CHAPTER

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404	Sep 15/2021	

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404	Sep 15/2021	
405	Sep 15/2021	

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407	May 15/2022	
408	Sep 15/2021	
409	Sep 15/2021	
410	BLANK	
52-41-00		
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527	Sep 15/2021	
528	Sep 15/2021	
529	Sep 15/2021	
530	Sep 15/2021	

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52-41-00 (cont)		
531	Sep 15/2021	
532	Sep 15/2021	
533	Sep 15/2021	
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540	Jan 15/2022	
541	Jan 15/2022	
542	Sep 15/2021	
543	Sep 15/2021	
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52-41-00		
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52-41-01		
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52-41-11		
401	Sep 15/2022	
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52-41-11 (cont)		
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404	Sep 15/2022	
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410	Sep 15/2022	
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412	Sep 15/2022	
52-41-21		
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52-41-31		
R 401	Sep 15/2023	
R 402	Sep 15/2023	
O 403	Sep 15/2023	
O 404	Sep 15/2023	
O 405	Sep 15/2023	
O 406	Sep 15/2023	
O 407	Sep 15/2023	
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52-41-41		
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404	Sep 15/2021	
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52-41-51		
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402	Sep 15/2021	
403	Sep 15/2021	
404	Sep 15/2021	
405	Sep 15/2021	
406	Sep 15/2021	
407	Sep 15/2021	
408	Sep 15/2021	
409	Sep 15/2022	
410	Jan 15/2022	
52-41-51		
601	Sep 15/2021	
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52-41-61		
401	Sep 15/2021	
402	Sep 15/2021	
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404	Sep 15/2021	
405	Sep 15/2021	
406	Sep 15/2021	
52-41-62		
401	Sep 15/2021	
402	Sep 15/2021	
403	Sep 15/2021	
404	BLANK	
52-48-21		
R 401	Sep 15/2023	
402	Sep 15/2021	
403	Jan 15/2023	
404	Jan 15/2023	
405	Jan 15/2023	
406	Sep 15/2021	
407	Sep 15/2021	
408	Sep 15/2022	
409	Jan 15/2023	

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52-48-21 (cont)		
R 410	Sep 15/2023	
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R 412	Sep 15/2023	
413	Sep 15/2022	
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52-48-31		
201	Sep 15/2021	
202	Sep 15/2021	
52-48-31		
401	May 15/2022	
402	Sep 15/2021	
403	May 15/2022	
404	May 15/2022	
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408	May 15/2022	
409	May 15/2022	
410	May 15/2022	
411	May 15/2022	
412	May 15/2022	
52-48-31		
601	Sep 15/2021	
602	Sep 15/2021	
603	Sep 15/2021	
604	Sep 15/2021	
52-48-41		
201	Sep 15/2021	
202	Sep 15/2021	
203	Sep 15/2021	
204	Sep 15/2021	
52-48-41		
401	Sep 15/2021	
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403	Sep 15/2021	
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52-48-41 (cont)		
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408	Sep 15/2021	
409	Sep 15/2021	
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413	Sep 15/2021	
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52-48-41		
601	May 15/2023	
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603	Sep 15/2021	
604	May 15/2023	
605	Sep 15/2021	
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52-48-42		
401	Sep 15/2022	
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414	Sep 15/2022	
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52-48-42		
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52-49-01		
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52-49-02		
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52-49-07		
401	Sep 15/2021	
402	Sep 15/2021	
403	Sep 15/2022	
404	May 15/2022	
52-49-09		
401	Sep 15/2021	
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52-49-11		
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402	May 15/2023	
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404	Sep 15/2021	
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52-49-11 (cont)		
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52-49-21		
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402	May 15/2023	
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404	May 15/2023	
405	Sep 15/2021	
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52-51-00		
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202	Sep 15/2021	
R 203	Sep 15/2023	
R 204	Sep 15/2023	
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206	Sep 15/2021	
52-51-00		
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52-51-00		
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52-51-01		
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402	Sep 15/2021	
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404	Sep 15/2021	
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406	May 15/2022	
52-51-01		
601	Sep 15/2022	
602	Jan 15/2022	
603	Sep 15/2021	
604	Sep 15/2021	
52-51-02		
401	May 15/2022	
402	May 15/2022	
403	Sep 15/2021	
404	Sep 15/2021	
52-51-03		
401	May 15/2022	
402	May 15/2022	
403	May 15/2022	
R 404	Sep 15/2023	
O 405	Sep 15/2023	
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52-51-04		
401	Jan 15/2022	
402	Sep 15/2021	
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52-51-05		
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52-51-06		
R 401	Sep 15/2023	
R 402	Sep 15/2023	
403	Sep 15/2021	

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702	BLANK	
52-51-07		
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52-51-08		
401	Sep 15/2021	
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403	Sep 15/2021	
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52-71-00		
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52-71-00		
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52-71-11		
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211	Sep 15/2022	
212	Sep 15/2022	

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52-71-11 (cont)		
213	Sep 15/2021	
214	Sep 15/2021	
215	Sep 15/2021	
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217	Sep 15/2021	
218	Sep 15/2021	
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52-71-22		
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205	Sep 15/2021	
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52-71-31		
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205	Sep 15/2021	
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52-71-42		
201	Sep 15/2021	
202	Sep 15/2021	
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DOORS - DDG MAINTENANCE PROCEDURES	52-00-00		901	SIA ALL
DDG 52-11-01 Left Main Cabin Door Pressure Stop Fittings Broken or Missing - Preparation TASK 52-00-00-040-801			901	SIA ALL
DDG 52-22-01 Flight Lock System Inoperative - Preparation TASK 52-00-00-040-802			906	SIA ALL
DDG 52-22-01 Flight Lock System Inoperative - Restoration TASK 52-00-00-440-802			911	SIA ALL
DDG 52-31-01 Lower Cargo Doors Pressure Stop Fittings Broken or Missing - Preparation TASK 52-00-00-040-803			912	SIA ALL
DDG 52-31-01 Lower Cargo Doors Pressure Stop Fittings Broken or Missing - Restoration TASK 52-00-00-440-803			913	SIA ALL
DDG 52-31-02 Lower Cargo Doors Door Balance Mechanism Inoperative - Preparation TASK 52-00-00-040-804			916	SIA ALL
DDG 52-31-04 Cargo Door Exterior Handle Recess/Hinge Spring Assemblies Inoperative - Preparation TASK 52-00-00-040-810			916	SIA ALL
DDG 52-51-01 Flight Deck Door Automatic Locking System Inoperative - Preparation TASK 52-00-00-040-805			916	SIA ALL
DDG 52-51-01 Flight Deck Door Automatic Locking System Inoperative - Restoration TASK 52-00-00-440-805			917	SIA ALL
DDG 52-51-01-01 Flight Deck Access Panel System (Keypad, Door Chime) Inoperative - Preparation TASK 52-00-00-040-806			917	SIA ALL
DDG 52-51-01-01 Flight Deck Access Panel System (Keypad, Door Chime) Inoperative - Restoration TASK 52-00-00-440-806			918	SIA ALL

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DDG 52-51-01-03 Flight Deck Door AUTO UNLK Light Inoperative - Preparation TASK 52-00-00-710-802			920	SIA ALL
DDG 52-51-01-04 Flight Deck Door Lock Control Selector Inoperative - Preparation TASK 52-00-00-040-807			921	SIA ALL
DDG 52-51-01-04 Flight Deck Door Lock Control Selector Inoperative - Restoration TASK 52-00-00-440-807			922	SIA ALL
DDG 52-71-01-01 Door Warning Light System (Entry and Service) Inoperative - Preparation TASK 52-00-00-040-808			923	SIA ALL
DDG 52-71-01-01 Door Warning Light System (Entry and Service) Inoperative - Restoration TASK 52-00-00-440-808			924	SIA ALL
DDG 52-71-01-02 Door Warning Light System (Cargo and Access) Inoperative - Preparation TASK 52-00-00-040-812			925	SIA ALL
DDG 52-71-01-02 Door Warning Light System (Cargo and Access) Inoperative - Restoration TASK 52-00-00-440-813			927	SIA ALL
DDG 52-71-01-03 Door Warning Light System (Airstair) Inoperative - Preparation TASK 52-00-00-040-813			927	SIA ALL
DDG 52-71-01-03 Door Warning Light System (Airstair) Inoperative - Restoration TASK 52-00-00-440-814			928	SIA ALL
DDG 52-71-01-04 Door Warning Light System (Overwing) Inoperative - Preparation TASK 52-00-00-040-809			929	SIA ALL
DDG 52-71-01-04 Door Warning Light System (Overwing) Inoperative - Restoration TASK 52-00-00-440-809			932	SIA ALL

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DOORS - STRUCTURAL INSPECTIONS - MAINTENANCE PRACTICES	52-05-03		201	SIA ALL
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EXTERNAL - DETAILED: FORWARD ACCESS DOOR STOP FITTINGS, STOP PINS, STOP BUSHINGS AND LATCH PINS TASK 52-05-03-211-804			209	SIA ALL
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EXTERNAL - DETAILED: FORWARD GALLEY SERVICE DOOR STOP FITTINGS AND PINS TASK 52-05-03-211-808			223	SIA ALL
EXTERNAL - DETAILED: AFT ENTRY DOOR STOP FITTINGS AND PINS TASK 52-05-03-211-809			225	SIA ALL
EXTERNAL - DETAILED: AFT GALLEY SERVICE DOOR STOP FITTINGS AND PINS TASK 52-05-03-211-810			227	SIA ALL
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INTERNAL - DETAILED: AFT GALLEY SERVICE DOOR TASK 52-05-03-211-814			235	SIA ALL
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INTERNAL - GENERAL VISUAL: FORWARD GALLEY SERVICE DOOR TASK 52-05-03-210-805			240	SIA ALL
INTERNAL - GENERAL VISUAL: AFT ENTRY DOOR TASK 52-05-03-210-806			243	SIA ALL
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INTERNAL - DETAILED: FORWARD CARGO DOOR TASK 52-05-03-211-817			253	SIA ALL
INTERNAL - DETAILED: AFT CARGO DOOR TASK 52-05-03-211-818			255	SIA ALL
INTERNAL - GENERAL VISUAL: FORWARD CARGO DOOR TASK 52-05-03-210-808			257	SIA ALL
INTERNAL - GENERAL VISUAL: AFT CARGO DOOR TASK 52-05-03-210-809			259	SIA ALL
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Aerodynamic Seals Removal TASK 52-09-15-000-801			401	SIA ALL
Aerodynamic Seals Installation TASK 52-09-15-400-801			405	SIA ALL
ACOUSTIC AND THERMO SEALS - REMOVAL/INSTALLATION	52-09-16		401	SIA ALL
Acoustic Seal Removal TASK 52-09-16-000-801			401	SIA ALL
Acoustic Seal Installation TASK 52-09-16-400-801			405	SIA ALL
Thermo Bulb Seal Removal TASK 52-09-16-000-802			406	SIA ALL
Thermo Bulb Seal Installation TASK 52-09-16-400-802			407	SIA ALL
LIGHT SEALS - REMOVAL/INSTALLATION	52-09-17		401	SIA ALL
Light Seals Removal TASK 52-09-17-000-801			401	SIA ALL
Light Seals Installation TASK 52-09-17-400-801			405	SIA ALL

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CHAPTER 52
DOORS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
FORWARD ENTRY DOOR - MAINTENANCE PRACTICES	52-11-00		201	SIA ALL
Open the Door with the Exterior Handle TASK 52-11-00-860-801			201	SIA ALL
Close the Door with the Exterior Handle TASK 52-11-00-860-802			202	SIA ALL
Open the Door with the Interior Handle TASK 52-11-00-860-803			204	SIA ALL
Close the Door with the Interior Handle TASK 52-11-00-860-804			205	SIA ALL
Forward Entry Door Corrosion Prevention TASK 52-11-00-600-801			209	SIA ALL
FORWARD ENTRY DOOR - REMOVAL/INSTALLATION	52-11-00		401	SIA ALL
Forward Entry Door Removal TASK 52-11-00-000-801			401	SIA ALL
Forward Entry Door Installation TASK 52-11-00-400-801			410	SIA ALL
Forward Entry Door Flapper Seal Removal TASK 52-11-00-020-801			413	SIA ALL
Forward Entry Door Flapper Seal Installation TASK 52-11-00-420-801			415	SIA ALL
FORWARD ENTRY DOOR - ADJUSTMENT/TEST	52-11-00		501	SIA ALL
Forward Entry Door Adjustment TASK 52-11-00-820-801			501	SIA ALL
Forward Entry Door (Soft Unlatching) TASK 52-11-00-820-802			515	SIA ALL
Forward Entry Door System Test TASK 52-11-00-700-801			517	SIA ALL
FORWARD ENTRY DOOR - INSPECTION/CHECK	52-11-00		601	SIA ALL
Forward Entry Door Check TASK 52-11-00-200-801			601	SIA ALL
Forward Entry Door Centering Guide Check TASK 52-11-00-200-802			605	SIA ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
Forward Entry Door Pressure Seal Check TASK 52-11-00-200-803			609	SIA ALL
Forward Entry Door Flapper Seal Check TASK 52-11-00-200-804			612	SIA ALL
Vacuum Tool Leak Check of the Forward Entry Door Seal TASK 52-11-00-700-802			615	SIA ALL
FORWARD ENTRY DOOR - REPAIRS	52-11-00		801	SIA ALL
Top Guide Plate Latch Pin Hole Repair TASK 52-11-00-350-801			801	SIA ALL
FORWARD ENTRY DOOR STOP BEARING PLATES - REMOVAL/INSTALLATION	52-11-01		401	SIA ALL
Stop Bearing Plate - Removal TASK 52-11-01-000-801			401	SIA ALL
Stop Bearing Plate - Installation TASK 52-11-01-400-801			402	SIA ALL
FORWARD ENTRY DOOR HINGE ARM - REMOVAL/INSTALLATION	52-11-11		401	SIA ALL
Forward Entry Door Hinge Arm Removal TASK 52-11-11-000-801			401	SIA ALL
Forward Entry Door Hinge Arm Installation TASK 52-11-11-400-801			404	SIA ALL
FORWARD ENTRY DOOR GUIDE ARM AND ROLLER - REMOVAL/INSTALLATION	52-11-21		401	SIA ALL
Forward Entry Door Guide Arm and Roller Removal TASK 52-11-21-000-801			401	SIA ALL
Forward Entry Door Guide Arm and Roller Installation TASK 52-11-21-400-801			407	SIA ALL
FORWARD ENTRY DOOR LINING - REMOVAL/INSTALLATION	52-11-31		401	SIA ALL
Forward Entry Door Lining Removal TASK 52-11-31-000-801			401	SIA ALL
Forward Entry Door Lining Installation TASK 52-11-31-400-801			406	SIA ALL

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DOORS

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FORWARD ENTRY DOOR ASSIST SPRINGS - REMOVAL/INSTALLATION	52-11-41		401	SIA ALL
Forward Entry Door Assist Springs Removal TASK 52-11-41-000-801			401	SIA ALL
Forward Entry Door Assist Springs Installation TASK 52-11-41-400-801			408	SIA ALL
FORWARD ENTRY DOOR SNUBBER - REMOVAL/INSTALLATION	52-11-51		401	SIA ALL
Forward Entry Door Snubber Removal TASK 52-11-51-000-801			401	SIA ALL
Forward Entry Door Snubber Installation TASK 52-11-51-400-801			405	SIA ALL
FORWARD ENTRY DOOR GATE - REMOVAL/INSTALLATION	52-11-61		401	SIA ALL
Forward Entry Door Gate - Removal TASK 52-11-61-000-801			401	SIA ALL
Forward Entry Door Gate - Installation TASK 52-11-61-400-801			402	SIA ALL
AFT ENTRY DOOR - MAINTENANCE PRACTICES	52-13-00		201	SIA ALL
Open the AFT Door with the Exterior Handle TASK 52-13-00-860-801			201	SIA ALL
Close the AFT Door with the Exterior Handle TASK 52-13-00-860-802			202	SIA ALL
Open the AFT Door with the Interior Handle TASK 52-13-00-860-803			203	SIA ALL
Close the AFT Door with the Interior Handle TASK 52-13-00-860-804			205	SIA ALL
Aft Entry Door Corrosion Prevention TASK 52-13-00-600-801			209	SIA ALL
AFT ENTRY DOOR - REMOVAL/INSTALLATION	52-13-00		401	SIA ALL
Aft Entry Door Removal TASK 52-13-00-000-801			401	SIA ALL
Aft Entry Door Installation TASK 52-13-00-400-801			407	SIA ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
AFT ENTRY DOOR - ADJUSTMENT/TEST	52-13-00		501	SIA ALL
Aft Entry Door Adjustment TASK 52-13-00-820-801			501	SIA ALL
Aft Entry Door (Soft Unlatching) TASK 52-13-00-820-802			514	SIA ALL
Aft Entry Door System Test TASK 52-13-00-700-801			516	SIA ALL
AFT ENTRY DOOR - INSPECTION/CHECK	52-13-00		601	SIA ALL
Aft Entry Door Check TASK 52-13-00-200-801			601	SIA ALL
Aft Entry Door Centering Guide Bearing Check TASK 52-13-00-200-802			605	SIA ALL
Aft Entry Door Pressure Seal Check TASK 52-13-00-200-803			609	SIA ALL
Vacuum Tool Leak Check of the Aft Entry Door Seal TASK 52-13-00-700-802			612	SIA ALL
AFT ENTRY DOOR STOP BEARING PLATES - REMOVAL/INSTALLATION	52-13-01		401	SIA ALL
Aft Entry Door Stop Bearing Plate - Removal TASK 52-13-01-000-801			401	SIA ALL
Aft Entry Door Stop Bearing Plate - Installation TASK 52-13-01-400-801			404	SIA ALL
AFT ENTRY DOOR HINGE ARM - REMOVAL/INSTALLATION	52-13-11		401	SIA ALL
Aft Entry Door Hinge Arm Removal TASK 52-13-11-000-801			401	SIA ALL
Aft Entry Door Hinge Arm Installation TASK 52-13-11-400-801			404	SIA ALL
AFT ENTRY DOOR GUIDE ARM AND ROLLER - REMOVAL/INSTALLATION	52-13-21		401	SIA ALL
Aft Entry Door Guide Arm and Roller Removal TASK 52-13-21-000-801			401	SIA ALL
Aft Entry Door Guide Arm and Roller Installation TASK 52-13-21-400-801			402	SIA ALL

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DOORS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
AFT ENTRY DOOR LINING - REMOVAL/INSTALLATION	52-13-31		401	SIA ALL
Aft Entry Door Lining Removal TASK 52-13-31-000-801			401	SIA ALL
Aft Entry Door Lining Installation TASK 52-13-31-400-801			406	SIA ALL
AFT ENTRY DOOR FUSELAGE HINGE TORQUE TUBE - REMOVAL/INSTALLATION	52-13-41		401	SIA ALL
Aft Entry Door Fuselage Hinge Torque Tube Removal TASK 52-13-41-000-801			401	SIA ALL
Aft Entry Door Fuselage Hinge Torque Tube Installation TASK 52-13-41-400-801			406	SIA ALL
AFT ENTRY DOOR SNUBBER/BUMPER - REMOVAL/INSTALLATION	52-13-51		401	SIA ALL
Aft Entry Door Snubber Removal TASK 52-13-51-000-801			401	SIA ALL
Aft Entry Door Snubber Installation TASK 52-13-51-400-801			405	SIA ALL
Aft Entry Door Bumper - Removal TASK 52-13-51-000-803			407	SIA ALL
Aft Entry Door Bumper - Installation TASK 52-13-51-400-803			410	SIA ALL
AFT ENTRY DOOR BUMPER - INSPECTION/CHECK	52-13-51		601	SIA ALL
Aft Entry Door Bumper - Inspection TASK 52-13-51-200-801			601	SIA ALL
AFT ENTRY DOOR GATE - REMOVAL/INSTALLATION	52-13-61		401	SIA ALL
Aft Entry Door Gate Removal TASK 52-13-61-000-801			401	SIA ALL
Aft Entry Door Gate Installation TASK 52-13-61-400-801			405	SIA ALL

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DOORS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
AFT ENTRY DOOR DRAIN VALVE ASSEMBLY - REMOVAL/INSTALLATION	52-13-62		401	SIA ALL
Aft Entry Door Drain Valve Assembly - Removal TASK 52-13-62-000-801			401	SIA ALL
Aft Entry Door Drain Valve Assembly - Installation TASK 52-13-62-400-801			403	SIA ALL
EMERGENCY EXIT DOOR - MAINTENANCE PRACTICES	52-22-00		201	SIA ALL
Open the Emergency Exit Door TASK 52-22-00-580-801			201	SIA ALL
Open the Emergency Exit Door from the Outside TASK 52-22-00-580-802			202	SIA ALL
Close the Emergency Exit Door TASK 52-22-00-580-803			203	SIA ALL
Emergency Exit Door Corrosion Protection TASK 52-22-00-600-801			208	SIA ALL
EMERGENCY EXIT DOOR - REMOVAL/INSTALLATION	52-22-00		401	SIA ALL
Emergency Exit Door Removal TASK 52-22-00-000-801			401	SIA ALL
Emergency Exit Door Installation TASK 52-22-00-400-801			406	SIA ALL
EMERGENCY EXIT DOOR - ADJUSTMENT/TEST	52-22-00		501	SIA ALL
Emergency Exit Door Operational Test TASK 52-22-00-710-801			501	SIA ALL
Emergency Exit Door Flight Lock Mechanical Switch Operational Test TASK 52-22-00-710-802			508	SIA ALL
Emergency Exit Door Flight Lock Engagement Operational Test TASK 52-22-00-710-803			511	SIA ALL
Emergency Exit Door Adjustment TASK 52-22-00-820-801			516	SIA ALL
Emergency Exit Door System Test TASK 52-22-00-730-801			534	SIA ALL

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DOORS

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EMERGENCY EXIT DOOR - INSPECTION/CHECK	52-22-00		601	SIA ALL
Emergency Exit Door Inspection/Check TASK 52-22-00-200-801			601	SIA ALL
Emergency Exit Door Pressure Seal Check TASK 52-22-00-200-802			604	SIA ALL
Emergency Exit Door Latch Components Detailed Inspection TASK 52-22-00-210-801			604	SIA ALL
Emergency Exit Door Flight Locks Detailed Inspection TASK 52-22-00-210-802			605	SIA ALL
EMERGENCY EXIT DOOR STOP BEARING PLATE - REMOVAL/INSTALLATION	52-22-01		401	SIA ALL
Emergency Exit Door Stop Bearing Plate Removal TASK 52-22-01-000-801			401	SIA ALL
Emergency Exit Door Stop Bearing Plate Installation TASK 52-22-01-400-801			404	SIA ALL
EMERGENCY EXIT DOOR COUNTERBALANCE ACTUATOR - REMOVAL/INSTALLATION	52-22-21		401	SIA ALL
Emergency Exit Door Counterbalance Actuator Removal TASK 52-22-21-000-801			401	SIA ALL
Emergency Exit Door Counterbalance Actuator Installation TASK 52-22-21-400-801			406	SIA ALL
EMERGENCY EXIT DOOR SNUBBER - REMOVAL/INSTALLATION	52-22-31		401	SIA ALL
Emergency Exit Door Snubber Removal TASK 52-22-31-000-801			401	SIA ALL
Emergency Exit Door Snubber Installation TASK 52-22-31-400-801			406	SIA ALL

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DOORS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
EMERGENCY EXIT DOOR FLIGHT LOCK SOLENOID ASSEMBLY - REMOVAL/INSTALLATION	52-22-41		401	SIA ALL
Emergency Exit Door Fight Lock Solenoid Removal TASK 52-22-41-000-801			401	SIA ALL
Emergency Exit Door Flight Lock Solenoid Installation TASK 52-22-41-400-801			406	SIA ALL
Emergency Exit Door Flight Lock Switch Removal TASK 52-22-41-020-801			407	SIA ALL
Emergency Exit Door Flight Lock Switch Installation TASK 52-22-41-420-801			408	SIA ALL
EMERGENCY EXIT DOOR LINING - REMOVAL/INSTALLATION	52-22-51		401	SIA ALL
Emergency Exit Door Lining Removal TASK 52-22-51-000-801			401	SIA ALL
Emergency Exit Door Lining Installation TASK 52-22-51-400-801			406	SIA ALL
CARGO DOOR - MAINTENANCE PRACTICES	52-31-00		201	SIA ALL
Open the Cargo Door TASK 52-31-00-580-801			201	SIA ALL
Close the Cargo Door TASK 52-31-00-580-802			201	SIA ALL
Open the Cargo Door when the Lock Mechanism will not Operate TASK 52-31-00-580-803			204	SIA ALL
Cargo Door Corrosion Prevention TASK 52-31-00-600-801			204	SIA ALL
CARGO DOOR - REMOVAL/INSTALLATION	52-31-00		401	SIA ALL
Cargo Door Removal TASK 52-31-00-000-801			401	SIA ALL
Cargo Door Installation TASK 52-31-00-400-801			407	SIA ALL

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DOORS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
CARGO DOOR - ADJUSTMENT/TEST	52-31-00		501	SIA ALL
Cargo Door Adjustment TASK 52-31-00-820-801			501	SIA ALL
Cargo Door System Test TASK 52-31-00-700-801			527	SIA ALL
CARGO DOOR - INSPECTION/CHECK	52-31-00		601	SIA ALL
Cargo Door Check TASK 52-31-00-200-801			601	SIA ALL
Cargo Door Pressure Seal Check TASK 52-31-00-200-802			604	SIA ALL
CARGO DOOR COUNTERBALANCE MECHANISM - REMOVAL/INSTALLATION	52-31-12		401	SIA ALL
Cargo Door Counterbalance Removal TASK 52-31-12-000-801			401	SIA ALL
Cargo Door Counterbalance Installation TASK 52-31-12-400-801			405	SIA ALL
CARGO DOOR COUNTERBALANCE MECHANISM - REPAIRS	52-31-12		801	SIA ALL
Broken Cargo Door Counterbalance Cable Replacement TASK 52-31-12-000-802			801	SIA ALL
CARGO DOOR SNUBBER - REMOVAL/INSTALLATION	52-31-13		401	SIA ALL
Cargo Door Snubber Removal TASK 52-31-13-000-801			401	SIA ALL
Cargo Door Snubber Installation TASK 52-31-13-400-801			403	SIA ALL
CARGO DOOR SNUBBER - ADJUSTMENT/TEST	52-31-13		501	SIA ALL
Cargo Door Snubber Operational Test TASK 52-31-13-710-801			501	SIA ALL
Cargo Door Snubber Functional Test TASK 52-31-13-710-802			503	SIA ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
CARGO DOOR HANDLE MECHANISM - REMOVAL/INSTALLATION	52-31-14		401	SIA ALL
Cargo Door Handle Mechanism Removal TASK 52-31-14-000-801			401	SIA ALL
Cargo Door Handle Mechanism Installation TASK 52-31-14-400-801			406	SIA ALL
GALLEY SERVICE DOORS - MAINTENANCE PRACTICES	52-41-00		201	SIA ALL
Open the Galley Service Door with the Exterior Handle TASK 52-41-00-860-801			201	SIA ALL
Close the Galley Service Door with the Exterior Handle TASK 52-41-00-860-802			202	SIA ALL
Open the Galley Service Door with the Interior Handle TASK 52-41-00-860-803			204	SIA ALL
Close the Galley Service Door with the Interior Handle TASK 52-41-00-860-804			205	SIA ALL
Galley Service Doors Corrosion Prevention TASK 52-41-00-600-801			209	SIA ALL
GALLEY SERVICE DOOR - REMOVAL/INSTALLATION	52-41-00		401	SIA ALL
Galley Service Door Removal TASK 52-41-00-000-801			401	SIA ALL
Galley Service Door Installation TASK 52-41-00-400-801			407	SIA ALL
GALLEY SERVICE DOOR - ADJUSTMENT/TEST	52-41-00		501	SIA ALL
Galley Service Door Adjustment TASK 52-41-00-820-801			501	SIA ALL
Galley Service Door (Soft Unlatching) TASK 52-41-00-820-802			540	SIA ALL
Galley Service Door System Test TASK 52-41-00-700-801			542	SIA ALL

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DOORS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
GALLEY SERVICE DOOR - INSPECTION/CHECK	52-41-00		601	SIA ALL
Galley Service Door Check TASK 52-41-00-200-801			601	SIA ALL
Galley Service Door Centering Guide Bearing Check TASK 52-41-00-200-802			606	SIA ALL
Galley Service Door Pressure Seal Check TASK 52-41-00-200-803			610	SIA ALL
GALLEY SERVICE DOORS STOP BEARING PLATES - REMOVAL/INSTALLATION	52-41-01		401	SIA ALL
Galley Service Door Stop Bearing Plate Removal TASK 52-41-01-000-801			401	SIA ALL
Galley Service Door Stop Bearing Plate Installation TASK 52-41-01-400-801			404	SIA ALL
GALLEY SERVICE DOOR HINGE ARM - REMOVAL/INSTALLATION	52-41-11		401	SIA ALL
Galley Service Door Hinge Arm Removal TASK 52-41-11-000-801			401	SIA ALL
Galley Service Door Hinge Arm Installation TASK 52-41-11-400-801			409	SIA ALL
GALLEY SERVICE DOOR GUIDE ARM AND ROLLER - REMOVAL/INSTALLATION	52-41-21		401	SIA ALL
Galley Service Door Guide Arm and Roller Removal TASK 52-41-21-000-801			401	SIA ALL
Galley Service Door Guide Arm and Roller Installation TASK 52-41-21-400-801			406	SIA ALL
GALLEY SERVICE DOOR LINING - REMOVAL/INSTALLATION	52-41-31		401	SIA ALL
Galley Service Door Lining Removal TASK 52-41-31-000-801			401	SIA ALL
Galley Service Door Lining Installation TASK 52-41-31-400-801			406	SIA ALL

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GALLEY SERVICE DOOR FUSELAGE HINGE TORQUE TUBE - REMOVAL/INSTALLATION	52-41-41		401	SIA ALL
Galley Service Door Fuselage Hinge Torque Tube Removal TASK 52-41-41-000-801			401	SIA ALL
Galley Service Door Fuselage Hinge Torque Tube Installation TASK 52-41-41-400-801			406	SIA ALL
GALLEY SERVICE DOOR SNUBBER/BUMPER - REMOVAL/INSTALLATION	52-41-51		401	SIA ALL
Galley Service Door Snubber Removal TASK 52-41-51-000-801			401	SIA ALL
Galley Service Door Snubber Installation TASK 52-41-51-400-801			404	SIA ALL
Galley Service Door Bumper - Removal TASK 52-41-51-000-802			405	SIA ALL
Galley Service Door Bumper - Installation TASK 52-41-51-400-802			409	SIA ALL
GALLEY SERVICE DOOR BUMPER INSPECTION/CHECK	52-41-51		601	SIA ALL
Galley Service Door Bumper - Inspection TASK 52-41-51-200-801			601	SIA ALL
GALLEY SERVICE DOOR GATE - REMOVAL/INSTALLATION	52-41-61		401	SIA ALL
Galley Service Door Gate Removal TASK 52-41-61-000-801			401	SIA ALL
Galley Service Door Gate Installation TASK 52-41-61-400-801			405	SIA ALL
GALLEY SERVICE DOOR DRAIN VALVE ASSEMBLY - REMOVAL/INSTALLATION	52-41-62		401	SIA ALL
Galley Service Door Drain Valve Assembly Removal TASK 52-41-62-000-801			401	SIA ALL
Galley Service Door Drain Valve Assembly Installation TASK 52-41-62-400-801			403	SIA ALL

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AUXILIARY POWER UNIT (APU) COWL DOOR - REMOVAL/INSTALLATION	52-48-21		401	SIA ALL
Auxiliary Power Unit (APU) Cowl Door Removal TASK 52-48-21-000-801			401	SIA ALL
Auxiliary Power Unit (APU) Cowl Door Installation TASK 52-48-21-400-801			408	SIA ALL
FORWARD ACCESS DOOR - MAINTENANCE PRACTICES	52-48-31		201	SIA ALL
Forward Access Door Corrosion Prevention TASK 52-48-31-600-801			201	SIA ALL
FORWARD ACCESS DOOR - REMOVAL/INSTALLATION	52-48-31		401	SIA ALL
Forward Access Door Removal TASK 52-48-31-000-801			401	SIA ALL
Forward Access Door Installation TASK 52-48-31-400-801			405	SIA ALL
FORWARD ACCESS DOOR - INSPECTION/CHECK	52-48-31		601	SIA ALL
Forward Access Door Check TASK 52-48-31-200-801			601	SIA ALL
Forward Access Door Pressure Seal Check TASK 52-48-31-200-802			603	SIA ALL
ELECTRONIC EQUIPMENT ACCESS DOOR - MAINTENANCE PRACTICES	52-48-41		201	SIA ALL
Open the Electronic Equipment Door when the Door Handle will not Move TASK 52-48-41-010-801			201	SIA ALL
Electronic Equipment Door Corrosion Prevention TASK 52-48-41-600-801			202	SIA ALL
ELECTRONIC EQUIPMENT ACCESS DOOR - REMOVAL/INSTALLATION	52-48-41		401	SIA ALL
Electronic Equipment Access Door Removal TASK 52-48-41-000-801			401	SIA ALL
Electronic Equipment Access Door Installation TASK 52-48-41-400-801			409	SIA ALL

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DOORS

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ELECTRONIC EQUIPMENT ACCESS DOOR - INSPECTION/CHECK	52-48-41		601	SIA ALL
Electronic Equipment Access Door Check TASK 52-48-41-200-801			601	SIA ALL
Electronic Equipment Access Door Pressure Seal Check TASK 52-48-41-200-802			603	SIA ALL
ENVIRONMENTAL CONTROL SYSTEMS (ECS) ACCESS AND HIGH PRESSURE DOORS- REMOVAL/INSTALLATION	52-48-42		401	SIA ALL
Environmental Control Systems (ECS) Access Door Removal TASK 52-48-42-000-801			401	SIA ALL
Environmental Control Systems (ECS) Access Door Installation TASK 52-48-42-400-801			407	SIA ALL
Environmental Control Systems (ECS) High Pressure Door Removal TASK 52-48-42-000-802			411	SIA ALL
Environmental Control System (ECS) High Pressure Door Installation TASK 52-48-42-400-802			414	SIA ALL
ENVIRONMENTAL CONTROL SYSTEMS (ECS) HIGH PRESSURE DOOR - ADJUSTMENT	52-48-42		501	SIA ALL
Environmental Control Systems (ECS) High Pressure Door Adjustment TASK 52-48-42-820-801			501	SIA ALL
FORWARD FAIRING ACCESS DOOR - REMOVAL/INSTALLATION	52-49-01		401	SIA ALL
Forward Fairing Access Door - Removal TASK 52-49-01-000-801			401	SIA ALL
Forward Fairing Access Door - Installation TASK 52-49-01-400-801			403	SIA ALL

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EXTERNAL POWER RECEPTACLE ACCESS DOOR - REMOVAL/INSTALLATION	52-49-02		401	SIA ALL
External Power Receptacle Access Door - Removal TASK 52-49-02-000-801			401	SIA ALL
External Power Receptacle Access Door - Installation TASK 52-49-02-400-801			403	SIA ALL
WASTE TANK SERVICE PANEL - REMOVAL/INSTALLATION	52-49-07		401	SIA ALL
Waste Tank Service Panel Removal TASK 52-49-07-000-801			401	SIA ALL
Waste Tank Service Panel Installation TASK 52-49-07-400-801			403	SIA ALL
Waste Tank Service Panel Fit Check TASK 52-49-07-000-802			404	SIA ALL
WATER SERVICE PANEL - REMOVAL/INSTALLATION	52-49-09		401	SIA ALL
Water Service Panel Removal TASK 52-49-09-000-801			401	SIA ALL
Water Service Panel Installation TASK 52-49-09-400-801			401	SIA ALL
Water Service Panel Fit Check TASK 52-49-09-000-802			402	SIA ALL
SECTION 48 ACCESS AND BLOWOUT DOOR - REMOVAL/INSTALLATION	52-49-11		401	SIA ALL
Section 48 Access and Blowout Door Removal TASK 52-49-11-000-801			401	SIA ALL
Section 48 Access and Blowout Door Installation TASK 52-49-11-400-801			401	SIA ALL
SECTION 48 ACCESS AND BLOWOUT DOOR - ADJUSTMENT/TEST	52-49-11		501	SIA ALL
Section 48 Access and Blowout Door Test TASK 52-49-11-720-801			501	SIA ALL

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CHAPTER 52
DOORS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
REFUELING STATION DOOR - REMOVAL/INSTALLATION	52-49-21		401	SIA ALL
Refueling Station Door Removal TASK 52-49-21-000-801			401	SIA ALL
Refueling Station Door Installation TASK 52-49-21-400-801			402	SIA ALL
FLIGHT COMPARTMENT DOOR - MAINTENANCE PRACTICES	52-51-00		201	SIA ALL
Program the Access Code TASK 52-51-00-900-801			201	SIA ALL
Program Time Delays and Door Bell Enable TASK 52-51-00-900-802			203	SIA ALL
Decompression Panel Hinge Operation TASK 52-51-00-710-801			204	SIA ALL
FLIGHT COMPARTMENT DOOR - ADJUSTMENT/TEST	52-51-00		501	SIA ALL
Operational Check of the Flight Compartment Access System TASK 52-51-00-710-802			501	SIA ALL
Flight Compartment Security Door Access System Test TASK 52-51-00-700-801			502	SIA ALL
Functional Check of the DENY Function of the Flight Deck Access System TASK 52-51-00-700-802			506	SIA ALL
Pressure Release Latch Functional Test TASK 52-51-00-710-803			508	SIA ALL
FLIGHT COMPARTMENT DOOR - INSPECTION/CHECK	52-51-00		601	SIA ALL
Decompression Panel Hinge - Inspection TASK 52-51-00-210-801			601	SIA ALL
Decompression Panel Seal - Inspection TASK 52-51-00-210-802			603	SIA ALL

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CHAPTER 52
DOORS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
FLIGHT COMPARTMENT DOOR - REMOVAL/INSTALLATION	52-51-01		401	SIA ALL
Flight Compartment Door Removal TASK 52-51-01-000-801			401	SIA ALL
Flight Compartment Door Installation TASK 52-51-01-400-801			405	SIA ALL
FLIGHT COMPARTMENT DOOR - INSPECTION/CHECK	52-51-01		601	SIA ALL
Flight Compartment Door Seal - Inspection TASK 52-51-01-200-801			601	SIA ALL
FLIGHT COMPARTMENT DOOR LATCH - REMOVAL/INSTALLATION	52-51-02		401	SIA ALL
Flight Compartment Door Latch Removal TASK 52-51-02-000-801			401	SIA ALL
Flight Compartment Door Latch Installation TASK 52-51-02-400-801			401	SIA ALL
ELECTRIC STRIKE - REMOVAL/INSTALLATION	52-51-03		401	SIA ALL
Electric Strike Removal TASK 52-51-03-000-801			401	SIA ALL
Electric Strike Installation TASK 52-51-03-400-801			404	SIA ALL
FLIGHT COMPARTMENT DOOR DEADBOLT - REMOVAL/INSTALLATION	52-51-04		401	SIA ALL
Flight Compartment Door Deadbolt Removal TASK 52-51-04-000-801			401	SIA ALL
Flight Compartment Door Deadbolt Installation TASK 52-51-04-400-801			401	SIA ALL
KEYPAD - REMOVAL/INSTALLATION	52-51-05		401	SIA ALL
Keypad Removal TASK 52-51-05-000-801			401	SIA ALL
Keypad Installation TASK 52-51-05-400-801			401	SIA ALL

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CHAPTER 52
DOORS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
CHIME MODULE - REMOVAL/INSTALLATION	52-51-06		401	SIA ALL
Chime Module Removal TASK 52-51-06-000-801			401	SIA ALL
Chime Module Installation TASK 52-51-06-400-801			401	SIA ALL
CHIME MODULE - CLEANING	52-51-06		701	SIA ALL
Chime Module Cleaning TASK 52-51-06-000-802			701	SIA ALL
COCKPIT CONTROL PANEL SWITCH/LIGHT (P8-47) - REMOVAL/INSTALLATION	52-51-07		401	SIA ALL
Cockpit Control Panel Switch/Light (P8-47) Removal TASK 52-51-07-020-801			401	SIA ALL
Cockpit Control Panel Switch/Light (P8-47) Installation TASK 52-51-07-420-801			401	SIA ALL
DECOMPRESSION PANEL AND PRESSURE RELEASE LATCH - REMOVAL/INSTALLAION	52-51-08		401	SIA ALL
Decompression Panel and Pressure Release Latch Removal TASK 52-51-08-000-801			401	SIA ALL
Decompression Panel and Pressure Release Latch Installation TASK 52-51-08-400-801			401	SIA ALL
DOOR WARNING SYSTEM - MAINTENANCE PRACTICES	52-71-00		201	SIA ALL
Door Warning Annunciator Panel Removal TASK 52-71-00-000-801			201	SIA ALL
Door Warning Annunciator Panel Installation TASK 52-71-00-400-801			203	SIA ALL
DOOR WARNING SYSTEM - ADJUSTMENT/TEST	52-71-00		501	SIA ALL
Door Warning System Test TASK 52-71-00-730-801			501	SIA ALL

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CHAPTER 52
DOORS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
ENTRY AND GALLEY SERVICE DOOR WARNING SYSTEM - MAINTENANCE PRACTICES	52-71-11		201	SIA ALL
Entry and Galley Service Door Indication Sensor Removal (S194, S195, S199, or S200) TASK 52-71-11-000-801			201	SIA ALL
Entry and Galley Service Door Indication Sensor Installation (S194, S195, S199, or S200) TASK 52-71-11-400-801			208	SIA ALL
Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200) TASK 52-71-11-820-801			209	SIA ALL
Entry and Galley Service Door Indication Sensor Test (S194, S195, S199, or S200) TASK 52-71-11-710-801			215	SIA ALL
Forward Entry Door Indication Sensor Plunger Adjustment (S199) TASK 52-71-11-820-802			215	SIA ALL
Forward Entry Door Switch Removal (S1147) TASK 52-71-11-000-802			216	SIA ALL
Forward Entry Door Switch Installation (S1147) TASK 52-71-11-400-802			219	SIA ALL
Forward Entry Door Switch Adjustment (S1147) TASK 52-71-11-820-803			220	SIA ALL
Forward Entry Door Switch Test (S1147) TASK 52-71-11-710-802			222	SIA ALL
EMERGENCY EXIT DOOR INDICATION SWITCH - MAINTENANCE PRACTICES	52-71-22		201	SIA ALL
Emergency Exit Door Indication Switch Removal TASK 52-71-22-000-801			201	SIA ALL
Emergency Exit Door Indication Switch Installation TASK 52-71-22-420-801			202	SIA ALL
Emergency Exit Door Indication Switch Test TASK 52-71-22-710-801			203	SIA ALL

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CHAPTER 52
DOORS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
CARGO DOOR WARNING SYSTEM - MAINTENANCE PRACTICES	52-71-31		201	SIA ALL
Forward Cargo Door Indication Switch - Removal TASK 52-71-31-000-801			201	SIA ALL
Forward Cargo Door Indication Switch - Installation TASK 52-71-31-400-801			205	SIA ALL
Aft Cargo Door Indication Switch - Removal TASK 52-71-31-000-802			205	SIA ALL
Aft Cargo Door Indication Switch - Installation TASK 52-71-31-400-802			210	SIA ALL
Cargo Door Indication Switch - Adjustment TASK 52-71-31-820-801			210	SIA ALL
Cargo Door Indication Switch - Test TASK 52-71-31-710-801			211	SIA ALL
FORWARD ACCESS DOOR WARNING SYSTEM - MAINTENANCE PRACTICES	52-71-41		201	SIA ALL
Forward Access Door Indication Switch Removal TASK 52-71-41-000-801			201	SIA ALL
Forward Access Door Indication Switch Installation TASK 52-71-41-400-801			204	SIA ALL
Forward Access Door Indication Switch Test TASK 52-71-41-710-801			204	SIA ALL
ELECTRONIC EQUIPMENT ACCESS DOOR WARNING SYSTEM - MAINTENANCE PRACTICES	52-71-42		201	SIA ALL
Electronic Equipment Access Door Indication Switch Removal TASK 52-71-42-000-801			201	SIA ALL
Electronic Equipment Access Door Indication Switch Installation TASK 52-71-42-400-801			205	SIA ALL
Electronic Equipment Access Door Indication Switch Test TASK 52-71-42-710-801			206	SIA ALL

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DOORS - DDG MAINTENANCE PROCEDURES

1. General

A. This procedure has the maintenance tasks for the Master Minimum Equipment List (MMEL) maintenance requirements as shown in the Dispatch Deviations Guide (DDG).

B. This procedure also has the tasks that put the airplane back to its usual condition.

C. These are the tasks for the components in the doors:

(1) DDG 52-11-01 Left Main Cabin Door Pressure Stop Fittings Broken or Missing - Preparation

(2) DDG 52-22-01 Flight Lock System Inoperative - Preparation

(3) DDG 52-22-01 Flight Lock System Inoperative - Restoration

(4) DDG 52-31-01 Lower Cargo Doors Pressure Stop Fittings Broken or Missing - Preparation

(5) DDG 52-31-01 Lower Cargo Doors Pressure Stop Fittings Broken or Missing - Restoration

(6) DDG 52-31-02 Lower Cargo Doors Door Balance Mechanism Inoperative - Preparation

(7) DDG 52-31-04 Cargo Door Exterior Handle Recess/Hinge Spring Assemblies Inoperative - Preparation

(8) DDG 52-51-01 Flight Deck Door Automatic Locking System Inoperative - Preparation

(9) DDG 52-51-01 Flight Deck Door Automatic Locking System Inoperative - Restoration

(10) DDG 52-51-01-01 Flight Deck Access Panel System (Keypad, Door Chime) Inoperative - Preparation

(11) DDG 52-51-01-01 Flight Deck Access Panel System (Keypad, Door Chime) Inoperative - Restoration

(12) DDG 52-51-01-02 Flight Deck Door LOCK FAIL Light Inoperative - Preparation

(13) DDG 52-51-01-03 Flight Deck Door AUTO UNLK Light Inoperative - Preparation

(14) DDG 52-51-01-04 Flight Deck Door Lock Control Selector Inoperative - Preparation

(15) DDG 52-51-01-04 Flight Deck Door Lock Control Selector Inoperative - Restoration

(16) DDG 52-71-01-01 Door Warning Light System (Entry and Service) Inoperative - Preparation

(17) DDG 52-71-01-01 Door Warning Light System (Entry and Service) Inoperative - Restoration

(18) DDG 52-71-01-02 Door Warning Light System (Cargo and Access) Inoperative - Preparation

(19) DDG 52-71-01-02 Door Warning Light System (Cargo and Access) Inoperative - Restoration

(20) DDG 52-71-01-03 Door Warning Light System (Airstair) Inoperative - Preparation

(21) DDG 52-71-01-03 Door Warning Light System (Airstair) Inoperative - Restoration

(22) DDG 52-71-01-04 Door Warning Light System (Overwing) Inoperative - Preparation

(23) DDG 52-71-01-04 Door Warning Light System (Overwing) Inoperative - Restoration

TASK 52-00-00-040-801

2. DDG 52-11-01 Left Main Cabin Door Pressure Stop Fittings Broken or Missing - Preparation

(Figure 901)

A. General

(1) This task gives the maintenance steps which prepare the airplane for flight with one stop fitting broken or missing inoperative.

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B. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door

C. Left Main Cabin Door Pressure Stop Fittings Visual Inspection

SUBTASK 52-00-00-210-001

(1) Do a visual inspection of the remaining fuselage stop fittings, door stop fittings, and stop pins as follows:

(a) Examine the door stop fittings.

1) Look for cracks and corrosion.

(b) Examine the stop pins.

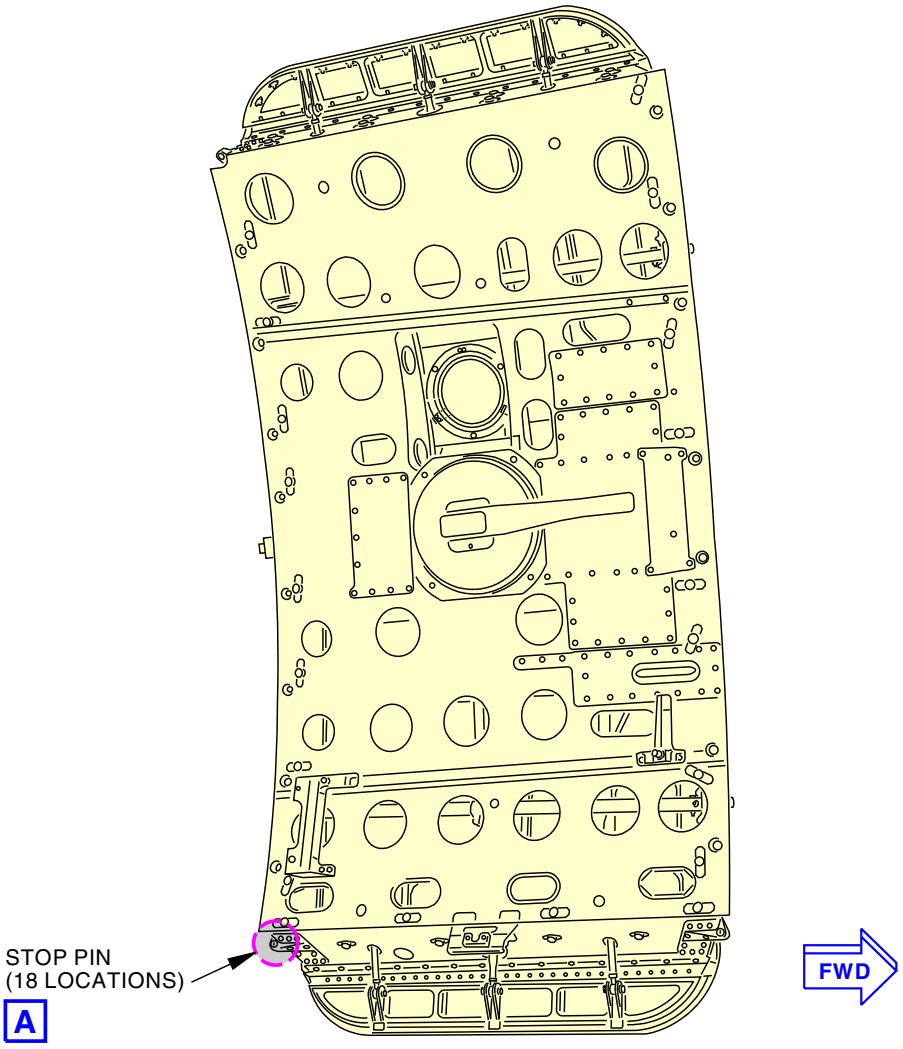
1) Look for cracks and corrosion.

2) Look for unwanted particles on the stop pins.

3) Make sure that the retaining springs are installed.

——— END OF TASK ———

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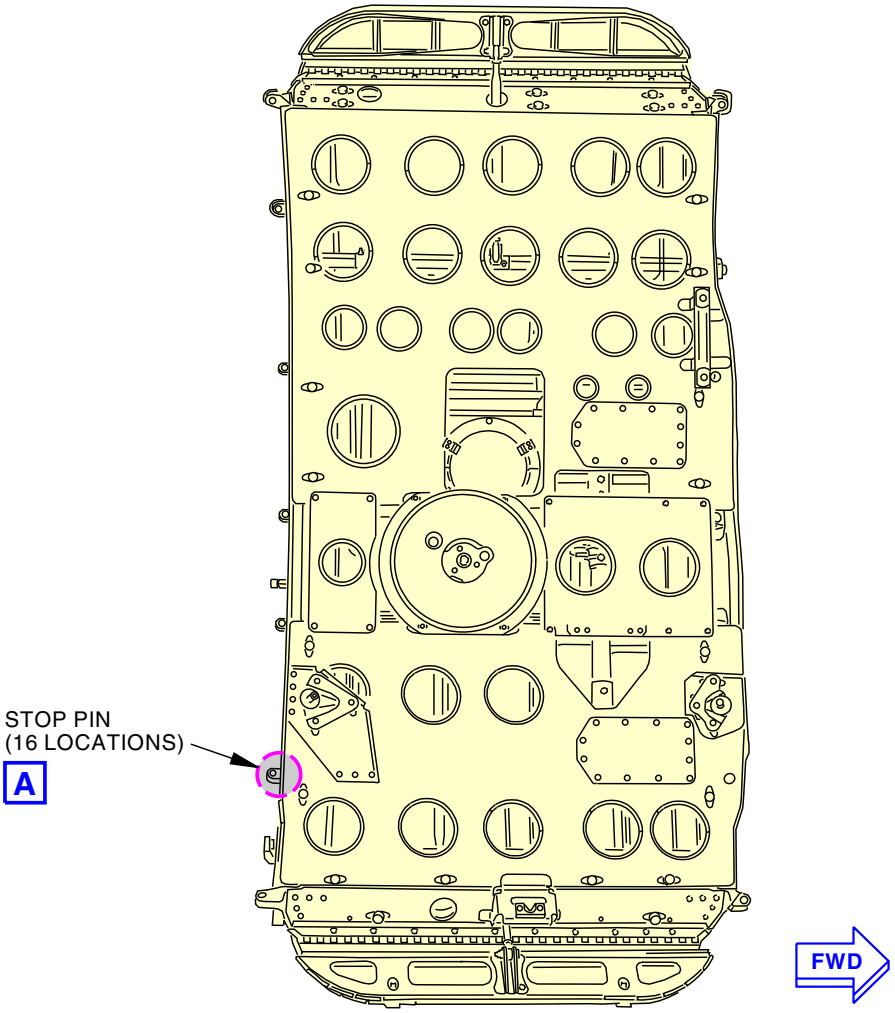


FORWARD ENTRY DOOR

2415653 S00061538597_V1

Left Main Cabin Door Pressure Fitting
Figure 901/52-00-00-990-802 (Sheet 1 of 3)

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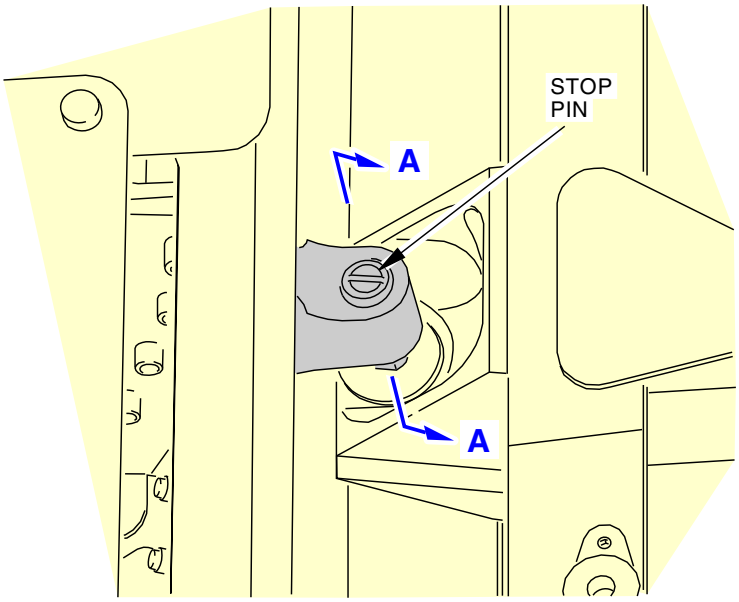


AFT ENTRY DOOR

2415654 S00061538598_V2

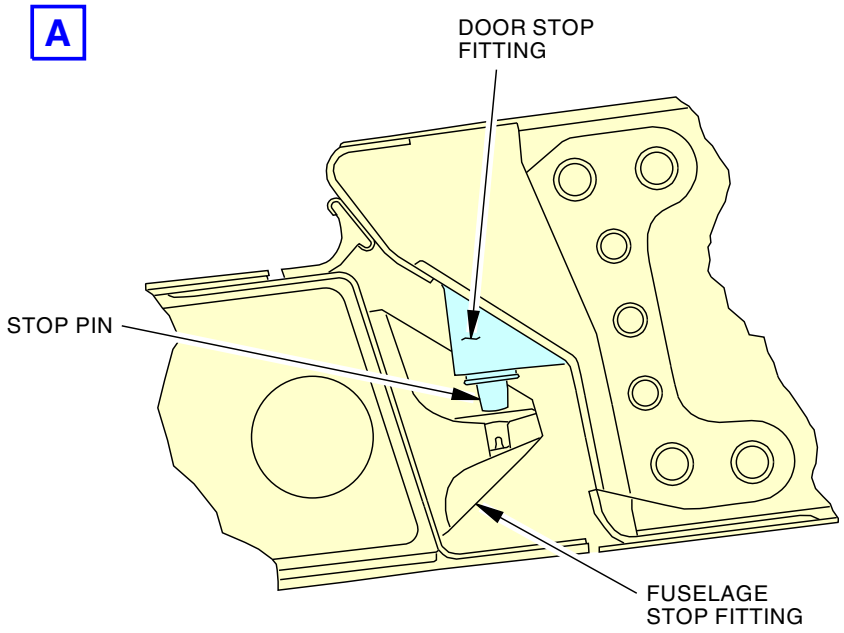
Left Main Cabin Door Pressure Fitting
Figure 901/52-00-00-990-802 (Sheet 2 of 3)

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**STOP PIN
(EXAMPLE)**

A



A-A

2415655 S00061538599_V1

**Left Main Cabin Door Pressure Fitting
Figure 901/52-00-00-990-802 (Sheet 3 of 3)**

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TASK 52-00-00-040-802

3. DDG 52-22-01 Flight Lock System Inoperative - Preparation

(Figure 902)

A. General

(1) This task gives the maintenance instruction to prepare the airplane for flight with the emergency exit flight lock system inoperative.

(2) For more information refer to SSM 52-71-13 and WDM 52-71-13 for the left side emergency exit doors and SSM 52-71-14 and WDM 52-71-14 for the right side emergency exit doors.

B. References

Reference	Title
31-65-00-750-801	Fault Interrogation for a Maintenance Message (P/B 201)
52-22-00-710-801	Emergency Exit Door Operational Test (P/B 501)
52-22-00-710-803	Emergency Exit Door Flight Lock Engagement Operational Test (P/B 501)
SWPM 20-30-12	ASSEMBLY OF SPLICES
WDM 52-71-13	Wiring Diagram Manual
WDM 52-71-14	Wiring Diagram Manual

C. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

D. Access Panels

Number	Name/Location
112A	Forward Access Door

E. Flight Lock System Deactivation

SUBTASK 52-00-00-710-001

(1) Make sure that the applicable door operates correctly:

(a) Do this task: Emergency Exit Door Operational Test, TASK 52-22-00-710-801.

1) If the door operates correctly, continue with the preparation procedure.

SUBTASK 52-00-00-760-001

(2) Deactivate the affected flight lock input(s) to associated flight deck indications, including the input to the master caution system.

(a) Open these circuit breakers and install safety tags:

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
D	1	C01515	OVERWING FLIGHT LOCK-RIGHT
D	2	C01514	OVERWING FLIGHT LOCK-LEFT

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
D	1	C01399	PSEU PRI

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(Continued)

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
D	2	C01400	PSEU ALTN

(b) To get access to the PSEU, open this access panel:

Number	Name/Location
112A	Forward Access Door

(c) For the applicable door, remove the pins from the applicable connectors (Table 901).

NOTE: The pin numbers are listed in the “Disconnect, Cap, and Stow the Wire for this Number” column.

Table 901/52-00-00-993-801 FLIGHT LOCK DEACTIVATION

Door Location	Electrical Connector	Disconnect, Cap, and Stow the Wire for this Pin Number	Pin Numbers - Jumpered
Left Aft	D10986 (J4)	Pin 20	Pin 40 to Pin 20
Left Forward	D10986 (J4)	Pin 53	Pin 40 to Pin 53
Left Aft and Left Forward	D10986 (J4)	Pin 20 and Pin 53	Pin 40 to Pin 20 and Pin 53
Right Aft	D10988 (J6)	Pin 2	Pin 53 to Pin 2
Right Forward	D10988 (J6)	Pin 52	Pin 53 to Pin 52
Right Aft and Right Forward	D10988 (J6)	Pin 2 and Pin 52	Pin 53 to Pin 2 and Pin 52

1) Cap and stow the wire (Figure 902).

(d) Jumper the applicable pins (Table 901):

NOTE: The pin numbers are listed in the “Pin Numbers - Jumpered” column.

1) Use a moisture proof splice to create an extension wire (Figure 902).

NOTE: Refer to SWPM 20-30-12 for more information on wire splices.

2) Connect the extension wire into applicable pin(s) (Table 901).

NOTE: The pin numbers are listed in the “Pin Numbers - Jumpered” column.

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

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
D	1	C01515	OVERWING FLIGHT LOCK-RIGHT
D	2	C01514	OVERWING FLIGHT LOCK-LEFT

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
D	1	C01399	PSEU PRI
D	2	C01400	PSEU ALTN

(f) Make sure that the light and annunciator for the applicable door are off (TASK 52-22-00-710-803).

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(g) Close this access panel:

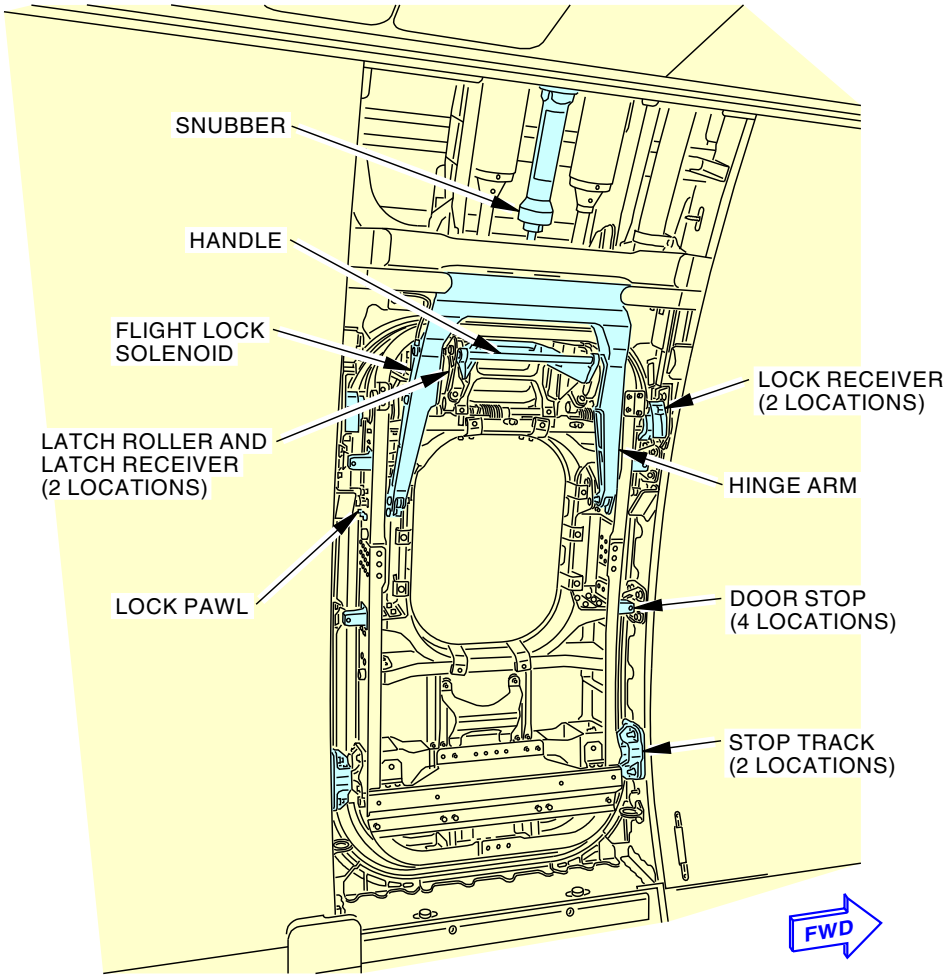
Number	Name/Location
112A	Forward Access Door

SUBTASK 52-00-00-810-003

(3) If it is necessary, extinguish the MAINT light on the P5-1 panel (TASK 31-65-00-750-801).

——— END OF TASK ———

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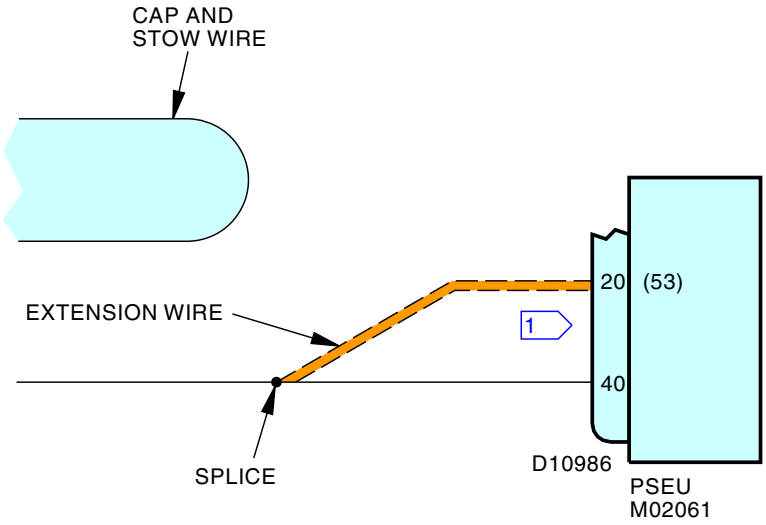


**EMERGENCY EXIT DOOR
(DOOR IN THE CLOSED POSITION
WITH DOOR LINING REMOVED)
(EXAMPLE)**

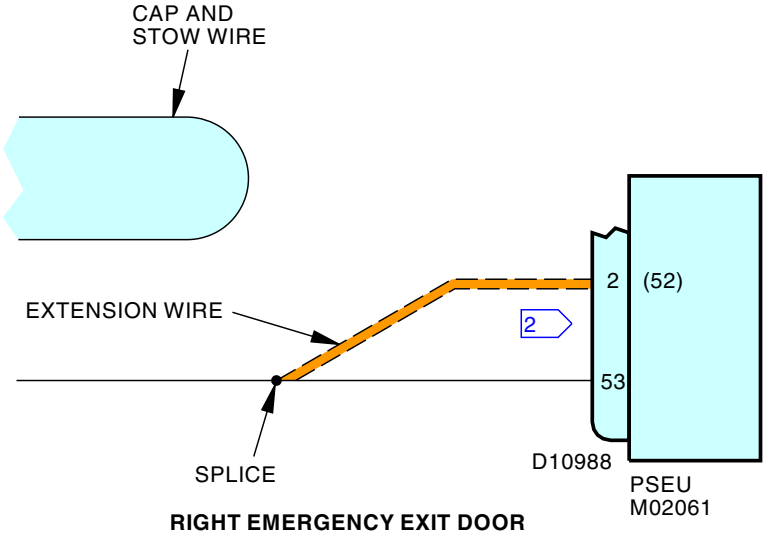
2415657 S00061538607_V1

**Emergency Exit Flight Lock System
Figure 902/52-00-00-990-804 (Sheet 1 of 2)**

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LEFT EMERGENCY EXIT DOOR



RIGHT EMERGENCY EXIT DOOR

1 LEFT OR AFT LEFT DOOR CONNECTION IS SHOWN. FOR THE FORWARD LEFT DOOR, JUMPER PIN 40 TO PIN 53.

2 RIGHT OR AFT RIGHT DOOR CONNECTION IS SHOWN. FOR THE FORWARD RIGHT DOOR, JUMPER PIN 53 TO PIN 52.

2415658 S00061538608_V4

Emergency Exit Flight Lock System
Figure 902/52-00-00-990-804 (Sheet 2 of 2)

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TASK 52-00-00-440-802

4. DDG 52-22-01 Flight Lock System Inoperative - Restoration

(Figure 902)

A. General

(1) This task puts the airplane back to its usual condition after operation with the emergency exit flight lock system inoperative.

B. References

Reference	Title
31-65-00-750-801	Fault Interrogation for a Maintenance Message (P/B 201)

C. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

D. Access Panels

Number	Name/Location
112A	Forward Access Door

E. Flight Lock System Activation

SUBTASK 52-00-00-440-001

(1) Restore the airplane to its usual condition (Figure 902).

(a) Open these circuit breakers and install safety tags:

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
D	1	C01515	OVERWING FLIGHT LOCK-RIGHT
D	2	C01514	OVERWING FLIGHT LOCK-LEFT

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
D	1	C01399	PSEU PRI
D	2	C01400	PSEU ALTN

(b) To get access to the PSEU, open this access panel:

Number	Name/Location
112A	Forward Access Door

(c) Disconnect, cap and stow the extension wire that was used in the deactivation of the flight lock system.

(d) Install the pins that were removed to the applicable connectors (Table 901).

(e) Close this access panel:

Number	Name/Location
112A	Forward Access Door

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

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
D	1	C01515	OVERWING FLIGHT LOCK-RIGHT
D	2	C01514	OVERWING FLIGHT LOCK-LEFT

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
D	1	C01399	PSEU PRI
D	2	C01400	PSEU ALTN

F. MAINT Light Status Message

SUBTASK 52-00-00-750-001

(1) Uncheck the applicable MAINT light Status Message(s) on the MAINT LIGHT menu (TASK 31-65-00-750-801).

——— END OF TASK ———

TASK 52-00-00-040-803

5. DDG 52-31-01 Lower Cargo Doors Pressure Stop Fittings Broken or Missing - Preparation

(Figure 903)

A. General

(1) This task gives the maintenance steps which prepare the airplane for flight with one or two stop fittings broken or missing on the lower cargo doors inoperative.

B. References

Reference	Title
21-25-00-710-801	Recirculation System - Operational Test (P/B 501)

C. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

D. Procedure

SUBTASK 52-00-00-210-003

(1) Do a visual inspection of the remaining door stop fittings and stop pins as follows:

(a) Examine the door stop fittings.

1) Look for cracks and corrosion.

(b) Examine the stop pins.

1) Look for cracks and corrosion.

2) Look for unwanted particles on the stop pins.

3) Make sure that the retaining springs are installed.

SUBTASK 52-00-00-210-004

(2) If one stop fitting is broken or missing on each door or frame, do a visual inspection to make sure that the cabin pressure controller AUTO mode operates normally.

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SUBTASK 52-00-00-930-001

(3) If two stop fittings are broken or missing on each door or frame, do these steps for unpressurized flight:

(a) Install the placard on the pressure control panel - UNPRESSURIZED FLIGHT ONLY.

(b) Make sure that the recirculation fans operate correctly (TASK 21-25-00-710-801).

(c) Do the next step to prepare for unpressurized flight.

NOTE: Repeat the inspection within 25 flights and complete repairs within 50 flights.

SUBTASK 52-00-00-860-001

(4) Do these steps to prepare for unpressurized flight:

(a) Put the pressurization mode selector on the P5-6 pressurization control panel in the MAN position.

(b) Hold the outflow valve toggle switch in the OPEN position until the valve position indicator indicates FULL OPEN.

(c) Open these circuit breakers and install safety locks:

F/O Electrical System Panel, P6-4

Row	Col	Number	Name
D	2	C01445	A/C OVERBOARD EXH VALVE RECONFIG CONT
F	3	C01270	PRESSURIZATION CONTROL AUTO 1
F	5	C01271	PRESSURIZATION CONTROL AUTO 2

——— END OF TASK ———

TASK 52-00-00-440-803

6. DDG 52-31-01 Lower Cargo Doors Pressure Stop Fittings Broken or Missing - Restoration

(Figure 903)

A. General

(1) This task puts the airplane back to its usual condition after operation with one or two door stop fittings broken or missing on the lower cargo doors inoperative.

B. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

C. Procedure

SUBTASK 52-00-00-440-007

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

F/O Electrical System Panel, P6-4

Row	Col	Number	Name
D	2	C01445	A/C OVERBOARD EXH VALVE RECONFIG CONT
F	3	C01270	PRESSURIZATION CONTROL AUTO 1
F	5	C01271	PRESSURIZATION CONTROL AUTO 2

SUBTASK 52-00-00-860-002

(2) Put the pressurization mode selector on the P5-6 pressurization control panel in the AUTO position.

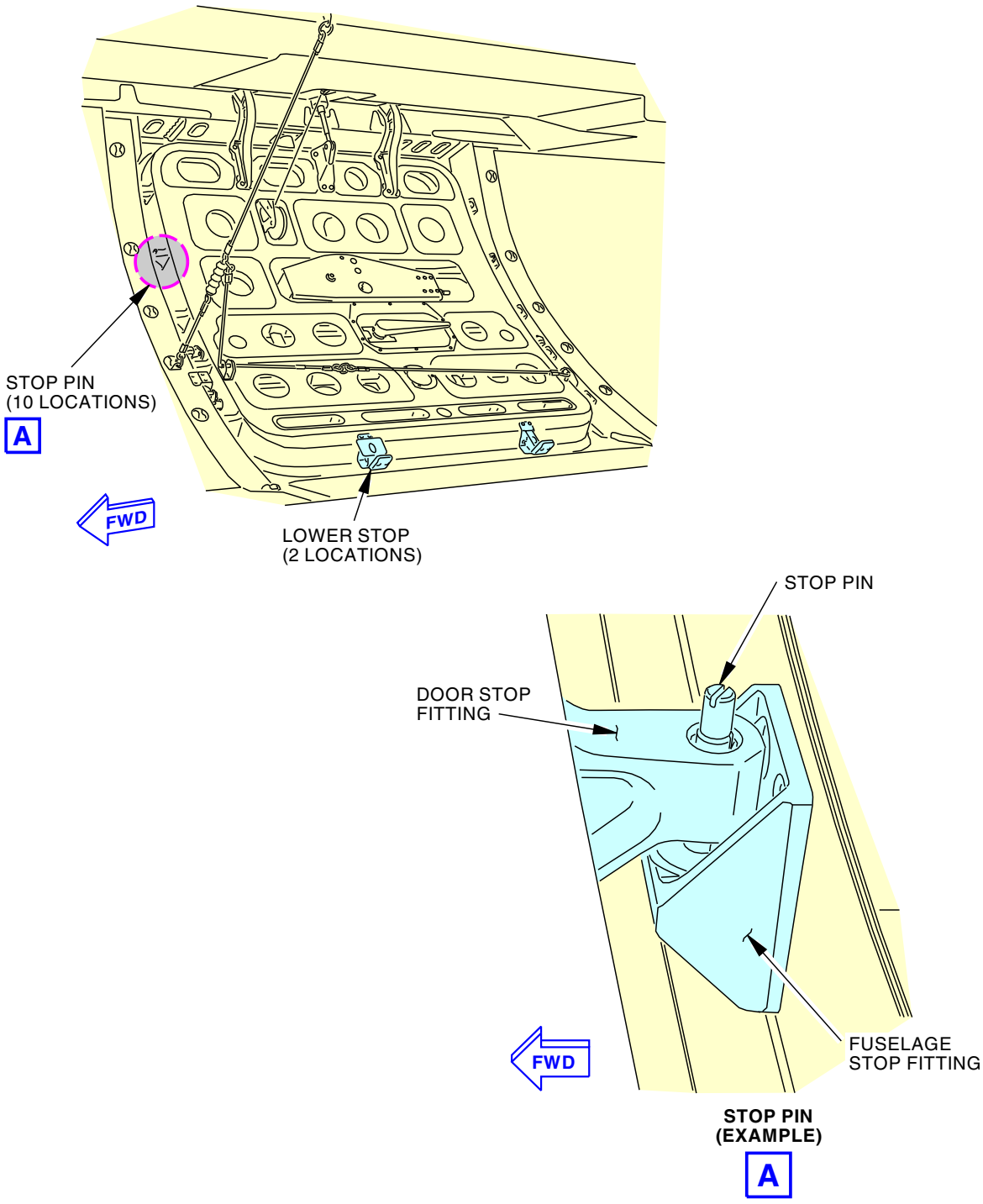
ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-00-00-000-001

(3) Remove the placard on the pressure control panel (forward overhead panel) - UNPRESSURIZED FLIGHT ONLY.

——— END OF TASK ———

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Lower Cargo Doors Pressure Stop Fitting
Figure 903/52-00-00-990-803

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-00-00-040-804

7. DDG 52-31-02 Lower Cargo Doors Door Balance Mechanism Inoperative - Preparation

A. General

(1) This task gives the maintenance steps which prepare the airplane for flight with the lower cargo door balance mechanism inoperative.

B. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

C. Procedure

SUBTASK 52-00-00-210-006

(1) Do one of the following steps to hold the door in the open position:

(a) Use the manual strap device located in the affected cargo compartment ceiling.

(b) Any appropriate safety device or equipment to hold the door open.

——— END OF TASK ———

TASK 52-00-00-040-810

8. DDG 52-31-04 Cargo Door Exterior Handle Recess/Hinge Spring Assemblies Inoperative - Preparation

A. General

(1) This task gives the maintenance steps which prepare the airplane for flight with the cargo door exterior handle recess/hinge spring assemblies inoperative.

B. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

C. Cargo Door Exterior Handle Securing

SUBTASK 52-00-00-800-001

(1) Secure the affected cargo door exterior handle in a recessed position flush with the fuselage.

NOTE: You can use speed tape to secure affected cargo door exterior handle in a recessed position flush with the fuselage. You must clean the area with solvent and use new speed tape each time the affected cargo door exterior handle is used to operate the door during the MMEL deferral period.

——— END OF TASK ———

TASK 52-00-00-040-805

9. DDG 52-51-01 Flight Deck Door Automatic Locking System Inoperative - Preparation

A. General

(1) This task gives the maintenance steps which prepare the airplane for flight with the flight deck security door automatic locking system inoperative.

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B. Location Zones

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

C. Flight Deck Door Automatic Locking System Deactivation

SUBTASK 52-00-00-040-001

(1) Put the Flight Deck Access System switch on the Chime Module in the OFF position (guard extended) to deactivate the automatic locking system.

NOTE: LOCK FAIL light will remain illuminated when the Flight Deck Access System switch is in the OFF position (guard extended).

——— END OF TASK ———

TASK 52-00-00-440-805

10. DDG 52-51-01 Flight Deck Door Automatic Locking System Inoperative - Restoration

A. General

(1) This task puts the airplane back to its usual condition after flight with the flight deck security door automatic locking system inoperative.

B. Location Zones

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

C. Flight Deck Door Automatic Locking System Activation

SUBTASK 52-00-00-440-002

(1) Put the Flight Deck Access System switch in the NORM position (guard closed) to activate the automatic locking system.

——— END OF TASK ———

TASK 52-00-00-040-806

11. DDG 52-51-01-01 Flight Deck Access Panel System (Keypad, Door Chime) Inoperative - Preparation

A. General

(1) This task gives the maintenance steps which prepare the airplane for flight with the flight deck access panel system (keypad, door chime) inoperative.

B. Location Zones

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

C. Flight Deck Access Panel System (Keypad, Door Chime) Deactivation

SUBTASK 52-00-00-040-002

(1) Do these steps to deactivate the keypad at the chime module side:

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(a) Open this circuit breaker and install safety tag:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

(b) Remove the screws that attach the chime module to the door post.

(c) Remove the chime module.

(d) Disconnect the keypad electrical connector from the chime module and stow the electrical connector.

(e) Put the chime module in its position.

(f) Install the screws that attach the chime module to the door post.

(g) Remove the safety tag and close this circuit breaker:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

1) On the Chime Module, make sure that the Flight Deck Access System switch is in the OFF position (guard extended) when the flight deck door is closed and the flight deck is not occupied.

——— END OF TASK ———

TASK 52-00-00-440-806

12. DDG 52-51-01-01 Flight Deck Access Panel System (Keypad, Door Chime) Inoperative - Restoration

A. General

(1) This task puts the airplane back to its usual condition after operation with the flight deck access panel system (keypad, door chime) inoperative.

B. References

Reference	Title
52-51-00-700-801	Flight Compartment Security Door Access System Test (P/B 501)

C. Location Zones

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

D. Flight Deck Access Panel System (Keypad, Door Chime) Activation

SUBTASK 52-00-00-440-003

(1) Do these steps to activate the keypad at the chime module side:

(a) Open this circuit breaker and install safety tag:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

(b) Remove the screws that attach the chime module to the door post.

(c) Remove the chime module.

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(d) Connect the keypad electrical connector to the chime module.

(e) Put the chime module in its position.

(f) Install the screws that attach the chime module to the door post.

(g) Remove the safety tag and close this circuit breaker:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

(h) Do the system test of the flight deck security door access system, do this task: Flight Compartment Security Door Access System Test, TASK 52-51-00-700-801.

——— END OF TASK ———

TASK 52-00-00-710-801

13. DDG 52-51-01-02 Flight Deck Door LOCK FAIL Light Inoperative - Preparation

A. General

(1) This task gives the maintenance steps which prepare the airplane for flight with the flight deck door LOCK FAIL light inoperative.

B. Location Zones

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

C. Automatic Lock Controls Test

SUBTASK 52-00-00-710-002

(1) Do these steps to make sure that the automatic lock controls operate normally:

(a) Open the flight deck door.

(b) Make sure that the Flight Deck Access System switch on the chime module is in the NORM (guard closed) position.

(c) Make sure that the FLT DK DOOR rotary switch on the Cockpit Control panel Switch/Light Module is in the AUTO position.

(d) Make sure that the electric strike is in the locked position.

NOTE: The solenoid pin in the electric strike will be extended up such that you can not rotate the strike.

(e) Enter the access code in the keypad and press the ENT key.

(f) Make sure that the chime module sounds.

(g) Put and momentarily hold the FLT DK DOOR switch in the DENY position.

(h) Do these steps before the DENY Time Delay has expired:

1) Enter the access code in the keypad and press the ENT key.

2) Make sure that the chime module does not sound.

(i) Set and hold the FLT DK DOOR lock selector in UNLKD position.

(j) Make sure that the electric strike is in the unlocked position.

NOTE: The solenoid pin in the electric strike will retract down such that you can rotate the strike.

(k) Set the FLT DK DOOR lock selector to AUTO.

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(l) Make sure that the electric strike is in the locked position.

NOTE: The solenoid pin in the electric strike will be extended up such that you can not rotate the strike.

——— END OF TASK ———

TASK 52-00-00-710-802

14. DDG 52-51-01-03 Flight Deck Door AUTO UNLK Light Inoperative - Preparation

A. General

(1) This task gives the maintenance steps which prepare the airplane for flight with the flight deck door AUTO UNLK light inoperative.

B. Location Zones

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

C. Automatic Lock Controls Test

SUBTASK 52-00-00-710-003

(1) Do these steps to make sure that the automatic lock controls operate normally:

(a) Open the flight deck door.

(b) Make sure that the Flight Deck Access System switch on the chime module is in the NORM (guard closed) position.

(c) Make sure that the FLT DK DOOR rotary switch on the Cockpit Control panel Switch/Light Module is in the AUTO position.

(d) Make sure that the electric strike is in the locked position.

NOTE: The solenoid pin in the electric strike will be extended up such that you can not rotate the strike.

(e) Enter the access code in the keypad and press the ENT key.

(f) Make sure that the chime module sounds.

(g) Set and momentarily hold the FLT DK DOOR switch in the DENY position.

(h) Do these steps before the DENY Time Delay has expired:

1) Enter the access code in the keypad and press the ENT key.

2) Make sure that the chime module does not sound.

(i) Set and hold the FLT DK DOOR switch to the UNLKD position.

(j) Make sure that the electric strike is in the unlocked position.

NOTE: The solenoid pin in the electric strike will retract down such that you can rotate the strike.

(k) Set the FLT DK DOOR switch back to the AUTO position.

(l) Make sure that the electric strike is in the locked position.

NOTE: The solenoid pin in the electric strike will be extended up such that you can not rotate the strike.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-00-00-040-807

15. DDG 52-51-01-04 Flight Deck Door Lock Control Selector Inoperative - Preparation

A. General

(1) This task gives the maintenance steps which prepare the airplane for flight with the flight deck door lock control selector inoperative.

B. Location Zones

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

C. Flight Deck Door Lock Control Selector Deactivation

SUBTASK 52-00-00-040-003

(1) Do these steps to deactivate the keypad at the chime module side:

(a) Open this circuit breaker and install safety tag:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

(b) Remove the screws that attach the chime module to the door post.

(c) Remove the chime module.

(d) Disconnect the keypad electrical connector from the chime module and stow the electrical connector.

(e) Put the chime module in its position.

(f) Install the screws that attach the chime module to the door post.

(g) Install an INOP placard adjacent to the keypad.

(h) Remove the safety tag and close this circuit breaker:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

1) Make sure that the Flight Deck Access System switch is in the OFF position (guard extended) when the flight deck door is closed and the flight deck is not occupied.

SUBTASK 52-00-00-710-004

(2) Do these steps to make sure the automatic lock operates normally:

(a) Open the flight deck door.

(b) Make sure that the Flight Deck Access System switch on the chime module is in the NORM (guard closed) position.

(c) Make sure that the electric strike is in the locked position.

NOTE: The solenoid pin in the electric strike will be extended up such that you can not rotate the strike.

(d) Set the Flight Deck Access System switch on the Chime Module to the OFF position (guard extended).

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(e) Make sure that the electric strike is in the unlocked position.

NOTE: The solenoid pin in the electric strike will retract down such that you can rotate the strike.

(f) Set the Flight Deck Access System switch on the chime module in the NORM (guard closed) position.

(g) Make sure that the electric strike is in the locked position.

NOTE: The solenoid pin in the electric strike will be extended up such that you can not rotate the strike.

——— END OF TASK ———

TASK 52-00-00-440-807

16. DDG 52-51-01-04 Flight Deck Door Lock Control Selector Inoperative - Restoration

A. General

(1) This task puts the airplane back to its usual condition after operation with the flight deck door control selector inoperative.

B. References

Reference	Title
52-51-00-700-801	Flight Compartment Security Door Access System Test (P/B 501)

C. Location Zones

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

D. Flight Deck Door Lock Control Selector Activation

SUBTASK 52-00-00-440-004

(1) Do these steps to activate the keypad at the chime module side:

(a) Open this circuit breaker and install safety tag:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

(b) Remove the screws that attach the chime module to the door post.

(c) Remove the chime module.

(d) Connect the keypad electrical connector to the chime module.

(e) Put the chime module in its position.

(f) Install the screws that attach the chime module to the door post.

(g) Remove the INOP placard from the keypad.

(h) Remove the safety tag and close this circuit breaker:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

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(i) Do the system test of the flight deck security door access system, do this task: Flight Compartment Security Door Access System Test, TASK 52-51-00-700-801.

——— END OF TASK ———

TASK 52-00-00-040-808

17. DDG 52-71-01-01 Door Warning Light System (Entry and Service) Inoperative - Preparation

A. General

(1) This task gives the maintenance steps which prepare the airplane for flight with the entry and service door warning light system inoperative.

NOTE: If two or more entry/service door warning lights are inoperative due to failed door sensors, all flight lock systems are considered inoperative (TASK 52-00-00-040-809).

B. References

Reference	Title
31-65-00-750-801	Fault Interrogation for a Maintenance Message (P/B 201)
32-09-10-740-801	Proximity Switch Electronics Unit - Operational Test (P/B 501)
52-71-11-000-801	Entry and Galley Service Door Indication Sensor Removal (S194, S195, S199, or S200) (P/B 201)

C. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
821	Forward Cargo Door
822	Aft Cargo Door
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

D. Door Warning Light System (Entry and Service) Deactivation

SUBTASK 52-00-00-020-004

(1) If it is necessary, deactivate a faulty forward entry door indication.

(a) Remove the wire W2216-0012-24 at the connector D1406 pin 8 on the Door Warning Annunciator Module, P5-20 (TASK 52-71-11-000-801).

1) Cap and stow the disconnected wire.

(b) Make sure that the FWD ENTRY door light remains off while the door is open.

(c) Do the PSEU self-test (TASK 32-09-10-740-801).

NOTE: With the FWD ENTRY door light disconnected, the PSEU self-test will fail and report the DOOR FWD ENTRY status message.

(d) Make sure that the forward entry door is closed and latched.

SUBTASK 52-00-00-020-005

(2) If it is necessary, deactivate a faulty aft entry door indication.

(a) Remove the wire W2216-0003-24 at the connector D1406 pin 5 on the Door Warning Annunciator Module, P5-20 (TASK 52-71-11-000-801).

1) Cap and stow the disconnected wire.

(b) Make sure that the AFT ENTRY door light remains off while the door is open.

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(c) Do the PSEU self-test (TASK 32-09-10-740-801).

NOTE: With the AFT ENTRY door light disconnected, the PSEU self-test will fail and report the DOOR AFT ENTRY status message.

(d) Make sure that the aft entry door is closed and latched.

SUBTASK 52-00-00-020-006

(3) If it is necessary, deactivate a faulty forward service door indication.

(a) Remove wire W2216-0004-24 at the connector D1406 pin 2 on the Door Warning Annunciator Module, P5-20 (TASK 52-71-11-000-801).

1) Cap and stow the disconnected wire.

(b) Make sure that the FWD SERVICE door light remains off while the door is open.

(c) Do the PSEU self-test (TASK 32-09-10-740-801).

NOTE: With the FWD SERVICE door light disconnected, PSEU self-test will fail and report the DOOR FWD SERVICE status message.

(d) Make sure that the forward service door is closed and latched.

SUBTASK 52-00-00-020-007

(4) If it is necessary, deactivate a faulty aft service door indication.

(a) Remove wire W2216-0005-24 at the connector D1406 pin 3 on the Door Warning Annunciator Module, P5-20 (TASK 52-71-11-000-801).

1) Cap and stow the disconnected wire.

(b) Make sure that the SERVICE door light remains off while the door is open.

(c) Do the PSEU self-test (TASK 32-09-10-740-801).

NOTE: With the AFT SERVICE door light disconnected, PSEU self-test will fail and report the DOOR AFT SERVICE status message.

(d) Make sure that the aft service door is closed and latched.

SUBTASK 52-00-00-860-005

(5) Make sure that the MAINT light does not turn on for the associated active status message (TASK 31-65-00-750-801).

SUBTASK 52-00-00-200-001

(6) Install an INDICATOR INOP placard adjacent to the applicable door warning light on the P5 overhead panel.

SUBTASK 52-00-00-810-004

(7) If it is necessary, extinguish the MAINT light on the P5-1 panel (TASK 31-65-00-750-801).

——— END OF TASK ———

TASK 52-00-00-440-808

18. DDG 52-71-01-01 Door Warning Light System (Entry and Service) Inoperative - Restoration

A. General

(1) This task puts the airplane back to its usual condition after operation with the entry and service door warning light system inoperative.

B. References

Reference	Title
31-65-00-750-801	Fault Interrogation for a Maintenance Message (P/B 201)

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(Continued)

Reference	Title
52-71-11-400-801	Entry and Galley Service Door Indication Sensor Installation (S194, S195, S199, or S200) (P/B 201)

C. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
821	Forward Cargo Door
822	Aft Cargo Door
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

D. Door Warning Light System (Entry and Service) Activation

SUBTASK 52-00-00-420-003

(1) To activate the forward entry door indication, connect the wire W2216-0012-24 at the connector D1406 pin 8 on the Door Warning Annunciator Module, P5-20 (TASK 52-71-11-400-801).

SUBTASK 52-00-00-420-004

(2) To activate the aft entry door indication, connect the wire W2216-0003-24 at the connector D1406 pin 5 on the Door Warning Annunciator Module, P5-20 (TASK 52-71-11-400-801).

SUBTASK 52-00-00-420-005

(3) To activate the forward service door indication, connect the wire W2216-0004-24 at the connector D1406 pin 2 on the Door Warning Annunciator Module, P5-20 (TASK 52-71-11-400-801).

SUBTASK 52-00-00-420-006

(4) To activate the aft service door indication, connect the wire W2216-0005-24 at the connector D1406 pin 3 on the Door Warning Annunciator Module, P5-20 (TASK 52-71-11-400-801).

SUBTASK 52-00-00-810-001

(5) Remove the INDICATOR INOP placard from the door warning light on the P5 overhead panel.

E. MAINT Light Status Message

SUBTASK 52-00-00-750-002

(1) Uncheck the applicable MAINT light Status Message(s) on the MAINT LIGHT menu (TASK 31-65-00-750-801).

——— END OF TASK ———

TASK 52-00-00-040-812

19. DDG 52-71-01-02 Door Warning Light System (Cargo and Access) Inoperative - Preparation

A. General

(1) This task gives the maintenance steps which prepare the airplane for flight with the cargo and access door warning light system inoperative.

B. References

Reference	Title
31-65-00-750-801	Fault Interrogation for a Maintenance Message (P/B 201)

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(Continued)

Reference	Title
52-71-00 P/B 201	DOOR WARNING SYSTEM - MAINTENANCE PRACTICES
52-71-31 P/B 201	CARGO DOOR WARNING SYSTEM - MAINTENANCE PRACTICES

C. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
821	Forward Cargo Door
822	Aft Cargo Door
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

D. Door Warning Light System (Cargo and Access) Deactivation

SUBTASK 52-00-00-020-008

(1) If it is necessary, deactivate a faulty forward or aft cargo door indication switch.

(a) Disconnect the ground wire from the applicable cargo door indication switch (PAGEBLOCK 52-71-31/201).

1) Cap and stow the disconnected wire.

(b) Make sure that the applicable cargo door is closed and latched.

(c) Make sure that the affected CARGO DOOR warning light and MASTER CAUTION lights are on.

(d) Press and release the MASTER CAUTION light to reset the light.

SUBTASK 52-00-00-020-009

(2) If it is necessary, deactivate a faulty forward access or electronic equipment access door indication switch.

(a) Disconnect the ground wire from the applicable access door indication switch (PAGEBLOCK 52-71-00/201).

1) Cap and stow the disconnected wire.

(b) Make sure that the applicable access door is closed and latched.

(c) Make sure that the affected EQUIP DOOR warning light and MASTER CAUTION lights are on.

(d) Press and release the MASTER CAUTION light to reset the light.

SUBTASK 52-00-00-860-006

(3) Make sure that the MAINT light does not turn on for the associated active status message (TASK 31-65-00-750-801).

SUBTASK 52-00-00-410-003

(4) Install an INDICATOR INOP placard adjacent to the applicable door warning light on the P5 overhead panel.

SUBTASK 52-00-00-810-007

(5) If it is necessary, extinguish the MAINT light on the P5-1 panel (TASK 31-65-00-750-801).

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-00-00-440-813

20. DDG 52-71-01-02 Door Warning Light System (Cargo and Access) Inoperative - Restoration

A. General

(1) This task puts the airplane back to its usual condition after operation with the cargo and access door warning light system inoperative.

B. References

Reference	Title
31-65-00-750-801	Fault Interrogation for a Maintenance Message (P/B 201)
52-71-00 P/B 201	DOOR WARNING SYSTEM - MAINTENANCE PRACTICES
52-71-31 P/B 201	CARGO DOOR WARNING SYSTEM - MAINTENANCE PRACTICES

C. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
821	Forward Cargo Door
822	Aft Cargo Door
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

D. Door Warning Light System (Cargo and Access) Activation

SUBTASK 52-00-00-420-007

(1) To activate the forward or aft cargo door indication switch, connect the ground wire to the applicable cargo door indication switch (PAGEBLOCK 52-71-31/201).

SUBTASK 52-00-00-420-008

(2) To activate the forward access or electronic equipment access door indication switch, connect the ground wire to the applicable access door indication switch (PAGEBLOCK 52-71-00/201).

SUBTASK 52-00-00-810-008

(3) Remove the INDICATOR INOP placard from the door warning light on the P5 overhead panel.

E. MAINT Light Status Message

SUBTASK 52-00-00-750-005

(1) Uncheck the applicable MAINT light Status Message(s) on the MAINT LIGHT menu (TASK 31-65-00-750-801).

——— END OF TASK ———

TASK 52-00-00-040-813

21. DDG 52-71-01-03 Door Warning Light System (Airstair) Inoperative - Preparation

A. General

(1) This task gives the maintenance steps which prepare the airplane for flight with the airstair door warning light system inoperative.

B. References

Reference	Title
31-65-00-750-801	Fault Interrogation for a Maintenance Message (P/B 201)

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C. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
821	Forward Cargo Door
822	Aft Cargo Door
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

D. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door

E. Door Warning Light System (Airstair) Deactivation

SUBTASK 52-00-00-200-003

(1) Make sure that the airstair door lock pin is engaged.

