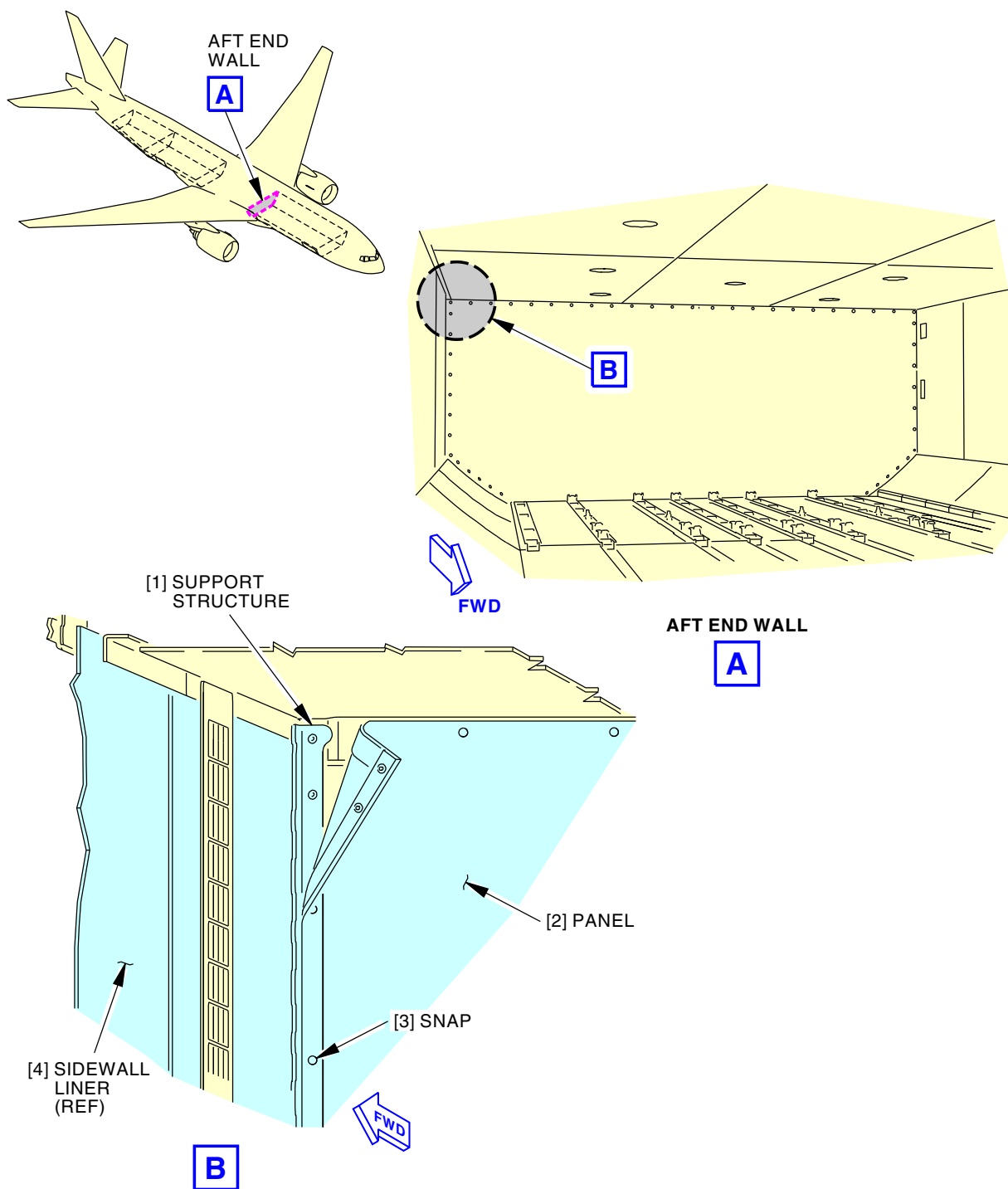
EFFECTIVITY
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25-52-17

D633W101-ARO

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Page 402
Sep 05/2017



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**Forward Cargo Compartment Aft End Wall Installation
Figure 401/25-52-17-990-801**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-17

Page 403
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

AFT CARGO COMPARTMENT- FORWARD END WALL - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Removal of the aft cargo compartment forward end wall.
 - (2) An installation of the aft cargo compartment forward end wall.
- B. The aft cargo compartment forward end wall is made of fiberglass panels.

TASK 25-52-18-000-801

2. Aft Cargo Compartment Forward End Wall Removal

(Figure 401)

A. **General**

- (1) This task removes one of the panels that makes the aft cargo compartment forward end wall. Do this task for the remaining panels if it is necessary to remove the full end wall.

B. **References**

Reference	Title
52-35-00 P/B 201	AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES

C. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1640	Tool - Removal, Scrivet Fastener Part #: ST991A-2 Supplier: 81205
SPL-2007	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205

D. **Location Zones**

Zone	Area
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

E. **Prepare for the Removal**

SUBTASK 25-52-18-010-002

- (1) To open the applicable cargo door, do the applicable tasks in the procedures that follow:
 - (a) For the standard cargo door: AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-35-00/201

SUBTASK 25-52-18-480-001

 WARNING	INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (2) Install the applicable safety barrier across the cargo door opening:
 - (a) For the standard cargo door: cargo door safety barrier, SPL-2007

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-18

Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

F. Aft Cargo Compartment Forward End Wall Removal

SUBTASK 25-52-18-020-001

- (1) Remove and discard the tape [7] from the panel [2], [6].

SUBTASK 25-52-18-020-002

- (2) Use the scrivet fastener tool, SPL-1640 to disconnect the scrivets [4] that attach the panel [2], [6], to the support structure [3].

SUBTASK 25-52-18-020-003

- (3) Carefully remove the applicable panel [2], [6], from the support structure [3].

NOTE: There is hook and loop fastener tape [1] that holds the panels to the support structure.

————— **END OF TASK** —————

TASK 25-52-18-400-801

3. Aft Cargo Compartment Forward End Wall Installation

(Figure 401)

A. References

Reference	Title
24-22-00-860-806	Remove Electrical Power (P/B 201)
52-35-00 P/B 201	AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-2007	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
G50428	Tape - Nitto P-629 (Formerly Permacel) Cargo Pit Seam Tape	BMS5-146

D. Location Zones

Zone	Area
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

E. Aft Cargo Compartment Forward End Wall Installation

SUBTASK 25-52-18-420-001

- (1) Align the hook and loop fastener tape [1] to hold the panel [2], [6] against the support structure [3].

SUBTASK 25-52-18-420-002

- (2) Attach the panel [2], [6] to the support structure [3] with the scrivets [4].

SUBTASK 25-52-18-420-003

- (3) Do these steps to install new Nitto P-629 tape, G50428 [7] at the panel [2], [6] joints:
 - (a) Make sure the tape [7] extends the height of the compartment.
 - (b) Align the center of the tape [7] over the scrivets [4].

EFFECTIVITY
ARO ALL

25-52-18

D633W101-ARO

Page 402
May 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

(c) Rub the length of the tape [7] to make sure the surface is smooth and continuous.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-18-080-001

- (1) Remove the applicable safety barrier from the cargo door opening:
- (a) For the standard cargo door: cargo door safety barrier, SPL-2007

SUBTASK 25-52-18-410-001

- (2) To close the applicable cargo door follow the tasks in this procedure:
- (a) For the standard cargo door: AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-35-00/201

SUBTASK 25-52-18-860-002

- (3) Do this task: Remove Electrical Power, TASK 24-22-00-860-806 if it is no longer required.

———— **END OF TASK** ————

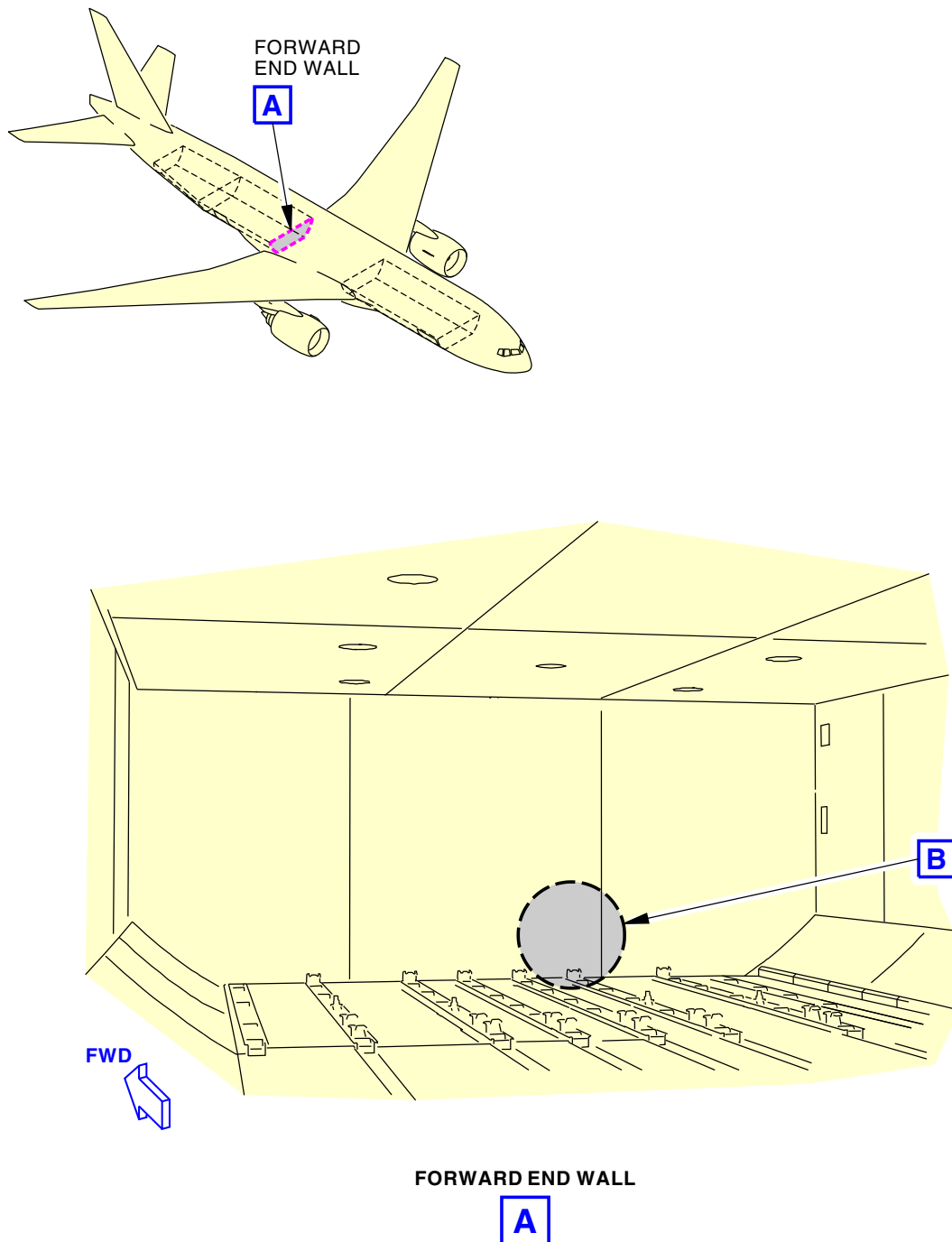
EFFECTIVITY
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D633W101-ARO

25-52-18

Page 403
May 05/2015

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777-200/300
AIRCRAFT MAINTENANCE MANUAL



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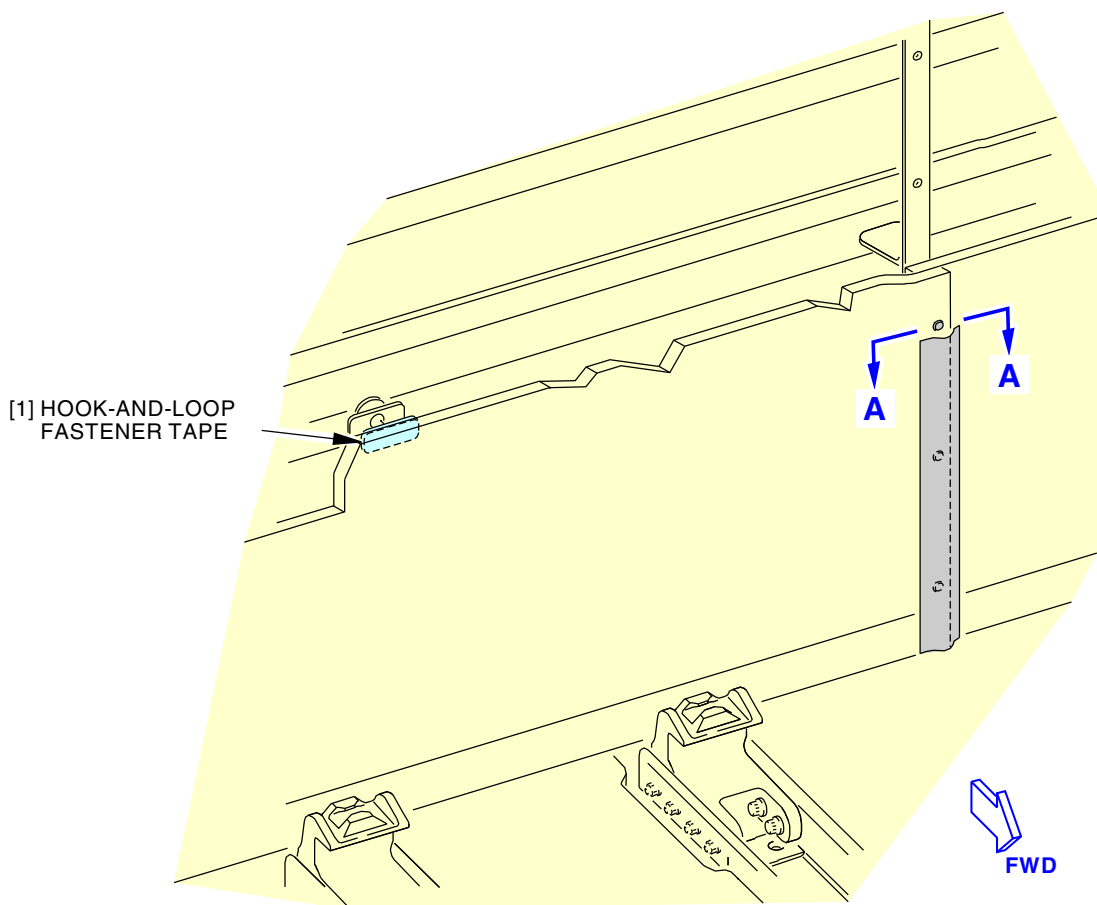
Aft Cargo Compartment Forward End Wall Installation
Figure 401/25-52-18-990-801 (Sheet 1 of 2)

EFFECTIVITY
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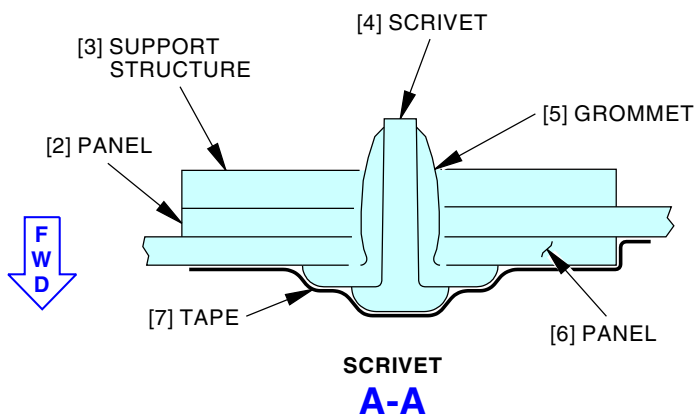
25-52-18

D633W101-ARO

Page 404
 May 05/2017



B



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Aft Cargo Compartment Forward End Wall Installation
Figure 401/25-52-18-990-801 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

25-52-18

D633W101-ARO

Page 405
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

BULK CARGO COMPARTMENT - AFT END WALL - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) Removal of the bulk cargo compartment aft end wall
- (2) Installation of the bulk cargo compartment aft end wall

TASK 25-52-19-000-801

2. Bulk Cargo Compartment Aft End Wall Removal

(Figure 401)

A. **General**

- (1) This task removes one of the panels that makes up the bulk cargo compartment aft end wall. Do this task for the remaining panels if it is necessary to remove the full end wall.

B. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1996	Barrier - Safety, Bulk Cargo Door Part #: J52020-1 Supplier: 81205

C. **Location Zones**

Zone	Area
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

D. **Prepare for the Removal**

SUBTASK 25-52-19-480-001

 WARNING	INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the bulk cargo door safety barrier, SPL-1996 across the bulk cargo door opening.

E. **Bulk Cargo Compartment Aft End Wall Removal**

SUBTASK 25-52-19-020-001

- (1) Turn the quick-release fasteners [6] counterclockwise.

SUBTASK 25-52-19-020-002

- (2) Turn the latches [1] that attach the panel [3], panel [5] to the upper support [2].

SUBTASK 25-52-19-020-003

- (3) Carefully remove the panel [3], panel [5].

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-19

Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-52-19-400-801

3. Bulk Cargo Compartment Aft End Wall Installation

(Figure 401)

A. References

Reference	Title
20-30-80-910-801	General Cleaning of Metal (Series 80) (P/B 201)
20-30-83-910-801	General Cleaning of Composites (Series 83) (P/B 201)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1996	Barrier - Safety, Bulk Cargo Door Part #: J52020-1 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
A00156	Adhesive - For Bonding Mylar And Nylon, 2 Part, RT Cure	BMS5-31
G50532	Tape - Silicone, Foam	BMS1-68

D. Location Zones

Zone	Area
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

E. Bulk Cargo Compartment Aft End Wall Installation

SUBTASK 25-52-19-210-001

- (1) Make sure the foam tape, G50532 [7] is bonded tightly to the panel [5], spaces are not permitted.
 - (a) If you see a space between the panel [5], panel [3] or support structure [4], replace the damaged bulb seal [11].
 - 1) Clean the panel [5] surface (TASK 20-30-80-910-801) (TASK 20-30-83-910-801).
 - 2) Cut the new foam tape, G50532 [7], to the necessary length.
 - 3) Bond the foam tape, G50532 [7] to the panel [5] surface with adhesive, A00156.

SUBTASK 25-52-19-420-001

- (2) Put the panel [3], panel [5] against the support structure [4].

SUBTASK 25-52-19-420-002

- (3) Turn the quick-release fasteners [6] clockwise to attach the panel [3], panel [5] to the support structure [4].

SUBTASK 25-52-19-420-003

- (4) Turn the latches [1] to hold the panel [3], panel [5] against the upper support [2].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-52-19

Page 402
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-19-080-001

- (1) Remove the bulk cargo door safety barrier, SPL-1996.

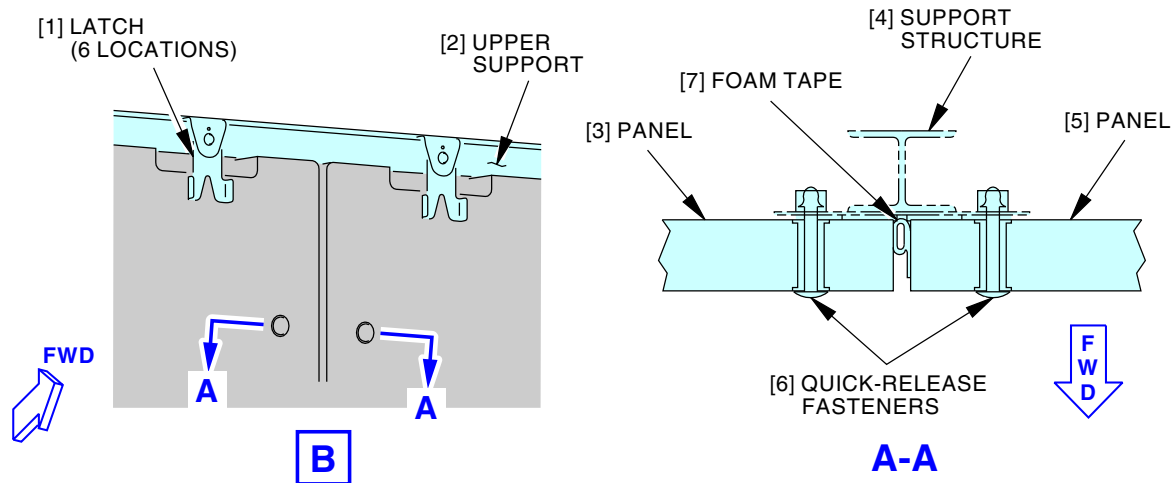
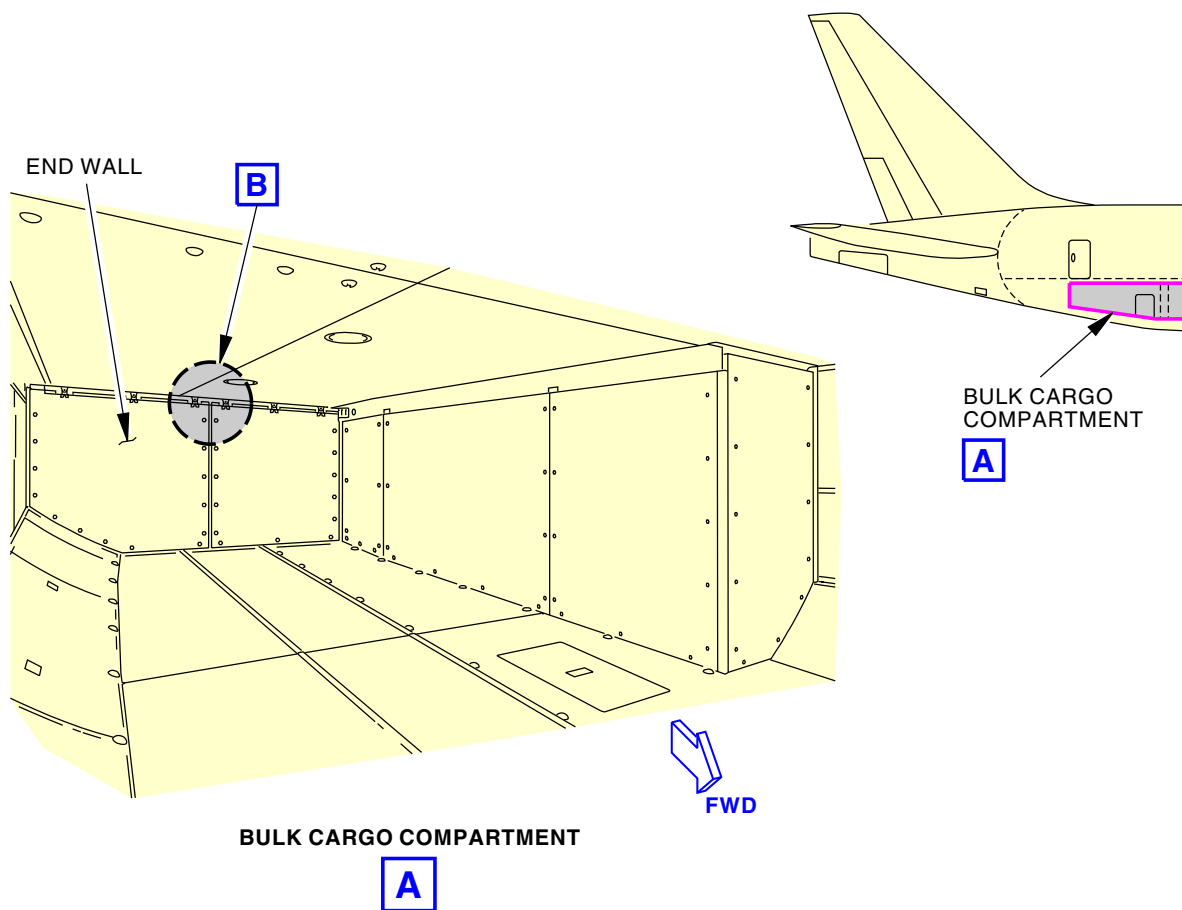
———— **END OF TASK** ————

EFFECTIVITY
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D633W101-ARO

25-52-19

Page 403
May 05/2017



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Bulk Cargo Compartment Aft End Wall Panels Installation
Figure 401/25-52-19-990-801

EFFECTIVITY
ARO ALL

25-52-19

D633W101-ARO

Page 404
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

WASTE TANK ENCLOSURE PANELS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the waste tank enclosure panels.
 - (2) An installation of the waste tank enclosure panels.
- B. The waste tank enclosure provides access to the waste tank components and the logic control modules. The panels are nomex honeycomb.

TASK 25-52-20-000-801

2. Waste Tank Enclosure Panels Removal

(Figure 401)

A. **General**

- (1) This task removes one of the panels that make up the waste tank enclosure. Do this task for the remaining panels if it is necessary to remove the full enclosure.

B. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-1996	Barrier - Safety, Bulk Cargo Door Part #: J52020-1 Supplier: 81205

C. **Location Zones**

Zone	Area
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

D. **Prepare for the Removal**

SUBTASK 25-52-20-480-001



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the bulk cargo door safety barrier, SPL-1996 across the cargo door opening.

E. **Waste Tank Enclosure Panel Removal**

SUBTASK 25-52-20-020-001

- (1) Turn the quick-release fasteners [4] counterclockwise.

SUBTASK 25-52-20-020-002

- (2) Carefully remove the panel [1] from the support structure [3].
 - (a) It can be necessary to remove smoke barrier seals attached or bonded to the waste tank enclosure panels.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

25-52-20

D633W101-ARO

Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-52-20-400-801

3. Waste Tank Enclosure Panels Installation

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-1996	Barrier - Safety, Bulk Cargo Door Part #: J52020-1 Supplier: 81205

B. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
A00225	Compound - Two Part Hole Filling, Polysulfide	BMS5-16
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
G02092	Tape - Flexible Foam Sound Damping And Sealing Tape	BMS8-283
G50024	Seal - Extruded Silicone Rubber, Fire Retardant	BAC1521-827 from BMS1-72
G50428	Tape - Nitto P-629 (Formerly Permacel) Cargo Pit Seam Tape	BMS5-146

C. Location Zones

Zone	Area
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

D. Waste Tank Enclosure Panels Installation

SUBTASK 25-52-20-210-001

- (1) Make sure the tape, G02092 [2] behind the panel is clean and has a smooth, continuous surface.
 - (a) Replace the tape, G02092 [2] if it is necessary.

SUBTASK 25-52-20-210-002

- (2) Make sure the bulb seal [5] is bonded tightly to the panel [1], spaces are not permitted.
 - (a) If you see a space between the forward waste tank enclosure panel and the sidewall panel. Replace the damaged bulb seal, G50024 [5].
 - 1) Clean the upper surface of the forward waste tank enclosure panel [1] where the bulb seal is attached.
 - 2) Cut the new bulb seal, G50024 [5], to the necessary length.
 - 3) Bond the bulb seal [5] to the edge of the forward waste tank enclosure panel, use adhesive, A00027.

SUBTASK 25-52-20-390-001

- (3) Make sure the Nitto P-629 tape, G50428 [6], is tightly attached to the forward support [7] and the upper support [8].

EFFECTIVITY
ARO ALL

25-52-20

D633W101-ARO

Page 402
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) It can be necessary to remove and replace the Nitto P-629 tape, G50428 [6], that is attached to the forward [7] and upper [8] supports.
 - 1) The tape must be clean with a smooth, continuous surface.
 - 2) If you see a space between the tape [6] and the forward support [7] and the upper support [8], remove the damaged tape [6].
 - 3) Clean the forward support [7] and the upper support [8] surfaces. Refer to AMM 20-30-80.
 - 4) Cut the new Nitto P-629 tape, G50428 [6] to the necessary length.
 - 5) Remove the backing material from the tape [6] and attach to the forward support [7] and the upper support [8].

SUBTASK 25-52-20-390-002

- (4) Make sure the sealant, A00247 [11], between support [9] and clip [12] is in satisfactory condition. There are no cracks.
 - (a) It can be necessary to remove the old sealant, A00247 [11], used to fill the space between support [9] and clip [12].
 - 1) Clean the support [9] and clip [12] surfaces. Refer to AMM 20-30-80.
 - 2) Apply new sealant, A00247 [11] to fill the space between support [9] and clip [12].

SUBTASK 25-52-20-390-003

- (5) Make sure the sealant compound, A00225 [14], between clip [12] and bracket [13] is in satisfactory condition. There are no cracks.
 - (a) It can be necessary to remove the old sealant compound, A00225 [14], used to fill the gap between clip [12] and bracket [13].
 - 1) Clean the clip [12] and bracket [13] surfaces. Refer to AMM 20-30-80.
 - 2) Apply new sealant compound, A00225 [14] to fill the gap between clip [12] and bracket [13].

SUBTASK 25-52-20-820-001

- (6) Put the panel [1] against the support structure [3].

SUBTASK 25-52-20-420-001

- (7) Turn the quick-release fasteners [4] clockwise to attach the panel [1] to the support structure [3].

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-52-20-080-001

- (1) Remove the bulk cargo door safety barrier, SPL-1996.

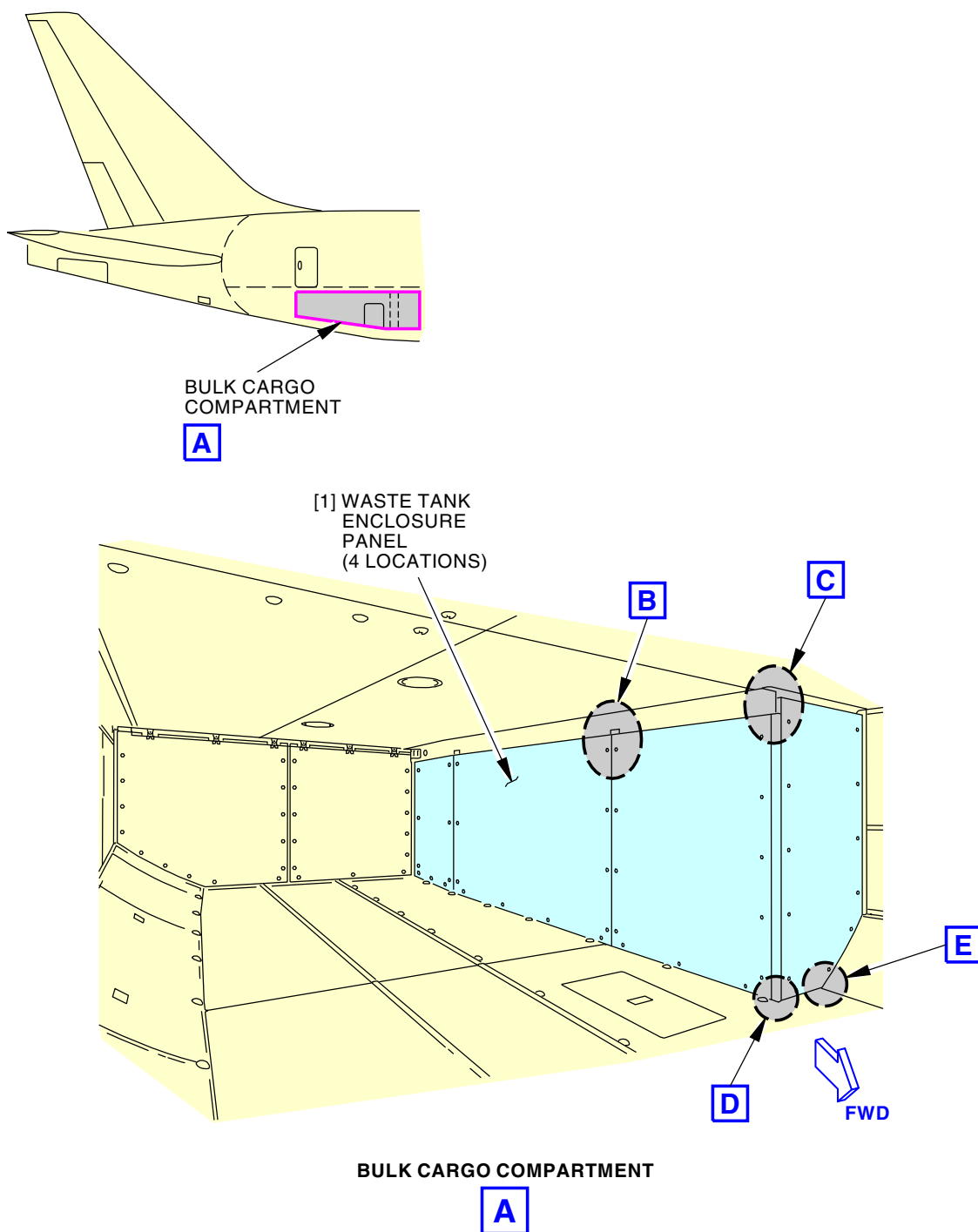
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EFFECTIVITY
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25-52-20

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Page 403
Jan 05/2015



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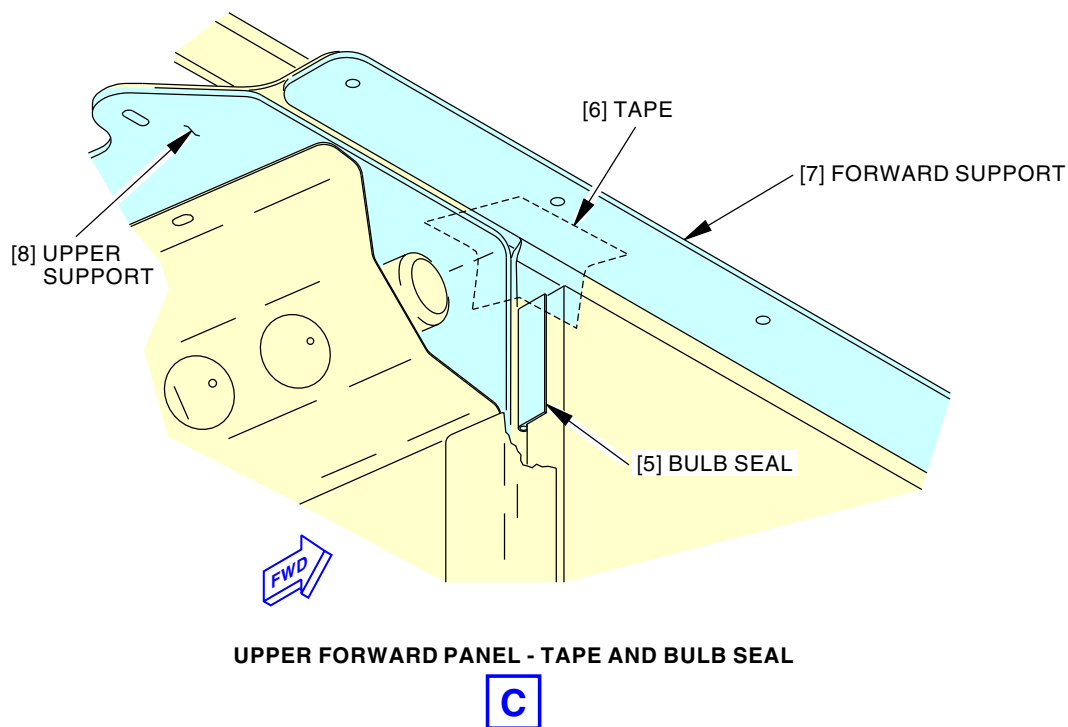
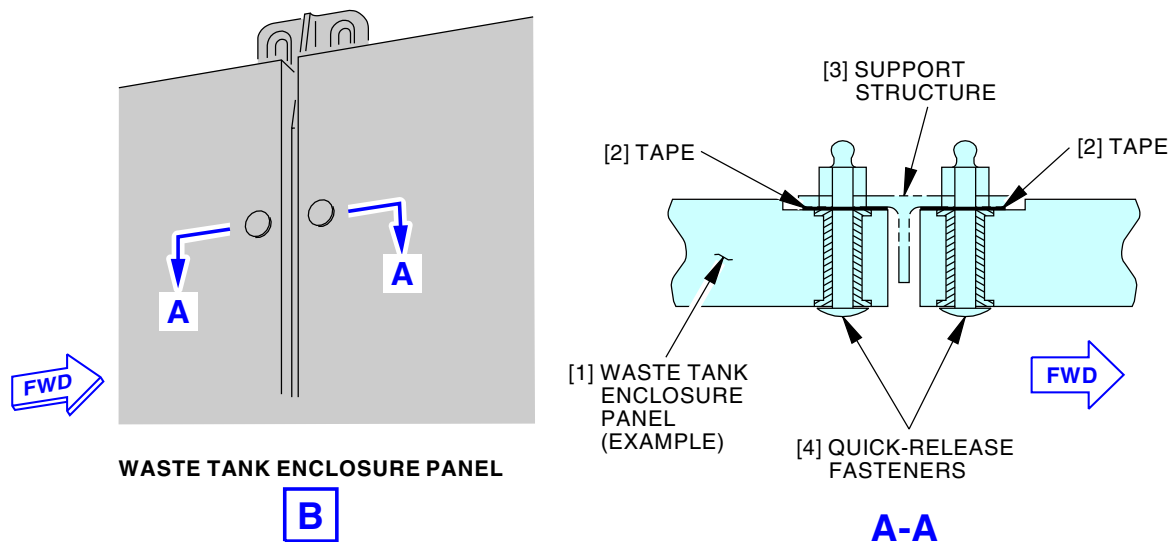
**Waste Tank Enclosure Panels Installation
Figure 401/25-52-20-990-801 (Sheet 1 of 3)**

EFFECTIVITY
ARO ALL

25-52-20

D633W101-ARO

Page 404
May 05/2017



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**Waste Tank Enclosure Panels Installation
Figure 401/25-52-20-990-801 (Sheet 2 of 3)**

EFFECTIVITY
ARO ALL

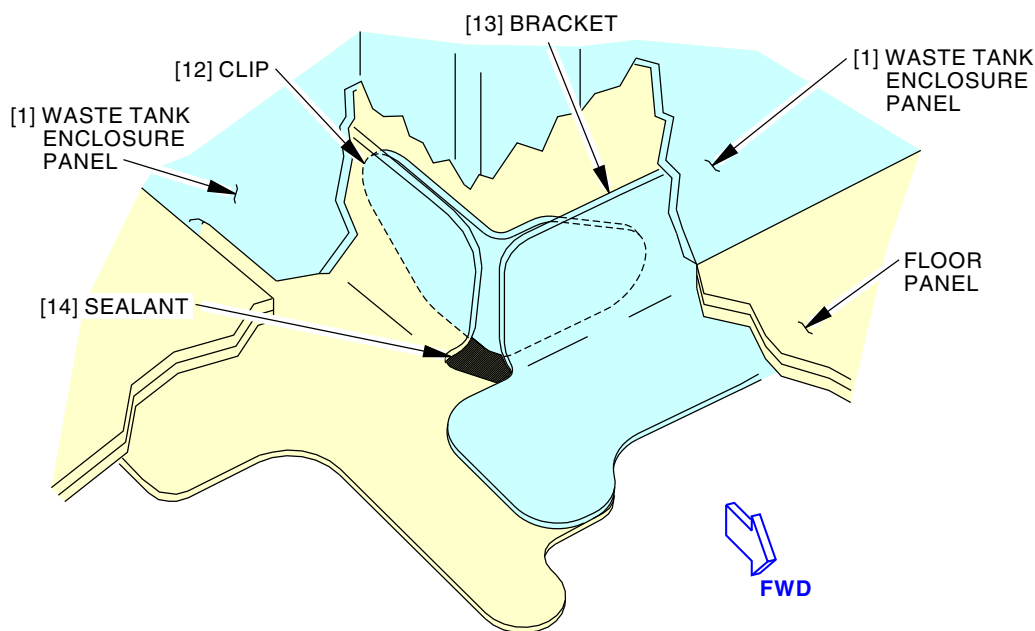
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25-52-20

Page 405
May 05/2017

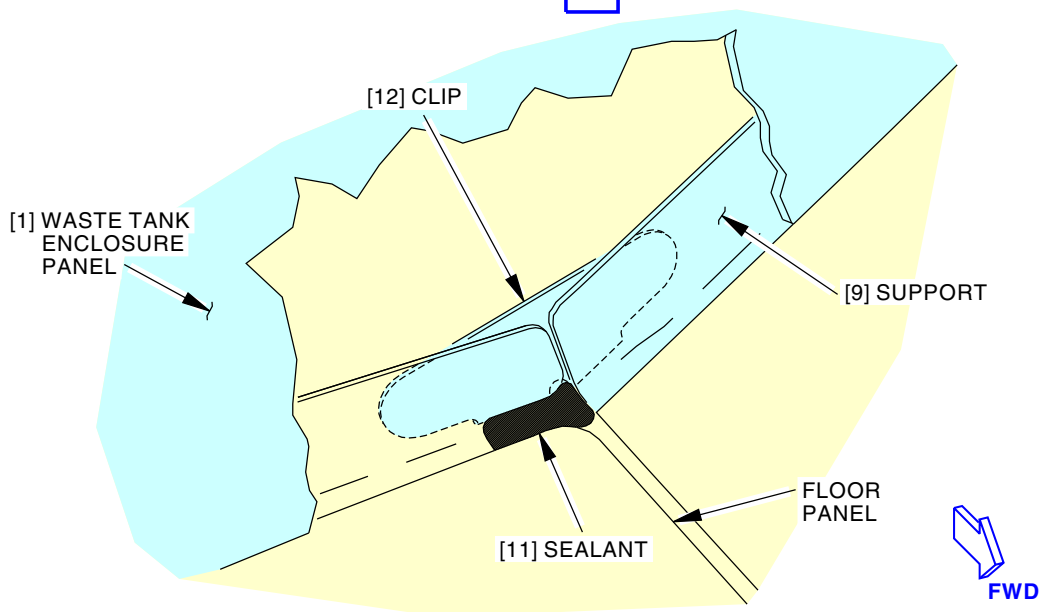


777-200/300
AIRCRAFT MAINTENANCE MANUAL



LOWER FORWARD ENCLOSURE SUPPORT PANEL - SEALANT

D



LOWER FORWARD PANEL - SEALANT

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Waste Tank Enclosure Panels Installation
Figure 401/25-52-20-990-801 (Sheet 3 of 3)

EFFECTIVITY
ARO ALL

25-52-20

D633W101-ARO

Page 406
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CARGO HANDLING SYSTEM - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks for the cargo handling system:

- (1) Deactivation of the Forward Cargo Handling System
- (2) Deactivation of the Aft Cargo Handling System
- (3) Activation of the Forward Cargo Handling System
- (4) Activation of the Aft Cargo Handling System

TASK 25-53-00-040-801

2. Forward Cargo Handling System - Deactivation

A. **General**

- (1) This task will deactivate the forward lower lobe cargo handling system.
- (2) This procedure should only be used if any uncommanded cargo movement is found.

B. **References**

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
24-22-00-860-806	Remove Electrical Power (P/B 201)
52-34-00-860-801	Open the Door Electrically with the External Cargo Door Control Switch (P/B 201)

C. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363

D. **Location Zones**

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right

E. **Prepare for the Procedure**

SUBTASK 25-53-00-860-K26

- (1) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-53-00-010-016

- (2) Do this task: Open the Door Electrically with the External Cargo Door Control Switch, TASK 52-34-00-860-801.

SUBTASK 25-53-00-010-017

- (3) Remove any cargo that is in the forward cargo compartment.

SUBTASK 25-53-00-040-001

- (4) Do this task: Remove Electrical Power, TASK 24-22-00-860-806.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Page 201
Jan 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-480-001



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (5) Install the large cargo door safety barrier, SPL-1988.

F. Procedure

SUBTASK 25-53-00-200-004

- (1) Make sure that all components are in the lowered position.
- (a) Power drive units
 - (b) Center and Auxiliary Lateral guides
 - (c) Sill and Retractable Guide rollers
 - (d) Rollout, Center and Auxiliary Stop/Locks

SUBTASK 25-53-00-860-N71

- (2) Open the cover to the cargo handling accessory panel.

Open these circuit breakers and install safety tags:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 001-010			
A	2	C25307	CARGO HDLG FWD COMPT L
ARO 011-999			
A	3	C25307	CARGO HDLG FWD COMPT L
ARO ALL			
B	3	C25308	CARGO HDLG FWD COMPT R

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	9	C25017	LATERAL GUIDES
A	10	C25028	CSC DC-LEFT
A	11	C25029	CSC DC-RIGHT
B	1	C25011	PDU 1L, 5L, 12L
B	2	C25012	PDU 2L, 7L, 13L
B	3	C25013	PDU 3L, 11L
B	4	C25014	PDU 4C, 8L, 16L
B	5	C25015	PDU 4L, 9L, 17L
B	6	C25016	PDU 6L, 10L, 18L
C	1	C25021	PDU 1R, 5R, 12R
C	2	C25022	PDU 2R, 7R, 13R
C	3	C25023	PDU 3R, 11R
C	4	C25024	PDU 6C, 8R, 16R
C	5	C25025	PDU 4R, 9R, 17R
C	6	C25026	PDU 6R, 10R, 18R
D	1	C25018	PDU 14L, 20L
D	2	C25019	PDU 15L, 21L

EFFECTIVITY
ARO ALL

25-53-00

D633W101-ARO

Page 202
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

(Continued)

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	3	C25020	PDU 19L
E	1	C25030	PDU 14R, 20R
E	2	C25031	PDU 15R, 21R
E	3	C25032	PDU 19R

G. Forward Cargo Handling System - Tryout

NOTE: This tryout is to make sure that the forward lower lobe cargo handling system is in a zero energy state.

SUBTASK 25-53-00-020-006

- (1) Open the lower deck cargo door to the fully open position.

SUBTASK 25-53-00-020-007

- (2) At the Master Control Panel (MCP) set the conditions that follow:

SYSTEM POWER	ON
SIDE SELECT/POWER DRIVE UNITS	BOTH

SUBTASK 25-53-00-210-004

- (3) Make sure that the indicator light on the MCP is on.

SUBTASK 25-53-00-420-001

- (4) Put the MCP joystick to the IN position.

SUBTASK 25-53-00-210-005

- (5) Make sure that the PDUs in the doorway do not move.

SUBTASK 25-53-00-020-009

- (6) Open these circuit breakers and install safety tags:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	9	C25017	LATERAL GUIDES
A	10	C25028	CSC DC-LEFT
A	11	C25029	CSC DC-RIGHT

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	9	C25613	CARGO HDLG CTRL FWD

SUBTASK 25-53-00-210-006

- (7) Make sure that the lights on the MCP go off.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

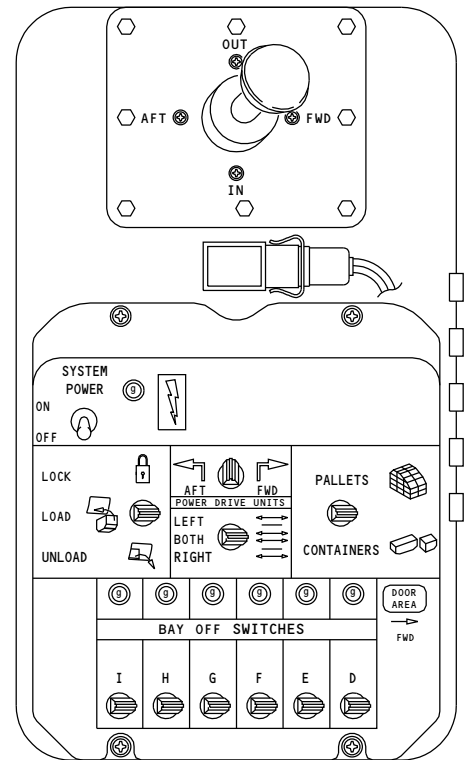
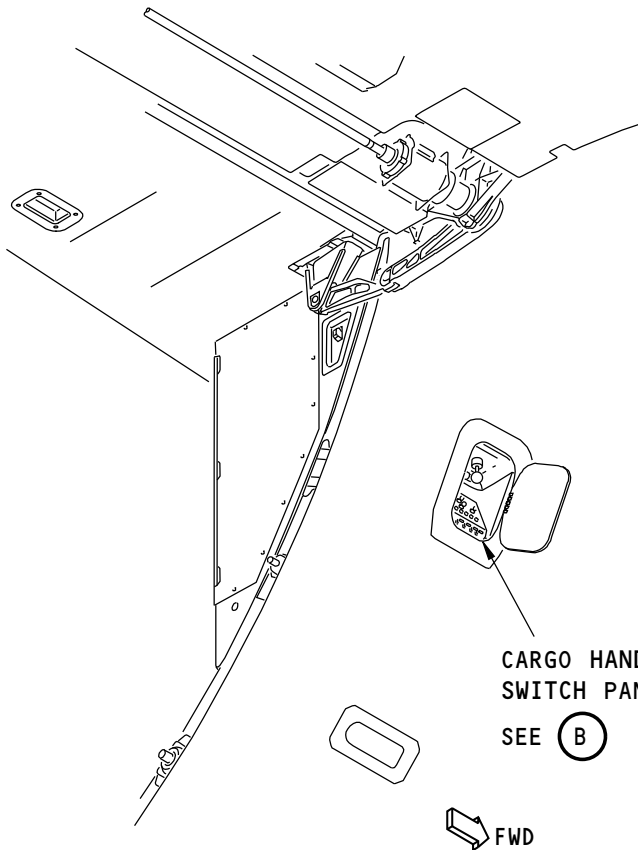
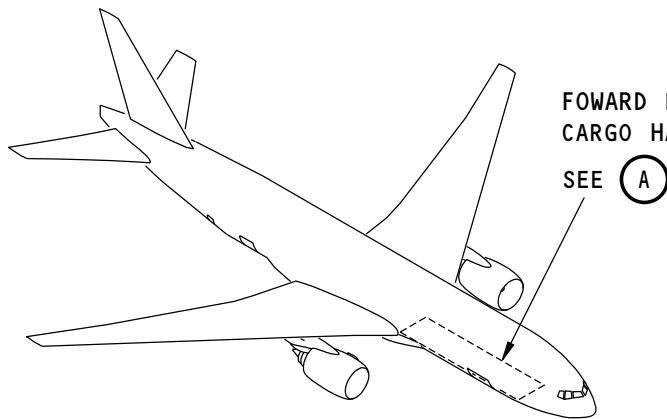
25-53-00

D633W101-ARO

Page 203
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



FORWARD CARGO
HANDLING SWITCH PANEL
(B)

2406809 S0000557029_V1

Forward Lower Lobe Cargo Handling System
Figure 201/25-53-00-990-824

EFFECTIVITY
ARO ALL

25-53-00

D633W101-ARO

Page 204
Jan 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-53-00-040-802

3. Aft Cargo Handling System - Deactivation

A. General

- (1) This task will deactivate the aft lower lobe cargo handling system.
- (2) This procedure should only be used if any uncommanded cargo movement is found.

B. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
24-22-00-860-806	Remove Electrical Power (P/B 201)
52-34-00-860-801	Open the Door Electrically with the External Cargo Door Control Switch (P/B 201)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

D. Location Zones

Zone	Area
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

E. Prepare for the Procedure

SUBTASK 25-53-00-860-K28

- (1) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-53-00-010-018

- (2) Do this task: Open the Door Electrically with the External Cargo Door Control Switch, TASK 52-34-00-860-801.

SUBTASK 25-53-00-010-019

- (3) Unload any cargo that is in the aft cargo compartment.

SUBTASK 25-53-00-040-002

- (4) Do this task: Remove Electrical Power, TASK 24-22-00-860-806.

SUBTASK 25-53-00-480-002



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (5) Install the safety barrier, SPL-2006 across the cargo door opening.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Page 205
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

F. Procedure

SUBTASK 25-53-00-200-005



WARNING

BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

- (1) Make sure that all components are in the lowered position.
 - (a) Power drive units
 - (b) Center and Auxiliary Lateral guides
 - (c) Sill and Retractable Guide rollers
 - (d) Rollout, Center and Auxiliary Stop/Locks

SUBTASK 25-53-00-860-N74

- (2) Open these circuit breakers and install safety tags:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 011-999			
A	2	C25309	CARGO HDLG AFT COMPT L
ARO 001-010			
A	3	C25309	CARGO HDLG AFT COMPT L
A	5	C25310	CARGO HDLG AFT COMPT R
ARO 011-999			
C	3	C25310	CARGO HDLG AFT COMPT R

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO ALL			
B	1	C25111	PDU 1L ,13L
B	2	C25112	PDU 2L, 8L, 12L
B	3	C25113	PDU 3L, 9L, 14L
B	4	C25114	PDU 4L, 10L, 12C
B	5	C25115	PDU 5L, 11L, 16L
B	6	C25117	PDU 6L, 17L
C	1	C25121	PDU 1R, 13R
C	2	C25122	PDU 2R, 8R, 12R
C	3	C25123	PDU 3R, 9R, 14R
C	4	C25124	PDU 4R, 10R, 14C
C	5	C25125	PDU 5R, 11R, 16R
C	6	C25119	PDU 6R, 17R
D	1	C25118	PDU 7L, 15L,
E	1	C25200	PDU 7R, 15R

G. Aft Cargo Handling System - Tryout

NOTE: This tryout is to make sure that the aft lower lobe cargo handling system is in a zero energy state.

SUBTASK 25-53-00-020-001

- (1) Open the lower deck cargo door to the fully open position.

EFFECTIVITY
ARO ALL

25-53-00

D633W101-ARO

Page 206
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-020-002

(2) At the Master Control Panel (MCP) set the conditions that follow:

SYSTEM POWER	ON
SIDE SELECT/POWER DRIVE UNITS	BOTH

SUBTASK 25-53-00-210-001

(3) Make sure that the indicator light on the MCP is on.

SUBTASK 25-53-00-410-005

(4) Put the MCP joystick to the IN position.

SUBTASK 25-53-00-210-002

(5) Make sure that the PDUs in the doorway do not move.

SUBTASK 25-53-00-020-004

(6) Open these circuit breakers and install safety tags:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	9	C25116	LATERAL GUIDES
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	10	C25614	CARGO HDLG CTRL AFT

SUBTASK 25-53-00-210-003

(7) Make sure that the lights on the MCP go off.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

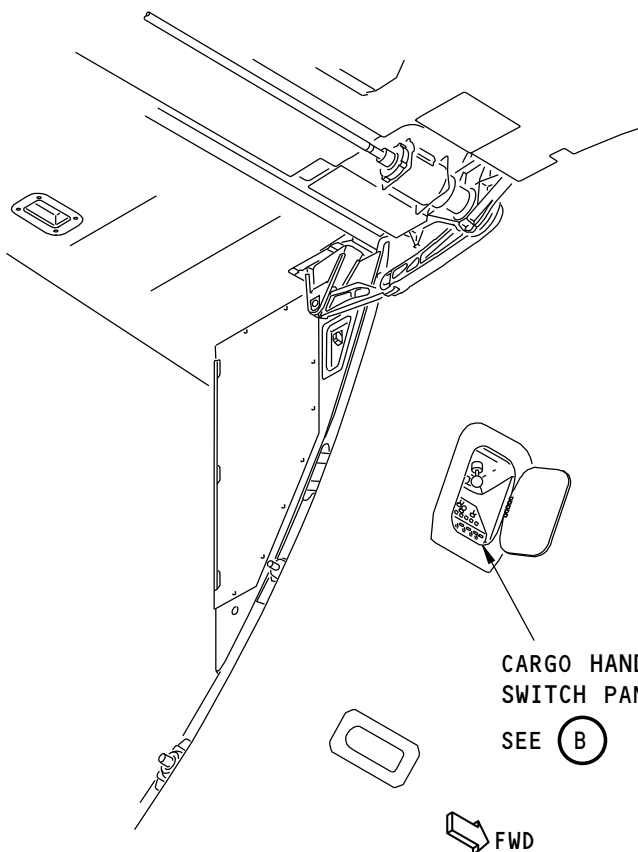
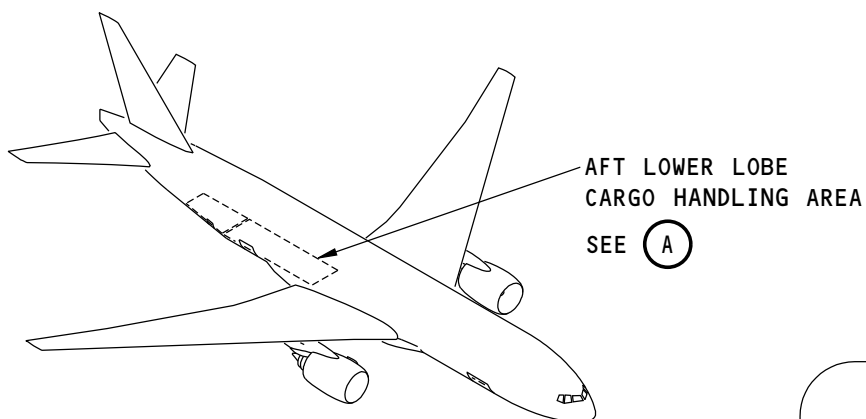
D633W101-ARO

25-53-00

Page 207
Sep 05/2017

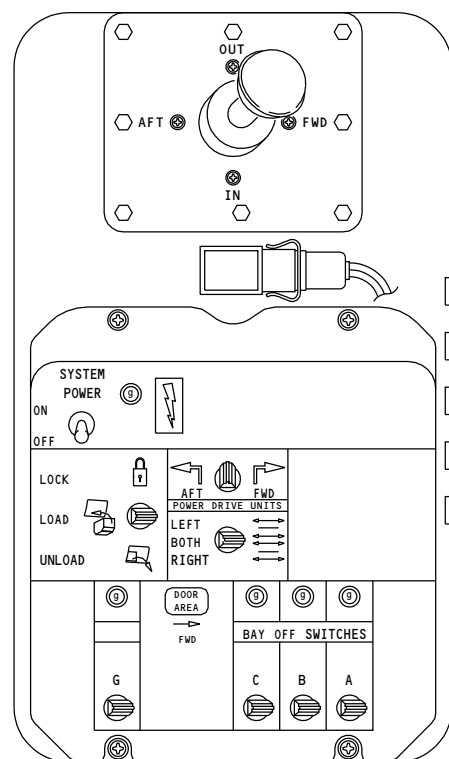


777-200/300
AIRCRAFT MAINTENANCE MANUAL



CARGO DOOR AREA

(A)



AFT CARGO
HANDLING SWITCH PANEL

(B)

2405493 S0000555955_V1

Aft Lower Lobe Cargo Handling System
Figure 202/25-53-00-990-823

EFFECTIVITY
ARO ALL

25-53-00

D633W101-ARO

Page 208
Jan 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-53-00-400-801

4. Forward Cargo Handling System - Activation

(Figure 201)

A. General

- (1) This task will activate the forward lower lobe cargo handling system.
- (2) This procedure should only be used to activate the cargo handling system for maintenance.

B. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
24-22-00-860-806	Remove Electrical Power (P/B 201)
52-34-00-860-801	Open the Door Electrically with the External Cargo Door Control Switch (P/B 201)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363

D. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right

E. Prepare for the Procedure

SUBTASK 25-53-00-860-K30

- (1) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-53-00-010-020

- (2) Do this task: Open the Door Electrically with the External Cargo Door Control Switch, TASK 52-34-00-860-801.

SUBTASK 25-53-00-010-021

- (3) Unload all cargo from the forward cargo compartment.

SUBTASK 25-53-00-040-003

- (4) Do this task: Remove Electrical Power, TASK 24-22-00-860-806.

SUBTASK 25-53-00-860-M78



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (5) Install the large cargo door safety barrier, SPL-1988 across the cargo door opening.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Page 209
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

F. Procedure

SUBTASK 25-53-00-010-022

- (1) Make sure that all components are in the lowered position.
 - (a) Power drive units
 - (b) Center and Auxiliary Lateral guides
 - (c) Sill and Retractable Guide rollers
 - (d) Rollout, Center and Auxiliary Stop/Locks

SUBTASK 25-53-00-860-N72

- (2) Open the cover to the cargo handling accessory panel.
Remove the safety tags and close these circuit breakers:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 001-010			
A	2	C25307	CARGO HDLG FWD COMPT L
ARO 011-999			
A	3	C25307	CARGO HDLG FWD COMPT L
ARO ALL			
B	3	C25308	CARGO HDLG FWD COMPT R

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	9	C25017	LATERAL GUIDES
A	10	C25028	CSC DC-LEFT
A	11	C25029	CSC DC-RIGHT
B	1	C25011	PDU 1L, 5L, 12L
B	2	C25012	PDU 2L, 7L, 13L
B	3	C25013	PDU 3L, 11L
B	4	C25014	PDU 4C, 8L, 16L
B	5	C25015	PDU 4L, 9L, 17L
B	6	C25016	PDU 6L, 10L, 18L
C	1	C25021	PDU 1R, 5R, 12R
C	2	C25022	PDU 2R, 7R, 13R
C	3	C25023	PDU 3R, 11R
C	4	C25024	PDU 6C, 8R, 16R
C	5	C25025	PDU 4R, 9R, 17R
C	6	C25026	PDU 6R, 10R, 18R
D	1	C25018	PDU 14L, 20L
D	2	C25019	PDU 15L, 21L
D	3	C25020	PDU 19L
E	1	C25030	PDU 14R, 20R
E	2	C25031	PDU 15R, 21R
E	3	C25032	PDU 19R

EFFECTIVITY
ARO ALL

25-53-00

D633W101-ARO

Page 210
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	9	C25613	CARGO HDLG CTRL FWD

SUBTASK 25-53-00-410-003



CAUTION

CLOSE THE COVER FOR THE CARGO HANDLING ACCESSORY PANEL. IF YOU DO NOT CLOSE THE COVER, THE CARGO DOOR CAN HIT IT AND CAUSE DAMAGE. IF THERE IS DAMAGE TO THE COVER, THE CARGO COMPARTMENT WILL NOT BE SEALED.

- (3) Close the cover for the cargo handling accessory panel.

————— **END OF TASK** —————

TASK 25-53-00-840-811

5. Aft Cargo Handling System - Activation

(Figure 202)

A. General

- (1) This task will activate the aft lower lobe cargo handling system.
- (2) This procedure should only be used to activate the cargo handling system for maintenance.

B. References

<u>Reference</u>	<u>Title</u>
24-22-00-860-805	Supply Electrical Power (P/B 201)
24-22-00-860-806	Remove Electrical Power (P/B 201)
52-30-00-860-801	Open the Aft Cargo Door (P/B 201)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

<u>Reference</u>	<u>Description</u>
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

D. Location Zones

<u>Zone</u>	<u>Area</u>
823	Aft Small Cargo Door

E. Prepare for the Procedure

SUBTASK 25-53-00-860-K31

- (1) Do this task: Supply Electrical Power, TASK 24-22-00-860-805

SUBTASK 25-53-00-010-024

- (2) Do this task: Open the Aft Cargo Door, TASK 52-30-00-860-801

SUBTASK 25-53-00-010-025

- (3) Unload all cargo from the aft cargo compartment.

SUBTASK 25-53-00-040-004

- (4) Do this task: Remove Electrical Power, TASK 24-22-00-860-806

EFFECTIVITY
ARO ALL

25-53-00

D633W101-ARO

Page 211
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-M77



WARNING

INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (5) Install the safety barrier, SPL-2006 across the cargo door opening.

F. Procedure



WARNING

BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

SUBTASK 25-53-00-010-026

- (1) Make sure that all components are in the lowered position.
- (a) Power drive units
 - (b) Center and Auxiliary Lateral guides
 - (c) Sill and Retractable Guide rollers
 - (d) Rollout, Center and Auxiliary Stop/Locks

SUBTASK 25-53-00-860-K32

- (2) Open the cover to the cargo handling accessory panel.
- (a) Remove the safety tags and close these circuit breakers:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 011-999			
A	2	C25309	CARGO HDLG AFT COMPT L
ARO 001-010			
A	3	C25309	CARGO HDLG AFT COMPT L
A	5	C25310	CARGO HDLG AFT COMPT R
ARO 011-999			
C	3	C25310	CARGO HDLG AFT COMPT R

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO ALL			
A	9	C25116	LATERAL GUIDES
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT
B	1	C25111	PDU 1L, 13L
B	2	C25112	PDU 2L, 8L, 12L
B	3	C25113	PDU 3L, 9L, 14L
B	4	C25114	PDU 4L, 10L, 12C
B	5	C25115	PDU 5L, 11L, 16L
B	6	C25117	PDU 6L, 17L
C	1	C25121	PDU 1R, 13R
C	2	C25122	PDU 2R, 8R, 12R

EFFECTIVITY
ARO ALL

25-53-00

D633W101-ARO

Page 212
Sep 05/2017



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

(Continued)

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	3	C25123	PDU 3R, 9R, 14R
C	4	C25124	PDU 4R, 10R, 14C
C	5	C25125	PDU 5R, 11R, 16R
C	6	C25119	PDU 6R, 17R
D	1	C25118	PDU 7L, 15L,
E	1	C25200	PDU 7R, 15R

SUBTASK 25-53-00-410-004



CAUTION

CLOSE THE COVER FOR THE CARGO HANDLING ACCESSORY PANEL. IF YOU DO NOT CLOSE THE COVER, THE CARGO DOOR CAN HIT IT AND CAUSE DAMAGE. IF THERE IS DAMAGE TO THE COVER, THE CARGO COMPARTMENT WILL NOT BE SEALED.

- (3) Close the cover for the cargo handling accessory panel.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Page 213
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CARGO HANDLING SYSTEM - ADJUSTMENT/TEST

1. General

A. This procedure has these tasks:

- (1) Prepare for the Test
- (2) Controller Power Test
- (3) Lateral Guide Test
- (4) Left Powered Drive Unit (PDU) Test
- (5) Right PDU Test
- (6) PDU Bay Off and PDU Up and Braked Test
- (7) Interlock Test
- (8) Put the Airplane Back to Its Usual Condition

B. The tasks that follow can be done as stand alone tests.

- (1) If you do these tasks in sequence the switches on the cargo system control panel may be in the correct positions from the previous task.

TASK 25-53-00-840-805-003

2. Prepare for the Test

(Figure 501)

A. **References**

Reference	Title
52-34-00 P/B 201	FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES
52-35-00 P/B 201	AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES

B. **Location Zones**

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. **Prepare for the Test**

SUBTASK 25-53-00-010-007-003

NOTE: FOR THE FORWARD CARGO COMPARTMENT

- (1) Open the cargo door. To open the cargo door do the applicable task in this procedure: FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-34-00/201.

SUBTASK 25-53-00-860-374-003

- (2) Open these circuit breakers and install safety tags:

Auxiliary Power Panel, P300

Row	Col	Number	Name
ARO 001-010			
A	2	C25307	CARGO HDLG FWD COMPT L

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 501
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

ARO 001-010 (Continued)

(Continued)

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 011-999			
A	3	C25307	CARGO HDLG FWD COMPT L
ARO ALL			
B	3	C25308	CARGO HDLG FWD COMPT R

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	9	C25613	CARGO HDLG CTRL FWD

SUBTASK 25-53-00-860-375-003

- (3) Open these circuit breakers and install safety tags:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	9	C25017	LATERAL GUIDES
A	10	C25028	CSC DC-LEFT
A	11	C25029	CSC DC-RIGHT
B	1	C25011	PDU 1L, 5L, 12L
B	2	C25012	PDU 2L, 7L, 13L
B	3	C25013	PDU 3L, 11L
B	4	C25014	PDU 4C, 8L, 16L
B	5	C25015	PDU 4L, 9L, 17L
B	6	C25016	PDU 6L, 10L, 18L
C	1	C25021	PDU 1R, 5R, 12R
C	2	C25022	PDU 2R, 7R, 13R
C	3	C25023	PDU 3R, 11R
C	4	C25024	PDU 6C, 8R, 16R
C	5	C25025	PDU 4R, 9R, 17R
C	6	C25026	PDU 6R, 10R, 18R
D	1	C25018	PDU 14L, 20L
D	2	C25019	PDU 15L, 21L
D	3	C25020	PDU 19L
E	1	C25030	PDU 14R, 20R
E	2	C25031	PDU 15R, 21R
E	3	C25032	PDU 19R

SUBTASK 25-53-00-860-377-003

- (4) Make sure the switches on the cargo system control panel, P24, are in these positions:

Table 501/25-53-00-993-837

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 502
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

Table 501/25-53-00-993-837 (Continued)

Switch Nomenclature	Position
Pallets/Containers	CONTAINERS

D. Prepare for the test

SUBTASK 25-53-00-010-009-003

NOTE: FOR THE AFT CARGO COMPARTMENT

- (1) Open the cargo door. To open the cargo door do the applicable task in this procedure: AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-35-00/201.

SUBTASK 25-53-00-860-382-003

- (2) Open these circuit breakers and install safety tags:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 011-999			
A	2	C25309	CARGO HDLG AFT COMPT L
ARO 001-010			
A	3	C25309	CARGO HDLG AFT COMPT L
A	5	C25310	CARGO HDLG AFT COMPT R
ARO 011-999			
C	3	C25310	CARGO HDLG AFT COMPT R

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO ALL			
C	10	C25614	CARGO HDLG CTRL AFT

SUBTASK 25-53-00-860-K33-003

- (3) Open these circuit breakers and install safety tags:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	9	C25116	LATERAL GUIDES
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT
B	1	C25111	PDU 1L, 13L
B	2	C25112	PDU 2L, 8L, 12L
B	3	C25113	PDU 3L, 9L, 14L
B	4	C25114	PDU 4L, 10L, 12C
B	5	C25115	PDU 5L, 11L, 16L
C	1	C25121	PDU 1R, 13R
C	2	C25122	PDU 2R, 8R, 12R
C	3	C25123	PDU 3R, 9R, 14R
C	4	C25124	PDU 4R, 10R, 14C
C	5	C25125	PDU 5R, 11R, 16R

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 503
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

Open these circuit breakers and install safety tags:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	6	C25117	PDU 6L, 17L
C	6	C25119	PDU 6R, 17R
D	1	C25118	PDU 7L, 15L,
E	1	C25200	PDU 7R, 15R

SUBTASK 25-53-00-860-384-003

(4) Make sure the switches on the cargo system control panel, P27, are in these positions:

Table 502/25-53-00-993-839

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

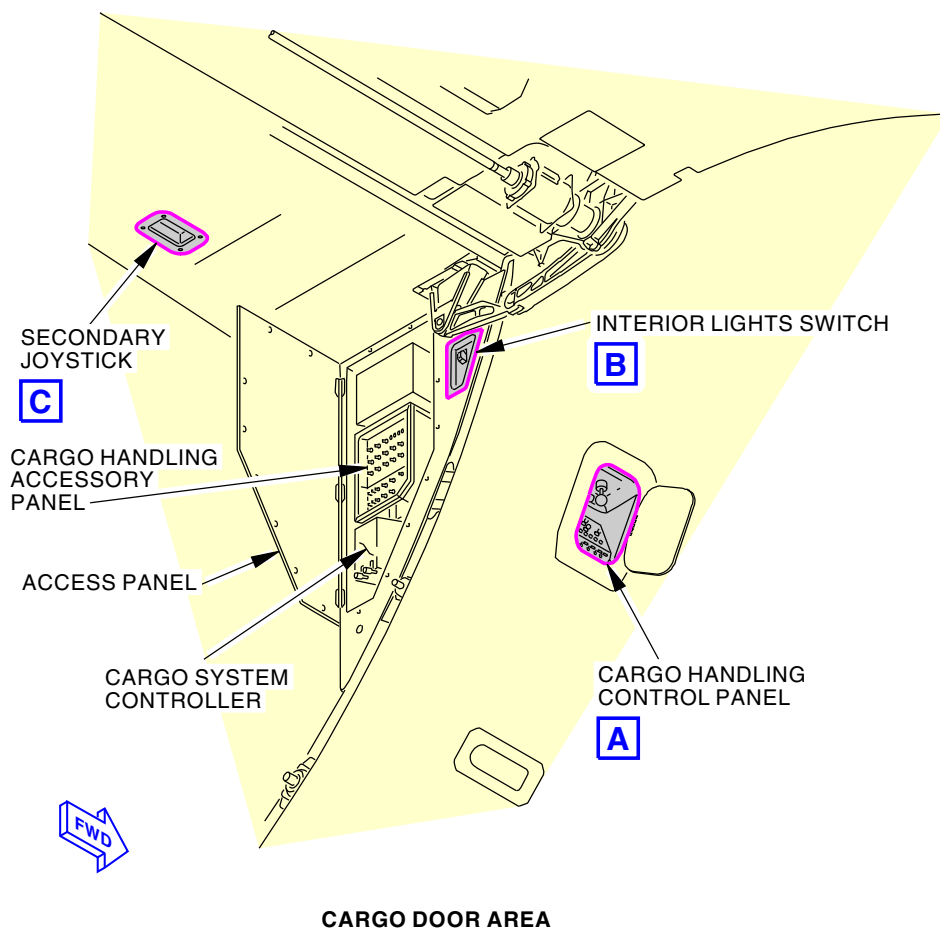
D633W101-ARO

25-53-00

Config 3
Page 504
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL



G88258 S0006410851_V2

Cargo Handling Control System
Figure 501/25-53-00-990-809-003 (Sheet 1 of 3)

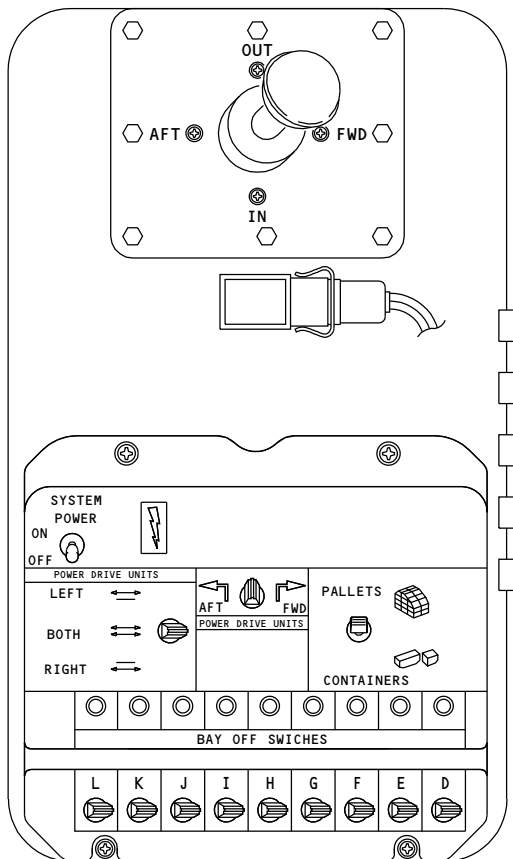
EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 505
May 05/2017

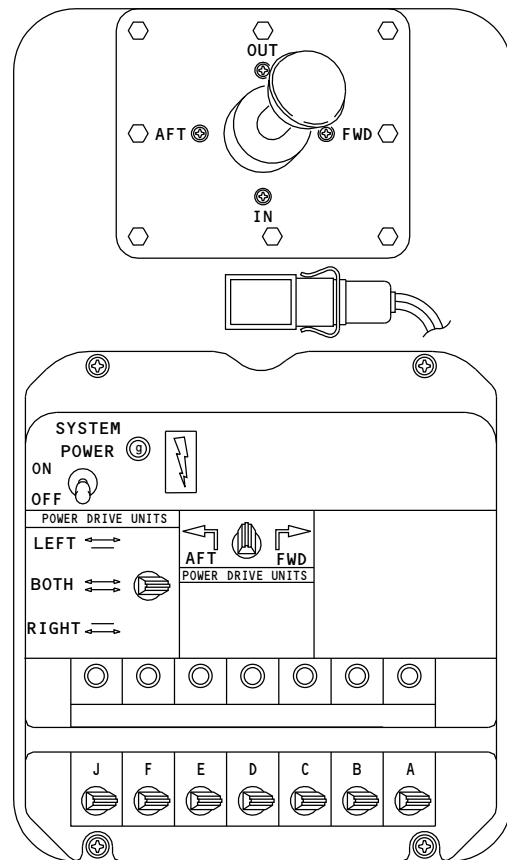
**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



⇒ FWD

**FORWARD CARGO
HANDLING CONTROL PANEL**

(A)



⇒ FWD

**AFT CARGO
HANDLING CONTROL PANEL**

(A)

H64650 S0006410853_V1

**Cargo Handling Control System
Figure 501/25-53-00-990-809-003 (Sheet 2 of 3)**

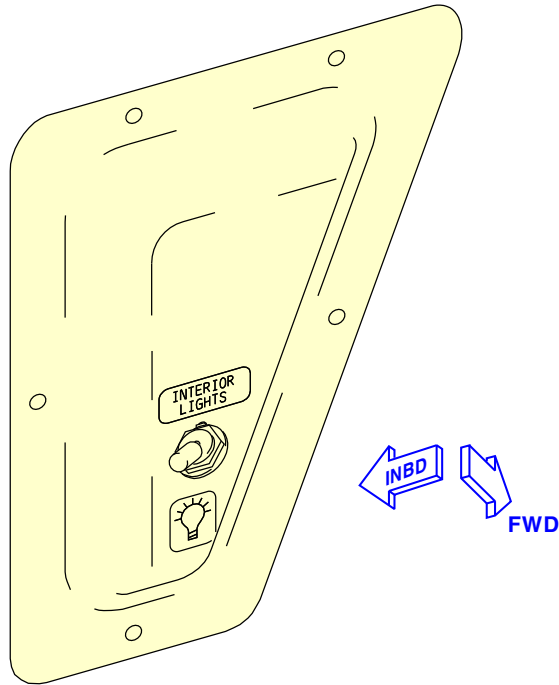
EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

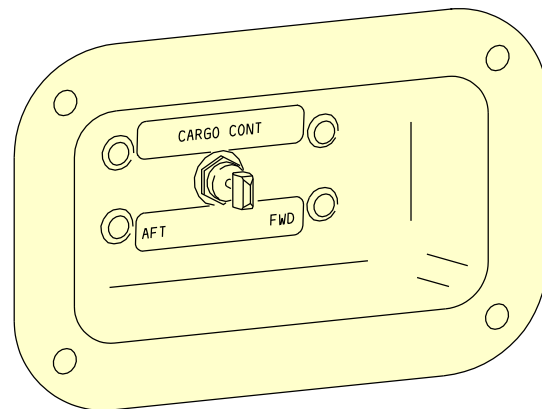
Config 3
Page 506
Jan 05/2015

777-200/300
AIRCRAFT MAINTENANCE MANUAL



INTERIOR LIGHTS SWITCH

B



SECONDARY JOYSTICK

C

G88261 S0006410854_V2

Cargo Handling Control System
Figure 501/25-53-00-990-809-003 (Sheet 3 of 3)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
 Page 507
 May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-53-00-700-814-003

3. Controller Power Test

A. General

- (1) This task contains the controller power test for these compartments:
- (a) Forward cargo compartment.
 - (b) Aft cargo compartment.

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Controller Power Test - Forward Cargo Compartment

SUBTASK 25-53-00-840-041-003

- (1) Do this task: Prepare for the Test, TASK 25-53-00-840-805-003.

SUBTASK 25-53-00-200-002-003

- (2) Make sure the switches on the cargo system control panel, P24, are in these positions:

Table 503/25-53-00-993-801

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD
Pallets/Containers	CONTAINERS

SUBTASK 25-53-00-710-509-003

- (3) Remove the safety tags and close these circuit breakers:

FWD Cargo Handling Access Panel, P35

Row	Col	Number	Name
A	11	C25029	CSC DC-RIGHT

Ground Service/Handling Power Panel, P320

Row	Col	Number	Name
C	9	C25613	CARGO HDLG CTRL FWD

- (a) Make sure the POWER ON light and the BAY ON lights come on.

SUBTASK 25-53-00-710-510-003

- (4) Put the SYSTEM POWER switch in the OFF position.
- (a) Make sure the POWER ON light and the BAY ON lights go off.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 508
Jan 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-385-003

- (5) Remove the safety tags and close these circuit breakers:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	3	C25308	CARGO HDLG FWD COMPT R

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	1	C25021	PDU 1R, 5R, 12R

SUBTASK 25-53-00-710-U79-003

- (6) Put the System Power switch to the ON position.

SUBTASK 25-53-00-710-U80-003

- (7) Move the joystick to the FWD direction.
(a) Make sure that PDU 1R operates FWD.

SUBTASK 25-53-00-710-511-003

- (8) Open these circuit breakers and install safety tags:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	11	C25029	CSC DC-RIGHT
C	1	C25021	PDU 1R, 5R, 12R

SUBTASK 25-53-00-710-U81-003

- (9) Make sure that the Power On and Bay On lights go off.

SUBTASK 25-53-00-860-386-003

- (10) Open this circuit breaker and install safety tag:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	3	C25308	CARGO HDLG FWD COMPT R

SUBTASK 25-53-00-710-512-003

- (11) Remove the safety tags and close these circuit breakers:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>

ARO 001-010

A	2	C25307	CARGO HDLG FWD COMPT L

ARO 011-999

A	3	C25307	CARGO HDLG FWD COMPT L

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>

ARO ALL

A	10	C25028	CSC DC-LEFT

- (a) Make sure the control panel area light comes on.
(b) Make sure the POWER ON light and the BAY ON lights come on.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 509
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-387-003

- (12) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	1	C25011	PDU 1L, 5L, 12L

SUBTASK 25-53-00-710-514-003

- (13) Move the secondary joystick in the AFT direction.

- (a) Make sure PDU 1L operates aft.

SUBTASK 25-53-00-860-388-003

- (14) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	1	C25011	PDU 1L, 5L, 12L

NOTE: The PDUs go down when you open the circuit breaker.

D. Controller Power Test - Aft Cargo Compartment

SUBTASK 25-53-00-840-042-003

- (1) Do this task: Prepare for the Test, TASK 25-53-00-840-805-003.

SUBTASK 25-53-00-710-U82-003

- (2) Make sure the switches on the cargo system control panel P27, are in these positions:

Table 504/25-53-00-993-969-003

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD
Pallets/Containers	CONTAINERS

SUBTASK 25-53-00-710-515-003

- (3) Remove the safety tags and close these circuit breakers:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT
C	1	C25121	PDU 1R, 13R

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	10	C25614	CARGO HDLG CTRL AFT

- (a) Make sure the POWER ON light and the BAY ON lights come on.

SUBTASK 25-53-00-710-516-003

- (4) Put the SYSTEM POWER switch in the OFF position.

- (a) Make sure the POWER ON light and the BAY ON lights go off.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 510
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-390-003

- (5) Remove the safety tags and close these circuit breakers:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 001-010			
A	5	C25310	CARGO HDLG AFT COMPT R
ARO 011-999			
C	3	C25310	CARGO HDLG AFT COMPT R

ARO ALL

SUBTASK 25-53-00-710-U83-003

- (6) Move the System Power switch to the ON position.

SUBTASK 25-53-00-710-U84-003

- (7) Move the secondary joystick to the FWD direction.
(a) Make sure that PDU 1R operates FWD.

SUBTASK 25-53-00-710-517-003

- (8) Open these circuit breakers and install safety tags:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT
C	1	C25121	PDU 1R, 13R

- (a) Make sure the POWER ON light and the BAY ON lights go off.

SUBTASK 25-53-00-860-391-003

- (9) Open these circuit breakers and install safety tags:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 001-010			
A	5	C25310	CARGO HDLG AFT COMPT R
ARO 011-999			
C	3	C25310	CARGO HDLG AFT COMPT R

ARO ALL

SUBTASK 25-53-00-860-392-003

- (10) Remove the safety tags and close these circuit breakers:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 011-999			
A	2	C25309	CARGO HDLG AFT COMPT L
ARO 001-010			
A	3	C25309	CARGO HDLG AFT COMPT L

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 511
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

ARO 001-010 (Continued)

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>

ARO ALL

A	10	C25128	CSC DC LEFT

- (a) Make sure the control panel area light comes on.
- (b) Make sure the POWER ON light and the BAY ON lights come on.

SUBTASK 25-53-00-860-393-003

- (11) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>

B	1	C25111	PDU 1L ,13L

SUBTASK 25-53-00-710-518-003

- (12) Move the secondary joystick in the AFT direction.
 - (a) Make sure PDU 1L operates AFT.

SUBTASK 25-53-00-860-394-003

- (13) Open this circuit breaker and install safety tag:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>

B	1	C25111	PDU 1L ,13L

NOTE: The PDUs go down when you open the circuit breaker.

————— **END OF TASK** —————

TASK 25-53-00-700-815-003

4. Lateral Guide Test

(Figure 502)

A. Location Zones

<u>Zone</u>	<u>Area</u>

121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

B. Lateral Guide Test - Forward Cargo Compartment

SUBTASK 25-53-00-840-043-003

- (1) Do this task: Prepare for the Test, TASK 25-53-00-840-805-003.

SUBTASK 25-53-00-860-396-003

- (2) Make sure the forward and aft lateral guides are in the raised position.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 512
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-N62-003

- (3) Remove the safety tags and close these circuit breakers:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 001-010			
A	2	C25307	CARGO HDLG FWD COMPT L
ARO 011-999			
A	3	C25307	CARGO HDLG FWD COMPT L

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO ALL			
A	9	C25017	LATERAL GUIDES
A	10	C25028	CSC DC-LEFT

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	9	C25613	CARGO HDLG CTRL FWD

SUBTASK 25-53-00-710-520-003

- (4) Move the PDU FWD/AFT switch to the AFT position.

SUBTASK 25-53-00-860-400-003

- (5) Make sure the switches on the cargo system control panel are in these positions:

Table 505/25-53-00-993-814

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	AFT
Pallets/Containers	CONTAINERS

SUBTASK 25-53-00-710-521-003

- (6) Move the joystick to the AFT position.
(a) Make sure the aft lateral guides 1, 2, 3, and 4 go down.

SUBTASK 25-53-00-710-522-003

- (7) Release the joystick.
(a) Make sure the aft lateral guides 1, 2, 3, and 4 come up.

SUBTASK 25-53-00-710-523-003

- (8) Move the PDU LEFT/BOTH/RIGHT switch to the RIGHT position.

SUBTASK 25-53-00-710-524-003

- (9) Move the joystick to the AFT position.
(a) Make sure the aft lateral guides 1 and 2 go down.

SUBTASK 25-53-00-710-525-003

- (10) Release the joystick.
(a) Make sure the aft lateral guides 1 and 2 come up.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 513
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-710-526-003

- (11) Move the PDU LEFT/BOTH/RIGHT switch to the LEFT position.

SUBTASK 25-53-00-710-527-003

- (12) Move the joystick to the AFT position.

(a) Make sure the aft lateral guides 3 and 4 go down.

SUBTASK 25-53-00-710-528-003

- (13) Release the joystick.

(a) Make sure the aft lateral guides 3 and 4 come up.

SUBTASK 25-53-00-710-529-003

- (14) Move the PDU FWD/AFT switch to the FWD position.

SUBTASK 25-53-00-710-530-003

- (15) Move the joystick to the FWD position.

(a) Make sure the forward lateral guides 3 and 4 go down.

SUBTASK 25-53-00-710-531-003

- (16) Release the joystick.

(a) Make sure the forward lateral guides 3 and 4 come up.

SUBTASK 25-53-00-710-532-003

- (17) Move the PDU LEFT/BOTH/RIGHT switch to the RIGHT position.

SUBTASK 25-53-00-710-533-003

- (18) Move the joystick to the FWD position.

(a) Make sure the forward lateral guides 1 and 2 go down.

SUBTASK 25-53-00-710-534-003

- (19) Release the joystick.

(a) Make sure the forward lateral guides 1 and 2 come up.

SUBTASK 25-53-00-710-535-003

- (20) Move the PDU LEFT/BOTH/RIGHT switch to the BOTH position.

SUBTASK 25-53-00-710-548-003

- (21) Move the joystick to the FWD position

(a) Make sure that the forward lateral guides 1, 2, 3, and 4 go down.

SUBTASK 25-53-00-710-549-003

- (22) Release the joystick.

(a) Make sure that the forward lateral guides 1, 2, 3, and 4 come up.

SUBTASK 25-53-00-860-401-003

- (23) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	9	C25017	LATERAL GUIDES

C. Lateral Guide Test - Aft Cargo Compartment

SUBTASK 25-53-00-840-044-003

- (1) Do this task: Prepare for the Test, TASK 25-53-00-840-805-003.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 514
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-404-003

- (2) Make sure the forward and aft lateral guides are in the raised position.

SUBTASK 25-53-00-860-405-003

- (3) Remove the safety tags and close these circuit breakers:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 011-999			
A	2	C25309	CARGO HDLG AFT COMPT L
ARO 001-010			
A	3	C25309	CARGO HDLG AFT COMPT L

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO ALL			
A	9	C25116	LATERAL GUIDES
A	10	C25128	CSC DC LEFT

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	10	C25614	CARGO HDLG CTRL AFT

SUBTASK 25-53-00-710-536-003

- (4) Move the PDU FWD/AFT switch to the AFT position.

SUBTASK 25-53-00-860-406-003

- (5) Make sure the switches on the cargo system control panel are in these positions:

Table 506/25-53-00-993-815

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	AFT

SUBTASK 25-53-00-710-537-003

- (6) Move the joystick to the AFT position.
(a) Make sure the aft lateral guides 1, 2, 3, and 4 go down.

SUBTASK 25-53-00-710-538-003

- (7) Release the joystick.
(a) Make sure the aft lateral guides 1, 2, 3, and 4 come up.

SUBTASK 25-53-00-710-539-003

- (8) Move the PDU LEFT/BOTH/RIGHT switch to the RIGHT position.

SUBTASK 25-53-00-710-540-003

- (9) Move the joystick to the AFT position.
(a) Make sure the aft lateral guides 1 and 2 go down.

SUBTASK 25-53-00-710-541-003

- (10) Release the joystick.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 515
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Make sure the aft lateral guides 1 and 2 come up.

SUBTASK 25-53-00-710-542-003

- (11) Move the PDU LEFT/BOTH/RIGHT switch to the LEFT position.

SUBTASK 25-53-00-710-543-003

- (12) Move the joystick to the AFT position.

- (a) Make sure the aft lateral guides 3 and 4 go down.

SUBTASK 25-53-00-710-544-003

- (13) Release the joystick.

- (a) Make sure the aft lateral guides 3 and 4 come up.

SUBTASK 25-53-00-710-545-003

- (14) Move the PDU FWD/AFT switch to the FWD position.

SUBTASK 25-53-00-710-546-003

- (15) Move the joystick to the FWD position.

- (a) Make sure the forward lateral guides 3 and 4 go down.

SUBTASK 25-53-00-710-547-003

- (16) Release the joystick.

- (a) Make sure the forward lateral guides 3 and 4 come up.

SUBTASK 25-53-00-710-548-003

- (17) Move the PDU LEFT/BOTH/RIGHT switch to the RIGHT position.

SUBTASK 25-53-00-710-549-003

- (18) Move the joystick to the FWD position.

- (a) Make sure the forward lateral guides 1 and 2 go down.

SUBTASK 25-53-00-710-550-003

- (19) Release the joystick.

- (a) Make sure the forward lateral guides 1 and 2 come up.

SUBTASK 25-53-00-710-551-003

- (20) Move the PDU LEFT/BOTH/RIGHT switch to the BOTH position.

SUBTASK 25-53-00-860-407-003

- (21) Open these circuit breakers and install safety tags:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 011-999			
A	2	C25309	CARGO HDLG AFT COMPT L
ARO 001-010			
A	3	C25309	CARGO HDLG AFT COMPT L

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO ALL			
A	9	C25116	LATERAL GUIDES
A	10	C25128	CSC DC LEFT

EFFECTIVITY
ARO ALL

D633W101-ARO

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25-53-00

Config 3
Page 516
Sep 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	10	C25614	CARGO HDLG CTRL AFT

————— END OF TASK —————

EFFECTIVITY
ARO ALL

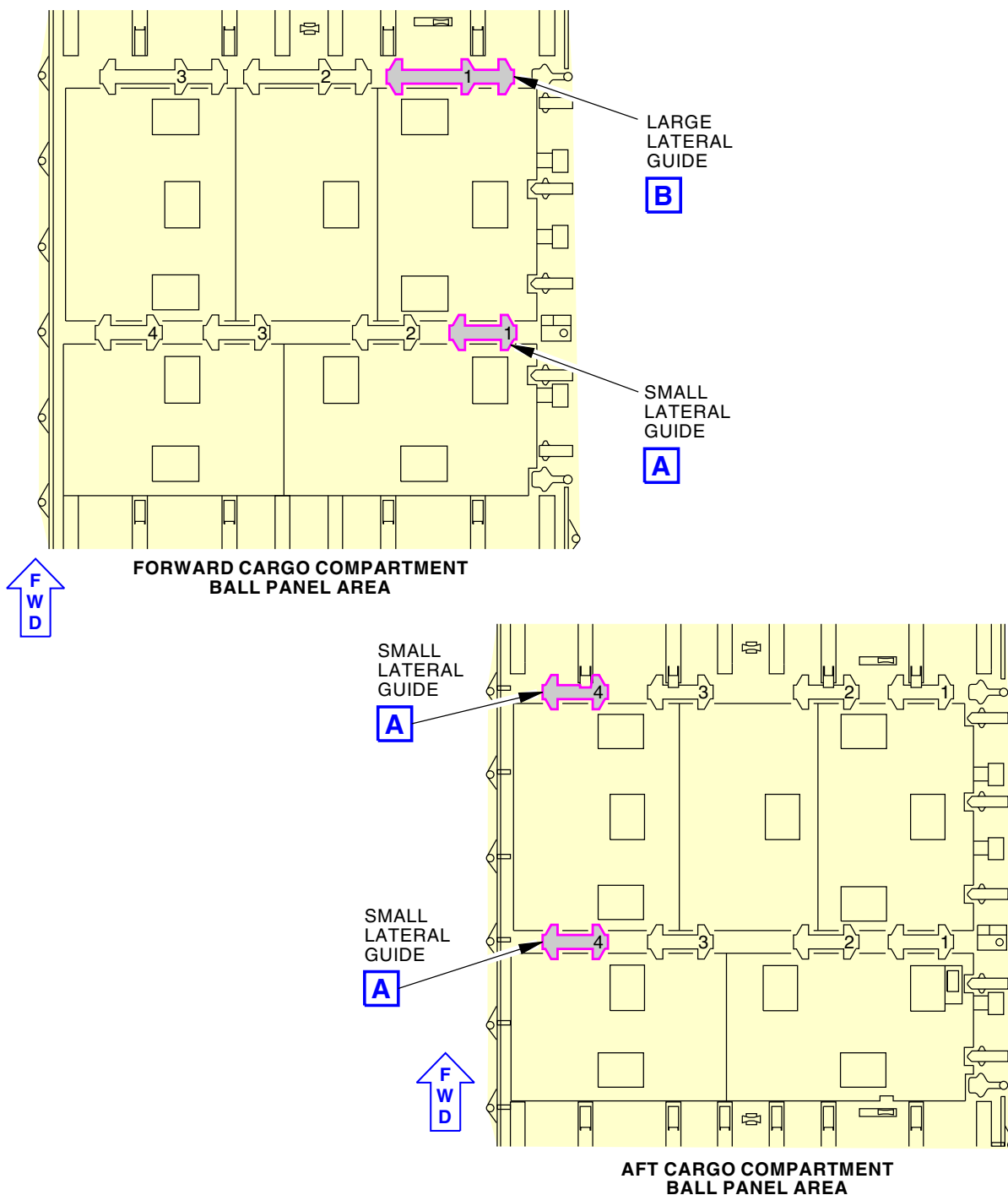
D633W101-ARO

25-53-00

Config 3
Page 517
Sep 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL



H65485 S0006410860_V2

Lateral Guide Test
Figure 502/25-53-00-990-810-003 (Sheet 1 of 2)

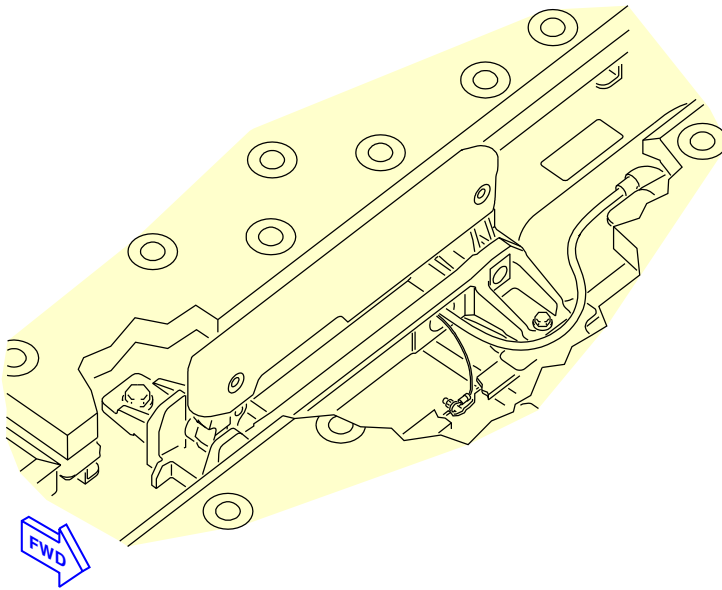
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ARO ALL

D633W101-ARO

25-53-00

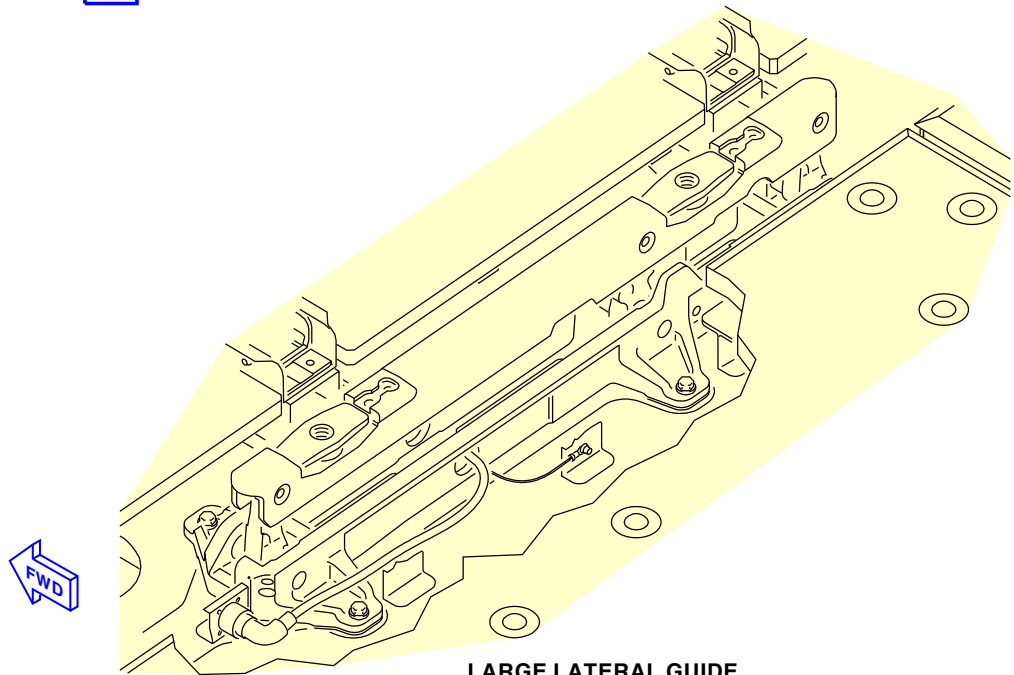
Config 3
Page 518
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



SMALL LATERAL GUIDE

A



LARGE LATERAL GUIDE

B

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Lateral Guide Test
Figure 502/25-53-00-990-810-003 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
 Page 519
 May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-53-00-700-816-003

5. **Left PDU Test**

(Figure 503)

A. General

- (1) This task contains the test for the left PDUs in these compartments:
 - (a) Forward cargo compartment
 - (b) Aft cargo compartment.

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Left PDU Test - Forward Cargo Compartment

SUBTASK 25-53-00-840-045-003

- (1) Do this task: Prepare for the Test, TASK 25-53-00-840-805-003.

SUBTASK 25-53-00-860-408-003

- (2) Remove the safety tags and close these circuit breakers:

Auxiliary Power Panel, P300

Row	Col	Number	Name
ARO 001-010			
A	2	C25307	CARGO HDLG FWD COMPT L
ARO 011-999			
A	3	C25307	CARGO HDLG FWD COMPT L

FWD Cargo Handling Access Panel, P35

Row	Col	Number	Name
ARO ALL			
A	10	C25028	CSC DC-LEFT
B	1	C25011	PDU 1L, 5L, 12L

Ground Service/Handling Power Panel, P320

Row	Col	Number	Name
C	9	C25613	CARGO HDLG CTRL FWD

SUBTASK 25-53-00-710-552-003

- (3) Put the SYSTEM POWER switch to ON.

SUBTASK 25-53-00-860-409-003

- (4) Make sure the switches on the cargo system control panel, P24, are in these positions:

Table 507/25-53-00-993-821

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 520
Sep 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

Table 507/25-53-00-993-821 (Continued)

Switch Nomenclature	Position
PDU Fwd/Aft	FWD
Pallets/Containers	PALLETS

SUBTASK 25-53-00-710-553-003

- (5) Move the joystick to the FWD position.
(a) Make sure that only PDUs 1L and 5L operate forward.

SUBTASK 25-53-00-860-410-003

- (6) Move the PDU FWD/AFT switch to the AFT position.

SUBTASK 25-53-00-710-554-003

- (7) Move the joystick to the AFT position.
(a) Make sure that only PDU 5L and 12L operate aft.

SUBTASK 25-53-00-860-411-003

- (8) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	1	C25011	PDU 1L, 5L, 12L

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-412-003

- (9) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	2	C25012	PDU 2L, 7L, 13L

SUBTASK 25-53-00-710-555-003

- (10) Move the joystick in the AFT position.
(a) Make sure that only PDUs 7L and 13L operate aft.

SUBTASK 25-53-00-710-556-003

- (11) Move the PDU FWD/AFT switch to the FWD position.

SUBTASK 25-53-00-710-557-003

- (12) Move the joystick to the FWD position.
(a) Make sure that only PDU 2L and 7L operate forward.

SUBTASK 25-53-00-860-413-003

- (13) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	2	C25012	PDU 2L, 7L, 13L

NOTE: The PDUs go down when you open the circuit breaker.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 521
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-414-003

- (14) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	3	C25013	PDU 3L, 11L

SUBTASK 25-53-00-710-558-003

- (15) Move the PDU FWD/AFT switch to the AFT position.

SUBTASK 25-53-00-710-559-003

- (16) Move the joystick to the AFT position.
(a) Make sure that only PDUs 3L and 11L operate aft.

SUBTASK 25-53-00-860-415-003

- (17) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	3	C25013	PDU 3L, 11L

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-416-003

- (18) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	4	C25014	PDU 4C, 8L, 16L

SUBTASK 25-53-00-710-560-003

- (19) Move the joystick to the AFT position.
(a) Make sure that only PDUs 8L and 16L operate aft.

SUBTASK 25-53-00-860-417-003

- (20) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	11	C25029	CSC DC-RIGHT

SUBTASK 25-53-00-710-561-003

- (21) Move the joystick to the OUT position.
(a) Make sure that only PDU 4C operates out.

SUBTASK 25-53-00-860-418-003

- (22) Open these circuit breakers and install safety tags:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	11	C25029	CSC DC-RIGHT
B	4	C25014	PDU 4C, 8L, 16L

NOTE: The PDUs go down when you open the circuit breaker.

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25-53-00

Config 3
Page 522
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-419-003

- (23) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	5	C25015	PDU 4L, 9L, 17L

SUBTASK 25-53-00-710-562-003

- (24) Move the joystick to the AFT position.
(a) Make sure that only PDUs 9L and 17L operate aft.

SUBTASK 25-53-00-710-563-003

- (25) Move the joystick to the OUT position.
(a) Make sure that only PDU 4L operates out.

SUBTASK 25-53-00-860-420-003

- (26) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	5	C25015	PDU 4L, 9L, 17L

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-421-003

- (27) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	6	C25016	PDU 6L, 10L, 18L

SUBTASK 25-53-00-710-564-003

- (28) Move the joystick to the AFT position.
(a) Make sure that only PDUs 10L and 18L operate aft.

SUBTASK 25-53-00-710-565-003

- (29) Move the joystick to the OUT position.
(a) Make sure that only PDU 6L operates out.

SUBTASK 25-53-00-860-422-003

- (30) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	6	C25016	PDU 6L, 10L, 18L

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-424-003

- (31) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	1	C25018	PDU 14L, 20L

SUBTASK 25-53-00-710-566-003

- (32) Move the joystick to the AFT position.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 523
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Make sure that only PDUs 14L and 20L operate aft.

SUBTASK 25-53-00-860-425-003

- (33) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	1	C25018	PDU 14L, 20L

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-426-003

- (34) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	2	C25019	PDU 15L, 21L

SUBTASK 25-53-00-710-567-003

- (35) Move the joystick to the AFT position.

- (a) Make sure that only PDUs 15L and 21L operate aft.

SUBTASK 25-53-00-860-427-003

- (36) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	2	C25019	PDU 15L, 21L

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-428-003

- (37) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	3	C25020	PDU 19L

SUBTASK 25-53-00-710-568-003

- (38) Move the joystick to the AFT position.

- (a) Make sure that only PDU 19L operates aft.

SUBTASK 25-53-00-860-429-003

- (39) Open these circuit breakers and install safety tags:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C25028	CSC DC-LEFT
D	3	C25020	PDU 19L

NOTE: The PDUs go down when you open the circuit breaker.

- (a) Make sure the control panel area light goes off.
(b) Make sure the SYSTEM POWER light and the BAY ON lights go off.

SUBTASK 25-53-00-710-569-003

- (40) Move the SYSTEM POWER switch to the OFF position.

EFFECTIVITY
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25-53-00

Config 3
Page 524
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-430-003

- (41) Open these circuit breakers and install safety tags:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 001-010			
A	2	C25307	CARGO HDLG FWD COMPT L
ARO 011-999			
A	3	C25307	CARGO HDLG FWD COMPT L

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO ALL			
C	9	C25613	CARGO HDLG CTRL FWD

D. Left PDU Test - Aft Cargo Compartment

SUBTASK 25-53-00-840-047-003

- (1) Do this task if it is necessary: Prepare for the Test, TASK 25-53-00-840-805-003

SUBTASK 25-53-00-860-450-003

- (2) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	1	C25111	PDU 1L ,13L

SUBTASK 25-53-00-860-N55-003

- (3) Put the SYSTEM POWER switch to ON.

SUBTASK 25-53-00-710-N71-003

- (4) Move the joystick to the FWD position.
(a) Make sure that only PDUs 1L and 13L operate forward.

SUBTASK 25-53-00-860-K34-003

- (5) Open this circuit breaker and install safety tag:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	1	C25111	PDU 1L ,13L

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-K35-003

- (6) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	2	C25112	PDU 2L, 8L, 12L

SUBTASK 25-53-00-710-N72-003

- (7) Move the joystick to the FWD position.
(a) Make sure that only PDUs 2L and 8L operate forward.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 525
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-K36-003

- (8) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	11	C25129	CSC DC RIGHT

SUBTASK 25-53-00-710-N73-003

- (9) Move joystick to the OUT position.
(a) Make sure that only PDU 12L operates out.

SUBTASK 25-53-00-860-K37-003

- (10) Open these circuit breakers and install safety tags:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	11	C25129	CSC DC RIGHT
B	2	C25112	PDU 2L, 8L, 12L

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-K38-003

- (11) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	3	C25113	PDU 3L, 9L, 14L

SUBTASK 25-53-00-710-N74-003

- (12) Move the joystick to the FWD position.
(a) Make sure that only PDUs 3L and 9L operate forward.

SUBTASK 25-53-00-860-K39-003

- (13) Open this circuit breaker and install safety tag:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	3	C25113	PDU 3L, 9L, 14L

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-K40-003

- (14) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	4	C25114	PDU 4L, 10L, 12C

SUBTASK 25-53-00-710-N75-003

- (15) Move the joystick to the FWD position.
(a) Make sure that only PDUs 4L and 10L operate forward.

SUBTASK 25-53-00-710-N76-003

- (16) Move joystick to the OUT position.
(a) Make sure that only PDU 12C operates out.

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25-53-00

Config 3
Page 526
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-K41-003

- (17) Open this circuit breaker and install safety tag:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	4	C25114	PDU 4L, 10L, 12C

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-K42-003

- (18) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	5	C25115	PDU 5L, 11L, 16L

SUBTASK 25-53-00-710-N77-003

- (19) Move the joystick to the FWD position.

- (a) Make sure that only PDU 5L and 11L operates forward.

SUBTASK 25-53-00-710-N78-003

- (20) Move the PDU FWD/AFT switch to the AFT position.

SUBTASK 25-53-00-860-N56-003

- (21) Make sure the switches on the cargo system control panel, P27, are in these positions:

Table 508/25-53-00-993-960-003

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	AFT

SUBTASK 25-53-00-710-N79-003

- (22) Move the joystick to the AFT position.

- (a) Make sure that PDUs 11L and 16L operate aft.

SUBTASK 25-53-00-860-K43-003

- (23) Open this circuit breaker and install safety tag:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	5	C25115	PDU 5L, 11L, 16L

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-K44-003

- (24) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	6	C25117	PDU 6L, 17L

SUBTASK 25-53-00-710-N80-003

- (25) Move the PDU FWD/AFT switch to the FWD position.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 527
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-N57-003

- (26) Make sure the switches on the cargo system control panel, P27, are in these positions:

Table 509/25-53-00-993-961-003

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD

SUBTASK 25-53-00-710-N81-003

- (27) Move the joystick to the FWD position.
(a) Make sure that only PDU 6L operates forward.

SUBTASK 25-53-00-860-K45-003

- (28) Open this circuit breaker and install safety tag:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	6	C25117	PDU 6L, 17L

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-K46-003

- (29) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	1	C25118	PDU 7L, 15L,

SUBTASK 25-53-00-710-N82-003

- (30) Move the joystick to the FWD position.
(a) Make sure that only PDU 7L operates forward.

SUBTASK 25-53-00-710-N83-003

- (31) Move the PDU FWD/AFT switch to the AFT position.

SUBTASK 25-53-00-860-N58-003

- (32) Make sure the switches on the cargo system control panel, P27, are in these positions:

Table 510/25-53-00-993-962-003

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	AFT

SUBTASK 25-53-00-710-N84-003

- (33) Move the joystick to the AFT position.
(a) Make sure that only PDU 15L operates aft.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 528
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-K47-003

- (34) Open these circuit breakers and install safety tags:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT
D	1	C25118	PDU 7L, 15L,

NOTE: The PDUs go down when you open the circuit breaker.

- (a) Make sure the control panel area light goes off.
- (b) Make sure the SYSTEM POWER light and the BAY ON lights go off.

SUBTASK 25-53-00-860-K48-003

- (35) Move the SYSTEM POWER switch to the OFF position.

SUBTASK 25-53-00-710-U40-003

- (36) Move the PDU FWD/AFT switch to the FWD position.

SUBTASK 25-53-00-860-N59-003

- (37) Make sure the switches on the cargo system control panel, P27, are in these positions:

Table 511/25-53-00-993-963-003

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD

SUBTASK 25-53-00-860-K49-003

- (38) Open these circuit breakers and install safety tags:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 011-999			
A	2	C25309	CARGO HDLG AFT COMPT L
ARO 001-010			
A	3	C25309	CARGO HDLG AFT COMPT L

ARO ALL

————— **END OF TASK** —————

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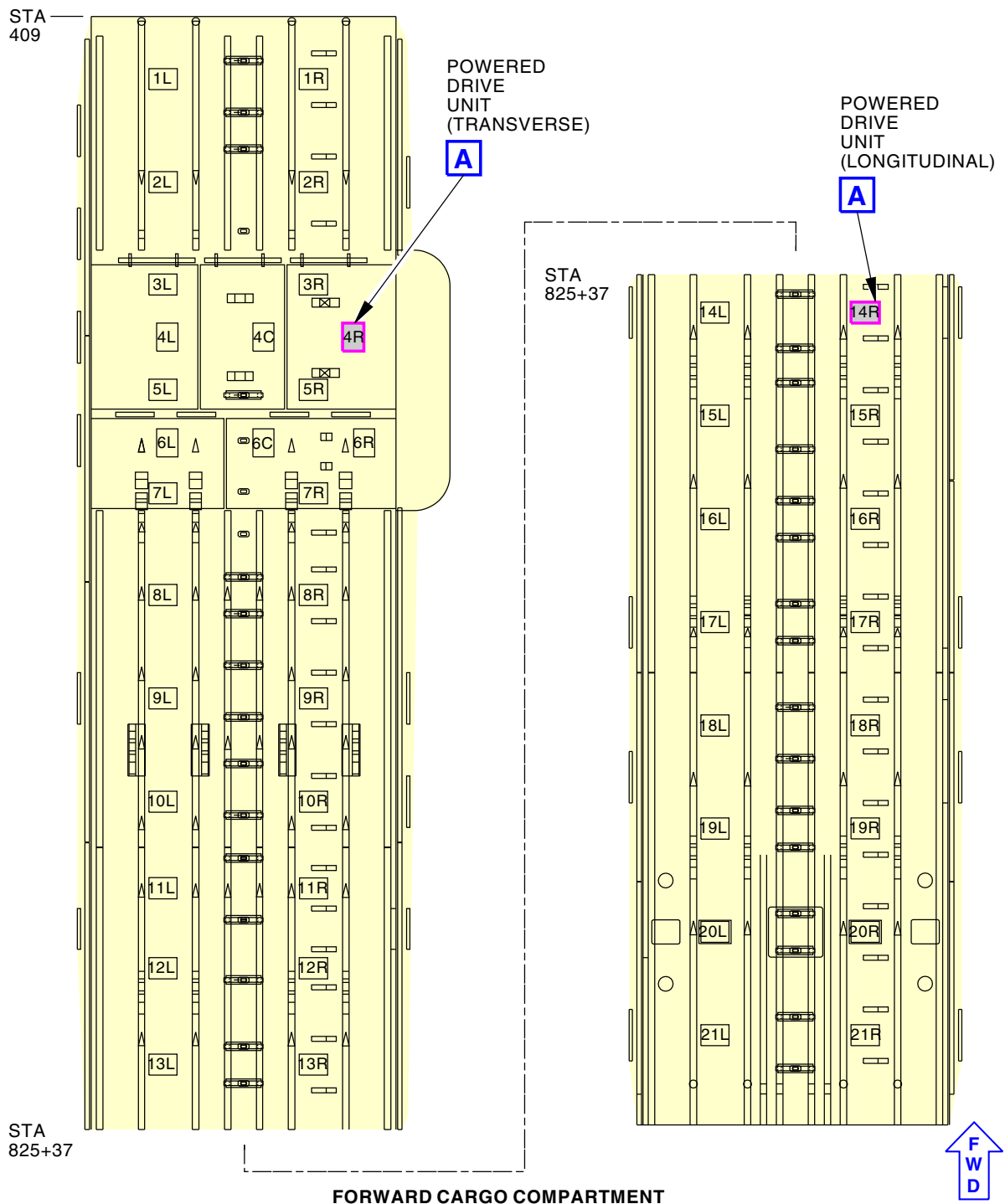
D633W101-ARO

25-53-00

Config 3
Page 529
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL



G86272 S0006410866_V2

Powered Drive Unit Test
Figure 503/25-53-00-990-811-003 (Sheet 1 of 3)

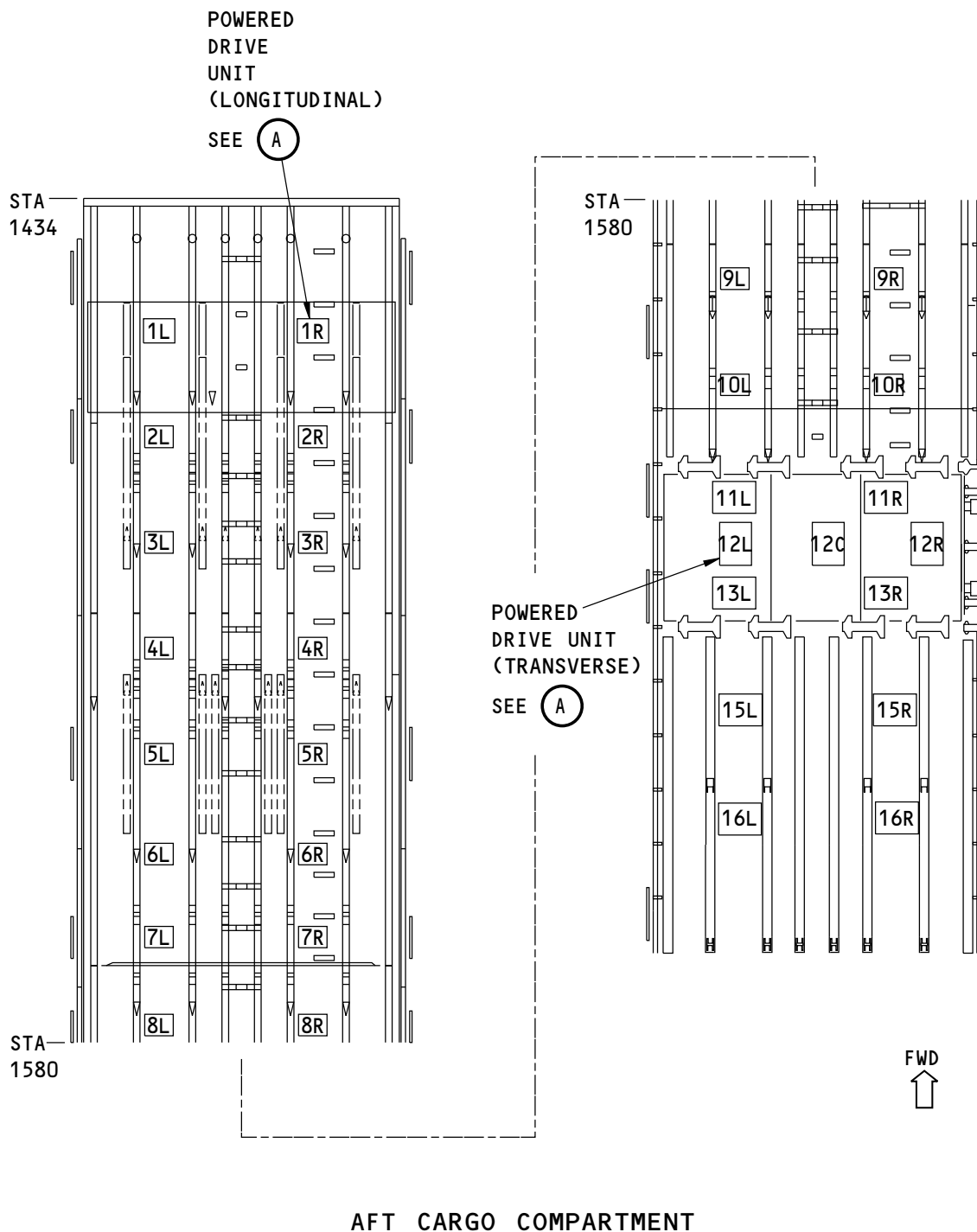
EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 530
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



H65465 S0006410868_V1

Powered Drive Unit Test
Figure 503/25-53-00-990-811-003 (Sheet 2 of 3)

EFFECTIVITY
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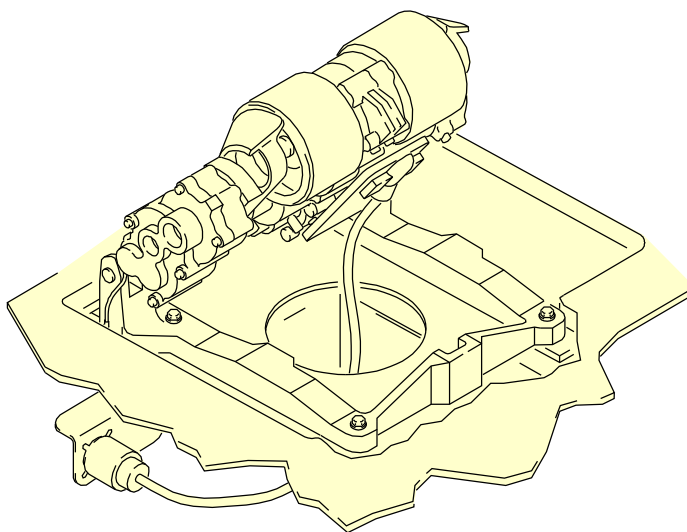
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25-53-00

Config 3
Page 531
Sep 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL



POWERED DRIVE UNIT



G86563 S0006410869_V2

Powered Drive Unit Test
Figure 503/25-53-00-990-811-003 (Sheet 3 of 3)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 532
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-53-00-700-817-003

6. **Right PDU Test**

(Figure 503)

A. General

- (1) This task contains the test for the right PDUs in these compartments:
 - (a) Forward cargo compartment
 - (b) Aft cargo compartment.

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Right PDU Test - Forward Cargo Compartment

SUBTASK 25-53-00-840-048-003

- (1) Do this task: Prepare for the Test, TASK 25-53-00-840-805-003.

SUBTASK 25-53-00-860-465-003

- (2) Remove the safety tags and close these circuit breakers:

Auxiliary Power Panel, P300

Row	Col	Number	Name
B	3	C25308	CARGO HDLG FWD COMPT R

FWD Cargo Handling Access Panel, P35

Row	Col	Number	Name
A	11	C25029	CSC DC-RIGHT

Ground Service/Handling Power Panel, P320

Row	Col	Number	Name
C	9	C25613	CARGO HDLG CTRL FWD

SUBTASK 25-53-00-860-466-003

- (3) Move the SYSTEM POWER switch to the ON position.

SUBTASK 25-53-00-860-467-003

- (4) Make sure the switches on the cargo system control panel, P24, are in these positions:

Table 512/25-53-00-993-849

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD
Pallets/Containers	PALLETS

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 533
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-468-003

- (5) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	1	C25021	PDU 1R, 5R, 12R

SUBTASK 25-53-00-710-606-003

- (6) Move the joystick to the FWD position.
(a) Make sure that only PDUs 1R and 5R operate forward.

SUBTASK 25-53-00-710-607-003

- (7) Move the PDU FWD/AFT switch to the AFT position.

SUBTASK 25-53-00-710-608-003

- (8) Move the joystick to the AFT position.
(a) Make sure that only PDUs 5R and 12R operate aft.

SUBTASK 25-53-00-860-469-003

- (9) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	1	C25021	PDU 1R, 5R, 12R

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-470-003

- (10) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C25022	PDU 2R, 7R, 13R

SUBTASK 25-53-00-710-609-003

- (11) Move the joystick to the AFT position.
(a) Make sure that only PDUs 7R and 13R operate aft.

SUBTASK 25-53-00-710-610-003

- (12) Move the PDU FWD/AFT switch to the FWD position.

SUBTASK 25-53-00-710-611-003

- (13) Move the joystick to the FWD position.
(a) Make sure that only PDUs 2R and 7R operate forward.

SUBTASK 25-53-00-860-471-003

- (14) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C25022	PDU 2R, 7R, 13R

NOTE: The PDUs go down when you open the circuit breaker.

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25-53-00

Config 3
Page 534
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-472-003

- (15) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	3	C25023	PDU 3R, 11R

SUBTASK 25-53-00-710-612-003

- (16) Move the PDU FWD/AFT switch to the AFT position.

SUBTASK 25-53-00-710-613-003

- (17) Move the joystick to the AFT position.
(a) Make sure that only PDUs 3R and 11R operate aft.

SUBTASK 25-53-00-860-473-003

- (18) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	3	C25023	PDU 3R, 11R

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-474-003

- (19) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	4	C25024	PDU 6C, 8R, 16R

SUBTASK 25-53-00-710-614-003

- (20) Move the joystick to the AFT position.
(a) Make sure that only PDUs 8R and 16R operate aft.

SUBTASK 25-53-00-710-615-003

- (21) Move the joystick to the IN position.
(a) Make sure that only PDU 6C operates in.

SUBTASK 25-53-00-860-475-003

- (22) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	4	C25024	PDU 6C, 8R, 16R

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-476-003

- (23) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	5	C25025	PDU 4R, 9R, 17R

SUBTASK 25-53-00-710-616-003

- (24) Move the joystick to the AFT position.
(a) Make sure that only PDUs 9R and 17R operate aft.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 535
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-710-617-003

- (25) Move the joystick to the OUT position.
- (a) Make sure that only PDU 4R operates out.

SUBTASK 25-53-00-860-477-003

- (26) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	5	C25025	PDU 4R, 9R, 17R

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-478-003

- (27) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	6	C25026	PDU 6R, 10R, 18R

SUBTASK 25-53-00-710-618-003

- (28) Move the joystick to the AFT position.
- (a) Make sure that only PDUs 10R and 18R operate aft.

SUBTASK 25-53-00-710-619-003

- (29) Move the joystick to the OUT position.
- (a) Make sure that only PDU 6R operates out.

SUBTASK 25-53-00-860-479-003

- (30) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	6	C25026	PDU 6R, 10R, 18R

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-480-003

- (31) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	1	C25030	PDU 14R, 20R

SUBTASK 25-53-00-710-620-003

- (32) Move the joystick to the AFT position.
- (a) Make sure that only PDUs 14R and 20R operate aft.

SUBTASK 25-53-00-860-481-003

- (33) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	1	C25030	PDU 14R, 20R

NOTE: The PDUs go down when you open the circuit breaker.

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25-53-00

Config 3
Page 536
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-482-003

- (34) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	2	C25031	PDU 15R, 21R

SUBTASK 25-53-00-710-621-003

- (35) Move the joystick to the AFT position.
(a) Make sure that only PDUs 15R and 21R operate aft.

SUBTASK 25-53-00-860-483-003

- (36) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	2	C25031	PDU 15R, 21R

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-484-003

- (37) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	3	C25032	PDU 19R

SUBTASK 25-53-00-710-622-003

- (38) Move the joystick to the AFT position.
(a) Make sure that only PDU 19R operates aft.

SUBTASK 25-53-00-860-485-003

- (39) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	3	C25032	PDU 19R

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-486-003

- (40) Move the SYSTEM POWER switch to the OFF position.

SUBTASK 25-53-00-860-N68-003

- (41) Make sure the switches on the cargo system control panel, P24, are in these positions:

Table 513/25-53-00-993-970-003

Switch Nomenclature	Position
System Power	OFF
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD
Pallets/Containers	PALLETS

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 537
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-487-003

- (42) Open these circuit breakers and install safety tags:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	3	C25308	CARGO HDLG FWD COMPT R

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	11	C25029	CSC DC-RIGHT

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	9	C25613	CARGO HDLG CTRL FWD

D. Right PDU Test - Aft Cargo Compartment

SUBTASK 25-53-00-840-050-003

- (1) Do this task: Prepare for the Test, TASK 25-53-00-840-805-003.

SUBTASK 25-53-00-860-507-003

- (2) Remove the safety tags and close these circuit breakers:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 001-010			
A	5	C25310	CARGO HDLG AFT COMPT R

ARO 011-999

C	3	C25310	CARGO HDLG AFT COMPT R

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO ALL			
A	11	C25129	CSC DC RIGHT
C	1	C25121	PDU 1R, 13R

SUBTASK 25-53-00-860-508-003

- (3) Move the SYSTEM POWER switch to the ON position.

SUBTASK 25-53-00-860-509-003

- (4) Make sure the switches on the cargo system control panel, P27, are in these positions:

Table 514/25-53-00-993-851

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD

SUBTASK 25-53-00-710-N85-003

- (5) Move the joystick to the FWD position.
(a) Make sure that only PDUs 1R and 13R operate forward.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 538
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-K51-003

- (6) Open this circuit breaker and install safety tag:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	1	C25121	PDU 1R, 13R

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-K52-003

- (7) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C25122	PDU 2R, 8R, 12R

SUBTASK 25-53-00-710-N86-003

- (8) Move the joystick to the FWD position.
(a) Make sure that only PDUs 2R and 8R operate forward.

SUBTASK 25-53-00-710-N87-003

- (9) Move the joystick to the IN position.
(a) Make sure that only PDU 12R operates in.

SUBTASK 25-53-00-860-K53-003

- (10) Open this circuit breaker and install safety tag:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C25122	PDU 2R, 8R, 12R

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-K54-003

- (11) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	3	C25123	PDU 3R, 9R, 14R

SUBTASK 25-53-00-710-N88-003

- (12) Move the joystick to the FWD position.
(a) Make sure that only PDUs 3R and 9R operate forward.

SUBTASK 25-53-00-860-K55-003

- (13) Open this circuit breaker and install safety tag:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	3	C25123	PDU 3R, 9R, 14R

NOTE: The PDUs go down when you open the circuit breaker.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 539
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-K56-003

- (14) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	4	C25124	PDU 4R, 10R, 14C

SUBTASK 25-53-00-710-N90-003

- (15) Move the joystick to the FWD position.
(a) Make sure that only PDUs 4R and 10R operate forward.