(a) Open this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

(b) Do a check of the lock pin through the transparent plastic shield.

(c) Close this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

SUBTASK 52-00-00-210-013

(2) Make sure that the airstair door exterior is flush with the fuselage skin.

SUBTASK 52-00-00-200-004

(3) Push inward against the airstair door to make sure that it is closed and latched.

SUBTASK 52-00-00-860-007

(4) Make sure that the MAINT light does not turn on for the associated active status message (TASK 31-65-00-750-801).

SUBTASK 52-00-00-410-004

(5) Install an INDICATOR INOP placard adjacent to the airstair door warning light on the P5 overhead panel.

SUBTASK 52-00-00-810-009

(6) If it is necessary, extinguish the MAINT light on the P5-1 panel (TASK 31-65-00-750-801).

——— END OF TASK ———

TASK 52-00-00-440-814

22. DDG 52-71-01-03 Door Warning Light System (Airstair) Inoperative - Restoration

A. General

(1) This task puts the airplane back to its usual condition after operation with the airstair door warning light system inoperative.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B. References

Reference	Title
31-65-00-750-801	Fault Interrogation for a Maintenance Message (P/B 201)

C. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
821	Forward Cargo Door
822	Aft Cargo Door
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

D. Door Warning Light System (Airstair) Activation

SUBTASK 52-00-00-810-010

(1) Remove the INDICATOR INOP placard from the door warning light on the P5 overhead panel.

E. MAINT Light Status Message

SUBTASK 52-00-00-750-006

(1) Uncheck the applicable MAINT light Status Message(s) on the MAINT LIGHT menu (TASK 31-65-00-750-801).

——— END OF TASK ———

TASK 52-00-00-040-809

23. DDG 52-71-01-04 Door Warning Light System (Overwing) Inoperative - Preparation

A. General

(1) This task gives the maintenance steps which prepare the airplane for flight with the overwing door warning light system inoperative.

B. References

Reference	Title
31-65-00-750-801	Fault Interrogation for a Maintenance Message (P/B 201)
46-13-02-700-803	Existing Flight Deck Effects Check (P/B 201)

C. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

D. Door Warning Light System (Overwing) Deactivation

SIA 001-006 PRE SB 737-32-1555

SUBTASK 52-00-00-210-009

(1) Verify that the associated flight lock is operating normally:

(a) Check PSEU BITE and confirm that the overwing flight lock faults are not displayed (TASK 46-13-02-700-803).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SIA 001-006 PRE SB 737-32-1555 (Continued)

(b) If necessary, inhibit the MAINT light for the associated active status message (TASK 31-65-00-750-801).

SIA ALL

SUBTASK 52-00-00-810-018

(2) Query maintenance messages to identify failed overwing door switches.

SUBTASK 52-00-00-860-016

(3) Open these circuit breakers and install safety tags:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
D	1	C01399	PSEU PRI
D	2	C01400	PSEU ALTN

SUBTASK 52-00-00-420-002

(4) If desired, deactivate the faulty left aft overwing door indication switch(es).

(a) For the left aft overwing door switch A, S1104, do these steps:

1) Remove the wire W5160-0007-20 at the PSEU connector D10986 pin 8.
2) Cap and stow the disconnected wire.
3) Connect the PSEU connector D10986 pin 8 to the ground.

(b) For the left aft overwing door switch B, S1105, do these steps:

1) Remove wire W5160-0022-20 at the PSEU connector D10988 pin 21.
2) Cap and stow the disconnected wire.
3) Connect the PSEU connector D10988 pin 21 to the ground.

SUBTASK 52-00-00-410-001

(5) If desired, deactivate the faulty right aft overwing door indication switch(es).

(a) For the right aft overwing door switch A, S1106, do these steps:

1) Remove wire W5160-0019-20 at the PSEU connector D10986 pin 61.
2) Cap and stow the disconnected wire.
3) Connect the PSEU connector D10986 pin 61 to the ground.

(b) For the right aft overwing door switch B, S1107, do these steps:

1) Remove wire W5160-0017-20 at the PSEU connector D10988 pin 1.
2) Cap and stow the disconnected wire.
3) Connect the PSEU connector D10988 pin 1 to the ground.

SUBTASK 52-00-00-040-005

(6) If desired, deactivate the faulty left forward overwing door indication switch(es).

(a) For the left forward overwing door switch A, S1108, do these steps:

1) Remove wire W5160-0509-20 at the PSEU connector D10986 pin 52.
2) Cap and stow the disconnected wire.
3) Connect the PSEU connector D10986 pin 52 to the ground.

(b) For the left forward overwing door switch B, S1109, do these steps:

1) Remove wire W5160-0533-20 at the PSEU connector D10988 pin 35.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

2) Cap and stow the disconnected wire.

3) Connect the PSEU connector D10988 pin 35 to the ground.

SUBTASK 52-00-00-040-004

(7) If desired, deactivate the faulty right forward overwing door indication switch(es).

(a) For the right forward overwing door switch A, S1110, do these steps:

1) Remove wire W5160-0539-20 at the PSEU connector D10986 pin 15.

2) Cap and stow the disconnected wire.

3) Connect the PSEU connector D10986 pin 15 to the ground.

(b) For the right forward overwing door switch B, S1111, do these steps:

1) Remove wire W5160-0535-20 at the PSEU connector D10988 pin 30.

2) Cap and stow the disconnected wire.

3) Connect the PSEU connector D10988 pin 30 to the ground.

SUBTASK 52-00-00-860-017

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

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
D	1	C01399	PSEU PRI
D	2	C01400	PSEU ALTN

SUBTASK 52-00-00-860-031

(9) Visually inspect the left aft, right aft, left forward, and right forward overwing doors and confirm that they are closed and latched.

SUBTASK 52-00-00-860-032

(10) Confirm that the left aft, right aft, left forward, and right forward overwing door warnings and MASTER CAUTION lights are off.

SIA 007-999; SIA 001-006 POST SB 737-32-1555

SUBTASK 52-00-00-810-014

(11) Verify that the associated flight lock is operating correctly.

(a) Check PSEU BITE and confirm that the overwing flight lock faults are not displayed (TASK 46-13-02-700-803).

SUBTASK 52-00-00-810-011

(12) If necessary, inhibit the MAINT light for the associated active status message (TASK 31-65-00-750-801).

SIA ALL

SUBTASK 52-00-00-200-005

(13) Install an INDICATOR INOP placard adjacent to the applicable door warning light on the P5 overhead panel.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-00-00-440-809

24. DDG 52-71-01-04 Door Warning Light System (Overwing) Inoperative - Restoration

A. General

(1) This task puts the airplane back to its usual condition after operation with the overwing door warning light system inoperative.

B. References

Reference	Title
31-65-00-750-801	Fault Interrogation for a Maintenance Message (P/B 201)

C. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

D. Door Warning Light System (Overwing) Activation

SUBTASK 52-00-00-860-018

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

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
D	1	C01399	PSEU PRI
D	2	C01400	PSEU ALTN

SUBTASK 52-00-00-440-008

(2) Activate the faulty left aft overwing door indication switches.

(a) For the left aft overwing door switch A, S1104, connect the wire W5160-0007-20 to the PSEU connector D10986 pin 8.

(b) For the left aft overwing door switch B, S1105, connect the wire W5160-0022-20 to the PSEU connector D10988 pin 21.

SUBTASK 52-00-00-440-009

(3) Activate the faulty right aft overwing door indication switches.

(a) For the right aft overwing door switch A, S1106, connect the wire W5160-0019-20 to the PSEU connector D10986 pin 61.

(b) For the right aft overwing door switch A, S1107, connect the wire W5160-0019-20 to the PSEU connector D10988 pin 1.

SUBTASK 52-00-00-440-010

(4) Activate the faulty left forward overwing door indication switches.

(a) For the left forward overwing door switch A, S1108, connect the wire W5160-0509-20 to the PSEU connector D10986 pin 52.

(b) For the left forward overwing door switch B, S1109, connect the wire W5160-0533-20 to the PSEU connector D10988 pin 35.

SUBTASK 52-00-00-440-011

(5) Activate the faulty right forward overwing door indication switches.

(a) For the right forward overwing door switch A, S1110, connect the wire W5160-0539-20 to the PSEU connector D10986 pin 15.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) For the right forward overwing door switch B, S1111, connect the wire W5160-0535-20 to the PSEU connector D10988 pin 30.

SUBTASK 52-00-00-860-019

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

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
D	1	C01399	PSEU PRI
D	2	C01400	PSEU ALTN

SUBTASK 52-00-00-810-002

(7) Remove the INDICATOR INOP placard from the overwing door warning light.

E. MAINT Light Status Message

SUBTASK 52-00-00-750-003

(1) Uncheck the applicable MAINT light Status Message(s) on the MAINT LIGHT menu (TASK 31-65-00-750-801).

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

DOORS - FATIGUE INSPECTIONS - MAINTENANCE PRACTICES

1. General

A. This procedure contains scheduled maintenance task data.

TASK 52-05-02-211-803

2. INTERNAL - DETAILED: Electronic Equipment Access Door

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left

B. Access Panels

Number	Name/Location
117AW	Equipment Access Door Cover

C. Inspection

NOTE: Removal of the door lining is required.

SUBTASK 52-05-02-010-003

(1) Open this access panel:

Number	Name/Location
117AW	Equipment Access Door Cover

SUBTASK 52-05-02-211-003

(2) Do a Detailed inspection around fastener locations common to the inner panel and the door frame adjacent to the four (4) door pin locations.

See Doc. D626A010, DTR check form 52-48-04-02 for alternative inspection.

SUBTASK 52-05-02-940-001

(3) Close this access panel:

Number	Name/Location
117AW	Equipment Access Door Cover

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-801

1. EXTERNAL - DETAILED: FLIGHT DECK SECURITY DOOR PANEL ASSEMBLY

A. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

B. Inspection

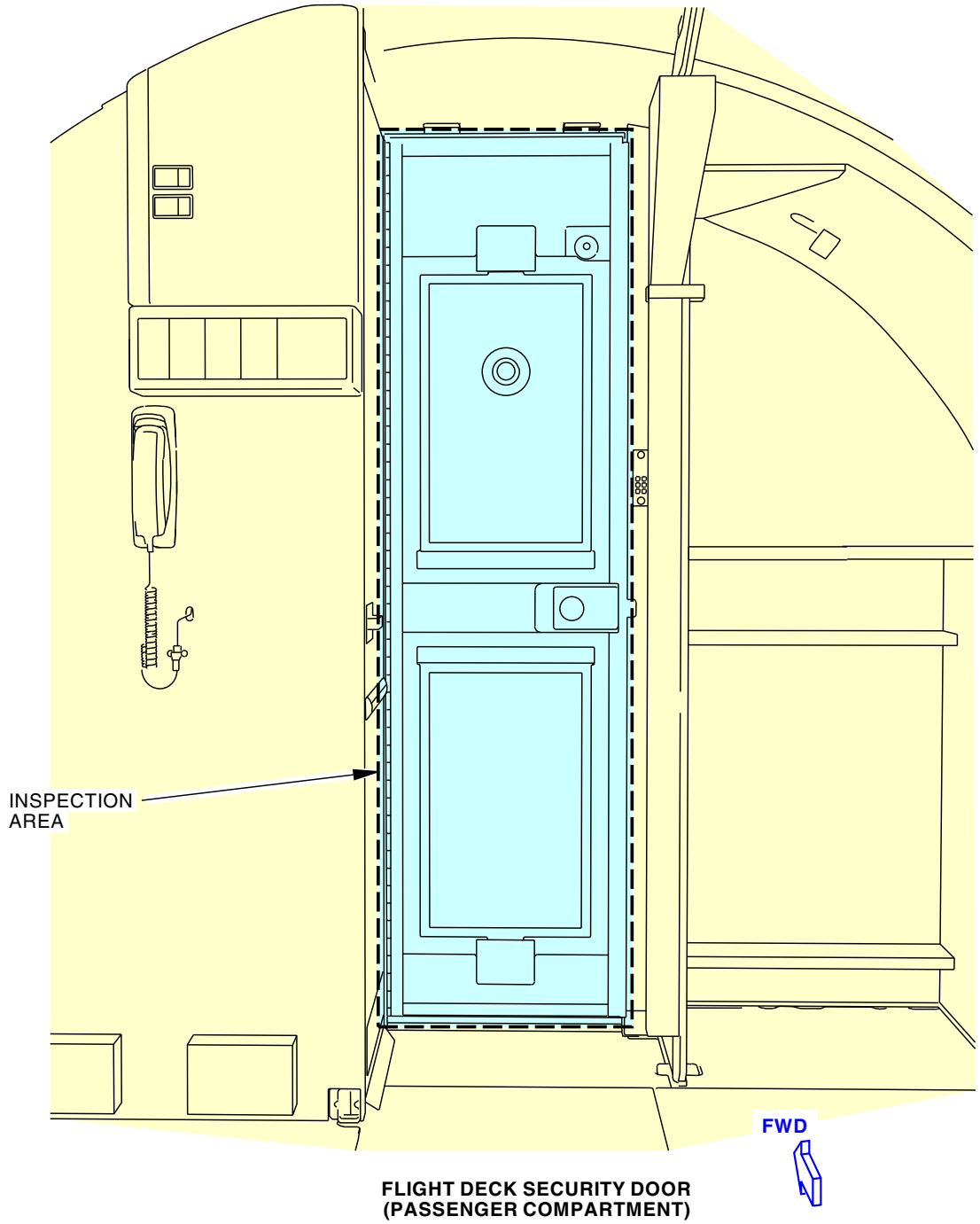
SUBTASK 52-05-03-211-001

(1) Do the inspection of the Flight Deck Security Door Assembly, including Main Door Panel Assy, Main Door Panel Bond Assy, and Armor Laminate Assy.

NOTE: Disassemble door only if evidence of damage, fatigue, delamination, and or bulging is found.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



**FLIGHT DECK SECURITY DOOR
(PASSENGER COMPARTMENT)**

2415659 S00061538626_V1

**Flight Deck Security Door Panel Assembly
Figure 201/52-05-03-990-801**

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-802

2. INTERNAL - DETAILED: FLIGHT DECK SECURITY DOOR PANEL ASSEMBLY

(Figure 202)

A. References

Reference	Title
51-05-01-210-803	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

C. Inspection

NOTE: Disassemble door only if evidence of damage, fatigue, delamination, and or bulging is found.

SUBTASK 52-05-03-211-002

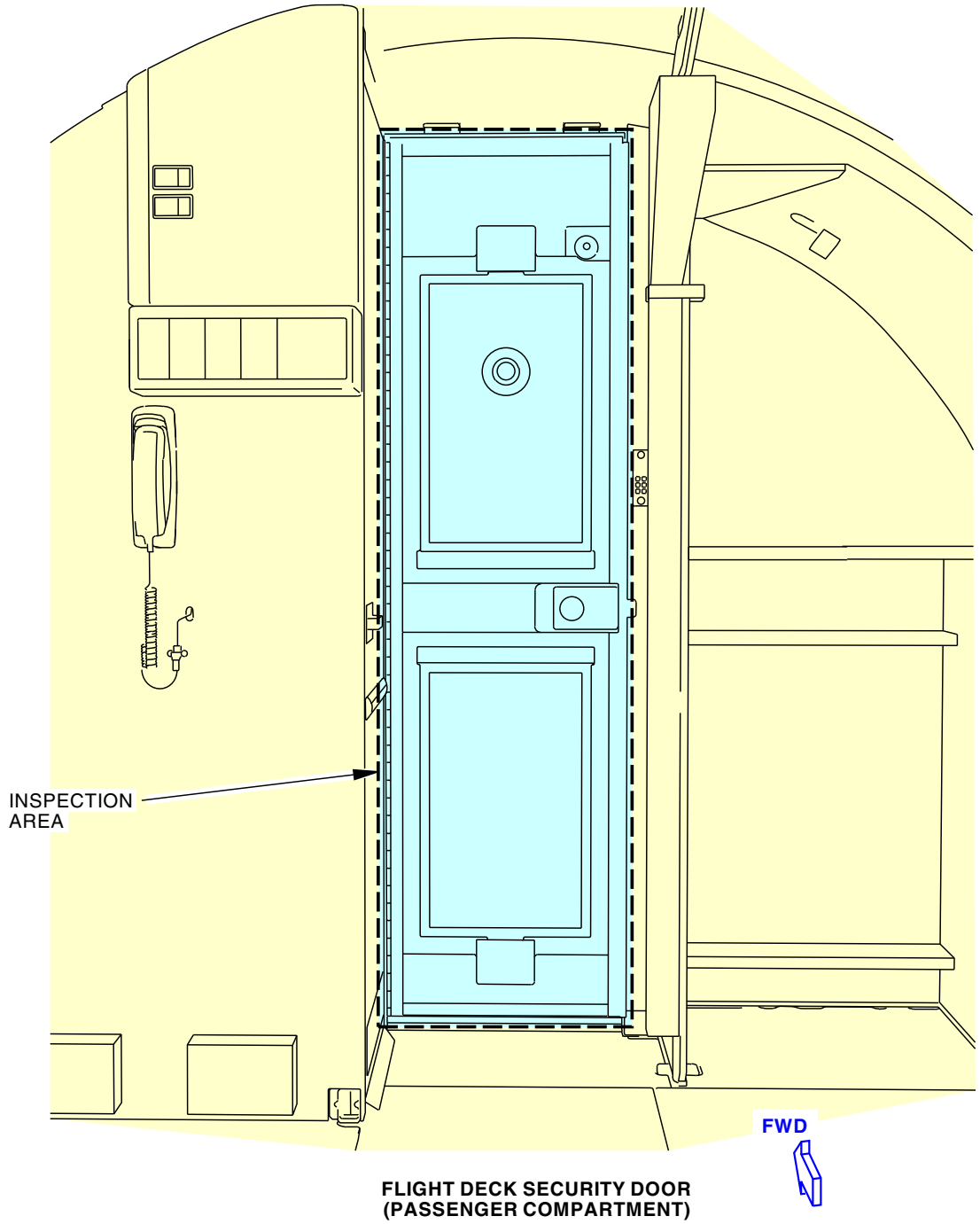
(1) Do a detailed inspection of the Flight Deck Security Door Assembly, including Main Door Panel Assembly, Main Door Panel Bond Assembly, and Armor Laminate Assembly.

SUBTASK 52-05-03-910-001

(2) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-803

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



**FLIGHT DECK SECURITY DOOR
(PASSENGER COMPARTMENT)**

2415659 S00061538626_V1

**Flight Deck Security Door Panel Assembly
Figure 202/52-05-03-990-802**

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-210-801

3. EXTERNAL - GENERAL VISUAL: FLIGHT DECK SECURITY DOOR SURROUND ASSEMBLY

(Figure 203)

A. References

Reference	Title
51-05-01-210-803	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

C. Inspection

NOTE: As visable with carpet, tapestries (if equipped) and kick strips displaced.

SUBTASK 52-05-03-210-001

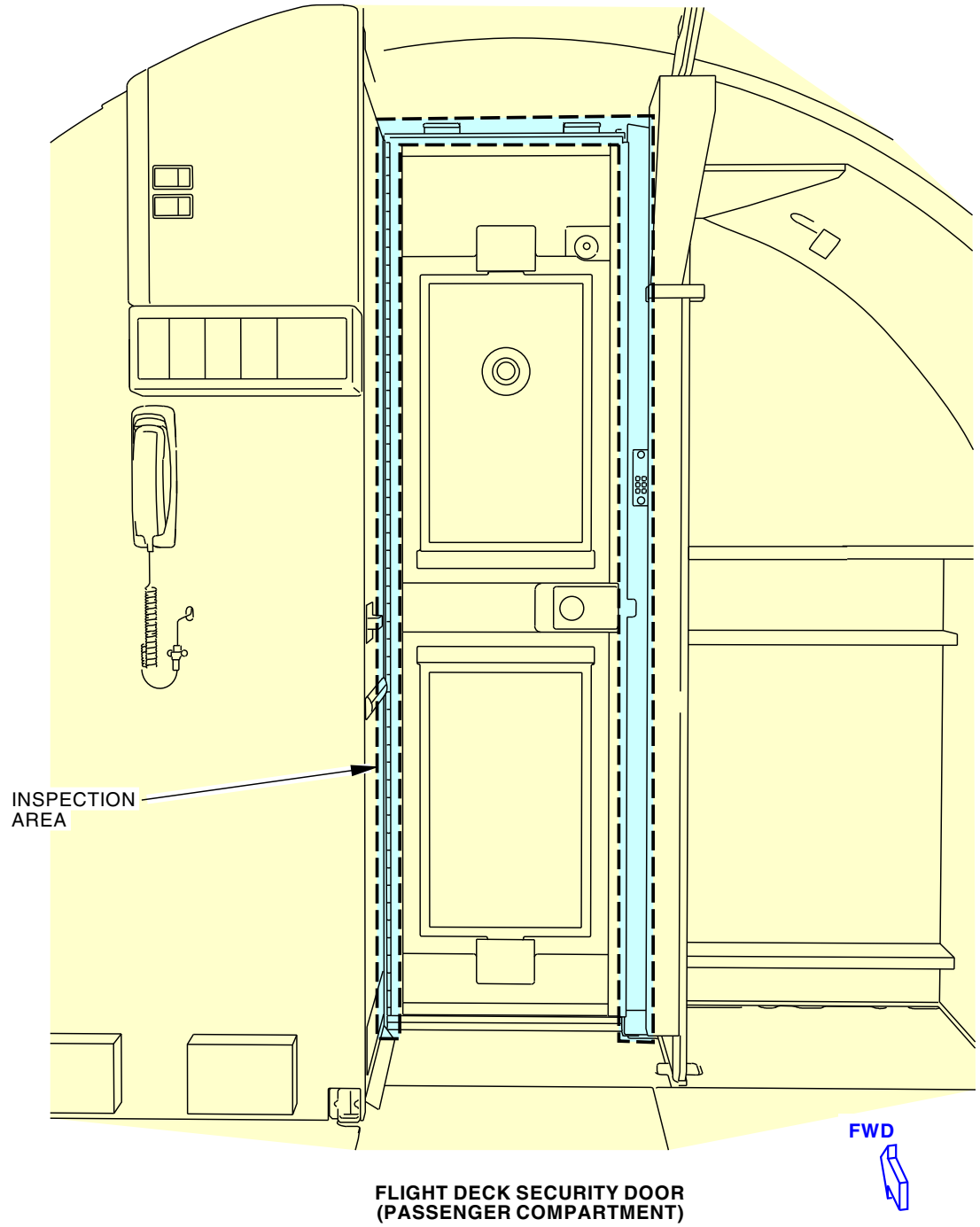
(1) Do a General Visual inspection of the Flight Deck Security Door Surround Assembly, including Header Assembly, Post Assembly (right hand post), Latch and Deadbolt Receiver Assembly, Support Structure, Post Cover Armor Assembly and Hinge Assembly.

SUBTASK 52-05-03-910-002

(2) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-803

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



**FLIGHT DECK SECURITY DOOR
(PASSENGER COMPARTMENT)**

2415660 S00061538629_V1

**Flight Deck Security Door Surround Assembly
Figure 203/52-05-03-990-803**

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-803

4. INTERNAL - DETAILED: FLIGHT DECK SECURITY DOOR SURROUND ASSEMBLY

(Figure 204)

A. References

Reference	Title
51-05-01-210-803	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

C. Inspection

NOTE: For access displace interior furnishings including closets, lavs, galleys (if equipped) adjacent to door frames, and ceiling panels above door.

SUBTASK 52-05-03-211-003

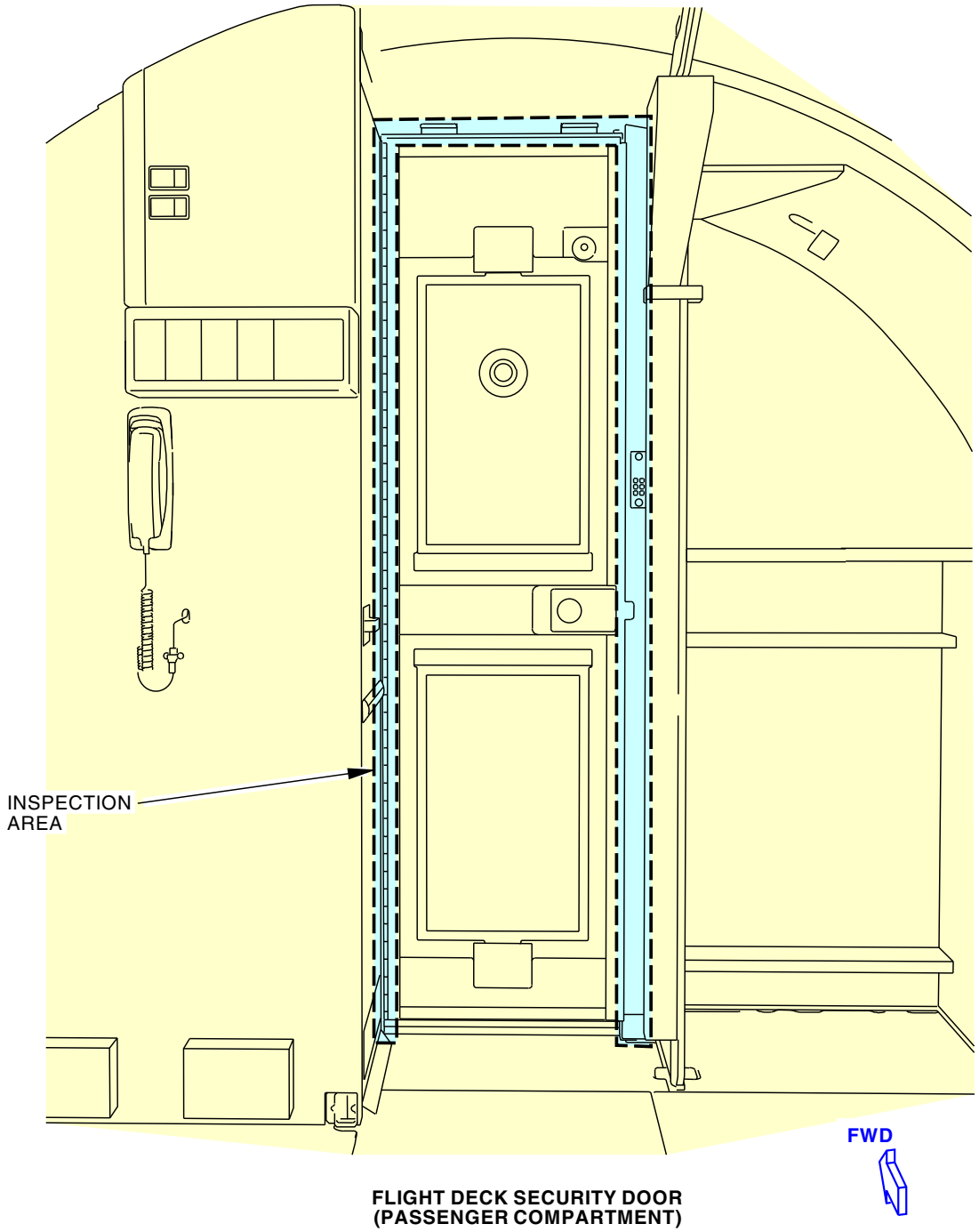
(1) Do a Detailed inspection of the Flight Deck Security Door Surround Assembly, including Header Assembly, Post Assembly (right hand post), Latch and Deadbolt Receiver Assembly, Support Structure, Post Cover Armor Assembly and Hinge Assembly.

SUBTASK 52-05-03-910-003

(2) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-803

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



**FLIGHT DECK SECURITY DOOR
(PASSENGER COMPARTMENT)**

2415660 S00061538629_V1

**Flight Deck Security Door Surround Assembly
Figure 204/52-05-03-990-804**

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-804

5. EXTERNAL - DETAILED: FORWARD ACCESS DOOR STOP FITTINGS, STOP PINS, STOP BUSHINGS AND LATCH PINS

(Figure 205)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

C. Access Panels

Number	Name/Location
112A	Forward Access Door
S1121	Forward Access Door Inspection

D. Inspection

SUBTASK 52-05-03-010-001

(1) Open this access panel:

Number	Name/Location
112A	Forward Access Door

Special Access:

Number	Name/Location
S1121	Forward Access Door Inspection

NOTE: Inspect with door opened and lining not removed.

SUBTASK 52-05-03-211-004

(2) Do a Detailed inspection of the forward access door stop fittings, stop pins, stop bushings and latch pins.

SUBTASK 52-05-03-910-004

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809

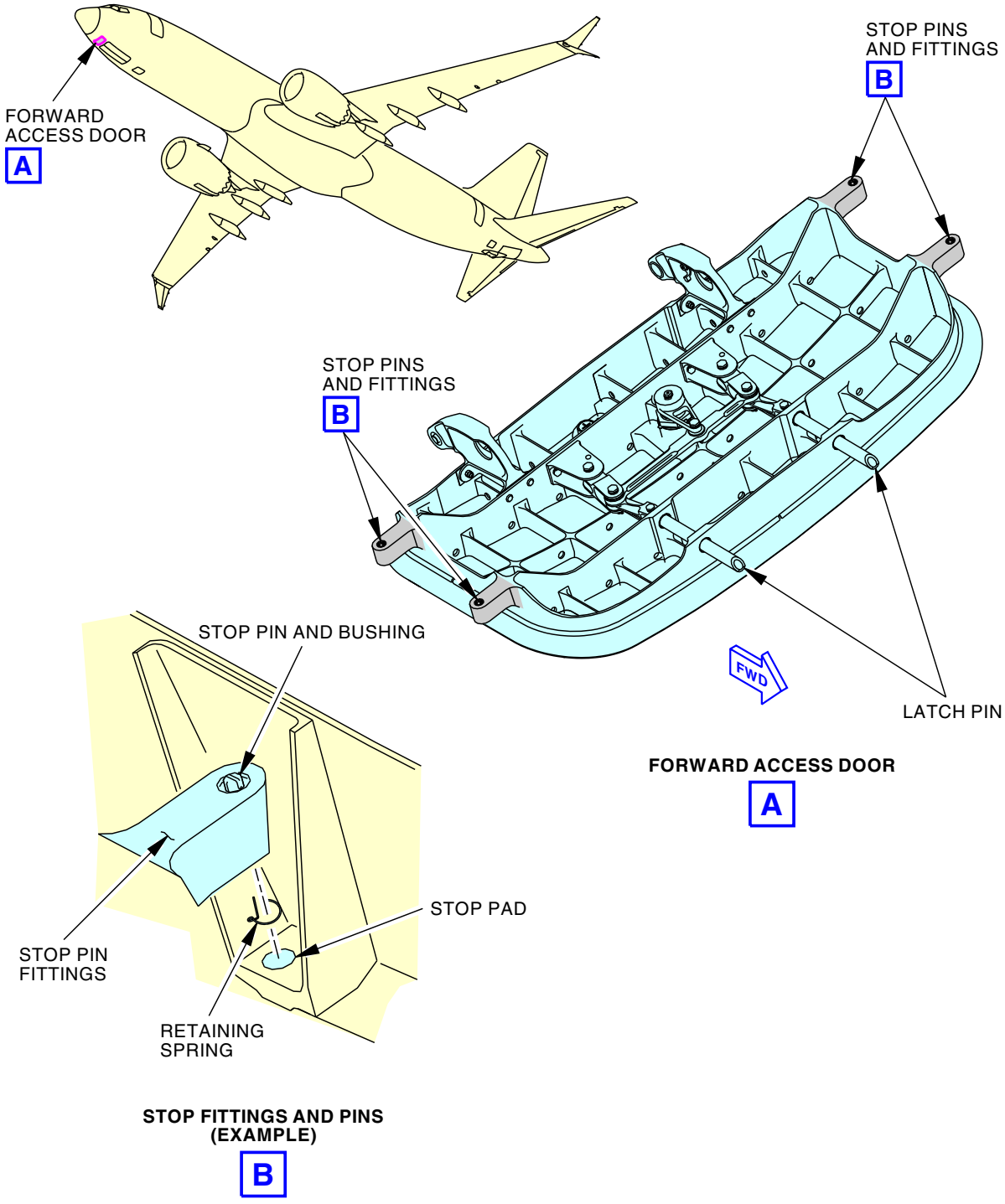
SUBTASK 52-05-03-410-001

(4) Close this access panel:

Number	Name/Location
112A	Forward Access Door

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415661 S00061538632_V4

External - Forward Access Door
Figure 205/52-05-03-990-805

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-210-802

6. INTERNAL - GENERAL VISUAL: FORWARD ACCESS DOOR SKIN AND STRUCTURE.

Figure 206

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-807	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

C. Access Panels

Number	Name/Location
112A	Forward Access Door
S1121	Forward Access Door Inspection

D. Inspection

SUBTASK 52-05-03-010-002

(1) Open this access panel:

Number	Name/Location
112A	Forward Access Door

Special Access:

Number	Name/Location
S1121	Forward Access Door Inspection

SUBTASK 52-05-03-210-002

(2) Do a General Visual inspection of the forward access door skin and structure.

NOTE: Inspect with door removed.

SUBTASK 52-05-03-910-005

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-807

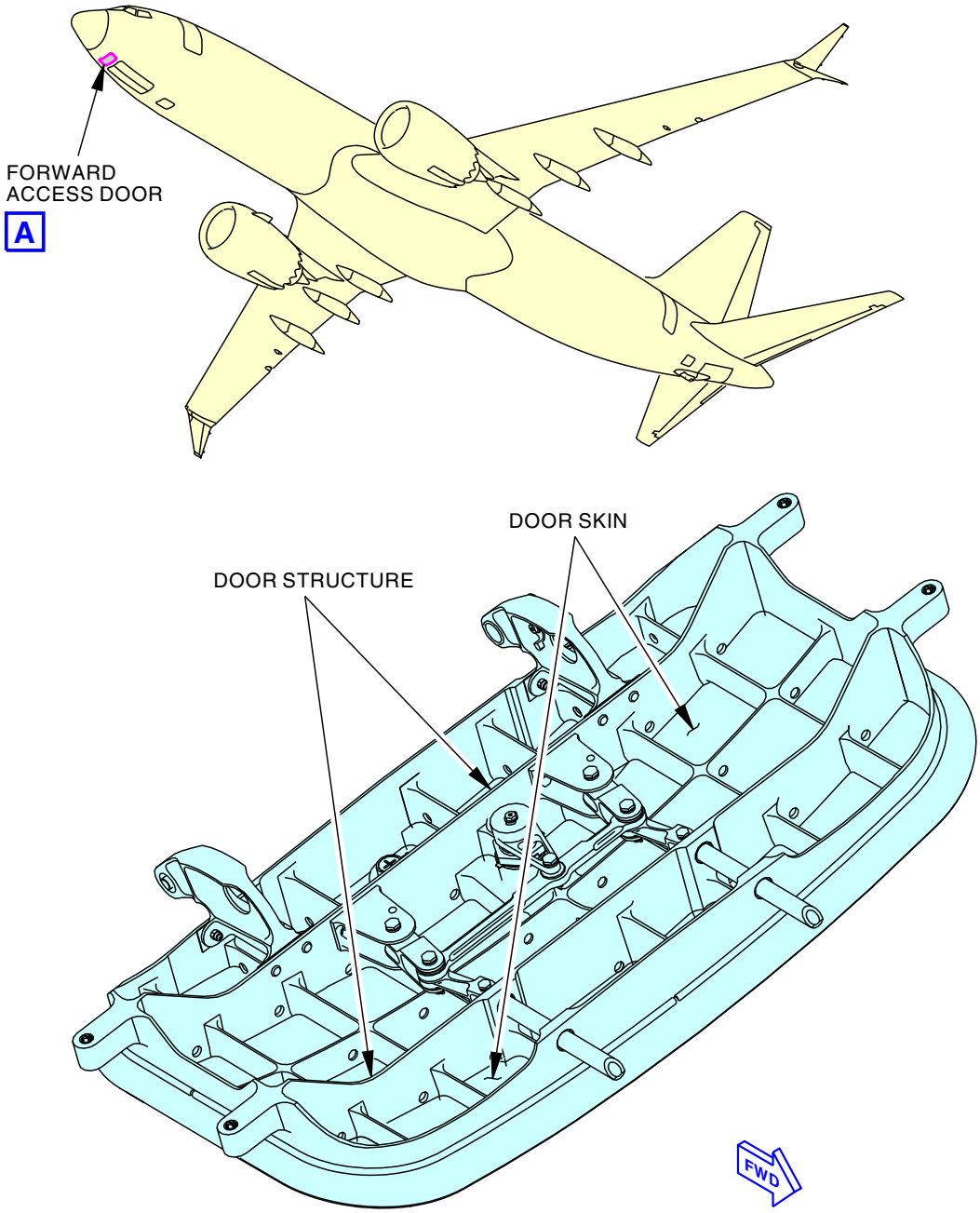
SUBTASK 52-05-03-410-002

(4) Close this access panel:

Number	Name/Location
112A	Forward Access Door

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



FORWARD ACCESS DOOR

A

2415662 S00061538634_V1

Forward Access Door General Visual (Internal)
Figure 206/52-05-03-990-806

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-805

7. EXTERNAL - DETAILED: E/E EQUIPMENT COMPARTMENT ACCESS DOOR STOP FITTINGS AND PINS

(Figure 207)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left

C. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door

D. Inspection

SUBTASK 52-05-03-010-003

(1) Open this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

NOTE: Inspect with door removed as required.

SUBTASK 52-05-03-211-005

(2) Do a Detailed inspection of the E/E equipment compartment access door stop fittings and pins.

SUBTASK 52-05-03-910-006

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809

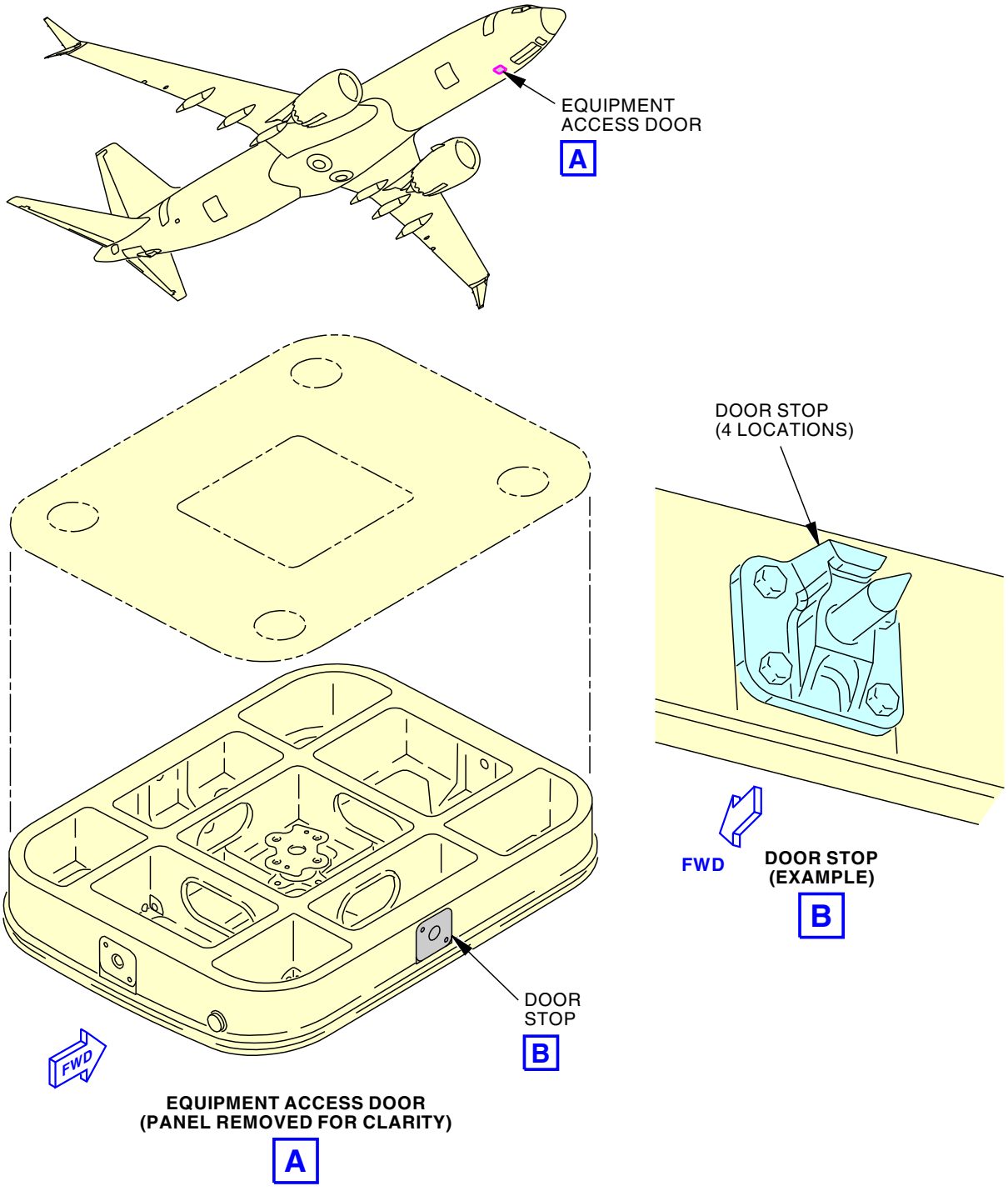
SUBTASK 52-05-03-410-003

(4) Close this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415663 S00061538636_V1

External - Equipment Compartment Access Door
Figure 207/52-05-03-990-807

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-806

8. INTERNAL - DETAILED: E/E EQUIPMENT COMPARTMENT ACCESS DOOR

(Figure 208)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left

C. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door

D. Inspection

SUBTASK 52-05-03-010-004

(1) Open this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

NOTE: Inspect with door and access panel removed. Remove dagger pins as required.

SUBTASK 52-05-03-211-006

(2) Do a Detailed inspection of the E/E equipment compartment access door stop fittings and pins.

SUBTASK 52-05-03-910-007

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809

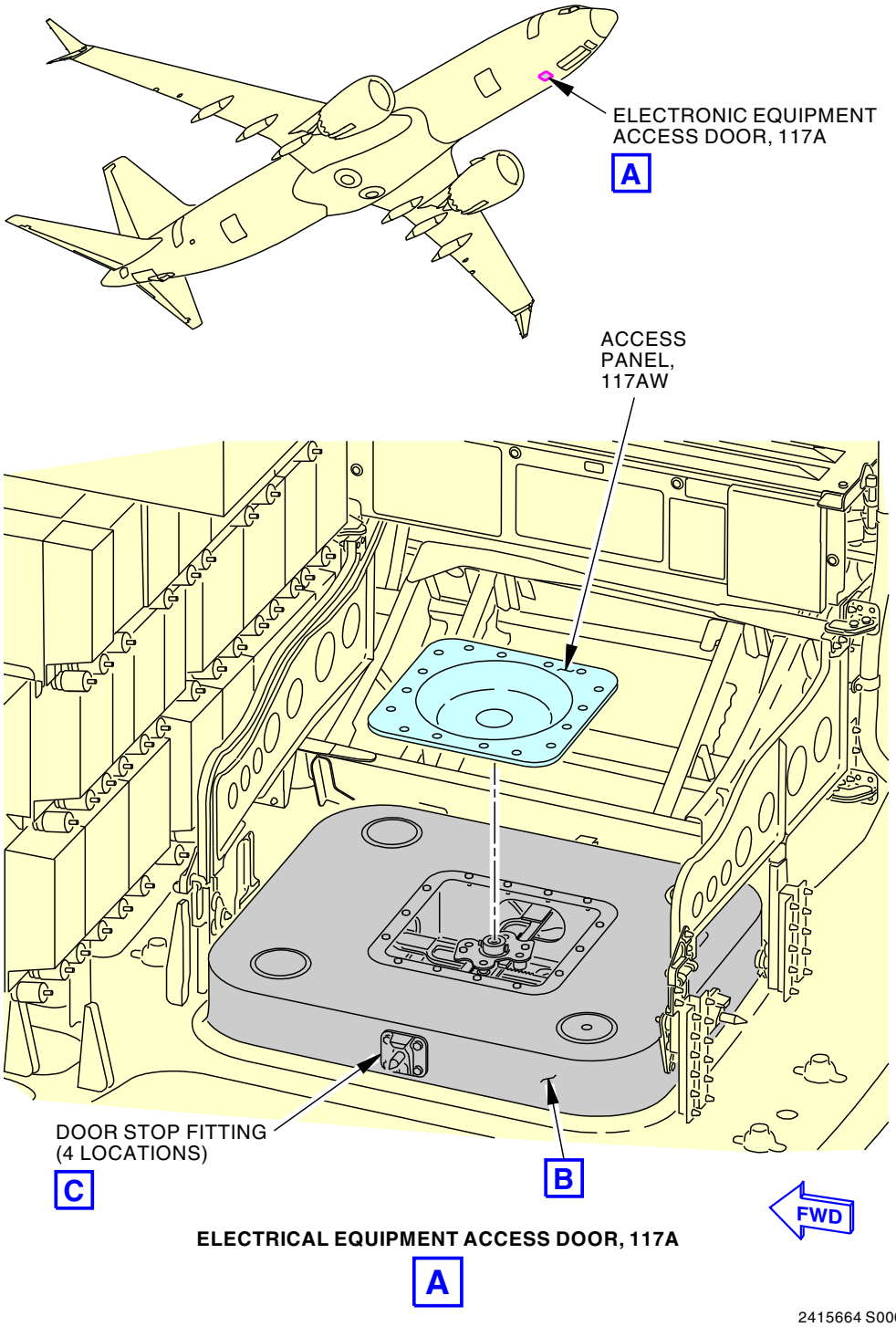
SUBTASK 52-05-03-410-004

(4) Close this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

END OF TASK

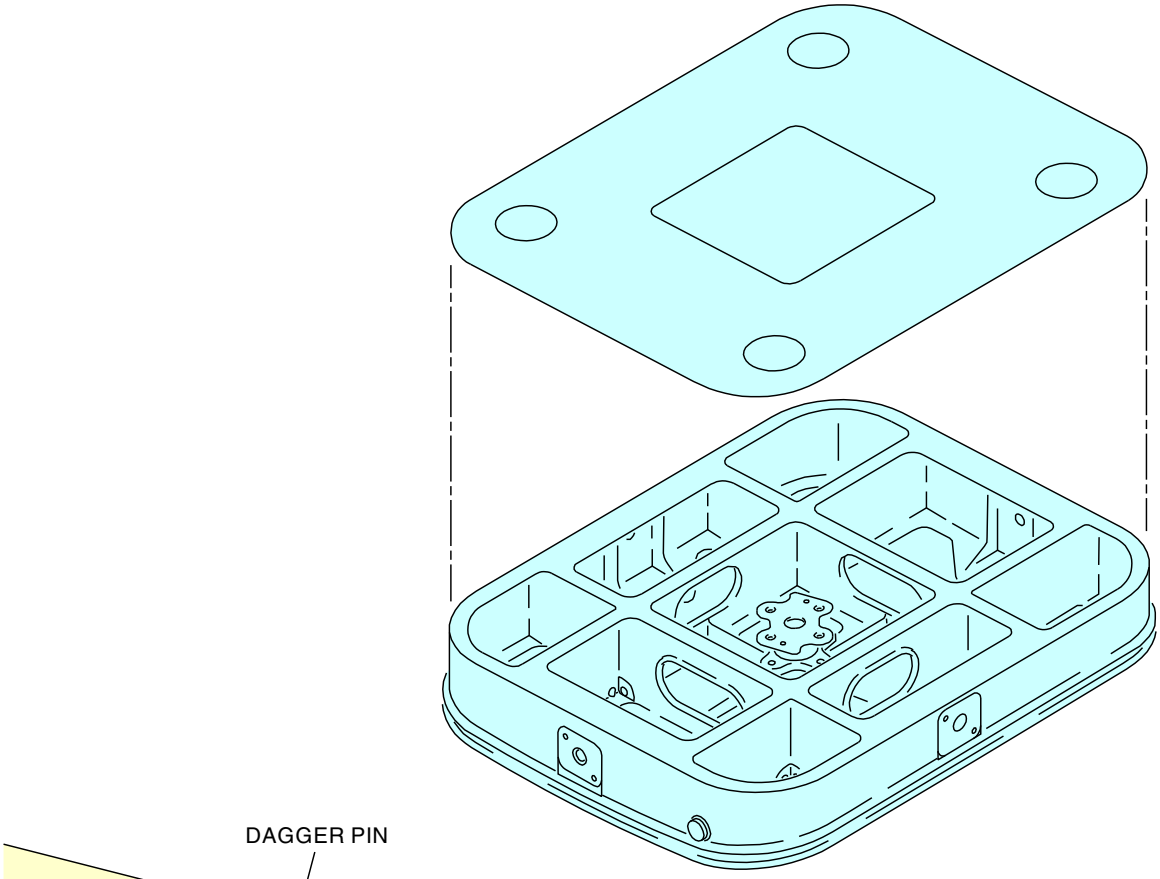
ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415664 S00061538638_V1

Electrical Equipment Access Door Detailed (Internal)
Figure 208/52-05-03-990-808 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



EQUIPMENT ACCESS DOOR
(PANEL REMOVED FOR CLARITY)

B

DOOR STOP FITTING
(EXAMPLE)

C

2415665 S00061538639_V1

Electrical Equipment Access Door Detailed (Internal)
Figure 208/52-05-03-990-808 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-210-803

9. INTERNAL - GENERAL VISUAL: E/E EQUIPMENT COMPARTMENT ACCESS DOOR

(Figure 209)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-804	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left

C. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door

D. Inspection

SUBTASK 52-05-03-010-005

(1) Open this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

NOTE: Inspect with door and access panel removed. Remove dagger pins as required.

SUBTASK 52-05-03-210-003

(2) Do a General Visual inspection of the E/E equipment compartment door skin and structure.

SUBTASK 52-05-03-910-008

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-804

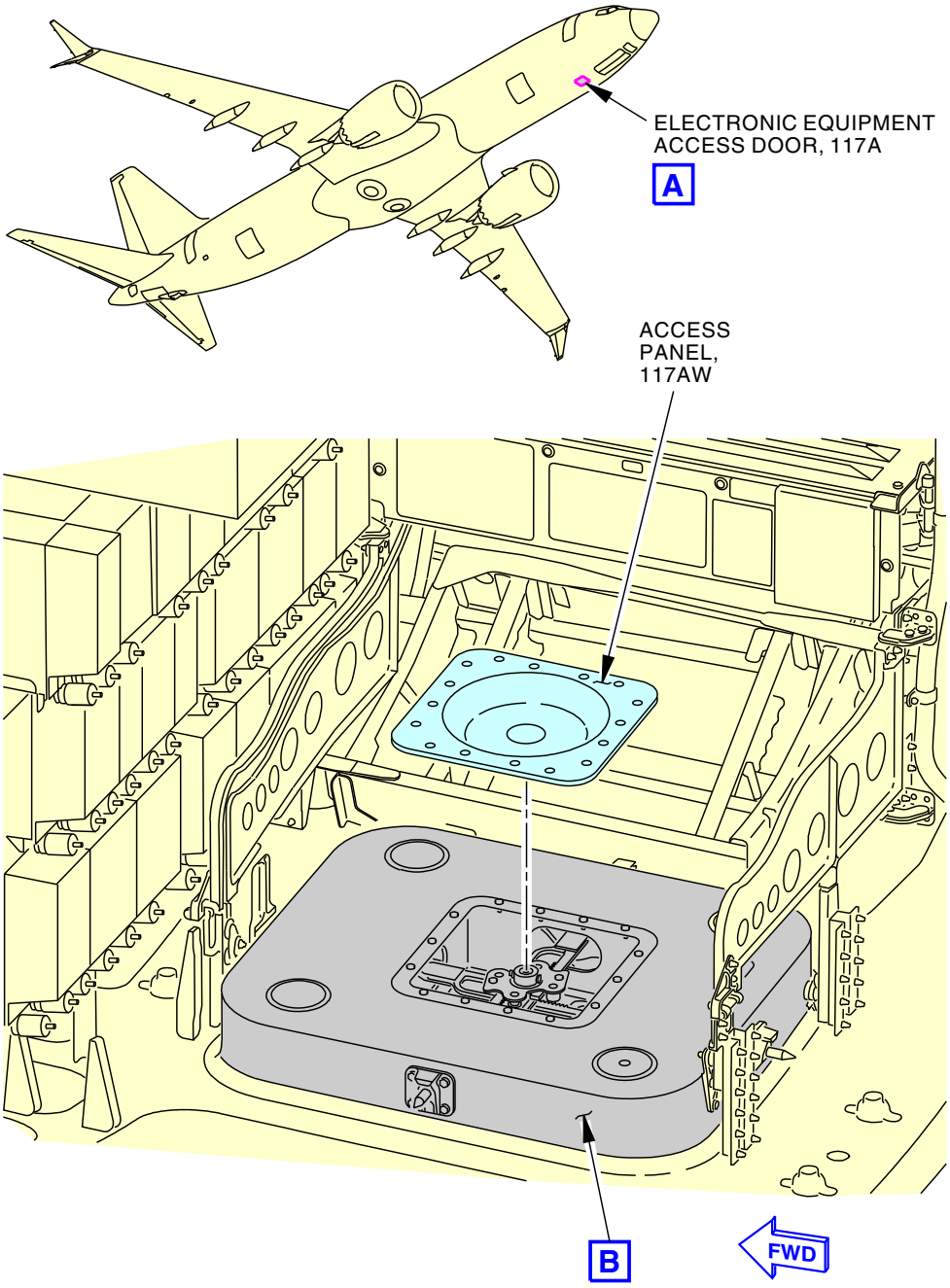
SUBTASK 52-05-03-410-005

(4) Close this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



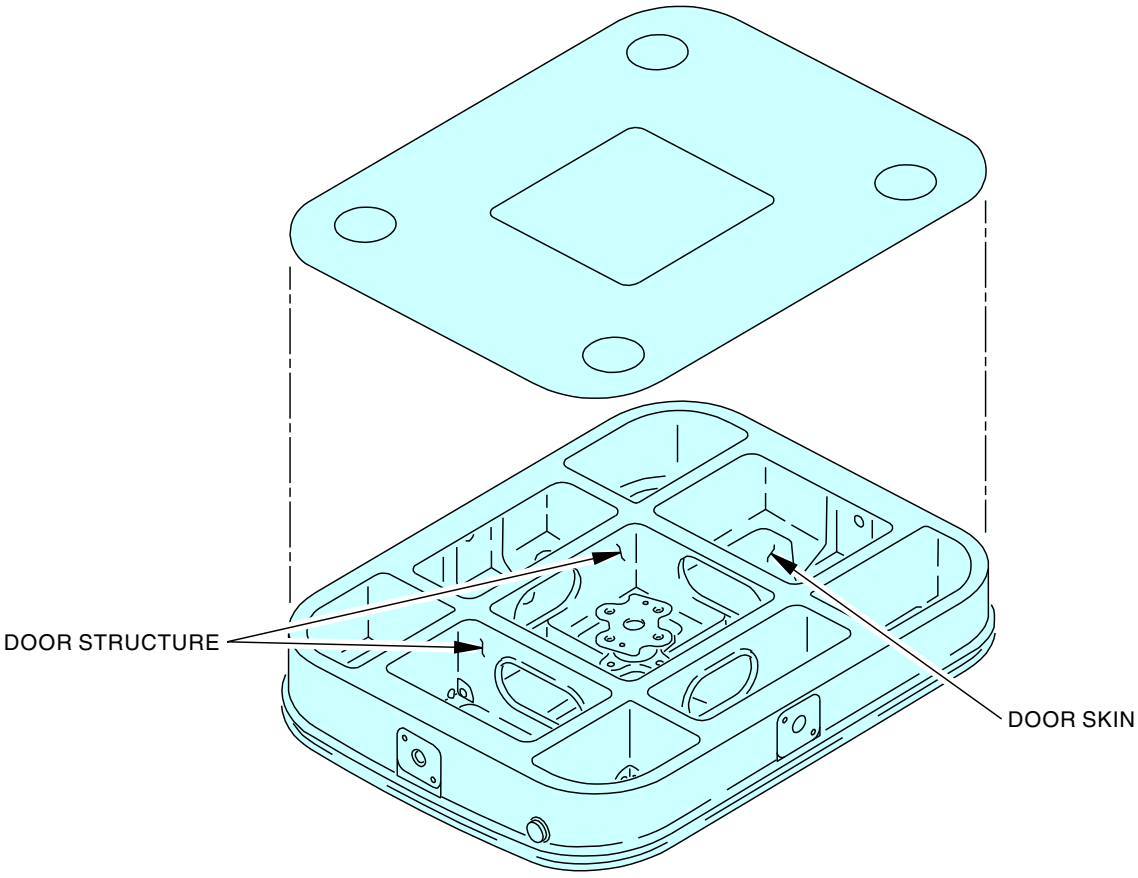
ELECTRICAL EQUIPMENT ACCESS DOOR, 117A

A

2415666 S00061538641_V1

Electrical Equipment Access Door General Visual (Internal)
Figure 209/52-05-03-990-809 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



EQUIPMENT ACCESS DOOR
(PANEL REMOVED FOR CLARITY)

B

2415667 S00061538642_V1

Electrical Equipment Access Door General Visual (Internal)
Figure 209/52-05-03-990-809 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-807

10. EXTERNAL - DETAILED: FORWARD ENTRY DOOR STOP FITTINGS AND PINS

(Figure 210)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
831	Forward Entry Door

C. Access Panels

Number	Name/Location
831	Forward Entry Door

D. Inspection

SUBTASK 52-05-03-010-006

(1) Open this access panel:

Number	Name/Location
831	Forward Entry Door

NOTE: Inspect with doors opened and lining not removed.

SUBTASK 52-05-03-211-007

(2) Do a Detailed inspection of the forward entry door stop fittings and pins.

SUBTASK 52-05-03-910-009

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809

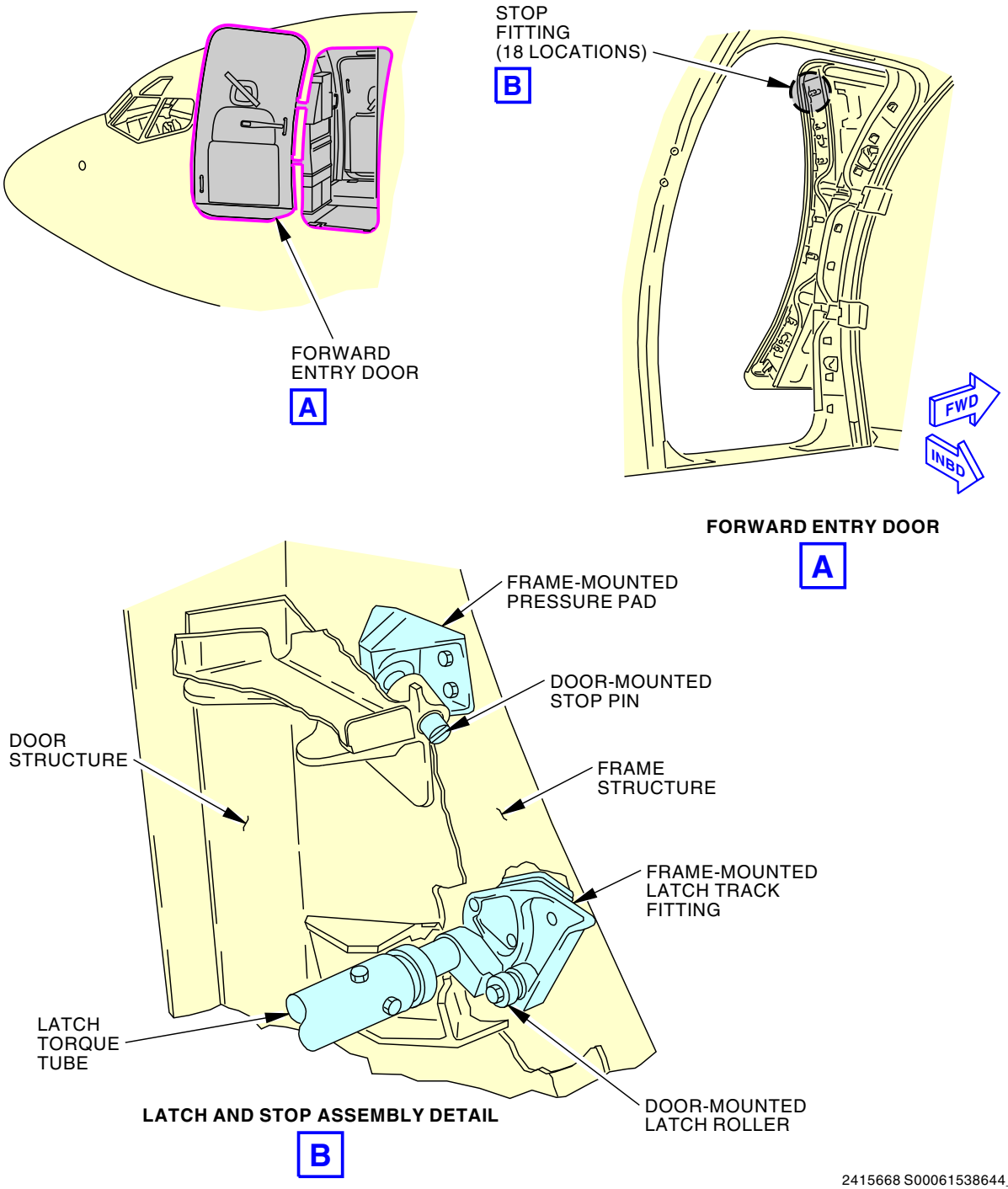
SUBTASK 52-05-03-410-006

(4) Close this access panel:

Number	Name/Location
831	Forward Entry Door

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



External - Forward Entry Door
Figure 210/52-05-03-990-810

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-808

11. EXTERNAL - DETAILED: FORWARD GALLEY SERVICE DOOR STOP FITTINGS AND PINS

(Figure 211)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
841	Forward Galley Service Door

C. Access Panels

Number	Name/Location
841	Forward Galley Service Door

D. Inspection

SUBTASK 52-05-03-010-007

(1) Open this access panel:

Number	Name/Location
841	Forward Galley Service Door

NOTE: Inspect with doors opened and lining not removed.

SUBTASK 52-05-03-211-008

(2) Do a Detailed inspection of the forward galley service door stop fittings and pins.

SUBTASK 52-05-03-910-010

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809

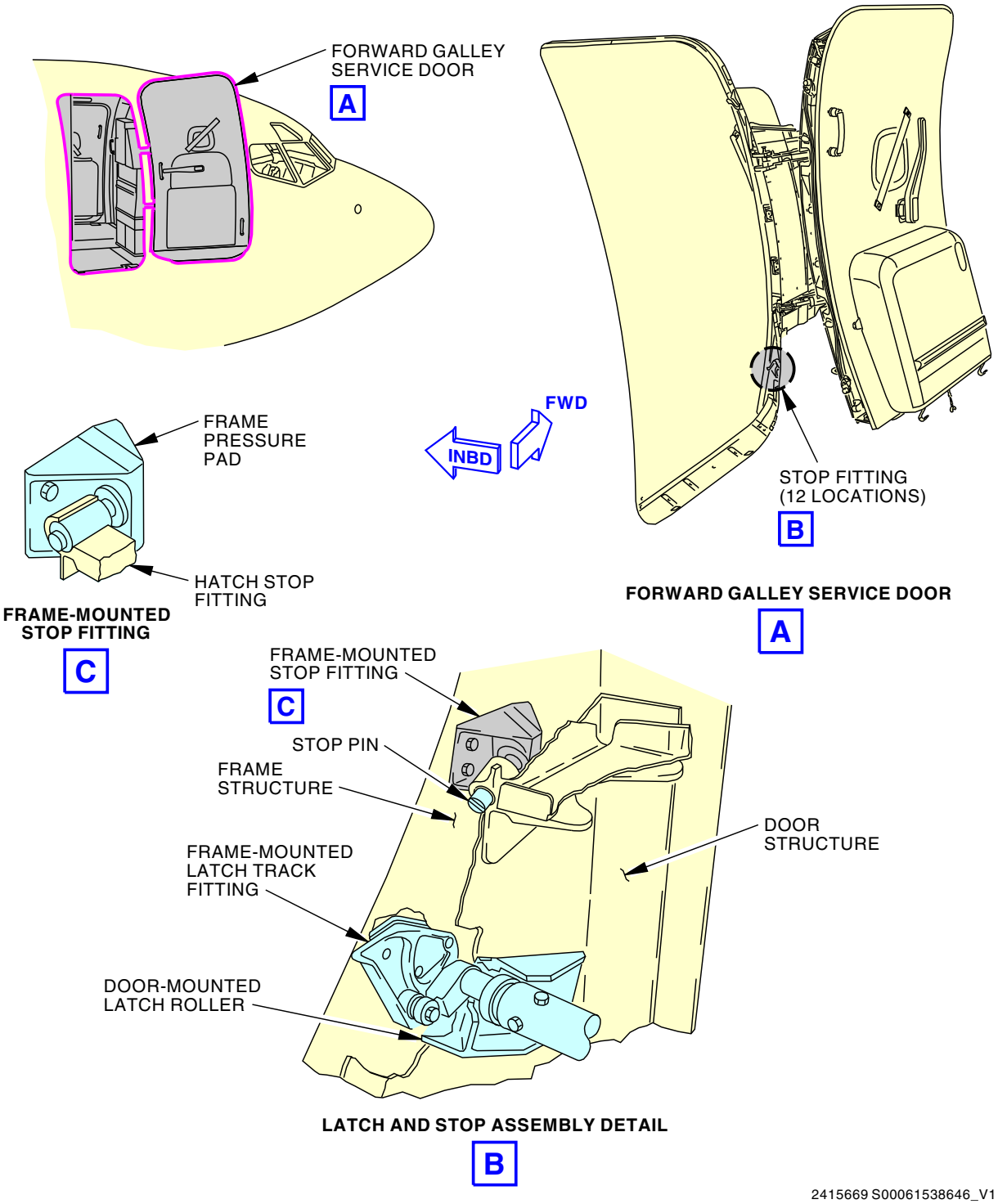
SUBTASK 52-05-03-410-007

(4) Close this access panel:

Number	Name/Location
841	Forward Galley Service Door

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



External - Forward Galley Service Door
Figure 211/52-05-03-990-811

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-809

12. EXTERNAL - DETAILED: AFT ENTRY DOOR STOP FITTINGS AND PINS

(Figure 212)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
834	Left Aft Entry Door

C. Access Panels

Number	Name/Location
834	Aft Entry Door

D. Inspection

SUBTASK 52-05-03-010-008

(1) Open this access panel:

Number	Name/Location
834	Aft Entry Door

NOTE: Inspect with doors opened and lining not removed.

SUBTASK 52-05-03-211-009

(2) Do a Detailed inspection of the aft entry door stop fittings and pins.

SUBTASK 52-05-03-910-011

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809.

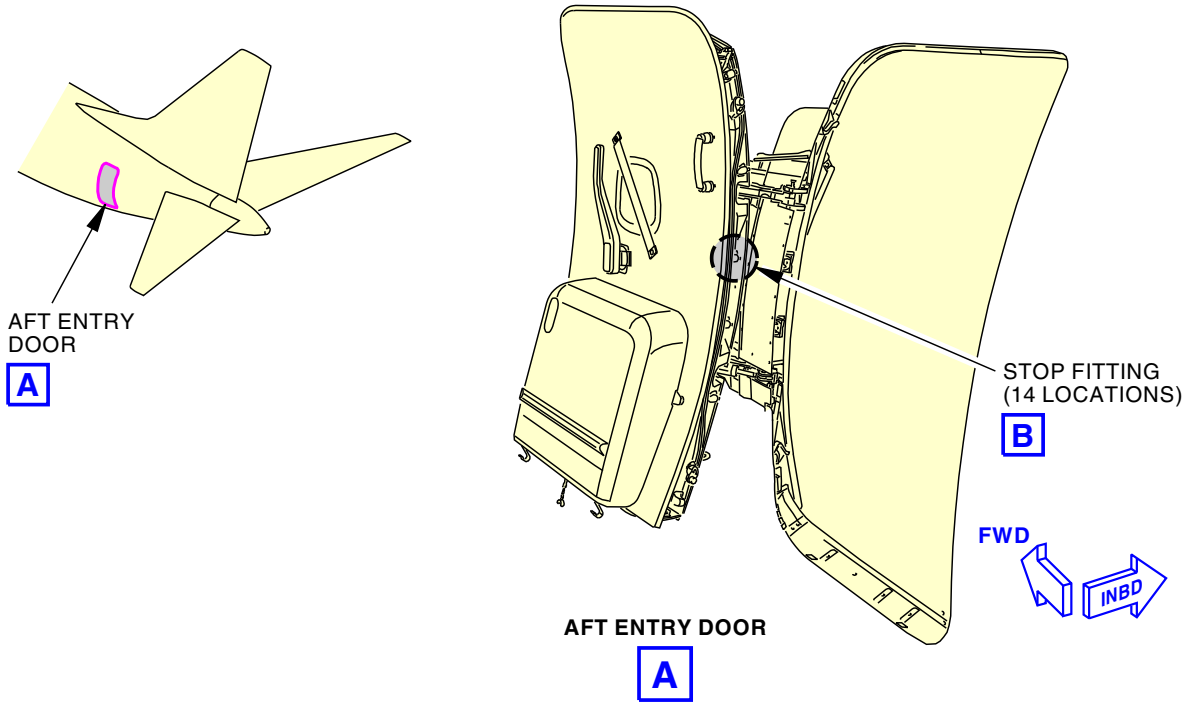
SUBTASK 52-05-03-410-008

(4) Close this access panel:

Number	Name/Location
834	Aft Entry Door

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



External - Aft Entry Door
Figure 212/52-05-03-990-812

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-810

13. EXTERNAL - DETAILED: AFT GALLEY SERVICE DOOR STOP FITTINGS AND PINS

(Figure 213)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
844	Aft Galley Service Door

C. Access Panels

Number	Name/Location
844	Aft Galley Service Door

D. Inspection

SUBTASK 52-05-03-010-009

(1) Open this access panel:

Number	Name/Location
844	Aft Galley Service Door

NOTE: Inspect with doors opened and lining not removed.

SUBTASK 52-05-03-211-010

(2) Do a Detailed inspection of the aft galley service door stop fittings and pins.

SUBTASK 52-05-03-910-012

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809

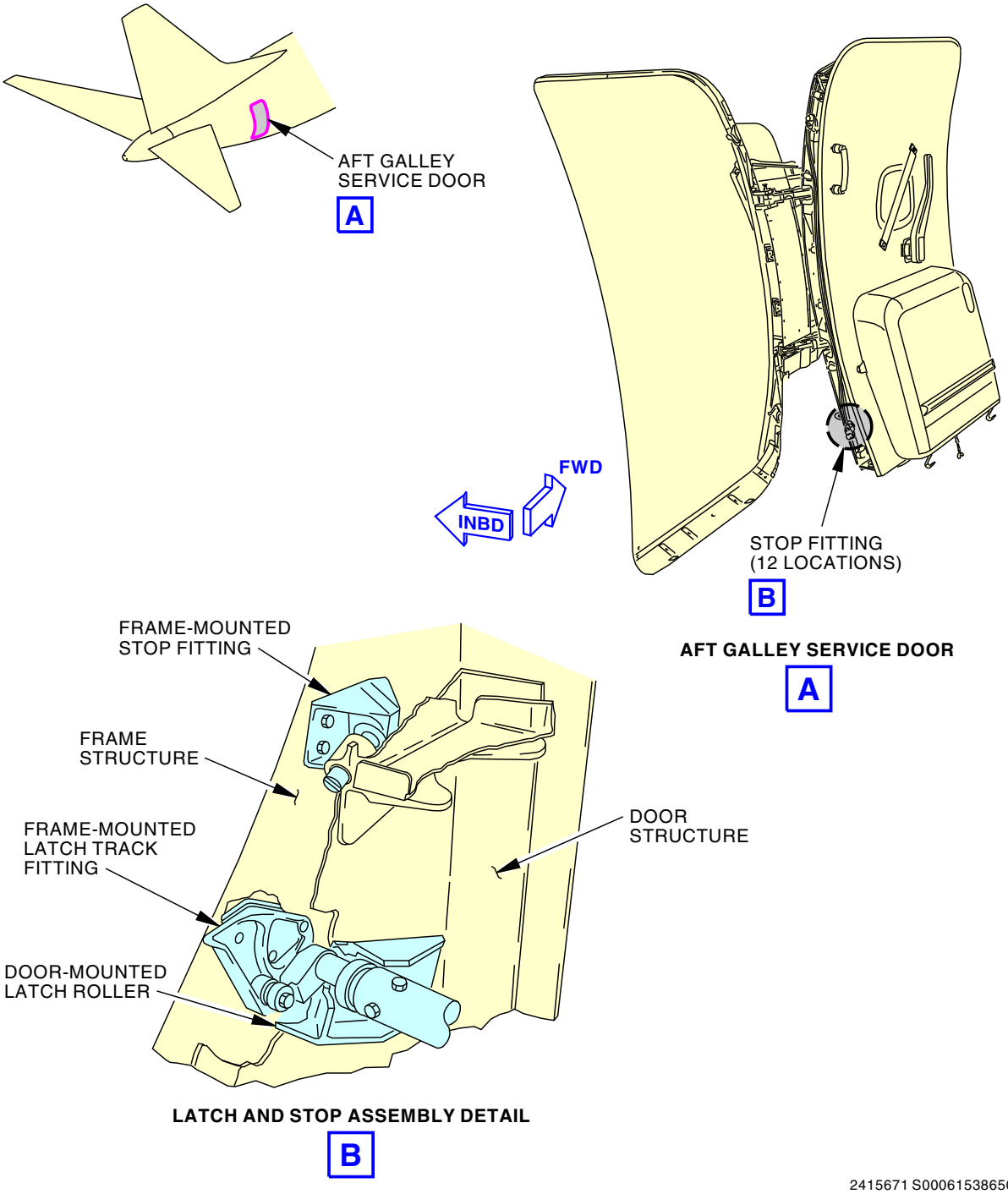
SUBTASK 52-05-03-410-009

(4) Close this access panel:

Number	Name/Location
844	Aft Galley Service Door

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



External - Aft Galley Service Door
Figure 213/52-05-03-990-813

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-811

14. INTERNAL - DETAILED: FORWARD ENTRY DOOR

(Figure 214)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-810	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
831	Forward Entry Door

C. Access Panels

Number	Name/Location
831	Forward Entry Door
831AW	Fwd Entry Door - Door Liner (Cosmetic)

D. Inspection

SUBTASK 52-05-03-010-010

(1) Open these access panels:

Number	Name/Location
831	Forward Entry Door
831AW	Fwd Entry Door - Door Liner (Cosmetic)

NOTE: Remove insulation, interior liners and access panels as required.

SUBTASK 52-05-03-211-011

(2) Do a Detailed inspection of the forward entry door stop fittings and pins.

SUBTASK 52-05-03-910-013

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-810

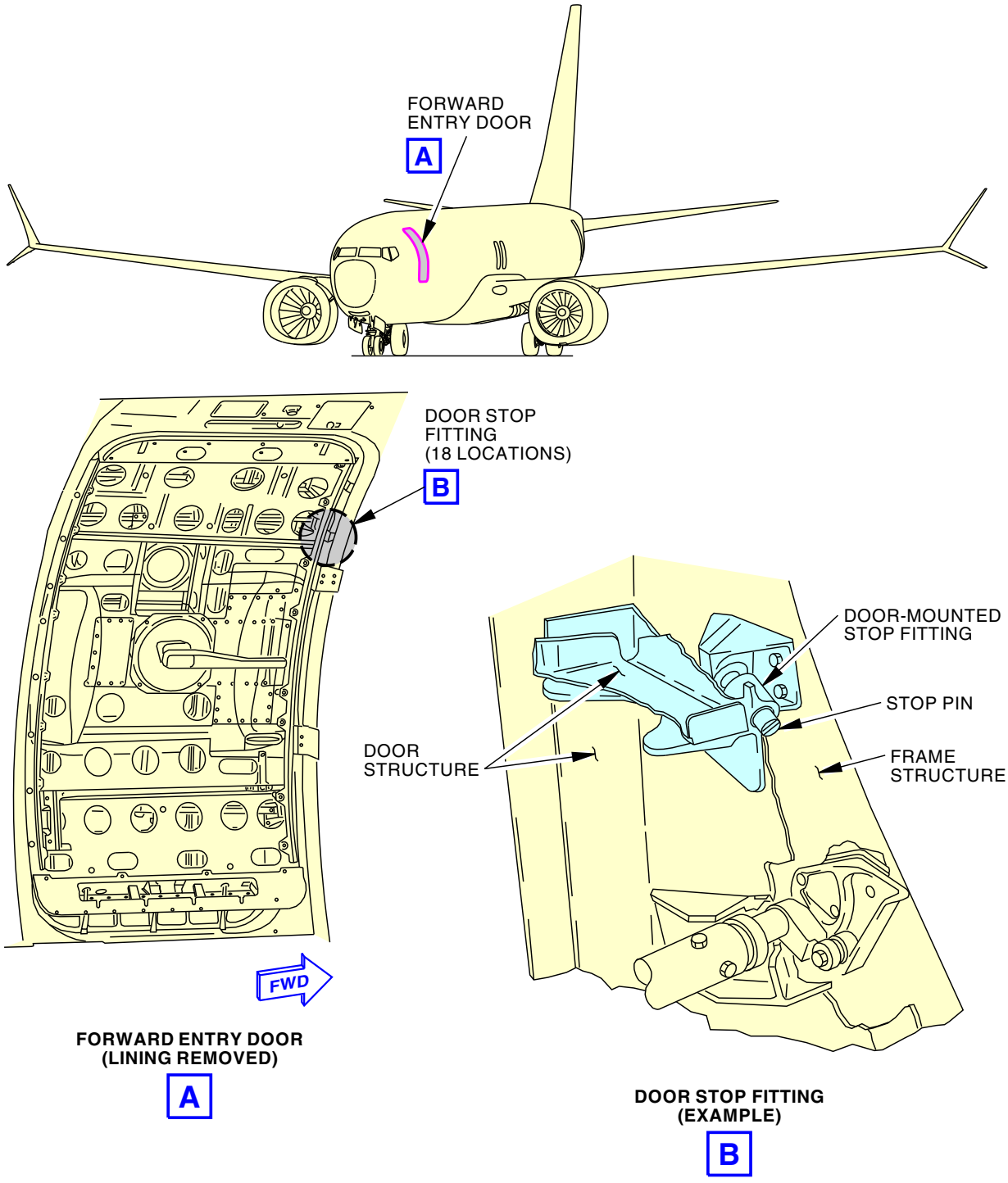
SUBTASK 52-05-03-410-010

(4) Close these access panels:

Number	Name/Location
831	Forward Entry Door
831AW	Fwd Entry Door - Door Liner (Cosmetic)

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Forward Entry Door Detailed (Internal)
Figure 214/52-05-03-990-814

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-812

15. INTERNAL - DETAILED: FORWARD GALLEY SERVICE DOOR

(Figure 215)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-810	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
841	Forward Galley Service Door

C. Access Panels

Number	Name/Location
841	Forward Galley Service Door
841AW	Fwd Galley Service Door - Door Liner

D. Inspection

SUBTASK 52-05-03-010-011

(1) Open these access panels:

Number	Name/Location
841	Forward Galley Service Door
841AW	Fwd Galley Service Door - Door Liner

NOTE: Remove insulation, interior liners and access panels as required.

SUBTASK 52-05-03-211-012

(2) Do a Detailed inspection of the forward galley service door stop fittings and pins.

SUBTASK 52-05-03-910-014

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-810

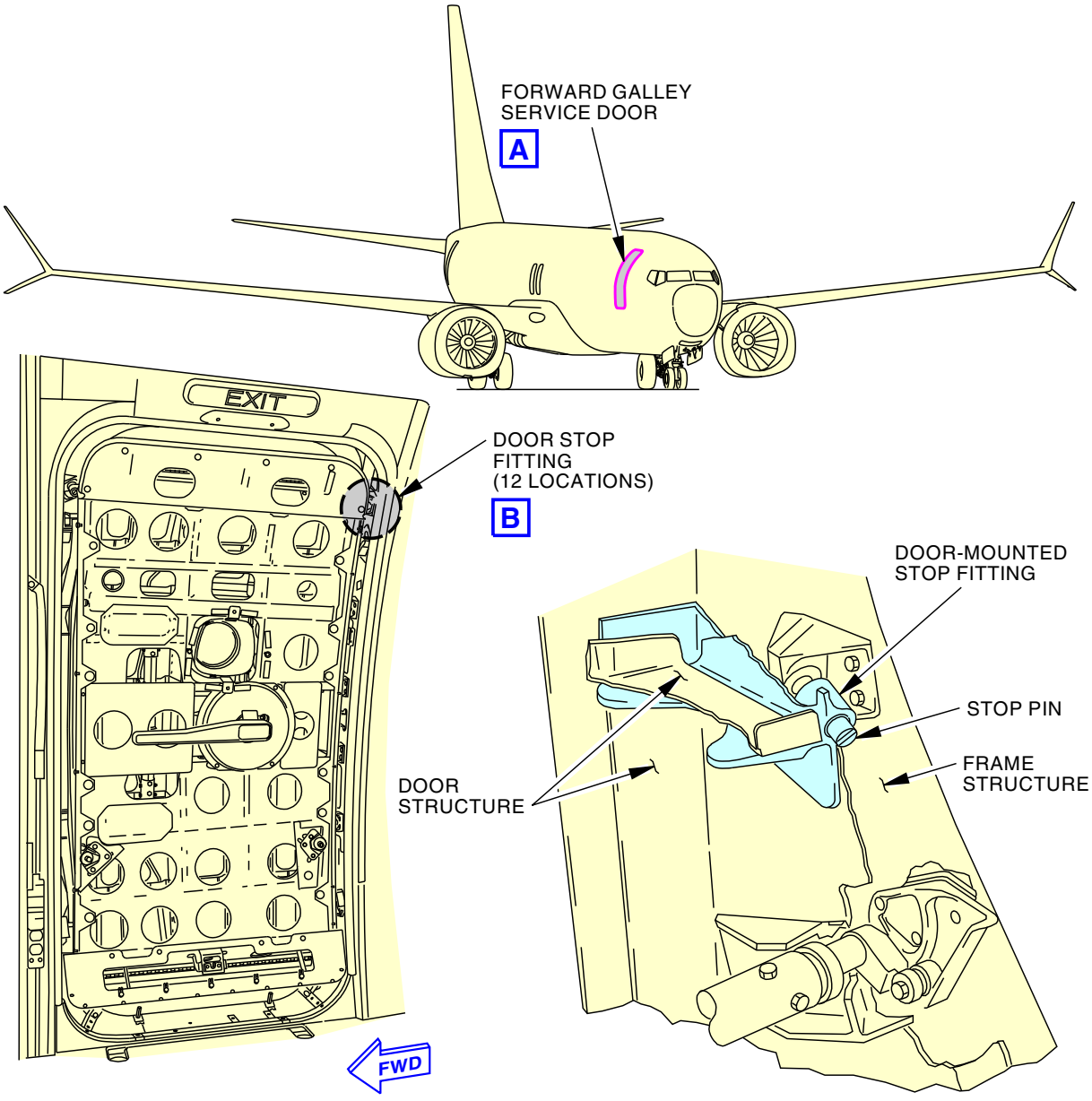
SUBTASK 52-05-03-410-011

(4) Close these access panels:

Number	Name/Location
841	Forward Galley Service Door
841AW	Fwd Galley Service Door - Door Liner

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



FORWARD GALLEY SERVICE DOOR (LINING REMOVED)

A

DOOR STOP FITTING (EXAMPLE)

B

2415673 S00061538654_V1

Forward Galley Service Door Detailed (Internal)
Figure 215/52-05-03-990-815

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-813

16. INTERNAL - DETAILED: AFT ENTRY DOOR

(Figure 216)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-810	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
834	Left Aft Entry Door

C. Access Panels

Number	Name/Location
834	Aft Entry Door
834AW	Aft Entry Door - Door Liner

D. Inspection

SUBTASK 52-05-03-010-012

(1) Open these access panels:

Number	Name/Location
834	Aft Entry Door
834AW	Aft Entry Door - Door Liner

NOTE: Remove insulation, interior liners and access panels as required.

SUBTASK 52-05-03-211-013

(2) Do a Detailed inspection of the aft entry door stop fittings and pins.

SUBTASK 52-05-03-910-015

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-810

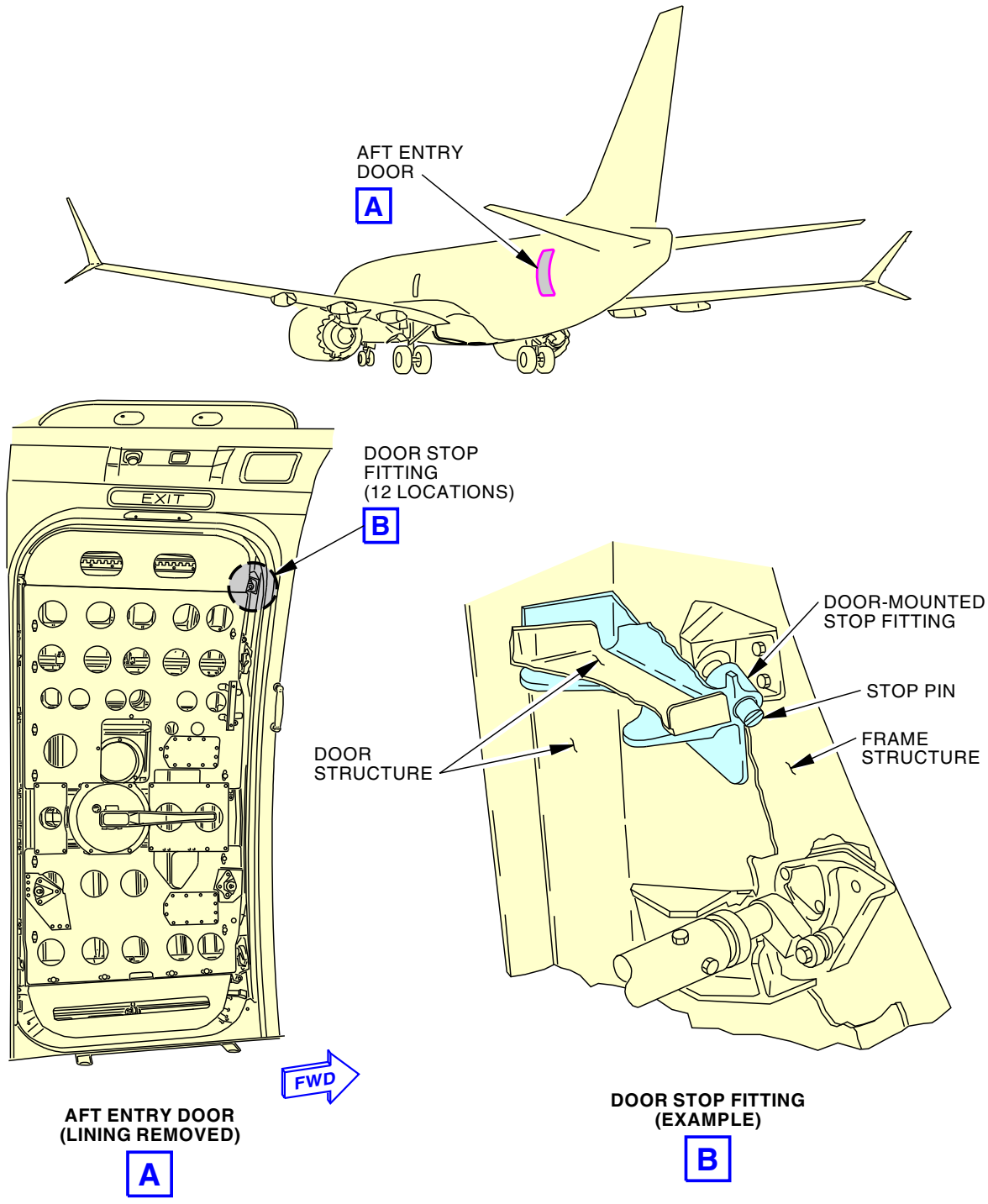
SUBTASK 52-05-03-410-012

(4) Close these access panels:

Number	Name/Location
834	Aft Entry Door
834AW	Aft Entry Door - Door Liner

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aft Entry Door Detailed (Internal)
Figure 216/52-05-03-990-816

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-814

17. INTERNAL - DETAILED: AFT GALLEY SERVICE DOOR

(Figure 217)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-810	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
844	Aft Galley Service Door

C. Access Panels

Number	Name/Location
844	Aft Galley Service Door
844AW	Aft Galley Service Door - Door Liner (Cosmetic)

D. Inspection

SUBTASK 52-05-03-010-013

(1) Open these access panels:

Number	Name/Location
844	Aft Galley Service Door
844AW	Aft Galley Service Door - Door Liner (Cosmetic)

NOTE: Remove insulation, interior liners and access panels as required.

SUBTASK 52-05-03-211-014

(2) Do a Detailed inspection of the aft galley service door stop fittings and pins.

SUBTASK 52-05-03-910-016

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-810

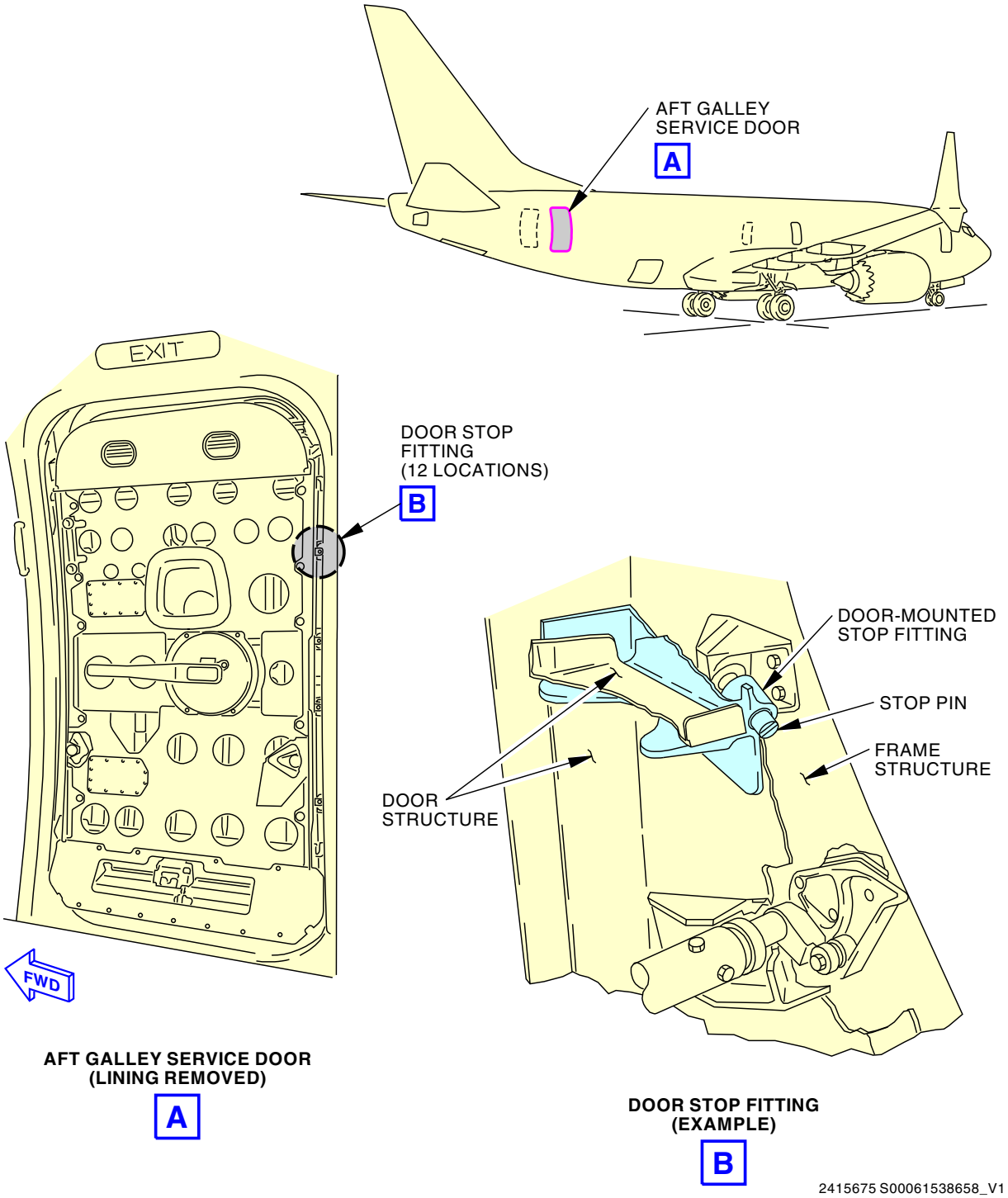
SUBTASK 52-05-03-410-013

(4) Close these access panels:

Number	Name/Location
844	Aft Galley Service Door
844AW	Aft Galley Service Door - Door Liner (Cosmetic)

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aft Galley Service Door Detailed (Internal)
Figure 217/52-05-03-990-817

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-210-804

18. INTERNAL - GENERAL VISUAL: FORWARD ENTRY DOOR

(Figure 218)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-808	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
831	Forward Entry Door

C. Access Panels

Number	Name/Location
831	Forward Entry Door
831AW	Fwd Entry Door - Door Liner (Cosmetic)
831AZ	Forward Entry Door - Torque Tube Access
831BZ	Forward Entry Door - Handle Box and Cam for Handle Box Access
831CZ	Forward Entry Door - Handle Box Access
831DZ	Forward Entry Door - Gate Hinge Pin Access
831EZ	Forward Entry Door - Gate Hinge Pin Access
S8311	Forward Passenger Entry Door Inspection

D. Inspection

SUBTASK 52-05-03-010-014

(1) Open these access panels:

Number	Name/Location
831	Forward Entry Door
831AW	Fwd Entry Door - Door Liner (Cosmetic)
831AZ	Forward Entry Door - Torque Tube Access
831BZ	Forward Entry Door - Handle Box and Cam for Handle Box Access
831CZ	Forward Entry Door - Handle Box Access
831DZ	Forward Entry Door - Gate Hinge Pin Access
831EZ	Forward Entry Door - Gate Hinge Pin Access

Special Access:

Number	Name/Location
S8311	Forward Passenger Entry Door Inspection

NOTE: Remove insulation, interior liners and access panels as required.

SUBTASK 52-05-03-210-004

(2) Do a General Visual inspection of the forward entry door skin and structure.

SUBTASK 52-05-03-910-017

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-808

ECCN 9E991 BOEING PROPRIETARY - See title page for details

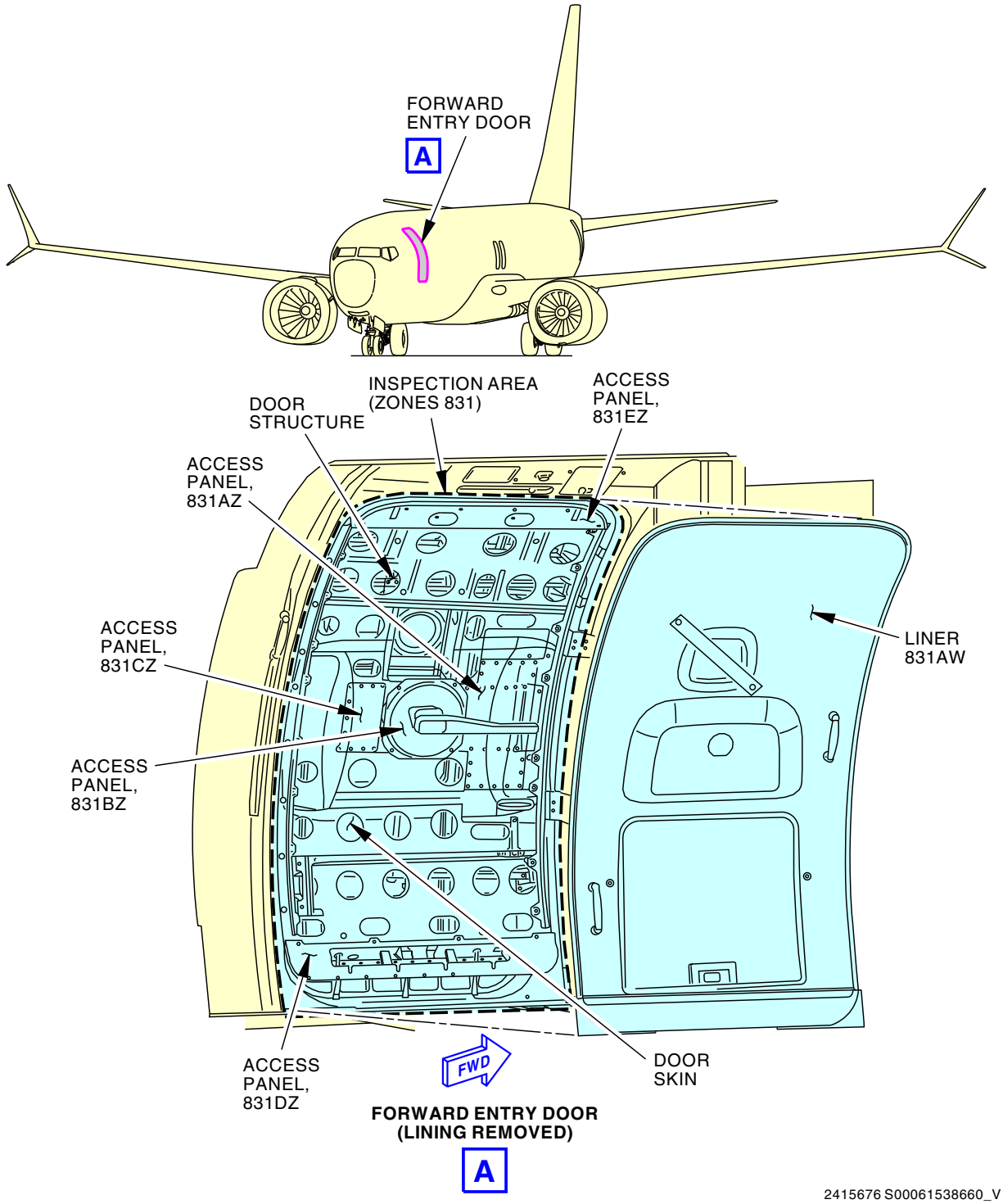
SUBTASK 52-05-03-410-014

(4) Close these access panels:

Number	Name/Location
831	Forward Entry Door
831AW	Fwd Entry Door - Door Liner (Cosmetic)
831AZ	Forward Entry Door - Torque Tube Access
831BZ	Forward Entry Door - Handle Box and Cam for Handle Box Access
831CZ	Forward Entry Door - Handle Box Access
831DZ	Forward Entry Door - Gate Hinge Pin Access
831EZ	Forward Entry Door - Gate Hinge Pin Access

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Forward Entry Door General Visual (Internal)
Figure 218/52-05-03-990-818

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-210-805

19. INTERNAL - GENERAL VISUAL: FORWARD GALLEY SERVICE DOOR

(Figure 219)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-808	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
841	Forward Galley Service Door

C. Access Panels

Number	Name/Location
841	Forward Galley Service Door
841AW	Fwd Galley Service Door - Door Liner
841AZ	Forward Galley Service Door - Torque Tube Access
841BZ	Forward Galley Service Door - Handle Box and Cam for Handle Box Access
841CZ	Forward Galley Service Door - Handle Box Access
841DZ	Forward Galley Service Door - Lower Hinge Access
841EZ	Forward Galley Service Door - Upper Hinge Access
S8411	Forward Galley Service Door Inspection

D. Inspection

SUBTASK 52-05-03-010-015

(1) Open these access panels:

Number	Name/Location
841	Forward Galley Service Door
841AW	Fwd Galley Service Door - Door Liner
841AZ	Forward Galley Service Door - Torque Tube Access
841BZ	Forward Galley Service Door - Handle Box and Cam for Handle Box Access
841CZ	Forward Galley Service Door - Handle Box Access
841DZ	Forward Galley Service Door - Lower Hinge Access
841EZ	Forward Galley Service Door - Upper Hinge Access

Special Access:

Number	Name/Location
S8411	Forward Galley Service Door Inspection

NOTE: Remove insulation, interior liners and access panels as required.

SUBTASK 52-05-03-210-005

(2) Do a General Visual inspection of the forward galley service door skin and structure.

SUBTASK 52-05-03-910-018

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-808

ECCN 9E991 BOEING PROPRIETARY - See title page for details

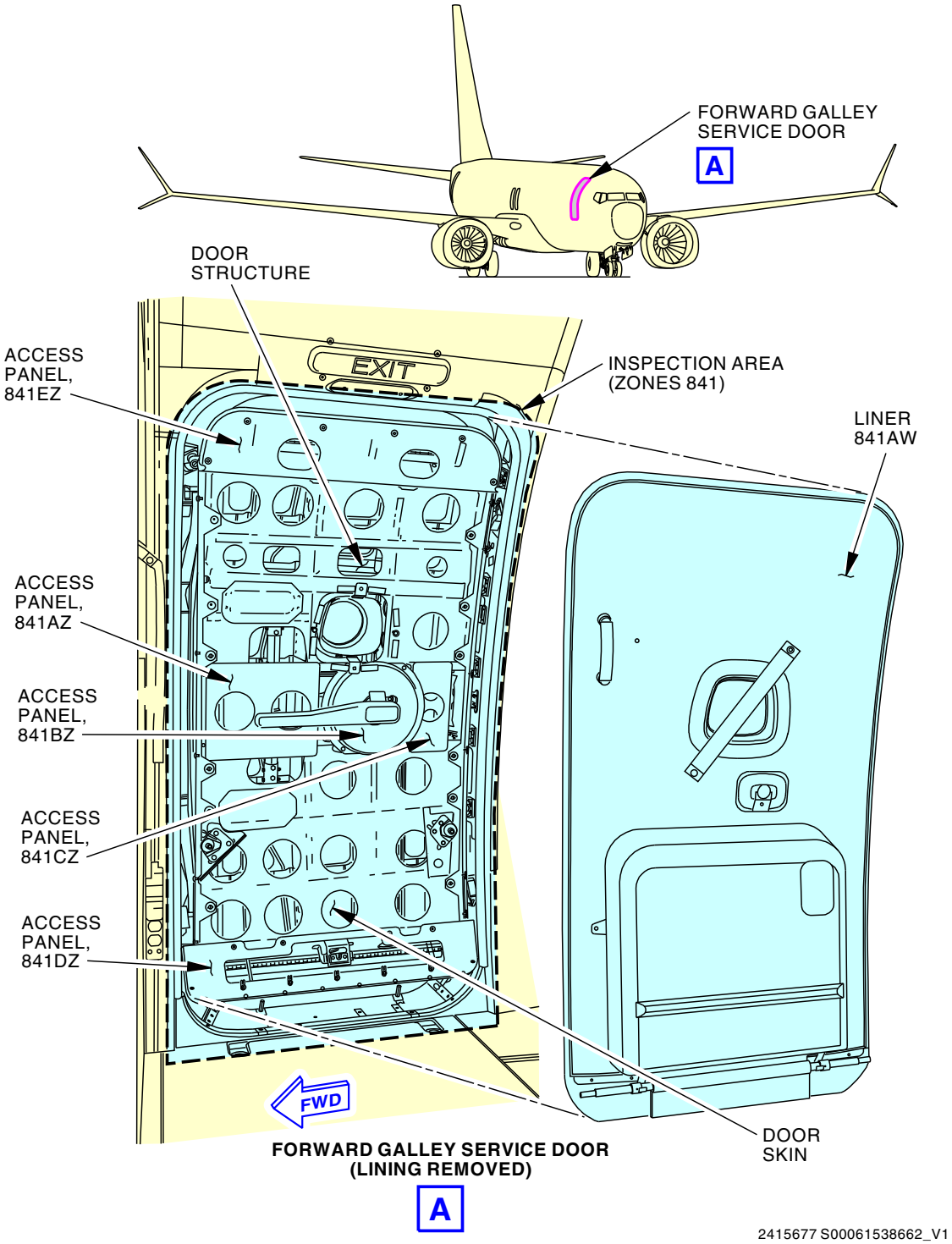
SUBTASK 52-05-03-410-015

(4) Close these access panels:

Number	Name/Location
841	Forward Galley Service Door
841AW	Fwd Galley Service Door - Door Liner
841AZ	Forward Galley Service Door - Torque Tube Access
841BZ	Forward Galley Service Door - Handle Box and Cam for Handle Box Access
841CZ	Forward Galley Service Door - Handle Box Access
841DZ	Forward Galley Service Door - Lower Hinge Access
841EZ	Forward Galley Service Door - Upper Hinge Access

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Forward Galley Service Door General Visual (Internal)
Figure 219/52-05-03-990-819

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-210-806

20. INTERNAL - GENERAL VISUAL: AFT ENTRY DOOR

(Figure 220)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-808	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
834	Left Aft Entry Door

C. Access Panels

Number	Name/Location
834	Aft Entry Door
834AW	Aft Entry Door - Door Liner
834AZ	Aft Entry Door - Torque Tube Access
834BZ	Aft Entry Door - Handle Box and Cam for Handle Box Access
834CZ	Aft Entry Door - Handle Box Access
834DZ	Aft Entry Door - Lower Hinge Access
834EZ	Aft Entry Door - Upper Hinge Access
S8341	Aft Passenger Entry Door Inspection

D. Inspection

SUBTASK 52-05-03-010-016

(1) Open these access panels:

Number	Name/Location
834	Aft Entry Door
834AW	Aft Entry Door - Door Liner
834AZ	Aft Entry Door - Torque Tube Access
834BZ	Aft Entry Door - Handle Box and Cam for Handle Box Access
834CZ	Aft Entry Door - Handle Box Access
834DZ	Aft Entry Door - Lower Hinge Access
834EZ	Aft Entry Door - Upper Hinge Access

Special Access:

Number	Name/Location
S8341	Aft Passenger Entry Door Inspection

NOTE: Remove insulation, interior liners and access panels as required.

SUBTASK 52-05-03-210-006

(2) Do a General Visual inspection of the aft entry door skin and structure.

SUBTASK 52-05-03-910-019

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-808

ECCN 9E991 BOEING PROPRIETARY - See title page for details

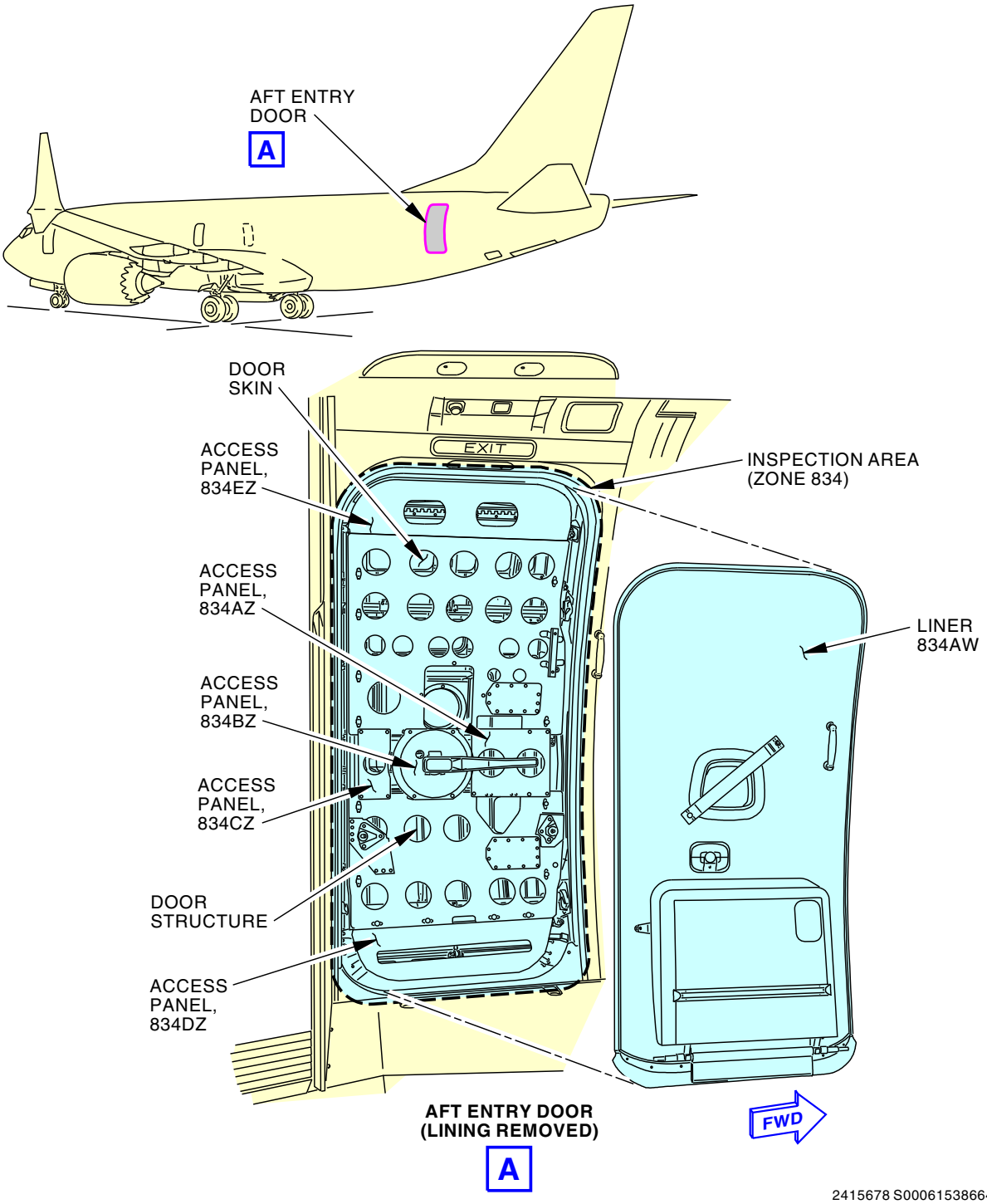
SUBTASK 52-05-03-410-016

(4) Close these access panels:

Number	Name/Location
834	Aft Entry Door
834AW	Aft Entry Door - Door Liner
834AZ	Aft Entry Door - Torque Tube Access
834BZ	Aft Entry Door - Handle Box and Cam for Handle Box Access
834CZ	Aft Entry Door - Handle Box Access
834DZ	Aft Entry Door - Lower Hinge Access
834EZ	Aft Entry Door - Upper Hinge Access

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aft Entry Door General Visual (Internal)
Figure 220/52-05-03-990-820

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-210-807

21. INTERNAL - GENERAL VISUAL: AFT GALLEY SERVICE DOOR

(Figure 221)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-808	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
844	Aft Galley Service Door

C. Access Panels

Number	Name/Location
844	Aft Galley Service Door
844AW	Aft Galley Service Door - Door Liner (Cosmetic)
844AZ	Aft Galley Service Door - Torque Tube Access
844BZ	Aft Galley Service Door - Handle Box and Cam for Handle Box Access
844CZ	Aft Galley Service Door - Handle Box Access
844DZ	Aft Galley Service Door - Lower Hinge Access
844EZ	Aft Galley Service Door - Upper Hinge Access
S8441	Aft Galley Service Door Inspection

D. Inspection

SUBTASK 52-05-03-010-017

(1) Open these access panels:

Number	Name/Location
844	Aft Galley Service Door
844AW	Aft Galley Service Door - Door Liner (Cosmetic)
844AZ	Aft Galley Service Door - Torque Tube Access
844BZ	Aft Galley Service Door - Handle Box and Cam for Handle Box Access
844CZ	Aft Galley Service Door - Handle Box Access
844DZ	Aft Galley Service Door - Lower Hinge Access
844EZ	Aft Galley Service Door - Upper Hinge Access

Special Access:

Number	Name/Location
S8441	Aft Galley Service Door Inspection

NOTE: Remove insulation, interior liners and access panels as required.

SUBTASK 52-05-03-210-007

(2) Do a General Visual inspection of the aft galley service door skin and structure.

SUBTASK 52-05-03-910-020

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-808.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

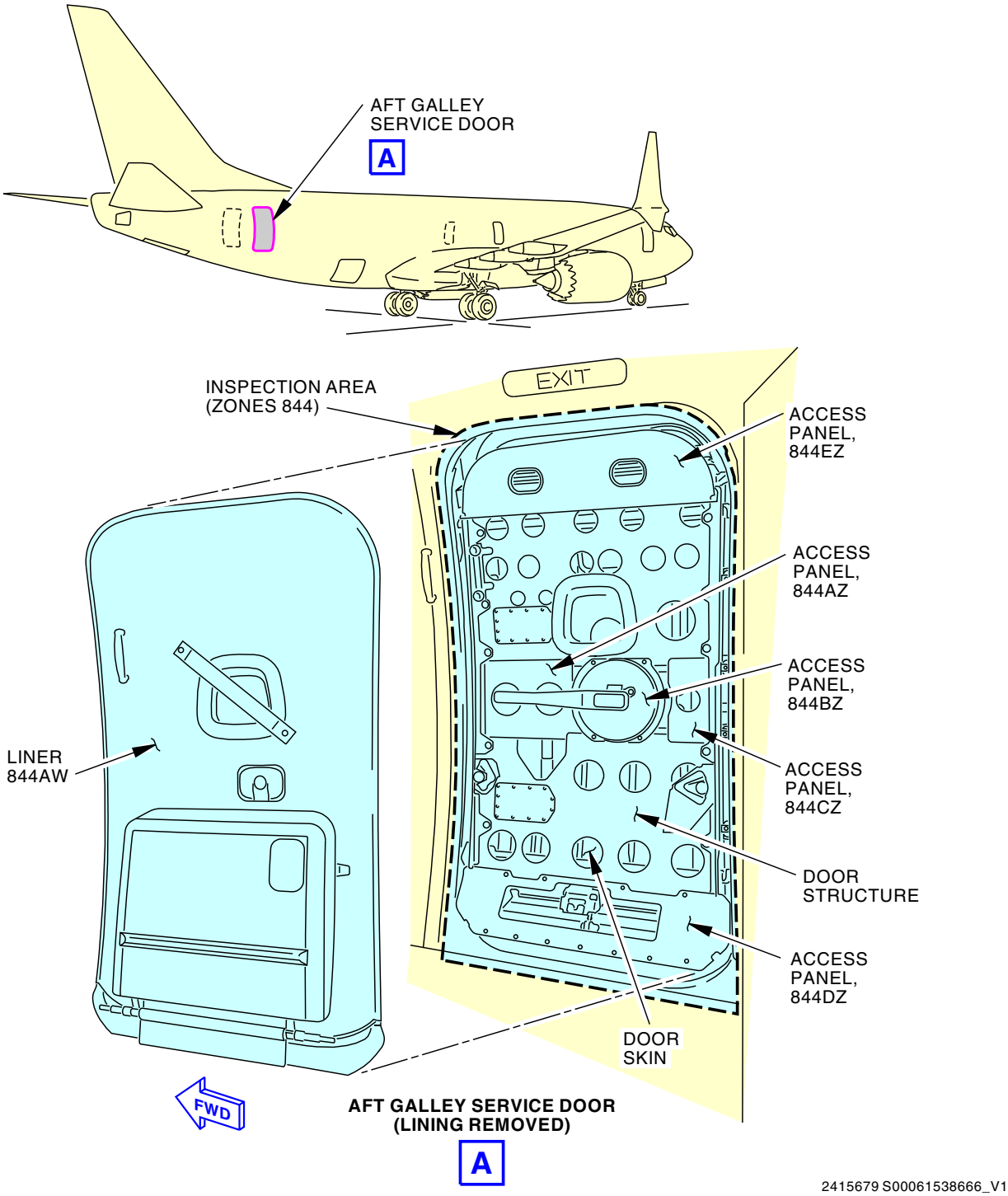
SUBTASK 52-05-03-410-017

(4) Close these access panels:

Number	Name/Location
844	Aft Galley Service Door
844AW	Aft Galley Service Door - Door Liner (Cosmetic)
844AZ	Aft Galley Service Door - Torque Tube Access
844BZ	Aft Galley Service Door - Handle Box and Cam for Handle Box Access
844CZ	Aft Galley Service Door - Handle Box Access
844DZ	Aft Galley Service Door - Lower Hinge Access
844EZ	Aft Galley Service Door - Upper Hinge Access

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aft Galley Service Door General Visual (Internal)
Figure 221/52-05-03-990-821

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-815

22. EXTERNAL - DETAILED: FORWARD CARGO DOOR STOP FITTINGS AND PINS

(Figure 222)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
821	Forward Cargo Door

C. Access Panels

Number	Name/Location
821	Forward Cargo Door

D. Inspection

SUBTASK 52-05-03-010-018

(1) Open this access panel:

Number	Name/Location
821	Forward Cargo Door

NOTE: Inspect with doors opened and lining not removed.

SUBTASK 52-05-03-211-015

(2) Do a Detailed inspection of the forward cargo door stop fittings and pins.

SUBTASK 52-05-03-910-021

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809.

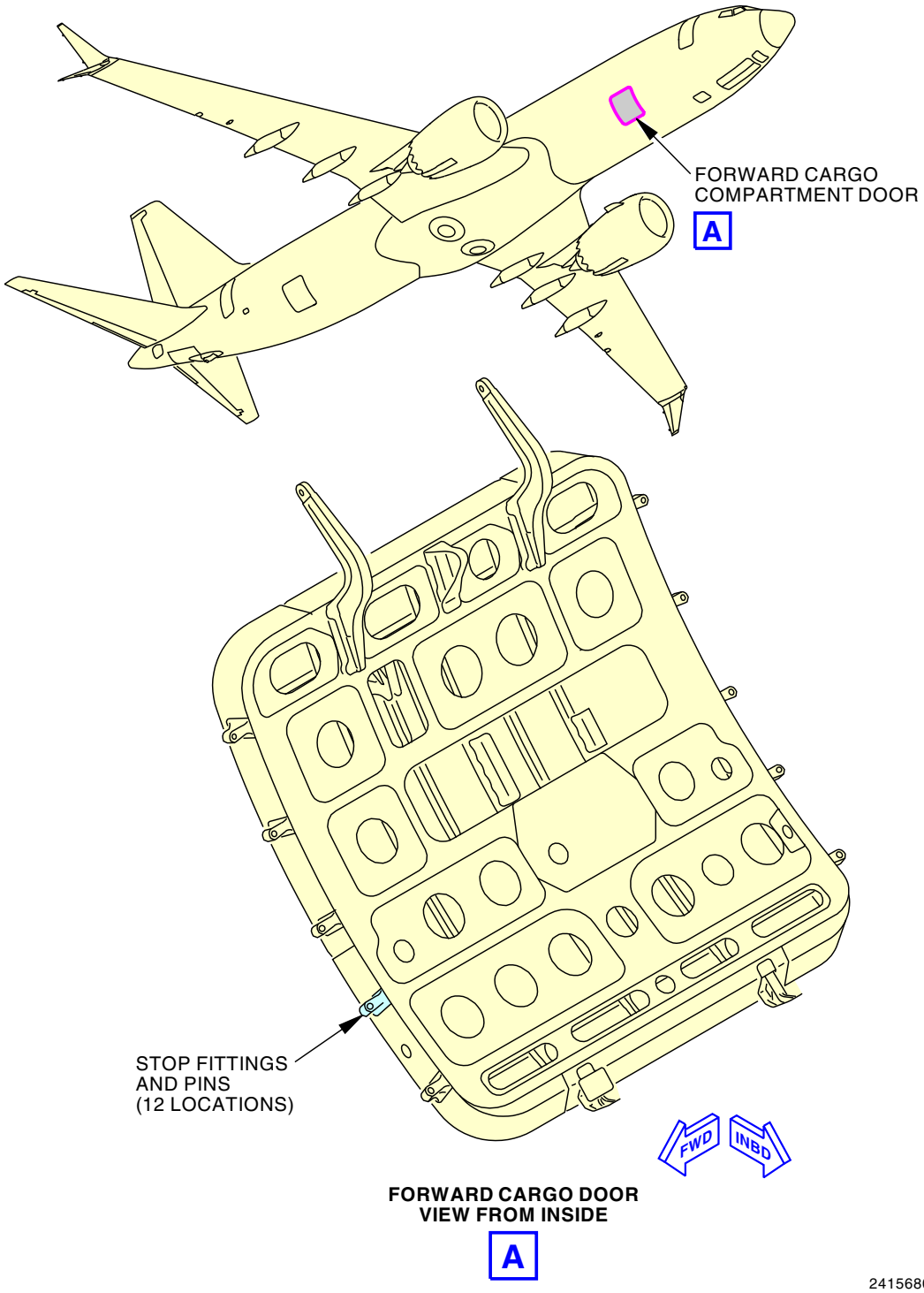
SUBTASK 52-05-03-410-018

(4) Close this access panel:

Number	Name/Location
821	Forward Cargo Door

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



External - Forward Cargo Door
Figure 222/52-05-03-990-822

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-816

23. EXTERNAL - DETAILED: AFT CARGO DOOR STOP FITTINGS AND PINS

(Figure 223)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
822	Aft Cargo Door

C. Access Panels

Number	Name/Location
822	Aft Cargo Door

D. Inspection

SUBTASK 52-05-03-010-019

(1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

NOTE: Inspect with doors opened and lining not removed.

SUBTASK 52-05-03-211-016

(2) Do a Detailed inspection of the aft cargo door stop fittings and pins.

SUBTASK 52-05-03-910-022

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809.

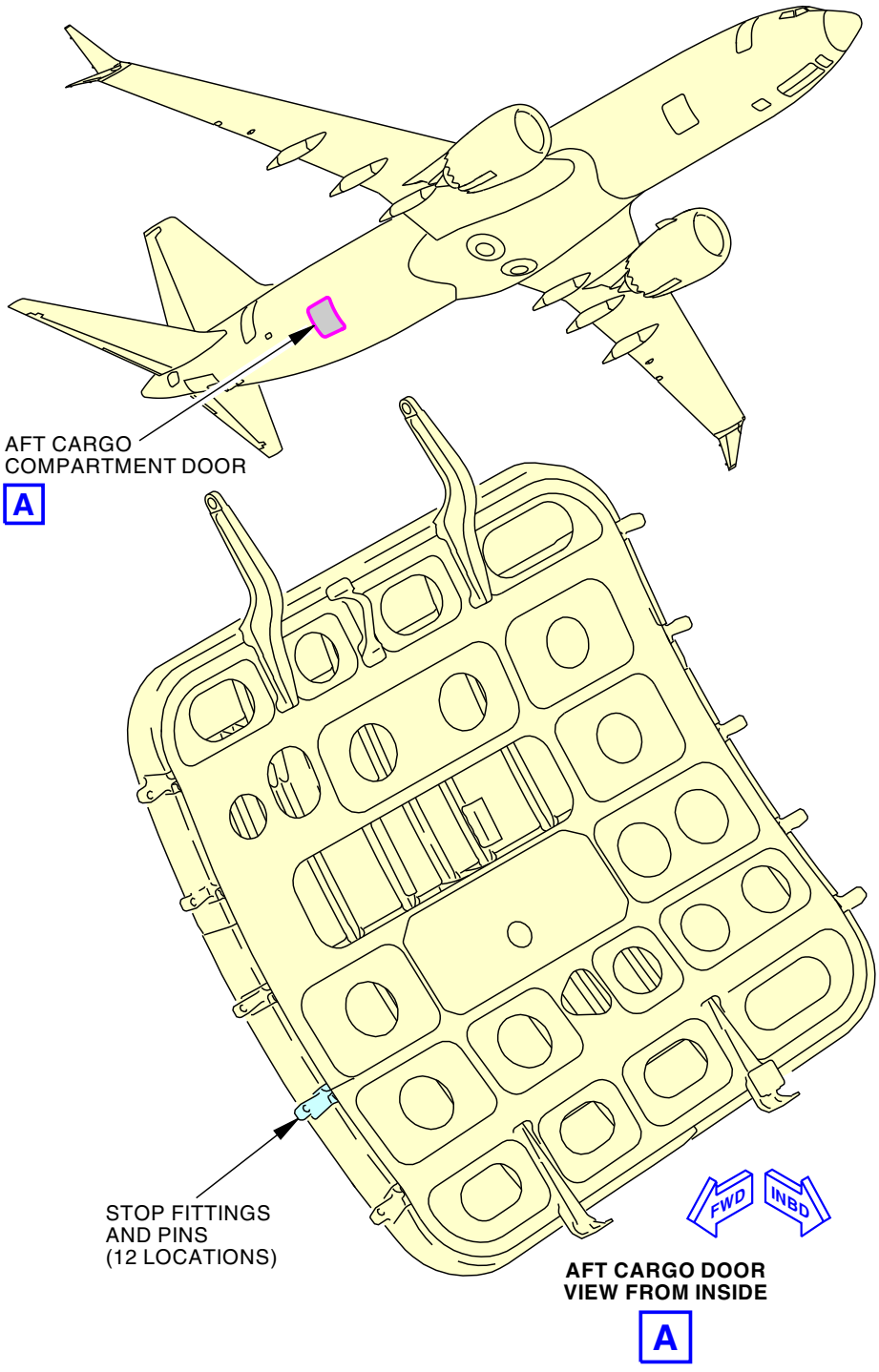
SUBTASK 52-05-03-410-019

(4) Close this access panel:

Number	Name/Location
822	Aft Cargo Door

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



External - Aft Cargo Door
Figure 223/52-05-03-990-823

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-817

24. INTERNAL - DETAILED: FORWARD CARGO DOOR

(Figure 224)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-811	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
821	Forward Cargo Door

C. Access Panels

Number	Name/Location
821	Forward Cargo Door
S8211	Forward Cargo Door Inspection

D. Inspection

SUBTASK 52-05-03-010-020

(1) Open this access panel:

Number	Name/Location
821	Forward Cargo Door

Special Access:

Number	Name/Location
S8211	Forward Cargo Door Inspection

NOTE: Inspect with insulation blanket removed.

SUBTASK 52-05-03-211-017

(2) Do a Detailed inspection of the forward cargo door stop fittings and pins.

SUBTASK 52-05-03-910-023

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-811.

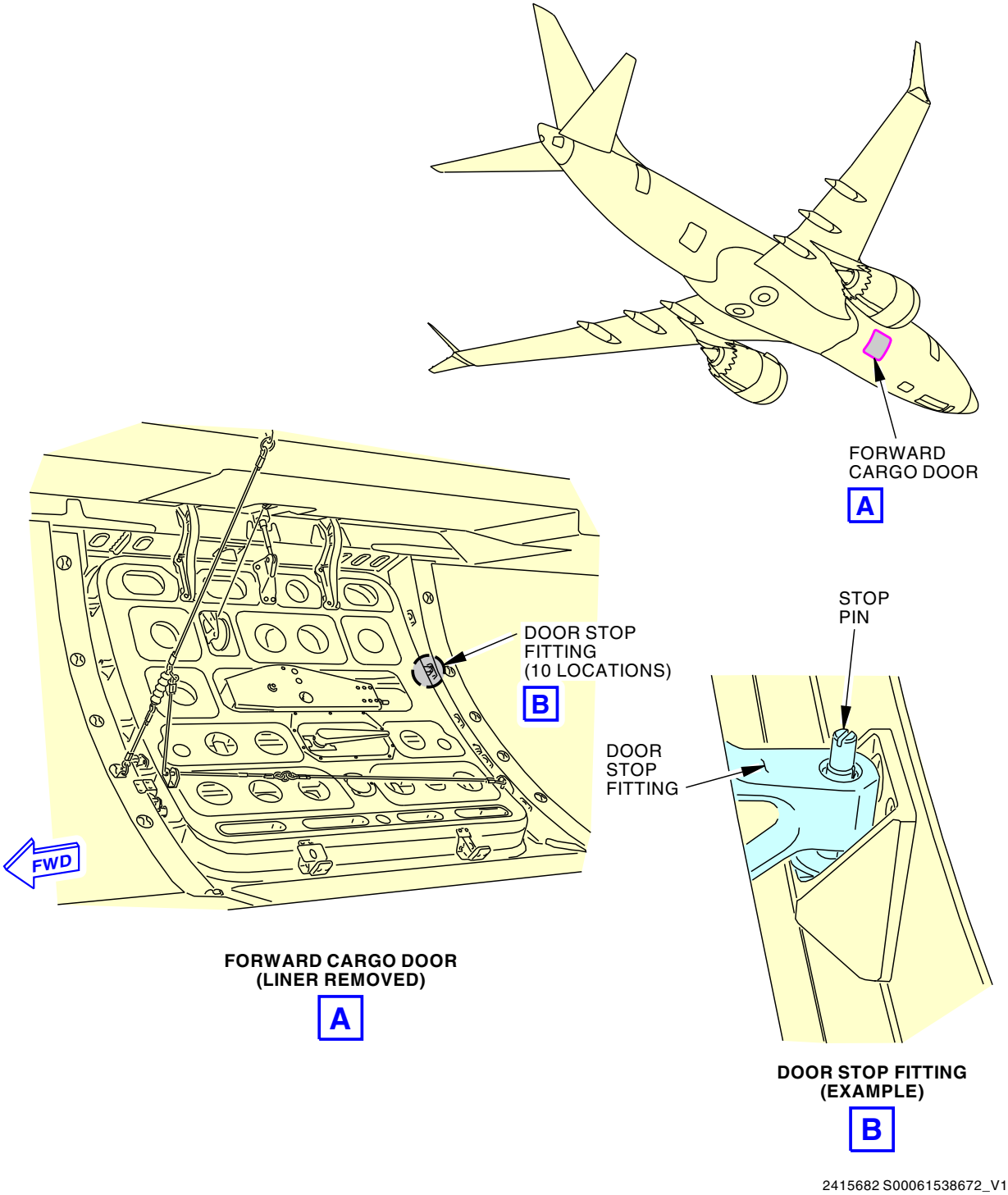
SUBTASK 52-05-03-410-020

(4) Close this access panel:

Number	Name/Location
821	Forward Cargo Door

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Forward Cargo Door
Figure 224/52-05-03-990-824

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-818

25. INTERNAL - DETAILED: AFT CARGO DOOR

(Figure 225)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-811	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
822	Aft Cargo Door

C. Access Panels

Number	Name/Location
822	Aft Cargo Door
S8221	Aft Cargo Door Inspection

D. Inspection

SUBTASK 52-05-03-010-021

(1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

Special Access:

Number	Name/Location
S8221	Aft Cargo Door Inspection

NOTE: Inspection with insulation blanket removed.

SUBTASK 52-05-03-211-018

(2) Do a Detailed inspection of the aft cargo door stop fittings and pins.

SUBTASK 52-05-03-910-024

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-811.

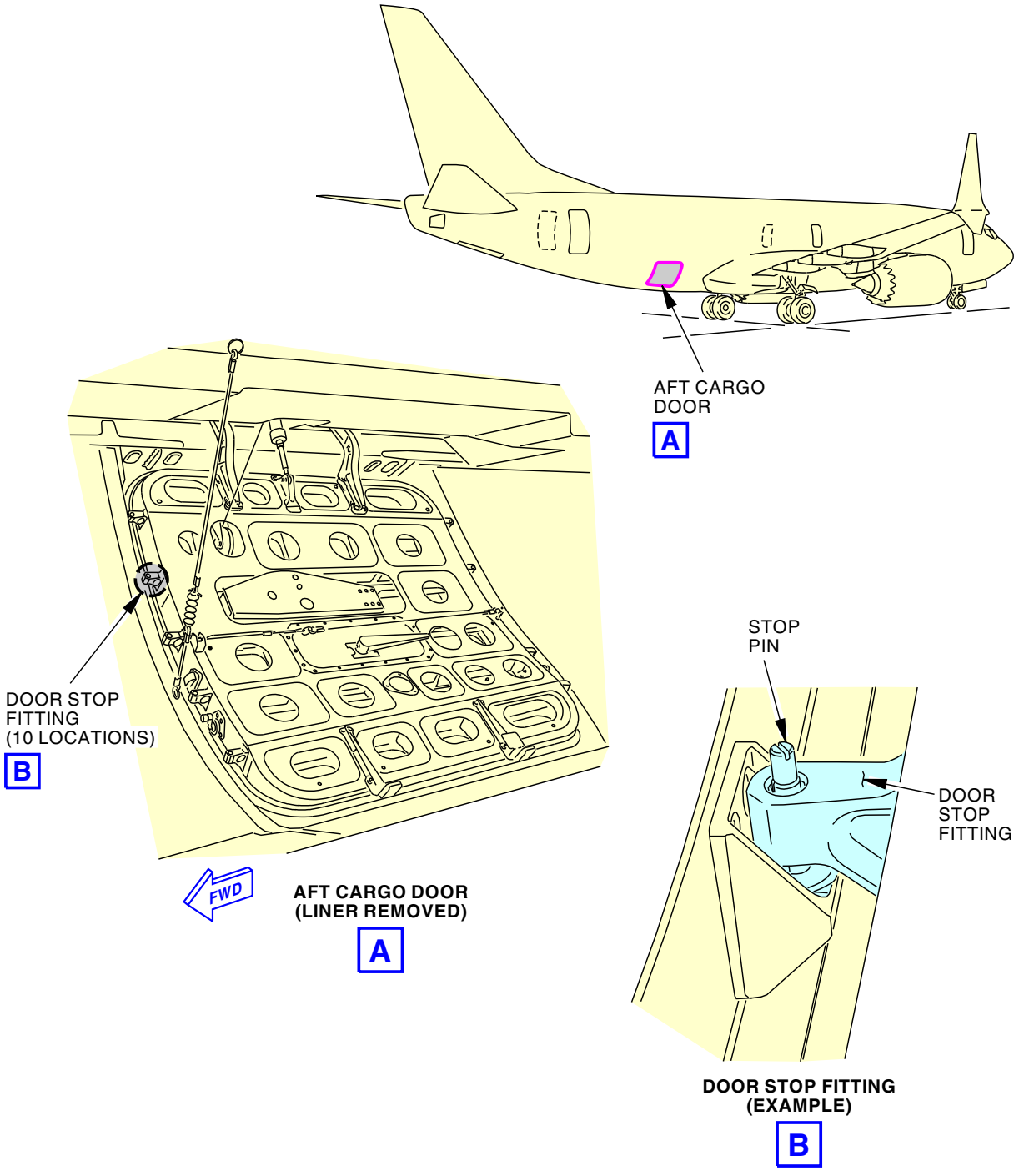
SUBTASK 52-05-03-410-021

(4) Close this access panel:

Number	Name/Location
822	Aft Cargo Door

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aft Cargo Door Detailed (Internal)
Figure 225/52-05-03-990-825

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-210-808

26. INTERNAL - GENERAL VISUAL: FORWARD CARGO DOOR

(Figure 226)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-808	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
821	Forward Cargo Door

C. Access Panels

Number	Name/Location
821	Forward Cargo Door
S8211	Forward Cargo Door Inspection

D. Inspection

SUBTASK 52-05-03-010-022

(1) Open this access panel:

Number	Name/Location
821	Forward Cargo Door

Special Access:

Number	Name/Location
S8211	Forward Cargo Door Inspection

NOTE: Inspect with insulation blanket removed.

SUBTASK 52-05-03-210-008

(2) Do a General Visual inspection of the forward cargo door skin and structure.

SUBTASK 52-05-03-910-025

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-808.

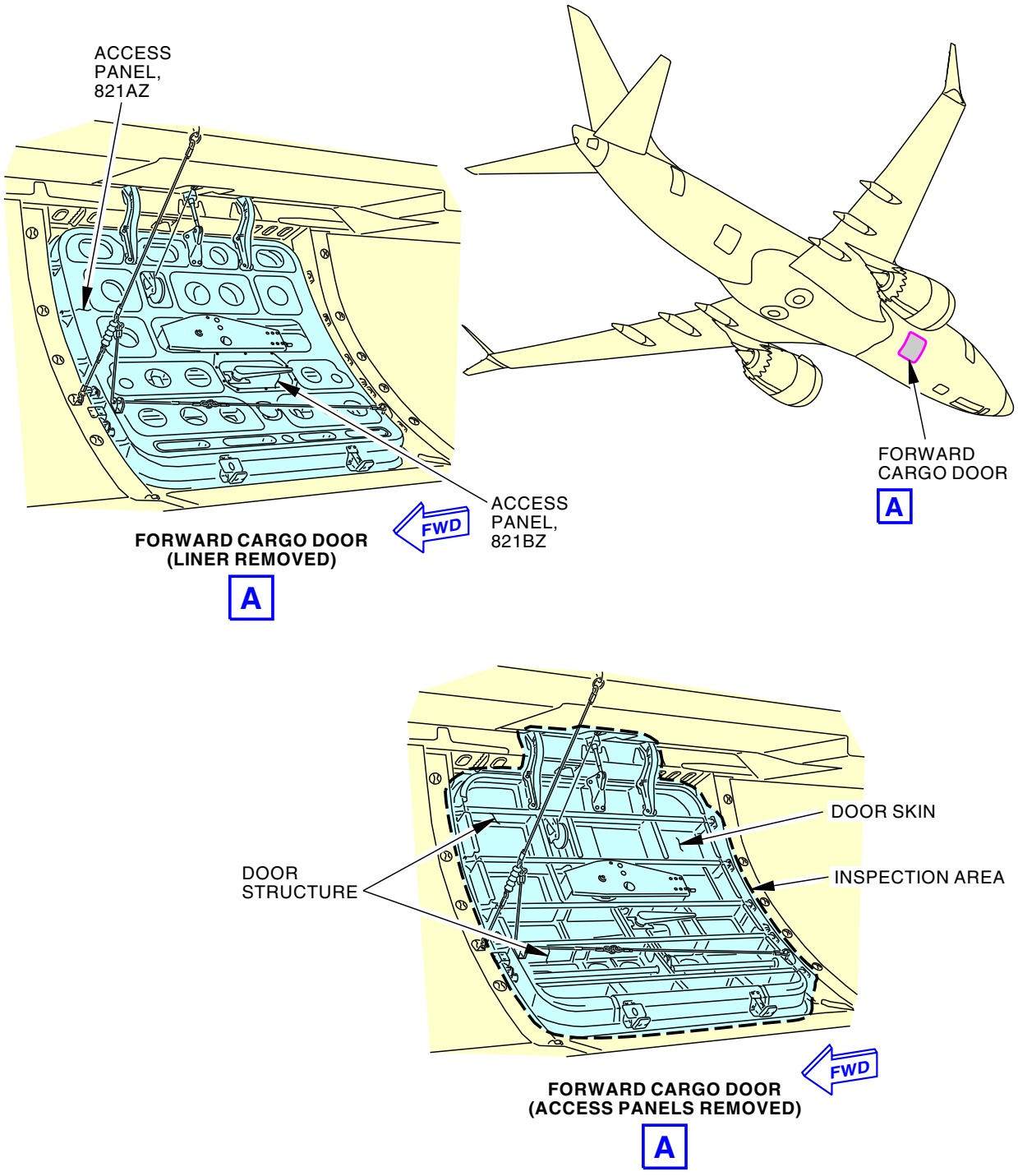
SUBTASK 52-05-03-410-022

(4) Close this access panel:

Number	Name/Location
821	Forward Cargo Door

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Forward Cargo Door General Visual (Internal)
Figure 226/52-05-03-990-826

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-210-809

27. INTERNAL - GENERAL VISUAL: AFT CARGO DOOR

(Figure 227)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-808	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
822	Aft Cargo Door

C. Access Panels

Number	Name/Location
822	Aft Cargo Door
S8221	Aft Cargo Door Inspection

D. Inspection

SUBTASK 52-05-03-010-023

(1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

Special Access:

Number	Name/Location
S8221	Aft Cargo Door Inspection

NOTE: Inspect with insulation blanket removed.

SUBTASK 52-05-03-210-009

(2) Do a General Visual inspection of the aft cargo door skin and structure.

SUBTASK 52-05-03-910-026

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-808.

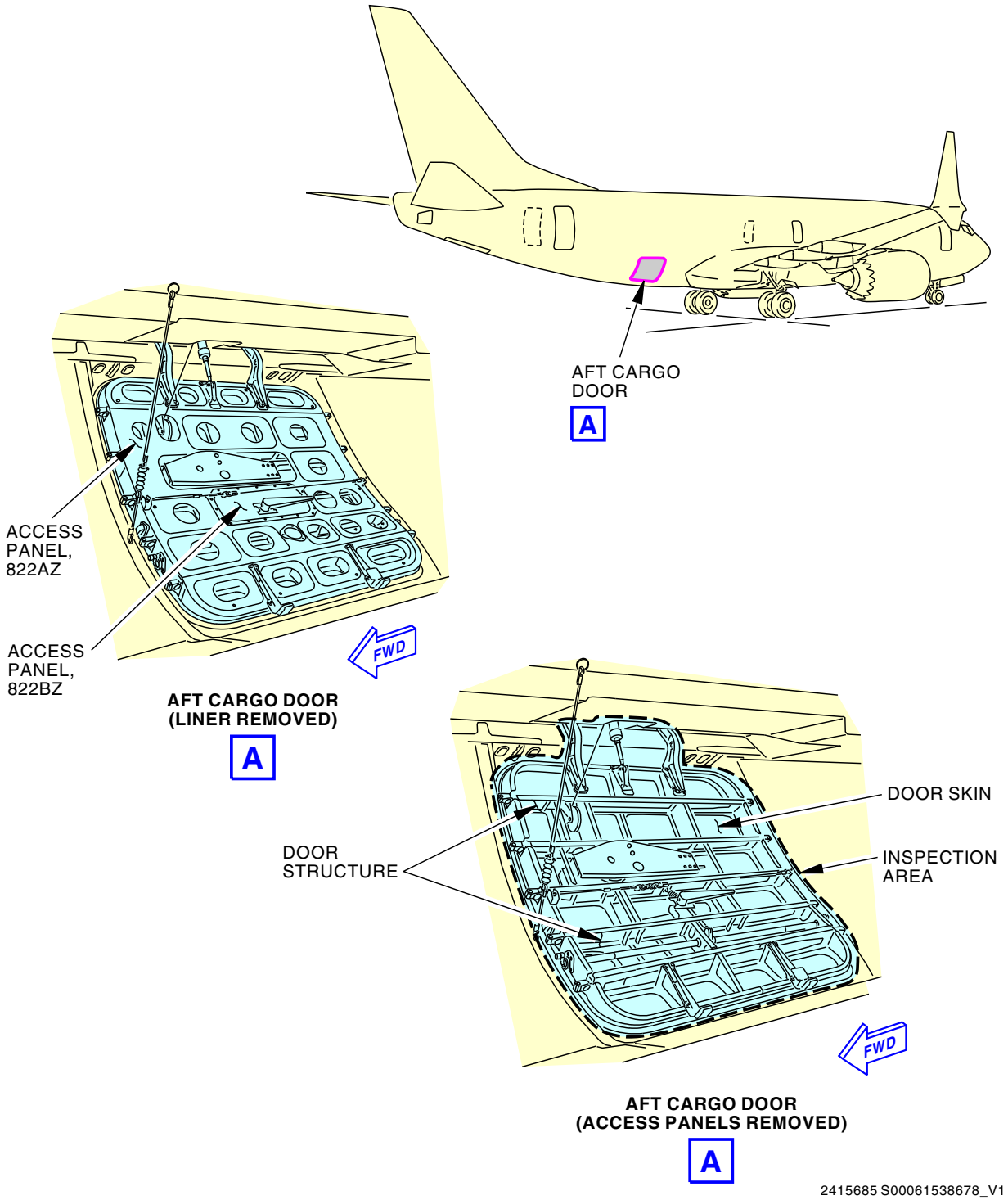
SUBTASK 52-05-03-410-023

(4) Close this access panel:

Number	Name/Location
822	Aft Cargo Door

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aft Cargo Door General Visual (Internal)
Figure 227/52-05-03-990-827

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-819

28. EXTERNAL - DETAILED: LEFT OVERWING EMERGENCY EXIT DOOR STOP FITTINGS AND PINS

(Figure 228)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)

C. Access Panels

Number	Name/Location
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)

D. Inspection

SUBTASK 52-05-03-010-024

(1) Open these access panels:

Number	Name/Location
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)

NOTE: Inspect with doors opened and lining not removed.

SUBTASK 52-05-03-211-019

(2) Do a Detailed inspection of the automatic overwing exit door stop fittings and pins.

SUBTASK 52-05-03-910-027

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809.

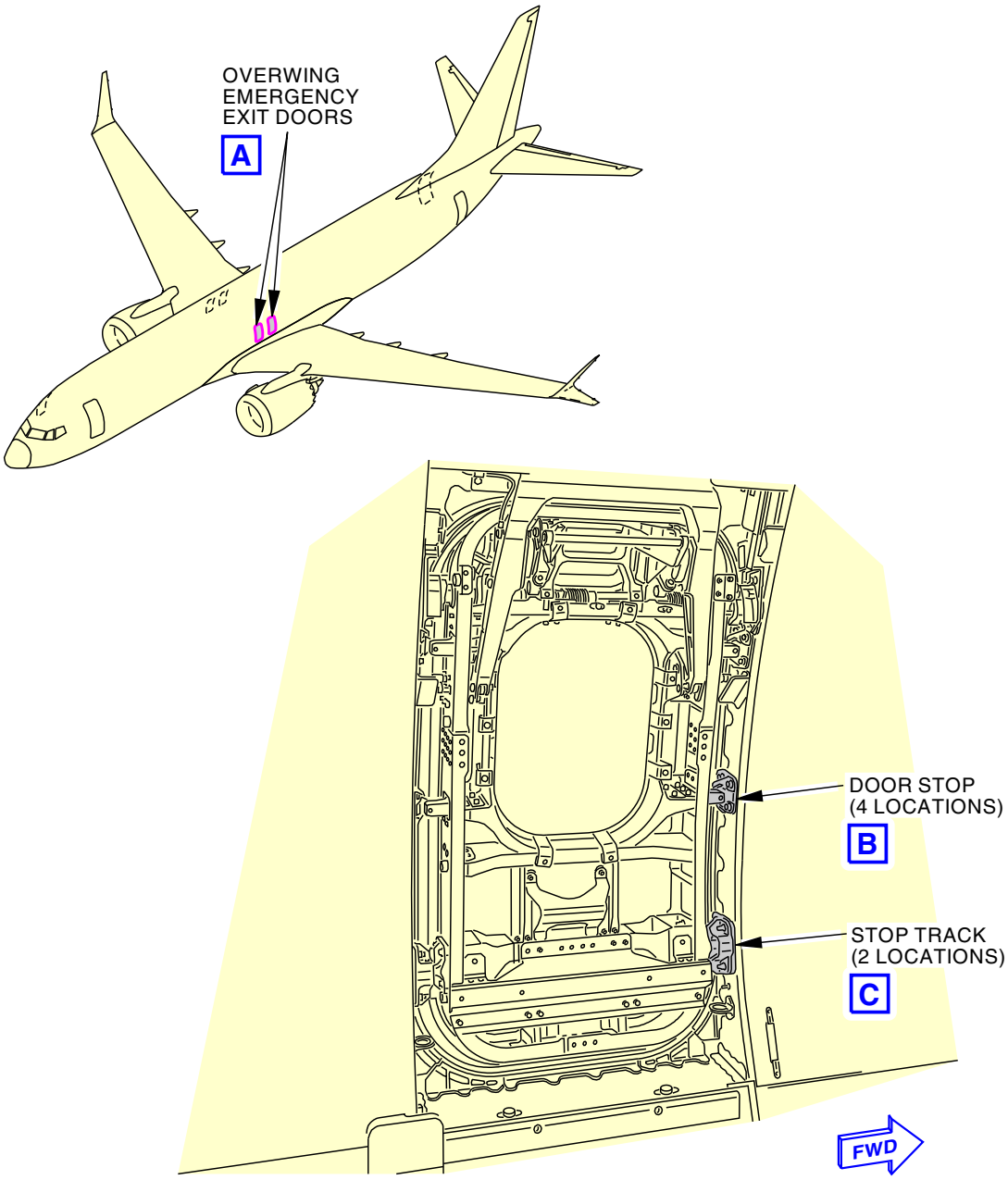
SUBTASK 52-05-03-410-024

(4) Close these access panels:

Number	Name/Location
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



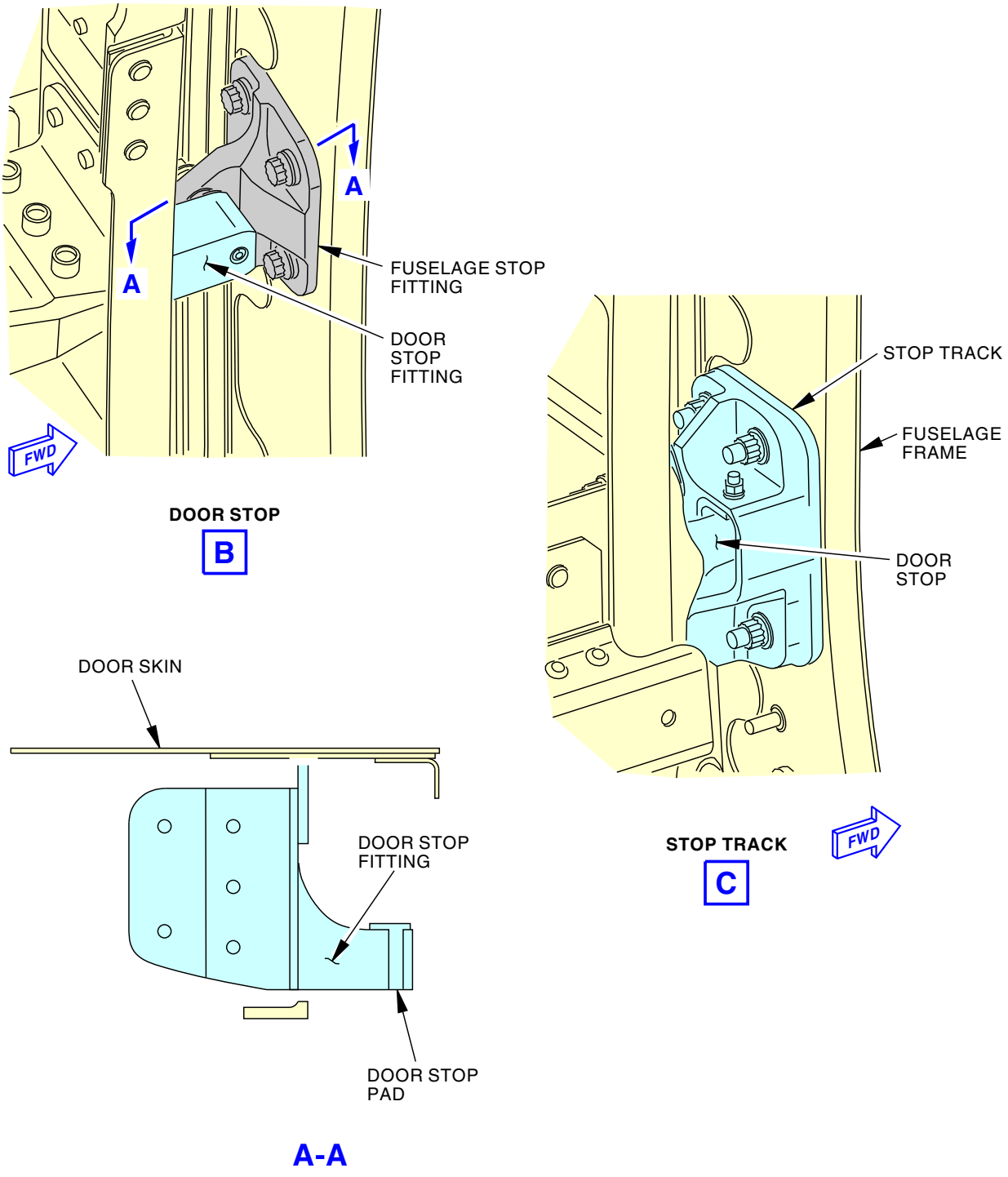
**EMERGENCY EXIT DOOR
(DOOR IN THE CLOSED POSITION
WITH DOOR LINING REMOVED)
(EXAMPLE)**

A

2415686 S00061538680_V1

**External - Left Overwing Emergency Exit Hatches
Figure 228/52-05-03-990-828 (Sheet 1 of 2)**

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415687 S00061538681_V1

External - Left Overwing Emergency Exit Hatches
Figure 228/52-05-03-990-828 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-820

29. EXTERNAL - DETAILED: RIGHT OVERWING EMERGENCY EXIT DOOR STOP FITTINGS AND PINS

(Figure 229)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

C. Access Panels

Number	Name/Location
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

D. Inspection

SUBTASK 52-05-03-010-025

(1) Open these access panels:

Number	Name/Location
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

NOTE: Inspect with doors opened and lining not removed.

SUBTASK 52-05-03-211-020

(2) Do a Detailed inspection of the automatic overwing exit door stop fittings and pins.

SUBTASK 52-05-03-910-028

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809.

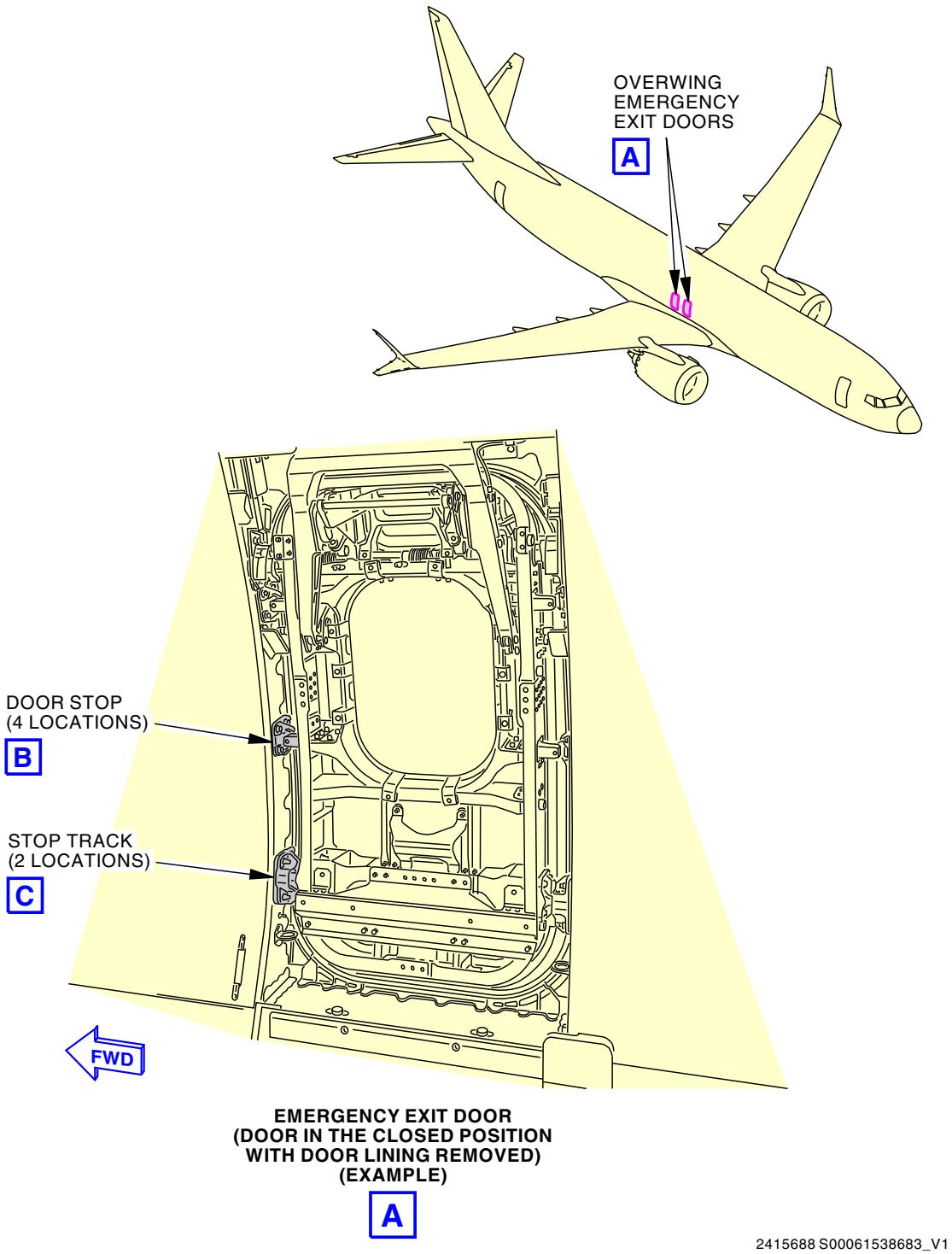
SUBTASK 52-05-03-410-025

(4) Close these access panels:

Number	Name/Location
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



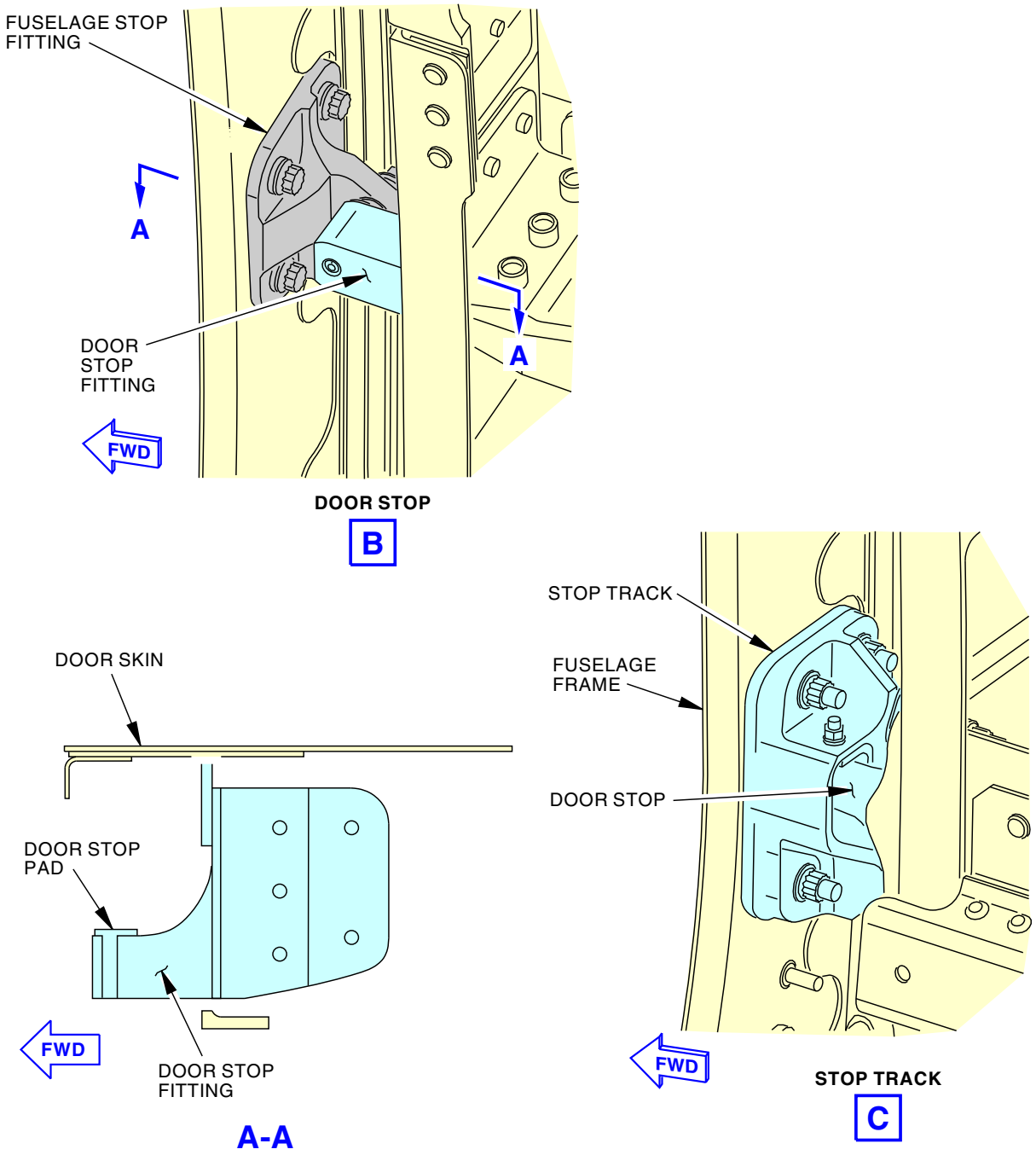
**EMERGENCY EXIT DOOR
(DOOR IN THE CLOSED POSITION
WITH DOOR LINING REMOVED)
(EXAMPLE)**

A

2415688 S00061538683_V1

**External - Right Overwing Emergency Exit Hatches
Figure 229/52-05-03-990-829 (Sheet 1 of 2)**

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415689 S00061538684_V2

External - Right Overwing Emergency Exit Hatches
Figure 229/52-05-03-990-829 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-821

30. INTERNAL - DETAILED: LEFT OVERWING EMERGENCY EXIT HATCH/AUTOMATIC OVERWING EXIT

(Figure 230)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-810	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)

C. Access Panels

Number	Name/Location
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
S8321	Automatic Overwing Exit Inspection
S8331	Automatic Overwing Exit Inspection

D. Inspection

SUBTASK 52-05-03-010-026

(1) Open these access panels:

Number	Name/Location
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)

Special Access:

Number	Name/Location
S8321	Automatic Overwing Exit Inspection
S8331	Automatic Overwing Exit Inspection

NOTE: Inspect with hatches removed, the door opened or removed. Remove linings and insulations.

SUBTASK 52-05-03-211-021

(2) Do a Detailed inspection of the automatic overwing exit door stop fittings and pins.

SUBTASK 52-05-03-910-029

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-810.

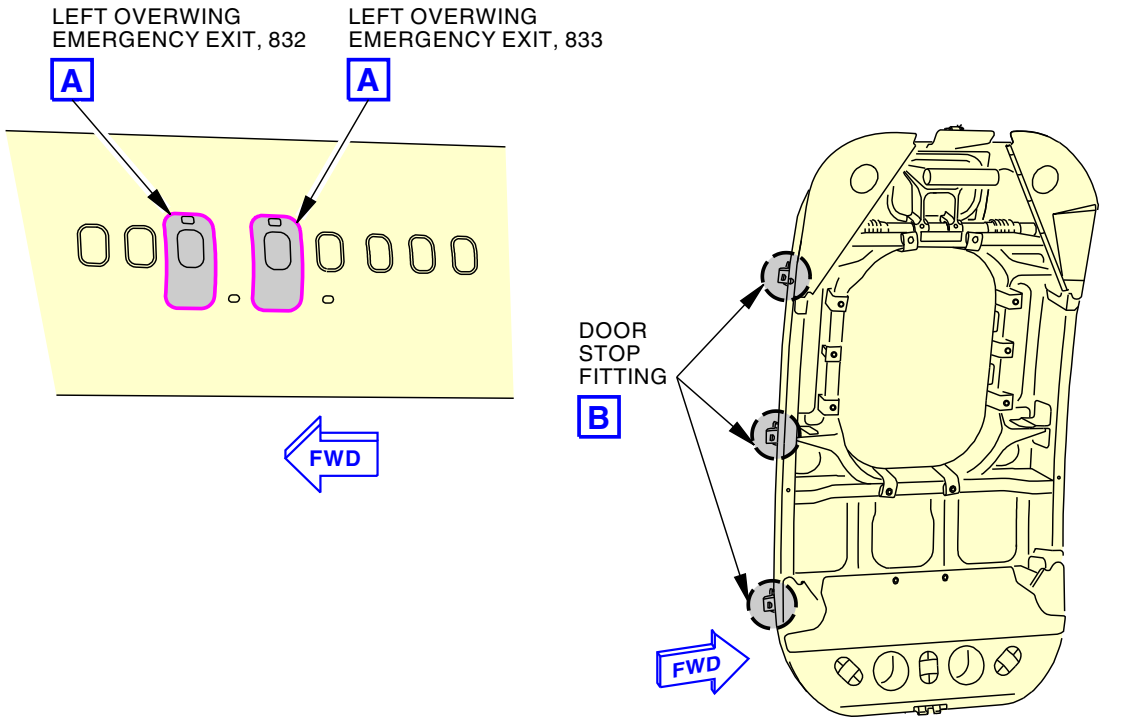
SUBTASK 52-05-03-410-026

(4) Close these access panels:

Number	Name/Location
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)

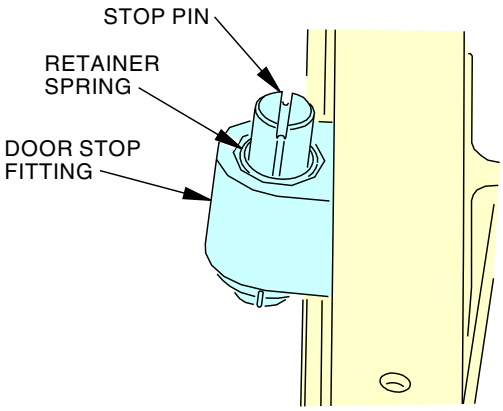
END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



**OVERWING EMERGENCY EXIT HATCH
(LINING REMOVED)
(EXAMPLE)**

A



**DOOR STOP FITTING
(EXAMPLE)**

B

2415690 S00061538686_V2

**Internal - Left Overwing Emergency Exit Hatch/Automatic Overwing Exit
Figure 230/52-05-03-990-830**

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-822

31. INTERNAL - DETAILED: RIGHT OVERWING EMERGENCY EXIT HATCH/AUTOMATIC OVERWING EXIT

(Figure 231)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-810	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

C. Access Panels

Number	Name/Location
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)
S8421	Emergency Exit Door (AOE) Inspection
S8431	Emergency Exit Door (AOE) Inspection

D. Inspection

SUBTASK 52-05-03-010-027

(1) Open these access panels:

Number	Name/Location
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

Special Access:

Number	Name/Location
S8421	Emergency Exit Door (AOE) Inspection
S8431	Emergency Exit Door (AOE) Inspection

NOTE: Inspect with hatches removed, the door opened or removed. Remove linings and insulations.

SUBTASK 52-05-03-211-022

(2) Do a Detailed inspection of the automatic overwing exit door stop fittings and pins.

SUBTASK 52-05-03-910-030

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-810.

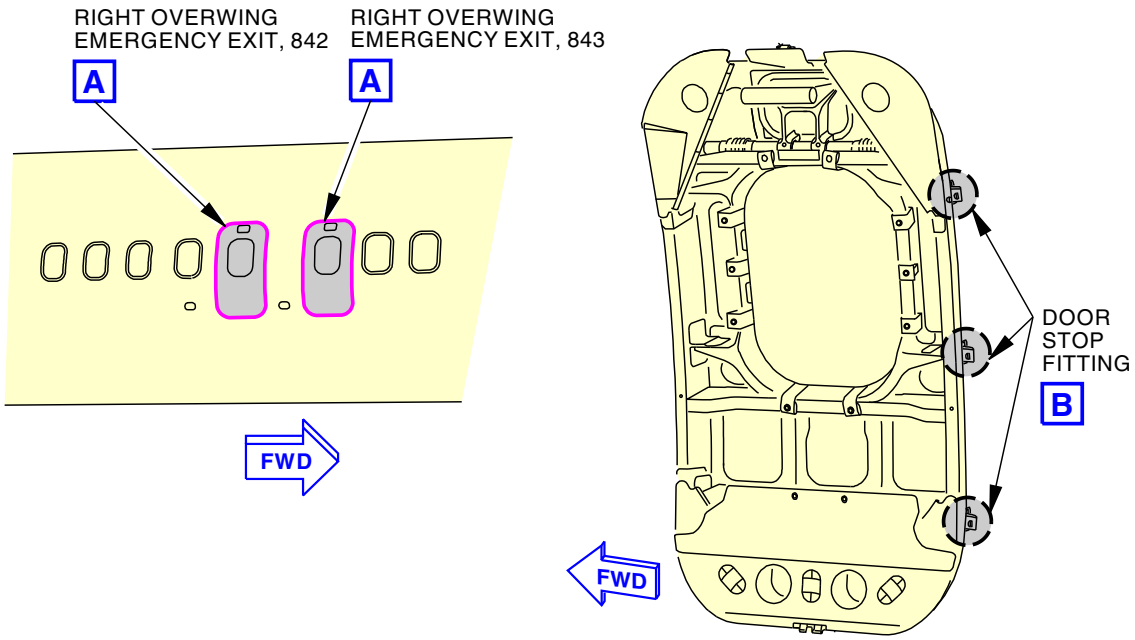
SUBTASK 52-05-03-410-027

(4) Close these access panels:

Number	Name/Location
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

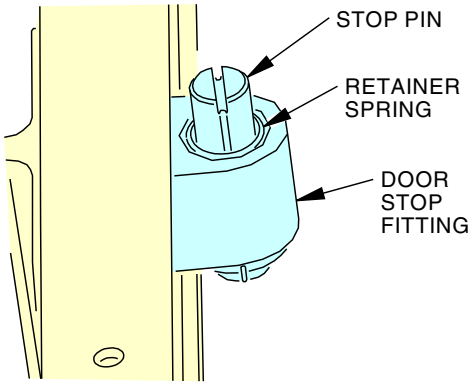
END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



OVERWING EMERGENCY EXIT HATCH (LINING REMOVED) (EXAMPLE)

A



DOOR STOP FITTING (EXAMPLE)

B

2415691 S00061538688_V3

Internal - Right Overwing Emergency Exit Hatch/Automatic Overwing Exit
Figure 231/52-05-03-990-831

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-210-810

32. INTERNAL - GENERAL VISUAL: LEFT OVERWING EMERGENCY EXIT HATCH/AUTOMATIC OVERWING EXIT

(Figure 232)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-808	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)

C. Access Panels

Number	Name/Location
832	Emergency Exit Door (AOE)
832AZ	Panel Assy - Emergency Exit Door (AOE) - Door Liner
833	Emergency Exit Door (AOE)
833AZ	Panel Assy - Emergency Exit Door (AOE) - Door Liner
S8321	Automatic Overwing Exit Inspection
S8331	Automatic Overwing Exit Inspection

D. Inspection

SUBTASK 52-05-03-010-028

(1) Open these access panels:

Number	Name/Location
832	Emergency Exit Door (AOE)
832AZ	Panel Assy - Emergency Exit Door (AOE) - Door Liner
833	Emergency Exit Door (AOE)
833AZ	Panel Assy - Emergency Exit Door (AOE) - Door Liner

Special Access:

Number	Name/Location
S8321	Automatic Overwing Exit Inspection
S8331	Automatic Overwing Exit Inspection

NOTE: Inspect with hatches removed, door opened or removed. Remove linings and insulations.

SUBTASK 52-05-03-210-010

(2) Do a General Visual inspection of the automatic overwing exit door skin and structure.

SUBTASK 52-05-03-910-031

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-808.

SUBTASK 52-05-03-410-028

(4) Close these access panels:

Number	Name/Location
832	Emergency Exit Door (AOE)

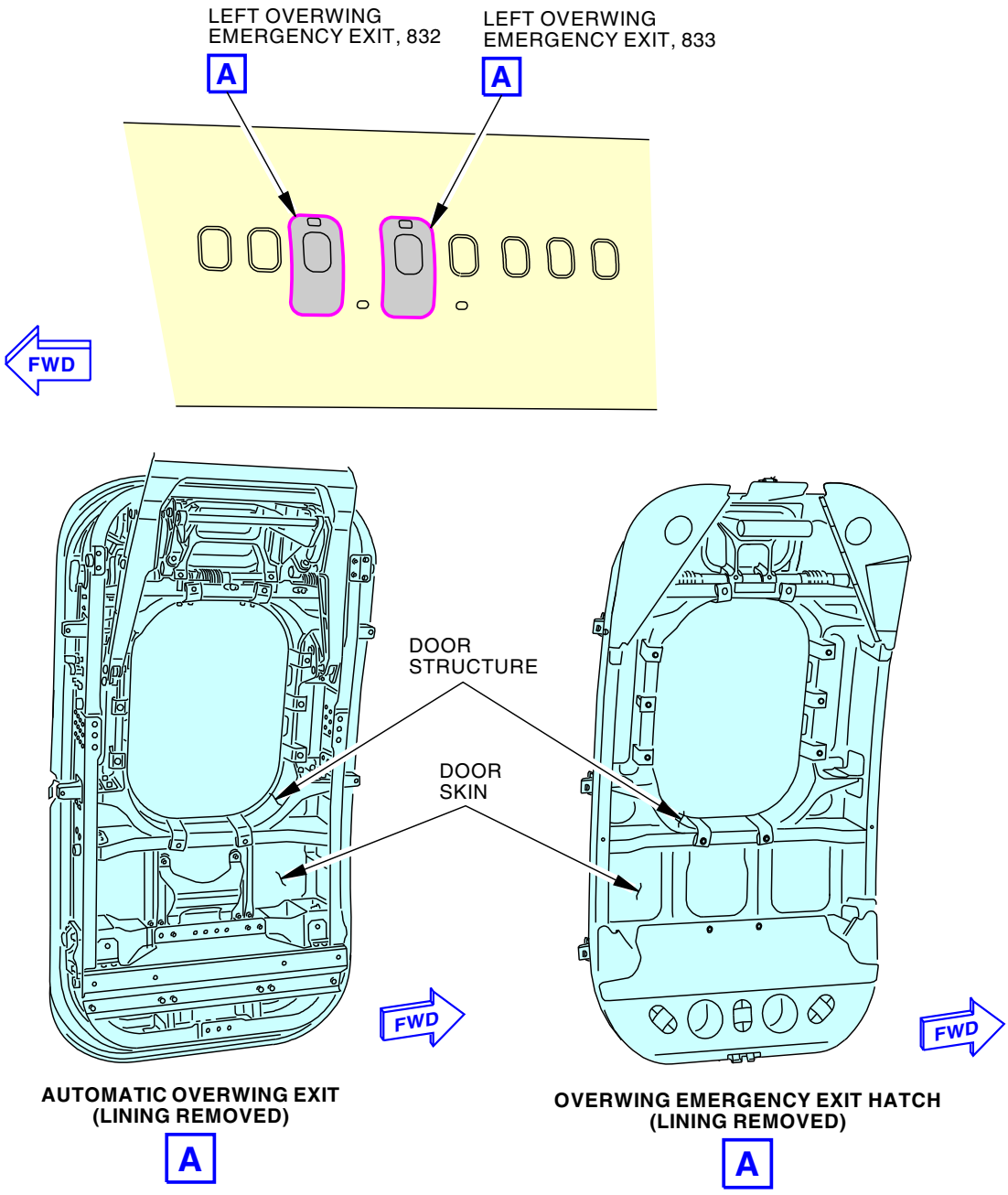
ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
832AZ	Panel Assy - Emergency Exit Door (AOE) - Door Liner
833	Emergency Exit Door (AOE)
833AZ	Panel Assy - Emergency Exit Door (AOE) - Door Liner

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415692 S00061538690_V2

Left Overwing Emergency Exit Hatch/Automatic Overwing Exit
Figure 232/52-05-03-990-832

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-210-811

33. INTERNAL - GENERAL VISUAL: RIGHT OVERWING EMERGENCY EXIT HATCH/AUTOMATIC OVERWING EXIT

(Figure 233)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-808	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

C. Access Panels

Number	Name/Location
842	Emergency Exit Door (AOE)
842AZ	Panel Assy - Emergency Exit Door (AOE) - Door Liner
843	Emergency Exit Door (AOE)
843AZ	Panel Assy - Emergency Exit Door (AOE) - Door Liner
S8421	Emergency Exit Door (AOE) Inspection
S8431	Emergency Exit Door (AOE) Inspection

D. Inspection

SUBTASK 52-05-03-010-029

(1) Open these access panels:

Number	Name/Location
842	Emergency Exit Door (AOE)
842AZ	Panel Assy - Emergency Exit Door (AOE) - Door Liner
843	Emergency Exit Door (AOE)
843AZ	Panel Assy - Emergency Exit Door (AOE) - Door Liner

Special Access:

Number	Name/Location
S8421	Emergency Exit Door (AOE) Inspection
S8431	Emergency Exit Door (AOE) Inspection

NOTE: Inspect with hatches removed, door opened or removed. Remove linings and insulations.

SUBTASK 52-05-03-210-011

(2) Do a General Visual inspection of the automatic overwing exit door skin and structure.

SUBTASK 52-05-03-910-032

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-808.

SUBTASK 52-05-03-410-029

(4) Close these access panels:

Number	Name/Location
842	Emergency Exit Door (AOE)

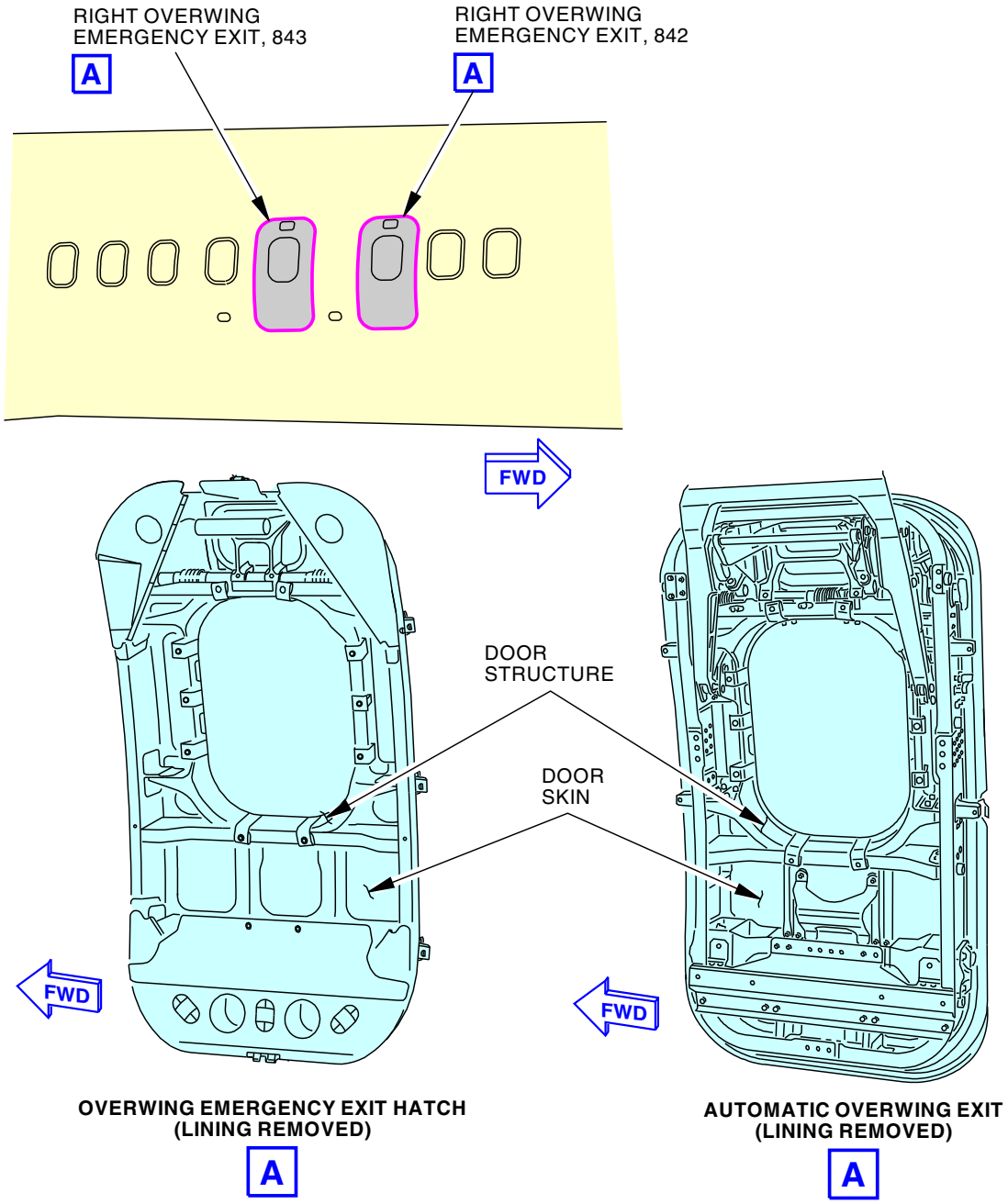
ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
842AZ	Panel Assy - Emergency Exit Door (AOE) - Door Liner
843	Emergency Exit Door (AOE)
843AZ	Panel Assy - Emergency Exit Door (AOE) - Door Liner

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415693 S00061538692_V2

Right Overwing Emergency Exit Hatch/Automatic Overwing Exit
Figure 233/52-05-03-990-833

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-824

34. EXTERNAL - DETAILED: FORWARD ACCESS DOOR SKIN, DOOR STRUCTURE AND HANDLE RECESS

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-807	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

C. Access Panels

Number	Name/Location
112A	Forward Access Door
S1121	Forward Access Door Inspection

D. Inspection

SUBTASK 52-05-03-010-031

(1) Open this access panel:

Number	Name/Location
112A	Forward Access Door

Special Access:

Number	Name/Location
S1121	Forward Access Door Inspection

NOTE: Inspect with door opened and door handle extended.

SUBTASK 52-05-03-211-026

(2) Do a Detailed inspection of the forward access door skin, door structure and door handle recess.

SUBTASK 52-05-03-910-035

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-807

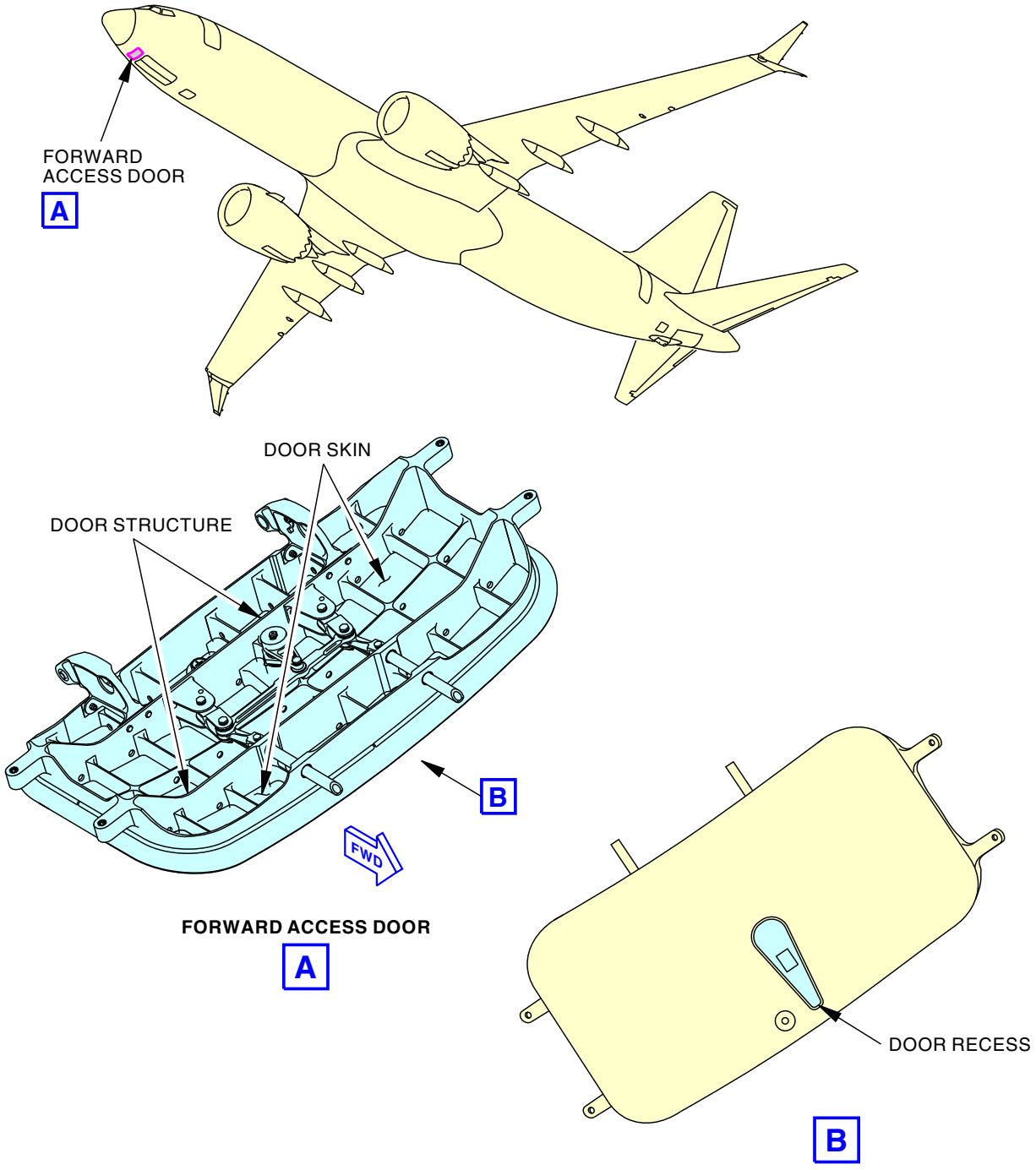
SUBTASK 52-05-03-410-030

(4) Close this access panel:

Number	Name/Location
112A	Forward Access Door

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



External - Forward Access Door
Figure 234/52-05-03-990-834

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-825

35. INTERNAL - DETAILED: FORWARD ACCESS DOOR HINGE FITTINGS AND HINGE PINS

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Access Panels

Number	Name/Location
112A	Forward Access Door
S1121	Forward Access Door Inspection

C. Inspection

SUBTASK 52-05-03-010-032

(1) Open this access panel:

Number	Name/Location
112A	Forward Access Door

Special Access:

Number	Name/Location
S1121	Forward Access Door Inspection

NOTE: Inspect with door opened, visible portions of hinge fittings and hinge pins.

SUBTASK 52-05-03-211-025

(2) Do a Detailed inspection of the forward access door hinge fittings and hinge pins.

SUBTASK 52-05-03-910-034

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809

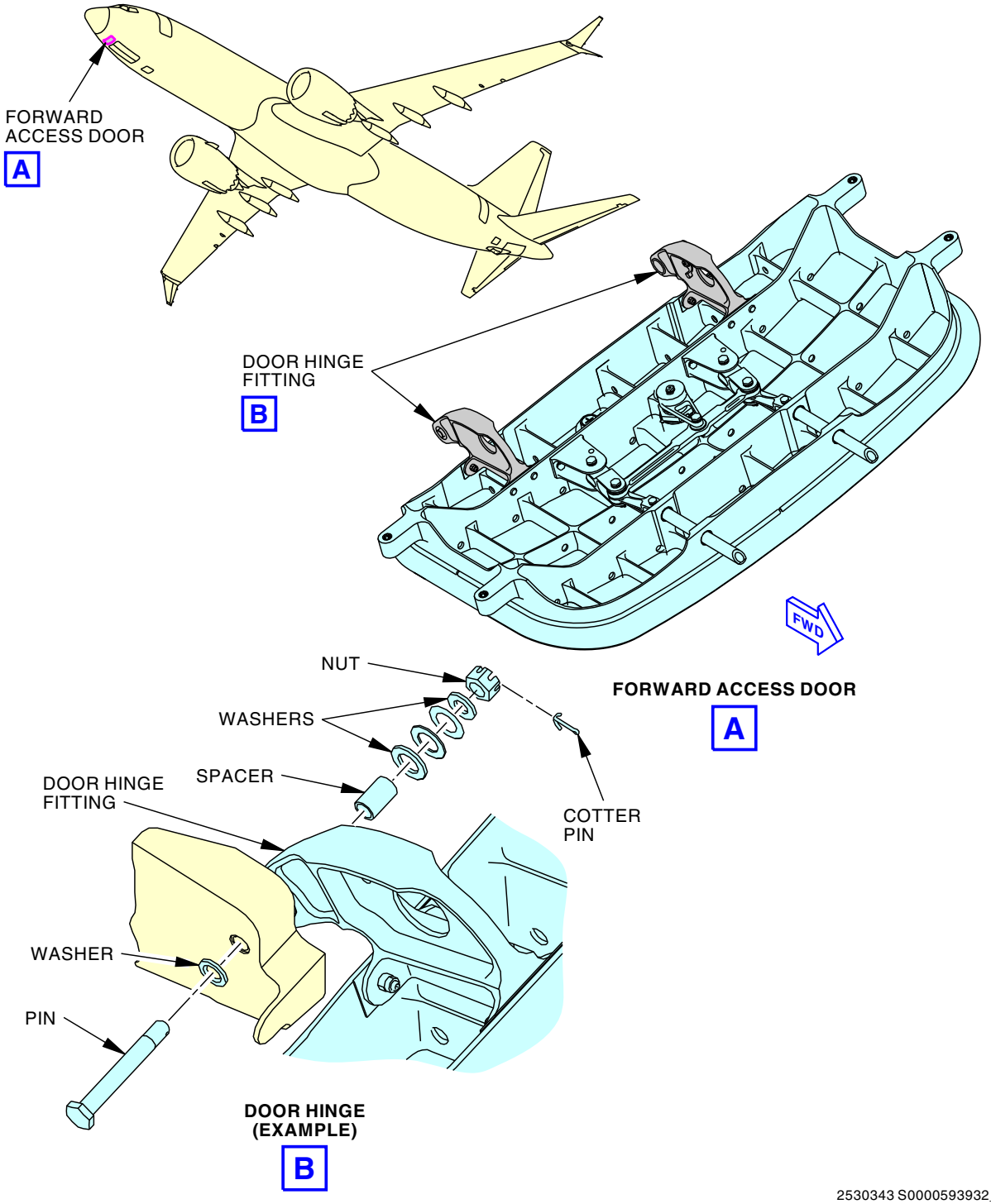
SUBTASK 52-05-03-410-031

(4) Close this access panel:

Number	Name/Location
112A	Forward Access Door

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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Internal - Forward Access Door
Figure 235/52-05-03-990-835

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-210-812

36. INTERNAL - GENERAL VISUAL: FORWARD ACCESS DOOR STOP FITTINGS, STOP PINS, STOP BUSHINGS, LATCH PINS

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Access Panels

Number	Name/Location
112A	Forward Access Door
S1121	Forward Access Door Inspection

C. Inspection

SUBTASK 52-05-03-010-033

(1) Open this access panel:

Number	Name/Location
112A	Forward Access Door

Special Access:

Number	Name/Location
S1121	Forward Access Door Inspection

SUBTASK 52-05-03-210-012

(2) Do a General Visual inspection of the forward access door stop fittings, stop pins, stop bushings and latch pins.

NOTE: Inspect with door removed.