SUBTASK 25-53-00-860-K57-003

- (16) Open this circuit breaker and install safety tag:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	4	C25124	PDU 4R, 10R, 14C

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-K58-003

- (17) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	5	C25125	PDU 5R, 11R, 16R

SUBTASK 25-53-00-710-N92-003

- (18) Move the joystick to the FWD position.
(a) Make sure that only PDUs 5R and 11R operate forward.

SUBTASK 25-53-00-710-N93-003

- (19) Move the PDU FWD/AFT switch to the AFT position.

SUBTASK 25-53-00-860-N38

- (20) Make sure the switches on the cargo system control panel, P27, are in these positions:

Table 515/25-53-00-993-942

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	AFT

SUBTASK 25-53-00-710-N94-003

- (21) Move the joystick to the AFT position.
(a) Make sure that only PDUs 11R and 16R operate aft.

SUBTASK 25-53-00-860-K59-003

- (22) Open this circuit breaker and install safety tag:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	5	C25125	PDU 5R, 11R, 16R

NOTE: The PDUs go down when you open the circuit breaker.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 540
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-K60-003

- (23) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	6	C25119	PDU 6R, 17R

SUBTASK 25-53-00-710-N95-003

- (24) Move the PDU FWD/AFT switch to the FWD position.

SUBTASK 25-53-00-860-N39

- (25) Make sure the switches on the cargo system control panel, P27, are in these positions:

Table 516/25-53-00-993-943

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD

SUBTASK 25-53-00-710-N96-003

- (26) Move the joystick to the AFT position.
(a) Make sure that only PDU 6R operates aft.

SUBTASK 25-53-00-860-K61-003

- (27) Open this circuit breaker and install safety tag:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	6	C25119	PDU 6R, 17R

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-K62-003

- (28) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	1	C25200	PDU 7R, 15R

SUBTASK 25-53-00-710-N99-003

- (29) Move the joystick to the FWD position.
(a) Make sure that only PDU 7R operates forward.

SUBTASK 25-53-00-710-P00-003

- (30) Move the PDU FWD/AFT switch to the AFT position.

SUBTASK 25-53-00-860-N40

- (31) Make sure the switches on the cargo system control panel, P27, are in these positions:

Table 517/25-53-00-993-944

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 541
Sep 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

Table 517/25-53-00-993-944 (Continued)

Switch Nomenclature	Position
PDU Fwd/Aft	AFT

SUBTASK 25-53-00-710-P01-003

- (32) Move the joystick to the AFT position.
- (a) Make sure that only PDU 15R operates aft.

SUBTASK 25-53-00-860-K63-003

- (33) Open this circuit breaker and install safety tag:

Cargo Handling Accessory Panel - Aft, P39

Row	Col	Number	Name
E	1	C25200	PDU 7R, 15R

NOTE: The PDUs go down when you open the circuit breaker.

SUBTASK 25-53-00-860-K64-003

- (34) Move the SYSTEM POWER switch to the OFF position.

SUBTASK 25-53-00-710-U38

- (35) Move the PDU FWD/AFT switch to the FWD position.

SUBTASK 25-53-00-860-N41

- (36) Make sure the switches on the cargo system control panel, P27, are in these positions:

Table 518/25-53-00-993-945

Switch Nomenclature	Position
System Power	OFF
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD

————— END OF TASK —————

TASK 25-53-00-700-818-003

7. PDU Bay Off and PDU Up and Braked Test

(Figure 503)

A. General

- (1) This task contains the PDU bay off and PDU Up and braked test in these compartments:
- (a) Forward cargo compartment
- (b) Aft cargo compartment.

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

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25-53-00

Config 3
Page 542
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

C. PDU Bay Off and PDU Up and Braked Test - Forward Cargo Compartment

SUBTASK 25-53-00-840-051-003

- (1) Do this task: Prepare for the Test, TASK 25-53-00-840-805-003.

SUBTASK 25-53-00-860-K66-003

- (2) Remove the safety tags and close these circuit breakers:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 001-010			
A	2	C25307	CARGO HDLG FWD COMPT L
ARO 011-999			
A	3	C25307	CARGO HDLG FWD COMPT L
ARO ALL			
B	3	C25308	CARGO HDLG FWD COMPT R

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C25028	CSC DC-LEFT
A	11	C25029	CSC DC-RIGHT
B	1	C25011	PDU 1L, 5L, 12L
B	2	C25012	PDU 2L, 7L, 13L
B	3	C25013	PDU 3L, 11L
B	4	C25014	PDU 4C, 8L, 16L
B	5	C25015	PDU 4L, 9L, 17L
B	6	C25016	PDU 6L, 10L, 18L
C	1	C25021	PDU 1R, 5R, 12R
C	2	C25022	PDU 2R, 7R, 13R
C	3	C25023	PDU 3R, 11R
C	4	C25024	PDU 6C, 8R, 16R
C	5	C25025	PDU 4R, 9R, 17R
C	6	C25026	PDU 6R, 10R, 18R
D	1	C25018	PDU 14L, 20L
D	2	C25019	PDU 15L, 21L
D	3	C25020	PDU 19L
E	1	C25030	PDU 14R, 20R
E	2	C25031	PDU 15R, 21R
E	3	C25032	PDU 19R

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	9	C25613	CARGO HDLG CTRL FWD

SUBTASK 25-53-00-710-660-003

- (3) Move the SYSTEM POWER switch to the ON position.
(a) Make sure the POWER ON light and the BAY ON lights come on.

SUBTASK 25-53-00-860-522-003

- (4) Make sure the switches on the cargo system control panel, P24, are in these positions:

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 543
Sep 05/2016



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

Table 519/25-53-00-993-827

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	AFT
Pallets/Containers	CONTAINERS

SUBTASK 25-53-00-710-662-003

- (5) Move the joystick to the FWD position.
- (a) Make sure these PDUs operate forward:
- 3L, 5L, 7L, 8L, 9L, 10L, 11L, 12L, 13L, 14L, 15L, 16L, 17L, 18L, 19L, 20L, 21L
 - 3R, 5R, 7R, 8R, 9R, 10R, 11R, 12R, 13R, 14R, 15R, 16R, 17R, 18R, 19R, 20R, 21R

SUBTASK 25-53-00-710-663-003

- (6) Release the joystick.
- (a) Make sure the rollers of the same PDUs lift above the conveyor plane and stay motionless.
- NOTE: The conveyor plane is the top of the rollers in the roller trays. In the doorway area, the conveyor plane is the top of the balls in the ball panels.

SUBTASK 25-53-00-710-664-003

- (7) Push and release the BAY L OFF switch.
- (a) Make sure the BAY L ON light goes off.

SUBTASK 25-53-00-710-665-003

- (8) Move the joystick to the FWD position.
- (a) Make sure these PDUs operate forward:
- 3L, 5L, 7L, 8L, 9L, 10L, 11L, 12L, 13L, 14L, 15L, 16L, 17L, 18L, 19L, 20L
 - 3R, 5R, 7R, 8R, 9R, 10R, 11R, 12R, 13R, 14R, 15R, 16R, 17R, 18R, 19R, 20R

SUBTASK 25-53-00-710-666-003

- (9) Push and release the BAY K OFF switch.
- (a) Make sure the BAY K ON light goes off.

SUBTASK 25-53-00-710-667-003

- (10) Move the joystick to the FWD position.
- (a) Make sure these PDUs operate forward:
- 3L, 5L, 7L, 8L, 9L, 10L, 11L, 12L, 13L, 14L, 15L, 16L, 17L, 18L
 - 3R, 5R, 7R, 8R, 9R, 10R, 11R, 12R, 13R, 14R, 15R, 16R, 17R, 18R

SUBTASK 25-53-00-710-668-003

- (11) Push and release the BAY J OFF switch.
- (a) Make sure the BAY J ON light goes off.

SUBTASK 25-53-00-710-669-003

- (12) Move the joystick to the FWD position.
- (a) Make sure these PDUs operate forward:

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 544
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 1) 3L, 5L, 7L, 8L, 9L, 10L, 11L, 12L, 13L, 14L, 15L, 16L, 17L
- 2) 3R, 5R, 7R, 8R, 9R, 10R, 11R, 12R, 13R, 14R, 15R, 16R, 17R

SUBTASK 25-53-00-710-670-003

- (13) Push and release the BAY I OFF switch.
 - (a) Make sure the BAY I ON light goes off.

SUBTASK 25-53-00-710-671-003

- (14) Move the joystick to the FWD position.
 - (a) Make sure these PDUs operate forward:
 - 1) 3L, 5L, 7L, 8L, 9L, 10L, 11L, 12L, 13L, 14L, 15L
 - 2) 3R, 5R, 7R, 8R, 9R, 10R, 11R, 12R, 13R, 14R, 15R

SUBTASK 25-53-00-710-672-003

- (15) Push and release the BAY H OFF switch.
 - (a) Make sure the BAY H ON light goes off.

SUBTASK 25-53-00-710-673-003

- (16) Move the joystick to the FWD position.
 - (a) Make sure these PDUs operate forward:
 - 1) 3L, 5L, 7L, 8L, 9L, 10L, 11L, 12L, 13L, 14L
 - 2) 3R, 5R, 7R, 8R, 9R, 10R, 11R, 12R, 13R, 14R

SUBTASK 25-53-00-710-674-003

- (17) Push and release the BAY G OFF switch.
 - (a) Make sure the BAY G ON light goes off.

SUBTASK 25-53-00-710-675-003

- (18) Move the joystick to the FWD position.
 - (a) Make sure these PDUs operate forward:
 - 1) 3L, 5L, 7L, 8L, 9L, 10L, 11L, 12L
 - 2) 3R, 5R, 7R, 8R, 9R, 10R, 11R, 12R

SUBTASK 25-53-00-710-676-003

- (19) Push and release the BAY F OFF switch.
 - (a) Make sure the BAY F ON light goes off.

SUBTASK 25-53-00-710-677-003

- (20) Move the joystick to the FWD position.
 - (a) Make sure these PDUs operate forward:
 - 1) 3L, 5L, 7L, 8L, 9L, 10L, 11L
 - 2) 3R, 5R, 7R, 8R, 9R, 10R, 11R

SUBTASK 25-53-00-710-678-003

- (21) Push and release the BAY E OFF switch.
 - (a) Make sure the BAY E ON light goes off.

SUBTASK 25-53-00-710-679-003

- (22) Move the joystick to the FWD position.
 - (a) Make sure these PDUs operate forward:

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 545
Sep 05/2016



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

- 1) 3L, 5L, 7L, 8L, 9L
- 2) 3R, 5R, 7R, 8R, 9R

SUBTASK 25-53-00-710-680-003

- (23) Push and release the BAY D OFF switch.
- (a) Make sure the BAY D ON light goes off.

SUBTASK 25-53-00-710-681-003

- (24) Move the joystick to the FWD position.
- (a) Make sure these PDUs operate forward:
- 1) 3L, 5L, 7L, 8L
 - 2) 3R, 5R, 7R, 8R

SUBTASK 25-53-00-710-U85-003

- (25) Push and release the BAY D OFF switch.
- (a) Make sure the BAY D ON light comes on.

SUBTASK 25-53-00-710-U86-003

- (26) Push and release the BAY E OFF switch.
- (a) Make sure the BAY E ON light comes on.

SUBTASK 25-53-00-710-U87-003

- (27) Push and release the BAY F OFF switch.
- (a) Make sure the BAY F ON light comes on.

SUBTASK 25-53-00-710-U88-003

- (28) Push and release the BAY G OFF switch.
- (a) Make sure the BAY G ON light comes on.

SUBTASK 25-53-00-710-U89-003

- (29) Push and release the BAY H OFF switch.
- (a) Make sure the BAY H ON light comes on.

SUBTASK 25-53-00-710-U90-003

- (30) Push and release the BAY I OFF switch.
- (a) Make sure the BAY I ON light comes on.

SUBTASK 25-53-00-710-U91-003

- (31) Push and release the BAY J OFF switch.
- (a) Make sure the BAY J ON light comes on.

SUBTASK 25-53-00-710-U92-003

- (32) Push and release the BAY K OFF switch.
- (a) Make sure the BAY K ON light comes on.

SUBTASK 25-53-00-710-U93-003

- (33) Push and release the BAY L OFF switch.
- (a) Make sure the BAY L ON light comes on.

SUBTASK 25-53-00-710-682-003

- (34) Move the PDU FWD/AFT switch to the FWD position.

SUBTASK 25-53-00-710-683-003

- (35) Move the PALLETS/CONTAINERS switch to the PALLETS position.

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ARO ALL

D633W101-ARO

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25-53-00

Config 3
Page 546
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-710-684-003

- (36) Move the joystick to the AFT position.
- (a) Make sure these PDUs operate aft:
- 1) 1L, 2L, 3L, 5L, 7L
 - 2) 1R, 2R, 3R, 5R, 7R

SUBTASK 25-53-00-710-685-003

- (37) Release the joystick.
- (a) Make sure the rollers of the same PDUs lift above the conveyor plane and stay motionless.
- NOTE: The conveyor plane is the top of the rollers in the roller trays. In the doorway area, the conveyor plane is the top of the balls in the ball panels.

SUBTASK 25-53-00-710-686-003

- (38) Move the joystick to the IN position.
- (a) Make sure these PDUs lower:
- 1) 3L, 5L, 7L
 - 2) 3R, 5R, 7R
- (b) Make sure these PDUs operate in:
- 1) 4L, 6L
 - 2) 4C, 6C
 - 3) 4R, 6R

SUBTASK 25-53-00-710-687-003

- (39) Release the joystick.
- (a) Make sure the rollers of the same PDUs lift above the conveyor plane and stay motionless.
- NOTE: The conveyor plane is the top of the rollers in the roller trays. In the doorway area, the conveyor plane is the top of the balls in the ball panels.

SUBTASK 25-53-00-710-688-003

- (40) Move the joystick to the AFT position.
- (a) Make sure these PDUs lower:
- 1) 4L, 6L
 - 2) 4C, 6C
 - 3) 4R, 6R
- (b) Make sure these PDUs operate aft:
- 1) 1L, 2L, 3L, 5L, 7L
 - 2) 1R, 2R, 3R, 5R, 7R

SUBTASK 25-53-00-860-524-003

- (41) Open these circuit breakers and install safety tags:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C25028	CSC DC-LEFT
A	11	C25029	CSC DC-RIGHT

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 547
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-523-003

- (42) Move the SYSTEM POWER switch to the OFF position.

D. PDU Bay Off and PDU Up and Braked Test - Aft Cargo Compartment

SUBTASK 25-53-00-840-053-003

- (1) Do this task: Prepare for the Test, TASK 25-53-00-840-805-003.

SUBTASK 25-53-00-860-K69-003

- (2) Remove the safety tags and close these circuit breakers:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 011-999			
A	2	C25309	CARGO HDLG AFT COMPT L
ARO 001-010			
A	3	C25309	CARGO HDLG AFT COMPT L
A	5	C25310	CARGO HDLG AFT COMPT R
ARO 011-999			
C	3	C25310	CARGO HDLG AFT COMPT R

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO ALL			
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT
B	1	C25111	PDU 1L ,13L
B	2	C25112	PDU 2L, 8L, 12L
B	3	C25113	PDU 3L, 9L, 14L
B	4	C25114	PDU 4L, 10L, 12C
B	5	C25115	PDU 5L, 11L, 16L
C	1	C25121	PDU 1R, 13R
C	2	C25122	PDU 2R, 8R, 12R
C	3	C25123	PDU 3R, 9R, 14R
C	4	C25124	PDU 4R, 10R, 14C
C	5	C25125	PDU 5R, 11R, 16R

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	10	C25614	CARGO HDLG CTRL AFT

Remove the safety tags and close these circuit breakers:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	6	C25117	PDU 6L, 17L
C	6	C25119	PDU 6R, 17R
D	1	C25118	PDU 7L, 15L,
E	1	C25200	PDU 7R, 15R

SUBTASK 25-53-00-710-P04-003

- (3) Move the SYSTEM POWER switch to the ON position.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 548
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Make sure that the BAY ON lights come on

SUBTASK 25-53-00-710-P05-003

- (4) Move the PDU FWD/AFT switch to the FWD position.

SUBTASK 25-53-00-860-K70-003

- (5) Make sure the switches on the cargo system control panel, P27, are in these positions:

Table 520/25-53-00-993-829

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD

SUBTASK 25-53-00-710-P06-003

- (6) Move the joystick to the AFT position.

- (a) Make sure these PDUs operate aft:

- 1) 1L, 2L, 3L, 4L, 5L, 6L, 7L, 8L, 9L, 10L, 11L, 13L
- 2) 1R, 2R, 3R, 4R, 5R, 6R, 7R, 8R, 9R, 10R, 11R, 13R

SUBTASK 25-53-00-710-P07-003

- (7) Release the joystick.

- (a) Make sure the rollers of the same PDUs lift above the conveyor plane and stay motionless.

NOTE: The conveyor plane is the top of the rollers in the roller trays. In the doorway area, the conveyor plane is the top of the balls in the ball panels.

SUBTASK 25-53-00-710-P08-003

- (8) Push and release the BAY A OFF switch.

- (a) Make sure the BAY A ON light goes off.

SUBTASK 25-53-00-710-P09-003

- (9) Move the joystick to the AFT position.

- (a) Make sure these PDUs operate aft:

- 1) 2L, 3L, 4L, 5L, 6L, 7L, 8L, 9L, 10L, 11L, 13L
- 2) 2R, 3R, 4R, 5R, 6R, 7R, 8R, 9R, 10R, 11R, 13R

SUBTASK 25-53-00-710-P10-003

- (10) Push and release the BAY B OFF switch.

- (a) Make sure the BAY B ON light goes off.

SUBTASK 25-53-00-710-P11-003

- (11) Move the joystick to the AFT position.

- (a) Make sure these PDUs operate aft:

- 1) 4L, 5L, 6L, 7L, 8L, 9L, 10L, 11L, 13L
- 2) 4R, 5R, 6R, 7R, 8R, 9R, 10R, 11R, 13R

SUBTASK 25-53-00-710-P12-003

- (12) Push and release the BAY C OFF switch.

- (a) Make sure the BAY C ON light goes off.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 549
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-710-P13-003

- (13) Move the joystick to the AFT position.
 - (a) Make sure these PDUs operate aft:
 - 1) 5L, 6L, 7L, 8L, 9L, 10L, 11L, 13L
 - 2) 5R, 6R, 7R, 8R, 9R, 10R, 11R, 13R

SUBTASK 25-53-00-710-P14-003

- (14) Push and release the BAY D OFF switch.
 - (a) Make sure the BAY D ON light goes off.

SUBTASK 25-53-00-710-P15-003

- (15) Move the joystick to the AFT position.
 - (a) Make sure these PDUs operate aft:
 - 1) 6L, 7L, 8L, 9L, 10L, 11L, 13L
 - 2) 6R, 7R, 8R, 9R, 10R, 11R, 13R

SUBTASK 25-53-00-710-P16-003

- (16) Push and release the BAY E OFF switch.
 - (a) Make sure the BAY E ON light goes off.

SUBTASK 25-53-00-710-P17-003

- (17) Move the joystick to the AFT position.
 - (a) Make sure these PDUs operate aft:
 - 1) 8L, 9L, 10L, 11L, 13L
 - 2) 8R, 9R, 10R, 11R, 13R

SUBTASK 25-53-00-710-P18-003

- (18) Push and release the BAY F OFF switch.
 - (a) Make sure the BAY F ON light goes off.

SUBTASK 25-53-00-710-P19-003

- (19) Move the joystick to the AFT position.
 - (a) Make sure these PDUs operate aft:
 - 1) 10L, 11L, 13L
 - 2) 10R, 11R, 13R

SUBTASK 25-53-00-710-P20-003

- (20) Move the PDU FWD/AFT switch to the AFT position.

SUBTASK 25-53-00-710-P21-003

- (21) Move the joystick to the FWD position.
 - (a) Make sure these PDUs operate forward:
 - 1) 11L, 13L, 15L, 16L
 - 2) 11R, 13R, 15R, 16R

SUBTASK 25-53-00-710-P22-003

- (22) Release the joystick.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 550
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Make sure the rollers of the same PDUs lift above the conveyor plane and stay motionless.

NOTE: The conveyor plane is the top of the rollers in the roller trays. In the doorway area, the conveyor plane is the top of the balls in the ball panels.

SUBTASK 25-53-00-710-P23-003

- (23) Move the joystick to the IN position.
 - (a) Make sure these PDUs lower:
 - 1) 11L, 13L
 - 2) 11R, 13R
 - (b) Make sure these PDUs operate in:
 - 1) 12L, 12C, 12R

SUBTASK 25-53-00-710-P24-003

- (24) Release the joystick.
 - (a) Make sure the rollers for these PDUs lift above the conveyor plane and stay motionless:
 - 1) 12L, 12C, 12R

SUBTASK 25-53-00-710-P25-003

- (25) Push and release the BAY J OFF switch.
 - (a) Make sure the BAY J ON light goes off.

SUBTASK 25-53-00-710-P26-003

- (26) Move the joystick to the FWD position.
 - (a) Make sure these PDUs lower:
 - 1) 12L, 12C, 12R
 - (b) Make sure that these PDUs operate forward:
 - 1) 11L, 13L, 15L
 - 2) 11R, 13R, 15R

SUBTASK 25-53-00-710-P27-003

- (27) Push and release the BAY F OFF switch.
 - (a) Make sure the BAY F ON light comes on.

SUBTASK 25-53-00-710-P28-003

- (28) Push and release the BAY E OFF switch.
 - (a) Make sure the BAY E ON light comes on.

SUBTASK 25-53-00-710-P29-003

- (29) Push and release the BAY D OFF switch.
 - (a) Make sure the BAY D ON light comes on.

SUBTASK 25-53-00-710-P30-003

- (30) Push and release the BAY C OFF switch.
 - (a) Make sure the BAY C ON light comes on.

SUBTASK 25-53-00-710-P31-003

- (31) Push and release the BAY B OFF switch.
 - (a) Make sure the BAY B ON light comes on.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 551
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-710-P32-003

- (32) Push and release the BAY A OFF switch.
- (a) Make sure the BAY A ON light comes on.

SUBTASK 25-53-00-710-P33-003

- (33) Push and release the BAY J OFF switch.
- (a) Make sure the BAY J ON light comes on.

SUBTASK 25-53-00-860-K71-003

- (34) Move the SYSTEM POWER switch to the OFF position.

SUBTASK 25-53-00-860-K72-003

- (35) Open these circuit breakers and install safety tags:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 011-999			
A	2	C25309	CARGO HDLG AFT COMPT L
ARO 001-010			
A	3	C25309	CARGO HDLG AFT COMPT L
A	5	C25310	CARGO HDLG AFT COMPT R
ARO 011-999			
C	3	C25310	CARGO HDLG AFT COMPT R

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO ALL			
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT
B	1	C25111	PDU 1L, 13L
B	2	C25112	PDU 2L, 8L, 12L
B	3	C25113	PDU 3L, 9L, 14L
B	4	C25114	PDU 4L, 10L, 12C
B	5	C25115	PDU 5L, 11L, 16L
C	1	C25121	PDU 1R, 13R
C	2	C25122	PDU 2R, 8R, 12R
C	3	C25123	PDU 3R, 9R, 14R
C	4	C25124	PDU 4R, 10R, 14C
C	5	C25125	PDU 5R, 11R, 16R

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	10	C25614	CARGO HDLG CTRL AFT

Open these circuit breakers and install safety tags:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	6	C25117	PDU 6L, 17L
C	6	C25119	PDU 6R, 17R
D	1	C25118	PDU 7L, 15L,

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 552
Sep 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	1	C25200	PDU 7R, 15R

———— **END OF TASK** ————

TASK 25-53-00-700-819-003

8. Interlock Test

(Figure 503)

A. General

- (1) This task contains the interlock test in these compartments:
- (a) Forward cargo compartment
 - (b) Aft cargo compartment.

B. References

<u>Reference</u>	<u>Title</u>
52-30-00-860-802	Close the Aft Cargo Door (P/B 201)
52-34-00-860-803	Close the Door Electrically with the External Cargo Door Control Switch (P/B 201)

C. Location Zones

<u>Zone</u>	<u>Area</u>
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

D. Interlock Test - Forward Cargo Compartment

SUBTASK 25-53-00-840-054-003

- (1) Do this task: Prepare for the Test, TASK 25-53-00-840-805-003.

SUBTASK 25-53-00-860-534-003

- (2) Remove the safety tags and close these circuit breakers:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 001-010			
A	2	C25307	CARGO HDLG FWD COMPT L
ARO 011-999			
A	3	C25307	CARGO HDLG FWD COMPT L
ARO ALL			
B	3	C25308	CARGO HDLG FWD COMPT R

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	11	C25029	CSC DC-RIGHT
B	1	C25011	PDU 1L, 5L, 12L
B	2	C25012	PDU 2L, 7L, 13L

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 553
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	3	C25013	PDU 3L, 11L
B	4	C25014	PDU 4C, 8L, 16L
B	5	C25015	PDU 4L, 9L, 17L
B	6	C25016	PDU 6L, 10L, 18L
C	1	C25021	PDU 1R, 5R, 12R
C	2	C25022	PDU 2R, 7R, 13R
C	3	C25023	PDU 3R, 11R
C	4	C25024	PDU 6C, 8R, 16R
C	5	C25025	PDU 4R, 9R, 17R
C	6	C25026	PDU 6R, 10R, 18R
D	1	C25018	PDU 14L, 20L
D	2	C25019	PDU 15L, 21L
D	3	C25020	PDU 19L
E	1	C25030	PDU 14R, 20R
E	2	C25031	PDU 15R, 21R
E	3	C25032	PDU 19R

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	9	C25613	CARGO HDLG CTRL FWD

SUBTASK 25-53-00-860-535-003

(3) Move the SYSTEM POWER switch to the ON position.

SUBTASK 25-53-00-860-536-003

(4) Make sure the switches on the cargo system control panel, P24, are in these positions:

Table 521/25-53-00-993-809

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD
Pallets/Containers	PALLETS

SUBTASK 25-53-00-710-741-003

(5) Move the joystick to the FWD position.

(a) Make sure these PDUs operate forward:

1) 1R, 2R, 3R, 5R, 7R

SUBTASK 25-53-00-710-742-003

(6) Move the PDU FWD/AFT switch to the AFT position.

SUBTASK 25-53-00-860-M80-003

(7) Make sure the switches on the cargo system control panel P24, are in these positions:

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 554
Sep 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

Table 522/25-53-00-993-905

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	AFT
Pallets/Containers	PALLETS

SUBTASK 25-53-00-710-743-003

- (8) Move the joystick to the AFT position.
- (a) Make sure these PDUs operate aft:
- 3R, 5R, 7R, 8R, 9R, 10R, 11R, 12R, 13R, 14R, 15R, 16R, 17R, 18R, 19R, 20R, 21R

SUBTASK 25-53-00-860-537-003

- (9) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C25028	CSC DC-LEFT

SUBTASK 25-53-00-860-538-003

- (10) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	11	C25029	CSC DC-RIGHT

SUBTASK 25-53-00-710-744-003

- (11) Move the joystick to the AFT position.
- (a) Make sure these PDUs operate aft:
- 3L, 5L, 7L, 8L, 9L, 10L, 11L, 12L, 13L, 14L, 15L, 16L, 17L, 18L, 19L, 20L, 21L

SUBTASK 25-53-00-710-745-003

- (12) Move the PDU FWD/AFT switch to the FWD position.

SUBTASK 25-53-00-860-M81-003

- (13) Make sure the switches on the cargo system control panel P24, are in these positions:

Table 523/25-53-00-993-904

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD
Pallets/Containers	PALLETS

SUBTASK 25-53-00-710-746-003

- (14) Move the joystick to the FWD position.
- (a) Make sure these PDUs operate forward:
- 1L, 2L, 3L, 5L, 7L

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 555
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-539-003

- (15) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	11	C25029	CSC DC-RIGHT

SUBTASK 25-53-00-860-540-003

- (16) Close the forward large cargo door approximately two feet. Do this task:
TASK 52-34-00-860-803.

- (a) Make sure the POWER ON light and the BAY ON lights go off.

SUBTASK 25-53-00-710-S44-003

- (17) Move the P24 cargo control panel joystick to the FWD, AFT, IN and OUT positions.

- (a) Make sure that the PDUs and lateral guides do not move.

SUBTASK 25-53-00-860-541-003

- (18) Move the SYSTEM POWER switch to the OFF position.

E. Interlock Test - Aft Cargo Compartment

SUBTASK 25-53-00-840-056-003

- (1) Do this task: Prepare for the Test, TASK 25-53-00-840-805-003.

SUBTASK 25-53-00-860-552-003

- (2) Remove the safety tags and close these circuit breakers:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 011-999			
A	2	C25309	CARGO HDLG AFT COMPT L
ARO 001-010			
A	3	C25309	CARGO HDLG AFT COMPT L
A	5	C25310	CARGO HDLG AFT COMPT R
ARO 011-999			
C	3	C25310	CARGO HDLG AFT COMPT R

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO ALL			
C	10	C25614	CARGO HDLG CTRL AFT

Remove the safety tags and close these circuit breakers:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	9	C25116	LATERAL GUIDES
A	11	C25129	CSC DC RIGHT
B	1	C25111	PDU 1L, 13L
B	2	C25112	PDU 2L, 8L, 12L
B	3	C25113	PDU 3L, 9L, 14L
B	4	C25114	PDU 4L, 10L, 12C
B	5	C25115	PDU 5L, 11L, 16L

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 556
Sep 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	6	C25117	PDU 6L, 17L
C	1	C25121	PDU 1R, 13R
C	2	C25122	PDU 2R, 8R, 12R
C	3	C25123	PDU 3R, 9R, 14R
C	4	C25124	PDU 4R, 10R, 14C
C	5	C25125	PDU 5R, 11R, 16R
C	6	C25119	PDU 6R, 17R
D	1	C25118	PDU 7L, 15L,
E	1	C25200	PDU 7R, 15R

SUBTASK 25-53-00-860-553-003

- (3) Move the SYSTEM POWER switch to the ON position.

SUBTASK 25-53-00-710-756-003

- (4) Move the PDU FWD/AFT switch to the AFT position.

SUBTASK 25-53-00-860-554-003

- (5) Make sure the switches on the cargo system control panel, P27, are in these positions:

Table 524/25-53-00-993-811

Switch Nomenclature	Position
System Power	ON
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	AFT

SUBTASK 25-53-00-710-757-003

- (6) Move the joystick to the AFT position.
- (a) Make sure these PDUs operate aft:
- 1) 11R, 13R, 15R, 16R

SUBTASK 25-53-00-710-758-003

- (7) Move the PDU FWD/AFT switch to the FWD position.

SUBTASK 25-53-00-710-759-003

- (8) Move the joystick to the FWD position.
- (a) Make sure these PDUs operate forward:
- 1) 1R, 2R, 3R, 4R, 5R, 6R, 7R, 8R, 9R, 10R, 11R, 13R

SUBTASK 25-53-00-860-555-003

- (9) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C25128	CSC DC LEFT

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 557
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-556-003

- (10) Open this circuit breaker and install safety tag:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	11	C25129	CSC DC RIGHT

SUBTASK 25-53-00-710-760-003

- (11) Move the joystick to the FWD position.

- (a) Make sure these PDUs operate forward:

1) 1L, 2L, 3L, 4L, 5L, 6L, 7L, 8L, 9L, 10L, 11L, 13L

SUBTASK 25-53-00-710-761-003

- (12) Move the PDU FWD/AFT switch to the AFT position.

SUBTASK 25-53-00-710-762-003

- (13) Move the joystick to the AFT position.

- (a) Make sure these PDUs operate aft:

1) 11L, 13L, 15L, 16L

SUBTASK 25-53-00-860-557-003

- (14) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	11	C25129	CSC DC RIGHT

SUBTASK 25-53-00-860-558-003

- (15) Close the aft cargo door approximately two feet. Do this task: TASK 52-30-00-860-802.

- (a) Make sure the POWER ON light and the BAY ON lights go off.

SUBTASK 25-53-00-710-P34-003

- (16) Move the joystick in the FWD, AFT, IN, and OUT directions.

- (a) Make sure the PDUs, and lateral guides do not move.

SUBTASK 25-53-00-860-559-003

- (17) Move the SYSTEM POWER switch to the OFF position.

SUBTASK 25-53-00-860-560-003

- (18) Open these circuit breakers and install safety tags:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>

ARO 011-999

A	2	C25309	CARGO HDLG AFT COMPT L

ARO 001-010

A	3	C25309	CARGO HDLG AFT COMPT L
A	5	C25310	CARGO HDLG AFT COMPT R

ARO 011-999

C	3	C25310	CARGO HDLG AFT COMPT R

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 558
Sep 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

ARO 011-999 (Continued)

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO ALL			
A	9	C25116	LATERAL GUIDES
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT
B	1	C25111	PDU 1L ,13L
B	2	C25112	PDU 2L, 8L, 12L
B	3	C25113	PDU 3L, 9L, 14L
B	4	C25114	PDU 4L, 10L, 12C
B	5	C25115	PDU 5L, 11L, 16L
C	1	C25121	PDU 1R, 13R
C	2	C25122	PDU 2R, 8R, 12R
C	3	C25123	PDU 3R, 9R, 14R
C	4	C25124	PDU 4R, 10R, 14C
C	5	C25125	PDU 5R, 11R, 16R

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	10	C25614	CARGO HDLG CTRL AFT

————— END OF TASK —————

TASK 25-53-00-840-806-003

9. Put the Airplane Back to Its Usual Condition

A. References

<u>Reference</u>	<u>Title</u>
52-30-00-860-802	Close the Aft Cargo Door (P/B 201)
52-34-00-860-803	Close the Door Electrically with the External Cargo Door Control Switch (P/B 201)

B. Location Zones

<u>Zone</u>	<u>Area</u>
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-00-840-057-003

- (1) Do this task: Close the Door Electrically with the External Cargo Door Control Switch, TASK 52-34-00-860-803.

SUBTASK 25-53-00-840-099-003

- (2) Do this task: Close the Aft Cargo Door, TASK 52-30-00-860-802.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 559
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-00-860-561-003

- (3) Remove the safety tags and close these circuit breakers:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	9	C25017	LATERAL GUIDES
A	10	C25028	CSC DC-LEFT
A	11	C25029	CSC DC-RIGHT
B	1	C25011	PDU 1L, 5L, 12L
B	2	C25012	PDU 2L, 7L, 13L
B	3	C25013	PDU 3L, 11L
B	4	C25014	PDU 4C, 8L, 16L
B	5	C25015	PDU 4L, 9L, 17L
B	6	C25016	PDU 6L, 10L, 18L
C	1	C25021	PDU 1R, 5R, 12R
C	2	C25022	PDU 2R, 7R, 13R
C	3	C25023	PDU 3R, 11R
C	4	C25024	PDU 6C, 8R, 16R
C	5	C25025	PDU 4R, 9R, 17R
C	6	C25026	PDU 6R, 10R, 18R
D	3	C25020	PDU 19L
E	1	C25030	PDU 14R, 20R
E	2	C25031	PDU 15R, 21R
E	3	C25032	PDU 19R

Remove the safety tags and close these circuit breakers:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	1	C25018	PDU 14L, 20L
D	2	C25019	PDU 15L, 21L

SUBTASK 25-53-00-860-562-003

- (4) Remove the safety tags and close these circuit breakers:

Auxiliary Power Panel, P300

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO 011-999			
A	2	C25309	CARGO HDLG AFT COMPT L
ARO 001-010			
A	2	C25307	CARGO HDLG FWD COMPT L
A	3	C25309	CARGO HDLG AFT COMPT L
ARO 011-999			
A	3	C25307	CARGO HDLG FWD COMPT L
ARO 001-010			
A	5	C25310	CARGO HDLG AFT COMPT R
ARO ALL			
B	3	C25308	CARGO HDLG FWD COMPT R
ARO 011-999			
C	3	C25310	CARGO HDLG AFT COMPT R

EFFECTIVITY
ARO ALL

D633W101-ARO

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25-53-00

Config 3
Page 560
Sep 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

ARO 011-999 (Continued)

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
ARO ALL			
A	9	C25116	LATERAL GUIDES
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT
B	1	C25111	PDU 1L ,13L
B	2	C25112	PDU 2L, 8L, 12L
B	3	C25113	PDU 3L, 9L, 14L
B	4	C25114	PDU 4L, 10L, 12C
B	5	C25115	PDU 5L, 11L, 16L
C	1	C25121	PDU 1R, 13R
C	2	C25122	PDU 2R, 8R, 12R
C	3	C25123	PDU 3R, 9R, 14R
C	4	C25124	PDU 4R, 10R, 14C
C	5	C25125	PDU 5R, 11R, 16R

Ground Service/Handling Power Panel, P320

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	9	C25613	CARGO HDLG CTRL FWD
C	10	C25614	CARGO HDLG CTRL AFT

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-00

Config 3
Page 561
Sep 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

POWER DRIVE UNIT - MAINTENANCE PRACTICES

1. General

- A. This procedure contains these tasks:
(1) Cleaning of the Power Drive Unit

TASK 25-53-01-160-801

2. Power Drive Unit - Cleaning

A. **Tools/Equipment**

Reference	Description
STD-133	Brush - Stiff Bristle, Non-metallic
STD-1280	Source - Air, Regulated, Dry Filtered, 0-30 PSIG

B. **Consumable Materials**

Reference	Description	Specification
B00722	Solvent - Stoddard	MIL-PRF-680 Type I or II (Supersedes P-D-680 Type I or II)
B50126	Solvent - Degreasing, General Purpose	MIL-PRF-680
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00834	Cloth - Lint-free Cotton	

C. **Location Zones**

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right
200	Upper Half of Fuselage

D. **Power Drive Unit Cleaning**

SUBTASK 25-53-01-160-001

- (1) To clean the PDU surface, do these steps:
(a) Remove any unwanted materials with a lint-free cloth, G00834.



WARNING

USE THE CLEANING SOLVENT IN AN AREA WITH GOOD FLOW OF AIR.
PUT ON EQUIPMENT THAT KEEPS THIS MATERIAL OFF YOUR SKIN.
THIS MATERIAL CAN CAUSE INJURIES TO YOUR SKIN.

- (b) Apply the degreasing solvent, B50126 or solvent, B00722 to the dirty area.
(c) Carefully rub the area with a clean cotton wiper, G00034 to remove the unwanted material.
(d) Remove any deposits with a brush, STD-133 if it is necessary.

EFFECTIVITY
ARO ALL

25-53-01

D633W101-ARO

Page 201
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



BEFORE YOU USE COMPRESSED AIR, PUT ON GOGGLES FOR EYE PROTECTION. DO NOT POINT THE NOZZLE AT OTHER PERSONNEL. IF YOU DO NOT OBEY THESE PRECAUTIONS, INJURIES TO PERSONNEL CAN OCCUR.

- (e) Dry the surface with a clean lint-free cloth, G00834, or use 0-30 psig dry filtered regulated air source, STD-1280.
- 1) Make sure the air pressure is not more than 30 psi (207 kPa) when you dry parts.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-01

Page 202
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

POWERED DRIVE UNIT - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the powered drive unit (PDU).
 - (2) An installation of the PDU.
 - (3) A PDU installation test.
 - (4) Replacement of the PDU rollers.
- B. The PDUs are installed along the forward and the aft cargo compartments. This procedure is applicable for each PDU.

TASK 25-53-01-000-801

2. Powered Drive Unit - Removal

NOTE: Figure 401

A. **References**

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
33-37-00 P/B 201	INTERIOR CARGO LIGHTS - MAINTENANCE PRACTICES
52-34-00 P/B 201	FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES
52-35-00 P/B 201	AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES

B. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205
STD-13539	Barrier - Safety, Small Cargo Door

C. **Location Zones**

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

D. **Prepare for the Removal**

SUBTASK 25-53-01-861-001

- (1) Do this task if it is necessary: Supply Electrical Power, TASK 24-22-00-860-805

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-01

Page 401
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-01-860-013

- (2) Open the forward cargo door if it is necessary. Do the applicable task in this procedure: FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-34-00/201.

SUBTASK 25-53-01-860-015

- (3) Open the aft cargo door if it is necessary. Do the applicable task in this procedure: AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-35-00/201.

SUBTASK 25-53-01-410-006



WARNING

INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (4) Install the applicable safety barrier across the cargo door opening:
- (a) large cargo door safety barrier, SPL-1988
 - (b) cargo door safety barrier, STD-13539
 - (c) safety barrier, SPL-2006

SUBTASK 25-53-01-860-016

- (5) Turn on the cargo compartment lights if it is necessary. Do the applicable task in this procedure: INTERIOR CARGO LIGHTS - MAINTENANCE PRACTICES, PAGEBLOCK 33-37-00/201.

SUBTASK 25-53-01-860-019

NOTE: FOR THE FORWARD CARGO COMPARTMENT

- (6) Open these circuit breakers and install safety tags:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C25028	CSC DC-LEFT
A	11	C25029	CSC DC-RIGHT
B	1	C25011	PDU 1L, 5L, 12L
B	2	C25012	PDU 2L, 7L, 13L
B	3	C25013	PDU 3L, 11L
B	4	C25014	PDU 4C, 8L, 16L
B	5	C25015	PDU 4L, 9L, 17L
B	6	C25016	PDU 6L, 10L, 18L
C	1	C25021	PDU 1R, 5R, 12R
C	2	C25022	PDU 2R, 7R, 13R
C	3	C25023	PDU 3R, 11R
C	4	C25024	PDU 6C, 8R, 16R
C	5	C25025	PDU 4R, 9R, 17R
C	6	C25026	PDU 6R, 10R, 18R
D	1	C25018	PDU 14L, 20L
D	2	C25019	PDU 15L, 21L
D	3	C25020	PDU 19L
E	1	C25030	PDU 14R, 20R
E	2	C25031	PDU 15R, 21R
E	3	C25032	PDU 19R

EFFECTIVITY
ARO ALL

25-53-01

D633W101-ARO

Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-01-860-021

NOTE: FOR THE AFT CARGO COMPARTMENT

(7) Open these circuit breakers and install safety tags:

Cargo Handling Accessory Panel - Aft, P39

Row	Col	Number	Name
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT
B	1	C25111	PDU 1L, 13L
B	2	C25112	PDU 2L, 8L, 12L
B	3	C25113	PDU 3L, 9L, 14L
B	4	C25114	PDU 4L, 10L, 12C
B	5	C25115	PDU 5L, 11L, 16L
B	6	C25117	PDU 6L, 17L
C	1	C25121	PDU 1R, 13R
C	2	C25122	PDU 2R, 8R, 12R
C	3	C25123	PDU 3R, 9R, 14R
C	4	C25124	PDU 4R, 10R, 14C
C	5	C25125	PDU 5R, 11R, 16R
C	6	C25119	PDU 6R, 17R
D	1	C25118	PDU 7L, 15L,
E	1	C25200	PDU 7R, 15R

E. Powered Drive Unit Removal

SUBTASK 25-53-01-930-001

(1) Make a note of the electrical cable routing (including clamp locations, and if an elastic bungee is used) to make sure it gets routed the same during the installation.

SUBTASK 25-53-01-930-002

(2) Make a note of the direction of the rollers before you remove the PDU.

SUBTASK 25-53-01-020-001

(3) Lift the PDU roller and disconnect the electrical connector [5].

SUBTASK 25-53-01-020-004

(4) Disconnect the grounding strap that is attached to the PDU and the airplane floor structure.

SUBTASK 25-53-01-020-002

(5) Remove the bolts [2] and washers [3] that attach the PDU to the floor structure [4].

SUBTASK 25-53-01-020-003

(6) Carefully remove the PDU.

————— END OF TASK —————

TASK 25-53-01-400-801

3. Powered Drive Unit - Installation

NOTE: Figure 401

A. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
24-22-00-860-806	Remove Electrical Power (P/B 201)

EFFECTIVITY
ARO ALL

25-53-01

D633W101-ARO

Page 403
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Title
33-37-00 P/B 201	INTERIOR CARGO LIGHTS - MAINTENANCE PRACTICES
52-34-00 P/B 201	FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES
52-35-00 P/B 201	AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-1550	Bonding Meters - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: T477W Supplier: 01014 Opt Part #: M1B Supplier: 3AD17
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205
STD-13539	Barrier - Safety, Small Cargo Door

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
G50268	Material - Synthetic Rubber, High Performance Silicone	BMS1-52

D. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

E. Powered Drive Unit Installation

SUBTASK 25-53-01-110-001

- (1) Clean the mating surfaces on the floor and the bottom of the PDU around the nutplate area.

SUBTASK 25-53-01-390-001

- (2) Apply sealant, A00247 to the bottom of the PDU around the nutplate area.

SUBTASK 25-53-01-390-002

- (3) Apply sealant, A00247 to the bolts [2] and the two sides of the washer [3].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-01

Page 404
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-01-820-001

- (4) Put the PDU in the correct position.

SUBTASK 25-53-01-420-002

- (5) Lift the roller end of the PDU body and install the bolts [2] and washers [3].

SUBTASK 25-53-01-420-003

- (6) Connect the grounding strap.

SUBTASK 25-53-01-420-001

- (7) Connect the electrical connector [5].

NOTE: For PDUs on a shear web, the electrical connection is through the access hole in the shear web.

SUBTASK 25-53-01-210-001



MAKE SURE THE ELECTRICAL CABLE IS OUT OF THE WAY WHEN YOU PUT THE PDU BODY DOWN. IF THE CABLE IS BETWEEN THE BASE AND THE BODY WHEN YOU PUT THE PDU DOWN, DAMAGE TO THE CABLE CAN OCCUR.

- (8) Put the PDU roller down.

- (a) Do these steps to make sure that the PDU electrical cable is routed and clamped correctly.

NOTE: The PDU electrical cable must be routed and clamped correctly to prevent pinching and chafing of the electrical cable

- 1) Make sure the electrical cable is not between the PDU body and the base.
 - 2) Use a tie-wrap to hold the PDU cable bundle to the support rod that spans between the base legs of the PDU.
 - 3) Use tie-wraps at locations where the wire bundle may contact the electrical disconnect support bracket.
 - 4) Make sure that the electrical cable has a minimum bend radius of 0.50 in. (12.70 mm) in all locations.

- 5) Do these steps to attach a bungie to the electrical cable:

NOTE: A bungie-rubber can be installed on the electrical cable to prevent pinching of the cable. The bungie cord installation is optional.

- a) Get synthetic rubber silicone, G50268.
 - b) Tie a knot in both ends of the bungie-rubber.
 - c) Attach one end of the bungie cord to the electrical cable behind the electrical connector [5] backshell with a tie-wrap.
 - d) Pull the bungie-rubber taught in a straight line.
 - e) Attach the other end of the bungie-rubber to the electrical cable with a tie-wrap.

- (b) Do a resistance check between the PDU and the nearest floor beam or shear web with a intrinsically safe approved bonding meter, COM-1550.

- 1) Make sure the resistance is a maximum of 0.008 ohms.

SUBTASK 25-53-01-860-024

NOTE: FOR THE FORWARD CARGO COMPARTMENT

EFFECTIVITY
ARO ALL

25-53-01

D633W101-ARO

Page 405
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (9) Remove the safety tags and close these circuit breakers:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	1	C25011	PDU 1L, 5L, 12L
B	2	C25012	PDU 2L, 7L, 13L
B	3	C25013	PDU 3L, 11L
B	4	C25014	PDU 4C, 8L, 16L
B	5	C25015	PDU 4L, 9L, 17L
B	6	C25016	PDU 6L, 10L, 18L
C	1	C25021	PDU 1R, 5R, 12R
C	2	C25022	PDU 2R, 7R, 13R
C	3	C25023	PDU 3R, 11R
C	4	C25024	PDU 6C, 8R, 16R
C	5	C25025	PDU 4R, 9R, 17R
C	6	C25026	PDU 6R, 10R, 18R
D	1	C25018	PDU 14L, 20L
D	2	C25019	PDU 15L, 21L
D	3	C25020	PDU 19L
E	1	C25030	PDU 14R, 20R
E	2	C25031	PDU 15R, 21R
E	3	C25032	PDU 19R

SUBTASK 25-53-01-860-026

NOTE: FOR THE AFT CARGO COMPARTMENT

- (10) Remove the safety tags and close these circuit breakers:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	1	C25111	PDU 1L, 13L
B	2	C25112	PDU 2L, 8L, 12L
B	3	C25113	PDU 3L, 9L, 14L
B	4	C25114	PDU 4L, 10L, 12C
B	5	C25115	PDU 5L, 11L, 16L
B	6	C25117	PDU 6L, 17L
C	1	C25121	PDU 1R, 13R
C	2	C25122	PDU 2R, 8R, 12R
C	3	C25123	PDU 3R, 9R, 14R
C	4	C25124	PDU 4R, 10R, 14C
C	5	C25125	PDU 5R, 11R, 16R
C	6	C25119	PDU 6R, 17R
D	1	C25118	PDU 7L, 15L,
E	1	C25200	PDU 7R, 15R

F. Powered Drive Unit Installation Test

SUBTASK 25-53-01-860-003

NOTE: FOR THE FORWARD CARGO COMPARTMENT

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-01

Page 406
May 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (1) Remove the safety tags and close these circuit breakers:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C25028	CSC DC-LEFT
A	11	C25029	CSC DC-RIGHT

SUBTASK 25-53-01-860-005

NOTE: FOR THE AFT CARGO COMPARTMENT

- (2) Remove the safety tags and close these circuit breakers:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT

SUBTASK 25-53-01-860-007

- (3) Make sure the switches on the cargo system control panel are in the positions that follow:

NOTE: The PALLETS/CONTAINERS switch is applicable to the compartments with the large cargo door.

Table 401/25-53-01-993-801

Switch	Position
SYSTEM POWER	OFF
LOCK/LOAD/UNLOAD (If Applicable)	LOCK
PDU LEFT/BOTH/RIGHT	BOTH
PDU FWD/AFT	AFT
PALLETS/CONTAINERS (If Applicable)	PALLETS

SUBTASK 25-53-01-860-008

- (4) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-53-01-860-009

- (5) Set the SYSTEM POWER switch to ON.

SUBTASK 25-53-01-710-001


WARNING

DO NOT TOUCH THE POWER DRIVE UNIT WHEN POWER IS ON. THE ROLLERS CAN MOVE SUDDENLY. INJURIES TO PERSONNEL AND DAMAGE TO THE EQUIPMENT CAN OCCUR.

- (6) Do the test that follows if the PDU is longitudinal and outside of the ball panels:
- (a) Make sure that the PDUs in this test have a cover on the sensor.
 - (b) Hold the joystick to FWD.
 - 1) Make sure the PDU operates in the forward direction.
 - (c) Release the joystick.
 - 1) Make sure the PDU is above the conveyor plane and remains without movement.
NOTE: The conveyor plane is the top of the rollers in the roller trays.
 - (d) Hold the joystick to AFT.

EFFECTIVITY
ARO ALL

25-53-01

D633W101-ARO

Page 407
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 1) Make sure the PDU operates in the aft direction.
- (e) Release the joystick.
 - 1) Make sure the PDU is above the conveyor plane and remains without movement.

SUBTASK 25-53-01-710-002



DO NOT TOUCH THE POWER DRIVE UNIT WHEN POWER IS ON. THE ROLLERS CAN MOVE SUDDENLY. INJURIES TO PERSONNEL AND DAMAGE TO THE EQUIPMENT CAN OCCUR.

- (7) Do the test that follows if the PDU is longitudinal and is in the ball panel area:
 - (a) Make sure that the PDUs in this test have a cover on the sensor.
 - (b) Hold the joystick to FWD.
 - 1) Make sure the PDU operates in the forward direction.
 - (c) Release the joystick.
 - 1) Make sure the PDU is above the conveyor plane and remains without movement.

NOTE: The conveyor plane is the top of the balls in the ball panels.
 - (d) Hold the joystick to AFT.
 - 1) Make sure the PDU operates in the aft direction.
 - (e) Release the joystick.
 - 1) Make sure the PDU is above the conveyor plane and remains without movement.
 - (f) Hold the joystick to OUT.
 - 1) Make sure the PDU lowers.

SUBTASK 25-53-01-710-003



DO NOT TOUCH THE POWER DRIVE UNIT WHEN POWER IS ON. THE ROLLERS CAN MOVE SUDDENLY. INJURIES TO PERSONNEL AND DAMAGE TO THE EQUIPMENT CAN OCCUR.

- (8) Do the test that follows if the PDU is a transverse PDU:

NOTE: A transverse PDU is installed laterally in the ball panel area.

 - (a) Make sure that the PDUs in this test have a cover on the sensor.
 - (b) Hold the joystick to OUT.
 - 1) Make sure the PDU operates out.
 - (c) Release the joystick.
 - 1) Make sure the PDU is above the conveyor plane and remains without movement.

NOTE: The conveyor plane is the top of the balls in the ball panels.
 - (d) Hold the joystick to IN.
 - 1) Make sure the PDU operates in.
 - (e) Release the joystick.
 - 1) Make sure the PDU is above the conveyor plane and remains without movement.
 - (f) Hold the joystick to FWD.
 - 1) Make sure the PDU lowers.

EFFECTIVITY
ARO ALL

25-53-01

D633W101-ARO

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Page 408
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-01-860-010

- (9) Set the SYSTEM POWER switch to OFF.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-01-080-001

- (1) Remove the large cargo door safety barrier, SPL-1988 the safety barrier, SPL-2006 or the cargo door safety barrier, STD-13539 from the cargo door opening.

SUBTASK 25-53-01-862-001

- (2) Turn off the cargo compartment lights if it is necessary. Do the applicable task in this procedure: INTERIOR CARGO LIGHTS - MAINTENANCE PRACTICES, PAGEBLOCK 33-37-00/201.

SUBTASK 25-53-01-410-002

- (3) Close the forward cargo door if it is necessary. Do the applicable task in this procedure: FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-34-00/201

SUBTASK 25-53-01-410-004

- (4) Close the aft cargo door if it is necessary. Do the applicable task in this procedure: AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-35-00/201

SUBTASK 25-53-01-860-017

- (5) Remove electrical power if it is not required. Do this task: Remove Electrical Power, TASK 24-22-00-860-806

————— **END OF TASK** —————

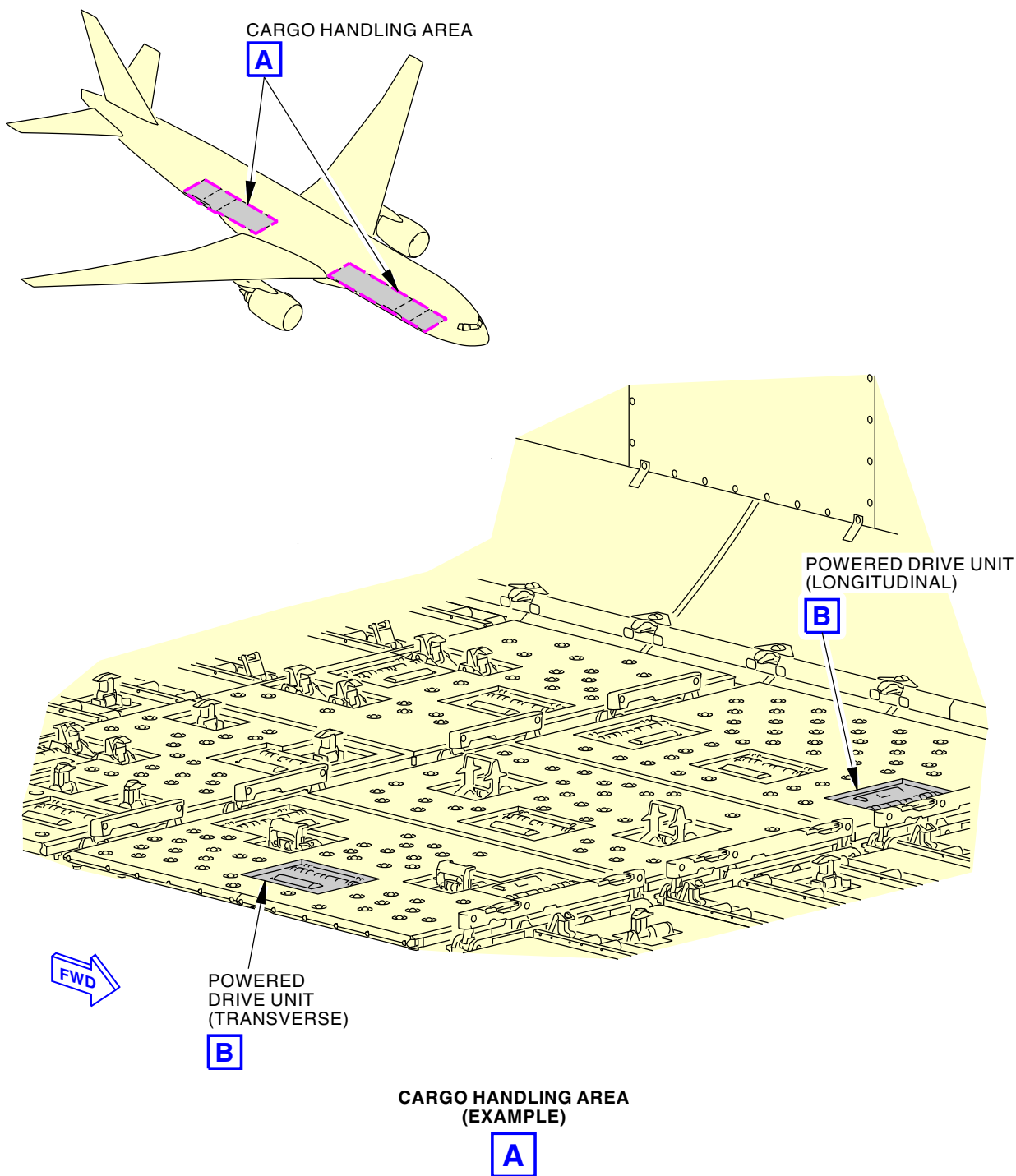
EFFECTIVITY
ARO ALL

25-53-01

D633W101-ARO

Page 409
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Powered Drive Unit Installation
Figure 401/25-53-01-990-804 (Sheet 1 of 3)**

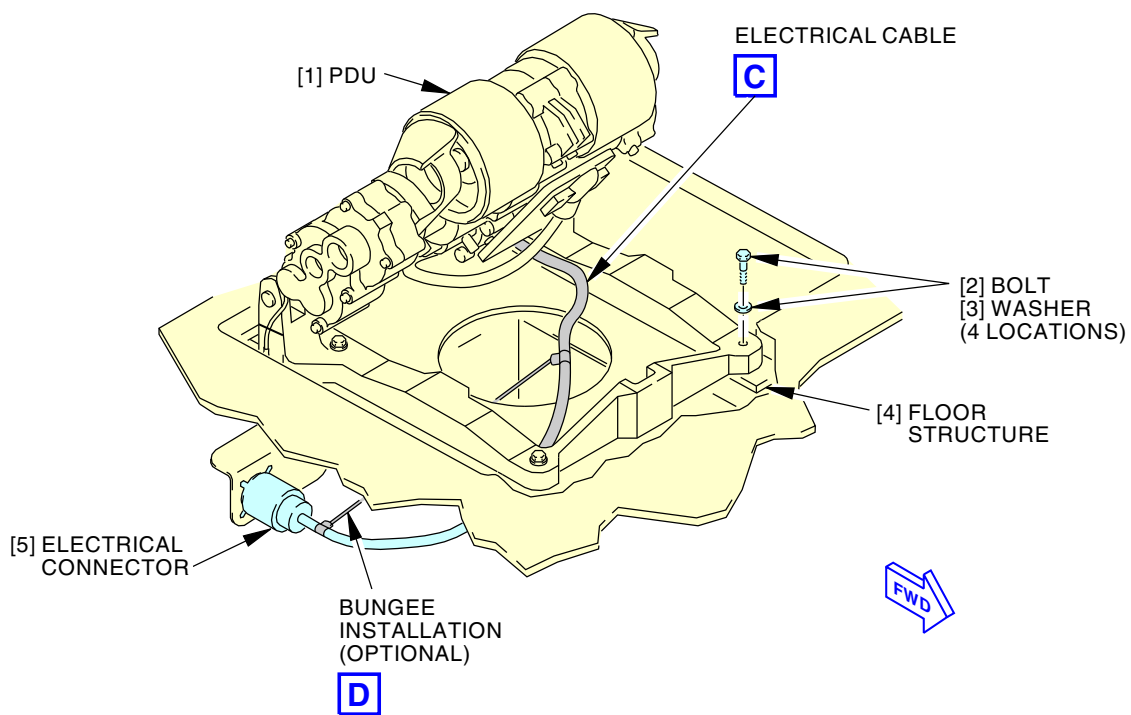
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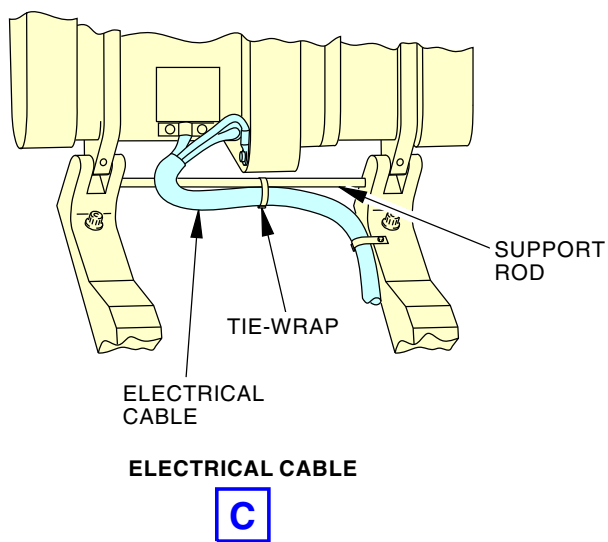
D633W101-ARO

Page 410
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



POWERED DRIVE UNIT



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Powered Drive Unit Installation
Figure 401/25-53-01-990-804 (Sheet 2 of 3)

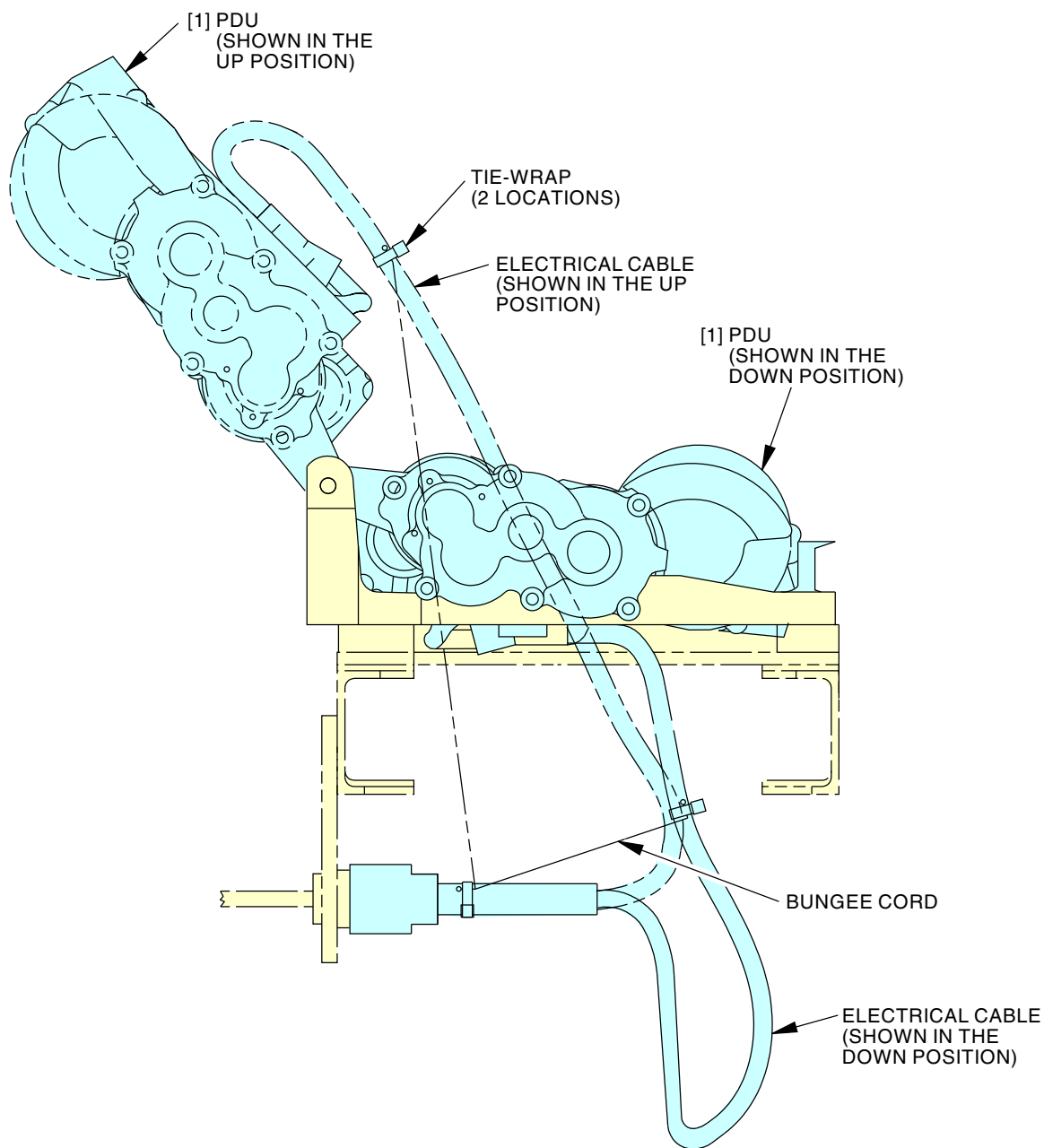
EFFECTIVITY
ARO ALL

25-53-01

D633W101-ARO

Page 411
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



**BUNGEE INSTALLATION
(OPTIONAL)**

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Powered Drive Unit Installation
Figure 401/25-53-01-990-804 (Sheet 3 of 3)

EFFECTIVITY
ARO ALL

25-53-01

D633W101-ARO

Page 412
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-53-01-000-802

4. PDU Roller Replacement

(Figure 402)

A. General

- (1) The PDU can be run without changing the roller as long as the roller surface is completely covered by rubber, and there is no significant wear or missing rubber. You must replace the PDU roller if the diameter is worn to less than 2.90 in. (7.37 cm), or the roller rubber width is less than 1.50 in. (3.81 cm) due to excessive wear, or missing rubber.

B. Consumable Materials

Reference	Description	Specification
A00648	Compound - Retaining - Loctite 242	ASTM D5363 Grp 3 Cl 2 Gd 1 (SUPERSEDES MIL-S-46163)
C00852	Compound - Antiseize, Molybdenum Disulfide-Petrolatum	MIL-PRF-83483
D00016	Grease - Aircraft, General Purpose, Wide Temperature Range	MIL-PRF-81322

C. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

D. Procedure

SUBTASK 25-53-01-010-001

- (1) To get access, lift the roller end of the PDU up.

NOTE: It is OK to swing the PDU up and over backwards.

SUBTASK 25-53-01-960-001

- (2) Do these steps to replace the rollers:

NOTE: These steps are for PDUs that have a two piece shaft.

- (a) Put a hex wrench in each end of the shaft [6].
- (b) Turn the hex wrenches to disconnect (unscrew) the two halves of the shaft [6].
- (c) Pull the two shaft halves [6] out and remove the rollers [10].

NOTE: If the O-rings on the shaft halves do not pull the hex shafts out enough to remove the wheels, use a screwdriver to move the hex shafts [8].

- (d) Clean the shafts [6] and hex shafts [8].
- (e) Make sure the retaining rings [9] in the ends of the hex shafts [8] are not loose or damaged.
- (f) If you have new O-rings [7], install them on the shaft halves [6].
- (g) Apply grease, D00016 at the O-rings on the inner ends of the shaft halves [6].
- (h) Put the hex shaft [8] in each new roller [10].
- (i) Put a drop of Loctite 242 compound, A00648 or equivalent on the threads of the support shaft half [6].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-01

Page 413
Sep 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (j) Put each roller [10] in its position, and install the shaft half [6].
NOTE: Turn the roller until the hex shaft engages the drive gear.
- (k) Use hex wrenches to tighten the shaft halves [6].

SUBTASK 25-53-01-960-004

- (3) To replace the roller, do the steps that follow:

NOTE: These steps are for PDUs that have a single shaft.

- (a) Remove the SEMS that attaches the roller and roller shaft to the PDU.
- (b) Remove the roller shaft from the left side of the PDU drive assembly.
- (c) Remove the roller.
- (d) Clean the roller shaft if it is necessary.
- (e) Put the new roller in its correct position on the PDU.
- (f) Apply compound, C00852 to the inner ends of the rollers.
- (g) Install the roller shaft through the left side of the PDU drive assembly.
- (h) Install the SEMS and tighten to 116 in-lb (13 N·m) to 129 in-lb (15 N·m).
- (i) Lower the PDU into the roller tray.
- (j) Push the PDU hold down pin and turn the pin 90 degrees clockwise.

SUBTASK 25-53-01-410-001



MAKE SURE THE ELECTRICAL CABLE IS OUT OF THE WAY WHEN YOU PUT THE PDU ROLLER DOWN. IF THE CABLE IS BETWEEN THE BASE AND THE ROLLER WHEN YOU PUT THE PDU DOWN, DAMAGE TO THE CABLE CAN OCCUR.

- (4) Move the PDU back down to its usual position.

SUBTASK 25-53-01-710-004

- (5) Do the Power Drive Unit Installation Test that is above. The test is part of this task: TASK 25-53-01-400-801.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

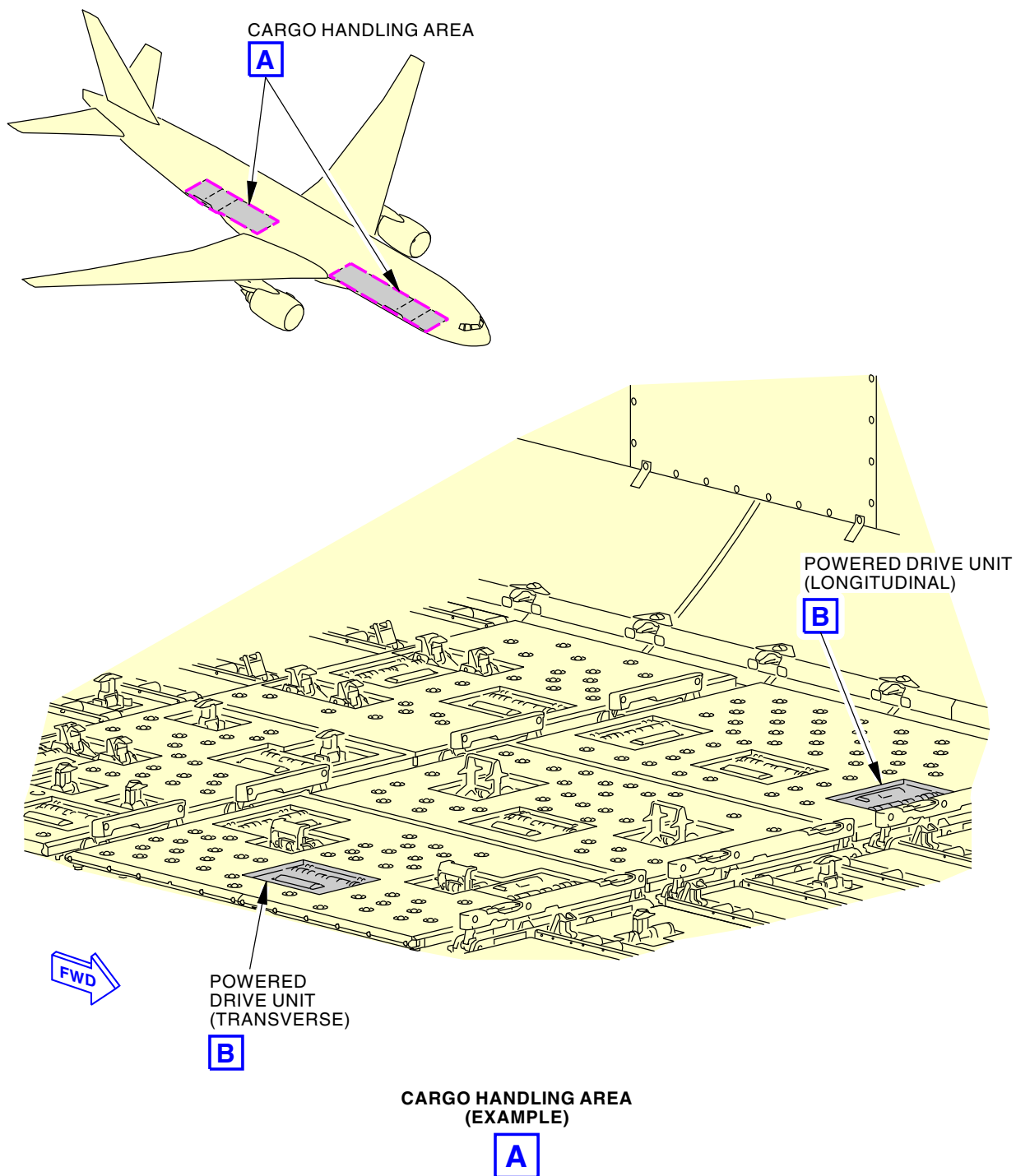
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25-53-01

Page 414
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Powered Drive Unit Roller Replacement
Figure 402/25-53-01-990-802 (Sheet 1 of 2)

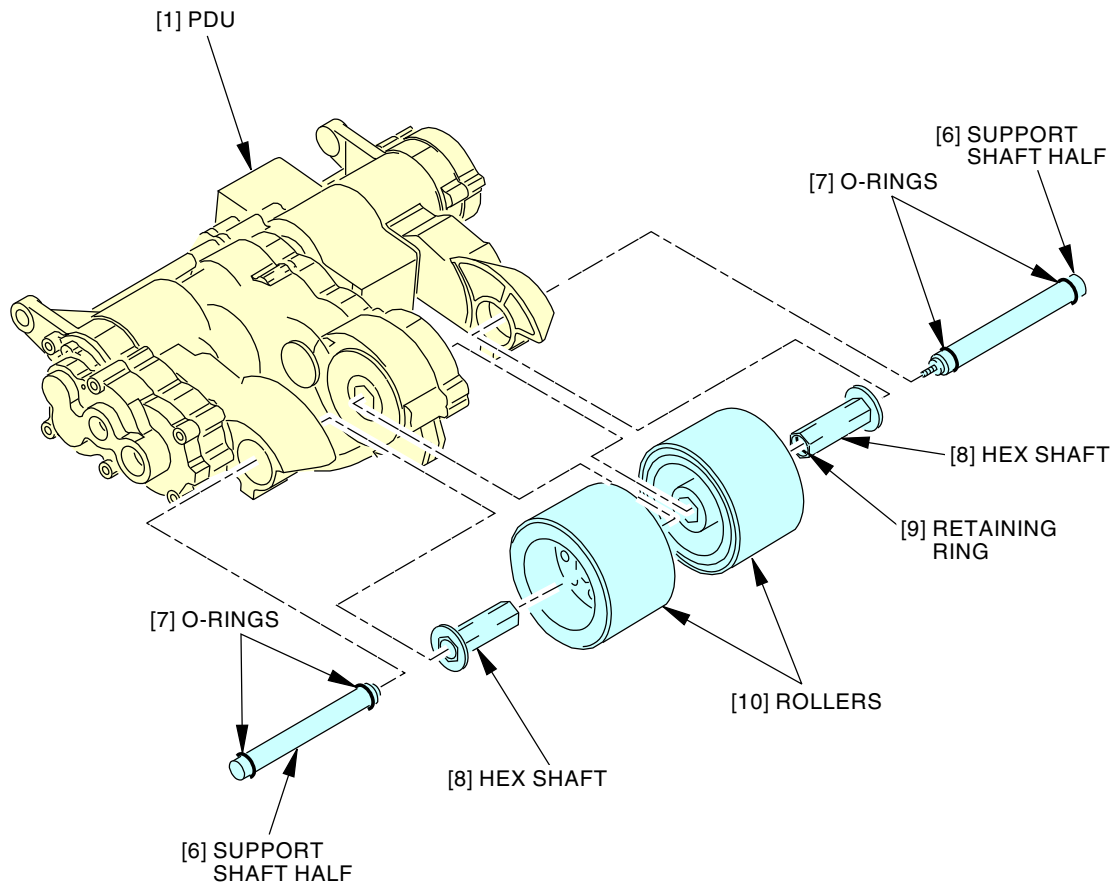
EFFECTIVITY
ARO ALL

25-53-01

D633W101-ARO

Page 415
May 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Powered Drive Unit Roller Replacement
Figure 402/25-53-01-990-802 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

25-53-01

D633W101-ARO

Page 416
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

BALL PANEL - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the ball panel.
 - (2) An installation of the ball panel.
 - (3) A removal of the ball transfer unit (BTU).
 - (4) An installation of the ball transfer unit (BTU).
- B. The ball panels are installed in the doorway area of the forward and aft cargo compartments. This procedure is applicable for each ball panel and BTU.

TASK 25-53-02-000-801

2. Ball Panel Removal

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Prepare for the Removal

SUBTASK 25-53-02-480-001



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 across the cargo door opening.

D. Ball Panel Removal

SUBTASK 25-53-02-020-001

- (1) Remove the bolts [2] and washers [3] that attach the ball panel [1] to the floor structure.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-02

Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-02-020-002

- (2) Remove the ball panel [1].

————— END OF TASK —————

TASK 25-53-02-400-801

3. Ball Panel Installation

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Ball Panel Installation

SUBTASK 25-53-02-820-001

- (1) Put the ball panel [1] in the correct location for the installation.

SUBTASK 25-53-02-420-001

- (2) Install the bolts [2] and washers [3] that attach the ball panel [1] to the floor structure.

SUBTASK 25-53-02-210-001

- (3) Make sure the cargo handling components do not touch the ball panel [1] during operation.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-02-080-001

- (1) Remove the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 from the cargo door opening.

————— END OF TASK —————

TASK 25-53-02-000-802

4. Ball Transfer Unit Removal

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

EFFECTIVITY
ARO ALL

25-53-02

D633W101-ARO

Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Prepare for the Removal

SUBTASK 25-53-02-480-002



WARNING

INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 across the cargo door opening.

D. Ball Transfer Unit Removal

SUBTASK 25-53-02-820-002

- (1) Put two small cylindrical rods in the holes on the top of the BTU [4].

SUBTASK 25-53-02-020-003

- (2) Push the two small cylindrical rods in the direction of the ball to disengage the latches [7].

SUBTASK 25-53-02-020-004

- (3) Lift the BTU [4] out of the insert cup [5].

————— END OF TASK —————

TASK 25-53-02-400-802

5. Ball Transfer Unit Installation

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

EFFECTIVITY
ARO ALL

25-53-02

D633W101-ARO

Page 403
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Ball Transfer Unit Installation

SUBTASK 25-53-02-820-003

- (1) Align the lugs [6] on the bottom of the BTU [4] with the slots in the bottom of the insert cup [5].

SUBTASK 25-53-02-420-002

- (2) Lightly push the BTU [4] down in the insert cup [5].

SUBTASK 25-53-02-280-001

- (3) Do a visual check to make sure the latches [7] engage below the top of the ball panel [1].

NOTE: You can also hear the latches [7] engage.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-02-080-002

- (1) Remove the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 across the cargo door opening.

————— END OF TASK —————

EFFECTIVITY
ARO ALL

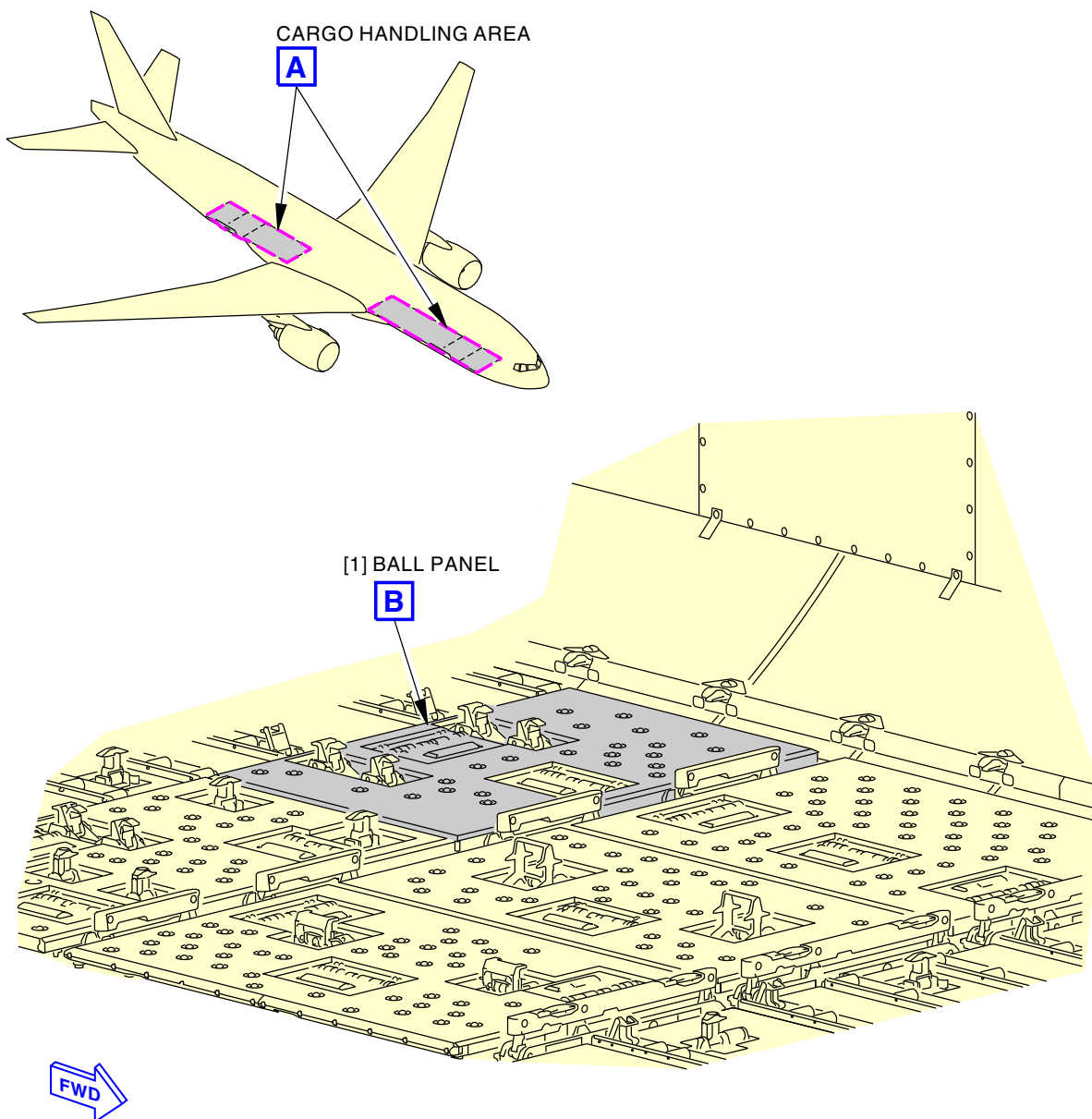
D633W101-ARO

25-53-02

Page 404
Sep 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL



**BALL PANELS
(LARGE CARGO DOOR AREA SHOWN)
(EXAMPLE)**

A

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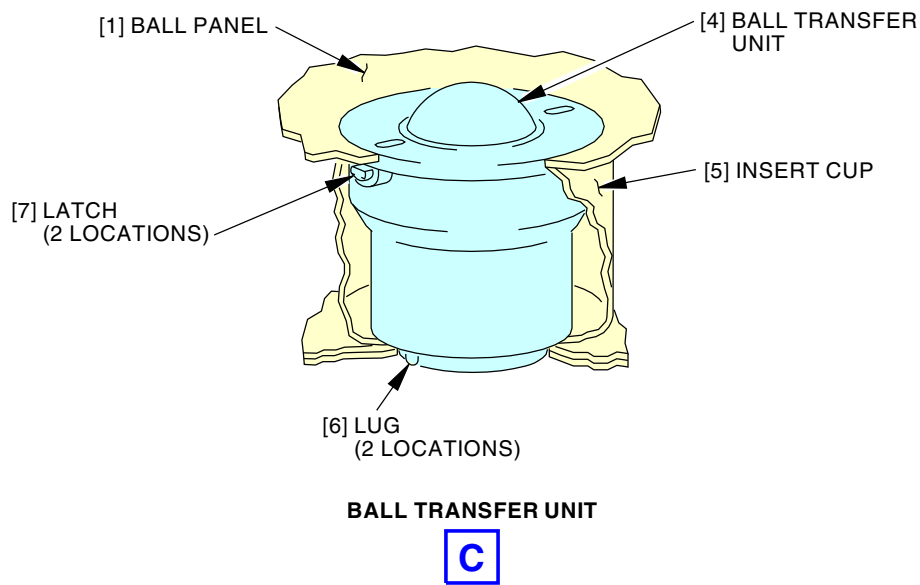
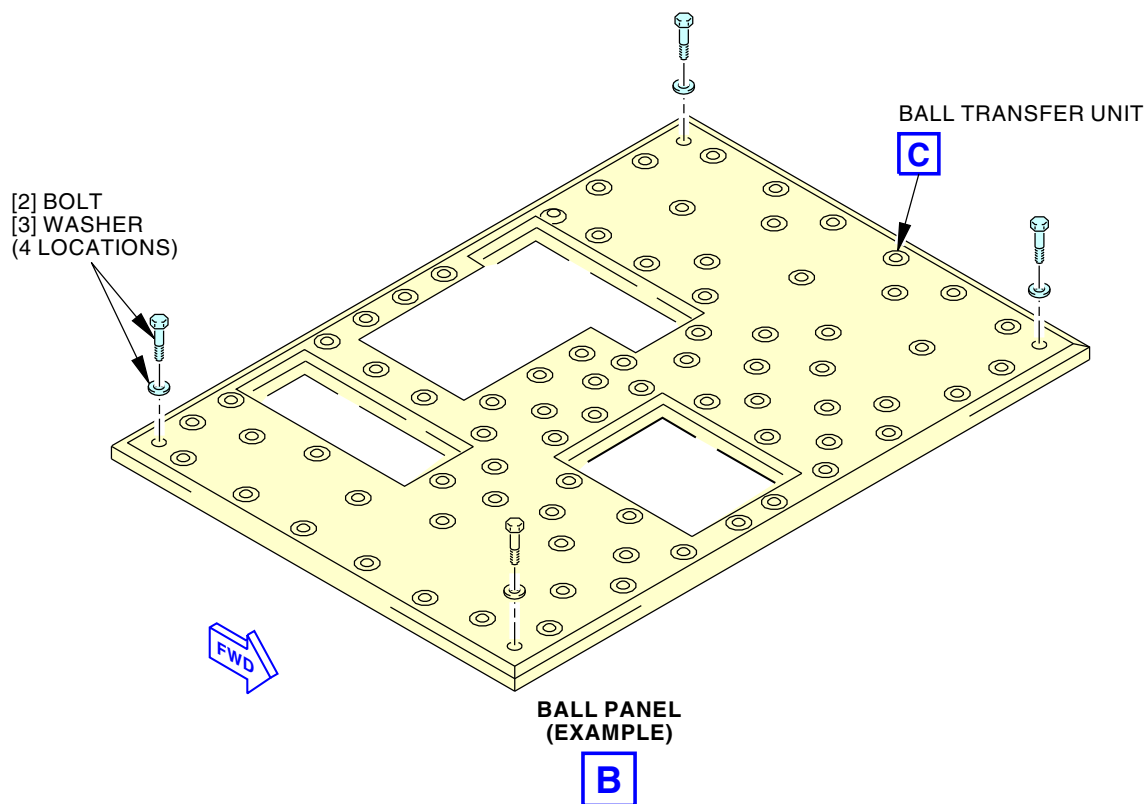
**Ball Panel Installation
Figure 401/25-53-02-990-801 (Sheet 1 of 2)**

EFFECTIVITY
ARO ALL

25-53-02

D633W101-ARO

Page 405
May 05/2017



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**Ball Panel Installation
Figure 401/25-53-02-990-801 (Sheet 2 of 2)**

EFFECTIVITY
ARO ALL

25-53-02

D633W101-ARO

Page 406
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
ROLLER TRAY - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Removal of the roller tray.
 - (2) Installation of the roller tray.
- B. The roller trays are installed along the forward and aft cargo compartments. This procedure is applicable to all of the roller trays.

TASK 25-53-03-000-801

2. Roller Tray - Removal

(Figure 401)

A. References

Reference	Title
52-34-00 P/B 201	FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES
52-35-00 P/B 201	AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

C. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

D. Prepare for the Removal

SUBTASK 25-53-03-010-002

- (1) Open the applicable cargo door if it is necessary. To open the cargo door do the applicable task in these procedures:
- (a) FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-34-00/201
 - (b) AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-35-00/201

EFFECTIVITY
ARO ALL

25-53-03

D633W101-ARO

Page 401
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-03-480-002



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (2) Install the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 across the cargo door opening.

SUBTASK 25-53-03-210-001

- (3) Find the areas where the roller trays [3] are attached with nuts [10].

NOTE: Look for the markers [12] that say: TO ACCESS NUTS UNDER ROLLER TRAYS, REMOVE FLOOR PANELS AS REQUIRED. The markers show that the roller trays are attached with nuts in that area.

E. Roller Tray Removal

SUBTASK 25-53-03-010-001

- (1) Do the applicable steps that follow to get access to the bolts [1], [4], washers [2] and nuts [10] (if applicable) that attach the roller tray [3] to the floor structure [6]:

- (a) Remove the rollers [5] that are on the top of the bolts [1], [4] and washers [2].

NOTE: The roller trays located at RBL and LBL 41.5 may have two different types of rollers. The two roller types are a standard transport roller and a braking roller.

- 1) Make a note of each rollers location for use during the installation of the rollers.
 - 2) Remove the bolt [9], washers [8], and nut [7] to disconnect the roller [5] from the roller tray [3].
 - (b) Remove the cargo handling components that are on top of the bolts [1], [4] and washers [2].
 - (c) Remove the adjacent floor panels [11] to access the nuts [10], if applicable.

SUBTASK 25-53-03-020-001

- (2) Remove the bolts [1], [4], washers [2] and nuts [10] (if applicable).

SUBTASK 25-53-03-020-002

- (3) Remove the roller tray [3].

————— END OF TASK —————

TASK 25-53-03-400-801

3. Roller Tray - Installation

(Figure 401)

A. References

Reference	Title
52-34-00 P/B 201	FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES
52-35-00 P/B 201	AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

EFFECTIVITY
ARO ALL

25-53-03

D633W101-ARO

Page 402
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A00723	Sealant - Corrosion Inhibitive, 2-Part - PR-1405-G	

D. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

E. Roller Tray Installation

SUBTASK 25-53-03-110-001

- (1) Clean the old PR-1405-G sealant, A00723 off of the floor structure [6] and the roller tray [3].

SUBTASK 25-53-03-390-001

- (2) Apply new PR-1405-G sealant, A00723 to the mating surfaces between the roller tray [3] and the floor structure [6].

SUBTASK 25-53-03-420-001



FOR NUTPLATES, TIGHTEN THE BOLTS SLOWLY AT THE START TO MAKE SURE THEY GO THROUGH THE NUTPLATE STRAIGHT. DAMAGE TO THE NUTPLATES CAN OCCUR IF THE BOLTS ARE NOT INSTALLED CORRECT.



FOR NUTS, TIGHTEN THE BOLTS FROM THE TOP LOCATION WHILE THE NUT IS HELD STATIONARY. DAMAGE TO THE STRUCTURE CAN OCCUR IF THE NUTS ARE NOT INSTALLED CORRECT.

- (3) Install the bolts [1], [4], washers [2] and nuts [10] (if applicable) that attach the roller tray [3] to the floor structure [6].

SUBTASK 25-53-03-410-001

- (4) Install the cargo handling components if necessary.

SUBTASK 25-53-03-410-002

- (5) Install the rollers [5] where applicable.

NOTE: The roller trays at RBL and LBL 41.5 may have two different types of rollers. The two roller types are a standard transport roller and a braking roller. Each type of roller is installed in a specific location.

EFFECTIVITY
ARO ALL

25-53-03

D633W101-ARO

Page 403
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Apply sealant, A00247 below the bolt [9] heads and washers [8].

NOTE: The sealant is optional.

- (b) Install the bolt [9], washers [8], and nut [7] to connect the rollers [5] to the roller tray [3] in the locations noted during the removal of the rollers.

- (c) Make sure the roller [5] turns freely.

NOTE: Rollers that are installed near pallet locks can interfere with the rollers. Rotate the pallet lock bolts to give a clearance between the rollers and the pallet lock bolts if it is necessary.

SUBTASK 25-53-03-410-003

- (6) Install the floor panels [11] if applicable.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-03-080-001

- (1) Remove the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 from the cargo door opening..

SUBTASK 25-53-03-410-004

- (2) Close the applicable cargo door. To close the cargo door do the applicable task in these procedures:
- (a) FORWARD LARGE CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-34-00/201
 - (b) AFT SMALL CARGO DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-35-00/201

————— **END OF TASK** —————

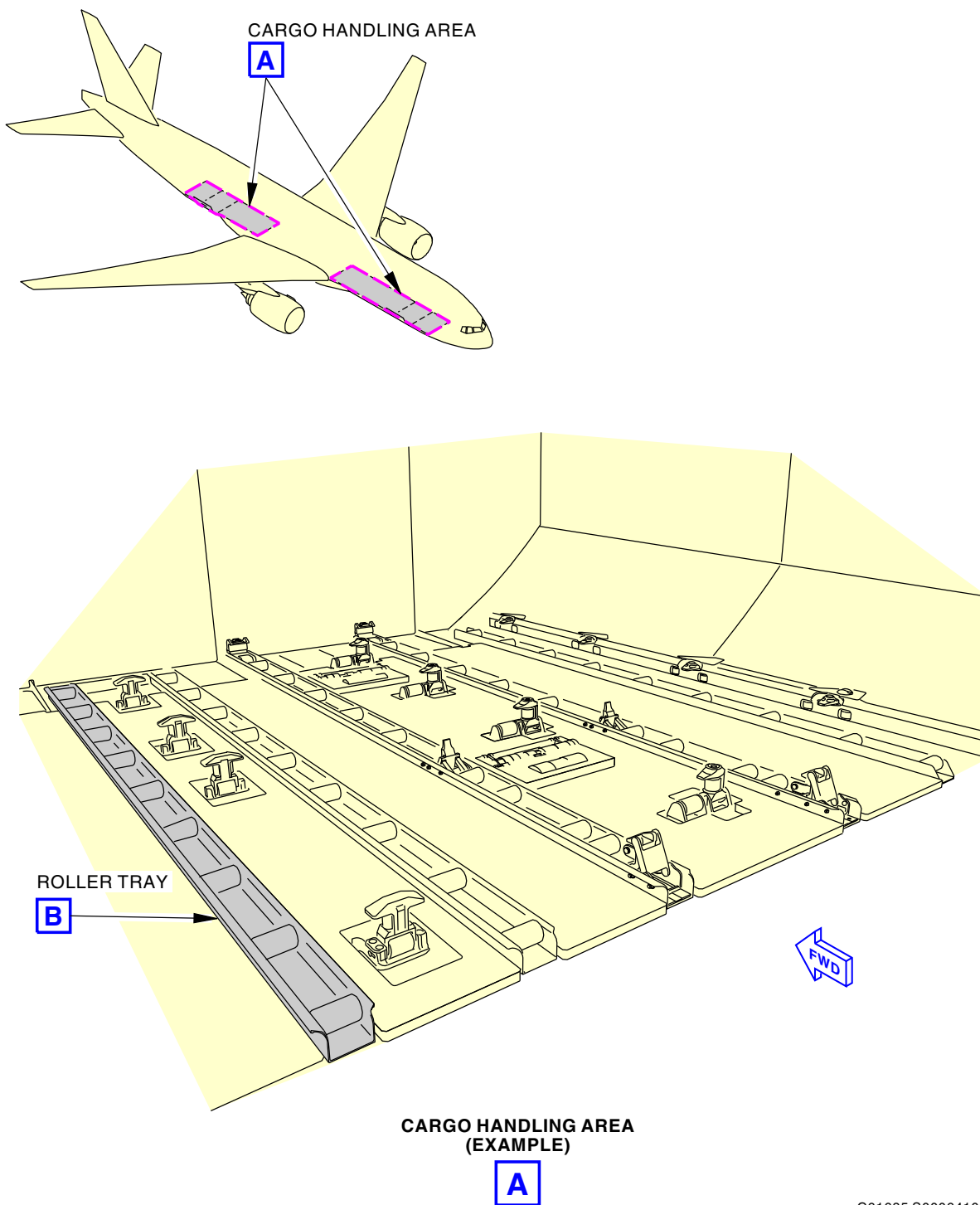
EFFECTIVITY
ARO ALL

25-53-03

D633W101-ARO

Page 404
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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Roller Tray Installation
Figure 401/25-53-03-990-801 (Sheet 1 of 2)

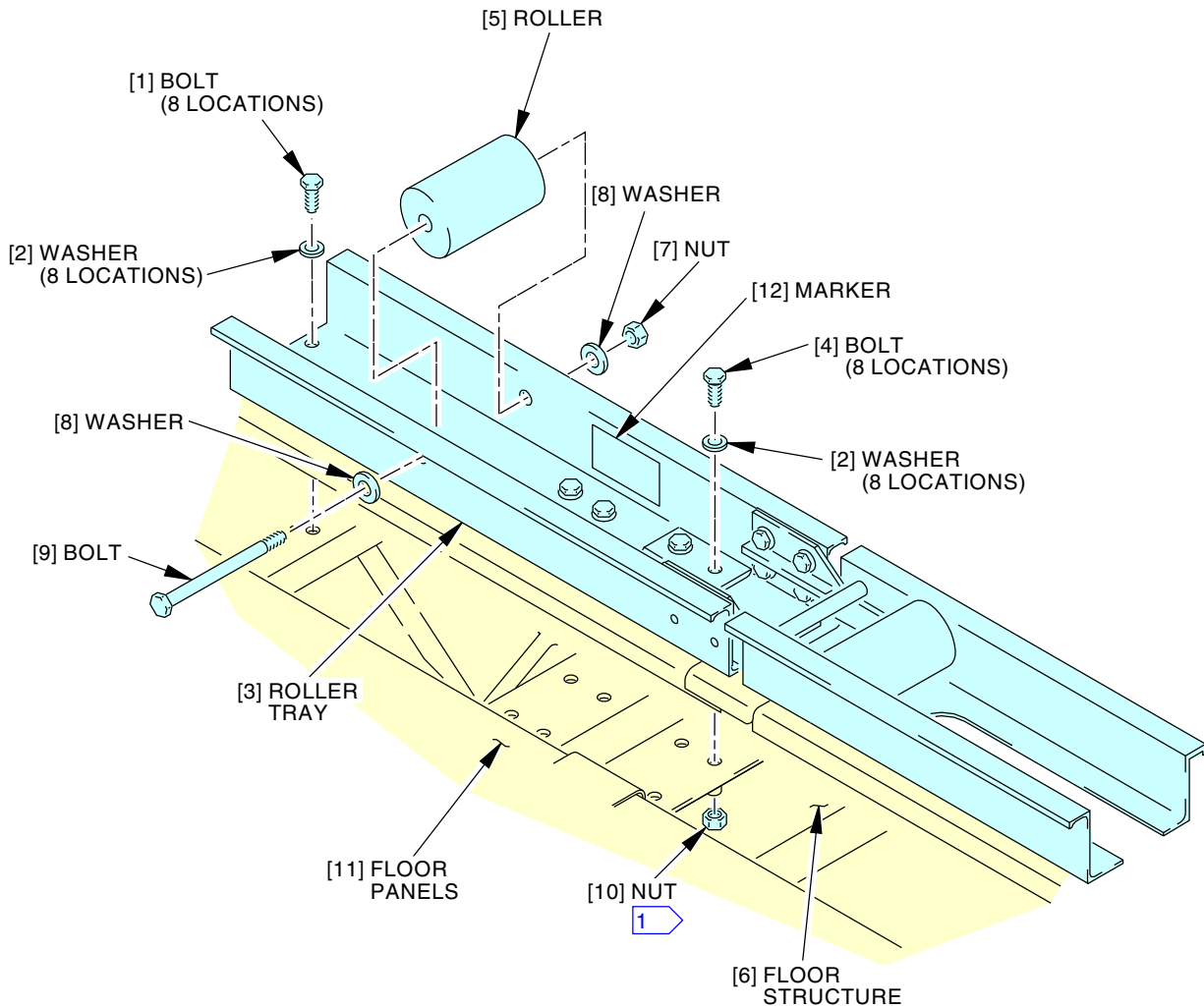
EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-03

Page 405
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**ROLLER TRAY
(EXAMPLE)**

B

1 WHERE APPLICABLE

C61705 S0006410994_V3

**Roller Tray Installation
Figure 401/25-53-03-990-801 (Sheet 2 of 2)**

**EFFECTIVITY
ARO ALL**

D633W101-ARO

25-53-03

Page 406
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

END STOP - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the end stop.
 - (2) An installation of the end stop.

TASK 25-53-04-000-801

2. End Stop Removal

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Prepare for the Removal

SUBTASK 25-53-04-480-001



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 across the cargo door opening.

D. End Stop Removal

SUBTASK 25-53-04-020-003

- (1) Remove the applicable bolts [2] [9], washers [3] [4] [10] [11], and nuts [5] [12], that attach the end stop [1] or [7] or [8] to the roller tray [6].

SUBTASK 25-53-04-020-004

- (2) Remove the end stop from the roller tray [6].

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

25-53-04

D633W101-ARO

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Page 401
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-53-04-400-801

3. End Stop Installation

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. End Stop Installation

SUBTASK 25-53-04-820-002

- (1) Put the end stop [1] or [7] or [8] in the roller tray [6].

SUBTASK 25-53-04-420-002

- (2) Install the applicable bolts [2] [9], washers [3] [4] [10] [11], and nuts [5] [12], that attach the end stop [1] or [7] or [8] to the roller tray [6].

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-04-080-001

- (1) Remove the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 from the cargo door opening.

———— **END OF TASK** ————

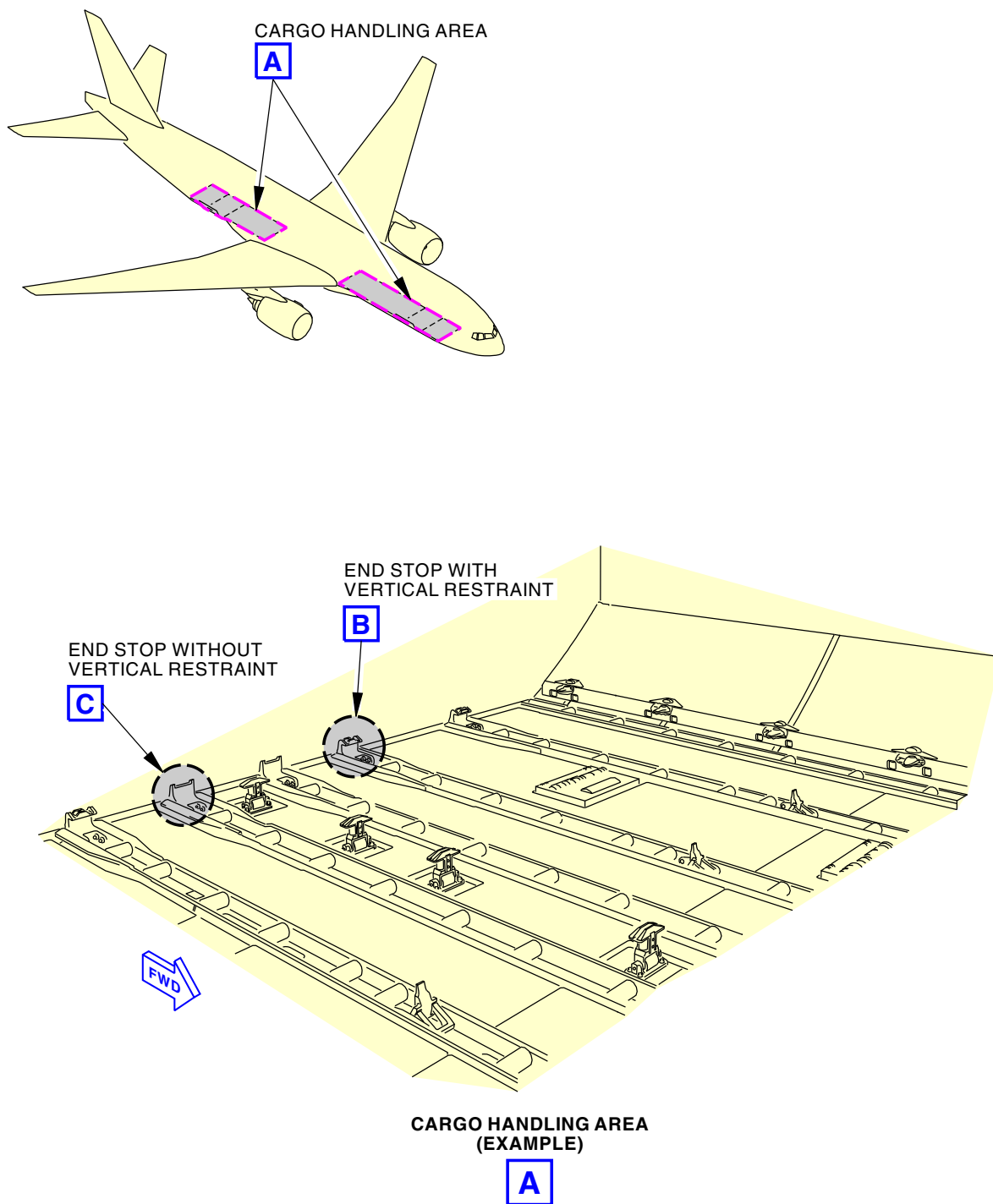
EFFECTIVITY
ARO ALL

25-53-04

D633W101-ARO

Page 402
Sep 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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End Stop Installation
Figure 401/25-53-04-990-801 (Sheet 1 of 3)

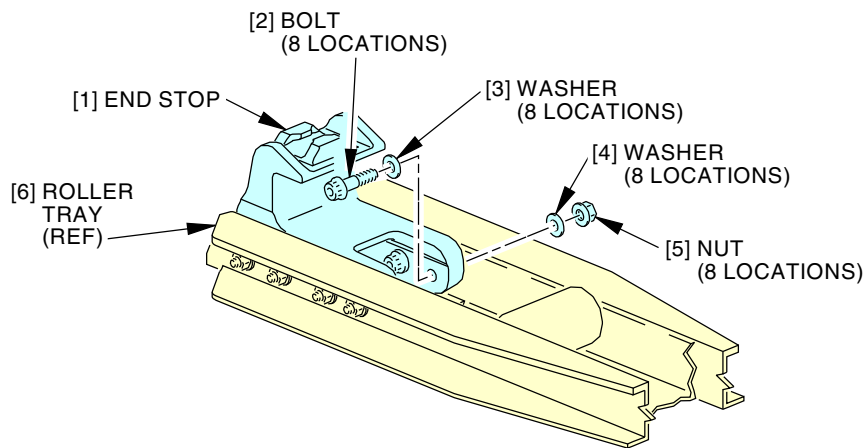
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25-53-04

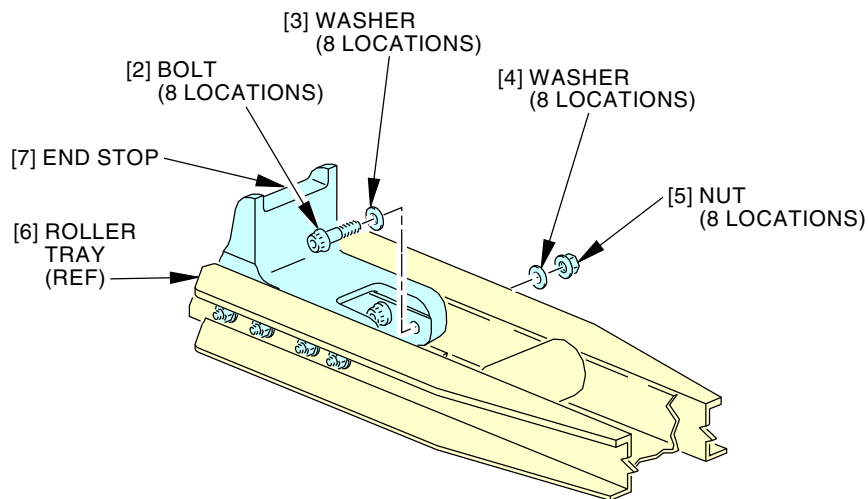
Page 403
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**END STOP
WITH VERTICAL RESTRAINT**

B



**END STOP
WITHOUT VERTICAL RESTRAINT
(EXAMPLE)**

C

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**End Stop Installation
Figure 401/25-53-04-990-801 (Sheet 2 of 3)**

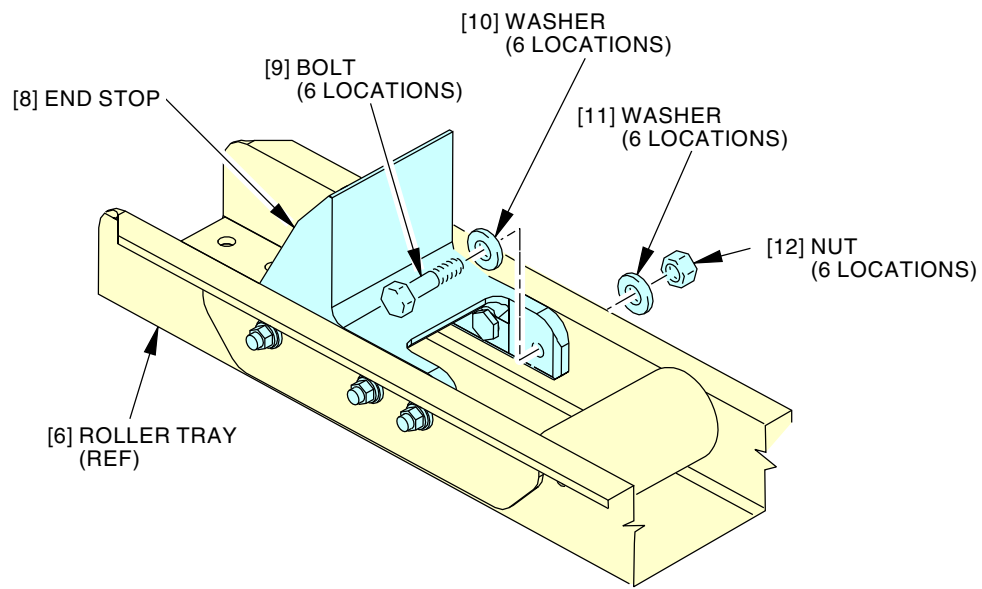
EFFECTIVITY
ARO ALL

25-53-04

D633W101-ARO

Page 404
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



**END STOP
 WITHOUT VERTICAL RESTRAINT
 (EXAMPLE)**

C

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End Stop Installation
Figure 401/25-53-04-990-801 (Sheet 3 of 3)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-04

Page 405
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

ROLLOUT STOP/LOCK - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the rollout stop/lock.
 - (2) An installation of the rollout stop/lock.
- B. This procedure is applicable for each rollout stop/lock.

TASK 25-53-11-000-805-003

2. Rollout Stop/Lock Removal

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

B. Location Zones

Zone	Area
122	Forward Cargo Compartment, Right
152	Aft Cargo Compartment, Right

C. Prepare for the Removal

SUBTASK 25-53-11-480-005-003



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 across the cargo door opening.

D. Rollout Stop/Lock Removal

SUBTASK 25-53-11-020-026-003

- (1) Remove the bolts [1] [4] and washers [2] [5] that attach the rollout stop/lock assy [3] to the door sill.

SUBTASK 25-53-11-020-027-003

- (2) Remove the rollout stop/lock assy [3].

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-11

Config 3
Page 401
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-53-11-400-805-003

3. Rollout Stop/Lock Installation

(Figure 401, Figure 402)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A00723	Sealant - Corrosion Inhibitive, 2-Part - PR-1405-G	
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
D50039	Lubricant - PTFE Release Agent - Miller-Stephenson MS-122RB (use until stock depleted)	
G02185	Agent - Peelable Parting (Valspar - 4A-183 Green Strippable Coating)Manufacturing discontinued, use stock until depleted	
G51444	Release Agent - Miller-Stephenson MS-122SEL	BMS15-21

C. Location Zones

Zone	Area
122	Forward Cargo Compartment, Right
152	Aft Cargo Compartment, Right

D. Rollout Stop/Lock Installation

(Figure 401)

SUBTASK 25-53-11-140-005-003

(1) Clean the old PR-1405-G sealant, A00723 off of the door sill structure.

SUBTASK 25-53-11-370-003-003

(2) Apply two coats of primer, C00259 to the bottom surface of the rollout stop/lock assy [3].

SUBTASK 25-53-11-390-016-003

(3) Apply MS-122RB lubricant, D50039, MS-122SEL release agent, G51444, or Valspar 4A-183 green strippable coating, G02185 to the bottom surface of the rollout stop/lock assy [3].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-11

Config 3
Page 402
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-11-390-010-003

- (4) Apply new PR-1405-G sealant, A00723 to the mating surfaces between the rollout stop/lock assy [3] and the door sill structure.

SUBTASK 25-53-11-820-005-003

- (5) To install the rollout stop/lock assy [3], align its holes with the ones on the door sill.

SUBTASK 25-53-11-390-011-003

- (6) Apply wet PR-1405-G sealant, A00723 to the bolts [1] [4].

SUBTASK 25-53-11-420-014-003



TIGHTEN THE BOLTS SLOWLY AT THE START TO MAKE SURE THEY GO THROUGH THE NUTPLATE STRAIGHT. DAMAGE TO THE NUTPLATES CAN OCCUR IF THE BOLTS ARE NOT INSTALLED STRAIGHT.

- (7) Install the bolts [1] [4] and washers [2] [5] that attach the rollout stop/lock assy [3] to the door sill.

SUBTASK 25-53-11-390-017-003

- (8) Apply a sealant, A00247 fillet seal around the rollout stop/lock assy [3].

E. Rollout Stop/Lock Installation Test

(Figure 402)

SUBTASK 25-53-11-980-017-003

- (1) Push down on the pedal [21] to manually retract the vertical restraint [23].

NOTE: This moves the rollout stop/lock assy [3] to the load position.

- (a) Make sure the vertical restraint [23] is below the conveyor plane.

NOTE: The conveyor plane is the top of the balls in the ball panels.

- (b) Make sure the lateral restraint [22] is in the vertical position.

SUBTASK 25-53-11-980-018-003

- (2) Push the lateral restraint [22] inboard, then rotate it downward to retract it.

NOTE: This moves the rollout stop/lock assy [3] to the unload position.

- (a) Make sure the lateral restraint [22] and the vertical restraint [23] are below the conveyor plane.

SUBTASK 25-53-11-980-019-003

- (3) Push down on the top of the lateral restraint [22] and turn down until it disengages.

NOTE: This moves the rollout stop/lock assy [3] to the container load position.

- (a) Make sure the lateral restraint [22] goes up to the vertical position.

- (b) Make sure the vertical restraint [23] remains below the conveyor plane.

SUBTASK 25-53-11-980-020-003

- (4) Pull up on the vertical restraint [23].

NOTE: This moves the rollout stop/lock assy [3] to the lock position.

- (a) Make sure the vertical restraint [23] fully engages in the vertical position.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-11

Config 3
Page 403
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-11-080-005-003

- (1) Remove the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 from the cargo door opening.

————— **END OF TASK** —————

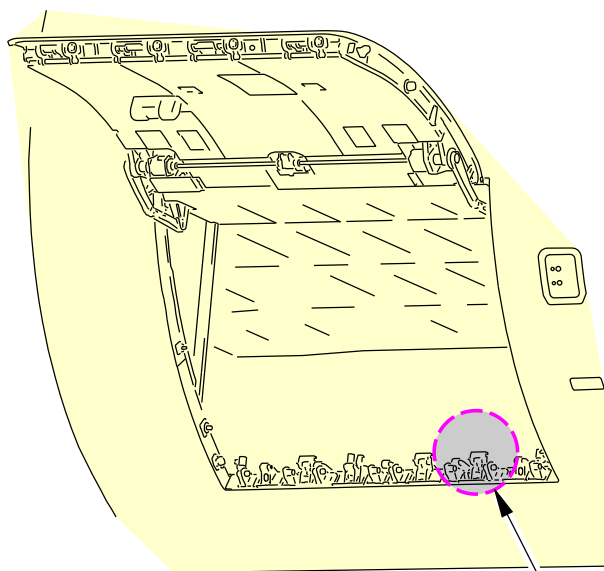
EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-11

Config 3
Page 404
Sep 05/2017

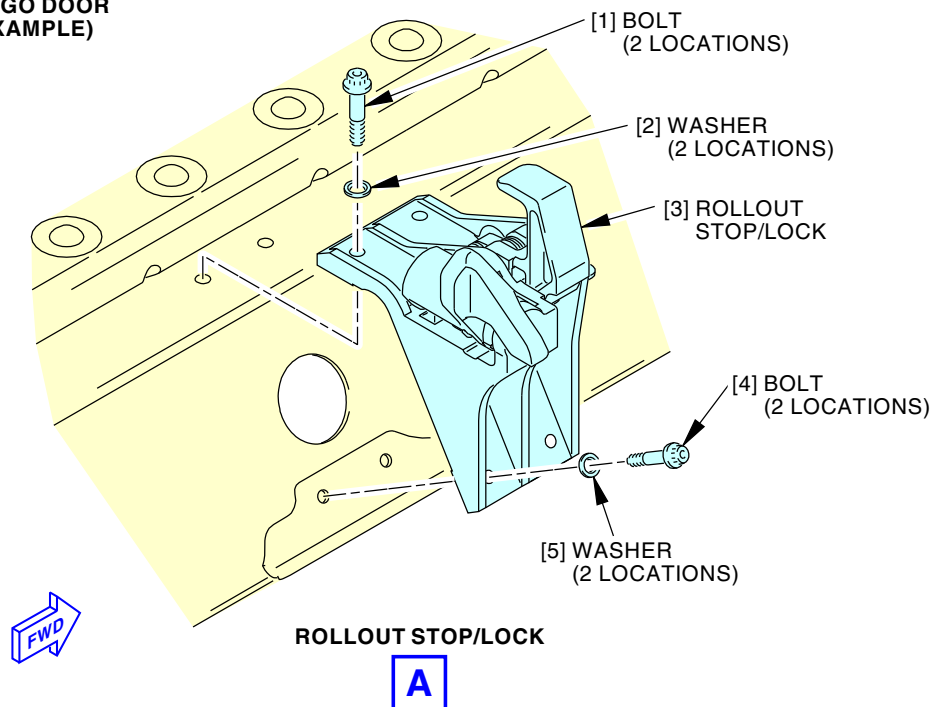
**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



ROLLOUT STOP/LOCK

A

**CARGO DOOR
(EXAMPLE)**



ROLLOUT STOP/LOCK

A

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**Rollout Stop/Lock Installation
Figure 401/25-53-11-990-809-003**

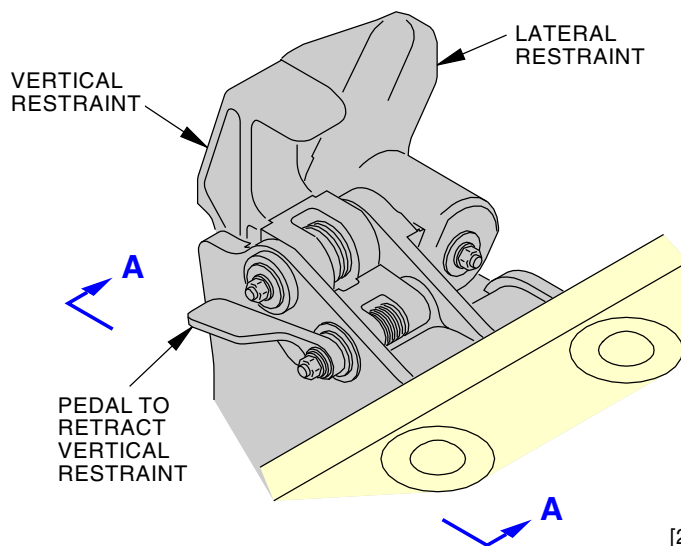
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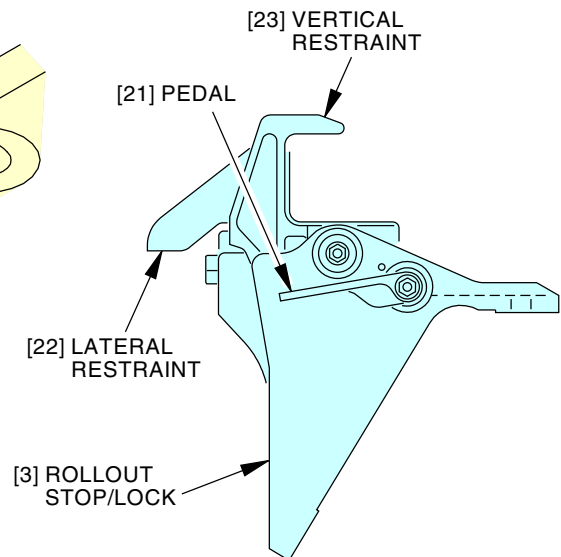
25-53-11

Config 3
Page 405
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

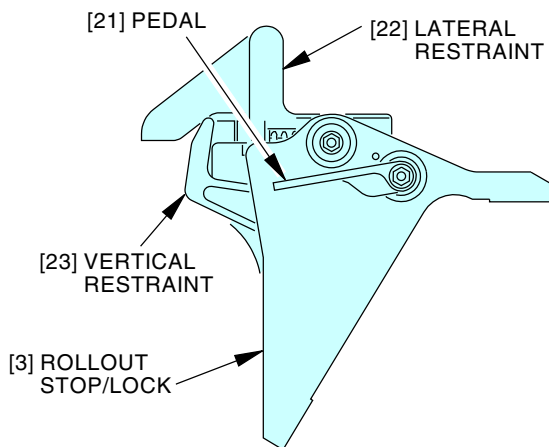


**ROLLOUT STOP/LOCK
(EXAMPLE)**



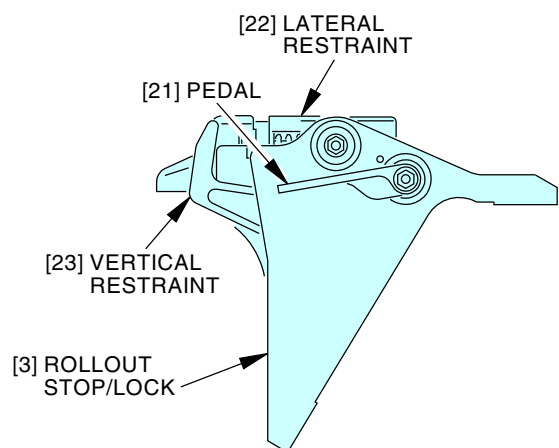
(LOCK POSITION)

A-A



**(CONTAINER
LOAD POSITION)**

A-A



**(UNLOAD/PALLET
LOAD POSITION)**

A-A

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**Rollout Stop/Lock Test
Figure 402/25-53-11-990-810-003**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-11

Config 3
Page 406
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

GUIDE ROLLER ASSEMBLY - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the guide roller assembly.
 - (2) An installation of the guide roller assembly.
- B. This procedure is applicable to all of the guide roller assemblies in the forward and aft cargo compartments.

TASK 25-53-12-000-801

2. Guide Roller Assembly Removal

(Figure 401)

A. References

Reference	Title
25-53-02-000-801	Ball Panel Removal (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

C. Location Zones

Zone	Area
122	Forward Cargo Compartment, Right
152	Aft Cargo Compartment, Right

D. Prepare for the Removal

SUBTASK 25-53-12-480-001



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 across the cargo door opening.

SUBTASK 25-53-12-010-001

- (2) Do this task: Ball Panel Removal, TASK 25-53-02-000-801.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-12

Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

E. Guide Roller Assembly Removal

SUBTASK 25-53-12-210-001

- (1) Do a check of the roller [1] to make sure it is necessary to remove the full guide roller assembly.

NOTE: You can easily remove the roller [1] from the guide roller assembly. It is not necessary to remove the guide roller assembly if only the roller [1] needs to be replaced.

- (a) Do these steps to remove the roller [1] if it is applicable:
- 1) Remove the nut [12] and washer [13] that hold the roller [1] on the spindle [15].
 - 2) Lift the shield [14] and roller [1] off of the spindle [15].

SUBTASK 25-53-12-020-002

- (2) Do these steps to remove the guide roller assembly [16] or guide roller assembly [21]:
- (a) Remove the applicable bolts [2] [6] [10], washers [4] [7] [8] [11], and nuts [5] [9], that hold the guide roller assembly [16].
 - (b) Remove the applicable bolts [2] [22] [24], washers [4] [23] [25] [26], and nuts [5] [9] [27] that hold the guide roller assembly [21].
 - (c) Remove the guide roller assembly [16] or guide roller assembly [21] from the door sill.

————— **END OF TASK** —————

TASK 25-53-12-400-801

3. Guide Roller Assembly Installation

(Figure 401)

A. References

Reference	Title
25-53-02-400-801	Ball Panel Installation (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A00723	Sealant - Corrosion Inhibitive, 2-Part - PR-1405-G	

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
16	Guide roller assembly	25-53-10-05B-025	ARO ALL

EFFECTIVITY
ARO ALL

25-53-12

D633W101-ARO

Page 402
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

AMM Item	Description	AIPC Reference	AIPC Effectivity
16 (cont.)		25-53-10-05B-170	ARO ALL
21	Guide roller assembly	25-53-10-11C-015	ARO 001-015
		25-53-10-11C-020	ARO 001-015

E. Location Zones

Zone	Area
122	Forward Cargo Compartment, Right
152	Aft Cargo Compartment, Right

F. Guide Roller Assembly Installation

SUBTASK 25-53-12-420-001

- (1) Do these steps to install the roller [1] if it was removed:
 - (a) Put the roller [1] on the spindle [15].
 - (b) Put the shield [14] on the roller [1].
 - (c) Apply wet PR-1405-G sealant, A00723 to the nut [12].
 - 1) Make sure you do not get PR-1405-G sealant, A00723 on the spindle threads.
 - (d) Install the washer [13] and nut [12].

SUBTASK 25-53-12-110-001

- (2) Clean the old sealant, A00247 off of the door sill structure.

SUBTASK 25-53-12-390-005

- (3) Apply sealant, A00247 to the mating surfaces between the guide roller assembly [16] or guide roller assembly [21] and the door sill structure.

SUBTASK 25-53-12-820-003

- (4) Put the guide roller assembly [16] or guide roller assembly [21] in the correct position on the door sill.

SUBTASK 25-53-12-390-006

- (5) Apply sealant, A00247 below the heads of the bolts [6] [10] [22] [24].

SUBTASK 25-53-12-420-004



CAUTION

TIGHTEN THE BOLTS SLOWLY AT THE START TO MAKE SURE THEY GO THROUGH THE NUTPLATE STRAIGHT. DAMAGE TO THE NUTPLATES CAN OCCUR IF THE BOLTS ARE NOT INSTALLED STRAIGHT.

- (6) Install the applicable bolts [2] [6] [10] [22] [24], washers [4] [7] [8] [11] [23] [25] [26] and nuts [5] [9] [27].

SUBTASK 25-53-12-390-008

- (7) Apply sealant, A00247 fillet seal around the guide roller assembly [16] or guide roller assembly [21].

G. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-12-410-001

- (1) Do this task: Ball Panel Installation, TASK 25-53-02-400-801.

EFFECTIVITY
ARO ALL

25-53-12

D633W101-ARO

Page 403
Jul 25/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-12-080-001

- (2) Remove the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 from the cargo door opening.