SUBTASK 52-05-03-910-036

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809

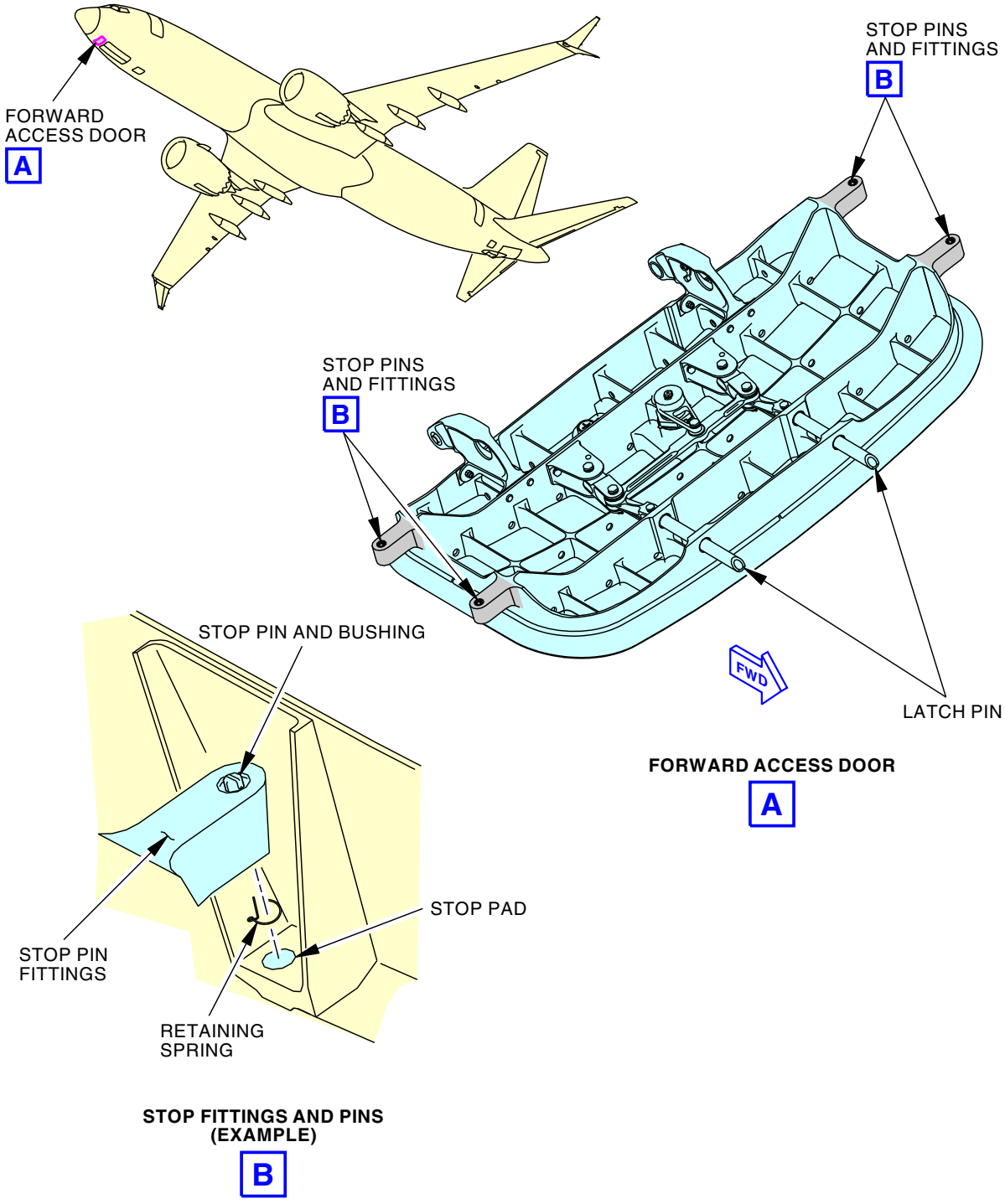
SUBTASK 52-05-03-410-032

(4) Close this access panel:

Number	Name/Location
112A	Forward Access Door

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Forward Access Door General Visual (Internal)
Figure 236/52-05-03-990-836

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-05-03-211-823

37. INTERNAL - DETAILED: FLIGHT DECK SECURITY DOOR LATCH AND HINGE SUPPORT ASSEMBLIES

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

C. Inspection

NOTE: Disassemble door only if evidence of damage, fatigue, delamination, and or bulging is found.

SUBTASK 52-05-03-211-023

(1) Do a detailed inspection of the Flight Deck Door latch and hinge support assemblies.

SUBTASK 52-05-03-910-033

(2) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

STANDARD DOOR SEALS - INSPECTION/CHECK

1. General

A. This procedure has this task:

(1) A check of the door seal.

TASK 52-09-00-700-801

2. Door Seal - Inspection/Check

Figure 201

A. General

(1) This task gives the instructions to do a check and test of the seals for the entry, service, cargo, and emergency exit doors.

B. References

Reference	Title
05-51-91-790-801	Cabin Pressure Leak Test (P/B 201)
52-09-10 P/B 801	DOOR SEALS - REPAIRS

C. Tools/Equipment

Reference	Description
STD-600	Mirror - Inspection
STD-1081	Flashlight - Explosion Proof
STD-1160	Stand - Cabin and General Access Stand, Adjustable Height, Max. Height 18 Feet, Platform 5 Feet by 10 Feet

D. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

E. Access Panels

Number	Name/Location
112A	Forward Access Door
117A	Electronic Equipment Access Door
821	Forward Cargo Door
822	Aft Cargo Door
831	Forward Entry Door
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
834	Aft Entry Door
841	Forward Galley Service Door
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)
844	Aft Galley Service Door

ECCN 9E991 BOEING PROPRIETARY - See title page for details

F. Prepare for the Inspection/Check

SUBTASK 52-09-00-010-001

(1) Open these access panels:

Number	Name/Location
112A	Forward Access Door
117A	Electronic Equipment Access Door
821	Forward Cargo Door
822	Aft Cargo Door
831	Forward Entry Door
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
834	Aft Entry Door
841	Forward Galley Service Door
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)
844	Aft Galley Service Door

G. Door Seal Check

SUBTASK 52-09-00-790-001

(1) Open and close the door and do these checks:

(a) Make sure that the seals are clear of the edge of all surrounding structure when the door opens and closes.

(b) Make sure that the blades or bulbs of the seals touch the seal depressors around the edge of the door when the door closes.

(c) Make sure that the seal does not flip outboard at the corners when the door closes.

(d) Make sure that there are no cuts, delamination, or damage to the seal.

(e) Make sure that the waviness in the straight sections of the seals is as shown Figure 201.

(f) Make sure that the door seal will not leak. Do these steps to check for light leaks:

1) Prepare for the light check

a) Remove the applicable linings for the door and doorway (if installed) to get visual access to the door seal.

b) Open and close the door three times.

c) Make sure that the door is closed and locked.

d) Put the adjustable height cabin and general access stand, STD-1160 outboard of the door.

2) Check for a light leak.

a) Point a flashlight beam around the door frame from the outside the airplane.

b) Have a person in the airplane check if the flashlight beam comes into the airplane.

NOTE: If necessary, use an inspection mirror, STD-600.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

<1> Make sure that there are no light leaks between the door seal and seal depressor.

NOTE: In-flight pressurization will cause the doors to move out against the door stops and seal completely. Without pressurization, some light can possibly be seen at the door seal installation. Operators must determine by experience how much light is acceptable for a correct installation.

3) If a light leak is found, do these steps:

a) If necessary, repair or replace the door seal, do this: DOOR SEALS - REPAIRS, PAGEBLOCK 52-09-10/801.

b) Use the explosion proof flashlight, STD-1081 again to check for light leaks.

NOTE: You will have to repeat the light leak check to make sure that the light leaks have been repaired.

(g) If the door seal has light leaks, do this task: Cabin Pressure Leak Test, TASK 05-51-91-790-801.

H. Put the Airplane Back to Its Usual Condition

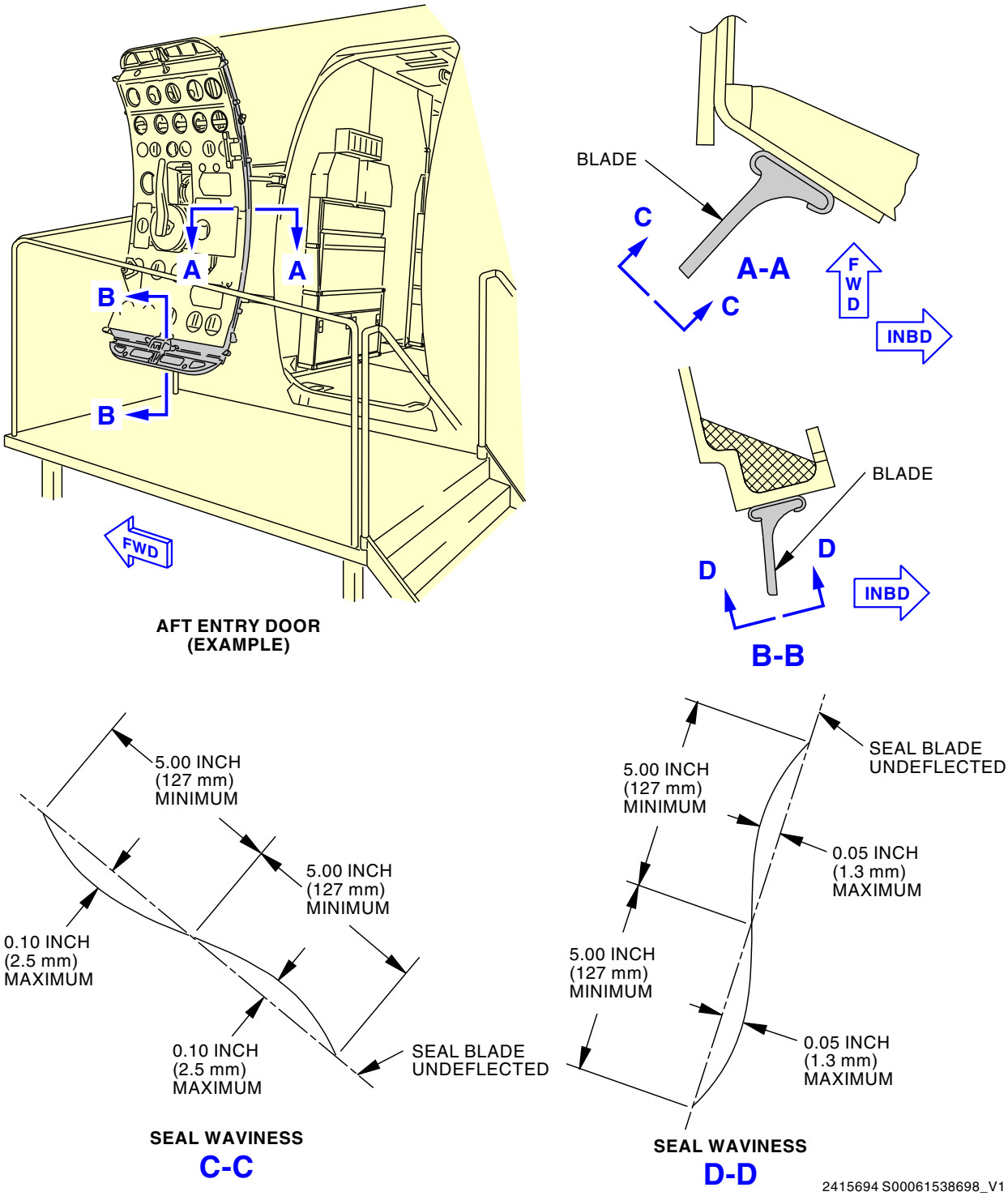
SUBTASK 52-09-00-410-001

(1) Close these access panels:

Number	Name/Location
112A	Forward Access Door
117A	Electronic Equipment Access Door
821	Forward Cargo Door
822	Aft Cargo Door
831	Forward Entry Door
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
834	Aft Entry Door
841	Forward Galley Service Door
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)
844	Aft Galley Service Door

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Door Seals Check
Figure 201/52-09-00-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

DOOR SEALS - REPAIRS

1. General

A. This procedure has a task to repair the door seals.

B. Seals prevent loss of cabin pressure at entry doors, galley service doors, cargo doors, the forward access door, electronic equipment access door, and emergency exit doors. Seals also keep water from entering the airplane at these door locations. Types of seals include:

(1) Blade seals

(2) Bulb seals

(3) Diaphragm seals

C. The silicone rubber seals used in these areas are subject three different types of failure or damage as follows:

(1) Delamination of joints occurs where the mechanical bulb seal section joins the diaphragm seal section on the door seals. The fabric-reinforced rubber which forms the joint peels loose from the mechanical or diaphragm seal. Primary cause of this failure is poor bonding.

(2) Cuts, nicks, splits or tears in the seal section are primarily a result of lack of care in handling and installation.

(3) Splice failure occurs on those continuous seals formed by splicing the ends of the extruded bulb section. Flexing of the seal causes separation of the bond between this material and the ends of the extruded section.

D. Seal repair procedures for the silicone rubber door and hatch seals may be divided into three general methods:

(1) Method A is a procedure for repairs in which the cut, delaminated, or otherwise separated surfaces are rejoined by adhesive only.

(2) Method B consists of repairs with an adhesive reinforced with open mesh fabric. The fabric is embedded in the adhesive on the seal surface.

(3) Method C repair procedure comprises the replacement of a section of seal using adhesive, and when required, fabric cemented into place.

E. Adhesives used for repairs are in three category types as follows:

(1) Type I is a two-part, air-cured adhesive.

(a) Use type I adhesives only on those parts of the blade seal where it is not necessary to have a flexible bond. Do not use on the diaphragm seals or on the seal lip of the blade seals.

(2) Type II is a one-part, air-cured adhesive. It is flexible at low temperatures.

(a) Use type II adhesives for repairs to the seal lip on the blade seals where it is necessary that the adhesive is flexible to make an air-tight seal.

(3) Type III is a quick repair air-cured adhesive (two-part kit) . It is very flexible.

(a) Use type III adhesives for fast repairs. You can use it in all locations on the seal.

TASK 52-09-10-100-801

2. Seal Repair Procedure Surface Preparation

A. General

(1) Make all of the seal repairs with the seal in a position for easy access and when the load on the seal is as small as possible. For seals that are installed, it may be necessary to remove parts of the seal retainer to do work on the damaged area.

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(2) Replace the seal if the damage is extensive.

B. Consumable Materials

Reference	Description	Specification
B00068	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002, MIL-E-51454 Type II
B00130	Alcohol - Isopropyl	TT-I-735
B00137	Abrasive - Garnet Coated Paper	
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

C. Procedure

SUBTASK 52-09-10-010-001

(1) Make sure there is access to the seal.

(a) If it is necessary, remove one or more sections of seal retainer to get access to a damaged section of seal.

SUBTASK 52-09-10-100-001

(2) Clean the area of the pressure seals with the seal in a position for easy access, do the steps that follow:

(a) Rub the area and approximately 2 in. (51 mm) or more on all sides of the area with a clean cotton wiper, G00034 that is wet with one of the solvents that follow:

1) solvent, B00148

2) alcohol, B00068

3) alcohol, B00130

(b) Lightly rub the surface to be repaired with the abrasive, B00137 (180 grit minimum).

(c) Wipe dry with a cotton wiper, G00034 before solvent evaporates.

1) If necessary repeat steps to completely remove dirt, oil, paint, and other soils.

NOTE: Clean surfaces are necessary to make a good bond.

——— END OF TASK ———

TASK 52-09-10-350-801

3. Seal Repair Procedures For Specified Types of Seal Damage

(Figure 801)

A. General

(1) Make all of the seal repairs with the seal in a position for easy access and when the load on the seal is as small as possible. For seals that are installed, it may be necessary to remove parts of the seal retainer to do work on the damaged area.

(2) Determine the type of repair that is necessary and the procedure to be used.

(a) Use fabric when a stronger bond is necessary.

(b) Replace the seal if the damage is extensive.

(3) Adhesives used in this procedure as follows:

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Table 801/52-09-10-993-801 Table Of Type I Adhesives

Bulk code	Description	Catalyst	Cure Time *[1]	BAC Process	Specification
Silgrip PSA529 adhesive base, A00336*[2]	**Light yellow, low viscosity, high temperature, silicone pressure sensitive adhesive**	**SRC-18 catalyst, A50112*[2]**	**3-7 Days at 74 ±3°F (23 ±2°C)**	**BAC 5010 Type 77**	**MIL-A-25457B**
RTV430 rubber base, A50025	Condensation Cure, Mouldmaking Rubber	Beta 5 catalyst, A50234*[3] Beta 11 catalyst, A50235*[4]	24 Hours for both catalysts	BAC 5010 Type 68	---

*[1] Refer to manufacturer's instructions for specific cure times based on local conditions of where the product is used.

*[2] Mixing ratio is 100 parts PSA529 base to 3.3 parts SRC-18 catalyst

*[3] Mixing ratio is 10 parts RTV430 base to 1 part Beta 5 catalyst

*[4] Mixing ratio is 10 parts RTV430 base to 1 part Beta 11 catalyst

Table 802/52-09-10-993-802 Table Of Type II Adhesives

Bulk code	Description	Tack Free Time	Cure Time*[1]	BAC Process	Specification
FRV1106 adhesive, A50026	One-component, Flurosilicone, adhesive sealant	20 Minutes	18–24 Hours	BAC 5010 Type 84	---
Dow Corning 732 multi-purpose sealant, A50031	General purpose silicone adhesive/sealant	20 Minutes	24 Hours	BAC 5010 Type 60	MIL-A-46106
Dow Corning 3145 RTV adhesive, A00281	1-part non-flowing adhesive, high tensile strength and elongation, enhanced thermal stability,	78 Minutes	48 Hours	BAC 5010 Type 79	MIL-A-46146
RTV 102 adhesive, A50067	One-Component Acetoxy Adhesive Sealants	20 Minutes	3 days at 77°F (25°C) and 50% relative humidity	BAC 5010 Type 60	MIL-A-46106
RTV 108 adhesive, A00635	One-Component Acetoxy Adhesive Sealants	20 Minutes	3 days at 77°F (25°C) and 50% relative humidity	BAC 5010 Type 60	MIL-A-46106

*[1] Refer to manufacturer's instructions for specific cure times based on local conditions of where the product is used.

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Table 803/52-09-10-993-803 Table Of Type III Adhesives

Bulk code	Description	Primer*[1]	Cure Time*[2]	BAC Process	Specification
Dow Corning 93-076-1/2 RF sealant and catalyst kit, A50094	Two part, thixotripic silicone elastomer	Dow Corning PR-1204 prime coat, C50242 or PR 1204 primer, A50126	4 Hours at 185°F (85°C) or 2 Hours at 203°F (95°C)	BAC 5010 Type 68	---
Dow Corning 93-076-2 RF sealant and catalyst kit, A50233	Two part, thixotripic silicone elastomer	Dow Corning PR-1204 prime coat, C50242 or PR 1204 primer, A50126	4 Hours at 185°F (85°C) or 2 Hours at 203°F (95°C)	BAC 5010 Type 68	---

*[1] This product enhances bonding but is not manditory for the sealant to fully cure

*[2] Refer to manufacturer's instructions for specific cure times based on local conditions of where the product is used.

B. Tools/Equipment

Reference	Description
STD-123	Brush - Soft Bristle
STD-1415	Knife - Utility

C. Consumable Materials

Reference	Description	Specification
A00281	Adhesive - Dow Corning 3145 RTV	MIL-A-46146 (BAC5010 Type 79)
A00336	Adhesive - Silicone Pressure Sensitive, Momentive Performance Materials Silgrip PSA529 Base (Formerly GE Silicones)	BAC5010 Type 77
A00635	Adhesive - RTV 108 Translucent Silicone Rubber RTV Paste, One-part	BAC5010 Type 60 Class A Grade 2 / MIL-A-46106 Type 1
A50025	Adhesive - Condensation Cure, Mouldmaking Rubber, Momentive Performance Materials RTV430 Base (Formerly GE Silicones)	
A50026	Adhesive - One-Component, Fluorosilicone, Momentive Performance Materials FRV1106 (Formally GE Silicones)	BAC5010 Type 84
A50031	Sealant - Dow Corning 732 Multi-Purpose Sealant	MIL-A-46106
A50067	Adhesive - Silicone Rubber - RTV 102 (White)	MIL-A-46106 Group 1 Type 1, BAC5010 Type 60 Class A Grade 1
A50094	Sealant - Kit (Sealant & Catalyst), Dow Corning 93-076-1/2 RF (Formerly 93-076-1/2. Use until Stock depleted)	
A50112	Catalyst - Silgrip Silicone Pressure Sensitive Adhesive Catalyst, Momentive Performance Materials SRC-18 Catalyst	BAC5010 Type 77
A50126	Primer - Adhesive Bonding (Formerly Dow Corning 1204 Clear)	

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(Continued)

Reference	Description	Specification
A50233	Sealant - Kit (Sealant & Catalyst), Dow Corning 93-076-2 RF (Formerly 93-076-2. Use until Stock depleted)	
A50234	Catalyst - Momentive Performance Materials Beta 5 Catalyst	
A50235	Catalyst - Momentive Performance Materials Beta 11 Catalyst	
C50242	Primer - Dow Corning PR-1204 RTV Prime Coat	

D. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door
830	Subzone - Passenger Compartment Doors, Left
840	Subzone - Passenger Compartment Doors, Right

E. Repair Procedures for Specified Types of Seal Damage

SUBTASK 52-09-10-390-001

(1) Repair a delaminated seal as follows:

NOTE: If the delaminated area is not repaired, leaks can occur when the area increases in size.

(a) If the delamination is on the seal edge, do these steps:

1) Do Seal Repair Procedure (Method A), TASK 52-09-10-350-802 or Seal Repair Procedure (Method B), TASK 52-09-10-350-803 to bond the delaminated seal with one of the adhesives in the tables that follow:

a) Table Of Type II Adhesives/Table 802

b) Table Of Type III Adhesives/Table 803

2) Push the surfaces tightly together to make sure the adhesive fully touches the repair area.

3) Make sure the adhesive cures the minimum time necessary.

(b) If the delamination is away from the seal edge, do these steps:

1) Do Seal Repair Procedure (Method A), TASK 52-09-10-350-802 or Seal Repair Procedure (Method B), TASK 52-09-10-350-803to bond the delaminated seal one of the adhesives in the tables that follow:

a) Table Of Type I Adhesives/Table 801

b) Table Of Type II Adhesives/Table 802

c) Table Of Type III Adhesives/Table 803

2) Push the surfaces tightly together to make sure the adhesive fully touches the repair area.

3) Make sure the adhesive cures the minimum time necessary.

SUBTASK 52-09-10-390-002

(2) Repair a delaminated seal joint as follows:

(a) If the delamination is small (0.50 in^2 (322.58 mm^2) maximum), do these steps:

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1) Do Seal Repair Procedure (Method A), TASK 52-09-10-350-802 to bond the delaminated seal with one of the adhesives in the table that follows:
   a) Table Of Type I Adhesives/Table 801
2) Push the surfaces tightly together to make sure the adhesive fully touches the repair area.
3) Make sure the adhesive cures the minimum time necessary.

(b) If the delamination is at the edge of the splice and the seal does not seal satisfactorily, do these steps:
1) Cut and remove the delaminated piece with a sharp knife, STD-1415.
2) Apply a light layer of one of the adhesives in the tables that follows:
   a) Table Of Type II Adhesives/Table 802
   b) Table Of Type III Adhesives/Table 803

SUBTASK 52-09-10-390-003

(3) Repair a cut or split in the rubber in the joint area of a seal as follows:
(a) Do Seal Repair Procedure (Method B), TASK 52-09-10-350-803 to bond the damaged seal with fabric and one of the adhesives in the tables that follow:
1) Table Of Type II Adhesives/Table 802
2) Table Of Type III Adhesives/Table 803
(b) Push the surfaces tightly together to make sure the adhesive fully touches the repair area.
(c) Make sure the adhesive cures the minimum time necessary.

SUBTASK 52-09-10-390-004

(4) Repair a cut or split in the blade or bulb section of a seal as follows:
(a) If the damage is a small cut or split (0.20 in. (5.08 mm) maximum length), do these steps:
1) Do Seal Repair Procedure (Method A), TASK 52-09-10-350-802 to bond the damaged seal with one of the adhesives in the tables that follow:
   a) Table Of Type I Adhesives/Table 801
   b) Table Of Type II Adhesives/Table 802
   c) Table Of Type III Adhesives/Table 803
2) Push the surfaces tightly together to make sure the adhesive fully touches the repair area.
3) Make sure the adhesive cures the minimum time necessary.
(b) If the damage is a large cut or split (1.00 in. (25.40 mm) maximum length), do these steps:
1) Push on the seal to open the cut.
2) Carefully drill a hole in each end of the cut.

   NOTE: A sharpened metal tube can be used as a drill bit to cut the holes.
3) Make the holes smooth and miter the edges.
4) Do Seal Repair Procedure (Method A), TASK 52-09-10-350-802 to bond the damaged seal with one of the adhesives in the tables that follow:
   a) Table Of Type II Adhesives/Table 802
   b) Table Of Type III Adhesives/Table 803

ECCN 9E991 BOEING PROPRIETARY - See title page for details

5) Push the surfaces tightly together to make sure the adhesive fully touches the repair area.

6) Make sure the adhesive cures the minimum time necessary.

(c) If the damage to the seal is a large split (2.00 in. (50.80 mm) maximum length), do these steps:

1) Push on the seal to open the cut.

2) Carefully drill a hole in each end of the cut.

NOTE: A sharpened metal tube can be used as a drill bit to cut the holes.

3) Make the holes smooth and miter the edges.

4) Do Seal Repair Procedure (Method B), TASK 52-09-10-350-803 to bond the damaged seal with one of the adhesives in the tables that follow:

a) Table Of Type I Adhesives/Table 801

b) Table Of Type II Adhesives/Table 802

c) Table Of Type III Adhesives/Table 803

5) Cut the fabric to make an overlap of 0.50 in. (12.70 mm) on the sides and ends of the split.

6) Push the surfaces tightly together to make sure the adhesive fully touches the repair area.

7) Make sure the adhesive cures the minimum time necessary.

SUBTASK 52-09-10-390-005

(5) Repair a damaged seal flange (3.00 in. (76.20 mm) maximum patch length) as follows:

(a) If it is not necessary to replace the flange, do these steps:

1) Do Seal Repair Procedure (Method B), TASK 52-09-10-350-803 to bond the damaged seal with one of the adhesives in the tables that follow:

a) Table Of Type II Adhesives/Table 802

b) Table Of Type III Adhesives/Table 803

2) Cut the fabric to make an overlap of 0.50 in. (12.70 mm) on the sides and ends of the split.

3) Push the surfaces tightly together to make sure the adhesive fully touches the repair area.

4) Make sure the adhesive cures the minimum time necessary.

(b) If a part of the flange is missing, do these steps:

1) Trim the seal edge adjacent to the missing part of the flange.

2) Cut a piece of replacement flange that is a correct fit for the missing part.

3) Do Seal Repair Procedure (Method C), TASK 52-09-10-350-804 to bond the replacement seal patch to the seal with one of the adhesives in the tables that follow:

a) Table Of Type II Adhesives/Table 802

b) Table Of Type III Adhesives/Table 803

4) Cut the fabric to make an overlap of 0.50 in. (12.70 mm) on the sides and ends of the split.

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5) Push the surfaces tightly together to make sure the adhesive fully touches the repair area.

6) Make sure the adhesive cures the minimum time necessary.

SUBTASK 52-09-10-390-006

(6) Repair a damaged seal lip or flat side of a seal blade (3.00 in. (76.20 mm) maximum patch length) as follows:

(a) If it is not necessary to replace the seal blade piece, do these steps:

1) Do Seal Repair Procedure (Method B), TASK 52-09-10-350-803 or Seal Repair Procedure (Method C), TASK 52-09-10-350-804 to bond the damaged seal with fabric one of the adhesives in the tables that follow:

a) Table Of Type II Adhesives/Table 802

b) Table Of Type III Adhesives/Table 803

2) Cut the fabric to make an overlap of 0.50 in. (12.70 mm) on the sides and ends of the split.

a) The patch must be 0.25 in. (6.35 mm) from the flange on both sides of the seal.

b) The patch must not stop on the flat area of the blade.

3) Push the surfaces tightly together to make sure the adhesive fully touches the repair area.

4) Make sure the adhesive cures the minimum time necessary.

(b) If a part of the seal is missing, do these steps:

1) Trim the seal edge adjacent to the missing part of the seal.

2) Cut a piece of replacement seal that is a correct fit for the missing part.

3) Do Seal Repair Procedure (Method C), TASK 52-09-10-350-804 to bond the replacement seal patch to the seal with one of the adhesives in the tables that follow:

a) Table Of Type II Adhesives/Table 802

b) Table Of Type III Adhesives/Table 803

4) Cut the fabric to make an overlap of 0.50 in. (12.70 mm) on the sides and ends of the split.

a) The patch must be 0.25 in. (6.35 mm) from the flange on both sides of the seal.

b) The patch must not stop on the flat area of the blade.

5) Push the surfaces tightly together to make sure the adhesive fully touches the repair area.

6) Make sure the adhesive cures the minimum time necessary.

SUBTASK 52-09-10-390-007

(7) Repair splice damage on entry door and galley service door seals as follows:

(a) Do Seal Repair Procedure (Method A), TASK 52-09-10-350-802 or Seal Repair Procedure (Method B), TASK 52-09-10-350-803 with one of the adhesives in the tables that follow:

1) Table Of Type II Adhesives/Table 802

2) Table Of Type III Adhesives/Table 803

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(b) Push the surfaces tightly together to make sure the adhesive fully touches the repair area.

(c) Make sure the adhesive cures the minimum time necessary.

SUBTASK 52-09-10-390-008

(8) Repair separation of splice bonds on cargo door and escape exit seals as follows:

(a) Do Seal Repair Procedure (Method B), TASK 52-09-10-350-803.

(b) Use a soft bristle brush, STD-123 to apply the adhesive on the clean surfaces of the seal. Use one of the adhesives in the tables that follow:

1) Table Of Type II Adhesives/Table 802

2) Table Of Type III Adhesives/Table 803

(c) Cut the fabric 2.00 in. (50.80 mm) in width, and sufficiently long to put fully around the seal.

(d) Push the surfaces tightly together to make sure the adhesive fully touches the repair area.

(e) Make sure the adhesive cures the minimum time necessary.

(f) Apply more light layers of adhesive with the brush.

(g) Make the edges of the patch smooth to make sure the seal lip is flat.

(h) To prevent a rigid area on the seal lip, do not apply too much adhesive.

SUBTASK 52-09-10-390-009

(9) Repair large damage to seal parts as follows:

(a) Find the seal splices in the straight parts of the seal.

(b) Remove the full damaged area.

(c) Replace the damaged area with a piece of replacement seal that has the same dimensions.

(d) Make mitered cuts on the seal surfaces that touch.

(e) Fill them with adhesive from the tables that follow:

1) Table Of Type II Adhesives/Table 802

2) Table Of Type III Adhesives/Table 803

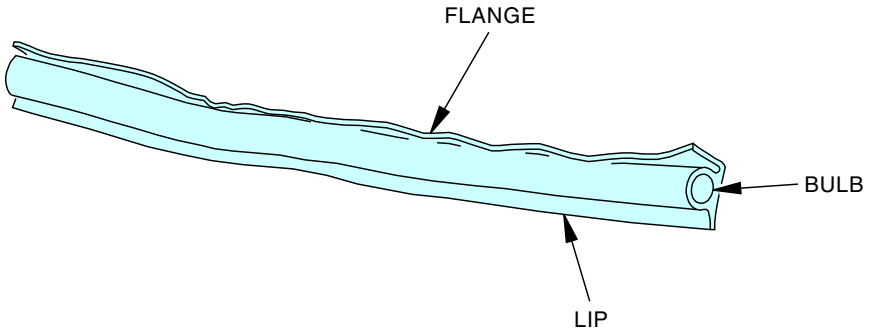
(f) Do Seal Repair Procedure (Method B), TASK 52-09-10-350-803 and Seal Repair Procedure (Method C), TASK 52-09-10-350-804 to bond the seal splices.

(g) Push the surfaces tightly together to make sure the adhesive fully touches the repair area.

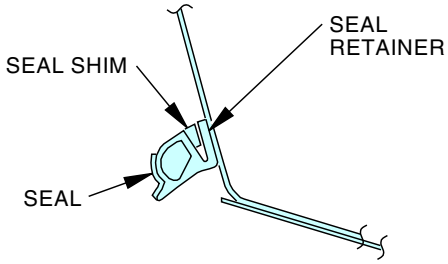
(h) Make sure the adhesive cures the minimum time necessary.

——— END OF TASK ———

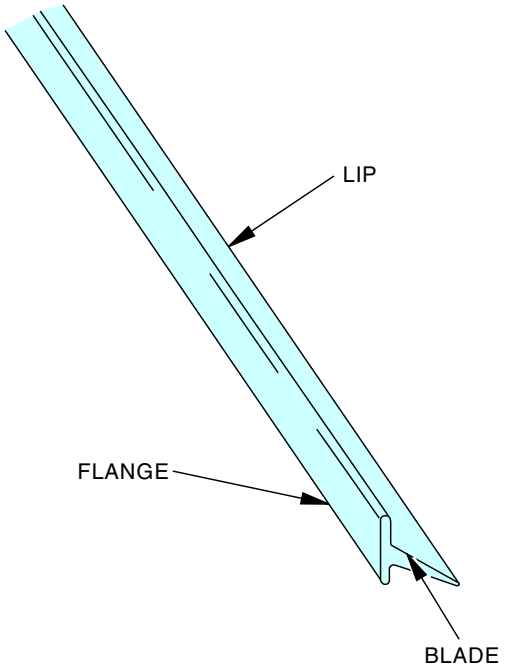
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BULB SEAL



SEAL SHIM

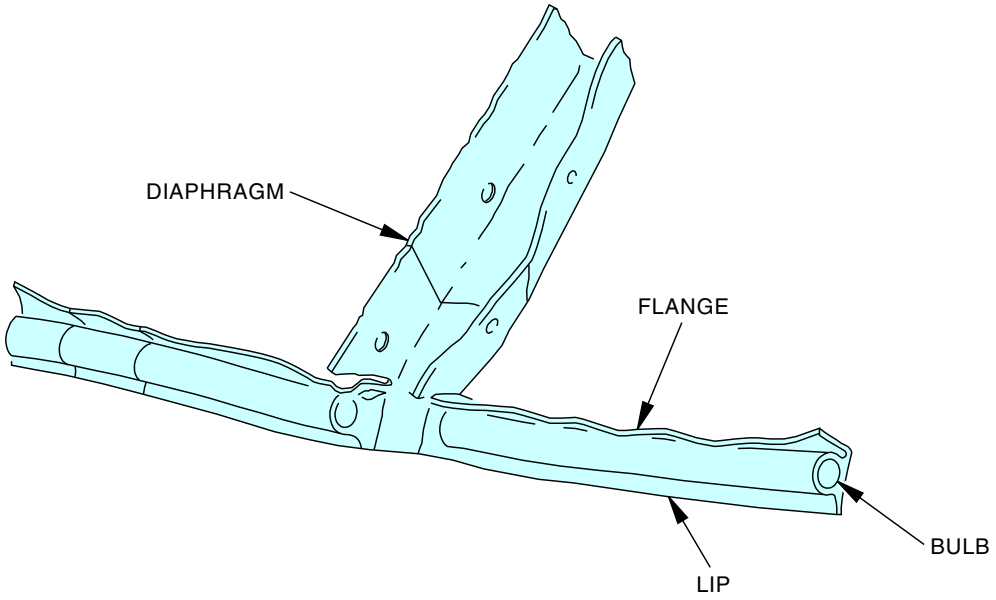


BLADE SEAL

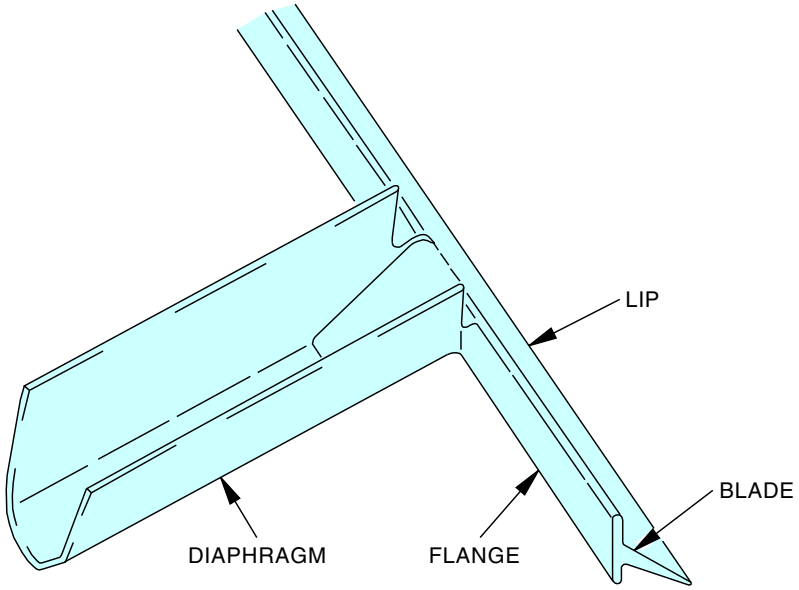
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Door Seals - Repairs
Figure 801/52-09-10-990-801 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



BULB AND DIAPHRAGM COMBINATION SEAL

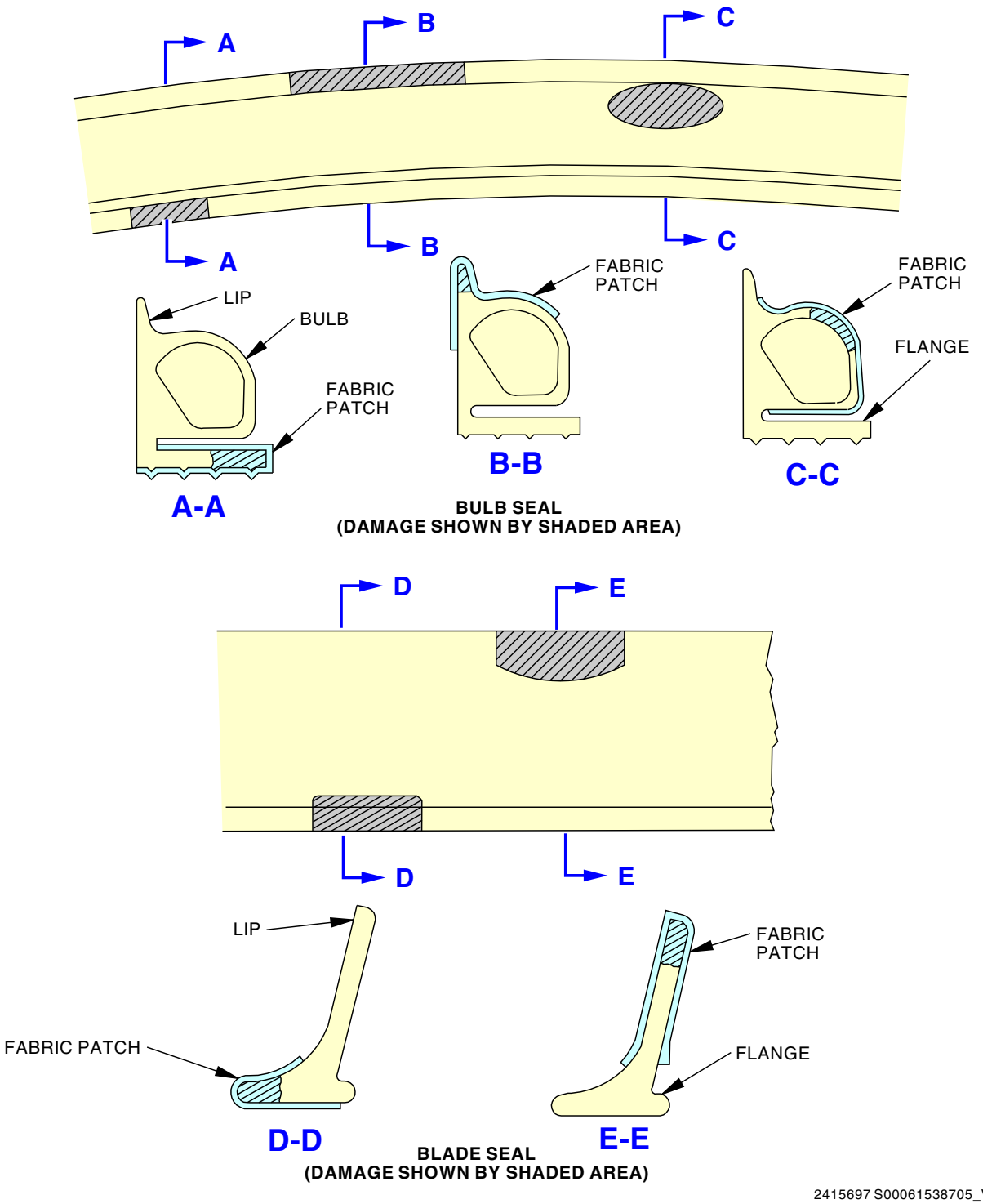


BLADE AND DIAPHRAGM SEALS

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Door Seals - Repairs
Figure 801/52-09-10-990-801 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Door Seals - Repairs
Figure 801/52-09-10-990-801 (Sheet 3 of 3)

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TASK 52-09-10-350-802

4. Seal Repair Procedure (Method A)

A. General

(1) This procedure is for repairs that only use adhesive.

B. Procedure

SUBTASK 52-09-10-300-001

(1) Do the steps that follow to repair the seal with adhesive only:

(a) Apply the adhesive to all of the areas to be bonded.

(b) Put a load on the seal to make sure the seal fully touches the adhesive.

(c) Let the adhesive cure the minimum time necessary before you put a load on it.

END OF TASK

TASK 52-09-10-350-803

5. Seal Repair Procedure (Method B)

A. General

(1) This procedure is for repairs with an adhesive reinforced with open mesh fabric. The fabric is embedded in the adhesive on the seal surface.

B. Consumable Materials

Reference	Description	Specification
G00028	Fabric - Dacron, 70/34 Mesh (Mohawk Dacron Fabrics - D117 Fabric)	
G00029	Fabric - Polyester, 30/17 Mesh (Mohawk Polyester Fabrics - P118 Fabric, Formerly Mohawk Dacron D118 Fabric)	

C. Procedure

SUBTASK 52-09-10-300-002

(1) Do the steps that follow to repair the seal with adhesive and open-meshed fabric:

(a) Cut the fabric to have the correct fit for the patch area. Use one of the fabrics that follow:

1) D117 Dacron Fabric, G00028

2) P118 polyester fabric, G00029

(b) Apply the adhesive to the repair area on the seal.

(c) Push the fabric patch into the wet adhesive and apply more adhesive on top of the patch.

(d) Make the surface smooth of unwanted adhesive and put a load on to make sure the seal fully touches the adhesive.

(e) Apply pressure to make sure the parts are fully bonded.

(f) Let the adhesive cure the minimum time necessary before you put a load on it.

END OF TASK

TASK 52-09-10-350-804

6. Seal Repair Procedure (Method C)

A. General

(1) This procedure replaces the damaged seal part with an equivalent piece of replacement seal.

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B. Consumable Materials

Reference	Description	Specification
G00028	Fabric - Dacron, 70/34 Mesh (Mohawk Dacron Fabrics - D117 Fabric)	
G00029	Fabric - Polyester, 30/17 Mesh (Mohawk Polyester Fabrics - P118 Fabric, Formerly Mohawk Dacron D118 Fabric)	

C. Procedure

SUBTASK 52-09-10-300-003

(1) Do the steps that follow to repair the seal with equivalent piece of replacement seal:

(a) Cut a piece of replacement seal that will have the correct fit for the repair area.

(b) Miter the seal and the replacement piece of seal to the correct fit.

(c) Do one of the procedures that follow:

1) To repair the seal with adhesive only:

a) Apply the adhesive to all of the areas to be bonded.

b) Put a load on the seal to make sure the seal fully touches the adhesive.

c) Let the adhesive cure the minimum time necessary before you put a load on it.

2) To repair the seal with adhesive and open-meshed fabric:

a) Cut the fabric to have the correct fit for the patch area. Use one of the fabrics that follow:

<1> D117 Dacron Fabric, G00028.

<2> P118 polyester fabric, G00029.

b) Apply the adhesive to the repair area on the seal.

c) Push the fabric patch into the wet adhesive and apply more adhesive on top of the patch.

d) Make the surface smooth of unwanted adhesive and put a load on to make sure the seal fully touches the adhesive.

e) Apply pressure to make sure the parts are fully bonded.

f) Let the adhesive cure the minimum time necessary before you put a load on it.

——— END OF TASK ———

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BLADE SEALS - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Blade seals removal

(2) Blade seals installation.

B. Blade seals are one-piece seals used to maintain cabin pressurization and are installed around the edges.

C. This procedure is the same for each door.

TASK 52-09-11-000-801

2. Blade Seals Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the blade seals.

B. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well
117	Electrical and Electronics Compartment - Left
821	Forward Cargo Door
822	Aft Cargo Door
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

C. Access Panels

Number	Name/Location
112A	Forward Access Door
117A	Electronic Equipment Access Door
821	Forward Cargo Door
822	Aft Cargo Door
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

D. Prepare for the Removal

SUBTASK 52-09-11-010-001

(1) Open the applicable access doors to get access to the blade seal [1]:

Number	Name/Location
112A	Forward Access Door
117A	Electronic Equipment Access Door
821	Forward Cargo Door
822	Aft Cargo Door
832	Emergency Exit Door (AOE)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

E. Blade Seals Removal

SUBTASK 52-09-11-020-001

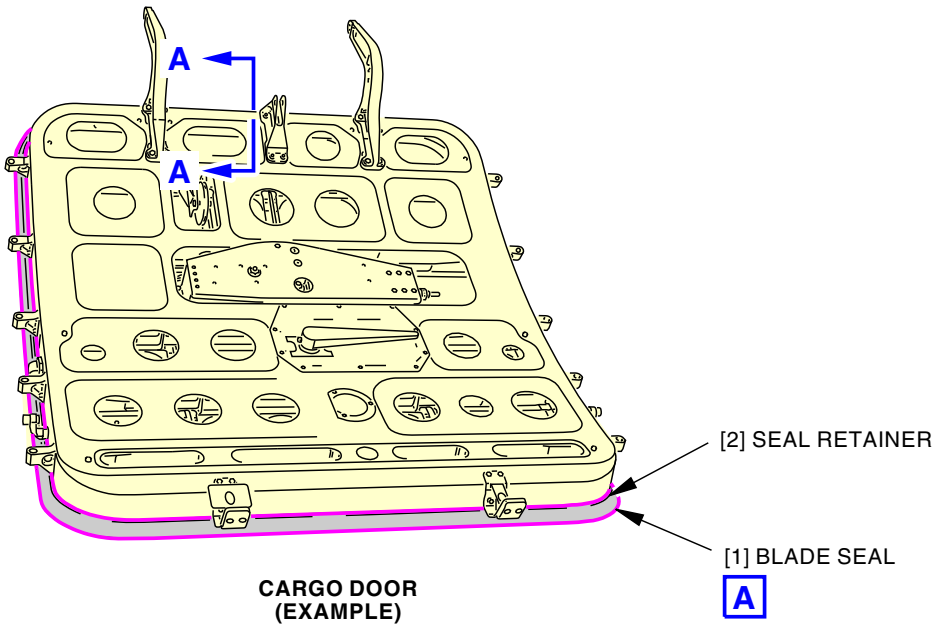
(1) Remove the blade seal [1] from the edge of the door:

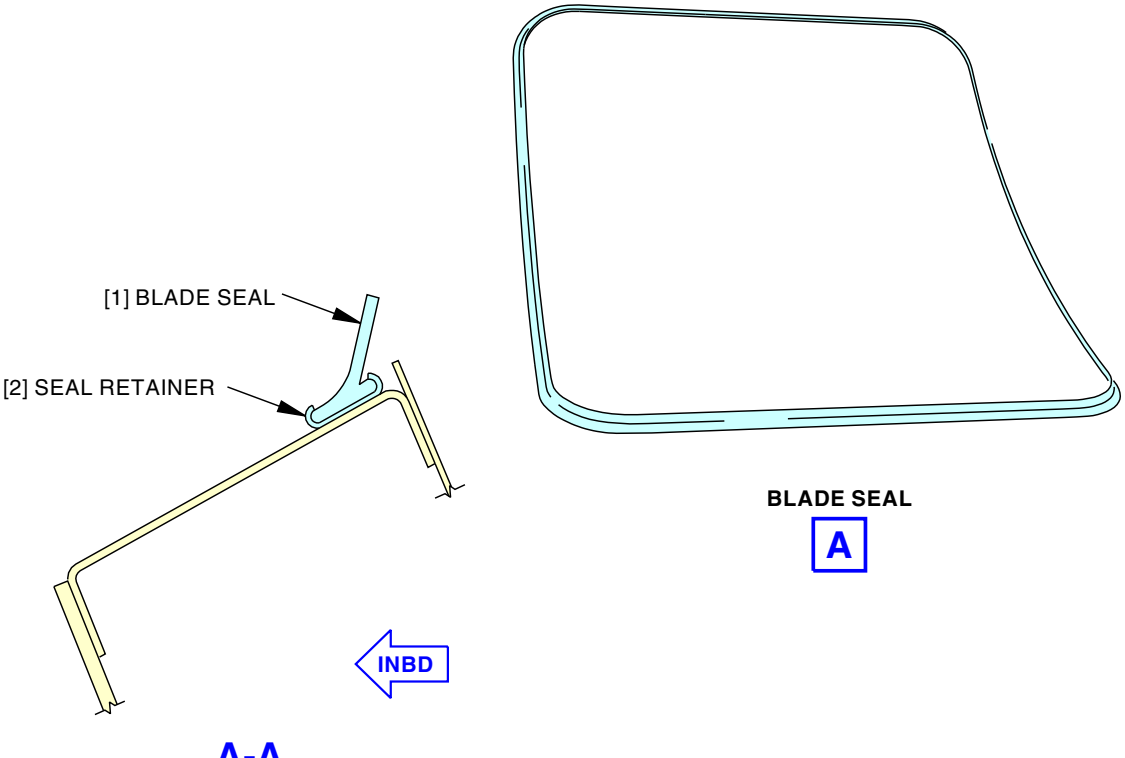
(a) Pull and push the blade seal [1] to disengage it from the seal retainer [2].

(b) Remove the blade seal [1].

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details





Blade Seal Installation
Figure 401/52-09-11-990-802

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-09-11-400-801

3. Blade Seals Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the blade seals.

B. References

Reference	Title
52-09-00-700-801	Door Seal - Inspection/Check (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-1981	Tool - Installation, Door Seal Part #: B52004-1 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
B00052	Soap - Liquid - Turco 1526	BAC5507

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Blade seal	52-09-10-01A-065	SIA ALL

F. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well
117	Electrical and Electronics Compartment - Left
821	Forward Cargo Door
822	Aft Cargo Door
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

G. Access Panels

Number	Name/Location
112A	Forward Access Door
117A	Electronic Equipment Access Door
821	Forward Cargo Door
822	Aft Cargo Door
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

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H. Prepare for the Installation

SUBTASK 52-09-11-110-001

(1) Make sure that the surfaces the blade seal [1] will touch are clean.

I. Blade Seals Installation

SUBTASK 52-09-11-420-001

(1) Install the blade seal [1]:

(a) Put the blade seal [1] in its correct position on the door.

NOTE: The tip of the blade seal [1] goes in the outboard direction.

(b) Move the blade seal [1] onto the door over the seal retainer [2] and keep it aligned correctly.

CAUTION BE CAREFUL WHEN YOU INSTALL THE SEAL. DO NOT CUT OR MAKE TEARS OR HOLES IN THE SEAL. DAMAGE TO THE SEAL CAN EASILY OCCUR.

(c) At each corner of the door, put 1 in. (25 mm) - 2 in. (51 mm) of the inboard edge of the blade seal [1] into the seal retainer [2].

(d) Use the door seal installation tool, SPL-1981 to push the outboard edge of the blade seal [1] into the seal retainer [2].

1) You can use Turco 1526 soap, B00052 to lubricate the blade seal [1] and make it easier to install.

(e) At the center of each side of the door, install 2 in. (51 mm) - 3 in. (76 mm) of the blade seal [1] into the seal retainer [2].

(f) Install the remaining part of the blade seal [1] in the seal retainer [2] along the edges of the door.

(g) Pull and push the blade seal [1] in the seal retainer [2] to make it equal around the door.

NOTE: Wrinkles in the blade seal [1] are not permitted.

SUBTASK 52-09-11-700-001

(2) Do this task: Door Seal - Inspection/Check, TASK 52-09-00-700-801.

J. Put the Airplane Back to Its Usual Condition

SUBTASK 52-09-11-410-001

(1) Close these access panels:

Number	Name/Location
112A	Forward Access Door
117A	Electronic Equipment Access Door
821	Forward Cargo Door
822	Aft Cargo Door
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

BLADE AND DIAPHRAGM SEALS - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Blade and diaphragm seals removal

(2) Blade and diaphragm seals installation.

B. Blade and diaphragm seals are installed at the aft entry door and the forward and aft galley service doors. The seals keep fuselage pressurization and prevent water from going into the passenger compartment.

C. The blade part of the seal is installed around the edge of the door. The diaphragm part of the seal is installed in two locations along the gate hinges at the upper and lower gates.

TASK 52-09-12-000-801

2. Blade and Diaphragm Seals Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the blade and diaphragm seals.

B. References

Reference	Title
52-13-31-000-801	Aft Entry Door Lining Removal (P/B 401)
52-41-31-000-801	Galley Service Door Lining Removal (P/B 401)

C. Tools/Equipment

Reference	Description
STD-1160	Stand - Cabin and General Access Stand, Adjustable Height, Max. Height 18 Feet, Platform 5 Feet by 10 Feet

D. Location Zones

Zone	Area
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Access Panels

Number	Name/Location
834	Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

F. Prepare for the Removal

SUBTASK 52-09-12-940-001

(1) Make sure that the adjustable height cabin and general access stand, STD-1160 is installed outboard of the door.

SUBTASK 52-09-12-010-001

(2) Open the applicable access doors to get access to the seal [2]:

Number	Name/Location
834	Aft Entry Door

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
841	Forward Galley Service Door
844	Aft Galley Service Door

SUBTASK 52-09-12-010-002

(3) Remove the door lining and insulation for the applicable door:

(a) Do this task: Aft Entry Door Lining Removal, TASK 52-13-31-000-801.

(b) Do this task: Galley Service Door Lining Removal, TASK 52-41-31-000-801.

G. Blade and Diaphragm Seals Removal

SUBTASK 52-09-12-020-001

(1) Remove the blade [4] from the gate [1]:

(a) Remove the blade [4] from the seal retainer [14].

(b) Remove the blade [4] from the gate [1].

SUBTASK 52-09-12-020-002

(2) Remove the blade [4] from the edge of the door:

(a) Remove the blade [4] from the seal retainer [14].

(b) Remove the blade [4] from the edge of the door.

SUBTASK 52-09-12-020-003

(3) Disconnect the gate control rod [5] from the gate [1]:

(a) Hold the gate control rod [5] and do not let them fall back into the door frame when the bolt [10] is removed.

NOTE: You can turn the door handle to extend or retract the gate control rod [5].

(b) Remove the bolt [10], washer [9], bushing [8], washer [7], and nut [6] that attach the gate control rod [5] to the gate [1].

(c) Safety the end of the gate control rod [5] to the door frame to hold them in position.

SUBTASK 52-09-12-020-004

(4) Remove the diaphragm [3] from the door and the gate [1]:

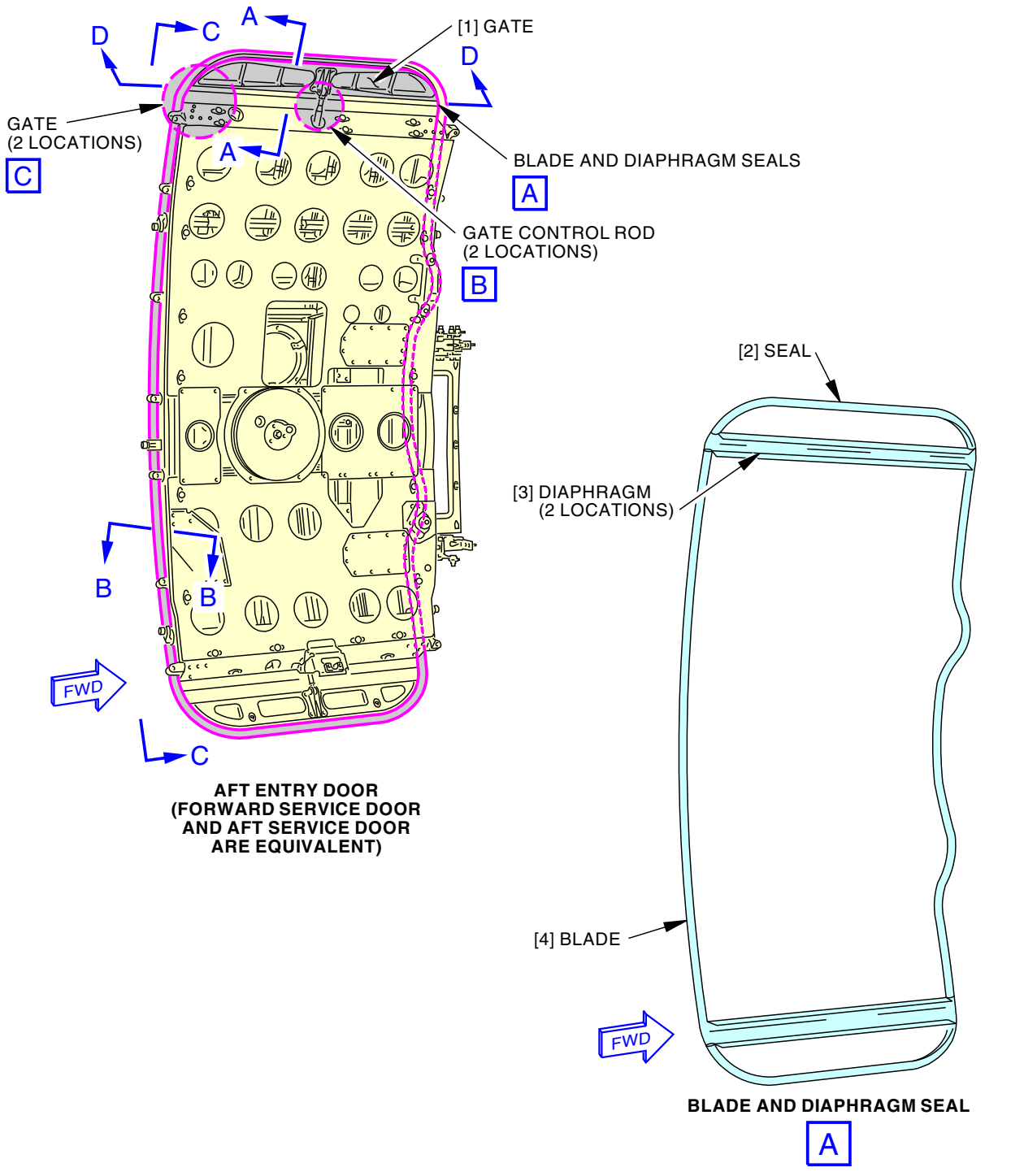
(a) Hold the gate [1] and move it to the vertical position.

(b) Remove the nylon rods [11] from the ends of the seal retainers [12] on the hinge [13] and the seal retainers [12] on the gate [1].

(c) Remove the diaphragm [3] from the door and the gate [1].

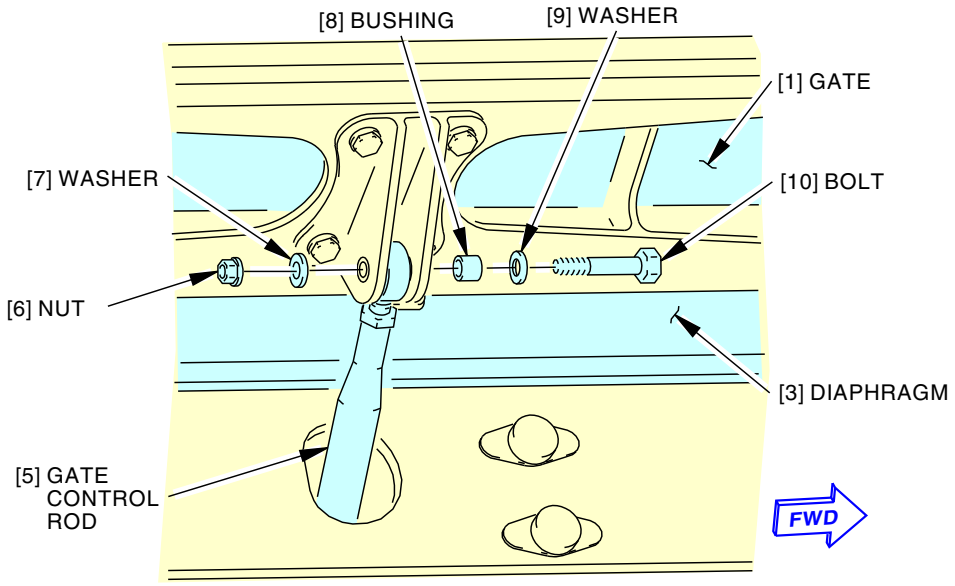
END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



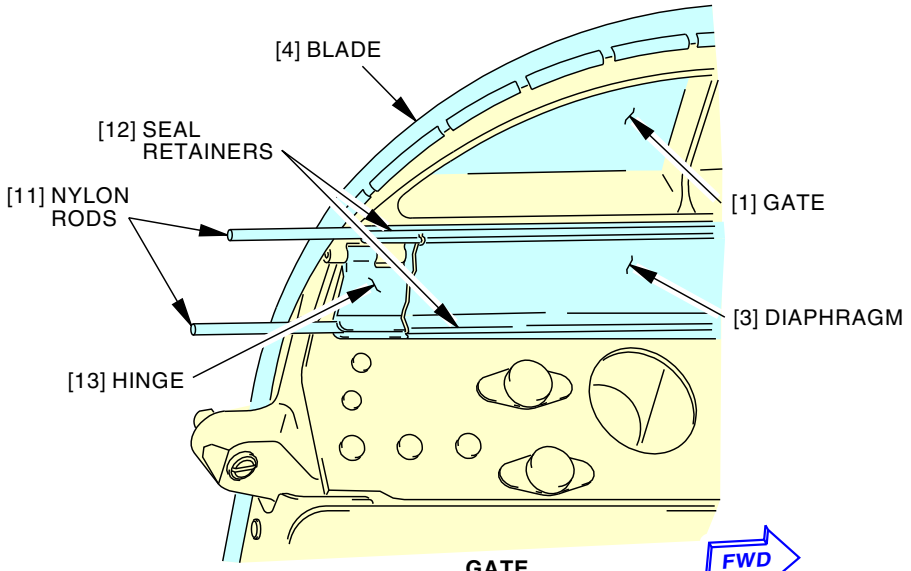
Blade and Diaphragm Seals Installation
Figure 401/52-09-12-990-802 (Sheet 1 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



ROD (EXAMPLE)

B



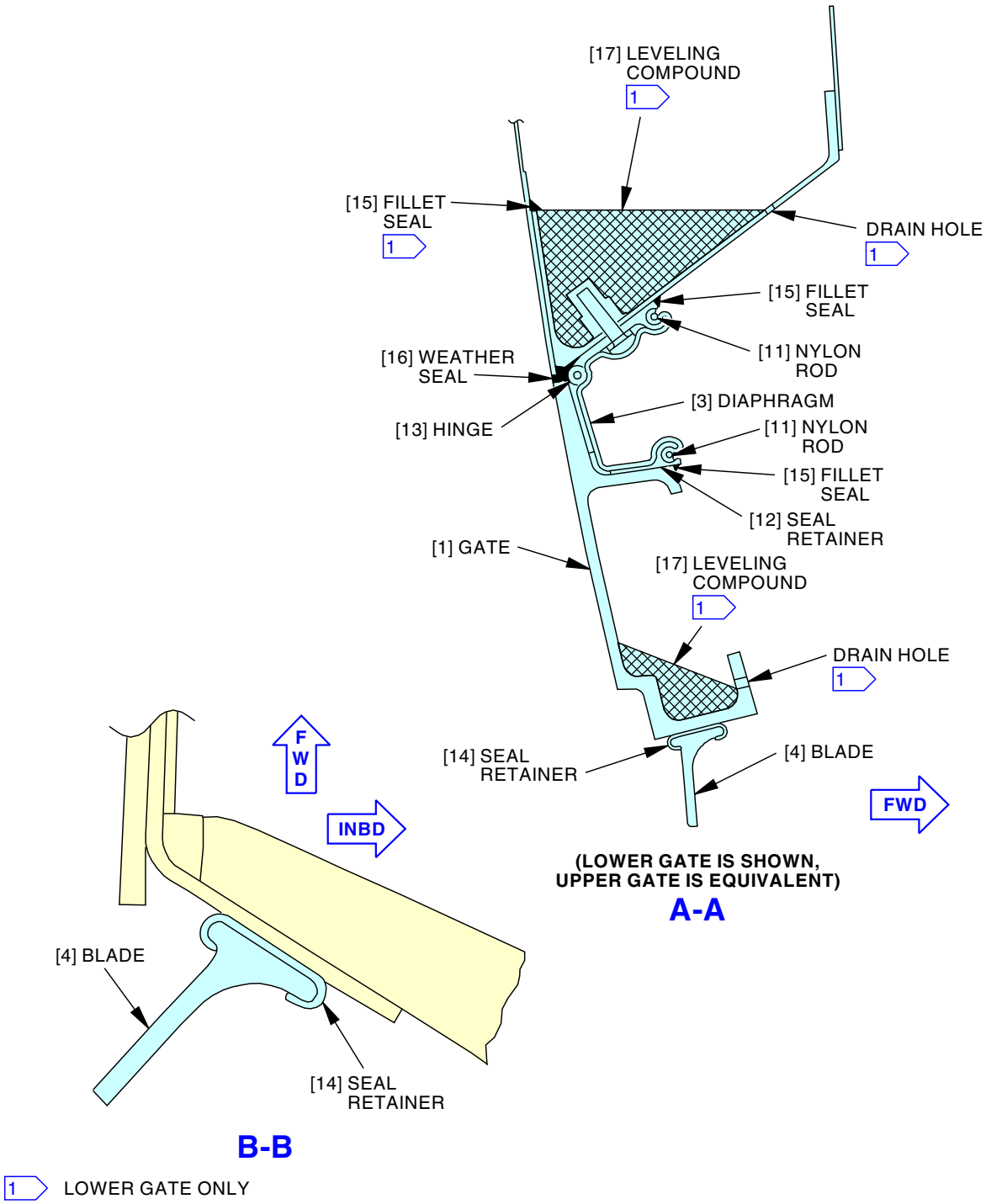
GATE (EXAMPLE) (DIAPHRAGM PARTIALLY REMOVED FOR CLARITY)

C

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Blade and Diaphragm Seals Installation
Figure 401/52-09-12-990-802 (Sheet 2 of 4)

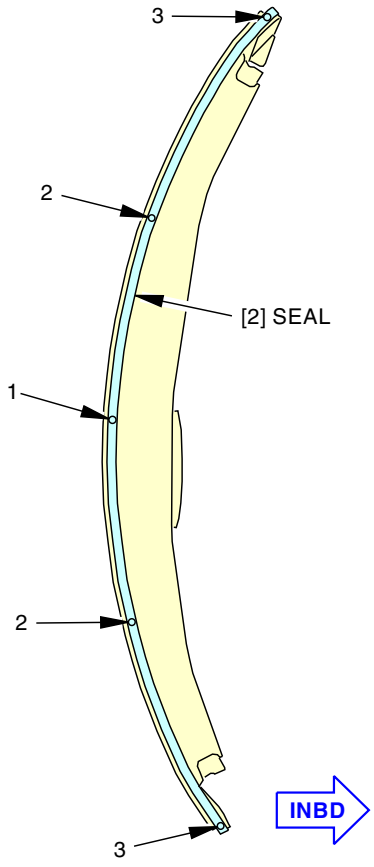
ECCN 9E991 BOEING PROPRIETARY - See title page for details



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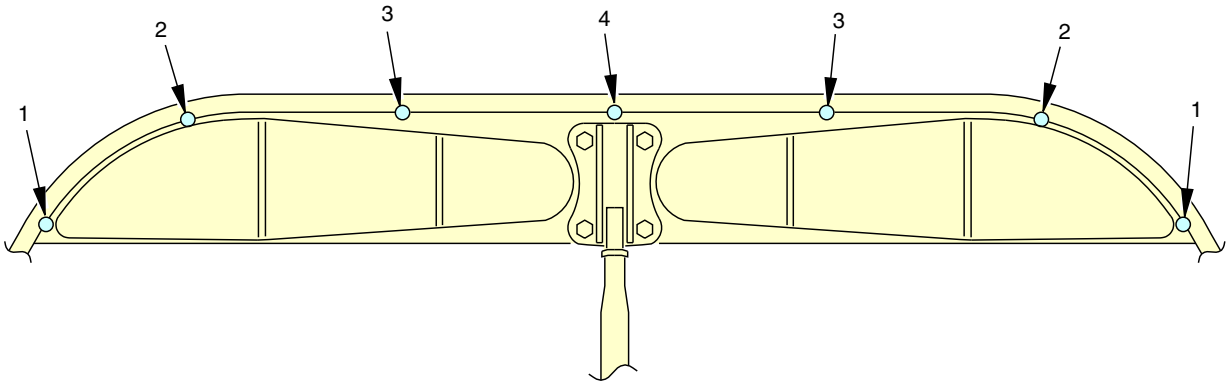
Blade and Diaphragm Seals Installation
Figure 401/52-09-12-990-802 (Sheet 3 of 4)

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(BLADE INSTALLATION SEQUENCE ON DOOR)

C-C



(BLADE INSTALLATION SEQUENCE ON GATE)

D-D

2415702 S00061538721_V1

Blade and Diaphragm Seals Installation
Figure 401/52-09-12-990-802 (Sheet 4 of 4)

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TASK 52-09-12-400-801

3. Blade and Diaphragm Seals Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the blade and diaphragm seals.

B. References

Reference	Title
52-09-00-700-801	Door Seal - Inspection/Check (P/B 201)
52-13-31-400-801	Aft Entry Door Lining Installation (P/B 401)
52-41-31-400-801	Galley Service Door Lining Installation (P/B 401)

C. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A50428	Compound - Self-Leveling, For Fluid Drainage, Flexible, Fire-Retarded	BMS5-125 Type IV
B00052	Soap - Liquid - Turco 1526	BAC5507
D50039	Lubricant - PTFE Release Agent - Miller-Stephenson MS-122RB (use until stock depleted)	
G50636	Lubricant - PTFE Release Agent - Miller-Stephenson MS-122RA (use until stock depleted)	
G51444	Release Agent - Miller-Stephenson MS-122SEL	BMS15-21

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
3	Diaphragm	52-09-10-06-010	SIA ALL
		52-09-10-07-010	SIA ALL
		52-09-10-15-010	SIA ALL
4	Blade	52-09-10-06-010	SIA ALL
		52-09-10-07-010	SIA ALL
		52-09-10-15-010	SIA ALL

E. Location Zones

Zone	Area
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

F. Access Panels

Number	Name/Location
834	Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

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G. Prepare for the Installation

SUBTASK 52-09-12-110-001

(1) Make sure that the surfaces of the blade [4] or diaphragm [3] that will touch the door are clean.

H. Blade and Diaphragm Seals Installation

SUBTASK 52-09-12-020-005

(1) Install the diaphragm [3] on the door and gate [1], View A-A (Figure 401) as follows:

(a) Apply sealant, A00247, as follows:

1) Lift the diaphragm [3].

2) Apply sealant, A00247, to the mating surfaces between the door and the diaphragm [3].

3) Apply sealant, A00247, to the mating surfaces between the gate [1] and the diaphragm [3].

(b) Push the edges of the diaphragm [3] into the seal retainer [12] on the hinge [13] and the seal retainer [12] on the gate [1].

(c) Use liquid Turco 1526 soap, B00052 to help push the nylon rods [11] into the seal retainers [12] on the hinge [13] and the seal retainers [12] on the gate [1].

NOTE: Push the nylon rods [11] into the seal retainer [12] on the hinge [13] from both ends.

(d) Cut the edges of the diaphragm [3] and the ends of the nylon rods [11] if it is necessary.

(e) Apply silicon adhesive, A00027 to the ends of the seal retainers [12], nylon rods [11], and diaphragm [3].

(f) Apply silicon adhesive, A00027 into the bead gap along the whole edge of the diaphragm [3].

(g) Let the adhesive dry before the operation of the door.

SUBTASK 52-09-12-420-001

(2) Connect the gate control rod [5] to the gate [1]:

(a) Fold the gate [1].

(b) Hold the gate control rod [5] to make sure it does not fall back into the door frame when the bolt [10] is installed.

(c) Align the gate control rod [5] with the gate [1].

(d) Install the bolt [10], washer [9], bushing [8], washer [7], and nut [6] to attach the gate control rod [5] to the gate [1].

SUBTASK 52-09-12-420-002

(3) Install the blade [4] around the edge of the door in the sequence shown, View C-C (Figure 401) as follows:

(a) Put the blade [4] around the edge of the door.

NOTE: The flat surface of the blade must point outboard.

(b) Put 1.0 in. (25.4 mm) to 2.0 in. (50.8 mm) of the inboard edge of the blade [4] into the seal retainer [14].

(c) Push the outboard edge of the blade [4] into the seal retainer [14].

(d) Install the remaining part of the blade [4] along the door edge.

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SUBTASK 52-09-12-420-003

(4) Install the blade [4] around the edge of the gate [1] in the sequence shown, View D-D (Figure 401) as follows:

(a) Align the notches in the blade [4] with the opening between the door and the gate [1].

(b) Put 1.0 in. (25.4 mm) to 2.0 in. (50.8 mm) of the inboard edge of the blade [4] into the seal retainer [14].

(c) Push the outboard edge of the blade [4] into the seal retainer [14].

(d) Install the remaining parts of the blade [4] along the edge of the gate [1].

(e) Apply adhesive, A00027 to the retainers and the cuts in the blade [4].

SUBTASK 52-09-12-390-001

(5) Make a weather seal [16] at the exterior of the gate hinge [13], View A-A (Figure 401) as follows:

(a) Make sure that the area is clean and free of debris.

CAUTION

DO NOT FILL THE DRAIN HOLES. DRAIN HOLES THAT ARE BLOCKED COULD CAUSE DAMAGE TO THE EQUIPMENT.

(b) If necessary put leveling compound, A50428 into the lower door area above the hinge [13] and the lower gate [1]

(c) Apply MS-122RA release agent, G50636, MS-122RB lubricant, D50039 or MS-122SEL release agent, G51444 to the exposed end of the gate hinge [13] and the edge of the gate for the entire width of door.

(d) Close and lock the door.

(e) Put sealant, A00247, into the space for the full width of the door.

1) Smooth the sealant, A00247 flush with the doors surface to 0.0000 ±0.0300 in. (0.0000 ±0.7620 mm)

(f) Allow sealant to dry before operating door.

SUBTASK 52-09-12-790-001

(6) Do this task: Door Seal - Inspection/Check, TASK 52-09-00-700-801.

I. Put the Airplane Back to Its Usual Condition

SUBTASK 52-09-12-840-001

(1) Install the door lining and insulation for the applicable door:

(a) Do this task: Aft Entry Door Lining Installation, TASK 52-13-31-400-801.

(b) Do this task: Galley Service Door Lining Installation, TASK 52-41-31-400-801.

SUBTASK 52-09-12-410-001

(2) Close the applicable access doors:

Number	Name/Location
834	Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

BULB AND DIAPHRAGM SEAL - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Bulb and diaphragm seal removal

(2) Bulb and diaphragm seal installation.

B. The bulb and diaphragm seal is installed at the forward entry door to maintain fuselage pressurization and prevent the entry of water into the passenger compartment.

C. The bulb part of the seal is installed around the edge of the door. The diaphragm part of the seal is installed in two locations along the hinges at the upper and lower gates.

D. In this procedure, the bulb seal will be referred to as the bulb.

E. In this procedure, the diaphragm seal will be referred to as the diaphragm.

TASK 52-09-14-000-801

2. Bulb and Diaphragm Seal Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the bulb and diaphragm seal.

B. References

Reference	Title
52-11-31-000-801	Forward Entry Door Lining Removal (P/B 401)

C. Tools/Equipment

Reference	Description
STD-1160	Stand - Cabin and General Access Stand, Adjustable Height, Max. Height 18 Feet, Platform 5 Feet by 10 Feet

D. Location Zones

Zone	Area
831	Forward Entry Door

E. Access Panels

Number	Name/Location
831	Forward Entry Door

F. Bulb and Diaphragm Seal Removal

SUBTASK 52-09-14-480-001

(1) Install the adjustable height cabin and general access stand, STD-1160 outboard of the forward entry door.

SUBTASK 52-09-14-010-001

(2) To get access to the bulb [1] and diaphragm [2],

Open this access panel:

Number	Name/Location
831	Forward Entry Door

SUBTASK 52-09-14-010-002

(3) Do this task: Forward Entry Door Lining Removal, TASK 52-11-31-000-801.

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G. Bulb and Diaphragm Seal Removal

SUBTASK 52-09-14-020-001

(1) Remove the upper or lower gates [4] from the door:

(a) Hold the rods [11] and do not let them fall back into the door frame when the bolts [9] are removed.

NOTE: You can turn the door handle to extend or retract the rods [11].

(b) Remove the cotter pins [6], bolts [9], washers [8], bushings [7], washers [12], and nuts [5] that attach the rods [11] to the gate [4].

(c) Safety the ends of the rods [11] to the door frame to hold them in position.

(d) Remove the screws [13] from the end of the hinges [10].

(e) Remove the hinge pins [14] from the hinges [10].

(f) Fold the gate [4] in the outboard direction.

(g) Remove the bolts [16] and washers [17] that attach the seal retainers [19] and diaphragm [2] to the door.

(h) Remove the seal retainers [19] from the diaphragm [2].

(i) Remove the diaphragm [2] from the door.

(j) Cut the bulb [1] to remove the gate [4] from the door.

(k) Remove the gate [4] from the door.

SUBTASK 52-09-14-020-002

(2) To remove the bulb [1], insert [24], and diaphragm [2] from the upper or lower gates [4], do these steps:

NOTE: It is permissible to remove only the bulb and insert or only the diaphragm.

NOTE: The insert is inside the bulb.

(a) Lift the bulb [1] to get access to the screws [21].

(b) Remove the screws [21] and washers [22] that attach the seal retainers [20] and the bulb [1] to the gate [4].

(c) Remove the seal retainers [20] from the bulb [1].

(d) Remove the bolts [16], washers [17], clamps [18], springs [15], seal retainers [19], and diaphragm [2] from the gate [4].

(e) Remove the seal retainers [19] from the diaphragm [2].

(f) Remove the bulb [1], insert [24], and diaphragm [2] from the gate [4].

SUBTASK 52-09-14-020-003

(3) Remove the bulb [1] and insert [24] from the edge of the door:

NOTE: The insert is inside the bulb.

(a) Lift the bulb [1] to get access to the screws [21].

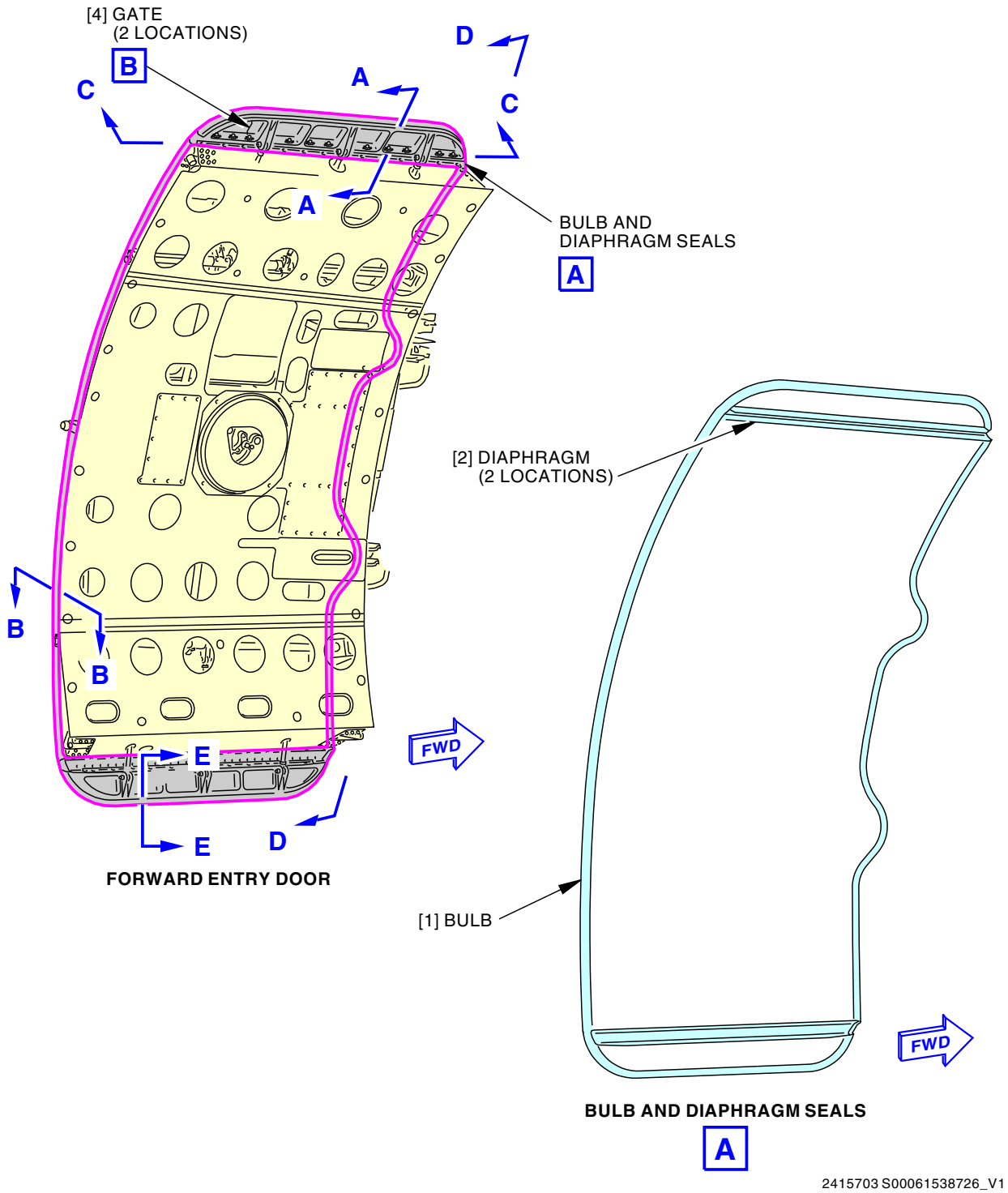
(b) Remove the screws [21] and washers [22] that attach the seal retainers [20] and bulb [1] to the door.

(c) Remove the seal retainers [20] from the bulb [1].

(d) Remove the bulb [1] and insert [24] from the edge of the door.

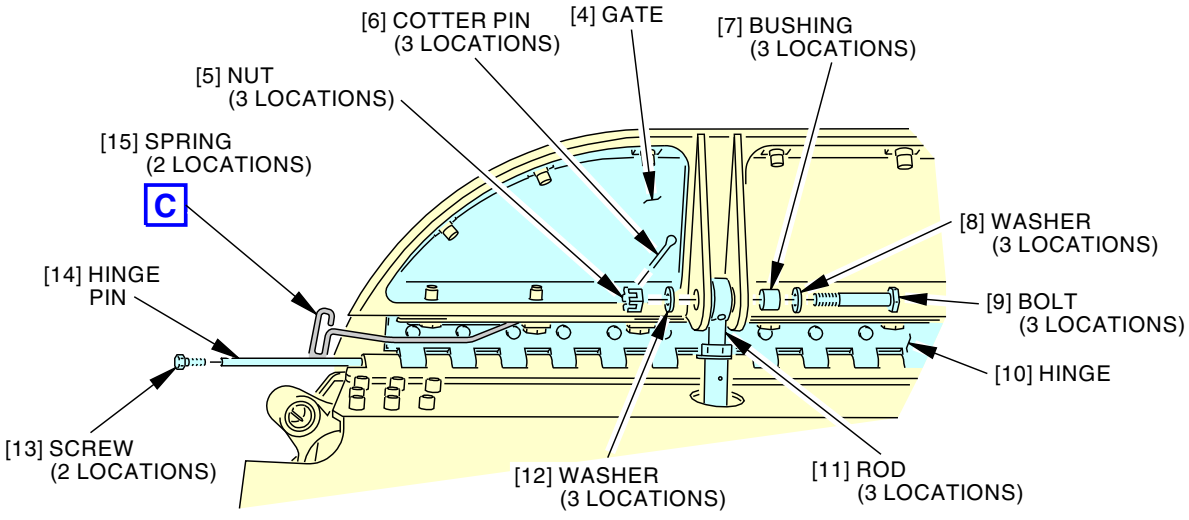
——— END OF TASK ———

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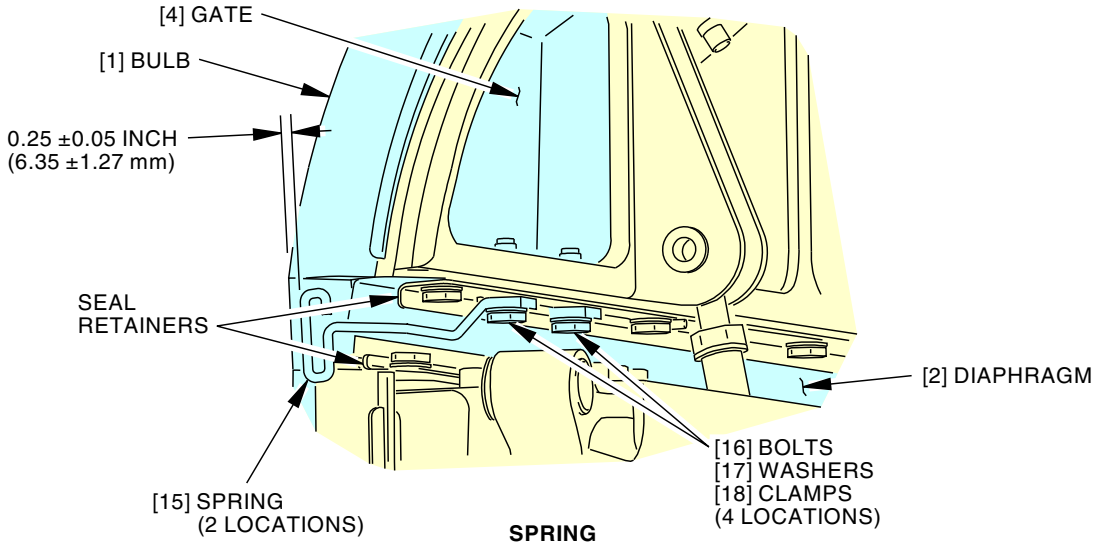
Bulb and Diaphragm Seals Installation
Figure 401/52-09-14-990-802 (Sheet 1 of 4)

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GATE
(UPPER GATE IS SHOWN,
LOWER GATE IS EQUIVALENT)
(SEAL REMOVED FOR CLARITY)

B



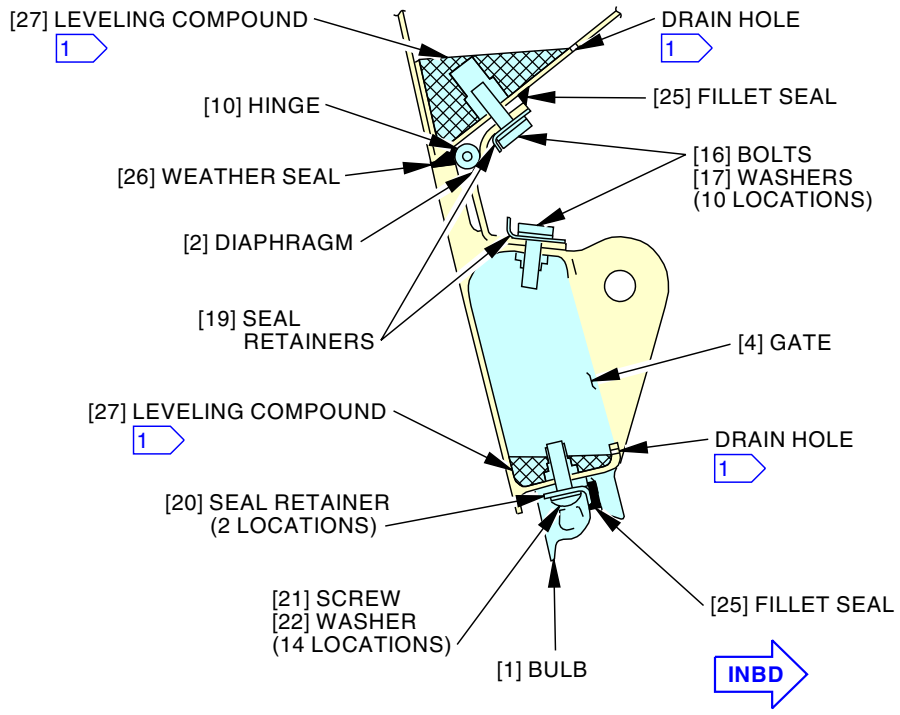
SPRING
(EXAMPLE)

C

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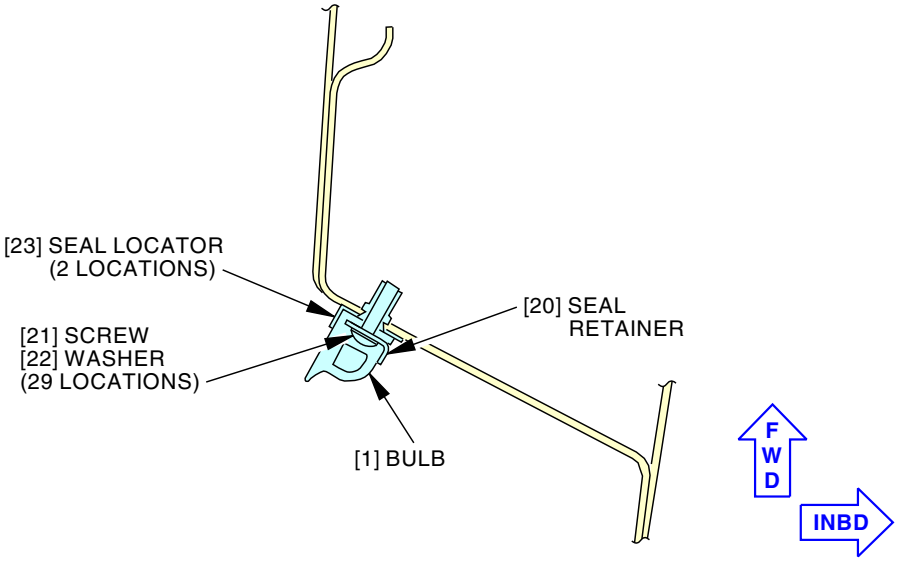
Bulb and Diaphragm Seals Installation
Figure 401/52-09-14-990-802 (Sheet 2 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



(LOWER GATE IS SHOWN, UPPER GATE IS EQUIVALENT)

A-A



(AFT EDGE OF DOOR)

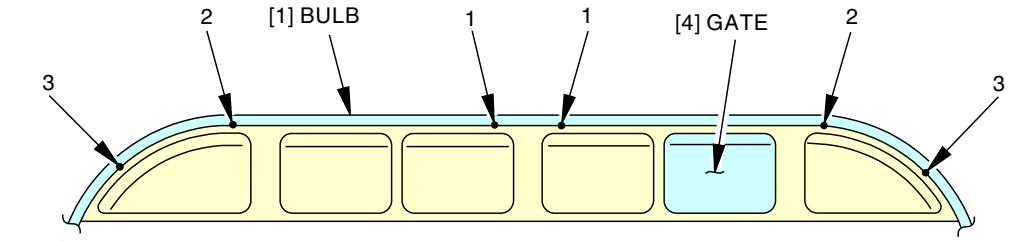
B-B

1 LOWER GATE ONLY

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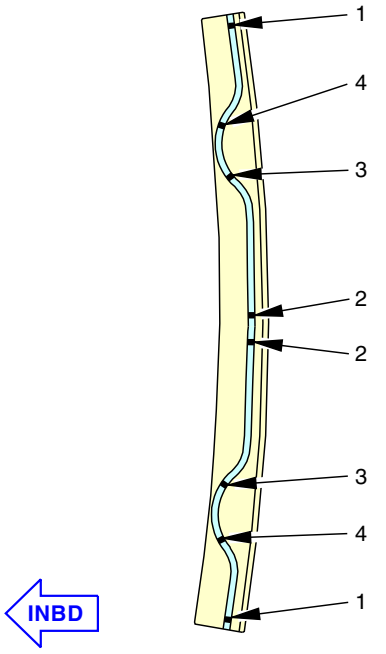
Bulb and Diaphragm Seals Installation
Figure 401/52-09-14-990-802 (Sheet 3 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



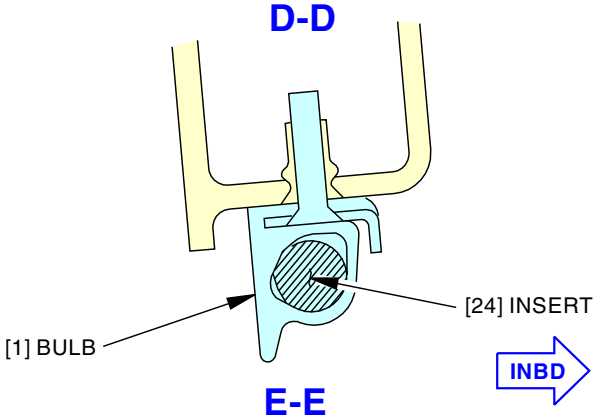
(BULB INSTALLATION SEQUENCE ON GATE)

C-C



(BULB INSTALLATION SEQUENCE ON DOOR FORWARD EDGE)

D-D



E-E

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Bulb and Diaphragm Seals Installation
Figure 401/52-09-14-990-802 (Sheet 4 of 4)

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TASK 52-09-14-400-801

3. Bulb and Diaphragm Seal Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the bulb and diaphragm seal.

B. References

Reference	Title
52-09-00-700-801	Door Seal - Inspection/Check (P/B 201)
52-11-31-400-801	Forward Entry Door Lining Installation (P/B 401)

C. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A50428	Compound - Self-Leveling, For Fluid Drainage, Flexible, Fire-Retarded	BMS5-125 Type IV
D50039	Lubricant - PTFE Release Agent - Miller-Stephenson MS-122RB (use until stock depleted)	
G50063	Lubricant - PTFE Release Agent - Miller-Stephenson MS-122XD (Replaces MS-122DF)	
G50636	Lubricant - PTFE Release Agent - Miller-Stephenson MS-122RA (use until stock depleted)	
G51444	Release Agent - Miller-Stephenson MS-122SEL	BMS15-21

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Bulb	52-09-13-01B-170	SIA ALL
2	Diaphragm	52-09-13-01B-170	SIA ALL

E. Location Zones

Zone	Area
831	Forward Entry Door

F. Access Panels

Number	Name/Location
831	Forward Entry Door

G. Prepare for the Installation

SUBTASK 52-09-14-110-001

(1) Make sure that the surfaces of the bulb [1] that touch the door are clean.

H. Bulb and Diaphragm Seal Installation

SUBTASK 52-09-14-860-001

(1) The bulb and diaphragm seal must be installed as one piece.

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SUBTASK 52-09-14-820-001

(2) Put the bulb [1] in its correct position on the applicable gate [4]:

NOTE: Make sure that the long part of the bulb [1] between the upper and lower gates [4] is forward.

(a) Put the bulb [1] around the edge of the gates [4].

NOTE: The flat surface of the bulb [1] must point outboard.

(b) Align the notches in the bulb [1] with the hinges [10].

(c) Put the diaphragm [2] along the hinges [10].

SUBTASK 52-09-14-420-001

(3) Install the bulb [1] on the gates [4]:

(a) Push the seal retainers [20] between the bulb [1] and flange.

NOTE: Make sure that the holes in the seal retainers [20] align with the holes in the gates [4].

(b) Attach the bulb [1] to the gates [4] in the sequence shown, (Figure 401), as follows:

1) lift the bulb [1] and make holes in the flange that align with the holes in the seal retainers [20].

2) Install the screws [21] and washers [22] that attach the seal retainers [20] and bulb [1] to the gates [4].

(c) Install the remaining screws [21] and washers [22] that attach the seal retainers [20] and bulb [1] to the gates [4].

(d) Lift the diaphragm [2] and apply the sealant, A00247 on the mating surfaces between the diaphragm [2] and gates [4].

(e) Put the seal retainers [19] over the diaphragm [2].

(f) Make sure that the holes in the seal retainers [19] align with the holes on the gates [4].

(g) Start at the ends of the gates [4] and work toward the center, attach the diaphragm [2] to the gates [4]:

1) Make holes in the diaphragm [2] that align with the holes in the seal retainers [19].

2) Install the bolts [16] and washers [17] that attach the clamps [18], springs [15], seal retainers [19], and diaphragm [2] to the gates [4].

3) Make sure that the distance between the edges of the springs [15] and bulb [1] is as shown.

CAUTION

MAKE SURE THAT THE SEALANT DOES NOT GO INTO THE DRAIN HOLES. DAMAGE TO EQUIPMENT CAN OCCUR.

4) Apply silicon adhesive, A00027 to the ends of the seal retainer [19] and the diaphragm [2].

a) Make sure that the adhesive overlaps the ends of the seal retainer [19] 0.25 in. (6.35 mm) min.

b) Smooth the adhesive out equally over the ends of the seal retainer [19] and diaphragm [2].

5) Apply the silicon adhesive, A00027 into a bead gap along the edge of the diaphragm [2].

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6) Make sure that the adhesive is dry before you operate the door.

SUBTASK 52-09-14-420-002

(4) Connect the upper or lower gates [4] to the door:

(a) Connect the diaphragm [2] to the door:

1) Hold the gates [4] in position along the top and bottom of the door.

2) Apply the sealant, A00247 on the mating surfaces between the diaphragm [2] and the door.

3) Put the seal retainers [19] over the diaphragm [2].

4) Make sure that the holes in the seal retainers [19] align with the holes on the door.

5) Start at the ends of the hinges [10] on the door and work toward the center, attach the diaphragm [2] to the doors:

a) Make holes in the diaphragm [2] that align with the holes in the seal retainers [19].

b) Install the bolts [16] and washers [17] that attach the seal retainers [19] and diaphragm [2] to the door.

(b) Connect the hinges [10] on the gates [4] to the hinges [10] on the door:

1) Align the hinges [10] on the gates [4] with the hinges [10] on the door.

2) Push the hinge pin [14] into the hinges [10].

3) Install the screws [13] in the ends of the hinges [10].

(c) Connect the rods [11] to the gates [4]:

1) Fold the gates [4].

2) Put the rods [11] in their correct position on the gates [4] and hold.

NOTE: Do not let the rods [11] fall back into the door frame when the bolts [9] are installed.

NOTE: You can turn the door handle to extend or retract the rods [11].

3) Install the bolts [9], washers [8], bushings [7], washers [12], nuts [5], and cotter pins [6] that attach the rods [11] to the gates [4].

SUBTASK 52-09-14-420-003

(5) Install the bulb [1] around the edge of the door:

(a) Put the flange of the bulb [1] in position along the seal locators [23].

(b) Attach the bulb [1] to the forward edge of the door in the sequence shown:

1) Push the seal retainers [20] between the bulb [1] and flange.

NOTE: Make sure that the holes in the seal retainers [20] align with the holes in the seal locators [23].

2) Make holes in the flange of the bulb [1] that align with the holes in the seal retainers [20].

3) Install the screws [21] and washers [22] that attach the seal retainers [20] and bulb [1] to the door.

4) Make sure that there is tension on the bulb [1] between points 3 and 4.

5) Make sure that the bulb [1] is compressed between points 1 and 4.

6) Make sure that the bulb [1] is compressed between points 2 and 3.

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7) Install the remaining screws [21] and washers [22] that attach the seal retainers [20] and bulb [1] to the door.

(c) Attach the bulb [1] along the aft edge of the door as follows:

NOTE: Attach the bulb [1] first in the middle of the door, then at the top and bottom corners of the door, then along the remaining part of the door edge.

1) Push the seal retainers [20] between the bulb [1] and flange.

NOTE: Make sure that the holes in the seal retainers [20] align with the holes in the seal locators [23].

2) Make holes in the flange of the bulb [1] that align with the holes in the seal retainers [20].

3) Install the screws [21] and washers [22] that attach the bulb [1] to the door.

SUBTASK 52-09-14-420-004

(6) Install the insert [24] in the bulb [1] on the lower gate [4]:

(a) Use the liquid soap to lubricate the inner surface of the open end of the bulb [1] at the lower gate [4].

(b) Twist the end of the insert [24] and put it in the open end of the bulb [1] at the lower gate [4].

(c) Blow compressed air into the open end of the bulb [1] adjacent to the insert [24]to inflate the bulb [1].

(d) Push the full length of the insert [24] into the bulb [1].

(e) Use compressed air to push the insert [24] into the straight section of the bulb [1].

(f) Make sure that you can see the insert [24] through the three vent holes in the straight section of the bulb [1].

SUBTASK 52-09-14-390-001

(7) Make a weather seal [26] at the interior of the gate hinge [10].

(a) Make sure that the area is clean and free of debris.

CAUTION

MAKE SURE THAT THE SEALANT DOES NOT GO INTO THE DRAIN HOLES. DAMAGE TO EQUIPMENT CAN OCCUR.

(b) If required pour leveling compound, A50428 [27] into lower door area above hinge [10] and lower gate [4].

(c) Apply parting MS-122RA release agent, G50636, MS-122RB lubricant, D50039, MS-122SEL release agent, G51444 or MS-122XD release agent, G50063 to the exposed end of gate hinge [10] and edge of gate for the entire width of door.

(d) Close and lock the door.

(e) Inject the cavity with sealant, A00247 and smooth flush with door surface.

(f) Allow sealant to cure before operating door.

SUBTASK 52-09-14-700-001

(8) Do this task: Door Seal - Inspection/Check, TASK 52-09-00-700-801.

I. Put the Airplane Back to Its Usual Condition

SUBTASK 52-09-14-840-001

(1) Do this task: Forward Entry Door Lining Installation, TASK 52-11-31-400-801.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-09-14-010-003

(2) Close this access panel:

Number	Name/Location
831	Forward Entry Door

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AERODYNAMIC SEALS - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Aerodynamic seals removal

(2) Aerodynamic seals installation.

B. Aerodynamic seals are installed around access panels to decrease aerodynamic drag.

C. There are two methods of attaching aerodynamic seals:

(1) The flange of the seal is held in a seal retainer.

(2) The seal is mechanically attached to the structure.

TASK 52-09-15-000-801

2. Aerodynamic Seals Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove aerodynamic seals.

B. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box

C. Access Panels

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door
192DR	ECS High Pressure Access Door

D. Prepare for the Removal

SUBTASK 52-09-15-010-001

(1) Open this access panel:

Number	Name/Location
192DR	ECS High Pressure Access Door

SUBTASK 52-09-15-010-002

CAUTION

DO NOT OPEN THE ECS ACCESS DOOR, 192CR UNTIL YOU OPEN THE ECS HIGH PRESSURE ACCESS DOOR, 192DR. DAMAGE TO THE ECS HIGH PRESSURE ACCESS DOOR, 192DR WILL OCCUR.

(2) Open this access panel:

Number	Name/Location
192CR	ECS Access Door

SUBTASK 52-09-15-010-003

(3) To get access to the aerodynamic seal [1] and aerodynamic seal [2],

Open the applicable access panels:

Number	Name/Location
192CL	ECS Access Door

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
192CR	ECS Access Door

E. Aerodynamic Seals Removal

SUBTASK 52-09-15-020-001

(1) Remove an aerodynamic seal [1] installed in a seal retainer [3] as follows:

(a) Remove the lockwire [4] that attaches the aerodynamic seal [1] to the seal retainer [3].

(b) Pull the aerodynamic seal [1] out of the seal retainer [3].

SUBTASK 52-09-15-020-002

(2) Remove an aerodynamic seal [2] that is mechanically attached to the structure as follows:

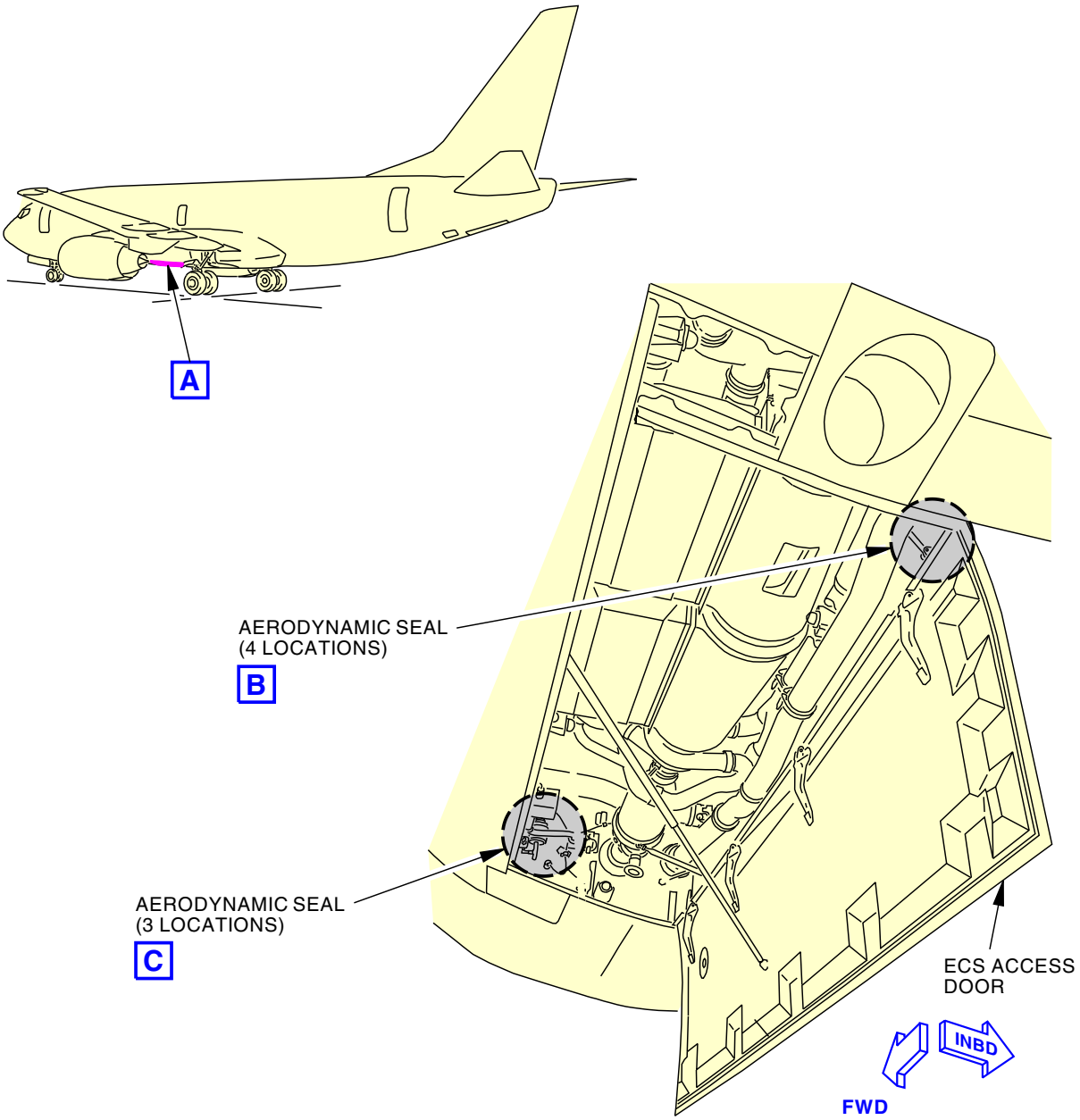
(a) Remove the bolts [7] that attach the seal retainer [6], aerodynamic seal [2], and deflector [5] to the structure.

(b) Remove the seal retainer [6] from the aerodynamic seal [2].

(c) Remove the aerodynamic seal [2] from the deflector [5].

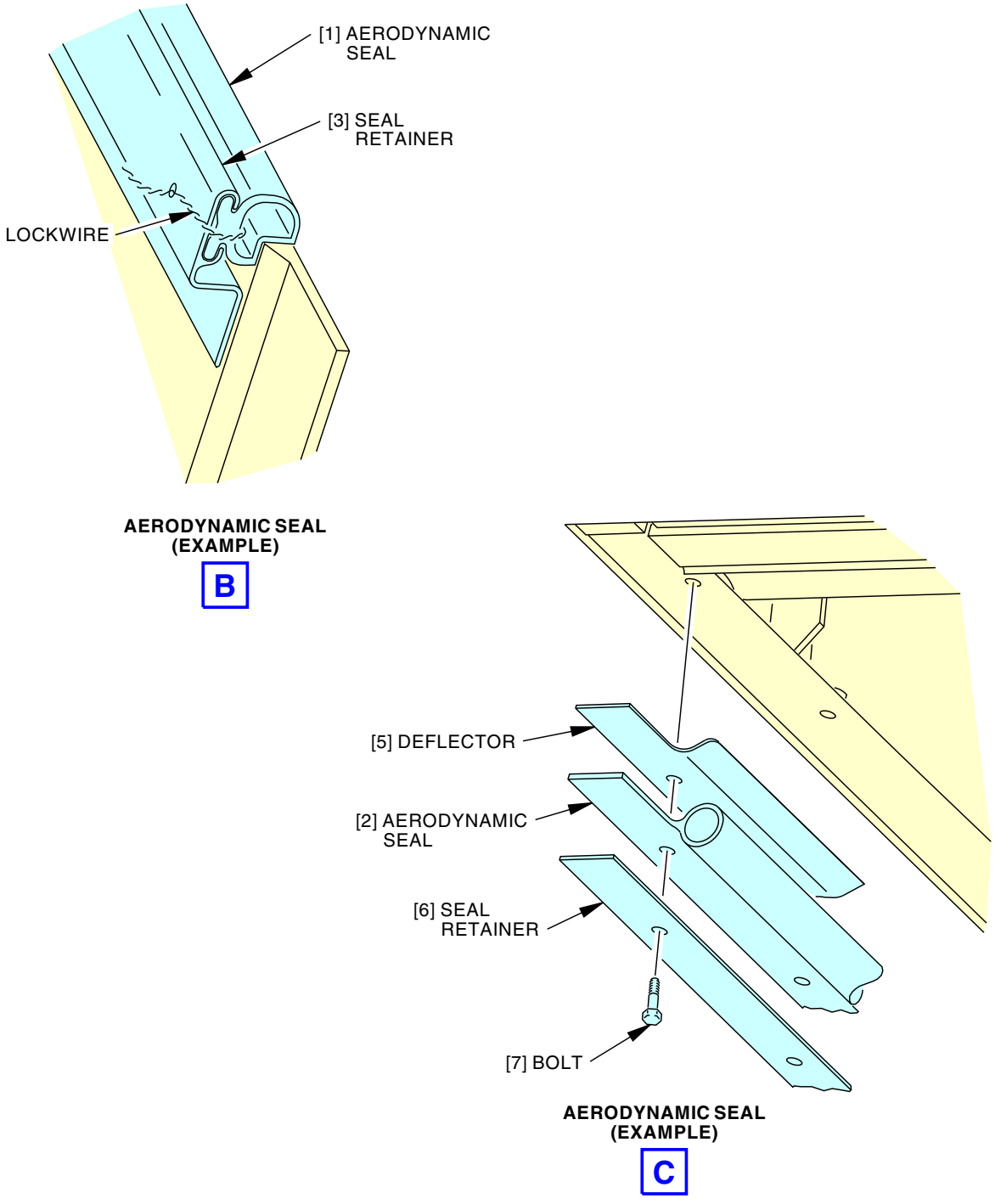
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aerodynamic Seal Installation
Figure 401/52-09-15-990-802 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aerodynamic Seal Installation
Figure 401/52-09-15-990-802 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-09-15-400-801

3. Aerodynamic Seals Installation

(Figure 401)

A. General

(1) This task gives the instructions to install aerodynamic seals.

B. Consumable Materials

Reference	Description	Specification
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
G01048	Lockwire - MS20995C32, Corrosion Resistant Steel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Aerodynamic seal	52-09-10-01-065	SIA ALL
		52-09-10-01-070	SIA ALL
		52-09-10-01-075	SIA ALL
		52-09-10-01-080	SIA ALL
		52-09-10-01-085	SIA ALL
		52-09-10-02-065	SIA ALL
		52-09-10-02-070	SIA ALL
		52-09-10-02-075	SIA ALL
		52-09-10-02-080	SIA ALL
		52-09-10-02-085	SIA ALL
2	Aerodynamic seal	52-09-15-03-015	SIA ALL
		52-09-15-03-020	SIA ALL

D. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box

E. Access Panels

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door
192DR	ECS High Pressure Access Door

F. Prepare for the Installation

SUBTASK 52-09-15-100-001

(1) Make sure that the aerodynamic seal [1] and aerodynamic seal [2] and the surfaces they will touch are clean.

G. Aerodynamic Seals Installation

SUBTASK 52-09-15-420-001

(1) Install an aerodynamic seal [1] in a seal retainer [3] as follows:

(a) Put one edge of the flange of the aerodynamic seal [1] in the seal retainer [3].

(b) Push the other edge of the flange of the aerodynamic seal [1] into the seal retainer [3].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(c) Install the MS20995C32 lockwire, G01048 to attach the aerodynamic seal [1] to the seal retainer [3].

SUBTASK 52-09-15-420-002

(2) Install an aerodynamic seal [2] that is mechanically attached to the structure as follows:

(a) Apply corrosion preventive compound, C00528 in the holes in the structure for the bolts [7].

NOTE: You must install the bolts [7] while the corrosion preventive compound, C00528 is wet.

(b) Put the deflector [5]in position along the structure.

(c) Put the aerodynamic seal [2] in position along the deflector [5].

(d) Put the seal retainer [6] over the aerodynamic seal [2].

(e) Align the holes in the aerodynamic seal [2] with the seal retainer [6], deflector [5], and the structure.

(f) Install the bolts [7] that attach the seal retainer [6], aerodynamic seal [2], and deflector [5] to the structure.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 52-09-15-840-001

(1) Close the applicable access panels:

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door

SUBTASK 52-09-15-840-002

(2) If you opened it, close this access panel:

Number	Name/Location
192DR	ECS High Pressure Access Door

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

ACOUSTIC AND THERMO SEALS - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Acoustic seals removal

(2) Acoustic seals installation

(3) Thermo bulb seals removal

(4) Thermo bulb seals installation.

B. Acoustic and thermo seals are installed at the interface of passenger compartment doorways and interior panels to decrease cabin noise and prevent heat loss from the passenger compartment.

TASK 52-09-16-000-801

2. Acoustic Seal Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove acoustic seal.

B. References

Reference	Title
25-66-01-000-801	Escape Slide Pack and Cover 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

D. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Prepare for the Removal

SUBTASK 52-09-16-860-001

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(c) Install the work platform, COM-1523 outboard of the door.

SUBTASK 52-09-16-010-001

(2) Get access to the door as follows:

(a) Make sure that the door is closed and latched.

(b) Do this task: Escape Slide Pack and Cover Removal, TASK 25-66-01-000-801.

(c) Fully open the door.

F. Acoustic Seal Removal

SUBTASK 52-09-16-020-001

(1) Remove the bulb seal [2] from the passenger compartment door liner:

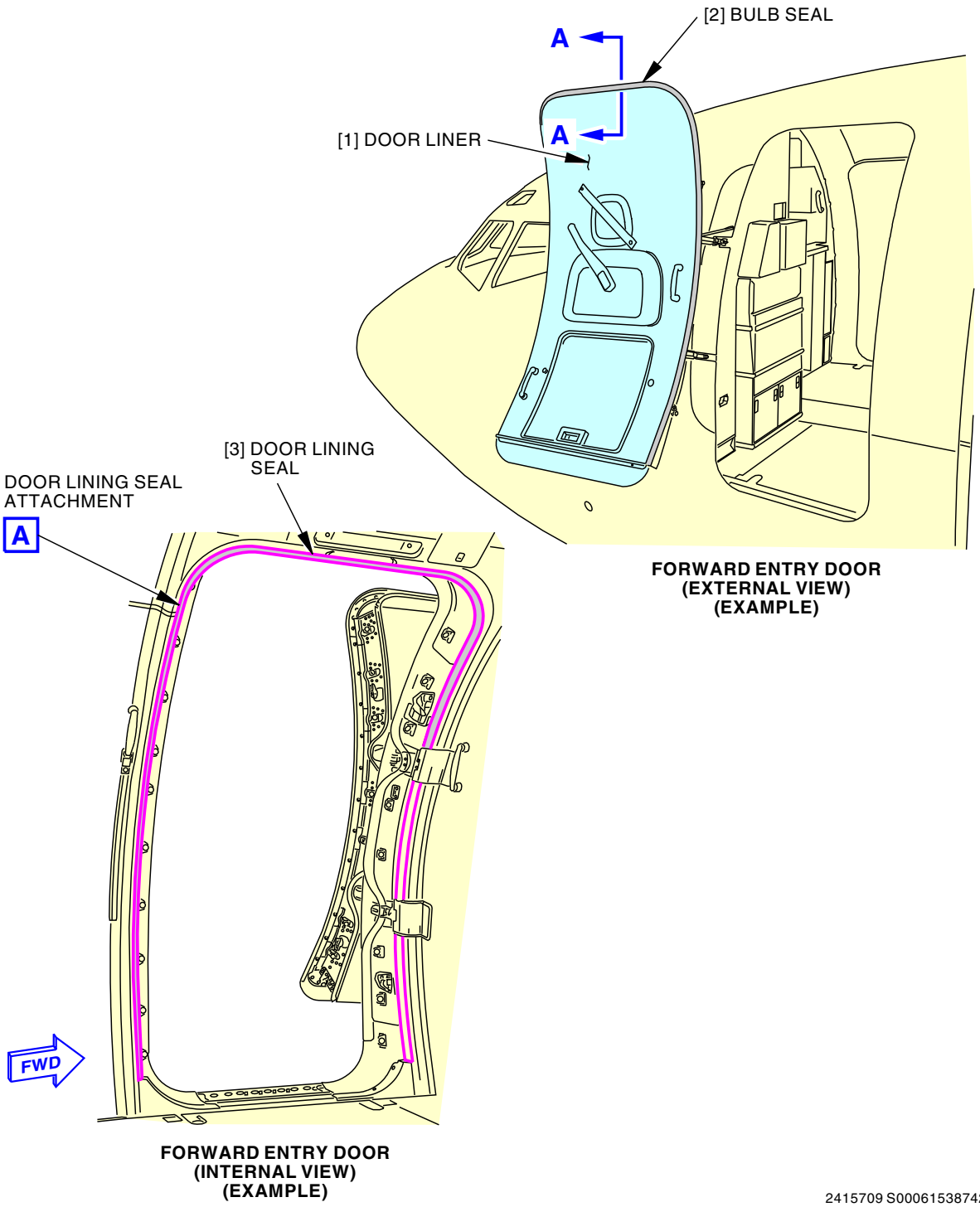
(a) Remove the nuts [6] that hold the seal retainers [5] onto the door liner [1].

(b) Remove the seal retainer [5].

(c) Remove the bulb seal [2].

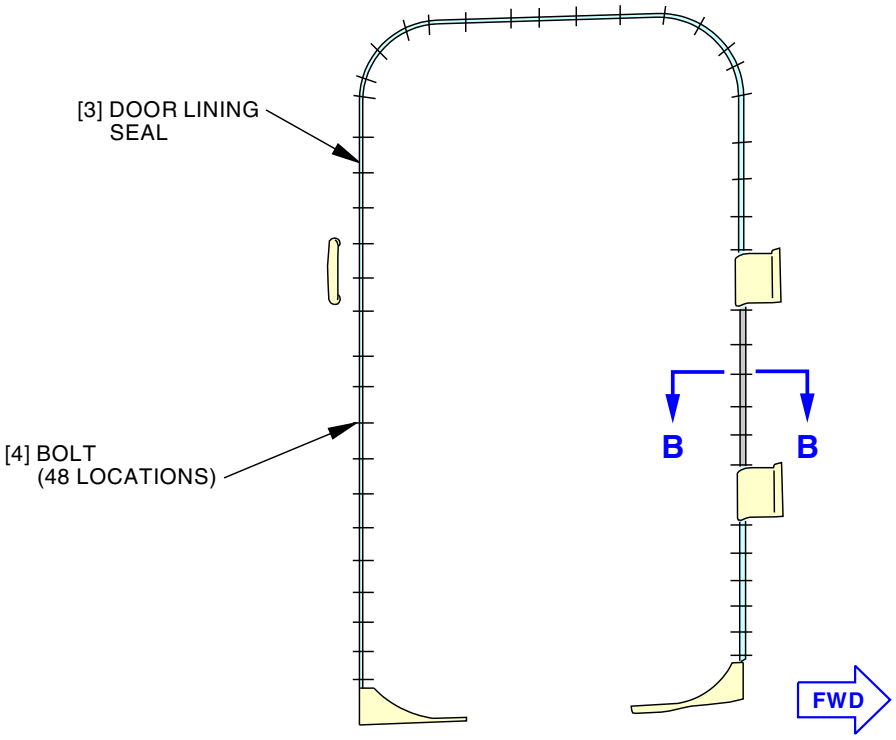
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



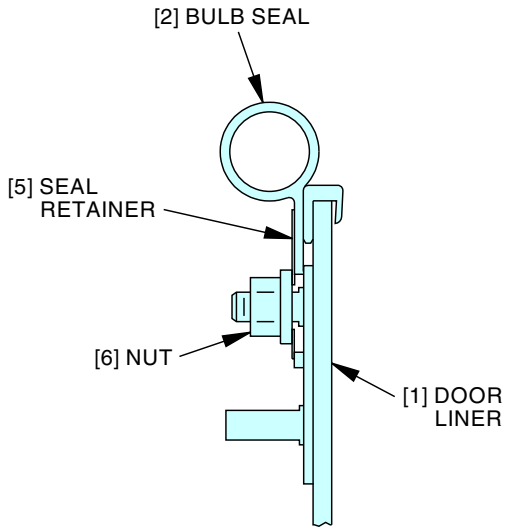
Acoustic and Thermo Seals Installation
Figure 401/52-09-16-990-802 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

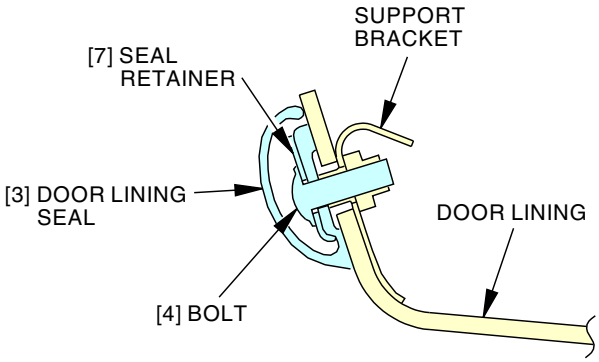


DOOR LINING SEAL ATTACHMENT (EXAMPLE)

A



A-A



(EXAMPLE)

B-B

2415710 S00061538743_V1

Acoustic and Thermo Seals Installation
Figure 401/52-09-16-990-802 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-09-16-400-801

3. Acoustic Seal Installation

(Figure 401)

A. General

(1) This task gives the instructions to install acoustic seal.

B. References

Reference	Title
25-66-01-400-801	Escape Slide Pack and Cover 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
2	Bulb seal	52-11-31-04-480	SIA ALL

E. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

F. Acoustic Seal Installation

SUBTASK 52-09-16-420-001

(1) Install the bulb seal [2] on the passenger compartment door liner:

(a) Install the bulb seal [2].

(b) Install the seal retainers [5].

(c) Install the nuts [6] that hold the seal retainers [5] onto the door liner [1].

G. Put the Airplane Back to Its Usual Condition

SUBTASK 52-09-16-080-001

(1) Remove the work platform, COM-1523 from outboard of the door.

SUBTASK 52-09-16-840-001

(2) Close and latch the door.

SUBTASK 52-09-16-420-002

(3) Do this task: Escape Slide Pack and Cover Installation, TASK 25-66-01-400-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-09-16-000-802

4. Thermo Bulb Seal Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove thermo bulb seal.

B. References

Reference	Title
25-66-01-000-801	Escape Slide Pack and Cover 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

D. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Prepare for the Removal

SUBTASK 52-09-16-860-002

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Install the work platform, COM-1523 outboard of the door.

SUBTASK 52-09-16-010-002

(2) Get access to the door as follows:

(a) Make sure that the door is closed and latched.

(b) Do this task: Escape Slide Pack and Cover Removal, TASK 25-66-01-000-801.

(c) Fully open the door.

F. Thermo Bulb Seal Removal

SUBTASK 52-09-16-020-002

(1) Remove the door lining seal [3] around the passenger compartment doorway:

(a) Remove the bolt [4] that hold the seal retainers [7] onto the lining of the doorway.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) Remove the seal retainers [7].

(c) Remove the door lining seal [3].

——— END OF TASK ———

TASK 52-09-16-400-802

5. Thermo Bulb Seal Installation

(Figure 401)

A. General

(1) This task gives the instructions to remove thermo bulb seal.

B. References

Reference	Title
25-66-01-400-801	Escape Slide Pack and Cover 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

D. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Thermo Bulb Seal Installation

SUBTASK 52-09-16-420-003

(1) Install the door lining seal [3] around the passenger compartment doorway:

(a) Install the door lining seal [3].

(b) Install the seal retainers [7].

(c) Install the bolt [4] that hold the seal retainers [7] onto the lining of the doorway

F. Put the Airplane Back to Its Usual Condition

SUBTASK 52-09-16-080-002

(1) Remove the work platform, COM-1523 from outboard of the door.

SUBTASK 52-09-16-840-002

(2) Close and latch the door.

SUBTASK 52-09-16-410-001

(3) Do this task: Escape Slide Pack and Cover Installation, TASK 25-66-01-400-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LIGHT SEALS - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Light seals removal

(2) Light seals installation.

B. Light seals are installed around the crew door to keep light out of the flight compartment. There are three light seals around the crew door:

(1) A door seal that is attached to the top of the crew door by a backing plate.

(2) A hinge seal that is bonded to the crew door hinge.

(3) A door post seal that is bonded to the crew door post.

TASK 52-09-17-000-801

2. Light Seals Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the light seals.

(2) Use this procedure to remove the light seals from around the crew door. If you want to remove only one seal, do the steps to remove that seal only.

B. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right
220	Subzone - Passenger Compartment - Body Station 259.50 to 360.00
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

C. Prepare for the Removal

SUBTASK 52-09-17-010-001

(1) Open the crew door [1] to get access to the door seal [2], hinge seal [3], and door post seal [5].

D. Light Seals Removal

SUBTASK 52-09-17-020-001

(1) Remove the door seal [2] that is attached to the top of the crew door [1]:

(a) Remove the screws [7] that hold the backing plate [8] to the crew door [1].

(b) Remove the backing plate [8] and door seal [2].

(c) Pull the door seal [2] away from the backing plate [8].

NOTE: The adhesive bond will break when you pull the door seal [2].

SUBTASK 52-09-17-020-002

(2) Remove the hinge seal [3] that is bonded to the crew door hinge [11]:

(a) Remove the screws [6] that attach the hinge [11] to the wall.

(b) Remove the crew door [1] from the wall.

(c) Remove the screws [4] that attach the hinge [11] to the crew door [1].

(d) Remove the hinge [11] from the crew door [1].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(e) Pull the hinge seal [3] away from the hinge [11].

NOTE: The adhesive bond will break when you pull the hinge seal [3].

SUBTASK 52-09-17-020-003

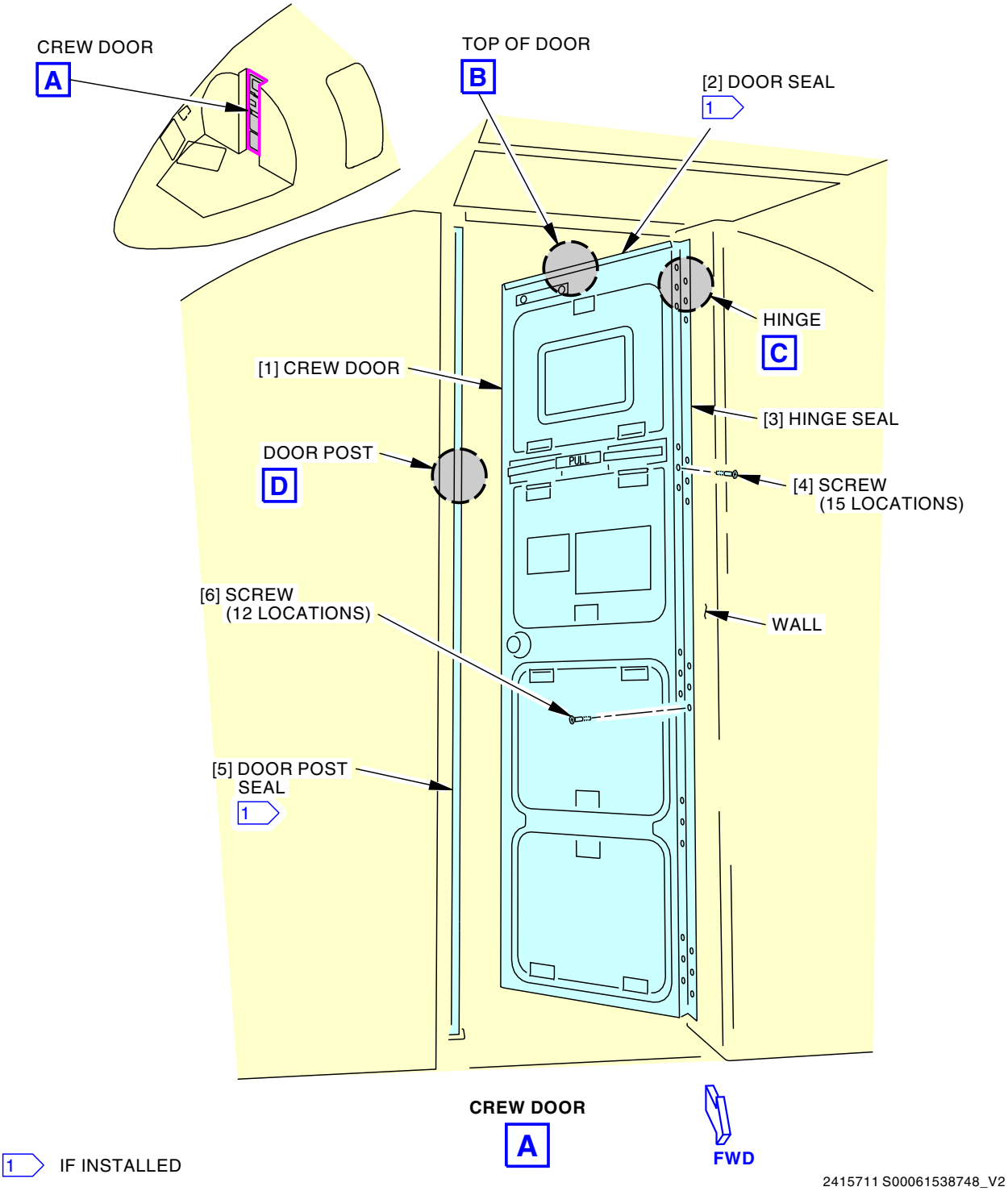
(3) Remove the door post seal [5] that is bonded to the trim angle [9] on the door post [10]:

(a) Pull the door post seal [5] away from the trim angle [9].

NOTE: The adhesive bond will break when you pull the door post seal [5].

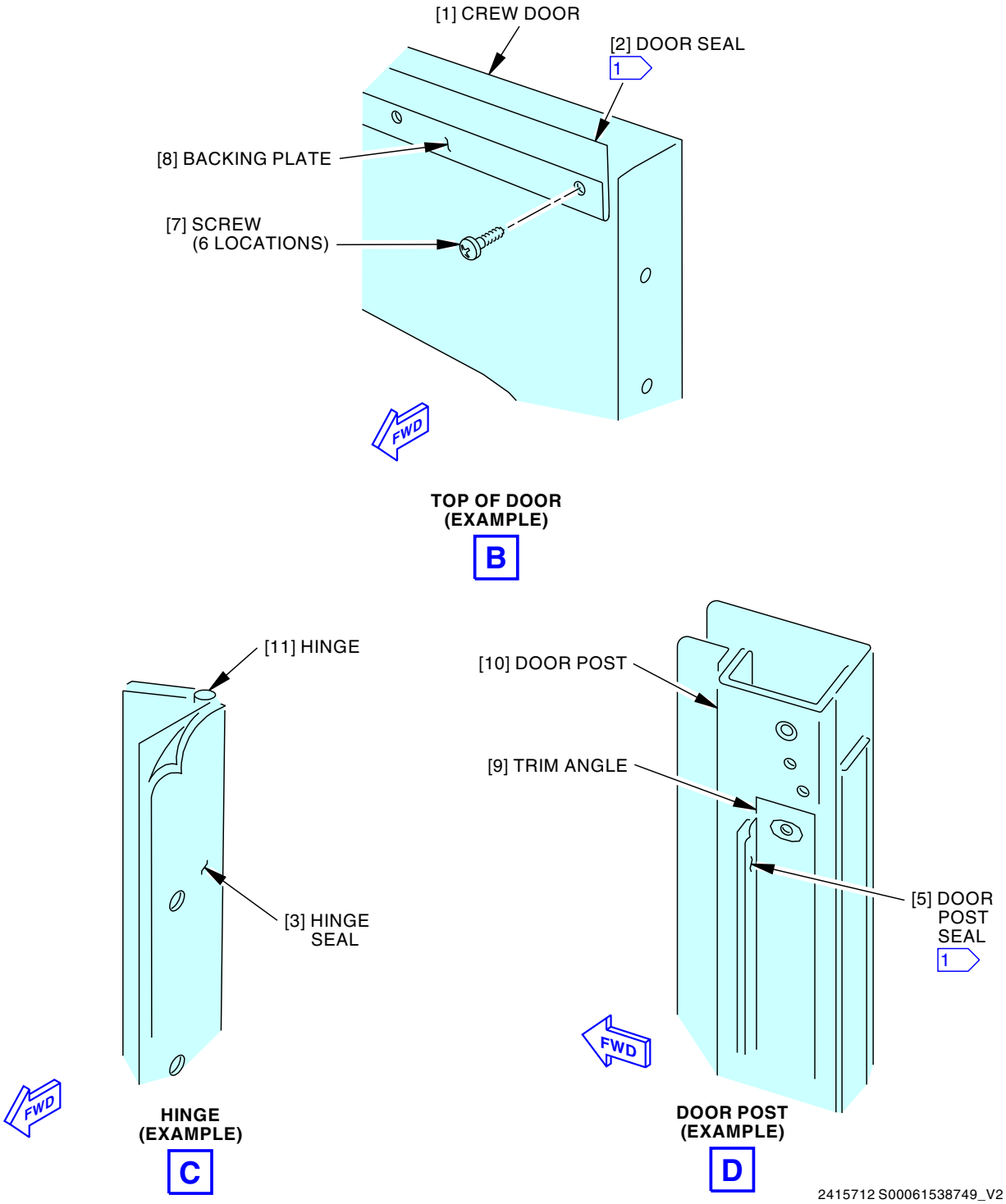
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Light Seals Installation
Figure 401/52-09-17-990-802 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Light Seals Installation
Figure 401/52-09-17-990-802 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-09-17-400-801

3. Light Seals Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the light seals.

(2) Use this procedure to install the light seals around the crew door. If you want to install only one seal, do the steps to install that seal only.

B. Consumable Materials

Reference	Description	Specification
A00153	Adhesive - Low Odor, Synthetic Rubber Cement	BMS5-30
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
2	Door seal	52-51-01-01-020	SIA ALL
3	Hinge seal	52-51-01-01-020	SIA ALL
5	Door post seal	52-51-01-02-020	SIA 001-005
		52-51-01-02-250	SIA 006-999

D. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right
220	Subzone - Passenger Compartment - Body Station 259.50 to 360.00
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

E. Light Seals Installation

SUBTASK 52-09-17-420-001

(1) Install the door seal [2] attached to the top of the crew door [1]:

(a) Clean the surface of the backing plate [8] with a clean cotton wiper, G00034 that is moist with solvent, B00083.

(b) Bond the door seal [2] to the backing plate [8] with adhesive, A00153.

(c) Hold the backing plate [8] against the forward side of the top of the crew door [1].

(d) Install the screws [7] that hold the backing plate [8] to the crew door [1].

SUBTASK 52-09-17-420-002

(2) Install the hinge seal [3] bonded to the crew door hinge [11]:

(a) Clean the surface of the hinge [11] with a clean cotton wiper, G00034 that is moist with solvent, B00083.

(b) Put the hinge [11] in the closed position.

(c) Bond the hinge seal [3] tightly around the hinge [11] with adhesive, A00153.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(d) Make holes in the hinge seal [3] that align with the holes in the hinge [11].

(e) Hold the hinge [11] against the edge of the crew door [1].

(f) Install the screws [4] that attach the hinge [11] to the crew door [1].

(g) Hold the crew door [1] against the wall.

(h) Install the screws [6] that attach the crew door [1] to the wall.

SUBTASK 52-09-17-420-003

(3) Install the door post seal [5] bonded to the trim angle [9] on the door post [10]:

(a) Clean the surface of the trim angle [9] with a clean cotton wiper, G00034 that is moist with solvent, B00083.

(b) Install the door post seal [5] on the trim angle [9].

NOTE: The seal has a layer of pressure-sensitive adhesive.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FORWARD ENTRY DOOR - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks:

(1) Open the forward entry door with the exterior handle

(2) Close the forward entry door with the exterior handle

(3) Open the forward entry door with the interior handle

(4) Close the forward entry door with the interior handle

(5) Open the Forward Entry Door from the Airstair with the Exterior Handle

(6) Close the Forward Entry Door from the Airstair with the Exterior Handle

(7) Forward Entry Door Corrosion Prevention.

TASK 52-11-00-860-801

2. Open the Door with the Exterior Handle

(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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

B. Location Zones

Zone	Area
831	Forward Entry Door

C. Procedure

SUBTASK 52-11-00-860-001

CAUTION DO NOT OPERATE THE DOOR IN STABLE WINDS OF MORE THAN 40 KNOTS. DO NOT LET THE DOOR STAY OPEN IN WIND GUSTS THAT ARE MORE THAN 65 KNOTS. STRONG WINDS CAN CAUSE DAMAGE TO THE STRUCTURE OF THE AIRPLANE.

(1) Put the work platform, COM-1523 in front of the door.

SUBTASK 52-11-00-860-002

(2) Make sure the door is safe as follows:

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WARNING MAKE SURE THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

(a) Make sure the girt bar is not engaged in the floor-mounted escape slide brackets.

SUBTASK 52-11-00-860-003

WARNING BE CAREFUL WHEN YOU OPERATE THE DOOR FROM A MAINTENANCE STAND. IT IS NOT EASY TO OPERATE THE DOOR FROM THE SMALL PLATFORM AREA AND DURING BAD WEATHER CONDITIONS. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

(3) Pull the exterior handle outboard from the recess in the door to engage the door drive mechanism.

SUBTASK 52-11-00-860-004

(4) Turn the exterior handle 180 degrees clockwise to unlatch the door.

NOTE: When you turn the handle 180 degrees clockwise, the latch rollers disengage with the latch fittings.

NOTE: The initial movement of the door is inward.

SUBTASK 52-11-00-860-005

(5) Return the exterior handle into the recess of the door.

SUBTASK 52-11-00-860-006

WARNING MAKE SURE THAT THE LATCH MECHANISM ENGAGES. IF THE DOOR IS NOT FULLY OPEN, THE DOOR CAN CLOSE SUDDENLY, AND QUICKLY. INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT CAN OCCUR.

(6) Use the door assist handle to pull the door outboard and forward until the door hold open lock in the upper hinge engages and the door is held in the fully open position.

NOTE: The door will be parallel to the fuselage when fully open.

SUBTASK 52-11-00-860-007

(7) Put the personnel barrier, SPL-2005 across the door opening.

END OF TASK

TASK 52-11-00-860-802

3. Close the Door with the Exterior Handle

(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.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Reference	Description
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

B. Location Zones

Zone	Area
831	Forward Entry Door

C. Procedure

SUBTASK 52-11-00-860-008

CAUTION DO NOT OPERATE THE DOOR IN STABLE WINDS OF MORE THAN 40 KNOTS. DO NOT LET THE DOOR STAY OPEN IN WIND GUSTS THAT ARE MORE THAN 65 KNOTS. STRONG WINDS CAN CAUSE DAMAGE TO THE STRUCTURE OF THE AIRPLANE.

(1) Make sure the work platform, COM-1523 is installed in front of the door.

SUBTASK 52-11-00-860-009

(2) Remove the personnel barrier, SPL-2005 from across the door opening if it is installed.

SUBTASK 52-11-00-860-010

WARNING BE CAREFUL WHEN YOU OPERATE THE DOOR FROM A MAINTENANCE STAND. IT IS NOT EASY TO OPERATE THE DOOR FROM THE SMALL PLATFORM AREA AND DURING BAD WEATHER CONDITIONS. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

(3) Release the door hold open lock from the locked position by using either the "Up to release" lever on the body torque tube, or the "Down to release" button on the guide arm.

SUBTASK 52-11-00-860-011

(4) Use the assist handle to swing the door into the door opening.

SUBTASK 52-11-00-860-012

(5) Pull the exterior handle outward to clear the handle recess.

SUBTASK 52-11-00-860-013

(6) Turn the exterior handle 180 degrees counterclockwise to close the door.

NOTE: When you turn the handle 180 degrees counterclockwise, the latch rollers engage with the latch fittings.

SUBTASK 52-11-00-860-014

(7) Release the exterior handle into the recess in the door.

(a) Manually put the exterior handle in the fully stowed position into its recess in the door.

SUBTASK 52-11-00-080-001

(8) Remove the stand, work platform, COM-1523 from the door.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-11-00-860-803

4. Open the Door with the Interior Handle

(Figure 202)

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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

B. Location Zones

Zone	Area
831	Forward Entry Door

C. Procedure

SUBTASK 52-11-00-860-015

CAUTION

DO NOT OPERATE THE DOOR IN STABLE WINDS OF MORE THAN 40 KNOTS. DO NOT LET THE DOOR STAY OPEN IN WIND GUSTS THAT ARE MORE THAN 65 KNOTS. STRONG WINDS CAN CAUSE DAMAGE TO THE STRUCTURE OF THE AIRPLANE.

(1) Put the work platform, COM-1523 in front of the door.

SUBTASK 52-11-00-860-016

(2) Make sure the door is safe as follows:

WARNING

MAKE SURE THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

(a) Make sure the girt bar is not engaged in the floor-mounted escape slide brackets.

SUBTASK 52-11-00-860-017

WARNING

BE CAREFUL WHEN YOU OPERATE THE DOOR FROM A MAINTENANCE STAND. IT IS NOT EASY TO OPERATE THE DOOR FROM THE SMALL PLATFORM AREA AND DURING BAD WEATHER CONDITIONS. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

(3) Turn the interior handle counterclockwise 180 degrees to unlatch the door.

NOTE: When you turn the handle 180 degrees in the open direction, the latch rollers disengage from the latch fittings and the initial movement of the door is inward.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-11-00-860-018

WARNING MAKE SURE THAT THE LATCH MECHANISM ENGAGES. IF THE DOOR IS NOT FULLY OPEN, THE DOOR CAN CLOSE SUDDENLY, AND QUICKLY. INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT CAN OCCUR.

(4) Use the door assist handle to push the door outboard and forward until the door hold open lock in the upper hinge engages and the door is held in the fully open position.

NOTE: The door will be parallel to the fuselage when fully open.

SUBTASK 52-11-00-860-019

(5) As required, put the personnel barrier, SPL-2005 across the door opening.

END OF TASK

TASK 52-11-00-860-804

5. Close the Door with the Interior Handle

(Figure 202)

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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

B. Location Zones

Zone	Area
831	Forward Entry Door

C. Procedure

SUBTASK 52-11-00-860-020

CAUTION DO NOT OPERATE THE DOOR IN STABLE WINDS OF MORE THAN 40 KNOTS. DO NOT LET THE DOOR STAY OPEN IN WIND GUSTS THAT ARE MORE THAN 65 KNOTS. STRONG WINDS CAN CAUSE DAMAGE TO THE STRUCTURE OF THE AIRPLANE.

(1) Make sure the work platform, COM-1523 is installed in front of the door.

SUBTASK 52-11-00-020-001

(2) Remove the personnel barrier, SPL-2005 from across the door opening if it is installed.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-11-00-860-021

WARNING BE CAREFUL WHEN YOU OPERATE THE DOOR FROM A MAINTENANCE STAND. IT IS NOT EASY TO OPERATE THE DOOR FROM THE SMALL PLATFORM AREA AND DURING BAD WEATHER CONDITIONS. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

(3) Release the door hold open lock from the locked position by using either the "Up to release" lever on the body torque tube, or the "Down to release" button on the guide arm.

NOTE: A light push at the door interior handle location towards the opening direction is allowed to release the hold open lever.

SUBTASK 52-11-00-860-022

(4) Use the assist handle to swing the door into the door opening.

SUBTASK 52-11-00-860-023

(5) Turn the interior handle 180 degrees clockwise to fully close the door.

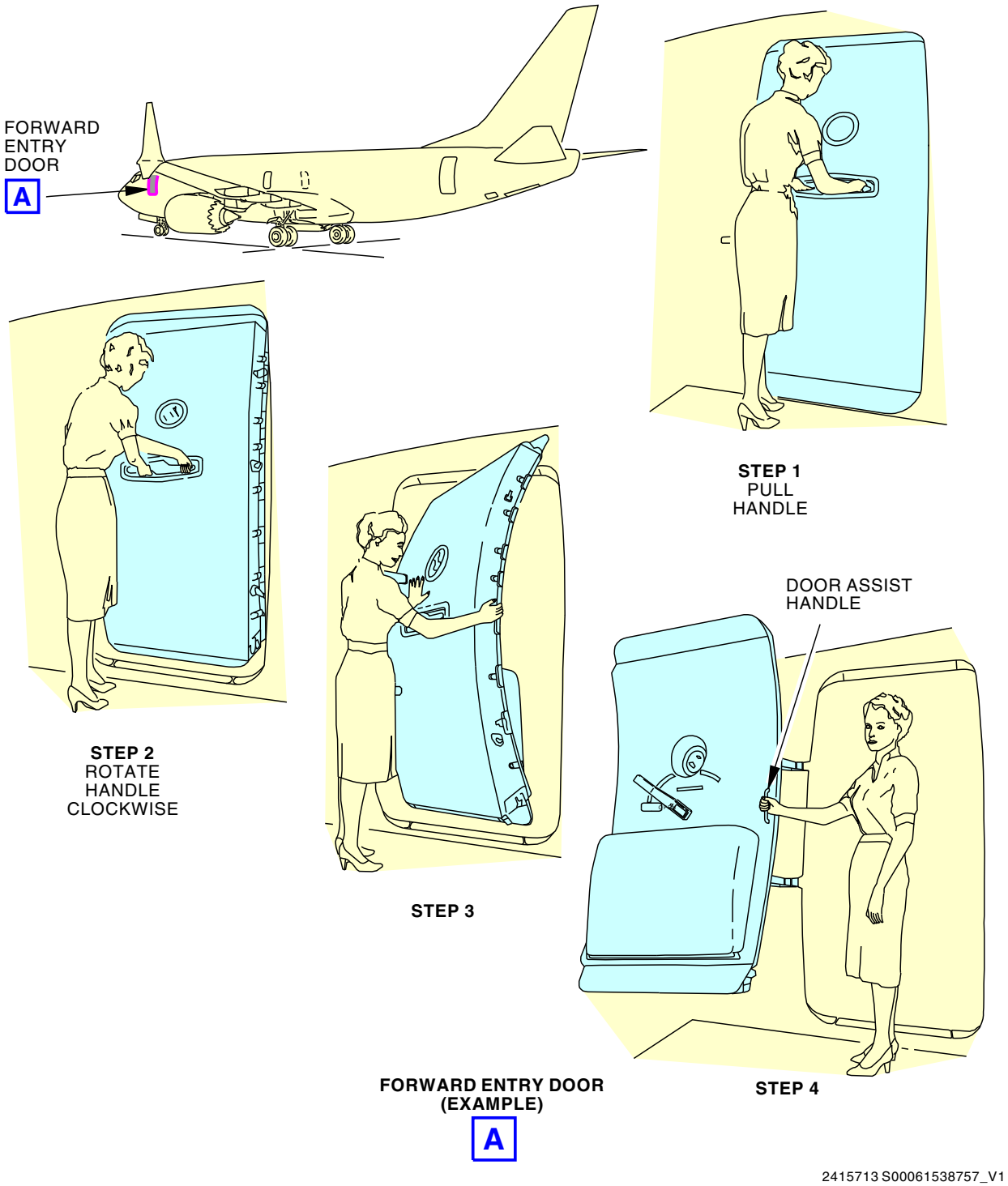
NOTE: When you turn the handle 180 degrees clockwise, the latch rollers engage with the latch fittings.

SUBTASK 52-11-00-080-002

(6) As required, remove the work platform, COM-1523 from the door.

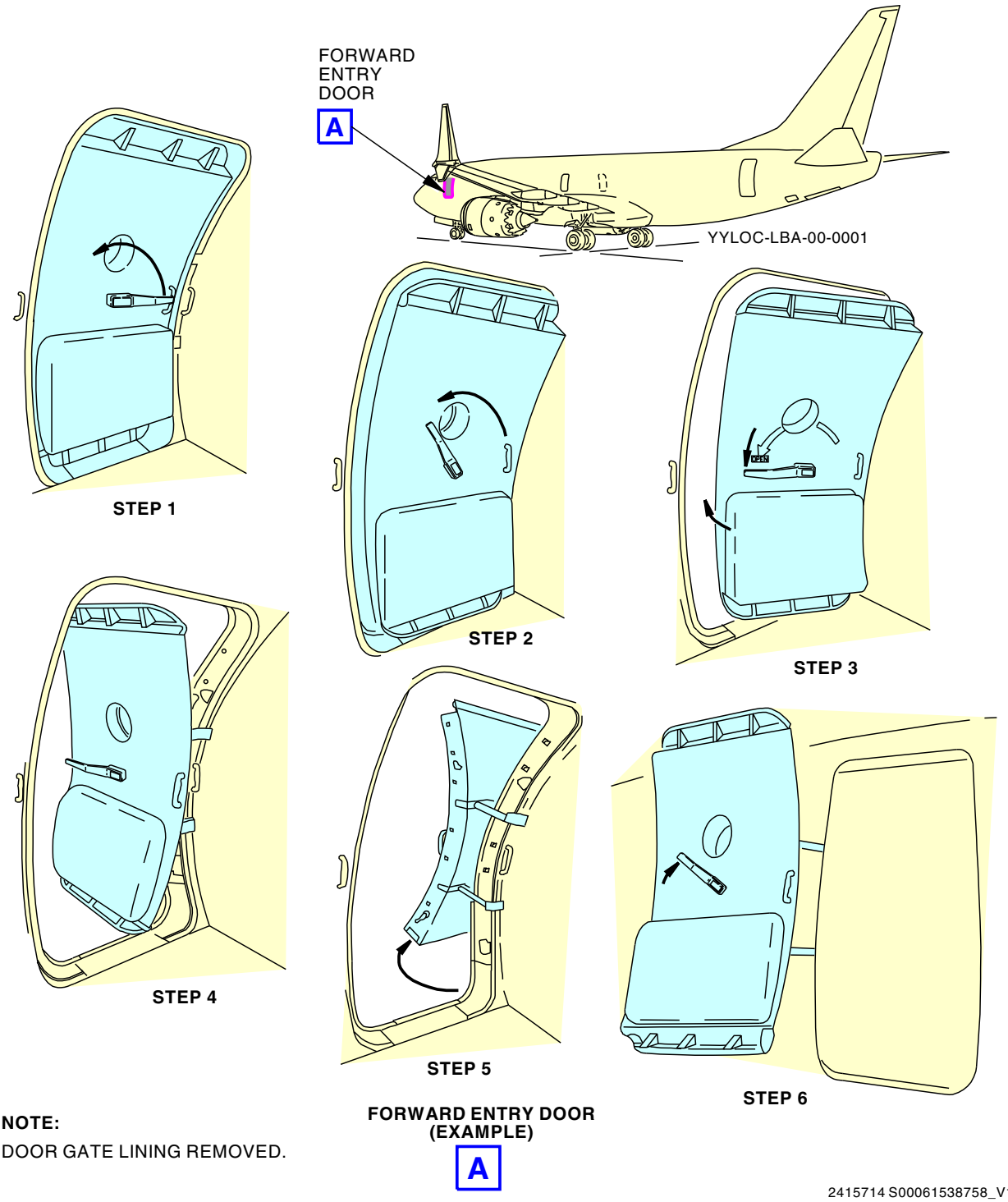
END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Forward Entry Door Operation from Outside Airplane
Figure 201/52-11-00-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Forward Entry Door Operation from Inside Airplane
Figure 202/52-11-00-990-802

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-11-00-600-801

6. Forward Entry Door Corrosion Prevention

A. References

Reference	Title
12-25-11 P/B 301	FORWARD ENTRY DOOR - SERVICING
52-11-00-200-801	Forward Entry Door Check (P/B 601)
52-11-31-000-801	Forward Entry Door Lining Removal (P/B 401)
52-11-31-400-801	Forward Entry Door Lining Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

C. Location Zones

Zone	Area
831	Forward Entry Door

D. General

SUBTASK 52-11-00-800-001

(1) Corrosion may occur on the internal and external surfaces of the door structure. especially the inside lower corners, the connection points, and the door mechanism.

(2) Corrosion has been found on the door torque tube, that is found adjacent to the door in the airplane body. The torque tube for the aft service door, in particular, has been found to contain large amounts of water.

(3) If a door is not opened often from the outside, corrosion has been found on the exterior door handle. The corrosion causes the handle to seize in the recess and prevents the handle from moving outward to unlock the door. Corrosion can also be found in the upper and lower bearings.

(a) If the door handle operates in a stiff or restricted manner, then increase the frequency of the lubrication.

(4) If applicable, stress corrosion cracks have been found on the aft upper stop fitting at the aft airstair door.

(5) Corrosion has been found on the rivets between the web and the intercostal at the aft galley door on some airplanes.

(6) Some items in this section maybe subject to the mandatory requirements for corrosion prevention and control programs for aging airplanes.

(7) Corrosion Prevention

(a) Do these tasks, Forward Entry Door Check, TASK 52-11-00-200-801 to detect the early stages of corrosion.

(b) Look for missing fasteners, white powdery deposits, and discolorations, as signs of corrosion.

1) If signs of corrosion are found, then a corrosion prevention program should be started to prevent the build up of corrosion products.

2) If corrosion products are allowed to build up, then they will cause further corrosion.

3) If corrosion is found, the refer to the Structural Repair Manual for detail instructions for the removal of corrosion.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(c) After the corrosion products are cleaned, make sure that the protective finishes are serviceable.

1) If only minor corrosion is found, then make sure that the area is clean.

2) Apply corrosion inhibiting compound on the affected area.

3) Make sure that the protective finish is restored at the next maintenance opportunity.

(8) Frequency of Application

(a) Periodic inspection is required to areas identified as prone to corrosion and should be scheduled to your Maintenance Planning Document.

(b) Periodic application of BMS 3-23 compounds are necessary to areas identified as prone to corrosion and should be scheduled to your Maintenance Planning Document.

1) Do the prevention treatment to the door at the same recommended interval as the door frame.

2) Do the prevention treatment to the exterior surface of the door at the same recommended interval as the exterior surface of the fuselage.

E. Corrosion Prevention

SUBTASK 52-11-00-620-001

(1) Prevention Treatment

(a) Remove the door liner to get access to the interior surfaces of the door.

1) Forward Entry Door Lining Removal, TASK 52-11-31-000-801

(b) Clean the drains and drain paths.

(c) Forward Entry Door Check, TASK 52-11-00-200-801

1) Remove or repair any corrosion that you find.

(d) Apply corrosion inhibiting compound, G00009 to the interior surfaces of the door.

1) Make sure that the corrosion inhibiting compound, G00009 completely covers the surfaces, with special attention given to the lower corners and the handle mechanism housing.

(e) If it is necessary, apply corrosion inhibiting compound, G00009 to the exterior surfaces of the door.

(f) Lubricate the door. FORWARD ENTRY DOOR - SERVICING, PAGEBLOCK 12-25-11/301

(g) Install the door lining.

1) Forward Entry Door Lining Installation, TASK 52-11-31-400-801

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FORWARD ENTRY DOOR - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the forward entry door

(2) An installation of the forward entry door

(3) A removal of the forward entry door flapper seal

(4) An installation of the forward entry door flapper seal.

TASK 52-11-00-000-801

2. Forward Entry Door Removal

(Figure 401)

A. References

Reference	Title
52-11-21-000-801	Forward Entry Door Guide Arm and Roller Removal (P/B 401)
52-11-31-000-801	Forward Entry Door Lining Removal (P/B 401)
52-11-41-000-801	Forward Entry Door Assist Springs Removal (P/B 401)
52-11-51-000-801	Forward Entry Door Snubber 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

C. Location Zones

Zone	Area
831	Forward Entry Door

D. Access Panels

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access

E. Prepare for the Removal

SUBTASK 52-11-00-860-024

(1) Make sure that the forward entry door [1] is safe as follows:

(a) Make sure that the forward entry door [1] is closed and latched.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Install the work platform, COM-1523, outboard of the forward entry door [1].

SUBTASK 52-11-00-010-001

(2) Do this task: Forward Entry Door Lining Removal, TASK 52-11-31-000-801.

SUBTASK 52-11-00-010-002

(3) Remove this access panel:

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access

F. Forward Entry Door Removal

SUBTASK 52-11-00-010-003

(1) Make sure that the forward entry door [1] is open.

SUBTASK 52-11-00-480-001

(2) Support the forward entry door [1] as follows:

(a) Install straps through two lightning holes of the forward entry door [1] to hold the weight of the forward entry door [1] from a position above the forward entry door [1].

NOTE: The lightning holes are installed above the handle of the door on the inboard side. The lightning holes can be seen when the lining of the door is removed.

NOTE: The door weight is 140 lb (64 kg) without the liner and slide installed.

SUBTASK 52-11-00-020-002

CAUTION REMOVE THE SNUBBER BEFORE YOU REMOVE THE DOOR. IF YOU DO NOT REMOVE THE SNUBBER BEFORE YOU REMOVE THE DOOR, DAMAGE TO THE SNUBBER CAN OCCUR.

(3) Do this task: Forward Entry Door Snubber Removal, TASK 52-11-51-000-801 (View B, Figure 401).

SUBTASK 52-11-00-020-003

(4) Disconnect the guide arm [15] from the forward entry door [1] (View A, Figure 401).

(a) Remove the filler [20] to get access to the fasteners that attach the guide arm [15] to the forward entry door [1].

(b) Remove the bolt [11], washers [12], cotter pin [14], and nut [13] that attach the guide arm [15] to the forward entry door [1].

NOTE: The guide arm will stay with the fuselage.

SUBTASK 52-11-00-020-012

(5) If it is necessary, remove the guide arm [15] from the fuselage (TASK 52-11-21-000-801).

SUBTASK 52-11-00-020-004

(6) Disconnect the torque tube from the upper hinge spigot [43] and lower hinge spigot [44] (TASK 52-11-41-000-801).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-11-00-020-005

(7) Disconnect the upper hinge arm [16] at the upper hinge spigot [43] (View A and View D, Figure 401).

(a) Remove the bolt [17], washer [18], and nut [19] that attach the upper hinge arm [16] to the upper hinge spigot [43] on the fuselage structure.

(b) Remove the upper hinge spigot [43], compresser spring [42], washer [41], packing [40], and thrust washer [46] from the upper hinge arm [16].

NOTE: The upper hinge arm will stay with the forward entry door.

SUBTASK 52-11-00-020-006

(8) Disconnect the lower hinge arm [22] at the lower hinge spigot [44] (View E, Figure 401).

(a) Remove the bolt [37], washer [38], and nut [39] that attach lower hinge arm [22] to the lower hinge spigot [44].

(b) Remove the lower hinge spigot [44], compresser spring [42], washer [41], packing [40], and thrust washer [46] from the lower hinge arm [22].

NOTE: The lower hinge arm will stay with the forward entry door.

SUBTASK 52-11-00-020-007

WARNING

BE CAREFUL WHEN YOU REMOVE THE DOOR FROM THE AIRPLANE. THE DOOR WEIGHS APPROXIMATELY 140 POUNDS. INJURY TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

(9) Remove the forward entry door [1] from the airplane as follows:

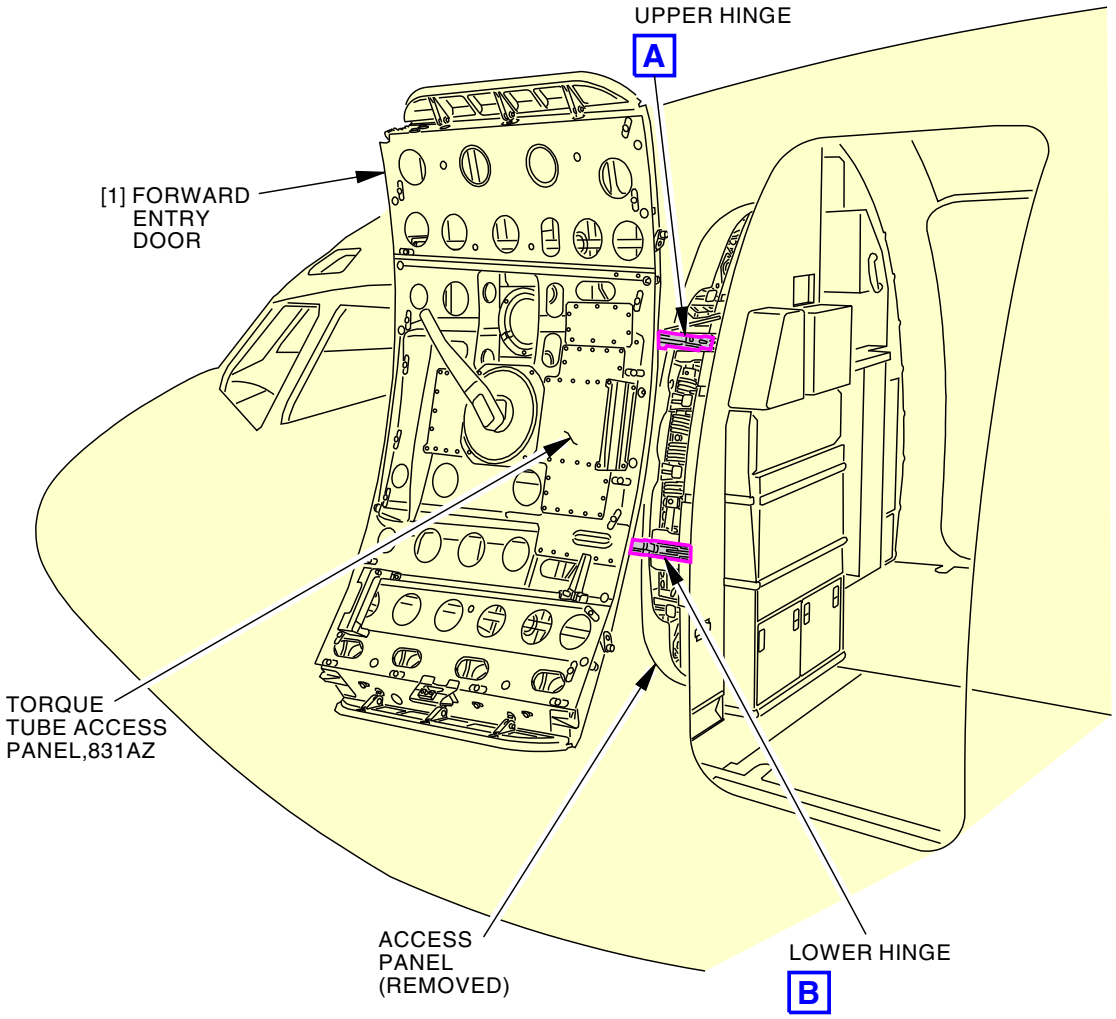
(a) Carefully move the forward entry door [1] from the fuselage and remove from the airplane.

SUBTASK 52-11-00-860-025

(10) Put the personnel barrier, SPL-2005, across the door opening.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

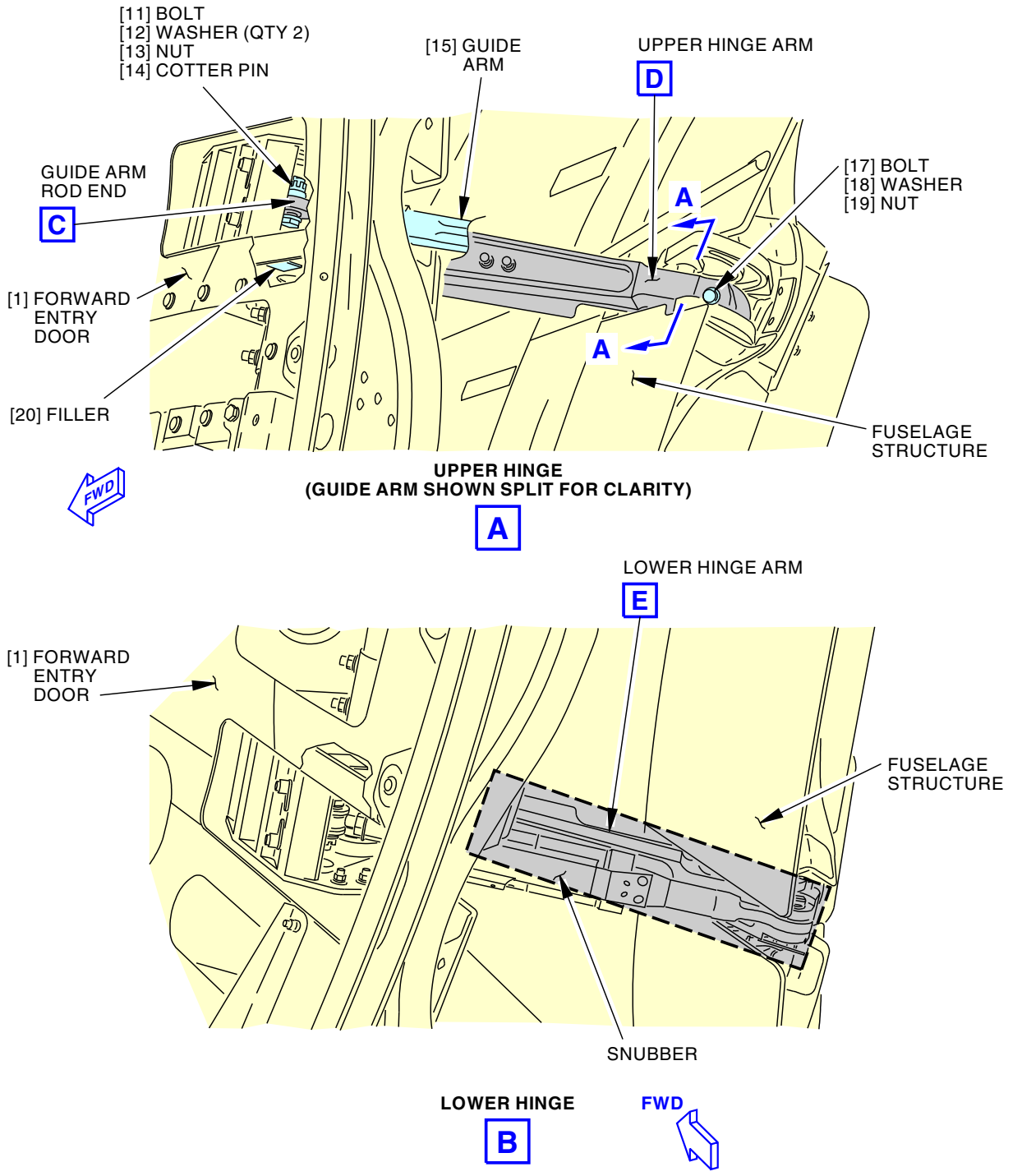


FORWARD ENTRY DOOR

2415715 S00061538765_V1

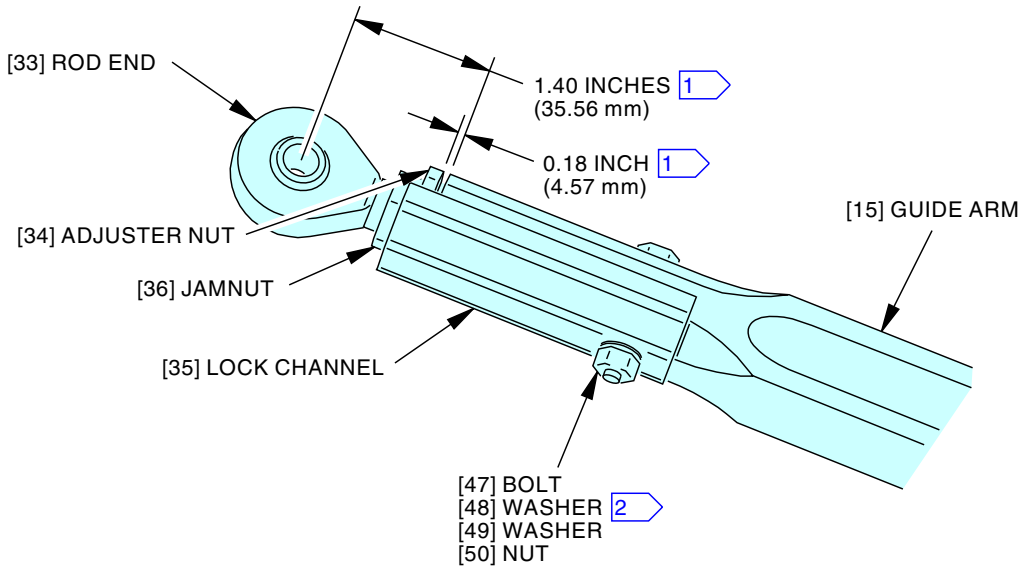
Forward Entry Door Installation
Figure 401/52-11-00-990-821 (Sheet 1 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Forward Entry Door Installation
Figure 401/52-11-00-990-821 (Sheet 2 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



GUIDE ARM ROD END

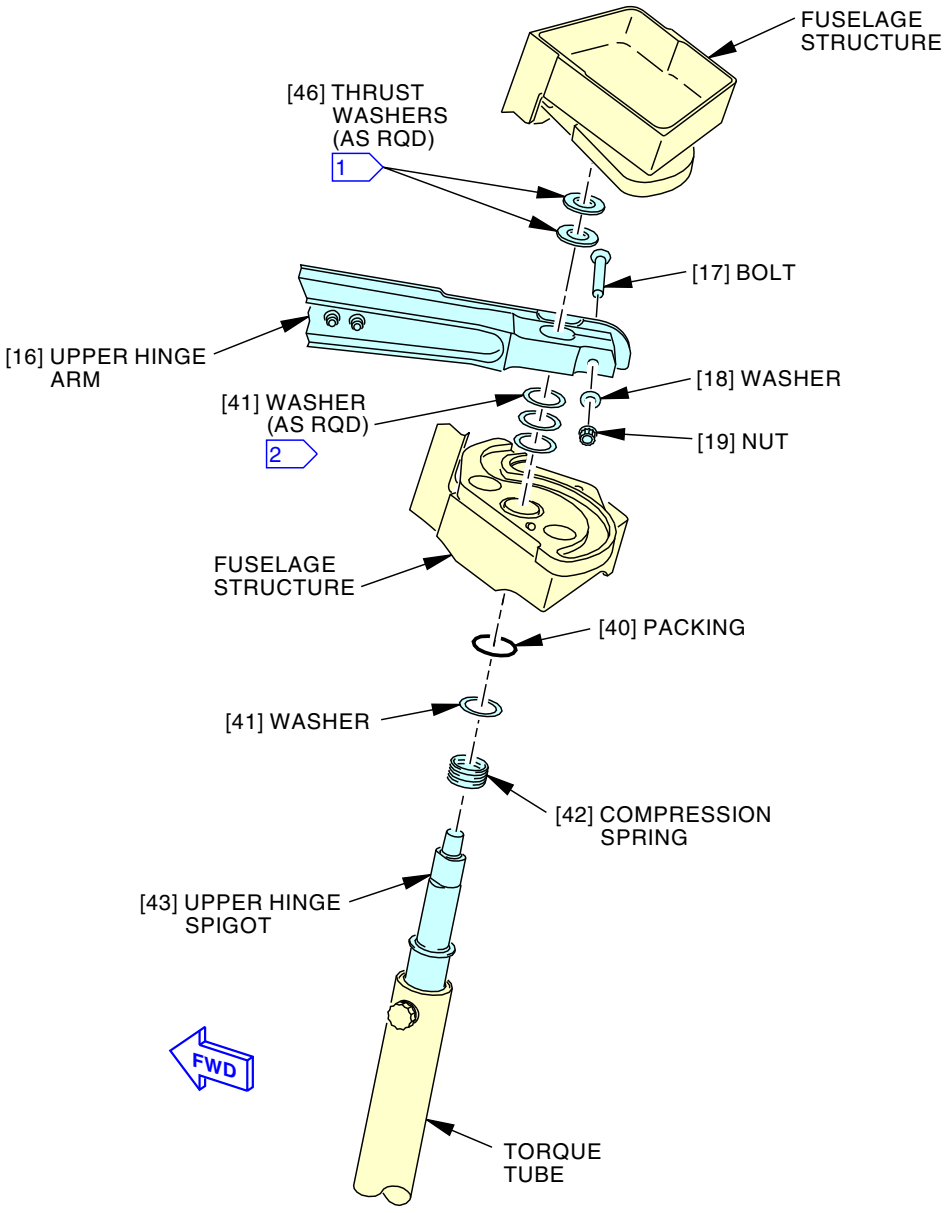
C

1 INITIAL ADJUSTMENT
2 WASHER USED WITH HEX HEAD BOLT

2415717 S00061538767_V1

Forward Entry Door Installation
Figure 401/52-11-00-990-821 (Sheet 3 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



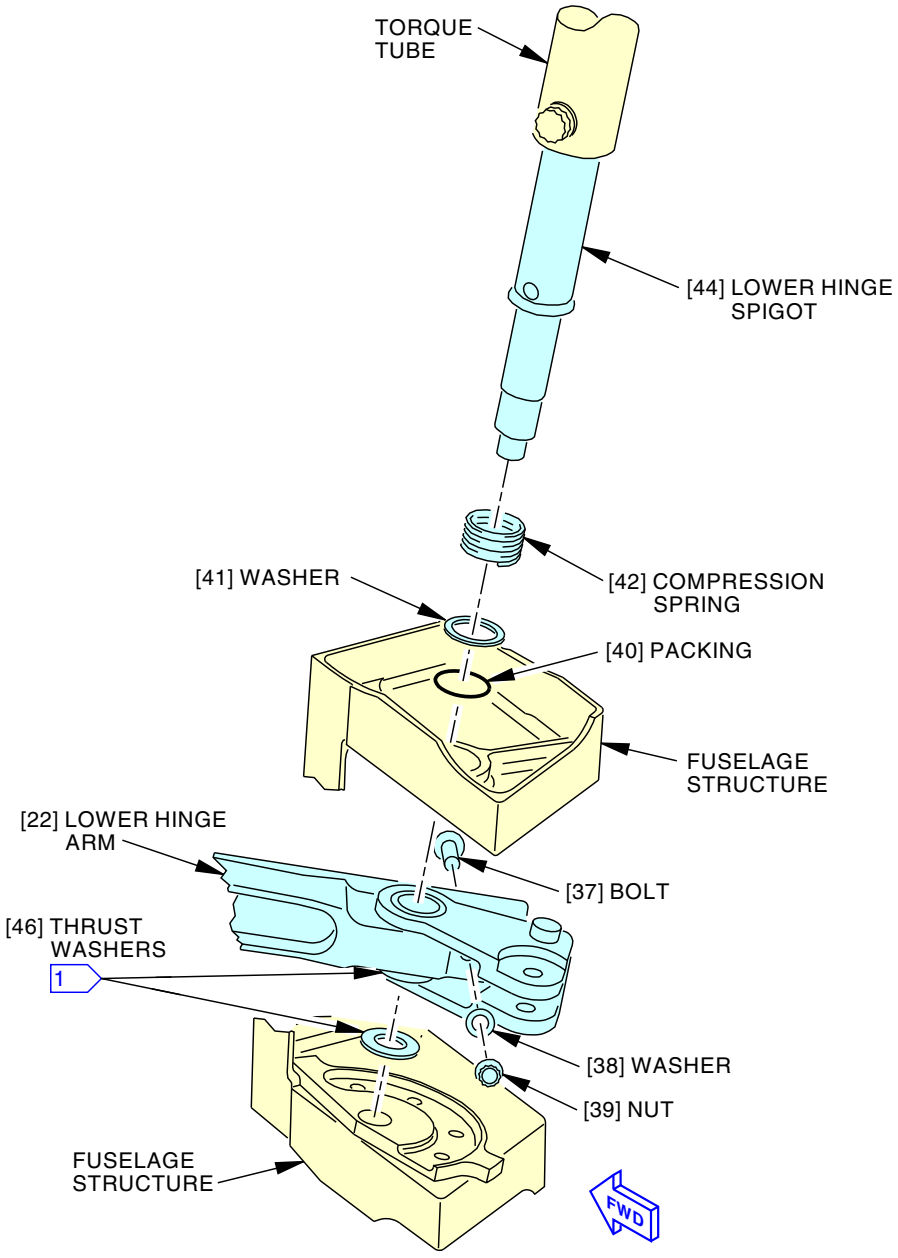
1 USE A MIXTURE OF THE THRUST WASHERS [46] (0.060 INCH (1.5240 mm), 0.0450 INCH (1.1430 mm)), AS NECESSARY, TO KEEP A 0.020 INCH (0.508 mm) CLEARANCE BETWEEN THE UPPER GUIDE PLATE AND THE UPPER RADIUS LINK.

2 USE A MIXTURE OF THE WASHERS [41] (0.050 INCH (1.270 mm), 0.071 INCH (1.803 mm), (0.012 INCH (0.305 mm)) TO KEEP A 0.020 INCH (0.508 mm) CLEARANCE BETWEEN THE HINGE ARM AND THE LOWER RADIUS LINK.

2415718 S00061538768_V3

Forward Entry Door Installation
Figure 401/52-11-00-990-821 (Sheet 4 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

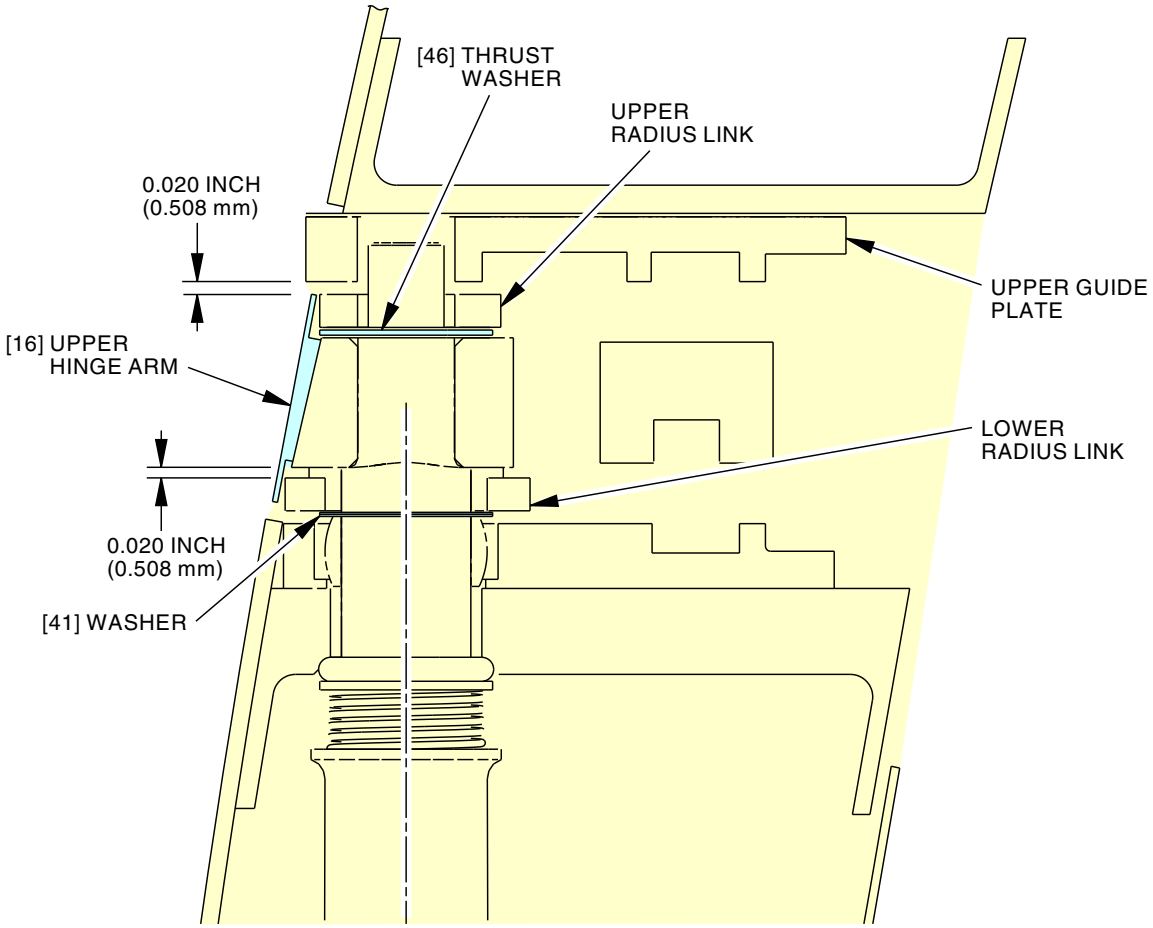


1 USE A MIXTURE OF THE THRUST WASHERS [46] (0.060 INCH (1.5240 mm), 0.0450 INCH (1.1430 mm)), AS NECESSARY, TO KEEP A 0.020 INCH (0.508 mm) CLEARANCE.

2415719 S00061538769_V3

Forward Entry Door Installation
Figure 401/52-11-00-990-821 (Sheet 5 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



A-A

2566486 S0000612977_V1

Forward Entry Door Installation
Figure 401/52-11-00-990-821 (Sheet 6 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-11-00-400-801

3. Forward Entry Door Installation

(Figure 401)

A. References

Reference	Title
52-11-00-200-803	Forward Entry Door Pressure Seal Check (P/B 601)
52-11-00-700-801	Forward Entry Door System Test (P/B 501)
52-11-00-820-801	Forward Entry Door Adjustment (P/B 501)
52-11-21-400-801	Forward Entry Door Guide Arm and Roller Installation (P/B 401)
52-11-31-400-801	Forward Entry Door Lining Installation (P/B 401)
52-11-41-400-801	Forward Entry Door Assist Springs Installation (P/B 401)
52-11-51-400-801	Forward Entry Door Snubber 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
D00633	Grease - Aircraft General Purpose	BMS3-33

D. Location Zones

Zone	Area
831	Forward Entry Door

E. Access Panels

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access

F. Forward Entry Door Installation

SUBTASK 52-11-00-860-026

(1) Remove the personnel barrier, SPL-2005, from across the door opening.

SUBTASK 52-11-00-700-001

(2) Inspect the pressure seal on the door before installation (TASK 52-11-00-200-803).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-11-00-420-001

WARNING BE CAREFUL WHEN YOU MOVE THE DOOR INTO THE AIRPLANE. THE DOOR WEIGHS APPROXIMATELY 140 POUNDS. INJURY OR DAMAGE CAN OCCUR.

(3) Carefully move the forward entry door [1] near the fuselage and align the upper and lower hinge arms with the fuselage.

SUBTASK 52-11-00-420-002

(4) Connect the lower hinge arm [22] at the lower hinge spigot [44] (View E, Figure 401).

(a) Align the lower hinge arm [22] in the correct position on the hinge fitting.

(b) Apply a light layer of grease, D00633, to the compresser spring [42] and packing [40].

(c) Install the lower hinge spigot [44], compresser spring [42], washer [41], packing [40], and thrust washer [46] (as necessary) in the lower hinge fitting.

NOTE: There are two different sizes of thrust washers [46], a 0.060 in. (1.5240 mm) and a 0.0450 in. (1.1430 mm). Use a mixture of two maximum thrust washers [46] to keep a 0.020 in. (0.508 mm) minimum clearance between the hinge arm and the lower radius link, as necessary.

(d) Install the bolt [37], washer [38], and nut [39] to attach the lower hinge arm [22] to the lower hinge spigot [44].

SUBTASK 52-11-00-020-008

(5) Connect the upper hinge arm [16] at the upper hinge spigot [43] (View D, Figure 401).

(a) Align the upper hinge arm [16] in the correct position on the hinge fitting.

(b) Apply a light layer of grease, D00633, to the compresser spring [42] and packing [40].

(c) Install the upper hinge spigot [43], compresser spring [42], washer [41], packing [40], and thrust washer [46] (as necessary) in the upper hinge fitting.

NOTE: There are two different sizes of thrust washers [46], a 0.060 in. (1.5240 mm) and a 0.0450 in. (1.1430 mm). Use a mixture of two maximum thrust washers [46] to keep a 0.020 in. (0.508 mm) minimum clearance between the upper guide plate and the upper radius link.

NOTE: There are three different sizes of washers. Use a mixture of the washers [41] (0.050 in. (1.270 mm), 0.071 in. (1.803 mm), 0.012 in. (0.305 mm)), as necessary, between the upper hinge arm [16] and lower radius link to get a 0.020 in. (0.508 mm) minimum clearance.

(d) Install the bolt [17], washer [18], and nut [19] that attach the upper hinge arm [16] to the upper hinge spigot [43].

SUBTASK 52-11-00-420-003

(6) Connect the fuselage hinge torque tube to the upper hinge spigot [43] and lower hinge spigot [44] (TASK 52-11-41-400-801).

SUBTASK 52-11-00-420-004

(7) Make sure that the distance from the rod end [33] centerline to the adjustment nut [34] and guide arm [15] is as shown (View C, Figure 401).

NOTE: This is an initial adjustment for a new guide arm or door.

SUBTASK 52-11-00-820-001

(8) Use the adjustment nut [34] to change the length of the guide arm [15] as follows:

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(a) Remove the bolt [47], washer [48], washer [49], and nut [50] on the lock channel [35].

(b) Remove the lock channel [35].

(c) Loosen the jamnut [36].

(d) Change the length of the rod end [33] of guide arm [15] with the adjustment nut [34] to get the correct dimension.

(e) Make sure that the adjustment nut [34] will align with the lock channel [35].

(f) Tighten the jamnut [36].

(g) Put the lock channel [35] in the correct position on the guide arm [15].

(h) Install the bolt [47], washer [48], washer [49], and nut [50] to hold the lock channel [35].

SUBTASK 52-11-00-420-010

(9) If it was removed, install the guide arm [15] on the fuselage (TASK 52-11-21-400-801).

SUBTASK 52-11-00-420-005

(10) Install the guide arm [15] on the upper hinge (View A, Figure 401).

(a) Put the guide arm [15] in its correct position.

SUBTASK 52-11-00-420-006

(11) Make sure that the lubrication fitting on the rod end [33] faces inboard.

(a) Install the bolt [11], washer [12], nut [13], and new cotter pin [14] to attach the guide arm [15] to the forward entry door [1].

(b) Make sure that the lock channel [35] is installed over the adjustment nut [34].

(c) Install the filler [20] with the sealant, A00247.

SUBTASK 52-11-00-410-001

(12) Install this access panel:

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access

SUBTASK 52-11-00-420-007

(13) Install the forward entry door snubber (TASK 52-11-51-400-801).

SUBTASK 52-11-00-080-003

(14) Remove the straps holding the forward entry door [1].

G. Forward Entry Door Adjustment

SUBTASK 52-11-00-820-002

(1) Do an adjustment of the forward entry door (TASK 52-11-00-820-801).

H. Put the Airplane Back to Its Usual Condition

SUBTASK 52-11-00-410-002

(1) Install the forward entry door lining (TASK 52-11-31-400-801).

SUBTASK 52-11-00-710-001

(2) Do a test of the forward entry door system (TASK 52-11-00-700-801).

SUBTASK 52-11-00-940-001

(3) Close and latch the forward entry door.

SUBTASK 52-11-00-940-002

(4) Remove the work platform, COM-1523, away from the airplane.

END OF TASK

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TASK 52-11-00-020-801

4. Forward Entry Door Flapper Seal Removal

(Figure 402)

A. References

Reference	Title
52-11-00-860-801	Open the Door with the Exterior Handle (P/B 201)

B. Location Zones

Zone	Area
831	Forward Entry Door

C. Prepare to Remove the Flapper Door Seal

SUBTASK 52-11-00-860-027

(1) Open the forward entry door (TASK 52-11-00-860-801).

D. Remove the Flapper Door Seal

SUBTASK 52-11-00-020-009

(1) Do these steps to remove the flapper door seal [71]:

(a) Push and hold the flapper door assembly to the open position.

(b) Remove the two aft screw [73], washer [74], and nut [75] from the flapper door seal [71].

(c) Remove the two forward screw [73] from the flapper door seal [71].

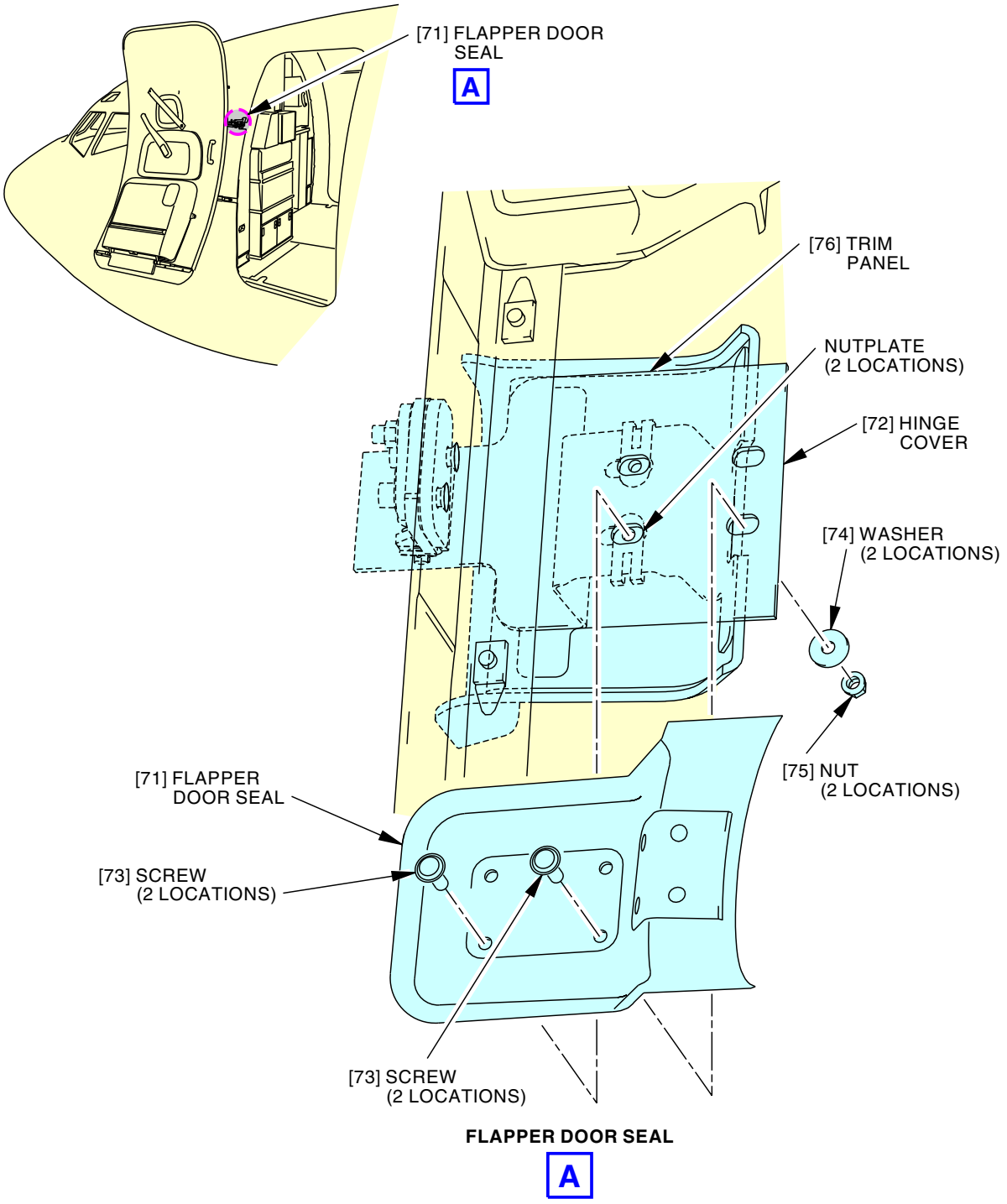
NOTE: The forward flapper door screws use nut plates attached to the trim panel.

(d) Remove the flapper door seal [71] and trim panel [76] from the hinge cover [72].

(e) If the flapper door seal [71] is to be re-installed, the old sealant must be removed and the area cleaned.