————— **END OF TASK** —————

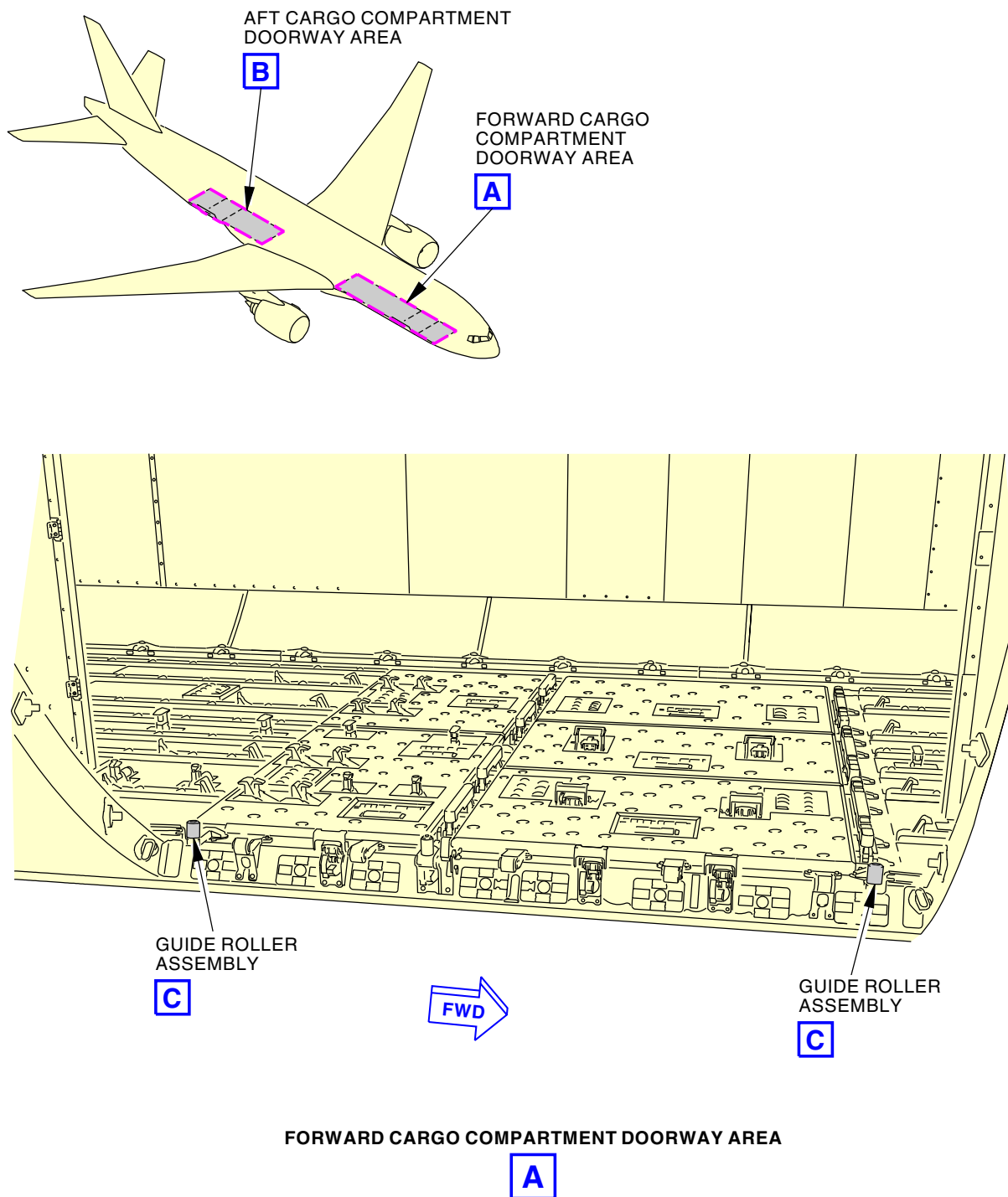
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25-53-12

Page 404
Sep 05/2015

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Guide Roller Assembly Installation
Figure 401/25-53-12-990-801 (Sheet 1 of 4)

EFFECTIVITY
ARO ALL

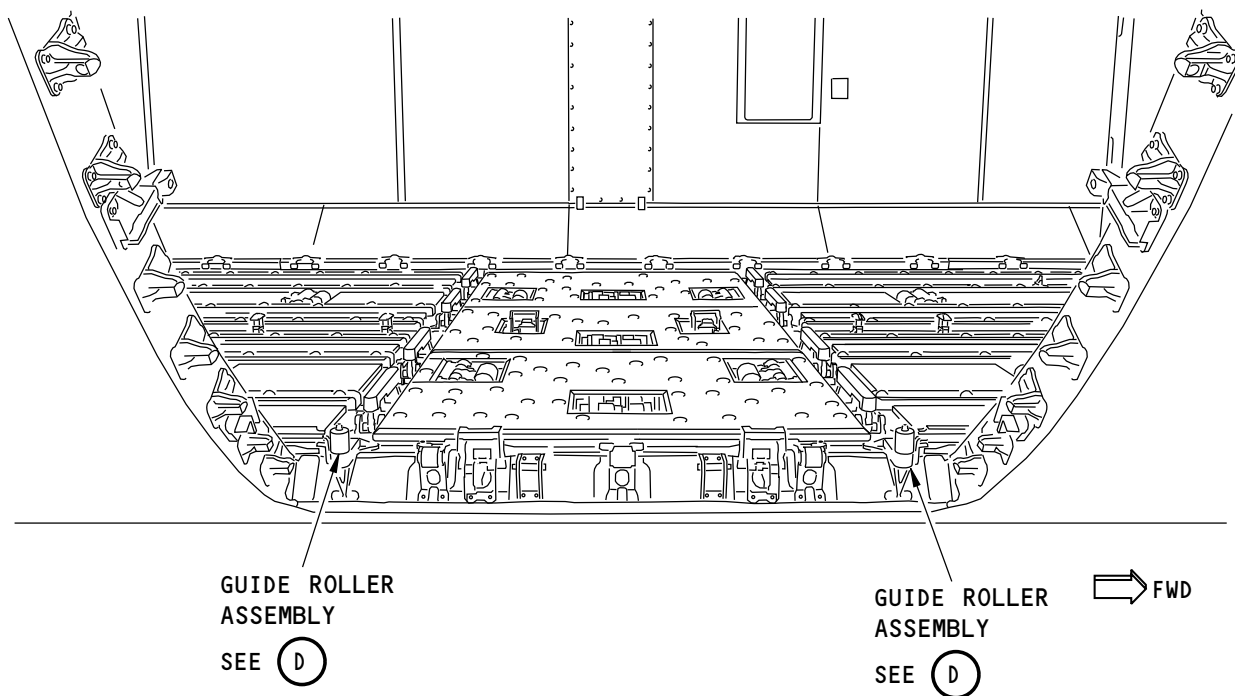
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D633W101-ARO

Page 405
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



AFT CARGO COMPARTMENT DOORWAY AREA

(B)

E58869 S0006411031_V1

Guide Roller Assembly Installation
Figure 401/25-53-12-990-801 (Sheet 2 of 4)

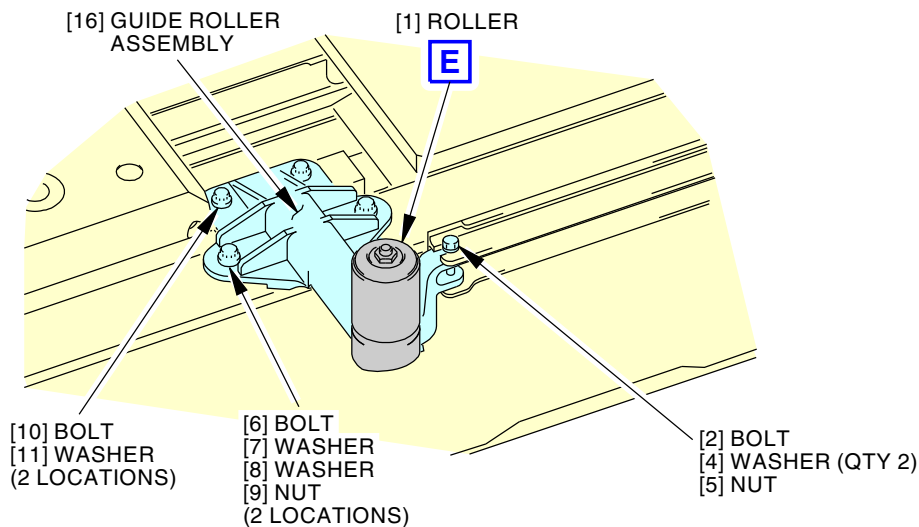
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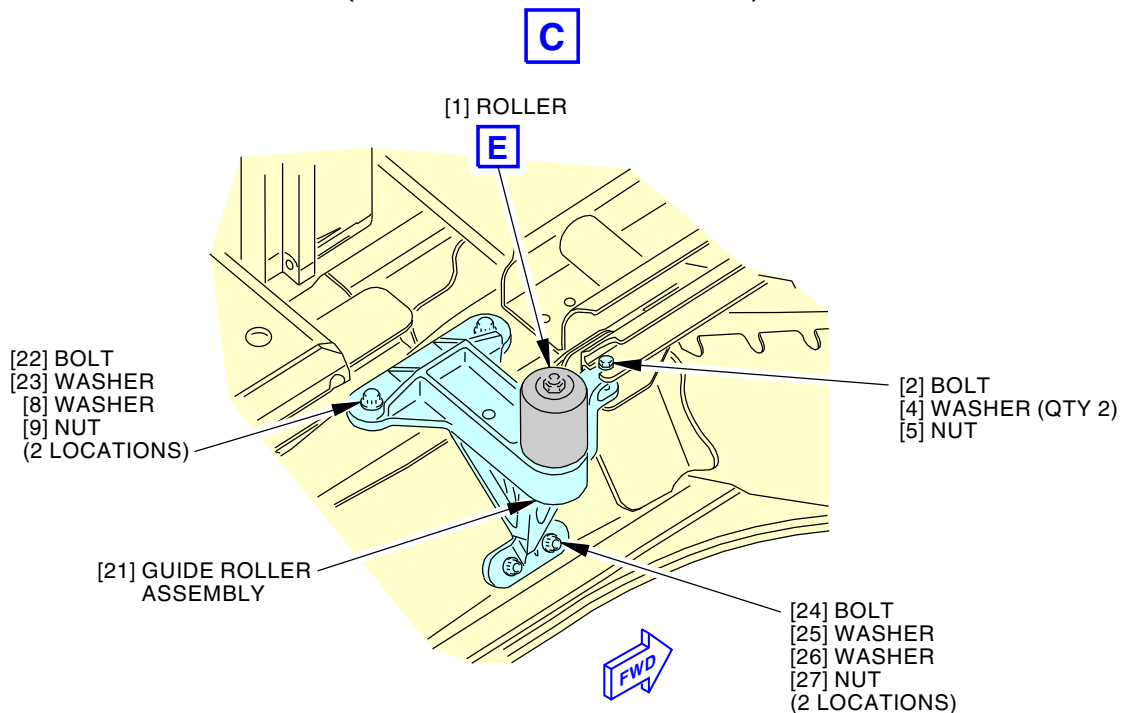
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Page 406
Jan 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL



**GUIDE ROLLER ASSEMBLY
(FORWARD CARGO COMPARTMENT)**



**GUIDE ROLLER ASSEMBLY
(AFT CARGO COMPARTMENT)**

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**Guide Roller Assembly Installation
Figure 401/25-53-12-990-801 (Sheet 3 of 4)**

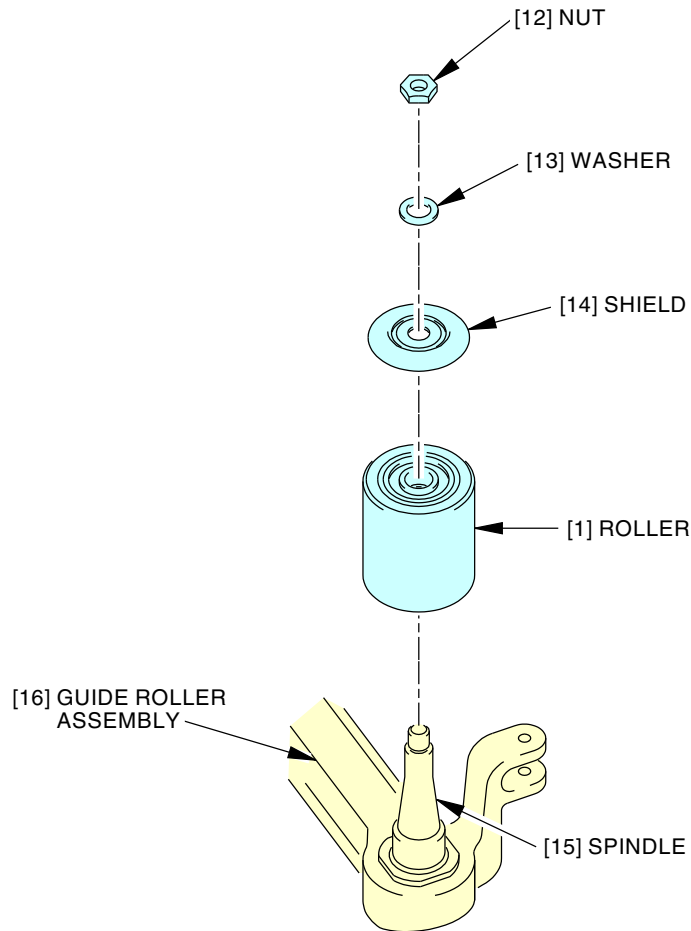
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25-53-12

D633W101-ARO

Page 407
May 05/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL



ROLLER
E

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Guide Roller Assembly Installation
Figure 401/25-53-12-990-801 (Sheet 4 of 4)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-12

Page 408
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

RETRACTABLE GUIDE ROLLER/LOCK - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the retractable guide roller/lock.
 - (2) An installation of the retractable guide roller/lock.
- B. This procedure is applicable for each retractable guide roller/lock.

TASK 25-53-13-000-805-003

2. Retractable Guide Roller/Lock Removal

(Figure 401, Figure 402)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363

B. Location Zones

Zone	Area
122	Forward Cargo Compartment, Right

C. Prepare for the Removal

SUBTASK 25-53-13-480-005-003



WARNING

INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 across the applicable cargo door opening.

D. Retractable Guide Roller/Lock Removal

SUBTASK 25-53-13-210-018-003

- (1) Do a check of the roller [4] to make sure it is necessary to remove the full lock assembly [3].

NOTE: You can easily remove the roller [4] from the retractable guide roller/lock [3]. It is not necessary to remove the retractable guide roller/lock [3] if the roller [4] is all that needs to be replaced.

SUBTASK 25-53-13-020-020-003

- (2) Remove the bolt [1], bolt [5] and washer [2], washer [6] that attach the lock assembly [3] to the door sill.

SUBTASK 25-53-13-020-021-003

- (3) Remove the lock assembly [3].

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-13

Config 3
Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-53-13-400-805-003

3. Retractable Guide Roller/Lock Installation

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A00723	Sealant - Corrosion Inhibitive, 2-Part - PR-1405-G	
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
D50039	Lubricant - PTFE Release Agent - Miller-Stephenson MS-122RB (use until stock depleted)	
G02185	Agent - Peelable Parting (Valspar - 4A-183 Green Strippable Coating)Manufacturing discontinued, use stock until depleted	
G51444	Release Agent - Miller-Stephenson MS-122SEL	BMS15-21

C. Location Zones

Zone	Area
122	Forward Cargo Compartment, Right

D. Retractable Guide Roller/Lock Installation

(Figure 401, Figure 402)

SUBTASK 25-53-13-140-005-003

(1) Clean the old PR-1405-G sealant, A00723 off of the door sill structure.

SUBTASK 25-53-13-370-003-003

(2) Apply two coats of primer, C00259 to the bottom surface of the lock assembly [3].

SUBTASK 25-53-13-390-017-003

(3) Apply MS-122RB lubricant, D50039, MS-122SEL release agent, G51444 or Valspar 4A-183 green strippable coating, G02185 to the bottom surface of the lock assembly [3].

SUBTASK 25-53-13-390-011-003

(4) Apply PR-1405-G sealant, A00723 to the mating surfaces between the lock assembly [3] and the structure on the door sill.

SUBTASK 25-53-13-820-006-003

(5) To install the lock assembly [3], align its holes with the holes on the door sill.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-13

Config 3
Page 402
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-13-390-012-003

- (6) Apply PR-1405-G sealant, A00723 to the bolt [1] and the bolt [5].

SUBTASK 25-53-13-420-012-003



TIGHTEN THE BOLTS SLOWLY AT THE START TO MAKE SURE THEY GO THROUGH THE NUTPLATE STRAIGHT. DAMAGE TO THE NUTPLATE CAN OCCUR IF THE BOLTS ARE NOT INSTALLED STRAIGHT.

- (7) Install the bolt [1], bolt [5] and washer [2], washer [6] that attach the lock assembly [3] to the door sill.

SUBTASK 25-53-13-390-018-003

- (8) Apply a sealant, A00247 fillet seal around the lock assembly [3].

E. Retractable Guide Roller/Lock Installation Test

(Figure 402)

SUBTASK 25-53-13-980-024-003

- (1) Push the roller release pedal [33] on the fork to manually retract the roller [4].
 - (a) Make sure the roller [4] is below the conveyor plane.

NOTE: The conveyor plane is the top of the balls in the ball panels.

SUBTASK 25-53-13-980-025-003

- (2) Push the vertical restraint release pedal [34] to manually retract the vertical restraint [32].
 - (a) Make sure the vertical restraint [32] is below the conveyor plane.

SUBTASK 25-53-13-980-026-003

- (3) Pull up on the vertical restraint [32] until it fully engages in the vertical position.
 - (a) Push on the vertical restraint [32] to make sure it does not retract.

SUBTASK 25-53-13-980-027-003

- (4) Pull up on the roller [4] until the roller [4] engages in the vertical position.

SUBTASK 25-53-13-210-019-003

- (5) Do a visual check to make sure the inboard face of the roller [4] is outboard or aligned with the side guide rail.

SUBTASK 25-53-13-980-028-003

- (6) Push the vertical restraint release pedal [34] to manually retract the restraint [32] again.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-13-080-005-003

- (1) Remove the large cargo door safety barrier, SPL-1988 from the applicable cargo door opening.

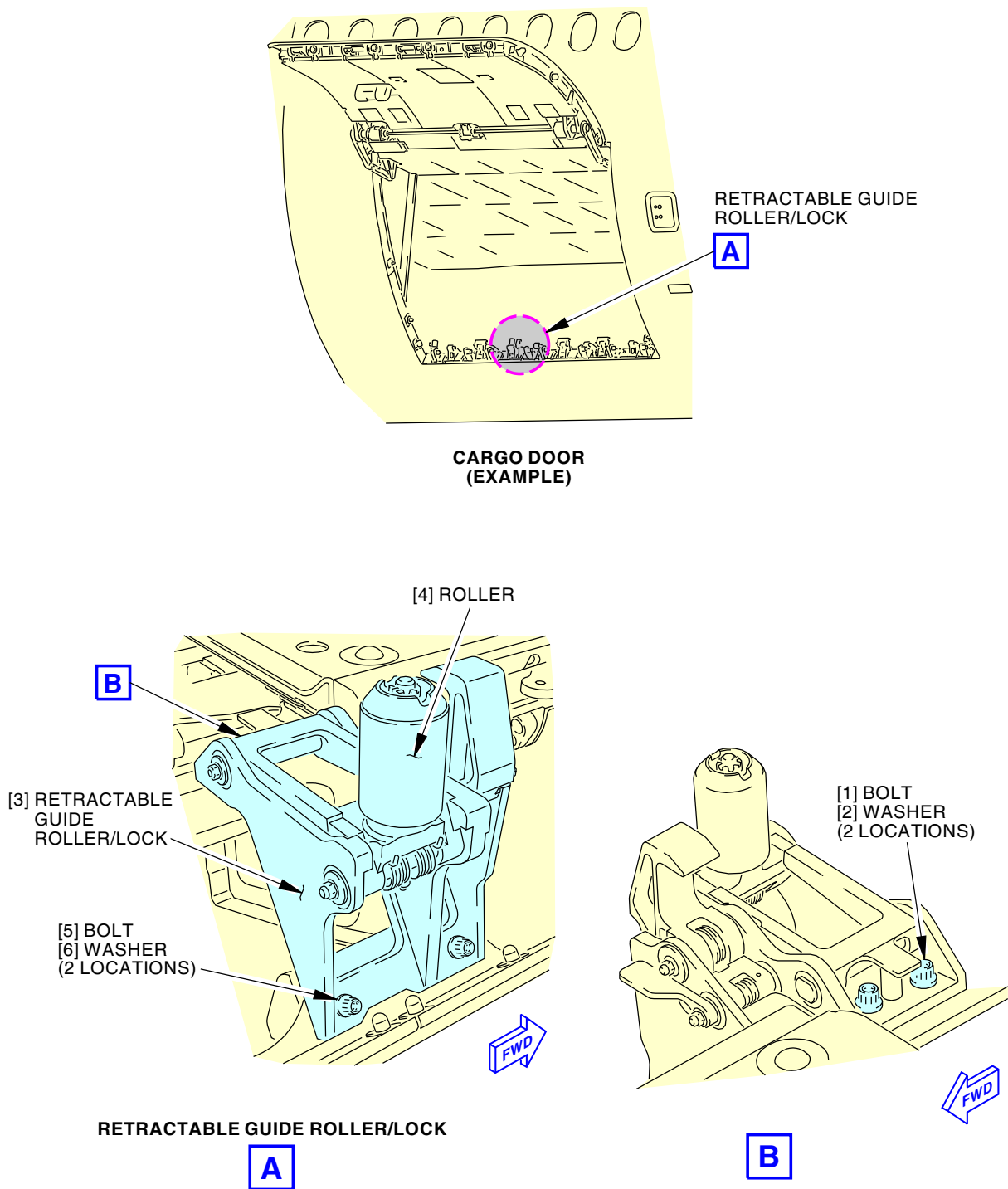
————— END OF TASK —————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-13

Config 3
Page 403
Sep 05/2017



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**Retractable Guide Roller/Lock Installation
Figure 401/25-53-13-990-809-003**

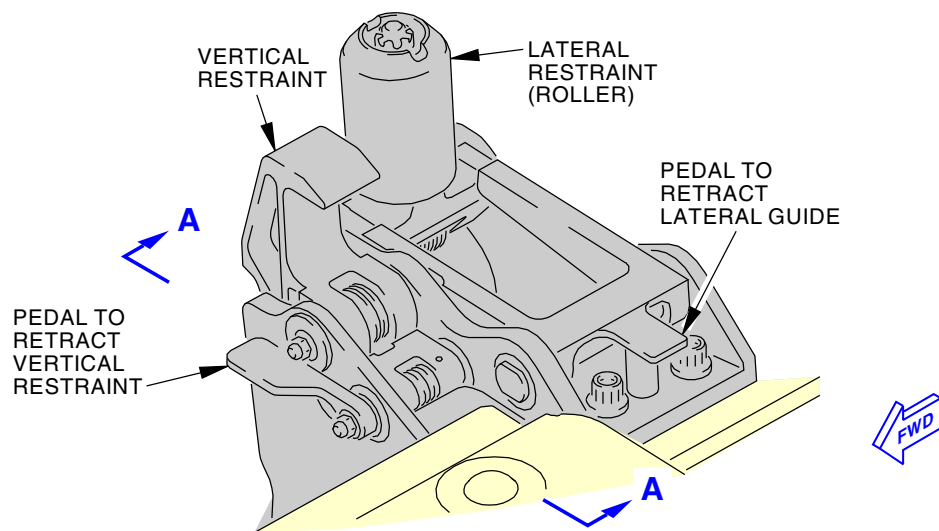
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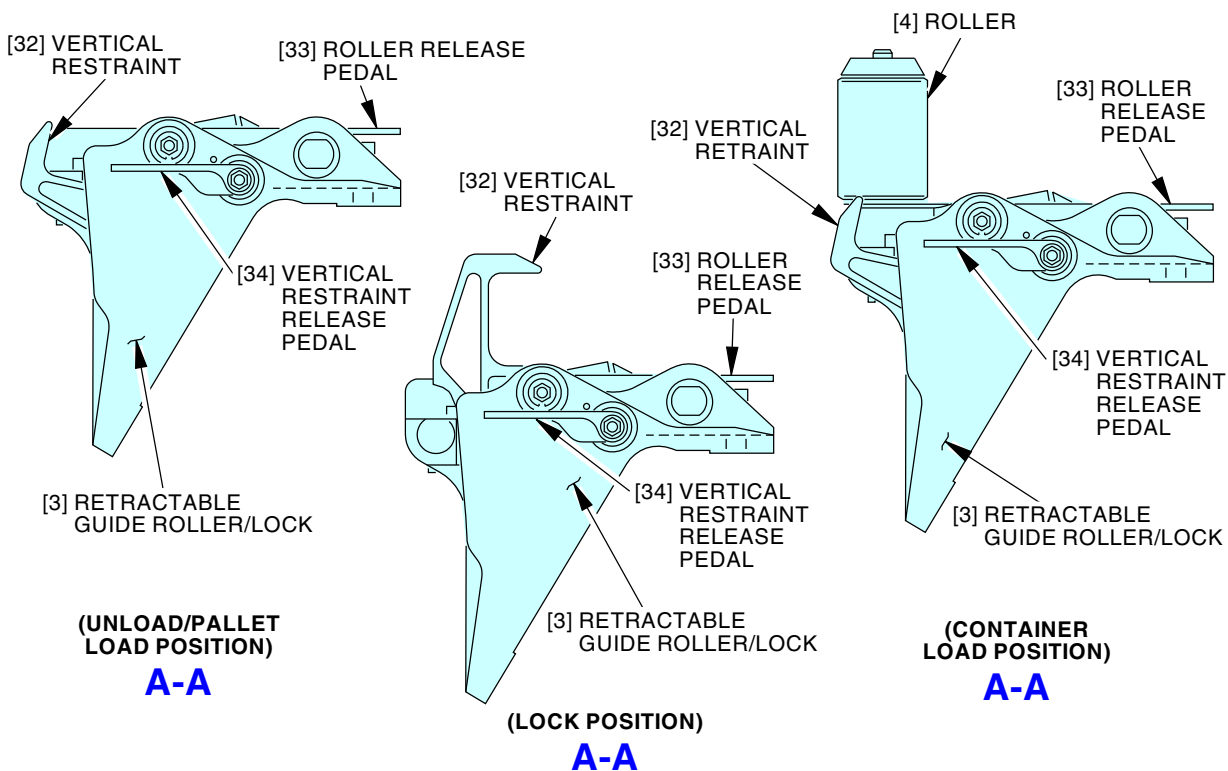
Config 3
Page 404
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**RETRACTABLE GUIDE ROLLER/LOCK
(EXAMPLE)**

A



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**Retractable Guide Roller/Lock Test
Figure 402/25-53-13-990-810-003**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-13

Config 3
Page 405
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SILL ROLLER ASSEMBLY - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the sill roller assembly.
 - (2) An installation of the sill roller assembly.
- B. There are two types of the sill roller assemblies. They are called the sill roller assembly and cantilevered sill roller assembly.
- (1) The cantilevered sill roller assemblies are installed with nuts on the door sill of the forward cargo compartment only. In the aft cargo compartment they are installed with nutplates. It is necessary to remove the ball panel adjacent to the cantilevered type.
 - (2) The sill roller assemblies are installed with nutplates. It is not necessary to remove the ball panel to remove this type.
- C. This procedure is applicable for the two types of sill roller assemblies.

TASK 25-53-14-000-801

2. Sill Roller Assembly Removal

(Figure 401)

A. References

Reference	Title
25-53-02-000-801	Ball Panel Removal (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

C. Location Zones

Zone	Area
122	Forward Cargo Compartment, Right
152	Aft Cargo Compartment, Right

D. Prepare for the Removal

SUBTASK 25-53-14-480-001



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 across the cargo door opening.

EFFECTIVITY
ARO ALL

25-53-14

D633W101-ARO

Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-14-010-001

- (2) FOR THE FORWARD CARGO COMPARTMENT; do this task for the cantilevered sill roller assemblies: Ball Panel Removal (TASK 25-53-02-000-801).

E. Sill Roller Assembly Removal

SUBTASK 25-53-14-210-001

- (1) Do a check of the roller [14] to make sure it is necessary to remove the full sill roller assembly.

NOTE: You can easily remove the roller [14] from the sill roller assembly. It is not necessary to remove the sill roller assembly if only the roller [14] needs to be replaced.

- (a) Do these steps to remove the roller [14] if it is applicable:
- 1) Remove the nut [16] and washer [15] that hold the roller [14] on the pin [13].
 - 2) Pull the pin [13] out of the bracket [12].
 - 3) Remove the roller [14].

SUBTASK 25-53-14-020-003

- (2) Do the steps that follow for the applicable sill roller assembly that you need to remove:
- (a) Remove the bolts [2] and washers [3] that hold the sill roller assembly [1] on the door sill.
 - (b) Remove the bolts [6] [10], washers [7] [8] [11], and nuts [9], that hold the sill roller assy [5] on the door sill.
 - (c) Remove the bolts [22], washers [23] [24], and nuts [25] that hold the sill roller assy [21] on the door sill.

SUBTASK 25-53-14-020-004

- (3) Remove the sill roller assembly [1], [5], or [21] from the door sill.

————— END OF TASK —————

TASK 25-53-14-400-801

3. Sill Roller Assembly Installation

(Figure 401)

A. References

Reference	Title
25-53-02-400-801	Ball Panel Installation (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

EFFECTIVITY
ARO ALL

25-53-14

D633W101-ARO

Page 402
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Sill roller assembly	25-53-10-05B-060	ARO 001-015
		25-53-10-11C-080	ARO 001-015

E. Location Zones

Zone	Area
122	Forward Cargo Compartment, Right
152	Aft Cargo Compartment, Right

F. Sill Roller Assembly Installation

SUBTASK 25-53-14-420-002

- (1) Do these steps to install the roller [14] if it was removed:
 - (a) Put the roller [14] between the forks on the bracket [12].
 - (b) Put the pin [13] through the bracket [12] and the roller [14].
 - (c) Loosely install the washer [15] and nut [16].
 - (d) Tighten the nut to 50-75 pound-inch.

SUBTASK 25-53-14-140-002

- (2) Clean the old sealant, A00247 off of the door sill structure.

SUBTASK 25-53-14-390-003

- (3) Apply sealant, A00247 to the mating surfaces between the sill roller assembly [1], sill roller assembly [5], or [21] and the door sill structure.

SUBTASK 25-53-14-820-002

- (4) Put the sill roller assembly [1], sill roller assembly [5], or [21] in the correct position on the door sill.

SUBTASK 25-53-14-390-004

- (5) Apply wet sealant, A00247 below the heads of the bolts [2] [6] [10] [22].

SUBTASK 25-53-14-420-003



TIGHTEN THE BOLTS SLOWLY AT THE START TO MAKE SURE THEY GO THROUGH THE NUTPLATES STRAIGHT. DAMAGE TO THE NUTPLATES CAN OCCUR IF THE BOLTS ARE NOT INSTALLED STRAIGHT.

- (6) Install the applicable bolts [2] [6] [10] [22], washers [3] [7] [8] [11] [23] [24], and nuts [9] [25].

SUBTASK 25-53-14-390-006

- (7) Apply a sealant, A00247 fillet seal around the sill roller assembly [1], sill roller assembly [5] and [21].

SUBTASK 25-53-14-410-001

- (8) Do this task if it is applicable: Ball Panel Installation (TASK 25-53-02-400-801).

SUBTASK 25-53-14-210-002

- (9) Make sure the roller [14] is at the conveyor plane.

NOTE: The conveyor plane is the top of the balls in the ball panels.

EFFECTIVITY
ARO ALL

25-53-14

D633W101-ARO

Page 403
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

G. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-14-080-001

- (1) Remove the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 from the cargo door opening.

————— **END OF TASK** —————

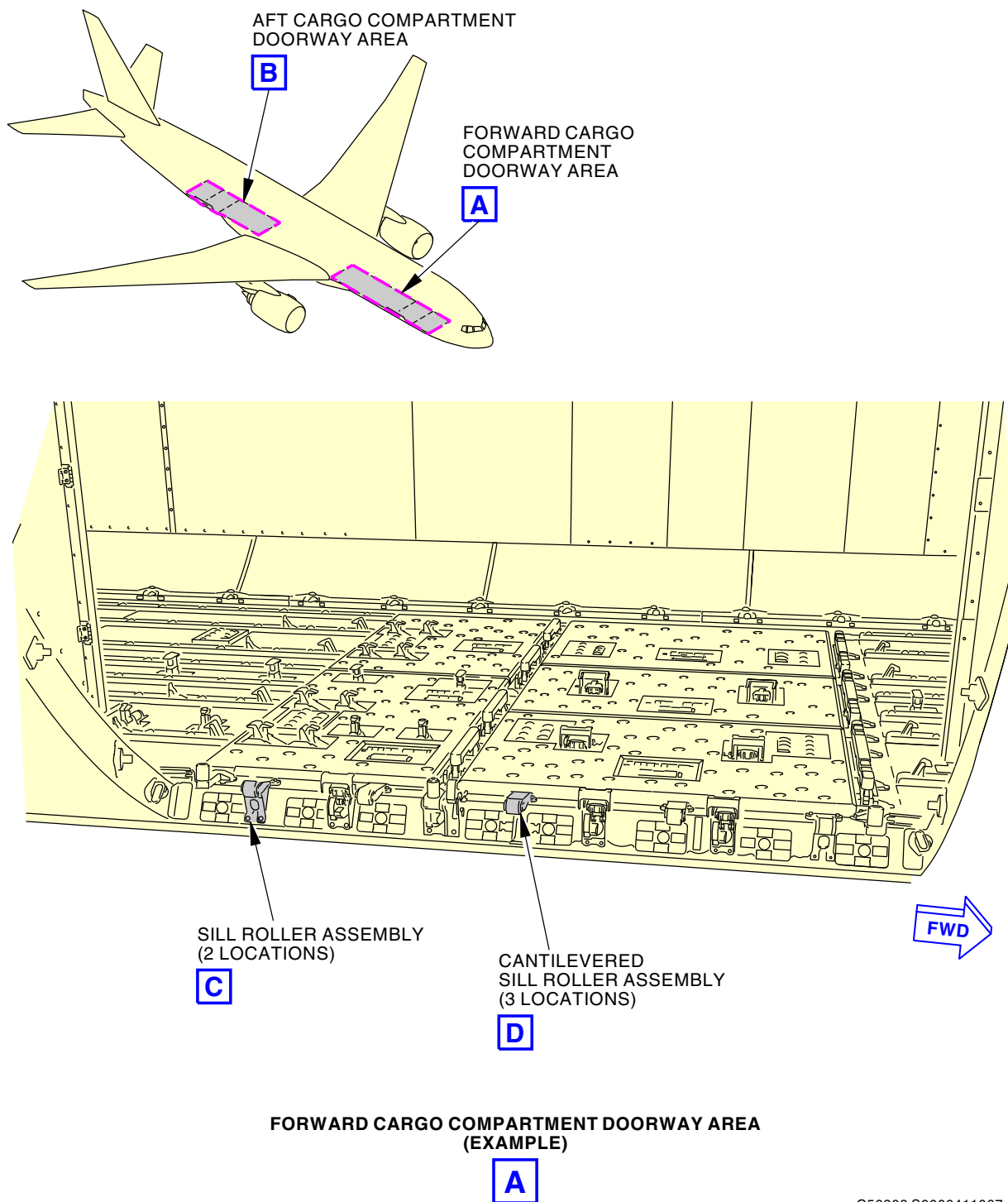
EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-14

Page 404
Sep 05/2015

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Sill Roller Assembly Installation
Figure 401/25-53-14-990-801 (Sheet 1 of 4)

EFFECTIVITY
ARO ALL

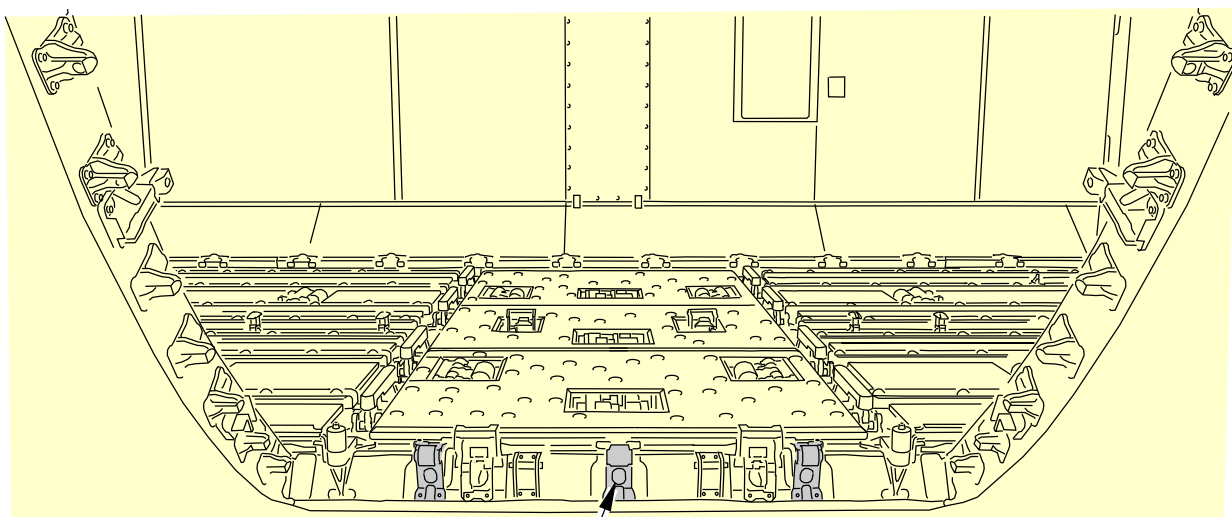
25-53-14

D633W101-ARO

Page 405
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



SILL ROLLER ASSEMBLY
(3 LOCATIONS)

E



AFT CARGO COMPARTMENT DOORWAY AREA
(EXAMPLE)

B

E58842 S0006411069_V2

Sill Roller Assembly Installation
Figure 401/25-53-14-990-801 (Sheet 2 of 4)

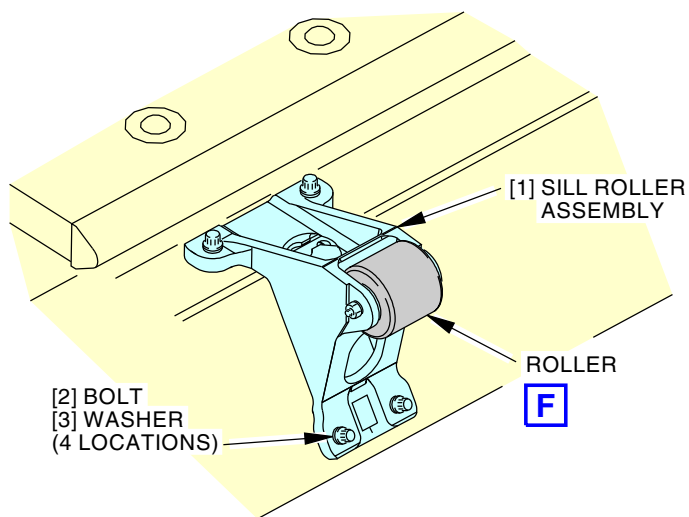
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25-53-14

D633W101-ARO

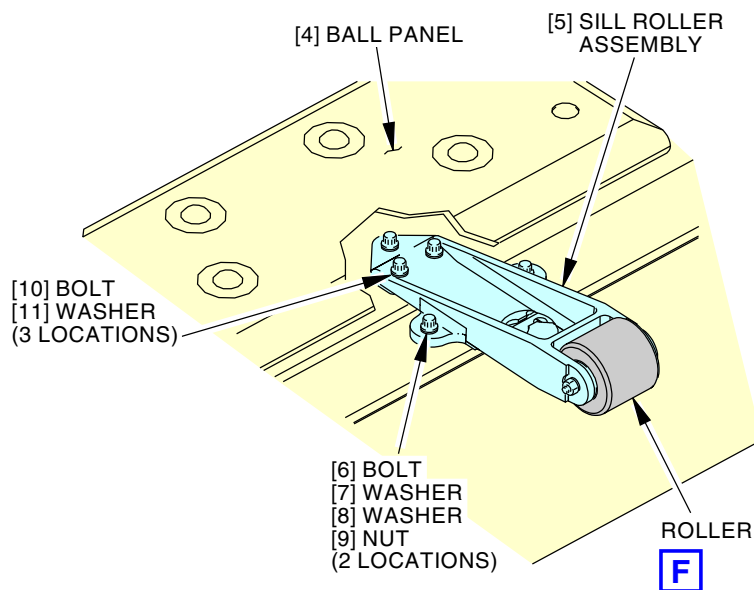
Page 406
May 05/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**SILL ROLLER ASSEMBLY
(FORWARD CARGO COMPARTMENT)**

C



**CANTILEVERED SILL ROLLER ASSEMBLY
(FORWARD CARGO COMPARTMENT)**

D

C56312 S0006411071_V2

**Sill Roller Assembly Installation
Figure 401/25-53-14-990-801 (Sheet 3 of 4)**

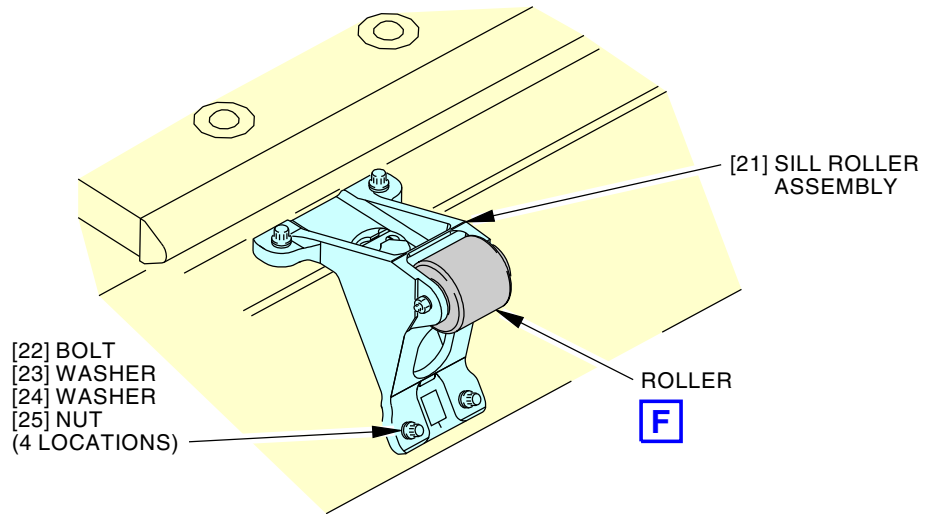
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25-53-14

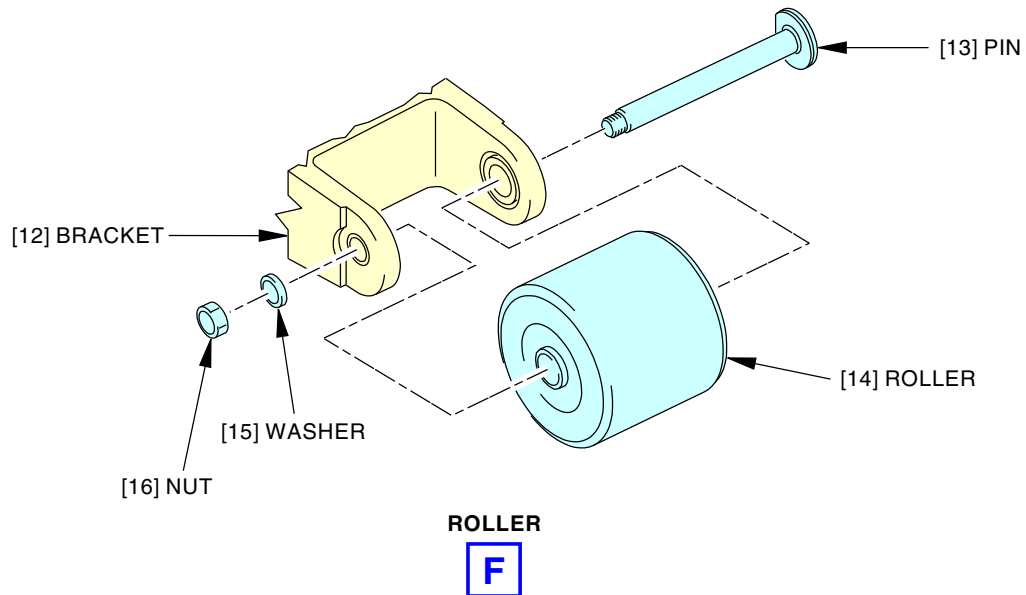
Page 407
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



**SILL ROLLER ASSEMBLY
(AFT CARGO COMPARTMENT)**

[E]



E59802 S0006411074_V2

Sill Roller Assembly Installation
Figure 401/25-53-14-990-801 (Sheet 4 of 4)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-14

Page 408
May 05/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL
SIDE GUIDE RAIL - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the side guide rail.
 - (2) An installation of the side guide rail.
- B. The side guide rails are along the outboard edges of the forward and aft cargo compartments. This procedure is applicable for all of the side guide rails.

TASK 25-53-21-000-801

2. Side Guide Rail Removal

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Prepare for the Removal

SUBTASK 25-53-21-480-001

 WARNING	INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 across the cargo door opening.

D. Side Guide Rail Removal

SUBTASK 25-53-21-020-001

- (1) Do these steps to disconnect the side guide rail [1]:
 - (a) Remove the bolts [8], [15], washers [13], [18], and nuts [12], [16] that attach the side guide rail [1] to the frame [11], [17].
 - (b) Remove the bolts [19], washers [20], [22], and nuts [23] that attach the side guide rail [1] to the intercostal [7].

EFFECTIVITY
ARO ALL

25-53-21

D633W101-ARO

Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (c) Remove the bolt [4], washers [3], [5], and nut [6] to disconnect the side guide rail [1] from the guide roller assembly [2].
- (d) Do these steps if it is necessary to disconnect the two side guide rails [1] at their interface:
 - 1) Loosen the nuts [26] from the bolts [30], [31] that go through the slots in the joint plates [25].
 - 2) Make sure the nuts [26] are loose enough to slide one side guide rail [1] away from the other.

SUBTASK 25-53-21-020-003

(2) FOR SIDE GUIDE RAILS INSTALLED WITH BUSHINGSS; do these steps:

- (a) Remove the side guide rail [1] carefully.

NOTE: There are bushings [33] between the frame [11] and the side guide rail [1].

END OF TASK

TASK 25-53-21-400-801

3. Side Guide Rail Installation

(Figure 401)

A. References

Reference	Title
20-11-00-910-801	Standard Torque Values (P/B 201)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A00723	Sealant - Corrosion Inhibitive, 2-Part - PR-1405-G	
C00913	Compound - Corrosion Inhibiting Material, Nondrying Resin Mix	BMS3-27
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38

D. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left

EFFECTIVITY
ARO ALL

25-53-21

D633W101-ARO

Page 402
Jan 05/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Zone	Area
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

E. Side Guide Rail Installation

SUBTASK 25-53-21-390-001

- (1) Refer to the steps that follow on the areas at the ends of the intercostal [7] to apply the PR-1405-G sealant, A00723, Views C-C and D-D (Figure 401):
 - (a) Apply PR-1405-G sealant, A00723 to the mating surfaces between the side guide rail [1] and frame [17].
 - (b) Apply PR-1405-G sealant, A00723 to the mating surfaces between the anchor fitting [10] and side guide rail [1].
 - (c) Apply PR-1405-G sealant, A00723 to the two sides of the shim [9] if a shim is used.

SUBTASK 25-53-21-390-004

- (2) FOR SIDE GUIDE RAILS INSTALLED WITH BUSHINGS; do these steps:
 - (a) Do these steps to install the bushings [33]:
 - 1) Apply sealant, A00247 to the bores of the side guide rail [1] where the bushings [33] are installed.
 - 2) Apply sealant, A00247 to the side of the bushing [33] facing the frame [11].
 - (b) Put the side guide rail [1] on the frame [11], [17].

SUBTASK 25-53-21-420-003

- (3) If it is necessary, do these steps to attach the side guide rail [1] to another side guide rail [1]:
 - (a) Slide the bolts [30], [31] with the bushings [28] on one side guide rail [1] into the slots in the joint plates [25] on the other side guide rail [1].
 - (b) Tighten the nuts [26] to firmly attach the two side guide rails [1].

SUBTASK 25-53-21-390-002

- (4) Apply wet PR-1405-G sealant, A00723 to the bolts [15], [19].

SUBTASK 25-53-21-390-003



USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-21

Page 403
Sep 05/2017



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

(WARNING PRECEDES)



DO NOT GET THIS MATERIAL IN YOUR MOUTH, EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM THIS MATERIAL. PUT ON A RESPIRATOR, EYE PROTECTION (GOGGLES, OR OTHER APPROVED PROTECTION), AND GLOVES BEFORE YOU USE THIS MATERIAL. MAKE SURE THAT THERE IS SUFFICIENT AIRFLOW. KEEP THIS MATERIAL AWAY FROM SPARKS, FLAME, AND HEAT. THIS MATERIAL CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (5) Apply Cor-Ban 27L Compound, G50237 or Mastinox 6856 K, C00913 to the mating surfaces, holes, and slots at the interface between the side guide rail [1] and the guide roller assembly [2].

SUBTASK 25-53-21-420-002

- (6) Install the bolts [4], [8], [15], [19], washers [3], [5], [13], [18], [20], [22], and nuts [6], [12], [16], [23]. Refer to Standard Torque Values, TASK 20-11-00-910-801.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-21-080-001

- (1) Remove the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 across the forward cargo door opening.

———— **END OF TASK** ————

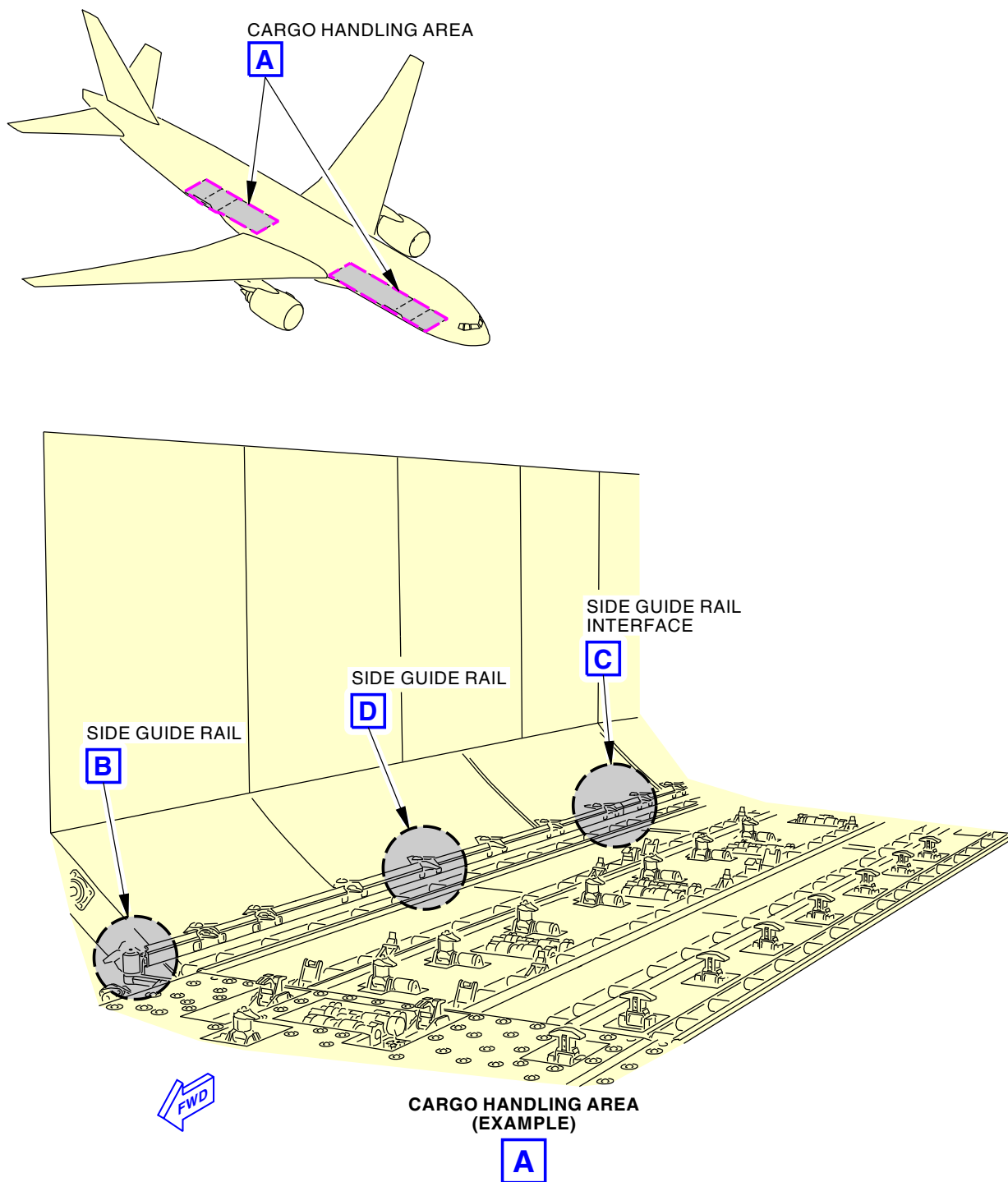
EFFECTIVITY
ARO ALL

25-53-21

D633W101-ARO

Page 404
Sep 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Side Guide Rail Installation
Figure 401/25-53-21-990-801 (Sheet 1 of 4)

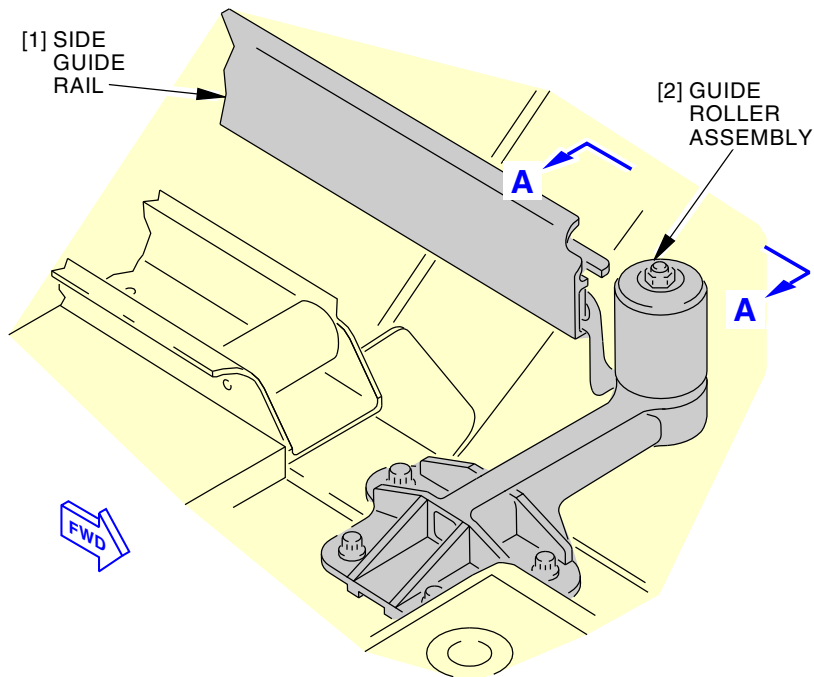
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25-53-21

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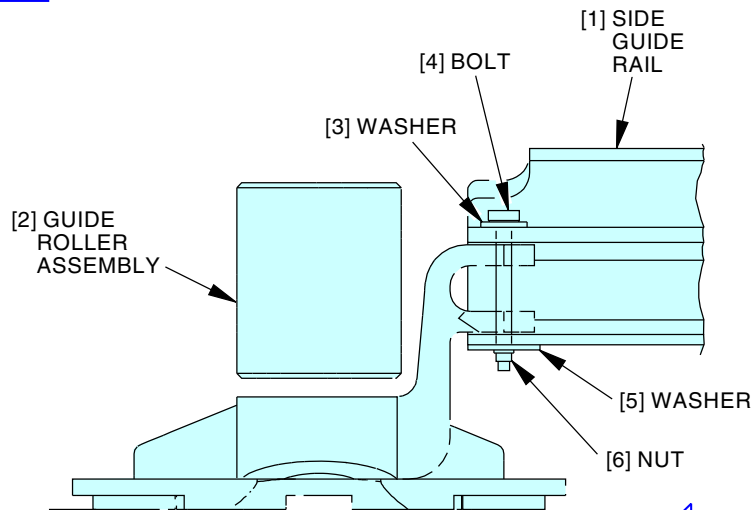
Page 405
May 05/2017

 BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



SIDE GUIDE RAIL

B



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Side Guide Rail Installation
Figure 401/25-53-21-990-801 (Sheet 2 of 4)

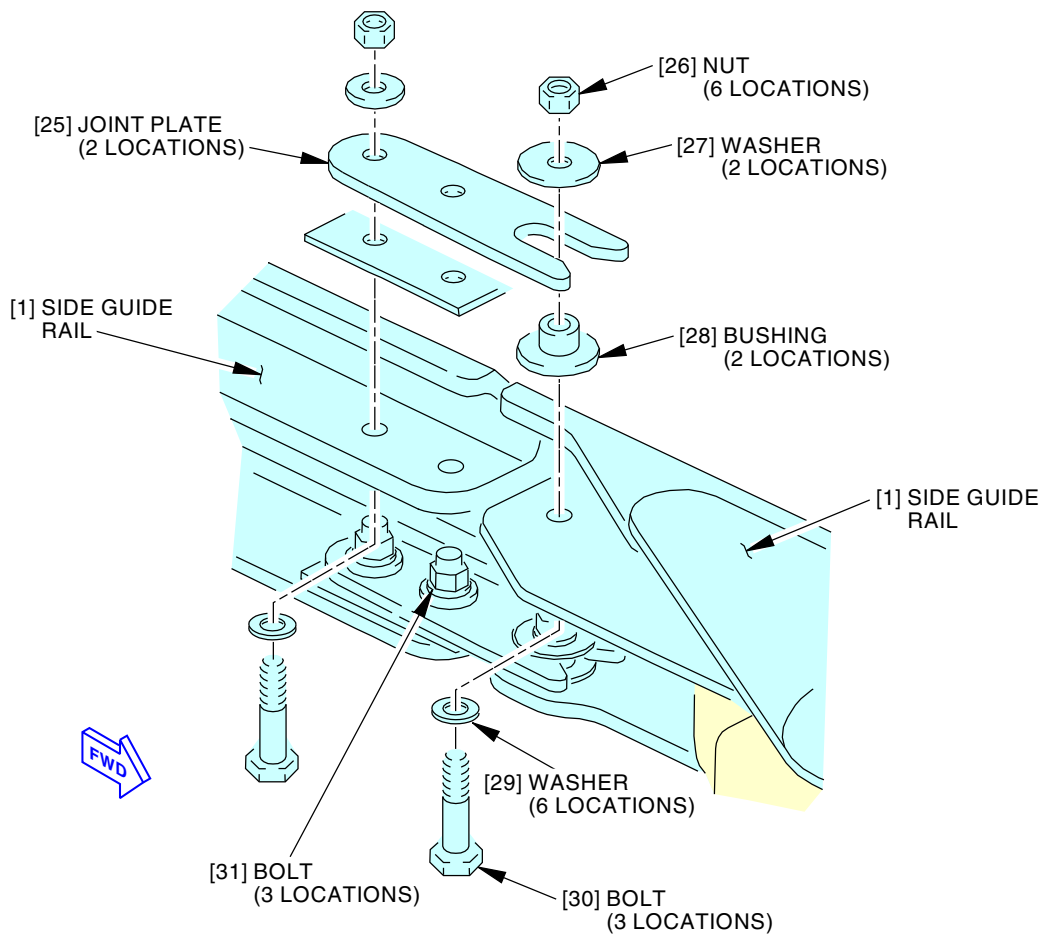
EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-21

Page 406
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**SIDE GUIDE RAIL INTERFACE
(EXAMPLE)**

C

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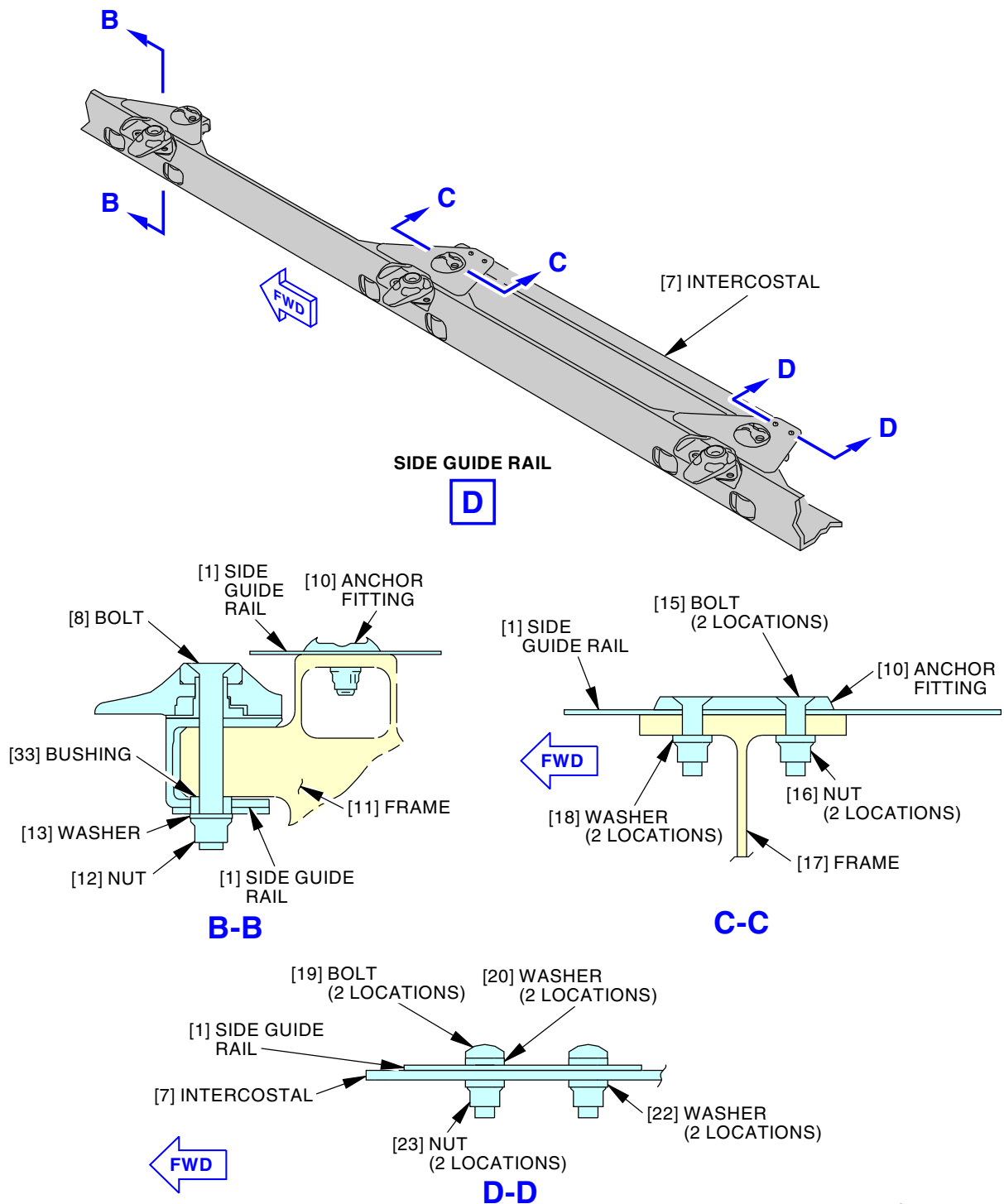
**Side Guide Rail Installation
Figure 401/25-53-21-990-801 (Sheet 3 of 4)**

**EFFECTIVITY
ARO ALL**

25-53-21

D633W101-ARO

Page 407
May 05/2017



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**Side Guide Rail Installation
Figure 401/25-53-21-990-801 (Sheet 4 of 4)**

EFFECTIVITY
ARO ALL

25-53-21

D633W101-ARO

Page 408
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

CENTER AND AUXILIARY GUIDE - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) The removal of the center guides
 - (2) The installation of the center guides

TASK 25-53-22-000-809-003

2. Center Guide Removal

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Prepare for the Removal

SUBTASK 25-53-22-480-009-003



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 across the cargo door opening.

D. Center Guide Removal

SUBTASK 25-53-22-020-021-003

- (1) Remove the bolt [1] that attach the center guide [2] to the floor structure.

SUBTASK 25-53-22-020-022-003

- (2) Remove the center guide [2].

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-22

Config 3
Page 401
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-53-22-400-809-003

3. **Center Guide Installation**

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

B. Consumable Materials

Reference	Description	Specification
A00723	Sealant - Corrosion Inhibitive, 2-Part - PR-1405-G	

C. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

D. Center Guide Installation

SUBTASK 25-53-22-110-009-003

(1) Clean the old PR-1405-G sealant, A00723 off of the structure.

SUBTASK 25-53-22-390-017-003

(2) Apply the PR-1405-G sealant, A00723 to the mating surfaces between the center guide [2].

SUBTASK 25-53-22-420-029-003

(3) Put the center guide [2] in its position.

SUBTASK 25-53-22-820-009-003

(4) Align the holes in the center guide [2] with the holes in the structure.

SUBTASK 25-53-22-390-018-003

(5) Apply the PR-1405-G sealant, A00723 below the bolts [1] heads.

SUBTASK 25-53-22-420-030-003

(6) Put the bolts [1] in the holes.

SUBTASK 25-53-22-420-031-003



TIGHTEN THE BOLTS SLOWLY AT THE START TO MAKE SURE THEY GO THROUGH THE NUTPLATE STRAIGHT. DAMAGE TO THE NUTPLATES CAN OCCUR IF THE BOLTS ARE NOT INSTALLED STRAIGHT.

(7) Tighten the bolts [1] to 50-80 pound-inch.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-22

Config 3
Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

E. Center Guide Installation Test

SUBTASK 25-53-22-210-013-003

- (1) Make sure all of the rollers turn.

SUBTASK 25-53-22-210-014-003

- (2) Push the center guide [2] forward and aft below the conveyor plane.

NOTE: The conveyor plane is the top of the rollers in the roller trays for the guides installed between the roller trays. The conveyor plane is the top of the balls in the ball panels for the guides installed in a cutout in the ball panels.

- (a) Make sure the center guide [2] locks below the conveyor plane.

SUBTASK 25-53-22-860-009-003

- (3) Release the center guide [2].

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-22-080-009-003

- (1) Remove the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006.

————— **END OF TASK** —————

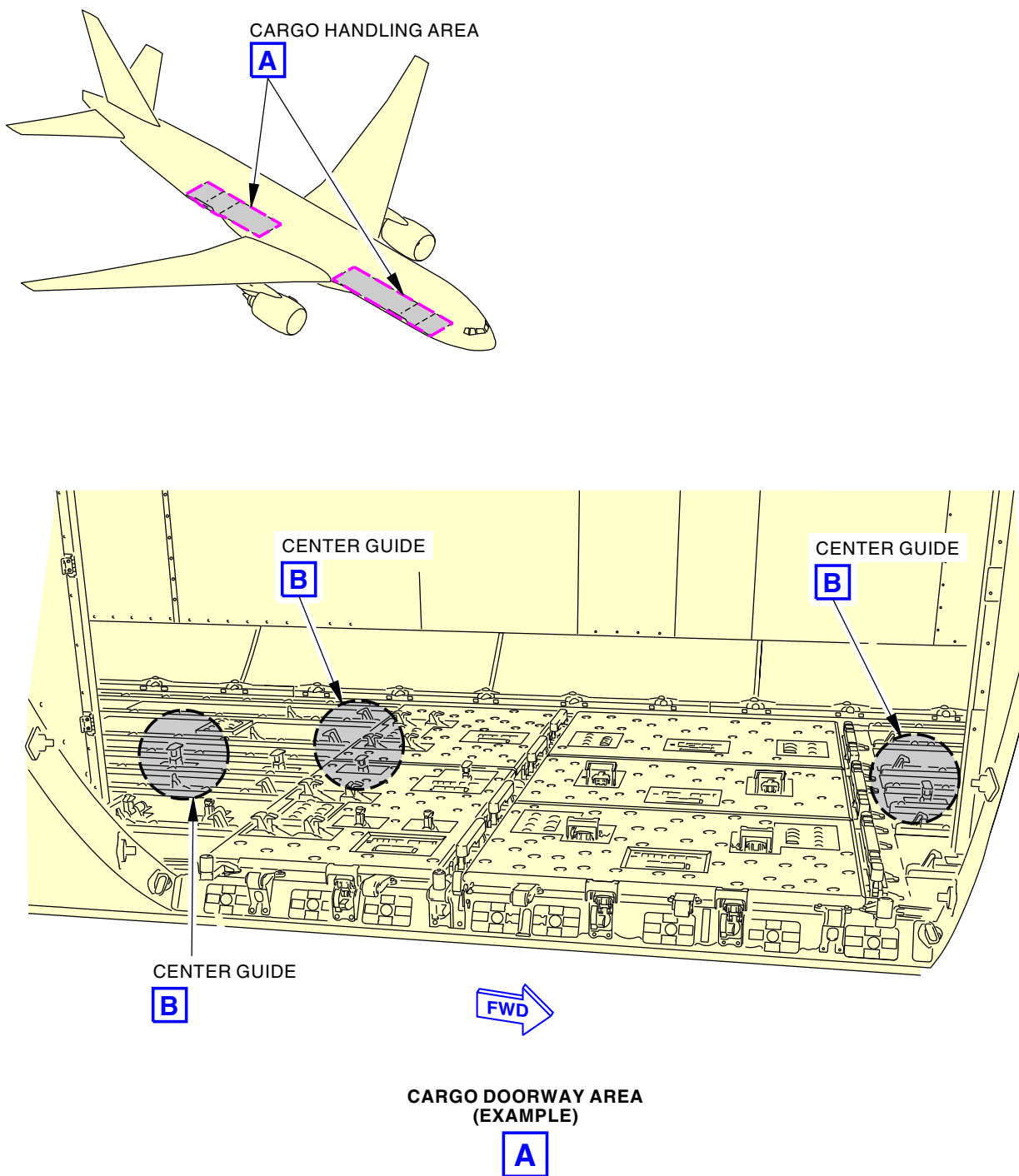
EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-22

Config 3
Page 403
Sep 05/2015

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Center Guide Installation
Figure 401/25-53-22-990-808-003 (Sheet 1 of 2)

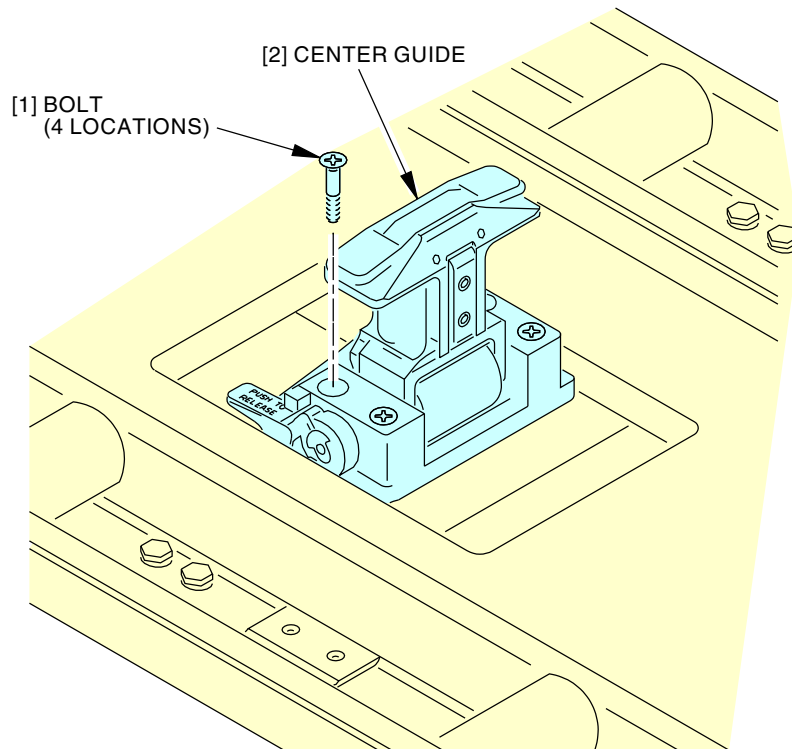
EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-22

Config 3
Page 404
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



**CENTER GUIDE
(EXAMPLE)**

B

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Center Guide Installation
Figure 401/25-53-22-990-808-003 (Sheet 2 of 2)

EFFECTIVITY
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25-53-22

Config 3
Page 405
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
LATERAL GUIDE - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) The removal of a large or small lateral guide.
 - (2) The installation of a large or small lateral guide.
 - (a) The lateral guide installation test.
 - (3) The removal of the lateral guide actuator.
 - (4) The installation of the lateral guide actuator.
- B. This procedure is applicable for each lateral guide in the forward and aft cargo compartments.

TASK 25-53-23-000-801

2. Lateral Guide Removal

(Figure 401)

A. References

Reference	Title
25-53-02-000-801	Ball Panel Removal (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

C. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

D. Prepare for the Removal

SUBTASK 25-53-23-480-001



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 across the cargo door opening.

SUBTASK 25-53-23-860-001

NOTE: FOR THE FORWARD CARGO COMPARTMENT

EFFECTIVITY
ARO ALL

25-53-23

D633W101-ARO

Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (2) Open this circuit breaker and install safety tag:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	9	C25017	LATERAL GUIDES

SUBTASK 25-53-23-860-002

NOTE: FOR THE AFT CARGO COMPARTMENT

- (3) Open this circuit breaker and install safety tag:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	9	C25116	LATERAL GUIDES

SUBTASK 25-53-23-010-001

- (4) Do this task: Ball Panel Removal, TASK 25-53-02-000-801.

E. Lateral Guide Removal (with Removable Pins)

SUBTASK 25-53-23-020-004

- (1) Remove the nut [36] and washer [37] to disconnect the ground strap [35] from the floor structure

SUBTASK 25-53-23-020-005

- (2) Disconnect the electrical connector [38] from the connector elbow.

SUBTASK 25-53-23-020-006

- (3) Do these steps to remove the lateral guide [31]:
- (a) Remove the retainer pins [33] from the removable pins [34].
 - (b) Remove the removable pins [34] and washers [32] from the lateral guide [31] and floor structure attachment points.

SUBTASK 25-53-23-020-007

- (4) Remove the lateral guide [31].

————— END OF TASK —————

TASK 25-53-23-400-801

3. Lateral Guide Installation

(Figure 401)

A. References

<u>Reference</u>	<u>Title</u>
24-22-00-860-805	Supply Electrical Power (P/B 201)
25-53-02-400-801	Ball Panel Installation (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

<u>Reference</u>	<u>Description</u>
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363

EFFECTIVITY
ARO ALL

25-53-23

D633W101-ARO

Page 402
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

C. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

D. Lateral Guide Installation (with Removal Pins)

SUBTASK 25-53-23-820-003

- (1) Put the lateral guide [31] in the correct installation position on the floor structure.

SUBTASK 25-53-23-420-011

- (2) Attach the ground strap [35] to the floor structure with nut [36] and washer [37].

SUBTASK 25-53-23-420-012

- (3) Connect the electrical connector [38].
 - (a) Make sure the connector elbow is in the same position as before you disconnected it.
NOTE: The position of the connector elbow is important to prevent damage to the electrical cable.

SUBTASK 25-53-23-420-013

- (4) Do these steps to install the lateral guide [31]:
 - (a) Install the removable pins [34] through the washers [32], lateral guide [31], and floor structure attachment points.
 - (b) Install the retainer pins [33] on the removable pins [34].

E. Lateral Guide Installation Test

SUBTASK 25-53-23-860-003

NOTE: FOR THE FORWARD CARGO COMPARTMENT

- (1) Remove the safety tag and close this circuit breaker:

FWD Cargo Handling Access Panel, P35

Row	Col	Number	Name
A	9	C25017	LATERAL GUIDES

SUBTASK 25-53-23-860-004

NOTE: FOR THE AFT CARGO COMPARTMENT

- (2) Remove the safety tag and close this circuit breaker:

Cargo Handling Accessory Panel - Aft, P39

Row	Col	Number	Name
A	9	C25116	LATERAL GUIDES

SUBTASK 25-53-23-860-005

- (3) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-53-23-860-006

- (4) At the Master Control Panel (MCP) set the conditions that follow:

EFFECTIVITY
ARO ALL

25-53-23

D633W101-ARO

Page 403
May 05/2015



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

Table 401/25-53-23-993-801

SYSTEM POWER	ON
CONTROL PANEL SELECT	MASTER
PALLETS/CONTAINERS	CONTAINERS
SIDE SELECT	CENTERLINE
BAY SELECT	FWD/AFT

SUBTASK 25-53-23-710-001

- (5) Move the joystick to the FWD position.
 - (a) Make sure the forward lateral guides move down.

SUBTASK 25-53-23-710-002

- (6) Release the joystick.
 - (a) Make sure the forward lateral guides move up.

SUBTASK 25-53-23-710-003

- (7) Move the joystick to the AFT position.
 - (a) Make sure the aft lateral guides move down.

SUBTASK 25-53-23-710-004

- (8) Release the joystick.
 - (a) Make sure the aft lateral guides move up.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-23-410-001

- (1) Do this task: Ball Panel Installation, TASK 25-53-02-400-801.

SUBTASK 25-53-23-080-001

- (2) Remove the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 from the cargo door opening.

————— END OF TASK —————

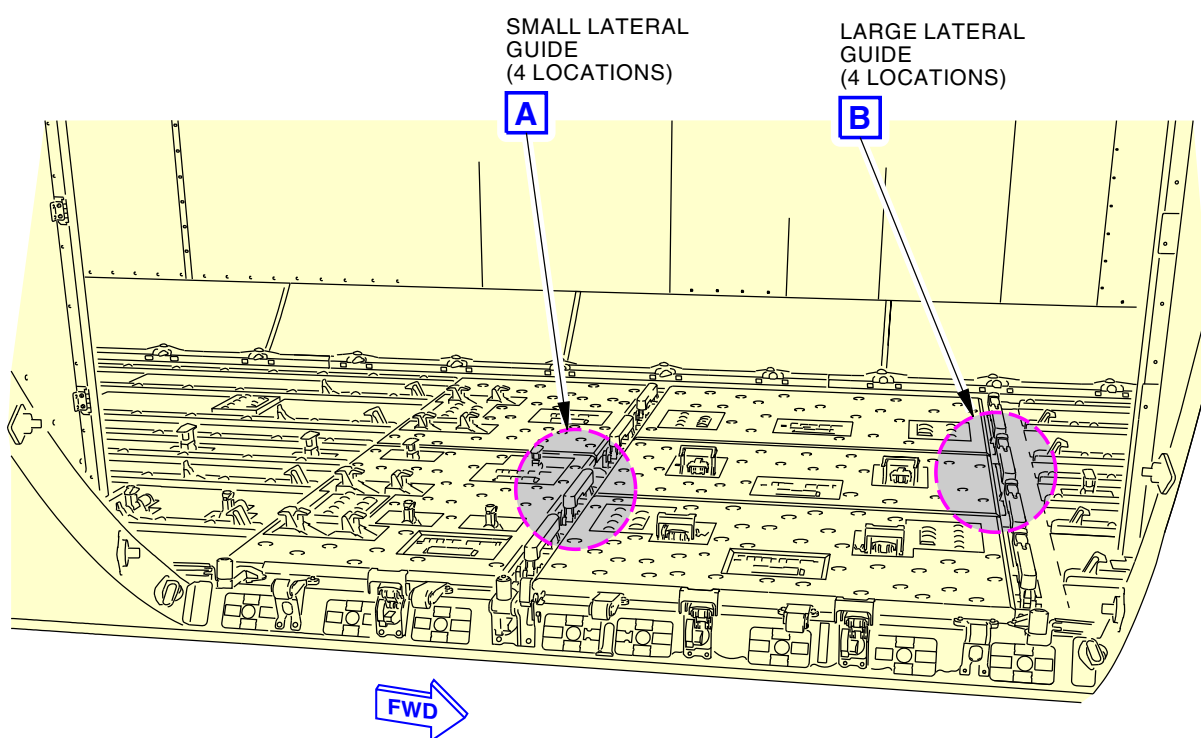
EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-23

Page 404
Sep 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**CARGO COMPARTMENT DOORWAY AREA
(EXAMPLE)**

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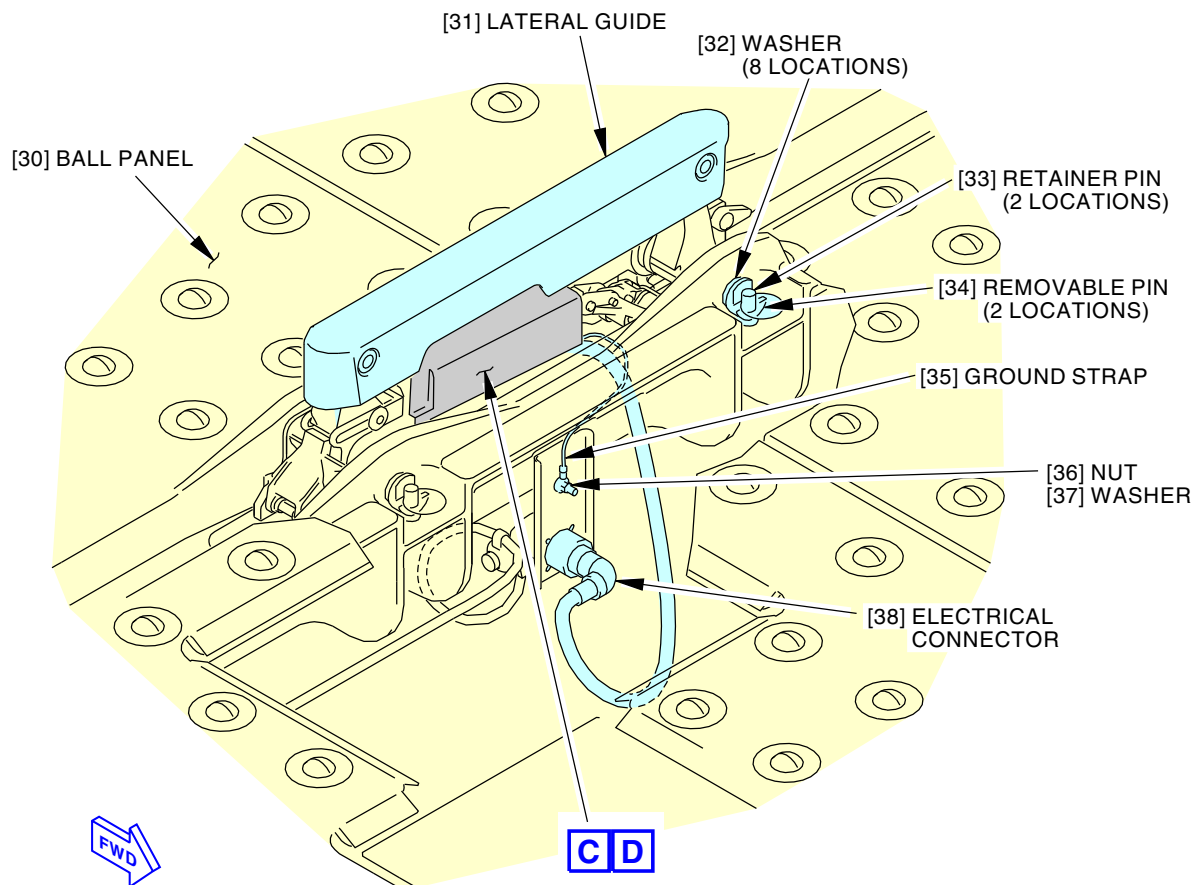
**Lateral Guide Installation (with Removable Pins)
Figure 401/25-53-23-990-802 (Sheet 1 of 4)**

EFFECTIVITY
ARO ALL

25-53-23

D633W101-ARO

Page 405
May 05/2017



**SMALL LATERAL GUIDE
(WITH REMOVABLE PINS)**

A

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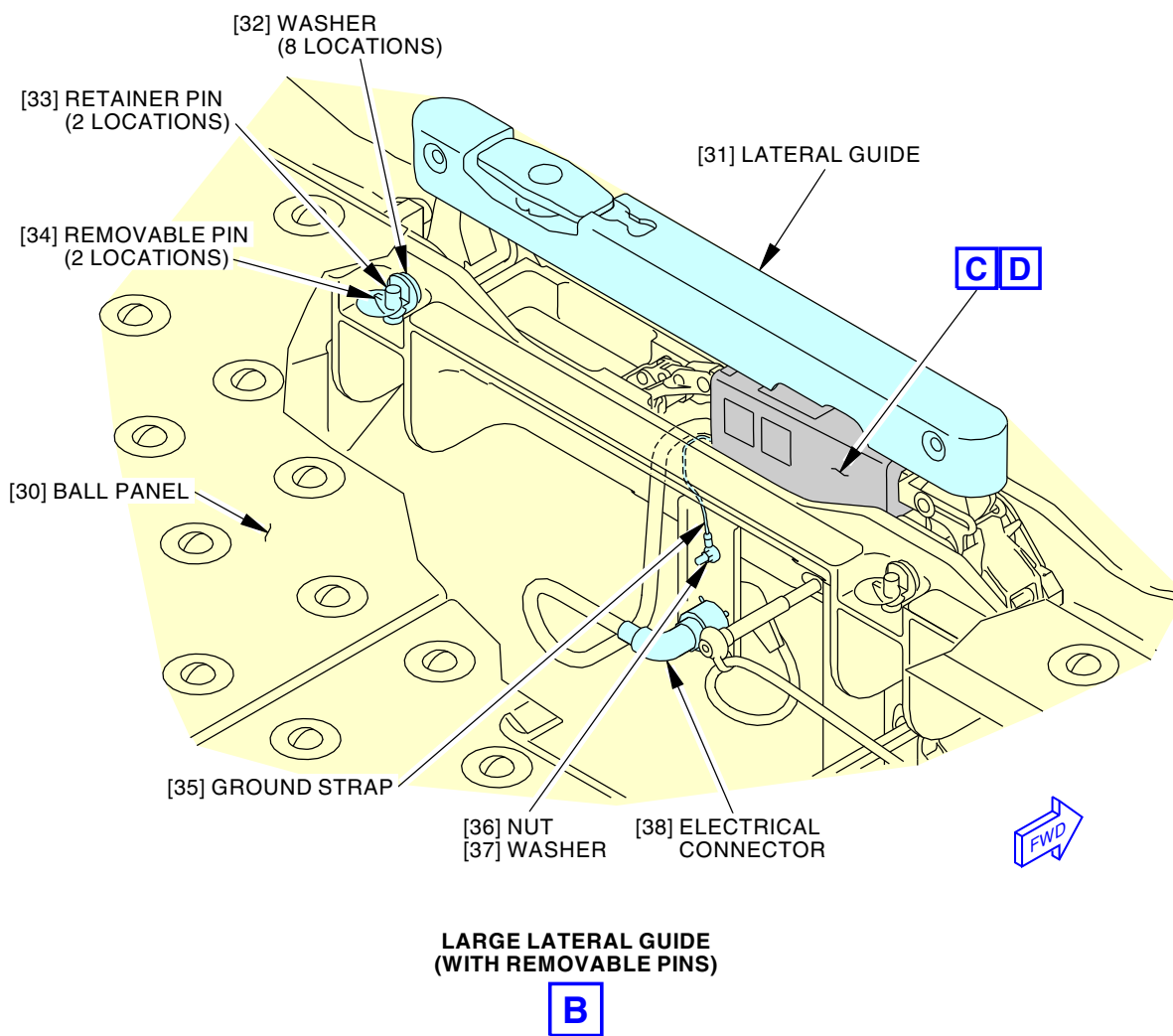
**Lateral Guide Installation (with Removable Pins)
Figure 401/25-53-23-990-802 (Sheet 2 of 4)**

EFFECTIVITY
ARO ALL

25-53-23

D633W101-ARO

Page 406
May 05/2017



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**Lateral Guide Installation (with Removable Pins)
Figure 401/25-53-23-990-802 (Sheet 3 of 4)**

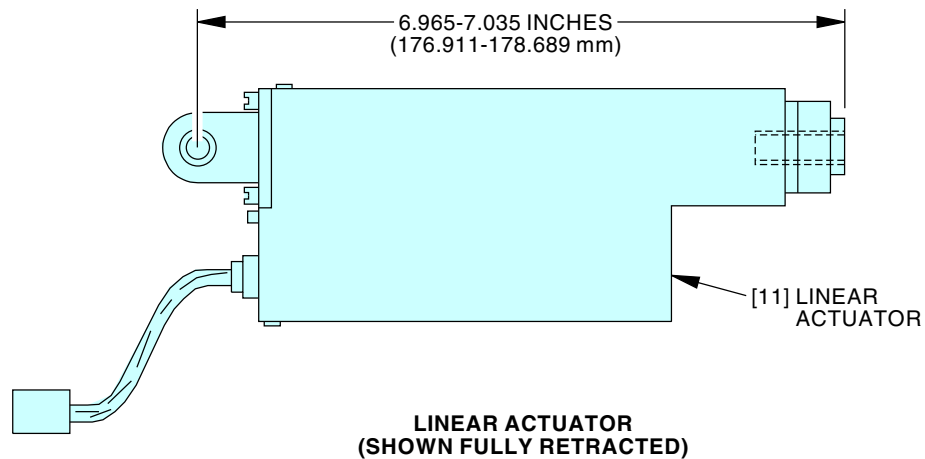
EFFECTIVITY
ARO ALL

D633W101-ARO

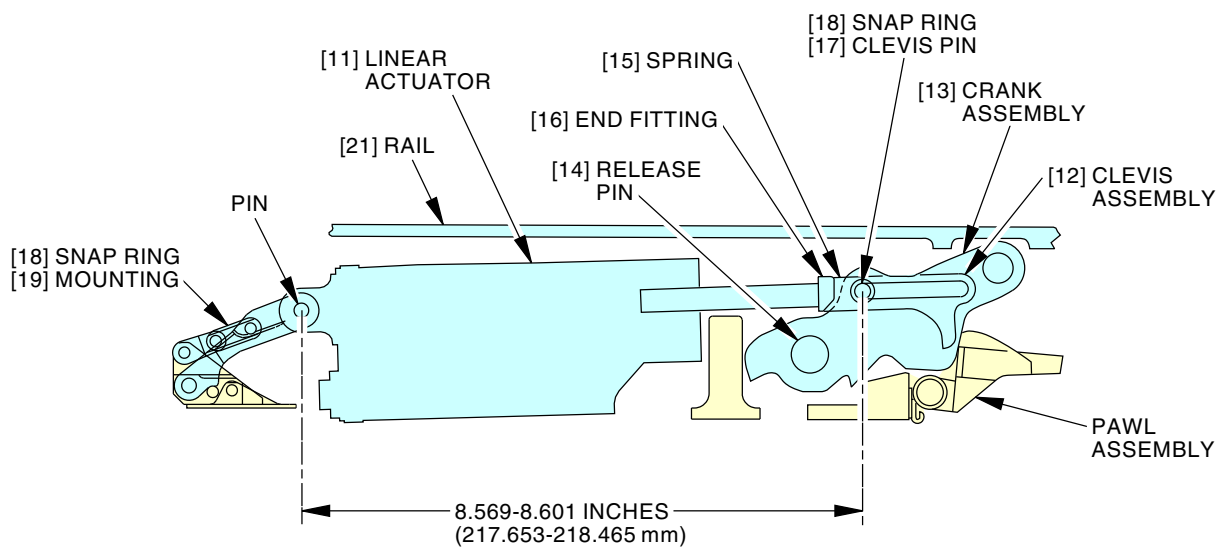
25-53-23

Page 407
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



C



CLEVIS

D

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Lateral Guide Installation (with Removable Pins)
Figure 401/25-53-23-990-802 (Sheet 4 of 4)

EFFECTIVITY
ARO ALL

25-53-23

D633W101-ARO

Page 408
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-53-23-000-802

4. Lateral Guide Actuator Removal

A. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

B. Procedure

SUBTASK 25-53-23-030-001

- (1) Disconnect the electrical connector.

SUBTASK 25-53-23-030-002

- (2) Disconnect the ground wire from the airplane ground stud.

SUBTASK 25-53-23-000-002

- (3) Remove the crank pins.

NOTE: Move the guide rail up out of the way.

SUBTASK 25-53-23-000-003

- (4) Remove the clevis pin [17].

SUBTASK 25-53-23-000-004

- (5) Remove the release pin [14].

NOTE: Make a written record of the pin installation direction.

SUBTASK 25-53-23-000-005

- (6) Remove the attenuator pin [19].

SUBTASK 25-53-23-000-006

- (7) Remove the actuator [11].

SUBTASK 25-53-23-030-003



HOLD THE ACTUATOR RAM WITH A WRENCH WHEN YOU ADJUST THE SLEEVE, THE END FITTING, OR THE LOCKOUT. INTERNAL DAMAGE TO THE ACTUATOR CAN OCCUR IF YOU LET THE ACTUATOR RAM TURN.

- (8) If you will install a new actuator, do the steps that follow:

- (a) Remove the clevis and the adjustable sleeve from the actuator ram.
- (b) Remove the snap ring [18], the mounting pin and the actuator support.

NOTE: Write the position of the spring in relation to the actuator end fitting on a paper. Also, write the position of the actuator support in relation to the actuator on a paper.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-53-23

D633W101-ARO

Page 409
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-53-23-400-802

5. Lateral Guide Actuator Installation

A. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

B. Procedure

SUBTASK 25-53-23-220-001

- (1) Measure the length of the linear actuator in the fully retracted position.

NOTE: If you do not get the dimension and the tolerance shown, replace the linear actuator

SUBTASK 25-53-23-420-004



HOLD THE ACTUATOR RAM WITH A WRENCH WHEN YOU ADJUST THE SLEEVE, THE END FITTING, OR THE LOCKOUT. INTERNAL DAMAGE TO THE ACTUATOR CAN OCCUR IF YOU LET THE ACTUATOR RAM TURN.

- (2) Install the clevis and adjustable sleeve on the actuator [11].

NOTE: Install the actuator [11] in the fully retracted position.

SUBTASK 25-53-23-820-002

- (3) Adjust the clevis to the dimension shown as follows:

NOTE: The dimension is between the centerline of the mounting pin hole in the actuator end fitting and the edge of slot in the clevis.

- (a) Turn the adjustable sleeve to get the correct dimension.

SUBTASK 25-53-23-420-005

- (4) Put the actuator [11] in the lateral guide with the long slot in the clevis [12] to the bottom.

SUBTASK 25-53-23-420-006

- (5) Put the crank assembly [13] in the lateral guide. Do not install the release pin [14].

SUBTASK 25-53-23-420-007

- (6) With the spring [15] in the correct position over the actuator end fitting [16], install the clevis pin [17].

SUBTASK 25-53-23-420-008

- (7) Install the snap ring [18] on the clevis pin [17].

SUBTASK 25-53-23-420-009

- (8) Install the release pin [19].

SUBTASK 25-53-23-420-010

- (9) Install the mounting pin [19] and the snap ring [18].

SUBTASK 25-53-23-220-002

- (10) Make sure the clearance between the clevis pin [17] and the clevis [13] is in the correct tolerance.

SUBTASK 25-53-23-430-001

- (11) Move the guide rail [21] down and install the crank pin [14].

EFFECTIVITY
ARO ALL

25-53-23

D633W101-ARO

Page 410
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-23-430-002

- (12) Connect the ground wire to the airplane ground stud.

SUBTASK 25-53-23-430-003

- (13) Connect the electrical connector.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-23

Page 411
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

CENTER AND AUXILIARY STOP/LOCK - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) the removal of the center stop/lock.
 - (2) the installation of the center stop/lock
 - (a) the installation test for the center stop/locks.
- B. This procedure is applicable to the stop/locks in the forward and aft cargo compartments.

TASK 25-53-24-000-809-003

2. Center Stop/Lock Removal

(Figure 401)

A. **References**

Reference	Title
25-53-02-000-801	Ball Panel Removal (P/B 401)

B. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

C. **Location Zones**

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

D. **Prepare for the Removal**

SUBTASK 25-53-24-480-009-003

 WARNING	INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 across the cargo door opening.

SUBTASK 25-53-24-010-018-003

- (2) Do this task: Ball Panel Removal, TASK 25-53-02-000-801.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-24

Config 3
Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

E. Center Stop/Lock Removal

SUBTASK 25-53-24-020-037-003

- (1) Remove the bolts [1] and washers [2] that attach the center stop/lock [3] to the floor structure or the shear web.

SUBTASK 25-53-24-020-038-003

- (2) Remove the center stop/lock [3].

————— END OF TASK —————

TASK 25-53-24-400-809-003

3. Center Stop/Lock Installation

(Figure 401, Figure 402)

A. References

Reference	Title
25-53-02-400-801	Ball Panel Installation (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
A00723	Sealant - Corrosion Inhibitive, 2-Part - PR-1405-G	

D. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

E. Center Stop/Lock Installation

(Figure 401)

SUBTASK 25-53-24-160-009-003

- (1) Clean the old PR-1405-G sealant, A00723 off of the floor structure or shear web.

SUBTASK 25-53-24-390-017-003

- (2) Apply PR-1405-G sealant, A00723 to the mating surfaces between the center stop/lock [3] and the floor structure or shear web.

SUBTASK 25-53-24-820-009-003

- (3) Align the holes in the center stop/lock [3] with the holes in the floor structure or shear web.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-24

Config 3
Page 402
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-24-390-018-003

- (4) Apply wet PR-1405-G sealant, A00723 to the bolts [1].

SUBTASK 25-53-24-420-025-003



TIGHTEN THE BOLTS SLOWLY AT THE START TO MAKE SURE THEY GO THROUGH THE NUTPLATE STRAIGHT. DAMAGE TO THE NUTPLATES CAN OCCUR IF THE BOLTS ARE NOT INSTALLED STRAIGHT.

- (5) Install the bolts [1] and washers [2] to attach the center stop/lock [3] to the floor structure or shear web.

- (a) Tighten the bolt [1] to 65-100 pound-inch.

F. Center Stop/Lock Installation Test

(Figure 402)

SUBTASK 25-53-24-860-052-003

- (1) Refer to the table that follows for a description of the center stop/lock [3] positions:

Table 401/25-53-24-993-805

CENTER STOP/LOCK POSITION	VERTICAL RESTRAINT [23]	LATERAL RESTRAINT [24]
LOCK	UP	UP
LOAD	DOWN	UP
UNLOAD	DOWN	DOWN

SUBTASK 25-53-24-860-053-003

- (2) Make sure the center stop/lock [3] is in the load position.

SUBTASK 25-53-24-980-011-003

- (3) Do a manual check of the center stop/lock [3].

- (a) Do these steps to check the lateral restraint [24]:

NOTE: As the pallets and the containers pass over a center stop/lock, the lateral restraint [24] will automatically go down and rise up. It is spring-loaded.

- 1) Lift up on the retract lever for the lateral restraint [25].

- a) Make sure the lateral restraint [24] locks in the DOWN position.

NOTE: The latch on top of the lateral restraint [24] will also retract.

- 2) Push down on the lockdown pawl for lateral restraint [21].

- a) Make sure the guide extends.

- (b) Do these steps to check the vertical restraint [23]:

- 1) Hold the vertical restraint [23] while pulling on the upper end of the pawl for the vertical restraint [22].

- a) Make sure the vertical restraint [23] retracts.

- 2) Lift the vertical restraint [23].

- a) Make sure the vertical restraint [23] locks in the vertical position.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-24-410-009-003

- (1) Do this task: Ball Panel Installation, TASK 25-53-02-400-801.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-24

Config 3
Page 403
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-24-080-009-003

- (2) Remove the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 from the cargo door opening..

————— **END OF TASK** —————

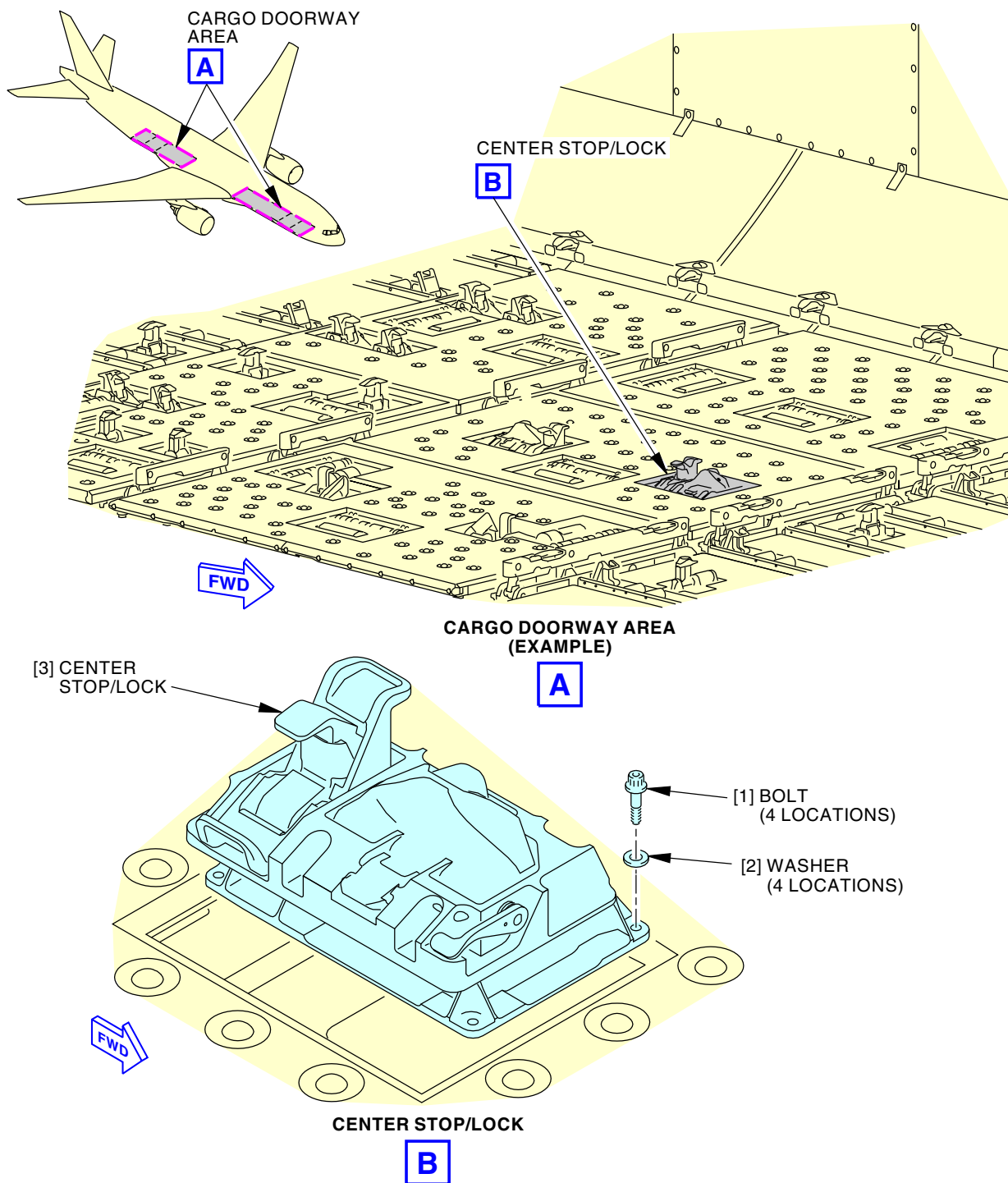
EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-24

Config 3
Page 404
Sep 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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Center Stop/Lock Installation
Figure 401/25-53-24-990-815-003

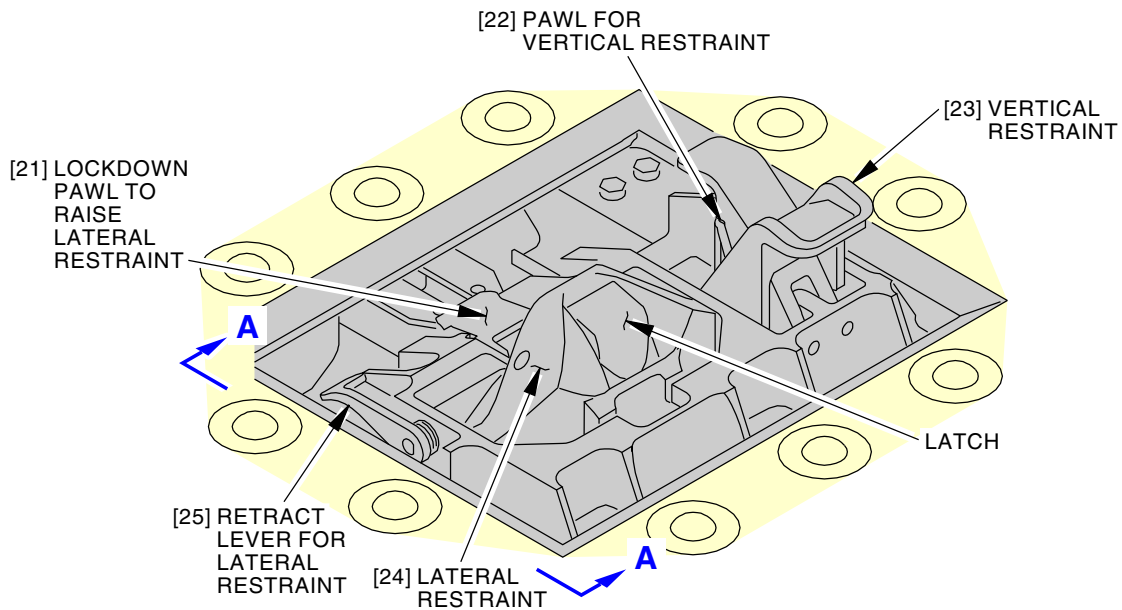
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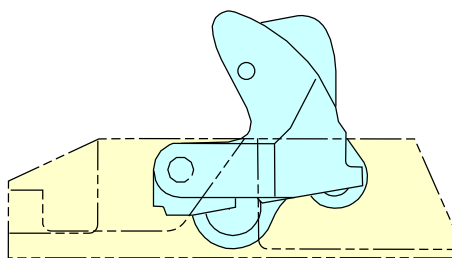
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Config 3
Page 405
May 05/2017

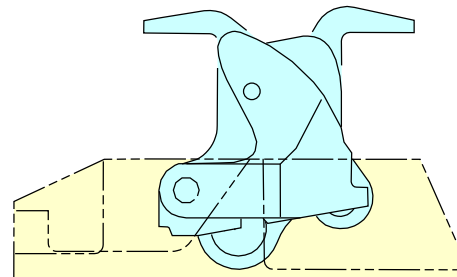
777-200/300
AIRCRAFT MAINTENANCE MANUAL



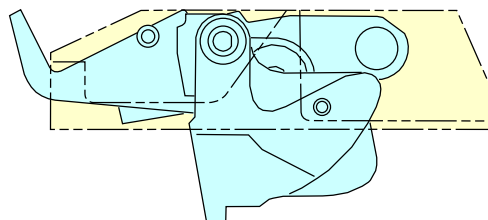
**CENTER STOP/LOCK
(LOCK POSITION)
(EXAMPLE)**



(LOAD POSITION)
A-A



(LOCK POSITION)
A-A



(UNLOAD POSITION)
A-A

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Center Stop/Lock Test
Figure 402/25-53-24-990-816-003

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-24

Config 3
Page 406
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

PARTIAL LOAD STOP - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the partial load stop.
 - (2) An installation of the partial load stop.
- B. These are two types of partial load stops:
- (1) Partial load stops mounted in the roller trays.
 - (2) Partial load stops mounted to the floor structure in the ball panel area.
- C. This procedure is applicable for all partial load stops in the forward and aft cargo compartment.

TASK 25-53-25-000-801

2. Partial Load Stop Removal

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Prepare for the Removal

SUBTASK 25-53-25-480-001

 WARNING	INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 across the cargo door opening.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-25

Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Partial Load Stop Removal

SUBTASK 25-53-25-930-002

- (1) Make a note of the partial load stop [1] [8] direction for the installation task.

NOTE: The partial load stop must be in the direction to stop container movement towards to the doorway area.

SUBTASK 25-53-25-020-004

- (2) FOR THE PARTIAL LOAD STOP THAT IS MOUNTED IN A ROLLER TRAY; remove the applicable bolts [3] [7] [9] [10], washers [4] [5] [11], and nuts [6] that attach the partial load stop [1] [8] to the roller tray [2].

SUBTASK 25-53-25-020-005

- (3) Remove the partial load stop.

————— END OF TASK —————

TASK 25-53-25-400-801

3. Partial Load Stop Installation

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Partial Load Stop Installation

SUBTASK 25-53-25-820-001

- (1) Put the partial load stop [1] [8] in the correct position for the installation.

SUBTASK 25-53-25-420-003

- (2) Install the applicable bolts [3] [7] [9] [10], washers [4] [5] [11], and nuts [6].

D. Partial Load Stop Installation Test

SUBTASK 25-53-25-710-001

- (1) Pull up on the stop head to put the partial load stop in the vertical position.
 - (a) Make sure the partial load stop fully engages in the vertical position.

EFFECTIVITY
ARO ALL

25-53-25

D633W101-ARO

Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-25-710-002

- (2) Continue to push the stop head past the vertical position until all parts of the partial load stop are below the conveyor plane.

NOTE: The conveyor plane is the top of the roller in the roller tray or the top of the balls in the ball panel.

SUBTASK 25-53-25-710-003

- (3) Release the stop head.
 - (a) Make sure the stop head goes back to the vertical position.

SUBTASK 25-53-25-710-004

- (4) Pull up on the pawl to retract the partial load stop.
 - (a) Make sure the partial load stop retracts below the conveyor plane.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-25-080-001

- (1) Remove the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 from the cargo door opening.

————— END OF TASK —————

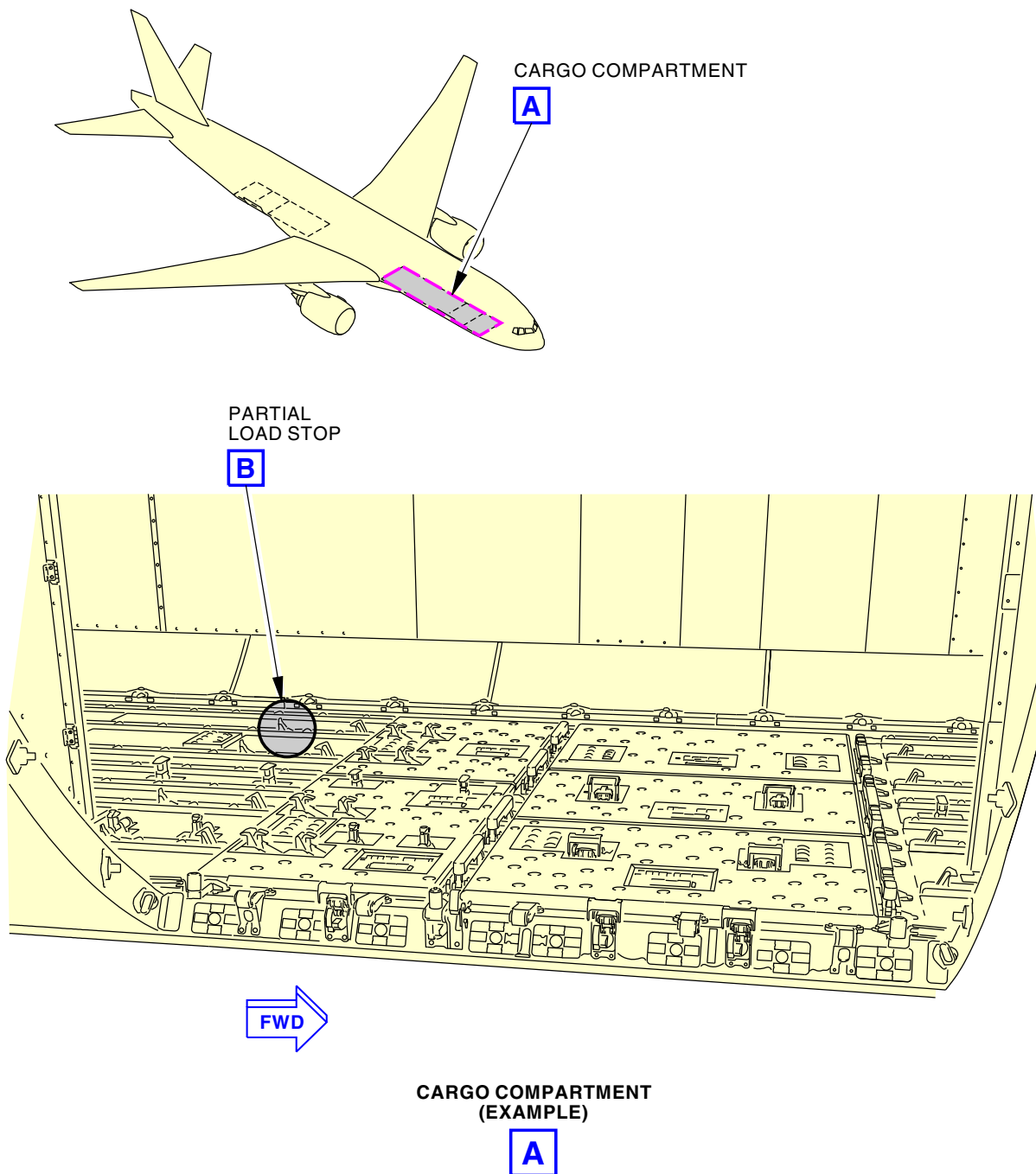
EFFECTIVITY
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D633W101-ARO

25-53-25

Page 403
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



E73523 S0006411182_V2

**Partial Load Stop Installation
Figure 401/25-53-25-990-801 (Sheet 1 of 2)**

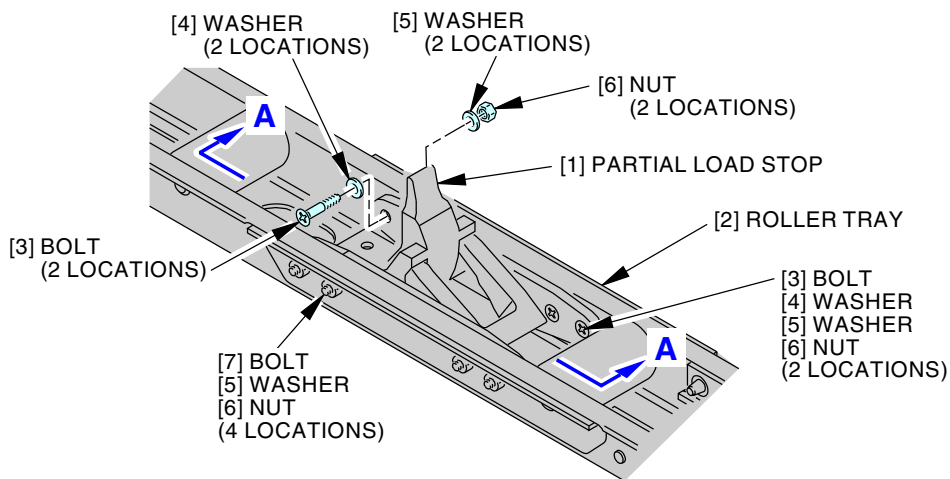
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25-53-25

D633W101-ARO

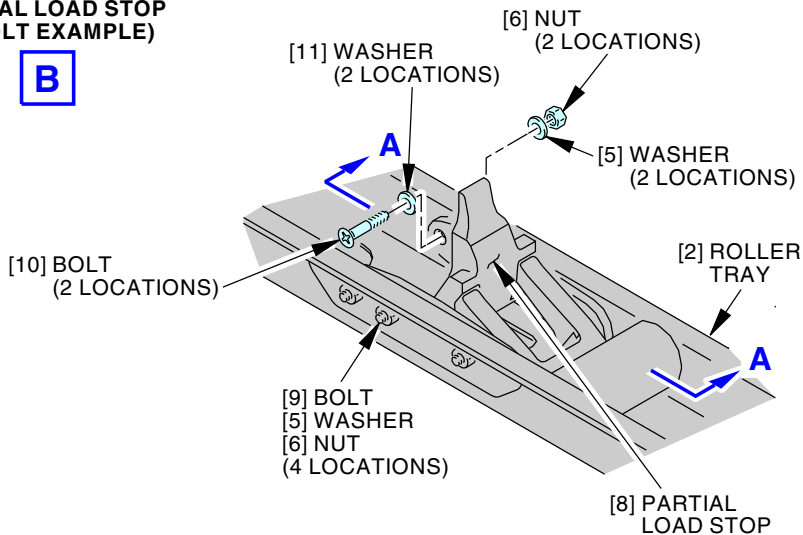
Page 404
May 05/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL



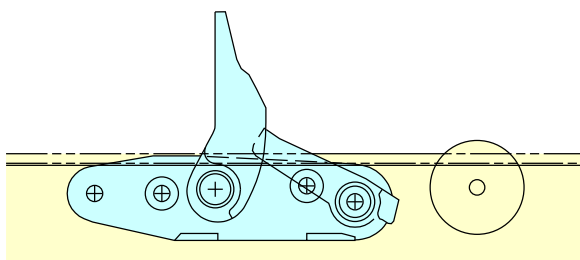
**PARTIAL LOAD STOP
(8 BOLT EXAMPLE)**

B



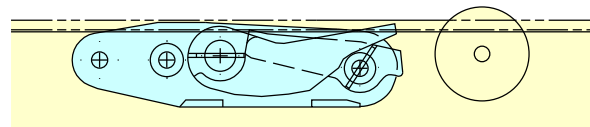
**PARTIAL LOAD STOP
(6 BOLT EXAMPLE)**

B



VERTICAL POSITION

A-A



RETRACTED POSITION

A-A

C59826 S0006411183_V2

**Partial Load Stop Installation
Figure 401/25-53-25-990-801 (Sheet 2 of 2)**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-25

Page 405
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
PALLET LOCK - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) A removal of the pallet lock.
 - (2) An installation of the pallet lock.
- B. These are the different types of pallet locks:
 - (1) roller tray mounted
 - (2) structure mounted.
- C. This procedure is applicable for each of the pallet locks.

TASK 25-53-26-000-801

2. Pallet Lock Removal

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Prepare for the Removal

SUBTASK 25-53-26-480-001



WARNING

INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 across the cargo door opening.

D. Pallet Lock Removal

SUBTASK 25-53-26-930-001

- (1) Make a note of the pallet lock direction for the installation task.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-26

Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-26-020-001

(2) FOR THE PALLET LOCK S THAT ARE MOUNTED IN A ROLLER TRAY; do these steps:

(a)

FOR THE SINGLE PALLET LOCKS; remove the bolts [3], washers [4] and nuts [5] that attach the pallet lock [1] to the roller tray [2].

(b)

FOR THE DOUBLE PALLET LOCKS; remove the bolts [10], washers [11], and nuts [13] that attach the pallet lock [8] to the roller tray [2].

(c) Remove the pallet lock.

SUBTASK 25-53-26-020-003

(3) FOR THE PALLET LOCK S THAT ARE STRUCTURE MOUNTED; do these steps:

(a) Remove the bolts [14], and washers [15] that attach the double pallet lock [16] or the single pallet lock [17] to the floor structure.

(b) Remove the pallet lock.

————— END OF TASK —————

TASK 25-53-26-400-801

3. Pallet Lock Installation

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A00723	Sealant - Corrosion Inhibitive, 2-Part - PR-1405-G	

C. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-26

Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Pallet Lock Installation

SUBTASK 25-53-26-140-001

- (1) FOR THE PALLET LOCK S THAT ARE STRUCTURE MOUNTED; do these steps:
 - (a) Clean the old PR-1405-G sealant, A00723 off of the floor structure.
 - (b) Apply PR-1405-G sealant, A00723 to the mating surfaces between the single pallet lock [16] or double pallet lock [17] and the floor structure.
 - (c) Put the single pallet lock [16] or double pallet lock [17] on the floor structure.
NOTE: Make sure that the pallet lock is positioned in the correct direction.
 - (d) Apply sealant, A00247 or PR-1405-G sealant, A00723 below the heads of the bolts [14].
 - (e) Install the bolts [14] and washers [15].

SUBTASK 25-53-26-420-001

- (2) FOR THE PALLET LOCK S THAT ARE MOUNTED IN A ROLLER TRAY ; do these steps:
 - (a)
FOR THE SINGLE PALLET LOCKS; do these steps to install a single pallet lock:
 - 1) Put the single pallet lock [1] in the roller tray [2].
NOTE: Make sure the pallet lock is positioned in the correct direction.
 - 2) Install the bolts [3], washers [4], and nuts [5].
NOTE: Use the correct bolt installation at each location. The specific bolt, washer and nut can be different at each location.
 - (b)
FOR THE DOUBLE PALLET LOCKS; do these steps to install a double pallet lock.
 - 1) Put the double pallet lock [8] in the roller tray [2].
NOTE: Make sure the pallet lock is positioned in the correct direction.
 - 2) Install the bolts [10], washers [11], and nuts [13].
NOTE: Use the correct bolts at each location. The specific bolt, washer and nut can be different at each location. The correct bolts must be used.
 - 3) Do a check of the rollers [6] next to the double pallet lock [8].
 - a) Make sure the head of the bolt [10] does not touch the roller [6].
 - b) Rotate the bolt [10] as necessary to make a clearance between the bolt head and the roller [6].
 - c) Do a check of the roller [6] to make sure the roller turns freely.

E. Pallet Lock Installation Test

SUBTASK 25-53-26-280-001

- (1) Put the applicable pallet lock in the vertical position.
 - (a) Make sure the pallet lock fully engages in the vertical position.
NOTE: You can hear a click when it engages in the vertical position.

SUBTASK 25-53-26-210-001

- (2) Retract the pallet lock.
 - (a) Make sure the lockhead retracts below the conveyor plane.
NOTE: The conveyor plane is the top of the roller in the roller tray or the top of a ball in the Ball panels.

EFFECTIVITY
ARO ALL

25-53-26

D633W101-ARO

Page 403
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-26-080-001

- (1) Remove the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 from the cargo door opening.

————— **END OF TASK** —————

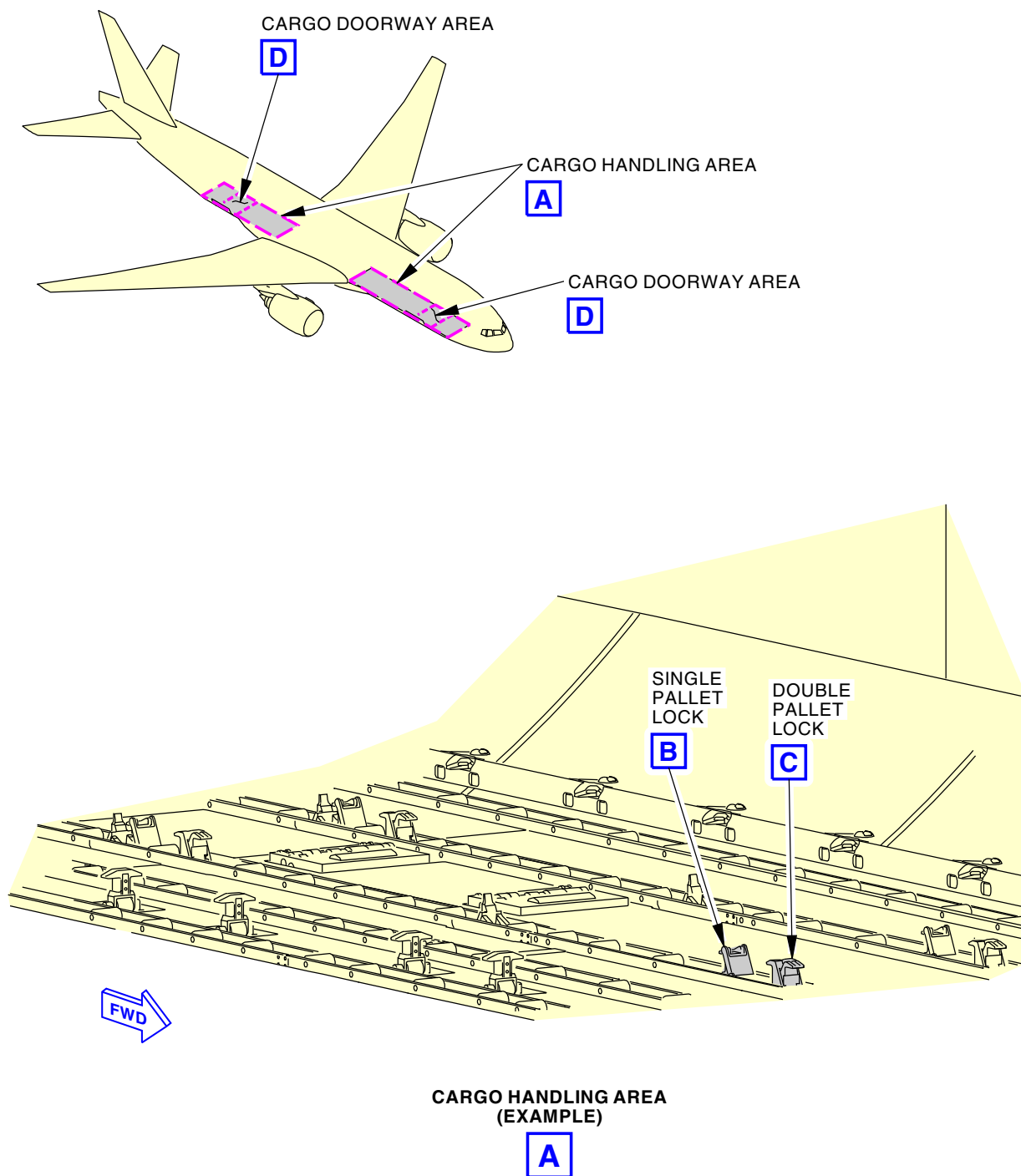
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D633W101-ARO

25-53-26

Page 404
Sep 05/2015

777-200/300
AIRCRAFT MAINTENANCE MANUAL



C63888 S0006411189_V2

Pallet Lock Installation
Figure 401/25-53-26-990-801 (Sheet 1 of 4)

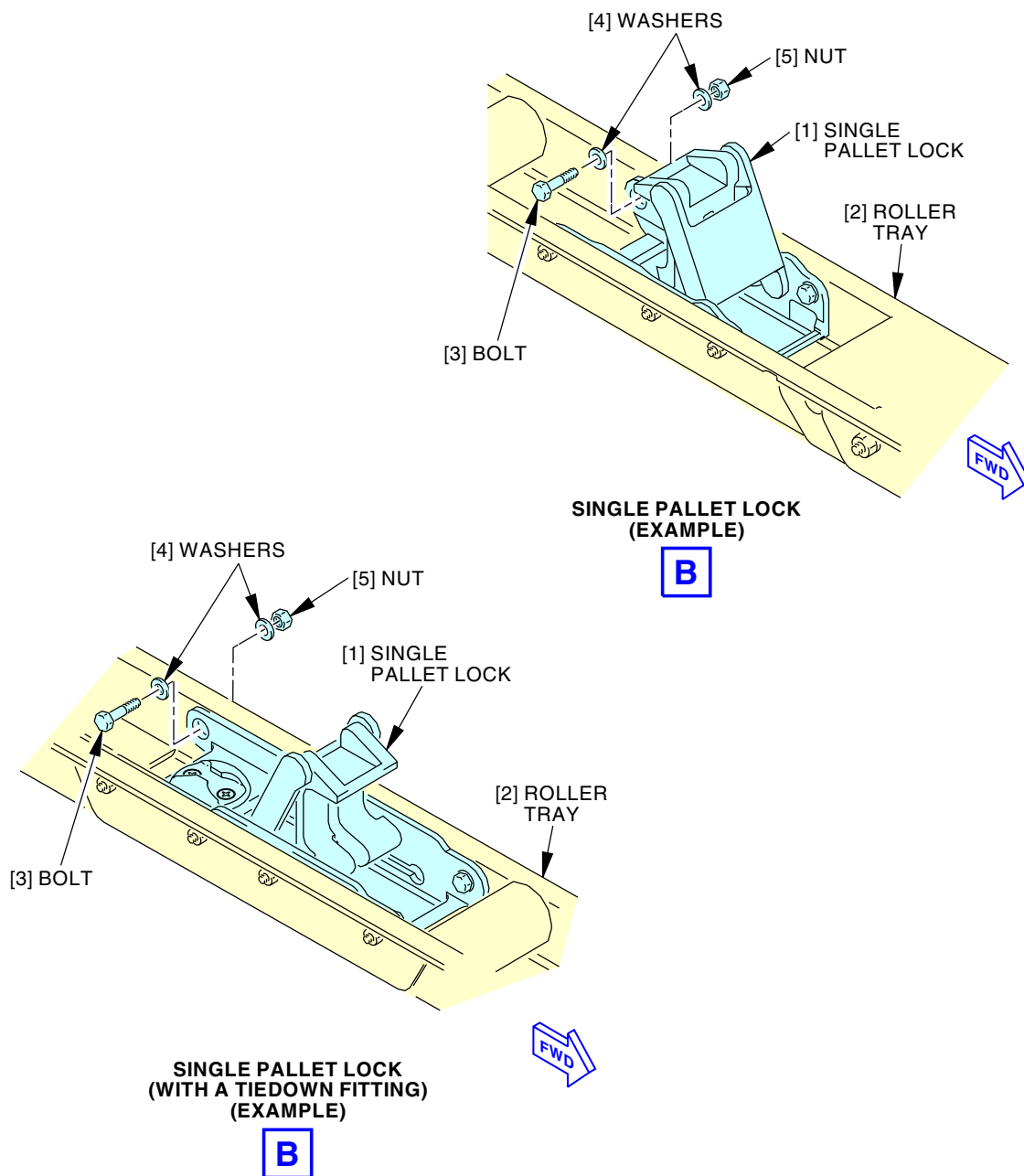
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ARO ALL

25-53-26

D633W101-ARO

Page 405
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



N28448 S0006411190_V2

**Pallet Lock Installation
Figure 401/25-53-26-990-801 (Sheet 2 of 4)**

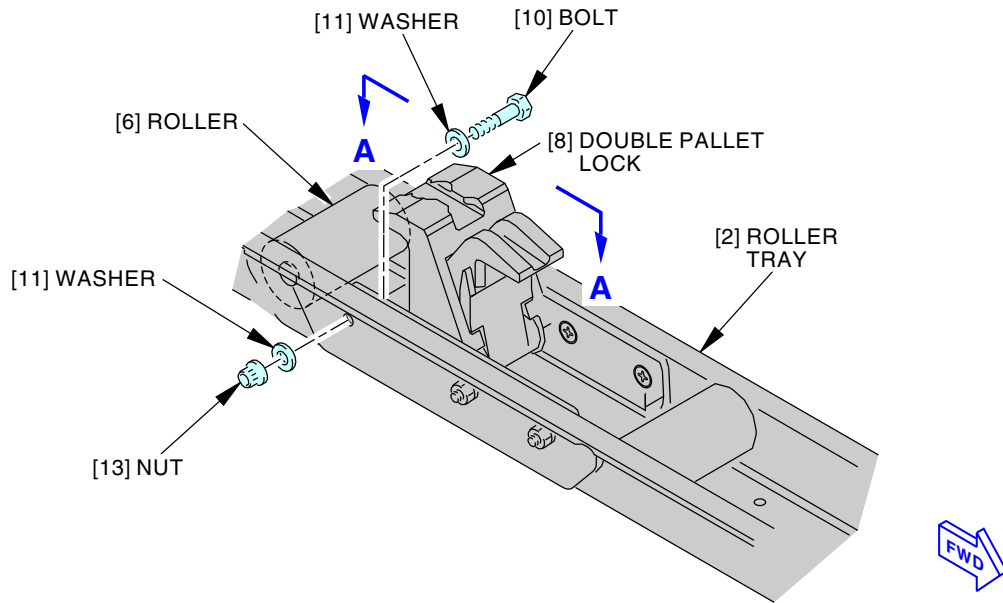
EFFECTIVITY
ARO ALL

25-53-26

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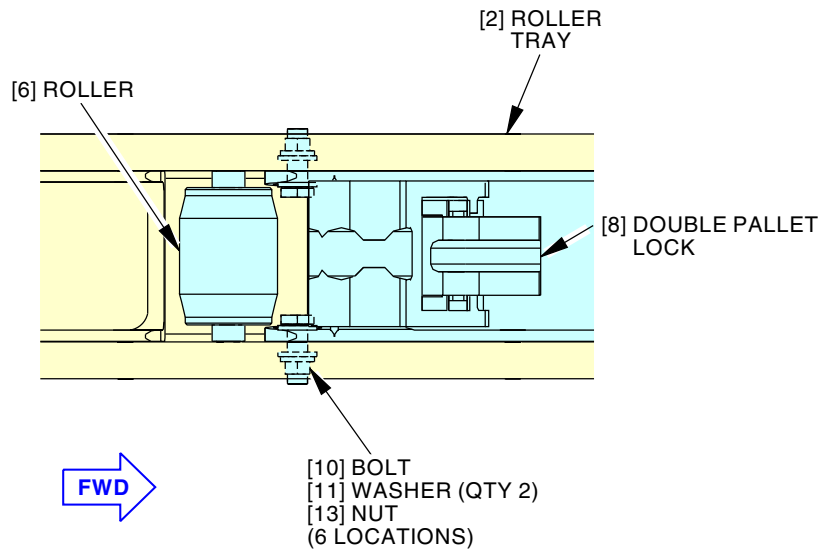
Page 406
May 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



**DOUBLE PALLET LOCK
(EXAMPLE)**

C



A-A

N28477 S0006411191_V2

**Pallet Lock Installation
Figure 401/25-53-26-990-801 (Sheet 3 of 4)**

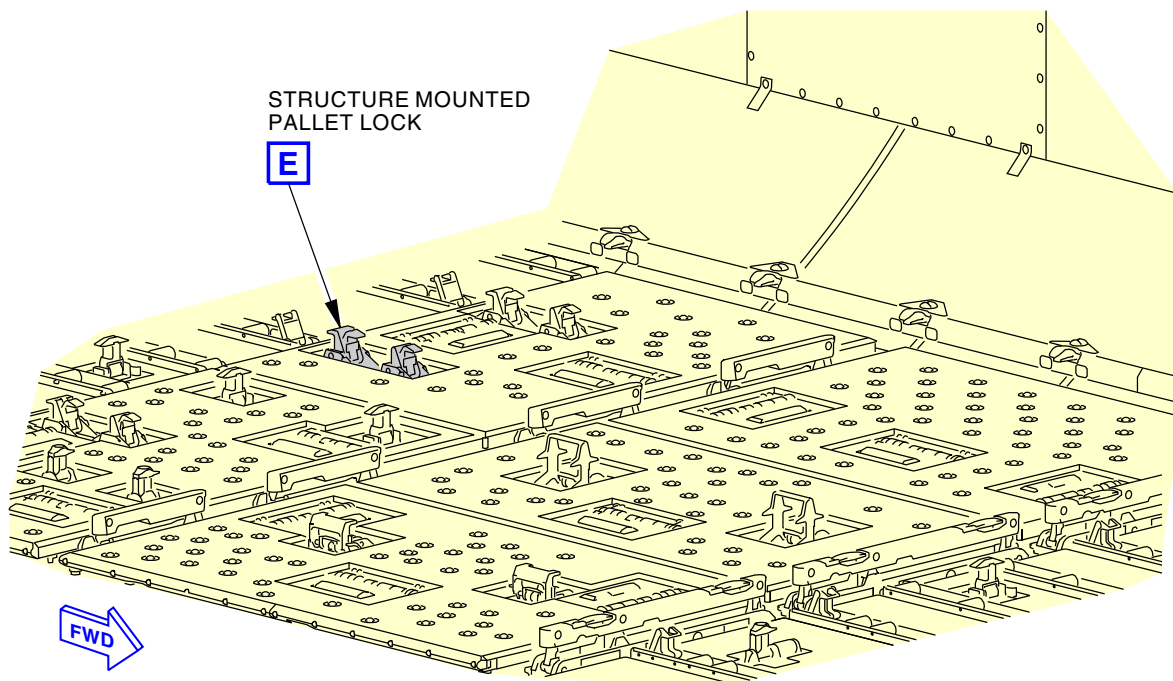
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D633W101-ARO

25-53-26

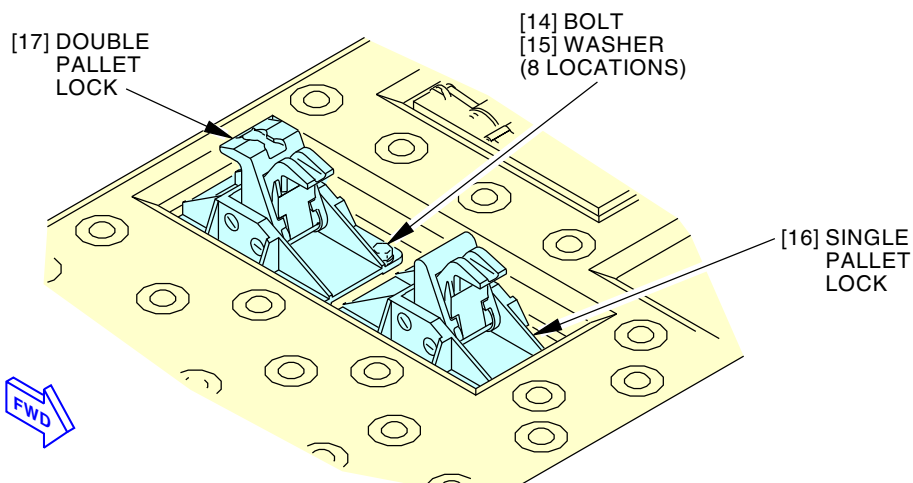
Page 407
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



**CARGO DOORWAY AREA
(EXAMPLE)**

D



**STRUCTURE MOUNTED
PALLET LOCK**

E

M99498 S0006411192_V2

Pallet Lock Installation
Figure 401/25-53-26-990-801 (Sheet 4 of 4)

EFFECTIVITY
ARO ALL

25-53-26

D633W101-ARO

Page 408
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

STOP/LOCK - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of a stop/lock.
 - (2) An installation of a stop/lock.

TASK 25-53-27-000-801

2. Stop/Lock Removal

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Prepare for the Removal

SUBTASK 25-53-27-480-001



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 across the cargo door opening.

D. Stop/Lock Removal

SUBTASK 25-53-27-020-003

- (1) Remove the bolts [4] [7], washers [2] [8], and nuts [3] [9] that attach the stop/lock [1] to the roller tray [6].

SUBTASK 25-53-27-020-004

- (2) Remove the stop/lock.

———— **END OF TASK** ————

EFFECTIVITY
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25-53-27

D633W101-ARO

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Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-53-27-400-801

3. Stop/Lock Installation

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

B. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right

C. Stop/Lock Installation

SUBTASK 25-53-27-820-002

- (1) Put the stop/lock [1] in the correct position in the roller tray [6].

SUBTASK 25-53-27-420-002

- (2) Install the bolts [4] [7], washers [2] [8], and nuts [3] [9].

D. Stop/Lock Installation Test

SUBTASK 25-53-27-710-001

- (1) Do these steps to make sure the stop [10] extends and retracts:
 - (a) Pull up on the stop [10] to put it in the vertical position.
 - 1) Push the stop [10] in the direction of the cargo door to make sure the stop [10] will not retract.
 - (b) Pull up on the pawl to retract the stop [10].
 - 1) Make sure the stop [10] retracts below the conveyor plane.

NOTE: The conveyor plane is the top of the rollers in the roller trays or the top of the balls in the ball panels.

SUBTASK 25-53-27-710-002

- (2) Do these steps to make sure the vertical restraint [5] extends and retracts:
 - (a) Pull up on the vertical restraint [5].
 - 1) Make sure the vertical restraint [5] locks in the vertical position with a click sound.
 - (b) Retract the vertical restraint [5].
 - 1) Make sure the vertical restraint [5] retracts below the conveyor plane.

EFFECTIVITY
ARO ALL

25-53-27

D633W101-ARO

Page 402
May 05/2015



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-27-080-001

- (1) Remove the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006 from the cargo door opening.

———— **END OF TASK** ————

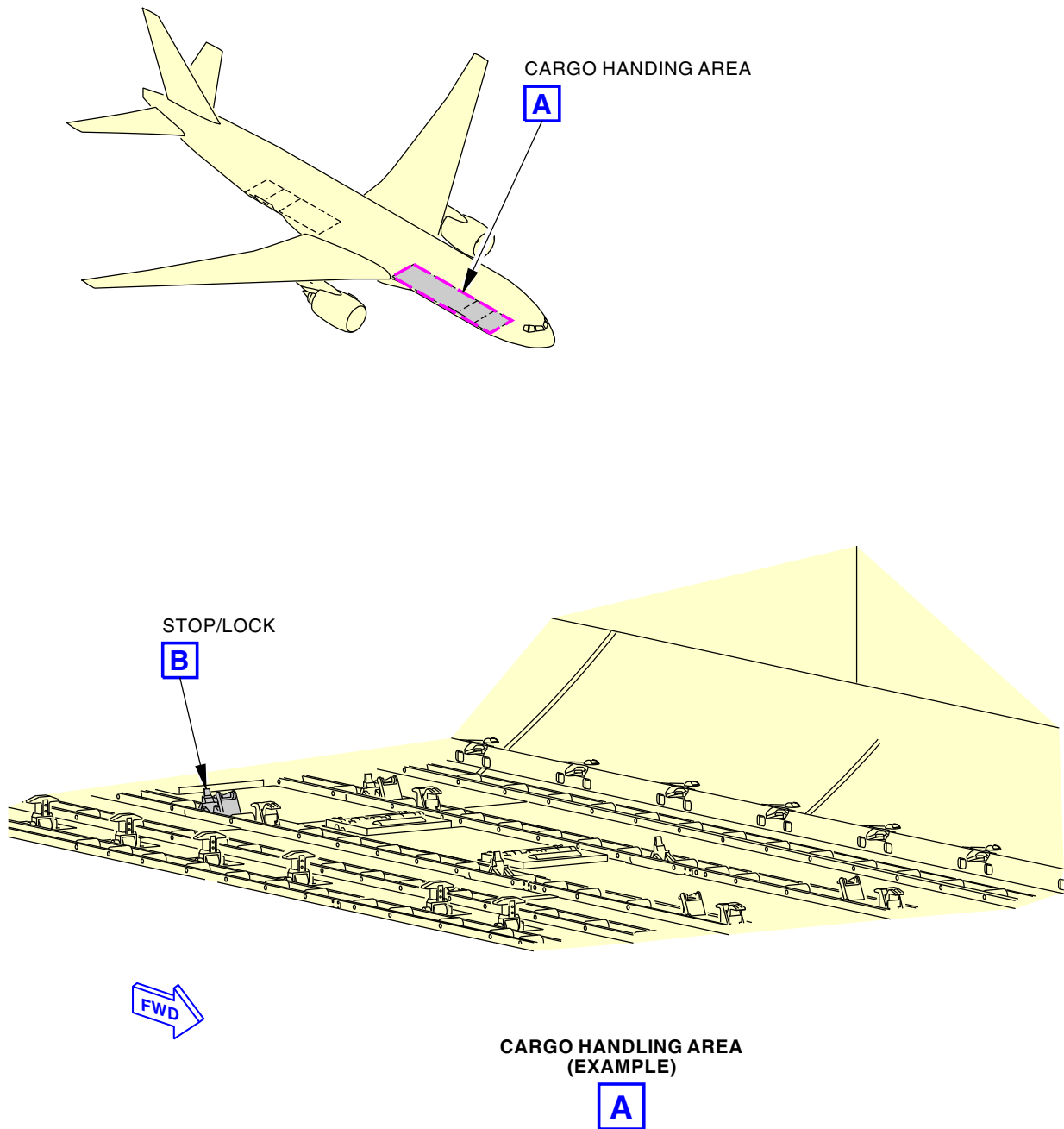
EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-27

Page 403
Sep 05/2015

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



E71332 S0006411198_V2

Stop/Lock Installation
Figure 401/25-53-27-990-801 (Sheet 1 of 2)

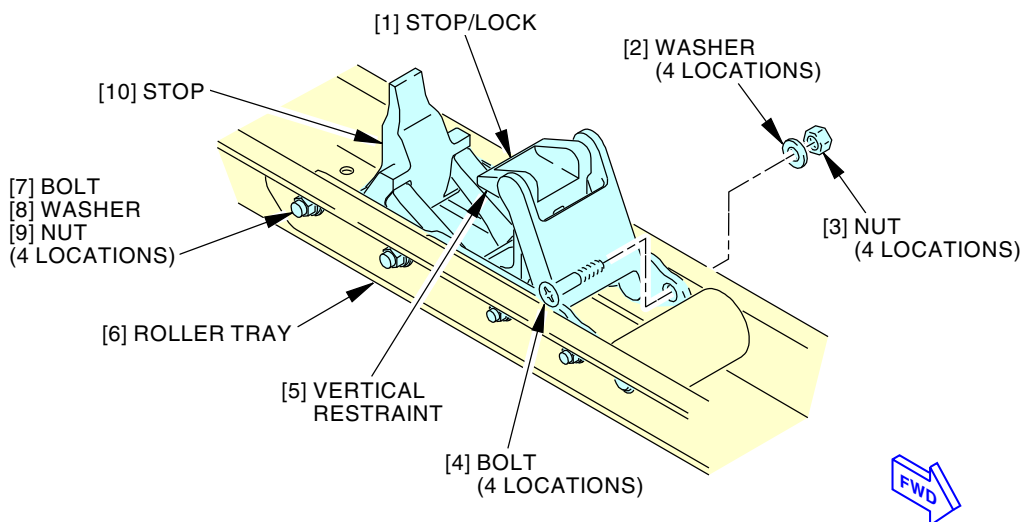
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D633W101-ARO

25-53-27

Page 404
May 05/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL



**STOP/LOCK
(FORWARD COMPARTMENT ONLY)**

B

C64442 S0006411199_V2

Stop/Lock Installation
Figure 401/25-53-27-990-801 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-27

Page 405
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

CARGO HANDLING CONTROL PANEL - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the cargo handling control panel.
 - (2) An installation of the cargo handling control panel.
- B. This procedure is applicable to the forward (P24) and aft (P27) cargo handling control panel.

TASK 25-53-31-000-801

2. Cargo Handling Control Panel Removal

(Figure 401)

A. **Location Zones**

Zone	Area
122	Forward Cargo Compartment, Right
152	Aft Cargo Compartment, Right

B. **Access Panels**

Number	Name/Location
122BR	Forward Cargo Handling Control Door
152BR	Aft Cargo Handling Control Door

C. **Prepare for the Removal**

SUBTASK 25-53-31-860-001

NOTE: FOR THE FORWARD CARGO COMPARTMENT

- (1) Open these circuit breakers and install safety tags:

FWD Cargo Handling Access Panel, P35

Row	Col	Number	Name
A	10	C25028	CSC DC-LEFT
A	11	C25029	CSC DC-RIGHT

SUBTASK 25-53-31-860-002

NOTE: FOR THE AFT CARGO COMPARTMENT

- (2) Open these circuit breakers and install safety tags:

Cargo Handling Accessory Panel - Aft, P39

Row	Col	Number	Name
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT

SUBTASK 25-53-31-010-001

- (3) Open these access panels:

Number	Name/Location
122BR	Forward Cargo Handling Control Door
152BR	Aft Cargo Handling Control Door

D. **Cargo Handling Control Panel Removal**

SUBTASK 25-53-31-020-001

- (1) Remove the screws [5] and washers [4] that attach the cargo handling control panel [3] to the pan.

EFFECTIVITY
ARO ALL

25-53-31

D633W101-ARO

Page 401
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-31-020-002

- (2) Lift the cargo handling control panel [3] outboard to get access to the electrical connector [1].

SUBTASK 25-53-31-020-003

- (3) Disconnect the electrical connector [1].

SUBTASK 25-53-31-020-004

- (4) Remove the cargo handling control panel.

————— END OF TASK —————

TASK 25-53-31-400-801

3. Cargo Handling Control Panel Installation

A. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C00064	Coating - Aluminum Chemical Conversion	BAC5719 Type II Class A (MIL-DTL-5541 Class 1A)

B. Location Zones

Zone	Area
122	Forward Cargo Compartment, Right
152	Aft Cargo Compartment, Right

C. Access Panels

Number	Name/Location
122BR	Forward Cargo Handling Control Door
152BR	Aft Cargo Handling Control Door

D. Cargo Handling Control Panel Installation

SUBTASK 25-53-31-110-001

- (1) Clean the pan and the cargo handling control panel [3] of all unwanted material.

SUBTASK 25-53-31-390-001

- (2) Apply the coating, C00064, to the mating surfaces between the washers [4] and the cargo handling control panel [3].

SUBTASK 25-53-31-420-001

- (3) Connect the electrical connector [1] to the cargo handling control panel [3].

SUBTASK 25-53-31-820-001

- (4) Put the cargo handling control panel [3] in the opening.

SUBTASK 25-53-31-820-002

- (5) Install the screws [5] and washers [4] attach the cargo handling control panel to the pan.

SUBTASK 25-53-31-420-002

- (6) Tighten the screws [5] and washers [4].

SUBTASK 25-53-31-390-002

- (7) Make a fay surface seal between the screws [5] and washers [4] with sealant, A00247.

EFFECTIVITY
ARO ALL

25-53-31

D633W101-ARO

Page 402
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

E. Cargo Handling Control Panel Installation Test

SUBTASK 25-53-31-860-007

- (1) Put the switches on the cargo control panel in these positions:

Table 401/25-53-31-993-801

Switch Nomenclature	Position
System Power	OFF
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD
Pallet/Containers (If Applicable)	CONTAINERS

SUBTASK 25-53-31-860-003

NOTE: FOR THE FORWARD CARGO COMPARTMENT

- (2) Remove the safety tags and close these circuit breakers:

FWD Cargo Handling Access Panel, P35

Row	Col	Number	Name
A	10	C25028	CSC DC-LEFT
A	11	C25029	CSC DC-RIGHT

SUBTASK 25-53-31-860-004

NOTE: FOR THE AFT CARGO COMPARTMENT

- (3) Remove the safety tags and close these circuit breakers:

Cargo Handling Accessory Panel - Aft, P39

Row	Col	Number	Name
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT

SUBTASK 25-53-31-710-001

- (4) Do the steps that follow to test the cargo control panel:
- Make sure the POWER ON light and the BAY ON lights are off.
 - Set the SYSTEM POWER switch to ON.
 - Make sure the POWER ON light and the BAY ON lights come on.
 - Make sure the rollout stop/locks and the retractable guide roller/lock move to or remain in the lock position.
 - Hold the joystick to OUT.
 - Make sure the rollout stop/locks move to the unload position.
 - Make sure the center stop/locks move to the unload position.
 - Release the joystick.
 - Hold the joystick to AFT.
 - Make sure the forward lateral guides move down.
 - Release the joystick.
 - Make sure the forward lateral guides move up.
 - Set the FWD/AFT switch to AFT.
 - Hold the joystick to FWD.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-31

Page 403
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 1) Make sure the aft lateral guides move down.
- (i) Release the joystick.
 - 1) Make sure the aft lateral guides move up.
- (j) Set the LEFT/BOTH/RIGHT switch to RIGHT.
- (k) Hold the joystick to FWD.
 - 1) Make sure the aft right lateral guides move down.
- (l) Release the joystick.
 - 1) Make sure the aft right lateral guides move up.
- (m) Set the LEFT/BOTH/RIGHT switch to LEFT.
- (n) Hold the joystick to FWD.
 - 1) Make sure the aft left lateral guides move down.
- (o) Release the joystick.
 - 1) Make sure the aft left lateral guides move up.
- (p) In the forward cargo compartment do these steps:
 - 1) Push and release the BAY L OFF switch.
 - a) Make sure the BAY L ON light goes off.
 - 2) Push and release the BAY K OFF switch.
 - a) Make sure the BAY K ON light goes off.
 - 3) Push and release the BAY J OFF switch.
 - a) Make sure the BAY J ON light goes off.
 - 4) Push and release the BAY I OFF switch.
 - a) Make sure the BAY I ON light goes off.
 - 5) Push and release the BAY H OFF switch.
 - a) Make sure the BAY H ON light goes off.
 - 6) Push and release the BAY G OFF switch.
 - a) Make sure the BAY G ON light goes off.
 - 7) Push and release the BAY F OFF switch.
 - a) Make sure the BAY F ON light goes off.
 - 8) Push and release the BAY E OFF switch.
 - a) Make sure the BAY E ON light goes off.
 - 9) Push and release the BAY D OFF switch.
 - a) Make sure the BAY D ON light goes off.
- (q) For the aft cargo compartment, do these steps:
 - 1) Push and release the BAY J OFF switch.
 - a) Make sure the BAY J ON light goes off.
 - 2) Push and release the BAY F OFF switch.
 - a) Make sure the BAY F ON light goes off.
 - 3) Push and release the BAY E OFF switch.
 - a) Make sure the BAY E ON light goes off.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-31

Page 404
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- 4) Push and release the BAY D OFF switch.
 - a) Make sure the BAY D ON light goes off.
- 5) Push and release the BAY A OFF switch.
 - a) Make sure the BAY A ON light goes off.
- 6) Push and release the BAY B OFF switch.
 - a) Make sure the BAY B ON light goes off.
- 7) Push and release the BAY C OFF switch.
 - a) Make sure the BAY C ON light goes off.
- (r) For cargo control panels with the pallet/container switch, do these steps:
 - 1) Set the PALLET/CONTAINER switch to PALLET.
 - a) Make sure the aft lateral guides move down.
 - 2) Set the PALLET/CONTAINER switch to CONTAINER.
 - a) Make sure the aft lateral guides move up.
- (s) Set the SYSTEM POWER switch to OFF.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-31-410-001

- (1) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
122BR	Forward Cargo Handling Control Door
152BR	Aft Cargo Handling Control Door

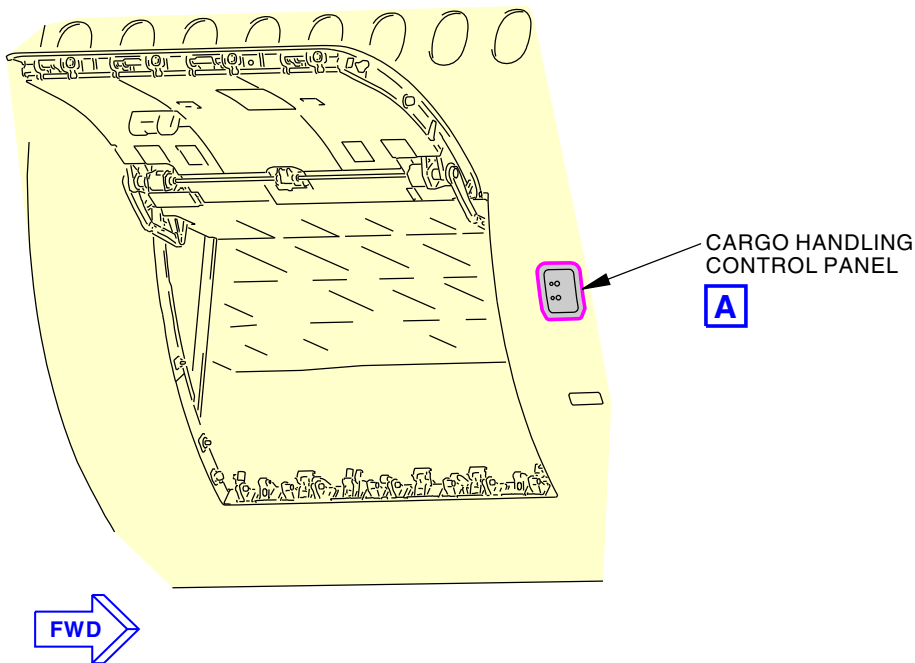
———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

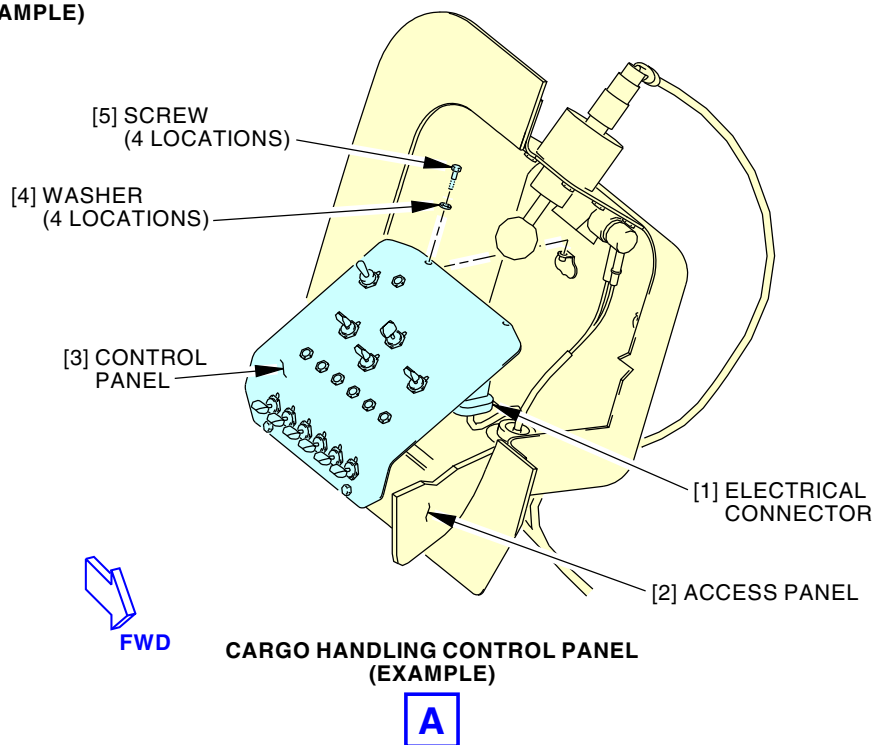
D633W101-ARO

25-53-31

Page 405
Jan 05/2015



**CARGO DOOR
(EXAMPLE)**



**CARGO HANDLING CONTROL PANEL
(EXAMPLE)**

C66673 S0006411212_V2

**Cargo Handling Control Panel Installation
Figure 401/25-53-31-990-801**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-31

Page 406
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

CARGO CONTROL JOYSTICK - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the cargo control joystick.
 - (2) An installation of the cargo control joystick.
- B. This procedure is applicable for the cargo control joystick used for the forward and aft cargo compartments.

TASK 25-53-32-000-802

2. Cargo Control Joystick Removal

(Figure 401)

A. **Location Zones**

Zone	Area
122	Forward Cargo Compartment, Right
152	Aft Cargo Compartment, Right

B. **Access Panels**

Number	Name/Location
122BR	Forward Cargo Handling Control Door
152BR	Aft Cargo Handling Control Door

C. **Prepare for the Removal**

SUBTASK 25-53-32-860-006

NOTE: FOR THE FORWARD CARGO COMPARTMENT

- (1) Open these circuit breakers and install safety tags:

FWD Cargo Handling Access Panel, P35

Row	Col	Number	Name
A	10	C25028	CSC DC-LEFT
A	11	C25029	CSC DC-RIGHT

SUBTASK 25-53-32-860-007

NOTE: FOR THE AFT CARGO COMPARTMENT

- (2) Open these circuit breakers and install safety tags:

Cargo Handling Accessory Panel - Aft, P39

Row	Col	Number	Name
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT

SUBTASK 25-53-32-010-003

- (3) Open these access panels as required

Number	Name/Location
122BR	Forward Cargo Handling Control Door
152BR	Aft Cargo Handling Control Door

D. **Cargo Control Joystick Removal**

SUBTASK 25-53-32-020-005

- (1) Remove the bolts [3] and washers [4] that attach the cargo control joystick [1] to the pan.

EFFECTIVITY
ARO ALL

25-53-32

D633W101-ARO

Page 401
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-32-010-004

- (2) Pull the cargo control joystick [1] down to get access to the electrical connector [5].

SUBTASK 25-53-32-020-006

- (3) Disconnect the electrical connector [5].

SUBTASK 25-53-32-020-007

- (4) Remove the cargo control joystick [1].

————— END OF TASK —————

TASK 25-53-32-400-802

3. Cargo Control Joystick Installation

(Figure 401)

A. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C00064	Coating - Aluminum Chemical Conversion	BAC5719 Type II Class A (MIL-DTL-5541 Class 1A)

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Joystick	25-53-32-01-010	ARO ALL
		25-53-32-01-110	ARO ALL

D. Location Zones

Zone	Area
122	Forward Cargo Compartment, Right
152	Aft Cargo Compartment, Right

E. Access Panels

Number	Name/Location
122BR	Forward Cargo Handling Control Door
152BR	Aft Cargo Handling Control Door

F. Cargo Control Joystick Installation

SUBTASK 25-53-32-110-002

- (1) Clean the area on the pan of all unwanted material to prepare for the installation of the cargo control joystick [1].

SUBTASK 25-53-32-390-004

- (2) Apply the surface treatment coating, C00064 to the mating surfaces between the cargo control joystick [1] and the pan.

SUBTASK 25-53-32-420-003

- (3) Connect the electrical connector [5] to the cargo control joystick [1].

EFFECTIVITY
ARO ALL

25-53-32

D633W101-ARO

Page 402
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-32-390-005

- (4) Make a fay surface seal with the sealant, A00247 between the cargo control joystick [1] and the pan.

SUBTASK 25-53-32-820-003

- (5) Put the cargo control joystick [1] in the opening.

SUBTASK 25-53-32-820-004

- (6) Put the bolts [3] and washers [4] in the holes that attach the cargo control joystick [1] to the pan.

SUBTASK 25-53-32-390-006

- (7) Make a fay surface seal between the bolts [3] and washers [4] with the sealant, A00247.

SUBTASK 25-53-32-420-004

- (8) Tighten the bolts [3] and washers [4].

G. Cargo Control Joystick Installation Test

SUBTASK 25-53-32-860-008

NOTE: FOR THE FORWARD CARGO COMPARTMENT

- (1) Remove the safety tags and close these circuit breakers:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C25028	CSC DC-LEFT
A	11	C25029	CSC DC-RIGHT

SUBTASK 25-53-32-860-009

NOTE: FOR THE AFT CARGO COMPARTMENT

- (2) Remove the safety tags and close these circuit breakers:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT

SUBTASK 25-53-32-860-010

- (3) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-53-32-710-003

- (4) FOR THE FORWARD CARGO COMPARTMENT; do the steps that follow to test the joystick:

NOTE: More than the specified cargo handling components will move during this test. Described below are the minimum required to make sure the joystick functions correctly. Ignore the movement of any additional components.

- (a) Make sure that these circuit breakers are closed:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	1	C25011	PDU 1L, 5L, 12L
B	2	C25012	PDU 2L, 7L, 13L
B	3	C25013	PDU 3L, 11L
B	4	C25014	PDU 4C, 8L, 16L
B	5	C25015	PDU 4L, 9L, 17L
B	6	C25016	PDU 6L, 10L, 18L

EFFECTIVITY
ARO ALL

25-53-32

D633W101-ARO

Page 403
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

FWD Cargo Handling Access Panel, P35

Row	Col	Number	Name
C	1	C25021	PDU 1R, 5R, 12R
C	2	C25022	PDU 2R, 7R, 13R
C	3	C25023	PDU 3R, 11R
C	4	C25024	PDU 6C, 8R, 16R
C	5	C25025	PDU 4R, 9R, 17R
C	6	C25026	PDU 6R, 10R, 18R
D	1	C25018	PDU 14L, 20L
D	2	C25019	PDU 15L, 21L
D	3	C25020	PDU 19L
E	1	C25030	PDU 14R, 20R
E	2	C25031	PDU 15R, 21R
E	3	C25032	PDU 19R

- (b) Make sure the switches on the cargo control panel are in these positions:

Table 401/25-53-32-993-803

Switch Nomenclature	Position
System Power	OFF
Lock/Load/Unload	UNLOAD
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD
Pallet/Containers	CONTAINERS

- (c) Set the SYSTEM POWER switch to ON.
- (d) Make sure the POWER ON light and the BAY ON lights come on.
- (e) Make sure that the PDU sensor is covered during the test.
- (f) Hold the joystick to OUT.
- 1) Make sure the powered drive units (PDUs) 4R, 4C, 4L drive in the out direction.
- (g) Hold the joystick to IN.
- 1) Make sure the PDUs 4R, 4C, 4L drive in the in direction.
- (h) Hold the joystick to FWD.
- 1) Make sure the PDUs 3L, 3R drive in the forward direction.
- (i) Hold the joystick to AFT.
- 1) Make sure the PDUs 3L, 3R drive in the aft direction.
- (j) Release the joystick.
- 1) Make sure all of the PDUs stop.
- (k) Put the SYSTEM POWER switch in the OFF position.

EFFECTIVITY
ARO ALL

25-53-32

D633W101-ARO

Page 404
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-32-710-004

- (5) FOR THE :AFT CARGO COMPARTMENT; do the steps that follow to test the joystick:

NOTE: More than the specified cargo handling components will move during this test.
Described below are the minimum required to make sure the joystick functions correctly. Ignore the movement of any additional components.

- (a) Make sure that these circuit breakers are closed:

Cargo Handling Accessory Panel - Aft, P39

Row	Col	Number	Name
A	9	C25116	LATERAL GUIDES
B	1	C25111	PDU 1L ,13L
B	2	C25112	PDU 2L, 8L, 12L
B	3	C25113	PDU 3L, 9L, 14L
B	4	C25114	PDU 4L, 10L, 12C
B	5	C25115	PDU 5L, 11L, 16L
C	1	C25121	PDU 1R, 13R
C	2	C25122	PDU 2R, 8R, 12R
C	3	C25123	PDU 3R, 9R, 14R
C	4	C25124	PDU 4R, 10R, 14C

- (b) Make sure the switches on the cargo control panel are in these positions:

Table 402/25-53-32-993-804

Switch Nomenclature	Position
System Power	OFF
Lock/Load/Unload	UNLOAD
PDU Left/Both/Right	BOTH
PDU Fwd/Aft	FWD
Pallet/Containers (If Applicable)	CONTAINERS

- (c) Set the SYSTEM POWER switch to ON.
- (d) Make sure the POWER ON light and the BAY ON lights come on.
- (e) Make sure that the PDU sensor is covered during the test.
- (f) Hold the joystick to OUT.
- 1) Make sure the powered drive units (PDUs) 8R, 8C, 8L drive in the out direction.
- (g) Hold the joystick to IN.
- 1) Make sure the PDUs 8R, 8C, 8L drive in the in direction.
- (h) Hold the joystick to FWD.
- 1) Make sure the PDUs 7L, 7R drive in the forward direction.
- (i) Hold the joystick to AFT.
- 1) Make sure the PDUs 7L, 7R drive in the aft direction.
- (j) Release the joystick.
- 1) Make sure all of the PDUs stop.
- (k) Put the SYSTEM POWER switch in the OFF position.

EFFECTIVITY
ARO ALL

25-53-32

D633W101-ARO

Page 405
Jan 05/2015



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

H. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-32-410-002

- (1) Close these access panels as applicable

<u>Number</u>	<u>Name/Location</u>
122BR	Forward Cargo Handling Control Door
152BR	Aft Cargo Handling Control Door

———— **END OF TASK** ————

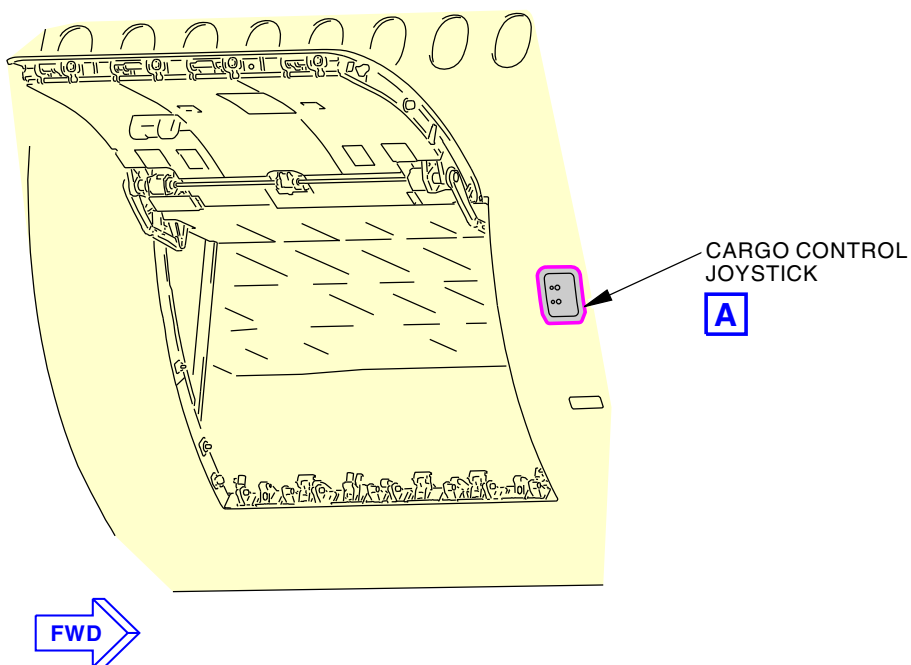
EFFECTIVITY
ARO ALL

D633W101-ARO

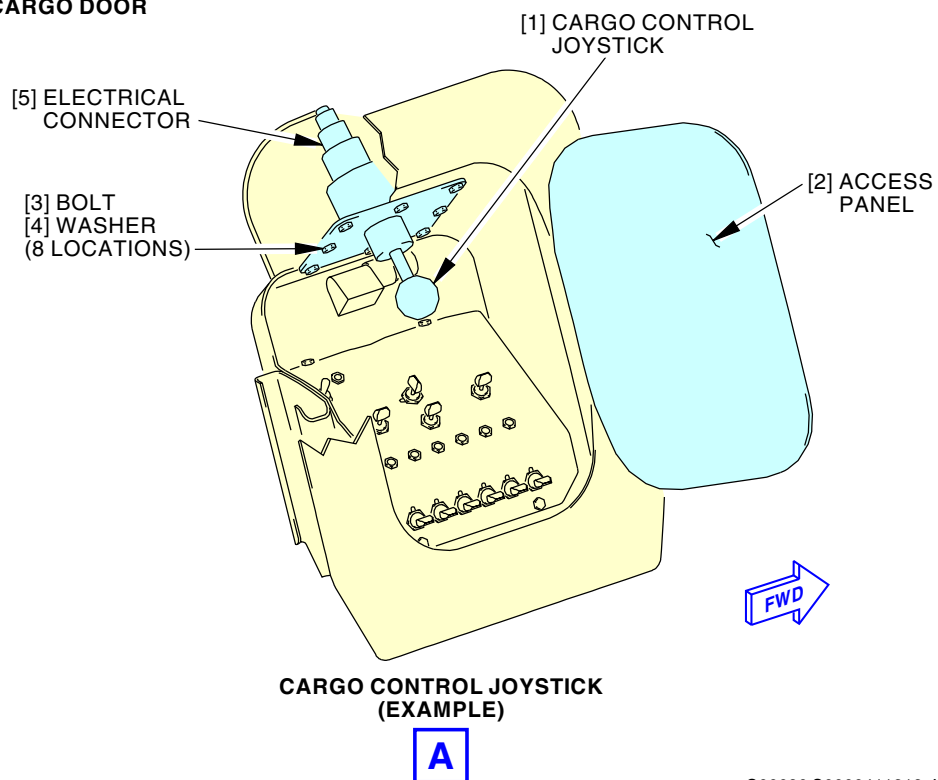
25-53-32

Page 406
Jan 05/2015

777-200/300
AIRCRAFT MAINTENANCE MANUAL



CARGO DOOR



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Cargo Control Joystick Installation
Figure 401/25-53-32-990-802

EFFECTIVITY
ARO ALL

25-53-32

D633W101-ARO

Page 407
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

CARGO SYSTEM CONTROLLER - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) A removal of the cargo system controller (CSC).
- (2) An installation of the cargo system controller (CSC).

B. This procedure is applicable for the CSC in the forward and aft cargo compartments.

TASK 25-53-33-000-804-003

2. Cargo System Controller (CSC) Removal

(Figure 401)

A. References

Reference	Title
20-10-01-000-801	E/E Box Removal (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

C. Location Zones

Zone	Area
821	Forward Large Cargo Door
823	Aft Small Cargo Door

D. Prepare for the Removal

SUBTASK 25-53-33-480-004-003



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

- (1) Install the safety large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006.

SUBTASK 25-53-33-010-004-003

- (2) Open the access panel to the circuit breakers and the CSC [1].

SUBTASK 25-53-33-860-028-003

NOTE: FOR THE FORWARD CARGO COMPARTMENT

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-33

Config 3
Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (3) Open these circuit breakers and install safety tags:

FWD Cargo Handling Access Panel, P35

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C25028	CSC DC-LEFT
A	11	C25029	CSC DC-RIGHT

SUBTASK 25-53-33-860-029-003

NOTE: FOR THE AFT CARGO COMPARTMENT

- (4) Open these circuit breakers and install safety tags:

Cargo Handling Accessory Panel - Aft, P39

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT

E. Cargo System Controller (CSC) Removal

SUBTASK 25-53-33-020-004-003

- (1) Do this task: E/E Box Removal, TASK 20-10-01-000-801.

————— END OF TASK —————

TASK 25-53-33-400-804-003

3. Cargo System Controller (CSC) Installation

(Figure 401)

A. References

<u>Reference</u>	<u>Title</u>
20-10-01-400-801	E/E Box Installation (P/B 401)
24-22-00-860-805	Supply Electrical Power (P/B 201)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

<u>Reference</u>	<u>Description</u>
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363
SPL-2006	Barrier - Safety, Aft Small Cargo Door Part #: J52011-2 Supplier: 81205

C. Location Zones

<u>Zone</u>	<u>Area</u>
821	Forward Large Cargo Door
823	Aft Small Cargo Door

D. Cargo System Controller Installation

SUBTASK 25-53-33-420-004-003

- (1) Do this task: E/E Box Installation, TASK 20-10-01-400-801.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-33

Config 3
Page 402
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

E. Cargo System Controller Installation Test

SUBTASK 25-53-33-160-004-003

- (1) Make sure the cargo handling area is clear of all tools, equipment, and personnel.

SUBTASK 25-53-33-860-030-003

- (2) Put the switches on the cargo handling control panel in these positions:

Table 401/25-53-33-993-802

Switch Nomenclature	Position
SYSTEM POWER	OFF
PDU LEFT/BOTH/RIGHT	BOTH
PDU FWD/AFT	AFT
PALLET/CONTAINERS (If Applicable)	CONTAINERS

SUBTASK 25-53-33-860-031-003

NOTE: FOR THE FORWARD CARGO COMPARTMENT

- (3) Remove the safety tags and close these circuit breakers:

FWD Cargo Handling Access Panel, P35

Row	Col	Number	Name
A	10	C25028	CSC DC-LEFT
A	11	C25029	CSC DC-RIGHT

SUBTASK 25-53-33-860-032-003

NOTE: FOR THE AFT CARGO COMPARTMENT

- (4) Remove the safety tags and close these circuit breakers:

Cargo Handling Accessory Panel - Aft, P39

Row	Col	Number	Name
A	10	C25128	CSC DC LEFT
A	11	C25129	CSC DC RIGHT

SUBTASK 25-53-33-860-033-003

- (5) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-53-33-710-047-003

- (6) Hold the joystick in the AFT position.
- (a) Make sure the aft lateral guides move down.
 - (b) Make sure the powered drive units (PDUs) aft of the forward lateral guides operate aft.

SUBTASK 25-53-33-710-048-003

- (7) Release the joystick.
- (a) Make sure the PDUs stop.
 - (b) Make sure the aft lateral guides move up.

SUBTASK 25-53-33-710-049-003

- (8) Hold the joystick to FWD.
- (a) Make sure the aft lateral guides move down.
 - (b) Make sure the PDUs aft of the forward lateral guides operate forward.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-33

Config 3
Page 403
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-53-33-710-050-003

- (9) Release the joystick.
 - (a) Make sure the PDUs stop.
 - (b) Make sure the aft lateral guides move up.

SUBTASK 25-53-33-710-051-003

- (10) Set the PDU FWD/AFT switch to FWD.

SUBTASK 25-53-33-710-052-003

- (11) Hold the joystick to AFT.
 - (a) Make sure the forward lateral guides move down.
 - (b) Make sure the PDUs forward of the aft lateral guides operate aft.

SUBTASK 25-53-33-710-053-003

- (12) Release the joystick.
 - (a) Make sure the PDUs stop.
 - (b) Make sure the forward lateral guides move up.

SUBTASK 25-53-33-710-054-003

- (13) Hold the joystick to FWD.
 - (a) Make sure the forward lateral guides move down.
 - (b) Make sure the PDUs forward of the aft lateral guides operate forward.

SUBTASK 25-53-33-710-055-003

- (14) Release the joystick.
 - (a) Make sure the PDUs stop.
 - (b) Make sure the forward lateral guides move up.

SUBTASK 25-53-33-710-056-003

- (15) FOR THE FORWARD CARGO COMPARTMENT; do these steps:
 - (a) Set the PALLETS/CONTAINERS switch to PALLETS.
 - (b) Hold the joystick in the OUT position.
 - 1) Make sure the PDUs 4R, 4L, 4C, 6L, 6R, and 6C operate out.
 - (c) Release the joystick.
 - 1) Make sure the PDUs 4R, 4L, 4C, 6L, 6R, and 6C stop.
 - (d) Hold the joystick in the IN position.
 - 1) Make sure the PDUs 4R, 4L, 4C, 6L, 6R, and 6C operate in.
 - (e) Release the joystick.
 - 1) Make sure the PDUs 4R, 4L, 4C, 6L, 6R, and 6C stop.

SUBTASK 25-53-33-710-057-003

- (16) FOR THE AFT CARGO COMPARTMENT; do these steps:
 - (a) Hold the joystick to OUT.
 - 1) Make sure the PDUs 12R, 12L, and 12C operate out.
 - (b) Release the joystick.
 - 1) Make sure the PDUs 12R, 12L, and 12C stop.
 - (c) Hold the joystick to IN.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-53-33

Config 3
Page 404
May 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- 1) Make sure the PDUs 12R, 12L, and 12C operate in.
- (d) Release the joystick.
- 1) Make sure the PDUs 12R, 12L, and 12C stop.

SUBTASK 25-53-33-860-034-003

- (17) Set the SYSTEM POWER switch to OFF.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-53-33-410-004-003



CAUTION

CLOSE THE ACCESS PANEL FOR THE CARGO SYSTEM CONTROLLER (CSC). IF YOU DO NOT CLOSE THE ACCESS PANEL, THE CARGO DOOR CAN HIT IT AND CAUSE DAMAGE. IF THERE IS DAMAGE TO THE ACCESS PANEL, THE CARGO COMPARTMENT WILL NOT BE SEALED.

- (1) Close the access panel for the circuit breakers and the CSC [1].

SUBTASK 25-53-33-860-035-003

- (2) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-53-33-080-004-003

- (3) Remove the large cargo door safety barrier, SPL-1988 or safety barrier, SPL-2006.

———— **END OF TASK** ————

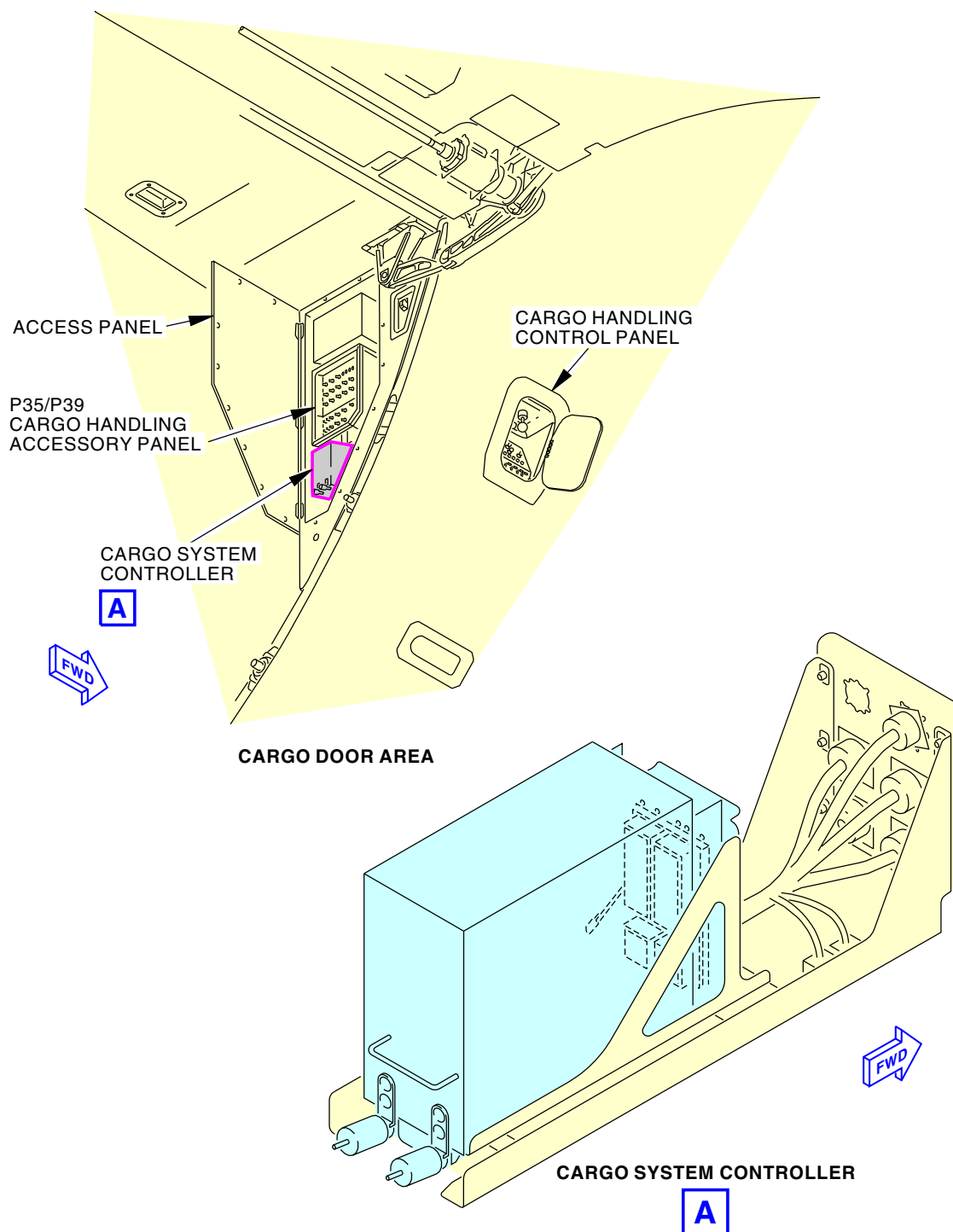
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25-53-33

Config 3
Page 405
Sep 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Cargo System Controller Installation
Figure 401/25-53-33-990-804-003

EFFECTIVITY
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D633W101-ARO

25-53-33

Config 3
Page 406
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

OVER-WING LIFELINE - MAINTENANCE PRACTICES

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure contains these tasks:
 - (1) An Overwing Emergency Exit Door Lifeline Removal,
 - (2) An Overwing Emergency Exit Door Lifeline Installation,
 - (3) An Overwing Emergency Exit Door - Lifeline General Visual Check,
 - (4) An Overwing Emergency Exit Door - Detailed Lifeline Check.

TASK 25-61-01-000-801

2. Overwing Emergency Exit Door - Lifeline Removal

(Figure 201)

A. **General**

- (1) The lifeline (also called the escape strap) is kept in a stowage tube installed in the ceiling of the passenger compartment. One end of the lifeline is attached to the doorway structure. In an emergency, the hook end of the lifeline is attached to the fitting on the wing. The lifeline is used to help the passengers when they are on the wing.

B. **References**

Reference	Title
25-21-02-000-801	Doorway Lining Removal (P/B 401)
52-12-00-860-803	Open the Door Internally with the Interior Handle (P/B 201)

C. **Location Zones**

Zone	Area
231	Passenger Compartment, Left - Section 43
232	Passenger Compartment, Right - Section 43

D. **Procedure**

SUBTASK 25-61-01-010-001

- (1) Open the overwing door. To open the overwing door, do this task: Open the Door Internally with the Interior Handle, TASK 52-12-00-860-803.

SUBTASK 25-61-01-010-002

- (2) Open the cloth cover [3] that holds the hook [4].

SUBTASK 25-61-01-020-001

- (3) Pull the lifeline [2] out of the storage tube [1].

SUBTASK 25-61-01-020-002

- (4) To disconnect the anchor fitting [9], do these steps:
 - (a) For access to the nut [5] on the anchor fitting, remove the upper lining that is above the door. To remove it, do this task: Doorway Lining Removal, TASK 25-21-02-000-801.
 - (b) Remove the nut [5], washers [6] and [8], and spacer [7] from the anchor fitting [9].

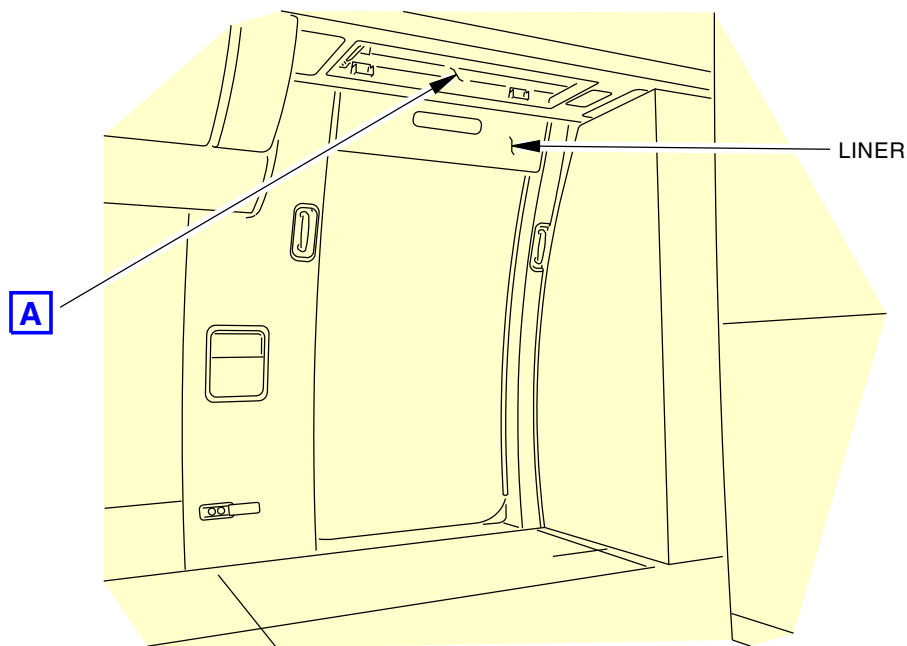
———— **END OF TASK** ————

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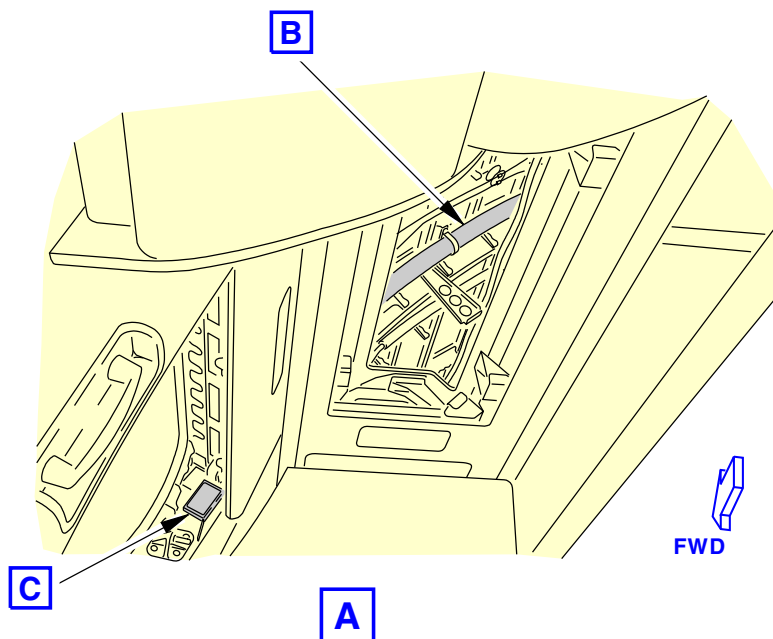
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Page 201
Jan 05/2015



**DOOR NO. 3
(INTERNAL VIEW)
(CEILING PANEL REMOVED)**



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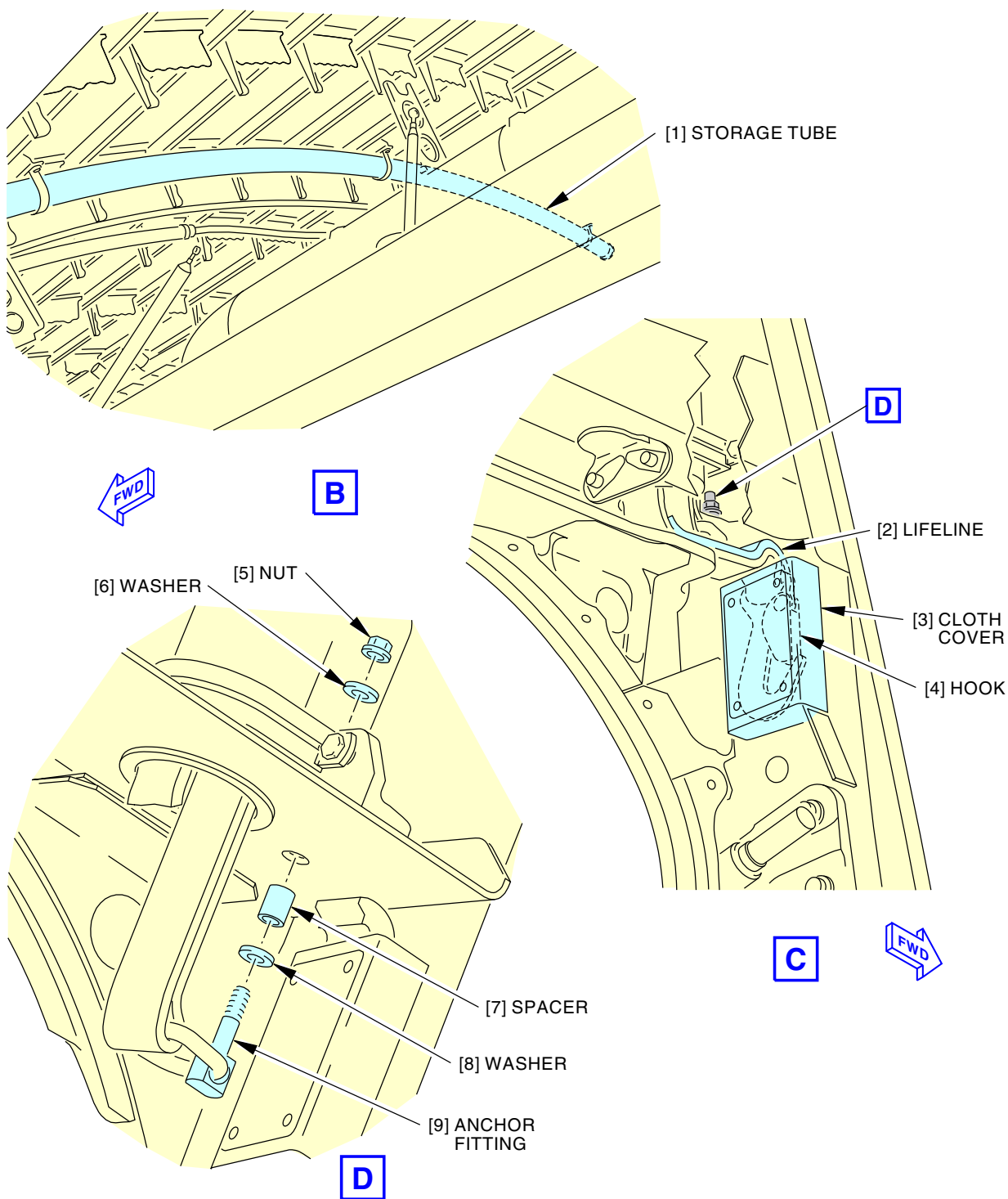
**Overwing Emergency Exit Door Lifeline Installation
Figure 201/25-61-01-990-801 (Sheet 1 of 2)**

EFFECTIVITY
ARO ALL

25-61-01

D633W101-ARO

Page 202
May 05/2017



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**Overwing Emergency Exit Door Lifeline Installation
Figure 201/25-61-01-990-801 (Sheet 2 of 2)**

**EFFECTIVITY
ARO ALL**

25-61-01

D633W101-ARO

Page 203
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-61-01-400-801

3. Overwing Emergency Exit Door - Lifeline Installation

(Figure 201, Figure 202)

A. General

- (1) The lifeline (also called the escape strap) is kept in a stowage tube installed in the ceiling of the passenger compartment. One end of the lifeline is attached to the doorway structure. In an emergency, the hook end of the lifeline is attached to the fitting on the wing. The lifeline is used to help the passengers when they are on the wing.

B. References

Reference	Title
25-21-02-400-801	Doorway Lining Installation (P/B 401)
25-21-06-000-801	Main Ceiling Panel - Removal (P/B 401)
25-21-06-400-801	Main Ceiling Panel - Installation (P/B 401)
52-12-00-860-804	Close the Door Internally with the Interior Handle (P/B 201)

C. Consumable Materials

Reference	Description	Specification
G00291	Tape - Aluminum Foil, Scotch 425	AMS-T-23397 / L-T-80

D. Location Zones

Zone	Area
231	Passenger Compartment, Left - Section 43
232	Passenger Compartment, Right - Section 43

E. Procedure

SUBTASK 25-61-01-530-001

- (1) Fold the lifeline [2] approximately as shown (Figure 202).

SUBTASK 25-61-01-530-002

- (2) Use 0.25 inch wide Scotch 425 Aluminum Foil Tape, G00291 to keep the lifeline folded. Wind the Scotch 425 Aluminum Foil Tape, G00291 two times around the lifeline at each of the seven locations shown (Figure 202).

SUBTASK 25-61-01-420-001

- (3) Attach the anchor fitting [9] with the nut [5], washers [6] and [8], and spacer [7].

SUBTASK 25-61-01-420-002

- (4) Do these steps to put the lifeline [2] in its tube [1]:
 - (a) Open the applicable ceiling panel for access to the top of the lifeline's tube. To open the ceiling panel, do this task: Main Ceiling Panel - Removal, TASK 25-21-06-000-801.
 - (b) Use pliers to remove the plug from the top end of the lifeline's tube.
NOTE: The end of the tube is near the top of the fuselage, about one foot (300 mm) left or right of the center of the airplane.
 - (c) Use a weight or a wire to put a string through the lifeline's tube [1].
NOTE: The string should be about 12 feet (3.5 m) long.
 - (d) Tie the string through the top of the lifeline [2].
NOTE: Do not tie the string directly to the lifeline. Put the string through the lifeline and make a loop in the string about one foot (300 mm) long. This will allow the knot to come out of the top of the tube when the lifeline is installed (so you can untie it).

EFFECTIVITY
ARO ALL

25-61-01

D633W101-ARO

Page 204
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (e) Put the top of the lifeline [2] in the tube [1] and pull the lifeline into its position with the string.
- (f) Remove the string from the lifeline.
- (g) Install the cap in the top of the lifeline's tube.

SUBTASK 25-61-01-420-003

- (5) Put the hook [4] into the retainer and close the cloth cover [3].

F. Put the Airplane Back to its Usual Condition.

SUBTASK 25-61-01-410-001

- (1) To replace the main ceiling panel, do this task: Main Ceiling Panel - Installation, TASK 25-21-06-400-801.

SUBTASK 25-61-01-410-002

- (2) If you removed the liner above the door, do this task: Doorway Lining Installation, TASK 25-21-02-400-801.

SUBTASK 25-61-01-410-003

- (3) Close the overwing door. To close the overwing door, do this task: Close the Door Internally with the Interior Handle, TASK 52-12-00-860-804.

————— END OF TASK —————

TASK 25-61-01-200-802

4. Overwing Emergency Exit Door - Lifeline General Visual Check

(Figure 201)

A. General

- (1) This task is a visual check of the lifeline condition and that it is attached correctly.
- (2) The lifeline (also called the escape or assist strap) is kept in a stowage tube installed in the ceiling of the passenger compartment. One end of the lifeline is attached to the doorway structure. In an emergency, the hook end of the lifeline is attached to the fitting on the wing. The lifeline is used to help the passengers when they are on the wing.

B. References

Reference	Title
52-12-00-860-803	Open the Door Internally with the Interior Handle (P/B 201)

C. Location Zones

Zone	Area
833	Left No. 3 Overwing Door - Section 44
843	Right No. 3 Overwing Door - Section 44

D. Access Panels

Number	Name/Location
833	Left No. 3 Overwing Door
843	Right No. 3 Overwing Door

E. Procedure

SUBTASK 25-61-01-010-005

- (1) To open the applicable No. 3 overwing door, do this task:
Open the Door Internally with the Interior Handle, TASK 52-12-00-860-803

EFFECTIVITY
ARO ALL

25-61-01

D633W101-ARO

Page 205
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

<u>Number</u>	<u>Name/Location</u>
833	Left No. 3 Overwing Door
843	Right No. 3 Overwing Door

SUBTASK 25-61-01-010-006

- (2) Open the cloth cover [3] that holds the hook [4] and lifeline [2].

SUBTASK 25-61-01-212-001

- (3) To make sure the lifeline [2] is installed correctly(Figure 202), do the steps that follow:
- (a) Make sure the lifeline is in the stowage tube.
 - (b) Make sure the lifeline anchor fitting is attached to the doorway structure.
 - (c) Make sure the hook is in the hook retainer pouch.

SUBTASK 25-61-01-410-007

- (4) Close the cloth cover [3].

SUBTASK 25-61-01-410-008

- (5) To close the applicable No. 3 overwing door, do this task:
Open the Door Internally with the Interior Handle, TASK 52-12-00-860-803

<u>Number</u>	<u>Name/Location</u>
833	Left No. 3 Overwing Door
843	Right No. 3 Overwing Door

————— **END OF TASK** —————

TASK 25-61-01-200-801

5. Overwing Emergency Exit Door - Detailed Lifeline Check

(Figure 201, Figure 202)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) The lifeline (also called the escape strap) is kept in a stowage tube installed in the ceiling of the passenger compartment. One end of the lifeline is attached to the doorway structure. In an emergency, the hook end of the lifeline is attached to the fitting on the wing. The lifeline is used to help the passengers when they are on the wing.

B. References

<u>Reference</u>	<u>Title</u>
25-21-02-400-801	Doorway Lining Installation (P/B 401)
25-21-06-000-801	Main Ceiling Panel - Removal (P/B 401)
25-21-06-400-801	Main Ceiling Panel - Installation (P/B 401)
52-12-00-860-803	Open the Door Internally with the Interior Handle (P/B 201)
52-12-00-860-804	Close the Door Internally with the Interior Handle (P/B 201)

C. Consumable Materials

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
G00291	Tape - Aluminum Foil, Scotch 425	AMS-T-23397 / L-T-80

D. Location Zones

<u>Zone</u>	<u>Area</u>
833	Left No. 3 Overwing Door - Section 44

EFFECTIVITY
ARO ALL

25-61-01

D633W101-ARO

Page 206
Sep 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Zone	Area

843	Right No. 3 Overwing Door - Section 44

E. Procedure

SUBTASK 25-61-01-010-003

- (1) Open the overwing door. To open the overwing door, do this task: Open the Door Internally with the Interior Handle, TASK 52-12-00-860-803.

SUBTASK 25-61-01-010-004

- (2) Open the cloth cover [3] that holds the hook [4] and lifeline [2].

SUBTASK 25-61-01-020-003

- (3) Pull the hook end [9] of the lifeline out over the wing.
 - (a) Make sure the lifeline can be attached to the fitting on the wing.

SUBTASK 25-61-01-210-001

- (4) Do these steps to examine the condition of the lifeline:
 - (a) Make sure the lifeline has no worn areas.
 - (b) Make sure the lifeline is not wet.
 - (c) Make sure the anchor fitting is not loose, corroded, or cracked.

SUBTASK 25-61-01-210-002

- (5) Do these steps to examine the condition of the hook:
 - (a) Make sure the hook is not bent or corroded.
 - (b) Make sure the gate on the hook opens smoothly. Make sure the spring closes the gate.

SUBTASK 25-61-01-530-003

- (6) Fold the lifeline [2] approximately as shown (Figure 202).

SUBTASK 25-61-01-530-004

- (7) Use 0.25 inch wide Scotch 425 Aluminum Foil Tape, G00291 to keep the lifeline folded. Wind the Scotch 425 Aluminum Foil Tape, G00291 two times around the lifeline at each of the seven locations shown (Figure 202).

SUBTASK 25-61-01-420-004

- (8) Do these steps to put the lifeline in its tube:
 - (a) Open the applicable ceiling panel for access to the top of the lifeline's tube. To open the ceiling panel, do this task: Main Ceiling Panel - Removal, TASK 25-21-06-000-801.
 - (b) Use pliers to remove the plug from the top end of the lifeline's tube.
NOTE: The end of the tube is near the top of the fuselage, about one foot (300 mm) left or right of the center of the airplane.
 - (c) Use a weight or a wire to put a string through the lifeline's tube.
NOTE: The string should be about 12 feet (3.5 m) long.
 - (d) Tie the string through the top of the lifeline.
NOTE: Do not tie in the string directly to the lifeline. Put the string through the lifeline and make a loop in the string about one foot (300 mm) long. This will allow the knot to come out of the top of the tube when the lifeline is installed (so you can untie it).
 - (e) Put the top of the lifeline in the tube and pull the lifeline into its position with the string.
 - (f) Remove the string from the lifeline.

EFFECTIVITY
ARO ALL

25-61-01

D633W101-ARO

Page 207
Sep 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (g) Install the cap in the top of the lifeline's tube

SUBTASK 25-61-01-420-005

- (9) Put the hook [4] into the retainer and close the cloth cover [3].

F. Put the Airplane Back to its Usual Condition.

SUBTASK 25-61-01-410-004

- (1) To replace the main ceiling panel, do this task: Main Ceiling Panel - Installation,
TASK 25-21-06-400-801

SUBTASK 25-61-01-410-005

- (2) If you removed the liner above the door, do this task: Doorway Lining Installation,
TASK 25-21-02-400-801.

SUBTASK 25-61-01-410-006

- (3) Close the overwing door. To close the overwing door, do this task: Close the Door Internally
with the Interior Handle, TASK 52-12-00-860-804.

———— **END OF TASK** ————

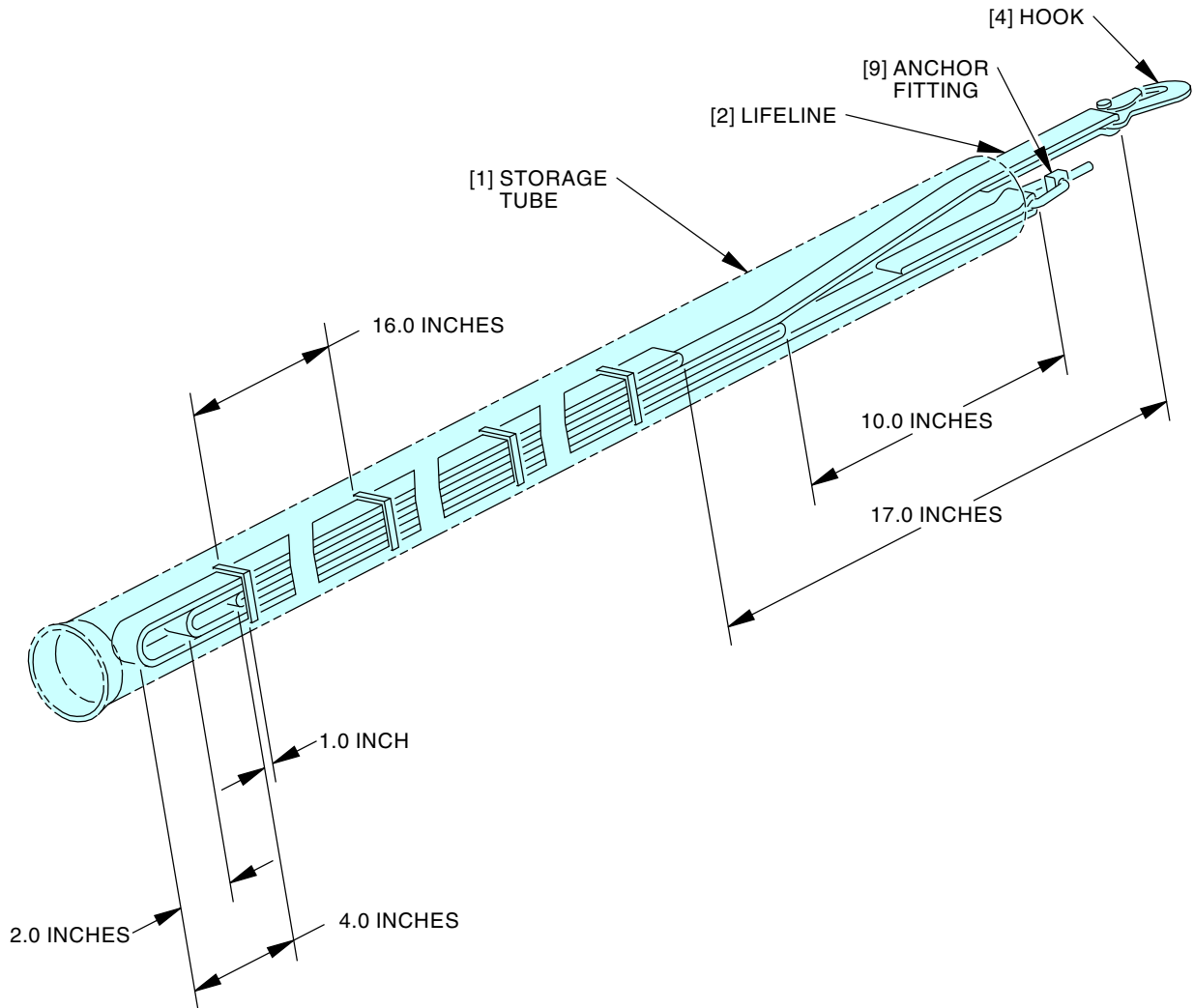
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25-61-01

D633W101-ARO

Page 208
Sep 05/2015

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Life Line Packing
Figure 202/25-61-01-990-802

EFFECTIVITY
ARO ALL

D633W101-ARO

25-61-01

Page 209
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
ESCAPE ROPES - MAINTENANCE PRACTICES

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure contains these tasks for the flight compartment escape rope:
 - (1) A removal of the escape rope
 - (2) An installation of the escape rope
 - (3) An inspection of the escape rope.
- C. The escape ropes are in the flight compartment near the No. 2 windows.

TASK 25-61-02-000-801

2. Escape Rope Removal

(Figure 201)

A. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

B. Escape Rope Removal

SUBTASK 25-61-02-010-001

- (1) Open the door [2] to the stowage pocket for the escape rope [1].

SUBTASK 25-61-02-020-001

- (2) Remove the escape rope [1] with the stowage bag [4] from the stowage pocket.

SUBTASK 25-61-02-020-013

- (3) Remove the cotter pin from the escape rope [1] anchor plate.

NOTE: The escape rope anchor plate is attached to the ring at the end of the escape rope.

SUBTASK 25-61-02-020-002

- (4) Disconnect the escape rope [1] from the anchor plate [3].

SUBTASK 25-61-02-020-003

- (5) Remove the escape rope [1] from the stowage bag [4].

———— **END OF TASK** ————

TASK 25-61-02-400-801

3. Escape Rope Installation

(Figure 201)

A. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

B. Escape Rope Installation

SUBTASK 25-61-02-420-001

- (1) Connect the escape rope [1] to the anchor plate [3].

EFFECTIVITY
ARO ALL

25-61-02

D633W101-ARO

Page 201
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-61-02-420-012

- (2) Install the cotter pin/safety pin in the escape rope [1] anchor plate.

NOTE: The escape rope anchor plate is attached to the ring at the end of the escape rope.

SUBTASK 25-61-02-420-002

- (3) Wind the escape rope [1] into the stowage bag [4], start with the unattached end of the escape rope [1].

SUBTASK 25-61-02-420-003

- (4) Wind the remaining part of the escape rope [1] into coils in the stowage pocket.

SUBTASK 25-61-02-420-004



DO NOT CLOSE OR ATTACH THE BAG. IF THE BAG IS CLOSED OR ATTACHED, THE BAG AND THE ROPE WILL NOT FALL FROM THE POCKET IN AN EMERGENCY. INJURY TO PERSONS CAN RESULT.

- (5) Put the stowage bag [4] in the stowage pocket with the bottom of the stowage bag [4] to the outboard side.

SUBTASK 25-61-02-410-001

- (6) Close the door [2] for the stowage pocket.

————— **END OF TASK** —————

TASK 25-61-02-210-801

4. Escape Rope Inspection

(Figure 201)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

B. Escape Rope Inspection

SUBTASK 25-61-02-020-004



REPLACE THE ESCAPE ROPE IF IT WAS USED BY PERSONNEL IN A DEMONSTRATION, TRAINING, OR AN ACTUAL EMERGENCY EVACUATION. YOU CANNOT DO A CHECK OF THE CENTRAL CORE FOR DAMAGE; AND, YOU CANNOT RE-WEAVE THE OUTER SHEATH AFTER IT IS USED. INJURY TO PERSONS CAN OCCUR IF THE ROPE IS NOT REPLACED.

- (1) Do a check of the escape rope and aircraft records for evidence that it was used. If you find evidence that the escape rope was used, replace the escape rope:
- Escape Rope Removal, TASK 25-61-02-000-801
 - Escape Rope Installation, TASK 25-61-02-400-801

SUBTASK 25-61-02-210-001

- (2) Do this check of each escape rope [1]:
- (a) Do a visual check of the anchor plate [3]:
- 1) Make sure the anchor plate [3] is satisfactorily attached to the structure.
 - 2) Tighten the loose fasteners for the anchor plate [3].

EFFECTIVITY
ARO ALL

25-61-02

D633W101-ARO

Page 202
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (b) Do a visual check of each escape rope [1] for fraying.
- (c) If the escape rope [1] is fraying, replace it.
- (d) Attach the escape rope [1] to the anchor plate [3].
- (e) Pull on the escape rope [1] to make sure it is satisfactorily attached.

SUBTASK 25-61-02-420-005

- (3) Do this task: Escape Rope Installation.

———— **END OF TASK** ————

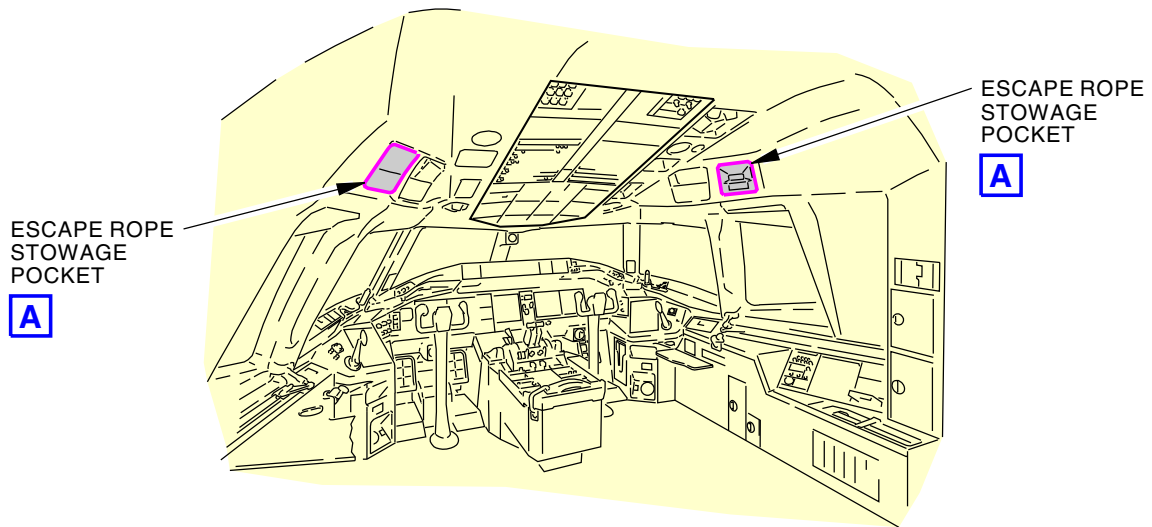
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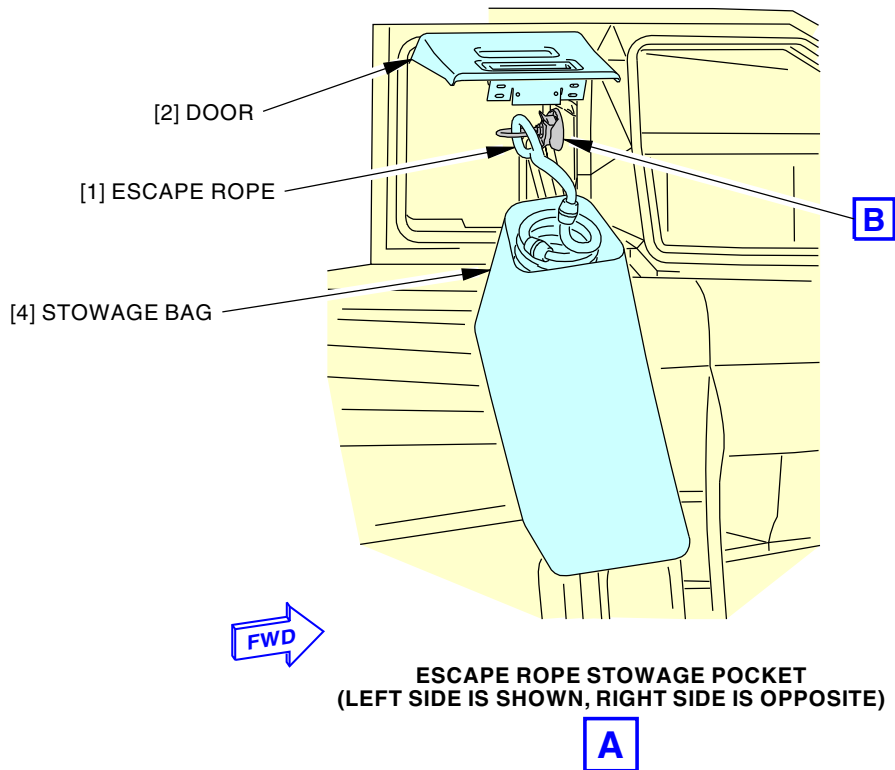
25-61-02

Page 203
Sep 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



FLIGHT COMPARTMENT



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Flight Compartment Escape Rope Installation
Figure 201/25-61-02-990-801 (Sheet 1 of 2)

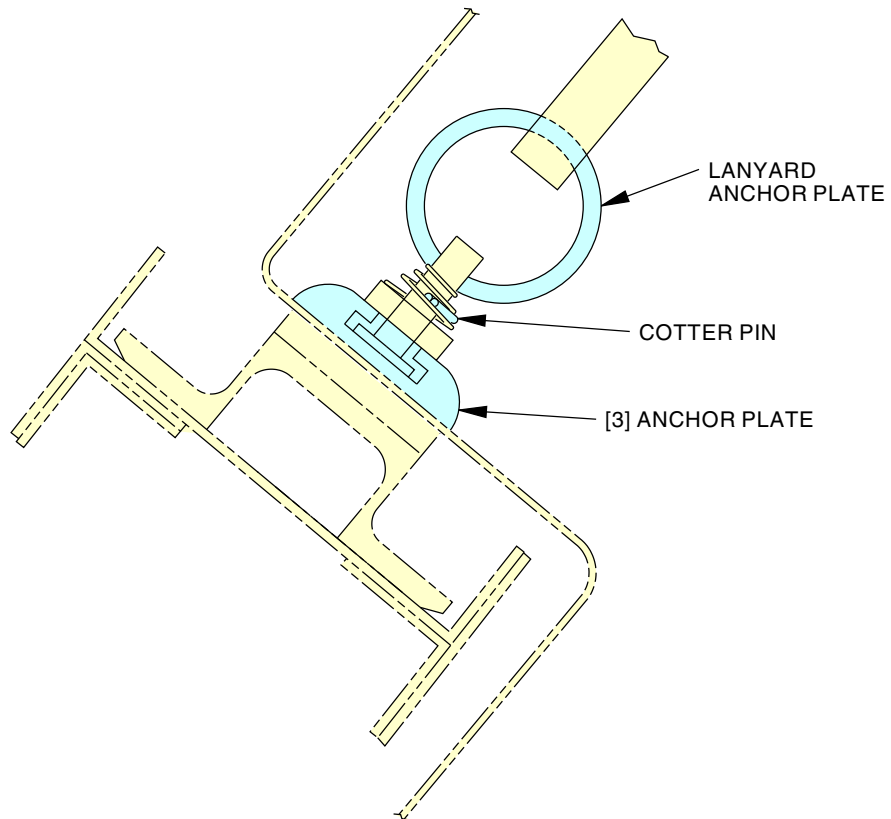
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25-61-02

Page 204
May 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



B

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Flight Compartment Escape Rope Installation
Figure 201/25-61-02-990-801 (Sheet 2 of 2)

EFFECTIVITY
 ARO ALL

25-61-02

D633W101-ARO

Page 205
 May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
LIFE VESTS - MAINTENANCE PRACTICES

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure contains a visual inspection of the life vests for the passengers and the flight crew.
- C. This procedure has these tasks:
 - (1) Life Vest Inspection
 - (2) Flotation Cot Replacement

TASK 25-62-01-200-801

2. Life Vest Inspection

(Figure 201)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-62-01-210-009

- (1) Make sure there is a life vest in these locations:
 - (a) below each passenger seat
 - (b) in the pouch on the back of each seat for the flight crew
 - (c) in the stowage compartment below each attendant seat.

SUBTASK 25-62-01-020-004

- (2) Remove the life vest.

SUBTASK 25-62-01-210-010

- (3) Make sure each life vest is sealed in a protective package.

SUBTASK 25-62-01-210-011

- (4) Do an inspection of the expiration date on the life vest.

SUBTASK 25-62-01-960-003

- (5) If the life vest is expired, replace it with a new one.

SUBTASK 25-62-01-210-012

- (6) If there is damage to the package, make sure there is no damage to the life vest.

SUBTASK 25-62-01-960-004

- (7) If there is damage to the life vest, replace it with a new one.

SUBTASK 25-62-01-420-006

- (8) Put the passenger life vests in the correct location below the seat.

SUBTASK 25-62-01-420-007

- (9) Put the flight attendant's life vests in the stowage compartment below the attendant seat.

SUBTASK 25-62-01-420-008

- (10) Put the flight crew life vests in the rear of the seats.

———— **END OF TASK** ————

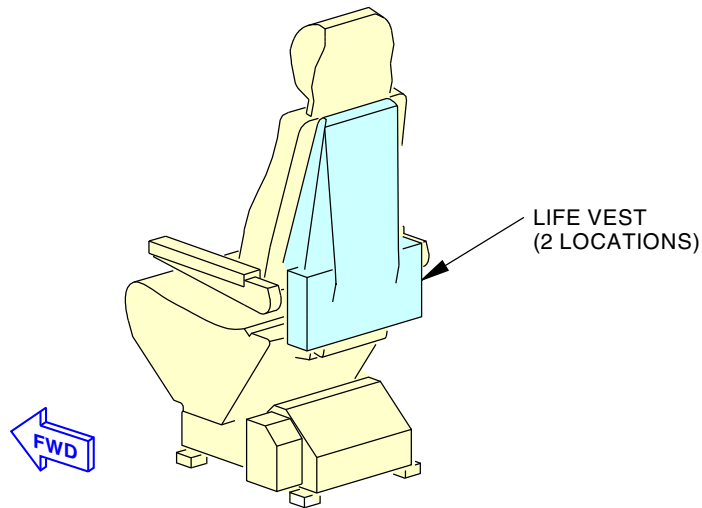
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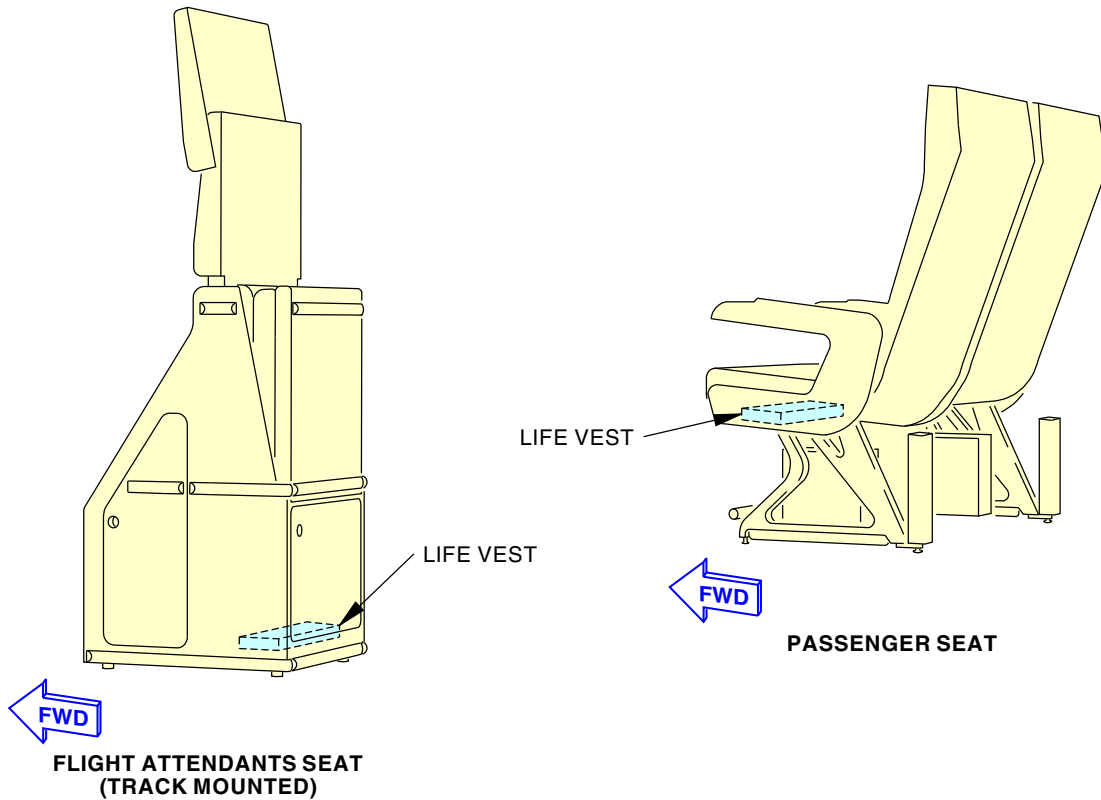
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Page 201
May 05/2015

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



CAPTAIN'S AND FIRST OFFICER'S SEATS



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Life Vest Inspection
Figure 201/25-62-01-990-801 (Sheet 1 of 2)

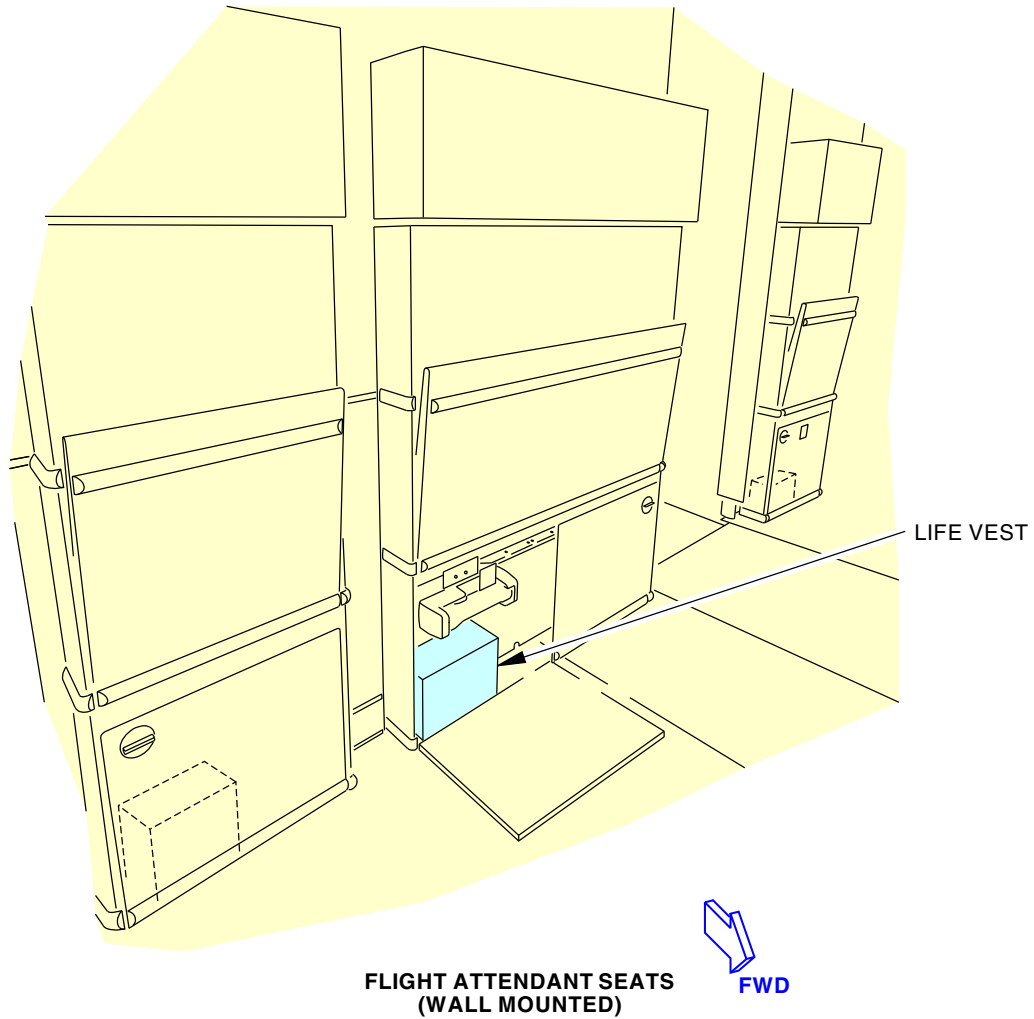
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25-62-01

Page 202
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Life Vest Inspection
Figure 201/25-62-01-990-801 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-62-01

Page 203
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-62-01-960-801

3. Flotation Cot Replacement

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Flotation Cot Replacement

SUBTASK 25-62-01-020-002

(1) Remove the flotation cot if it is necessary for an off aircraft restoration.

SUBTASK 25-62-01-420-004

(2) Install a new flotation cot.

————— END OF TASK —————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-62-01

Page 204
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

PORTABLE EMERGENCY LOCATOR TRANSMITTER - MAINTENANCE PRACTICES

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) Removal of the portable Emergency Locator Transmitter (ELT).
 - (2) Installation of the portable ELT.
- C. This procedure is applicable to the portable ELTs that are kept in stowage compartments. This procedure is not applicable to the ELTs in the slide packs.

TASK 25-63-01-020-801

2. Portable Emergency Locator Transmitter (ELT) - Removal

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Emergency Locator Transmitter (ELT) Removal

SUBTASK 25-63-01-020-004

- (1) For ELTs with a metal lanyard, do this step:
 - (a) Remove the lanyard from the screw.

SUBTASK 25-63-01-020-011

- (2) Remove the ELT from the bracket.

SUBTASK 25-63-01-040-001

- (3) If installed, make sure the four-position switch is set to the correct position per the airline's regulatory requirements.
 - (a) It is recommended that the four position switch be put in the OFF position.

————— **END OF TASK** —————

TASK 25-63-01-420-801

3. Portable Emergency Locator Transmitter (ELT) - Installation

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Emergency Locator Transmitter Installation

SUBTASK 25-63-01-540-001

- (1) If installed, remove the packing label from the ELT.

SUBTASK 25-63-01-420-003

- (2) For ELTs with a metal lanyard, do these steps:
 - (a) Attach the end of the lanyard to a screw installed on the attaching bracket.
 - (b) Make sure that the lanyard is contained in the Velcro strap.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-63-01

Page 201
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-63-01-420-005

(3) Install the ELT on the bracket.

(a) Make sure that the strap can be accessed for easy release of the Velcro fastener.

NOTE: The snap fastener must be visible and easy to access. The placard on the strap must be centered on the ELT unit.

SUBTASK 25-63-01-440-001

(4) If installed, make sure the four-position switch is set to the correct position per the airline's regulatory requirements.

(a) It is recommended that the four-position switch be put in the ARMED position.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-63-01

D633W101-ARO

Page 202
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

EMERGENCY EVACUATION SIGNAL SYSTEM - MAINTENANCE PRACTICES

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks for the emergency evacuation signal (EES) system:
 - (1) Emergency Evacuation Signal System Operation Test
- C. This system is used by the flight crew to start an alarm signal for emergency evacuation procedures.

TASK 25-63-02-700-801

2. Emergency Evacuation Signal System Operational Test

(Figure 201 or Figure 202)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) The EES systems are on the aisle stand in the flight compartment and on the attendant switch panels throughout the passenger compartment. The attendant switch panels are installed on or above the attendant seats near the passenger entry doors.

B. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)

C. Location Zones

Zone	Area
200	Upper Half of Fuselage

D. Procedure

SUBTASK 25-63-02-860-001

- (1) Do this task: Supply Electrical Power, TASK 24-22-00-860-805.

SUBTASK 25-63-02-860-002

- (2) Make sure that this circuit breaker is closed:

Standby Power Management Panel, P310

Row	Col	Number	Name
K	4	C25604	EMER EVAC SIG

SUBTASK 25-63-02-710-017

- (3) Set the COMMAND switch on the flight compartment EES panel to the ON position.
 - (a) Make sure that the horn on the flight compartment EES panel operates.
 - (b) Make sure that all horns on the passenger compartment EES panels operate.
 - (c) Make sure that the EVAC light is on in the flight compartment.
 - (d) Make sure that all EVACUATE lights are on in the passenger compartment.
 - (e) Pull or Push the HORN SHUTOFF button on the flight compartment EES panel.
 - 1) Make sure that in the flight compartment horn stops and EVAC light stays on.
 - 2) Make sure that in the passenger compartment all horns stay on and all EVACUATE lights stay on.
 - (f) Do these steps for each passenger compartment EES panel that has a HORN SHUTOFF button:

EFFECTIVITY
ARO ALL

25-63-02

D633W101-ARO

Page 201
May 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- 1) Push the HORN SHUTOFF button.
 - a) Make sure that the horn on that EES panel stops.
 - b) Make sure that all EVACUATE lights on the passenger compartment EES panel stay on.
 - c) Make sure that the EVAC light on the flight compartment EES panel stays on.

SUBTASK 25-63-02-710-018

- (4) Set the COMMAND switch on the flight compartment EES panel to the OFF position.
 - (a) Make sure that all horns stay off in the flight compartment and in the passenger compartment.
 - (b) Make sure that all EVAC lights stay off in the flight compartment and in the passenger compartment.
 - (c) Do these steps for each passenger compartment EES panel that has a COMMAND button:
 - 1) Push the COMMAND button.
 - a) Make sure that the COMMAND button light on that EES panel comes on.
 - b) Make sure that all EVACUATE lights on the flight compartment EES panel is on.
 - c) Make sure that all EVACUATE lights on the passenger compartment EES panels are on.
 - d) Make sure that all horns in the flight compartment and passenger compartment operate.
 - 2) Push that COMMAND button again.
 - a) Make sure that the COMMAND button light is off on that EES panel.
 - b) Make sure that in the flight compartment horns stop and the EVAC light is off.
 - c) Make sure that in the passenger compartment all horns stop and all EVAC lights are off.

———— **END OF TASK** ————

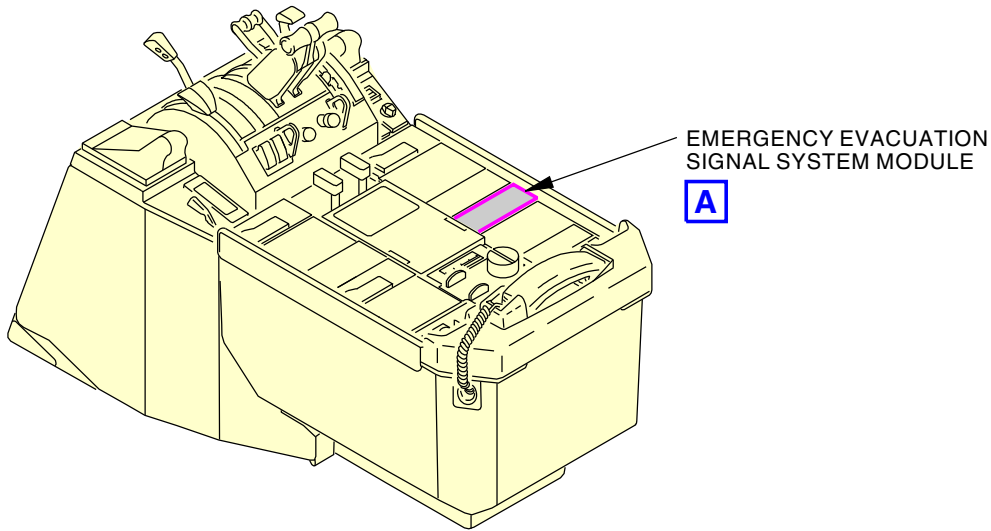
EFFECTIVITY
ARO ALL

25-63-02

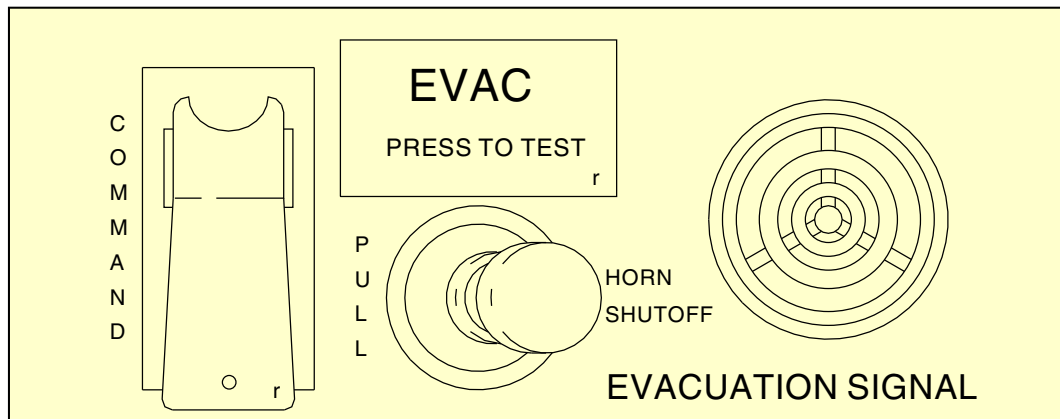
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Page 202
Jan 05/2015

777-200/300
AIRCRAFT MAINTENANCE MANUAL



AISLE STAND



EMERGENCY EVACUATION SIGNAL SYSTEM MODULE

C99145 S0006411414_V2

Flight Compartment Emergency Evacuation Signal System
Figure 201/25-63-02-990-803

EFFECTIVITY
 ARO ALL

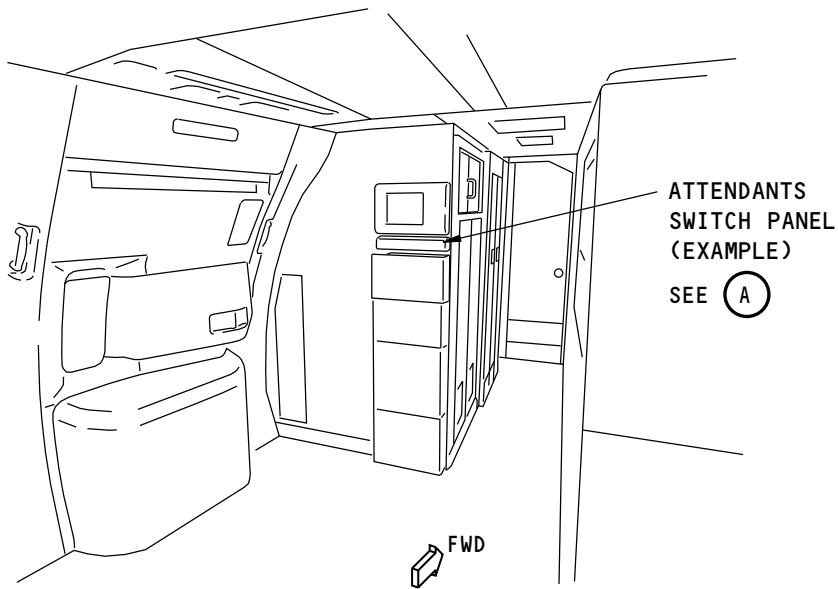
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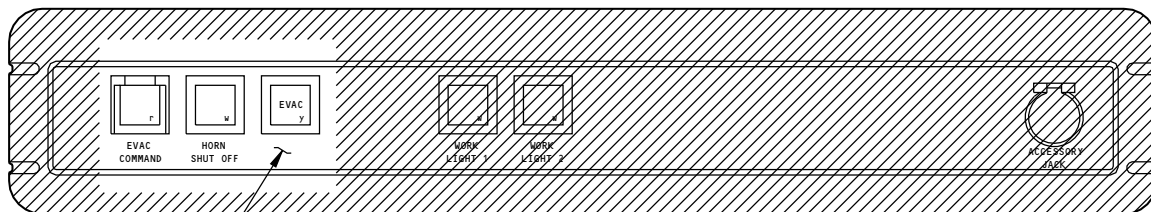
Page 203
 May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



PASSENGER ENTRY DOOR
(EXAMPLE)



EMERGENCY
EVACUATION
SIGNAL SYSTEM

ATTENDANTS SWITCH PANEL
(EXAMPLE)

A

C99744 S0006411412_V1

Passenger Compartment Emergency Evacuation Signal System
Figure 202/25-63-02-990-801

EFFECTIVITY
ARO ALL

25-63-02

D633W101-ARO

Page 204
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

DETACHABLE EMERGENCY EQUIPMENT - MAINTENANCE PRACTICES

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks for the detachable emergency equipment:
 - (1) Protective Breathing Equipment (Smokehoods) Inspection
 - (2) Smokehood Replacement
 - (3) Detachable Emergency Equipment Visual Check
 - (4) Flashlight Operational Test
 - (5) Flashlight Battery Replacement
 - (6) Life Raft Inspection
 - (7) Life Raft Restoration

TASK 25-64-01-200-801

2. Protective Breathing Equipment (Smokehood) Inspection

(Figure 201)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. General

SUBTASK 25-64-01-210-005

- (1) This procedure is a scheduled maintenance task.
- (2) This task visually checks the smoke hoods for general serviceability.

C. Procedure

SUBTASK 25-64-01-210-001

- (1) Use the applicable steps that follow to do an inspection of the smoke hoods:

NOTE: The smoke hoods may have any combination of tamper tags or visual indicators. Most smoke hood containers have warning indicators that show when the smoke hood is no longer good for use.

- (a) FOR SMOKE HOOD CONTAINERS WITH TAMPER TAGS; do a visual check of the tamper tags to make sure that they are not broke or ripped.

NOTE: Tamper tags for the different installations may vary in shape and size. All the different types of tamper tags have the same function.

- (b) FOR SMOKE HOOD CONTAINERS WITH AN INDICATOR WINDOW; do a visual check of the indicator window on the container to make sure the smoke hood has not filled the window.

- (c) FOR SMOKE HOOD CONTAINERS WITHOUT AN INDICATOR WINDOW; feel the smoke hood to make sure it remains hard and solid.

NOTE: The smoke hood is vacuum packed. If the smoke hood feels soft, then it is not vacuum packed.

EFFECTIVITY
ARO ALL

25-64-01

D633W101-ARO

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Page 201
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-64-01-900-001

- (2) Replace any smoke hood that fails this inspection with a new smoke hood assembly if it is necessary.

NOTE: If only the tamper tags of the smokehood container are damaged, and the vacuum seal is not damaged, you do not have to replace the full assembly. You can replace only the tamper tags.

———— **END OF TASK** ————

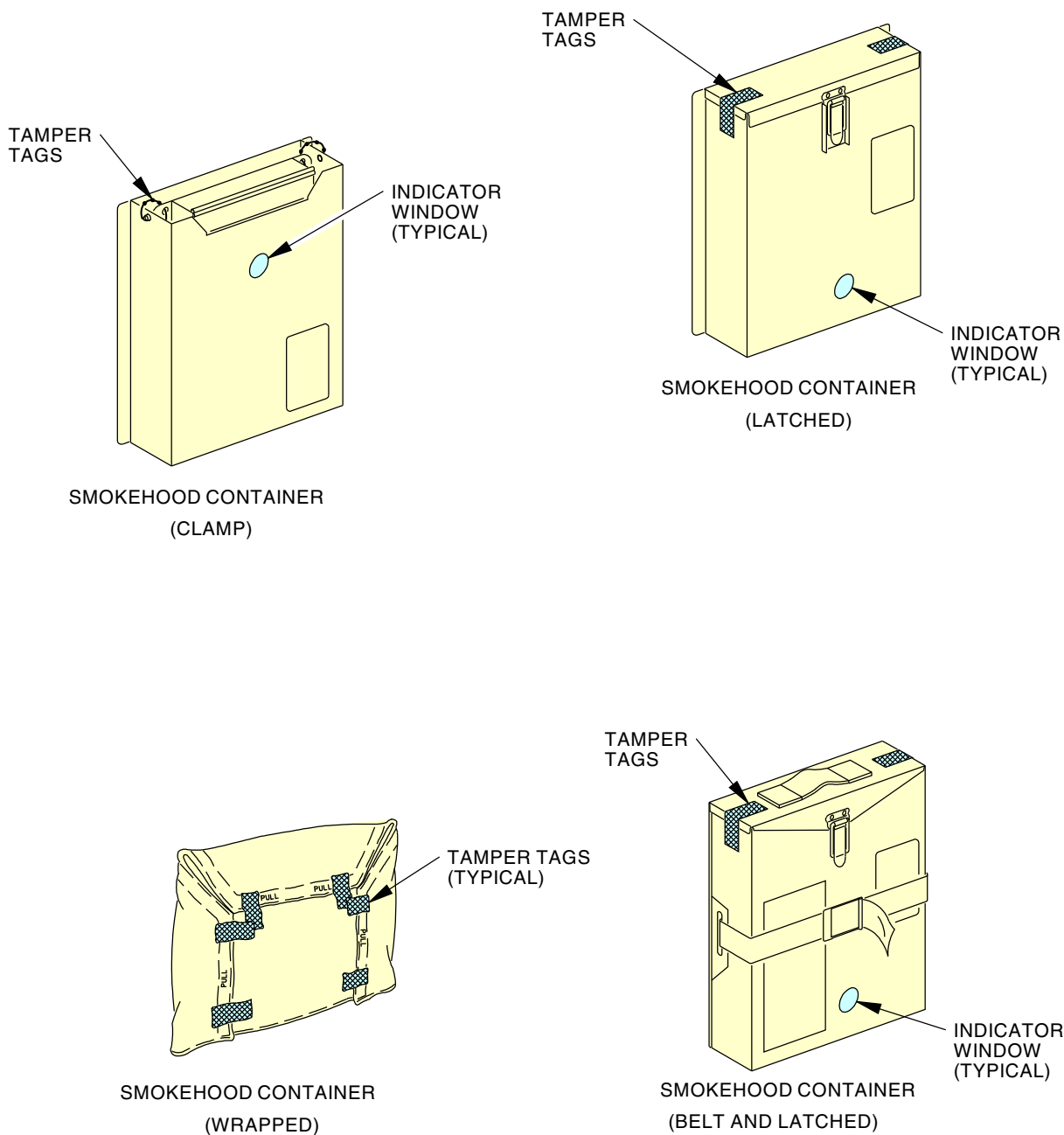
EFFECTIVITY
ARO ALL

25-64-01

D633W101-ARO

Page 202
Jan 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



D19507 S0006411430_V3

**Protective Breathing Equipment (Smokehood)
Figure 201/25-64-01-990-801 (Sheet 1 of 2)**

EFFECTIVITY
ARO 001-013

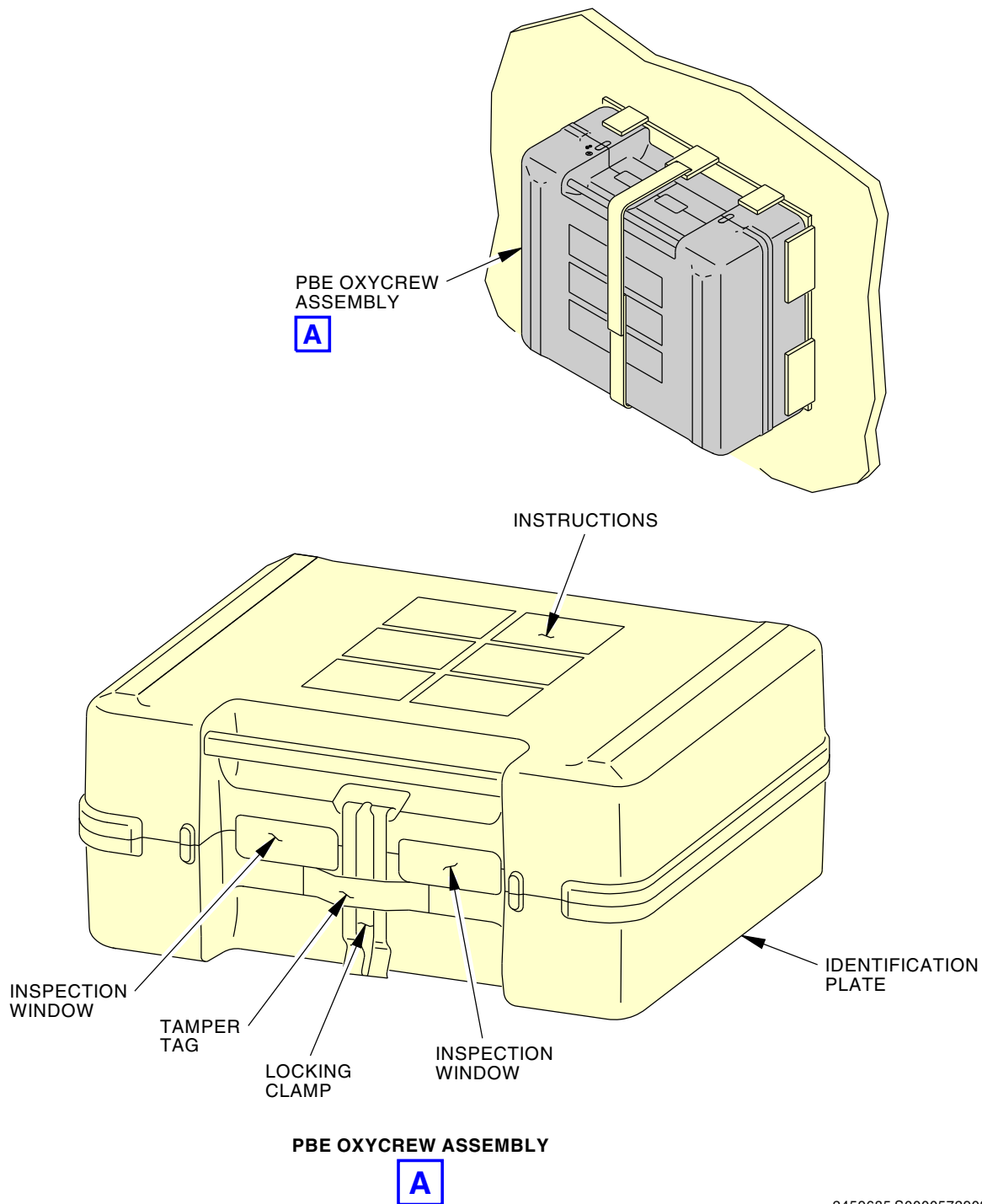
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25-64-01

Page 203
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



2459685 S0000572908_V2

Protective Breathing Equipment (Smokehood)
Figure 201/25-64-01-990-801 (Sheet 2 of 2)

EFFECTIVITY
ARO 014-999

25-64-01

D633W101-ARO

Page 204
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-64-01-960-801

3. Smoke Hood Replacement

(Figure 201)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-01-960-001

- (1) Replace the smoke hoods at the manufacturers recommended life limit.

————— **END OF TASK** —————

TASK 25-64-01-210-801

4. Detachable Emergency Equipment Visual Check

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-01-210-006

- (1) Make sure the following pieces of emergency equipment are installed in the applicable locations and have no visible defects:

NOTE: Use the standard method of your airline to do this check.

- (a) Gloves
- (b) Smoke goggles
- (c) Crash ax
- (d) Flash lights
- (e) First aid kits
- (f) Medical kits
- (g) Portable oxygen masks
- (h) Extension seat belts
- (i) Fire extinguishers
- (j) Fire gloves
- (k) Oxygen bottles

————— **END OF TASK** —————

TASK 25-64-01-710-801

5. Flashlight Operational Test

(Figure 202)

NOTE: This procedure is a scheduled maintenance task.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-64-01

Page 205
Jan 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

ARO ALL; AIRPLANES WITH DME EF-1 FLASHLIGHTS

B. Flashing LED

SUBTASK 25-64-01-010-001

- (1) Remove the tamper shield if it is installed.

SUBTASK 25-64-01-020-001

- (2) Remove the flashlight [1] from the mounting bracket.

SUBTASK 25-64-01-700-001

- (3) Make sure that the flashlight [1] operates correctly.
(a) If the light does not come on or is weak, refer to the table to identify the problem:

Symptom	Probable Cause	Corrective Action
LED is not flashing.	Battery is depleted.	Replace battery at next opportunity.
	Lamp is burned out.	Replace lamp.
	LED is inoperative.	Return unit for service.
	Defective Bracket. Flashlight did not turn off when installed in bracket.	Return entire system to factory for check.
LED is flashing at interval of 10 seconds or greater.	Battery is at or beyond cutoff point.	Replace battery within 10 days.
Flashlight does not turn on when removed from bracket.	Unauthorized use of flashlight. Battery depleted.	Replace battery.
	Lamp is burned out.	Replace lamp.
	Battery pack not installed or connected.	Check battery and connection.
	Broken contacts in flashlight body.	Return flashlight for service.
	Defective bracket. Flashlight did not turn off when installed in bracket.	Return entire system to factory for check.

SUBTASK 25-64-01-420-001

- (4) Install the flashlight [1] on the mounting bracket.

NOTE: Make sure that the red flashing light is visible.

SUBTASK 25-64-01-420-012

- (5) Install a new tamper shield.

———— **END OF TASK** ————

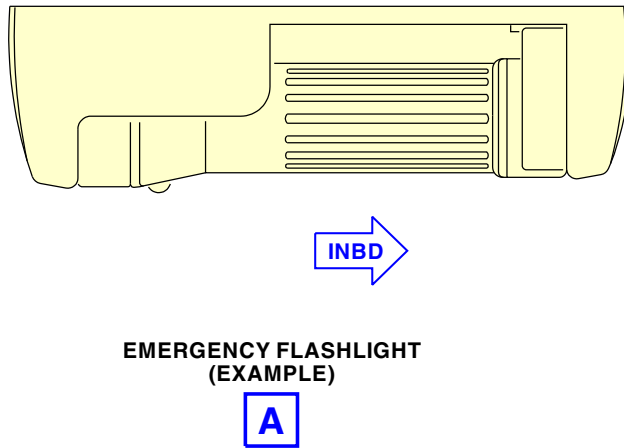
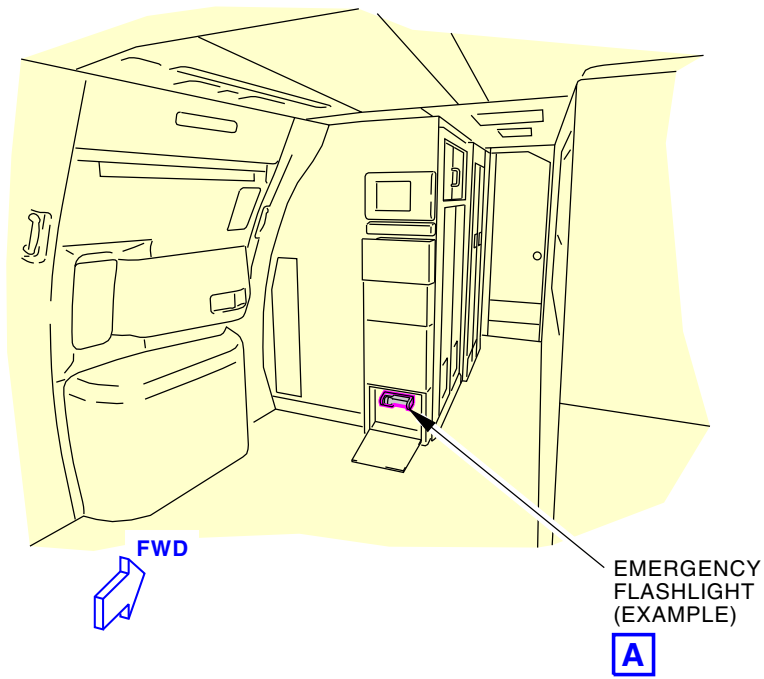
EFFECTIVITY
ARO ALL

25-64-01

D633W101-ARO

Page 206
Jan 05/2016

777-200/300
AIRCRAFT MAINTENANCE MANUAL



D18598 S0006411435_V2

Emergency Flashlight
Figure 202/25-64-01-990-802

EFFECTIVITY
ARO ALL

D633W101-ARO

25-64-01

Page 207
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

ARO ALL; AIRPLANES WITH DME EF-1 FLASHLIGHTS (Continued)

TASK 25-64-01-960-802

6. Flashlight Battery Replacement

(Figure 202)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Flashlight Battery Replacement

SUBTASK 25-64-01-020-002

- (1) Carefully remove the tamper shield if it is installed.
 - (a) Discard the tamper shield.

SUBTASK 25-64-01-020-003

- (2) Remove the flashlight [1] from the mounting bracket.

SUBTASK 25-64-01-020-004

- (3) Remove the bottom cap assembly

SUBTASK 25-64-01-020-005

- (4) Remove the O-ring.
 - (a) Discard the O-ring as required.

SUBTASK 25-64-01-020-006

- (5) Remove the old battery pack from the flashlight tube.

SUBTASK 25-64-01-420-005

- (6) Install the new battery pack in the flashlight tube.

SUBTASK 25-64-01-860-002

- (7) Make sure that the battery pack is in the correct position.

NOTE: The battery contacts will face the flashlight head.

SUBTASK 25-64-01-860-003

- (8) Make sure that the battery pack sits against the flashlight head assembly.

SUBTASK 25-64-01-420-006

- (9) Install the new or original O-ring on the flashlight tube.

SUBTASK 25-64-01-420-007

- (10) Install the bottom cap assembly.
 - (a) Tighten the bottom cap assembly manually.

SUBTASK 25-64-01-420-008

- (11) Install the flashlight [1] in the mounting bracket.

SUBTASK 25-64-01-420-009

- (12) Install a new tamper shield if it is necessary.

————— END OF TASK —————

EFFECTIVITY
ARO ALL

25-64-01

D633W101-ARO

Page 208
Jan 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

ARO ALL; AIRPLANES WITH DME EF-1 FLASHLIGHTS (Continued)

TASK 25-64-01-200-804

7. Life Raft Inspection

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-01-200-011

- (1) Inspect the life rafts.
 - (a) Use the standard method of your airline to inspect the life rafts.

———— **END OF TASK** ————

TASK 25-64-01-960-803

8. Life Raft Restoration

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-01-960-003

- (1) Replace the life rafts.
 - (a) Use the standard method of your airline to replace the life rafts.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

25-64-01

D633W101-ARO

Page 209
Jan 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL
SAFETY EQUIPMENT - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.

TASK 25-64-01-200-805

2. Crash Axe - Inspection/Check

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Crash Axe Check

SUBTASK 25-64-01-212-003

- (1) Do a check for the presence and condition of the crash axes.

SUBTASK 25-64-01-860-001

- (2) Make sure that the mounting is secure.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-64-01

Page 601
May 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL
MEGAPHONE - MAINTENANCE PRACTICES

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) An operational test of the megaphone
 - (2) the megaphone battery replacement.
- C. The megaphones are used during emergencies by the attendants to provide instructions to the passengers.

TASK 25-64-02-710-801

2. Megaphone Operational Test

(Figure 201)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-02-020-001

- (1) Disconnect the clamp and remove the megaphone from the mounting bracket.

SUBTASK 25-64-02-710-001

- (2) Put the microphone near your mouth while you point the horn at the opposite end of the airplane.

SUBTASK 25-64-02-710-002

- (3) Push the trigger while you count slowly in a clear voice.

SUBTASK 25-64-02-710-003

- (4) Make sure your voice can be heard clearly by another person two passenger entry doors away.