——— END OF TASK ———

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Flapper Door Seal Installation
Figure 402/52-11-00-990-822

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TASK 52-11-00-420-801

5. Forward Entry Door Flapper Seal Installation

(Figure 402)

A. References

Reference	Title
52-11-00-860-802	Close the Door with the Exterior Handle (P/B 201)

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

C. Location Zones

Zone	Area
831	Forward Entry Door

D. Install the Flapper Door Seal

SUBTASK 52-11-00-020-010

(1) Do these steps to install the flapper door seal [71]:

(a) Push and hold the hinge cover [72] to the open position.

(b) Put sealant, A00247, under the four screw heads.

NOTE: The BMS5-95 Sealant replaces the plastic washers.

(c) Put the flapper door seal [71] assembly on the outboard side of the hinge cover [72] and install the two aft screw [73], washer [74], and nut [75].

(d) Put the trim panel [76] on the inboard side of the hinge cover [72] and install the two forward screw [73].

(e) Make sure that the seal makes contact with the cutout mating surface.

(f) Tighten the screw [73] to 20 in-lb (2.3 N·m).

(g) Remove the unwanted sealant from the area.

SUBTASK 52-11-00-860-028

(2) Close the forward entry door [1] (Close the Door with the Exterior Handle, TASK 52-11-00-860-802).

——— END OF TASK ———

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FORWARD ENTRY DOOR - ADJUSTMENT/TEST

1. General

A. This procedure has these tasks:

(1) An adjustment of the forward entry door.

(2) A special adjustment to correct "soft unlatching".

(3) A system test of the forward entry door.

TASK 52-11-00-820-801

2. Forward Entry Door Adjustment

A. General

(1) Do the procedure with airplane at its Standard Basic Empty Weight (SBEW) and airplane supported on its landing gear.

(2) After the adjustment is completed, make sure that all adjustment points are locked and sealed.

B. References

Reference	Title
20-50-11-910-801	Standard Torque Values (P/B 201)
52-11-31-000-801	Forward Entry Door Lining Removal (P/B 401)
52-11-31-400-801	Forward Entry Door Lining Installation (P/B 401)
52-11-51-400-801	Forward Entry Door Snubber Installation (P/B 401)
52-71-11-820-801	Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200) (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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
COM-1557	Gauge - Force Part #: DG-200 Supplier: 92456 Part #: FDIX 100 Supplier: 0BFD9 Part #: FDIX 50 Supplier: 0BFD9 Part #: LG-050 Supplier: 92456 Part #: LG-100 Supplier: 92456 Opt Part #: DPP-500G Supplier: 92456 Opt Part #: DPPH-150 Supplier: 92456 Opt Part #: DPPH-200 Supplier: 92456 Opt Part #: DPPH-50 Supplier: 92456 Opt Part #: FDI 100 Supplier: 0BFD9 Opt Part #: FDI 50 Supplier: 0BFD9 Opt Part #: FDV 100 Supplier: 0BFD9 Opt Part #: FDV 50 Supplier: 0BFD9
SPL-2003	Simulator - Escape Slide, Passenger Door Part #: C52006-74 Supplier: 81205

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D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
D00504	Grease - Petrolatum	VV-P-236
G01912	Lockwire - MS20995NC32, Monel - 0.032 Inch (0.8128 mm) Diameter	NASM20995
G02020	Clay, Modeling	

E. Location Zones

Zone	Area
831	Forward Entry Door

F. Access Panels

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access

G. Prepare for the Adjustment

SUBTASK 52-11-00-860-029

(1) If a new door was installed do these steps:

(a) Make sure that the centering guide is not installed on the door.

(b) Make sure that the stop pins are retracted into the stop fittings or removed.

SUBTASK 52-11-00-860-030

(2) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Install a work platform, COM-1523, outboard of the door.

SUBTASK 52-11-00-010-004

(3) Get access to the door as follows (Figure 501):

(a) Make sure that the door is closed and latched.

(b) Remove the entry door lining (TASK 52-11-31-000-801).

(c) Install a 90 lb (41 kg) weight or equivalent weight on the door or escape slide simulator, SPL-2003.

H. Guide Arm Adjustment

SUBTASK 52-11-00-820-003

(1) Adjust the guide arm (Figure 502):

(a) Open the door and move it until the door is parallel to the contour of the fuselage near the closed position.

(b) To make sure that the door is parallel, two conditions must be verified:

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1) The forward edge of the door next to the latch receiver should be positioned 0.50 ±0.10 in. (12.70 ±2.54 mm) inboard of the fuselage skin.

2) While maintaining the position and dimension on the forward edge of the door, the distance between the aft edge of the door next to the aft latch receiver should be within 0.00 ±0.20 in. (0.00 ±5.08 mm) of the forward edge dimension.

(c) If the door is not parallel to the contour of the fuselage after taking the above dimensions, adjust as follows:

1) Move the door to slightly short of the fully open position.

2) Remove the nut and washer on the lock channel.

3) Remove the lock channel.

4) Loosen the jamnut.

5) Turn the adjuster nut to change the length of the guide arm rod end and get the correct position of the door.

NOTE: If you shorten the guide arm it will turn the aft edge of the door inboard.

6) Make sure that the adjuster nut will align with the lock channel.

7) Tighten the jamnut.

8) Put the lock channel in its correct position on the guide arm.

9) Install the nut and washer to hold the lock channel in position.

10) Do the steps again for the lower latch receiver pair.

I. Door Vertical Adjustment

SUBTASK 52-11-00-820-004

(1) Adjust the door vertical adjustment:

(a) Close and latch the door.

(b) Make sure that the stop pins align with the stop pads, as shown in Figure 505.

NOTE: This is an alignment of the stop pads with the stop pins. Do not set the stop pin and pad clearance.

(c) Make sure that the forward and aft, upper and lower latch rollers are centered in the latch receivers.

(d) Measure the skin clearance between the upper and lower gates and fuselage skin along the top and bottom of the door at the locations that follow:

NOTE: Make additional measurements, as necessary.

1) Three locations evenly spaced along the horizontal edge of the upper and lower gates.

(e) If it is necessary, adjust the door vertically, as follows (Figure 504):

1) Make sure this access panel is open:

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access

2) Remove the cotter pins on the upper and lower adjuster nuts.

3) Loosen the upper adjuster nut and turn the lower adjuster nut to get the correct door vertical position.

4) Make sure that the lower adjuster nut is aligned with a cotter pin hole.

(f) Make sure that the clearances are as shown in Figure 503.

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1) If it is necessary, adjust the door vertically to get the clearances.

(g) Make sure that the stop pins continue to align with the stop pads.

(h) Make sure that the door is bottomed out on the lower adjuster nut.

(i) Tighten the upper adjuster nut hand tight and turn back to align with the nearest cotter pin hole.

NOTE: Do not tighten the nuts too much. If the nuts are tightened too much it can put high end loads on the bearings in the handle mechanism.

(j) Install the new cotter pins in the upper and lower adjuster nuts.

J. Skin Clearance Adjustment

SUBTASK 52-11-00-820-005

(1) Two measurement methods are provided to adjust the door.

(a) Method 1 is the Standard measurement method for skin clearance adjustment.

(b) Method 2 is Aero-Averaging measurement for skin clearance adjustment.

SUBTASK 52-11-00-820-006

(2) Adjust the skin clearance with Method 1 (Figure 503):

(a) Make sure that the clearances between the door skin and fuselage skin are as shown in Table 501.

Table 501/52-11-00-993-801 Aerosmoothness Limits - Forward Entry Door (Method 1) (Key to Figure 503)

ZONE	CLEARANCE		FLUSHNESS	
	NOMINAL Inch (mm)	TOLERANCE Inch (mm)	NOMINAL Inch (mm)	TOLERANCE Inch (mm)
A	0.12 (3.05)	0.06 to 0.18 (1.52 to 4.57)	--	NOT APPLICABLE
B	0.12 (3.05)	0.06 to 0.15 (1.52 to 3.81)	-0.25 (-6.35)	-0.30 to -0.20 (-7.62 to -5.08)
C	0.12 (3.05)	0.06 to 0.18 (1.52 to 4.57)	--	NOT APPLICABLE
D	0.09 (2.29)	0.06 to 0.18 (1.52 to 4.57)	-0.06 (-1.52)	-0.12 to 0.06 (-3.05 to 1.52)
E	0.15 (3.81)	0.06 to 0.20 (1.52 to 5.08)	--	NOT APPLICABLE
F	0.15 (3.81)	0.09 to 0.20 (2.29 to 5.08)	-0.25 (-6.35)	-0.30 to -0.20 (-7.62 to -5.08)
G	0.15 (3.81)	0.06 to 0.20 (1.52 to 5.08)	--	NOT APPLICABLE
H	0.09 (2.29)	0.06 to 0.18 (1.52 to 4.57)	-0.06 (-1.52)	-0.12 to -0.03 (-3.05 to -0.76)
I	--	NOT APPLICABLE	--	NOT APPLICABLE
J	--	0.06 MINIMUM (1.52)	--	NOT APPLICABLE

(b) If it is necessary, adjust as follows:

1) Open the door.

2) Trim the edge of the door to get the correct skin clearances.

(c) Make sure that the minimum distance from the edge of the door outer skin to the door frame is as shown in Figure 503.

SUBTASK 52-11-00-820-007

(3) Adjust the skin clearance with Method 2 (Aero-Averaging) (Table 503):

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(a) Make sure that the clearances between the door skin and fuselage skin are as shown in Table 502.

Table 502/52-11-00-993-802 Aerosmoothness Limits - Forward Entry Door (Method 2) (Key to Figure 503)

ZONE	CLEARANCE		FLUSHNESS	
	NOMINAL Inch (mm)	TOLERANCE Inch (mm)	NOMINAL Inch (mm)	TOLERANCE Inch (mm)
A	0.12 (3.05)	0.06 to 0.21 (1.52 to 5.33)	--	NOT APPLICABLE
B	0.12 (3.05)	0.06 to 0.18 (1.52 to 4.57)	-0.25 (-6.35)	-0.33 to -0.17 (-8.38 to -4.31)
C	0.12 (3.05)	0.06 to 0.21 (1.52 to 5.33)	--	NOT APPLICABLE
D	0.09 (2.29)	0.06 to 0.18 (1.52 to 4.57)	-0.06 (-1.52)	-0.15 to 0.06 (-3.81 to 1.52)
E	0.15 (3.81)	0.06 to 0.23 (1.52 to 5.84)	--	NOT APPLICABLE
F	0.15 (3.81)	0.09 to 0.23 (2.29 to 5.84)	-0.25 (-6.35)	-0.33 to -0.17 (-8.38 to -4.31)
G	0.15 (3.81)	0.06 to 0.23 (1.52 to 5.84)	--	NOT APPLICABLE
H	0.09 (2.29)	0.06 to 0.21 (1.52 to 5.33)	-0.06 (-1.52)	-0.15 to 0.00 (-3.81 to 0.00)

(b) If it is necessary, adjust as follows:

1) Open the door.

2) Trim the edge of the door to get the correct skin clearances.

(c) Make sure that the minimum distance from the edge of the door outer skin to the door frame is as shown in Figure 503 (Aero-Averaging).

(d) Measure the clearance between the door skin and fuselage skin along the forward and aft edges of the door at the locations that follow:

1) Within 0 ±1 in. (0.0 ±25.4 mm) of each stop fitting along the forward and aft edges of the door.

2) Record the skin clearance for each stop fitting.

3) Use the Table 503 to change the clearance to a drag value.

NOTE: A measurement of 0.10 in. (2.54 mm) clearance is a drag value of 0.63.

4) Record the drag value for each measurement from Table 503.

Table 503/52-11-00-993-803 Drag Values for Forward Entry Door Skin Clearance (Method 2)

CLEARANCE Inch (mm)	DRAG VALUE
0.06 (1.52)	0.38
0.07 (1.78)	0.44
0.08 (2.03)	0.50
0.09 (2.29)	0.56
0.10 (2.54)	0.63
0.11 (2.79)	0.69
0.12 (3.05)	0.75
0.13 (3.30)	0.81

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Table 503/52-11-00-993-803 Drag Values for Forward Entry Door Skin Clearance (Method 2) (Continued)

CLEARANCE Inch (mm)	DRAG VALUE
0.14 (3.56)	0.88
0.15 (3.81)	0.94
0.16 (4.06)	1.00
0.17 (4.32)	1.06
0.18 (4.57)	1.12
0.19 (4.83)	1.19
0.20 (5.08)	1.25
0.21 (5.33)	1.31

5) Add all the drag values together (sum).
   a) Record the sum of the drag values as measurement A.
6) Divide measurement A by the total number of measurements recorded.
   NOTE: If the measurement was made at each of the door stops, divide Measurement A (the sum of the drag values) by 18.
7) Make sure that this average drag value is 1.00 or less.

K. Horizontal Control Rod Adjustment

SUBTASK 52-11-00-820-008

(1) Adjust the horizontal control rod:
   (a) Put the door parallel to the contour of the fuselage near the closed position.
   (b) Move the door handle in the closed direction until the latches begin to turn.
   (c) The exterior skin at the forward edge of the door should initially be 1.0 ±0.1 in. (25.4 ±2.5 mm) inboard of the body.
      1) If it is necessary, adjust the horizontal control rod (Figure 504):
         a) Open the door.
         b) To get access to the door hinge torque tube,

            Make sure that this access panel is open:

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access

         c) Remove the bolt, washers, nut, and cotter pin that attach the horizontal control rod to the torque tube.
         d) Loosen the checknut on the horizontal control rod.
         e) Turn the rod end to change the length of the horizontal control rod to get the correct dimension.
            NOTE: When the horizontal control rod is made shorter it moves the door outboard, when made longer it moves the door inboard.
         f) Install the bolt, washer, and nut to attach the rod end to the torque tube.
         g) Do not tighten the checknut.

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L. Latch Receivers Adjustment

SUBTASK 52-11-00-820-009

(1) Adjust the latch receivers (Figure 506):

(a) Close and latch the door.

(b) Measure the flushness between the door skin and fuselage skin along each edge of the door at the locations that follow:

NOTE: Make additional measurements as necessary.

1) Within 0 ±1 in. (0.0 ±25.4 mm) of each stop fitting along the forward and aft edges of the door.

(c) Make sure that the door flushness is as shown in Figure 503.

1) If it is necessary, do the Skin Flushness Adjustment steps.

(d) Do the latch adjustment (Figure 506).

1) If using clay to measure the latch roller clearances, do these steps:

a) Put clay, G02020, in the latch fitting.

b) Put a layer of grease, D00504, on the latch roller.

c) Close and latch the door.

d) Open the door.

e) Make sure that the clearance between the bottom of the latch roller and latch fitting is correct (View B-B, Figure 506).

f) Remove unwanted material from the surfaces of latch roller and latch fitting.

(e) Make sure that the clearance between the forward and aft, upper and lower latch rollers and latch receivers is as shown in Figure 506.

1) If it is necessary, adjust the latch (Figure 506).

a) Open the door.

b) Loosen the bolts and washers that attach the latch receivers to the fuselage frame.

c) Move the latch receivers inward or outward on their serrated plates to get the correct clearance between the latch roller and latch receiver.

d) Tighten the bolts and washers to attach the latch receivers to the fuselage frame.

(f) Close and latch the door.

(g) Make sure that the distance the forward and aft, upper and lower latch rollers engage in the latch receivers is as shown in Figure 506.

M. Skin Flushness Adjustment

SUBTASK 52-11-00-820-010

(1) Two measurement methods are provided to adjust the door.

(a) Method 1 is the Standard measurement method for skin flushness adjustment.

NOTE: In one or more locations the tolerance can be increased by 0.03 in. (0.76 mm), except the total length cannot exceed five percent of the door periphery (Method 1 only).

(b) Method 2 is Aero-Averaging measurement for skin flushness adjustment.

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SUBTASK 52-11-00-820-011

(2) Adjust the skin flushness using Method 1 (Figure 503):

(a) Make sure that the flushness between the door skin and fuselage skin are as shown in Figure 503.

(b) As a minimum, measure the flushness between the door skin and fuselage skin along the forward and aft edges of the door at the locations that follow:

1) Within 0 ±1 in. (0.0 ±25.4 mm) of each stop fitting along the forward and aft edges of the door.

NOTE: Make additional measurements if necessary. Do not make measurements that are within 8 in. (203 mm) of the body skin lap joint.

2) Three locations evenly spaced along the horizontal edge of the upper and lower gates.

(c) If it is necessary, adjust as follows:

1) Open the door.

2) Loosen the bolts and washers that attach the forward and aft, upper and lower latch receivers to the fuselage frame.

3) Move the latch receivers inboard or outboard on their serrated plates to get the correct door flushness (Figure 506).

4) Tighten the bolts and washers to attach the latch receivers to the fuselage frame.

SUBTASK 52-11-00-820-012

(3) Adjust the skin flushness using Method 2 (Aero-Averaging) (Table 504):

(a) Make sure that the flushness between the door skin and fuselage skin are as shown in Figure 503.

(b) As a minimum, measure the flushness between the door skin and fuselage skin at the locations that follow:

1) Within 0 ±1 in. (0.0 ±25.4 mm) of each stop fitting along the forward and aft edges of the door.

NOTE: Make additional measurements if necessary. Do not take measurements that are within 8 in. (203 mm) of the body skin lap joint.

2) Three locations evenly spaced along the horizontal edge of the upper and lower gates.

3) Record the skin flushness at each stop fitting.

4) Use Table 504 to change the flushness to a Drag value.

NOTE: A measurement of -0.10 in. (-2.54 mm) flushness at the door fwd edge is a Drag value of 0.56.

5) Record the Drag value for each measurement from Table 504.

Table 504/52-11-00-993-804 Drag Values for Forward Entry Door Skin Flushness (Method 2)

DOOR FLUSHNESS		
FWD EDGE Inch (mm)	AFT EDGE Inch (mm)	DRAG VALUE
	0.06 (1.52)	2.10
	0.05 (1.27)	1.89

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Table 504/52-11-00-993-804 Drag Values for Forward Entry Door Skin Flushness (Method 2) (Continued)

DOOR FLUSHNESS		
FWD EDGE Inch (mm)	AFT EDGE Inch (mm)	DRAG VALUE
	0.04 (1.02)	1.69
-0.15 (-3.81)	0.03 (0.76)	1.49
-0.14 (-3.56)	0.02 (0.51)	1.29
-0.13 (-3.30)	0.01 (0.25)	1.10
-0.12 (-3.05)	0.00	0.91
-0.11 (-2.79)	-0.01 (-0.25)	0.73
-0.10 (-2.54)	-0.02 (-0.51)	0.56
-0.09 (-2.29)	-0.03 (-0.76)	0.39
-0.08 (-2.03)	-0.04 (-1.02)	0.23
-0.07 (-1.78)	-0.05 (-1.27)	0.09
-0.06 (-1.52)	-0.06 (-1.52)	0
-0.05 (-1.27)	-0.07 (-1.78)	0.11
-0.04 (-1.02)	-0.08 (-2.03)	0.38
-0.03 (-0.76)	-0.09 (-2.29)	0.70
-0.02 (-0.51)	-0.10 (-2.54)	1.06
-0.01 (-0.25)	-0.11 (-2.79)	1.44
0.00	-0.12 (-3.05)	1.85
	-0.13 (-3.30)	2.23
	-0.14 (-3.56)	2.67
	-0.15 (-3.81)	3.12

6) Add all the Drag values together (sum).

a) Record the sum of the drag values as Measurement A.

7) Divide Measurement A by the number of measurements that you made.

NOTE: If the measurement was made a each of the door stops, then divide Measurement A (the sum of the Drag Values) by 18.

a) Make sure that this drag value is 1.00 or less.

(c) If the average drag value is greater than 1.00 then adjust the door as follows:

1) Open the door.

2) Loosen the bolts and washers that attach the forward and aft, upper and lower latch receivers to the fuselage frame.

3) Move the latch receivers inboard or outboard on their serrated plates to get the correct door flushness (Figure 506).

4) Tighten the bolts and washers to attach the latch receivers to the fuselage frame.

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N. Gate Adjustment

SUBTASK 52-11-00-820-013

(1) Adjust the gate (Figure 507):

(a) Close and latch the door.

(b) Measure the flushness between the gate skin and fuselage skin at the locations that follow:

NOTE: Make additional measurements if necessary.

1) Three locations evenly spaced along the horizontal edges of the upper and lower gates.

(c) Make sure that the flushness between the upper and lower gates and fuselage skin is as shown in Figure 503.

1) If it is necessary, adjust the gate control rod (Figure 507):

a) Open the door.

b) Remove the bolt, washers, nut, and pin that attach the gate control rod to the gate.

c) Loosen the checknut.

d) Turn the rod end bearing to change the length of the gate control rod to get the correct flushness.

e) Install the bolt, washers, nut, and pin to attach the gate control rod to the gate.

<1> Make sure that the lube fitting on the rod end points inboard.

2) Tighten the checknut.

(d) Set the gate stop rods as follows (Figure 507):

1) Remove the bolt, washers, nut, and pin that attach the gate stop rod to the gate.

2) Remove the lockwire and loosen the checknut.

3) Turn the rod end bearing into the stop rod until the shoulder of the rod touches the bearing, then turn back to the nearest locking notch.

4) If it is necessary, turn the rod and rod end bearing 1/2 turn to point the lube fitting and locking tang of the lock washer inboard.

5) Install the bolt, washers, nut, and pin to attach the gate control rod to the gate.

6) Tighten the checknut.

7) Install the MS20995NC32 lockwire, G01912.

O. Hinge Cover Adjustment

SUBTASK 52-11-00-820-014

(1) Adjust the hinge cover (Figure 508):

(a) Make sure that the door is closed and latched.

(b) Make sure that the skin clearance and flushness between the hinge covers, fuselage skin, and door skin are as shown in Table 505 and Figure 508.

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Table 505/52-11-00-993-805 Aerosmoothness Limits - Hinge Cover at Forward Edge of Forward Entry Door (Key to Figure 509)

LOCATION	CLEARANCE *[1]		FLUSHNESS *[2]	
	NOMINAL Inch (mm)	TOLERANCE Inch (mm)	NOMINAL Inch (mm)	TOLERANCE Inch (mm)
A	0.09 in. (2.29 mm)	0.06 in. (1.52 mm) to 0.15 in. (3.81 mm)	0.00 in. (0.00 mm)	-0.03 in. (0.76 mm) to 0.03 in. (0.76 mm)
B	0.09 in. (2.29 mm)	0.06 in. (1.52 mm) to 0.15 in. (3.81 mm)		NOT APPLICABLE
C	0.12 in. (3.05 mm)	0.09 in. (2.29 mm) to 0.18 in. (4.57 mm)	0.00 in. (0.00 mm)	-0.03 in. (0.76 mm) to 0.03 in. (0.76 mm)
D	0.09 in. (2.29 mm)	0.06 in. (1.52 mm) to 0.15 in. (3.81 mm)		NOT APPLICABLE
E	0.09 in. (2.29 mm)	0.06 in. (1.52 mm) to 0.15 in. (3.81 mm)	0.00 in. (0.00 mm)	-0.03 in. (0.76 mm) to 0.06 in. (1.52 mm)
F	0.09 in. (2.29 mm)	0.06 in. (1.52 mm) to 0.15 in. (3.81 mm)		NOT APPLICABLE
G	0.12 in. (3.05 mm)	0.09 in. (2.29 mm) to 0.18 in. (4.57 mm)	0.00 in. (0.00 mm)	-0.03 in. (0.76 mm) to 0.03 in. (0.76 mm)
H	0.09 in. (2.29 mm)	0.06 in. (1.52 mm) to 0.15 in. (3.81 mm)		NOT APPLICABLE

*[1] Clearance at the aft corners of the hinge cover must be a smooth transition.

*[2] Flushness from the forward edge to the aft edge of the hinge cover must be a smooth transition.

(c) If you need to adjust the skin clearances or flushness, do these steps:

1) Adjust the skin clearance as follows:

a) Trim the hinge covers to get the correct clearance.

2) Adjust the flushness as follows (Figure 508):

NOTE: Do the adjustment for each hinge cover as required.

a) Remove the bolts that attach the hinge cover to the hinge arm and clip.

b) Remove shim laminations or add a new shim at the forward end of the hinge arm to get the correct flushness at the forward edge of the hinge cover.

c) Loosen the bolts and washers that attach the clip to the aft end of the hinge arm.

d) Move the clip inboard or outboard to get the correct flushness at the aft edge of the hinge cover.

e) Tighten the bolts and washers that attach the clip to the aft end of the hinge arm.

f) Remove shim laminations or add a new shim at the middle of the hinge arm to get a smooth change in flushness between the forward and aft edges of the hinge cover.

g) Install the bolts to attach the hinge cover to the hinge arm and clip.

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P. Latch Engagement Adjustment

SUBTASK 52-11-00-820-015

(1) Adjust the latch engagement (Figure 506):

(a) Close and latch the door.

(b) Make sure that the distance the forward and aft, upper and lower latch rollers engage in the latch receivers is as shown in Figure 506. If it is necessary, adjust as follows:

1) Open the door.

2) Move the spacers from one end of the latch torque tube to the other end to increase or decrease the distance the latch roller engages in the latch receiver at one end of the latch torque tube.

3) If more adjustment is necessary, do the steps that follow:

a) Remove the nut that attaches the latch roller to the latch crank.

b) Put the washers on the roller side or the nut side of the latch crank to increase or decrease the distance the latch roller engages in the latch receiver.

c) Install the nut to attach the latch roller to the latch crank.

d) Operate the latch torque tube and make sure that the shank of the latch roller is clear of the door frame by 0.02 in. (0.5 mm) minimum after the adjustment.

(c) Make sure that the door is open.

(d) Move the latch torque tube forward and aft to do a check for latch torque tube end play.

(e) Make sure that the latch torque tube end play is 0.02 in. (0.5 mm) maximum. If necessary, adjust as follows:

1) Add adjustment spacers at one of the ends of the latch torque tube to decrease the end play.

2) Operate the latch torque tube and make sure that the shank of the latch roller is clear of the door frame by 0.02 in. (0.5 mm) minimum after the adjustment.

3) When the adjustment is complete, turn the spacers in a random direction.

NOTE: The spacers slots should not be aligned.

4) Apply the sealant, A00247, to the adjustment spacers.

5) Make sure that the sealant, A00247, does not stop the latch torque tube support bearing from turning freely.

6) Do this task: Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200), TASK 52-71-11-820-801.

Q. Snubber Adjustment

SUBTASK 52-11-00-820-016

(1) Install the forward entry door snubber, if not installed (TASK 52-11-51-400-801).

SUBTASK 52-11-00-820-024

(2) Adjust the snubber (Figure 509):

(a) With the door open and the hold open lock engaged, make sure that more extension of the snubber is available (Figure 509).

1) If it is necessary, adjust the length of the snubber as follows:

a) Make sure that the door is fully open.

b) Remove the bolt, washers, and nut that attach the snubber to the door.

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c) Loosen the jamnut on the snubber rod end.

d) Turn the snubber rod end to change the length of the snubber.

e) Tighten the jamnut (TASK 20-50-11-910-801).

f) Install the MS20995NC32 lockwire, G01912 on the jamnut.

2) Install the bolt, washers, and nut to attach the snubber to the door.

(b) Move the door to the closed position.

(c) Make sure that the snubber does not bottom out when the door is closed.

NOTE: You should be able to turn the snubber link a small amount.

(d) Install the cotter pins in the fasteners that attach the snubber to the door and fuselage frame.

R. Latch Clearance Adjustment

SUBTASK 52-11-00-820-017

(1) Do the latch clearance adjustment:

(a) Move the door to the cocked position.

(b) Turn the door handle until the latch rollers start to engage the latch receivers.

(c) Monitor each latch roller as it goes into its latch receiver.

(d) Make sure that the latch rollers are clear of the entry lip on the latch receiver when the door handle is moved to the latched position.

(e) Do a check for drag caused by the door seal liner:

NOTE: Do the steps for each latch receiver.

1) Apply a 10 ±1 lb (5 ±1 kg) spring load or equivalent to the door in an inboard direction at a stop fitting adjacent to a latch roller.

2) Monitor the latch roller as it goes into its latch receiver.

3) Make sure that the latch rollers are clear of the entry lip on the latch receiver when the door handle is moved to the latched position. If necessary, adjust the clearance as follows (Figure 506):

a) Open the door.

b) If installed, remove the bolt, washers, nut and cotter pin, that attach the horizontal control rod end to the door hinge torque tube (Figure 504).

c) Turn the rod end to decrease the length of the horizontal control rod to get the correct clearance.

NOTE: Do not turn the rod end more than 1-1/2 turns.

4) Install the bolt, washers, nut, and new cotter pin to attach the horizontal control rod end to the door hinge torque tube.

5) Tighten the checknut.

6) Close and latch the door.

(f) Install this access panel:

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access

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S. Handle Retraction Adjustment

SUBTASK 52-11-00-820-018

(1) Do the handle retraction adjustment:

(a) Make sure that the door is closed and latched.

(b) Pull the exterior handle to its extended position.

(c) Use a force gauge, COM-1557, to measure the force necessary to move the exterior handle back to its retracted position.

(d) Make sure that the force necessary to move the handle to its retracted position is not more than 20 lb (9 kg).

1) If it is necessary, do the steps to adjust the horizontal control rod.

T. Centering Guide Adjustment

SUBTASK 52-11-00-820-019

(1) Do the centering guide adjustment (Figure 510):

(a) Make sure that the door is open.

(b) Make sure that the centering guide body track thickness is not less then 0.070 in. (1.778 mm).

(c) Hold the centering guide in position adjacent to the aft door frame.

(d) Install the bolts and washers to attach the centering guide to the door frame.

(e) Close the door slowly.

(f) Make sure that the centering guide goes in the body track and is clear of the track as the door closes.

(g) Make sure that the clearance between the centering guide roller and track is as shown in Figure 510.

(h) Adjust the guide roller as follows:

1) Loosen the bolts and washers that attach the centering guide to the door frame.

2) Move the centering guide on the serrated plate to get the correct clearance.

NOTE: The centering guide has slots for the bolts for adjustment.

3) Tighten the bolts.

U. Stop Pin Adjustment

SUBTASK 52-11-00-820-020

(1) Do the stop pin adjustment (Figure 505).

(a) Install the stop pins in the door if they are removed.

(b) For stop pins that have no access, use clay to measure the pin-to-pad clearance, as follows:

1) Put clay, G02020, on the stop pad.

2) Put a layer of grease, D00504, on the stop pin.

3) Close and latch the door.

4) Open the door.

5) Make sure that the clearance between the stop pin and stop pad is correct (View A, Section A-A, Figure 505).

6) Remove unwanted material from the surfaces of all stop pins and stop pads.

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(c) If it is necessary, adjust as follows:

1) Turn the stop pin fully outboard until it just touches the stop pad.

2) Turn the stop pin back 1/2 turn and then to the nearest lock groove for the lock spring.

3) Install the lock spring.

(d) Make sure that the stop pins align with the stop pads on the forward and aft edges of the door (View A, Section B-B, Figure 505).

(e) Put sealant, A00247, or sealant, A02315, on the door stop pins.

SUBTASK 52-11-00-820-021

(2) Adjust the forward entry door warning sensor, do this task: Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200), TASK 52-71-11-820-801.

V. Put the Airplane Back to Its Usual Condition

SUBTASK 52-11-00-410-003

(1) Do this task: Forward Entry Door Lining Installation, TASK 52-11-31-400-801.

SUBTASK 52-11-00-940-003

(2) Remove the work platform, COM-1523.

——— END OF TASK ———

TASK 52-11-00-820-802

3. Forward Entry Door (Soft Unlatching)

(Figure 511)

A. General

(1) Do the procedure with airplane at its Standard Basic Empty Weight (SBEW) and the airplane supported on its landing gear.

(2) If the latch torque tubes are not adjusted correctly, the door handle can move too easily. This can cause the door to open accidentally (soft unlatching). This task is a special procedure to adjust the door if it opens accidentally (soft unlatching).

(3) The soft unlatching adjustment and the vertical adjustment for the forward entry door are related. When you do the soft unlatching adjustment, it affects the vertical adjustment. Make sure that these adjustments are within tolerance before you complete the soft unlatching adjustment procedure.

B. References

Reference	Title
25-66-01-000-801	Escape Slide Pack and Cover Removal (P/B 401)
25-66-01-400-801	Escape Slide Pack and Cover Installation (P/B 401)
52-11-31-000-801	Forward Entry Door Lining Removal (P/B 401)
52-11-31-400-801	Forward Entry Door Lining Installation (P/B 401)
52-71-11-820-801	Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200) (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.

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Reference	Description
SPL-1980	Tool - Setting, Forward Entry Door Latch Roller Part #: F80178-1 Supplier: 81205
SPL-2003	Simulator - Escape Slide, Passenger Door Part #: C52006-74 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
D00504	Grease - Petrolatum	VV-P-236
G02020	Clay, Modeling	

E. Location Zones

Zone	Area
831	Forward Entry Door

F. Forward Entry Door (Soft Unlatching)

SUBTASK 52-11-00-010-005

(1) Do this task: Escape Slide Pack and Cover Removal, TASK 25-66-01-000-801.

SUBTASK 52-11-00-010-006

(2) Do this task: Forward Entry Door Lining Removal, TASK 52-11-31-000-801.

SUBTASK 52-11-00-480-002

(3) Attach a 90 lb (41 kg) weight to the door approximately in the middle of the bottom half of the door.

(a) You may use the escape slide simulator, SPL-2003.

SUBTASK 52-11-00-820-022

(4) Do a check of the clearance between the latch rollers and the latch fittings.

(a) Use clay, G02020, to measure the latch roller clearances.

1) Put clay in the latch fitting.

2) Put a layer of grease, D00504, on the latch roller.

3) Close and latch the door.

4) Open the door.

5) Measure the depth of the clay to find the latch roller clearance.

(b) Make sure that the clearance between the bottom of the latch roller and the latch fitting is between 0.03 in. (0.76 mm) - 0.15 in. (3.81 mm) (Figure 511).

(c) Make sure that the clearance between the back of the latch roller and the latch fitting is more than 0.005 in. (0.127 mm) (Figure 511).

(d) If the clearance is not correct, do these steps at the upper and lower latch torque tubes:

1) If the tool, SPL-1980, is available, use it to set the latch roller overcenter.

a) Disconnect the control rods from the upper and lower latch torque tubes at the control rod cranks.

2) If the tool, SPL-1980, is not available, set the latch roller overcenter by the steps below:

NOTE: A locally made tool may be used to get the straight line relationship.

a) Disconnect the control rods from the upper and lower latch torque tubes at the control rod cranks.

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b) Align the latch torque tube, the gate control rod crank, and the gate control rod in a straight line relationship.

3) While you have a straight line relationship, adjust the length of the upper and lower control rods as necessary to permit installation of the bolt through the control rod end and the control rod crank.

a) Install the bolt through the control rod end and the control rod crank for the upper and lower latch torque tubes.

b) Connect the control rod to the latch torque tube.

c) With the mechanism in the closed position, make sure that the latch rollers engage the latch roller cam fittings.

SUBTASK 52-11-00-820-023

(5) Adjust the forward entry door warning sensor.

(a) Do this task: Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200), TASK 52-71-11-820-801.

SUBTASK 52-11-00-080-004

(6) Remove the weight or the escape slide simulator, SPL-2003 from the door.

SUBTASK 52-11-00-410-004

(7) Do this task: Forward Entry Door Lining Installation, TASK 52-11-31-400-801.

SUBTASK 52-11-00-410-005

(8) Do this task: Escape Slide Pack and Cover Installation, TASK 25-66-01-400-801.

——— END OF TASK ———

TASK 52-11-00-700-801

4. Forward Entry Door System Test

A. General

(1) The system test is a check that the door is installed and adjusted correctly and that the mechanical systems operate correctly.

(2) Make sure the installation and adjustment of the door is done. Make sure the door seal and lining are installed.

B. References

Reference	Title
52-11-00-860-803	Open the Door with the Interior Handle (P/B 201)
52-11-00-860-804	Close the Door with the Interior Handle (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-3898	Adapter - Torque Wrench, Galley and Entry Door Part #: C52008-1 Supplier: 81205

D. Location Zones

Zone	Area
831	Forward Entry Door

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E. System Test

SUBTASK 52-11-00-730-001

(1) Do the forward entry door system test:

(a) Make sure the forward entry door is fully closed, latched and locked.

(b) Make sure that the FWD ENTRY light does not show on the Forward Overhead Panel, P5, in the flight compartment.

(c) Open the door. To open the door, do this task: Open the Door with the Interior Handle, TASK 52-11-00-860-803.

(d) Make sure the FWD ENTRY light on the Forward Overhead Panel, P5, comes on for the door.

(e) Close and latch the door. To close and latch the door, do this task: Close the Door with the Interior Handle, TASK 52-11-00-860-804.

(f) Make sure the FWD ENTRY light goes off.

SUBTASK 52-11-00-730-002

(2) Do the door handle torque test:

(a) Install the adapter, SPL-3898 on the interior door handle.

(b) Open the door. To open the door, do this task: Open the Door with the Interior Handle, TASK 52-11-00-860-803.

(c) Measure the torque on the interior handle perpendicular to the handle cam to close the door.

(d) Make sure the maximum torque on the interior handle to close the door is 600 in-lb (68 N·m).

1) If the maximum handle torque is more than 600 in-lb (68 N·m), do these steps:

NOTE: The most likely cause for the increase in door closing force is the door guide ball is binding in the track.

a) Make sure the door guide ball is correctly adjusted.

b) Make sure the stop pins are correctly adjusted.

c) Make sure the upper and lower gate adjustment is correct.

d) Adjust the horizontal control rod. To adjust it, do this task: Forward Entry Door Adjustment, TASK 52-11-00-820-801.

NOTE: Do the horizontal control rod adjustment only.

(e) Close and latch the door. To close and latch the door, do this task: Close the Door with the Interior Handle, TASK 52-11-00-860-804.

(f) Measure the torque on the interior handle perpendicular to the handle cam to open the door.

(g) Make sure the maximum torque on the interior handle to open the door is 420 in-lb (47 N·m).

NOTE: In this step, the door is only opened to the cocked position.

1) If the maximum handle torque is more than 420 in-lb (47 N·m), do these steps:

a) Make sure the door is correcly installed.

b) Adjust the horizontal control rod. To adjust it, do this task: Forward Entry Door Adjustment, TASK 52-11-00-820-801.

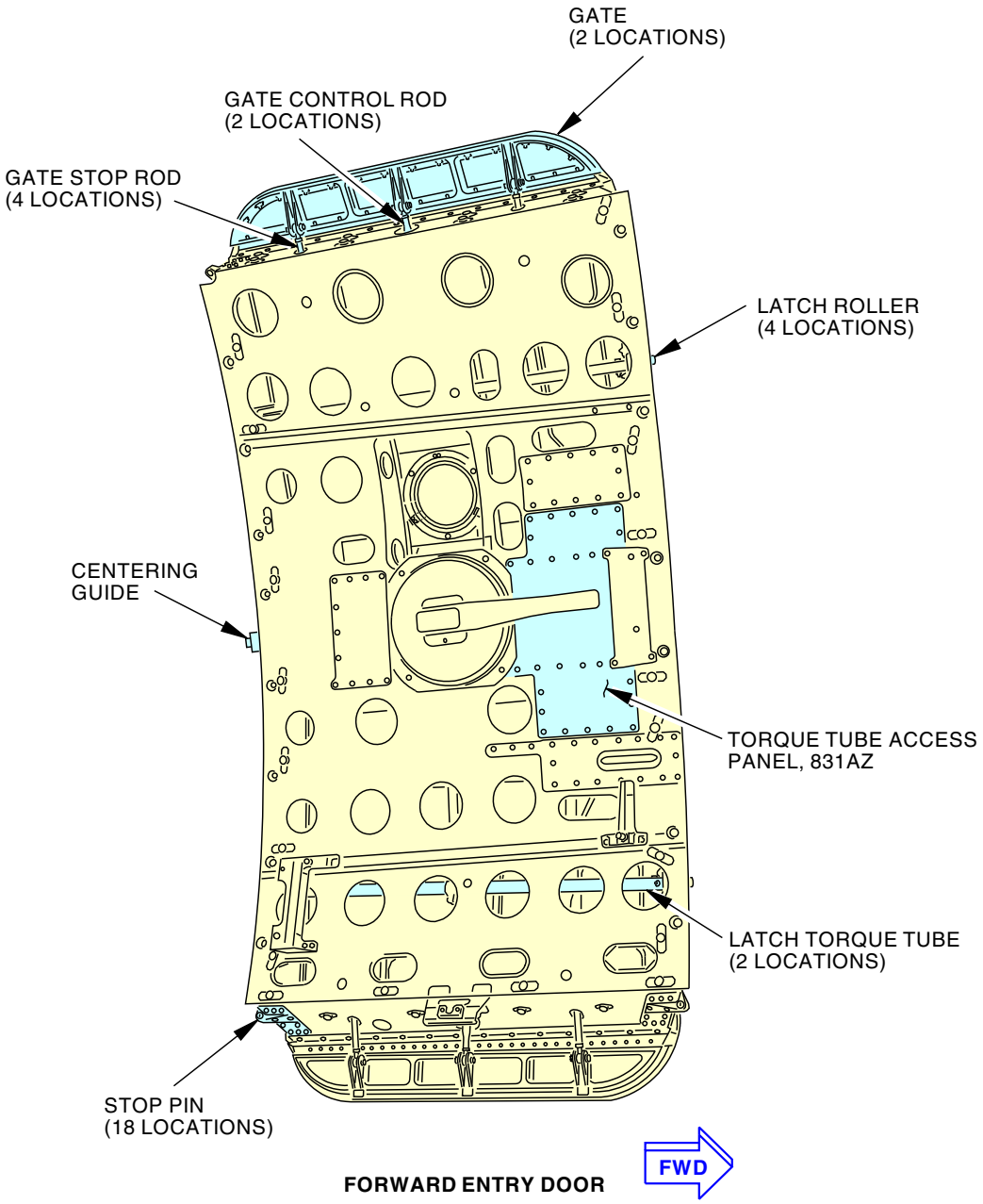
NOTE: Do the horizontal control rod adjustment only.

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(h) Remove the adapter, SPL-3898 from the internal door handle.

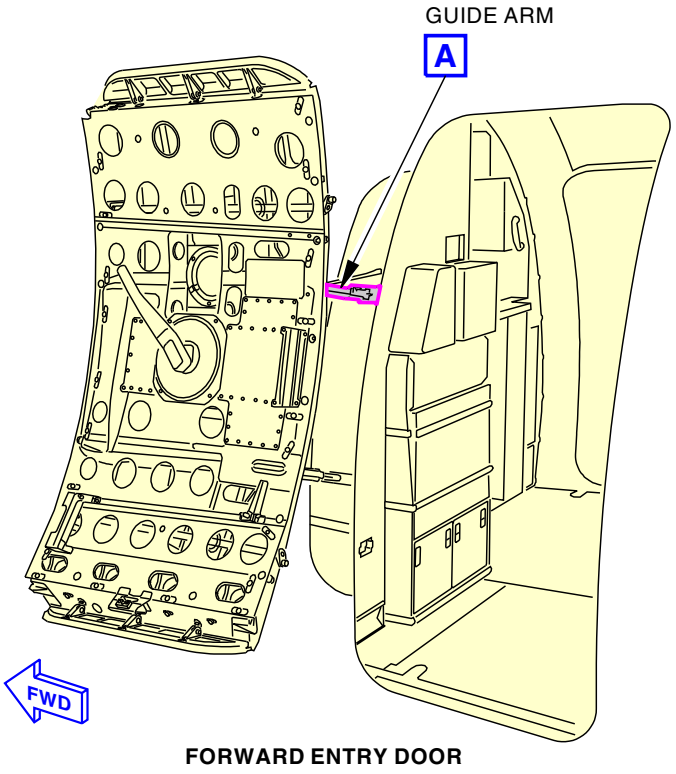
END OF TASK

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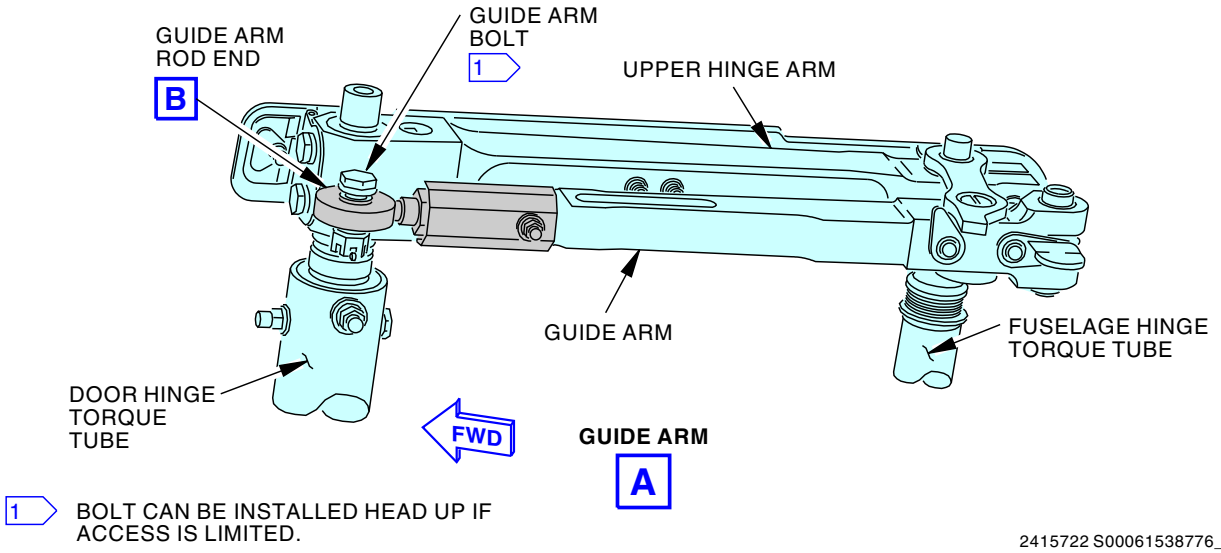


Forward Entry Door Adjustment
Figure 501/52-11-00-990-805

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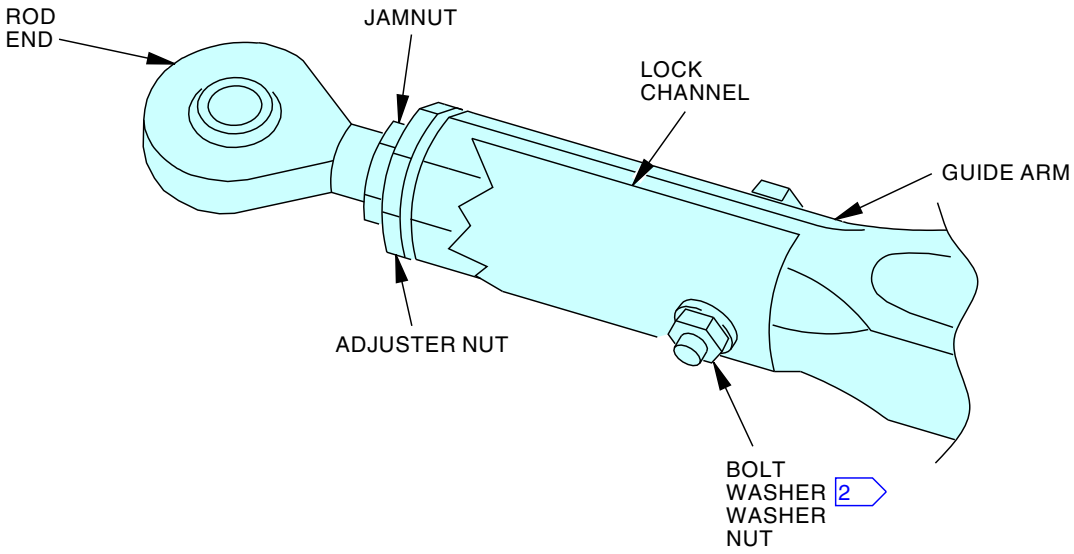
FORWARD ENTRY DOOR



2415722 S00061538776_V1

Guide Arm Adjustment
Figure 502/52-11-00-990-806 (Sheet 1 of 2)

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GUIDE ARM ROD END

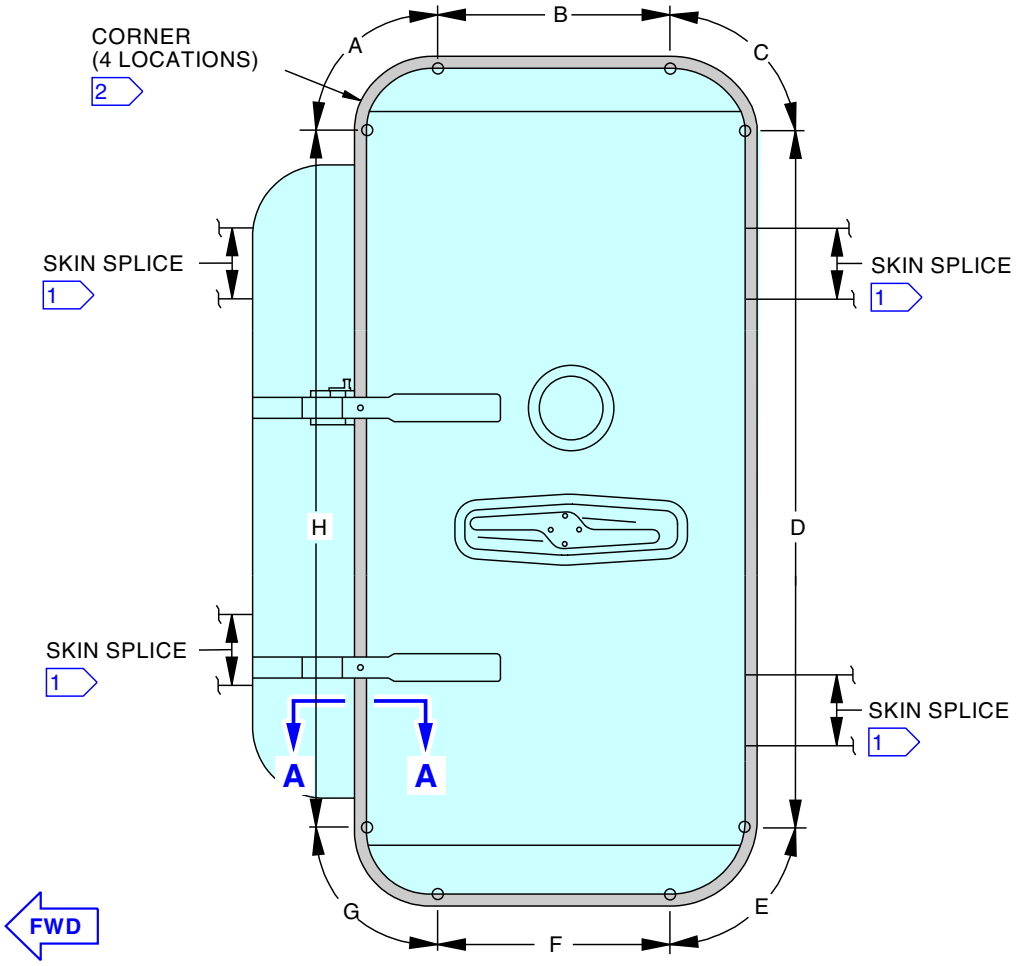
B

2 WASHER USED WITH HEX HEAD BOLT

2415723 S00061538777_V1

Guide Arm Adjustment
Figure 502/52-11-00-990-806 (Sheet 2 of 2)

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SKIN CLEARANCE AND FLUSHNESS ZONES OF THE FORWARD ENTRY DOOR (METHOD 1 OR METHOD 2)

NOTE:

DIMENSION STANDARD: NOMINAL
UPPER LIMIT
LOWER LIMIT

A NEGATIVE FLUSHNESS SHOWS THE DOOR IS INBOARD OF THE FUSELAGE CUTOUT. YOU CAN ADD ±0.03 INCH TO ANY MEASUREMENT PROVIDED THAT THE TOTAL LENGTH OF THE ADJUSTED MEASUREMENT DOES NOT EXCEED 5% OF THE DOOR PERIPHERY.

REFER TO THE METHOD 1 TABLE OR THE METHOD 2 TABLE FOR AEROSMOOTHNESS LIMITS.

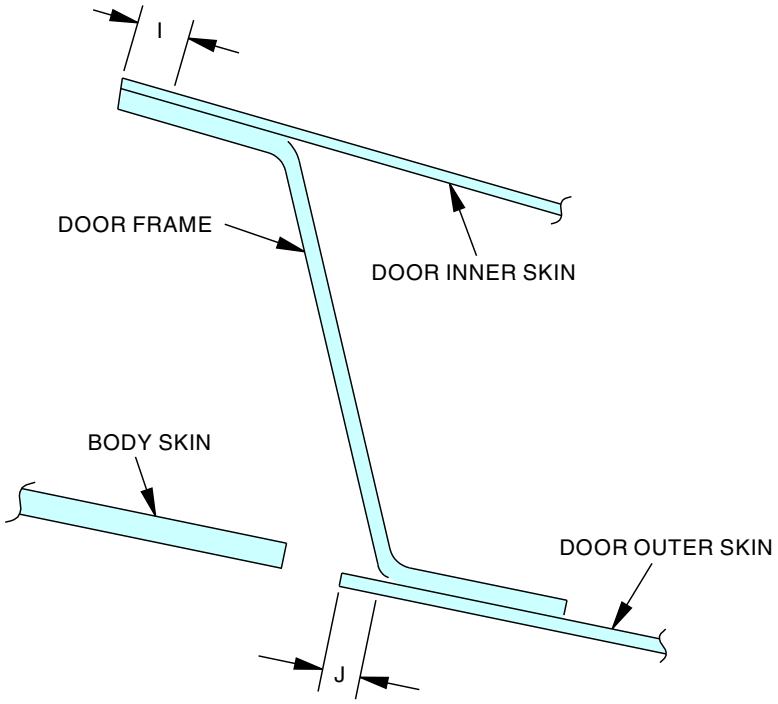
1 THE FLUSHNESS AT SKIN SPLICES WILL BE MORE THAN THE FLUSHNESS SHOWN BY THE ADDITIONAL SKIN AND BONDING THICKNESS.

2 FLUSHNESS IS NOT APPLICABLE AT CORNERS.

2415724 S00061538778_V1

Forward Entry Door Skin Clearance and Flushness
Figure 503/52-11-00-990-807 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



SKIN CLEARANCES

A-A

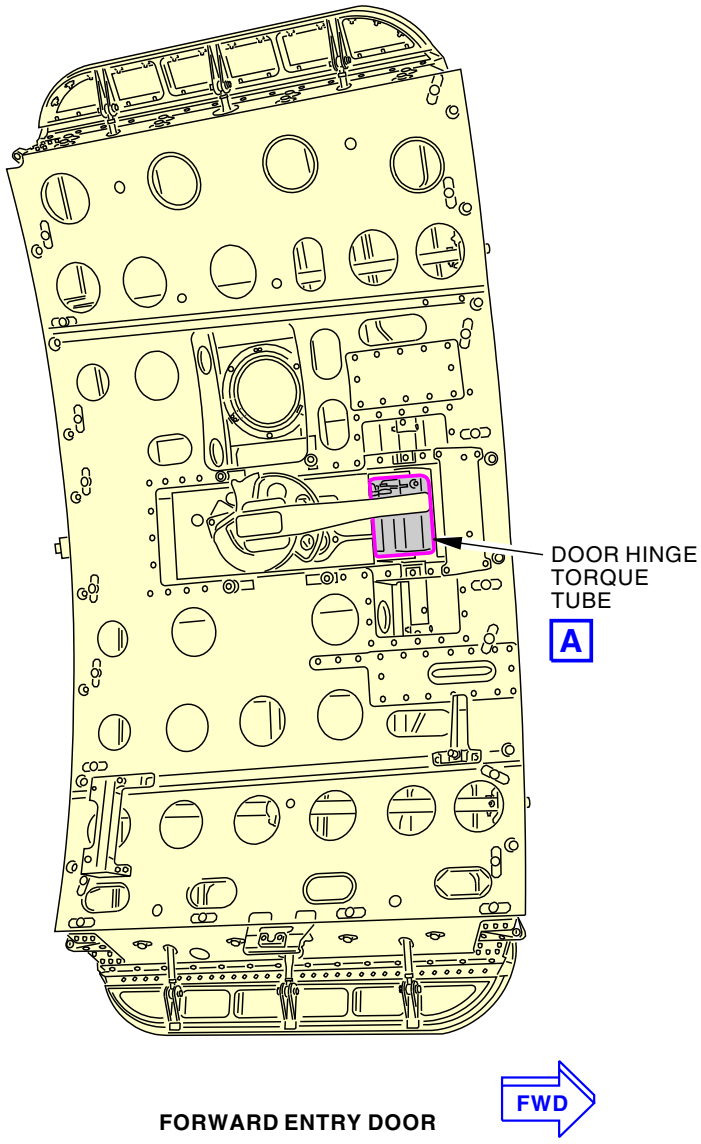
NOTE:

REFER TO THE METHOD 1 TABLE FOR AEROSMOOTHNESS LIMITS.

2415725 S00061538779_V1

Forward Entry Door Skin Clearance and Flushness
Figure 503/52-11-00-990-807 (Sheet 2 of 2)

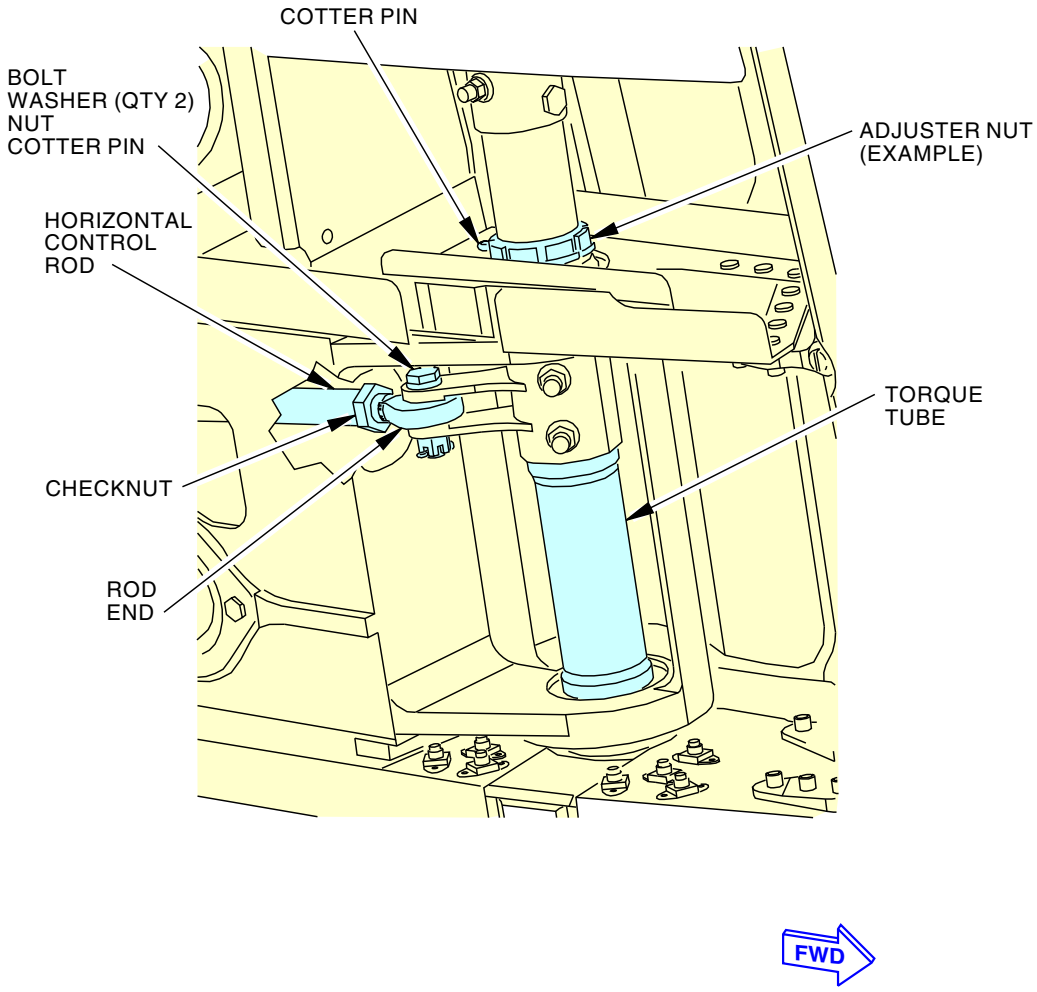
ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415726 S00061538780_V1

Door Hinge Torque Tube Adjustment
Figure 504/52-11-00-990-808 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



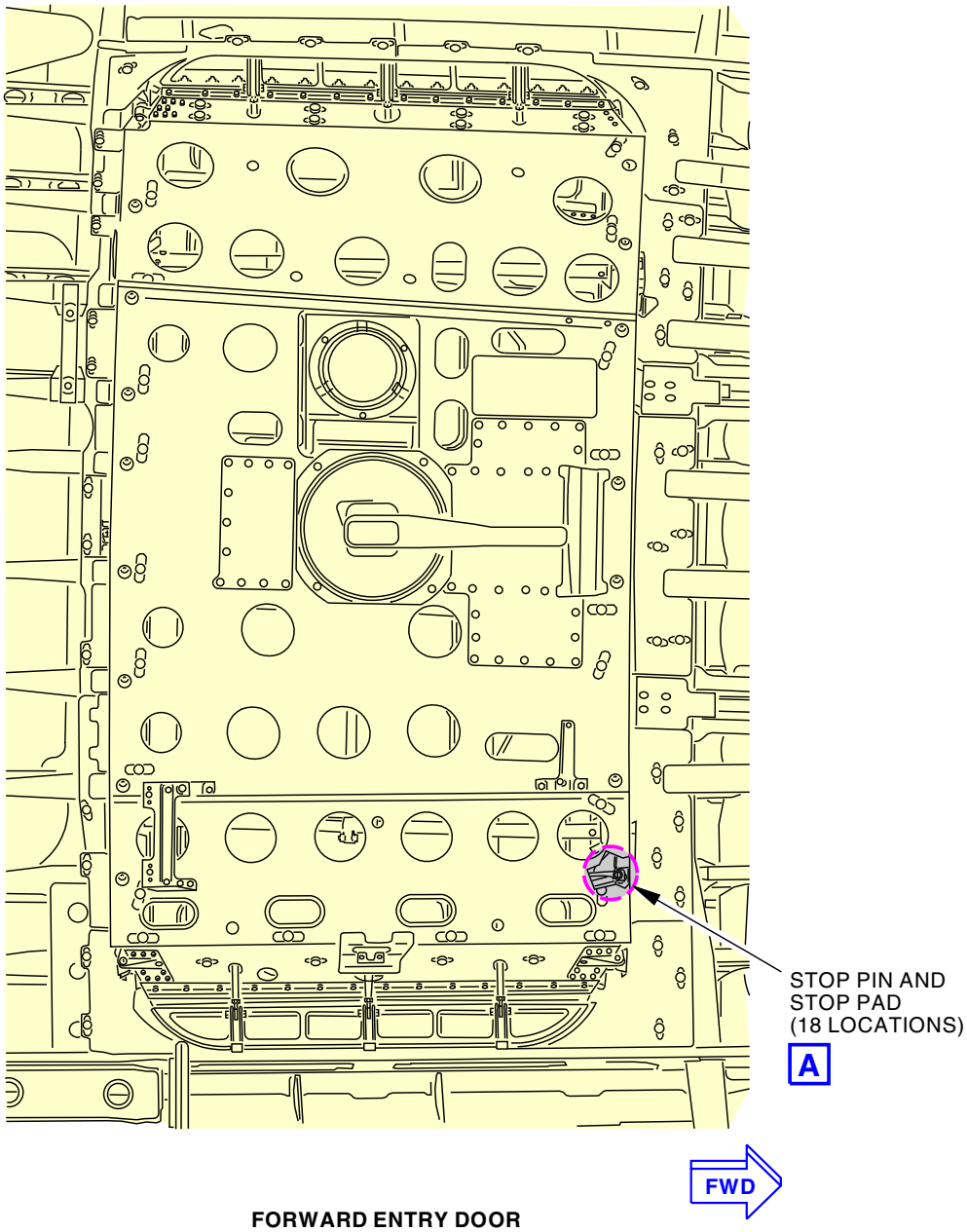
DOOR HINGE TORQUE TUBE

A

2415727 S00061538781_V1

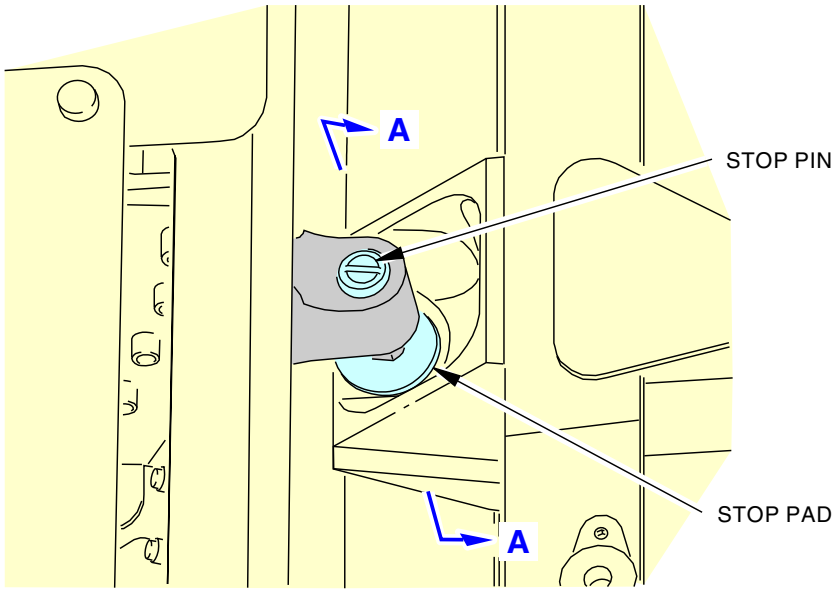
Door Hinge Torque Tube Adjustment
Figure 504/52-11-00-990-808 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

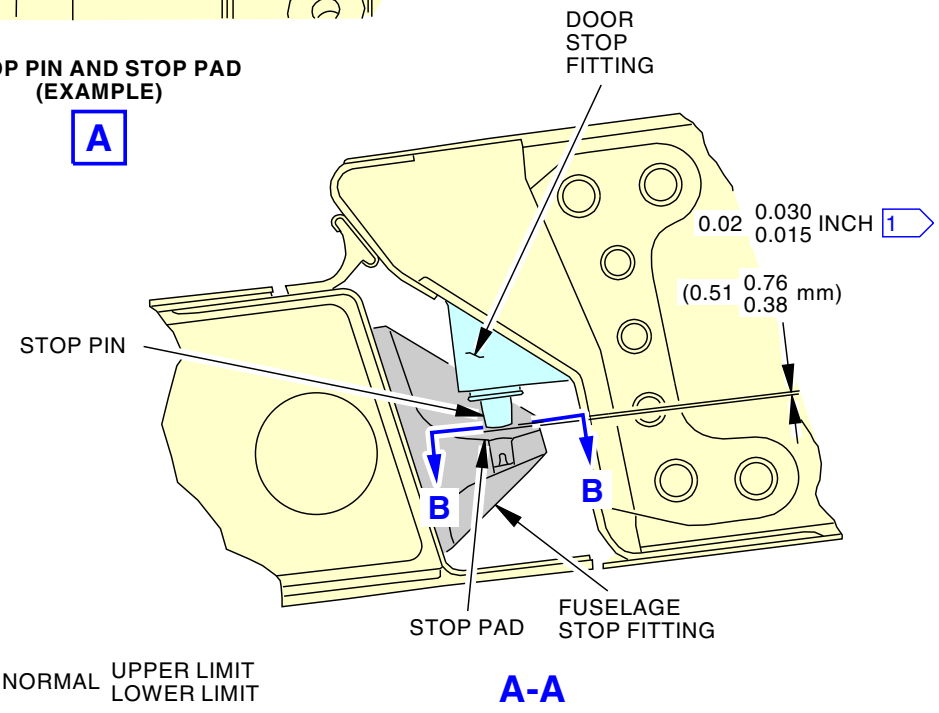


Stop Pin Adjustment
Figure 505/52-11-00-990-809 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



STOP PIN AND STOP PAD (EXAMPLE)



NOTE:

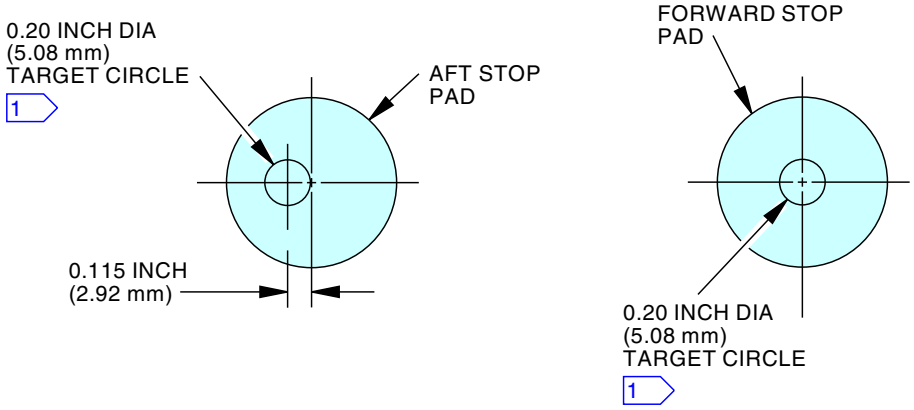
DIMENSION STANDARD: NORMAL UPPER LIMIT LOWER LIMIT

1 IF CLAY IS USED, A LOWER LIMIT OF 0.000 AND UPPER LIMIT OF 0.020 (0.51 mm) IS ALLOWED DUE TO THE OVER CENTERING MOTION OF THE LATCH RECEIVERS.

2415729 S00061538783_V1

Stop Pin Adjustment
Figure 505/52-11-00-990-809 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



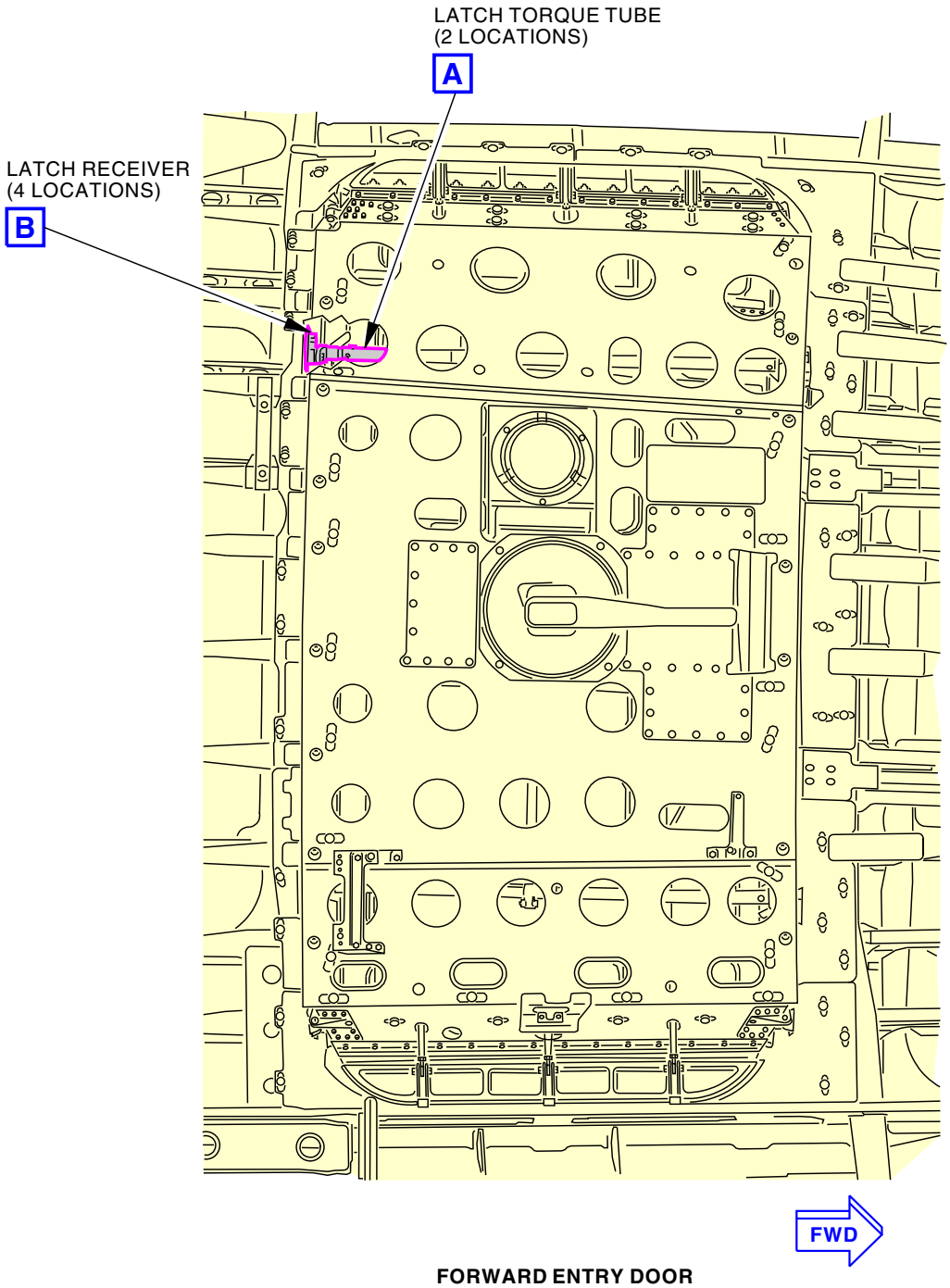
B-B

1 STOP PIN CENTER MUST TOUCH STOP PAD WITHIN THE TARGET CIRCLE SHOWN.

2415730 S00061538784_V1

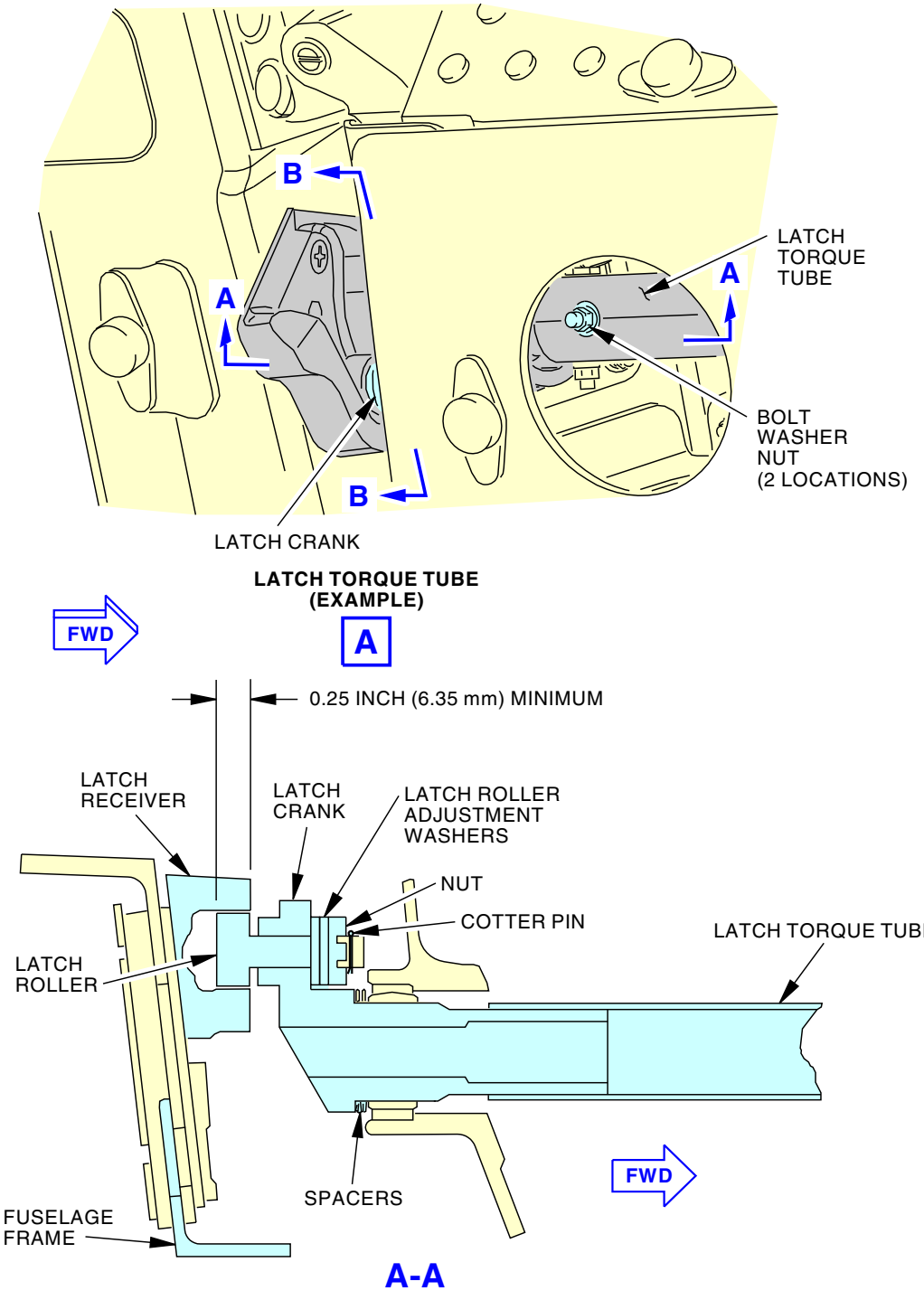
Stop Pin Adjustment
Figure 505/52-11-00-990-809 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



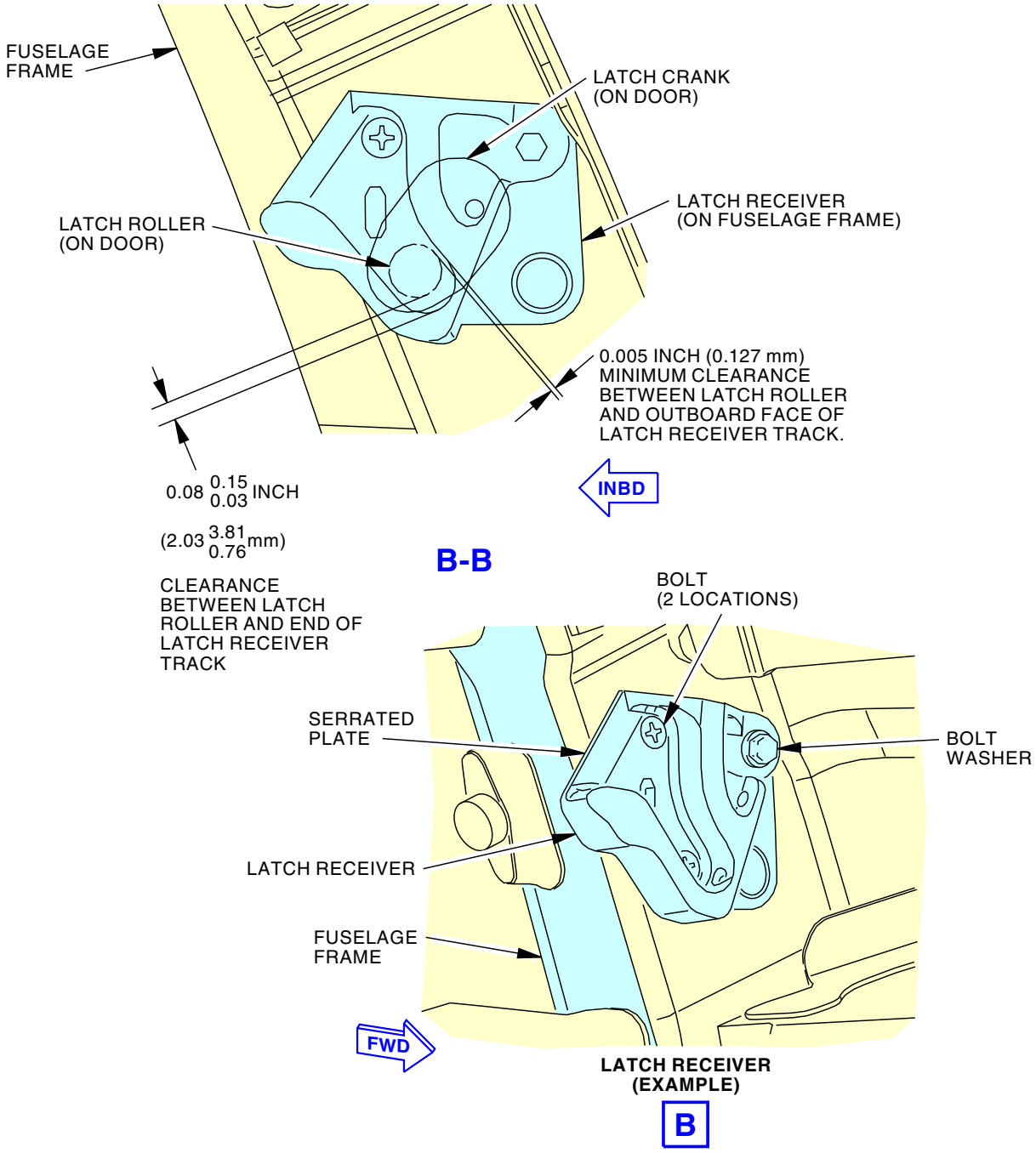
Latch Adjustment
Figure 506/52-11-00-990-810 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Latch Adjustment
Figure 506/52-11-00-990-810 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



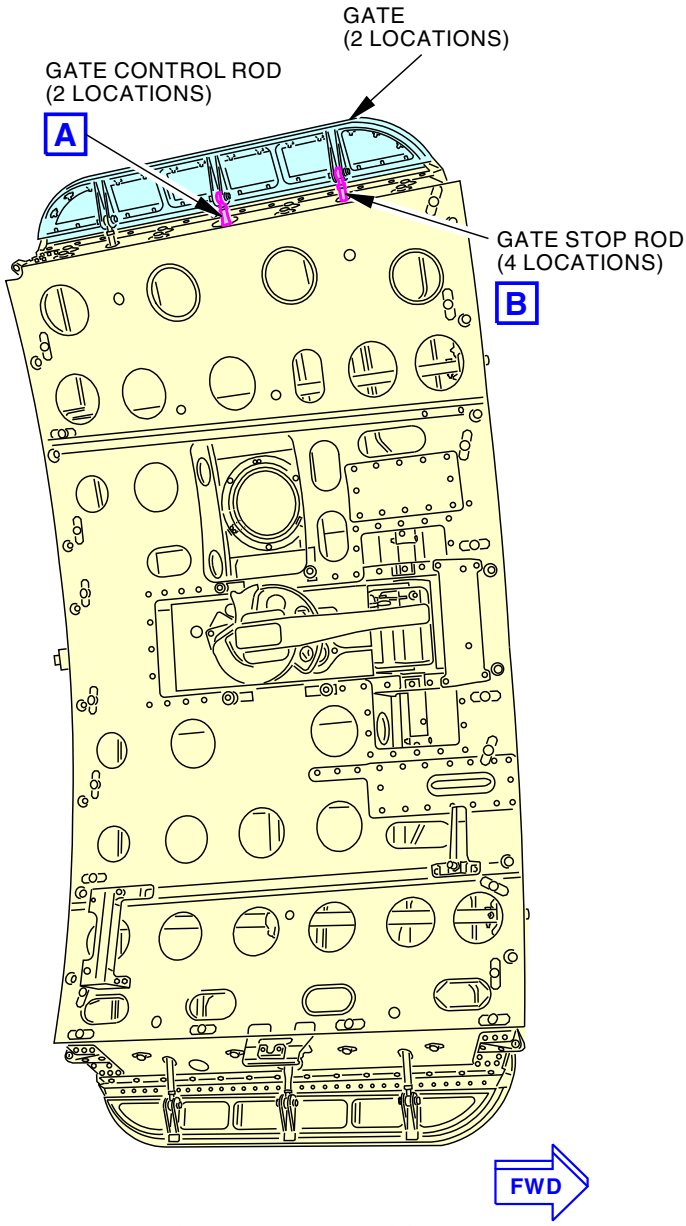
NOTE:

DIMENSION STANDARD: NOMINAL UPPER LIMIT LOWER LIMIT

2415733 S00061538787_V1

Latch Adjustment
Figure 506/52-11-00-990-810 (Sheet 3 of 3)

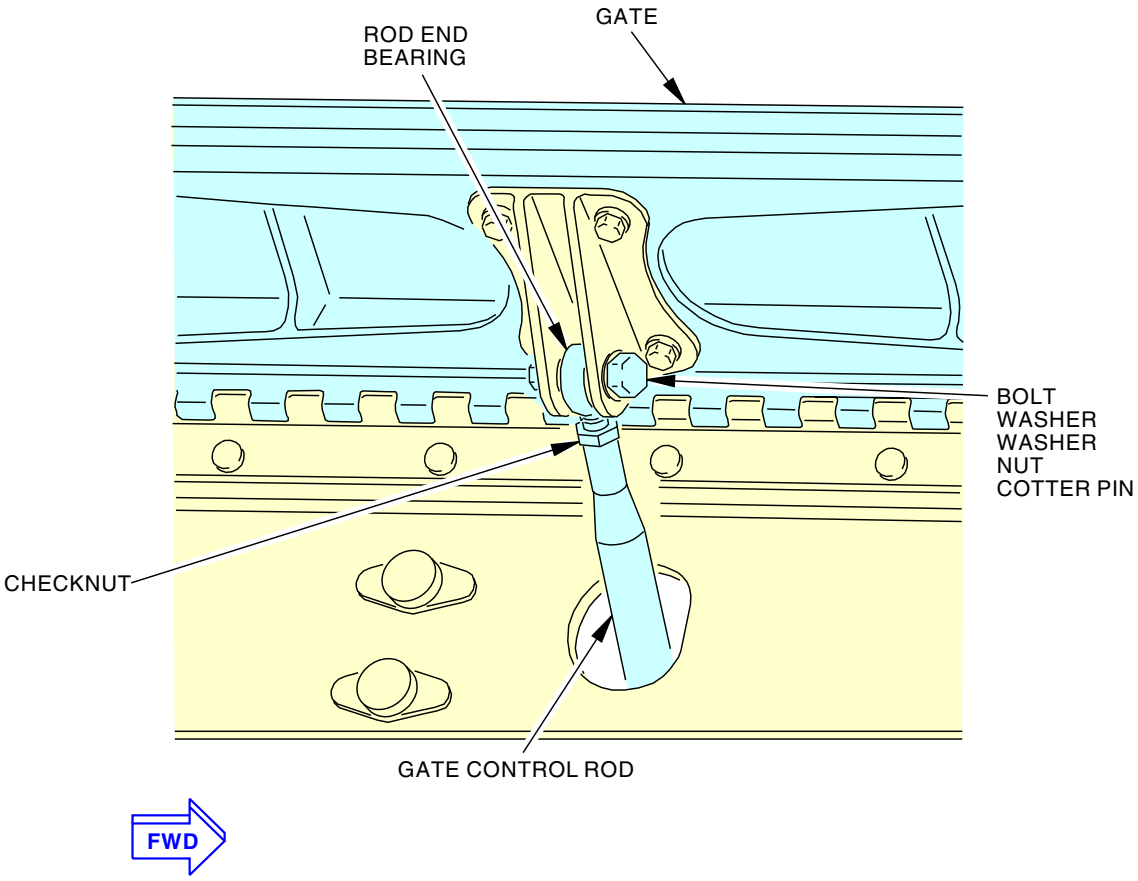
ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415734 S00061538788_V1

Gate Adjustment
Figure 507/52-11-00-990-811 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



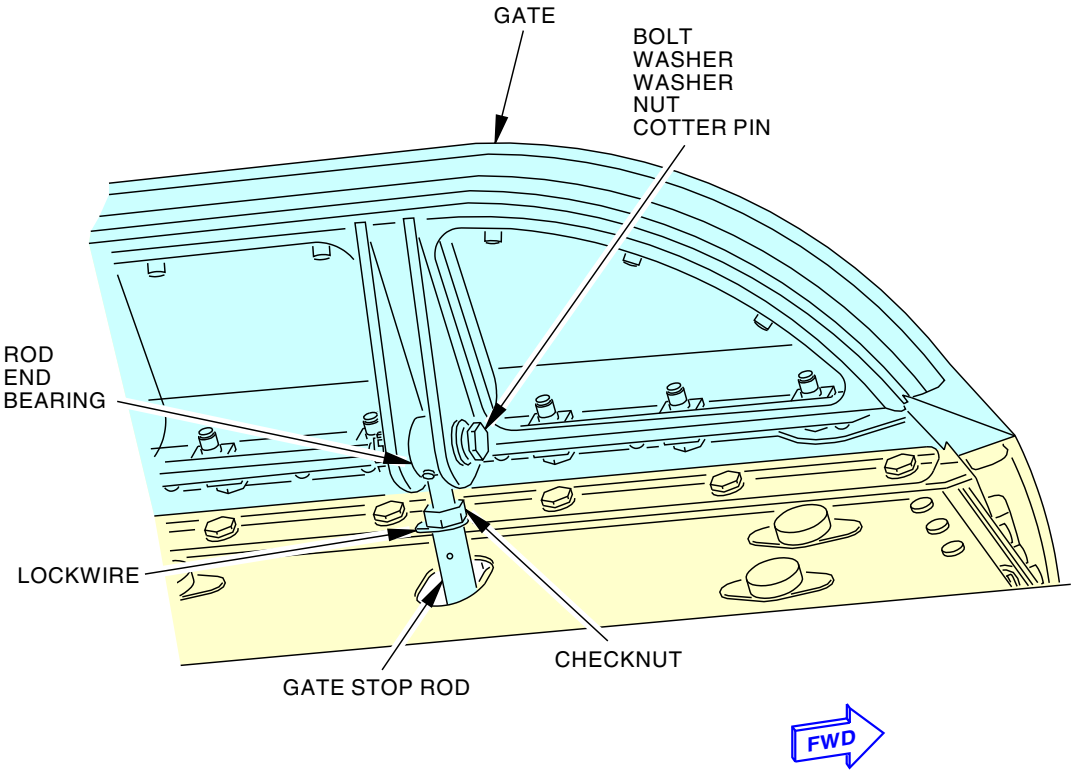
GATE CONTROL ROD (EXAMPLE)

A

2415735 S00061538789_V1

Gate Adjustment
Figure 507/52-11-00-990-811 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



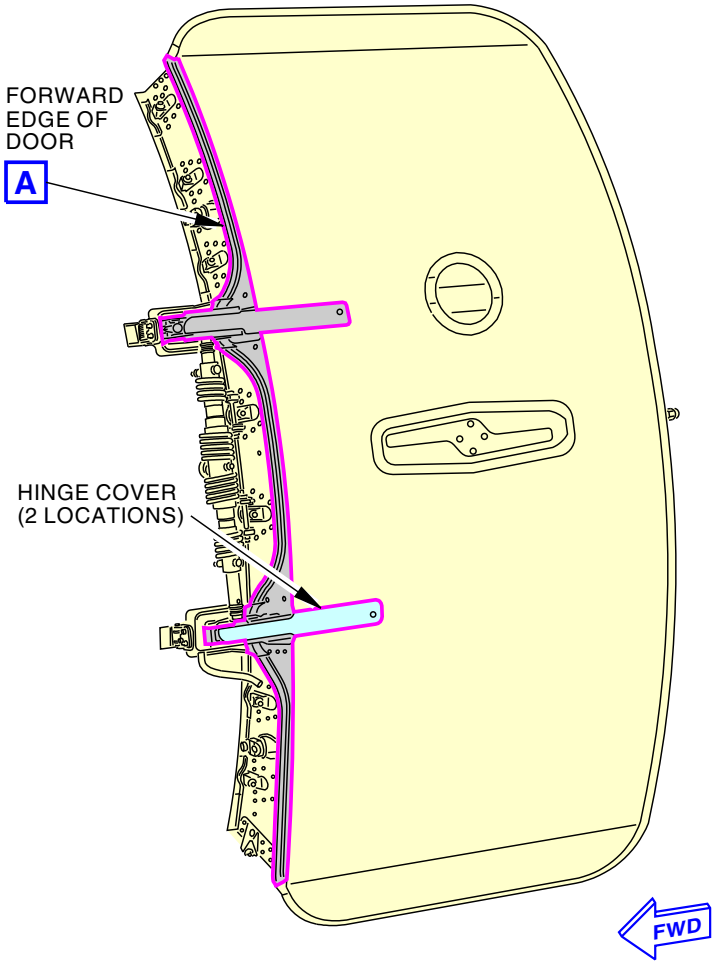
GATE STOP ROD
(EXAMPLE)

B

2415736 S00061538790_V1

Gate Adjustment
Figure 507/52-11-00-990-811 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

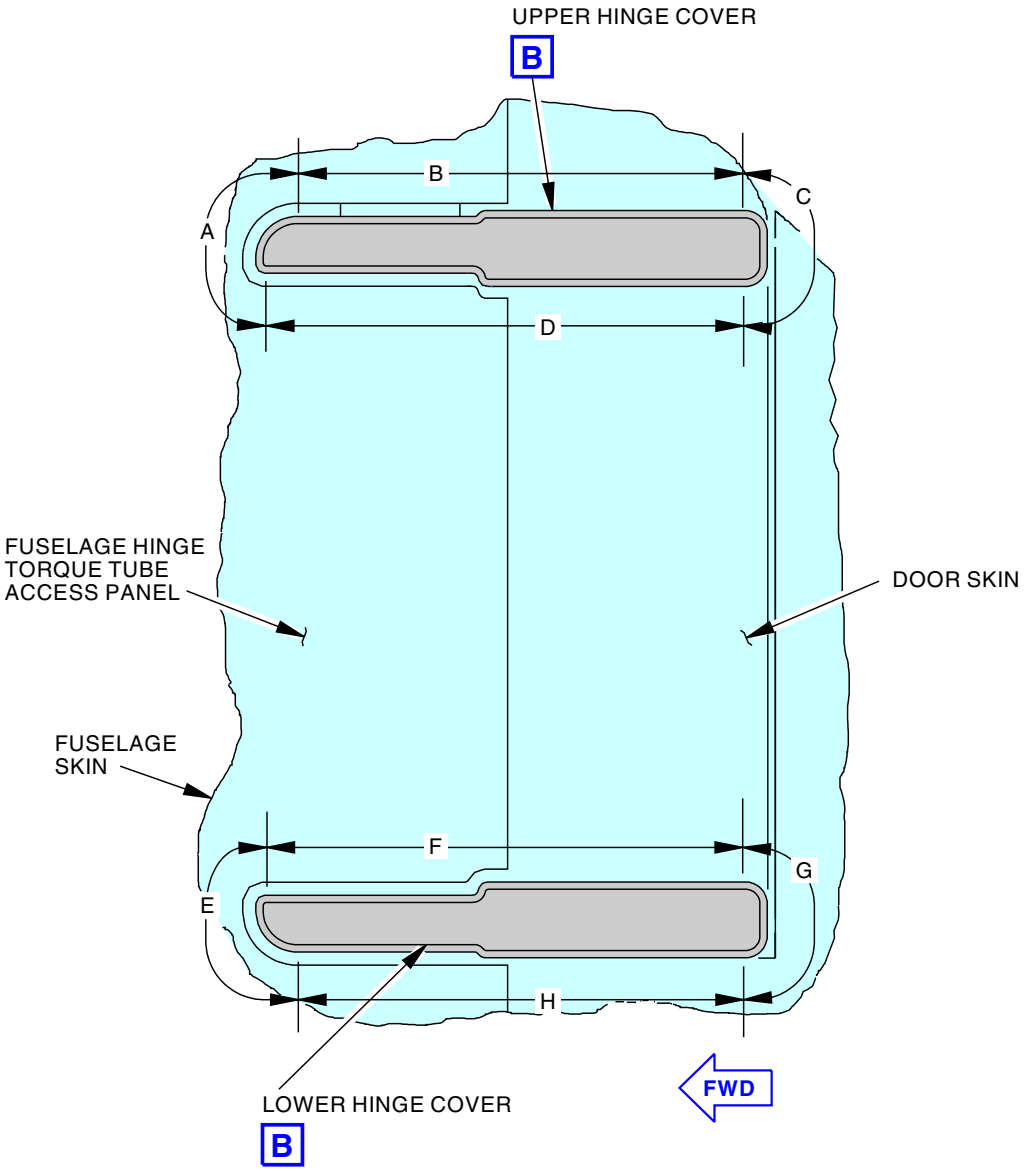


FORWARD ENTRY DOOR

2415737 S00061538791_V1

Hinge Cover Adjustment
Figure 508/52-11-00-990-812 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



FORWARD EDGE OF THE FORWARD ENTRY DOOR

A

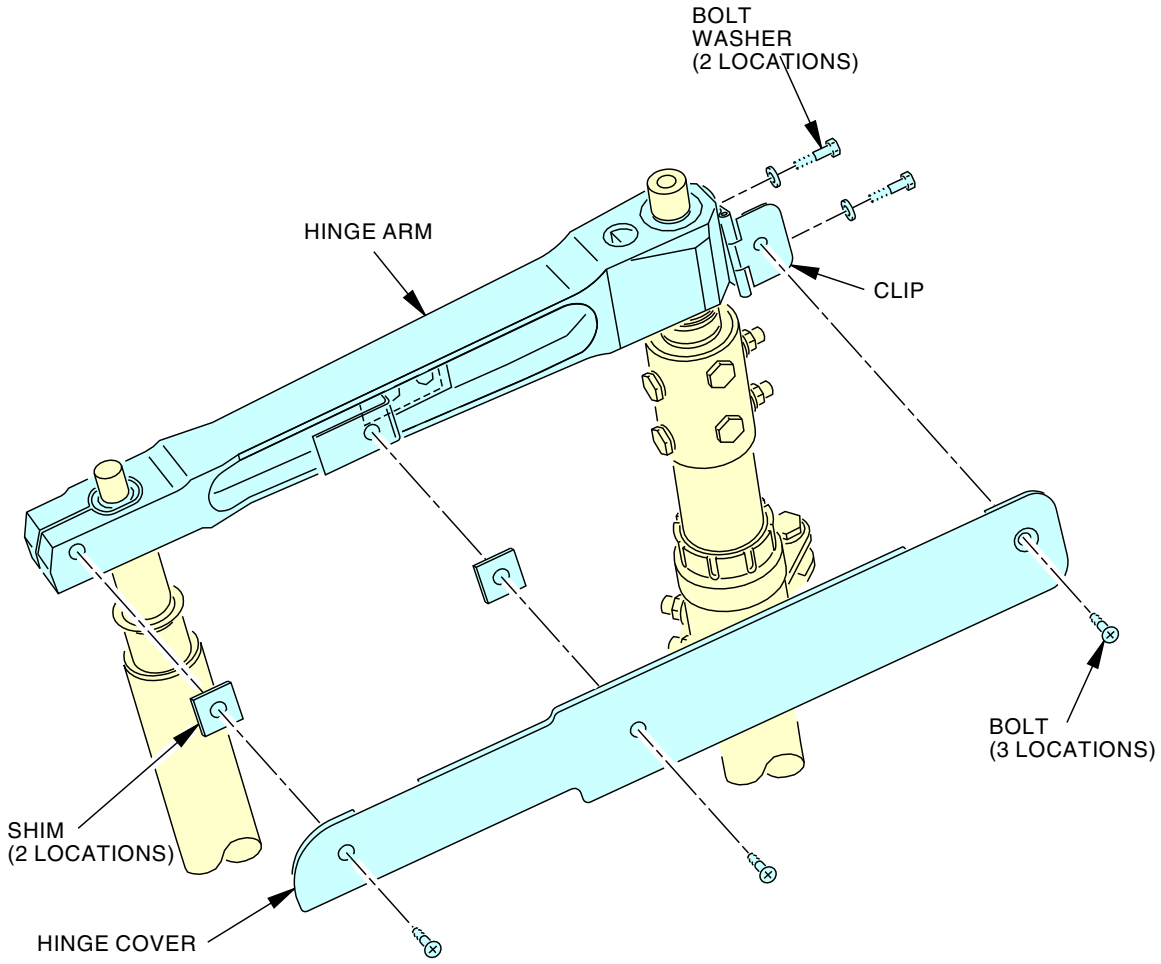
NOTE:

REFER TO AERO-SMOOTHNESS LIMITS TABLE FOR THE HINGE COVER OF THE FORWARD ENTRY DOOR.