SUBTASK 25-64-02-710-004

- (5) If the voice output is weak, do these steps:
 - (a) Do this task: Megaphone Battery Replacement, TASK 25-64-02-960-801.
 - (b) Do this task again: Megaphone Operational Test.
 - (c) If the voice output remains weak, replace the megaphone.

SUBTASK 25-64-02-420-001

- (6) Attach the megaphone on the mounting bracket with the clamp.

——— **END OF TASK** ———

EFFECTIVITY
ARO ALL

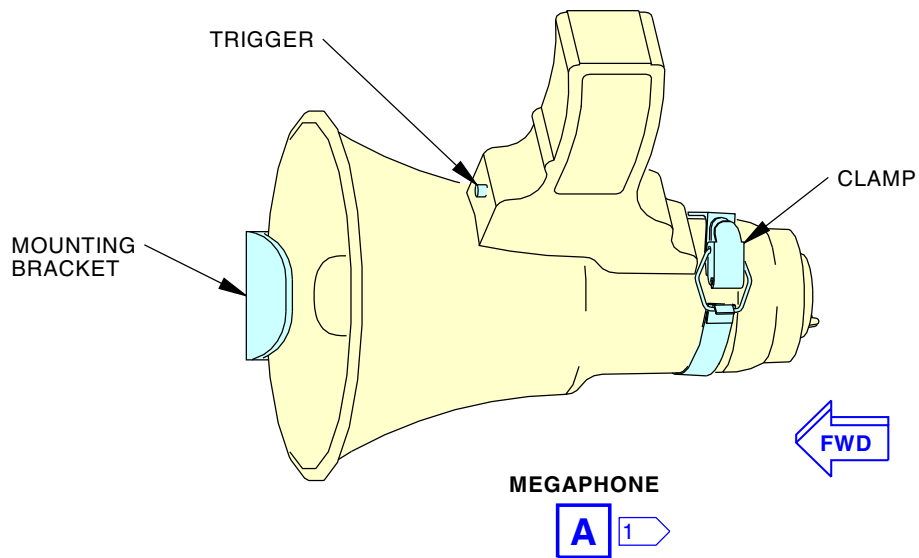
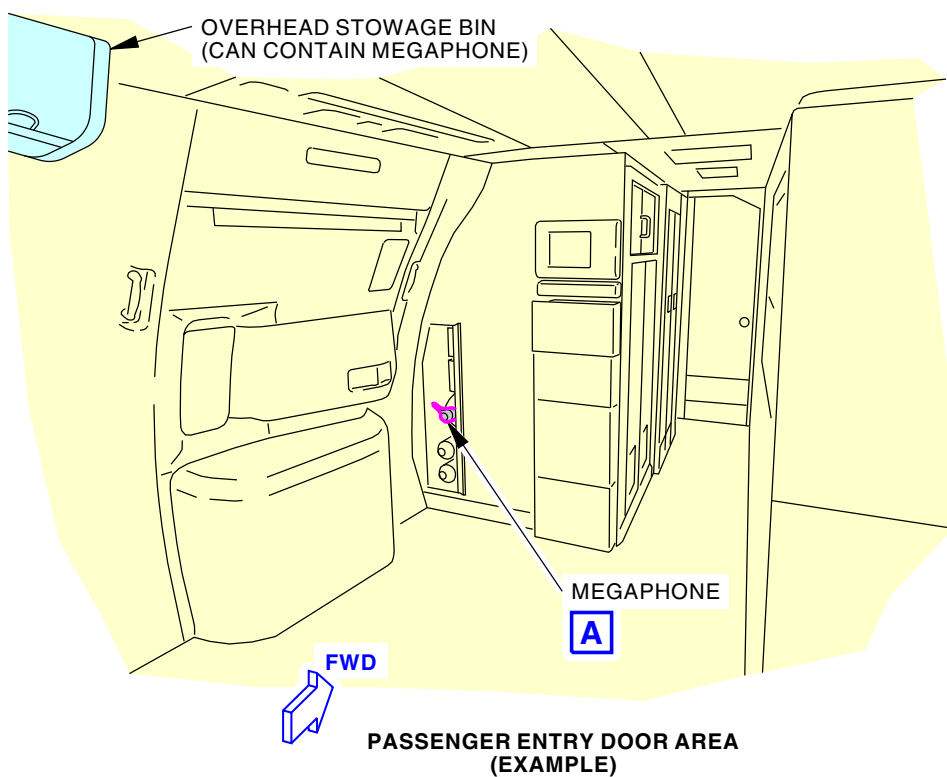
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25-64-02

Page 201
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL



1 THE MEGAPHONES ARE MOUNTED
IN STOWAGE COMPARTMENTS

D08103 S0006411445_V3

Megaphone Maintenance Practices
Figure 201/25-64-02-990-801

EFFECTIVITY
ARO ALL

25-64-02

D633W101-ARO

Page 202
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-64-02-960-801

3. **Megaphone Battery Replacement**

(Figure 201)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

ARO ALL; AIRPLANES WITH CABLEFORM OR FEDERAL SIGNAL MEGAPHONES

SUBTASK 25-64-02-960-001

- (1) Replace the megaphone batteries.

ARO ALL; AIRPLANES WITH ACR MEGAPHONES

SUBTASK 25-64-02-960-002

- (2) Replace the megaphone batteries (Figure 202). Install the batteries in the direction shown on the megaphone.

ARO ALL

————— **END OF TASK** —————

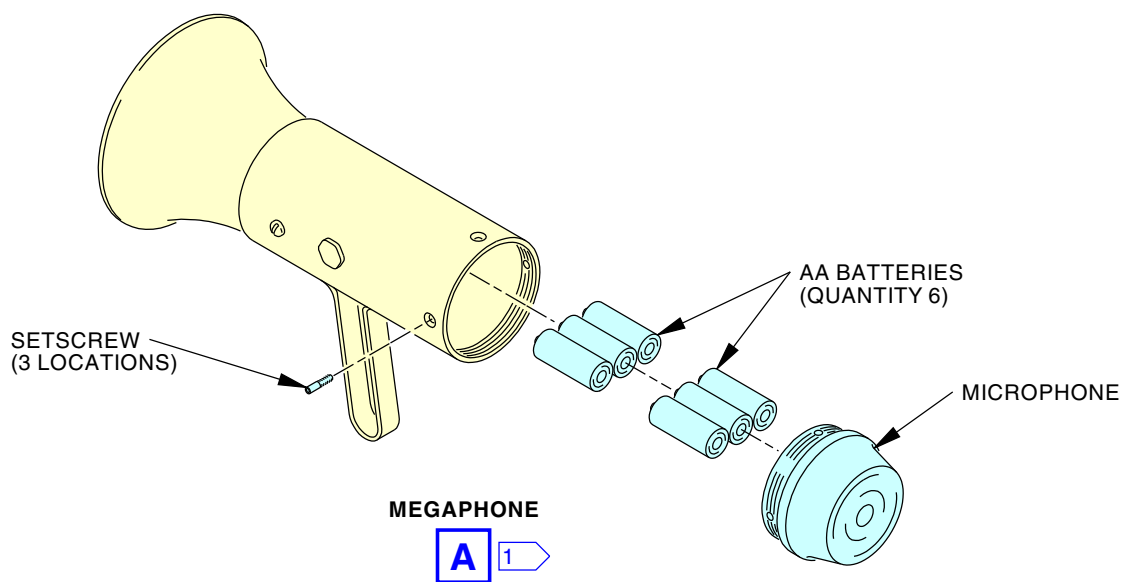
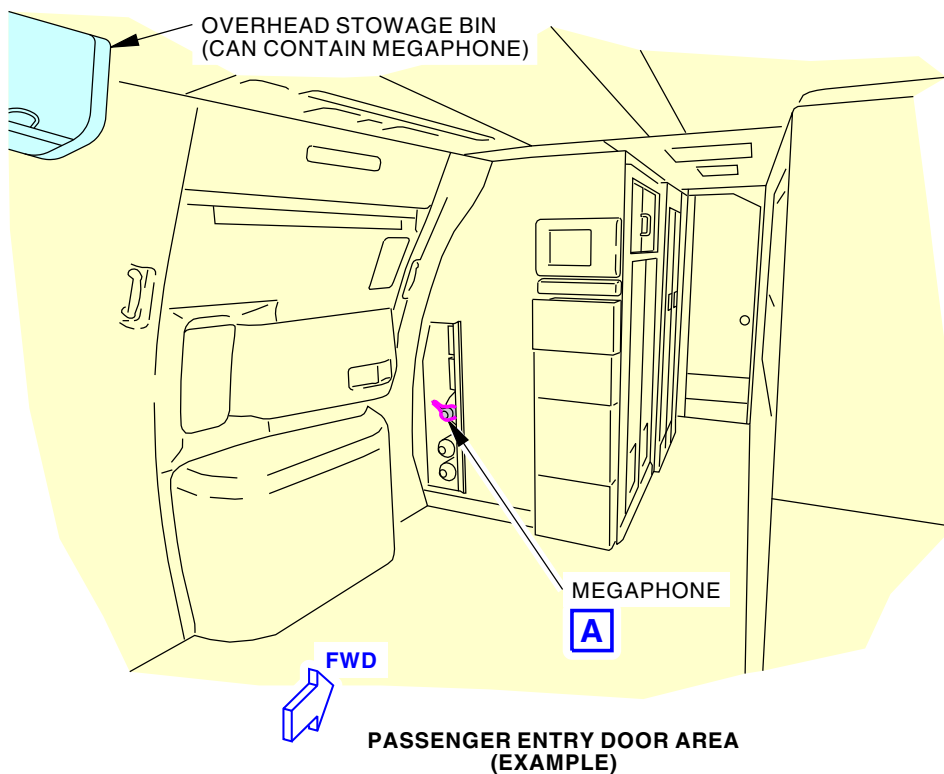
EFFECTIVITY
ARO ALL

D633W101-ARO

25-64-02

Page 203
May 05/2015

777-200/300
AIRCRAFT MAINTENANCE MANUAL



1 THE MEGAPHONES ARE MOUNTED
IN STOWAGE COMPARTMENTS

G34201 S0006411447_V3

Megaphone Battery Replacement
Figure 202/25-64-02-990-802 (Sheet 1 of 2)

EFFECTIVITY
ARO ALL; AIRPLANES WITH ACR MEGAPHONES

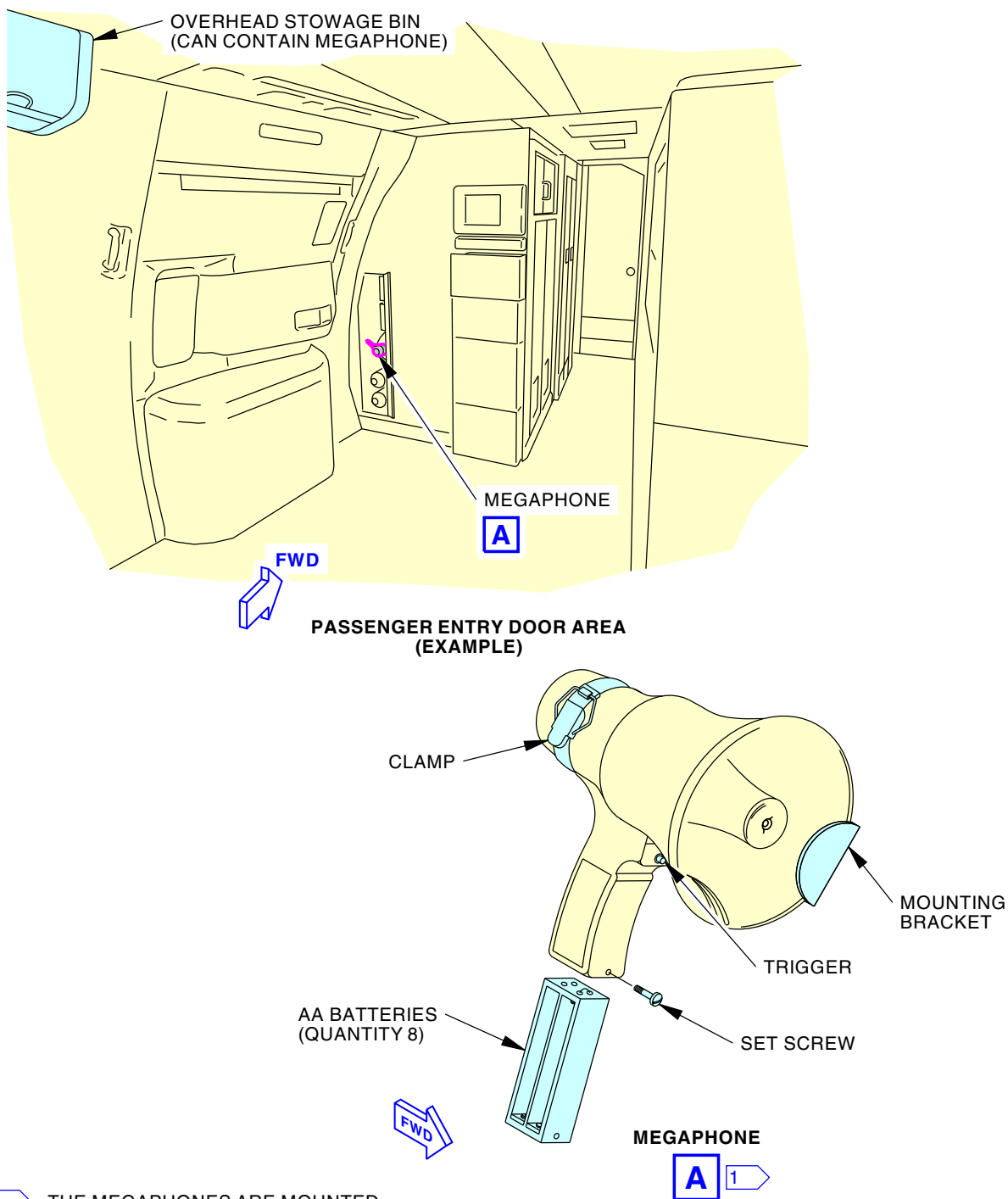
D633W101-ARO

25-64-02

Page 204
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



2417652 S0000558666_V2

Megaphone Battery Replacement
Figure 202/25-64-02-990-802 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL; AIRPLANES WITH CABLEFORM OR
FEDERAL SIGNAL MEGAPHONES

D633W101-ARO

25-64-02

Page 205
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
MEDICAL KIT - MAINTENANCE PRACTICES

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has a task to replace the medical kit in the passenger compartment or flight compartment.

TASK 25-64-50-960-802

2. Medical Kit Replacement

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
200	Upper Half of Fuselage

B. Procedure

SUBTASK 25-64-50-020-003

- (1) Remove the medical kit from the storage box, bracket, or storage compartment.

SUBTASK 25-64-50-210-003

- (2) Do a check of the seal on the medical kit.

SUBTASK 25-64-50-960-004

- (3) If the seal is broken, replace the medical kit with a new presealed medical kit.

SUBTASK 25-64-50-210-004

- (4) Do a check of the expiration date on the medical kit.

SUBTASK 25-64-50-960-005

- (5) Use the standard method of your airline to replace the medical kits as necessary.

SUBTASK 25-64-50-020-004

- (6) Install the medical kit in the storage box, bracket, or storage compartment.

SUBTASK 25-64-50-390-002

- (7) If the medical kit is in a storage box, put a new seal on the storage box.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-64-50

Config 1
Page 201
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

FIRST AID KIT - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has the task to examine the first aid kit.

TASK 25-64-50-200-803

2. First Aid Kit Examination

NOTE: This procedure is a scheduled maintenance task.

A. **Location Zones**

Zone	Area
200	Upper Half of Fuselage

B. **First Aid Kit Examination**

SUBTASK 25-64-50-212-001

- (1) Do a check for the security mounting.

SUBTASK 25-64-50-212-002

- (2) Do a check for the seal.

SUBTASK 25-64-50-860-001

- (3) Make sure that the seal is intact.

SUBTASK 25-64-50-860-003

- (4) Replace the first aid kit if the seal is broken.

SUBTASK 25-64-50-210-005-002

- (5) Do a check of the expiration date on the first aid kit.

SUBTASK 25-64-50-860-004-002

- (6) Make sure that there is more than three months of time remaining before the next inspection.
 - (a) If there is less than three months remaining, replace the first aid kit with a serviceable first aid kit.

———— **END OF TASK** ————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-64-50

Config 2
Page 601
May 05/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL

AUTOMATED EXTERNAL DEFIBRILLATOR - REMOVAL/INSTALLATION

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has the removal and installation task for the Automated External Defibrillator.

TASK 25-64-53-020-801

2. Automated External Defibrillator Removal

NOTE: This procedure is a scheduled maintenance task.

A. Access

- (1) Locate the automated external defibrillator.

B. Location Zones

Zone	Area

200	Upper Half of Fuselage

C. Automated External Defibrillator Removal

SUBTASK 25-64-53-020-001

- (1) Remove the Automated External Defibrillator from the airplane.

SUBTASK 25-64-53-902-001

- (2) Restore the Automated External Defibrillator to a serviceable condition per the vendor recommendations.

————— END OF TASK —————

TASK 25-64-53-420-801

3. Automated External Defibrillator Installation

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

200	Upper Half of Fuselage

B. Automated Defibrillator Installation

SUBTASK 25-64-53-420-001

- (1) Install the Automated External Defibrillator on the airplane.

C. Automated Defibrillator Post Installation Test

SUBTASK 25-64-53-700-001

- (1) Put the button to the ON position.

SUBTASK 25-64-53-700-002

- (2) Do a check for the normal operation on the LCD screen.

SUBTASK 25-64-53-800-001

- (3) Put the button to the OFF position to turn off the unit.

SUBTASK 25-64-53-800-002

- (4) Make sure that the unit is secure.

————— END OF TASK —————

EFFECTIVITY
ARO ALL

25-64-53

D633W101-ARO

Page 401
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

OFF-WING ESCAPE SYSTEM - MAINTENANCE PRACTICES

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) Off-wing escape system - deactivation.
 - (2) Off-wing escape system - activation.
 - (3) Disarm the off-wing escape system.
 - (4) Arm the off-wing escape system.
 - (5) Release the gas from the escape slide inflation bottle (if the squib was fired with the safety pin installed).
 - (6) Put the off-wing escape system back to its initial condition after a deployment of the escape slide.

TASK 25-65-00-040-802

2. Off-Wing Escape System - Deactivation

(Figure 201)

A. **General**

- (1) This task will deactivate the off-wing escape system.

B. **References**

Reference	Title
25-21-08-000-801	Overdoor Panel Opening/Removal (P/B 201)

C. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-1525	Platform - Work, General Purpose Part #: 1190-8000 Supplier: 00994 Opt Part #: 8601-010 Supplier: 00994 Opt Part #: AM-2849 Supplier: 9M323 Opt Part #: MODEL 137 Supplier: 2S363
STD-858	Tag - DO NOT OPERATE

D. **Location Zones**

Zone	Area
195	Underwing Wing-to-Body Fairings, Left
196	Underwing Wing-to-Body Fairings, Right
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right
211	Flight Compartment, Left
212	Flight Compartment, Right
243	Area Above Passenger Compartment Ceiling, Left - Section 44
244	Area Above Passenger Compartment Ceiling, Right - Section 44
833	Left No. 3 Overwing Door - Section 44

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-00

Page 201
Jan 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Zone	Area
843	Right No. 3 Overwing Door - Section 44

E. Access Panels

Number	Name/Location
197DL	Air-Driven Pump (ADP) Filter Module Access Door and Escape Slide Inflation Bottle
198DR	Hydraulic Ground Service Bay Access Door and Escape Slide Inflation Bottle

F. Procedure

SUBTASK 25-65-00-860-013



KEEP PERSONNEL AND EQUIPMENT AWAY FROM THE FLIGHT CONTROL SURFACES, THE THRUST REVERSERS, DRIVE MECHANISMS AND THE LANDING GEAR. THESE COMPONENTS CAN MOVE SUDDENLY WHEN YOU OPERATE THEM WITH ELECTRICAL OR HYDRAULIC POWER. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.



BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

- (1) Open these circuit breakers and install safety tags:

Left Power Management Panel, P110

Row	Col	Number	Name
H	15	C52612	L EPAS BACKUP BAT

Overhead Circuit Breaker Panel, P11

Row	Col	Number	Name
H	16	C33621	EMERGENCY LIGHTS DOOR 3L
H	17	C33620	EMERGENCY LIGHTS DOOR 3R

Right Power Management Panel, P210

Row	Col	Number	Name
J	14	C52613	R EPAS BACKUP BAT

SUBTASK 25-65-00-040-006

- (2) Deactivate the overwing emergency exit door (PED 3) as follows:
- (a) Put the overwing door mode select handle in the MANUAL/DISARM position.
 - 1) Install a DO NOT OPERATE tag, STD-858 on the mode select lever.

SUBTASK 25-65-00-040-007

- (3) Deactivate the backup battery for the off-wing escape system as follows:
- (a) Open the overdoor panel to get access to the backup battery above the PED 3 door.
 - 1) Do this task: Overdoor Panel Opening/Removal, TASK 25-21-08-000-801.
 - (b) Turn the safety switch for the backup battery to the DISARM position.
 - 1) Install a DO NOT OPERATE tag, STD-858 on the backup battery safety switch.

SUBTASK 25-65-00-040-008

- (4) Deactivate the inflation bottle for the escape slide as follows:

EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 202
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (a) For the left and right wing, open these access panels:

<u>Number</u>	<u>Name/Location</u>
197DL	Air-Driven Pump (ADP) Filter Module Access Door and Escape Slide Inflation Bottle
198DR	Hydraulic Ground Service Bay Access Door and Escape Slide Inflation Bottle

- (b) Open the forward end of the insulation blanket that is around the inflation bottle.
(c) Remove the safety pin from the storage pouch on the inflation bottle.
(d) Install the safety pin in the pressure regulator on the inflation bottle.
(e) Install a DO NOT OPERATE tag, STD-858 on the safety switch.

SUBTASK 25-65-00-040-009

- (5) Deactivate the latch actuator for the escape slide compartment door as follows:
- (a) Put the work platform, COM-1525 outboard of the slide compartment door.
(b) Open the access panel to get access to the latch actuator.
(c) Pull the mode select lever on the latch actuator outboard and up until it turns 90 degrees.
(d) Install a DO NOT OPERATE tag, STD-858 on the mode select lever.

G. Off-Wing Escape System - Tryout

NOTE: This tryout is to make sure that the off-wing escape system is in a zero energy state.

SUBTASK 25-65-00-860-014

- (1) Make sure that the overwing door select handle is in the MANUAL/DISARMED position and DO NOT OPERATE tag, STD-858 is installed.
(2) Make sure that the safety pin in the pressure regulator on the inflation bottle and DO NOT OPERATE tag, STD-858 are installed.
(3) Make sure that the mode select lever on the latch actuator is in the up and outboard position and that the DO NOT OPERATE tag, STD-858 is installed.

———— **END OF TASK** ————

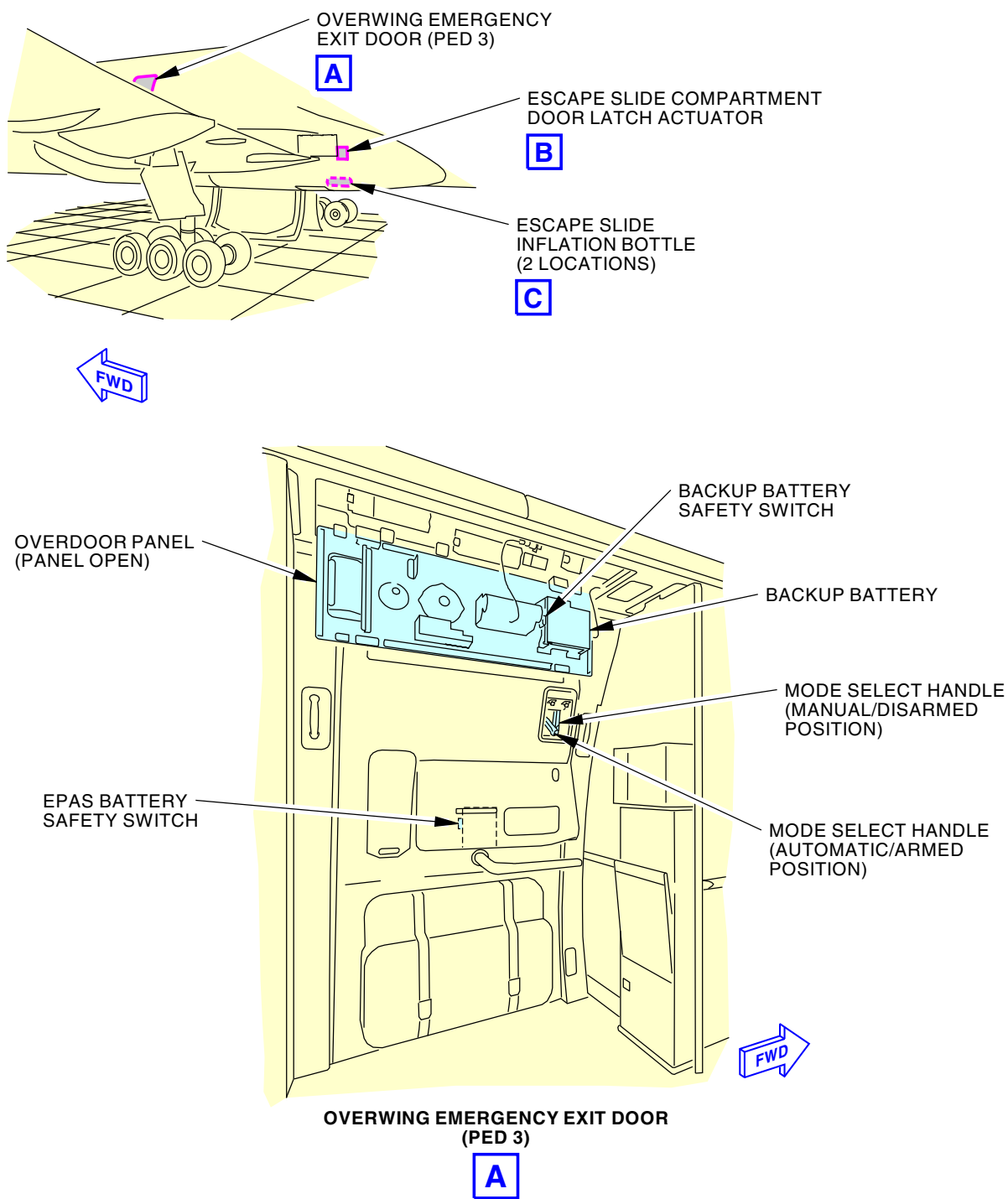
EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 203
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



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Off-Wing Escape System
Figure 201/25-65-00-990-808 (Sheet 1 of 3)

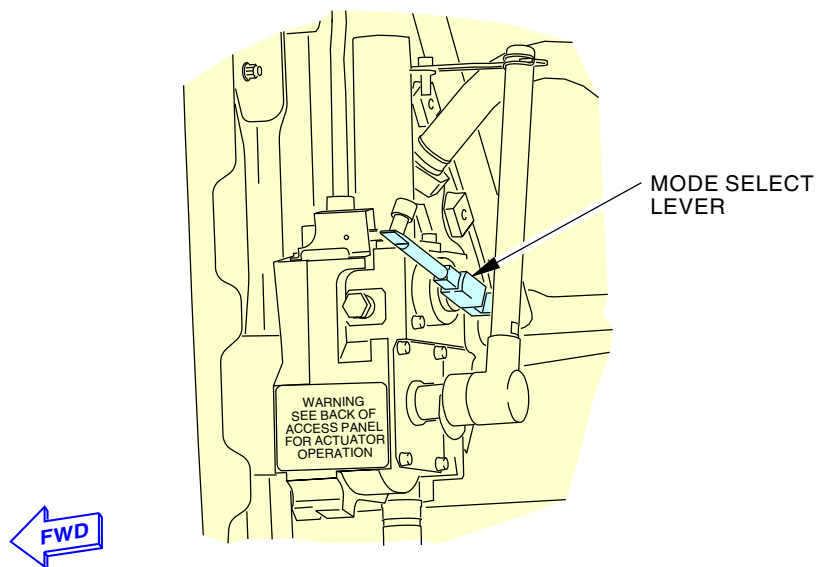
EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

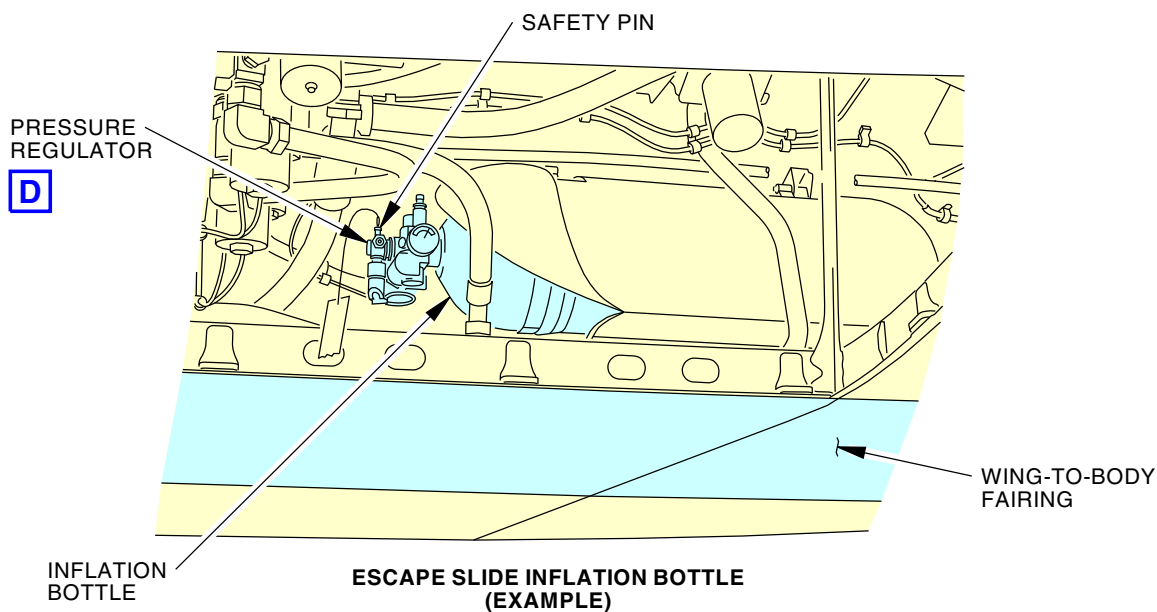
Page 204
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**ESCAPE SLIDE COMPARTMENT
DOOR LATCH ACTUATOR
(DISARMED POSITION)**

B



**ESCAPE SLIDE INFLATION BOTTLE
(EXAMPLE)**

C

2416699 S0000557671_V2

**Off-Wing Escape System
Figure 201/25-65-00-990-808 (Sheet 2 of 3)**

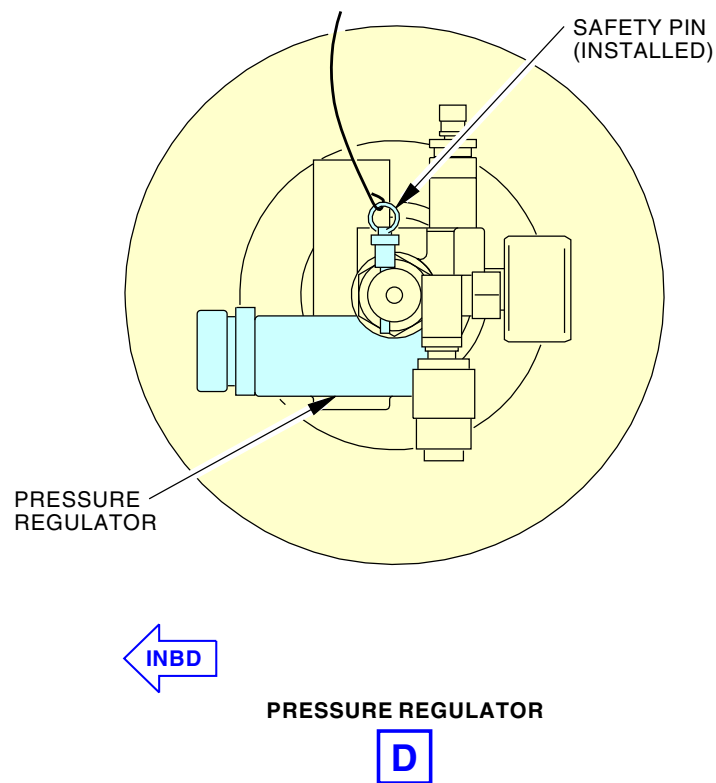
EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-00

Page 205
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Off-Wing Escape System
Figure 201/25-65-00-990-808 (Sheet 3 of 3)

	EFFECTIVITY	
	ARO ALL	

D633W101-ARO

25-65-00

Page 206
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-65-00-440-802

3. Off-Wing Escape System - Activation

(Figure 201)

A. General

- (1) This task will activate the off-wing escape system.

B. References

Reference	Title
25-21-08-400-801	Overdoor Panel Installation/Closing (P/B 201)
25-65-10-400-801	Close the Escape Slide Compartment Door (P/B 201)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-1525	Platform - Work, General Purpose Part #: 1190-8000 Supplier: 00994 Opt Part #: 8601-010 Supplier: 00994 Opt Part #: AM-2849 Supplier: 9M323 Opt Part #: MODEL 137 Supplier: 2S363
STD-858	Tag - DO NOT OPERATE

D. Location Zones

Zone	Area
195	Underwing Wing-to-Body Fairings, Left
196	Underwing Wing-to-Body Fairings, Right
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right
211	Flight Compartment, Left
212	Flight Compartment, Right
243	Area Above Passenger Compartment Ceiling, Left - Section 44
244	Area Above Passenger Compartment Ceiling, Right - Section 44
833	Left No. 3 Overwing Door - Section 44
843	Right No. 3 Overwing Door - Section 44

E. Access Panels

Number	Name/Location
197DL	Air-Driven Pump (ADP) Filter Module Access Door and Escape Slide Inflation Bottle
198DR	Hydraulic Ground Service Bay Access Door and Escape Slide Inflation Bottle

F. Procedure

SUBTASK 25-65-00-440-008

- (1) Activate the latch actuator door for the escape slide compartment door as follows:
- (a) Push the mode select lever on the latch actuator inboard and down until it turns 90 degrees.
 - (b) Close the access panel for the latch actuator.
 - 1) Do this task: Close the Escape Slide Compartment Door, TASK 25-65-10-400-801.

EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 207
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (c) Remove the work platform, COM-1525.

SUBTASK 25-65-00-440-009



MAKE SURE THAT IT IS SAFE TO REMOVE THE SAFETY PIN FROM THE PRESSURE REGULATOR ON THE BOTTLE. THE SQUIB ON THE BOTTLE WITH THE INSTALLED SAFETY PIN CAN ACCIDENTALLY FIRE. WHEN YOU REMOVE THE SAFETY PIN, THE ESCAPE SLIDE WILL OPEN. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (2) Activate the escape slide inflation bottle as follows:
- (a) Remove the DO NOT OPERATE tag, STD-858 from the pressure regulator valve safety pin.
 - (b) Remove the safety pin from the pressure regulator valve.
 - (c) Put the safety pin into the storage pouch on the inflation bottle.
 - (d) Close the insulation blanket that is around the inflation bottle.
 - (e) For the left and right wing, close these access panels:

<u>Number</u>	<u>Name/Location</u>
197DL	Air-Driven Pump (ADP) Filter Module Access Door and Escape Slide Inflation Bottle
198DR	Hydraulic Ground Service Bay Access Door and Escape Slide Inflation Bottle

SUBTASK 25-65-00-440-010

- (3) Activate the backup battery for the off-wing escape system as follows:
- (a) Remove the DO NOT OPERATE tag, STD-858 from the back battery safety switch.
 - (b) Turn the safety switch for the backup battery to the ARM position.
 - (c) Close the overdoor panel for the backup battery above PED 3.
 - 1) Do this task: Overdoor Panel Installation/Closing, TASK 25-21-08-400-801.

SUBTASK 25-65-00-440-011

- (4) Activate the overwing emergency exit door (PED 3) as follows:
- (a) Remove the DO NOT OPERATE tag, STD-858 on the mode select lever.
 - (b) Put the overwing door mode select handle in the ARM position.
 - (c) Make sure that the passenger entry door is CLOSED and LATCHED.

SUBTASK 25-65-00-860-015



BE CAREFUL WHEN YOU DO WORK AROUND ENERGIZED PANELS. HIGH VOLTAGES CAN KILL YOU.

- (5) Remove the safety tags and close these circuit breakers:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	15	C52612	L EPAS BACKUP BAT

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-00

Page 208
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

Overhead Circuit Breaker Panel, P11

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	16	C33621	EMERGENCY LIGHTS DOOR 3L
H	17	C33620	EMERGENCY LIGHTS DOOR 3R

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	14	C52613	R EPAS BACKUP BAT

————— **END OF TASK** —————

TASK 25-65-00-040-801

4. Disarm the Off-Wing Escape System

(Figure 202)

A. References

<u>Reference</u>	<u>Title</u>
25-21-08-000-801	Overdoor Panel Opening/Removal (P/B 201)
52-12-25-000-802	Hinge Covers Removal (P/B 201)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

<u>Reference</u>	<u>Description</u>
COM-1525	Platform - Work, General Purpose Part #: 1190-8000 Supplier: 00994 Opt Part #: 8601-010 Supplier: 00994 Opt Part #: AM-2849 Supplier: 9M323 Opt Part #: MODEL 137 Supplier: 2S363

C. Location Zones

<u>Zone</u>	<u>Area</u>
195	Underwing Wing-to-Body Fairings, Left
196	Underwing Wing-to-Body Fairings, Right
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right
211	Flight Compartment, Left
212	Flight Compartment, Right
243	Area Above Passenger Compartment Ceiling, Left - Section 44
244	Area Above Passenger Compartment Ceiling, Right - Section 44
833	Left No. 3 Overwing Door - Section 44
843	Right No. 3 Overwing Door - Section 44

D. Access Panels

<u>Number</u>	<u>Name/Location</u>
197DL	Air-Driven Pump (ADP) Filter Module Access Door and Escape Slide Inflation Bottle
198DR	Hydraulic Ground Service Bay Access Door and Escape Slide Inflation Bottle

EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 209
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL

E. Disarm the Off-Wing Escape System Procedure

SUBTASK 25-65-00-865-001



KEEP PERSONNEL AND EQUIPMENT AWAY FROM THE FLIGHT CONTROL SURFACES, THE THRUST REVERSERS, DRIVE MECHANISMS AND THE LANDING GEAR. THESE COMPONENTS CAN MOVE SUDDENLY WHEN YOU OPERATE THEM WITH ELECTRICAL OR HYDRAULIC POWER. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (1) Open these circuit breakers and install safety tags:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	15	C52612	L EPAS BACKUP BAT

Overhead Circuit Breaker Panel, P11

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	16	C33621	EMERGENCY LIGHTS DOOR 3L
H	17	C33620	EMERGENCY LIGHTS DOOR 3R

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	14	C52613	R EPAS BACKUP BAT

SUBTASK 25-65-00-040-002

- (2) Disarm the overwing emergency exit door (PED 3) as follows:
 - (a) Make sure the mode select handle is in the MANUAL/DISARM position.
 - (b) Remove the aft hinge cover and the forward hinge cover from the applicable passenger entry door 3.
 - 1) Do this task: Hinge Covers Removal, TASK 52-12-25-000-802.
 - (c) Turn the safety switch for the EPAS battery to the DISARM position.

SUBTASK 25-65-00-040-003

- (3) Disarm the backup battery for the off-wing escape system as follows:
 - (a) Open the overdoor panel to get access to the backup battery above the PED 3 door.
 - 1) Do this task: Overdoor Panel Opening/Removal, TASK 25-21-08-000-801.
 - (b) Turn the safety switch for the backup battery to the DISARM position.

SUBTASK 25-65-00-040-004

- (4) Disarm the inflation bottle for the escape slide as follows:
 - (a) For the left and right wing, open these access panels:

<u>Number</u>	<u>Name/Location</u>
197DL	Air-Driven Pump (ADP) Filter Module Access Door and Escape Slide Inflation Bottle
198DR	Hydraulic Ground Service Bay Access Door and Escape Slide Inflation Bottle
 - (b) Open the forward end of the insulation blanket that is around the inflation bottle.
 - (c) Remove the safety pin from the storage pouch on the inflation bottle.
 - (d) Install the safety pin in the regulator on the inflation bottle.

EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 210
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-65-00-040-005

- (5) Disarm the latch actuator for the escape slide compartment door as follows:
- (a) Put the work platform, COM-1525 outboard of the slide compartment door.
 - (b) Open the access panel to get access to the latch actuator.
 - (c) Pull the mode select lever on the latch actuator outboard and up until it turns 90 degrees.

————— END OF TASK —————

TASK 25-65-00-440-801

5. Arm the Off-Wing Escape System

(Figure 202)

A. References

Reference	Title
25-21-08-400-801	Overdoor Panel Installation/Closing (P/B 201)
25-65-02-200-801	Inflation Bottle Pressure Check (P/B 601)
25-65-10-400-801	Close the Escape Slide Compartment Door (P/B 201)
52-12-25-400-802	Hinge Covers Installation (P/B 201)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-1525	Platform - Work, General Purpose Part #: 1190-8000 Supplier: 00994 Opt Part #: 8601-010 Supplier: 00994 Opt Part #: AM-2849 Supplier: 9M323 Opt Part #: MODEL 137 Supplier: 2S363

C. Location Zones

Zone	Area
195	Underwing Wing-to-Body Fairings, Left
196	Underwing Wing-to-Body Fairings, Right
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right
211	Flight Compartment, Left
212	Flight Compartment, Right
243	Area Above Passenger Compartment Ceiling, Left - Section 44
244	Area Above Passenger Compartment Ceiling, Right - Section 44
833	Left No. 3 Overwing Door - Section 44
843	Right No. 3 Overwing Door - Section 44

D. Access Panels

Number	Name/Location
197DL	Air-Driven Pump (ADP) Filter Module Access Door and Escape Slide Inflation Bottle
198DR	Hydraulic Ground Service Bay Access Door and Escape Slide Inflation Bottle

EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 211
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL

E. Arm the Off-Wing Escape System Procedure

SUBTASK 25-65-00-440-003

- (1) Arm the latch actuator for the escape slide compartment door as follows:
 - (a) Push the mode select lever on the latch actuator inboard and down until it turns 90 degrees.
 - (b) Close the access panel for the latch actuator.
 - 1) Do this task: Close the Escape Slide Compartment Door, TASK 25-65-10-400-801.
 - (c) Remove the work platform, COM-1525.

SUBTASK 25-65-00-440-004



MAKE SURE THAT IT IS SAFE TO REMOVE THE SAFETY PIN FROM THE PRESSURE REGULATOR ON THE BOTTLE. THE SQUIB ON THE BOTTLE WITH THE INSTALLED SAFETY PIN CAN ACCIDENTALLY FIRE. WHEN YOU REMOVE THE SAFETY PIN, THE ESCAPE SLIDE WILL OPEN. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (2) Arm the escape slide inflation bottle as follows:
 - (a) Make sure it is safe to remove the safety pin from the pressure regulator.
 - 1) Examine the pressure regulator to see if the warning indicator shows (red).

NOTE: If the warning indicator shows, the squib is fired.
 - 2) Examine the pressure gage to see if the inflation bottle is pressurized.
 - a) Do this task: Inflation Bottle Pressure Check, TASK 25-65-02-200-801.

NOTE: If the needle for the pressure gage is in the green area, the inflation bottle is fully pressurized. If the needle for the pressure gage is at the bottom of the red area, there is zero pressure in the inflation bottle.



RELEASE THE PRESSURE FROM THE BOTTLE BEFORE YOU REMOVE THE BOTTLE FROM THE AIRPLANE. IF THE BOTTLE SQUIB FIRED AND YOU ACCIDENTALLY REMOVE THE SAFETY PIN WHILE YOU REMOVE THE BOTTLE, PRESSURE WILL RELEASE. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

- 3) If the squib for the inflation bottle is fired and there is more than zero pressure in the inflation bottle, do these tasks in the order that follows:

NOTE: Do not replace the escape slide pack.

 - a) Do this task: Release the Gas From the Inflation Bottle for the Off-Wing Escape Slide, TASK 25-65-00-870-801
 - b) Do this task: Put the Off-Wing Escape System Back to its Initial Condition after Deployment, TASK 25-65-00-840-801.
- 4) If the squib is not fired, continue.
- (b) Remove the safety pin from the pressure regulator for the inflation bottle.
- (c) Put the safety pin into the storage pouch on the inflation bottle.
- (d) Close the insulation blanket that is around the inflation bottle.



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (e) For the left and right wing, close these access panels:

<u>Number</u>	<u>Name/Location</u>
197DL	Air-Driven Pump (ADP) Filter Module Access Door and Escape Slide Inflation Bottle
198DR	Hydraulic Ground Service Bay Access Door and Escape Slide Inflation Bottle

SUBTASK 25-65-00-440-005

- (3) Arm the backup battery for the off-wing escape system as follows:
- (a) Turn the safety switch for the backup battery to the ARM position.
 - (b) Close the overdoor panel for the backup battery above PED 3.
 - 1) Do this task: Overdoor Panel Installation/Closing, TASK 25-21-08-400-801.

SUBTASK 25-65-00-440-006

- (4) Arm the overwing emergency exit door (PED 3) as follows:
- (a) Turn the safety switch for the EPAS battery to the ARM position.
 - (b) Install the forward hinge cover and the aft hinge cover on the applicable passenger entry door 3.
 - 1) Do this task: Hinge Covers Installation, TASK 52-12-25-400-802.

NOTE: If the EPAS battery safety switch is in the DISARM position, the aft hinge cover will not be flush.
 - (c) Make sure the passenger entry door is CLOSED and LATCHED.

SUBTASK 25-65-00-865-002

- (5) Remove the safety tags and close these circuit breakers:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	15	C52612	L EPAS BACKUP BAT

Overhead Circuit Breaker Panel, P11

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	16	C33621	EMERGENCY LIGHTS DOOR 3L
H	17	C33620	EMERGENCY LIGHTS DOOR 3R

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	14	C52613	R EPAS BACKUP BAT

————— END OF TASK —————

TASK 25-65-00-870-801

6. Release the Gas From the Inflation Bottle for the Off-Wing Escape Slide

(Figure 202)

A. General

- (1) It is possible that the squib for the inflation bottle was accidentally fired while the safety pin was installed in the pressure regulator.
- (2) If that occurred, you must release the gas in the inflation bottle before you can safely remove it from the airplane.

EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 213
May 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL

B. Consumable Materials

Reference	Description	Specification
G02438	Wrap - Tie - TY24M (TY-RAP)	

C. Location Zones

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right

D. Procedure

SUBTASK 25-65-00-870-001

- (1) Release the pressure from the inflation bottle for the escape slide as follows:
 - (a) Open the insulation blanket around the inflation bottle.
 - (b) Install a plastic tie- TY24M (TY-RAP) tie wrap, G02438 to make sure the safety pin stays in the pressure regulator.
 - (c) Disconnect the electrical connector from the squib.
 - (d) Install a cap on the electrical connector for the wiring.
 - (e) Disconnect the inflation tube from the pressure regulator.
 - (f) Install caps and plugs on the inflation tube and the pressure regulator.
 - (g) Loosen the clamps that hold the inflation bottle.
 - (h) Turn the inflation bottle so the Schrader valve points away from personnel and the airplane structure.
 - (i) Tighten the clamps that hold the inflation bottle.
 - (j) Remove the cap from the Schrader valve.



WARNING

DO NOT TURN THE FITTING ON THE SCHRADER VALVE TOO MUCH. IF YOU DO NOT OBEY THIS INSTRUCTION, THE FITTING CAN QUICKLY DISENGAGE FROM THE SCHRADER VALVE, AND INJURY TO PERSONNEL OR DAMAGE TO EQUIPMENT CAN OCCUR.

- (k) Slowly turn the fitting on the Schrader valve until the gas in the inflation bottle starts to release.
- (l) Wait until all the gas in the inflation bottle releases.

NOTE: One hour can be necessary to release all the gas in the bottle.
- (m) Make sure the pressure gage shows zero pressure.
- (n) Tighten the fitting on the Schrader valve.
- (o) Re-install the cap on the Schrader valve.

————— END OF TASK —————

TASK 25-65-00-840-801

7. Put the Off-Wing Escape System Back to its Initial Condition after Deployment

(Figure 203)

NOTE: This procedure is a scheduled maintenance task.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-00

Page 214
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

A. References

Reference	Title
25-65-01-000-801	Escape Slide Pack Removal (P/B 401)
25-65-01-400-801	Escape Slide Pack Installation (P/B 401)
25-65-02-000-801	Inflation Bottle for the Off-Wing Escape Slide - Removal (P/B 401)
25-65-02-400-801	Inflation Bottle for the Off-Wing Escape Slide - Installation (P/B 401)
25-65-10-010-801	Open the Escape Slide Compartment Door (P/B 201)
27-61-13-000-801	SARD Cylinder Removal (P/B 401)
27-61-13-000-802	SARD Cartridge Removal (P/B 401)
27-61-13-000-803	SARD Cleaning (P/B 701)
27-61-13-400-801	SARD Cylinder Installation (P/B 401)
27-61-13-400-802	SARD Cartridge Installation (P/B 401)
52-12-19-200-801	Emergency Power Assist System (EPAS) Battery - Electrical Charge Check (PED 3) (P/B 601)
52-12-20-200-805	Emergency Power Assist System (EPAS) Battery - Electrical Charge Check (PED 1, 2, 4, 5) (P/B 601)
52-12-22-000-801	Emergency Power Assist System (EPAS) Reservoir Removal (P/B 401)
52-12-22-400-801	Emergency Power Assist System (EPAS) Reservoir Installation (P/B 401)
52-12-24-000-803	Off-Wing Escape System Backup Battery - Electrical Charge Check (P/B 601)

B. Location Zones

Zone	Area
195	Underwing Wing-to-Body Fairings, Left
196	Underwing Wing-to-Body Fairings, Right
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right
833	Left No. 3 Overwing Door - Section 44
843	Right No. 3 Overwing Door - Section 44

C. Prepare for the Procedure

SUBTASK 25-65-00-840-001

(1) Disarm the off-wing escape system as follows:

- Move the mode select handle for the overwing emergency exit door (PED 3) to the MANUAL/DISARM position.
- Turn the EPAS battery safety switch to the DISARM position.
NOTE: If the EPAS battery safety switch is in the DISARM position, the aft hinge cover will not be flush.
- Disarm the backup battery for the off-wing escape system as follows:
 - Open the overdoor panel above the cutout for the door.
 - Turn the safety switch on the backup battery to the DISARM position.

EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 215
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-65-00-010-002

- (2) Install the hold-open strap on the door for the off-wing escape slide compartment (TASK 25-65-10-010-801).

D. Procedure

SUBTASK 25-65-00-020-001

- (1) Remove the deployed escape slide as follows:



CAUTION

DO NOT DEFLATE THE ESCAPE SLIDE BY OPENING AN ASPIRATOR. DAMAGE TO THE ASPIRATOR CAN OCCUR.

- (a) Open the deflation valve on the escape slide to lower the pressure in the slide, then close the valve.

NOTE: Do not fully deflate the escape slide. Make sure the slide is soft, but keeps its shape.

- (b) Pull the red handle to open the cover for the "W" fitting.
- (c) Disconnect the inflation hose from the "W" fitting.
- (d) Disconnect the in-line electrical connector.
- (e) Pull the handle on the girt release cable on the escape slide cover to disengage the slide from the packboard.

NOTE: The cover will hang below the escape slide compartment after the escape slide deploys.

- (f) Carefully pull the escape slide off the trailing edge of the wing onto the ground.

NOTE: Two persons are required on the ground to catch the slide.

- (g) Fully deflate the escape slide as follows:

- 1) Open the deflation valve.



WARNING

DO NOT REMOVE THE PRESSURE RELIEF VALVE UNLESS THE ESCAPE SLIDE IS SOFT WHEN YOU TOUCH IT. IF YOU DO NOT OBEY THIS INSTRUCTION, INJURY TO PERSONS OR DAMAGE TO THE VALVE CAN OCCUR.

- 2) Loosen the band clamp that holds the pressure relief valve and remove the valve.
 - 3) When the escape slide is fully deflated, close the deflation valve and install the pressure relief valve with the band clamp.
- (h) Remove the packboard of the escape slide from the slide compartment.
 - 1) To remove it, do this task: Escape Slide Pack Removal, TASK 25-65-01-000-801.

SUBTASK 25-65-00-420-001

- (2) Replace the escape slide inflation bottle.

NOTE: Do not arm the off-wing escape system.

- (a) Do this task: Inflation Bottle for the Off-Wing Escape Slide - Removal, TASK 25-65-02-000-801,
- (b) Do this task: Inflation Bottle for the Off-Wing Escape Slide - Installation, TASK 25-65-02-400-801.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-00

Page 216
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-65-00-420-002

- (3) Do this task: Escape Slide Pack Installation, TASK 25-65-01-400-801.

NOTE: Do not arm the off-wing escape system.

SUBTASK 25-65-00-420-003

- (4) Replace the EPAS reservoir for the overwing emergency exit door (PED 3).

NOTE: Do not arm the off-wing escape system, and do not do a system test.

- (a) Do this task: Emergency Power Assist System (EPAS) Reservoir Removal, TASK 52-12-22-000-801.
- (b) Do this task: Emergency Power Assist System (EPAS) Reservoir Installation, TASK 52-12-22-400-801.

SUBTASK 25-65-00-420-004

- (5) Replace each SARD (Spoiler Auxiliary Retract Device) cylinder that has been fired 50 times.

- (a) Do this task: SARD Cylinder Removal, TASK 27-61-13-000-801.
- (b) Do this task: SARD Cylinder Installation, TASK 27-61-13-400-801.

SUBTASK 25-65-00-420-005

- (6) If the SARD cylinder has been fired less than 50 times, do these steps:

- (a) Do this task: SARD Cleaning, TASK 27-61-13-000-803.
- (b) Replace the SARD cartridge.
- 1) Do this task: SARD Cartridge Removal, TASK 27-61-13-000-802,
- 2) Do this task: SARD Cartridge Installation, TASK 27-61-13-400-802.

ARO ALL; AIRPLANES WITH THE S283W203-5 BATTERY

SUBTASK 25-65-00-720-003

- (7) Do this task: Emergency Power Assist System (EPAS) Battery - Electrical Charge Check (PED 3), TASK 52-12-19-200-801.

ARO ALL; AIRPLANES WITH THE S283W203-6 OR S283W203-7 BATTERY

SUBTASK 25-65-00-720-008

- (8) Do this task: Emergency Power Assist System (EPAS) Battery - Electrical Charge Check (PED 1, 2, 4, 5), TASK 52-12-20-200-805.

ARO ALL; AIRPLANES WITH THE S283W203-5 BATTERY

SUBTASK 25-65-00-720-004

- (9) Do this task: Off-Wing Escape System Backup Battery - Electrical Charge Check, TASK 52-12-24-000-803.

ARO ALL

SUBTASK 25-65-00-440-001

- (10) Do this task: Arm the Off-Wing Escape System, TASK 25-65-00-440-801.

————— END OF TASK —————

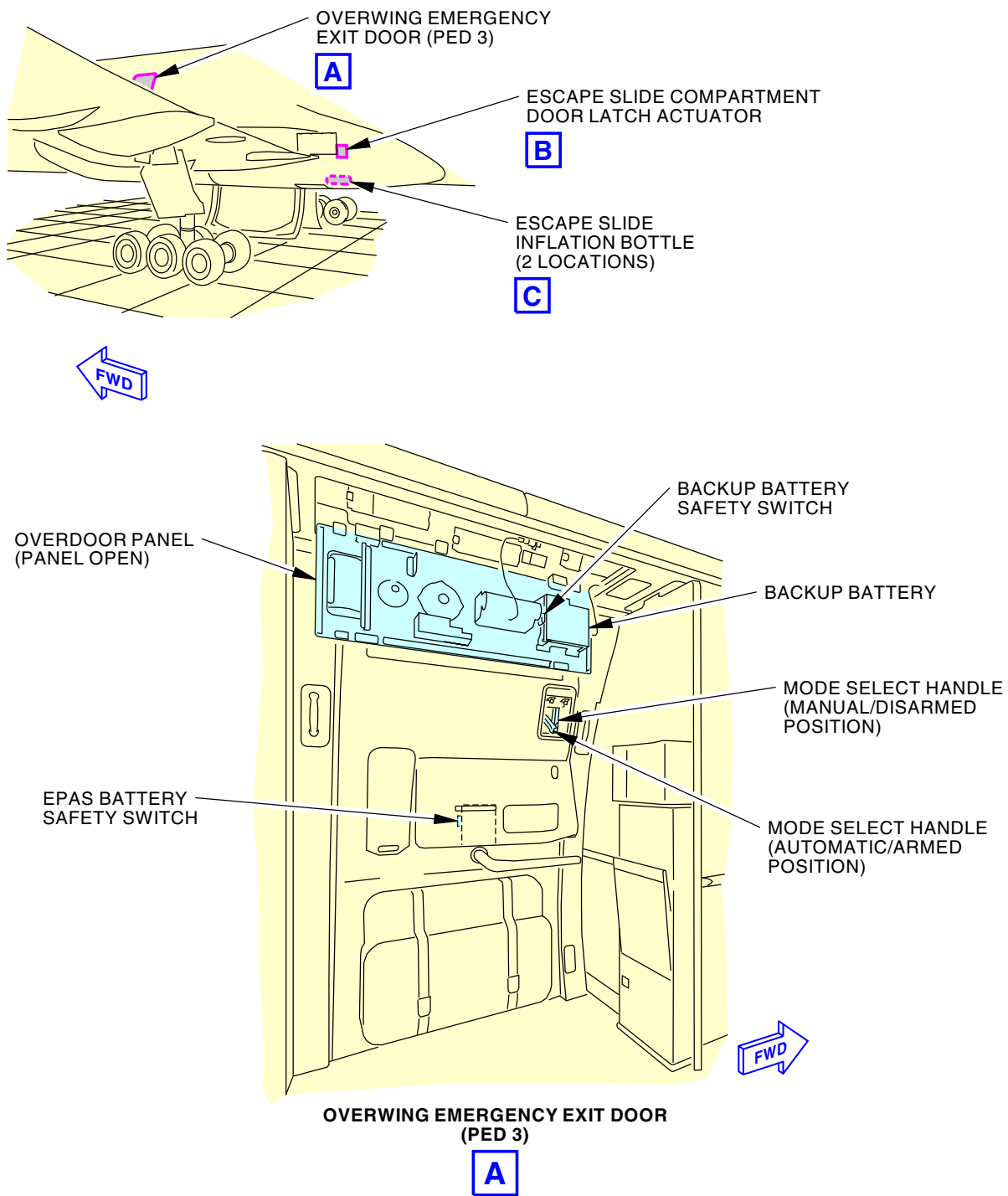
EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-00

Page 217
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



G52029 S0006411491_V3

Off-Wing Escape System
Figure 202/25-65-00-990-801 (Sheet 1 of 3)

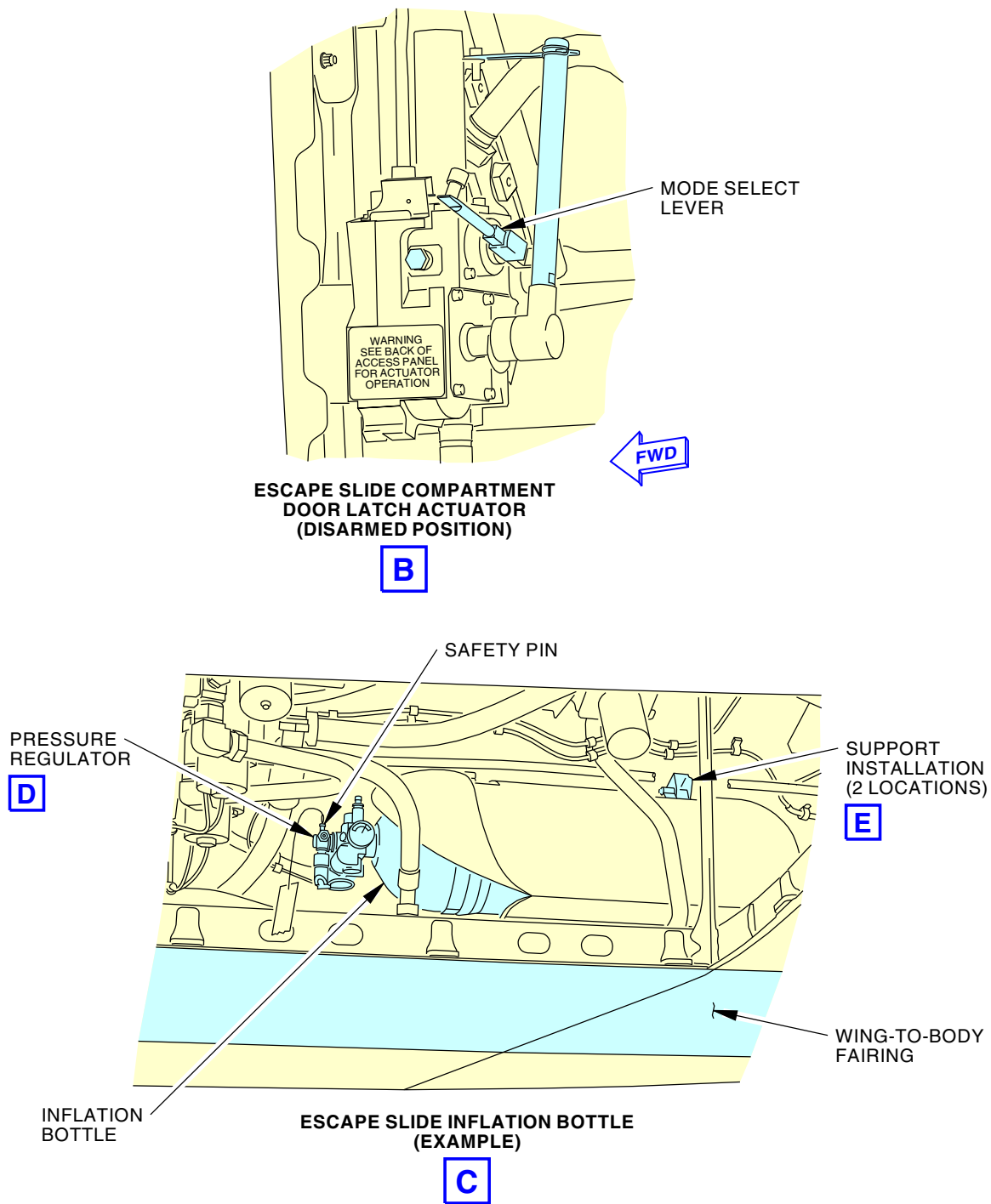
EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 218
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



G52038 S0006411492_V2

**Off-Wing Escape System
Figure 202/25-65-00-990-801 (Sheet 2 of 3)**

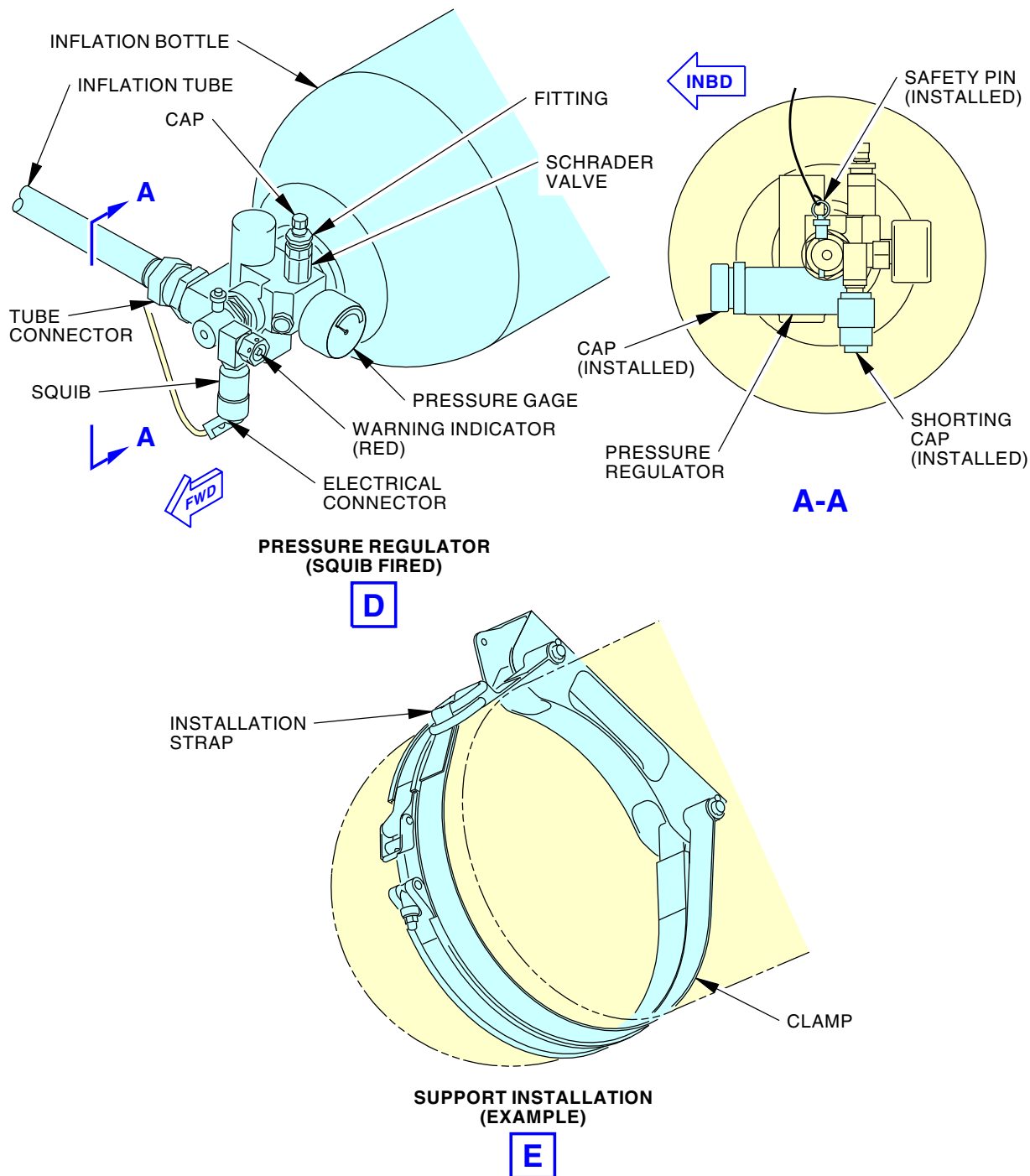
EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-00

Page 219
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



K30069 S0006411493_V3

**Off-Wing Escape System
Figure 202/25-65-00-990-801 (Sheet 3 of 3)**

EFFECTIVITY
ARO ALL

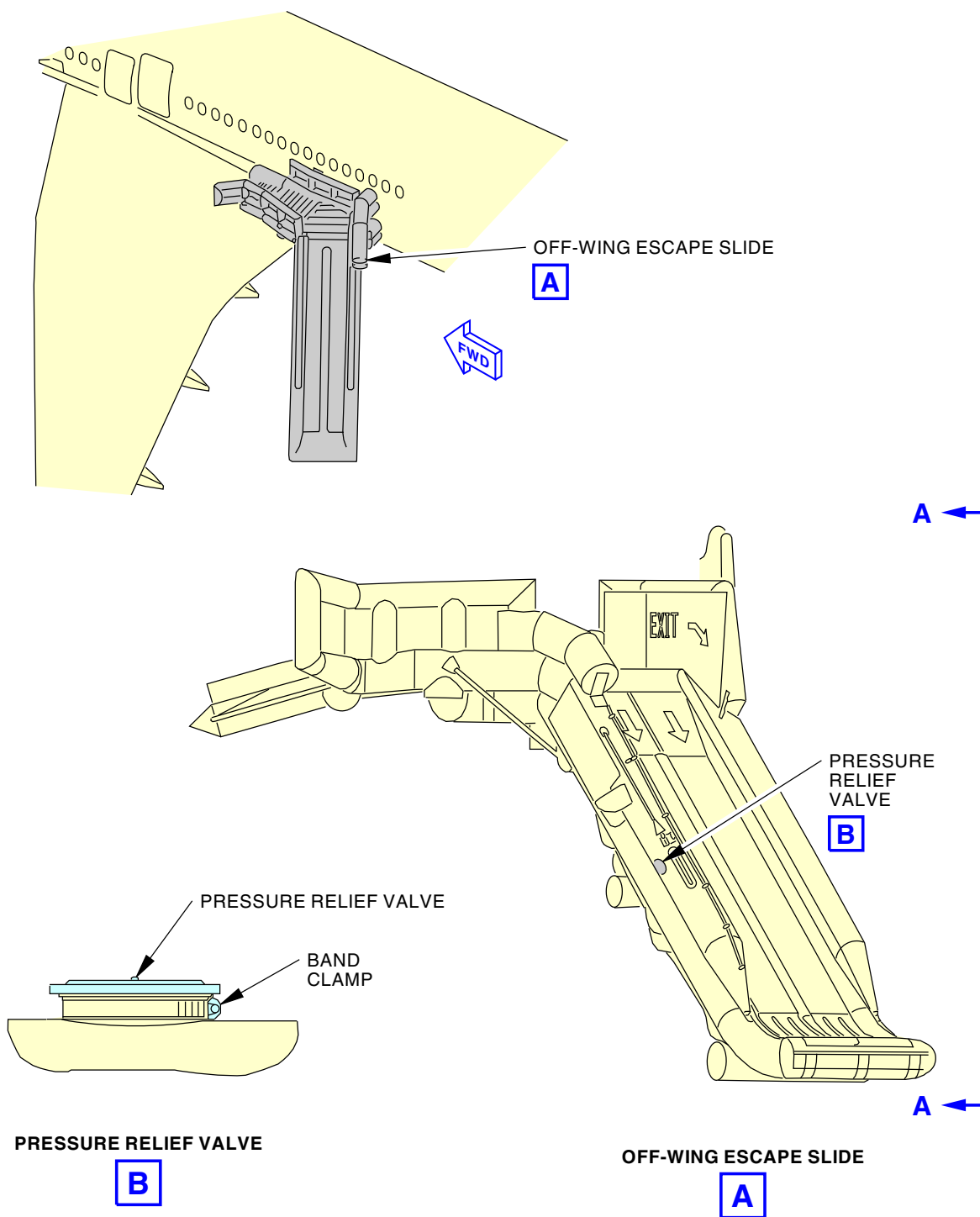
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D633W101-ARO

Page 220
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL



H02359 S0006411494_V2

Off-Wing Escape Slide
Figure 203/25-65-00-990-803 (Sheet 1 of 3)

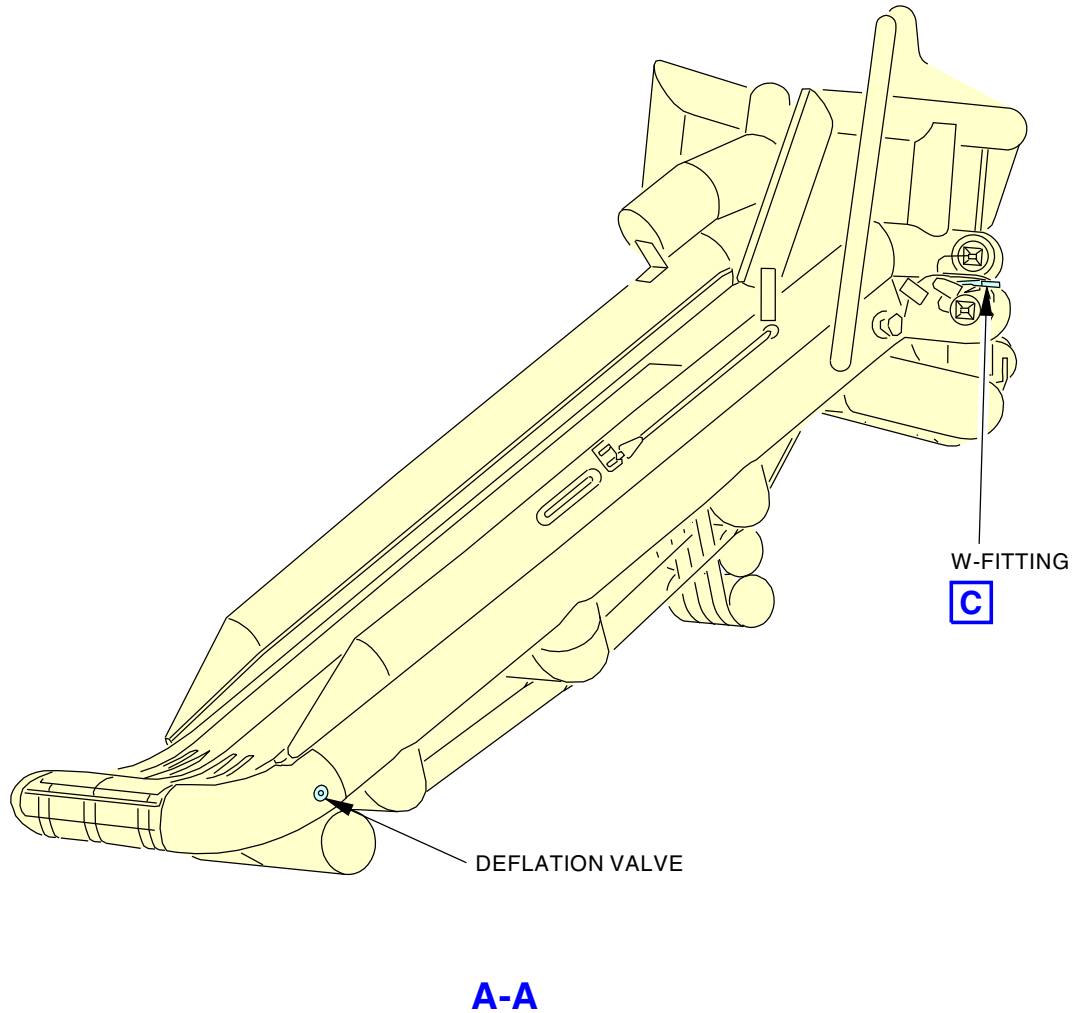
EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-00

Page 221
May 05/2017

 BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



H01133 S0006411495_V2

Off-Wing Escape Slide
Figure 203/25-65-00-990-803 (Sheet 2 of 3)

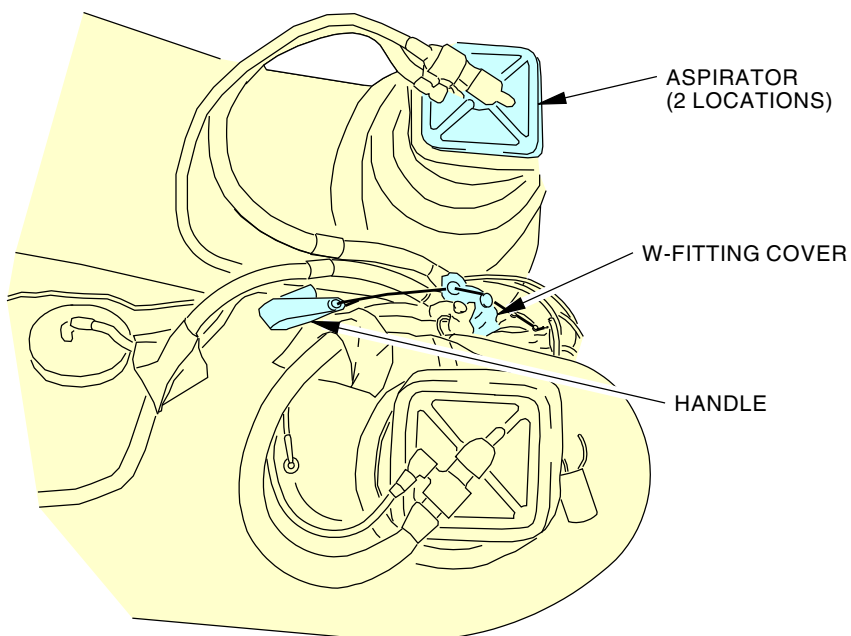
EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

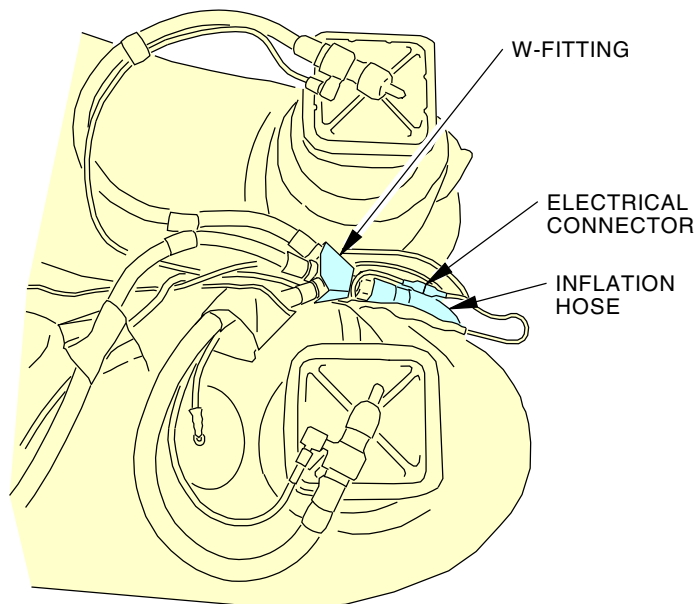
Page 222
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**W-FITTING
(COVER INSTALLED)**

C



**W-FITTING
(COVER REMOVED)**

D

H02399 S0006411496_V2

**Off-Wing Escape Slide
Figure 203/25-65-00-990-803 (Sheet 3 of 3)**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-00

Page 223
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

OFF-WING ESCAPE SYSTEM - ADJUSTMENT/TEST

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
- (1) An operational test of the off-wing escape system
 - (2) Continuity test for off-wing escape slide
 - (3) A system test of the off-wing escape slide mechanism using tool J25016-1.
 - (a) Tool J25016-1 or tool J25009-1 can be used to accomplish a system test of the off-wing escape slide mechanism.
 - (b) Tool J25016-1 is the preferred tool.
 - (4) A system test of the off-wing escape slide mechanism using tool J25009-1.
 - (a) Tool J25016-1 or tool J25009-1 can be used to accomplish a system test of the off-wing escape slide mechanism.
 - (b) Tool J25016-1 is the preferred tool.

TASK 25-65-00-840-802

2. Off-Wing Escape System - Operational Test (Slide Will Inflate)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
25-65-00-440-801	Arm the Off-Wing Escape System (P/B 201)
25-65-00-840-801	Put the Off-Wing Escape System Back to its Initial Condition after Deployment (P/B 201)
29-11-00-860-803	Main Hydraulic System Pressurization with an Alternating Current Motor Pump (P/B 201)
29-11-00-860-808	Main Hydraulic System Power Removal (P/B 201)
WDM 33-51-11	Wiring Diagram Manual
WDM 33-51-99	Wiring Diagram Manual

B. Tools/Equipment

Reference	Description
STD-1433	Pad - Protective, Ensolite or equivalent 1/2 (or less) inches by 72 inches by 48 inches

C. Consumable Materials

Reference	Description	Specification
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G50155	Tape - Carpet, Double-sided, 16 oz/sq. yd., White. Storage Life 18 Months.	BMS5-133 Type II Class 1
G50156	Tape - Carpet, Double-sided, 16 oz/sq. yd., Black. Storage Life 18 Months.	BMS5-133 Type II Class 2

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-00

Page 501
Sep 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Prepare for the Test

SUBTASK 25-65-00-860-011

- (1) Do a check of the test switch on the nose landing gear (WDM 33-51-11 through WDM 33-51-99).
 - (a) At the service and APU shutdown panel, P40, set the test switch for the emergency lights to the on mode.
 - 1) Quickly make sure the exterior emergency lights come on.
NOTE: This check includes all slide/overwing lights.
 - 2) After one minute, make sure the lights go off automatically.

SUBTASK 25-65-00-710-002

- (2) Do this test at the left and right overwing doors (PED 3).
 - (a) Lower the overdoor panel to gain access to the emergency power supplies.
 - (b) Press and release the test button on the battery pack:
 - 1) Left door M33301
 - 2) Right door M33304
 - (c) Make sure the test light adjacent to the battery pack illuminates.
 - (d) Close the overdoor panel.
 - (e) Let the emergency light batteries charge for 10 minutes after the operational test.

SUBTASK 25-65-00-840-002



ATTACH PROTECTIVE PAD TO THE FUSELAGE ABOVE THE OFF-WING SLIDE DOOR. IF THE PROTECTIVE PAD IS NOT INSTALLED, DAMAGE TO THE FUSELAGE SKIN CAN OCCUR.

- (3) Do these steps to attach the protective pad, STD-1433 to the fuselage above the off-wing escape slide door.
 - (a) Make sure that the fuselage skin area where the pad is attached is clean.
 - (b) Use one of the materials that follow to keep the pad in its position:
 - tape, G50155
 - tape, G50156
 - Scotch Flatback Masking Tape 250, G00270
 - (c) Attach the protective pad, STD-1433 to the fuselage above the off-wing escape slide door.

E. Test Procedure

SUBTASK 25-65-00-710-001

- (1) Do the operational test of the off-wing escape slide as follows:



MAKE SURE THERE ARE NO PERSONS OR EQUIPMENT IN THE AREA BELOW THE OFF-WING ESCAPE SLIDE DOOR OR AFT OF THE WING TRAILING EDGE. WHEN THE SLIDE DEPLOYS, INJURY TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

- (a) Make sure there are no persons or equipment on the ground in the area below the door or aft of the wing trailing edge.

EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 502
Sep 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (b) Put the EMER LIGHTS switch, on the P5 Overhead panel, to the ARMED position.
- (c) Arm the off-wing exit door (PED 3) to be tested. To do this, do this task: Arm the Off-Wing Escape System, TASK 25-65-00-440-801.

NOTE: This test can be conducted with one or both of the off-wing escape systems armed.



WARNING

KEEP PERSONS AND EQUIPMENT CLEAR OF FLIGHT CONTROL SURFACES, THE THRUST REVERSERS, AND THE LANDING GEAR. THESE COMPONENTS CAN MOVE SUDDENLY WHEN YOU SUPPLY HYDRAULIC POWER. THIS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (d) To pressurize the center hydraulic system, do this task: Main Hydraulic System Pressurization with an Alternating Current Motor Pump, TASK 29-11-00-860-803.
- (e) Put the Primary Flight Computer (PFC) disconnect switch, on the P5 Overhead Panel, to the AUTO position.
- (f) Show the Flight Controls Synoptic display on a DU.
 - 1) Make sure the FLT CNTRL MODE is NORMAL (white).



WARNING

KEEP PERSONS AND EQUIPMENT CLEAR OF FLIGHT CONTROL SURFACES, THE THRUST REVERSERS, AND THE LANDING GEAR. THESE COMPONENTS CAN MOVE SUDDENLY WHEN YOU SUPPLY HYDRAULIC POWER. THIS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (g) Put the C WING switch, on the FLIGHT CONTROL HYDRAULIC POWER Panel P61, to the NORM position.
- (h) Put the speed brake lever to the full UP position.
- (i) Show the Flight Controls Maintenance Pages on a DU.
 - 1) Make sure Spoiler position 7 or 8, as applicable, shows 2.3 inches minimum on the display.
- (j) To turn off the center hydraulic system, do this task: Main Hydraulic System Power Removal, TASK 29-11-00-860-808.

NOTE: After turning off the hydraulic power, quickly (that is, with minimum delay) do the steps to open the overwing door (PED 3) and inflate the escape slide.



WARNING

REMOVE ALL PERSONS AND GROUND EQUIPMENT AWAY FROM THE WING AREA AND GROUND TEST AREA. KEEP AWAY FOR A MINIMUM DISTANCE OF 25 FEET FROM THE CENTERLINE OF THE AIRPLANE AND 25 FEET AFT OF THE WING. THE DOOR WILL POWER OPEN AND THE SLIDE WILL INFLATE AUTOMATICALLY. THIS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (k) Put the overwing door (PED 3) select handle to the AUTOMATIC/ARM position.
- (l) Move the door interior handle to the open position.
- (m) Open the door fully.
- (n) Look for these conditions:



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 1) The slide is fully inflated.
NOTE: The slide inflates in 10 seconds or less after it starts to inflate.
NOTE: The slide must inflate automatically to pass the operational test.
- 2) If the slide does not inflate automatically, pull the backup inflation handle to inflate the slide.
NOTE: The backup inflation handle is located at the upper aft corner of the overwing door cutout.
- 3) Spoiler 7 or 8, as applicable, retracts correctly.
- 4) The exterior emergency lights operated correctly.
- 5) The escape slide lights operated correctly.

F. Put the Airplane Back to its Usual Condition

SUBTASK 25-65-00-860-012

- (1) Do this task: Put the Off-Wing Escape System Back to its Initial Condition after Deployment, TASK 25-65-00-840-801.

SUBTASK 25-65-00-080-003

- (2) Remove the protective pad, STD-1433 from the fuselage area above the off-wing escape slide door.
 - (a) Make sure that tape is removed from the fuselage skin and the skin is clean of tape adhesive.

————— END OF TASK —————

TASK 25-65-00-710-801

3. Off-Wing Escape Slide Mechanism - System Test (Using Tool J25016-1)

(Figure 501, Figure 502, Figure 503)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This task has the steps to perform a system test using test valve, SPL-13403.

B. References

Reference	Title
25-65-00-040-801	Disarm the Off-Wing Escape System (P/B 201)
25-65-00-440-801	Arm the Off-Wing Escape System (P/B 201)
25-65-10-010-801	Open the Escape Slide Compartment Door (P/B 201)
25-65-10-400-801	Close the Escape Slide Compartment Door (P/B 201)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-13403	Test Valve - Latch Actuator, Off-wing Escape Slide Compartment Door Part #: J25016-1 Supplier: 81205

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-00

Page 504
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Consumable Materials

Reference	Description	Specification
G01048	Lockwire - MS20995C32, Corrosion Resistant Steel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

E. Location Zones

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right

F. Prepare for the Test

SUBTASK 25-65-00-040-001

- (1) Disarm the off-wing escape system.
 - (a) Do this task: Disarm the Off-Wing Escape System, TASK 25-65-00-040-801.

SUBTASK 25-65-00-010-001

- (2) Open the escape slide compartment door.
 - (a) Do this task: Open the Escape Slide Compartment Door, TASK 25-65-10-010-801.

SUBTASK 25-65-00-020-003

- (3) Disconnect the cover lacing release cable from the escape slide pack as follows (Figure 502):
 - (a) Remove the MS20995C32 lockwire, G01048 that holds the knurled nut to the release mechanism.
 - (b) Loosen the knurled nut [2] that attaches the release cable to the release mechanism.
 - (c) Remove the end of the release cable from the trigger pin slot.



WARNING

MAKE SURE THAT THE C-SHAPED WASHER IS INSTALLED ON THE END OF THE RELEASE CABLE. WITHOUT THE C-SHAPED WASHER, THE ESCAPE SLIDE WILL NOT RELEASE WHEN THE OVERWING EMERGENCY EXIT DOOR OPENS. THIS CAN CAUSE INJURIES DURING AN EMERGENCY.

- (d) Make sure that the crimped C-shaped washer [1] is installed on the end of the release cable.

NOTE: The C-shaped washer [1] is under the knurled nut [2] on the release mechanism end of the cable.

- (e) Remove the safety pin from the storage pouch on the escape slide pack.
- (f) Install the safety pin as shown in Figure 502, Detail B, safety pin installed.
- (g) Measure the cover lacing release cable length.

SUBTASK 25-65-00-410-002

- (4) Close the escape slide compartment door.
 - (a) Do this task: Close the Escape Slide Compartment Door, TASK 25-65-10-400-801.

SUBTASK 25-65-00-480-001

- (5) Install the test valve, SPL-13403 in the test port on the escape slide compartment door latch actuator (Figure 503).

NOTE: The valve must fully open when you turn it 90 degrees.

EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 505
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-65-00-480-003



WARNING

MAKE SURE THAT THE SOURCE PRESSURE IS LESS THAN THE SPECIFIED PRESSURE. IF THE SOURCE PRESSURE IS TOO HIGH, INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (6) Connect a source of 1750 psig (1750 psi) to 2700 psig (2700 psi) air or nitrogen to the test valve, SPL-13403.

G. Test Procedure

SUBTASK 25-65-00-720-002

- (1) Do a test of the off-wing escape system mechanism.

NOTE: If you do the test again, you must first do the steps in this procedure to release the air or nitrogen pressure inside the latch actuator. You also must put the cover lacing release cable back to its initial position.

- (a) Make sure that the handle is up and the mode select lever on the latch actuator is in the disarm (test) position shown in View B, (Figure 503).



WARNING

PUT ON PROTECTIVE GOGGLES, EAR PLUGS, AND GLOVES BEFORE YOU DO THE TEST. IF YOU DO NOT OBEY THIS INSTRUCTION, INJURIES TO YOU CAN OCCUR.

- (b) Open the valve on the air or nitrogen source.
- (c) Quickly open the valve on the test valve, SPL-13403. After 4 seconds close the air flow regulator valve.

NOTE: The valve on the air flow regulator is installed in the test port on the latch actuator.

- 1) Make sure that the door opened in 4 seconds.
- 2) Make sure that the cover lacing release cable retracted by measuring the cable length.

NOTE: The release cable retracts approximately, 0.60 in. (15.24 mm).

H. Put the Airplane Back to its Usual Condition

SUBTASK 25-65-00-080-002

- (1) Remove the test equipment.
 - (a) Close the valve on the air or nitrogen source.
 - (b) Disconnect the air or nitrogen source from the test valve, SPL-13403.



WARNING

YOU MUST RELEASE THE PRESSURE OF THE AIR OR NITROGEN BEFORE YOU REMOVE THE VALVE INSTALLED IN THE TEST PORT IN THE LATCH ACTUATOR. IF YOU DO NOT OBEY THIS INSTRUCTION, INJURY TO PERSONS CAN OCCUR.

- (c) Slowly open the valve on the test valve, SPL-13403 to release the air or nitrogen.
- (d) Remove the test valve, SPL-13403 from the latch actuator test port.

SUBTASK 25-65-00-420-007

- (2) Install the plug in the latch actuator test port (Figure 502).

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-00

Page 506
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-65-00-420-009

- (3) Connect the cover lacing release cable to the escape slide pack (Figure 502).
 - (a) Remove the safety pin from the release mechanism.
 - (b) Put the safety pin in the storage pouch on the escape slide pack.



WARNING

MAKE SURE THAT THE C-SHAPED WASHER IS INSTALLED ON THE END OF THE RELEASE CABLE. WITHOUT THE C-SHAPED WASHER, THE ESCAPE SLIDE WILL NOT RELEASE WHEN THE OVERWING EMERGENCY EXIT DOOR OPENS. THIS CAN CAUSE INJURIES DURING AN EMERGENCY.

- (c) Make sure that the crimped C-shaped washer [1] is installed on the end of the release cable.

NOTE: The C-shaped washer [1] is under the knurled nut [2] on the release mechanism end of the cable.



WARNING

INSTALL THE RELEASE CABLE CORRECTLY. IF YOU INSTALL IT INCORRECTLY, THE ESCAPE SLIDE WILL NOT RELEASE WHEN THE OVERWING EMERGENCY EXIT DOOR OPENS. THIS CAN CAUSE INJURIES DURING AN EMERGENCY.

- (d) Put the end of the release cable in the trigger pin slot of the release mechanism as shown in Figure 502, Detail C).



CAUTION

DO NOT USE PLIERS TO TIGHTEN THE KNURLED NUT. DAMAGE TO EQUIPMENT CAN OCCUR.

- (e) Use your hand to tighten the knurled nut [2].



CAUTION

BEND THE ENDS OF THE LOCKWIRE SO THEY WILL NOT CAUSE DAMAGE TO THE ESCAPE SLIDE.

- (f) Install the MS20995C32 lockwire, G01048 through the hole in the knurled nut [2] and the hole in the release mechanism.

SUBTASK 25-65-00-420-010

- (4) Close the escape slide compartment door.
 - (a) Do this task: Close the Escape Slide Compartment Door, TASK 25-65-10-400-801.

SUBTASK 25-65-00-440-002

- (5) Arm the off-wing escape system.
 - (a) Do this task: Arm the Off-Wing Escape System, TASK 25-65-00-440-801.

— END OF TASK —

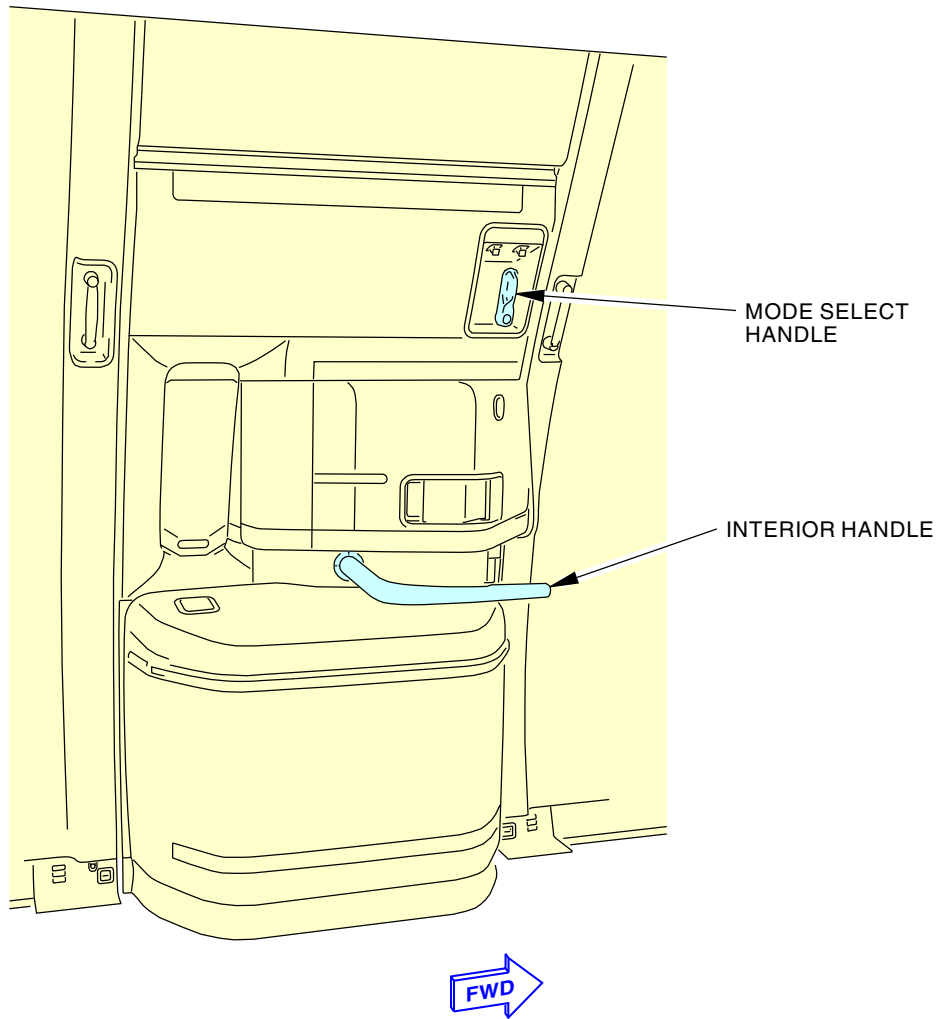
EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 507
Sep 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



**PASSENGER ENTRY DOOR
(EXAMPLE)**

L08079 S0006411500_V2

**Escape System Operational Test
Figure 501/25-65-00-990-802 (Sheet 1 of 2)**

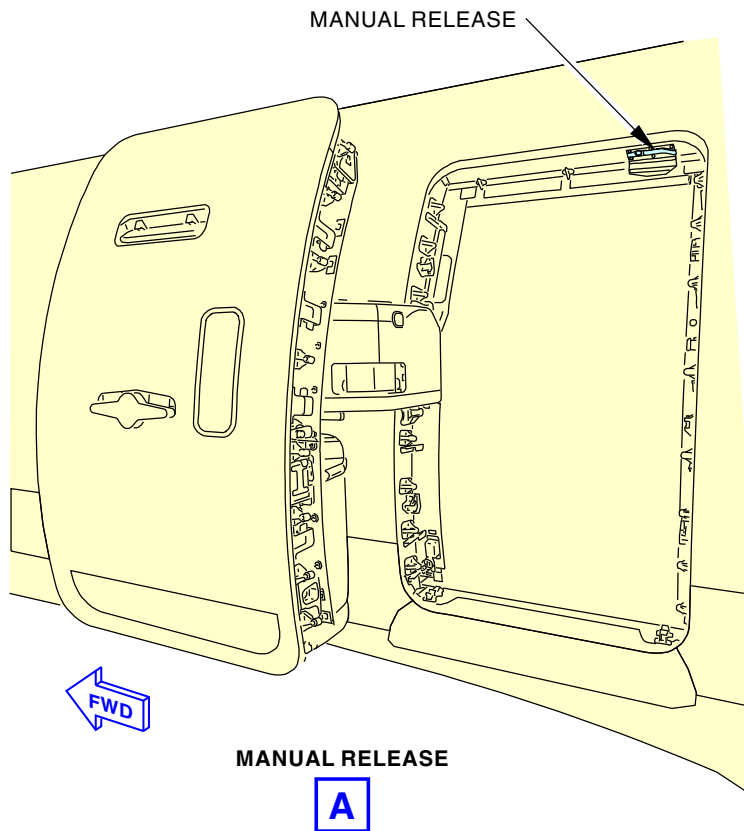
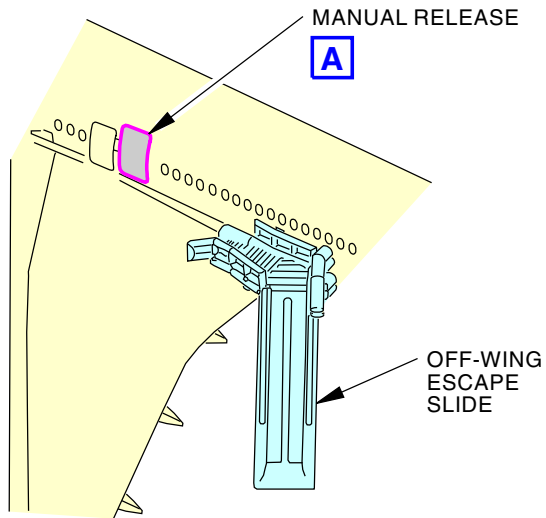
EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 508
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



L08084 S0006411501_V2

Escape System Operational Test
Figure 501/25-65-00-990-802 (Sheet 2 of 2)

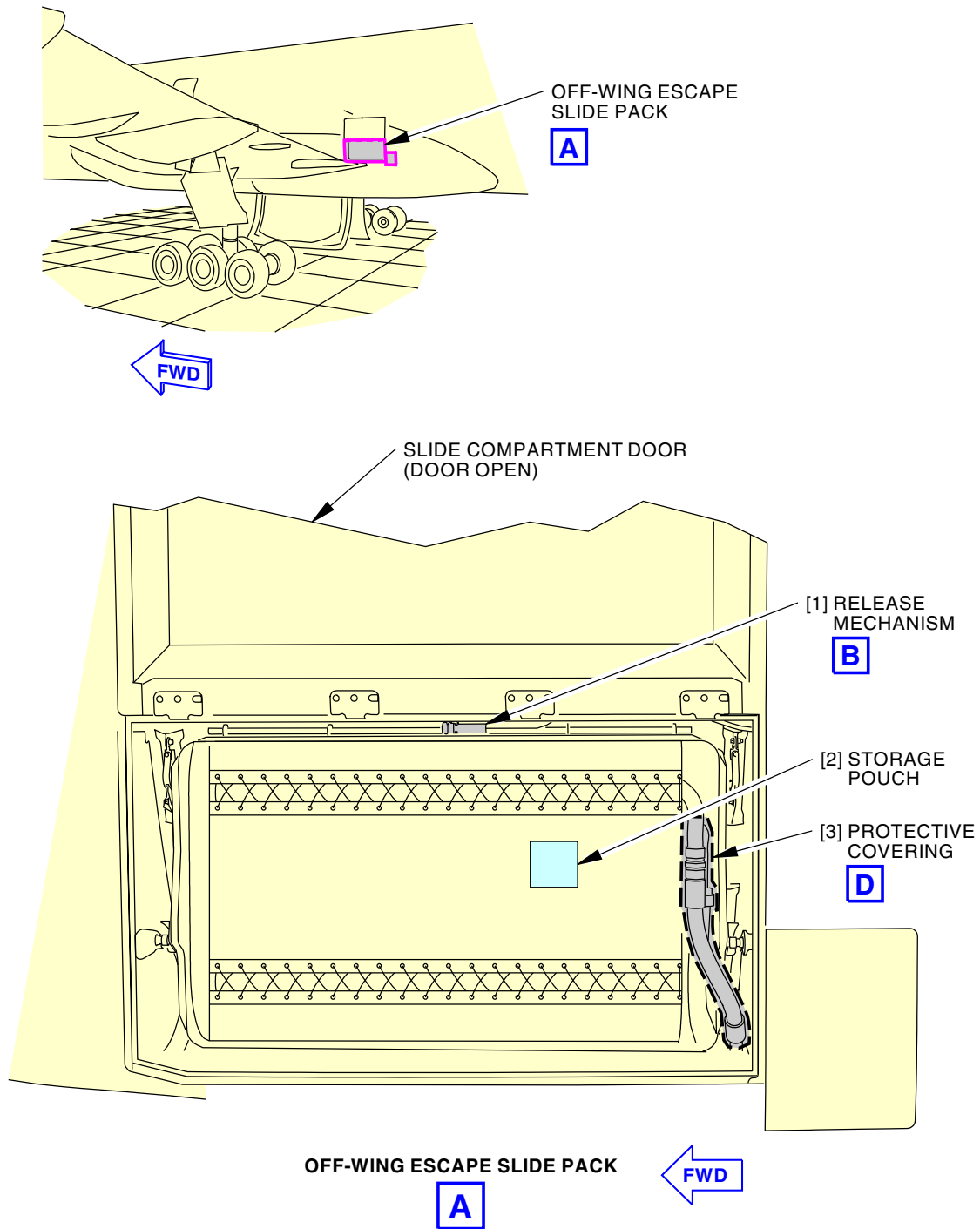
EFFECTIVITY
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D633W101-ARO

25-65-00

Page 509
May 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



H01798 S0006411502_V3

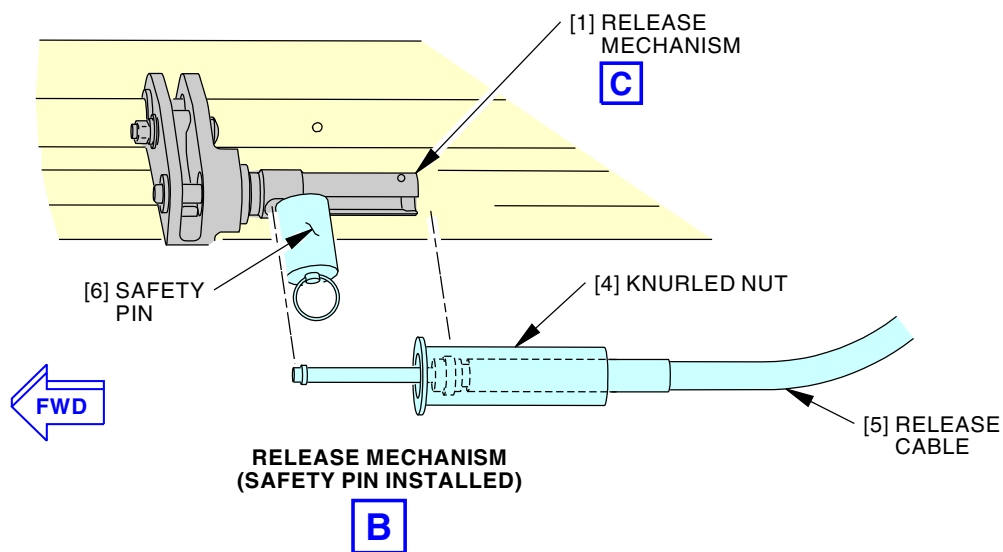
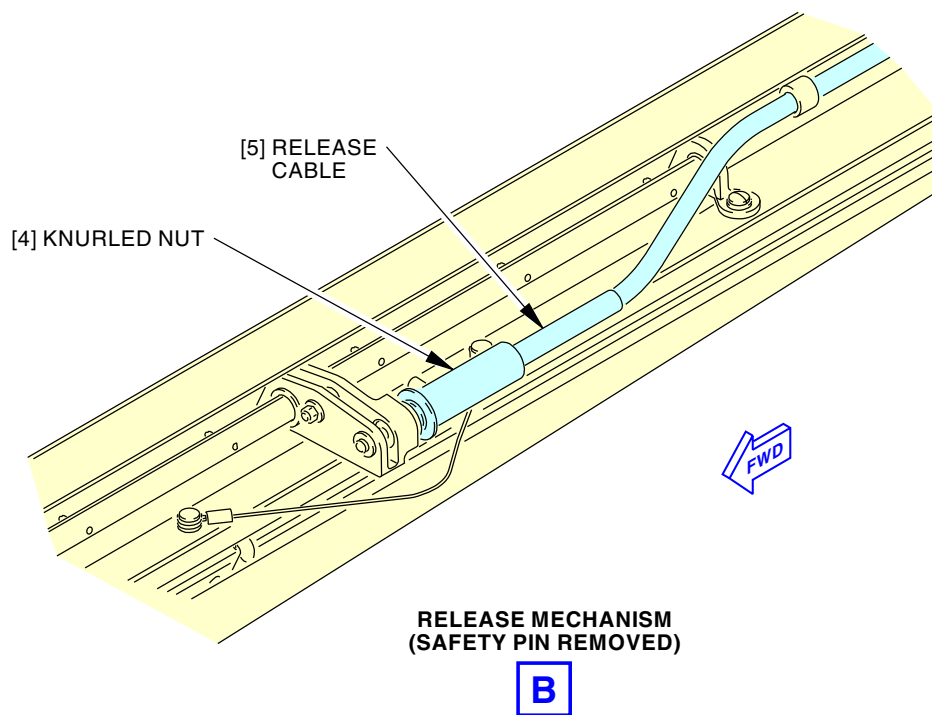
Off-Wing Escape Slide Pack Release Mechanism
Figure 502/25-65-00-990-804 (Sheet 1 of 4)

EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 510
Jan 05/2018



H01801 S0006411503_V4

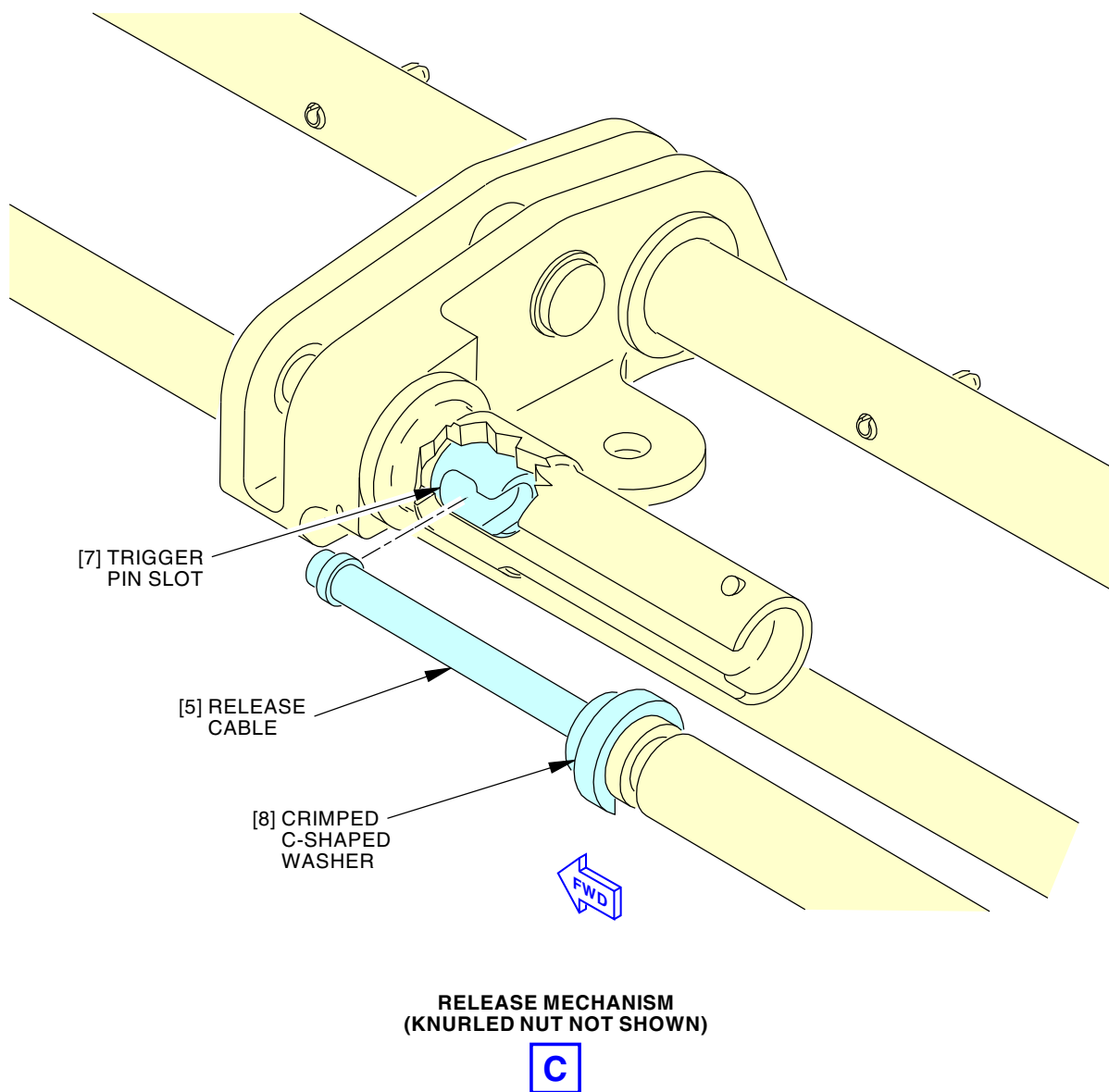
**Off-Wing Escape Slide Pack Release Mechanism
Figure 502/25-65-00-990-804 (Sheet 2 of 4)**

EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 511
Jan 05/2018



H01815 S0006411504_V4

Off-Wing Escape Slide Pack Release Mechanism
Figure 502/25-65-00-990-804 (Sheet 3 of 4)

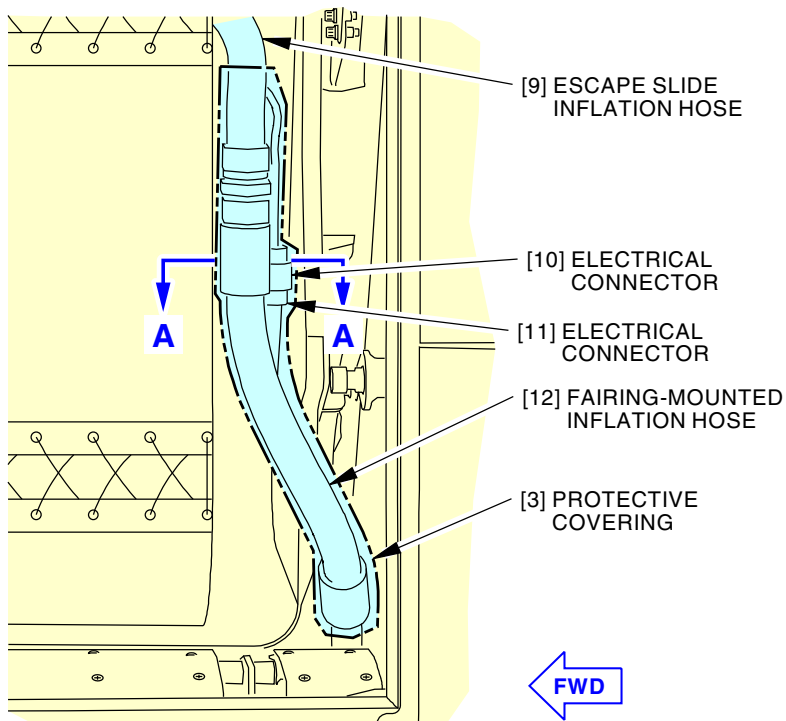
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25-65-00

D633W101-ARO

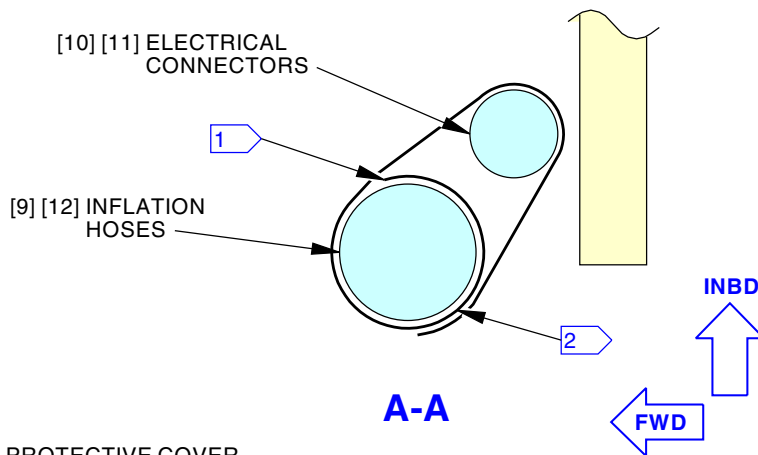
Page 512
Jan 05/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL



PROTECTIVE COVERING

D



- 1** PUT THE LOOSE FLAP OF THE PROTECTIVE COVER BETWEEN THE HOSE AND THE WIRE BUNDLE.
- 2** ENGAGE THE VELCRO STRIP ALONG THIS EDGE.

2752491 S0000628841_V1

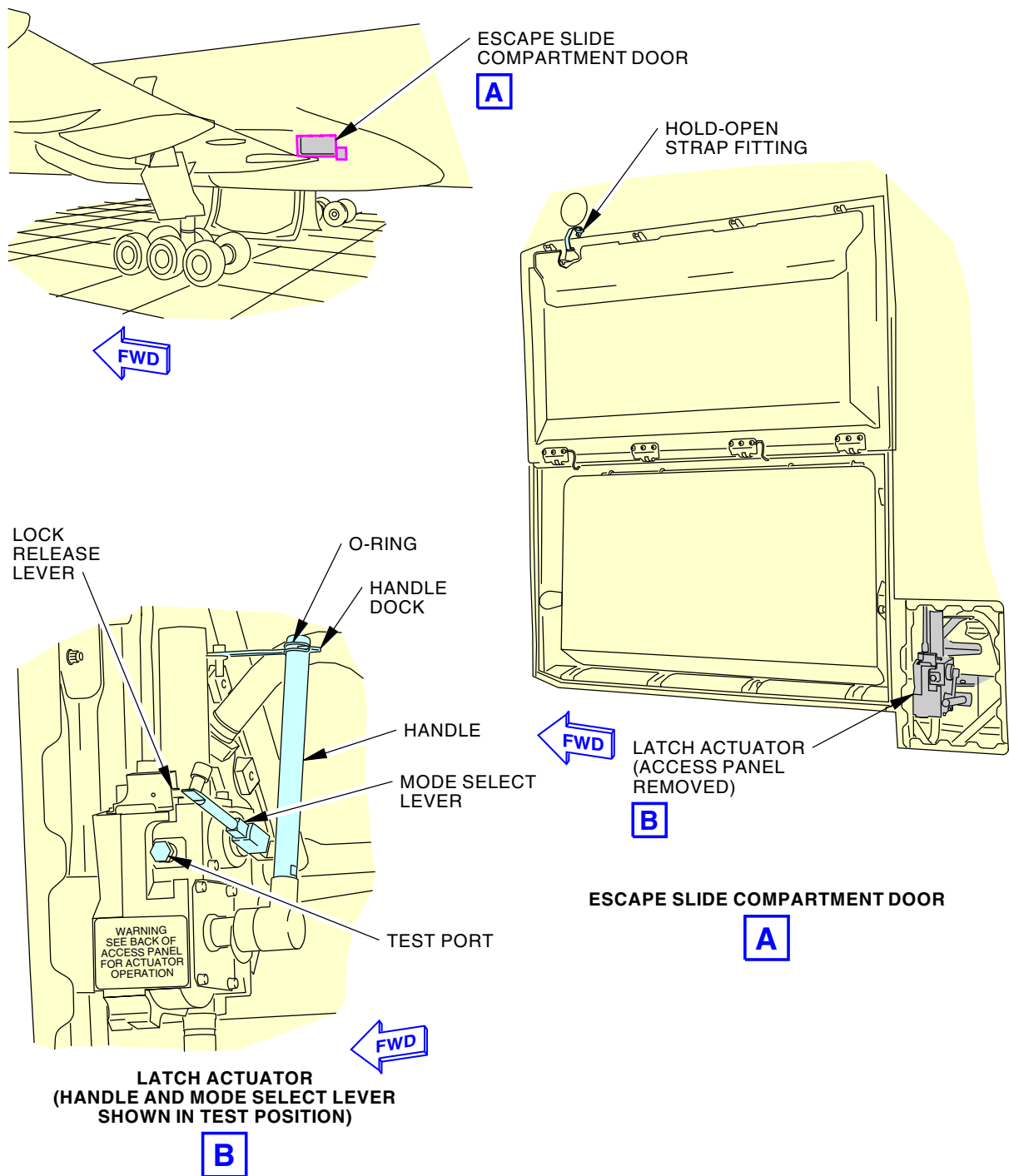
Off-Wing Escape Slide Pack Release Mechanism
Figure 502/25-65-00-990-804 (Sheet 4 of 4)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-00

Page 513
Jan 05/2018



G92478 S0006411505_V3

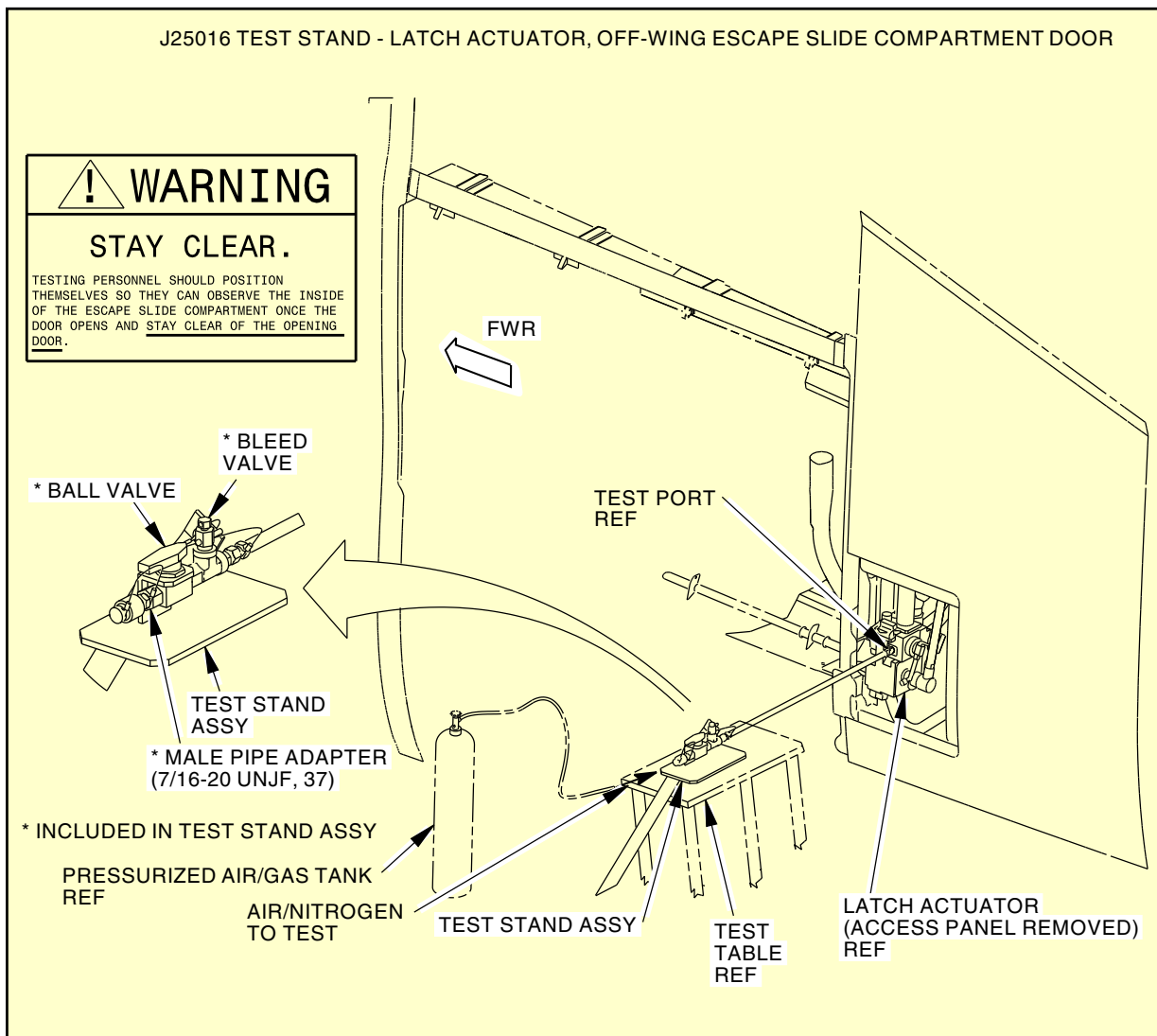
**Escape Slide Compartment Door Latch Actuator
Figure 503/25-65-00-990-805**

**EFFECTIVITY
ARO ALL**

25-65-00

D633W101-ARO

Page 514
Jan 05/2018



2090677 S0000441155_V2

**Off-Wing Escape Slide Test Stand - Placard
Figure 504/25-65-00-990-806**

EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 515
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-65-00-710-802

4. Off-Wing Escape Slide Mechanism - System Test (Using Tool J25009-1)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This task has the steps to do a system test using air flow regulator, SPL-7858.

B. References

Reference	Title
25-65-02-000-801	Inflation Bottle for the Off-Wing Escape Slide - Removal (P/B 401)
25-65-02-400-801	Inflation Bottle for the Off-Wing Escape Slide - Installation (P/B 401)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-7858	Air Flow Regulator - Pneumatic Pressure Test, Off-wing Escape Slide Part #: J25009-1 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
G01048	Lockwire - MS20995C32, Corrosion Resistant Steel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

E. Location Zones

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right

F. Prepare for the Test

SUBTASK 25-65-00-010-007

- (1) Do the steps in this task to disconnect the inflation bottle: Inflation Bottle for the Off-Wing Escape Slide - Removal, TASK 25-65-02-000-801.

- (a) Do the steps through installing a cap or plug on the inflation tube.

NOTE: It is not necessary to remove the inflation bottle from the aircraft.

SUBTASK 25-65-00-020-005

- (2) Do these steps to get access to the hose assembly [12]:

- (a) Remove the MS20995C32 lockwire, G01048 that holds the knurled nut [4] to the release mechanism [1].
- (b) Loosen the knurled nut [4] that attaches the release cable [5] to the release mechanism [1].
- (c) Remove the end of the release cable [5] from the trigger pin slot [7].

EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 516
Jan 05/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL



WARNING

MAKE SURE THAT THE C-SHAPED WASHER IS INSTALLED ON THE END OF THE RELEASE CABLE. WITHOUT THE C-SHAPED WASHER, THE ESCAPE SLIDE WILL NOT RELEASE WHEN THE OVERWING EMERGENCY EXIT DOOR OPENS. THIS CAN CAUSE INJURIES DURING AN EMERGENCY.

- (d) Make sure that the crimped C-shaped washer [8] is installed on the end of the release cable [5].

NOTE: The crimped C-shaped washer [8] is underneath the knurled nut [4] on the release mechanism end of the cable.

- (e) Remove the safety pin [6] from the storage pouch [2] on the escape slide pack.
- (f) Install the safety pin [6] as shown, View B, (Safety Pin Installed) Figure 502.
- (g) Open the protective covering [3] that covers the escape slide inflation hose [9], fairing-mounted inflation hose [12] and the electrical connector [10], electrical connector [11].

SUBTASK 25-65-00-480-004

- (3) Connect the air flow regulator, SPL-7858 to the fairing-mounted inflation hose and inflation tube as shown in Figure 505.

SUBTASK 25-65-00-480-005



WARNING

MAKE SURE THAT THE SOURCE PRESSURE IS LESS THAN THE SPECIFIED PRESSURE. IF THE SOURCE PRESSURE IS TOO HIGH, INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (4) Connect a source of 1750 psig (1750 psi) to 2700 psig (2700 psi) air or nitrogen to the air flow regulator, SPL-7858.

G. Test Procedure

SUBTASK 25-65-00-730-001

- (1) Do a test of the off-wing escape system mechanism.

NOTE: If you do the test again, you must first do the steps in this procedure to release the air or nitrogen pressure inside the latch actuator. You also must put the cover lacing release cable back to its initial position.



WARNING

PUT ON PROTECTIVE GOGGLES, EAR PLUGS, AND GLOVES BEFORE YOU DO THE TEST. IF YOU DO NOT OBEY THIS INSTRUCTION, INJURIES TO YOU CAN OCCUR.

- (a) Make sure that valves "A" and "C" on the air flow regulator, SPL-7858 are closed.
- (b) Open valve "B" on the air flow regulator, SPL-7858.
- (c) Open the valve on the air or nitrogen source.
- (d) Quickly open valve "A" on the air flow regulator, SPL-7858. After 4 seconds close valve "A".
 - 1) Visually make sure that the door latching mechanism fully rotated in 4 seconds.
 - 2) Make sure that the cover lacing release cable retracted in 4 seconds.

EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 517
Jan 05/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL

H. Put the Airplane Back to Its Usual Condition

SUBTASK 25-65-00-080-004

- (1) Remove the test equipment.
 - (a) Close the valve on the air or nitrogen source.
 - (b) Disconnect the air or nitrogen source from the air flow regulator, SPL-7858.



WARNING

YOU MUST RELEASE THE PRESSURE OF THE AIR OR NITROGEN BEFORE YOU REMOVE THE AIR FLOW REGULATOR ADAPTER AND B-NUT. IF YOU DO NOT OBEY THIS INSTRUCTION, INJURY TO PERSONS CAN OCCUR.

- (c) Slowly open valve "C" on the air flow regulator, SPL-7858 to release the air or nitrogen.
- (d) Remove the air flow regulator adapter from the inflation tube.
- (e) Remove the B-nut from the fairing mounted inflation hose.

SUBTASK 25-65-00-440-007

- (2) Do the steps necessary in this task to restore the inflation bottle: Inflation Bottle for the Off-Wing Escape Slide - Installation, TASK 25-65-02-400-801.

SUBTASK 25-65-00-410-008

- (3) Does these steps to get access to the hose assembly [15]:
 - (a) Position the protective covering [3] over fittings of the escape slide inflation hose [9], fairing-mounted inflation hose [12], electrical connector [10], electrical connector [11] as shown in View D and Section A-A, Figure 502.
 - (b) Remove the safety pin [6] from the release mechanism [1].
 - (c) Put the safety pin [6] in the storage pouch [2] on the escape slide pack.



WARNING

MAKE SURE THAT THE C-SHAPED WASHER IS INSTALLED ON THE END OF THE RELEASE CABLE. WITHOUT THE C-SHAPED WASHER, THE ESCAPE SLIDE WILL NOT RELEASE WHEN THE OVERWING EMERGENCY EXIT DOOR OPENS. THIS CAN CAUSE INJURIES DURING AN EMERGENCY.

- (d) Make sure that the crimped C-shaped washer [8] is installed on the end of the release cable [5].

NOTE: The crimped C-shaped washer [8] is under the knurled nut [4] on the release mechanism end of the cable.
- (e) Put the end of the release cable [5] in the trigger pin slot [7] of the release mechanism [1] as shown in View C, Figure 502.
- (f) Use your hand to tighten the knurled nut [4].



CAUTION

DO NOT USE PLIERS TO TIGHTEN THE KNURLED NUT. KNURLED NUT INSTALLED BELOW THE TENSION CAN CAUSE LOAD ON THE RELEASE CABLE. DAMAGE TO EQUIPMENT CAN OCCUR.

- (g) Install the MS20995C32 lockwire, G01048 through the hole in knurled nut [4] and the hole in the release mechanism [1].

————— END OF TASK —————

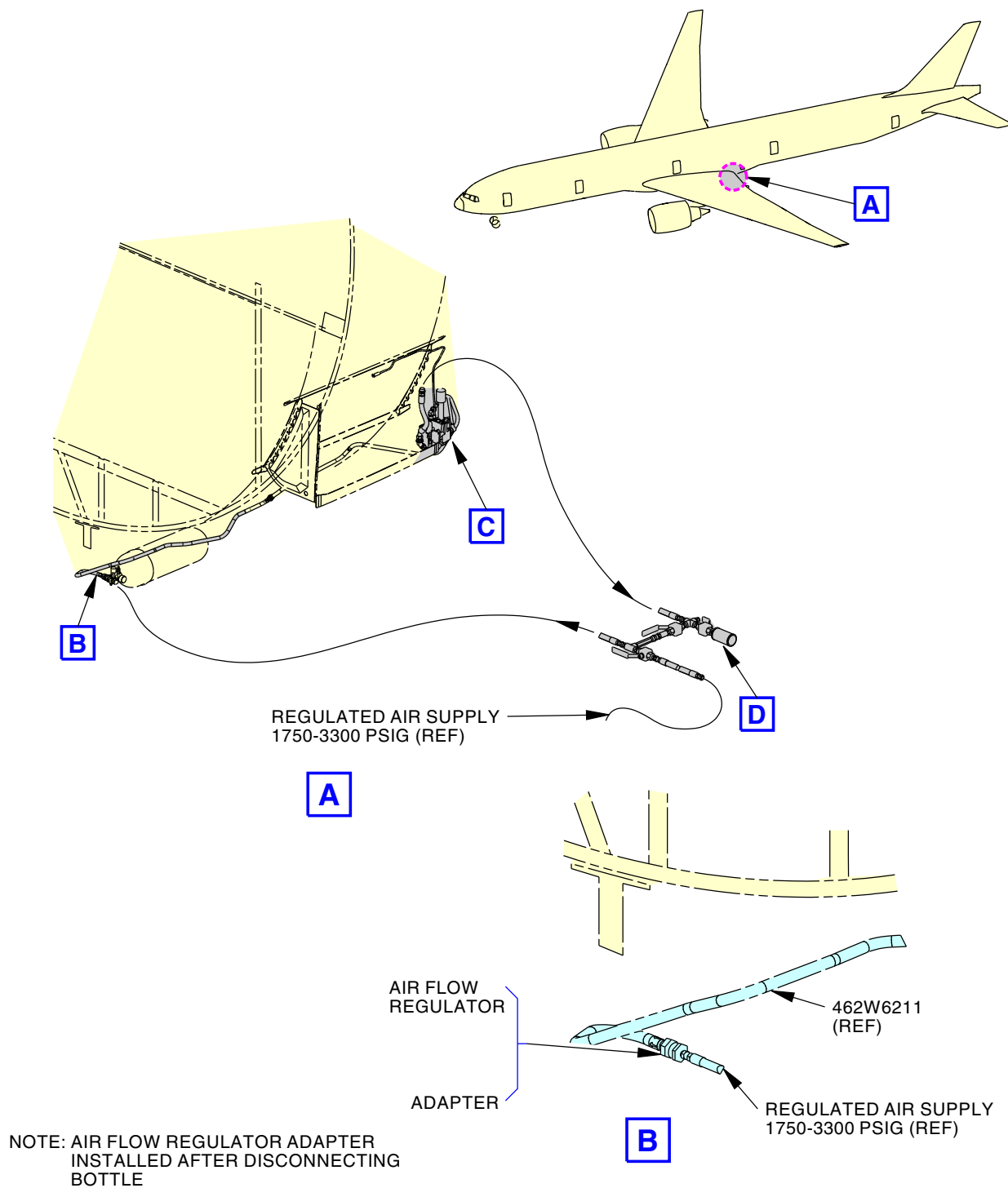
EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 518
Jan 05/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL



2180379 S0000481586_V2

Off-Wing Escape Slide Test (J25009) - Placard
Figure 505/25-65-00-990-807 (Sheet 1 of 2)

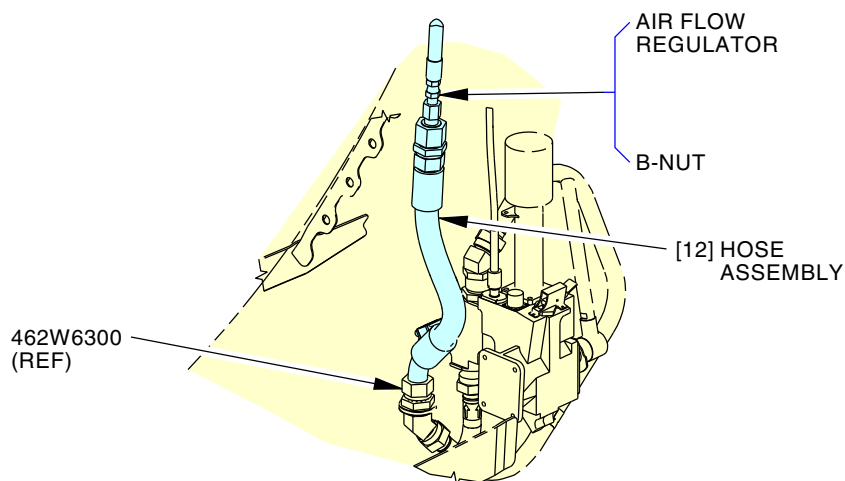
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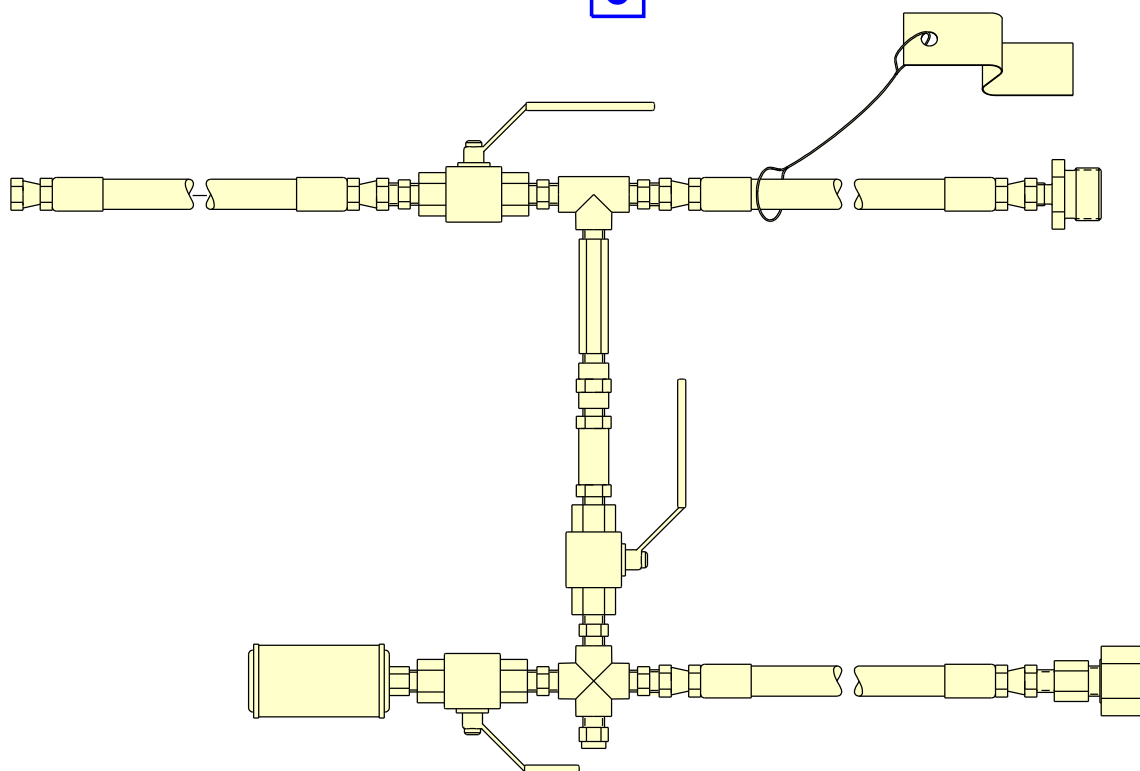
Page 519
Jan 05/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL



NOTE: SLIDE REMOVED WHEN AIR FLOW
REGULATOR B-NUT IS INSTALLED.

C



AIR FLOW REGULATOR ASSEMBLY

D

2180384 S0000481759_V3

Off-Wing Escape Slide Test (J25009) - Placard
Figure 505/25-65-00-990-807 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

25-65-00

D633W101-ARO

Page 520
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

OFF-WING ESCAPE SLIDE PACK - REMOVAL/INSTALLATION

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) A removal of the off-wing escape slide pack.
 - (2) An installation of the off-wing escape slide pack.

TASK 25-65-01-000-801

2. Escape Slide Pack Removal

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. **References**

Reference	Title
25-65-00-040-801	Disarm the Off-Wing Escape System (P/B 201)
25-65-10-010-801	Open the Escape Slide Compartment Door (P/B 201)

B. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-7857	Removal/Installation Equipment - Off-Wing Escape Slide Part #: J25006-20 Supplier: 81205 Opt Part #: J25006-1 Supplier: 81205

C. **Consumable Materials**

Reference	Description	Specification
G01048	Lockwire - MS20995C32, Corrosion Resistant Steel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

D. **Location Zones**

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right

E. **Prepare for the Removal**

SUBTASK 25-65-01-040-001

- (1) Do this task: Disarm the Off-Wing Escape System, TASK 25-65-00-040-801.

SUBTASK 25-65-01-010-001

- (2) Do this task: Open the Escape Slide Compartment Door, TASK 25-65-10-010-801.

F. **Removal**

SUBTASK 25-65-01-020-001

- (1) Remove the escape slide pack as follows:
 - (a) Remove the MS20995C32 lockwire, G01048 that holds the knurled nut [4] to the release mechanism [1].

EFFECTIVITY
ARO ALL

25-65-01

D633W101-ARO

Page 401
Jan 05/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (b) Loosen the knurled nut [4] that attaches the release cable [5] to the release mechanism [1].
- (c) Remove the end of the release cable [5] from the trigger pin slot [7].



WARNING

MAKE SURE THAT THE C-SHAPED WASHER IS INSTALLED ON THE END OF THE RELEASE CABLE. WITHOUT THE C-SHAPED WASHER, THE ESCAPE SLIDE WILL NOT RELEASE WHEN THE OVERWING EMERGENCY EXIT DOOR OPENS. THIS CAN CAUSE INJURIES DURING AN EMERGENCY.

- (d) Make sure that the crimped C-shaped washer [8] is installed on the end of the release cable.

NOTE: The crimped C-shaped washer [8] is under the knurled nut [4] on the release mechanism end of the cable.

- (e) Remove the safety pin [6] from the storage pouch [2] on the escape slide pack.
- (f) Install the safety pin [6] as shown, View B, Release Mechanism, (Safety Pin Installed) (Figure 401).
- (g) Open the protective covering [3] that covers the inflation hose [10], inflation hose [13] and the electrical connector [11], electrical connector [12].
- (h) Disconnect the electrical connector [11] and electrical connector [12].
- (i) Install protective caps on the electrical connector [11] and electrical connector [12].
- (j) Disconnect the escape slide inflation hose [10] from the fairing-mounted inflation hose [13].
- (k) Install protective caps on the inflation hose [10] and inflation hose [13].
- (l) Remove the bolts [21] and washers [22] that hold the retainers [15] to the support fittings [16].
- (m) Turn the retainers [15] downward.



WARNING

BE CAREFUL WHEN YOU MOVE THE ESCAPE SLIDE PACK. THE ESCAPE SLIDE PACK WEIGHS 180 POUNDS. INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

- (n) Pull the top of the escape slide pack outboard until it is in position as shown, Section B-B, Escape Slide Pack - Initial Position (Figure 401).
- (o) Install escape slide removal/installation equipment, SPL-7857, on the escape slide pack.
- (p) Remove the escape slide pack from the slide compartment.

————— **END OF TASK** —————

TASK 25-65-01-400-801

3. Escape Slide Pack Installation

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
25-65-00-440-801	Arm the Off-Wing Escape System (P/B 201)
25-65-10-400-801	Close the Escape Slide Compartment Door (P/B 201)

EFFECTIVITY
ARO ALL

25-65-01

D633W101-ARO

Page 402
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Title
52-12-22-200-801	Emergency Power Assist System (EPAS) Reservoir Pressure Level Check (P/B 601)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-7857	Removal/Installation Equipment - Off-Wing Escape Slide Part #: J25006-20 Supplier: 81205 Opt Part #: J25006-1 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
G01048	Lockwire - MS20995C32, Corrosion Resistant Steel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

D. Location Zones

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right

E. Procedure

SUBTASK 25-65-01-420-002

- (1) Install escape slide removal/installation equipment, SPL-7857, on the escape slide pack.

SUBTASK 25-65-01-420-001

- (2) Install the escape slide pack as follows:



WARNING

BE CAREFUL WHEN YOU MOVE THE ESCAPE SLIDE PACK. THE ESCAPE SLIDE PACK WEIGHS 180 POUNDS. INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

- (a) Put the escape slide pack in position as shown, Section B-B, Escape Slide Pack - Initial Position (Figure 401).
- (b) Make sure the forward and aft ends of the escape slide pack are parallel with the forward and aft end of the escape slide compartment.
- (c) Make sure that the guide rollers [20] at the forward and aft ends of the escape slide compartment engage the side rails [18] on the escape slide pack.
- (d) Remove the escape slide removal/installation equipment, SPL-7857, from the escape slide pack.
- (e) Push the outboard end of the escape slide pack up and into the escape slide compartment until the lower pins [17] engage the support hooks [19].
- (f) Lift and hold the escape slide pack to engage the upper pins [14] in the support fittings [16].
NOTE: The lower pins on the escape slide pack will not touch the bottom of the hooks.
- (g) Turn the forward and aft retainers [15] upward until they touch the support fittings [16].
- (h) Install the bolts [21] and washers [22] to hold the retainers [15] to the support fittings [16].

EFFECTIVITY
ARO ALL

25-65-01

D633W101-ARO

Page 403
Jan 05/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (i) Remove the protective caps from the inflation hose [10] and inflation hose [13].
- (j) Connect the escape slide inflation hose [10] to the fairing-mounted inflation hose [13].
- (k) Remove the protective caps from the electrical connector [11] and electrical connector [12].
- (l) Connect the electrical connector [11] and electrical connector [12].
- (m) Position the protective covering [3] over the fittings of the inflation hose [10], inflation hose [13] and the electrical connector [11], electrical connector [12] as shown, View D and Section A-A (Figure 401).
- (n) Remove the safety pin [6] from the release mechanism [1].
- (o) Put the safety pin [6] in the storage pouch [2] on the escape slide pack.



MAKE SURE THAT THE C-SHAPED WASHER IS INSTALLED ON THE END OF THE RELEASE CABLE. WITHOUT THE C-SHAPED WASHER, THE ESCAPE SLIDE WILL NOT RELEASE WHEN THE OVERWING EMERGENCY EXIT DOOR OPENS. THIS CAN CAUSE INJURIES DURING AN EMERGENCY.

- (p) Make sure that the crimped C-shaped washer [8] is installed on the end of the release cable.

NOTE: The crimped C-shaped washer [8] is under the knurled nut [4] on the release mechanism end of the cable.



INSTALL THE RELEASE CABLE CORRECTLY. IF YOU INSTALL IT INCORRECTLY, THE ESCAPE SLIDE WILL NOT RELEASE WHEN THE OVERWING EMERGENCY EXIT DOOR OPENS. THIS CAN CAUSE INJURIES DURING AN EMERGENCY.

- (q) Put the end of the release cable [5] in the trigger pin slot [7] of the release mechanism [1] as shown, View C (Figure 401).



DO NOT USE PLIERS TO TIGHTEN THE KNURLED NUT. KNURLED NUT INSTALLED BELOW THE TENSION CAN CAUSE LOAD ON THE RELEASE CABLE. DAMAGE TO EQUIPMENT CAN OCCUR.

- (r) Use your hand to tighten the knurled nut [4].



BEND THE ENDS OF THE MS20995C32 LOCKWIRE, G01048 SO THEY WILL NOT CAUSE DAMAGE TO THE ESCAPE SLIDE.

- (s) Install the MS20995C32 lockwire, G01048 through the hole in the knurled nut [4] and the hole in the release mechanism [1].

F. Off-Wing Escape Slide Lights Test

(Figure 402)

SUBTASK 25-65-01-760-001

- (1) Left Off-Wing Escape Slide Light Test

NOTE: The escape slide must be installed or the SLIDE TEST LIGHT will not come on.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-01

Page 404
Jan 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Remove the safety tag and close this circuit breaker:

Overhead Circuit Breaker Panel, P11

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	16	C33621	EMERGENCY LIGHTS DOOR 3L

- (b) On the power supply (M33301), push and release the power supply test switch.
(c) Make sure that the SLIDE TEST LIGHT comes on.

SUBTASK 25-65-01-760-002

- (2) Right Off-Wing Escape Slide Light Test

NOTE: The escape slide must be installed or the SLIDE TEST LIGHT will not come on.

- (a) Remove the safety tag and close this circuit breaker:

Overhead Circuit Breaker Panel, P11

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	17	C33620	EMERGENCY LIGHTS DOOR 3R

- (b) On the power supply (M33304), push and release the power supply test switch.
(c) Make sure that the SLIDE TEST LIGHT comes on.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 25-65-01-410-001

- (1) Do this task: Close the Escape Slide Compartment Door, TASK 25-65-10-400-801.

SUBTASK 25-65-01-440-001

- (2) Do this task: Arm the Off-Wing Escape System, TASK 25-65-00-440-801.

SUBTASK 25-65-01-210-001

- (3) Do this task: Emergency Power Assist System (EPAS) Reservoir Pressure Level Check, TASK 52-12-22-200-801.

————— END OF TASK —————

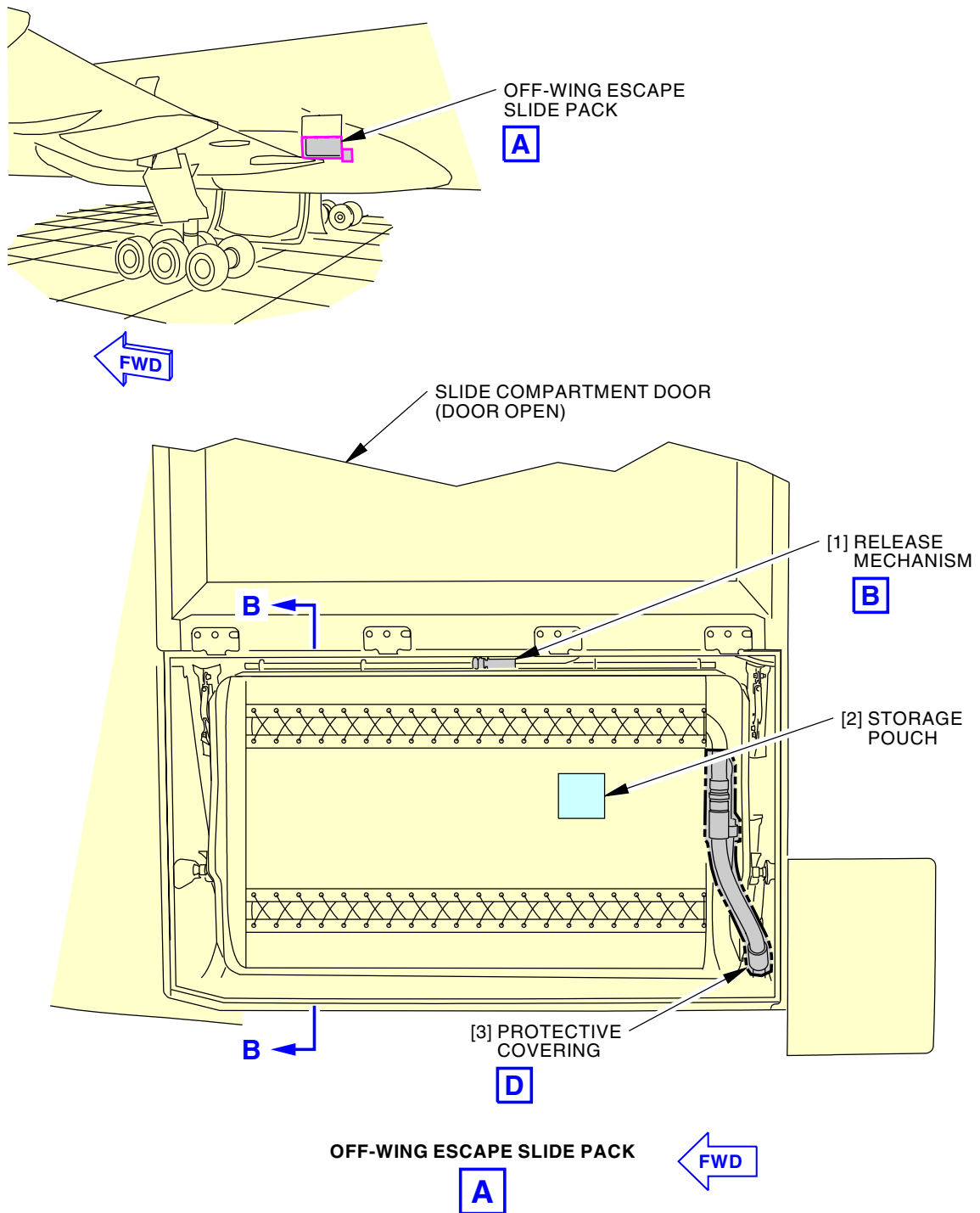
EFFECTIVITY
ARO ALL

25-65-01

D633W101-ARO

Page 405
Sep 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



G55796 S0006411510_V2

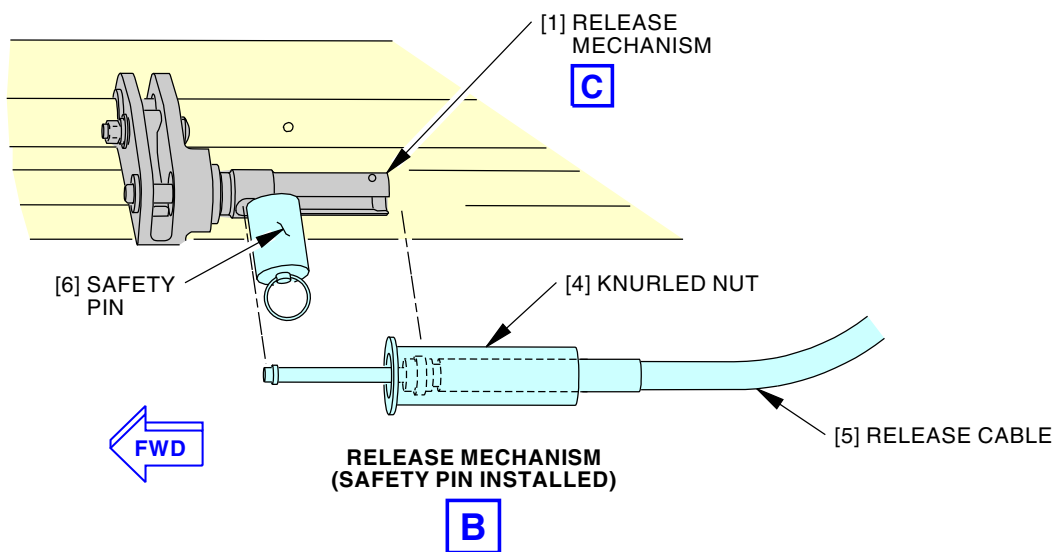
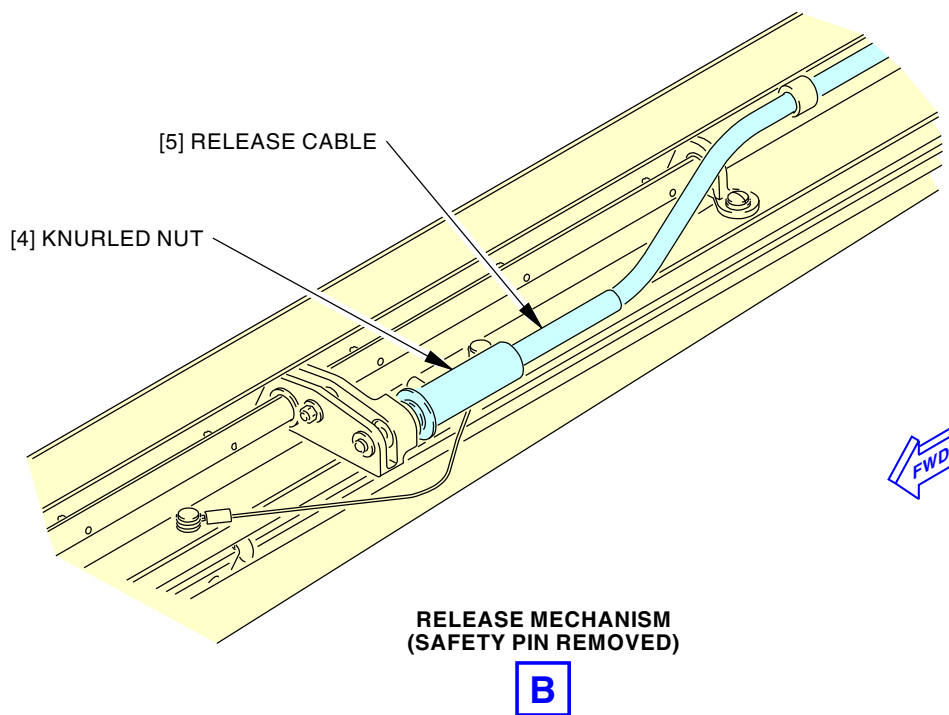
Off-Wing Escape Slide Pack Installation
Figure 401/25-65-01-990-801 (Sheet 1 of 6)

EFFECTIVITY
ARO ALL

25-65-01

D633W101-ARO

Page 406
May 05/2017



G55890 S0006411511_V3

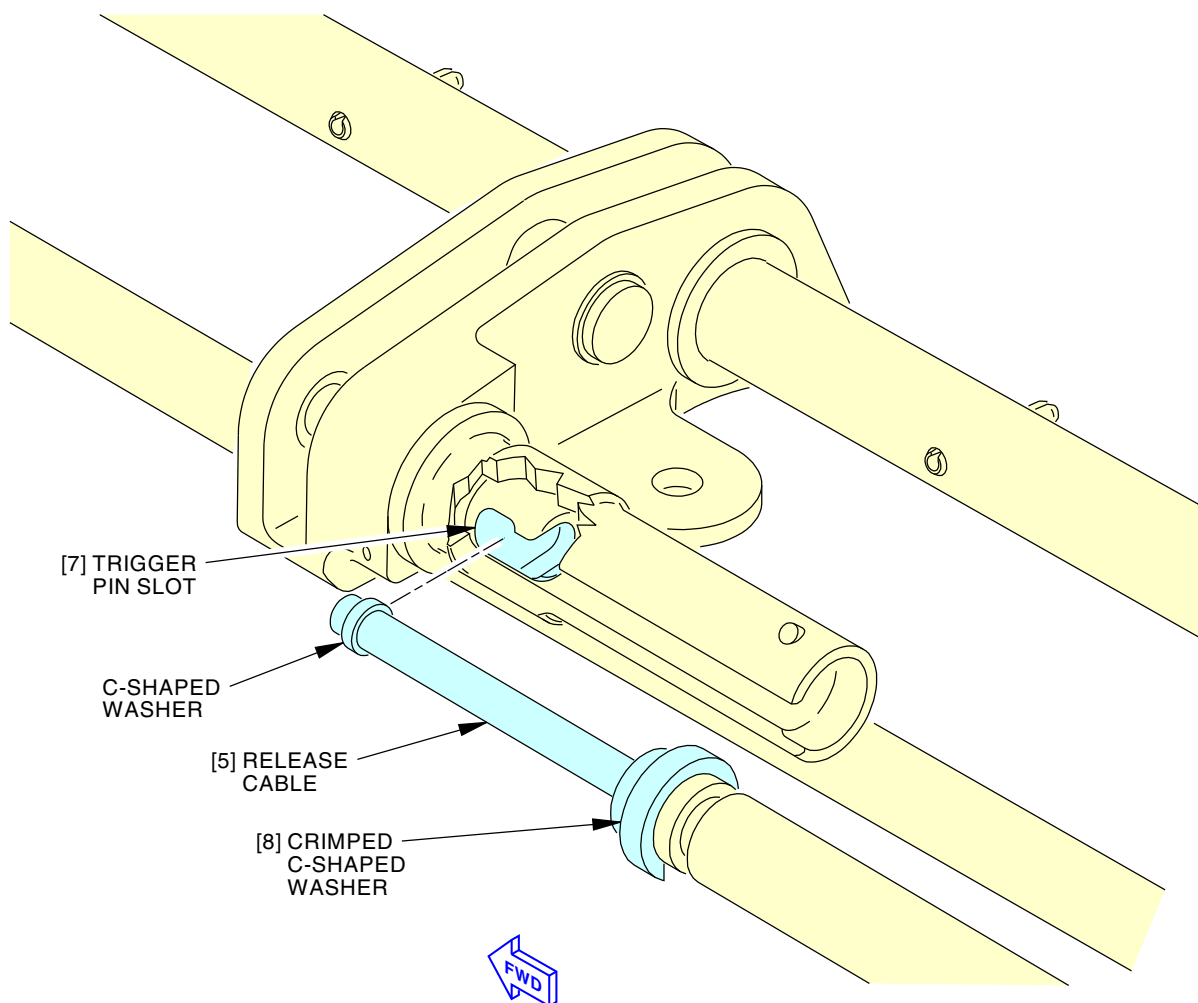
**Off-Wing Escape Slide Pack Installation
Figure 401/25-65-01-990-801 (Sheet 2 of 6)**

EFFECTIVITY
ARO ALL

25-65-01

D633W101-ARO

Page 407
May 05/2017



RELEASE MECHANISM
(KNURLED NUT NOT SHOWN)

C

H01751 S0006411512_V5

Off-Wing Escape Slide Pack Installation
Figure 401/25-65-01-990-801 (Sheet 3 of 6)

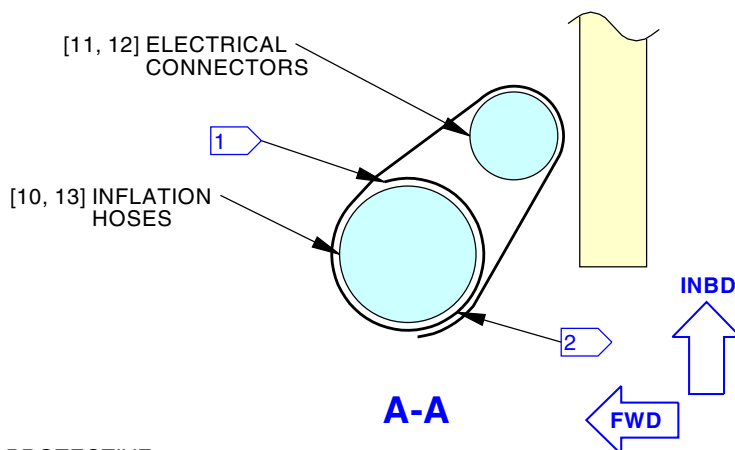
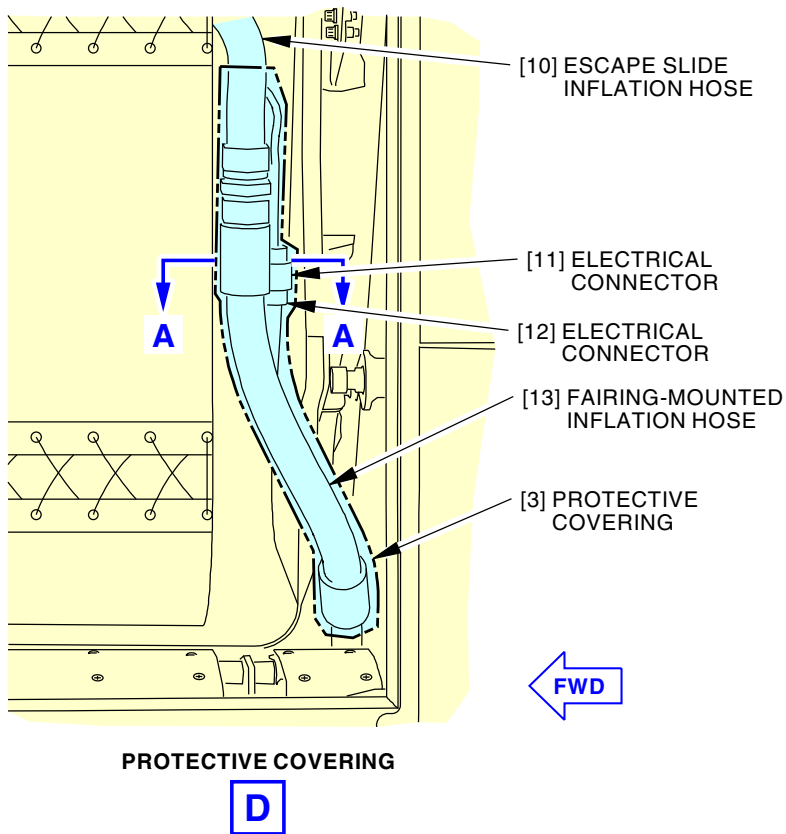
EFFECTIVITY
ARO ALL

25-65-01

D633W101-ARO

Page 408
Jan 05/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



- 1** PUT THE LOOSE FLAP OF THE PROTECTIVE COVER BETWEEN THE HOSE AND THE WIRE BUNDLE.
- 2** ENGAGE THE VELCRO STRIP ALONG THIS EDGE.

G55920 S0006411513_V2

**Off-Wing Escape Slide Pack Installation
Figure 401/25-65-01-990-801 (Sheet 4 of 6)**

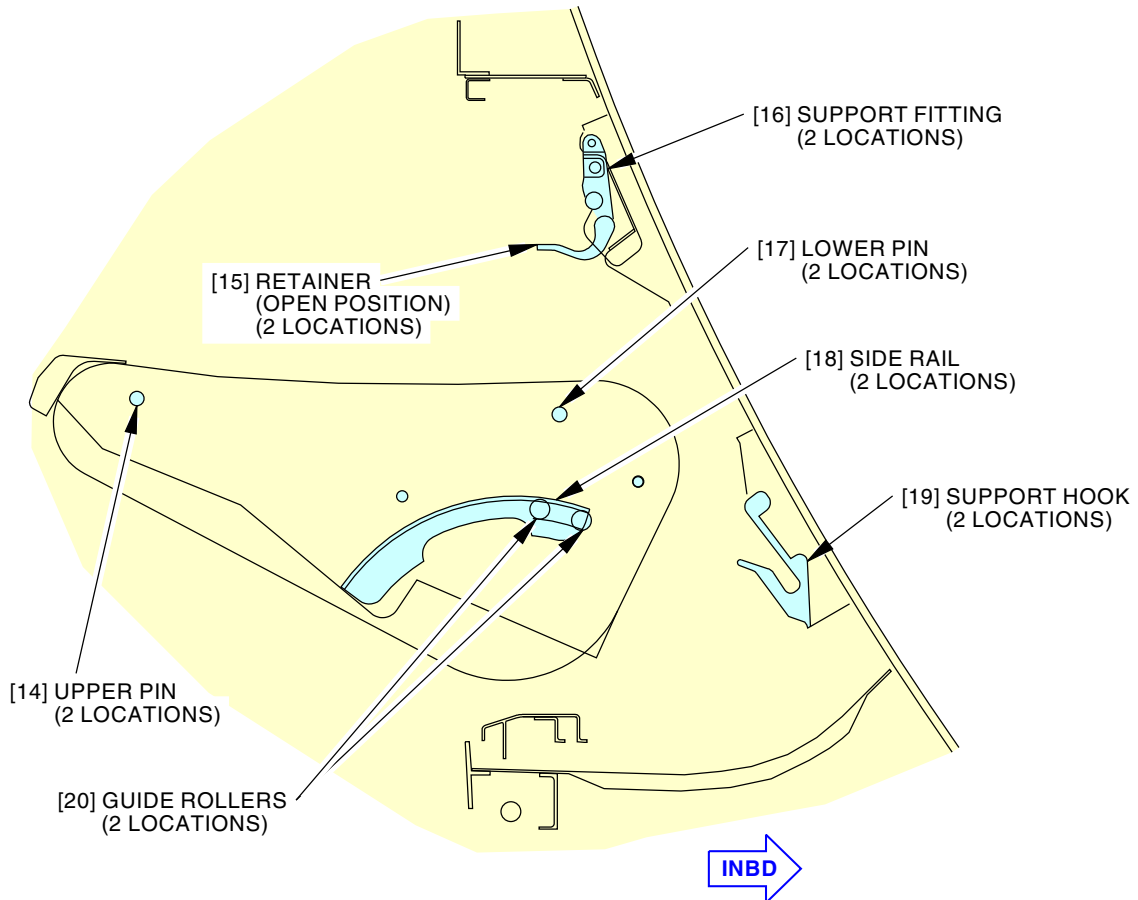
EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-01

Page 409
May 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



**ESCAPE SLIDE PACK
(INITIAL POSITION)**

B-B

G57173 S0006411514_V2

**Off-Wing Escape Slide Pack Installation
Figure 401/25-65-01-990-801 (Sheet 5 of 6)**

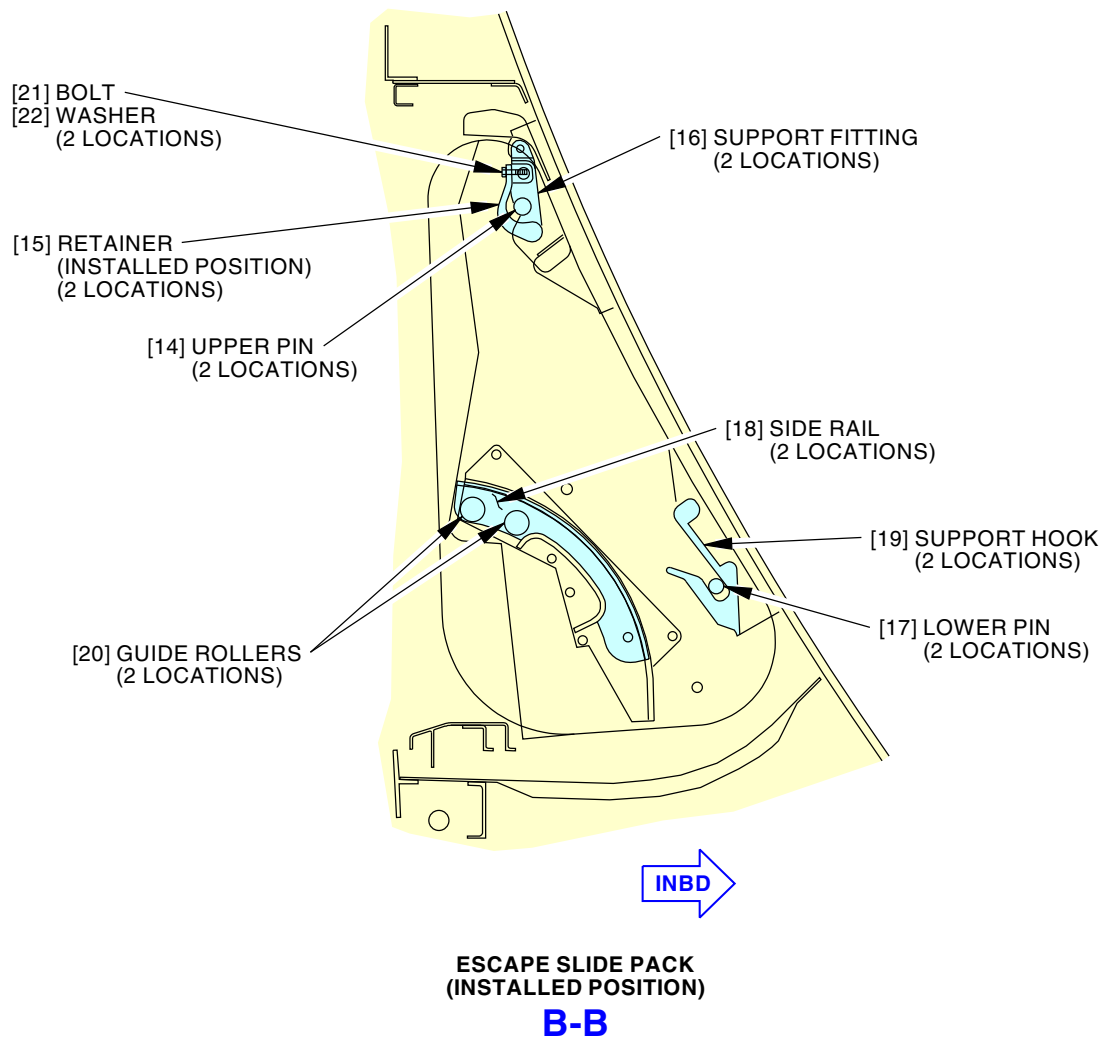
EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-01

Page 410
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



G57174 S0006411515_V3

Off-Wing Escape Slide Pack Installation
Figure 401/25-65-01-990-801 (Sheet 6 of 6)

EFFECTIVITY
ARO ALL

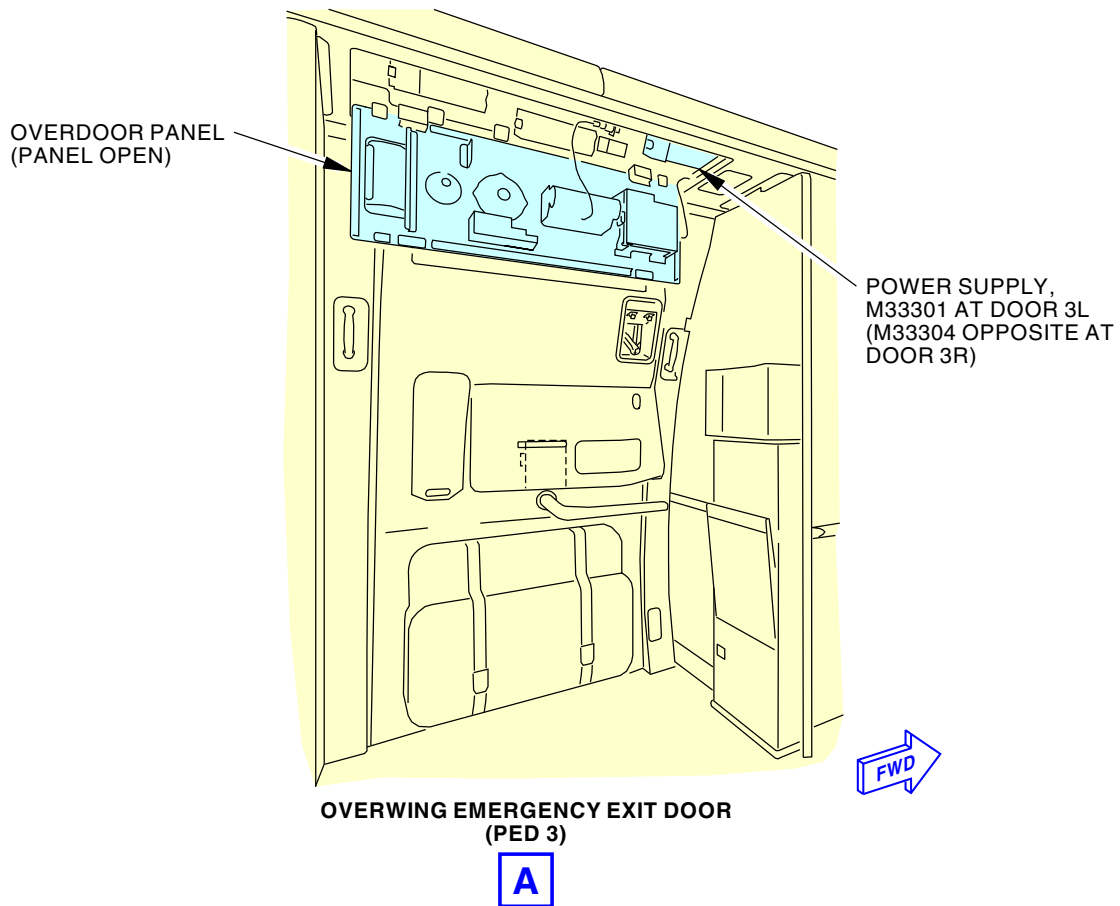
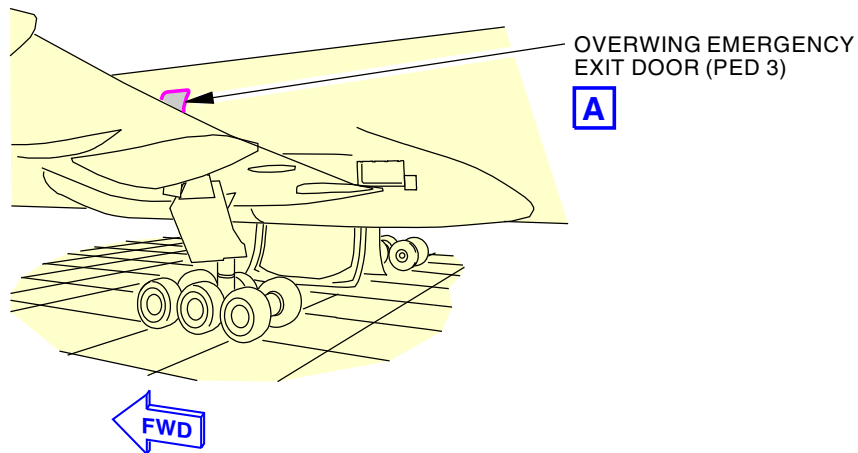
D633W101-ARO

25-65-01

Page 411
Jan 05/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL



2176224 S0000479862_V2

Off-Wing Escape Slide Lights Test
Figure 402/25-65-01-990-802 (Sheet 1 of 2)

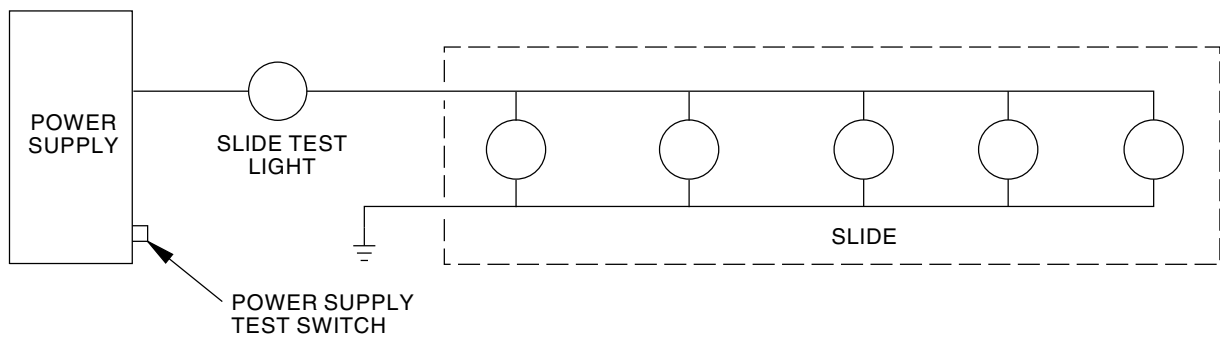
EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-01

Page 412
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



2116323 S0000453615_V2

Off-Wing Escape Slide Lights Test
Figure 402/25-65-01-990-802 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-01

Page 413
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

INFLATION BOTTLE FOR THE OFF-WING ESCAPE SLIDE - REMOVAL/INSTALLATION

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) Removal of the inflation bottle for the off-wing escape slide.
 - (2) Installation of the inflation bottle for the off-wing escape slide.

TASK 25-65-02-000-801

2. Inflation Bottle for the Off-Wing Escape Slide - Removal

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This procedure gives the task to remove the inflation bottle for the over wing escape slide.
- (2) The EPAS battery pack on each passenger entry door (PED) 3 fires the squibs on the EPAS pneumatic reservoir, the escape slide inflation bottle and the SARD cartridge. The over wing system backup battery on an overhead panel near the PED 3 fires the squibs on the inflation bottle and the SARD cartridge.
- (3) The squibs are electro-explosive devices (EED). Maintenance personnel that touch the EED must use wrist straps to ground themselves to a ground point. These persons must wear clothes that make a small static electrical charge such as cotton or cotton/synthetic blends. Do not wear all wool clothing, all nylon clothing or all synthetic clothing. Remove reflective outerwear such as visual safety vests or coats before you touch the EED or disconnect or connect wire bundles.

B. References

Reference	Title
25-21-08-000-801	Overdoor Panel Opening/Removal (P/B 201)
25-65-00-840-801	Put the Off-Wing Escape System Back to its Initial Condition after Deployment (P/B 201)
25-65-00-870-801	Release the Gas From the Inflation Bottle for the Off-Wing Escape Slide (P/B 201)
25-65-02-200-801	Inflation Bottle Pressure Check (P/B 601)
52-12-25-000-802	Hinge Covers Removal (P/B 201)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-1565	Strap - Adjustable Wrist, Conductive, Static Control
	Part #: 09070 Supplier: 62576
	Part #: 14810 Supplier: 62576
	Part #: 2214 Supplier: 55203
	Opt Part #: 2211 Supplier: 55203
	Opt Part #: 2212 Supplier: 55203
	Opt Part #: 2213 Supplier: 55203

EFFECTIVITY
ARO ALL

25-65-02

D633W101-ARO

Page 401
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Location Zones

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right
211	Flight Compartment, Left
212	Flight Compartment, Right
243	Area Above Passenger Compartment Ceiling, Left - Section 44
244	Area Above Passenger Compartment Ceiling, Right - Section 44
833	Left No. 3 Overwing Door - Section 44
843	Right No. 3 Overwing Door - Section 44

E. Access Panels

Number	Name/Location
197EL	Aft Wing To Body Fairing Panel
198ER	Aft Wing To Body Fairing Panel

F. Prepare for the Removal

SUBTASK 25-65-02-865-001

- (1) Open these circuit breakers and install safety tags:

Left Power Management Panel, P110

Row	Col	Number	Name
H	15	C52612	L EPAS BACKUP BAT

Overhead Circuit Breaker Panel, P11

Row	Col	Number	Name
H	16	C33621	EMERGENCY LIGHTS DOOR 3L
H	17	C33620	EMERGENCY LIGHTS DOOR 3R

Right Power Management Panel, P210

Row	Col	Number	Name
J	14	C52613	R EPAS BACKUP BAT

SUBTASK 25-65-02-860-004

- (2) Make sure the passenger entry door 3 (PED 3 or overwing emergency exit door) is closed and locked.

SUBTASK 25-65-02-040-005

- (3) Make sure the mode select handle on the PED 3 door is in the MANUAL/DISARM position.

SUBTASK 25-65-02-010-003

- (4) Remove the aft hinge cover and the forward hinge cover on the PED 3 to get access to the EPAS battery.

- (a) Do this task: Hinge Covers Removal, TASK 52-12-25-000-802.

SUBTASK 25-65-02-040-003

- (5) Move the safety switch for the EPAS battery to the DISARM position.

SUBTASK 25-65-02-010-004

- (6) Open the overhead panel above the PED 3 door to get access to the backup battery.

- (a) Do this task: Overdoor Panel Opening/Removal, TASK 25-21-08-000-801.

EFFECTIVITY
ARO ALL

25-65-02

D633W101-ARO

Page 402
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-65-02-040-004

- (7) Move the safety switch for the backup battery to the DISARM position.

SUBTASK 25-65-02-010-001

- (8) Get access to the inflation bottle [1] as follows:

- (a) For the left wing, open this access panel:

<u>Number</u>	<u>Name/Location</u>
197EL	Aft Wing To Body Fairing Panel

For the right wing, open this access panel:

<u>Number</u>	<u>Name/Location</u>
198ER	Aft Wing To Body Fairing Panel

SUBTASK 25-65-02-030-001

- (9) Open the insulation blanket around the inflation bottle [1].

SUBTASK 25-65-02-860-005

 WARNING	PUT ON A WRIST STRAP THAT IS ATTACHED TO A GROUND BEFORE YOU MAKE ELECTRICAL CONNECTIONS TO AN ELECTRICAL EXPLOSIVE DEVICE. STATIC ELECTRICITY CAN CAUSE AN EXPLOSION.

- (10) Before you touch the cartridge (squib), put on a static control wrist strap, COM-1565 so that it touches your skin, then connect it to an electrical ground.

SUBTASK 25-65-02-210-001

- (11) Make sure it is safe to remove the inflation bottle [1] as follows:

- (a) Remove the safety pin [5] from the storage pouch.
(b) Install the safety pin [5] in the pressure regulator [9] on the inflation bottle [1].
(c) Examine the pressure regulator [9] to see if the warning indicator [12] shows (red).

NOTE: If the warning indicator shows, the squib [10] is fired.

- (d) Examine the pressure gage [13] to see if the inflation bottle [1] is pressurized.

NOTE: If the needle for the pressure gage is in the green area, the inflation bottle is fully pressurized. If the needle for the pressure gage is at the bottom of the red area, there is zero pressure in the inflation bottle.

- 1) Refer to the task: Inflation Bottle Pressure Check, TASK 25-65-02-200-801.

 WARNING	IF THE SQUIB IS FIRED, AND THE SAFETY PIN IS INSTALLED, YOU MUST RELEASE THE PRESSURE FROM THE INFLATION BOTTLE BEFORE YOU REMOVE IT FROM THE AIRPLANE. IF THE SAFETY PIN IS ACCIDENTALLY PULLED WHEN THE BOTTLE IS NOT TIGHTLY HELD, INJURY TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (e) If the squib [10] is fired, and the safety pin [5] is installed, and there is more than zero pressure in the inflation bottle [1], then do these steps:

- 1) Do this task: Release the Gas From the Inflation Bottle for the Off-Wing Escape Slide, TASK 25-65-00-870-801.
2) Do this task: Put the Off-Wing Escape System Back to its Initial Condition after Deployment, TASK 25-65-00-840-801.

NOTE: Do not replace the escape slide pack.

EFFECTIVITY
ARO ALL

25-65-02

D633W101-ARO

Page 403
Sep 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL

G. Removal

SUBTASK 25-65-02-020-001

- (1) Remove the inflation bottle [1] as follows:



WARNING

MAKE SURE THE SAFETY PIN IS INSTALLED IN THE PRESSURE REGULATOR ON THE INFLATION BOTTLE. IF YOU DO NOT OBEY THIS INSTRUCTION, THE INFLATION BOTTLE CAN DISCHARGE AND INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT CAN OCCUR.

- (a) Make sure the safety pin [5] is installed in the regulator [9] on the inflation bottle [1].



WARNING

PUT ON A WRIST STRAP THAT IS ATTACHED TO A GROUND BEFORE YOU MAKE ELECTRICAL CONNECTIONS TO AN ELECTRICAL EXPLOSIVE DEVICE. STATIC ELECTRICITY CAN CAUSE AN EXPLOSION.

- (b) Before you touch the squib [10] for the inflation bottle [1], put on a static control wrist strap, COM-1565 so that it touches your skin, then connect it to an electrical ground.
(c) Disconnect the electrical connector [2] from the squib [10].
(d) Remove the shorting cap [6] from the storage pouch.



WARNING

PUT ON A WRIST STRAP THAT IS ATTACHED TO A GROUND BEFORE YOU MAKE ELECTRICAL CONNECTIONS TO AN ELECTRICAL EXPLOSIVE DEVICE. STATIC ELECTRICITY CAN CAUSE AN EXPLOSION.

- (e) Install the shorting cap [6] on the squib [10].
(f) Disconnect the inflation tube [11] from the pressure regulator [9].
(g) Remove the cap [4] from the storage pouch.
(h) Install the cap [4] on the tube connector [3] for the regulator [9].
(i) Install a cap or plug on the inflation tube [11].
(j) Make sure the installation straps [7] are tight.
(k) Disconnect the clamps [8] that hold the inflation bottle [1].
(l) Lower the inflation bottle [1] using the installation straps [7].



WARNING

BE CAREFUL WHEN YOU MOVE THE INFLATION BOTTLE. THE INFLATION BOTTLE WEIGHS APPROXIMATELY 65 POUNDS. IF YOU DO NOT OBEY THIS INSTRUCTION, INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

- (m) Carefully remove the inflation bottle [1].

————— END OF TASK —————

TASK 25-65-02-400-801

3. Inflation Bottle for the Off-Wing Escape Slide - Installation

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-02

Page 404
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

A. General

- (1) This procedure gives the task to install the inflation bottle for the over wing escape slide.
- (2) The EPAS battery pack on each passenger entry door (PED) 3 fires the squibs on the EPAS pneumatic reservoir, the escape slide inflation bottle and the SARD cartridge. The over wing system backup battery on an overhead panel near the PED 3 fires the squibs on the inflation bottle and the SARD cartridge.
- (3) The squibs are electro-explosive devices (EED). Maintenance personnel that touch the EED must use wrist straps to ground themselves to a ground point. These persons must wear clothes that make a small static electrical charge such as cotton or cotton/synthetic blends. Do not wear all wool clothing, all nylon clothing or all synthetic clothing. Remove reflective outerwear such as visual safety vests or coats before you touch the EED or disconnect or connect wire bundles.

B. References

Reference	Title
25-21-08-400-801	Overdoor Panel Installation/Closing (P/B 201)
52-12-19-710-801	Emergency Power Assist System (EPAS) Squib Test (PED 3) (P/B 501)
52-12-25-400-802	Hinge Covers Installation (P/B 201)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-1565	Strap - Adjustable Wrist, Conductive, Static Control Part #: 09070 Supplier: 62576 Part #: 14810 Supplier: 62576 Part #: 2214 Supplier: 55203 Opt Part #: 2211 Supplier: 55203 Opt Part #: 2212 Supplier: 55203 Opt Part #: 2213 Supplier: 55203

D. Location Zones

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right
211	Flight Compartment, Left
212	Flight Compartment, Right
243	Area Above Passenger Compartment Ceiling, Left - Section 44
244	Area Above Passenger Compartment Ceiling, Right - Section 44
833	Left No. 3 Overwing Door - Section 44
843	Right No. 3 Overwing Door - Section 44

E. Access Panels

Number	Name/Location
197EL	Aft Wing To Body Fairing Panel
198ER	Aft Wing To Body Fairing Panel

EFFECTIVITY
ARO ALL

25-65-02

D633W101-ARO

Page 405
May 05/2015

777-200/300
AIRCRAFT MAINTENANCE MANUAL

F. Prepare for the Installation

SUBTASK 25-65-02-200-001



MAKE SURE THE SAFETY PIN IS INSTALLED IN THE PRESSURE REGULATOR ON THE INFLATION BOTTLE. IF YOU DO NOT OBEY THIS INSTRUCTION, THE INFLATION BOTTLE CAN DISCHARGE AND INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

- (1) Make sure the safety pin [5] is installed in the pressure regulator [9] on the inflation bottle [1], and that the shorting cap [6] is installed on the squib [10].

G. Installation

SUBTASK 25-65-02-400-001

- (1) Install the inflation bottle [1] as follows:

- (a) If necessary, open the insulation blanket for the inflation bottle [1].



BE CAREFUL WHEN YOU MOVE THE INFLATION BOTTLE. THE INFLATION BOTTLE WEIGHS APPROXIMATELY 65 POUNDS. IF YOU DO NOT OBEY THIS INSTRUCTION, INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

- (b) Lift the inflation bottle [1] into its correct position with the installation straps [7] as follows:
 - 1) Make sure the two parts of each installation strap [7] are connected.
 - 2) Put the aft end of the inflation bottle [1] into the aft installation strap [7], then put the forward end of the inflation bottle [1] into the forward installation strap [7].
 - 3) Pull the loose ends of the installation straps [7] until the inflation bottle [1] is in its correct position against the fuselage structure.
 - 4) Connect the clamps [8], but do not tighten them.
- (c) Remove the cap [4] from the tube connector [3] on the pressure regulator [9].
- (d) Put the cap [4] in the storage pouch.
- (e) Align the tube connector [3] on the pressure regulator [9] with the inflation tube [11].



MAKE SURE THE THREADS OF THE INFLATION TUBE ARE CORRECTLY ENGAGED WITH THE THREADS OF THE TUBE CONNECTOR. IF THE THREADS ARE NOT CORRECTLY ENGAGED, DAMAGE TO THE EQUIPMENT CAN OCCUR.

- (f) Engage the threads of the inflation tube [11] with the tube connector [3].
- (g) Tighten the fitting on the end of the inflation tube [11].

NOTE: This step will put the inflation bottle [1] in its correct position.
- (h) Tighten the clamps [8] that hold the inflation bottle [1].



PUT ON A WRIST STRAP THAT IS ATTACHED TO A GROUND BEFORE YOU MAKE ELECTRICAL CONNECTIONS TO AN ELECTRICAL EXPLOSIVE DEVICE. STATIC ELECTRICITY CAN CAUSE AN EXPLOSION.

- (i) Before you touch the squib [10] for the inflation bottle [1], put on a static control wrist strap, COM-1565 so that it touches your skin, then connect it to an electrical ground.
- (j) Remove the shorting cap [6] from the squib [10].

EFFECTIVITY
ARO ALL

25-65-02

777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (k) Put the shorting cap [6] in the storage pouch.
- (l) Connect the electrical connector [2] to the squib [10].

NOTE: You must be careful when you connect the electrical connectors to the squibs. When examined, the electrical connector can appear to be completely engaged. However, a bent pin in the connector will not let the squib fire. You must straighten any bent pins in the squib.



WARNING

REMOVE THE SAFETY PIN FROM THE PRESSURE REGULATOR ON THE INFLATION BOTTLE. IF YOU DO NOT OBEY THIS INSTRUCTION, THE INFLATION BOTTLE WILL NOT CAUSE THE ESCAPE SLIDE TO OPERATE. IF THE ESCAPE SLIDE DOES NOT OPERATE DURING AN EMERGENCY, INJURIES TO PERSONS CAN OCCUR.

- (m) Remove the safety pin [5] from the pressure regulator [9].
- (n) Put the safety pin [5] in the storage pouch.

SUBTASK 25-65-02-860-001

- (2) Close the insulation around the inflation bottle.

SUBTASK 25-65-02-720-001

- (3) Do a test for continuity through the inflation bottle squib.

- (a) Do this task: Emergency Power Assist System (EPAS) Squib Test (PED 3), TASK 52-12-19-710-801.

NOTE: This test uses an inline electrical connector D6253P/D6253J on the PED 3 door.

NOTE: This test is recommended whenever an electrical connector is disconnected and connected again to an off-wing escape system squib or the EPAS reservoir squib.

NOTE: Do not use any multimeter for the continuity check across the squib circuit because the use of the wrong multimeter can cause the squib to fire. Use an approved ignition circuit tester.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 25-65-02-410-003

- (1) Install the applicable wing access panel to close access to the inflation bottle [1].

For the left wing, close this access panel:

<u>Number</u>	<u>Name/Location</u>
197EL	Aft Wing To Body Fairing Panel

For the right wing, close this access panel:

<u>Number</u>	<u>Name/Location</u>
198ER	Aft Wing To Body Fairing Panel

SUBTASK 25-65-02-440-001

- (2) Turn the safety switch on the backup battery to the ARM position.

SUBTASK 25-65-02-410-004

- (3) Close the overhead panel above the PED 3 door.

- (a) Do this task: Overdoor Panel Installation/Closing, TASK 25-21-08-400-801.

SUBTASK 25-65-02-440-002

- (4) Put the safety switch on the EPAS battery pack to the ARM position.

EFFECTIVITY
ARO ALL

25-65-02

D633W101-ARO

Page 407
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-65-02-410-005

(5) Install the forward and aft hinge covers on the passenger entry door 3 (PED 3).

(a) Do this task: Hinge Covers Installation, TASK 52-12-25-400-802.

NOTE: If the safety switch for the EPAS battery is in the DISARM position, the aft hinge cover will not be flush.

SUBTASK 25-65-02-865-002

(6) Remove the safety tags and close these circuit breakers:

Left Power Management Panel, P110

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	15	C52612	L EPAS BACKUP BAT

Overhead Circuit Breaker Panel, P11

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	16	C33621	EMERGENCY LIGHTS DOOR 3L
H	17	C33620	EMERGENCY LIGHTS DOOR 3R

Right Power Management Panel, P210

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
J	14	C52613	R EPAS BACKUP BAT

————— **END OF TASK** —————

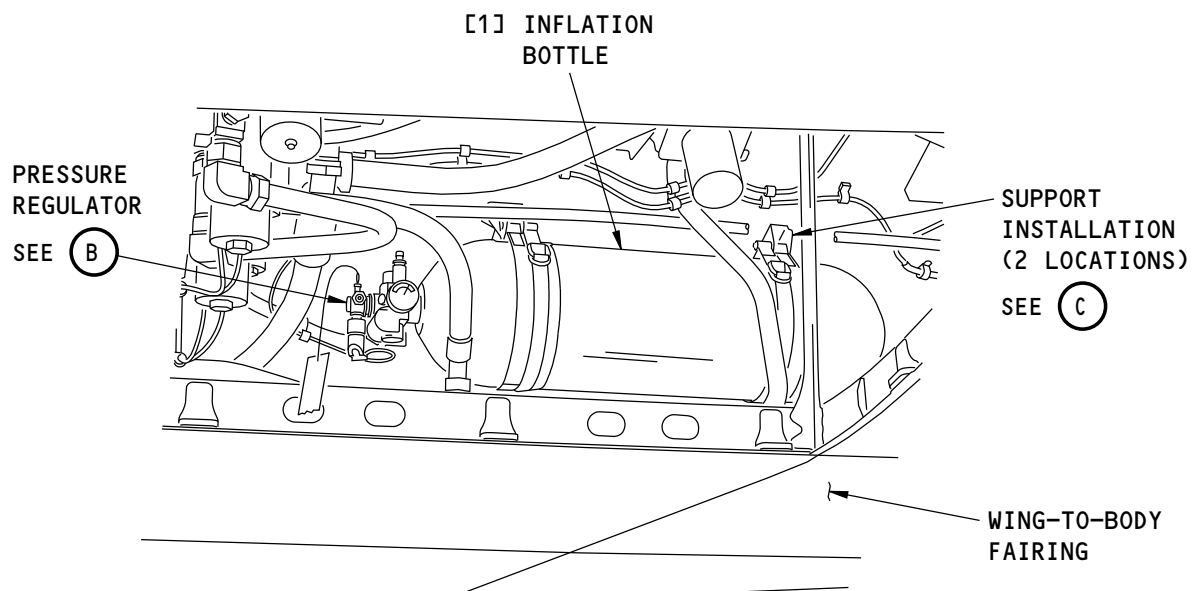
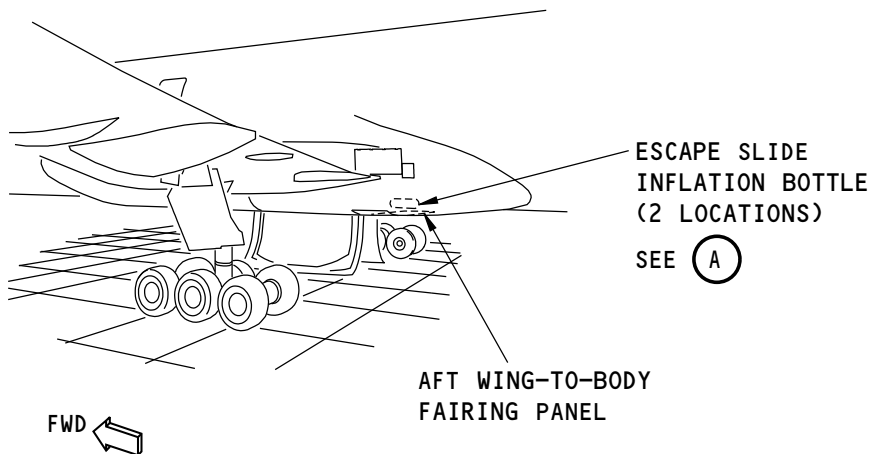
EFFECTIVITY
ARO ALL

25-65-02

D633W101-ARO

Page 408
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**ESCAPE SLIDE INFLATION BOTTLE
(INSULATION BLANKET REMOVED)
(EXAMPLE)**

(A)

G42776 S0006411520_V1

**Escape Slide Inflation Bottle Installation
Figure 401/25-65-02-990-801 (Sheet 1 of 2)**

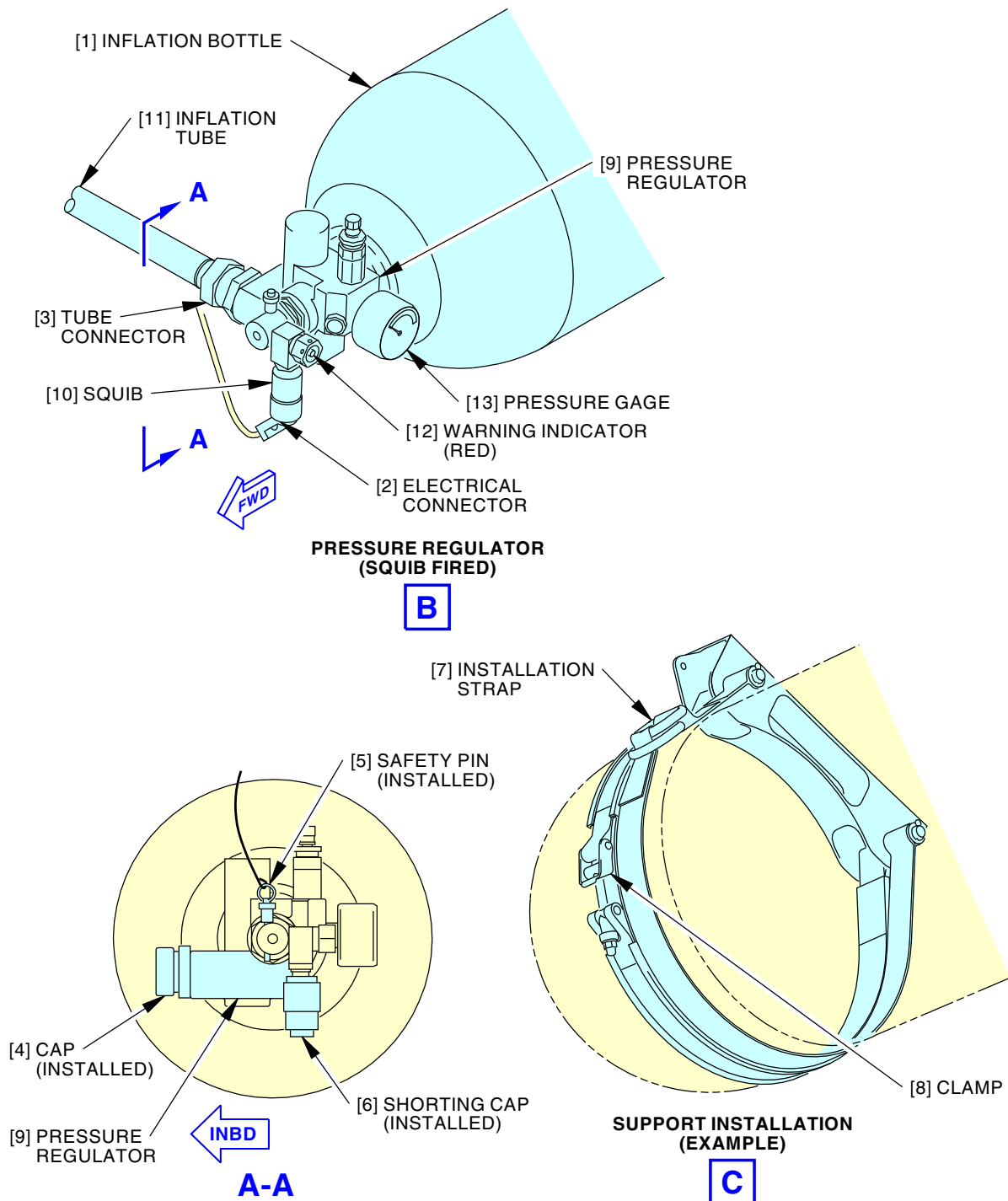
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D633W101-ARO

25-65-02

Page 409
Jan 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Escape Slide Inflation Bottle Installation
Figure 401/25-65-02-990-801 (Sheet 2 of 2)**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-02

Page 410
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

OFF-WING ESCAPE SLIDE INFLATION BOTTLE - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure is a check of the inflation bottle pressure for the off-wing escape slide.

TASK 25-65-02-200-801

2. Inflation Bottle Pressure Check

(Figure 601)

NOTE: This procedure is a scheduled maintenance task.

A. **References**

Reference	Title
25-65-00-040-801	Disarm the Off-Wing Escape System (P/B 201)
25-65-00-440-801	Arm the Off-Wing Escape System (P/B 201)

B. **Location Zones**

Zone	Area
195	Underwing Wing-to-Body Fairings, Left
196	Underwing Wing-to-Body Fairings, Right

C. **Access Panels**

Number	Name/Location
197DL	Air-Driven Pump (ADP) Filter Module Access Door and Escape Slide Inflation Bottle
198DR	Hydraulic Ground Service Bay Access Door and Escape Slide Inflation Bottle

D. **Prepare for the Procedure**

SUBTASK 25-65-02-040-002

- (1) Make sure the mode select handle on the PED 3 is in the MANUAL/DISARM position.

SUBTASK 25-65-02-040-006

- (2) Do this task: Disarm the Off-Wing Escape System, TASK 25-65-00-040-801.

NOTE: Only do the steps to disarm the EPAS battery and the EPAS backup battery.

SUBTASK 25-65-02-010-002

- (3) Get access to the inflation bottle:

- (a) For the left wing, open this access panel:

Number	Name/Location
197DL	Air-Driven Pump (ADP) Filter Module Access Door and Escape Slide Inflation Bottle

For the right wing, open this access panel:

Number	Name/Location
198DR	Hydraulic Ground Service Bay Access Door and Escape Slide Inflation Bottle

SUBTASK 25-65-02-030-002

- (4) Open the forward end of the insulation blanket around the inflation bottle.

E. **Procedure**

SUBTASK 25-65-02-860-002

- (1) Do a check on the inflation bottle pressure level as follows:

EFFECTIVITY
ARO ALL

25-65-02

D633W101-ARO

Page 601
May 05/2015



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**

- (a) Make sure the pressure indicator needle is in the GO band (green).

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-65-02-430-001

- (1) Close the forward end of the insulation blanket around the inflation bottle.

SUBTASK 25-65-02-410-002

- (2) Close the access for the inflation bottle:

- (a) For the left wing, close this access panel:

<u>Number</u>	<u>Name/Location</u>
197DL	Air-Driven Pump (ADP) Filter Module Access Door and Escape Slide Inflation Bottle

For the right wing, close this access panel:

<u>Number</u>	<u>Name/Location</u>
198DR	Hydraulic Ground Service Bay Access Door and Escape Slide Inflation Bottle

SUBTASK 25-65-02-860-003

- (3) Do this task: Arm the Off-Wing Escape System, TASK 25-65-00-440-801.

———— **END OF TASK** ————

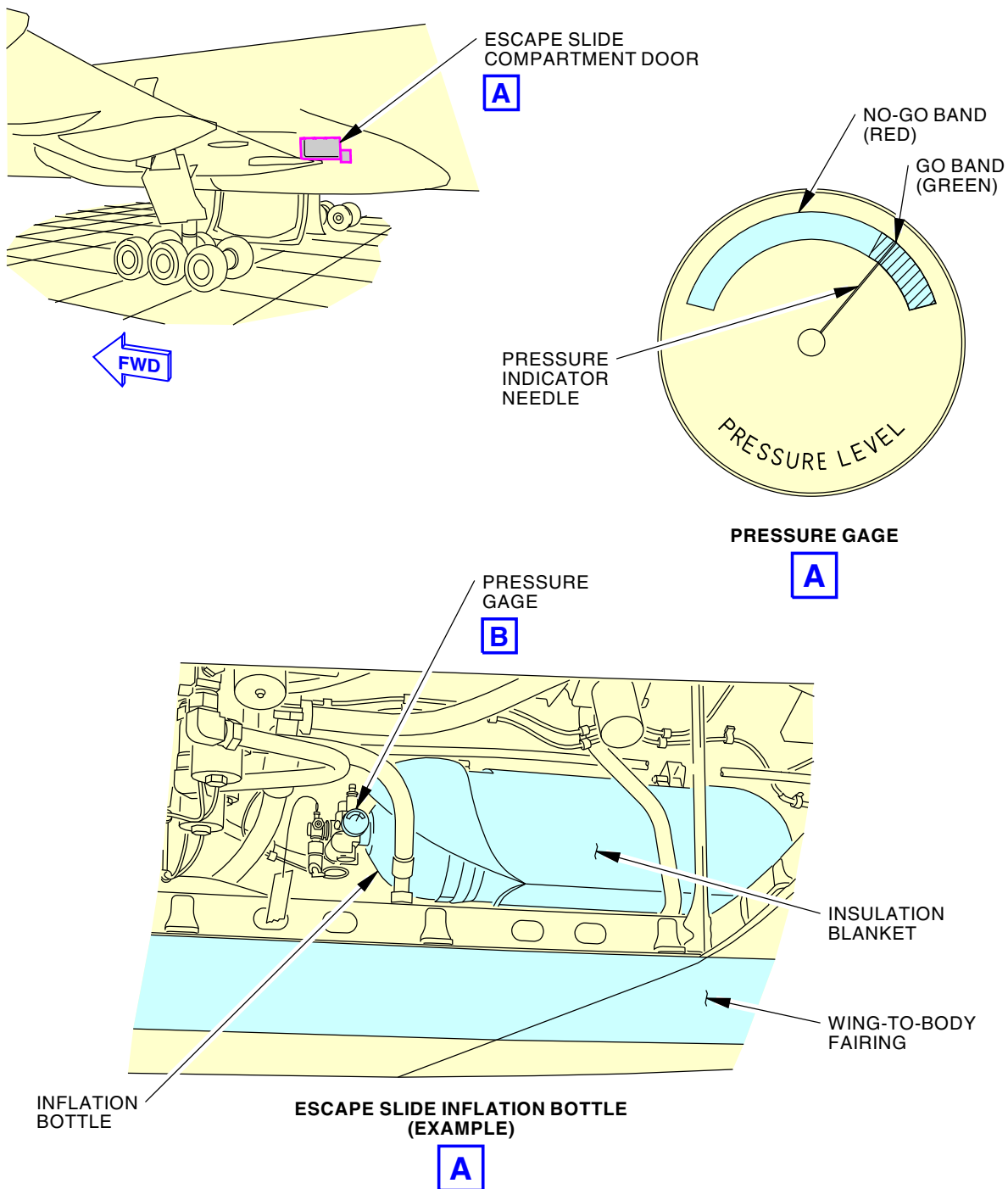
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ARO ALL

D633W101-ARO

25-65-02

Page 602
May 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Escape Slide Inflation Bottle Inspection
Figure 601/25-65-02-990-802**

EFFECTIVITY
ARO ALL

25-65-02

D633W101-ARO

Page 603
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

OFF-WING ESCAPE SLIDE COMPARTMENT DOOR - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks:

- (1) Open the off-wing escape slide compartment door.
- (2) Close the off-wing escape slide compartment door.

TASK 25-65-10-010-801

2. Open the Escape Slide Compartment Door

(Figure 201)

A. **References**

Reference	Title
25-65-00-040-801	Disarm the Off-Wing Escape System (P/B 201)

B. **Location Zones**

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right

C. **Prepare for the Procedure**

SUBTASK 25-65-10-840-001

- (1) Do this task: Disarm the Off-Wing Escape System, TASK 25-65-00-040-801.

D. **Procedure**

SUBTASK 25-65-10-860-001



DO NOT TRY TO OPEN THE SLIDE COMPARTMENT DOOR BEFORE YOU DISARM THE OFF-WING ESCAPE SYSTEM. THE ESCAPE SLIDE CAN INFLATE AND INJURIES OR DAMAGE CAN OCCUR.

- (1) Open the slide compartment door as follows:
 - (a) Disengage the o-ring from the handle at the handle dock.
 - (b) Push and hold the lock release lever to disengage the uplock detent.
 - (c) Push the handle forward approximately 0.25 inch, then pull the handle outboard until it turns approximately 30 degrees.

NOTE: You must first push the handle forward before you can pull the handle outboard.
 - (d) Release the lock release lever.
 - (e) If necessary, pull the handle with a force of not more than 150 pounds to open the door.

NOTE: Ice buildup around the door perimeter can increase the handle pull force.
 - (f) Continue to pull the handle until you hear a click as the downlock detent engages.
 - (g) Remove the hold open strap fitting from the dock inside the lower forward corner of the door.
 - (h) Push the door up against the fuselage to the open position.
 - (i) Put the hold open strap fitting into the receptacle in the fuselage.

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-10

Page 201
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-65-10-400-801

3. Close the Escape Slide Compartment Door

(Figure 201)

A. References

Reference	Title
25-65-00-440-801	Arm the Off-Wing Escape System (P/B 201)
31-61-00-800-813	Showing Status Messages (P/B 201)
31-61-00-800-814	Showing Alert Messages (P/B 201)

B. Location Zones

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right

C. Prepare for the Escape Slide Compartment Door Closure.

SUBTASK 25-65-10-860-006

- (1) Make sure the slide compartment door is in the open position.
- (2) Make sure the latch actuator handle is engaged in the downlock detent.
- (3) Do a check of the DOOR WING SLIDE EICAS Advisory and Status messages.

NOTE: EICAS alert and status messages are checked before closing the slide compartment door. This will confirm EICAS messages are available to show an open or unlock condition.

- (a) Make sure that EICAS DOOR WING SLIDE L/R alert message shows for the L/R slide compartment door. To show alert messages, do this task: Showing Alert Messages, TASK 31-61-00-800-814.

NOTE: EICAS alert level message is shown when the slide compartment door is not fully closed and locked.

- (b) Make sure that EICAS DOOR WING SLIDE L/R and DOOR WING SLIDE LK L/R status messages do not show for the L/R slide compartment door. To show status messages, do this task: Showing Status Messages, TASK 31-61-00-800-813.

NOTE: DOOR WING SLIDE L/R message is for faulty door proximity sensor. DOOR WING SLIDE LK L/R message is for faulty door latch actuator lock switch.

D. Procedure

SUBTASK 25-65-10-860-002



WARNING DO NOT TRY TO CLOSE THE SLIDE COMPARTMENT DOOR BEFORE YOU DISARM THE OFF-WING ESCAPE SYSTEM. THE ESCAPE SLIDE CAN INFLATE AND INJURIES OR DAMAGE CAN OCCUR.

- (1) Close the slide compartment door as follows:



CAUTION DO NOT LET THE DOOR FALL AND HIT THE LATCH MECHANISM. DAMAGE TO THE LATCH MECHANISM CAN OCCUR.

- (a) Disconnect the hold open strap fitting from the receptacle in the fuselage.
- (b) Lower the door with your hand to the straight down position.

EFFECTIVITY
ARO ALL

25-65-10

D633W101-ARO

Page 202
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (c) Put the hold open strap fitting in the dock inside the lower forward corner of the door shroud.
- (d) Push and hold the lock release lever to disengage the downlock detent.
- (e) Push the handle inboard until it turns approximately 30 degrees.
- (f) Release the lock release lever.
- (g) Push and hold the door to engage the latch mechanism.
- (h) Push the handle inboard until you hear a click as the uplock detent engages.
- (i) Make sure the door is flush with the aft wing-to-body fairing.
- (j) Engage the o-ring on the handle at the handle dock.
- (k) Make sure that EICAS DOOR WING SLIDE L/R alert messages do not show for the escape slide compartment door. To show the messages, do this task: Showing Alert Messages, TASK 31-61-00-800-814.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-65-10-410-001

- (1) Do this task: Arm the Off-Wing Escape System, TASK 25-65-00-440-801.

———— **END OF TASK** ————

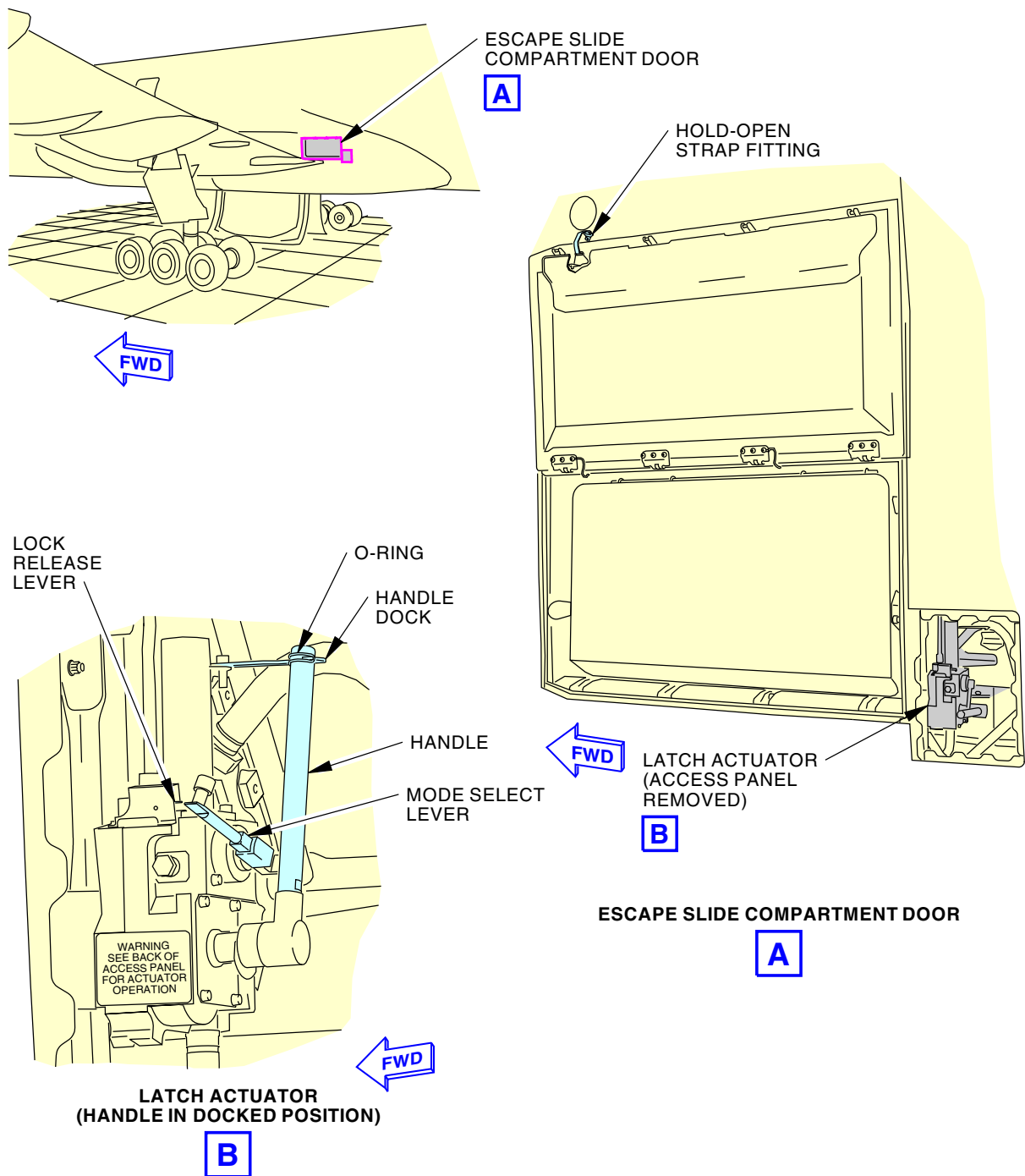
EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-10

Page 203
Sep 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Off-Wing Escape Slide Compartment Door
Figure 201/25-65-10-990-801

EFFECTIVITY
ARO ALL

25-65-10

D633W101-ARO

Page 204
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

OFF-WING ESCAPE SLIDE COMPARTMENT DOOR - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) A removal of the off-wing escape slide compartment door.
- (2) An installation of the off-wing escape slide compartment door.

TASK 25-65-10-000-801

2. Escape Slide Compartment Door Removal

(Figure 401)

A. References

Reference	Title
25-65-00-040-801	Disarm the Off-Wing Escape System (P/B 201)
25-65-10-010-801	Open the Escape Slide Compartment Door (P/B 201)

B. Location Zones

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right

C. Prepare for the Removal

SUBTASK 25-65-10-040-001

- (1) Do this task: Disarm the Off-Wing Escape System, TASK 25-65-00-040-801.

SUBTASK 25-65-10-010-001

- (2) Do this task: Open the Escape Slide Compartment Door, TASK 25-65-10-010-801.

D. Removal

SUBTASK 25-65-10-020-001

- (1) Remove the escape slide compartment door [1] as follows:
 - (a) Remove the bolts [13][22], spacer [19], clamp [16], washers [14][23], and nuts [15][21] that attach the bonding jumpers [17][18] to the wing-to-body fairing as shown, Views B-B and D-D (Figure 401).
 - (b) Remove the retainer pins [12] from the caps [10] and the hinge pins [11].
 - (c) Remove the caps [10] and hinge pins [11] that attach the door [1] to the wing-to-body fairing.
 - (d) Remove the door [1].

————— **END OF TASK** —————

TASK 25-65-10-400-802

3. Escape Slide Compartment Door Installation

(Figure 401)

A. References

Reference	Title
25-65-00-440-801	Arm the Off-Wing Escape System (P/B 201)
25-65-10-400-801	Close the Escape Slide Compartment Door (P/B 201)
SWPM 20-20-00	Standard Wiring Practices Manual

EFFECTIVITY
ARO ALL

25-65-10

D633W101-ARO

Page 401
May 05/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

C. Location Zones

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right

D. Procedure

SUBTASK 25-65-10-420-001

- (1) Install the escape slide compartment door [1] as follows:
 - (a) Put the door [1] in its correct position against the fuselage and engage the hinges.
 - (b) Install the hinge pins [11] through the hinges in the door [1] and the wing-to-body fairing.
 - (c) Install the caps [10] on the hinge pins [11].
 - (d) Tighten the caps [10] to a torque of 12 - 15 pound-inches.
 - (e) Install new retainer pins [12] through each of the hinge pins [11] and caps [10].
 - (f) Install the bolts [13][22], washers [14][23], spacer [19], clamp [16], and nuts [15][21] to attach the bonding jumpers [17][18] to the wing-to-body fairing as shown, Views B-B and D-D (Figure 401). Refer to Electrical Bonding and Grounding (SWPM 20-20-00).

SUBTASK 25-65-10-820-001

- (2) If you installed a new escape slide compartment door [1], adjust it as follows:
 - (a) Make sure the handle [2] on the latch actuator is in the down position detent.
 - (b) Push the door [1] inboard with your hand until the latch pins [5] touch the latch hooks [3] as shown, View A-A (handle down) (Figure 401).
 - (c) Make sure the clearance between the inner surface of the door [1] and the outer surface of the wing-to-body fairing is as shown, View A-A (handle down) (Figure 401) at each latch location. If necessary, adjust the door as follows:
 - 1) Remove the bolts [6], washers [7], and nuts [8] that attach the latch fitting [4] to the door [1].
 - 2) Add laminated shims [9] between the latch fitting [4] and the door [1] to get the correct clearance.

NOTE: Do not remove laminations from the shims until you measure the door clearance with the handle up.
 - 3) Temporarily install the bolts [6], washers [7], and nuts [8] to attach the latch fitting [4] to the door [1].
 - (d) Push the door [1] inboard with your hand until the latch pins [5] touch the latch hooks [3].
 - (e) Push the handle [2] for the latch actuator forward until it turns upward approximately 110 degrees (until it touches the stop).
 - (f) Make sure the clearance between the inner surface of the door [1] and the outer surface of the wing-to-body fairing is as shown, View A-A (handle up) (Figure 401) at each latch location. If necessary, adjust the door as follows:
 - 1) Remove the bolts [6], washers [7], and nuts [8] that attach the latch fitting [4] to the door [1].

EFFECTIVITY
ARO ALL

25-65-10

D633W101-ARO

Page 402
Sep 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- 2) Remove laminations from the laminated shim [9] between the latch fitting [4] and the door [1] to get the correct clearance.
- (g) Remove the bolts [6], washers [7], and nuts [8] that attach the latch fitting [4] to the door [1].
- (h) Apply the sealant, A00247 to the adjacent surfaces of the shim [9], door [1], and latch fitting [4].
- (i) Install the bolts [6], washers [7], and nuts [8] to attach the latch fitting [4] to the door [1].
- (j) Fillet seal around the edge of the latch fitting [4] and the laminated shim [9] with sealant, A00247.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-65-10-410-002

- (1) Do this task: Close the Escape Slide Compartment Door, TASK 25-65-10-400-801.

SUBTASK 25-65-10-860-003

- (2) Do this task: Arm the Off-Wing Escape System, TASK 25-65-00-440-801.

———— **END OF TASK** ————

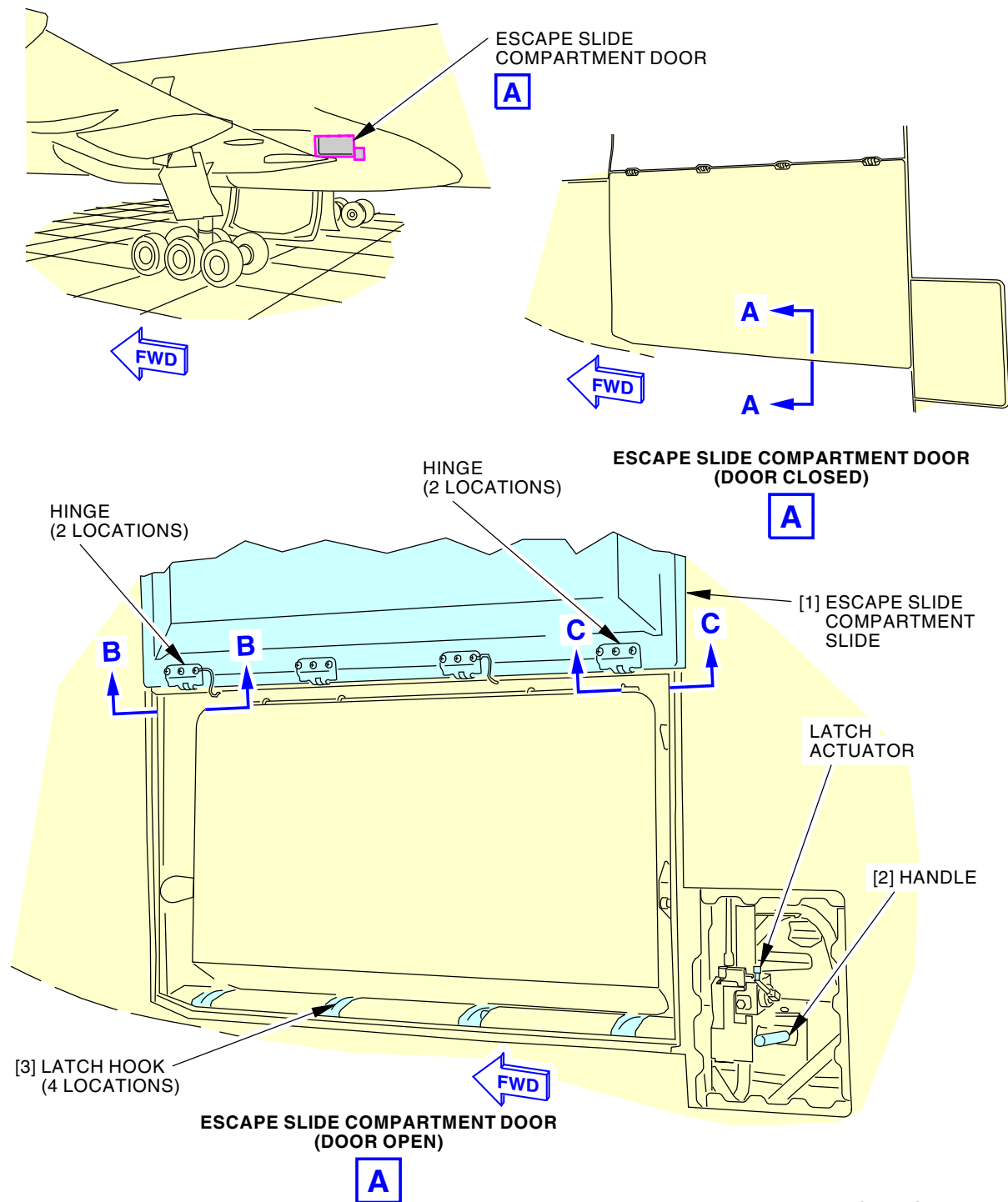
EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-10

Page 403
Jan 05/2015

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Off-Wing Escape Slide Compartment Door Installation
Figure 401/25-65-10-990-802 (Sheet 1 of 4)

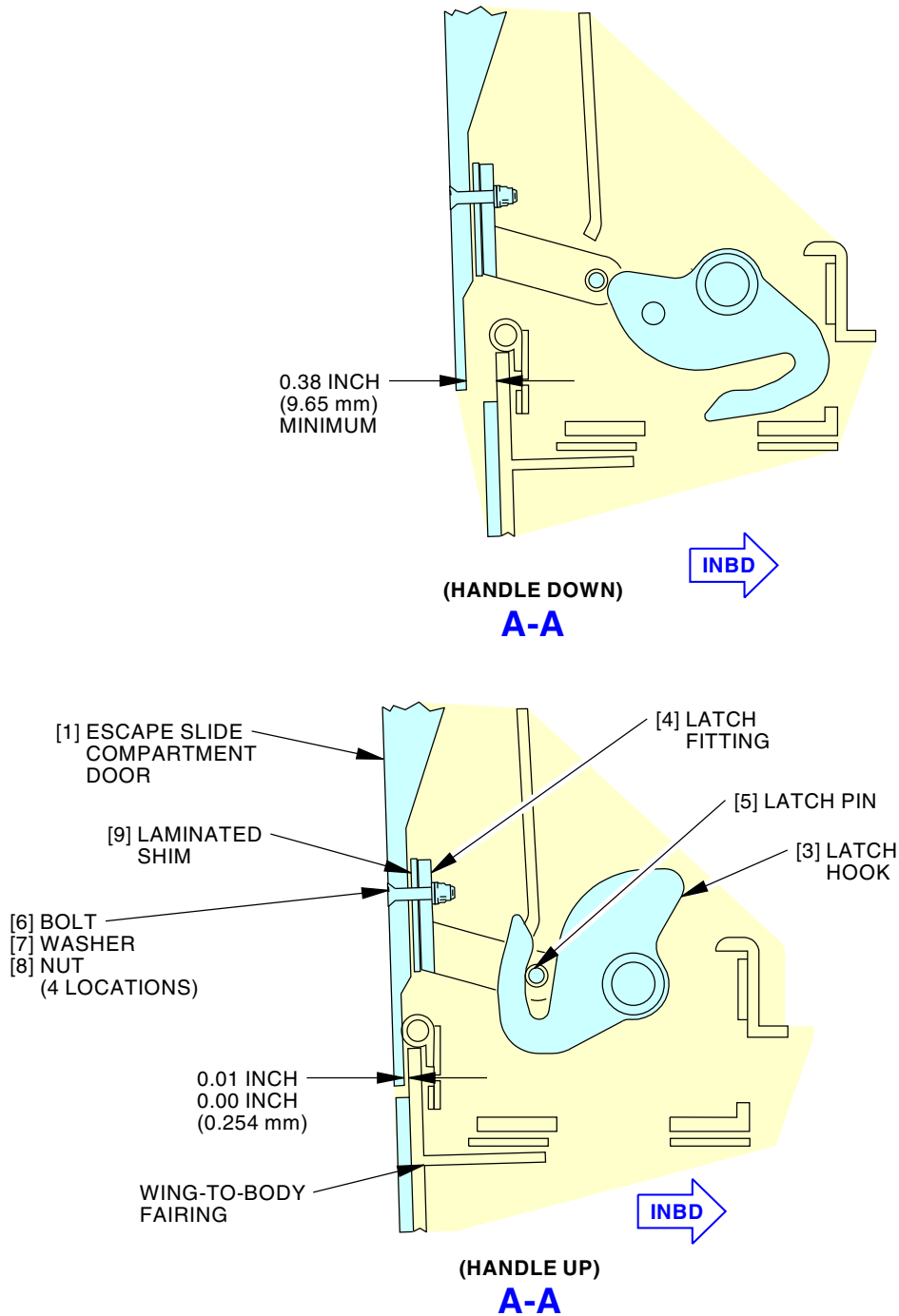
EFFECTIVITY
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25-65-10

D633W101-ARO

Page 404
May 05/2017

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777-200/300
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Off-Wing Escape Slide Compartment Door Installation
Figure 401/25-65-10-990-802 (Sheet 2 of 4)

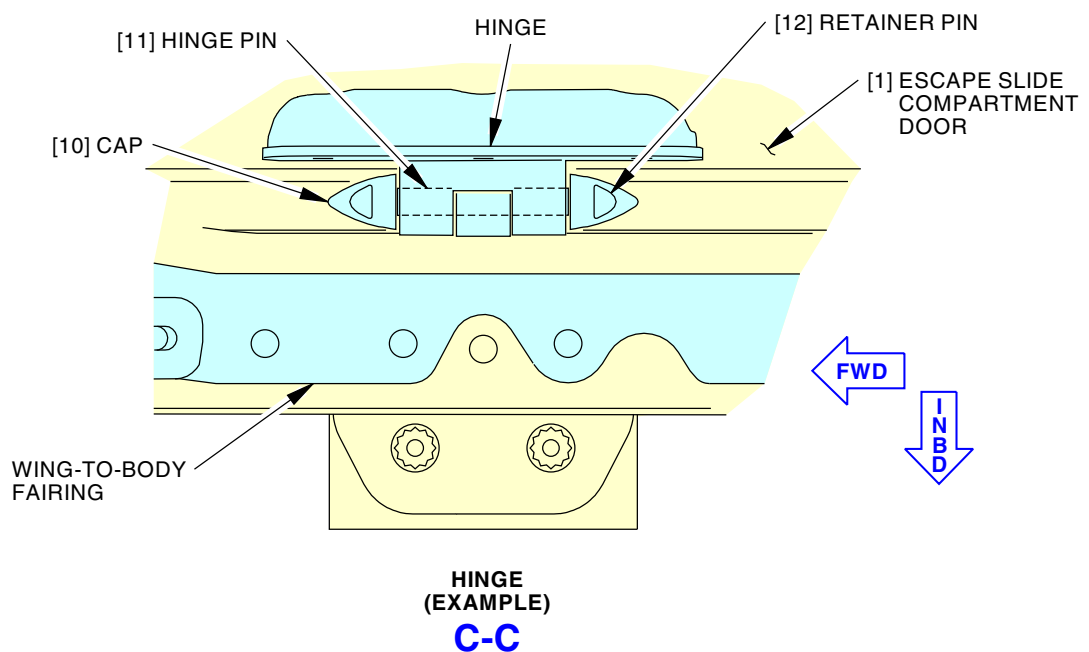
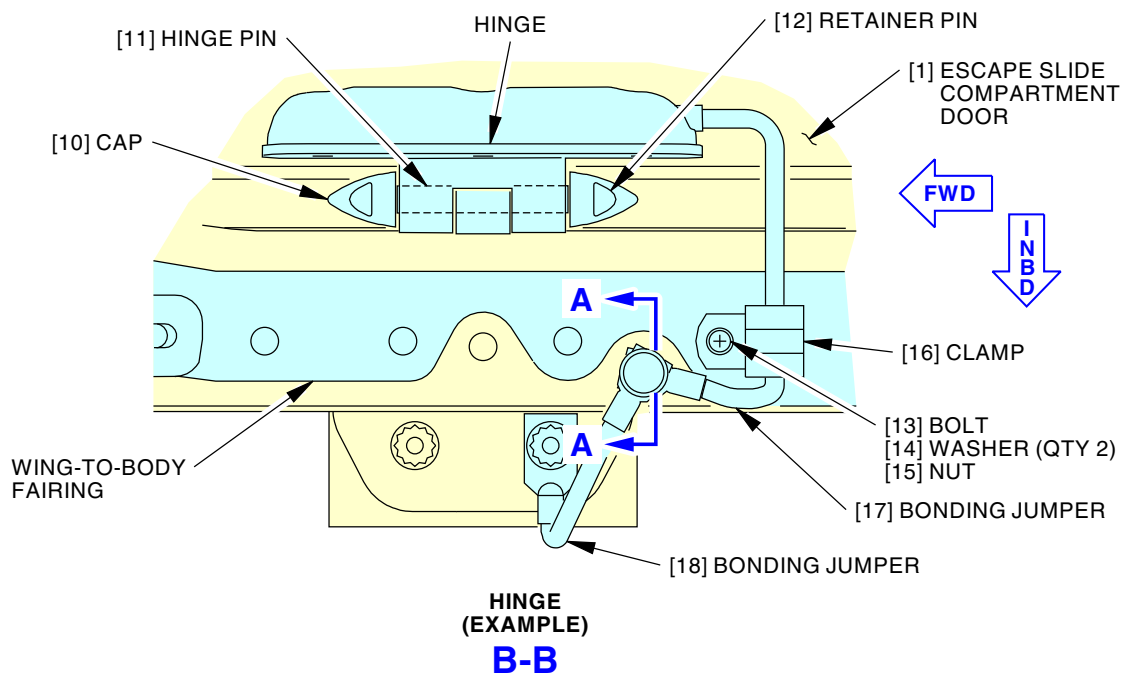
EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-10

Page 405
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Off-Wing Escape Slide Compartment Door Installation
Figure 401/25-65-10-990-802 (Sheet 3 of 4)**

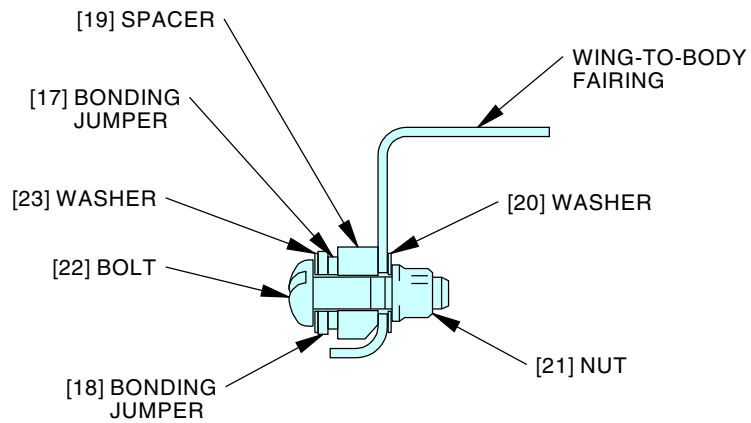
EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-10

Page 406
May 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Off-Wing Escape Slide Compartment Door Installation
Figure 401/25-65-10-990-802 (Sheet 4 of 4)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-10

Page 407
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

OFF-WING ESCAPE SLIDE COMPARTMENT DOOR LATCH ACTUATOR - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) A removal of the escape slide compartment door latch actuator.
- (2) An installation of the escape slide compartment door latch actuator.

TASK 25-65-11-000-801

2. Latch Actuator Removal

(Figure 401)

A. References

Reference	Title
25-65-00-040-801	Disarm the Off-Wing Escape System (P/B 201)
25-65-10-010-801	Open the Escape Slide Compartment Door (P/B 201)

B. Location Zones

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right

C. Prepare for the Removal

SUBTASK 25-65-11-040-001

- (1) Do this task: Disarm the Off-Wing Escape System, TASK 25-65-00-040-801.

SUBTASK 25-65-11-010-001

- (2) Do this task: Open the Escape Slide Compartment Door, TASK 25-65-10-010-801.

D. Removal

SUBTASK 25-65-11-000-001

- (1) Remove the latch actuator [4] as follows (Figure 401):
 - (a) Disconnect the electrical connector [1] from the latch actuator [4].
 - (b) Disconnect the release cable [2] from the latch actuator [4] as follows:
 - 1) Remove the lockwire from the knurled nut [11] on the end of the release cable [2].



DO NOT USE PLIERS TO LOOSEN THE KNURLED NUT [11].
DAMAGE TO EQUIPMENT CAN OCCUR.

- 2) Use your hand to loosen the knurled nut [11] on the end of the release cable [2].



DO NOT LET THE "C" SHAPED WASHER [10] ON THE END OF THE
RELEASE CABLE [2] FALL. IF THE WASHER FALLS, IT IS POSSIBLE
THAT YOU WILL NOT FIND IT.

- 3) Remove the end of the release cable [2] from the fitting on the latch actuator [4].
- (c) Disconnect the tube connectors [3], [5] from the latch actuator [4].
- (d) Install protective caps on the tube connectors [3], [5].
- (e) Remove the bolts [7], washers [8], and nuts [9] that attach the latch actuator [4] to the fuselage structure.

EFFECTIVITY
ARO ALL

25-65-11

D633W101-ARO

Page 401
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (f) Disconnect the latch actuator [4] from the end of the torque tube.
- (g) Remove the latch actuator [4].

————— END OF TASK —————

TASK 25-65-11-400-801

3. Latch Actuator Installation

(Figure 401, Figure 402)

A. References

Reference	Title
20-11-00-910-801	Standard Torque Values (P/B 201)
25-65-00-440-801	Arm the Off-Wing Escape System (P/B 201)
25-65-10-400-801	Close the Escape Slide Compartment Door (P/B 201)

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C00913	Compound - Corrosion Inhibiting Material, Nondrying Resin Mix	BMS3-27
D00633	Grease - Aircraft General Purpose	BMS3-33
G01048	Lockwire - MS20995C32, Corrosion Resistant Steel - 0.032 Inch (0.8128 mm) Diameter	NASM20995
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38

C. Location Zones

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right

D. Prepare for the Installation

SUBTASK 25-65-11-840-001

- (1) If it is necessary, turn the latch actuator [4] to the open position as follows (Figure 402):
 - (a) Hold the latch actuator [4] so it points the way you will install it in the airplane.
 - (b) Disengage the o-ring [22] from the handle [24] at the handle dock [23].
 - (c) Pull the mode select lever [25] up and outboard until it turns 90 degrees.
 - (d) Push and hold the lock release lever [21].
 - (e) Push the handle [24] inboard approximately 0.25 inch, then pull the handle outboard and down until it turns approximately 30 degrees.

NOTE: You must first push the handle [24] inboard before you can pull it outboard.
 - (f) Release the lock release lever [21].
 - (g) Pull the handle [24] outboard until you hear a click as the detent engages.

E. Installation

SUBTASK 25-65-11-400-001

- (1) Install the latch actuator [4] as follows (Figure 401):
 - (a) Install the latch actuator [4] on the end of the torque tube.

EFFECTIVITY
ARO ALL

25-65-11

D633W101-ARO

Page 402
Jan 05/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL



USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.



DO NOT GET THIS MATERIAL IN YOUR MOUTH, EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM THIS MATERIAL. PUT ON A RESPIRATOR, EYE PROTECTION (GOGGLES, OR OTHER APPROVED PROTECTION), AND GLOVES BEFORE YOU USE THIS MATERIAL. MAKE SURE THAT THERE IS SUFFICIENT AIRFLOW. KEEP THIS MATERIAL AWAY FROM SPARKS, FLAME, AND HEAT. THIS MATERIAL CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (b) Apply corrosion inhibiting Cor-Ban 27L Compound, G50237 or Mastinox 6856 K, C00913 to the threads of the bolts [7].
 - (c) Install the bolts [7], washers [8], and nuts [9] to attach the latch actuator [4] to the fuselage structure. Refer to Standard Torque Values, TASK 20-11-00-910-801.
 - (d) Make a fillet seal between the top edge of the flange of the latch actuator [4] and the fuselage structure with sealant, A00247.
- NOTE:** Do not make a fillet seal at the other edges of the latch actuator [4] flange.
- (e) Remove the protective caps from the tube connectors [3], [5].
 - (f) Connect the tube connectors [3], [5] to the latch actuator [4].
 - (g) Connect the release cable [2] to the latch actuator [4] as follows:
 - 1) Apply grease, D00633 to the threads of the knurled nut [11] and to the fitting on the latch actuator [4].



MAKE SURE YOU INSTALL THE "C" SHAPED WASHER [10]. IF YOU DO NOT OBEY THIS INSTRUCTION, THE ESCAPE SLIDE WILL NOT DEPLOY WHEN THE OVER-WING EMERGENCY EXIT DOOR (PED 3) OPENS.

- 2) Install the "C" shaped washer [10] on the end of the release cable [2].



MAKE SURE YOU INSTALL THE RELEASE CABLE [2] CORRECTLY. IF YOU DO NOT OBEY THIS INSTRUCTION, THE ESCAPE SLIDE WILL NOT DEPLOY WHEN THE OVER-WING EMERGENCY EXIT DOOR (PED 3) OPENS.

- 3) Put the end of the release cable [2] in the slot [12] in the pin [13] inside the fitting on the latch actuator [4] as shown, View C (Figure 401).



DO NOT USE PLIERS TO TIGHTEN THE KNURLED NUT [11]. DAMAGE TO EQUIPMENT CAN OCCUR.

- 4) Use your hand to tighten the knurled nut [11] on the fitting on the latch actuator [4].



777-200/300
AIRCRAFT MAINTENANCE MANUAL

5) Install the MS20995C32 lockwire, G01048 through the hole in the knurled nut [11] and the hole in the latch actuator [4].

(h) Connect the electrical connector [1] to the latch actuator [4].

F. Put the Airplane Back to Its Usual Condition

SUBTASK 25-65-11-410-001

(1) Do this task: Close the Escape Slide Compartment Door, TASK 25-65-10-400-801.

SUBTASK 25-65-11-440-001

(2) Do this task: Arm the Off-Wing Escape System, TASK 25-65-00-440-801.

———— **END OF TASK** ————

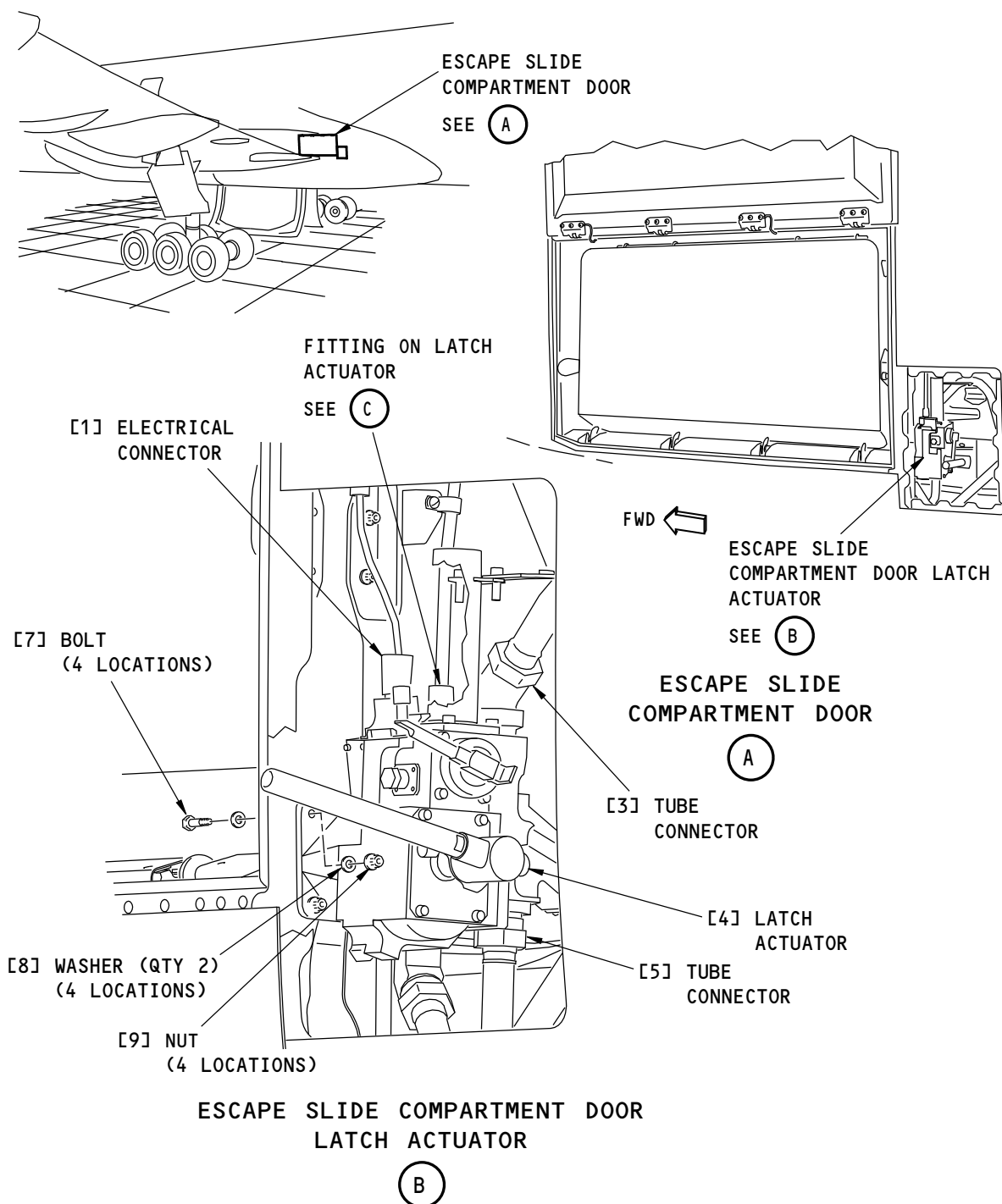
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D633W101-ARO

25-65-11

Page 404
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



G42129 S0006411541_V1

**Escape Slide Compartment Door Latch Actuator Installation
Figure 401/25-65-11-990-801 (Sheet 1 of 2)**

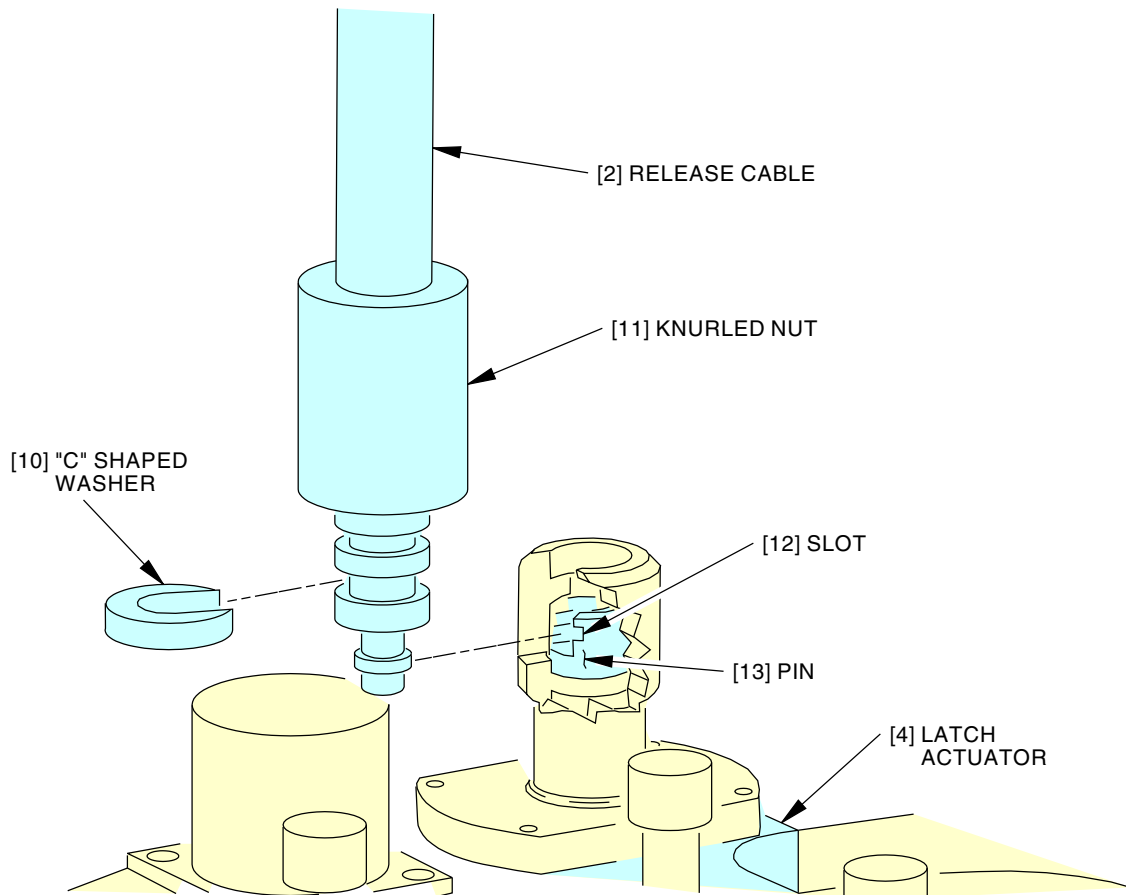
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25-65-11

D633W101-ARO

Page 405
Jan 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



FITTING ON LATCH ACTUATOR



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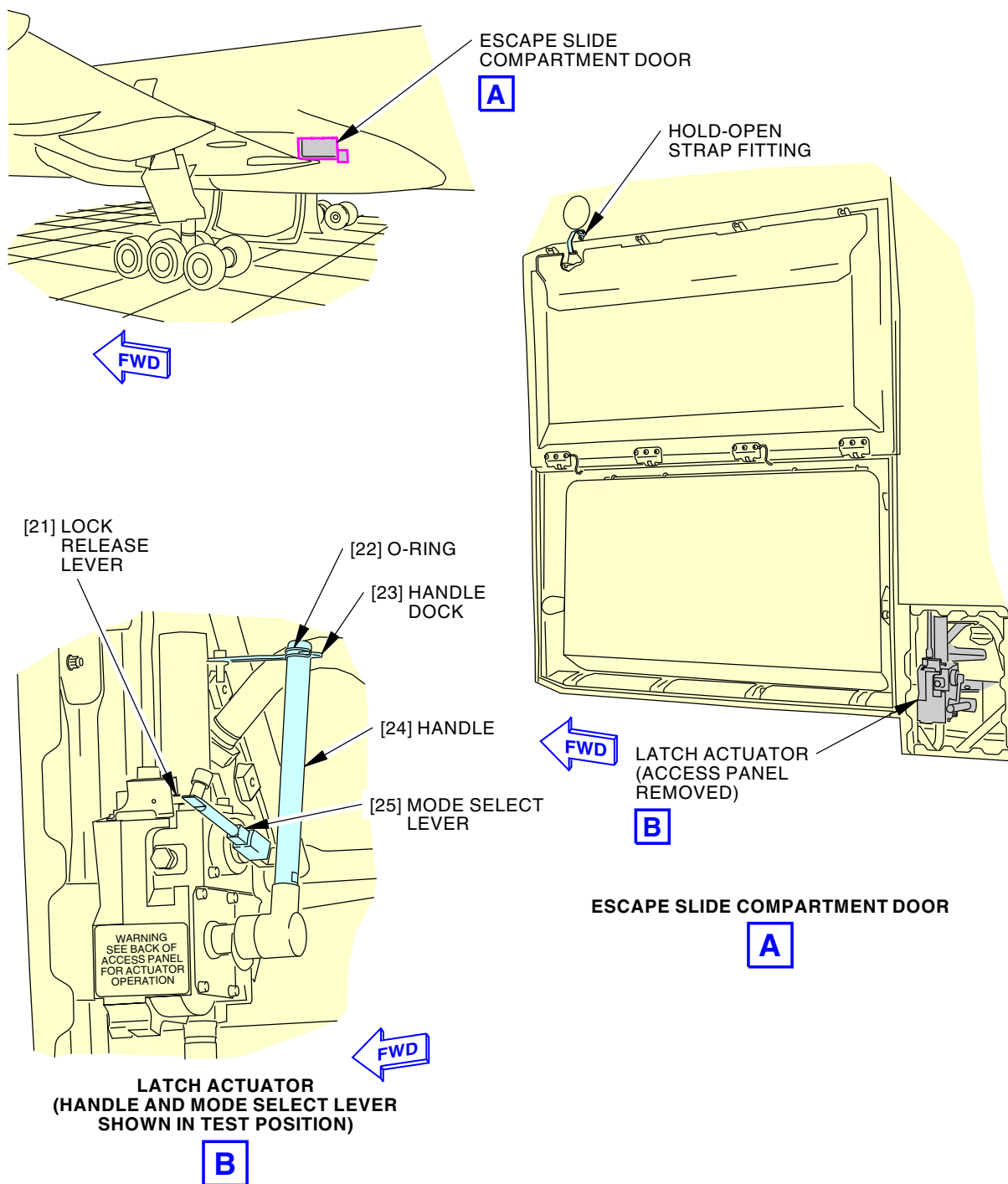
Escape Slide Compartment Door Latch Actuator Installation
Figure 401/25-65-11-990-801 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

25-65-11

D633W101-ARO

Page 406
May 05/2017



G82455 S0006411543_V2

**Escape Slide Compartment Door Latch Actuator Installation
Figure 402/25-65-11-990-802**

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-11

Page 407
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

OFF-WING ESCAPE SLIDE PACK COVER LACING RELEASE CABLE - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) A removal of the cover lacing release cable for the off-wing escape slide pack.
- (2) An installation of the cover lacing release cable for the off-wing escape slide pack.

TASK 25-65-12-000-801

2. Cover Lacing Release Cable Removal

(Figure 401)

A. References

Reference	Title
25-65-00-040-801	Disarm the Off-Wing Escape System (P/B 201)
25-65-10-010-801	Open the Escape Slide Compartment Door (P/B 201)

B. Consumable Materials

Reference	Description	Specification
G01048	Lockwire - MS20995C32, Corrosion Resistant Steel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

C. Location Zones

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right

D. Prepare for the Removal

SUBTASK 25-65-12-040-001

- (1) Do this task: Disarm the Off-Wing Escape System, TASK 25-65-00-040-801.

SUBTASK 25-65-12-010-001

- (2) Do this task: Open the Escape Slide Compartment Door, TASK 25-65-10-010-801.

E. Removal

SUBTASK 25-65-12-020-001

- (1) Remove the release cable [1] as follows:
 - (a) Remove the bolts [4], [5], washers [3], [6], and clamps [2], [7], [8], [9], [10] that attach the release cable [1] to the fuselage structure.
 - (b) Disconnect the release cable [1] from the latch actuator [11] as follows:
 - 1) Remove the MS20995C32 lockwire, G01048 that holds the knurled nut [16].



DO NOT USE PLIERS TO LOOSEN THE KNURLED NUT. DAMAGE TO EQUIPMENT CAN OCCUR.

- 2) Loosen the knurled nut [16] that attaches the release cable [1] to the fitting on the latch actuator [11].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-12

Page 401
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



DO NOT LET THE C-SHAPED WASHER [19] ON THE END OF THE RELEASE CABLE [1] FALL. IF THE WASHER FALLS, IT IS POSSIBLE THAT YOU WILL NOT FIND IT.

- 3) Remove the end of the release cable [1] from the fitting on the latch actuator [11].
 - 4) Remove the C-shaped washer [19] on the end of the release cable [1].
 - 5) Remove the knurled nut [16] from the end of the release cable [1].
- (c) Disconnect the release cable [1] from the release mechanism [14] on the escape slide pack as follows:



DO NOT USE PLIERS TO LOOSEN THE KNURLED NUT. DAMAGE TO EQUIPMENT CAN OCCUR.

- 1) Loosen the knurled nut [12] that attaches the release cable [1] to the release mechanism [14] on the escape slide pack.
- 2) Remove the end of the release cable [1] from the trigger pin slot [13] in the release mechanism [14] on the escape slide pack.



MAKE SURE THAT THE C-SHAPED WASHER IS INSTALLED ON THE END OF THE RELEASE CABLE. WITHOUT THE C-SHAPED WASHER, THE ESCAPE SLIDE WILL NOT RELEASE WHEN THE OVERWING EMERGENCY EXIT DOOR OPENS. THIS CAN CAUSE INJURIES DURING AN EMERGENCY.

- 3) Make sure that the crimped C-shaped washer [20] is installed on the end of the release cable.

NOTE: The C-shaped washer [20] is under the knurled nut [12] on the release mechanism end of the cable.

- (d) Remove the safety pin [15] from the storage pouch on the escape slide pack.
- (e) Install the safety pin [15] in the release mechanism [14] on the escape slide pack.
- (f) Remove the release cable [1].