2415738 S00061538792_V1

Hinge Cover Adjustment
Figure 508/52-11-00-990-812 (Sheet 2 of 3)

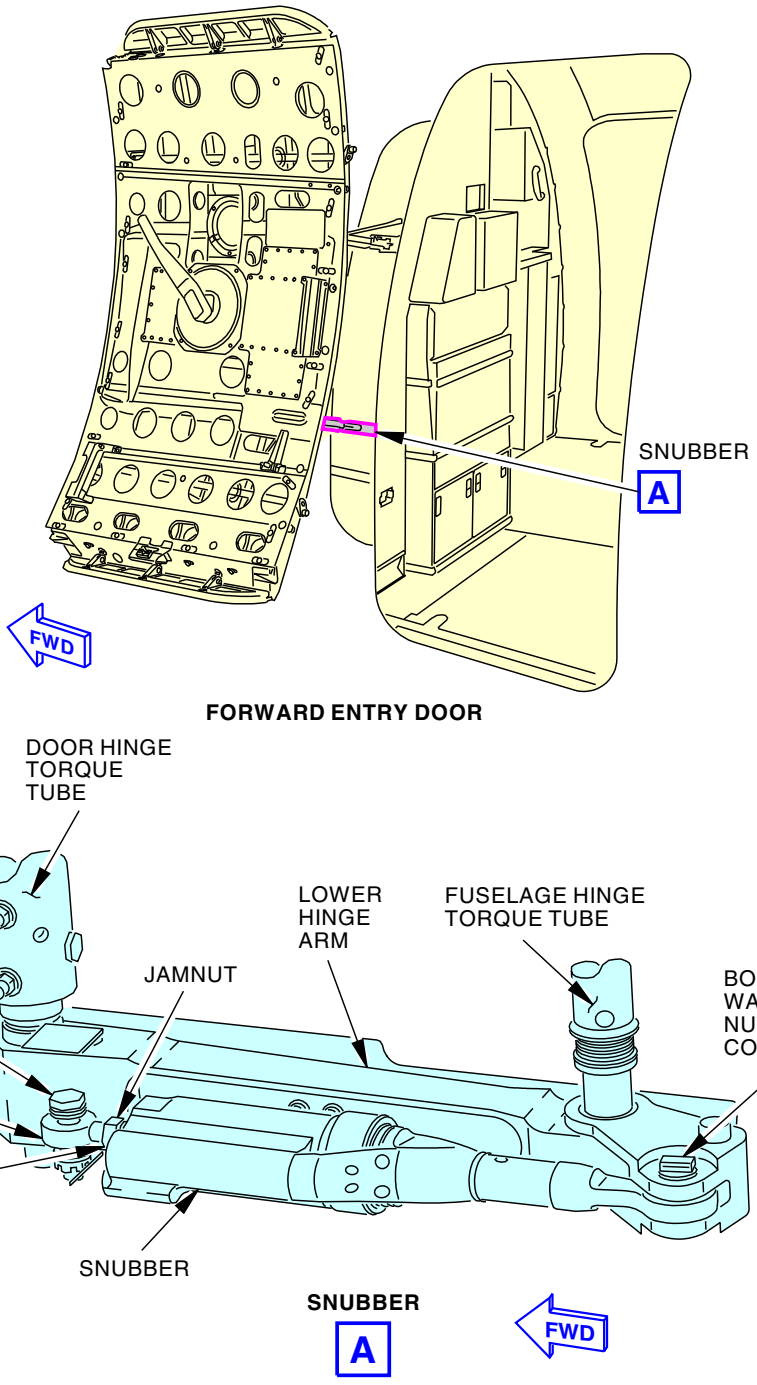
ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415739 S00061538793_V1

Hinge Cover Adjustment
Figure 508/52-11-00-990-812 (Sheet 3 of 3)

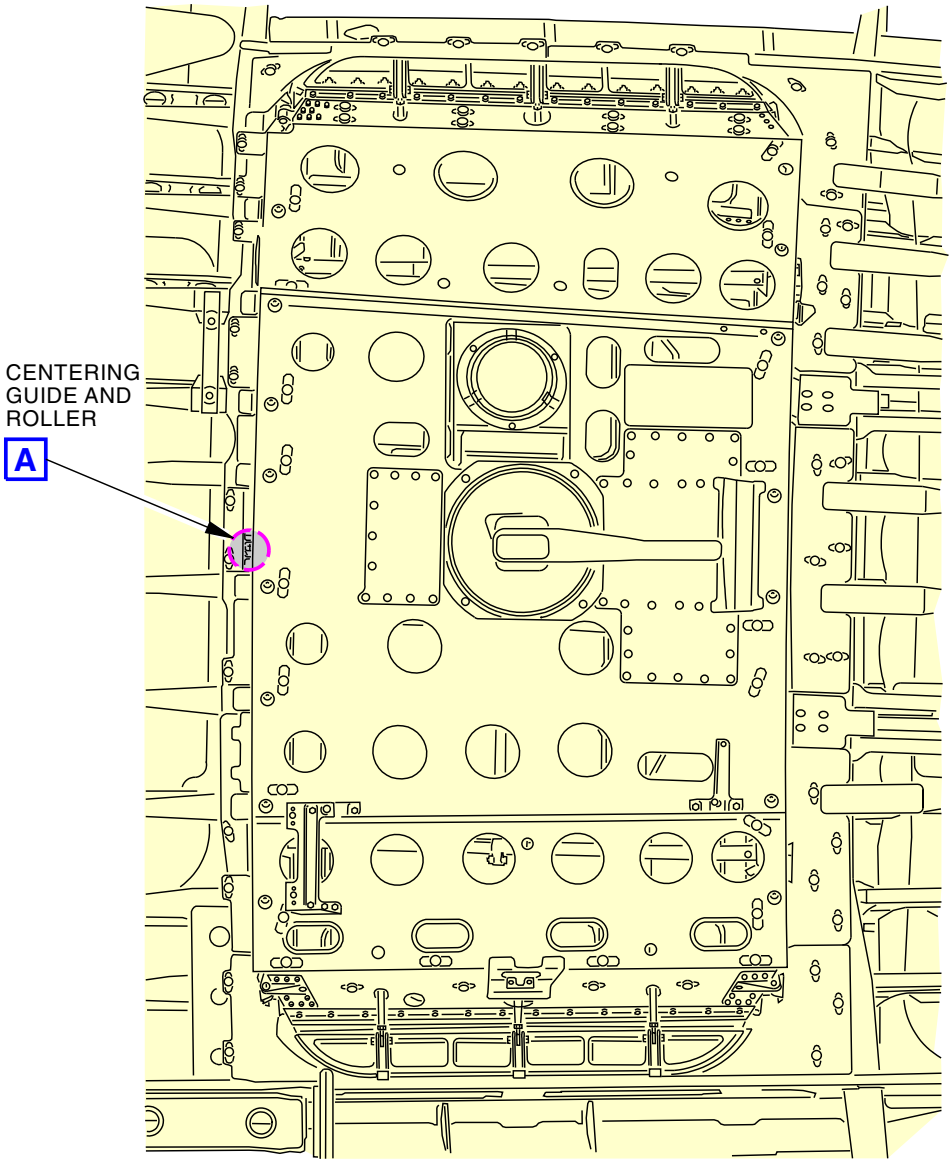
ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415740 S00061538794_V1

Snubber Adjustment
Figure 509/52-11-00-990-813

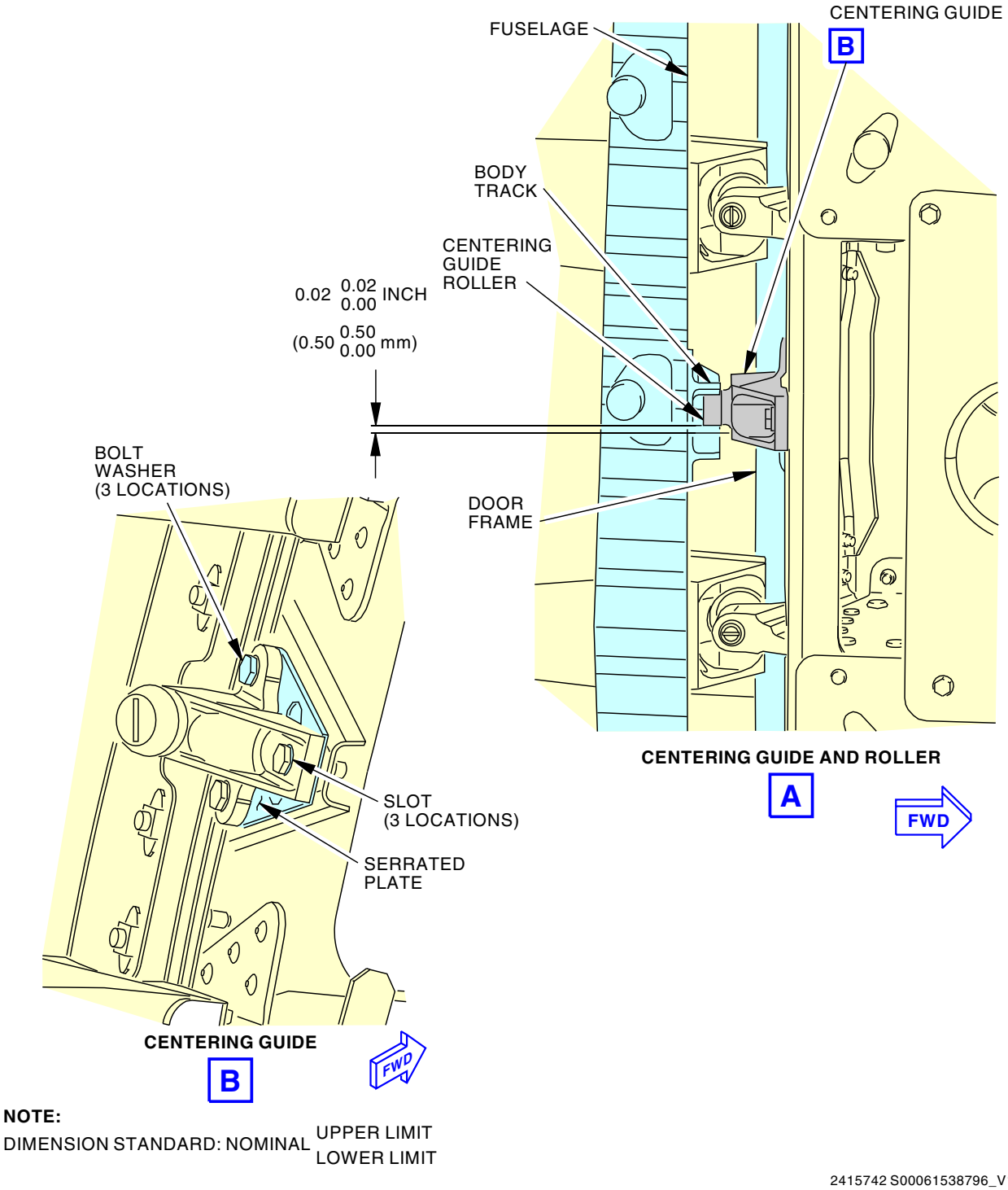
ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415741 S00061538795_V1

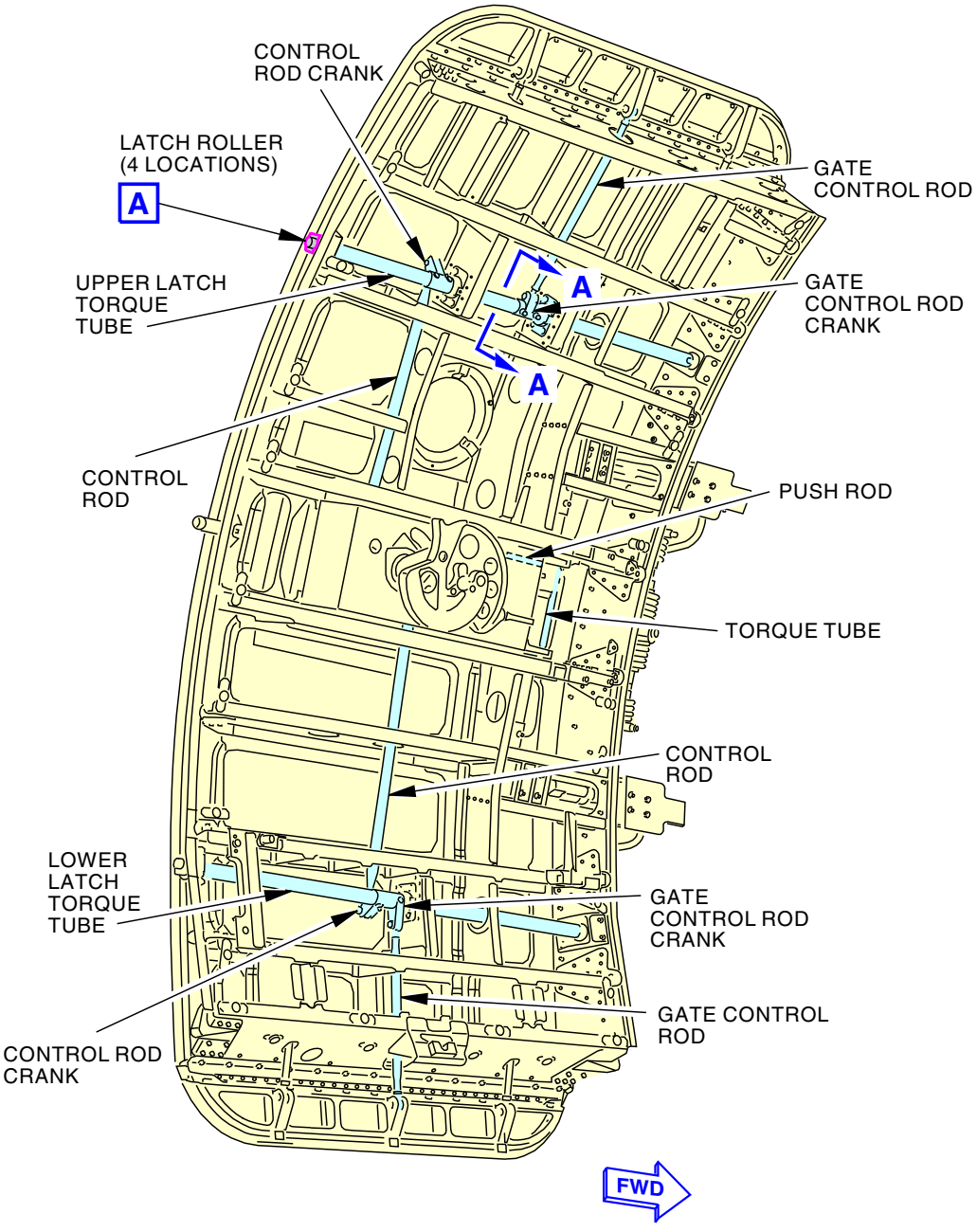
Centering Guide Adjustment
Figure 510/52-11-00-990-814 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Centering Guide Adjustment
Figure 510/52-11-00-990-814 (Sheet 2 of 2)

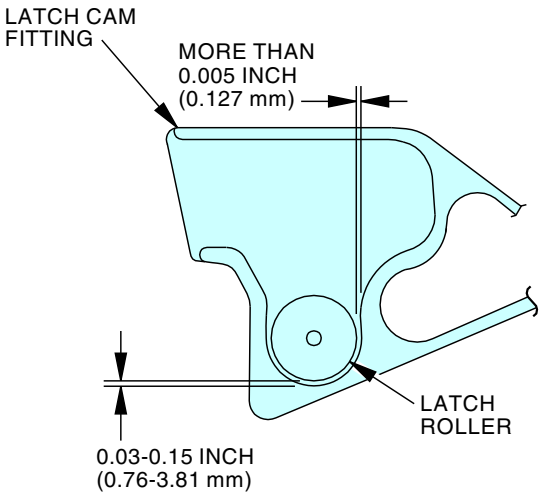
ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415743 S00061538797_V1

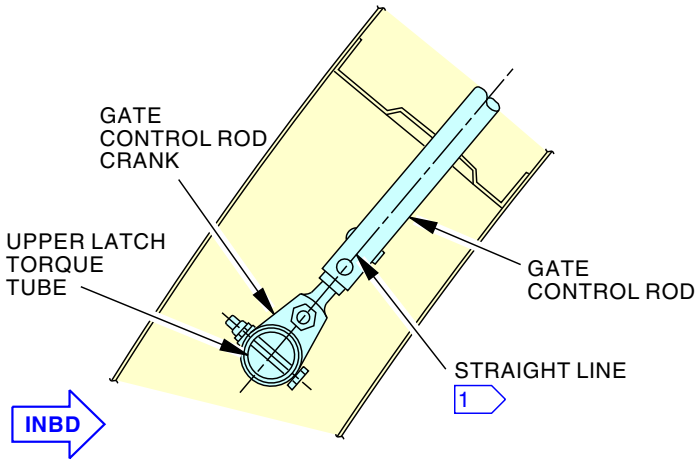
Forward Entry Door Mechanism
Figure 511/52-11-00-990-815 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



ROLLER CLEARANCE

A



**STRAIGHT LINE RELATIONSHIP
(EXAMPLE)**

A-A

1 YOU CAN USE A LOCALLY MADE TOOL TO GET THIS STRAIGHT LINE RELATIONSHIP.

2415744 S00061538798_V1

**Forward Entry Door Mechanism
Figure 511/52-11-00-990-815 (Sheet 2 of 2)**

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FORWARD ENTRY DOOR - INSPECTION/CHECK

1. General

A. This procedure has these tasks:

(1) A check of the forward entry door

(2) A check of the forward entry door centering guide

(3) A check of the forward entry door pressure seal

(4) A check of the forward entry door flapper seal

(5) A vacuum tool leak check of the forward entry door seal.

TASK 52-11-00-200-801

2. Forward Entry Door Check

A. References

Reference	Title
52-11-00 P/B 201	FORWARD ENTRY DOOR - MAINTENANCE PRACTICES
52-11-31-000-801	Forward Entry Door Lining Removal (P/B 401)
52-11-31-400-801	Forward Entry Door Lining 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Location Zones

Zone	Area
831	Forward Entry Door

D. Access Panels

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access
831BZ	Forward Entry Door - Handle Box and Cam for Handle Box Access
831CZ	Forward Entry Door - Handle Box Access
831DZ	Forward Entry Door - Gate Hinge Pin Access
831EZ	Forward Entry Door - Gate Hinge Pin Access

E. Prepare for the Inspection

SUBTASK 52-11-00-860-031

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched (PAGEBLOCK 52-11-00/201).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WARNING MAKE SURE THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure that a work platform, COM-1523, is installed outboard of the door.

SUBTASK 52-11-00-010-007

(2) Do this task: Forward Entry Door Lining Removal, TASK 52-11-31-000-801.

SUBTASK 52-11-00-010-008

(3) Remove the access panels as necessary to get access to the door components:

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access
831BZ	Forward Entry Door - Handle Box and Cam for Handle Box Access
831CZ	Forward Entry Door - Handle Box Access
831DZ	Forward Entry Door - Gate Hinge Pin Access
831EZ	Forward Entry Door - Gate Hinge Pin Access

SUBTASK 52-11-00-010-009

(4) Open and close the door as necessary to inspect the door components (PAGEBLOCK 52-11-00/201).

F. Forward Entry Door Inspection

SUBTASK 52-11-00-210-001

(1) Do a visual inspection of the external door structure and handle as follows:

(a) Examine the external skin.

1) Look for cracks and corrosion.

2) Look for burrs.

3) Look for loose and missing fasteners.

(b) Examine the window.

1) Look for cracks.

2) Look for crazing.

(c) Examine the window frame.

1) Look for cracks and corrosion.

(d) Examine the external handle.

1) Look for cracks and corrosion.

2) Look for too much wear.

(e) Examine the handle pan.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

SUBTASK 52-11-00-210-002

(2) Do a visual inspection of the door internal structure and handle mechanism as follows:

(a) Examine the internal skin.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1) Look for cracks and corrosion.
2) Look for burrs.
3) Look for loose and missing fasteners.

(b) Examine the internal frames and brackets.
1) Look for cracks and corrosion.
2) Look for loose and missing fasteners.

(c) Examine the drain holes.
1) Look for blockage.

(d) Examine the handle box.
1) Look for cracks and corrosion.
2) Look for too much wear.

(e) Examine the handle housing.
1) Look for cracks and corrosion.
2) Look for too much wear.

(f) Examine the internal handle.
1) Look for cracks and corrosion.
2) Look for too much wear.

SUBTASK 52-11-00-210-003

(3) Do a visual inspection of the latch mechanism as follows:

(a) Examine the latch control rods.
1) Look for cracks and corrosion.
2) Look for too much wear.

(b) Examine the latch torque tubes.
1) Look for cracks and corrosion.
2) Look for too much wear.

(c) Examine the latch cranks and latch rollers.
1) Look for cracks and corrosion.
2) Look for too much wear.
3) Look for unwanted particles on the latch rollers.

(d) Examine the gate control rods.
1) Look for cracks and corrosion.
2) Look for too much wear.

(e) Examine the gate stop rods.
1) Look for cracks and corrosion.
2) Look for too much wear.

SUBTASK 52-11-00-210-004

(4) Do a visual inspection of the door stop fittings and stop pins as follows:

(a) Examine the door stop fittings.
1) Look for cracks and corrosion.

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(b) Examine the stop pins.

1) Look for cracks and corrosion.

2) Look for unwanted particles on the stop pins.

3) Make sure the retaining springs are installed.

SUBTASK 52-11-00-210-005

(5) Do a visual inspection of the attach structure and hinge mechanism as follows:

(a) Examine the fuselage hinge torque tube.

1) Look for cracks and corrosion.

2) Look for too much wear.

(b) Examine the hinge arms.

1) Look for cracks and corrosion.

2) Look for too much wear.

(c) Examine the hinge arm fasteners.

1) Make sure that the bolts fully engage the nuts.

2) Make sure that the bolt threads are not damaged.

(d) Examine the hinge pins.

1) Look for cracks and corrosion.

2) Look for too much wear.

(e) Examine the door hinge torque tube.

1) Look for cracks and corrosion.

2) Look for too much wear.

NOTE: The nuts and bolts that connect the sleeves to the torque tube may appear loose, because they are not tightened to a clamp up pressure. A small gap between the washer and the sleeve is acceptable.

(f) Examine the guide arm and roller.

1) Look for cracks and corrosion.

2) Look for too much wear.

(g) Examine the guide plates.

1) Look for cracks and corrosion.

2) Look for too much wear.

(h) Examine the guide plate drain holes.

1) Look for blockage.

(i) Examine the snubber.

1) Look for leakage.

2) Look for too much wear.

SUBTASK 52-11-00-210-006

(6) Do a visual inspection of the structure around the door opening as follows:

(a) Examine the fuselage stop fittings and stop pads.

1) Look for cracks and corrosion.

2) Look for unwanted particles on the stop fittings.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) Examine the latch receivers.

1) Look for cracks and corrosion.

2) Look for too much wear.

3) Look for unwanted particles in the latch receivers.

(c) Examine the fuselage frame.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 52-11-00-410-006

(1) Install these access panels as necessary:

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access
831BZ	Forward Entry Door - Handle Box and Cam for Handle Box Access
831CZ	Forward Entry Door - Handle Box Access
831DZ	Forward Entry Door - Gate Hinge Pin Access
831EZ	Forward Entry Door - Gate Hinge Pin Access

SUBTASK 52-11-00-210-007

(2) Do this task: Forward Entry Door Lining Installation, TASK 52-11-31-400-801.

SUBTASK 52-11-00-860-032

(3) Close and latch the door (PAGEBLOCK 52-11-00/201).

SUBTASK 52-11-00-940-004

(4) Remove the work platform, COM-1523.

——— END OF TASK ———

TASK 52-11-00-200-802

3. Forward Entry Door Centering Guide Check

(Figure 601)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
52-11-00 P/B 201	FORWARD ENTRY 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Location Zones

Zone	Area
831	Forward Entry Door

ECCN 9E991 BOEING PROPRIETARY - See title page for details

D. Prepare for the Inspection

SUBTASK 52-11-00-860-033

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched (PAGEBLOCK 52-11-00/201).

WARNING MAKE SURE THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure that a work platform, COM-1523, is installed outboard of the door.

SUBTASK 52-11-00-010-010

(2) Open the door (PAGEBLOCK 52-11-00/201).

E. Forward Entry Door Centering Guide Inspection

SUBTASK 52-11-00-210-008

(1) Do a visual inspection of the centering guide (Figure 601):

(a) Examine the guide track.

1) Look for cracks and corrosion.

2) Make sure that the nylon track pads are not worn.

3) Look for loose and missing fasteners.

(b) Examine the guide ball.

1) Make sure that the guide ball is round and symmetrical.

2) Make sure that the ball is not loose.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 52-11-00-860-034

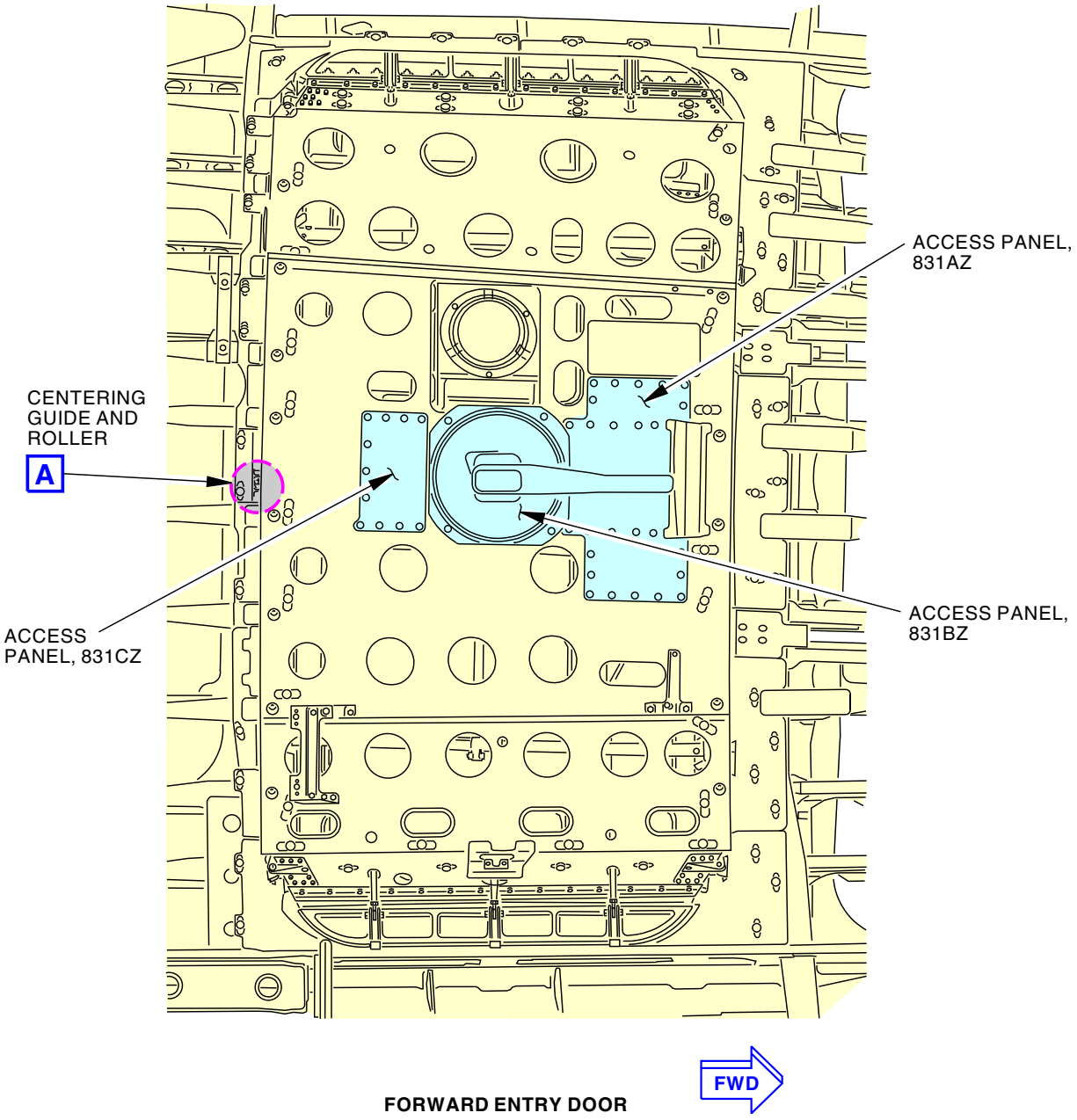
(1) Close and latch the door (PAGEBLOCK 52-11-00/201).

SUBTASK 52-11-00-940-005

(2) Remove the work platform, COM-1523.

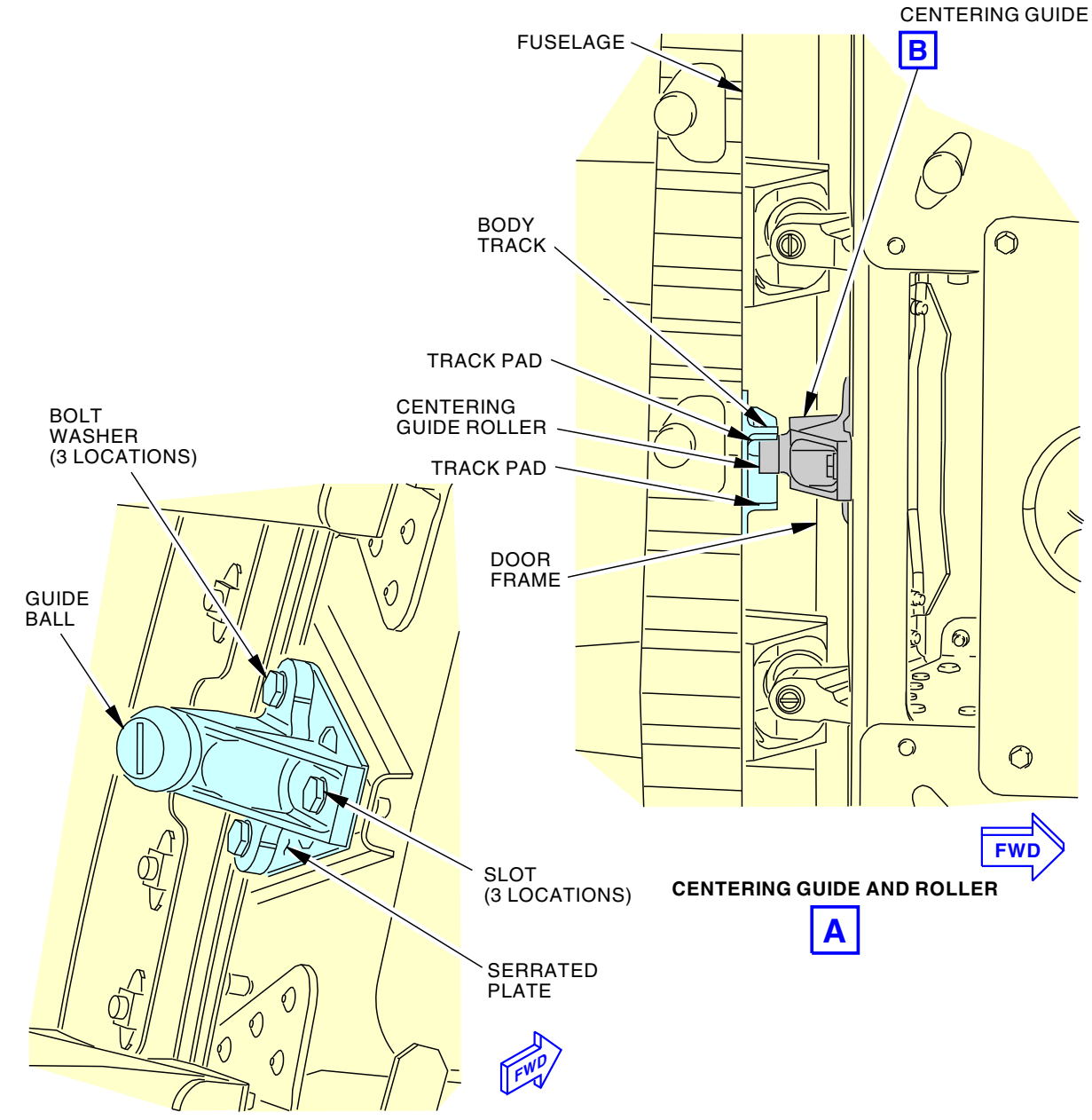
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Guide Ball Inspection/Check
Figure 601/52-11-00-990-816 (Sheet 1 of 2)

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NOTE:

DIMENSION STANDARD: NOMINAL UPPER LIMIT LOWER LIMIT

2415746 S00061538803_V1

Guide Ball Inspection/Check
Figure 601/52-11-00-990-816 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-11-00-200-803

4. Forward Entry Door Pressure Seal Check

(Figure 602)

A. References

Reference	Title
52-11-00 P/B 201	FORWARD ENTRY 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Location Zones

Zone	Area
831	Forward Entry Door

D. Prepare for the Inspection

SUBTASK 52-11-00-860-035

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched (PAGEBLOCK 52-11-00/201).

WARNING MAKE SURE THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure that a work platform, COM-1523, is installed outboard of the door.

SUBTASK 52-11-00-010-011

(2) Open the door (PAGEBLOCK 52-11-00/201).

E. Forward Entry Door Pressure Seal Inspection

SUBTASK 52-11-00-210-009

(1) Do a visual inspection of the door pressure seal (Figure 602):

NOTE: You can do the door seal inspection with the door lining installed.

(a) Examine the seal.

1) Look for cracks, holes, and tears.

2) Look for indications of seal deterioration.

3) Make sure that the seal is installed in the seal retainer.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 52-11-00-860-036

(1) Close and latch the door (PAGEBLOCK 52-11-00/201).

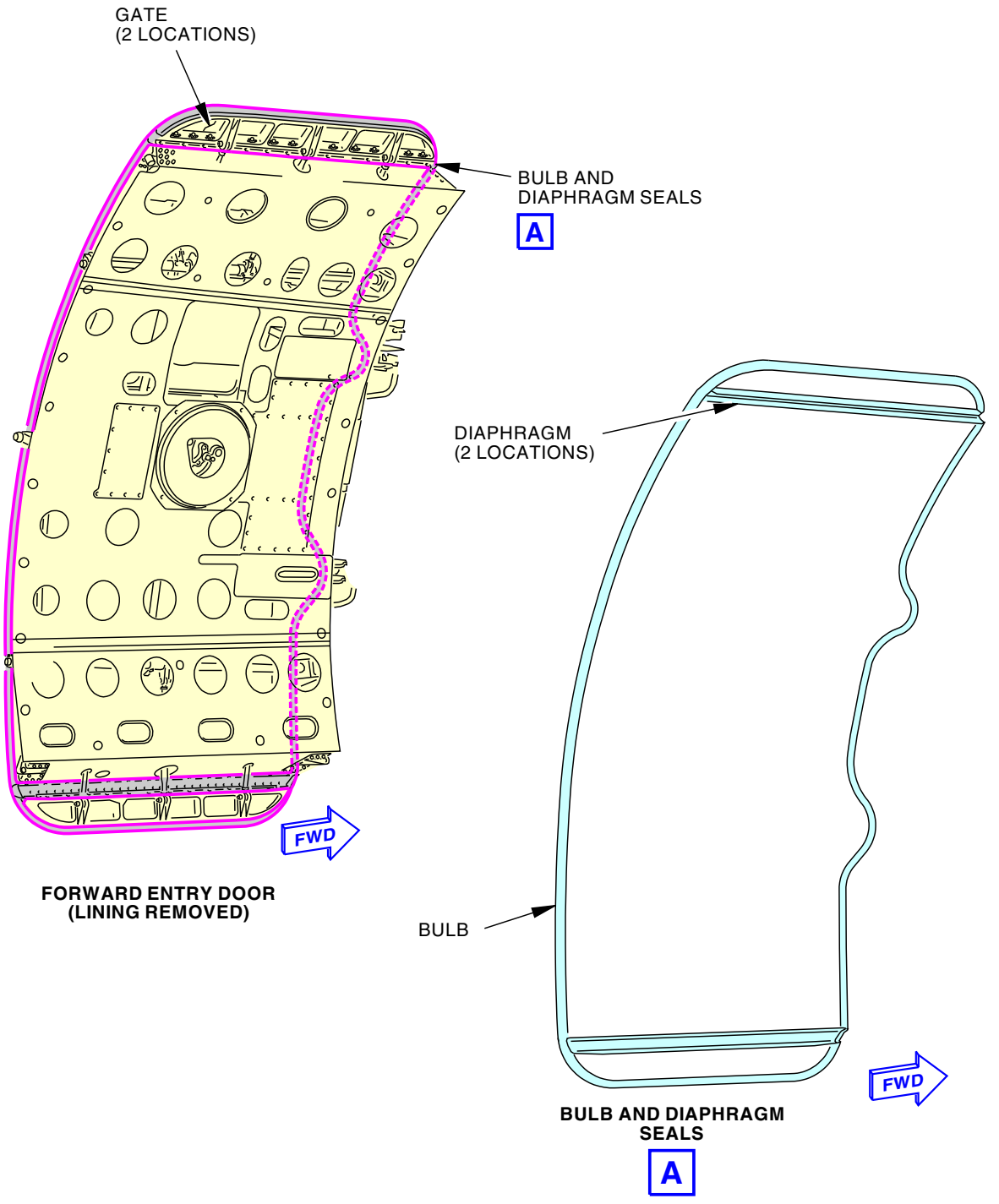
ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-11-00-940-006

(2) Remove the work platform, COM-1523.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Forward Entry Door Inspection/Check
Figure 602/52-11-00-990-817

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-11-00-200-804

5. Forward Entry Door Flapper Seal Check

(Figure 603)

A. References

Reference	Title
52-11-00 P/B 201	FORWARD ENTRY 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Location Zones

Zone	Area
831	Forward Entry Door

D. Prepare for the Inspection

SUBTASK 52-11-00-860-037

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched (PAGEBLOCK 52-11-00/201).

WARNING MAKE SURE THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure that a work platform, COM-1523, is installed outboard of the door.

SUBTASK 52-11-00-010-012

(2) Open the door (PAGEBLOCK 52-11-00/201).

E. Forward Entry Door Flapper Seal Inspection

SUBTASK 52-11-00-210-010

(1) Do a visual inspection of the door flapper seal as follows:

(a) Examine the seals.

1) Look for cracks, holes, and tears.

2) Look for indications of seal deterioration.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 52-11-00-860-038

(1) Close and latch the door (PAGEBLOCK 52-11-00/201).

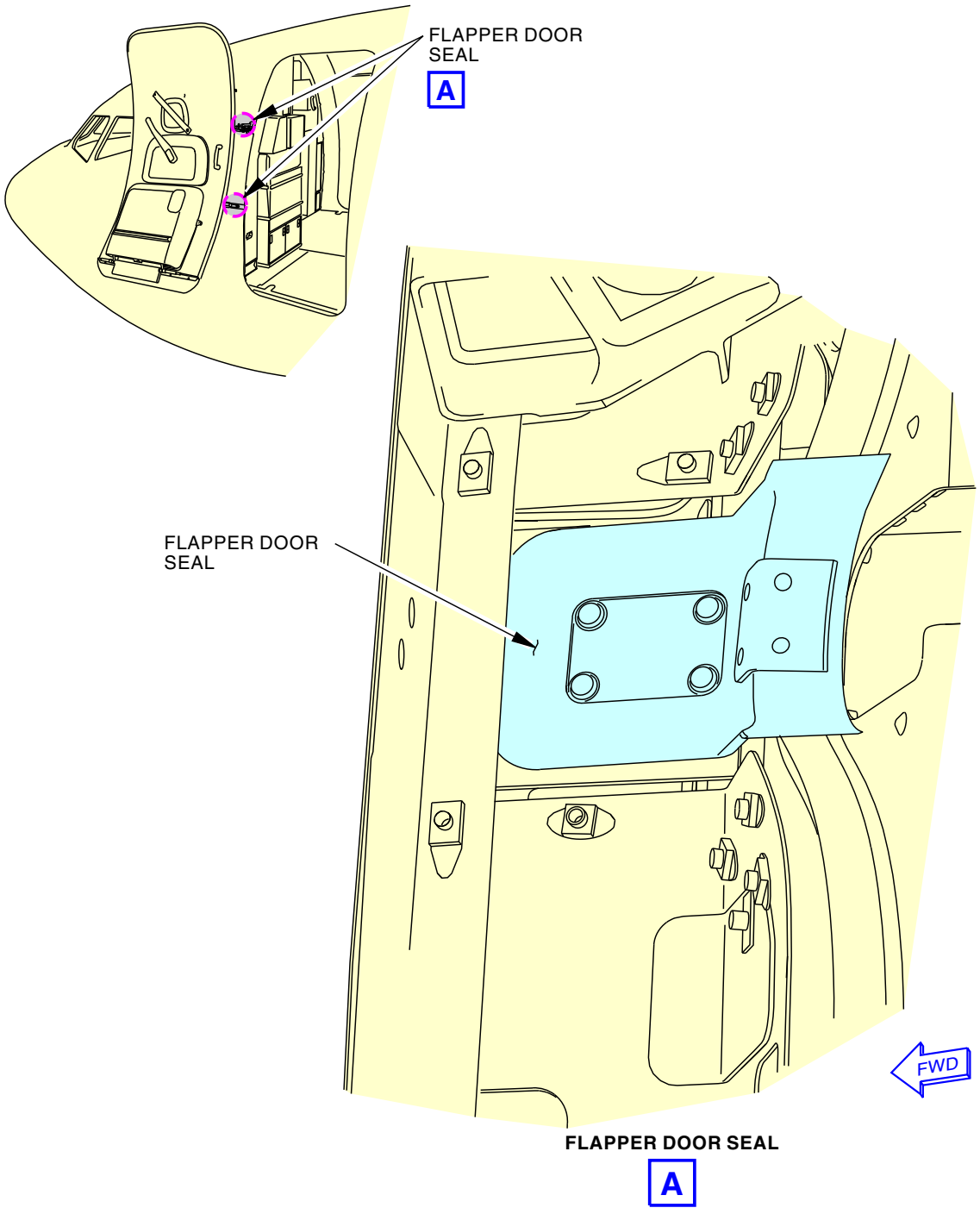
ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-11-00-940-007

(2) Remove the work platform, COM-1523.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Flapper Door Seal Inspection
Figure 603/52-11-00-990-818

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-11-00-700-802

6. Vacuum Tool Leak Check of the Forward Entry Door Seal

(Figure 604)

A. References

Reference	Title
52-09-10 P/B 801	DOOR SEALS - REPAIRS
52-11-00 P/B 201	FORWARD ENTRY 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
COM-1797	Stethoscope - Mechanics, 12 Inch Probe Part #: GA111D Supplier: 55719 Opt Part #: GA111C Supplier: 55719
SPL-1473	Probe - Kit, Ultrasonic Leak Part #: B00033 Supplier: 62373 Part #: ST6760A-1 Supplier: 81205
SPL-1474	Generator - Vacuum Part #: ST9999-VBA-1 Supplier: 81205 Part #: ST9999-VBA-201 Supplier: 81205 Opt Part #: ST9999-VBA-301 Supplier: 81205
SPL-1475	Bag - Assembly, Door Vacuum Part #: J51004-1 Supplier: 81205 Opt Part #: ST6760 Supplier: 81205 Opt Part #: ST9999-VB Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
A01024	Compound - Fairing - 3M EC-3587B	BAC5530

D. Location Zones

Zone	Area
831	Forward Entry Door
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
834	Left Aft Entry Door
835	Main Deck Cargo Door
841	Forward Galley Service Door
842	Right Forward Emergency Exit
844	Aft Galley Service Door

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E. Prepare for the Leak Check

SUBTASK 52-11-00-860-039

(1) Do the steps that follow to prepare for the leak check:

(a) Make sure that the door is safe as follows:

WARNING MAKE SURE THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

1) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(b) Open and close the door a minimum of three times (PAGEBLOCK 52-11-00/201).

(c) Close and lock the door (PAGEBLOCK 52-11-00/201).

(d) Put the work platform, COM-1523, outboard of the door.

(e) Calibrate the ultrasonic leak probe, SPL-1473.

(f) Connect the vacuum generator, SPL-1474, to the door vacuum assembly bag, SPL-1475.

(g) Connect the vacuum generator, SPL-1474, to a compressed air source.

(h) Install the door vacuum assembly bag, SPL-1475, over the passenger entry door (Figure 604):

1) Make sure that the door vacuum assembly bag, SPL-1475, covers the entire door and the gap between the door and the fuselage.

2) Remove all bubbles and creases from the door vacuum assembly bag, SPL-1475.

F. Forward Entry Door Seal Leak Check

SUBTASK 52-11-00-200-001

(1) Do a check of the noise levels around the interior of the door as follows:

(a) Use the vacuum generator, SPL-1474, to apply approximately 8 in/Hg (27.1 kPa) - 12 in/Hg (40.6 kPa).

1) Apply the vacuum gradually until you get to the 8 in/Hg (27.1 kPa) - 12 in/Hg (40.6 kPa) range.

(b) Hold the ultrasonic leak probe, SPL-1473, approximately 1 in. (25.4 mm) - 2 in. (50.8 mm) from the door surface.

(c) Move the ultrasonic leak probe, SPL-1473, around the edge of the door.

NOTE: The tip of the leak probe must not touch the door surface.

(d) Use the headphones and monitor the noise meter on the ultrasonic leak probe, SPL-1473.

G. Repair the Leak

SUBTASK 52-11-00-360-001

(1) If the noise levels go above the red line on the ultrasonic leak probe, SPL-1473, meter, do these steps:

(a) Find the exact location of the noise with a stethoscope, COM-1797.

(b) Remove the door vacuum assembly bag, SPL-1475, from the door.

(c) Make sure that the door seal is clean and in a good condition.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(d) Adjust the door seal, do this task.

1) Make sure that the door is safe.

a) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

2) Pull and push the seal in the seal retainer to get a good seal around the edge of the door.

NOTE: Wrinkles in the seal are not permitted.

3) Make sure that there are no leaks between the seal and seal depressor on the door.

4) If it is necessary, adjust as follows:

a) Apply the 3M EC-3587B compound, A01024, to the seal depressor and make smooth.

b) Make sure that the thickness of the 3M EC-3587B compound, A01024, is not more than 0.4 in. (10.16 mm).

(e) If it is necessary, repair or replace the door seal (PAGEBLOCK 52-09-10/801).

(f) Install the door vacuum assembly bag, SPL-1475, again and check for noise leaks.

1) Repeat the installation of the vacuum bag and do a check for leaks to make sure that all the noise leaks have been repaired.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 52-11-00-440-001

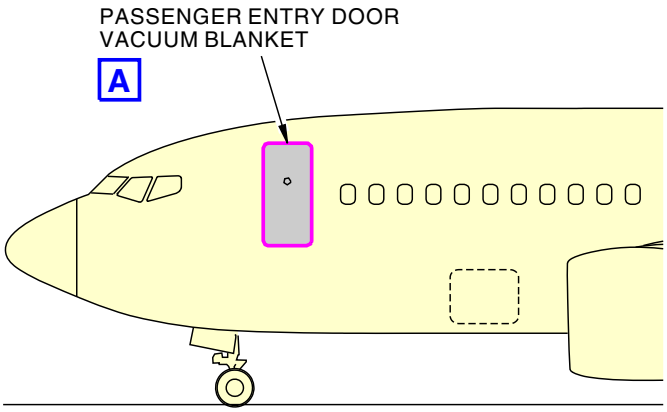
(1) Put the airplane back to its usual condition, do these steps:

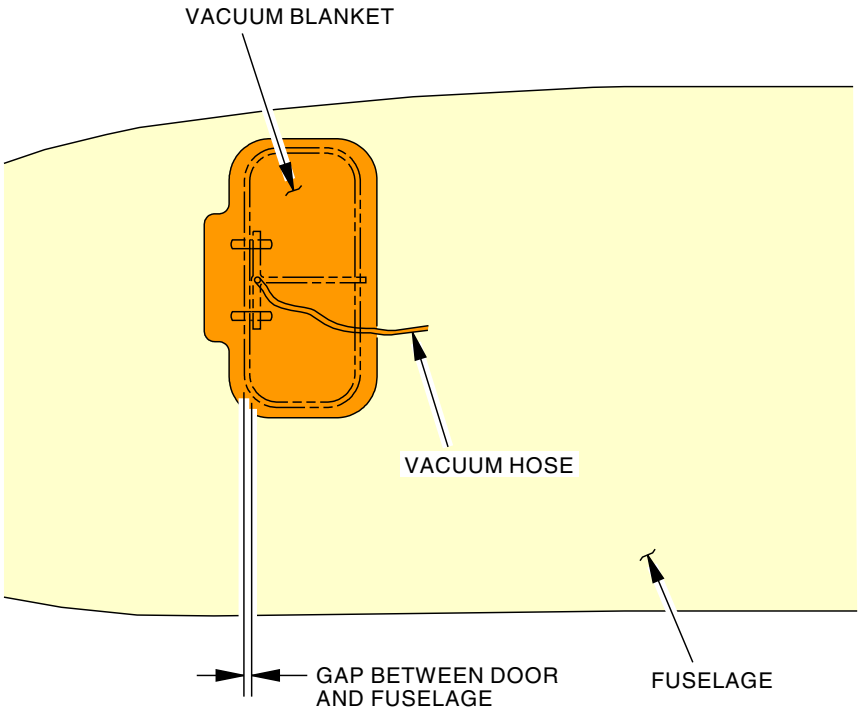
(a) Make sure that the door vacuum assembly bag, SPL-1475, is removed from the door.

(b) Remove the work platform, COM-1523.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details





PASSENGER ENTRY DOOR VACUUM BLANKET (EXAMPLE)

A

NOTE:

THE VACUUM BLANKET COVERS THE ENTIRE DOOR AND THE GAP BETWEEN THE DOOR AND THE FUSELAGE.

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Passenger Entry Door Pressure Seal Leak check
Figure 604/52-11-00-990-819

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FORWARD ENTRY DOOR - REPAIRS

1. General

A. This procedure has this task:

(1) A repair of an unsatisfactory hole for the latch pin in the top guide plate.

(2) The repair installs a stainless steel bushing to make the hole the correct dimension.

TASK 52-11-00-350-801

2. Top Guide Plate Latch Pin Hole Repair

(Figure 801)

A. References

Reference	Title
51-21-99-300-802	Decorative Exterior Paint System Repair (P/B 701)

B. Consumable Materials

Reference	Description	Specification
G50005	Sheet - Stainless Steel	

C. Location Zones

Zone	Area
831	Forward Entry Door

D. Procedure

SUBTASK 52-11-00-020-011

(1) Get access to the latch pin hole in the top guide plate:

(a) Remove the bolts that hold the top guide plate.

(b) Move the top guide plate to get access to the hole for the latch pin.

SUBTASK 52-11-00-220-001

(2) Measure the latch pin hole.

(a) The latch pin hole is satisfactory if the diameter is less than 0.4078 inch (10.358 mm).

NOTE: If the latch pin hole is satisfactory, do not do the remaining steps in this task.

(b) Repair the latch pin hole if the diameter is more than 0.4078 inch (10.358mm).

SUBTASK 52-11-00-350-001

(3) Make a spot face at the latch pin hole:

(a) Use a tool to make a spot face with a diameter of 0.593 inch (15.0622 mm).

(b) Make the depth of the spotface 0.20 inch (5.0 mm).

SUBTASK 52-11-00-350-002

(4) Make a bushing:

(a) Use the piece of stainless steel sheet, G50005 to make a bushing that is approximately 0.20 inch (5.0 mm) thick with diameter of approximately 0.60 inch (15.24 mm).

(b) Make the thickness of the bushing the same as the depth of the spotface.

(c) Make the inner diameter of the bushing 0.3438-0.3478 inch (8.732-8.834 mm).

(d) Make the outer diameter of the bushing is larger than the outer diameter of the spot face by 0.0010-0.0015 inch (0.025-0.038 mm).

(e) Heat treat the bushing.

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1) Increase the temperature of the bushing to 900 degrees F° (482 degrees C°) for one hour.

2) Let the temperature of the bushing decrease in the air.

SUBTASK 52-11-00-420-008

(5) Install the bushing in the top guide plate.

(a) Put the bushing in the spot face.

(b) Apply paint to the area of the repair, do this task: Decorative Exterior Paint System Repair, TASK 51-21-99-300-802.

SUBTASK 52-11-00-420-009

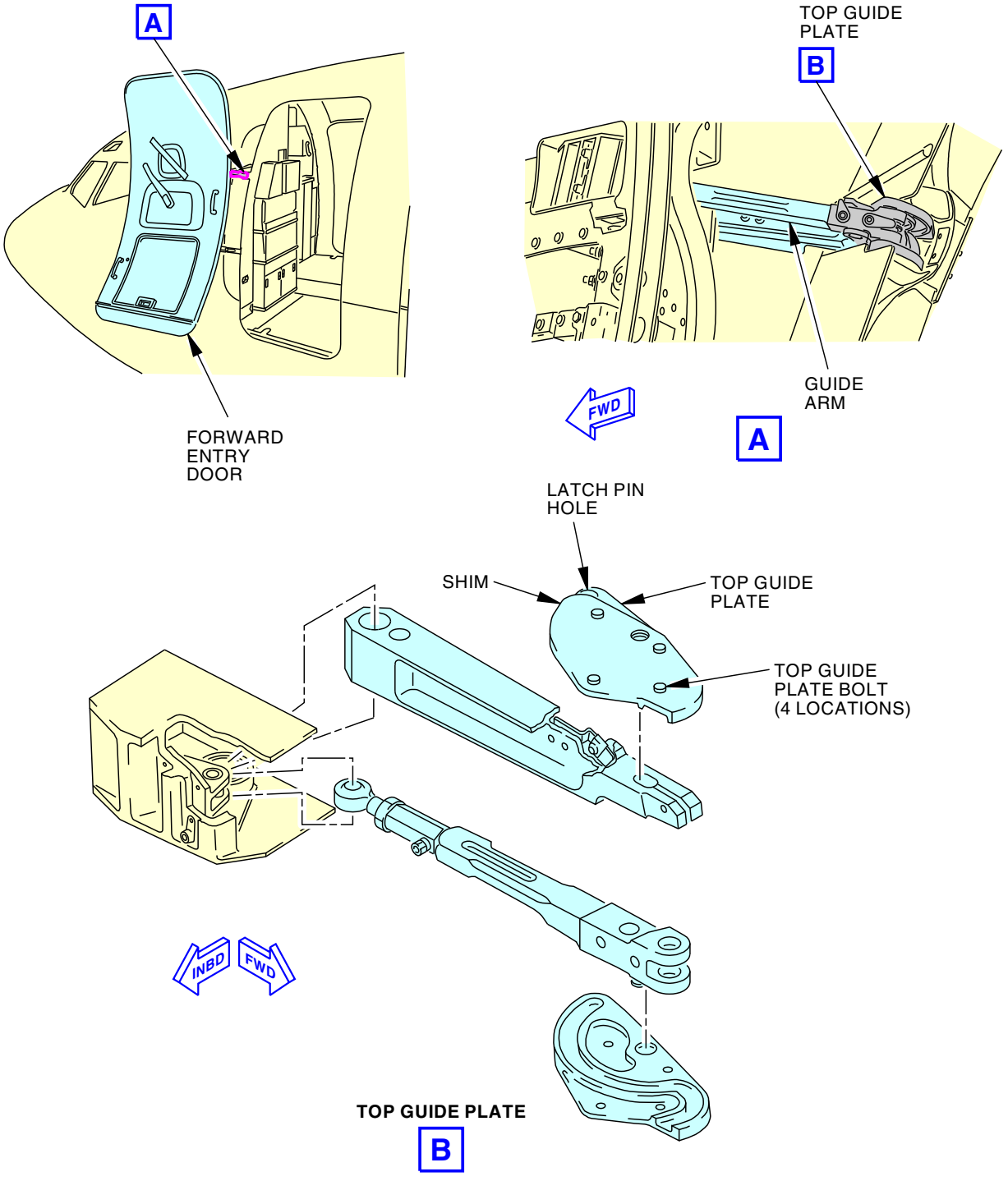
(6) Install the top guide plate.

(a) Move the top guide plate to align the holes for the bolts.

(b) Install the bolts in the top guide plate.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Repair of the Latch Pin Hole In the Top Guide Plate
Figure 801/52-11-00-990-820

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FORWARD ENTRY DOOR STOP BEARING PLATES - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Removal - stop bearing plate [1].l.

(2) Installation - stop bearing plate [1].

TASK 52-11-01-000-801

2. Stop Bearing Plate - Removal

A. References

Reference	Title
52-11-00 P/B 201	FORWARD ENTRY 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
STD-291	Drift - Light Weight, Metal or Plastic
STD-1242	Hammer - Standard

C. Consumable Materials

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

D. Location Zones

Zone	Area
831	Forward Entry Door

E. Prepare for the Removal

SUBTASK 52-11-01-860-001

(1) Install the work platform, COM-1523, outboard of the door.

(2) Open the forward entry door FORWARD ENTRY DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-11-00/201

F. Procedure

SUBTASK 52-11-01-020-001

(1) A. If necessary, use a standard hammer, STD-1242, and a non-metallic light weight, metal or plastic drift, STD-291, to remove the stop bearing plate [1].

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(2) Clean the mounting hole with a clean cotton wiper, G00034, that is moist with solvent, B00083.

NOTE: Clean surfaces are necessary to make a good bond.

——— END OF TASK ———

TASK 52-11-01-400-801

3. Stop Bearing Plate - Installation

A. References

Reference	Title
52-11-00 P/B 201	FORWARD ENTRY 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
STD-1242	Hammer - Standard

C. Consumable Materials

Reference	Description	Specification
A00551	Sealant - Fuel Tank	BAC5010 Type 44 (BMS5-44, BMS5-45)
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

D. Location Zones

Zone	Area
831	Forward Entry Door

E. Prepare for the installation

SUBTASK 52-11-01-420-001

(1) Do a test of the fit of the stop bearing plate [1] before the installation.

(a) Use hand pressure to install the stop bearing plate [1] into the mounting hole.

(b) Discard the stop bearing plate [1], if you can install it with hand pressure.

(c) Get a new stop bearing plate [1], if needed.

NOTE: When hand pressure is not sufficient to install the stop bearing plate [1], a new stop bearing plate [1] is not necessary.

F. Procedure

SUBTASK 52-11-01-420-002

(1) Install the stop bearing plate [1].

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(a) Apply a layer of adhesive sealant, A00551, to the stop bearing plate [1] and to the mounting hole.

(b) Install the stop bearing plate [1] with a pneumatic rivet gun with a brass set.

NOTE: If the pneumatic rivet gun is not available, use a standard hammer, STD-1242, and a non-metallic drift to install the stop bearing plate [1].

(c) Use a clean cotton wiper, G00034, that is moist with solvent, B00083, to remove the unwanted adhesive sealant, A00551, from the stop bearing plate [1] before it dries.

G. Put the airplane back to its usual condition

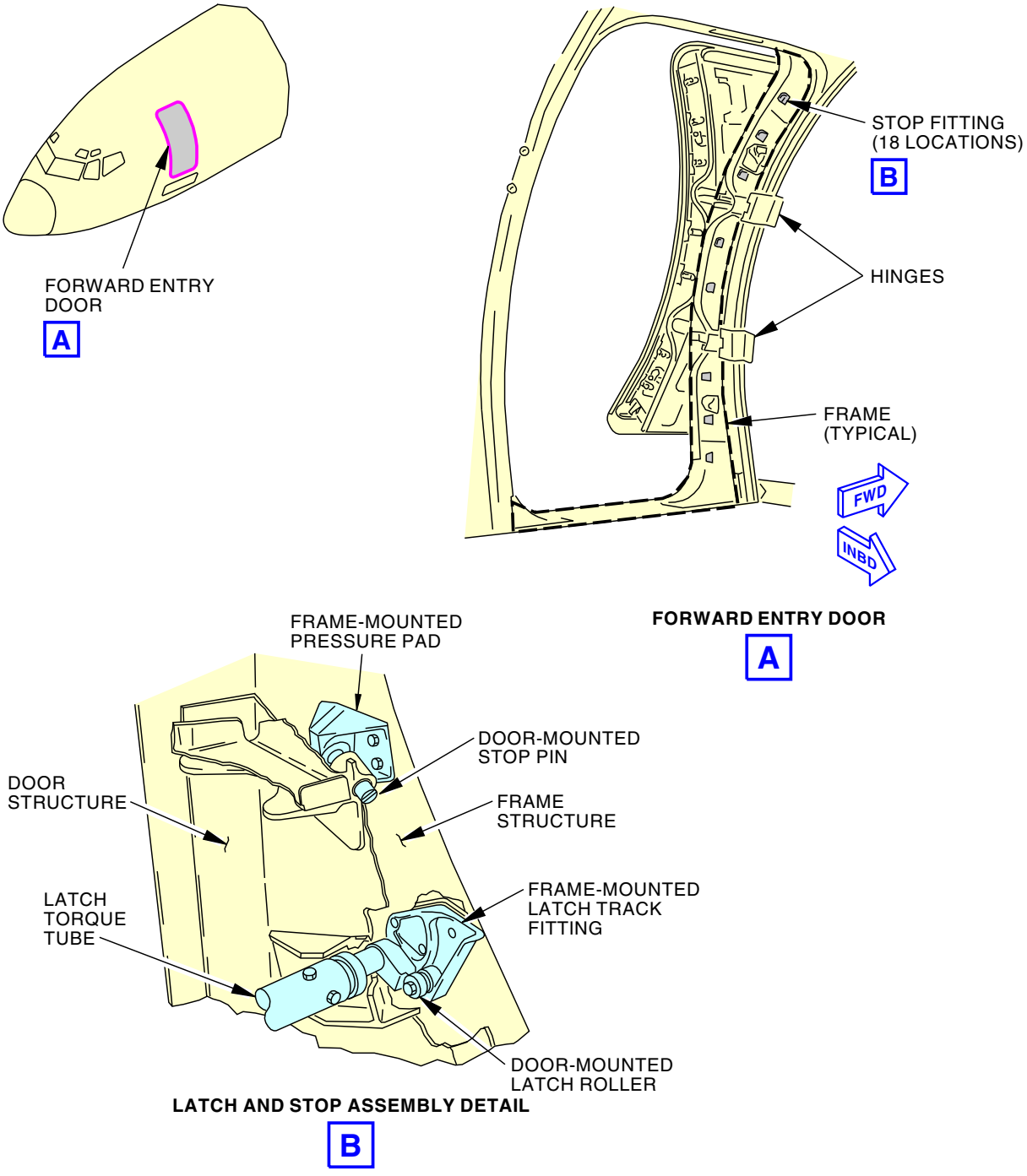
SUBTASK 52-11-01-940-001

(1) Close the forward entry door FORWARD ENTRY DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-11-00/201.

(2) Remove the work platform, COM-1523.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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DOOR STOP BEARING PLATE - REMOVAL/INSTALLATION
Figure 401/52-11-01-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FORWARD ENTRY DOOR HINGE ARM - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the forward entry door hinge arm [2].

(2) An installation of the forward entry door hinge arm [2].

TASK 52-11-11-000-801

2. Forward Entry Door Hinge Arm Removal

(Figure 401)

A. References

Reference	Title
52-11-00-000-801	Forward Entry Door 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Location Zones

Zone	Area
831	Forward Entry Door

D. Access Panels

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access
831CZ	Forward Entry Door - Handle Box Access

E. Prepare for the Removal

SUBTASK 52-11-11-860-001

(1) Make sure that the forward entry door [1] is safe as follows:

(a) Make sure that the forward entry door [1] is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Install the work platform, COM-1523, outboard of the door.

SUBTASK 52-11-11-010-001

(2) Do this task: Forward Entry Door Removal, TASK 52-11-00-000-801.

SUBTASK 52-11-11-410-001

(3) Get access to the door [1]:

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(a) Remove the assist handle bracket [3] to the forward entry door [1].

(b) Remove this access panel:

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access

(c) Remove this access panel:

Number	Name/Location
831CZ	Forward Entry Door - Handle Box Access

F. Foward Entry Door Hinge Arm Removal

SUBTASK 52-11-11-020-001

(1) Remove the handle mechanism:

(a) Remove the cover [35] on the interior handle [32] to get access to the fasteners that attach the interior handle [32] to the handle mechanism.

(b) Remove the cotter pin [36], nut [34], and washer [33] that attach the interior handle [32] to the hub [38].

(c) Remove the interior handle [32].

(d) Remove the bolt [37] from the hub [38] if they are loose.

NOTE: The bolt [37] are bonded to the hub [38] and it is not necessary to remove them if the bond is tight.

(e) Remove the bolts [40] and washers [27] that attach the cam cover [28] to the handle box [7].

(f) Remove the cam cover [28].

(g) Remove the lockwire, bolt [30], and washer [29] that attach the hub [38] and shim [39] to the handle cam [26].

(h) Remove the hub [38] and shim [39].

(i) Remove the cotter pin [42] from the nut [41] that holds the handle cam [26] to the handle shaft [49].

(j) Hold the exterior handle [13] and remove the nut [41] and washer [43] that hold the handle cam [26] to the handle shaft [49].

NOTE: When you remove the nut [41], the exterior handle [13] and part of the handle mechanism will be loose on the outer side of the door.

(k) Remove the handle cam [26].

(l) From the outer side of the door, remove the exterior handle [13], sleeve [47], handle shaft [49], and centering cam [46] as an assembly.

(m) If it is necessary, disassemble these parts further as follows:

1) Remove the bolts [12], washers [48], and nuts [45] that attach the exterior handle [13] to the centering cam [46] through the sleeve [47].

2) Remove the exterior handle [13].

3) Remove the centering cam [46].

4) Remove the handle shaft [49] from the sleeve [47].

5) Remove the spring pin [11] from the washer [14] and pin [52].

6) Remove the washer [14] from the end of the pin [52].

7) Remove the lock ring [50] from the handle shaft [49].

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8) Remove the nut [53] from the end of the handle shaft [49].

9) Remove the spring [51] and pin [52] from the handle shaft [49].

(n) Remove the bolt [17] and washer [15] that attach thehandle pan [16], seal plate [19], and handle housing [23] to the handle box [7].

(o) Remove the handle pan [16] and seal plate [19] from the external side of the forward entry door [1].

(p) Remove the seal plate [19] from the handle pan [16] and packing [20] from the seal plate [19].

(q) Remove the handle housing [23] from the handle box [7] and packing [20] from the handle housing [23].

(r) If it is necessary, remove the bearing [24] from the handle box [7]:

1) Remove the rataining ring [25] that holds the bearing [24] in the handle box [7].

2) Remove the bearing [24] from the handle box [7].

SUBTASK 52-11-11-020-002

(2) Remove the upper and lower latch control rods [18]:

(a) Remove the bolts [60] and washer [61] that connect the latch control rods [18] to the handle mechanism in the handle box [7].

Remove the bolts [54], washers [55], nuts [56], and cotter pins [57] that connect the latch control rods [18] to the upper and lowerlatch torque tubes [58].

(b) Remove the latch control rod [18] from the handle box [7] and forward entry door [1] to make clearance for the handle box [7] removal.

SUBTASK 52-11-11-020-003

(3) Disconnect the door hinge torque tube [59]:

(a) Remove the bolts [72], washers [70], and nuts [69] that go through the upper and lower sleeve [71] on the door hinge torque tube [59].

(b) Move the sleeve [71] toward the center of the door hinge torque tube [59] to make clearance to remove the door hinge torque tube [59] and handle box [7] at the same time.

SUBTASK 52-11-11-020-004

(4) Remove the handle box [7] and door hinge torque tube [59]:

(a) Remove the bolts [68] and washers [67] that attach the upper and lower splice angles [66] to the beams.

(b) Remove the upper and lower splice angle [66] from the beams to get access to the door hinge torque tube [59].

(c) Remove the bolt [63], washer [64], bolts [65], and washers [64] that attach the top and bottom of the handle box [7] to the beam.

(d) Carefully remove the handle box [7] and door hinge torque tube [59] from the door structure.

(e) If the laminated shim [62] between the top of the handle box [7] and beam are loose, remove them.

SUBTASK 52-11-11-020-005

(5) Remove the hinge arm [2] from the hinge support:

NOTE: Do this step for each hinge arm.

(a) Loosen the bolts [74] and washer [75] that hold the hinge pin [76] in the hinge arm [2].

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(b) Remove hinge clip [78].

(c) Remove the hinge pin [76] from the hinge arm [2].

(d) Remove the packing [73] from the hinge pin [76].

(e) Remove the hinge arm [2].

——— END OF TASK ———

TASK 52-11-11-400-801

3. Forward Entry Door Hinge Arm Installation

(Figure 401)

A. References

Reference	Title
52-11-00-400-801	Forward Entry Door 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
D00633	Grease - Aircraft General Purpose	BMS3-33
G00440	Lockwire - MS20995C41, Corrosion Resistant Steel - 0.041 Inch (1.0414 mm) Diameter	NASM20995

D. Location Zones

Zone	Area
831	Forward Entry Door

E. Access Panels

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access
831CZ	Forward Entry Door - Handle Box Access

F. Forward Entry Door Hinge Arm Installation

SUBTASK 52-11-11-420-001

(1) Install the hinge arm [2] in the hinge support:

NOTE: Do this step for each hinge arm.

(a) Put the hinge arm [2] in its correct position in the hinge support.

(b) Do a check of the packing [73] for damage or wear and replace it if necessary.

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(c) Apply grease, D00633, to the packing [73] before installation.

(d) Install the packing [73] on the hinge pin [76].

(e) Apply grease, D00633, to the hinge pin [76] and bolt [74] before installation.

(f) Install the hinge pin [76] in the hinge arm [2].

(g) Install the hinge clip [78], bolt [74], and washer [75] to hold the hinge pin [76] in the hinge arm [2].

(h) Apply grease, D00633, in the opening between the hinge arm [2] and hinge pin [76] to any openings between the hinge support and the hinge pin [76].

SUBTASK 52-11-11-420-002

(2) Install the handle box [7] and the door hinge torque tube [59]:

(a) Apply sealant, A00247, to the mating surfaces between the bottom of the handle box [7] and the beam before installation.

(b) Carefully put the handle box [7] and the door hinge torque tube [59] in their correct position in the door structure.

(c) If the laminated shim [62] between the top of the handle box [7] and the beam were removed, do these steps:

1) Make sure that the maximum clearance between the top of the handle box [7] and the beam is 0.01 in. (0.25 mm).

2) Apply sealant, A00247, to the mating surfaces between the handle box [7], laminated shims [62], and beam before installation.

3) Install the laminated shim [62] between the handle box [7] and the beam.

(d) Apply sealant, A00247, to the mating surfaces of the bolts [63], washers [64], bolts [65], washers [64], handle box [7], and beam before installation.

(e) Install the bolts [63], washer [64], bolts [65], and washers [64] to attach the top and bottom of the handle box [7] to the beams.

(f) Put the upper and lower splice angle [66] in their correct position on the beams.

(g) Apply compound, C00528, to the holes for the bolts [68] before installation.

(h) Install the bolts [68] and washers [67] to attach the upper and lower splice angles [66] to the beams.

SUBTASK 52-11-11-420-003

(3) Connect the door hinge torque tube [59]:

(a) Apply grease, D00633, to the mating surfaces of thesleeves [71] , hinge pins [76], and door hinge torque tube [59] before installation.

(b) Put the sleeves [71] over the hinge pins [76].

(c) Apply compound, C00528, to the holes for the bolts [72] before installation.

(d) Install the bolts [72], washers [70], and nuts [69] that go through the upper and lower sleeves [71] on the door hinge torque tube [59].

SUBTASK 52-11-11-420-004

(4) Install the upper and lower latch control rods [18]:

(a) Put the latch control rods [18] in their correct positions in the handle box [7] and forward entry door [1].

(b) Apply compound, C00528, to the holes for the bolts [54] and bolts [60] before installation.

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(c) Install the bolts [54], washers [55], nuts [56], and cotter pins [57] to connect the latch control rod [18] to the upper and lower latch torque tube [58].

(d) Install thebolts [60] and washers [61] to connect the latch control rods [18] to the handle mechanism in thehandle box [7].

SUBTASK 52-11-11-420-005

(5) Install the handle mechanism:

(a) Do a check of the packing [20] and packing [21] for damage or wear and replace them if it is necessary.

(b) Apply grease, D00633, to the packing [20] and packing [21] before installation.

(c) Install the packing [21] in the seal plate [19] and the packing [20] in the handle housing [23].

(d) Put the handle housing [23] in its correct position against the handle box [7].

(e) Put the seal plate [19] in its correct position against the handle pan [16].

(f) Put the handle pan [16] and seal plate [19] in position on the external side of theforward entry door [1].

(g) Install the bolts [17] and washers [15] to attach the handle pan [16], seal plate [19], and handle housing [23] to the handle box [7].

(h) Install the exterior handle [13], handle shaft [49], sleeve [47], and centering cam [46] as an assembly.

(i) Make sure that the lubrication fitting on the sleeve [47] is in its correct position.

(j) If it is necessary, assemble these parts before installation:

1) Install the pin [52] and spring [51] in the handle shaft [49].

2) Install the nut [53] in the end of the handle shaft [49].

3) Install thelock ring [50] on the handle shaft [49].

4) Install the washer [14] on the end of the pin [52].

5) Install the spring pin [11] through the washer [14] and pin [52].

6) Apply grease, D00633, to the mating surfaces of the handle shaft [49] and sleeve [47] before installation.

7) Install the handle shaft [49] in the sleeve [47].

8) Install the bolts [12], washers [48], and nuts [45] to attach the exterior handle [13] and sleeve [47] to the centering cam [46].

(k) If it is necessary, install the bearing [24] and rataining ring [25] in the handle box [7]:

1) Put the bearing [24] in its position in the handle box [7].

2) Install the rataining ring [25] to hold the bearing [24] in the handle box [7].

(l) Apply grease, D00633, to the mating surfaces of the handle shaft [49] and handle cam [26] before installation in the handle box [7].

(m) Hold the exterior handle [13] in its position on the exterior side of the forward entry door [1].

(n) Install the handle shaft [49] through the handle box [7].

(o) Install the handle cam [26] on the end of the handle shaft [49].

(p) Install the washer [43], nut [41], and cotter pin [42] to hold the handle cam [26] to thehandle shaft [49].

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(q) Put the hub [38] and shim [39] in their correct position against the handle cam [26].

(r) Install the bolt [30] and washer [29] to attach the hub [38] and shim [39] to the handle cam [26].

(s) Install MS20995C41 lockwire, G00440, on the bolt [30].

(t) Put the cam cover [28] in its correct position against thehandle box [7].

(u) Install the bolts [40] and washers [27] to attach the cam cover [28] to the handle box [7].

(v) Put the bolts [37] through the hub [38].

(w) Put the interior handle [32] in its correct position against the hub [38].

(x) Install the washers [33], nuts [34], and cotter pins [36] to attach the interior handle [32] to the hub [38].

(y) Install the cover [35] on the interior handle [32].

SUBTASK 52-11-11-420-006

(6) Do this task: Forward Entry Door Installation, TASK 52-11-00-400-801.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 52-11-11-410-002

(1) Install this access panel:

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access

(2) Install this access panel:

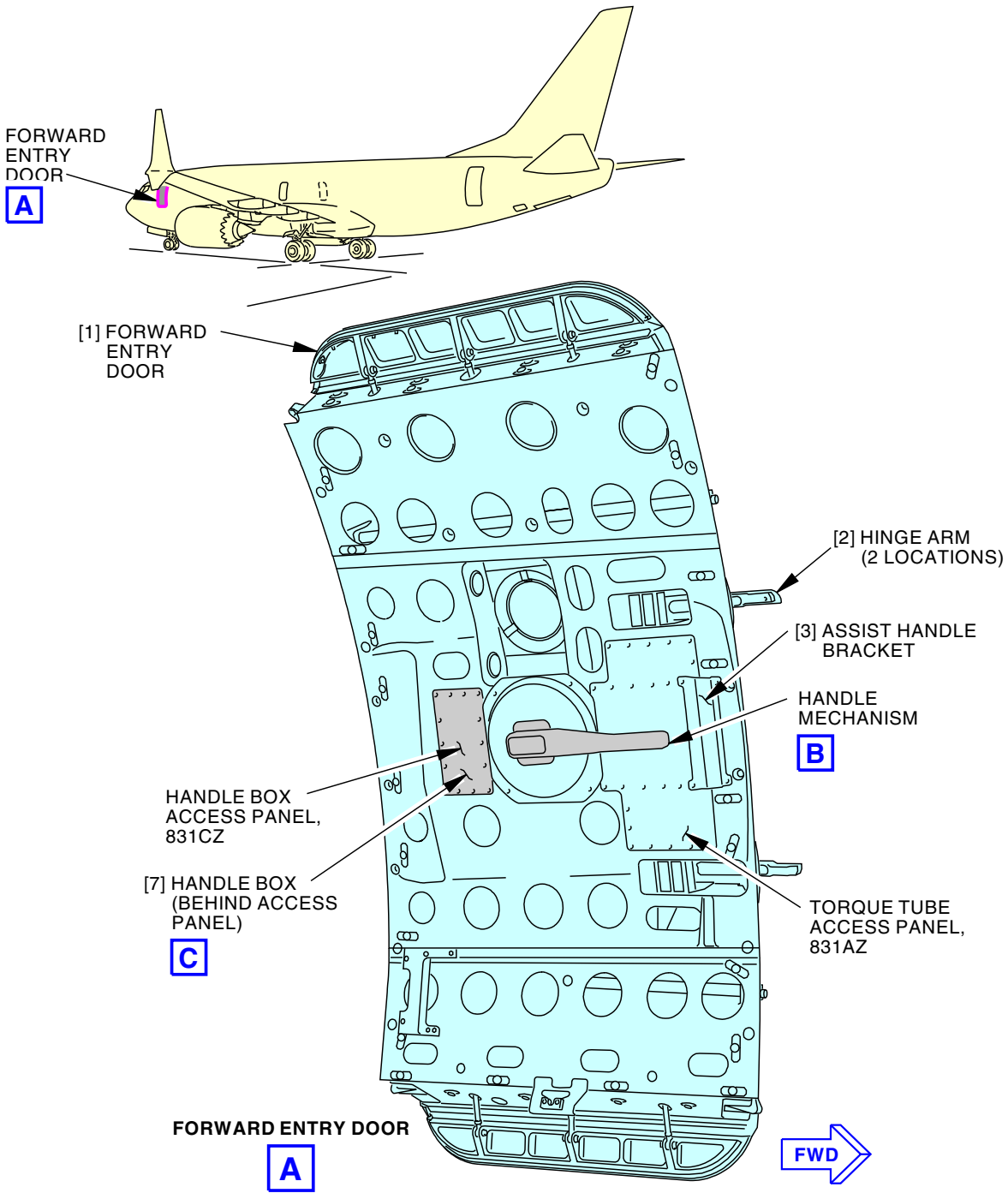
Number	Name/Location
831CZ	Forward Entry Door - Handle Box Access

SUBTASK 52-11-11-080-001

(3) Remove the work platform, COM-1523, from the door.

END OF TASK

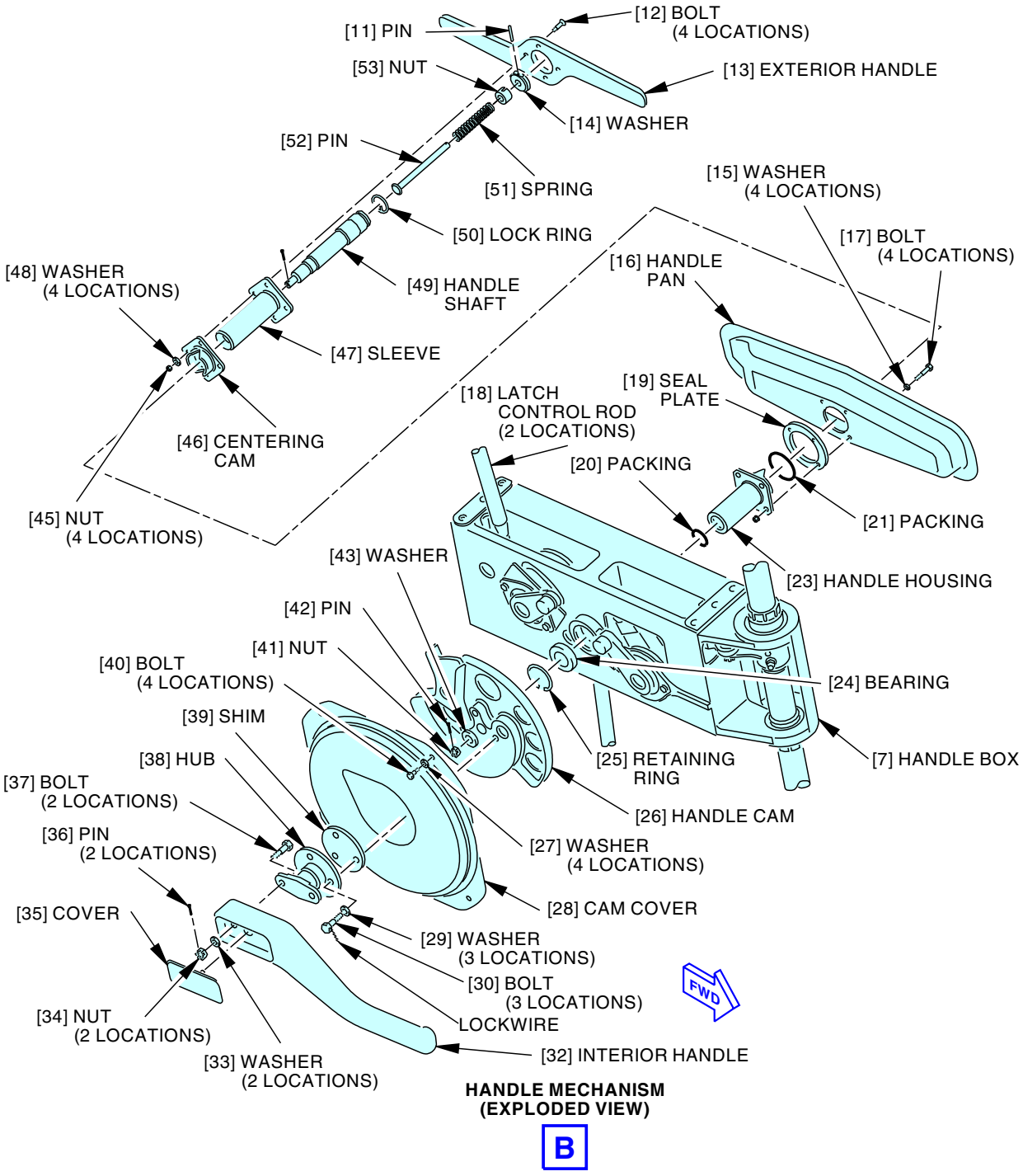
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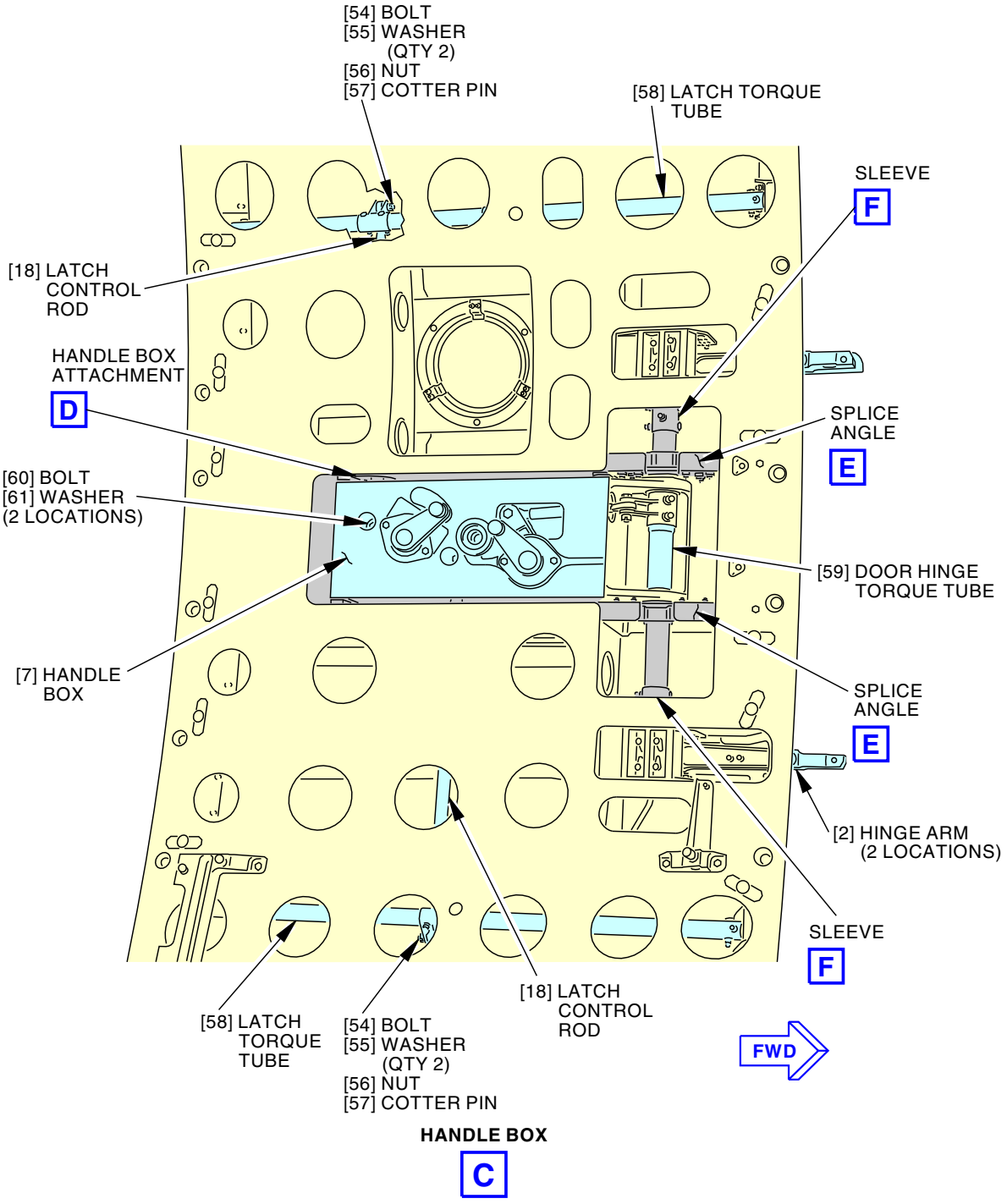
Forward Entry Door Hinge Arm Installation
Figure 401/52-11-11-990-801 (Sheet 1 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Forward Entry Door Hinge Arm Installation
Figure 401/52-11-11-990-801 (Sheet 2 of 5)

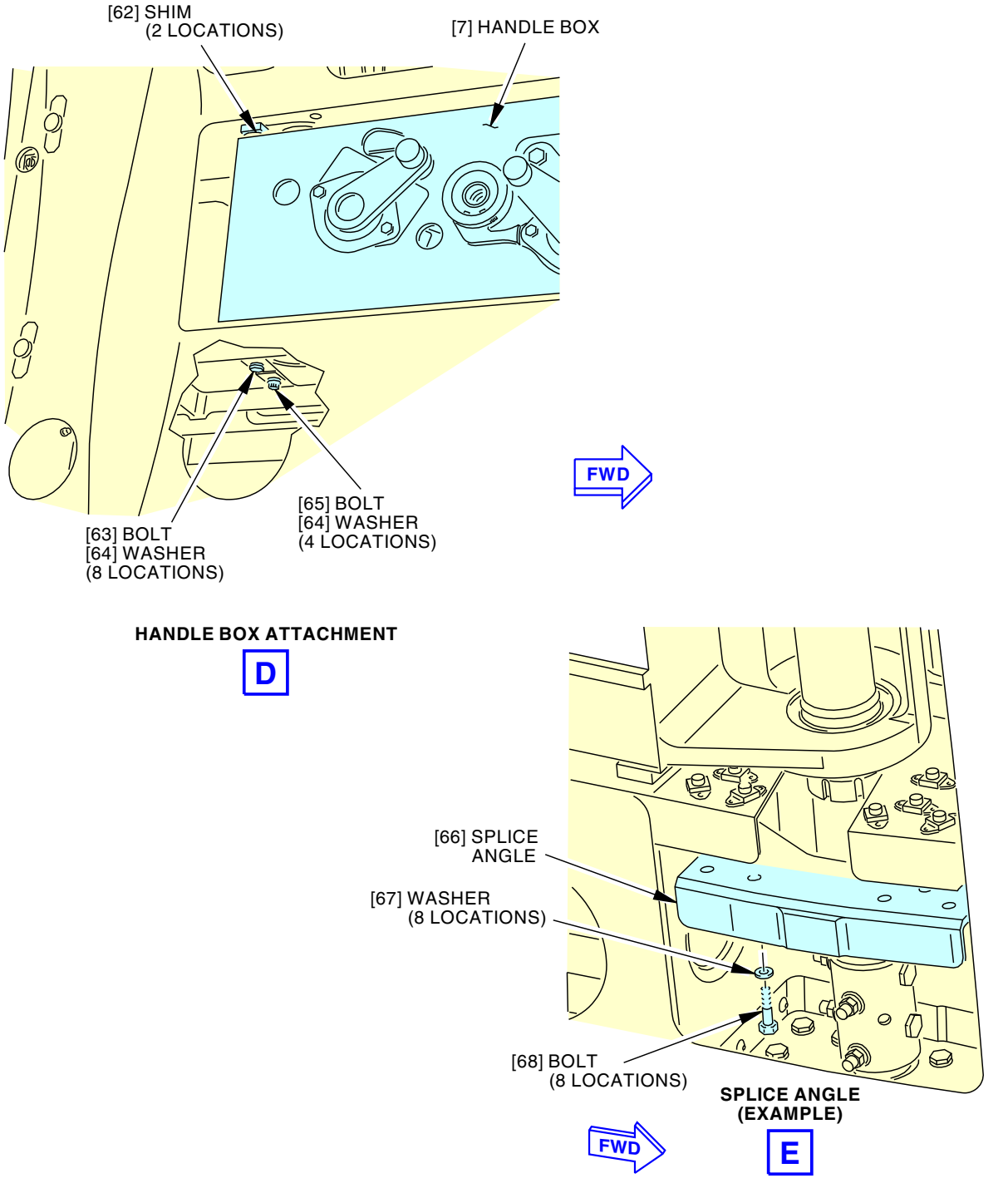
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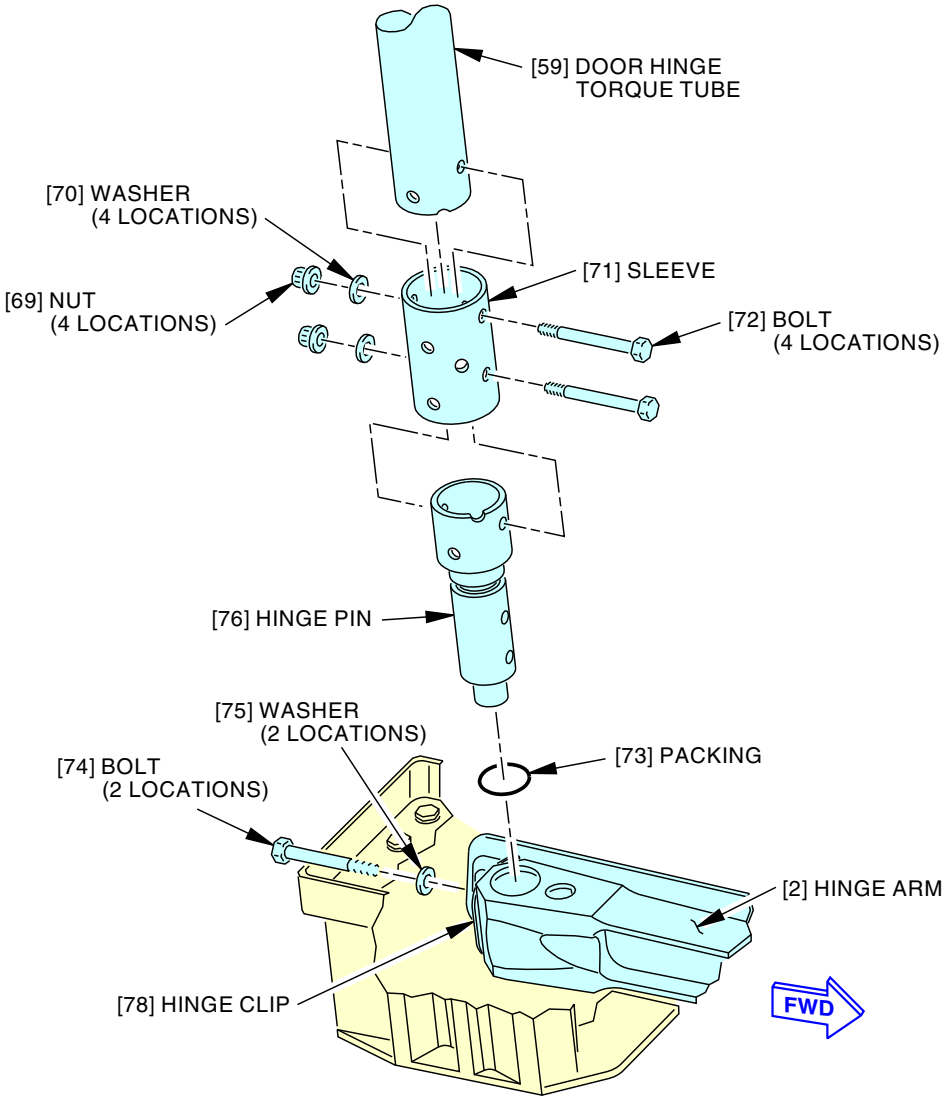
Forward Entry Door Hinge Arm Installation
Figure 401/52-11-11-990-801 (Sheet 3 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Forward Entry Door Hinge Arm Installation
Figure 401/52-11-11-990-801 (Sheet 4 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415756 S00061538826_V1

Forward Entry Door Hinge Arm Installation
Figure 401/52-11-11-990-801 (Sheet 5 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FORWARD ENTRY DOOR GUIDE ARM AND ROLLER - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the forward entry door guide arm and roller.