————— **END OF TASK** —————

TASK 25-65-12-400-801

3. Cover Lacing Release Cable Installation

(Figure 401)

A. References

Reference	Title
20-11-00-910-801	Standard Torque Values (P/B 201)
25-65-00-440-801	Arm the Off-Wing Escape System (P/B 201)
25-65-10-400-801	Close the Escape Slide Compartment Door (P/B 201)

B. Consumable Materials

Reference	Description	Specification
C00913	Compound - Corrosion Inhibiting Material, Nondrying Resin Mix	BMS3-27

EFFECTIVITY
ARO ALL

25-65-12

D633W101-ARO

Page 402
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33
G01048	Lockwire - MS20995C32, Corrosion Resistant Steel - 0.032 Inch (0.8128 mm) Diameter	NASM20995
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38

C. Location Zones

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right

D. Procedure

SUBTASK 25-65-12-860-001

- (1) Install the release cable [1] as follows:
 - (a) If necessary, remove the C-shaped washer [19] on the end of the release cable [1], and remove the knurled nut [16].
 - (b) Put the release cable [1] in its correct position on the fuselage structure.



USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.



DO NOT GET THIS MATERIAL IN YOUR MOUTH, EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM THIS MATERIAL. PUT ON A RESPIRATOR, EYE PROTECTION (GOGGLES, OR OTHER APPROVED PROTECTION), AND GLOVES BEFORE YOU USE THIS MATERIAL. MAKE SURE THAT THERE IS SUFFICIENT AIRFLOW. KEEP THIS MATERIAL AWAY FROM SPARKS, FLAME, AND HEAT. THIS MATERIAL CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (c) Apply Cor-Ban 27L Compound, G50237 or Mastinox 6856 K, C00913 to the threads of the bolts [4], [5].
- (d) Loosely install the bolts [4], [5], washers [3], [6], and clamps [2], [7], [8], [9], [10] that attach the release cable [1] to the fuselage structure.
- (e) Connect the release cable [1] to the release mechanism [14] on the escape slide pack as follows:
 - 1) Apply grease, D00633 to the threads of the knurled nut [12] and the release mechanism [14] on the escape slide pack.
 - 2) Remove the safety pin [15] from the release mechanism [14] on the escape slide pack.
 - 3) Put the safety pin [15] in the storage pouch on the escape slide pack.

EFFECTIVITY
ARO ALL

25-65-12

D633W101-ARO

Page 403
Jan 05/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL



MAKE SURE THAT THE C-SHAPED WASHER IS INSTALLED ON THE END OF THE RELEASE CABLE. WITHOUT THE C-SHAPED WASHER, THE ESCAPE SLIDE WILL NOT RELEASE WHEN THE OVERWING EMERGENCY EXIT DOOR OPENS. THIS CAN CAUSE INJURIES DURING AN EMERGENCY.

- (f) Make sure that the crimped C-shaped washer [20] is installed on the end of the release cable.

NOTE: The C-shaped washer [20] is under the knurled nut [12] on the release mechanism end of the cable.



INSTALL THE RELEASE CABLE CORRECTLY. IF YOU INSTALL IT INCORRECTLY, THE ESCAPE SLIDE WILL NOT RELEASE WHEN THE OVERWING EMERGENCY EXIT DOOR OPENS. THIS CAN CAUSE INJURIES DURING AN EMERGENCY.

- (g) Put the end of the release cable [1] in the trigger pin slot [13] of the release mechanism as shown, View C (Figure 401).



DO NOT USE PLIERS TO TIGHTEN THE KNURLED NUT. DAMAGE TO EQUIPMENT CAN OCCUR.

- 1) Use your hand to tighten the knurled nut [12].
 - 2) Install the MS20995C32 lockwire, G01048 through the hole in the knurled nut [12] and the hole in the release mechanism [14] on the escape slide pack.
- (h) Tighten the bolt [4] for the clamp [2] to put the release cable [1] in the position shown, View B (Safety Pin Removed) (Figure 401).
- NOTE: Do not tighten the bolts for the clamps [7], [8], [9], [10] until later.
- 1) Refer to Standard Torque Values, TASK 20-11-00-910-801.
- (i) Connect the release cable [1] to the latch actuator [11] as follows:
- 1) Apply grease, D00633 to the threads of the knurled nut [16] and to the fitting on the latch actuator [11].
 - 2) Install the knurled nut [16] on the release cable [1].



MAKE SURE THAT THE C-SHAPED WASHER IS INSTALLED ON THE END OF THE RELEASE CABLE. WITHOUT THE C-SHAPED WASHER, THE ESCAPE SLIDE WILL NOT RELEASE WHEN THE OVERWING EMERGENCY EXIT DOOR OPENS. THIS CAN CAUSE INJURIES DURING AN EMERGENCY.

- 3) Install the C-shaped washer [19] on the end of the release cable [1].



INSTALL THE RELEASE CABLE CORRECTLY. IF YOU INSTALL IT INCORRECTLY, THE ESCAPE SLIDE WILL NOT RELEASE WHEN THE OVERWING EMERGENCY EXIT DOOR OPENS. THIS CAN CAUSE INJURIES DURING AN EMERGENCY.

- (j) Put the end of the release cable [1] in the slot [17] in the pin [18] inside the fitting on the latch actuator as shown, View D (Figure 401).



**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



CAUTION

DO NOT USE PLIERS TO TIGHTEN THE KNURLED NUT. DAMAGE TO EQUIPMENT CAN OCCUR.

- 1) Use your hand to tighten the knurled nut [16].
- 2) Install the MS20995C32 lockwire, G01048 through the hole in the knurled nut [16] and the hole in the fitting on the latch actuator [11].
- (k) Tighten the bolts [4], [5] for the clamps [7], [8], [9], [10] to position the release cable [1] as shown, View A (Figure 401).
 - 1) Refer to Standard Torque Values, TASK 20-11-00-910-801.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-65-12-410-001

- (1) Do this task: Close the Escape Slide Compartment Door, TASK 25-65-10-400-801.

SUBTASK 25-65-12-440-001

- (2) Do this task: Arm the Off-Wing Escape System, TASK 25-65-00-440-801.

———— **END OF TASK** ————

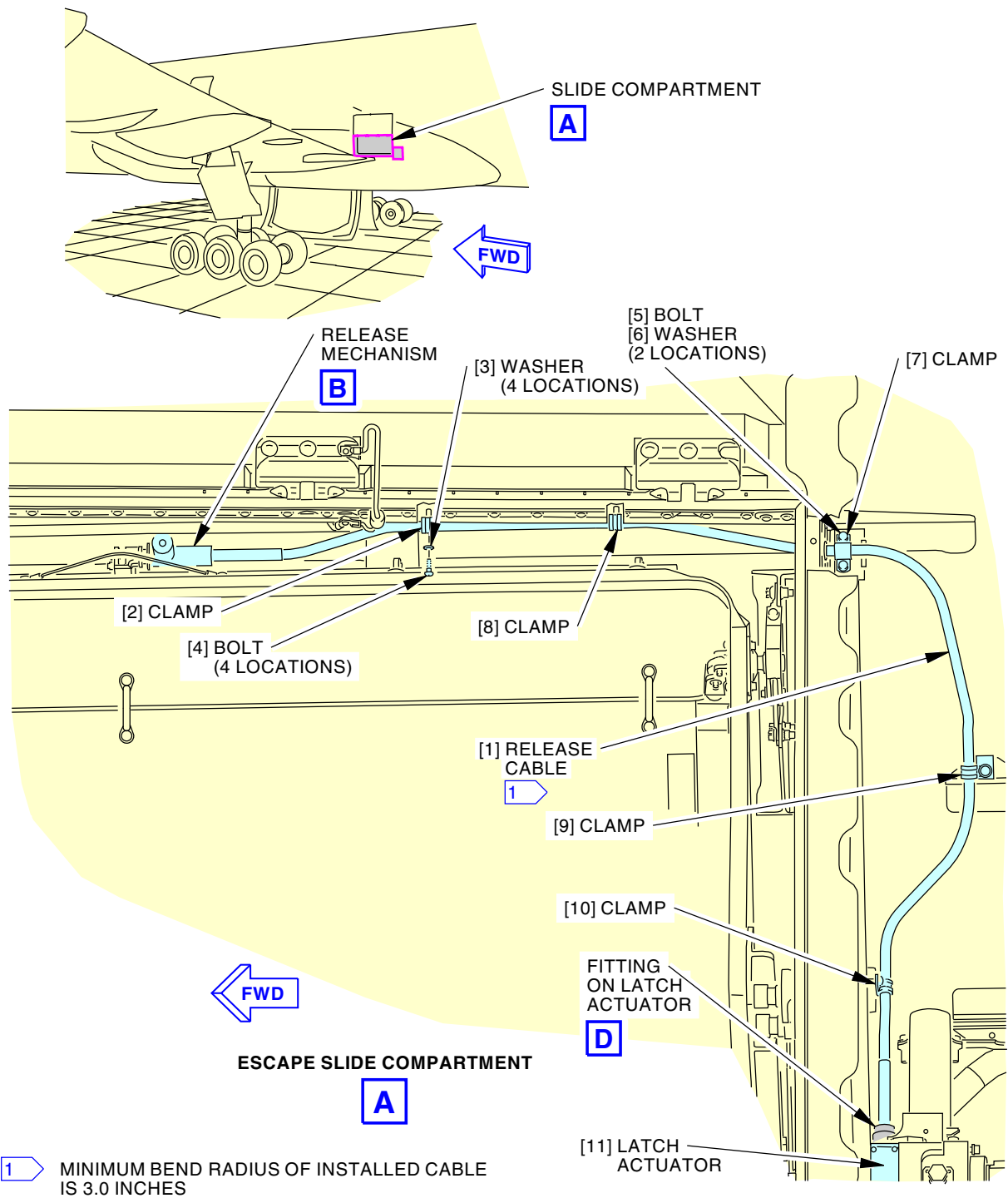
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D633W101-ARO

25-65-12

Page 405
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Cover Lacing Release Cable Installation
Figure 401/25-65-12-990-801 (Sheet 1 of 4)**

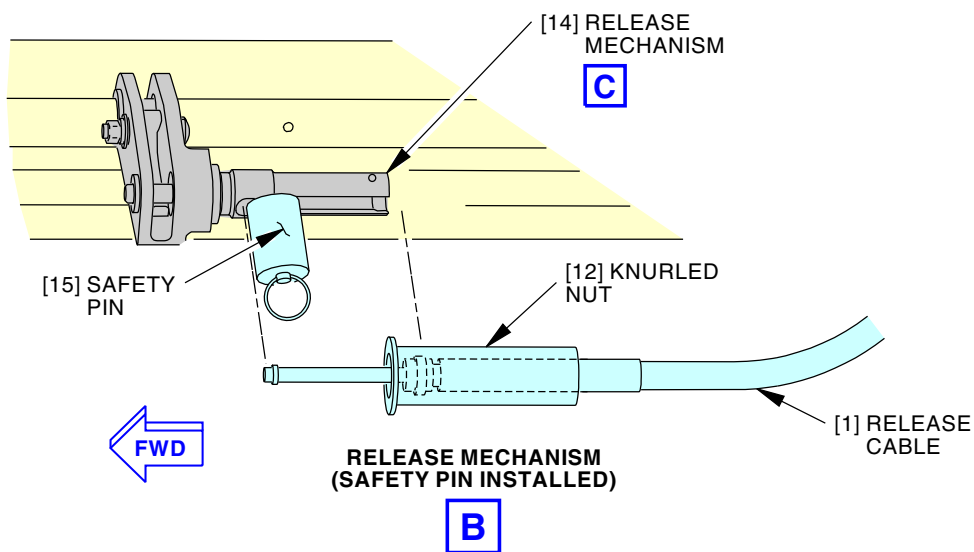
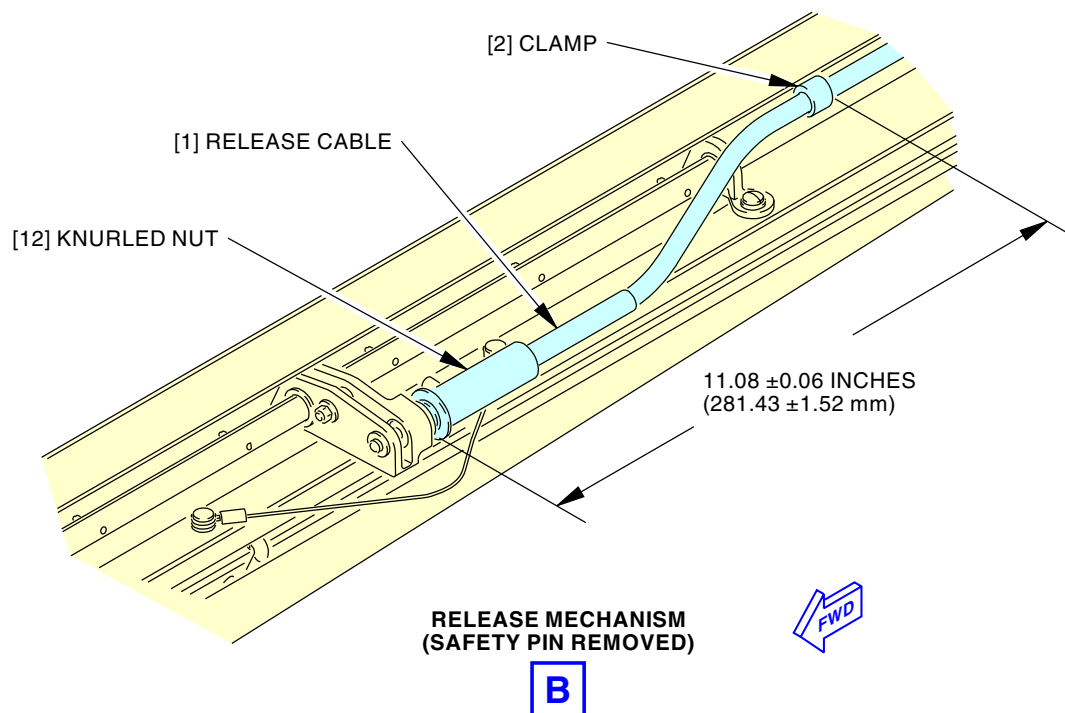
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D633W101-ARO

25-65-12

Page 406
Sep 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



G44880 S0006411549_V3

Cover Lacing Release Cable Installation
Figure 401/25-65-12-990-801 (Sheet 2 of 4)

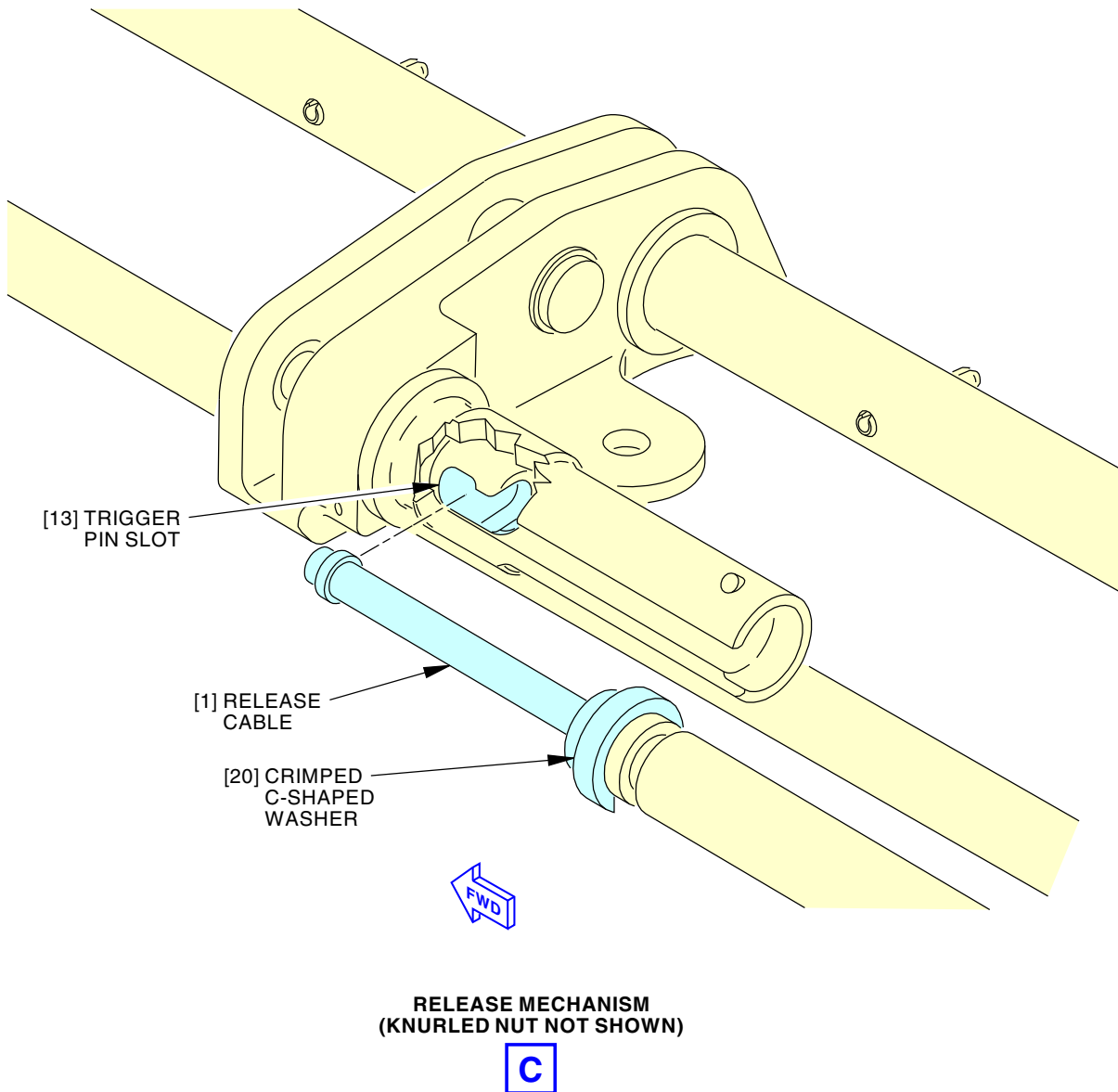
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D633W101-ARO

25-65-12

Page 407
Sep 05/2017

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777-200/300
AIRCRAFT MAINTENANCE MANUAL



H01784 S0006411550_V3

Cover Lacing Release Cable Installation
Figure 401/25-65-12-990-801 (Sheet 3 of 4)

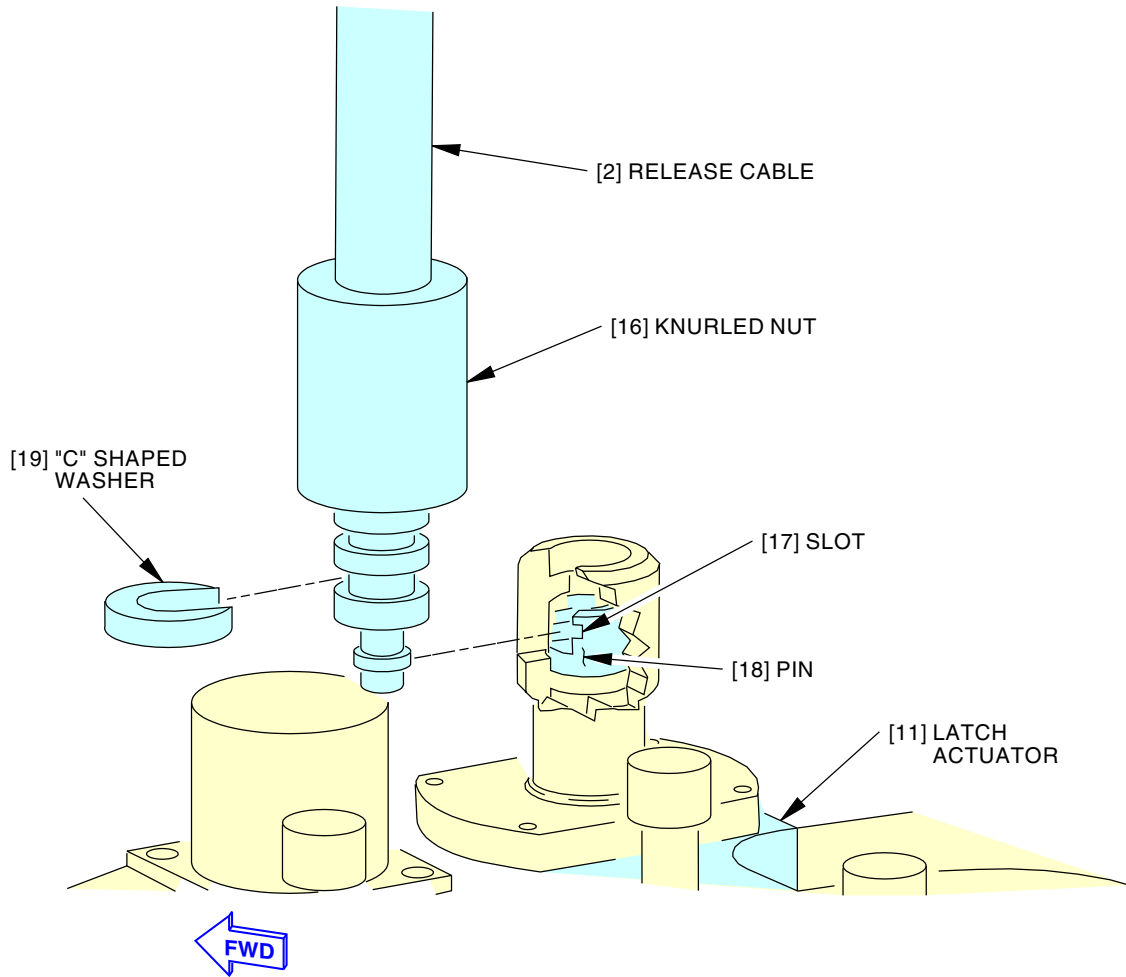
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ARO ALL

25-65-12

D633W101-ARO

Page 408
Sep 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



FITTING ON LATCH ACTUATOR

C

G82005 S0006411551_V2

Cover Lacing Release Cable Installation
Figure 401/25-65-12-990-801 (Sheet 4 of 4)

EFFECTIVITY
ARO ALL

D633W101-ARO

25-65-12

Page 409
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

OFF-WING ESCAPE SLIDE COMPARTMENT DOOR LATCH TORQUE TUBE - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) A removal of the latch torque tube for the slide compartment door.
- (2) An installation of the latch torque tube for the slide compartment door.

TASK 25-65-13-000-801

2. Latch Torque Tube Removal

(Figure 401)

A. References

Reference	Title
25-65-00-040-801	Disarm the Off-Wing Escape System (P/B 201)
25-65-10-010-801	Open the Escape Slide Compartment Door (P/B 201)

B. Location Zones

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right

C. Prepare for the Removal

SUBTASK 25-65-13-040-001

- (1) Do this task: Disarm the Off-Wing Escape System, TASK 25-65-00-040-801.

SUBTASK 25-65-13-010-001

- (2) Do this task: Open the Escape Slide Compartment Door, TASK 25-65-10-010-801.

SUBTASK 25-65-13-020-001

- (3) Remove the screws [1] that attach the threshold panels [2] to the fuselage structure to get access to the latch torque tube [5].

D. Removal

SUBTASK 25-65-13-000-001

- (1) Remove the latch torque tube [5] as follows:
 - (a) Remove the bolts [3] and the washers [4] that attach the bearing straps [10] to the latch support fittings [6].
 - (b) Remove the split bushings [9] from the torque tube [5].
NOTE: Only remove the upper split bushings. The lower split bushings can stay in the latch support fittings.
 - (c) Remove the torque tube [5] from the latch actuator [11] and the latch support fittings [6].
 - (d) Remove the torque tube spring [8] and spring bushing [7] from the forward end of the torque tube [5].

————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

25-65-13

D633W101-ARO

Page 401
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-65-13-400-801

3. Latch Torque Tube Installation

(Figure 401)

A. References

Reference	Title
25-65-00-440-801	Arm the Off-Wing Escape System (P/B 201)
25-65-10-400-801	Close the Escape Slide Compartment Door (P/B 201)

B. Location Zones

Zone	Area
197	Aft Wing-to-Body Fairings, Left
198	Aft Wing-to-Body Fairings, Right

C. Installation

SUBTASK 25-65-13-400-001

(1) Install the latch torque tube [5] as follows:

- (a) Install the torque tube spring [8] and spring bushing [7] on the forward end of the torque tube [5].

NOTE: Make sure the hook end of the spring is inserted into the hole in the latch hook and the extension end of the spring is inserted in the hole in the latch support fitting.

- (b) Make sure the lower split bushings [9] are installed in the latch support fittings [6].
- (c) Move the spline on the end of the torque tube into the latch actuator [11], and put the torque tube [5] in its correct position in the latch support fittings [6].
- (d) Install the bearing straps [10] and the upper split bushings [9] onto the torque tube [8].
- (e) Install the bolts [3] and washers [4] through the bearing straps [10] into the latch support fittings [6].
- (f) Tighten the bolts [3] as follows:
- 1) Apply a torque of 20-25 pound-inches to the bolts [3].
 - 2) Make sure you can turn the torque tube [5] with your hand. If the torque tube [5] does not turn freely do these steps:
 - a) Loosen the bolts [3].
 - b) Apply a torque of 20-25 pound-inches to the bolts [3].

D. Put the Airplane Back to Its Usual Condition

SUBTASK 25-65-13-410-001

(1) Install the screws [1] to attach the threshold panels [2] to the airplane structure.

SUBTASK 25-65-13-410-002

(2) Do this task: Close the Escape Slide Compartment Door, TASK 25-65-10-400-801.

SUBTASK 25-65-13-440-001

(3) Do this task: Arm the Off-Wing Escape System, TASK 25-65-00-440-801.

——— **END OF TASK** ———

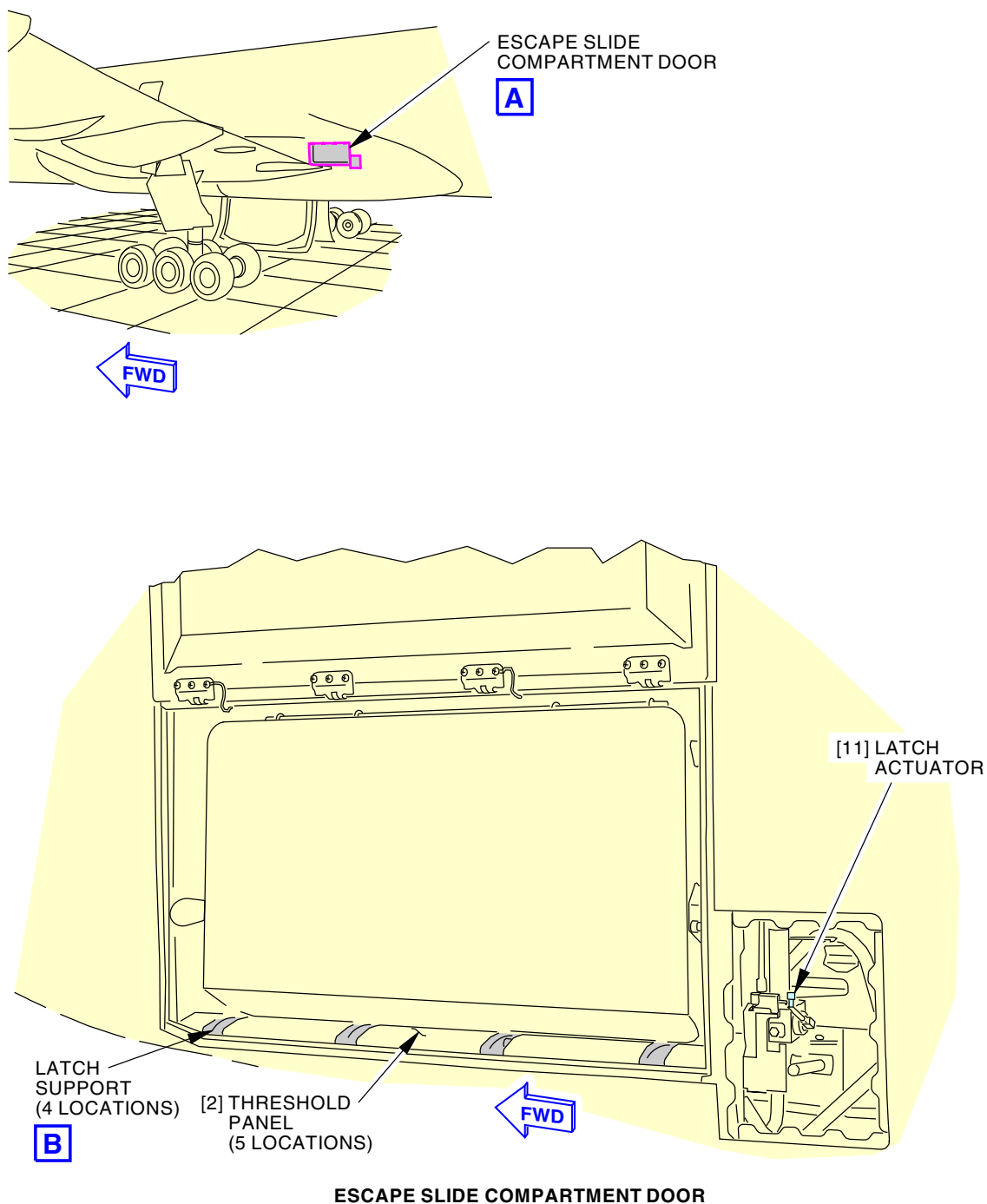
EFFECTIVITY
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25-65-13

D633W101-ARO

Page 402
Jan 05/2015

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Latch Torque Tube Installation
Figure 401/25-65-13-990-801 (Sheet 1 of 2)**

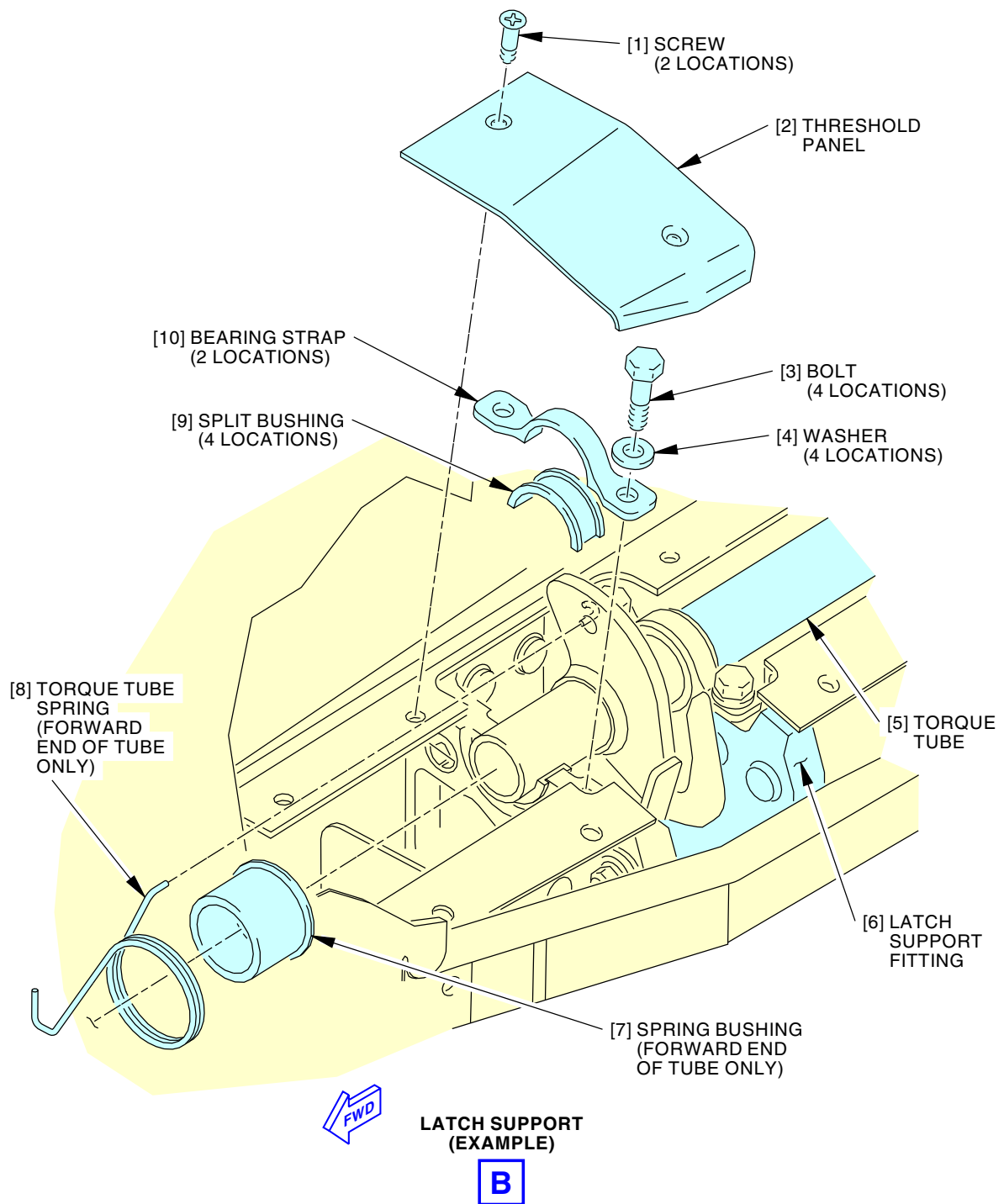
EFFECTIVITY
ARO ALL

25-65-13

D633W101-ARO

Page 403
May 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Latch Torque Tube Installation
Figure 401/25-65-13-990-801 (Sheet 2 of 2)**

EFFECTIVITY
ARO ALL

25-65-13

D633W101-ARO

Page 404
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

DOOR-MOUNTED ESCAPE SYSTEM - MAINTENANCE PRACTICES

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) A restoration of the door-mounted escape system after an escape slide deployment.
 - (2) Door-mounted escape system - deactivation.
 - (3) Door-mounted escape system - activation.

TASK 25-66-00-840-801

2. Door-Mounted Escape System Restoration

(Figure 201)

NOTE: This procedure is a scheduled maintenance task.

A. **General**

- (1) This task is not applicable to the overwing emergency exit door.

B. **References**

Reference	Title
25-66-01-400-801	Door-Mounted Escape Slide Pack Installation (P/B 401)
25-66-06-000-801	Bustle Removal (P/B 401)
52-12-22-000-801	Emergency Power Assist System (EPAS) Reservoir Removal (P/B 401)
52-12-22-400-801	Emergency Power Assist System (EPAS) Reservoir Installation (P/B 401)

C. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
COM-1639	Clamp - Slide Deflation (Vinyl Covered Jaws) Part #: 83-262 Supplier: 78525
STD-1145	Rope - 50 Foot

D. **Procedure**

SUBTASK 25-66-00-840-001

- (1) Restore the escape slide as follows:
 - (a) Put the passenger entry door warning strap across the door opening.
 - (b) Attach the rope (50 ft.), STD-1145 to the top part of the escape slide as follows:
 - 1) Put the rope (50 ft.), STD-1145 through the full width of the girt between the top and bottom halves of the girt assembly.

NOTE: The hem reinforcements along each side of the girt assembly do not tear from the tension of the rope.

EFFECTIVITY
ARO ALL

25-66-00

D633W101-ARO

Page 201
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- a) If necessary, release some of the air from the escape slide so as to put the rope around the girt assembly.

NOTE: Too much tension in the girt material can prevent routing of the rope around the girt assembly.

- 2) Attach the end of the rope (50 ft.), STD-1145 with the part of the rope in tension as shown in View B of the Figure 201 (Sheet 3).

NOTE: The rope will be in the shape of a triangle.

- (c) Put two persons in position to hold the rope (50 ft.), STD-1145 and two persons to hold the lower end of the slide.
- (d) Pull the girt release handle.

NOTE: The girt release handle is located below the flap on the girt. If you pull the girt release handle, the escape slide will fully detach from the airplane. Keep the girt release handle with the slide.



BE CAREFUL WHEN YOU LOWER THE ESCAPE SLIDE. BECAUSE THE ESCAPE SLIDE WEIGHS APPROXIMATELY 225 POUNDS, INJURIES TO PERSONS CAN OCCUR. DO NOT PERMIT THE ESCAPE SLIDE TO MOVE ON THE GROUND. THERE ARE COMPONENTS UNDER THE ESCAPE SLIDE THAT CAN BE DAMAGED IF IT FALLS OR SCRAPES ON THE GROUND.

- (e) Carefully lower the escape slide to the ground with the rope (50 ft.), STD-1145.
- (f) Disconnect the wires from the battery pack to the escape slide lights.

NOTE: The battery pack is located on the bottom surface of the escape slide near the inflation reservoir.

- (g) Disengage the girt bar from the floor fittings.

NOTE: Keep the girt bar with the slide.

- (h) Carefully install the slide deflation clamp, COM-1639 on the aspirators to deflate the escape slide.

NOTE: It takes approximately 10 minutes for the escape slide to deflate.

- (i) Remove the wire pieces from the frangible links on the escape slide.

NOTE: The wire pieces can cause damage to the slide when it is folded.

- (j) Fold the slide three times lengthwise and roll up loosely.

- (k) Remove the slide deflation clamp, COM-1639 from the aspirators.

- (l) Refer to the instructions from the escape slide manufacturer to examine, repair, and repack the escape slide.

SUBTASK 25-66-00-840-002

- (2) Restore the passenger entry door as follows:

- (a) Remove the warning strap from across the door opening if it is installed.
- (b) Close the door as follows:

NOTE: If you used the emergency power assist system (EPAS) to open the door, it takes approximately 5 minutes for the EPAS reservoir to empty from the time the escape system deployed.

- 1) Move the door near to the cutout.

EFFECTIVITY
ARO ALL

25-66-00

D633W101-ARO

Page 202
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- 2) Push the door down with the interior handle and engage the latch rollers with the latch tracks.

NOTE: When the weight of the escape slide pack is not on the door, the counterbalance spring lifts the door above its normal height and it can be difficult to engage the latch rollers with the latch tracks.

- 3) Turn the interior handle to the closed position.
- (c) Move the mode select handle to the MANUAL/DISARM position.
- (d) Do this task: Bustle Removal, TASK 25-66-06-000-801.
- (e) Turn the packboard latch handle forward.
- (f) Turn the packboard inboard and lift the packboard from the door.

NOTE: Keep the packboard with the slide.

- (g) If you used the emergency power assist system (EPAS) to open the door, do these steps to replace the EPAS reservoir:
 - 1) Do this task: Emergency Power Assist System (EPAS) Reservoir Removal, TASK 52-12-22-000-801.
 - 2) Do this task: Emergency Power Assist System (EPAS) Reservoir Installation, TASK 52-12-22-400-801.
- (h) Do this task: Door-Mounted Escape Slide Pack Installation, TASK 25-66-01-400-801.

———— **END OF TASK** ————

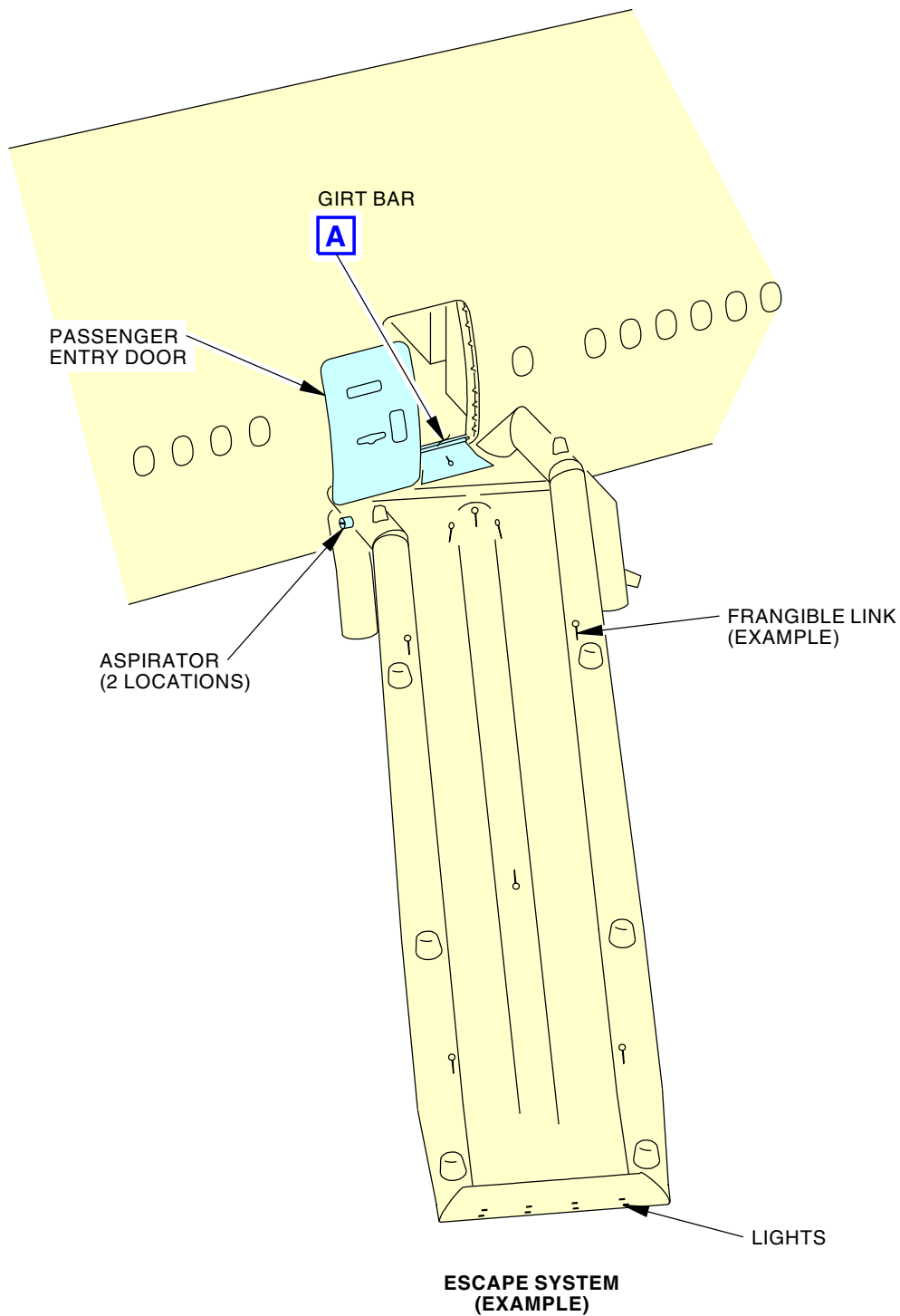
EFFECTIVITY
ARO ALL

25-66-00

D633W101-ARO

Page 203
May 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



E09806 S0006411562_V2

Escape System Restoration
Figure 201/25-66-00-990-801 (Sheet 1 of 3)

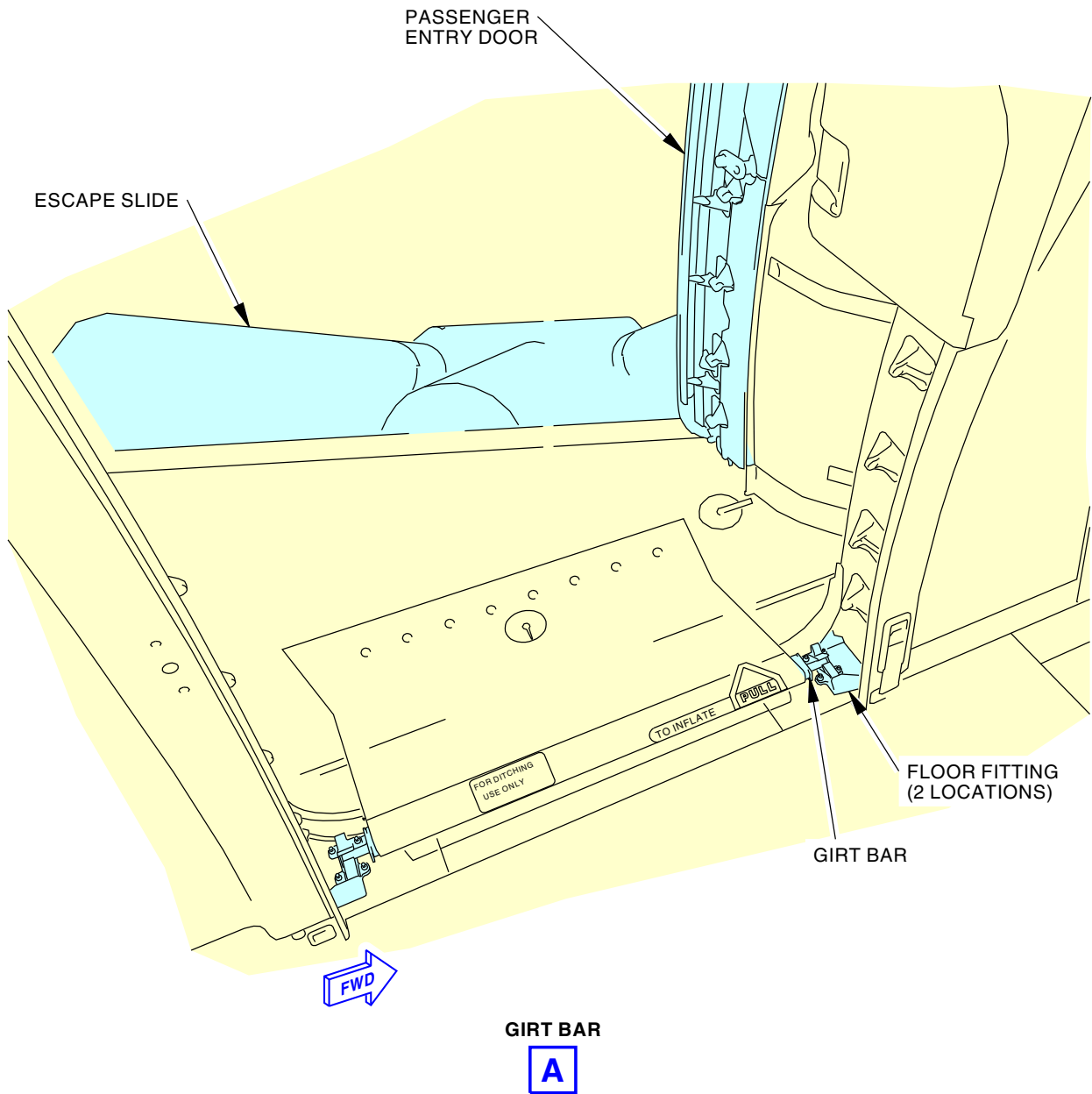
EFFECTIVITY
ARO ALL

D633W101-ARO

25-66-00

Page 204
May 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



E09800 S0006411563_V2

Escape System Restoration
Figure 201/25-66-00-990-801 (Sheet 2 of 3)

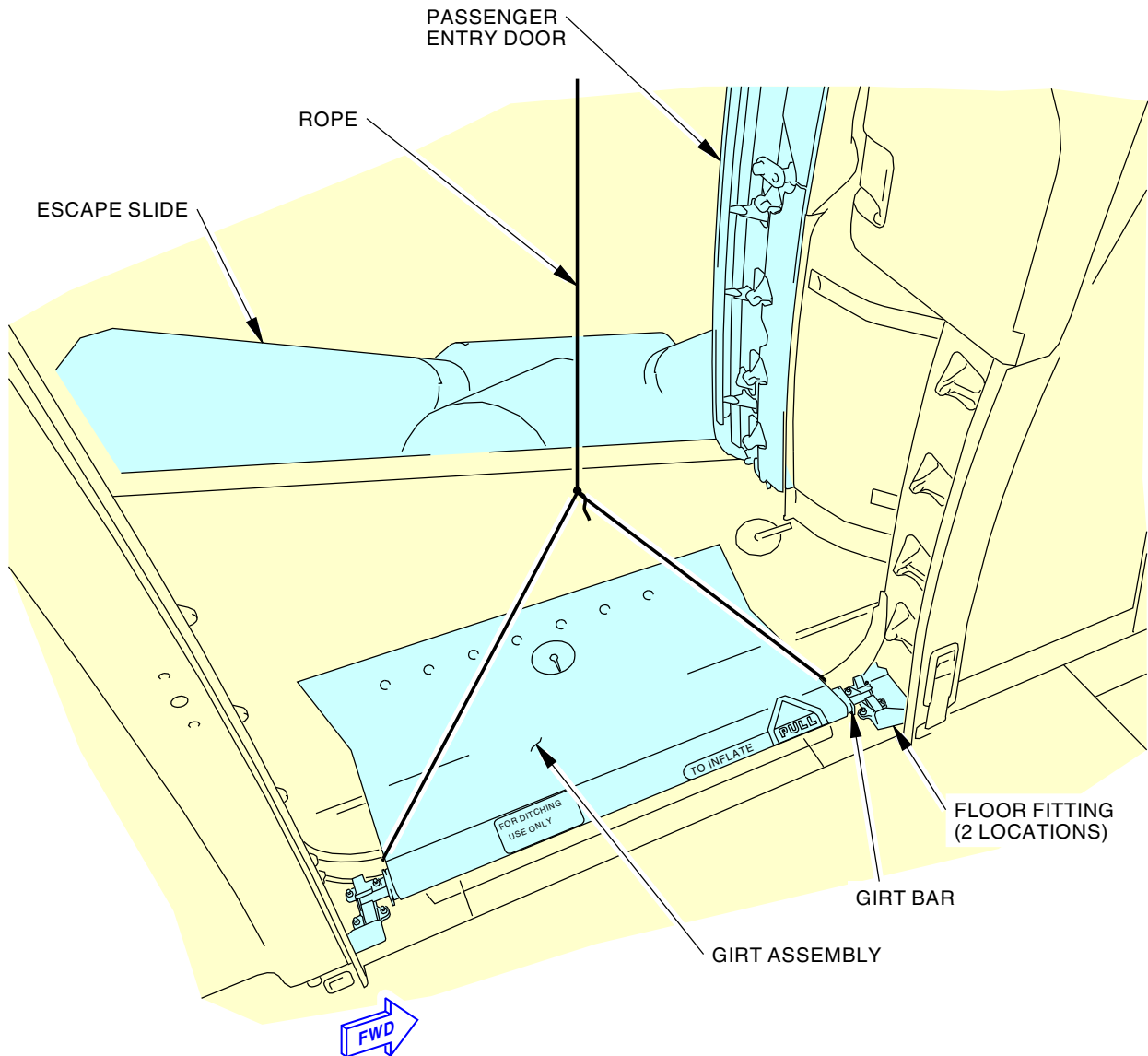
EFFECTIVITY
ARO ALL

25-66-00

D633W101-ARO

Page 205
May 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



**GIRT ASSEMBLY
(SHOWN WITH STANDARD ROPE FOR LIFTING GIRT ASSEMBLY)**

B

1627508 S0000299625_V2

**Escape System Restoration
Figure 201/25-66-00-990-801 (Sheet 3 of 3)**

EFFECTIVITY
ARO ALL

25-66-00

D633W101-ARO

Page 206
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-66-00-040-801

3. Door-Mounted Escape System - Deactivation

A. General

- (1) This task will deactivate the door-mounted escape system.

B. Tools/Equipment

Reference	Description
STD-858	Tag - DO NOT OPERATE

C. Location Zones

Zone	Area
831	Left No. 1 Passenger Entry Door - Section 41
832	Left No. 2 Passenger Entry Door - Section 43
834	Left No. 4 Passenger Entry Door - Section 46
835	Left No. 5 Passenger Entry Door - Section 47
841	Right No. 1 Passenger Entry Door - Section 41
842	Right No. 2 Passenger Entry Door - Section 43
844	Right No. 4 Passenger Entry Door - Section 46
845	Right No. 5 Passenger Entry Door - Section 47

D. Procedure

SUBTASK 25-66-00-210-001



WARNING

KEEP PERSONNEL, EQUIPMENT, AND OTHER ITEMS OUT OF THE HAZARDOUS ENERGY ZONES. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (1) Make sure that there is no blockage in the area outside of the door from the fuselage to 33 feet outboard of the fuselage and from six feet forward and six feet aft of the door all the way to the ground.

SUBTASK 25-66-00-020-001

- (2) Move the door mode select lever to the MANUAL/DISARMED position.

SUBTASK 25-66-00-420-001

- (3) Install a DO NOT OPERATE tag, STD-858 on the door mode select lever.

SUBTASK 25-66-00-420-002

- (4) Install the safety pins into the pressure reservoir valve and the escape slide release mechanism.

NOTE: Safety pins are located in the pouch on the inboard face of the escape slide.

SUBTASK 25-66-00-420-003

- (5) Install DO NOT OPERATE tags, STD-858 on the escape slide safety pins.

SUBTASK 25-66-00-020-002

- (6) Turn the EPAS battery safety switch to the DISARM position.

E. Door-Mounted Escape System - Tryout

NOTE: This tryout is to make sure that the door-mounted escape system is in a zero energy state.

EFFECTIVITY
ARO ALL

25-66-00

D633W101-ARO

Page 207
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-66-00-210-002



MAKE SURE THAT THE EPAS SAFETY SWITCH IS IN THE SAFE POSITION. IF THE SWITCH IS NOT IN THE SAFE POSITION AND YOU MOVE THE DOOR HANDLE TO OPEN, THE RESERVOIR SQUIB CAN FIRE. RESERVOIR PRESSURE WILL OPEN THE DOOR AND RELEASE THE ESCAPE SLIDE. THIS CAN CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

- (1) Make sure that the EPAS battery safety switch is in the DISARM position.

SUBTASK 25-66-00-210-003

- (2) Make sure that the door mode select lever is in the DISARMED/MANUAL position.

SUBTASK 25-66-00-210-004

- (3) Make sure that the DO NOT OPERATE tag, STD-858 is installed on the door mode select lever.

SUBTASK 25-66-00-210-005

- (4) Make sure that the safety pins are installed in the pressure reservoir valve and escape slide mechanism.

SUBTASK 25-66-00-210-006

- (5) Make sure that DO NOT OPERATE tags, STD-858 are installed on the safety pins.

————— **END OF TASK** —————

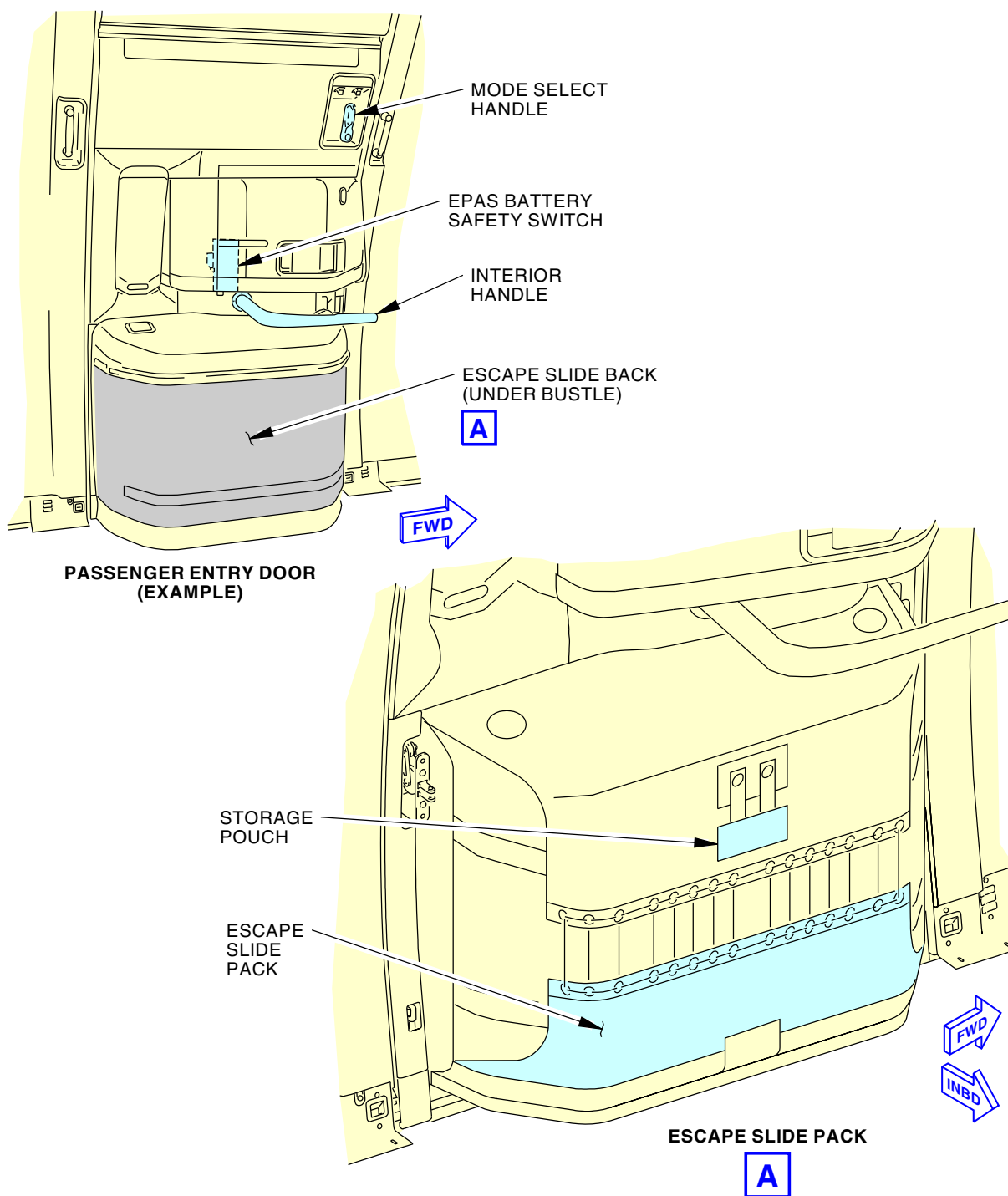
EFFECTIVITY
ARO ALL

25-66-00

D633W101-ARO

Page 208
Sep 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



2404739 S0000556035_V2

Door-Mounted Escape System
Figure 202/25-66-00-990-803

EFFECTIVITY
ARO ALL

25-66-00

D633W101-ARO

Page 209
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

TASK 25-66-00-840-803

4. Door-Mounted Escape System - Activation

(Figure 202)

A. General

- (1) This task will activate the door-mounted escape system.

B. Tools/Equipment

Reference	Description
STD-858	Tag - DO NOT OPERATE

C. Location Zones

Zone	Area
831	Left No. 1 Passenger Entry Door - Section 41
832	Left No. 2 Passenger Entry Door - Section 43
834	Left No. 4 Passenger Entry Door - Section 46
835	Left No. 5 Passenger Entry Door - Section 47
841	Right No. 1 Passenger Entry Door - Section 41
842	Right No. 2 Passenger Entry Door - Section 43
844	Right No. 4 Passenger Entry Door - Section 46
845	Right No. 5 Passenger Entry Door - Section 47

D. Procedure

SUBTASK 25-66-00-420-004



KEEP PERSONNEL, EQUIPMENT, AND OTHER ITEMS OUT OF THE HAZARDOUS ENERGY ZONES. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (1) Turn the EPAS battery safety switch to the ARM position.

SUBTASK 25-66-00-020-003

- (2) Remove the DO NOT OPERATE tags, STD-858 from the escape slide safety pins.

SUBTASK 25-66-00-020-004

- (3) Remove the safety pins from the pressure reservoir valve and the escape slide release mechanism.

NOTE: Place the safety pins back into the pouch located on the inboard face of the escape slide.

SUBTASK 25-66-00-020-005

- (4) Remove the DO NOT OPERATE tag, STD-858 from the door mode select lever.

——— **END OF TASK** ———

EFFECTIVITY
ARO ALL

25-66-00

D633W101-ARO

Page 210
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

DOOR-MOUNTED ESCAPE SYSTEM - ADJUSTMENT/TEST

1. **General**

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has one task:
 - (1) An operational test of the door-mounted escape system.

TASK 25-66-00-840-802

2. **Door-Mounted Escape System Operational Test**

(Figure 501)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This task is not applicable to the over-wing exit door.

B. References

Reference	Title
25-66-00-840-801	Door-Mounted Escape System Restoration (P/B 201)

C. Tools/Equipment

Reference	Description
STD-1146	Pad - Protective, Ensolite or Equivalent 1/2 Inch by 72 Inches by 96 Inches

D. Procedure

SUBTASK 25-66-00-860-001

- (1) Prepare for the test as follows:



YOU MUST ATTACH THE PROTECTIVE PAD TO THE FUSELAGE BELOW THE APPLICABLE DOOR. IF YOU DO NOT INSTALL THE PROTECTIVE PAD, DAMAGE TO THE FUSELAGE SKIN AND PAINT CAN OCCUR.

- (a) Install the protective pad, STD-1146 to the fuselage below the applicable door with the long side parallel to the ground.
 - 1) Use tape of sufficient width and strength to make sure that no edges come loose when the slide is deployed.

NOTE: Make sure that the protective pad is correctly attached to the fuselage. If the protective pad is not attached correctly, the protective pad can come loose and stop the slide from deploying correctly.

- (b) Make sure the door is closed.

SUBTASK 25-66-00-710-001

- (2) Do the operational test as follows:



MAKE SURE THERE ARE NO PERSONS OR EQUIPMENT IN THE AREA BELOW THE DOOR. WHEN THE SLIDE DEPLOYS, INJURY TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

- (a) Make sure there are no persons or equipment on the ground in the area below the door.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-66-00

Page 501
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (b) Turn the EPAS battery safety switch to the ARM position.

NOTE: If the EPAS battery safety switch is in the DISARM position, the aft hinge cover will not be flush.

- (c) Move the mode select handle to the AUTOMATIC/ARM position.
(d) Move the door interior handle to the open position.



CAUTION

WHILE EPAS WILL AUTOMATICALLY OPEN THE DOOR, YOU NEED TO ASSURE THE DOOR FULLY OPEN TO PREVENT DAMAGE TO THE SLIDE.

- (e) Make sure the door opens fully.
(f) Make sure the escape slide is fully inflated.
NOTE: The slide inflates in 6 seconds or less after it starts to inflate.
NOTE: The escape slide must inflate automatically to pass the operational test.
(g) If the slide does not inflate automatically, pull the manual inflation handle to inflate the slide.
(h) Make sure the girt bar is fully locked in the two girt bar floor fittings after the slide inflates.

SUBTASK 25-66-00-860-002

- (3) Put the airplane back to its usual condition as follows:
(a) Do this task: Door-Mounted Escape System Restoration, TASK 25-66-00-840-801.

———— **END OF TASK** ————

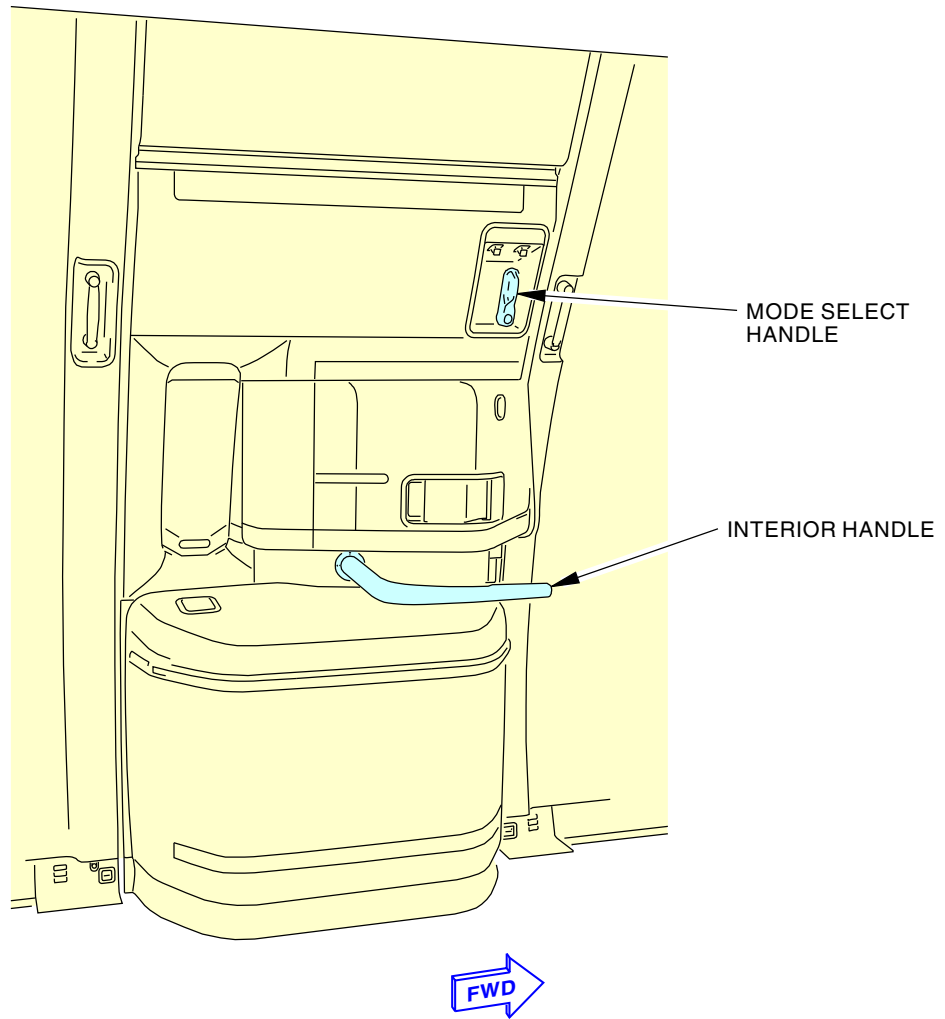
EFFECTIVITY
ARO ALL

25-66-00

D633W101-ARO

Page 502
Sep 05/2017

777-200/300
AIRCRAFT MAINTENANCE MANUAL



PASSENGER ENTRY DOOR
(EXAMPLE)

E08985 S0006411567_V2

Escape System Operational Test
Figure 501/25-66-00-990-802 (Sheet 1 of 2)

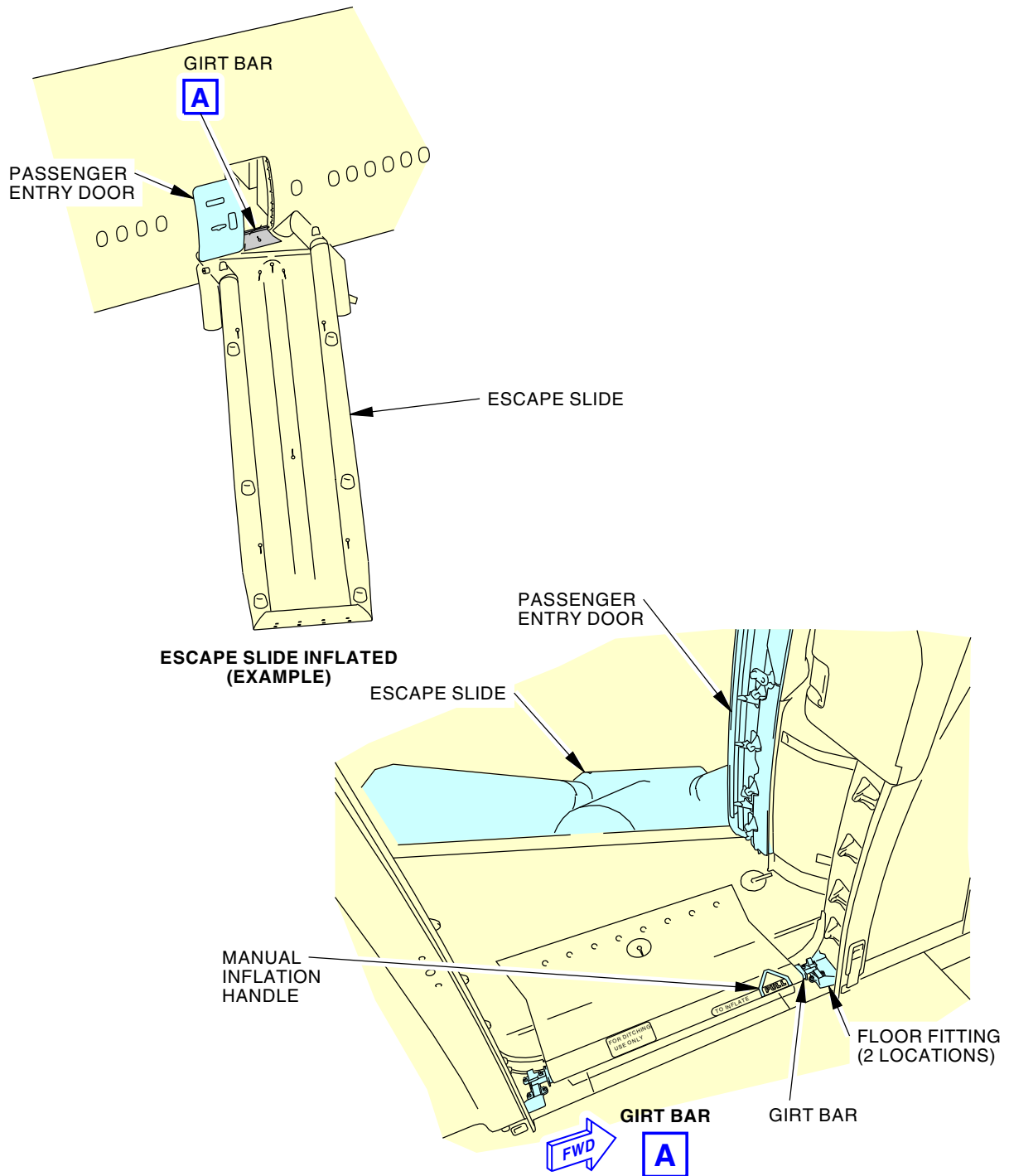
EFFECTIVITY
ARO ALL

25-66-00

D633W101-ARO

Page 503
May 05/2017

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



E54845 S0006411568_V2

Escape System Operational Test
Figure 501/25-66-00-990-802 (Sheet 2 of 2)

EFFECTIVITY
ARO ALL

25-66-00

D633W101-ARO

Page 504
May 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

DOOR-MOUNTED ESCAPE SLIDE PACK - REMOVAL/INSTALLATION

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) A removal of the door-mounted escape slide pack.
 - (2) An installation of the door-mounted escape slide pack.
- C. The escape slide is also an escape slide/raft. It can be disconnected from the airplane and used as a life raft. In this procedure, an escape slide/raft will be called an escape slide.
- D. Two people are necessary to lift or move the escape slide pack. The weight of the escape slide pack is approximately 230 pounds.

TASK 25-66-01-000-801

2. Door-Mounted Escape Slide Pack Removal

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) Use this procedure to remove the slide pack.
- (2) This task is not applicable to the over wing emergency exit door.

B. References

Reference	Title
25-66-06-000-801	Bustle Removal (P/B 401)

C. Prepare for the Removal

SUBTASK 25-66-01-860-001

- (1) Make sure the door is safe as follows:
 - (a) Make sure the door is closed and latched.
 - (b) Make sure the mode select handle [1] is in the MANUAL/DISARM position.



WARNING

WITH MODE SELECT SWITCH IN "AUTO" POSITION AND DOOR OPEN SWITCH IN "OPEN" POSITION, THE SQUIB WILL FIRE UNLESS BATTERY PACK SAFETY SWITCH IS IN THE "DISARM" POSITION. ACCIDENTAL DEPLOYMENT OF THE EPAS CAN CAUSE DAMAGE TO EQUIPMENT OR INJURIES TO PERSONNEL

- (c) Turn the Emergency Power Assist System (EPAS) battery safety switch to the DISARM position.

NOTE: When the EPAS battery safety switch is in the DISARM position, the aft hinge cover cannot be closed. To prevent accidental deployment of the EPAS, make sure that the aft hinge cover will not close before continuing.

SUBTASK 25-66-01-860-002

- (2) Make sure the slide assembly [10] is safe as follows:
 - (a) Do this task: Bustle Removal, TASK 25-66-06-000-801.
 - (b) Remove the Cylinder Safety Pin [13] and Girt Safety Release Pin [17] from the storage pouch [3] on the slide assembly [10].
 - (c) Install the Cylinder Safety Pin [13] for the inflation cylinder [9], View A-A (Figure 401).

EFFECTIVITY
ARO ALL

25-66-01

D633W101-ARO

Page 401
Jul 25/2018

777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Removal

SUBTASK 25-66-01-020-001

- (1) Release the girt bar [16] from the girt bar floor fittings [12] as follows:
 - (a) Move the mode select handle [1] to the AUTOMATIC/ARM position.
 - (b) For the applicable passenger entry door:

Open these circuit breakers and install safety tags:

Overhead Circuit Breaker Panel, P11

Row	Col	Number	Name
H	9	C33640	EMER LTS-DR 5L & 5R
H	10	C33641	EMER LTS-DR 2L & 2R
H	11	C33642	EMER LTS-DR 1L & 1R
H	18	C33619	EMERGENCY LIGHTS DOOR 4L & 4R

NOTE: You open the circuit breaker so the door armed alert horn will not make a sound when you turn the interior handle.



HOLD THE DOOR AND DO NOT LET THE DOOR MOVE FROM THE CUTOUT. IF YOU DO NOT DO ALL OF THE SAFETY STEPS ABOVE AND THE DOOR MOVES OUT OF THE CUTOUT, THE ESCAPE SYSTEM CAN DEPLOY. INJURIES TO THE PERSON OR DAMAGE TO THE AIRPLANE STRUCTURE CAN OCCUR.

- (c) Turn the interior handle [2] approximately 135 degrees to unlatch and lift the door.
- (d) Install the Girt Safety Release Pin [17] for the pack release [19], Views B-B and View C (Figure 401).

NOTE: To install the Girt Safety Release Pin [17] you must put the pin and lanyard through the center slit in the girt material [18].

- (e) Turn the interior handle [2] to the open position to fully lift the door, but do not let the door move out of the cutout.



DO NOT PULL ON THE GIRT MATERIAL. IF THE GIRT MATERIAL IS PULLED, THE ESCAPE SLIDE CAN FALL OUT OF THE BUSTLE. DAMAGE TO EQUIPMENT OR INJURIES TO PERSONNEL CAN OCCUR.

- (f) Remove the girt bar [16] from the girt bar floor fittings [12] on the door cutout.
- (g) Put the girt bar [16] on the floor inboard of the girt bar floor fittings [12].
- (h) Turn the interior handle [2] to the close position to lower and latch the door.
- (i) Move the mode select handle [1] to the MANUAL/DISARM position.

SUBTASK 25-66-01-020-002

- (2) Disengage the slide assembly [10] from the door as follows:
 - (a) Push outboard on the slide assembly [10] and hold.
 - (b) Turn the latch handle [8] to release the latch hook [6] from the latch attach bracket [4] on the door.
 - (c) Lower the top of the slide assembly [10] inboard and down.
 - (d) Disengage the lower fittings [11] from the hooks [5] on the door.

EFFECTIVITY
ARO ALL

25-66-01

D633W101-ARO

Page 402
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (e) Remove the slide assembly [10] from the door.

————— **END OF TASK** —————

TASK 25-66-01-400-801

3. Door-Mounted Escape Slide Pack Installation

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) Use this procedure to install the slide pack.
- (2) This task is not applicable to the overwing emergency exit door.

B. References

Reference	Title
25-66-06-400-801	Bustle Installation (P/B 401)
52-12-22-200-801	Emergency Power Assist System (EPAS) Reservoir Pressure Level Check (P/B 601)

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
10	Slide assembly	25-66-01-02-010	ARO ALL
		25-66-01-02-510	ARO ALL
		25-66-01-03A-050	ARO ALL
		25-66-01-03A-550	ARO ALL
		25-66-01-04A-050	ARO ALL
		25-66-01-04A-550	ARO ALL
		25-66-01-05A-050	ARO ALL
		25-66-01-05A-550	ARO ALL

D. Procedure

SUBTASK 25-66-01-860-003

- (1) Make sure the door and slide assembly [10] are safe as follows:

- (a) Make sure the door is closed and latched.



WARNING

WITH MODE SELECT SWITCH IN "AUTO" POSITION AND DOOR OPEN SWITCH IN "OPEN" POSITION, THE SQUIB WILL FIRE UNLESS BATTERY PACK SAFETY SWITCH IS IN THE "DISARM" POSITION. ACCIDENTAL DEPLOYMENT OF THE EPAS CAN CAUSE DAMAGE TO EQUIPMENT OR INJURIES TO PERSONNEL

- (b) Make sure the EPAS battery safety switch is in the DISARM position.

NOTE: If the EPAS battery safety switch is in the DISARM position, the aft hinge cover will not be flush.

- (c) Make sure the Cylinder Safety Pin [13] for the inflation cylinder [9] is installed, View A-A (Figure 401).
- (d) Make sure the Girt Safety Release Pin [17] for the pack release [19] is installed, Views B-B and C (Figure 401).

EFFECTIVITY
ARO ALL

25-66-01

D633W101-ARO

Page 403
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-66-01-420-001

- (2) Install the slide assembly [10] on the door as follows:
 - (a) Put the slide assembly [10] in front of the door with the packboard [20] on top and the lower fittings [11] near the door.
 - (b) Engage the lower fittings [11] with the hooks [5] on the door.
 - (c) Move the top of the packboard [20] up and outboard until the upper latch mechanism [7] touches the latch attach bracket [4].
 - (d) Turn the latch handle [8] and engage the latch hook [6] with the latch attach bracket [4] on the door to install the slide assembly [10].
 - (e) Make sure that the latch handle [8] is correctly secured into its latch handle support [23] to avoid any latch handle opening.

SUBTASK 25-66-01-420-002

- (3) Install the girt bar [16] in the girt bar floor fittings [12] as follows:

NOTE: Use two persons to do these steps.

- (a) Move the mode select handle to the AUTOMATIC/ARM position.



HOLD THE DOOR AND DO NOT LET THE DOOR MOVE FROM THE CUTOUT. IF YOU DO NOT DO ALL OF THE SAFETY STEPS ABOVE AND THE DOOR MOVES OUT OF THE CUTOUT, THE ESCAPE SYSTEM CAN DEPLOY. INJURIES TO THE PERSON OR DAMAGE TO THE AIRPLANE STRUCTURE CAN OCCUR.

- (b) Turn the interior handle [2] approximately 135 degrees to unlatch and lift the door.
- (c) Align the girt bar [16] with the girt bar floor fittings [12] on the door cutout. Make sure the manual inflation handle on the girt faces up (away from the floor).
- (d) Push the ends of the girt bar [16] down into the girt bar floor fittings [12] until they lock into the correct position.



DO NOT PULL ON THE GIRT MATERIAL. IF THE GIRT MATERIAL IS PULLED, THE ESCAPE SLIDE CAN FALL OUT OF THE BUSTLE. DAMAGE TO EQUIPMENT OR INJURIES TO PERSONNEL CAN OCCUR.

- (e) Remove the [17] for the pack release [19], Views B-B and View C (Figure 401) and put it in the storage pouch [3] on the slide assembly [10].
- (f) Turn the interior handle [2] to the close position to lower and latch the door.

SUBTASK 25-66-01-080-004

- (4) Do this task: Escape Slide Pack - Girt Material Stowage, TASK 25-66-01-820-801.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 25-66-01-080-005

- (1) Remove the Cylinder Safety Pin [13] for the inflation cylinder [9] and put it in the storage pouch [3].

SUBTASK 25-66-01-410-002

- (2) Do this task: Bustle Installation, TASK 25-66-06-400-801.

SUBTASK 25-66-01-860-008

- (3) Turn the EPAS battery safety switch to the ARM position.

EFFECTIVITY
ARO ALL

25-66-01

D633W101-ARO

Page 404
Jul 25/2018



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-66-01-860-011

- (4) Check the Emergency Power Assist System (EPAS) reservoir pressure gage. Do the following task: Emergency Power Assist System (EPAS) Reservoir Pressure Level Check, TASK 52-12-22-200-801.

————— END OF TASK —————

TASK 25-66-01-820-801

4. Escape Slide Pack - Girt Material Stowage

(Figure 401)

A. General

- (1) This task is not applicable to the overwing emergency exit door.
- (2) Stowage of the girt material must be checked each time a passenger entry door is lifted when the mode select handle is in the AUTOMATIC/ARM position.
- (3) If there is interference between the girt material and the door bottom seal, air leaks and noise can occur when the airplane is in flight.

B. Procedure

SUBTASK 25-66-01-080-006

- (1) Make sure the girt material [18] is stowed correctly as follows:

NOTE: Use two persons to do these steps.

- (a) Make sure that the EPAS battery safety switch is in the DISARM position.

NOTE: If the EPAS battery safety switch is in the DISARM position, the aft hinge cover will not be flush.

- (b) Make sure the mode select handle [1] is in the AUTOMATIC/ARM position.



WARNING

HOLD THE DOOR AND DO NOT LET IT MOVE FROM THE CUTOUT. IF THE DOOR MOVES FROM THE CUTOUT WITH THE GIRT BAR LOCKED IN THE FLOOR FITTINGS, THE ESCAPE SLIDE WILL DEPLOY AND DAMAGE TO EQUIPMENT OR INJURIES TO PERSONNEL CAN OCCUR.

- (c) Turn the interior handle [2] approximately 135 degrees to unlatch and lift the door.
- (d) If the escape slide pack [10] has a girt storage tray [15], push the girt material [18] back into the tray if it has pulled out.



WARNING

DO NOT PULL TOO TIGHTLY ON THE GIRT MATERIAL WHILE YOU ATTACH IT TO THE HOOK-AND-LOOP MATERIAL ON THE FLAP. IF THE GIRT MATERIAL IS TOO TIGHT, THE GIRT BAR WILL TURN TO AN INCORRECT POSITION. IF THE GIRT BAR IS IN AN INCORRECT POSITION, IT WILL NOT RELEASE FROM THE FLOOR FITTINGS WHEN YOU OPEN THE DOOR (WHEN THE MODE-SELECT HANDLE IS IN THE MANUAL/DISARM POSITION). IF THE GIRT BAR DOES NOT RELEASE, THE ESCAPE SLIDE WILL DEPLOY, AND DAMAGE TO EQUIPMENT OR INJURIES TO PERSONNEL CAN OCCUR.

- (e) If the escape slide pack [10] does not have a girt storage tray, make sure the hook-and-loop material [21] on the flap [22] holds the girt material [18] correctly.
- (f) Turn the interior handle [2] to the close position to lower and latch the door.
- (g) Move the mode select handle [1] to the MANUAL/DISARM position.

EFFECTIVITY
ARO ALL

25-66-01

D633W101-ARO

Page 405
Jul 25/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- (h) Turn the EPAS battery safety switch to the ARM position.
- (i) For the applicable passenger entry door:
Remove the safety tags and close these circuit breakers:

Overhead Circuit Breaker Panel, P11

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
H	9	C33640	EMER LTS-DR 5L & 5R
H	10	C33641	EMER LTS-DR 2L & 2R
H	11	C33642	EMER LTS-DR 1L & 1R
H	18	C33619	EMERGENCY LIGHTS DOOR 4L & 4R

———— **END OF TASK** ————

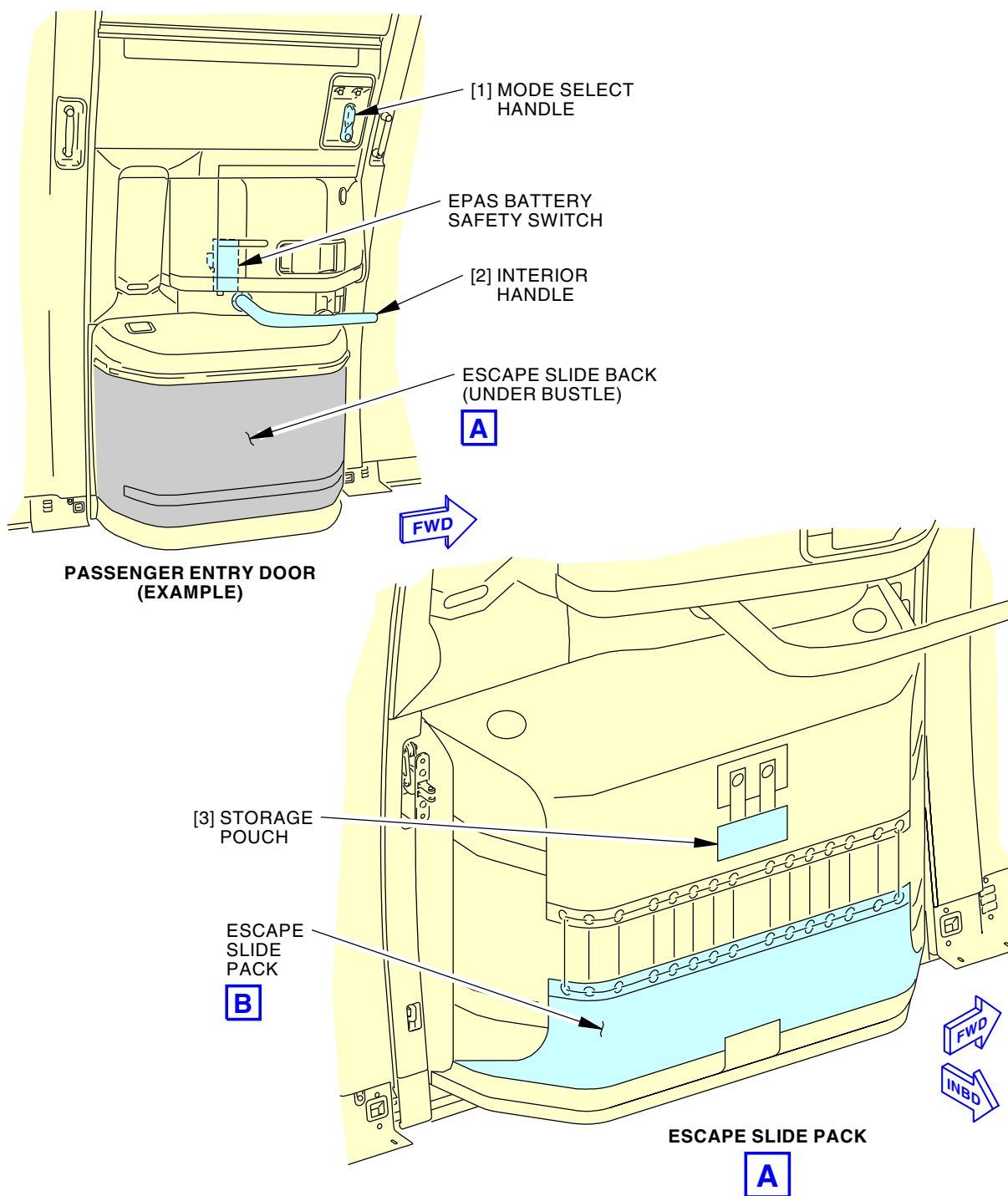
EFFECTIVITY
ARO ALL

D633W101-ARO

25-66-01

Page 406
Jul 25/2018

777-200/300
AIRCRAFT MAINTENANCE MANUAL



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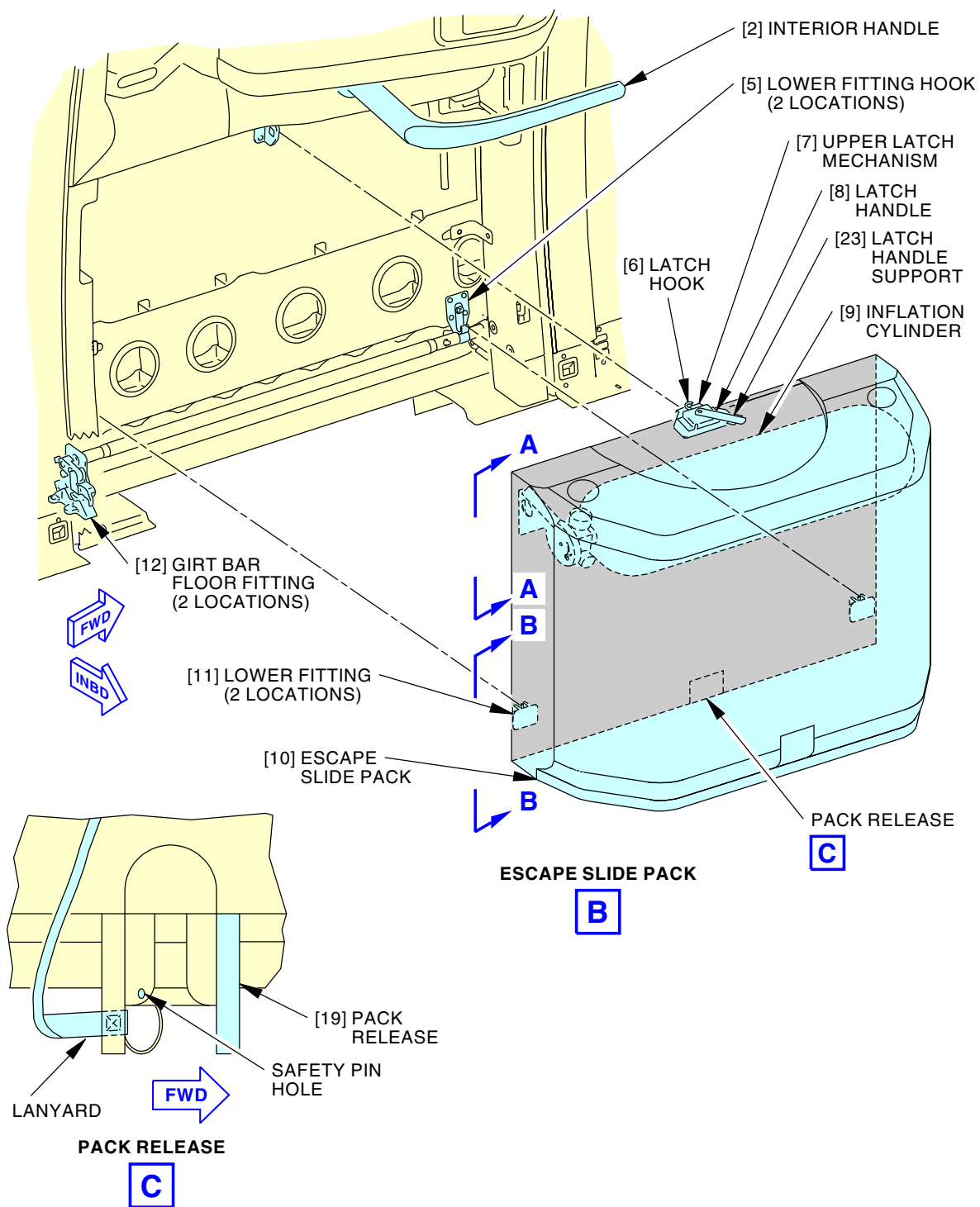
Escape Slide Pack Installation
Figure 401/25-66-01-990-802 (Sheet 1 of 4)

EFFECTIVITY
ARO ALL

25-66-01

D633W101-ARO

Page 407
May 05/2017



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**Escape Slide Pack Installation
Figure 401/25-66-01-990-802 (Sheet 2 of 4)**

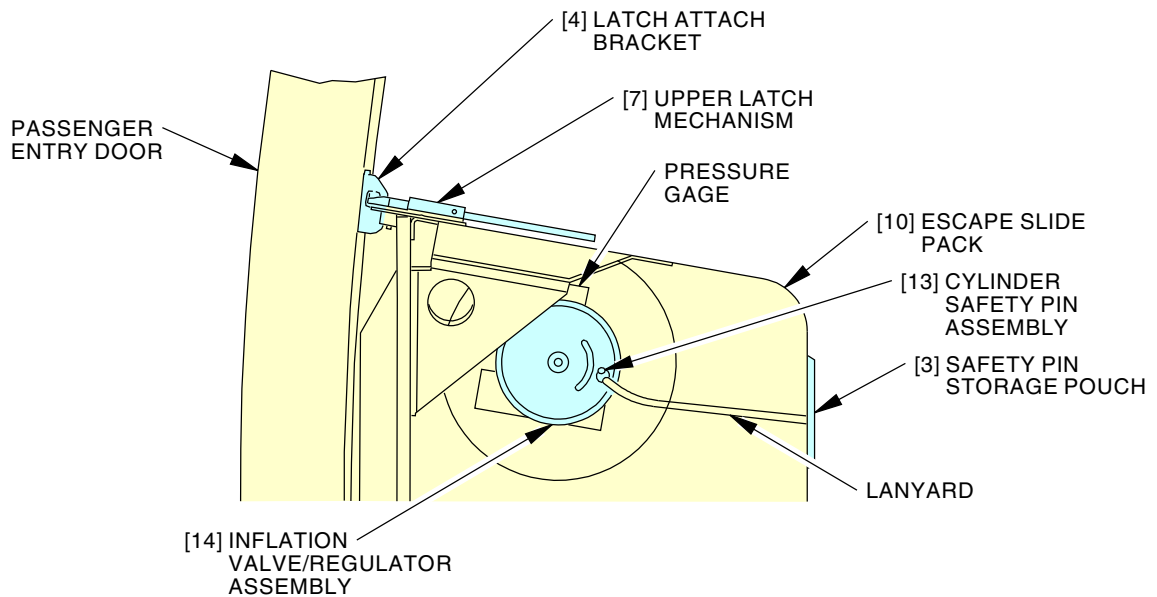
EFFECTIVITY
ARO ALL

25-66-01

D633W101-ARO

Page 408
Jan 05/2018

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



A-A



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Escape Slide Pack Installation
Figure 401/25-66-01-990-802 (Sheet 3 of 4)

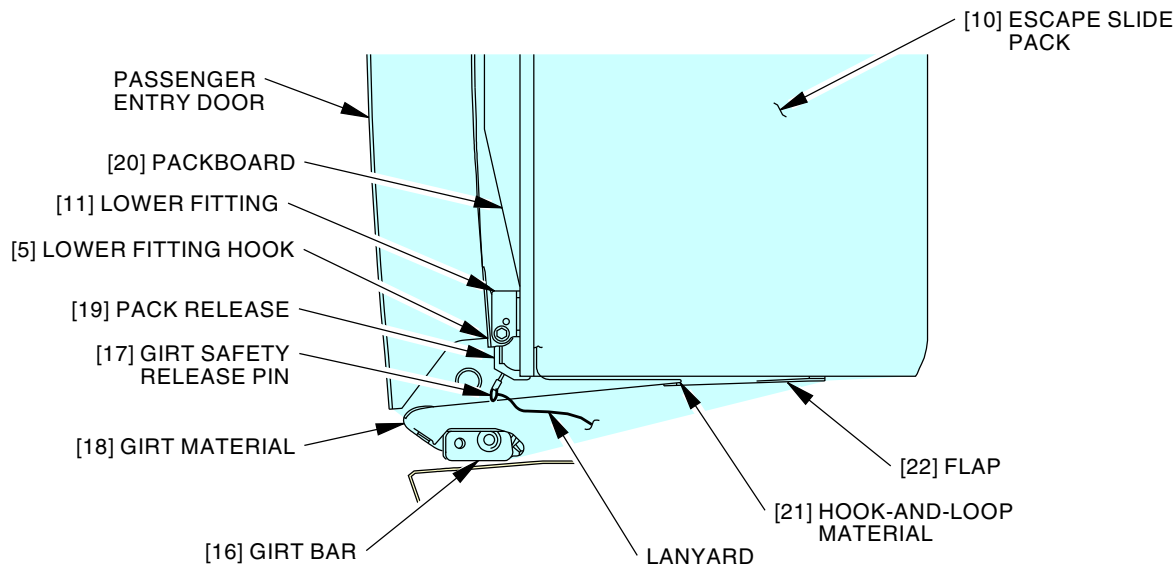
EFFECTIVITY
ARO ALL

25-66-01

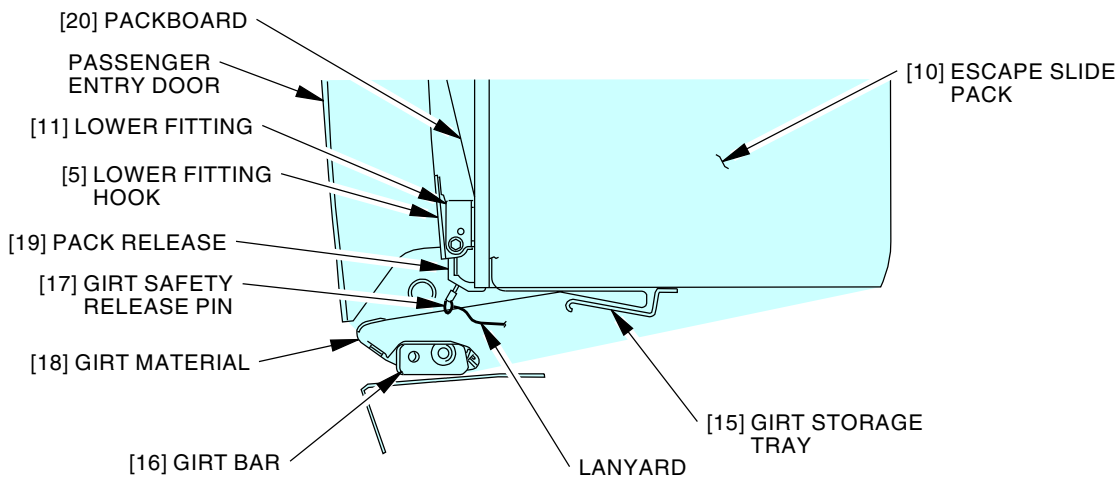
D633W101-ARO

Page 409
Jul 25/2018

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



B-B 1



B-B 2

- 1** SLIDE PACKS WITH HOOK-AND-LOOP MATERIAL
- 2** SLIDE PACKS WITH GIRT STORAGE TRAYS

K38096 S0006411577_V3

**Escape Slide Pack Installation
Figure 401/25-66-01-990-802 (Sheet 4 of 4)**

EFFECTIVITY
ARO ALL

25-66-01

D633W101-ARO

Page 410
Jul 25/2018



777-200/300
AIRCRAFT MAINTENANCE MANUAL

DOOR-MOUNTED ESCAPE SLIDE PACK - INSPECTION/CHECK

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has these tasks:
 - (1) A check of the door-mounted escape slide pack inflation cylinder.

TASK 25-66-01-200-801

2. Door-Mounted Escape Slide Pack Inflation Cylinder Check

(Figure 601)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This task is not applicable to the overwing emergency exit door.
- (2) This task is an inspection of the escape slide pack inflation cylinder.

B. Procedure

SUBTASK 25-66-01-280-001

- (1) Do a check on the inflation cylinder pressure level as follows:
 - (a) Look through the window in the bustle at the inflation cylinder pressure gage.
 - (b) Make sure the pressure gage needle is in the GO band (green).

NOTE: The inflation cylinder must be at a constant, stable temperature for two hours or more for the GO band to be in the correct position. The inflation cylinder has a temperature compensating pressure gage. This makes the GO band move when the temperature changes. A fast change in the temperature causes the green GO band to move more quickly than the pressure gage needle. The pressure gage needle can show an incorrect indication immediately after a large change in temperature.

———— **END OF TASK** ————

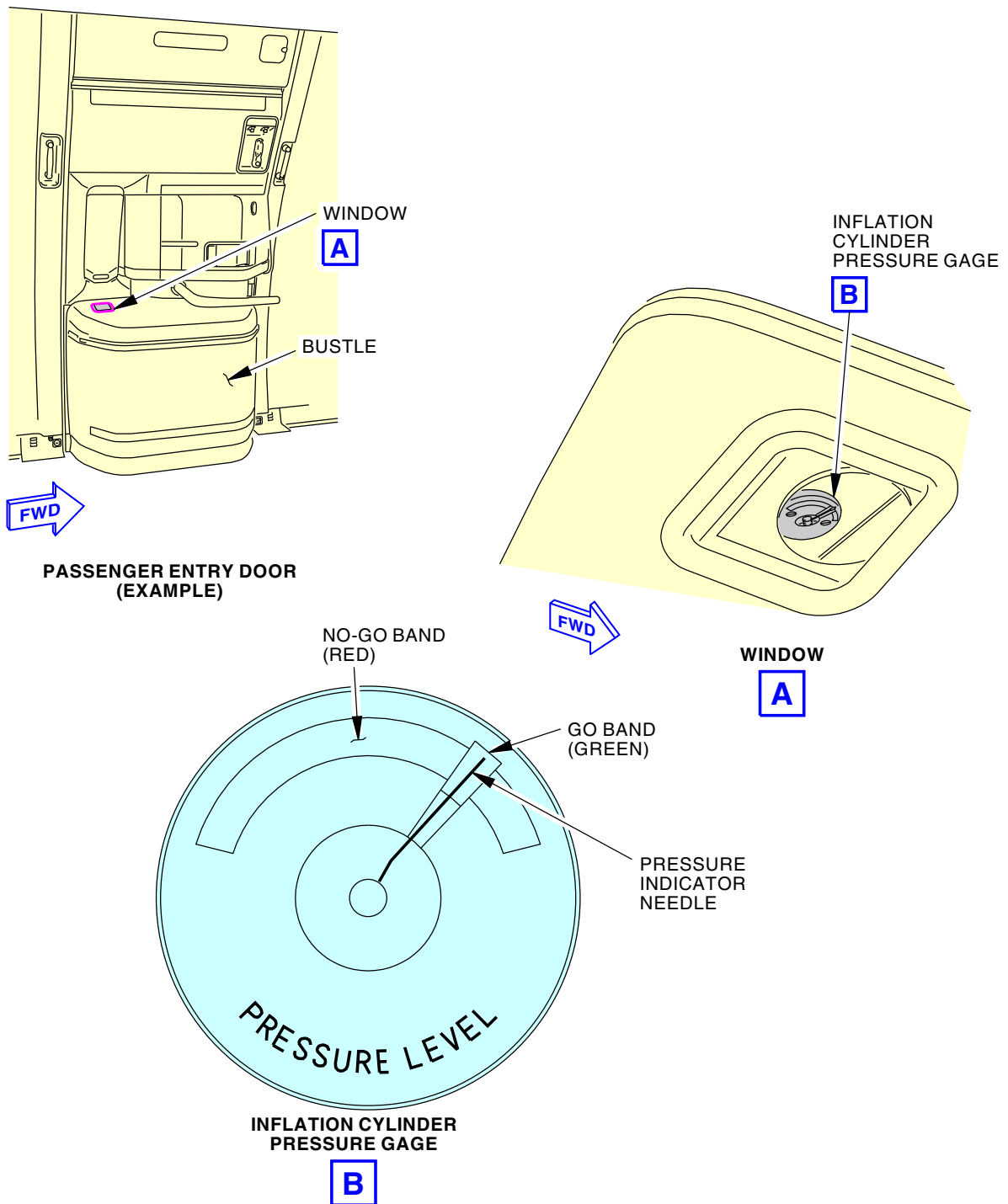
EFFECTIVITY
ARO ALL

D633W101-ARO

25-66-01

Page 601
May 05/2015

BOEING
777-200/300
AIRCRAFT MAINTENANCE MANUAL



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Inflation Cylinder Pressure Level Check
Figure 601/25-66-01-990-801

EFFECTIVITY
ARO ALL

D633W101-ARO

25-66-01

Page 602
Sep 05/2016



777-200/300
AIRCRAFT MAINTENANCE MANUAL

BUSTLE - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the bustle.
 - (2) An installation of the bustle.

TASK 25-66-06-000-801

2. Bustle Removal

(Figure 401)

A. Removal

SUBTASK 25-66-06-020-001

- (1) Pull the bottom of the bustle [2] inboard to disengage the guides [4] from the lower attachments [5] on the door.

SUBTASK 25-66-06-020-002

- (2) Push the triggers [3] on the latches [6] to release the latches from the hinges [1] on the door.

SUBTASK 25-66-06-020-003

- (3) Pull the bustle [2] away from the door.

————— **END OF TASK** —————

TASK 25-66-06-400-801

3. Bustle Installation

(Figure 401)

A. Installation

SUBTASK 25-66-06-410-001

- (1) Put the bustle [2] in its correct position in front of the door.

SUBTASK 25-66-06-410-002

- (2) Engage the latches [6] with the hinges [1] on the door and close the latches.

SUBTASK 25-66-06-410-003

- (3) Engage the guides [4] with the lower attachments [5] on the door.

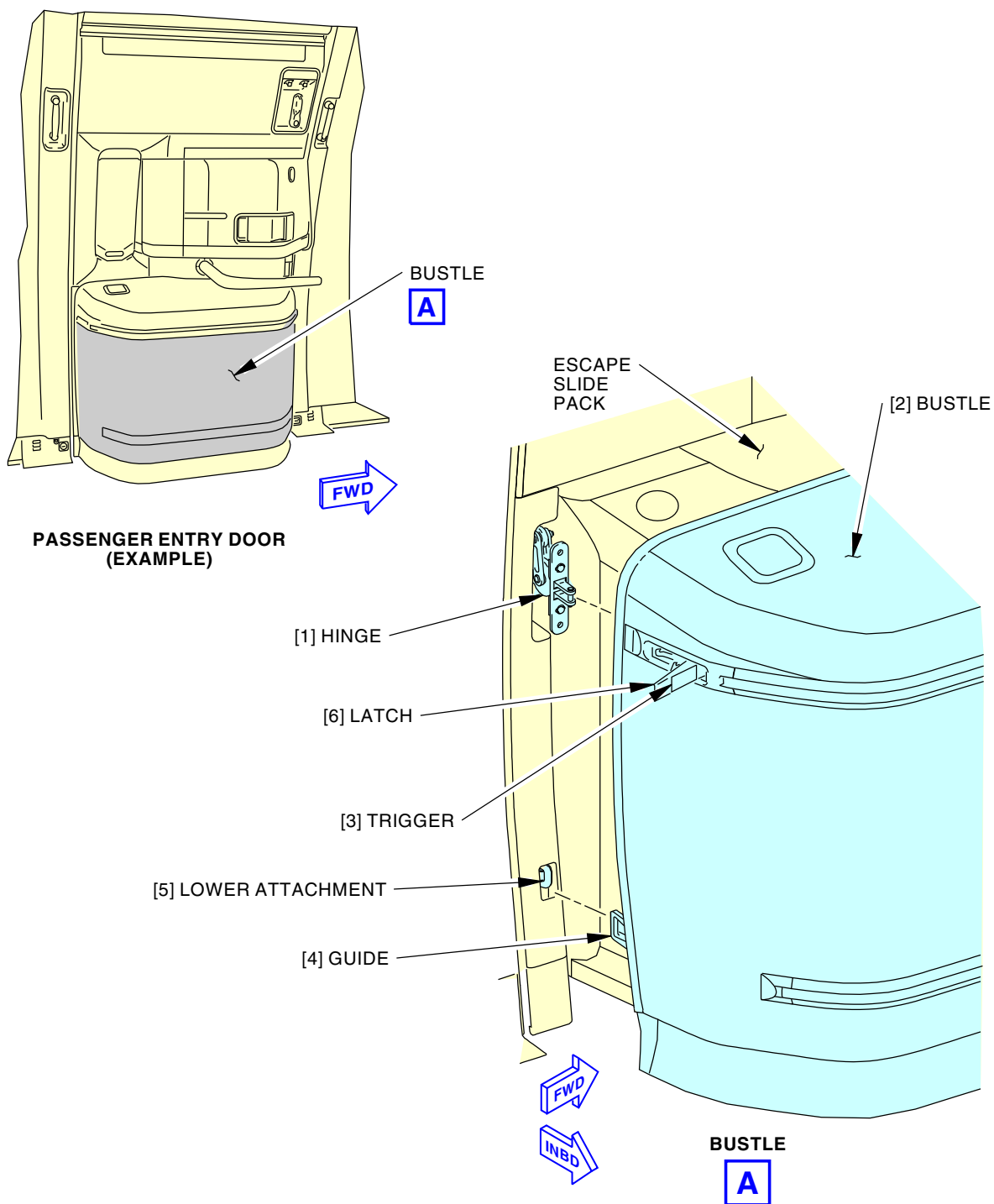
————— **END OF TASK** —————

EFFECTIVITY
ARO ALL

D633W101-ARO

25-66-06

Page 401
Jan 05/2015



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**Bustle Installation
Figure 401/25-66-06-990-801**

**EFFECTIVITY
ARO ALL**

25-66-06

D633W101-ARO

Page 402
May 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL
INSULATION - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Insulation Blanket Removal.
 - (2) Insulation Blanket Installation.
- B. This procedure is applicable for insulation blankets in all compartments. Examples are given of how to remove and install insulation blankets in the main deck and lower lobe.

TASK 25-80-00-000-801

2. Insulation Blanket Removal

(Figure 401, Figure 402)

A. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

B. Insulation Blanket Removal

SUBTASK 25-80-00-020-001

- (1) Do the applicable steps that follow to disconnect the insulation blanket [1] from the aircraft structure:

NOTE: There are different configurations of the attachments used to install each insulation blanket.

- (a) Roll the clamps [3], [6] off of the insulation blanket [1].
- (b) Remove the disks [11] from the index pins [10].
- (c) Remove the disks [7] from the studs [9].
- (d) Cut through any blanket tape to allow blanket removal.
- (e) Gently remove any moisture control blankets (Figure 402) at structural intercostal locations: these parts may be re-used.
NOTE: The moisture control blanket is attached to the insulation by double-backed tape.
- (f) Rubber moisture seals must be either removed or cut through to allow blanket removal. If systems or structure are still installed then the rubber seal must be cut through to enable removal; make this cut along the slit in the blanket.
- (g) Put your hand on the back of the grommet [13] and pull the insulation blanket [1] away from the stand-off [12].

NOTE: The grommet is bonded to the insulation blanket.

SUBTASK 25-80-00-020-002

- (2) Remove the insulation blanket [1].

EFFECTIVITY
ARO ALL

D633W101-ARO

25-80-00

Page 401
May 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-80-00-500-002



DO NOT COMPRESS THE INSULATION BLANKET BY MORE THAN 50 PERCENT. THIS DECREASES THE THERMAL AND ACOUSTIC PROPERTIES. IF YOU COMPRESS IT TOO MUCH, DAMAGE TO THE INSULATION BLANKET WILL OCCUR.

- (3) Put the insulation blanket [1] in a neat stack on a shelf or in bags for shipping.

————— **END OF TASK** —————

TASK 25-80-00-400-801

3. Insulation Blanket - Installation

(Figure 401, Figure 402, Figure 403)

A. General

- (1) The use of BMS 8-39 Urethane foam for replacement or repair of insulation in areas where it is used to prevent fire or smoke penetration is not permitted due to the degradation in flammability properties over time.
- (2) BMS8-371 insulation foam or BMS1-68 silicone foam rubber replaces BMS8-39 Urethane foam in areas where it is used to prevent fire or smoke penetration. The selection of either BMS8-371 or BMS1-68 material will be based on requirements for use and its location in the airplane. BMS8-39 foam is replaced in areas of the airplane where it is not easy to access for fire and smoke detection or suppression. The BMS8-39 foam is also replaced in areas where it is used to prevent fire or smoke penetration. It is not replaced in areas where it is encapsulated by a protective fire resistant barrier or where it is physically isolated from an ignition source.

NOTE: Foam pads installed at insulation blanket penetrations and foam seals around systems penetrations are affected by AD 2013-11-04.

- (3) Refer to PAGEBLOCK 53-17-00/201 for flight compartment and cargo compartment foam Urethane foam identification and replacement.

B. Consumable Materials

Reference	Description	Specification
C00755	Compound - Organic Corrosion Inhibiting, Heavy Duty	BMS3-26
C00915	Compound - Organic Corrosion Inhibiting, Advanced	BMS3-29
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23
G50333	Tape - Hook/Loop Fastener, Flame Propagation Resistant	BMS8-372
G50789	Tape - Adhesive Insulation Blanket	BMS5-157 Type I Class 2 Grade C Composition MPEEK

C. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

EFFECTIVITY
ARO ALL

D633W101-ARO

25-80-00

Page 402
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL

D. Check for Insulation Blanket Contamination

SUBTASK 25-80-00-430-002



WARNING

LET THE CORROSION-INHIBITING COMPOUNDS (CIC) BECOME FULLY DRY. IF CIC GETS ON THE INSULATION BLANKET, THE INSULATION BLANKET WILL BECOME LESS FLAME-RESISTANT. THIS INCREASES THE RISK OF FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (1) To prevent CIC contamination of insulation blankets, let the corrosion-inhibiting compounds fully dry before you install the insulation blankets.
 - (a) Let the corrosion-inhibiting compounds dry longer than the minimum times listed below if you have one of these conditions:
 - 1) Low temperature.
 - 2) High humidity.
 - 3) Thick layer of corrosion-inhibiting compounds.
 - (b) Ventilate areas treated with CIC such as corrosion inhibiting compound, G00009 (BMS 3-23), with good air flow for a minimum of one hour.
 - (c) Ventilate areas treated with CIC such as compound, C00755 (BMS 3-26) or compound, C00915 (BMS 3-29), with good air flow for a minimum of four hours.

SUBTASK 25-80-00-160-001



WARNING

DO NOT USE DETERGENTS OR SOLVENTS TO CLEAN THE INSULATION BLANKET. IT CAN REMOVE FLAME RETARDANTS AND CAUSE FLAMMABLE RESIDUES ON THE INSULATION BLANKET WHICH INCREASES THE RISK OF FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (2) If there is Corrosion-inhibiting Compounds (CIC) contamination, oily or waxy substances or other fluids (which typically changes the color and appearance of the insulation blanket cover), replace the insulation blanket.

SUBTASK 25-80-00-160-015

- (3) If there are dust, lint or other loose debris on the insulation blanket, use a vacuum cleaner or a non-metallic soft brush to remove the contamination.

NOTE: It is acceptable to use a lint free cloth moistened with clean water to clean the insulation blanket cover if a vacuum cleaner does not remove stains or other loose debris.

SUBTASK 25-80-00-160-002

- (4) Make sure the area is clean before you install the insulation blanket.

E. Install the Insulation Blanket

SUBTASK 25-80-00-960-002

- (1) If you replace an insulation blanket or capstrip, install an insulation blanket or a capstrip that complies with FAR 25.856(b).
 - (a) Use tape, G50789 (BMS5-157) or hook and loop tape, G50333 (BMS8-372), where necessary.

NOTE: Tape (BMS5-157) and hook and loop tape (BMS8-372) are FAR 25.856 compliant.

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

Page 403
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (b) Replace the part of the hook and loop tape that is installed on the airplane structure where the replacement insulation blanket attaches, with hook and loop tape, G50333 (BMS8-372).

SUBTASK 25-80-00-820-002

- (2) Put the side of the insulation blanket [1] with the clamp indicators [16] inboard.

NOTE: Some blankets will have clamp spacing indicators. All blankets must maintain spacing requirements.

SUBTASK 25-80-00-820-001

- (3) Align the holes in the insulation blanket [1] with the index pins [10].

SUBTASK 25-80-00-420-001

- (4) Do the applicable steps that follow to attach the insulation blanket [1] to the airplane structure:
- Install the disks [11] on the index pins [10].
 - Put the grommets [13] that bond to the insulation blanket [1] on the standoffs [12].
 - Do these steps to wrap the insulation blanket [1] correctly around the airplane structure [2], [4]:
 - Put the blanket tab [8] around the airplane structure [2], [4].
 - Put the capstrip [17] over the blanket tab [8].
 - Look for the clamp indicator [16] on the insulation blanket [1].
 - When you install the clamps [3], [6], make sure they are the minimum distance from adjacent hoses, wires, or ducts:

Table 401/25-80-00-993-801

Separation Requirements	
Hoses, Wires, or Ducts and other systems	Minimum Distance from Clamp (Inch)
Supported (at the stand off)	0.25
Unsupported	0.5



CAUTION

DO NOT USE FORCE TO PUSH THE CLAMP STRAIGHT ON THE AIRPLANE STRUCTURE. IF YOU USE FORCE TO PUSH THE CLAMP STRAIGHT ON THE AIRPLANE STRUCTURE, YOU WILL CAUSE PERMANENT DAMAGE TO THE CLAMP AND TEAR THE INSULATION BLANKET.

- Use a roll movement with two hands to install the clamps [3], [6] on the clamp indicator [16].
- Put the studs [9] through the insulation blanket [1].
- Install the disks [7] on the studs [9].
- Install the pins and the c-clamps with a maximum spacing of 14 in. (36 cm).
 - Install the c-clamp within the width of the c-clamp indicator box for correct spacing.

SUBTASK 25-80-00-390-002

- (5) For replacement insulation blanket, push on the insulation blanket to remove the air that is inside the insulation blanket through the vent hole(s).
- Peel off the attached release liner on the circle tape and seal the vent hole(s).

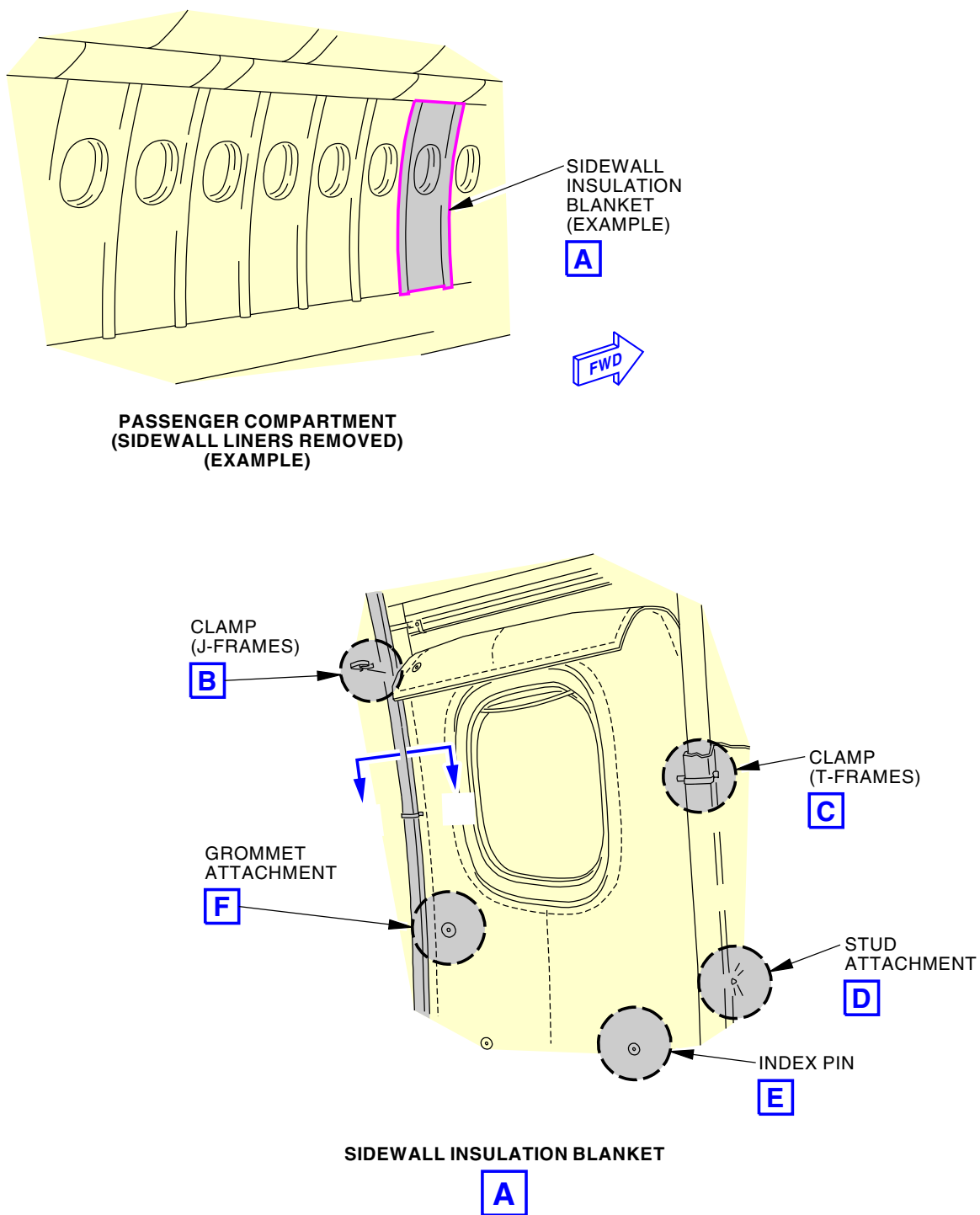
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EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

Page 404
Sep 05/2017



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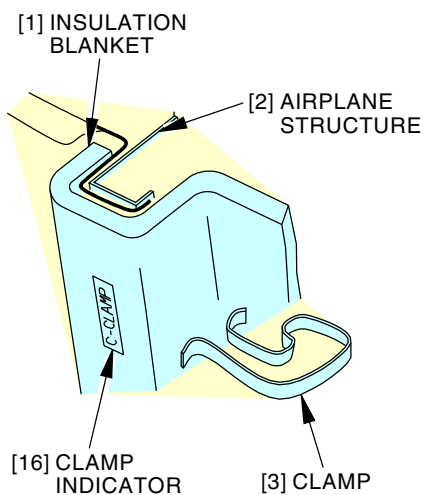
**Sidewall Insulation Blanket Installation
Figure 401/25-80-00-990-802 (Sheet 1 of 3)**

EFFECTIVITY
ARO ALL

25-80-00

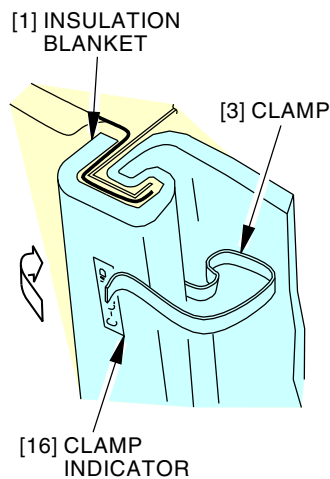
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**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



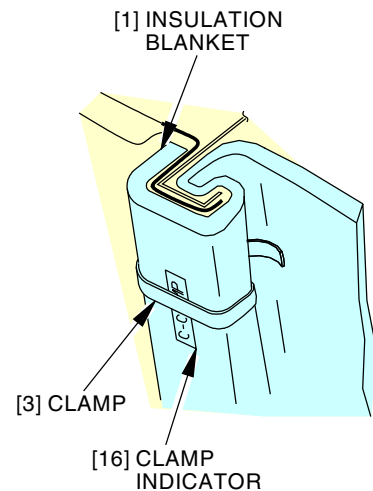
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CLAMP
(J-FRAMES)**

B



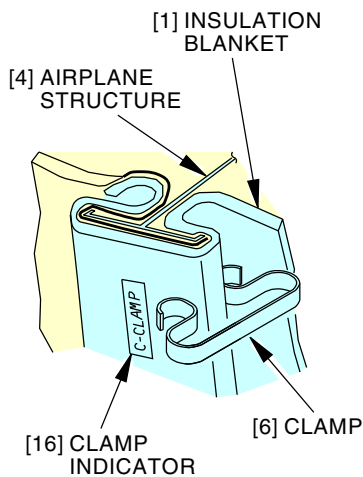
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CLAMP
(J-FRAMES)**

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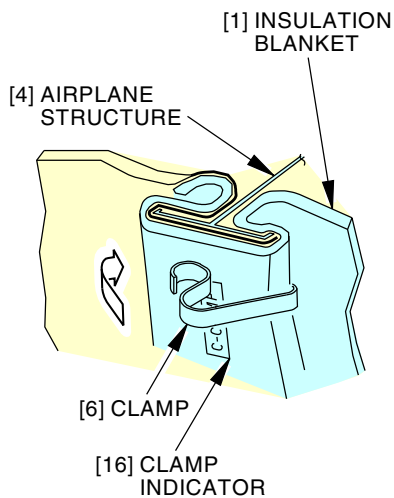
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(J-FRAMES)**

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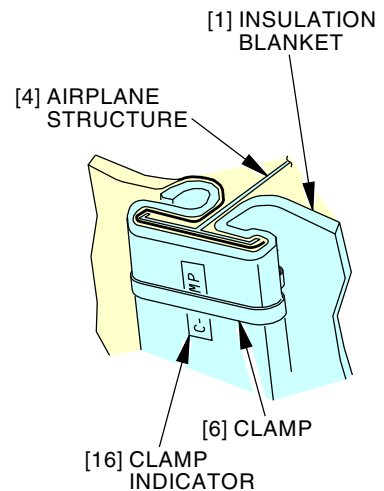
**STEP 1
CLAMP
(T-FRAMES)**

C



**STEP 2
CLAMP
(T-FRAMES)**

C



**STEP 3
CLAMP
(T-FRAMES)**

C

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**Sidewall Insulation Blanket Installation
Figure 401/25-80-00-990-802 (Sheet 2 of 3)**

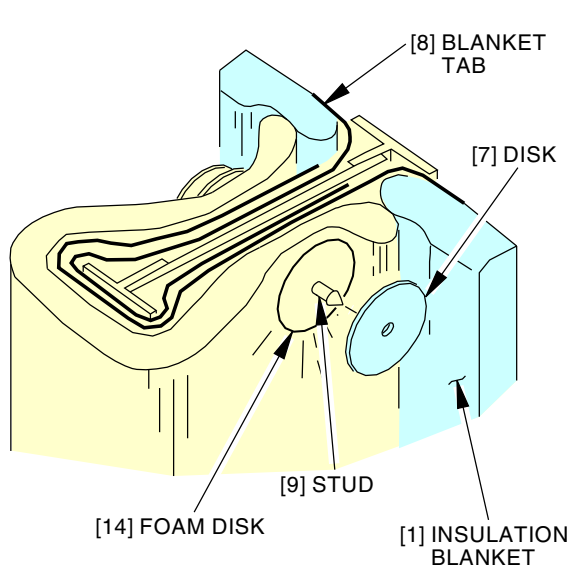
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D633W101-ARO

25-80-00

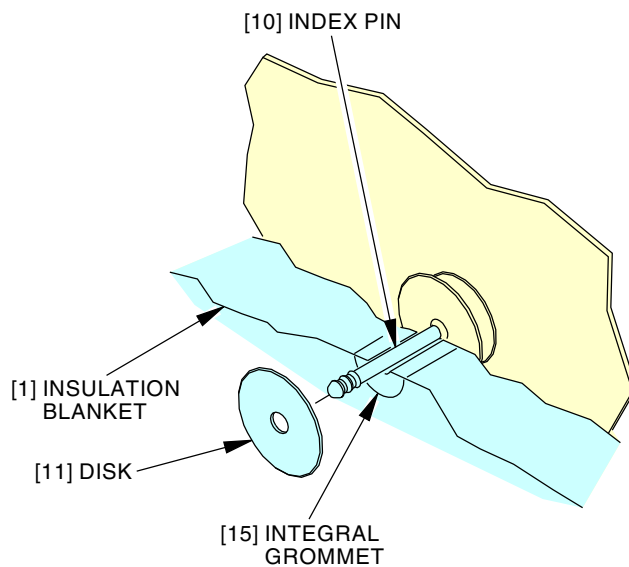
Page 406
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



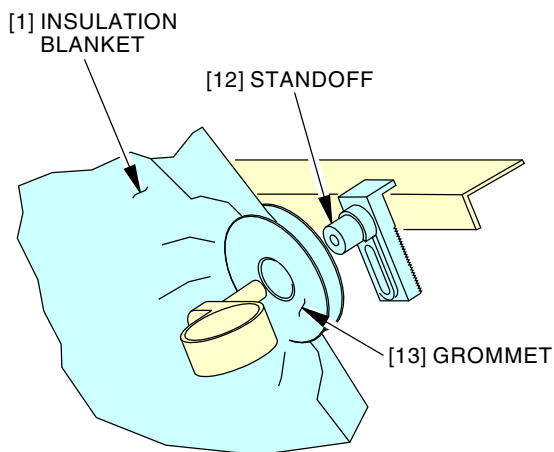
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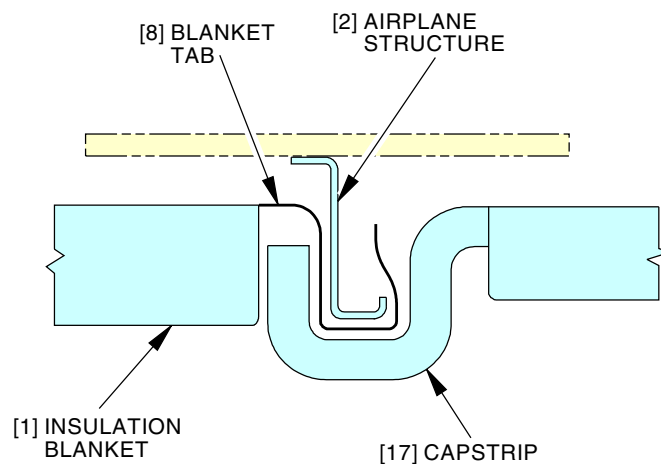
INDEX PIN

E



GROMMET ATTACHMENT

F



A-A

E31642 S0006411598_V2

**Sidewall Insulation Blanket Installation
Figure 401/25-80-00-990-802 (Sheet 3 of 3)**

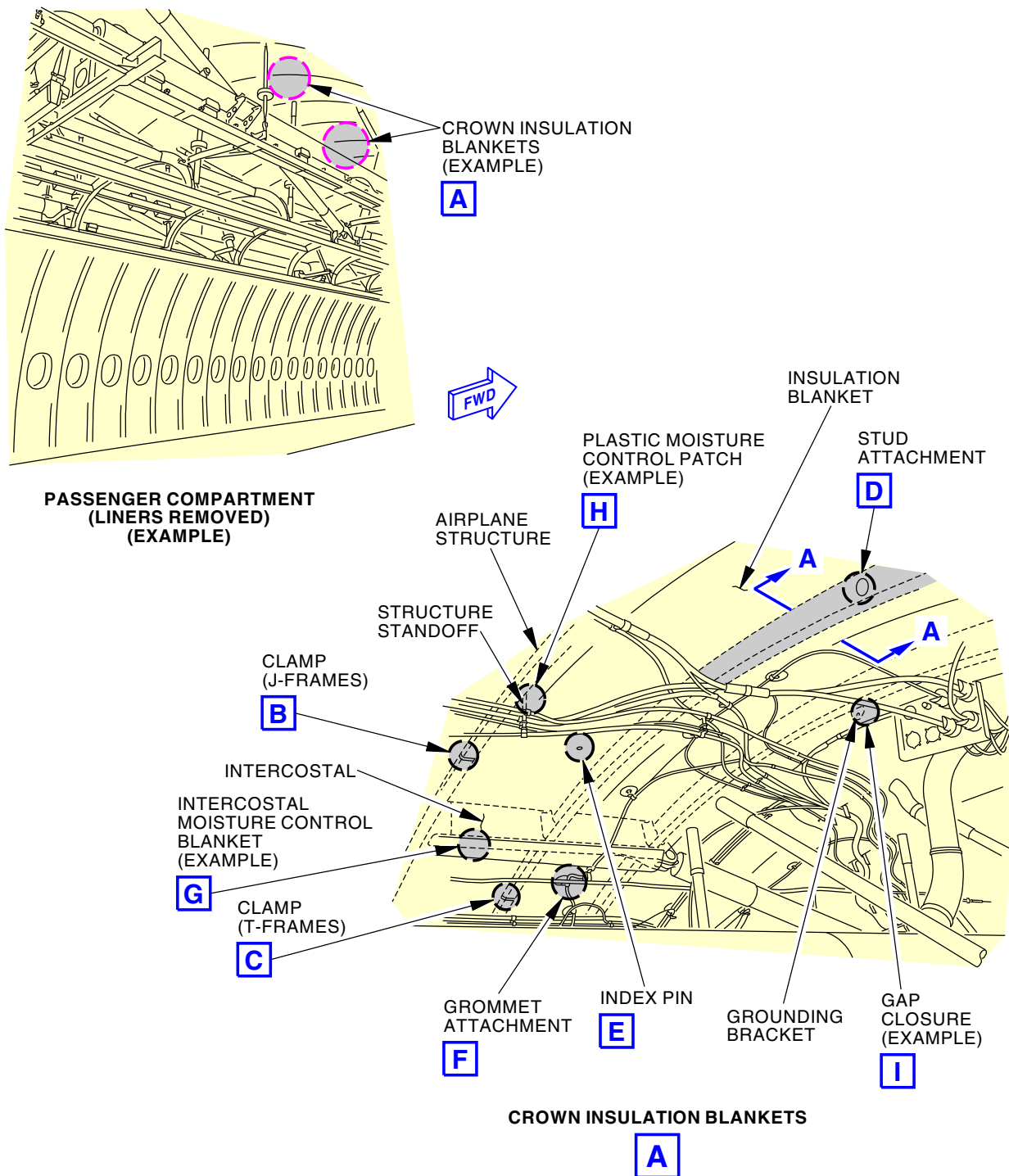
EFFECTIVITY
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D633W101-ARO

25-80-00

Page 407
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



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**Crown Insulation Blanket Installation
Figure 402/25-80-00-990-805 (Sheet 1 of 6)**

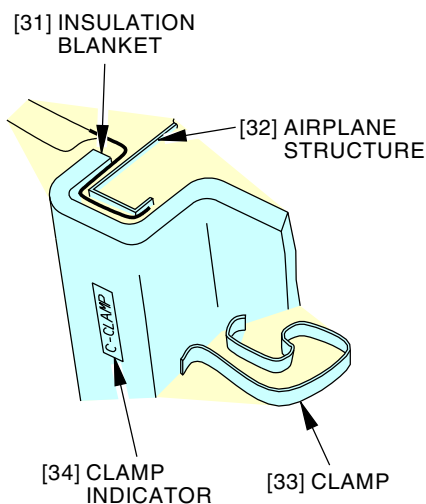
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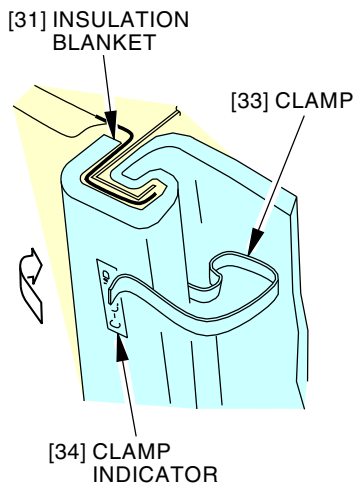
Page 408
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



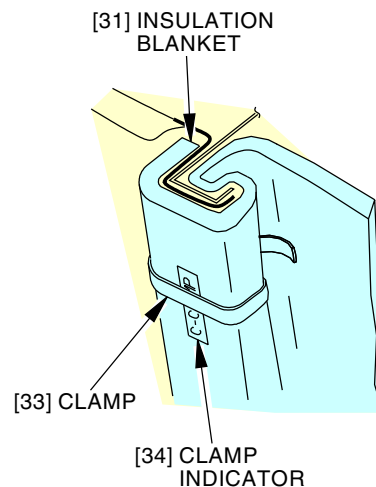
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(J-FRAMES)**

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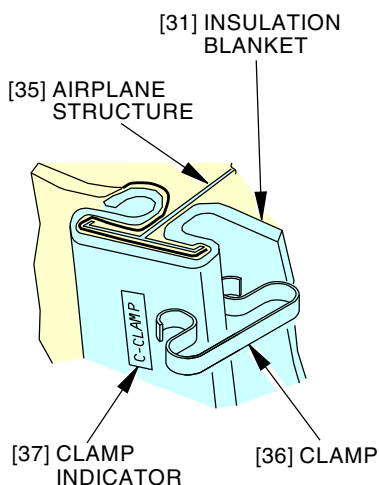
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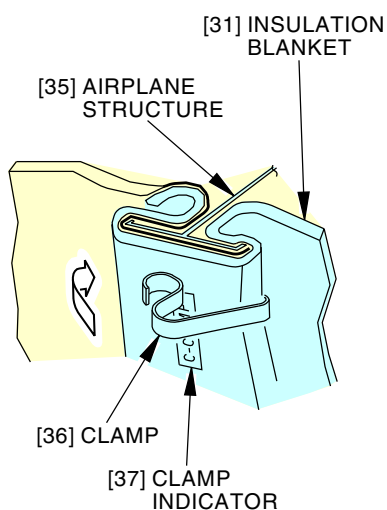
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(J-FRAMES)**

B



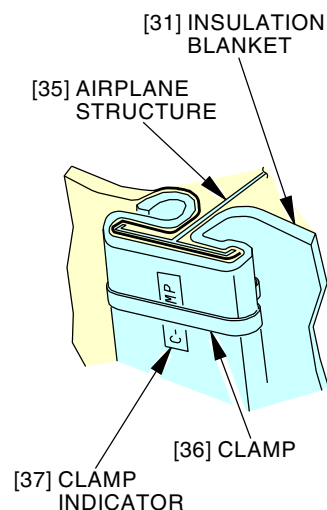
**STEP 1
CLAMP
(T-FRAMES)**

C



**STEP 2
CLAMP
(T-FRAMES)**

C



**STEP 3
CLAMP
(T-FRAMES)**

C

L23744 S0006411600_V2

**Crown Insulation Blanket Installation
Figure 402/25-80-00-990-805 (Sheet 2 of 6)**

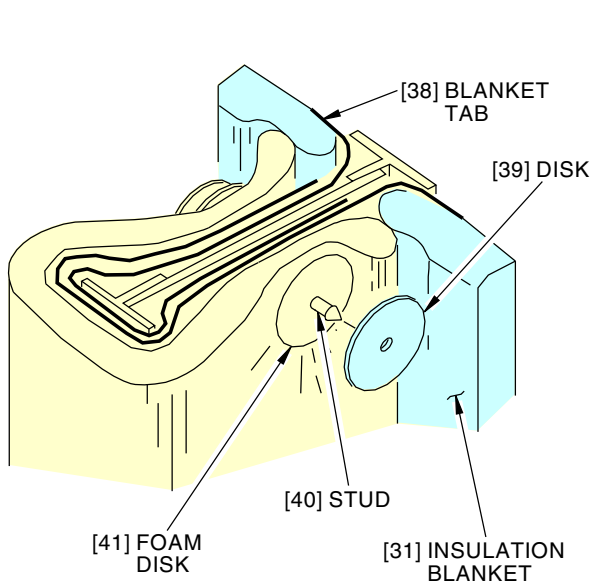
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ARO ALL

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25-80-00

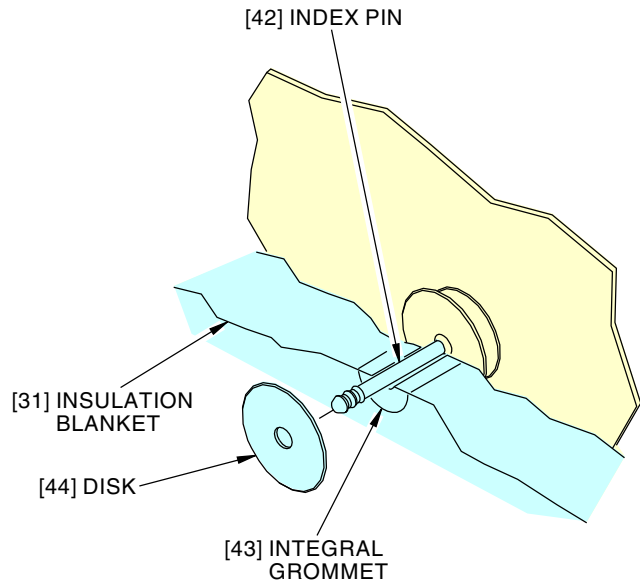
Page 409
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



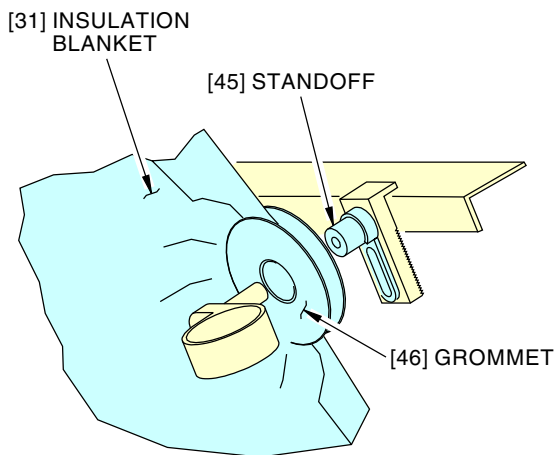
STUD ATTACHMENT

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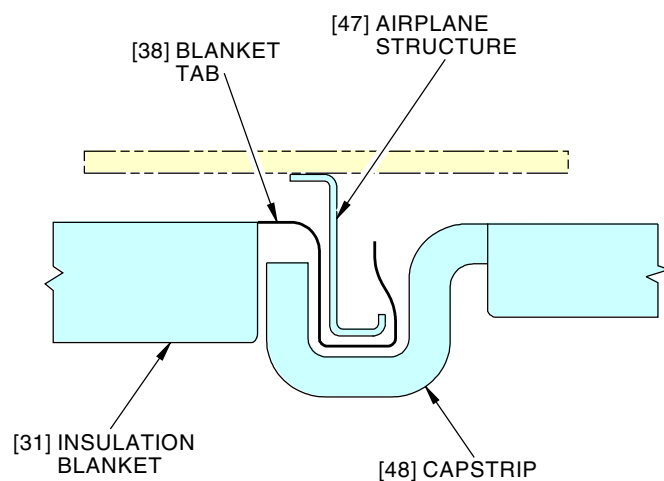
INDEX PIN

E



GROMMET ATTACHMENT

F



A-A

L23745 S0006411601_V2

**Crown Insulation Blanket Installation
Figure 402/25-80-00-990-805 (Sheet 3 of 6)**

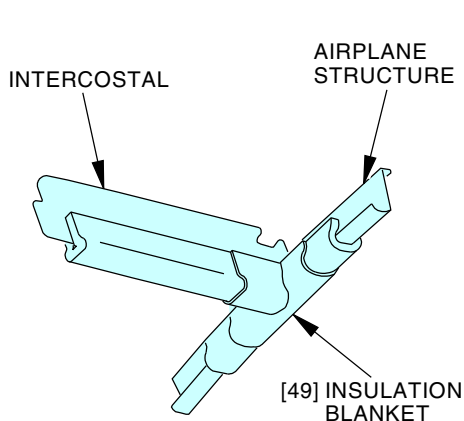
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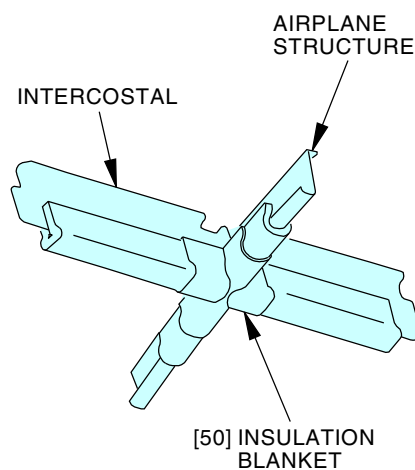
Page 410
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



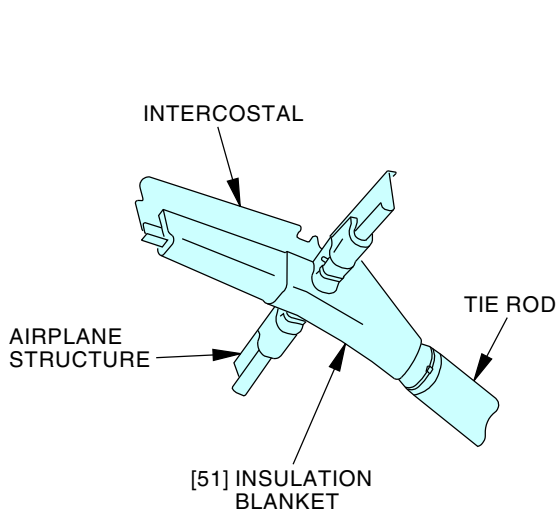
**INTERCOSTAL MOISTURE
CONTROL BLANKET
(SINGLE INTERCOSTAL)**

G



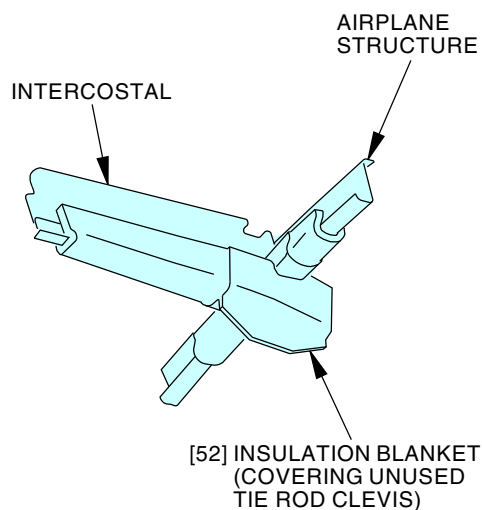
**INTERCOSTAL MOISTURE
CONTROL BLANKET
(DOUBLE INTERCOSTAL)**

G



**INTERCOSTAL MOISTURE
CONTROL BLANKET
(WITH TIE ROD)**

G



**INTERCOSTAL MOISTURE
CONTROL BLANKET
(WITHOUT TIE ROD)**

G

L19759 S0006411602_V2

**Crown Insulation Blanket Installation
Figure 402/25-80-00-990-805 (Sheet 4 of 6)**

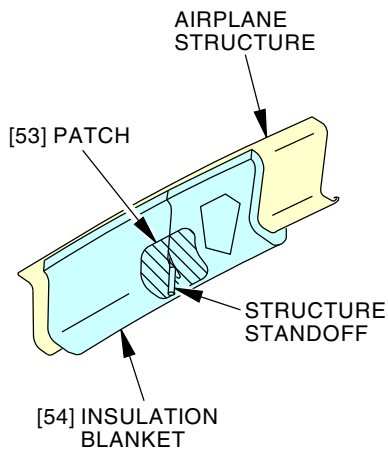
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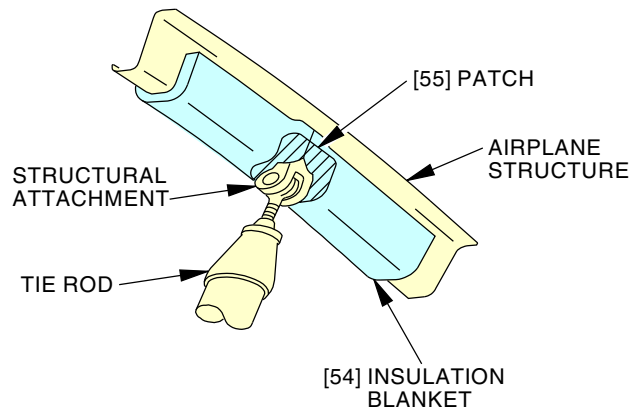
Page 411
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



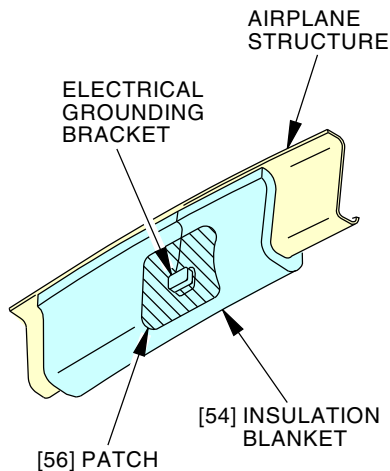
**PLASTIC MOISTURE CONTROL PATCH
(STRUCTURE STANDOFF)**

H



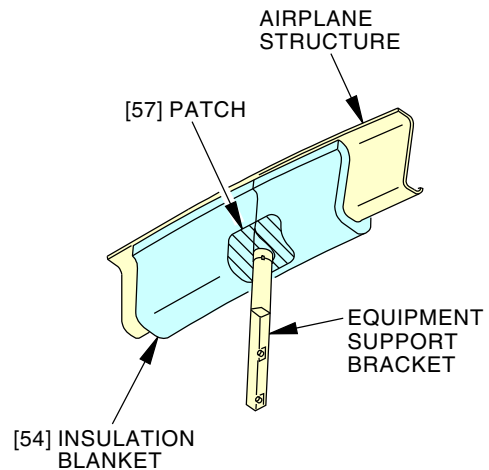
**PLASTIC MOISTURE CONTROL PATCH
(TIE ROD)**

H



**PLASTIC MOISTURE CONTROL PATCH
(ELECTRICAL GROUNDING BRACKET)**

H



**PLASTIC MOISTURE CONTROL PATCH
(EQUIPMENT SUPPORT BRACKET)**

H

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**Crown Insulation Blanket Installation
Figure 402/25-80-00-990-805 (Sheet 5 of 6)**

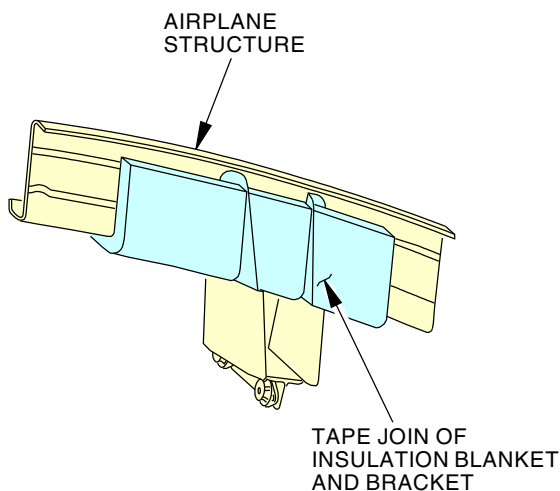
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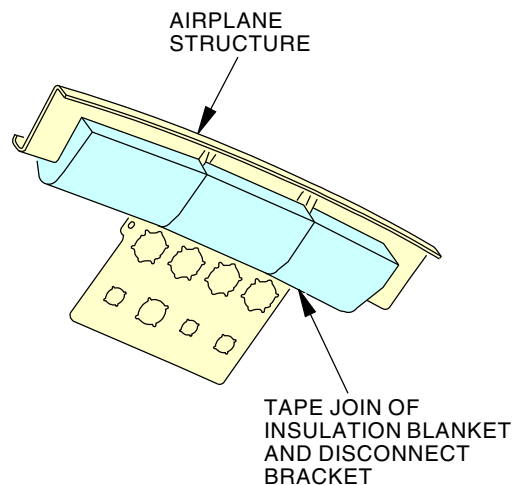
25-80-00

Page 412
Sep 05/2017

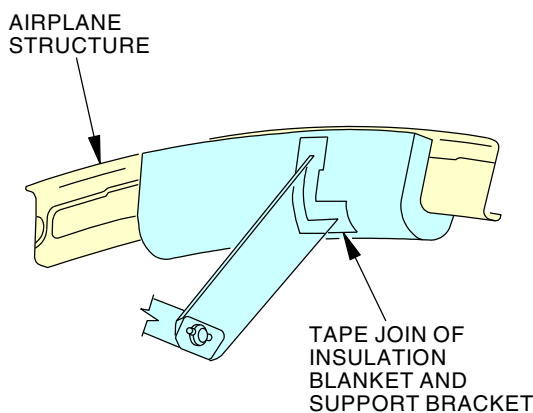
777-200/300
AIRCRAFT MAINTENANCE MANUAL



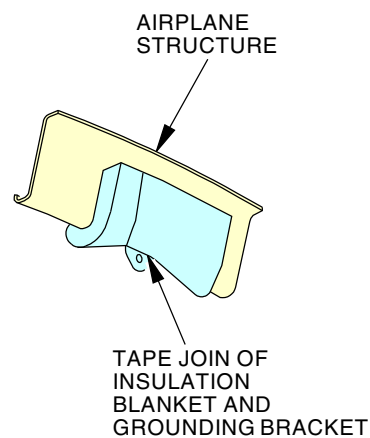
**GAP CLOSURE
(BRACKET)**



**GAP CLOSURE
(DISCONNECT BRACKET)**



**GAP CLOSURE
(SUPPORT BRACKET)**



**GAP CLOSURE
(GROUNDING BRACKET)**



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Crown Insulation Blanket Installation
Figure 402/25-80-00-990-805 (Sheet 6 of 6)

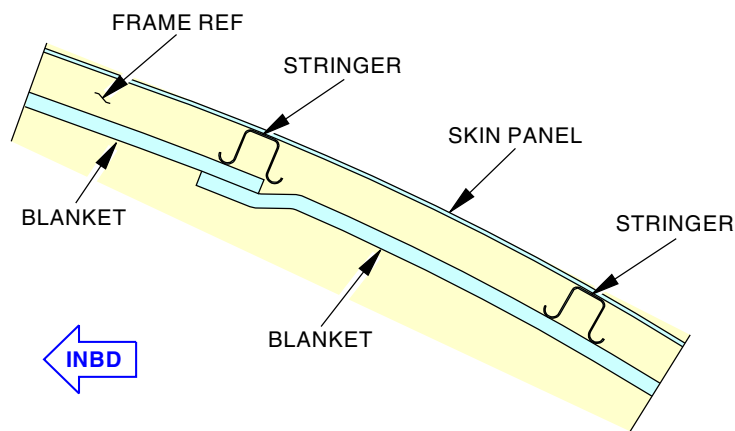
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25-80-00

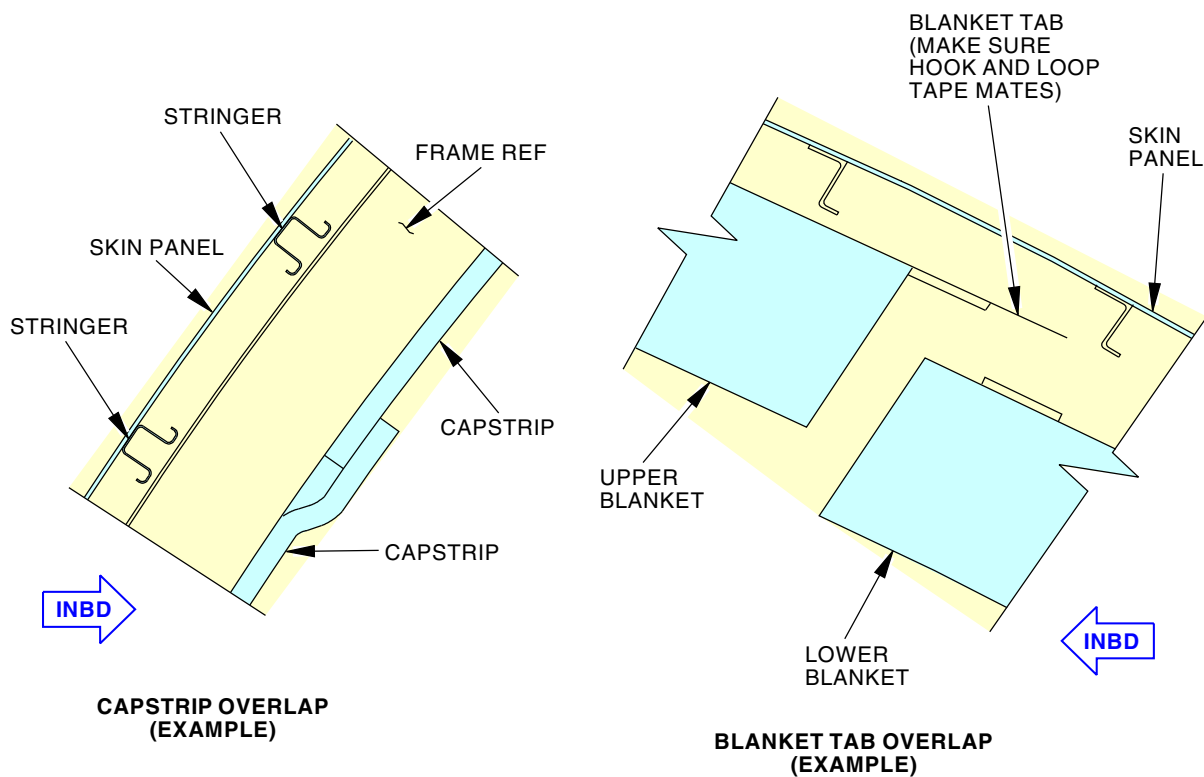
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Page 413
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**BLANKET TO BLANKET INSTALLATION
(EXAMPLE)**



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**Insulation Blanket Overlap
Figure 403/25-80-00-990-808**

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D633W101-ARO

25-80-00



777-200/300 AIRCRAFT MAINTENANCE MANUAL

INSULATION - INSPECTION/CHECK

1. General

A. This procedure has these tasks:

- (1) A check procedure to examine the passenger compartment insulation blankets with its focus on moisture control.
- (2) A check procedure to examine the flight compartment insulation blankets with its focus on moisture control.
- (3) A check procedure to examine the cargo compartment insulation blankets with its focus on moisture control.

TASK 25-80-00-200-801

2. Passenger Compartment Insulation and Moisture Control Check

A. General

- (1) This procedure gives the steps to do a check of the insulation blankets for moisture control. This procedure is applicable to these areas:
 - Aft of the flight compartment, station 246, and back to the aft pressure dome.
 - Interior pressurized areas above the main cabin floor.
 - Thermal blankets that line the sidewall, and ceiling crown areas.
 - Adjacent to windows and door frames.
- (2) When doing this check, be aware of design features that control moisture condensation:
 - (a) Correct installation of thermal blankets, and the use of sealing foam and tape that insulates the cold structure from contact with warm, humid cabin air.
 - (b) Correct application of sealing materials where the blanket is penetrated, or where wires, or structures pass through the blanket.
 - (c) The correct installation of moisture collection trays, for example at the base of intercostals. These assist in evaporation, and prevent saturation of more absorbent parts.
 - (d) Elsewhere, the correct application of moisture guiding tape, for example above the overhead baggage bins.

NOTE: Do not use tape as insulation. Tape does not insulate or prevent moisture condensation.

- (3) Moisture control procedures can help to control a problem that some refer to as "rain in the cabin."

B. References

Reference	Title
25-21-01 P/B 401	SIDEWALL PANEL - REMOVAL/INSTALLATION
25-21-02 P/B 401	DOORWAY LINING - REMOVAL/INSTALLATION
25-21-06 P/B 401	MAIN CEILING PANEL - REMOVAL/INSTALLATION
25-21-07 P/B 401	LOWERED CEILING PANEL - REMOVAL/INSTALLATION
25-80-00 P/B 401	INSULATION - REMOVAL/INSTALLATION
25-80-00 P/B 801	INSULATION - REPAIRS
25-80-00-990-802	Figure: Sidewall Insulation Blanket Installation (P/B 401)
25-80-00-990-803	Figure: Blanket Overlap (P/B 801)
25-80-00-990-805	Figure: Crown Insulation Blanket Installation (P/B 401)

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

Page 601
May 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Title
25-80-00-990-808	Figure: Insulation Blanket Overlap (P/B 401)
AIPC 25-82-00	PASSENGER COMPARTMENT INSULATION

C. Location Zones

Zone	Area
220	Subzone 220 - Section 41
230	Subzone 230 - Section 43
240	Subzone 240 - Section 44
250	Subzone 250 - Section 46
260	Subzone 260 - Section 47

D. Prepare for Insulation and Moisture Control Check

SUBTASK 25-80-00-010-002

- (1) If necessary, get access to specific area or section. Remove the applicable passenger compartment panels:
 - (a) Remove the applicable sidewall linings, (PAGEBLOCK 25-21-01/401).
 - (b) Remove the applicable doorway linings (PAGEBLOCK 25-21-02/401).
 - (c) Remove the applicable ceiling panels (PAGEBLOCK 25-21-06/401, or PAGEBLOCK 25-21-07/401).

E. Insulation and Moisture Control Check - Procedure

SUBTASK 25-80-00-820-003

- (1) When you have access to individual blankets before installation, examine each blanket one at a time.
 - (a) Make sure each blanket is serviceable:
 - 1) Make sure the cover is not torn, and has no other damage.
 - 2) Make sure attachment points and taped edges are not damaged.
 - 3) Make sure drains and vents are open.
 - (b) If you find a problem, then do the corrective action (PAGEBLOCK 25-80-00/801).

SUBTASK 25-80-00-820-004

- (2) Before blanket installation, examine the installation area as follows (PAGEBLOCK 25-80-00/401; Figure 25-80-00-990-802, Figure 25-80-00-990-805).
 - (a) Examine the airplane structure to make sure drain holes and drainage paths are not blocked, or filled with corrosion inhibiting compound.
 - (b) Examine the installation area and make sure that all index pins are serviceable.
 - 1) Examine bonded index pins.
 - 2) Examine stand-off (or, clip-on) index pins.
 - (c) Examine structural attachment points (that is, brackets, tie rods, struts and supports).
 - 1) Make sure that structural members are wrapped and secure.
 - (d) If you find a problem, then do the corrective action.

SUBTASK 25-80-00-860-001

- (3) After blanket installation, for sidewall and crown (or, ceiling), examine the installation as follows.

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

Page 602
May 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Make sure that the correct clamp type is installed at the locations specified by the blanket markings.
 - 1) C-CLAMP
 - 2) LG-CLAMP
 - 3) T-CLAMP.
 - a) You can refer to (AIPC 25-82-00) for additional clamp information.
- (b) Where blankets are pierced or penetrated by index pins, make sure that grommets, tape or felt disks, and washers and fasteners are serviceable.
- (c) When blankets have markings, make sure that installed parts agree with the blanket markings.
- (d) Where blankets overlap, make sure the overlap joint is serviceable (Figure 25-80-00-990-803, Figure 25-80-00-990-808).
 - 1) Make sure that blankets do not show unusual buckles, wrinkles or evidence they're not set correctly.
 - 2) Follow along the edges of each blanket for incorrect overlap or tuck.
 - 3) Make sure that taped seams that join the blankets are sealed correctly.
 - 4) Make sure there are sufficient clamps along the structural parts to prevent blanket movement or abrasion during flight.
- (e) Where a wire, cable, bracket, or other structure passes through the blanket, make sure that a patch, rubber seal, insulation felt, foam or tape are installed correctly for that installation.
 - 1) A correct installation prevents warm, humid cabin air from coming in contact with the cold aircraft structure.
 - a) Typically, void areas at the structure can be filled with felt sheets where each has been rolled up, and bundled using a self-locking strap.
 - b) The bundle is set in place, and the installation is wrapped again and fastened with a self-locking strap.
 - 2) A correct installation does not cause abrasion, binding or interfere with moving parts (for example, tie rods, or control cables).

F. Put the Airplane Back to its Usual Condition

SUBTASK 25-80-00-410-001

- (1) Install the linings and ceiling panels that were removed.
 - (a) Install the applicable sidewall linings, (PAGEBLOCK 25-21-01/401).
 - (b) Install the applicable doorway linings (PAGEBLOCK 25-21-02/401).
 - (c) Install the applicable ceiling panels (PAGEBLOCK 25-21-06/401, and PAGEBLOCK 25-21-07/401).

————— END OF TASK —————

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

Page 603
May 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-80-00-200-802

3. Flight Compartment Insulation and Moisture Control Check

A. General

- (1) This procedure gives the steps to do a check of the insulation blankets for moisture control. This procedure is applicable to these areas:
 - Flight compartment (FC) from the pressure wall (STA 126.5) to the FC partition (STA 246).
 - Interior pressurized areas above the flight compartment floor.
 - Thermal blankets that line the forward firewall, sidewalls, overhead panel, and bulkhead decompression wall areas.
 - Areas adjacent to flight compartment windshield and windows.
- (2) When doing this check, be aware of design features that control moisture condensation:
 - (a) Correct installation of thermal blankets, and the use of sealing foam and tape that insulates the cold structure from contact with warm, humid cabin air.
 - (b) Correct application of sealing materials where the blanket is penetrated, or where wires, or structures pass through the blanket.
 - (c) The correct installation of dripshields.

NOTE: Do not use tape as insulation. Tape does not insulate or prevent moisture condensation.

B. References

Reference	Title
24-22-00-860-805	Supply Electrical Power (P/B 201)
24-22-00-860-806	Remove Electrical Power (P/B 201)
25-11-01-000-801	Captain and First Officer Seat Removal (P/B 401)
25-11-01-400-801	Captain and First Officer Seat - Installation (P/B 401)
25-11-03-000-801	First Observer Seat - Removal (P/B 401)
25-11-03-000-802	Second Observer Seat - Removal (P/B 401)
25-11-03-400-801	First Observer Seat - Installation (P/B 401)
25-11-03-400-802	Second Observer Seat - Installation (P/B 401)
25-15-01-000-801	Side Console - Removal (P/B 401)
25-15-01-400-801	Side Console - Installation (P/B 401)
25-15-02-010-801	Stowage Closet Removal (P/B 401)
25-15-02-400-801	Stowage Closet Installation (P/B 401)
25-15-03-000-801	Forward Console Removal (P/B 401)
25-15-03-400-801	Forward Console Installation (P/B 401)
25-15-05-010-801	Observers Console Removal (P/B 401)
25-15-05-400-801	Observers Console Installation (P/B 401)
25-15-06-000-801	Overhead Lining - Removal (P/B 401)
25-15-06-400-801	Overhead Lining - Installation (P/B 401)
25-80-00 P/B 401	INSULATION - REMOVAL/INSTALLATION
25-80-00-990-802	Figure: Sidewall Insulation Blanket Installation (P/B 401)
25-80-00-990-803	Figure: Blanket Overlap (P/B 801)
25-80-00-990-805	Figure: Crown Insulation Blanket Installation (P/B 401)
25-80-00-990-808	Figure: Insulation Blanket Overlap (P/B 401)

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

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Page 604
May 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Title
AIPC 25-81	FLIGHT COMPARTMENT INSULATION

C. Location Zones

Zone	Area
211	Flight Compartment, Left
212	Flight Compartment, Right

D. Prepare for Insulation and Moisture Control Check

SUBTASK 25-80-00-010-003

- (1) Do these tasks, when necessary:
 - (a) Remove Electrical Power, TASK 24-22-00-860-806
 - (b) Captain and First Officer Seat Removal, TASK 25-11-01-000-801
 - (c) First Observer Seat - Removal, TASK 25-11-03-000-801
 - (d) Second Observer Seat - Removal, TASK 25-11-03-000-802
 - (e) Stowage Closet Removal, TASK 25-15-02-010-801
 - (f) Side Console - Removal, TASK 25-15-01-000-801
 - (g) Observers Console Removal, TASK 25-15-05-010-801
 - (h) Forward Console Removal, TASK 25-15-03-000-801
 - (i) Overhead Lining - Removal, TASK 25-15-06-000-801.

E. Flight Compartment Insulation and Moisture Control Check - Procedure

SUBTASK 25-80-00-210-016

- (1) When you have access to individual blankets before installation, examine each blanket one at a time.
 - (a) Make sure each blanket is serviceable:
 - 1) Make sure the cover is not torn, and has no other damage.
 - 2) Make sure attachment points and taped edges are not damaged.
 - 3) Make sure drains and vents are open.
 - 4) Make sure grommets, felt disks or washers agree with the blanket markings.
 - 5) If there is dust, lint or other loose debris on the insulation blanket, use a vacuum cleaner or a non-metallic soft brush to remove the contamination.

SUBTASK 25-80-00-210-018

- (2) Before blanket installation, examine the installation area as follows (PAGEBLOCK 25-80-00/401; Figure 25-80-00-990-802, Figure 25-80-00-990-805).
 - (a) Examine the airplane structure to make sure drain holes and drainage paths are not blocked, or filled with corrosion inhibiting compound.
 - (b) Examine the installation area and make sure that all index pins are serviceable.
 - 1) Examine bonded index pins.
 - 2) Examine stand-off (or, clip-on) index pins.
 - (c) Examine structural attachment points (that is, brackets, tie rods, struts and supports).
 - 1) Make sure that structural members are wrapped and secure.
 - (d) If you find a problem, then do the corrective action.

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

Page 605
May 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-80-00-210-019

- (3) After blanket installation, for sidewalls, overhead and bulkhead areas, examine the installation as follows.
- (a) Make sure that the correct clamp type is installed at the locations specified by the blanket markings.
 - 1) C-CLAMP (or, frame clip).
 - a) You can refer to (AIPC 25-81) for additional information.
 - (b) Where blankets are pierced or penetrated by index pins, make sure that grommets, tape or felt disks, and washers and fasteners are serviceable.
 - (c) When blankets have markings, make sure that the installation and blanket markings agree.
 - (d) Where blankets overlap, make sure the overlap joint is serviceable (Figure 25-80-00-990-803, Figure 25-80-00-990-808).
 - 1) Make sure that blankets do not show unusual buckles, wrinkles or evidence they're not set correctly.
 - 2) Follow along the edges of each blanket for incorrect overlap or tuck.
 - 3) Make sure that taped seams that join the blankets are sealed correctly.
 - 4) Make sure there are sufficient clamps along the structural parts to prevent blanket movement or abrasion during flight.
 - (e) Where a wire, cable, bracket, or other structure passes through the blanket, make sure that a patch, rubber seal, insulation felt, foam or tape are installed correctly for that installation.
 - 1) A correct installation prevents warm, humid cabin air from coming in contact with the cold aircraft structure.
 - a) Typically, void areas at the structure can be filled with felt sheets where each has been rolled up, and bundled using a self-locking strap.
 - b) The bundle is set in place, and the installation is wrapped again and fastened with a self-locking strap.
 - 2) A correct installation does not cause abrasion, binding or interfere with moving parts (for example, tie rods, or control cables).

F. Put the Airplane Back to its Usual Condition

SUBTASK 25-80-00-410-002

- (1) Do these tasks, as necessary:
- (a) Overhead Lining - Installation, TASK 25-15-06-400-801.
 - (b) Forward Console Installation, TASK 25-15-03-400-801.
 - (c) Observers Console Installation, TASK 25-15-05-400-801.
 - (d) Side Console - Installation, TASK 25-15-01-400-801.
 - (e) Stowage Closet Installation, TASK 25-15-02-400-801.
 - (f) Second Observer Seat - Installation, TASK 25-11-03-400-802.
 - (g) First Observer Seat - Installation, TASK 25-11-03-400-801.
 - (h) Captain and First Officer Seat - Installation, TASK 25-11-01-400-801.
 - (i) Supply Electrical Power, TASK 24-22-00-860-805.

————— END OF TASK —————

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

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Page 606
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-80-00-200-803

4. Cargo Compartment Insulation and Moisture Control Check

A. General

- (1) This procedure gives the steps to do a check of the insulation blankets for moisture control. This procedure is applicable to these areas:
 - Aft of the E/E bay, station 246, and back to the aft pressure dome.
 - Interior pressurized areas below the main cabin floor.
 - Thermal blankets that line the sidewall, and belly areas.
 - Adjacent to cargo doors and frames.
 - (2) When doing this check, be aware of design features that control moisture condensation:
 - (a) Correct installation of thermal blankets, and the use of sealing foam and tape that insulates the cold structure from contact with warm, humid cabin air.
 - (b) Correct application of sealing materials where the blanket is penetrated, or where wires, or structures pass through the blanket.
 - (c) The correct installation of moisture collection trays, for example at the base of intercostals. These assist in evaporation, and prevent saturation of more absorbent parts.
- NOTE:** Do not use tape as insulation. Tape does not insulate or prevent moisture condensation.
- (3) Moisture control procedures can help to control a problem that some refer to as "rain in the cabin."

B. References

Reference	Title
25-52-03 P/B 401	BULK CARGO COMPARTMENT CARGO NET - REMOVAL/INSTALLATION
25-52-06 P/B 401	SIDEWALL LINERS - REMOVAL/INSTALLATION
25-52-09 P/B 401	CEILING LINER - REMOVAL/INSTALLATION
25-52-10 P/B 401	FLOOR PANELS AND WALKWAYS - REMOVAL/INSTALLATION
25-52-11 P/B 401	BULK CARGO FLOOR - REMOVAL/INSTALLATION
25-52-18 P/B 401	AFT CARGO COMPARTMENT- FORWARD END WALL - REMOVAL/INSTALLATION
25-52-19 P/B 401	BULK CARGO COMPARTMENT - AFT END WALL - REMOVAL/INSTALLATION
25-80-00 P/B 401	INSULATION - REMOVAL/INSTALLATION
25-80-00 P/B 801	INSULATION - REPAIRS
25-80-00-400-801	Insulation Blanket - Installation (P/B 401)
25-80-00-990-802	Figure: Sidewall Insulation Blanket Installation (P/B 401)
25-80-00-990-803	Figure: Blanket Overlap (P/B 801)
25-80-00-990-808	Figure: Insulation Blanket Overlap (P/B 401)
AIPC 25-85-00	CARGO COMPARTMENT INSULATION

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

Page 607
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

Reference	Description
SPL-1988	Barrier - Safety, Large Cargo Door Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363

D. Location Zones

Zone	Area
121	Forward Cargo Compartment, Left
122	Forward Cargo Compartment, Right
151	Aft Cargo Compartment, Left
152	Aft Cargo Compartment, Right
161	Bulk Cargo Compartment, Left
162	Bulk Cargo Compartment, Right

E. Prepare for Insulation and Moisture Control Check

SUBTASK 25-80-00-840-002

- (1) Install the cargo door safety barrier across the cargo door opening. large cargo door safety barrier, SPL-1988

SUBTASK 25-80-00-010-004

- (2) If necessary, get access to the specific area or section. Remove the applicable cargo compartment equipment:
 - (a) BULK CARGO COMPARTMENT CARGO NET - REMOVAL/INSTALLATION, PAGEBLOCK 25-52-03/401.
 - (b) BULK CARGO FLOOR - REMOVAL/INSTALLATION, PAGEBLOCK 25-52-11/401.
 - (c) BULK CARGO COMPARTMENT - AFT END WALL - REMOVAL/INSTALLATION, PAGEBLOCK 25-52-19/401.
 - (d) SIDEWALL LINERS - REMOVAL/INSTALLATION, PAGEBLOCK 25-52-06/401.
 - (e) CEILING LINER - REMOVAL/INSTALLATION, PAGEBLOCK 25-52-09/401.
 - (f) FLOOR PANELS AND WALKWAYS - REMOVAL/INSTALLATION, PAGEBLOCK 25-52-10/401.
 - (g) AFT CARGO COMPARTMENT- FORWARD END WALL - REMOVAL/INSTALLATION, PAGEBLOCK 25-52-18/401.

F. Insulation and Moisture Control Check - Procedure

SUBTASK 25-80-00-210-020

- (1) When you have access to individual blankets before installation, examine each blanket one at a time.
 - (a) Make sure each blanket is serviceable:
 - 1) Make sure the cover is not torn, and has no other damage.
 - 2) Make sure attachment points and taped edges are not damaged.
 - 3) Make sure drains and vents are open.
 - (b) If you find a problem, then do the corrective action (PAGEBLOCK 25-80-00/801).

SUBTASK 25-80-00-210-021

- (2) Before blanket installation, examine the installation area as follows (Insulation Blanket - Installation, TASK 25-80-00-400-801).

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

Page 608
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (a) Examine the airplane structure to make sure drain holes and drainage paths are not blocked, or filled with corrosion inhibiting compound.
- (b) Examine the installation area and make sure that all index pins are serviceable.
 - 1) Examine bonded index pins.
 - 2) Examine stand-off (or, clip-on) index pins.
- (c) Examine structural attachment points (that is, brackets, tie rods, struts and supports).
 - 1) Make sure that structural members are wrapped and secure.
- (d) If you find a problem, then do the corrective action.

SUBTASK 25-80-00-210-022

- (3) After blanket installation, for sidewall and crown (or, ceiling), examine the installation as follows.
 - (a) Make sure that the correct clamp type is installed at the locations specified by the blanket markings.
 - 1) C-CLAMP
 - 2) LG-CLAMP
 - 3) T-CLAMP.
 - a) You can refer to (AIPC 25-85-00) for additional clamp information.
 - (b) Where blankets are pierced or penetrated by index pins, make sure that grommets, tape or felt disks, and washers and fasteners are serviceable.
 - (c) When blankets have markings, make sure that installed parts agree with the blanket markings.
 - (d) Where blankets overlap, make sure the overlap joint is serviceable (PAGEBLOCK 25-80-00/401; Figure 25-80-00-990-802, Figure 25-80-00-990-803, Figure 25-80-00-990-808).
 - 1) Make sure that blankets do now show unusual buckles, wrinkles or evidence they're not set correctly.
 - 2) Follow along the edges of each blanket for incorrect overlap or tuck.
 - 3) Make sure that taped seams that join the blankets are sealed correctly.
 - 4) Make sure there are sufficient clamps along the structural parts to prevent blanket movement or abrasion during flight.
 - (e) Where a wire, cable, bracket, or other structure passes through the blanket, make sure that a patch, rubber seal, insulation felt, foam or tape are installed correctly for that installation.
 - 1) A correct installation prevents warm, humid cabin air from coming in contact with the cold aircraft structure.
 - a) Typically, void areas at the structure can be filled with felt sheets where each has been rolled up, and bundled using a self-locking strap.
 - b) The bundle is set in place, and the installation is wrapped again and fastened with a self-locking strap.
 - 2) A correct installation does not cause abrasion, binding or interfere with moving parts (for example, tie rods, or control cables).

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

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Page 609
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

G. Put the Airplane Back to its Usual Condition

SUBTASK 25-80-00-410-003

- (1) Install the cargo floors, liners, panels and other equipment that was removed.
 - (a) BULK CARGO COMPARTMENT CARGO NET - REMOVAL/INSTALLATION, PAGEBLOCK 25-52-03/401.
 - (b) BULK CARGO FLOOR - REMOVAL/INSTALLATION, PAGEBLOCK 25-52-11/401.
 - (c) BULK CARGO COMPARTMENT - AFT END WALL - REMOVAL/INSTALLATION, PAGEBLOCK 25-52-19/401.
 - (d) SIDEWALL LINERS - REMOVAL/INSTALLATION, PAGEBLOCK 25-52-06/401.
 - (e) CEILING LINER - REMOVAL/INSTALLATION, PAGEBLOCK 25-52-09/401.
 - (f) FLOOR PANELS AND WALKWAYS - REMOVAL/INSTALLATION, PAGEBLOCK 25-52-10/401.
 - (g) AFT CARGO COMPARTMENT- FORWARD END WALL - REMOVAL/INSTALLATION, PAGEBLOCK 25-52-18/401.

SUBTASK 25-80-00-840-003

- (2) Remove the cargo door safety barrier. large cargo door safety barrier, SPL-1988

————— END OF TASK —————

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

Page 610
Sep 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

INSULATION - REPAIRS

1. General

- A. This procedure has these tasks:
- (1) Repair of the Insulation Blanket that has BMS8-396 Cover Material
 - (2) Repair of the Insulation Blanket that has BMS8-380 Cover Material
 - (3) Insulation Blanket Manufacturing.
 - (4) Moisture Damaged Insulation Blanket Repair.
- B. This procedure is applicable for insulation blankets in all compartments.
- C. The use of BMS 8-39 Urethane foam for replacement or repair of insulation in areas where it is used to prevent fire or smoke penetration is not permitted due to the degradation in flammability properties over time.
- D. BMS8-371 insulation foam or BMS1-68 silicone foam rubber replaces BMS8-39 Urethane foam in areas where it is used to prevent fire or smoke penetration. The selection of either BMS8-371 or BMS1-68 material will be based on requirements for use and its location in the airplane. BMS8-39 foam is replaced in areas of the airplane where it is not easy to access for fire and smoke detection or suppression. The BMS8-39 foam is also replaced in areas where it is used to prevent fire or smoke penetration. It is not replaced in areas where it is encapsulated by a protective fire resistant barrier or where it is physically isolated from an ignition source.
- NOTE: Foam pads installed at insulation blanket penetrations and foam seals around systems penetrations are affected by AD 2013-11-04.
- E. Refer to PAGEBLOCK 53-17-00/201 for flight compartment and cargo compartment foam Urethane foam identification and replacement.

TASK 25-80-00-340-809

2. Repair of the Insulation Blanket that has BMS8-396 Cover Material

A. **General**

- (1) This procedure has instructions to repair insulation blankets that have the BMS8-396 fire resistant barrier.

B. **References**

Reference	Title
25-80-00-000-801	Insulation Blanket Removal (P/B 401)
25-80-00-400-801	Insulation Blanket - Installation (P/B 401)

C. **Tools/Equipment**

Reference	Description
STD-126	Brush - Soft-bristle, Non-metallic
STD-6636	Vacuum Cleaner - wet and dry type

D. **Consumable Materials**

Reference	Description	Specification
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00086	Insulation - Thermal-Acoustical Fiberglass (Water-Repellant, Punk-Resistant Fiberglass Batting)	BMS8-48 Type III

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

Page 801
Sep 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description	Specification
G02470	Foam - Flexible Polyimide	BMS8-300 Type I
G50329	Fabric - High Mass Coated, Flame Propagation Resistant	BMS8-374
G50330	Fabric - Insulation Covering, Flame Propagation Resistant	BMS8-377
G50333	Tape - Hook/Loop Fastener, Flame Propagation Resistant	BMS8-372
G50520	Foam - Melamine with laminated cover film (PEKK) & Type 2 high mass fabric.	BMS8-385 Type 2 Grade 1
G50606	Cover - Insulation, Polyetherketoneketone (PEKK) - Flame Propagation Resistant	BMS8-380 Type 2 Class 2
G50779	Material - Insulation Flame Penetration Resistant, Barrier Covering	BMS8-396
G50789	Tape - Adhesive Insulation Blanket	BMS5-157 Type I Class 2 Grade C Composition MPEEK

E. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

F. Prepare to Repair the Insulation Blanket

SUBTASK 25-80-00-210-007

- (1) Visually check the amount of damage to the insulation blanket.
 - (a) If the amount of damage is more than 25 percent of the total area on either the front side or back side of the insulation blanket, replace the insulation blanket. Do these tasks:
 - 1) Insulation Blanket Removal, TASK 25-80-00-000-801
 - 2) Insulation Blanket - Installation, TASK 25-80-00-400-801
 - (b) If the amount of damage is less than 25 percent of the total area on either the front side or back side of the insulation blanket, continue.

SUBTASK 25-80-00-210-009



WARNING

DO NOT USE DETERGENTS OR SOLVENTS TO CLEAN THE INSULATION BLANKET. IT CAN REMOVE FLAME RETARDANTS AND CAUSE FLAMMABLE RESIDUES ON THE INSULATION BLANKET WHICH INCREASES THE RISK OF FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (2) If there is Corrosion-inhibiting Compounds (CIC) contamination, oily or waxy substances or other fluids (which typically changes the color and appearance of the insulation blanket cover), replace the insulation blanket.

SUBTASK 25-80-00-210-010

- (3) If there is dust, lint or other loose debris on the insulation blanket, use a vacuum cleaner, STD-6636 or a non-metallic soft-bristle non-metallic brush, STD-126 to remove the contamination.

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

Page 802
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-80-00-210-011

- (4) If there is delamination specific to the BMS8-396 material then do the repair listed below.

NOTE: Delamination is damage that may occur to the outer most layer of the BMS8-396 build-up and does not penetrate through the core ceramic paper.

SUBTASK 25-80-00-210-012

- (5) Make sure the repair area is clean and dry.

G. Repair the Insulation Blanket that has the BMS 8-396 Fire Resistant Barrier

SUBTASK 25-80-00-350-027

- (1) To repair a grommet hole in the insulation blanket, do these steps:
- Make two round tape patches from tape, G50789 (BMS5-157) that are a minimum of 1.5 in. (38.1 mm) to 2 in. (51 mm) larger than the grommet hole.
 - Make a fiberglass plug from fiberglass batting insulation, G00086 (BMS8-48) that is equivalent in type/class/grade as those used in the insulation blanket.
 - Put the fiberglass plug into the grommet hole.
 - Put the round tape patches over the grommet hole on both sides of the insulation blanket.
 - Make sure the tape patch overlaps the edge of the grommet hole by a minimum of 0.75 in. (19.05 mm).
 - Push on the tape patch to make sure there is a good bond with the insulation blanket cover.

SUBTASK 25-80-00-020-004

- (2) To remove a line of stitching do these steps:
- Remove the thread from the line of stitching.
 - Cover the affected area with tape, G50789.

SUBTASK 25-80-00-350-028

- (3) To replace snaps with hook and loop tape, do these steps:
- Remove the snaps.

NOTE: Be careful to do as little damage as is possible to the blanket material.
 - Cover all of the snap holes with tape, G50789.
 - Cover both sides of the blanket if it is necessary.
 - Install the tape, G50333.

NOTE: Apply the tape using normal fabrication methods.

SUBTASK 25-80-00-350-029

- (4) To repair a tear in the insulation material, G50779, do these steps:
- Clean the area with a cotton wiper, G00034 wet with solvent, B00184.
 - Dry the area with a cotton wiper, G00034
 - Make a round tape patch from tape, G50789 (BMS5-157) that is a minimum of 1.5 in. (38.1 mm) to 2 in. (51 mm) larger than the tear.
 - Push on the tape patch to make sure there is a good bond with the insulation blanket cover.

SUBTASK 25-80-00-350-030

- (5) To repair damage that is larger than a tear in the insulation blanket cover, do these steps:
- Cut a rectangle out of the damaged blanket cover which fully removes the damaged area.

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

Page 803
Jan 05/2015



777-200/300
AIRCRAFT MAINTENANCE MANUAL

- 1) Keep the rectangle cutout as template to make a new replacement cover patch.
- (b) Use the rectangle cutout template to make a rectangle cover patch that is similar in shape and size as the template from fabric, G50330(BMS8-370) or insulation cover, G50606 (BMS8-380).
- (c) If there is damage to the fiberglass batting insulation, G00086 (BMS8-48) inside the blanket cover, do these steps:
 - 1) If the damaged area is only on the first layer of the fiberglass batting, do these steps:
 - a) Cut a rectangle out of the damaged fiberglass batting to fully remove the damaged area on the first layer of the fiberglass batting, and leave behind a rectangular void in the blanket.
 - b) Cut a ply of replacement fiberglass patch from fiberglass batting insulation, G00086 (BMS8-48) that extends a minimum of 2 in. (51 mm) past the edges of the rectangular void.
 - c) Put the replacement fiberglass patch over the center of the rectangular void and under the blanket cover.
 - 2) If the damaged area is on multiple layers of the fiberglass batting, do these steps:
 - a) Cut out the damaged fiberglass batting to fully remove the damaged area.
 - b) Interleave new plies of fiberglass batting from fiberglass batting insulation, G00086 (BMS8-48) that is equivalent in type/class/grade as those used in the insulation blanket, as necessary
- (d) Put the rectangle cover patch over the cutout on the insulation blanket cover.
- (e) Make a tape patch from tape, G50789 (BMS5-157) that is a minimum of 1 in. (25 mm) larger than all sides of the rectangle cutout.
 - 1) Make sure the corners on the tape patch are rounded.
- (f) Put the tape patches over the joints to keep the rectangle cover patch in place on all sides.
 - 1) Make sure the tape patch overlaps the joint by a minimum of 1 in. (25 mm) on all sides.
- (g) Push on the tape patch to make sure there is a good bond with the insulation blanket cover.
- (h) Install external garment tags, spaced at 6 in. (152 mm) onto the overlapped fiberglass repair area to keep the fiberglass batting in position between the covers.
 - 1) Cut a 1 in. (25 mm) diameter circle of tape from tape, G50789 (BMS5-157) for use as reinforcement tape.
 - 2) Put the reinforcement tape over the area where the external garment tag is to be stapled through on both sides of the blanket.
 - 3) Staple the external garment tag through all layers of the insulation blanket, which includes the reinforcement tapes.
 - 4) Cut a 2 in. (51 mm) diameter circle of tape from tape, G50789 (BMS5-157) for use as covering tape.
 - 5) Put the covering tape over the external garment tag and reinforcement tape onto the insulation cover on both sides of the insulation blanket.
 - 6) Push on the tape to make sure there is a good bond with the insulation blanket cover.

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

Page 804
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-80-00-350-031

- (6) To repair delamination of the cover material, do these steps:

NOTE: There is no limit to the delamination area repair. Apply the tape patch to any damaged area.

- (a) Make sure that the damage is limited to the outermost film only.
- (b) Make a tape patch from tape, G50789 that is a minimum of 1 in. (25 mm) to 1.5 in. (38.1 mm) beyond the damaged area in all directions.
- (c) Apply the tape to the damaged area.

SUBTASK 25-80-00-350-032

- (7) To repair the foam insulation, G50520 do these steps:

- (a) Fabricate an extension piece of the foam insulation, G02470.
- (b) The original damaged foam may be used as a template.
- (c) Remove the end tab made from fabric, G50329 before joining the new extension piece.
- (d) Butt the extension piece to the end of the remaining foam section,
 - 1) Make sure that the new extension piece has a tab on the end.
- (e) Apply the tape, G50789 to the joint on both sides.
 - 1) Make sure that the tape is at least 20 in. (51 cm) wide.

————— **END OF TASK** —————

TASK 25-80-00-340-810

3. Repair of the Insulation Blanket that has BMS8-380 Cover Material

A. General

- (1) This procedure has instructions to repair insulation blankets that have the BMS 8-380 fire resistant barrier.

B. References

Reference	Title
25-80-00-000-801	Insulation Blanket Removal (P/B 401)
25-80-00-400-801	Insulation Blanket - Installation (P/B 401)

C. Tools/Equipment

Reference	Description
STD-126	Brush - Soft-bristle, Non-metallic
STD-6636	Vacuum Cleaner - wet and dry type

D. Consumable Materials

Reference	Description	Specification
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5 Class A
G00086	Insulation - Thermal-Acoustical Fiberglass (Water-Repellant, Punk-Resistant Fiberglass Batting)	BMS8-48 Type III
G50333	Tape - Hook/Loop Fastener, Flame Propagation Resistant	BMS8-372

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

Page 805
Sep 05/2015

777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description	Specification
G50606	Cover - Insulation, Polyetherketoneketone (PEKK) - Flame Propagation Resistant	BMS8-380 Type 2 Class 2
G50789	Tape - Adhesive Insulation Blanket	BMS5-157 Type I Class 2 Grade C Composition MPEEK

E. Location Zones

Zone	Area
100	Lower Half of Fuselage

F. Prepare to Repair the Insulation Blanket

SUBTASK 25-80-00-210-013

- (1) Visually check the amount of damage to the insulation blanket.
 - (a) If the amount of damage is more than 25 percent of the total area on either the front side or back side of the insulation blanket, replace the insulation blanket. Do these tasks:
 - 1) Insulation Blanket Removal, TASK 25-80-00-000-801
 - 2) Insulation Blanket - Installation, TASK 25-80-00-400-801
 - (b) If the amount of damage is less than 25 percent of the total area on either the front side or back side of the insulation blanket, continue.

SUBTASK 25-80-00-210-014



WARNING

DO NOT USE DETERGENTS OR SOLVENTS TO CLEAN THE INSULATION BLANKET. IT CAN REMOVE FLAME RETARDANTS AND CAUSE FLAMMABLE RESIDUES ON THE INSULATION BLANKET WHICH INCREASES THE RISK OF FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (2) If there is Corrosion-inhibiting Compounds (CIC) contamination, oily or waxy substances or other fluids (which typically changes the color and appearance of the insulation blanket cover), replace the insulation blanket.

SUBTASK 25-80-00-210-015

- (3) If there is dust, lint or other loose debris on the insulation blanket, use a vacuum cleaner, STD-6636 or a non-metallic soft-bristle non-metallic brush, STD-126 to remove contamination.

SUBTASK 25-80-00-160-018

- (4) Make sure the repair area is clean and dry.

G. Repair the Insulation Blanket that has the BMS 8-380 Cover Material

NOTE: BMS8-380 cover material is a thin opaque gray plastic film with an open weave scrim on one side and has a grid-like appearance.

SUBTASK 25-80-00-350-033

- (1) To repair a grommet hole in the insulation blanket, do these steps:
 - (a) Make two round tape patches from tape, G50789 (BMS5-157) that are a minimum 1.5 in. (38.1 mm) to 2 in. (51 mm) larger than the grommet hole.
 - (b) Make a fiberglass plug from fiberglass batting insulation, G00086 (BMS8-48) that is equivalent in type/class/grade as those used in the insulation blanket.
 - (c) Put the fiberglass plug into the grommet hole.

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

Page 806
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (d) Put the round tape patches over the grommet hole on both sides of the insulation blanket.
 - 1) Make sure the tape patch overlaps the edge of the grommet hole by a minimum of 0.75 in. (19.05 mm).
- (e) Push on the tape patch to make sure there is a good bond with the insulation blanket cover.

SUBTASK 25-80-00-020-005

- (2) To remove a line of stitching do these steps:
 - (a) Remove the thread from the line of stitching.
 - (b) Cover the affected area with tape, G50789.

SUBTASK 25-80-00-960-003

- (3) To replace snaps with hook and loop tape, do these steps:
 - (a) Remove the snaps.

NOTE: Be careful to do as little damage as is possible to the blanket material.
 - (b) Cover all of the snap holes with tape, G50789.
 - (c) Cover both sides of the blanket if it is necessary.
 - (d) Install the tape, G50333.

NOTE: Apply the tape using normal fabrication methods.

SUBTASK 25-80-00-350-034

- (4) To repair a tear in the insulation cover, G50606, do these steps:
 - (a) Clean the area with a cotton wiper, G00034 wet with solvent, B00184.
 - (b) Dry the area with a cotton wiper, G00034 cotton wiper, G00034.
 - (c) Make a round tape patch from tape, G50789 (BMS5-157) that is a minimum of 0.75 in. (19.05 mm) to 1.5 in. (38.1 mm) larger than the tear on all sides.
 - 1) Make sure the corners on the tape patch are rounded.
 - (d) Put the tape patch over the tear.
 - 1) Make sure the tape patch overlaps the damaged area by 0.75 in. (19.05 mm) to 1.5 in. (38.1 mm) on all sides.
 - (e) Push on the tape patch to make sure there is a good bond with the insulation blanket cover.

SUBTASK 25-80-00-350-035

- (5) To repair damage that is larger than a tear in the insulation blanket cover, do these steps:
 - (a) Cut a rectangle out of the damaged blanket cover which fully removes the damaged area.
 - 1) Keep the rectangle cutout as template to make a new replacement cover patch.
 - (b) Use the rectangle cutout template to make a rectangle cover patch that is similar in shape and size as the template from insulation cover, G50606 (BMS8-380).
 - (c) If there is damage to the fiberglass batting insulation, G00086 (BMS8-48) inside the blanket cover, do these steps:
 - 1) If the damaged area is only on the first layer of the fiberglass batting, do these steps:
 - a) Cut a rectangle out of the damaged fiberglass batting to fully remove the damaged area on the first layer of the fiberglass batting, and leave behind a rectangular void in the blanket.

EFFECTIVITY
ARO ALL

D633W101-ARO

25-80-00

Page 807
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- b) Cut a ply of replacement fiberglass patch from fiberglass batting insulation, G00086 (BMS8-48) that extends a minimum of 2 in. (51 mm) past the edges of the rectangular void.
- c) Put the replacement fiberglass patch over the center of the rectangular void and under the blanket cover.
- 2) If the damaged area is on multiple layers of the fiberglass batting, do these steps:
 - a) Cut out the damaged fiberglass batting to fully remove the damaged area.
 - b) Interleave new plies of fiberglass batting from fiberglass batting insulation, G00086 (BMS8-48) that is equivalent in type/class/grade as those used in the insulation blanket, as necessary.
- (d) Put the rectangle cover patch over the cutout on the insulation blanket cover.
- (e) Make a tape patch from tape, G50789 (BMS5-157) that is a minimum of 1 in. (25 mm) larger than all sides of the rectangle cutout.
 - 1) Make sure the corners on the tape patch are rounded.
- (f) Put the tape patches over the joints to keep the rectangle cover patch in place on all sides.
 - 1) Make sure the tape patch overlaps the joint by a minimum of 1 in. (25 mm) on all sides.
- (g) Push on the tape patch to make sure there is a good bond with the insulation blanket cover.
- (h) Install external garment tags, spaced at 6 in. (152 mm) onto the overlapped fiberglass repair area to keep the fiberglass batting in position between the covers.
 - 1) Cut a 1 in. (25 mm) diameter circle of tape from tape, G50789 (BMS5-157) for use as reinforcement tape.
 - 2) Put the reinforcement tape over the area where the external garment tag is to be stapled through on both sides of the blanket.
 - 3) Staple the external garment tag through all layers of the insulation blanket, which includes the reinforcement tapes.
 - 4) Cut a 2 in. (51 mm) diameter circle of tape from tape, G50789 (BMS5-157) for use as covering tape.
 - 5) Put the covering tape over the external garment tag and reinforcement tape onto the insulation cover on both sides of the insulation blanket.
 - 6) Push on the tape to make sure there is a good bond with the insulation blanket cover.

SUBTASK 25-80-00-350-036

- (6) To replace damaged hook/loop tape, G50333 (BMS8-372) on the insulation blanket cover, do these steps:
 - (a) Carefully removed the damaged part of the hook/loop tape, G50333 from the insulation blanket cover.
 - (b) Clean and dry the adhesive surface left by the removal of the damaged hook/loop tape, G50333.
 - (c) Put a piece of tape, G50789 (BMS5-157) over the area left by the removal of the damaged hook/loop tape, G50333 on both sides of the insulation blanket assembly, if it is necessary.

EFFECTIVITY
ARO ALL

25-80-00

D633W101-ARO

Page 808
Jan 05/2015



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- 1) Make sure the tape is larger than the damaged area on the insulation cover by a minimum of 1 in. (25 mm) on all sides.
- (d) Install the replacement hook/loop tape, tape, G50333 (BMS8-372) at the correct location on the insulation blanket cover

————— **END OF TASK** —————

TASK 25-80-00-340-806

4. Insulation Blanket Manufacturing

(Figure 802)

A. General

- (1) This procedure has instructions to make a new insulation blanket.
- (2) The new insulation blanket can either be cut from the assembly of various component materials, or from a semi-finished insulation blanket strip, that is pre-assembled and built from equivalent component materials that are comparable in type/class/grade as those which are not pre-assembled.
- (3) The damaged insulation blanket can be used as a template to make a new insulation blanket.

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
COM-11573	Installation Tool - Garment Tag Part #: 954885 Supplier: 16956

C. Consumable Materials

Reference	Description	Specification
D50299	Tape - Advanced Insulation Blanket	BMS5-157 Grade A Composition MPVF
G00086	Insulation - Thermal-Acoustical Fiberglass (Water-Repellant, Punk-Resistant Fiberglass Batting)	BMS8-48 Type III
G02470	Foam - Flexible Polyimide	BMS8-300 Type I
G50328	Fabric - Advance Polymer Coated, Flame Propagation Resistant	BMS8-370
G50329	Fabric - High Mass Coated, Flame Propagation Resistant	BMS8-374
G50330	Fabric - Insulation Covering, Flame Propagation Resistant	BMS8-377
G50333	Tape - Hook/Loop Fastener, Flame Propagation Resistant	BMS8-372
G50334	Felt - Needled, Flame Propagation Resistant	BMS8-373
G50341	Thread - Kevlar Sewing (T40), Strip Machine Thread (T60)	A-A-55220 Bonded Tex 40, Tex 60
G50408	Foam - Flexible Polyvinylidene Fluoride	BMS8-371
G50442	Fastener - Garment Tag, Nylon (Avery Dennison Standard T-End Swiftach)	

EFFECTIVITY
ARO ALL

D633W101-ARO

25-80-00

Page 809
May 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description	Specification
G50521	Tape - Advanced Insulation	BMS5-157 Type IV Class 1 Grade A Form 1 MPVF
G50522	Tape - Advanced Insulation	BMS5-157 Type III Class 1 Grade A Form 1 MPVF
G50523	Tape - Advanced Insulation	BMS5-157 Type II Class I Grade A Form 1 PVF
G50606	Cover - Insulation, Polyetherketoneketone (PEKK) - Flame Propagation Resistant	BMS8-380 Type 2 Class 2
G50779	Material - Insulation Flame Penetration Resistant, Barrier Covering	BMS8-396
G50789	Tape - Adhesive Insulation Blanket	BMS5-157 Type I Class 2 Grade C Composition MPEEK

D. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

E. Make a New Insulation Blanket

NOTE: The new insulation blanket can either be cut from the assembly of various component materials, or from a semi-finished insulation blanket strip, that is pre-assembled and built from equivalent component materials that are comparable in type/class/grade as those which are not pre-assembled.

NOTE: Insulation cover, insulation material, G50779 (BMS8-396) must be continuous when used as inboard or outboard covering

SUBTASK 25-80-00-350-018

- (1) To cut out a new insulation blanket from component materials, do these steps:
 - (a) Use the damaged insulation blanket as a template to outline its shape.
 - (b) Cut the applicable insulation cover (or combination of covers):
 - 1) fabric, G50330 (BMS8-377).
 - 2) fabric, G50328 (BMS8-370).
 - 3) fabric, G50329 (BMS8-374).
 - 4) felt, G50334 (BMS8-373).
 - 5) insulation cover, G50606 (BMS8-380).
 - 6) insulation material, G50779 (BMS8-396).
 - (c) Cut the fiberglass insulation fiberglass batting insulation, G00086 (BMS8-48) or the foam insulation, G02470 (BMS8-300).
 - 1) Make sure to use fiberglass insulation fiberglass batting insulation, G00086 (BMS8-48) or foam insulation, G02470 (BMS8-300) that are equivalent in type/class/grade as those in the template.
 - 2) Interleave the fiberglass insulation fiberglass batting insulation, G00086 (BMS8-48) batting or foam insulation, G02470 (BMS8-300), if it is necessary to extend the blanket.

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25-80-00

D633W101-ARO

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Page 810
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

- (d) Put the fiberglass insulation fiberglass batting insulation, G00086 (BMS8-48) or the foam insulation, G02470 (BMS8-300) in between the applicable inboard and outboard insulation covers.

SUBTASK 25-80-00-350-019

- (2) To cut a new insulation blanket from a semi-finished insulation blanket strip, do these steps:
 - (a) Make sure to use a semi-finished insulation blanket strip that is pre-assembled and built from equivalent component materials that are comparable in type/class/grade as those which are not pre-assembled.
 - (b) Use the damaged insulation blanket as a template to outline its shape on the semi-finished insulation blanket strip.
 - (c) Cut the semi-finished insulation blanket strip to the same shape as the template outline.
 - (d) Interleave the fiberglass insulation fiberglass batting insulation, G00086 (BMS8-48) batting or foam insulation, G02470 (BMS8-300), if it is necessary to extend the blanket.

SUBTASK 25-80-00-420-003

- (3) Do these steps to install the external garment tag fastener, G50442 to connect the layers of insulation blanket materials:

NOTE: The garment tag is a commercially available plastic fastener that is stapled through all layers of the insulation blanket and fastened to keep the fiberglass batting inside the insulation blanket in the same position in relation to the blanket covers.

- (a) Use only tape, D50299 (BMS5-157) with fabric, G50330 (BMS8-377).
 - 1) You can use these tapes if necessary: tape, G50521, tape, G50522, or tape, G50523.
- (b) Use only tape, G50789 (BMS8-157) with insulation cover, G50606 (BMS8-380) and insulation material, G50779 (BMS8-396).
- (c) Cut a 1 in. (25 mm) diameter circle of tape, D50299 (BMS5-157) or tape, G50789 (BMS5-157) for use as reinforcement tape.
 - 1) You can use these tapes if necessary: tape, G50521, tape, G50522, or tape, G50523.
- (d) Put the reinforcement tape over the area where the external garment tag fastener, G50442 is to be stapled through on both sides of the blanket.
- (e) Use the garment tag installer, COM-11573 to staple the external garment tag fastener, G50442 through all layers of the insulation blanket, which includes the reinforcement tapes.
 - 1) Make sure to use a garment tag fastener, G50442 of the correct length in relation to the nominal thickness of the insulation blanket, see Table 801.

Table 801/25-80-00-993-803 Table 801 - Insulation Blanket Garment Tag Sizes

Nominal Thickness of Insulation Blanket ^{*[1]}	Garment Tag Length
4.01 in. (101.85 mm) to 7.01 in. (178.05 mm)	3.00 in. (76.20 mm)
2.01 in. (51.05 mm) to 4.00 in. (101.60 mm)	2.00 in. (50.80 mm)
1.26 in. (32.00 mm) to 2.00 in. (50.80 mm)	1.00 in. (25.40 mm)
0.51 in. (12.95 mm) to 1.25 in. (31.75 mm)	0.50 in. (12.70 mm)
0.38 in. (9.65 mm) to 0.50 in. (12.70 mm)	0.25 in. (6.35 mm)

EFFECTIVITY
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25-80-00

D633W101-ARO

Page 811
Sep 05/2017



777-200/300
AIRCRAFT MAINTENANCE MANUAL

Table 801/25-80-00-993-803 Table 801 - Insulation Blanket Garment Tag Sizes (Continued)

Nominal Thickness of Insulation Blanket ^{*[1]}	Garment Tag Length
* This is the total nominal thickness of all layers of raw material used in blankets.	

^{*[1]} This is the total nominal thickness of all layers of raw material used in blankets.

- (f) Cut a 2 in. (51 mm) diameter circle of tape, D50299 (BMS5-157) or tape, G50789 (BMS5-157) for use as covering tape.
 - 1) You can use these tapes if necessary: tape, G50521, tape, G50522, or tape, G50523.
- (g) Put the covering tape over the external garment tag fastener, G50442 and reinforcement tape, onto the insulation cover on both sides of the blanket.
- (h) Push on the tape to make sure there is a good bond with the blanket cover.

SUBTASK 25-80-00-350-020

(4) Do the applicable steps to close the edges and cutouts of the insulation blanket:

(a) Method 1: Sew the edges.

- 1) Fold the cover fabric over the edge of the blanket or wrap a strip of cover fabric over the edge of the blanket as applicable to bind the edge on the blanket.
- 2) Stitch the edge with kevlar sewing thread, G50341 at 4 to 6 stitches per each inch.
- 3) Make sure the stitches go through the edge binding on both sides of the insulation blanket.
- 4) Seal the stitching on the blanket with tape, D50299 (BMS5-157) or tape, G50789 (BMS5-157).
 - a) You can use these tapes if necessary: tape, G50521, tape, G50522, or tape, G50523.

(b) Method 2: Tape the edges.

NOTE: Applicable for BMS8-377, BMS8-380 and BMS8-396 materials only.

- 1) Use tape, D50299 (BMS5-157) for fabric, G50330 (BMS8-377) and tape, G50789 (BMS5-157) for insulation cover, G50606 (BMS8-380) and insulation material, G50779 (BMS8-396) that is sufficiently wide to overlap the top and bottom of the blanket by a minimum of 0.75 in. (19.05 mm).
- 2) You can use these tapes if necessary: tape, G50521, tape, G50522, or tape, G50523.
- 3) Make the edge the same height as the template.

(c) Method 3: Heat-seal the edges.

NOTE: Not all types of fabric can be heat sealed. Fabric that can be heat sealed may be heavier than fabric that cannot be heat sealed. Make sure you use the correct type of fabric. Blanket edges can be heat sealed using a thermal or ultra sonic equipment.

- 1) Hold the top and bottom covers together and heat-seal the edges of the blanket.
- 2) The width of the heat seal must be 0.25 in. (6.35 mm) to 0.5 in. (12.7 mm).

SUBTASK 25-80-00-420-004

(5) Install hook/loop tape, G50333 (BMS8-372), where applicable.

EFFECTIVITY
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25-80-00

D633W101-ARO

Page 812
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-80-00-420-005

- (6) Install water diverter on the insulation blanket with foam, G50408 (BMS8-371) or equivalent, where applicable.

SUBTASK 25-80-00-350-021

- (7) To make a grommet through a hole in the insulation blanket with cover fabric, G50330 (BMS8-377), use tape, D50299 (BMS5-157) only, or fabric, G50330 (BMS8-377) with tape, D50299 (BMS5-157) to bond it to the insulation.
- (a) You can use these tapes if necessary: tape, G50521, tape, G50522, or tape, G50523.

SUBTASK 25-80-00-350-022

- (8) To make a grommet through a hole in the insulation blanket with insulation cover, G50606 (BMS8-380) and insulation material, G50779 (BMS8-396) use tape, G50789 (BMS5-157), or insulation cover, G50606 (BMS8-380) with tape, G50789 to bond it to the insulation blanket.

SUBTASK 25-80-00-350-023

- (9) Do these steps to install vents in the insulation blanket cover fabric, G50330 (BMS8-377):
- (a) Make sure you install the vent so that it opens in the same direction as on the template.
- (b) Cut a hole approximately 1 in. (25 mm) in diameter in the cover fabric.
- (c) Cut a 2 in. (51 mm) circle of tape from tape, D50299 (BMS5-157).
- (d) Remove the release liner from a small part of the circle tape, D50299 (BMS5-157).
- (e) Attach the circle tape, D50299 (BMS5-157) over the hole in the blanket.
- (f) You can use these tapes if necessary: tape, G50521, tape, G50522, or tape, G50523.

SUBTASK 25-80-00-420-006

- (10) Do these steps to install vents in the insulation cover, G50606 (BMS8-380) and insulation material, G50779 (BMS8-396):
- (a) Make sure you install the vent so that it opens in the same direction as on the template.
- (b) Cut a hole approximately 1 in. (25 mm) in diameter in the cover fabric.
- (c) Cut a 2 in. (51 mm) circle of tape from tape, G50789 (BMS5-157).
- (d) Remove the release liner from a small part of the circle tape, G50789 (BMS5-157).
- (e) Attach the circle tape, G50789 (BMS5-157) over the hole in the blanket.

SUBTASK 25-80-00-350-024

- (11) Do these steps to quilt the blanket, where applicable:
- (a) Quilt through all layers of the insulation blanket, from cover to cover with kevlar sewing thread, G50341 at 4 to 6 stitches per inch.
- (b) Make sure the grid size of the quilting is a minimum 1 in. (25 mm) by 1 in. (25 mm) square or larger.
- (c) Apply the applicable strips of tape over the quilting.
- 1) tape, D50299 (BMS5-157) for fabric, G50330 (BMS8-377).
- a) You can use these tapes if necessary: tape, G50521, tape, G50522, or tape, G50523.
- 2) tape, G50789 (BMS5-157) for insulation cover, G50606 (BMS8-380) and insulation material, G50779 (BMS8-396).
- (d) Overlap the strips of tape over both sides of the quilting at 0.75 in. (19.05 mm) intervals.

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D633W101-ARO

25-80-00

Page 813
May 05/2016



777-200/300 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 25-80-00-350-025

- (12) To add drain holes to the insulation blanket, cut 0.5 in. (12.7 mm) diameter drain holes at the bottom edge of the blanket on the inboard side at 2 in. (51 mm) intervals, where applicable.

SUBTASK 25-80-00-350-026

- (13) Add these part information on the inboard side of the completed insulation blanket cover:
- (a) Part Number.
 - (b) Supplier Name.
 - (c) Date of Manufacture.

SUBTASK 25-80-00-840-001



CAUTION

DO NOT COMPRESS THE INSULATION BLANKET BY MORE THAN 50 PERCENT. THIS DECREASES THE THERMAL AND ACOUSTIC PROPERTIES. IF YOU COMPRESS IT TOO MUCH, DAMAGE TO THE INSULATION BLANKET WILL OCCUR.

- (14) Put the insulation blanket in a neat stack on a shelf or in a bag for shipping.

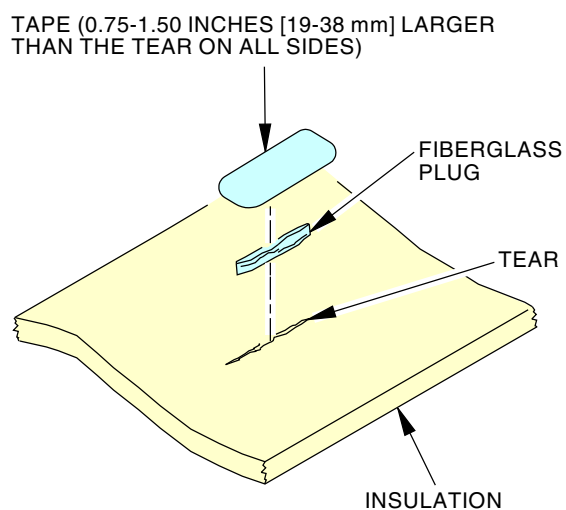
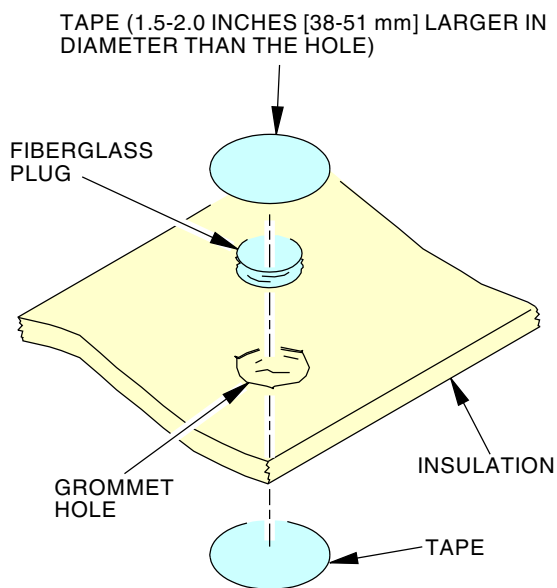
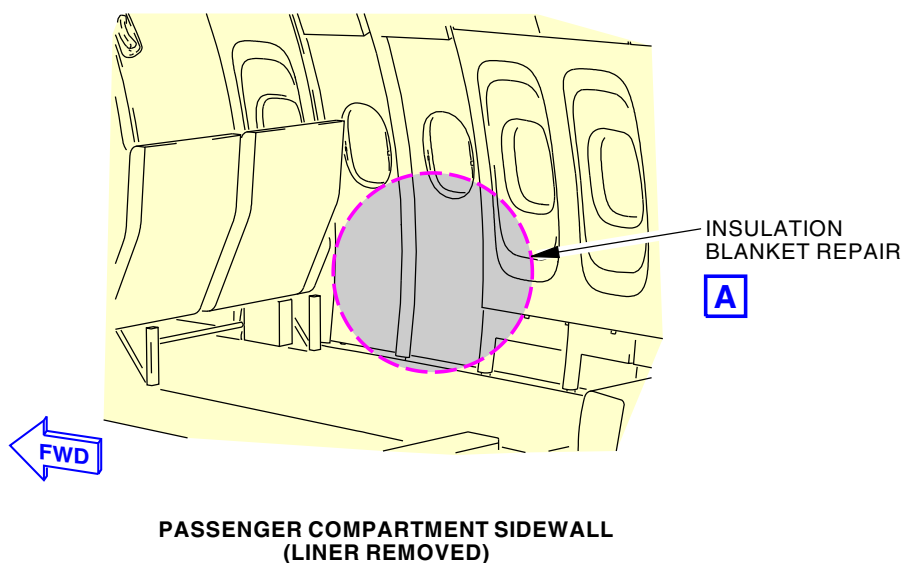
————— **END OF TASK** —————

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25-80-00

D633W101-ARO

Page 814
Sep 05/2017



**INSULATION BLANKET REPAIR
(EXAMPLE)**

A

C85266 S0006411609_V4

**Insulation Blanket Repair
Figure 801/25-80-00-990-811 (Sheet 1 of 2)**

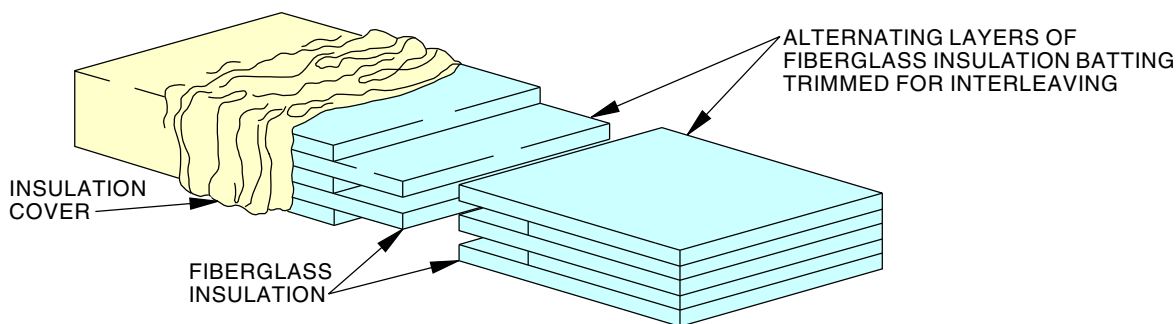
EFFECTIVITY
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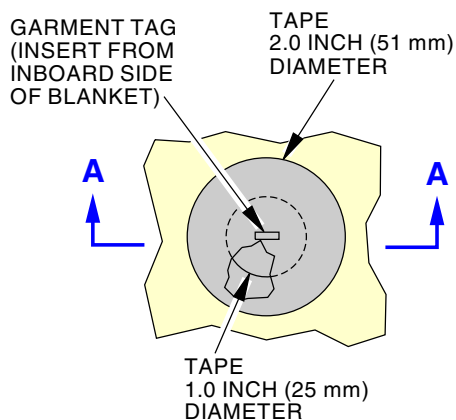
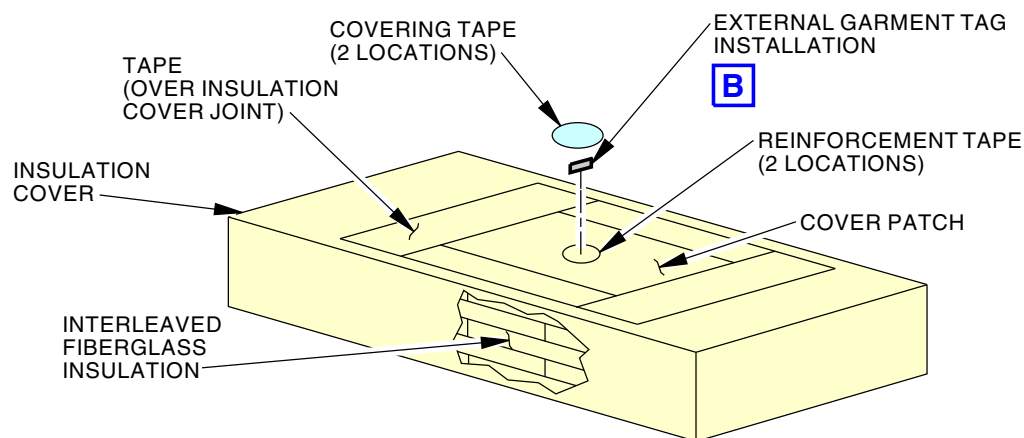
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Page 815
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL



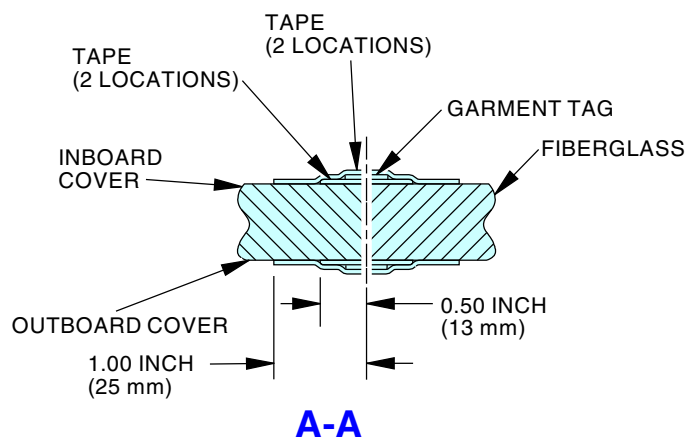
PROCEDURE TO INTERLEAVE FIBERGLASS INSULATION BATTING



EXTERNAL GARMENT TAG INSTALLATION (EXAMPLE)

B

ATTACHMENT OF INTERLEAVED PARTS



J91571 S0000186016_V2

Insulation Blanket Repair
Figure 801/25-80-00-990-811 (Sheet 2 of 2)

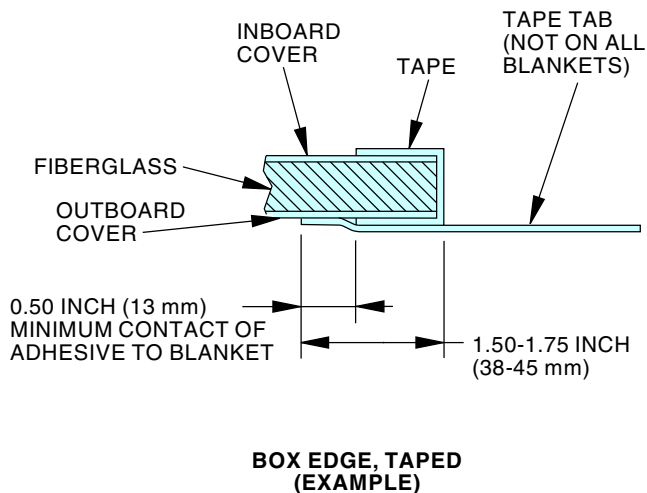
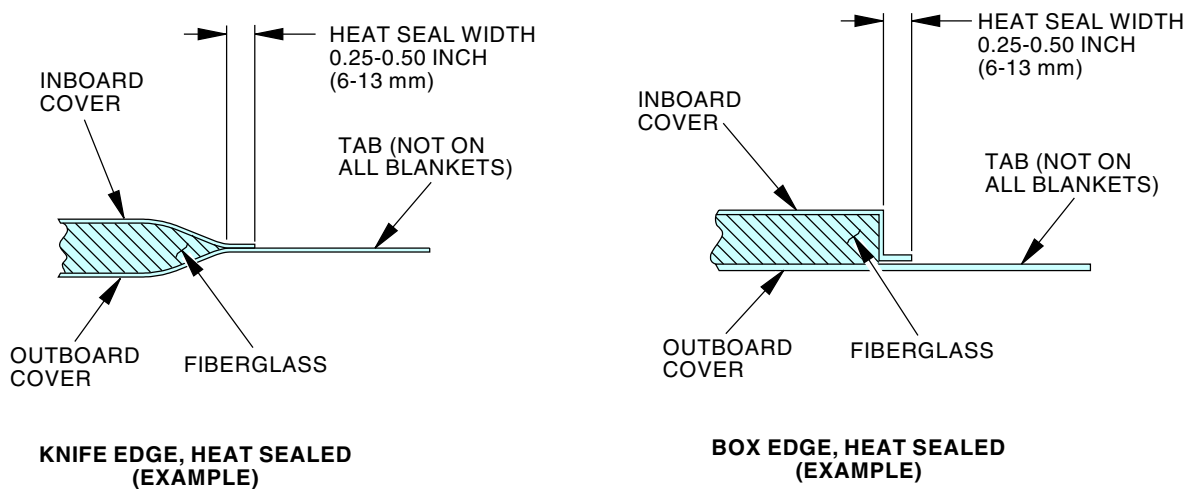
EFFECTIVITY
ARO ALL

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25-80-00

Page 816
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



J61246 S0000172518_V4

**Insulation Blanket Manufacturing
Figure 802/25-80-00-990-812 (Sheet 1 of 8)**

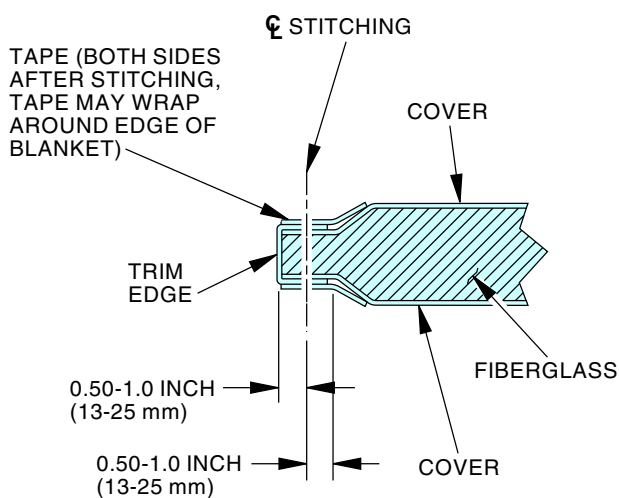
EFFECTIVITY
ARO ALL

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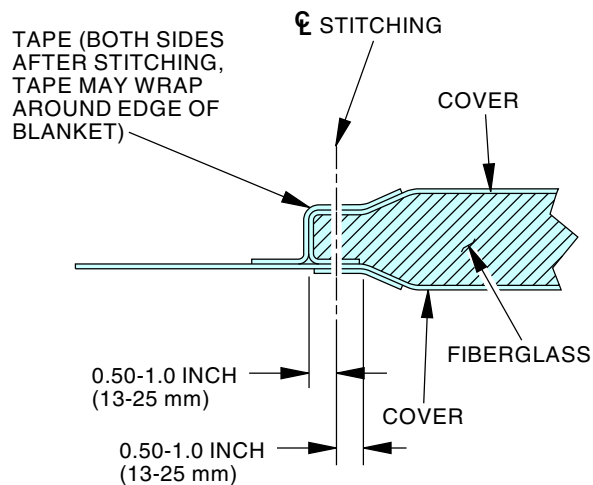
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Page 817
Sep 05/2017

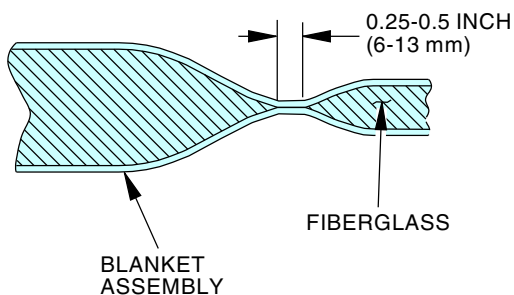
**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



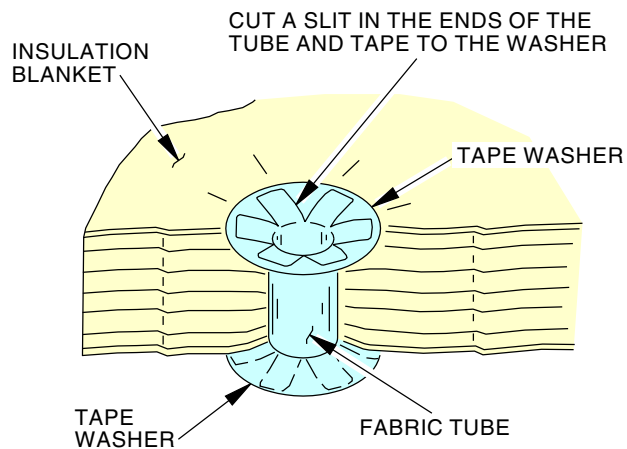
**EDGE BINDING WITHOUT A TAB,
SEWN EDGE**



**EDGE BINDING WITH A TAB,
SEWN EDGE**



**HEATSEAL SEAM LINE
(EXAMPLE)**



**GROMMET INSTALLATION ON
INSULATION BLANKETS**

J61304 S0000172519_V3

**Insulation Blanket Manufacturing
Figure 802/25-80-00-990-812 (Sheet 2 of 8)**

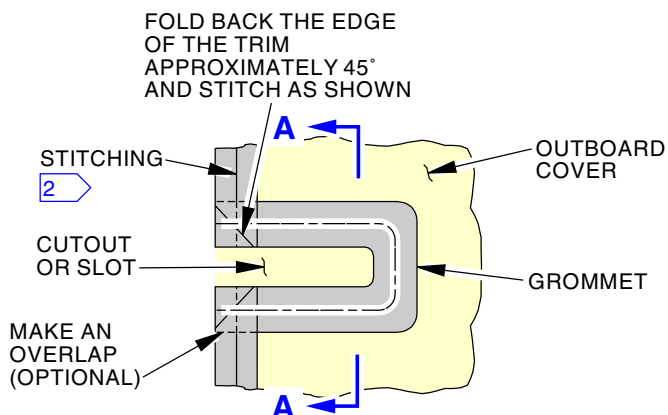
EFFECTIVITY
ARO ALL

D633W101-ARO

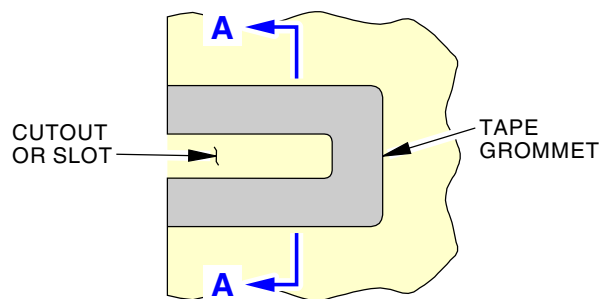
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Page 818
Sep 05/2017

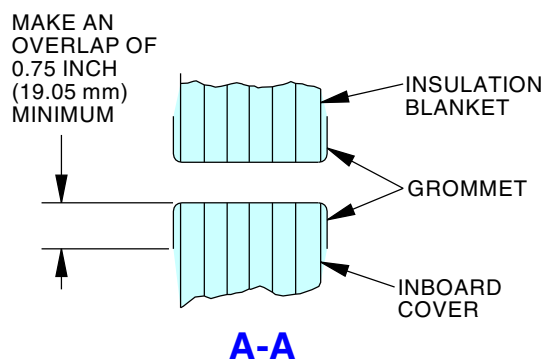
777-200/300 AIRCRAFT MAINTENANCE MANUAL



TRIM EDGE STITCHED CUTOUT OR SLOT



TRIM EDGE TAPED CUTOUT OR SLOT



- 2 USE KEVLAR SEWING THREAD TO MAKE 5 ± 1 STITCHES FOR EACH INCH
- 3 USE TAPE TO MAKE GROMMET

J61278 S0000172520_V2

Insulation Blanket Manufacturing
Figure 802/25-80-00-990-812 (Sheet 3 of 8)

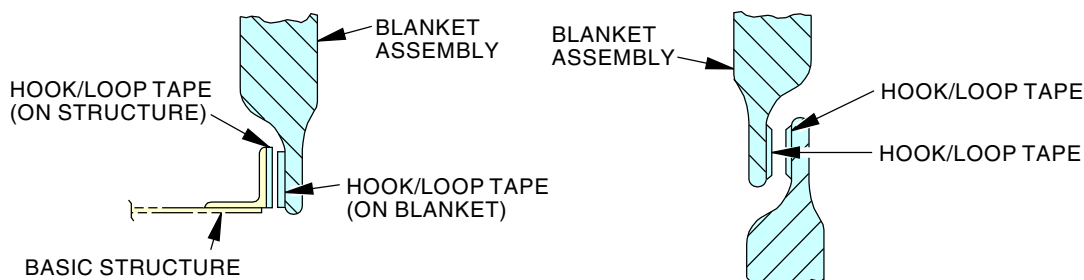
EFFECTIVITY
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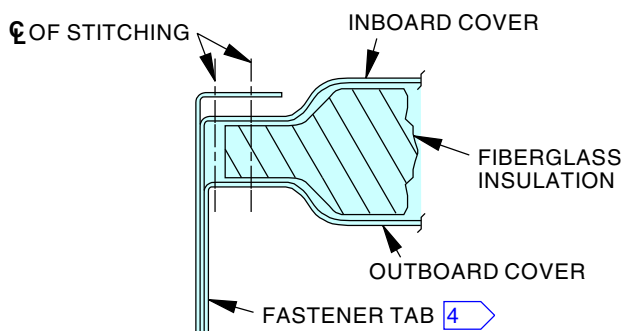
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Page 819
Sep 05/2017

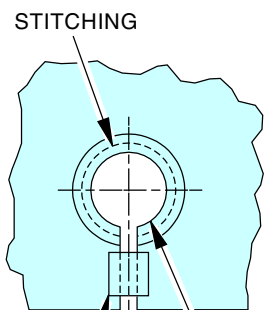
777-200/300 AIRCRAFT MAINTENANCE MANUAL



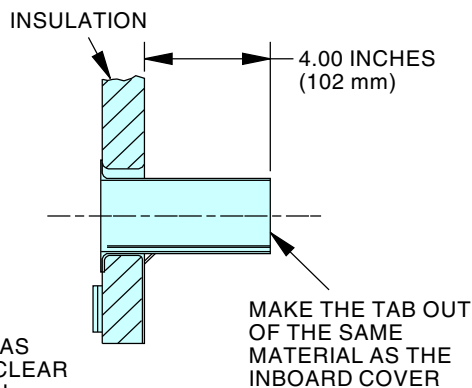
EXAMPLE PROCEDURE TO ATTACH THE BLANKET ASSEMBLIES TO THE AIRPLANE STRUCTURE OR TO OTHER BLANKET ASSEMBLIES WITH HOOK/LOOP TAPE



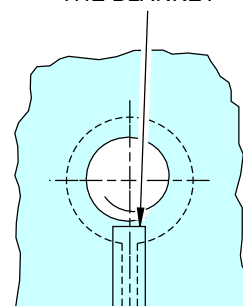
TRIM-EDGE WITH A TAB



HOLE DIAMETER AS NECESSARY TO CLEAR THE SYSTEM RUN



SEAL THE GAP IN THE COVER WITH TAPE AFTER YOU INSTALL THE BLANKET



2.00 INCHES (51 mm) (EXAMPLE)

BLANKET OPENINGS FOR SYSTEM (TUBING, ETC)

- 4 MAKE THE FASTENER TAB FROM THE INBOARD AND OUTBOARD COVER, PLUS ONE LAYER OF COVER FABRIC.

J61261 S0000172521_V3

Insulation Blanket Manufacturing Figure 802/25-80-00-990-812 (Sheet 4 of 8)

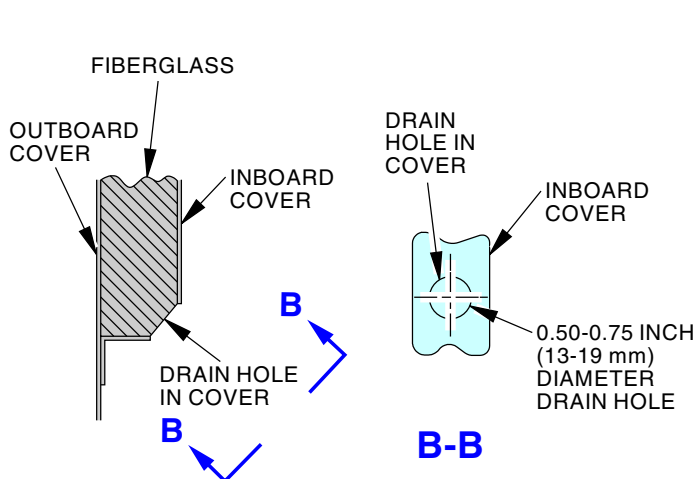
EFFECTIVITY
ARO ALL

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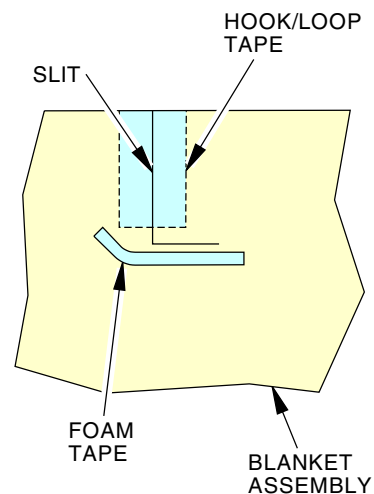
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Page 820
Sep 05/2016

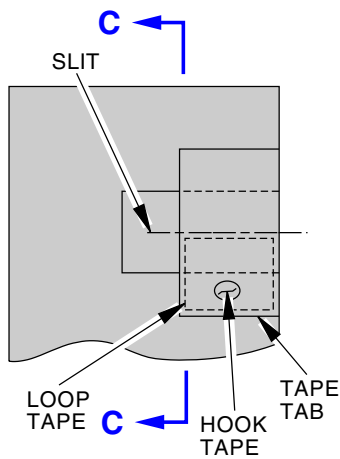
**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



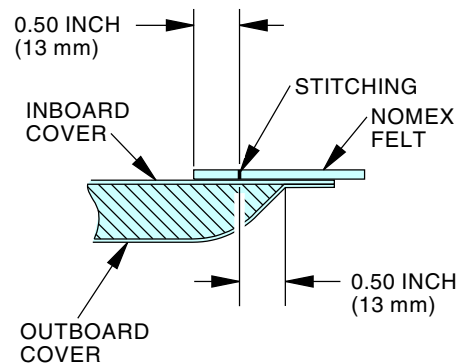
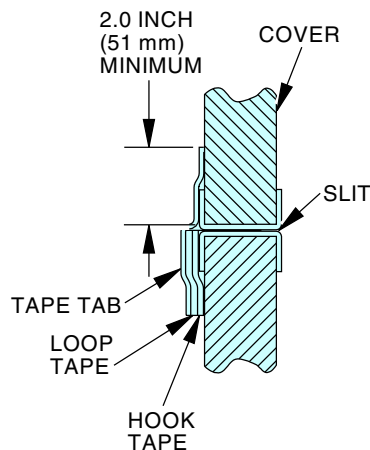
**BOX EDGE DRAIN
(EXAMPLE)**



**FOAM TAPE WATER DIVERter
(FOAM TAPE LOCATED ON OUTBOARD
SIDE OF CAPSTRIP)
(EXAMPLE)**



**CLOSURE FOR SLITS
(EXAMPLE)**



**NOMEX ATTACHMENT
(EXAMPLE)**

J61353 S0000172522_V3

**Insulation Blanket Manufacturing
Figure 802/25-80-00-990-812 (Sheet 5 of 8)**

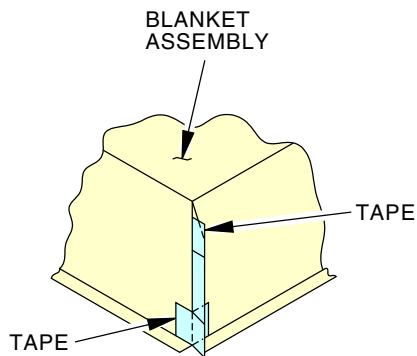
EFFECTIVITY
ARO ALL

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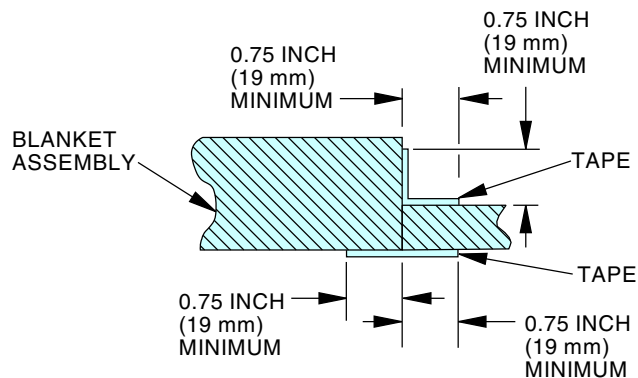
25-80-00

Page 821
Sep 05/2017

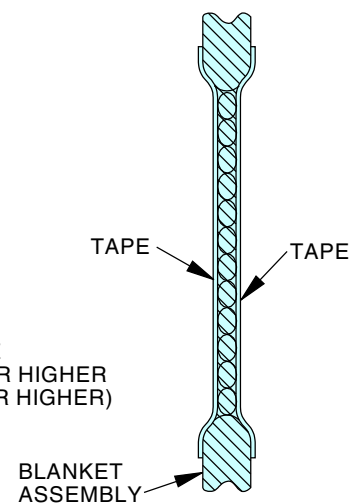
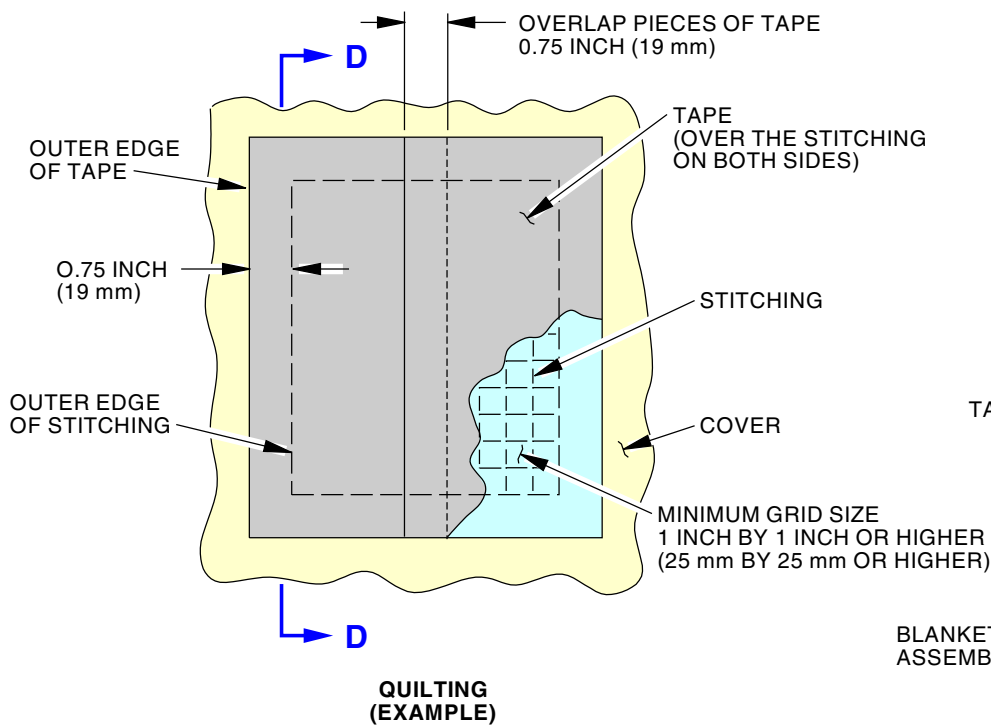
**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**REINFORCED CORNER
OF BOXED BLANKET
(EXAMPLE)**



**BLANKET ATTACHMENT
(EXAMPLE)**



D-D

J61359 S0000172523_V3

**Insulation Blanket Manufacturing
Figure 802/25-80-00-990-812 (Sheet 6 of 8)**

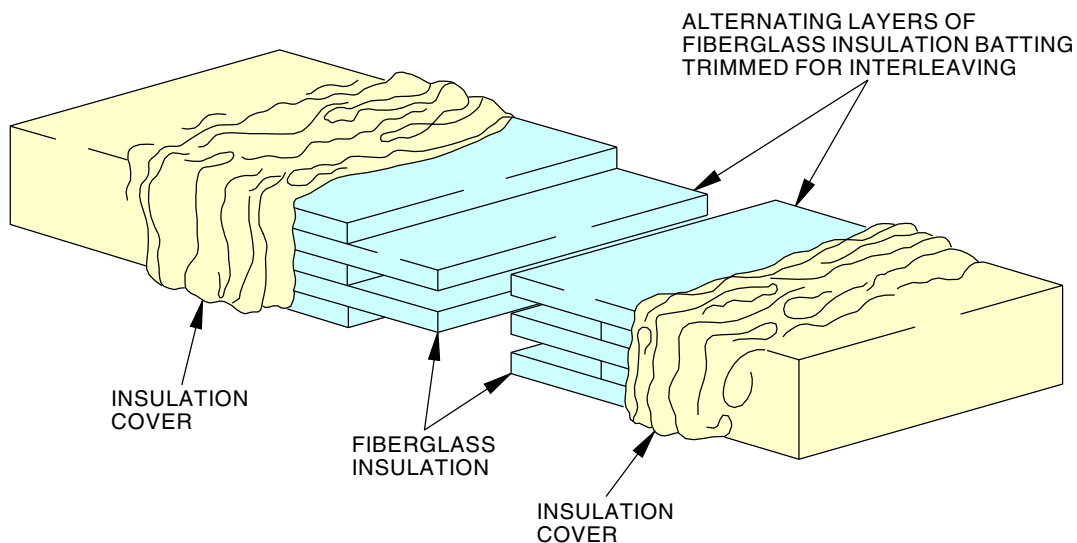
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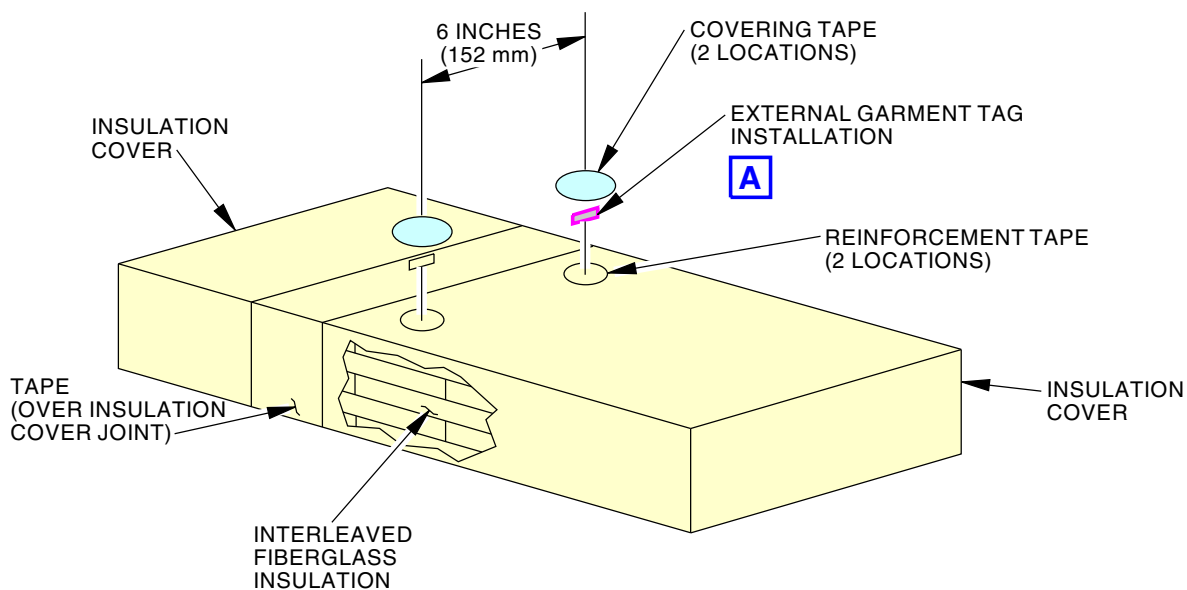
25-80-00

Page 822
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



PROCEDURE TO INTERLEAVE FIBERGLASS INSULATION BATTING



ATTACHMENT OF INTERLEAVED PARTS

J61386 S0000172524_V3

**Insulation Blanket Manufacturing
Figure 802/25-80-00-990-812 (Sheet 7 of 8)**

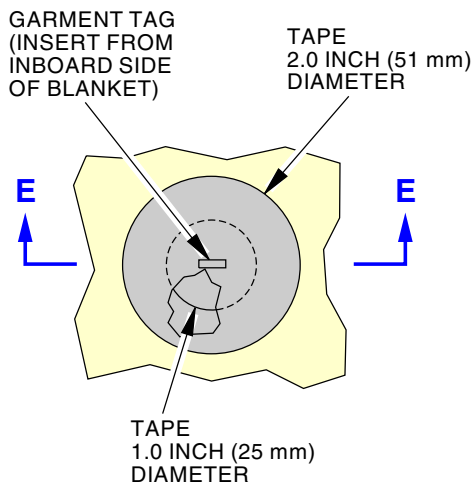
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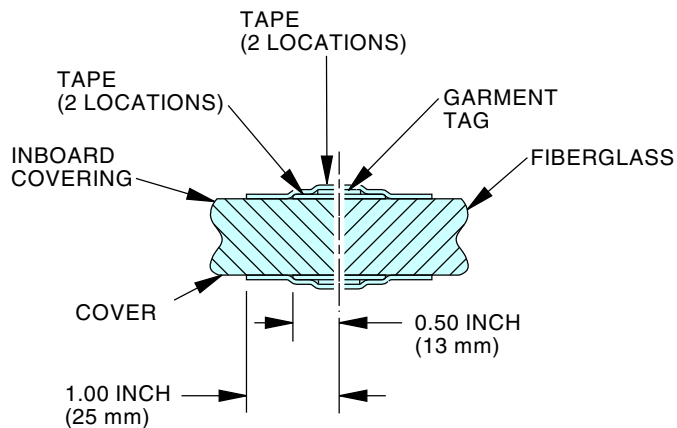
Page 823
Sep 05/2017

777-200/300 AIRCRAFT MAINTENANCE MANUAL

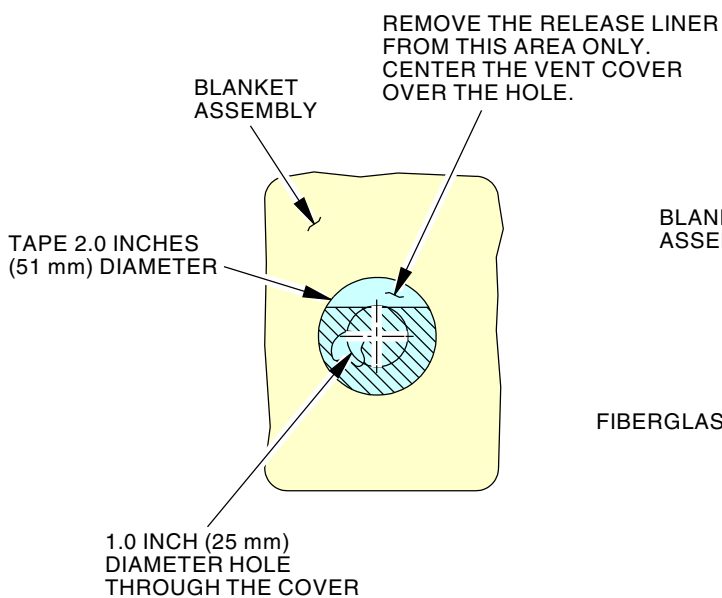


**EXTERNAL GARMENT
TAG INSTALLATION
(EXAMPLE)**

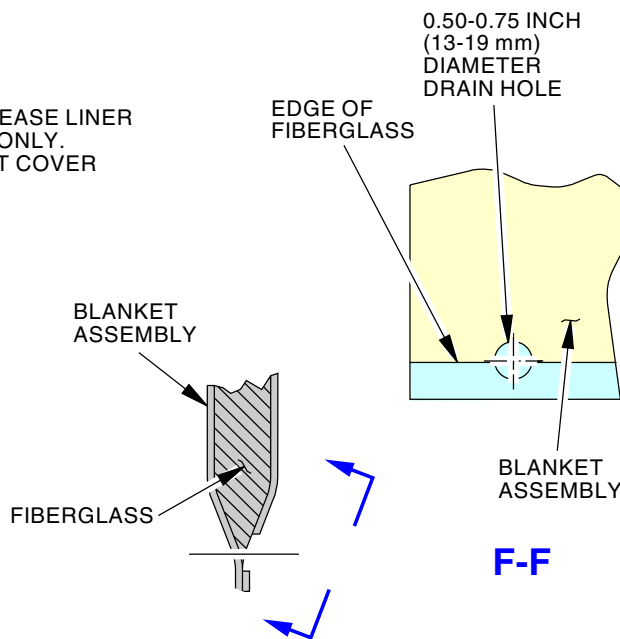
A



E-E



**VENT INSTALLATION
(EXAMPLE)**



F-F

**KNIFE EDGE DRAIN
(EXAMPLE)**

J61388 S0000172525_V3

**Insulation Blanket Manufacturing
Figure 802/25-80-00-990-812 (Sheet 8 of 8)**

EFFECTIVITY
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D633W101-ARO

25-80-00

Page 824
Sep 05/2017



777-200/300 AIRCRAFT MAINTENANCE MANUAL

TASK 25-80-00-340-804

5. Moisture Damaged Insulation Blanket Repair

(Figure 803)

A. General

- (1) This procedure has instructions to repair moisture damaged insulation blanket.
- (2) If the amount of damage on the insulation blanket is more than 25 percent of the total area on either the front side or the back side of an insulation blanket, replace the damaged insulation blanket. The damaged insulation blanket can be used as a template to make a new insulation blanket.

B. References

Reference	Title
25-80-00-000-801	Insulation Blanket Removal (P/B 401)
25-80-00-400-801	Insulation Blanket - Installation (P/B 401)

C. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

D. Prepare to Repair the Insulation Blanket

SUBTASK 25-80-00-212-003

- (1) Visually check the amount of damage to the insulation blanket.
 - (a) If the amount of damage is more than 25 percent of the total area on either the front side or back side of the insulation blanket, replace the insulation blanket. Do these tasks:
 - 1) Insulation Blanket Removal, TASK 25-80-00-000-801.
 - 2) Insulation Blanket - Installation, TASK 25-80-00-400-801.
 - (b) If the amount of damage is less than 25 percent of the total area on either the front side or back side of the insulation blanket, continue.

SUBTASK 25-80-00-110-010



DO NOT USE DETERGENTS OR SOLVENTS TO CLEAN THE INSULATION BLANKET. IT CAN REMOVE FLAME RETARDANTS AND CAUSE FLAMMABLE RESIDUES ON THE INSULATION BLANKET WHICH INCREASES THE RISK OF FIRE. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (2) If there is Corrosion-inhibiting Compounds (CIC) contamination, oily or waxy substances or other fluids (which typically changes the color and appearance of the insulation blanket cover), replace the insulation blanket.

SUBTASK 25-80-00-160-016

- (3) If there are dust, lint or other loose debris on the insulation blanket, use a vacuum cleaner or a non-metallic soft brush to remove the contamination.

SUBTASK 25-80-00-160-017

- (4) Dry the surface of any wet insulation blankets.

————— **END OF TASK** —————

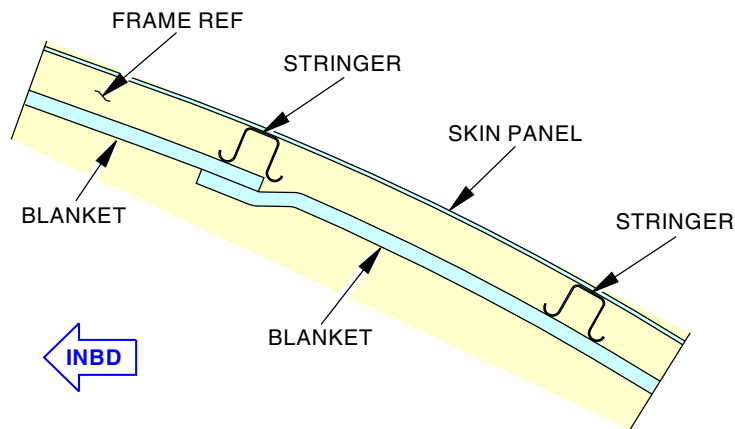
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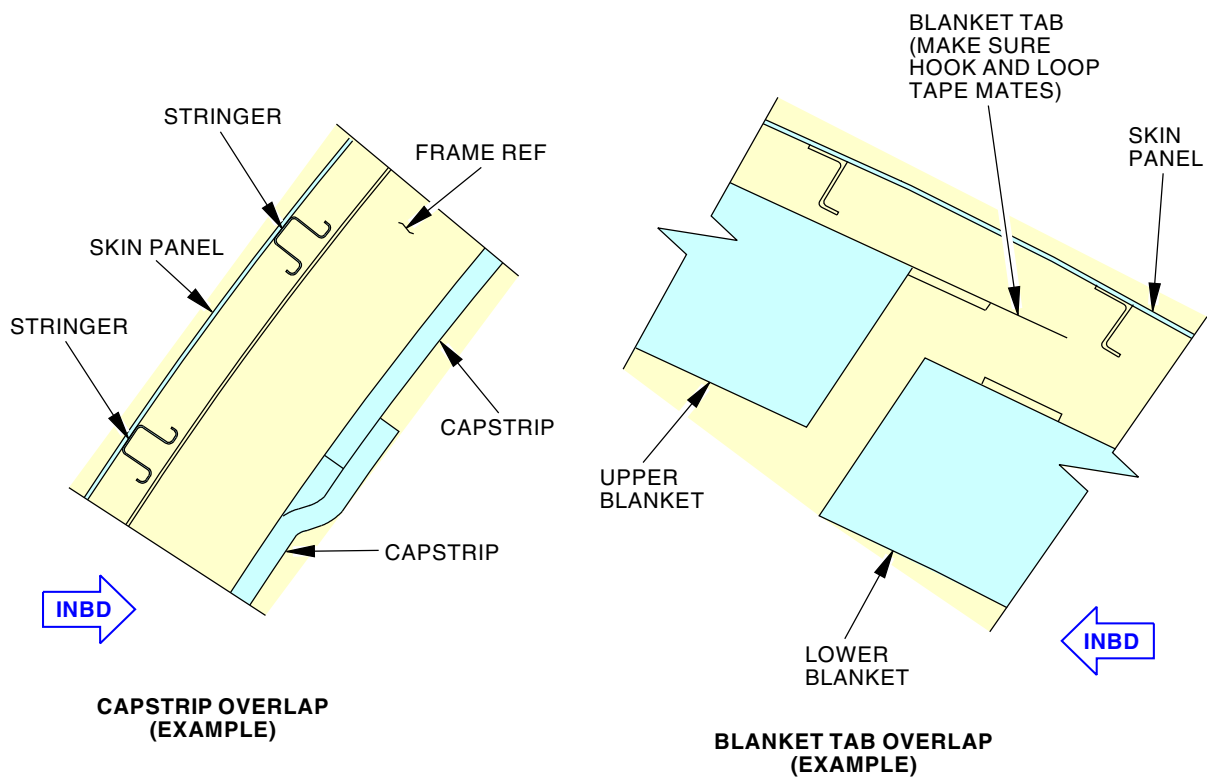
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Page 825
Sep 05/2017

**777-200/300
AIRCRAFT MAINTENANCE MANUAL**



**BLANKET TO BLANKET INSTALLATION
(EXAMPLE)**



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**Blanket Overlap
Figure 803/25-80-00-990-803**

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25-80-00

Page 826
Sep 05/2017