(2) An installation of the forward entry door guide arm and roller.

B. The forward entry door guide arm and roller are referred to as the guide arm and roller in this procedure.

TASK 52-11-21-000-801

2. Forward Entry Door Guide Arm and Roller Removal

(Figure 401)

A. References

Reference	Title
52-11-31-000-801	Forward Entry Door Lining 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Location Zones

Zone	Area
831	Forward Entry Door

D. Access Panels

Number	Name/Location
831	Forward Entry Door

E. Prepare for the Removal

SUBTASK 52-11-21-860-001

(1) Make sure that the forward entry door [1] is safe as follows:

(a) Make sure that the forward entry door [1] is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Install the work platform, COM-1523, outboard of the forward entry door [1].

SUBTASK 52-11-21-010-001

(2) Get access to the forward entry door [1] as follows:

(a) Make sure that the forward entry door [1] is closed and latched.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) Do this task: Forward Entry Door Lining Removal, TASK 52-11-31-000-801.

(c) Open this access panel:

Number	Name/Location
831	Forward Entry Door

F. Forward Entry Door Guide Arm and Roller Removal

SUBTASK 52-11-21-020-001

WARNING BE CAREFUL WHEN YOU CONNECT OR DISCONNECT THE GUIDE ARM TO THE ENTRY DOOR. THE DOOR CAN HIT THE FUSELAGE. IF YOU DO NOT OBEY, DAMAGE TO EQUIPMENT AND INJURY TO THE PERSONNEL CAN OCCUR.

(1) Disconnect the guide arm [2] from the forward entry door [1]:

(a) Remove the bolt [3], washer [4], washer [6], nut [5], and cotter pin [7] that attach the guide arm [2] to the door structure.

(b) Remove the guide arm [2] from the forward entry door [1].

SUBTASK 52-11-21-020-002

(2) Disconnect the upper radius link [8] and lower radius link [10] from the guide arm [2]:

(a) Remove the screw [12], keywasher [11], washers [36], bushing [35], and pin [9] that attach to the upper radius link [8] and lower radius link [10] to the guide arm [2].

(b) Move the guide arm [2] away from the upper radius link [8] and lower radius link [10].

SUBTASK 52-11-21-020-003

(3) Remove the hold open mechanism from the guide arm [2]:

(a) Disconnect the ends of the spring [17] from the cam [15] and link [18].

(b) If it is necessary, remove the spring pin [37] from the guide arm [2].

(c) Remove the spacers [16] that attach the spring [17], cam [15], link [18], and washers [19] to the shafts [14].

(d) Remove the spring [17], cam [15], link [18], and washer [19] from the shaft [14].

(e) Remove the screw [22], washer [13], lever [21], and washer [19] from the shaft [14] nearest the roller end of the guide arm [2].

(f) Remove the screw [22], washer [13], cam [23], and washer [19] from the other shaft [14].

NOTE: The shaft will be loose in the guide arm.

SUBTASK 52-11-21-020-004

(4) Disconnect the guide arm [2] and roller [20] from the guide plates on the fuselage:

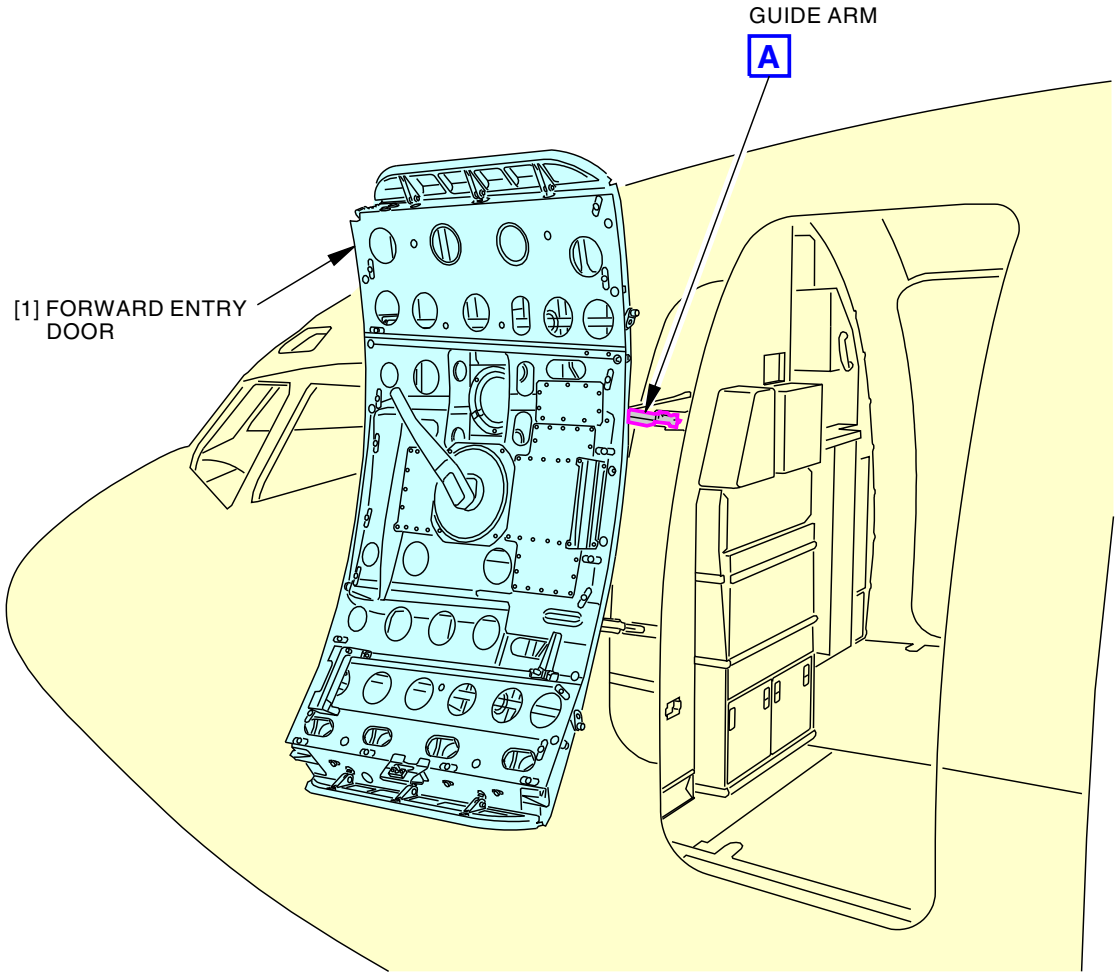
(a) Move the guide arm [2] away from the forward entry door [1] until it is parallel to the fuselage.

(b) Move the guide arm [2] and roller [20] forward to the open end of the guide plate tracks until the roller [20] is clear of the guide plates.

(c) Remove the guide arm [2] and roller [20] from the airplane.

END OF TASK

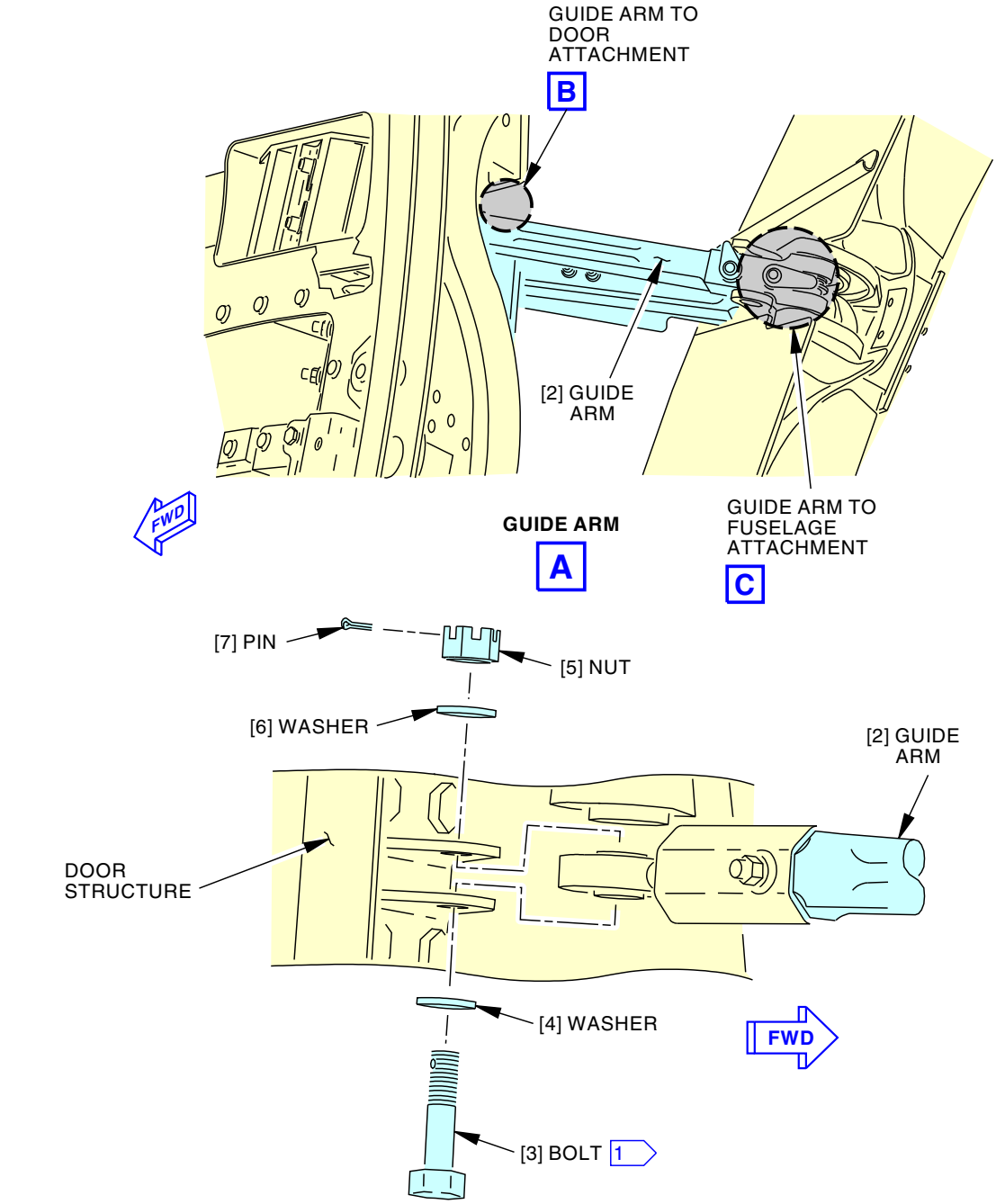
ECCN 9E991 BOEING PROPRIETARY - See title page for details



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Forward Entry Guide Arm and Roller Installation
Figure 401/52-11-21-990-802 (Sheet 1 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

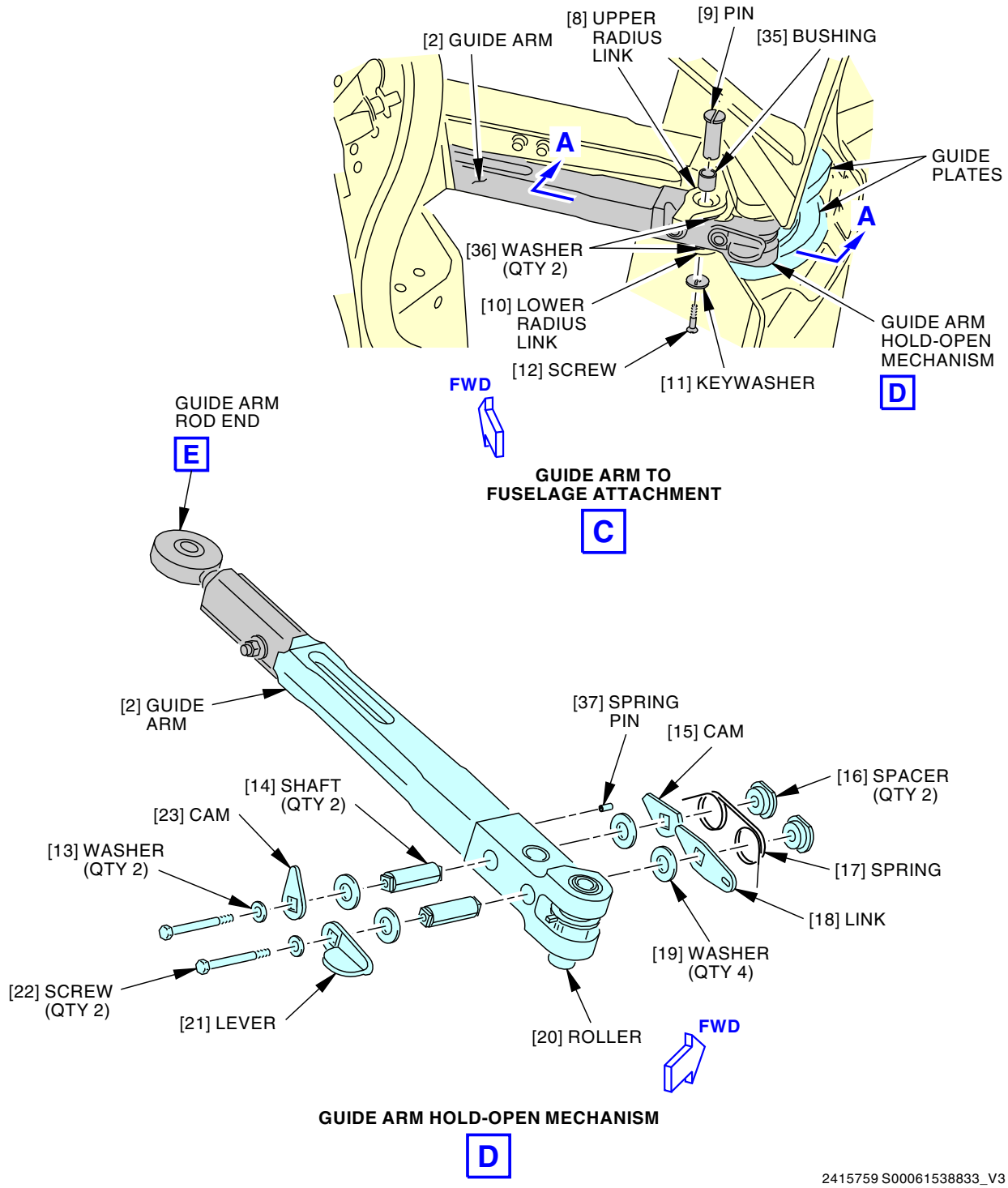


1 BOLT CAN BE INSTALLED HEAD UP IF ACCESS IS LIMITED.

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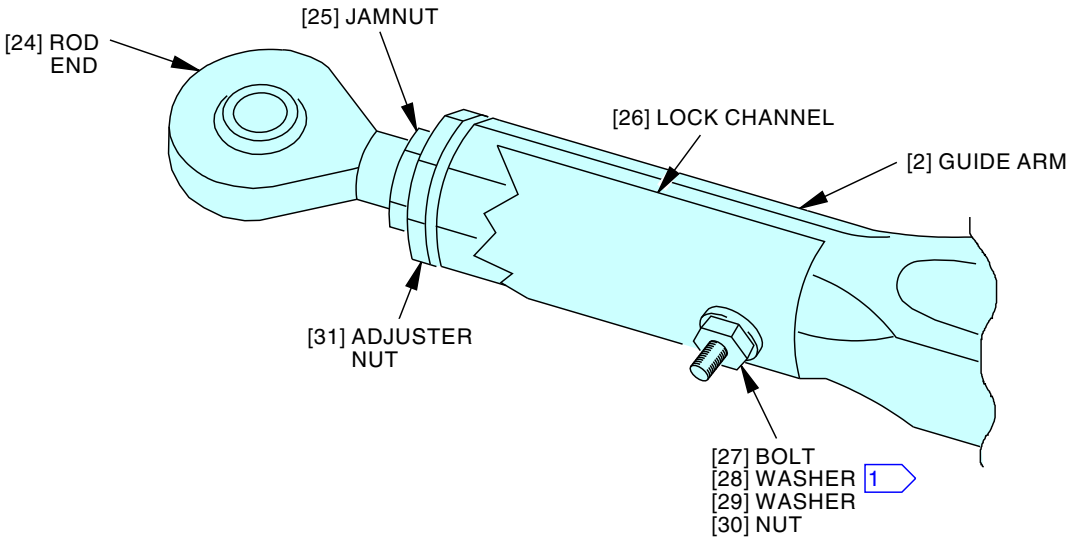
Forward Entry Guide Arm and Roller Installation
Figure 401/52-11-21-990-802 (Sheet 2 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



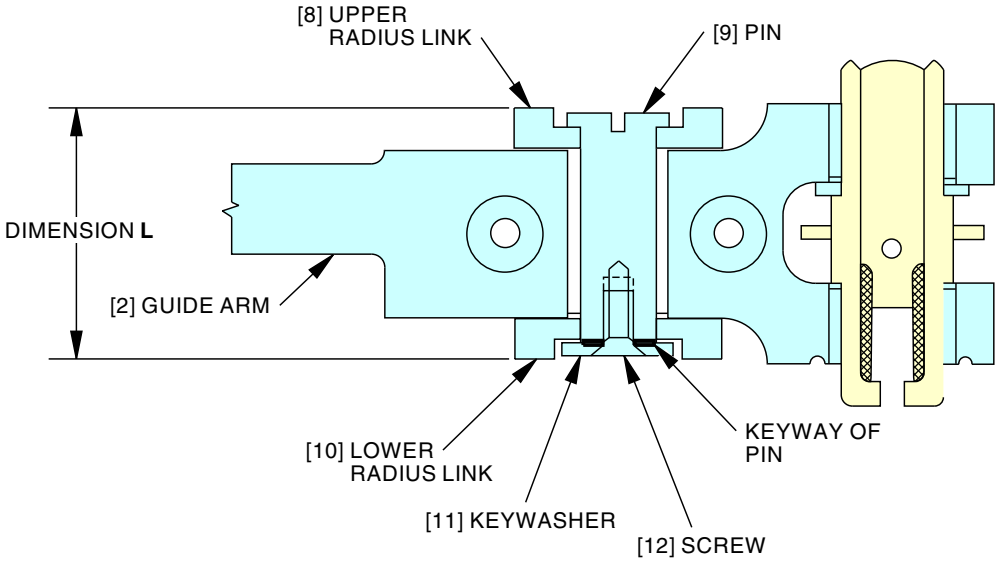
Forward Entry Guide Arm and Roller Installation
Figure 401/52-11-21-990-802 (Sheet 3 of 4)

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GUIDE ARM ROD END

E



A-A

1 WASHER USED WITH HEX HEAD BOLT

2415760 S00061538834_V3

Forward Entry Guide Arm and Roller Installation
Figure 401/52-11-21-990-802 (Sheet 4 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-11-21-400-801

3. Forward Entry Door Guide Arm and Roller Installation

(Figure 401)

A. References

Reference	Title
52-11-00-820-801	Forward Entry Door Adjustment (P/B 501)
52-11-31-400-801	Forward Entry Door Lining Installation (P/B 401)
SOPM 20-30-03	General Cleaning Procedures

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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Consumable Materials

Reference	Description	Specification
A00648	Compound - Retaining - Loctite 242	ASTM D5363 Grp 3 Cl 2 Gd 1 (SUPERSEDES MIL-S-46163)
A01076	Adhesive - Synthetic Rubber	BAC5010 Type 93 (BMS5-95 Class B)
A50129	Primer - Loctite 7649	ASTM D5363
A50481	Compound - Retaining, INSTAbond 124	MIL-S-46163 Type II, Grade N
A50547	Compound - Threadlocking - Permabond MM115	MIL-S-46163, Type II, Grade N
A50548	Primer - Adhesive - Permabond ASC10	MIL-S-46163 Grade F
C50088	Primer - Adhesive (MIL-S-46163 Grade F)	MIL-S-46163
D00633	Grease - Aircraft General Purpose	BMS3-33
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
2	Guide arm	52-11-21-01-240	SIA ALL
7	Cotter pin	52-11-21-01-025	SIA ALL
37	Spring pin	52-11-21-01-137	SIA ALL

E. Location Zones

Zone	Area
831	Forward Entry Door

ECCN 9E991 BOEING PROPRIETARY - See title page for details

F. Access Panels

Number	Name/Location
831	Forward Entry Door

G. Forward Entry Door Guide Arm and Roller Installation

SUBTASK 52-11-21-820-001

(1) If a new guide arm [2] is being installed, make sure that the length of the new guide arm [2] is the same as the guide arm [2] that was removed.

(a) If it is necessary, use the adjuster nut [31] to change the length of the guide arm [2]:

NOTE: This is an initial adjustment for a new guide arm.

1) Remove the bolt [27], washer [28], washer [29], and nut [30] that attach the lock channel [26] to the guide arm [2].

2) Remove the lock channel [26].

3) Loosen the jamnut [25].

4) Change the length of the guide arm rod end [24] with the adjuster nut [31].

5) Make sure that the adjuster nut [31] will align with the lock channel [26].

6) Tighten the jamnut [25].

7) Put the lock channel [26] in its correct position on the guide arm [2].

8) Apply corrosion inhibiting material, G50136, to mating surfaces of the bolt [27], washer [28], washer [29], nut [30], lock channel [26], and guide arm [2].

9) Immediately install the bolt [27], washer [28], washer [29], and nut [30] to hold the lock channel [26] for the adjuster nut [31] in its position.

SUBTASK 52-11-21-420-001

(2) Connect the guide arm [2] and roller [20] to the fuselage at the guide plates:

(a) Put the guide arm [2] in position parallel to the fuselage with the roller [20] forward and lock channel [26] on the inboard side.

(b) Put the roller [20] in the open end of the guide plate tracks at the forward edge of the guide plates.

(c) Move the guide arm [2] and roller [20] to the aft end of the guide plate tracks.

SUBTASK 52-11-21-420-002

(3) Install the hold open mechanism on the guide arm [2]:

(a) Turn the guide arm [2] until the face with the lock channel [26] is nearest personnel.

(b) If the shafts [14] were removed from the guide arm [2], do these steps:

1) Apply grease, D00633, to the shafts [14].

2) Put the shafts [14] in the guide arm [2].

(c) Apply adhesive, A01076, to the two washers [19].

(d) Put the washers [19] on the shafts [14] and remove excess adhesive, A01076.

1) Wait until adhesive, A01076, cures.

(e) Put the lever [21] on the washer [19] and shaft [14] nearest to the roller end of the guide arm [2].

1) Make sure that the lever [21] is parallel to the axis of the guide arm [2] and points to the roller [20].

(f) Apply corrosion inhibiting material, G50136, to the mating surfaces of the screw [22].

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(g) Immediately install the screw [22] and washer [13] to attach the lever [21] to the shaft [14].

(h) Put the cam [23] on the washer [19] and other shaft [14].

1) Make sure that the lobe of the cam [23] points up.

(i) Apply corrosion inhibiting material, G50136, to the mating surfaces of the screw [22].

(j) Immediately install the screw [22] and washer [13] to attach the cam [23] to the shaft [14].

(k) Turn the guide arm [2] until the face with the lock channel [26] is away from personnel.

(l) Apply adhesive, A01076, to the two washers [19].

(m) Put the washers [19] on the shafts [14] and remove excess adhesive, A01076.

1) Wait until adhesive, A01076, cures.

(n) Put the link [18] on the washer [19] and shaft [14] nearest to the roller end of the guide arm [2].

1) Make sure that the link [18] is parallel to the lever [21] and slotted end points to the roller [20].

(o) Put the cam [15] on the washer [19] and other shaft [14].

1) Make sure that the cam [15] is parallel to the axis of the guide arm [2] and lobe points away from the roller [20].

(p) Put the spring [17] on the cam [15] and link [18].

1) Make sure that the ends of the spring [17] point down.

(q) Install the spacers [16] to attach the spring [17], cam [15], and link [18], to the shafts [14].

(r) Connect the ends of the spring [17] to the cam [15] and link [18].

(s) If it was removed, install a new spring pin [37] to the guide arm [2].

SUBTASK 52-11-21-420-003

(4) Connect the upper radius link [8] and lower radius link [10] to the guide arm [2]:

(a) Put the guide arm [2] in position between the upper radius link [8] and lower radius link [10].

(b) Put grease, D00633, on the pin [9].

NOTE: Do not get grease on screw threads.

(c) Make sure that the pin [9] threads, washer [36], and screw [12] are clean.

(d) Install the pin [9], bushing [35], washers [36], upper radius link [8], and lower radius link [10] to the guide arm [2].

(e) Put the key of the keywasher [11] into the keyway of pin [9].

(f) Make sure that the keywasher [11] is engaged in the keyway of pin [9].

(g) Do these steps to install the screw [12]:

1) Remove preload from guide arm [2].

NOTE: Preloading on the guide arm can prevent correct installation of the screw.

a) Move the forward entry door [1] and guide arm [2].

b) Make sure that the guide arm [2] rod end bearing does not touch the clevis bracket on the forward entry door [1].

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2) Put adhesive primer, C50088, Permabond ASC10 primer, A50548, or Loctite 7649 Primer, A50129, to the threads of the screw [12] and slot of pin [9] where it connects with the keywasher [11].

a) Make sure that all the mating surfaces are clean and free of grease (SOPM 20-30-03).

3) Put compound, A50481, Permabond MM115 compound, A50547, or Loctite 242 compound, A00648, to the threads of the screw [12] and slot of pin [9] where it connects with the keywasher [11].

4) Install the screw [12].

5) Tighten the screw [12] to 20.0 in-lb (2.26 N·m).

(h) Make sure that the pin [9] has no horizontal movement.

NOTE: There can be up to 0.048 in. (1.219 mm) of vertical movement of the pin.

NOTE: As preventative maintenance, Boeing recommends marking an ink stripe across the screw/keywasher surfaces and check periodically for misalignment. Misalignment indicates screw movement that could result in retention failure.

NOTE: As a reference, the maximum distance from the upper radius link (upper side) to the lower radius link (lower side), dimension “L”, is 1.285 in. (32.639 mm) (View A-A, Figure 401).

SUBTASK 52-11-21-020-005

WARNING BE CAREFUL WHEN YOU CONNECT OR DISCONNECT THE GUIDE ARM TO THE ENTRY DOOR. THE DOOR CAN HIT THE FUSELAGE. IF YOU DO NOT OBEY, DAMAGE TO EQUIPMENT AND INJURY TO THE PERSONNEL CAN OCCUR.

(5) Connect the guide arm [2] to the forward entry door [1]:

(a) Move the forward entry door [1] until the rod end [24] of the guide arm [2] is in position in the door structure.

(b) Apply grease, D00633, to the bolt [3].

(c) Apply corrosion inhibiting material, G50136, to the mating surface of the rod end [24].

(d) Immediately install the bolt [3], washer [4], washer [6], nut [5], and new cotter pin [7] to attach the rod end [24] to the door structure.

NOTE: The bolt can be installed head down or head up depending on the limitation of access to the guide arm rod end.

SUBTASK 52-11-21-820-002

(6) Do an adjustment of the guide arm [2], do this task: Forward Entry Door Adjustment, TASK 52-11-00-820-801.

NOTE: Do only the guide arm adjustment.

SUBTASK 52-11-21-410-001

(7) Do this task: Forward Entry Door Lining Installation, TASK 52-11-31-400-801.

SUBTASK 52-11-21-710-001

(8) Do a test on the forward entry door [1] as follows:

(a) Close and open the forward entry door [1].

(b) Make sure that the forward entry door [1] operates easily and smoothly.

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H. Put the Airplane Back to Its Usual Condition

SUBTASK 52-11-21-410-002

(1) Close this access panel:

Number	Name/Location
831	Forward Entry Door

SUBTASK 52-11-21-480-001

(2) Remove the work platform, COM-1523, from the forward entry door [1].

——— END OF TASK ———

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FORWARD ENTRY DOOR LINING - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the forward entry door lining [1].

(2) An installation of the forward entry door lining [1].

TASK 52-11-31-000-801

2. Forward Entry Door Lining Removal

(Figure 401)

A. References

Reference	Title
25-66-01-000-801	Escape Slide Pack and Cover 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-5216	Wrench - Spanner, Main Entry Door Assist Handle Part #: F70336-4 Supplier: 81205 Opt Part #: F70336-1 Supplier: 81205

C. Location Zones

Zone	Area
831	Forward Entry Door

D. Access Panels

Number	Name/Location
831	Forward Entry Door

E. Prepare for the Removal

SUBTASK 52-11-31-860-001

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Install the work platform, COM-1523, outboard of the door.

SUBTASK 52-11-31-010-001

(2) Get access to the door as follows:

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(a) Make sure that the door is closed and latched.

(b) Do this task: Escape Slide Pack and Cover Removal, TASK 25-66-01-000-801.

(c) Fully open this access panel:

Number	Name/Location
831	Forward Entry Door

F. Removal of the Forward Entry Door Lining

SUBTASK 52-11-31-020-001

(1) Remove the interior handle [3] from the door.

(a) Remove the cover [8] on the interior handle [3] to get access to the fasteners that attach the interior handle [3] to the hub [4].

(b) Remove the cotter pins [10], nuts [9], and washers [11] that attach the interior handle [3] to the hub [4].

(c) Remove the interior handle [3].

(d) Remove the bolts [5] from the hub [4] if they are loose.

NOTE: The bolts are bonded to the hub and it is not necessary to remove them if the bond is tight.

SUBTASK 52-11-31-020-002

(2) Remove the upper cover plate [12] and lower cover plate [6] from the door lining [1].

(a) Remove the screw [7] that attaches the lower cover plate [6] to the door lining [1].

(b) Pull the lower cover plate [6] away from the upper cover plate [12].

(c) Pull the upper cover plate [12] down to disengage it from the cutout in the door lining [1] and remove from the door.

SUBTASK 52-11-31-020-003

(3) Remove the assist handle [2] from the door.

(a) Loosen the handle nuts [16] with the entry door assist handle wrench, SPL-5216, that attach the assist handle [2] to the door.

NOTE: The loosen direction is clockwise when you face the door lining surface.

(b) Remove the assist handle [2] from the door.

(c) Hold the handle nuts [16] and remove the bolts [14], collars [15], and washers [13] that attach the handle nuts [16] to the door.

(d) Remove the handle nuts [16] from the door.

SUBTASK 52-11-31-020-004

(4) Disconnect the door lining [1] from the door.

(a) Remove the nuts [17] that attach the upper part of the door lining [1] to the door.

(b) Remove the nuts [20] that attach the lower part of the door lining [1] to the door.

(c) Remove the screws [19] that attach the lower part of the door lining [1] to the door.

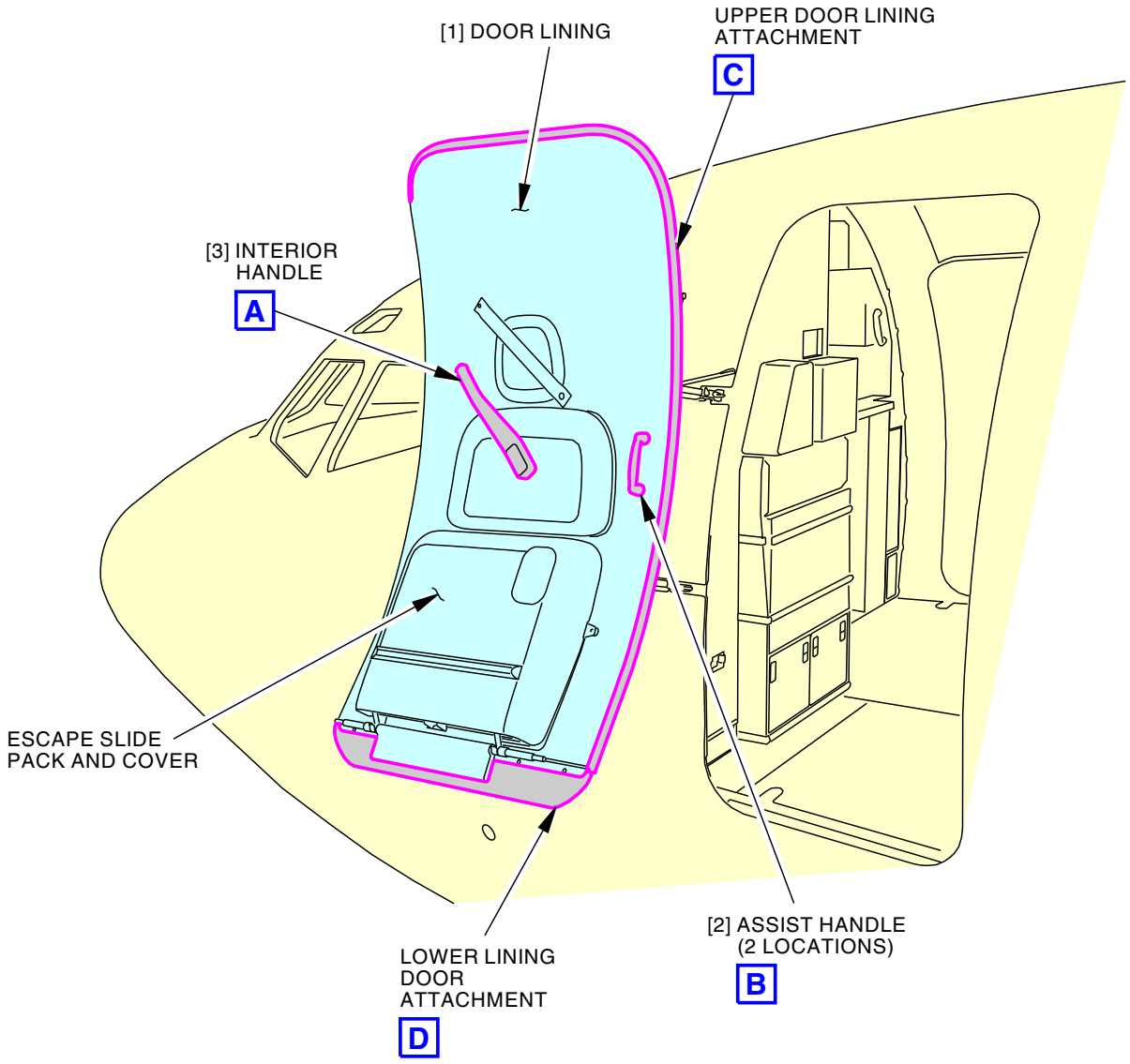
(d) Hold the door lining [1].

(e) Remove the screws [18] that attach the forward and aft edges of the door lining [1] to the door.

(f) Carefully lift the door lining [1] and remove it from the door.

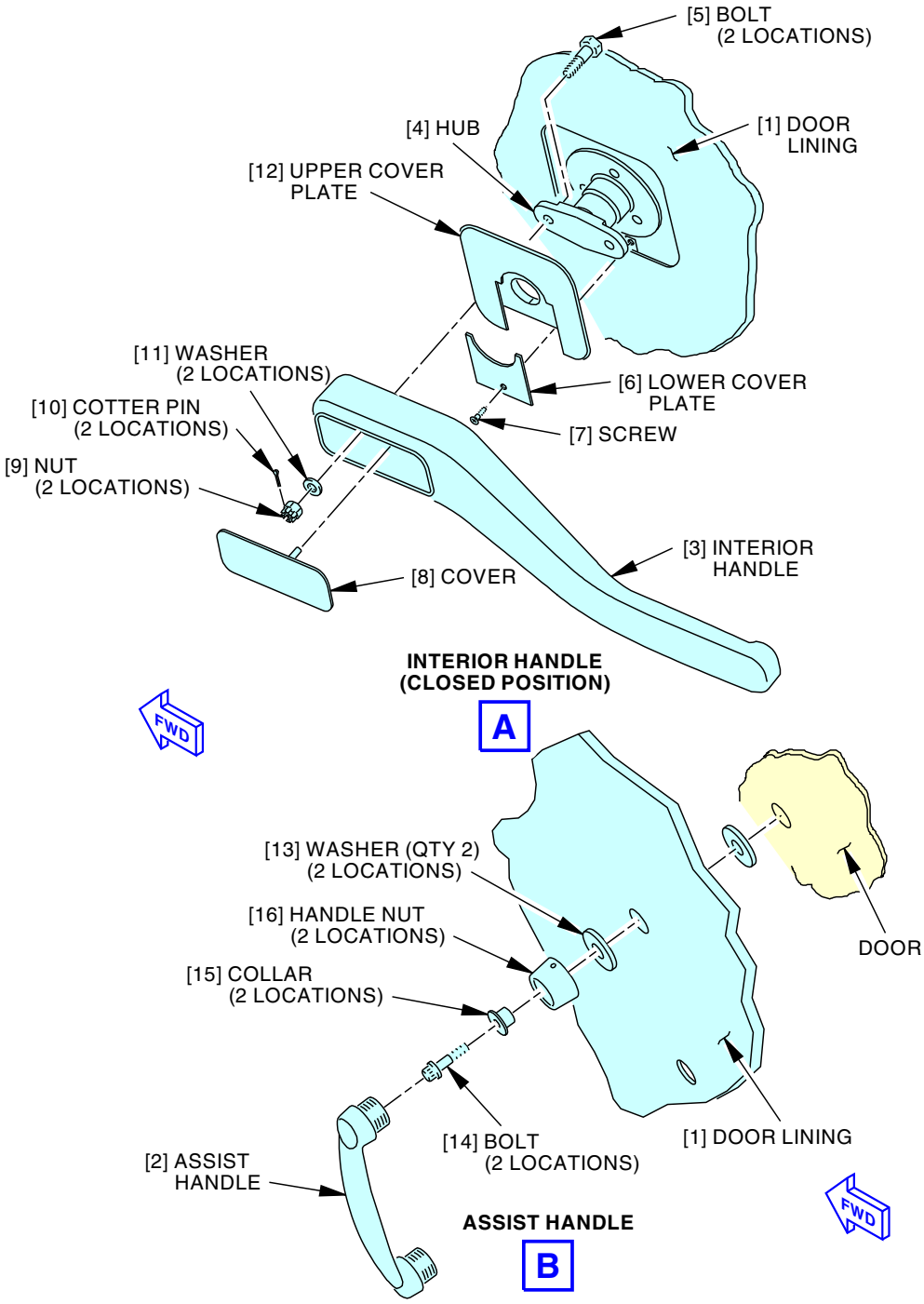
END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Forward Entry Door Lining Installation
Figure 401/52-11-31-990-802 (Sheet 1 of 3)

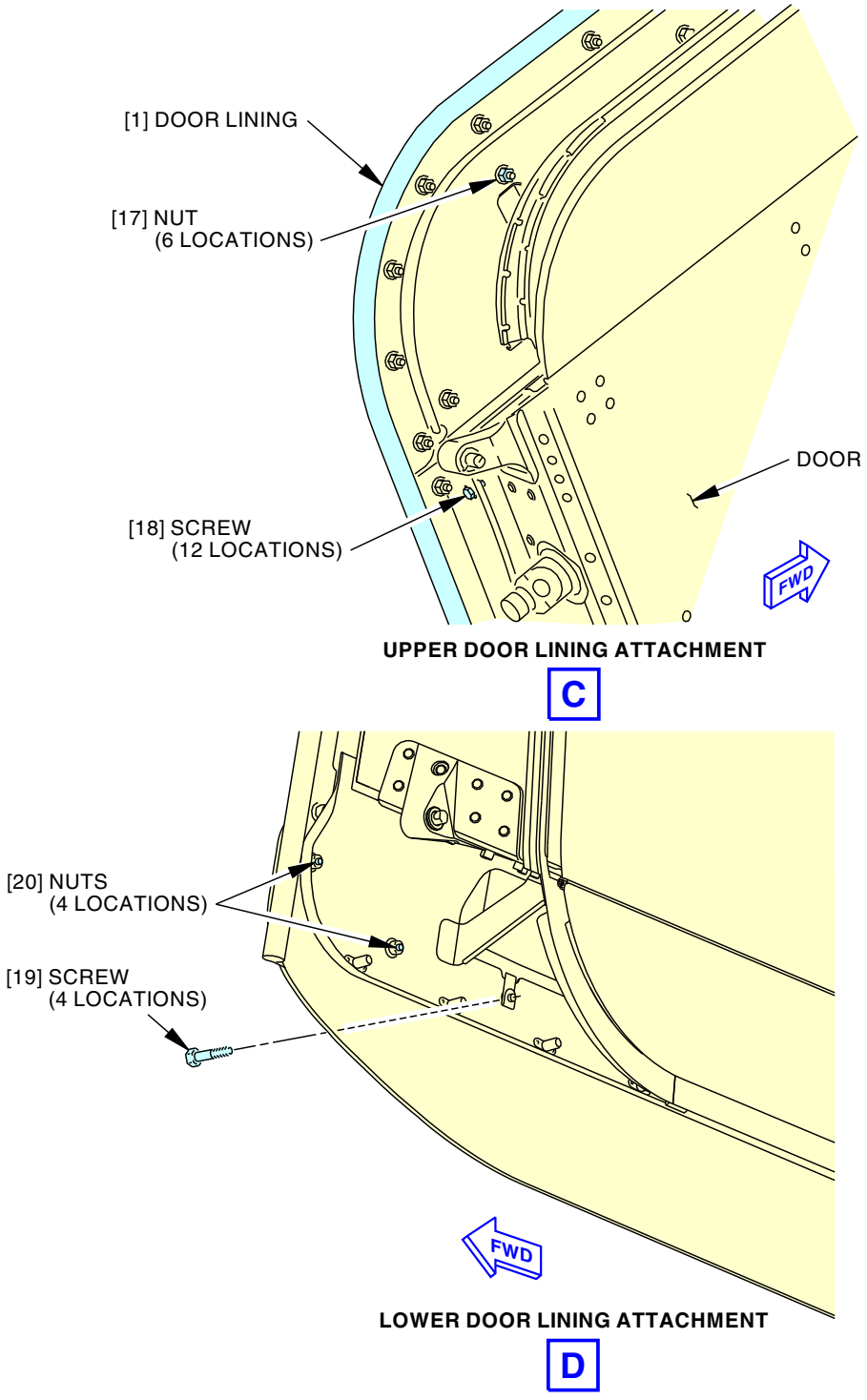
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Forward Entry Door Lining Installation
Figure 401/52-11-31-990-802 (Sheet 2 of 3)

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Forward Entry Door Lining Installation
Figure 401/52-11-31-990-802 (Sheet 3 of 3)

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TASK 52-11-31-400-801

3. Forward Entry Door Lining Installation

(Figure 401)

A. References

Reference	Title
25-66-01-400-801	Escape Slide Pack and Cover 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-5216	Wrench - Spanner, Main Entry Door Assist Handle Part #: F70336-4 Supplier: 81205 Opt Part #: F70336-1 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
A00555	Adhesive - For Bonding Decorative Laminate, 2 Part, Sprayable	BMS5-127 Type II

D. Location Zones

Zone	Area
831	Forward Entry Door

E. Access Panels

Number	Name/Location
831	Forward Entry Door

F. Installation of the Forward Entry Door Lining

SUBTASK 52-11-31-420-002

(1) Install the door lining [1] on the door.

(a) Carefully hold the door lining [1] and put it in position on the door.

(b) Install the screws [18] that attach the forward and aft edges of the door lining [1] to the door.

(c) Install the nuts [17] to attach the upper part of the door lining [1] to the door.

(d) Install the nuts [20] to attach the lower part of the door lining [1] to the door.

(e) Install the screw [19] to attach the lower part of the door lining [1] to the door.

SUBTASK 52-11-31-420-003

(2) Install the assist handle [2].

(a) Put the handle nuts [16] in position on the door lining [1].

(b) Install the bolts [14], collars [15], and washers [13] to attach the handle nuts [16] to the door.

(c) Put the assist handle [2] in position against the handle nuts [16].

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(d) Tighten the handle nuts [16] counterclockwise with the entry door assist handle wrench, SPL-5216, to attach the assist handle [2] to the door.

SUBTASK 52-11-31-420-004

(3) Install the upper cover plate [12] and lower cover plate [6] on the door.

(a) Put the upper cover plate [12] into the cutout in the door lining [1].

(b) Connect the lower cover plate [6] to the upper cover plate [12].

(c) Install the screw [7] to attach the lower cover plate [6] to the door lining [1].

SUBTASK 52-11-31-420-005

(4) Install the interior handle [3].

(a) Install the bolt [5] in the hub [4] with adhesive, A00555, if they are loose.

(b) Put the interior handle [3] in its correct position over the bolt [5] in the hub [4].

(c) Install the washers [11], nuts [9], and new cotter pins [10], to attach the interior handle [3] to the hub [4].

(d) Install the cover [8] on the interior handle [3].

G. Put the Airplane Back to Its Usual Condition

SUBTASK 52-11-31-410-001

(1) Install the escape slide pack and cover (TASK 25-66-01-400-801).

SUBTASK 52-11-31-840-001

(2) Close this access panel:

Number	Name/Location
831	Forward Entry Door

SUBTASK 52-11-31-480-001

(3) Remove the work platform, COM-1523, away from the door.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FORWARD ENTRY DOOR ASSIST SPRINGS - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the forward entry door assist spring [5], assist spring [6], and assist spring [7].

(2) An installation of the forward entry door assist spring [5], assist spring [6], and assist spring [7].

B. The forward entry door assist spring [5], assist spring [6], and assist spring [7] are referred to as the "assist springs" in this procedure.

TASK 52-11-41-000-801

2. Forward Entry Door Assist Springs Removal

(Figure 401)

A. Location Zones

Zone	Area
831	Forward Entry Door

B. Access Panels

Number	Name/Location
831	Forward Entry Door
831AZ	Forward Entry Door - Torque Tube Access

C. Prepare for the Removal

SUBTASK 52-11-41-860-001

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure that a stand is installed outboard of the door.

SUBTASK 52-11-41-410-001

(2) Get access to assist spring [5], assist spring [6], and assist spring [7] as follows:

WARNING BE CAREFUL WHEN YOU OPERATE THE DOOR FROM A MAINTENANCE STAND. IT IS NOT EASY TO OPERATE THE DOOR FROM THE SMALL PLATFORM AREA AND DURING BAD WEATHER CONDITIONS. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

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(WARNING PRECEDES)

CAUTION

DO NOT LET THE DOOR HIT THE FUSELAGE. DAMAGE TO THE DOOR AND THE FUSELAGE WILL OCCUR.

(a) Open this door:

Number	Name/Location
831	Forward Entry Door

(b) Make sure that there is no load on the assist spring [5], assist spring [6], and assist spring [7]. To remove the load, do these steps:

1) Move the forward entry door to the open position.

2) Stop when the door is approximately 60°arc (1 rad) from the full open position

NOTE: With the door in this position, the hazardous energy in the assist springs is released.

3) Keep the door in this position for the remaining assist springs removal procedure.

SUBTASK 52-11-41-010-001

(3) Remove this access panel:

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access

(a) Remove the screws [2] that attach the panel reveal [3] to the fuselage.

(b) Remove the panel reveal [3].

D. Removal of the Forward Entry Door Assist Springs

SUBTASK 52-11-41-020-001

(1) Disconnect the assist spring [5], assist spring [6], and assist spring [7] from the torque tube [22] and torque tube [31] as follows:

(a) Remove the bolts [30], spring retainers [24],bushings [28], bushings [25], and nuts [23] that attach the assist spring [5] and assist spring [7] to the assist spring [6].

(b) Remove the bolt [17], washer [16], washer [15], bushing [14], washer [13], and nut [12] that attach the assist spring [6] to the ttorque tube [22] and torque tube [31] through the center sleeve [10]].

SUBTASK 52-11-41-020-002

(2) Disconnect the S-12 stop fitting [35] from the fuselage frame:

(a) Remove the bolts [34], washers [33], and nuts [32] that attach the S-12 stop fitting [35] to the frame.

(b) Remove the S-12 stop fitting [35] from the fuselage frame.

SUBTASK 52-11-41-020-003

(3) Remove the assist spring [5], assist spring [6], assist spring [7], torque tube [22], and torque tube [31] from the fuselage:

(a) Put marks on the spigots and torque tube to show the alignment of the parts.

NOTE: These marks help the installation that will occur.

(b) Remove the bolt [26], washer [27], bushing [21], washer [18], washer [20], and nut [19] that attach the torque tube [22], and lower sleeve [8] to the lower hinge spigot [9].

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(c) Remove the bolt [26], washer [27], bushing [21], washer [18], washer [20], and nut [19] that attach the torque tube [31] and upper sleeve [4] to the upper hinge spigot [11].

(d) Push the torque tube [22] and torque tube [31] together to make sufficient clearance to remove them from the fuselage structure.

(e) Remove the assist spring [7] and lower sleeve [8] from the torque tube [22].

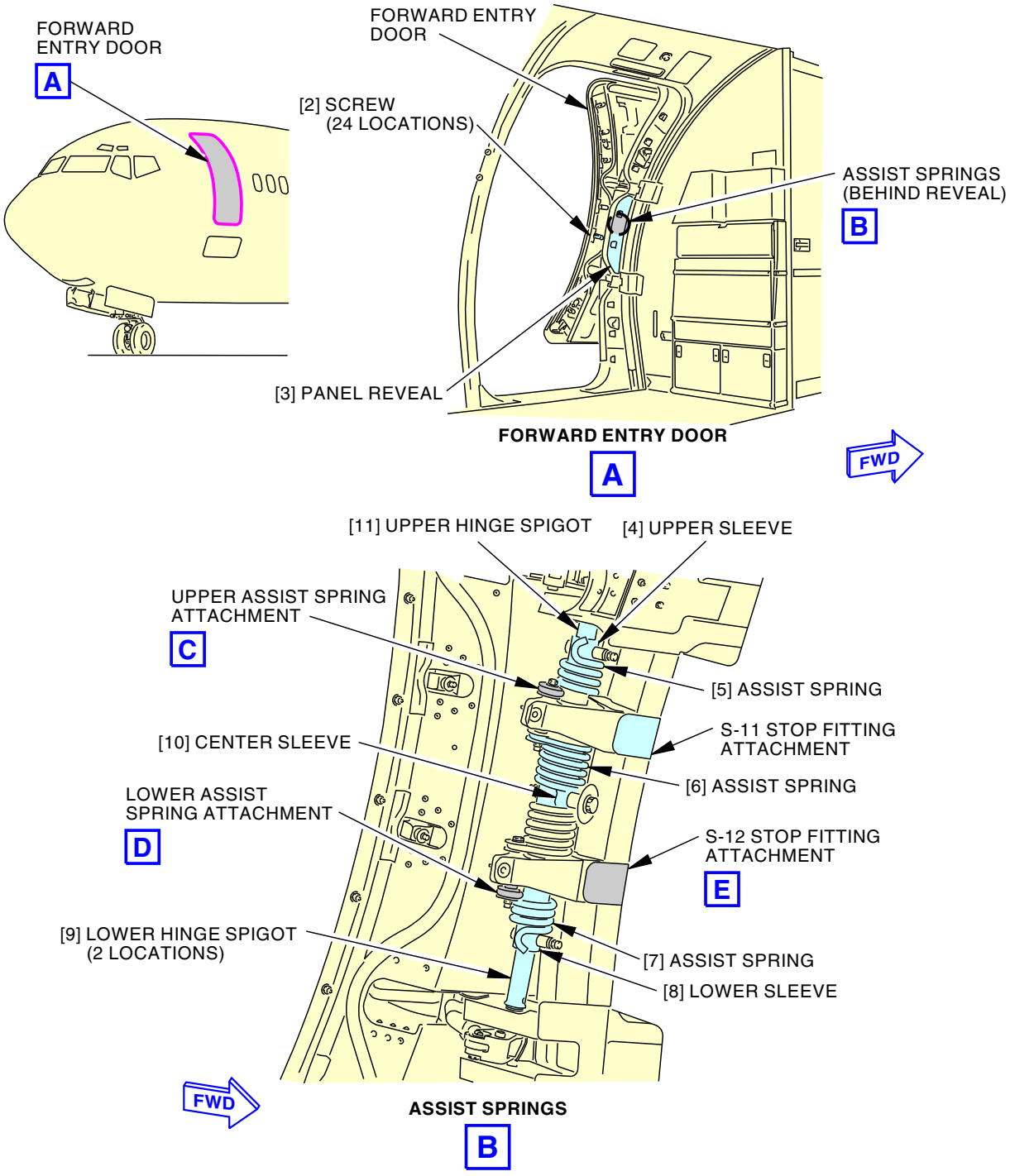
(f) Remove the S-12 stop fitting [35] from the torque tube [22].

(g) Remove the torque tube [22], torque tube [31], upper sleeve [4], center sleeve [10], and assist spring [6] from the opening in the fuselage structure.

(h) Remove the assist spring [5] from the S-12 stop fitting [35].

——— END OF TASK ———

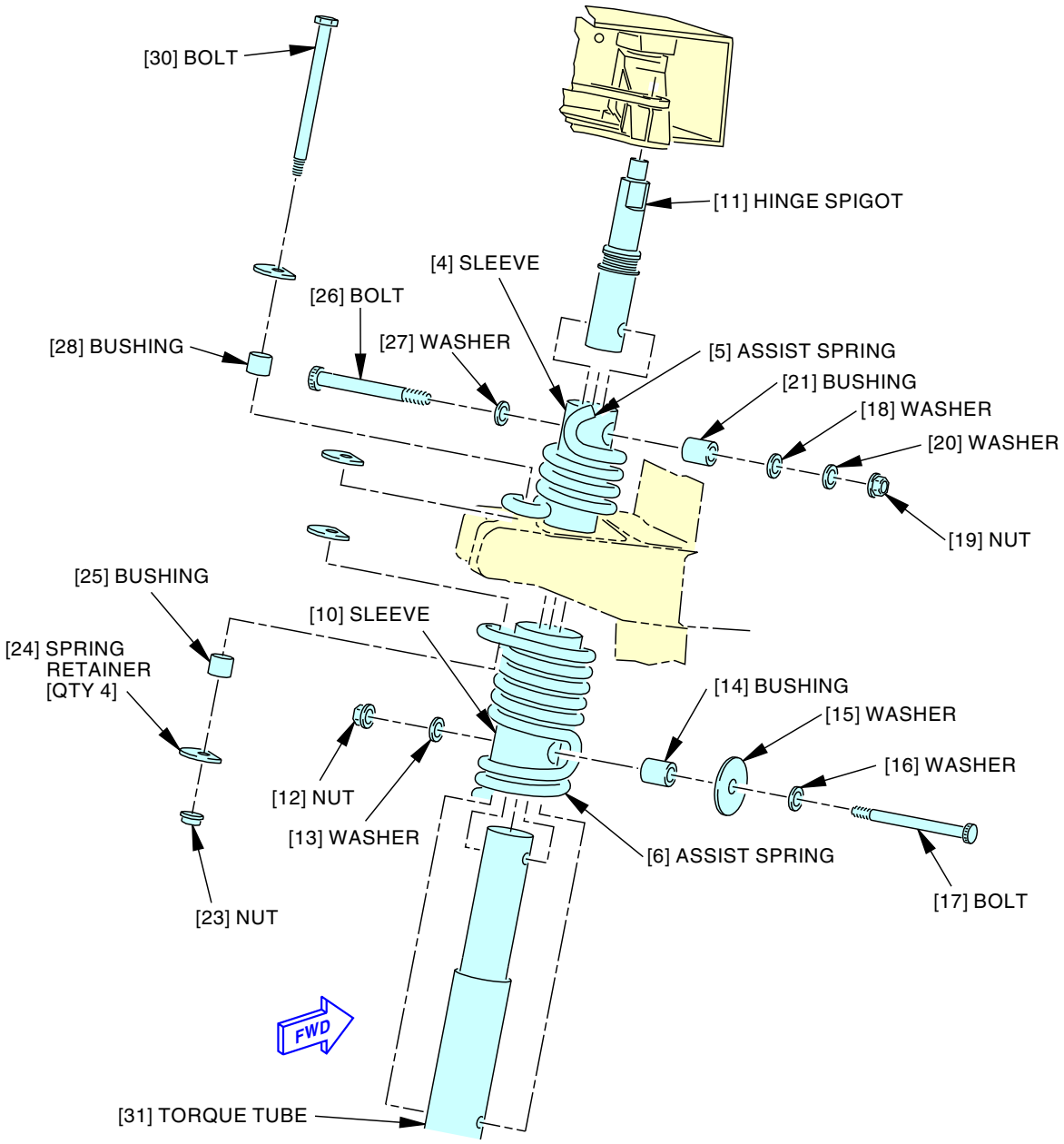
ECCN 9E991 BOEING PROPRIETARY - See title page for details



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Forward Entry Door Assist Spring Installation
Figure 401/52-11-41-990-802 (Sheet 1 of 4)

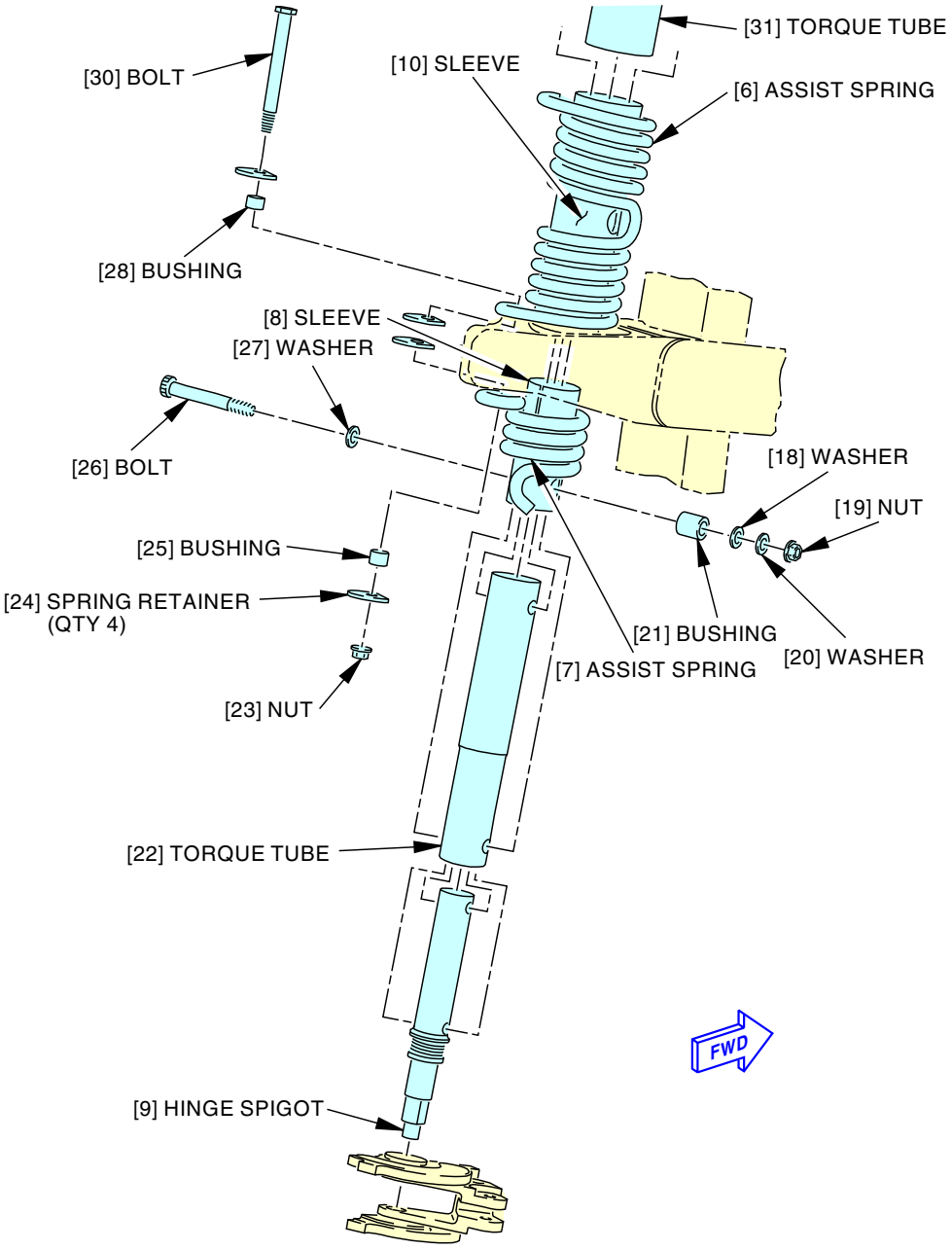
ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415765 S00061538847_V1

Forward Entry Door Assist Spring Installation
Figure 401/52-11-41-990-802 (Sheet 2 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



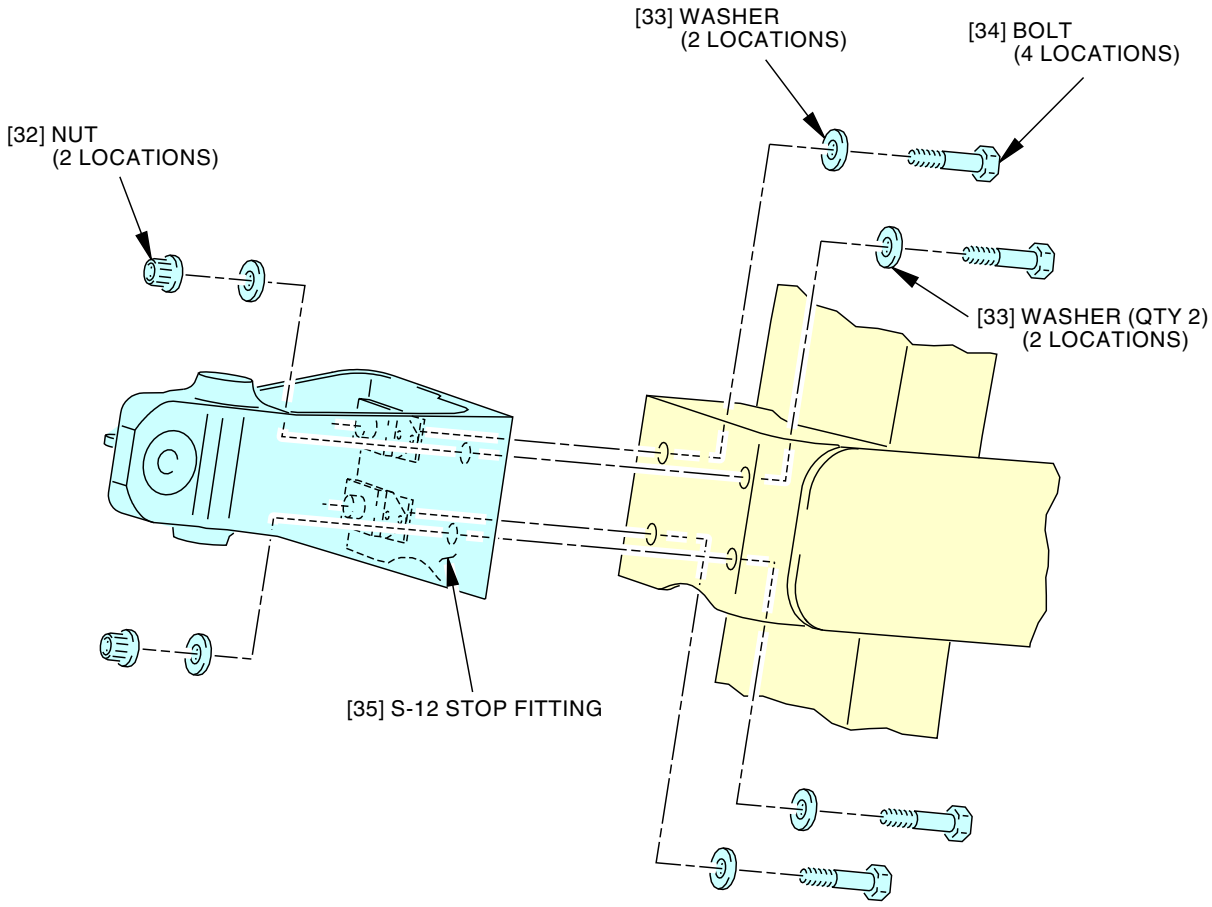
LOWER ASSIST SPRING ATTACHMENT

D

2415766 S00061538848_V1

Forward Entry Door Assist Spring Installation
Figure 401/52-11-41-990-802 (Sheet 3 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415767 S00061538849_V1

Forward Entry Door Assist Spring Installation
Figure 401/52-11-41-990-802 (Sheet 4 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-11-41-400-801

3. Forward Entry Door Assist Springs Installation

(Figure 401)

A. Consumable Materials

Reference	Description	Specification
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
D00633	Grease - Aircraft General Purpose	BMS3-33

B. Location Zones

Zone	Area
831	Forward Entry Door

C. Access Panels

Number	Name/Location
831	Forward Entry Door

D. Installation of the Forward Entry Door Assist Springs Installation.

SUBTASK 52-11-41-420-001

CAUTION OBEY THE INSTALLATION PROCEDURE FOR THE ASSIST SPRINGS. THE DOOR WILL NOT OPERATE PROPERLY IF YOU INSTALL THE ASSIST SPRINGS INCORRECTLY.

(1) If necessary, assemble torque tube [22], torque tube [31] and the assist spring [6]:

(a) Apply a light layer of grease, D00633, to the mating surfaces of the torque tube [22] and torque tube [31] before installation.

(b) Put the torque tube [22] into the torque tube [31].

(c) Put the center sleeve [10] over the torque tube [22] and torque tube [31].

(d) Put the assist spring [6] over the center sleeve [10].

NOTE: Make sure that the closed end of the coil in the middle of the assist spring [6] is facing forward.

(e) Put the upper sleeve [4] over the torque tube [31].

SUBTASK 52-11-41-420-002

(2) Install the torque tube [22], torque tube [31], assist spring [5], assist spring [6], and assist spring [7] in the fuselage:

(a) Put the assist spring [5] in position above the S-11 stop fitting.

NOTE: Make sure that the coil that holds the bolt [30] is in the down position and facing aft.

(b) Put the assembled torque tube [22], torque tube [31], upper sleeve [4], center sleeve [10], and assist spring [6] in their position in the fuselage frame.

(c) Put the S-12 stop fitting [35] over the torque tube [22].

(d) Put the lower sleeve [8] and assist spring [7] over the torque tube [22].

NOTE: Make sure that the coil that holds the bolt [30] is in the up position and facing aft.

(e) Pull the torque tube [22] and torque tube [31] apart to move the ends of the torque tube [22] and torque tube [31] fully over the lower hinge spigot [9] and upper hinge spigot [11].

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(f) Align the bolt holes in the ends of the torque tube [22] and torque tube [31] with the bolt holes in the upper sleeve [4], lower sleeve [8], lower hinge spigot [9], and upper hinge spigot [11].

(g) Install the bolt [26], washer [27], bushing [21], washer [18], washer [20], and nut [19] to attach the torque tube [31] to the hinge upper hinge spigot [11].

1) Make sure that the head of bolt [26] is on the near side.

(h) Torque the nut [19] to 70 in-lb (7.9 N·m) - 90 in-lb (10.2 N·m).

1) Make sure that the nut [19] touches the shank of the bolt [26].

2) Make sure that there is a minimum of 0.016 in. (0.406 mm) between the washer [27] and upper sleeve [4].

(i) Install the bolt [26], washer [27], bushing [21], washer [18], washer [20], and nut [19] to attach the torque tube [22] to the lower hinge spigot [9].

1) Make sure that the head of bolt [26] is on the near side.

(j) Torque the nut [19] to 70 in-lb (7.9 N·m) - 90 in-lb (10.2 N·m).

1) Make sure that the nut [19] touches the shank of the bolt [26].

2) Make sure that there is a minimum of 0.016 in. (0.406 mm) gap between the washer [27] and lower sleeve [8].

SUBTASK 52-11-41-420-003

(3) Connect the S-12 stop fitting [35] to the fuselage frame as follows:

(a) Put the S-12 stop fitting [35] in position against the fuselage frame.

(b) Install the bolt [34], washer [33], and nut [32] to attach the S-12 stop fitting [35] to the fuselage frame.

SUBTASK 52-11-41-420-004

(4) Connect the assist spring [5], assist spring [6], and assist spring [7] to the torque tube [22] and torque tube [31]:

(a) Align the bolt holes in the center sleeve [10] with the bolt holes in the torque tube [22] and torque tube [31].

(b) Install the bolt [17], washer [16], washer [15], bushing [14], washer [13], and nut [12] to connect the assist spring [6], center sleeve [10],torque tube [22] and torque tube [31].

(c) Torque the nut [12] to 70 in-lb (7.9 N·m) - 90 in-lb (10.2 N·m).

1) Make sure that the nut [12] touches the shank of the bolt [17].

2) Make sure that there is a minimum of 0.016 in. (0.406 mm) gap between the washer [13] and center sleeve [10].

(d) Before you install them, apply compound, C00528, to the bolts [30] and the spring retainers [24].

(e) Install the bolts [30], spring retainers [24], bushings [28], bushings [25], and nuts [23] to attach the assist spring [5] and assist spring [7] to the assist spring [6].

SUBTASK 52-11-41-840-001

(5) Install the panel reveal [3]:

(a) Put the panel reveal [3] in position on the fuselage.

(b) Install the screw [2] to attach the panel reveal [3] to the fuselage.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-11-41-710-001

(6) Do a test on this access panel:

Number	Name/Location
831	Forward Entry Door

(a) Close this access panel:

Number	Name/Location
831	Forward Entry Door

(b) Open this access panel:

Number	Name/Location
831	Forward Entry Door

(c) Make sure that it opens easily and smoothly.

SUBTASK 52-11-41-410-002

(7) Close this access panel:

Number	Name/Location
831	Forward Entry Door

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FORWARD ENTRY DOOR SNUBBER - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the forward entry door snubber [21].

(2) An installation of the forward entry door snubber [21].

B. The forward entry door will be called the door in this procedure.

TASK 52-11-51-000-801

2. Forward Entry Door Snubber Removal

(Figure 401)

A. References

Reference	Title
52-11-31-000-801	Forward Entry Door Lining 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Location Zones

Zone	Area
831	Forward Entry Door

D. Access Panels

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access

E. Prepare for the Removal

SUBTASK 52-11-51-860-001

(1) Make sure that the door is safe:

(a) Make sure that the door is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE BRACKETS OF THE FLOOR-MOUNTED ESCAPE SLIDE. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN OPERATE WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Install the work platform, COM-1523, outboard of the door.

(d) Put the forward entry door in the full open position.

SUBTASK 52-11-51-010-001

(2) Do this task: Forward Entry Door Lining Removal, TASK 52-11-31-000-801.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-11-51-020-001

(3) Remove the four bolts [1] and washers [2] to remove the bracket [3] from the door.

SUBTASK 52-11-51-010-002

(4) Open this access panel:

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access

SUBTASK 52-11-51-010-003

(5) Remove the 32 fasteners [4] to remove the access panel [5] to get access to the snubber [21].

F. Forward Entry Door Snubber Removal

SUBTASK 52-11-51-020-002

CAUTION

DO NOT MOVE THE DOOR WITH THE SNUBBER REMOVED. THE DOOR CAN MOVE QUICKLY WITH THE SNUBBER REMOVED. IF THE DOOR MOVES QUICKLY TO THE OPEN OR CLOSED POSITION, IT CAN CAUSE DAMAGE TO THE EQUIPMENT.

(1) Do these steps to remove the snubber [21] from the door:

(a) Remove and discard the cotter pin [10].

(b) Remove the bolt [6], washers [7], washer [8], and nut [9] that attach the snubber [21] to the fuselage.

1) Make a record of the location of the washers [7] and washer [8] on the bolt [6].

(c) Make a line to show the alignment of the snubber [21] attachment fitting to the door.

(d) Remove the filler [18] to get access to the fastener that attaches the rod end [12] to the snubber [21] attachment fitting.

(e) Remove and discard the cotter pin [17].

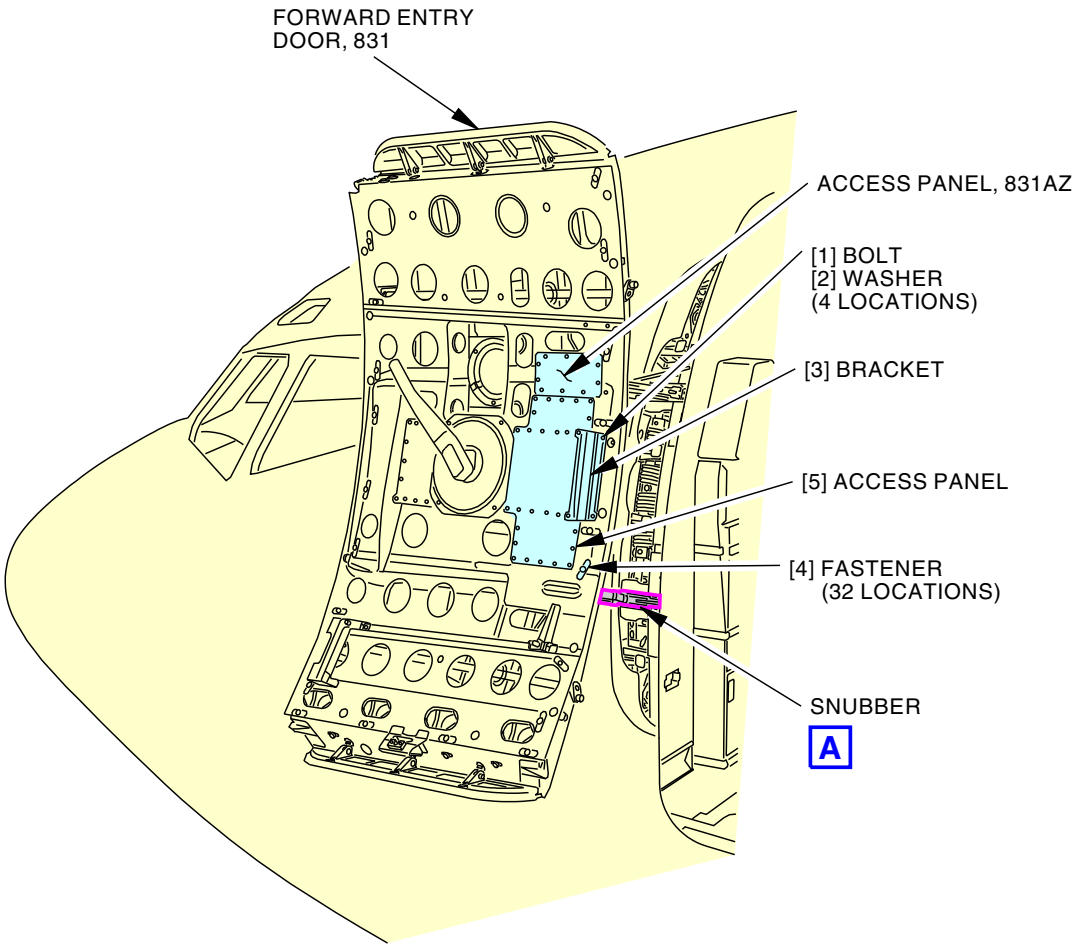
(f) Remove the bolt [13], washer [14], washers [15], and nut [16] that attach the rod end [12] to the snubber [21] attachment fitting.

1) Make a record of the location of the washer [14] and washers [15] on the bolt [13].

(g) Remove the snubber [21].

END OF TASK

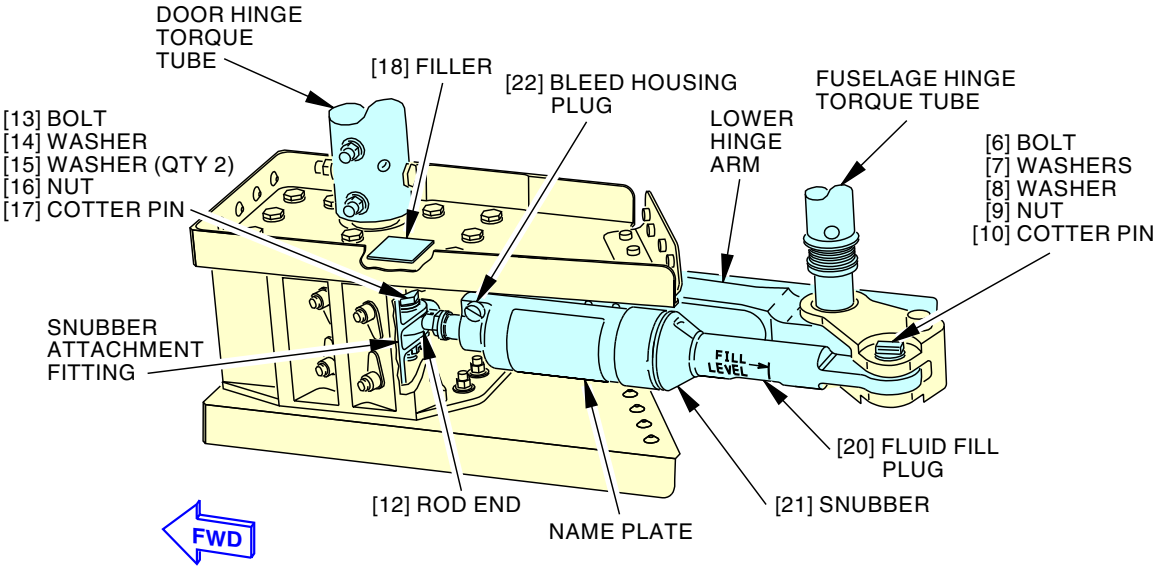
ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415768 S00061538854_V1

Snubber Installation
Figure 401/52-11-51-990-802 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415769 S00061538855_V3

Snubber Installation
Figure 401/52-11-51-990-802 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-11-51-400-801

3. Forward Entry Door Snubber Installation

(Figure 401)

A. References

Reference	Title
52-11-31-400-801	Forward Entry Door Lining 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Consumable Materials

Reference	Description	Specification
A01076	Adhesive - Synthetic Rubber	BAC5010 Type 93 (BMS5-95 Class B)
B00068	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002, MIL-E-51454 Type II
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

D. Location Zones

Zone	Area
831	Forward Entry Door

E. Access Panels

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access

F. Forward Entry Door Snubber Installation

SUBTASK 52-11-51-420-001

CAUTION DO NOT MOVE THE DOOR WITH THE SNUBBER REMOVED. THE DOOR CAN MOVE QUICKLY WITH THE SNUBBER REMOVED. IF THE DOOR MOVES QUICKLY TO THE OPEN OR CLOSED POSITION, IT CAN CAUSE DAMAGE TO THE EQUIPMENT.

(1) Do these steps to install the snubber [21] on the door:

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CAUTION MAKE SURE TO INSTALL THE SNUBBER WITH THE RAMP SIDE OF THE SNUBBER INBOARD. IF THE SNUBBER IS NOT INSTALLED WITH THE RAMP INBOARD, THE SNUBBER WILL CONTACT THE HINGE ARM WHEN THE DOOR IS CLOSED. THIS WILL CAUSE DAMAGE TO THE EQUIPMENT.

(a) Set the snubber [21] in its usual position on the door.

1) Make sure that you install the snubber [21] with the fluid fill plug [20] recess pointed down and the bleed housing plug [22] pointed up.

(b) Install the bolt [13], washer [14], washers [15], and nut [16] to attach the rod end [12] to the snubber attachment fitting.

(c) Install the bolt [6], washers [7], washer [8], and nut [9] to attach the snubber [21] to the fuselage structure.

(d) Install a new cotter pin [10] on the nut [9].

(e) Install a new cotter pin [17] on the nut [16].

(f) Do these steps to install the filler [18]:

WARNING DO NOT GET SOLVENTS IN YOUR MOUTH, EYES, OR SKIN. DO NOT BREATHE FUMES FROM SOLVENTS. REFER TO PRODUCT MATERIAL SAFETY DATA SHEETS (MSDS) AND LOCAL REQUIREMENTS FOR PROPER HANDLING. SOLVENTS ARE HAZARDOUS MATERIALS AND MAY BE FLAMMABLE OR HARMFUL TO THE ENVIRONMENT.

1) With a clean cotton wiper, G00034, soaked in solvent, B00184, or alcohol, B00068, clean the mating surfaces .

2) Dry the mating surfaces with a clean, dry cotton wiper, G00034.

3) Repeat the previous two steps until the cotton wiper, G00034, stays clean.

a) Replace dirty cotton wipers, G00034, with clean cotton wipers, G00034, when it is necessary.

4) Apply a thin layer of adhesive, A01076, to each mating surface.

5) Install the filler [18].

a) Apply sufficient pressure to make sure that the mating surfaces touch.

6) Let the adhesive, A01076, dry before you continue.

G. Forward Entry Door Snubber Installation Test

SUBTASK 52-11-51-710-001

(1) Do an installation test on the snubber [21]:

(a) Make sure that the door is fully open with the hold-open lock engaged.

(b) Make sure that more extension is available on the snubber [21].

H. Put the Airplane Back to Its Usual Condition

SUBTASK 52-11-51-410-001

(1) Install the 32 fasteners [4] to install the access panel [5] on the door.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-11-51-410-002

(2) Close this access panel:

Number	Name/Location
831AZ	Forward Entry Door - Torque Tube Access

SUBTASK 52-11-51-420-002

(3) Install the four bolts [1] and four washers [2] to install the bracket [3] on the door.

SUBTASK 52-11-51-410-003

(4) Do this task: Forward Entry Door Lining Installation, TASK 52-11-31-400-801

SUBTASK 52-11-51-410-004

(5) Make sure that the door is closed and latched.

NOTE: This will make sure the door is safe.

SUBTASK 52-11-51-080-001

(6) Remove the work platform, COM-1523.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FORWARD ENTRY DOOR GATE - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) The removal of the upper or lower forward entry door gate [3].

(2) The installation of the upper or lower forward entry door gate [3].

TASK 52-11-61-000-801

2. Forward Entry Door Gate - Removal

Figure 401

A. References

Reference	Title
52-09-14-000-801	Bulb and Diaphragm Seal Removal (P/B 401)
52-11-31-000-801	Forward Entry Door Lining 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
COM-1540	Stand - Work, General Purpose Part #: AM-1737 Supplier: 9M323 Opt Part #: MODEL 136 Supplier: 2S363

C. Location Zones

Zone	Area
831	Forward Entry Door

D. Prepare for Removal

SUBTASK 52-11-61-840-001

(1) Make sure that the door is safe as follows:

(a) The door is closed and latched.

WARNING MAKE SURE THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

(b) The girt bar is not engaged in the floor-mounted escape slide brackets.

SUBTASK 52-11-61-480-001

(2) Put a work stand, COM-1540, outboard of the door.

SUBTASK 52-11-61-010-001

(3) Remove the door linining.

(a) Do this task: Forward Entry Door Lining Removal, TASK 52-11-31-000-801.

E. Procedure

SUBTASK 52-11-61-010-002

(1) Remove only the bulb [6] from the gate [3].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) Do this task: Bulb and Diaphragm Seal Removal, TASK 52-09-14-000-801.

NOTE: Only do the procedure to remove the bulb seal from the gate.

SUBTASK 52-11-61-020-001

(2) Disconnect the rod [2] from the upper or lower gate [3].

(a) Hold the rod [2]. Do not let the rod [2] fall back in the door frame when the bolt [8] is removed.

NOTE: Turn the door handle to extend or retract the rod.

(b) Remove the bolt [8], washer [7], bushing [9], bushing [10], washer [12], and nut [11] that attach the rod [2] to the gate [3].

(c) Safety the end of the rod [2] to the door frame to hold it in its position.

SUBTASK 52-11-61-010-003

(3) Remove the upper or lower gate [3] from the forward entry door [1].

(a) Fold the gate [3] in the outboard direction.

(b) Remove the 13 bolts [13] that attach the hinge [4] to the forward entry door [1].

(c) Remove the gate [3] from the forward entry door [1].

——— END OF TASK ———

TASK 52-11-61-400-801

3. Forward Entry Door Gate - Installation

Figure 401

A. References

Reference	Title
52-09-14-400-801	Bulb and Diaphragm Seal Installation (P/B 401)
52-11-00-820-801	Forward Entry Door Adjustment (P/B 501)
52-11-31-400-801	Forward Entry Door Lining Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

C. Location Zones

Zone	Area
831	Forward Entry Door

D. Procedure

SUBTASK 52-11-61-420-001

(1) Connect the upper or lower gate [3] to the forward entry door [1] at the hinge [4].

(a) Apply sealant, A00247, to the mating surfaces between the hinge [4] and forward entry door [1].

(b) Put the gate [3] in its position on the forward entry door [1].

(c) Install the 13 bolt [13] to attach the hinge [4] to the forward entry door [1].

SUBTASK 52-11-61-410-001

(2) Install the diaphragm seal [5] between the forward entry door [1] and upper or lower gate [3].

(a) Fold the gate [3] outboard.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) Install the diaphragm seal [5] between the forward entry door [1] and gate [3].

1) Do this task: Bulb and Diaphragm Seal Installation, TASK 52-09-14-400-801.

NOTE: Only do the diaphragm seal installation procedure.

SUBTASK 52-11-61-420-002

(3) Connect the rod [2] to the upper or lower gate [3].

(a) Fold the gate [3] inboard.

(b) Align the rod [2] in its correct position on the gate [3].

1) Hold the rod [2]. Do not let the rod [2] fall back in the door frame.

NOTE: Turn the door handle to extend or retract the rod.

(c) Install the bolt [8], washer [7], bushing [9], bushing [10], washer [12], and nut [11] to attach the rod [2] to the gate [3].

SUBTASK 52-11-61-410-002

(4) Install the bulb [6] on the upper or lower gate [3].

(a) Do this task: Bulb and Diaphragm Seal Installation, TASK 52-09-14-400-801.

NOTE: Only do the bulb seal installation on the gate.

SUBTASK 52-11-61-420-003

(5) Adjust the gate [3].

(a) Do this task: Forward Entry Door Adjustment, TASK 52-11-00-820-801.

NOTE: Only do the gate adjustment.

E. Restore the Airplane

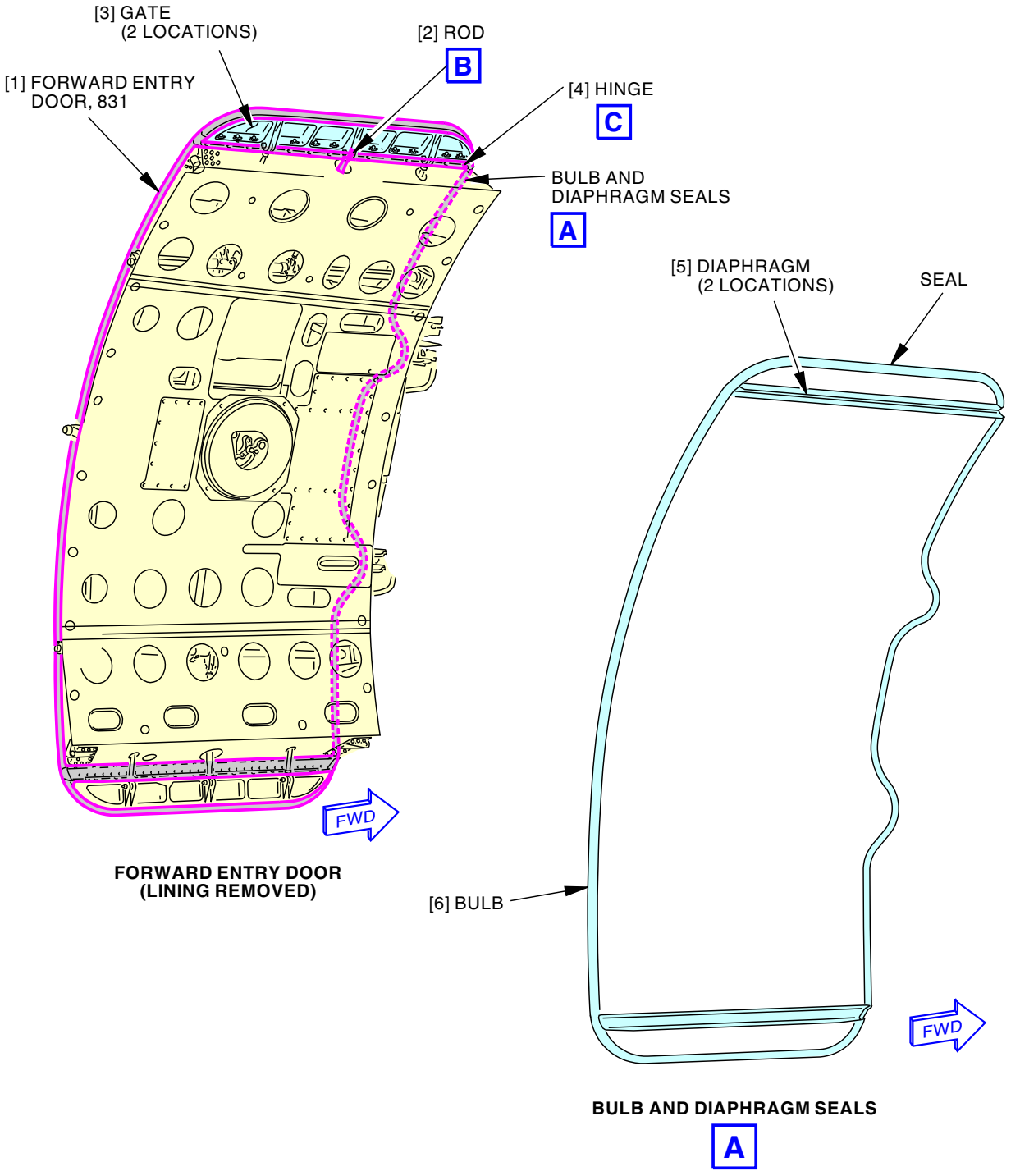
SUBTASK 52-11-61-410-003

(1) Install the door lining.

(a) Do this task: Forward Entry Door Lining Installation, TASK 52-11-31-400-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



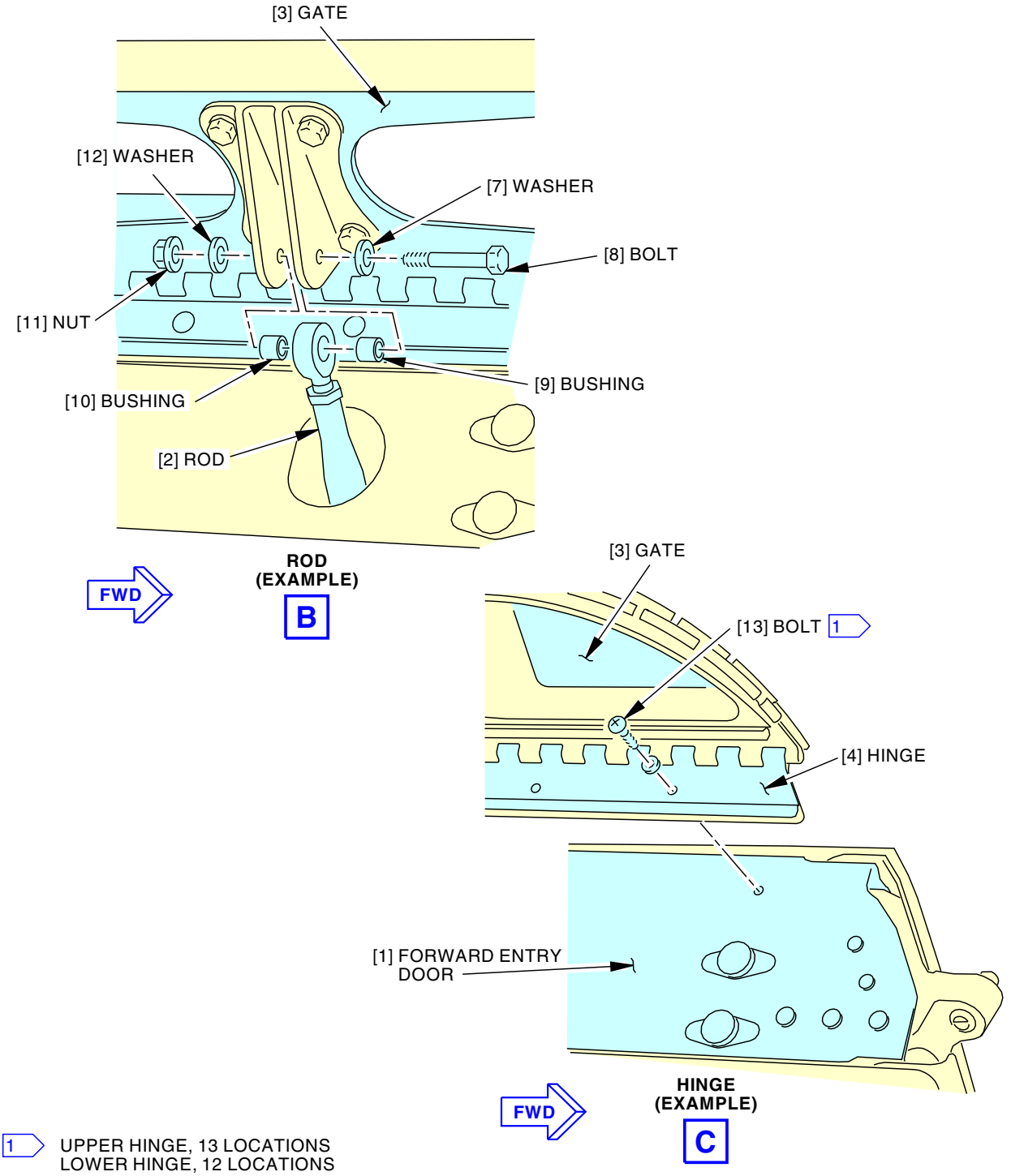
**FORWARD ENTRY DOOR
(LINING REMOVED)**

BULB AND DIAPHRAGM SEALS

2415770 S00061538860_V2

**Forward Entry Door Gate - Installation
Figure 401/52-11-61-990-801 (Sheet 1 of 2)**

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Forward Entry Door Gate - Installation
Figure 401/52-11-61-990-801 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AFT ENTRY DOOR - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks:

(1) Open the AFT Entry Door with the exterior handle.

(2) Close the Aft Entry Door with the exterior handle.

(3) Open the AFT Entry Door with the interior handle.

(4) Close the AFT Entry Door with the interior handle.

(5) Aft Entry Door Corrosion Prevention.

TASK 52-13-00-860-801

2. Open the AFT Door with the Exterior Handle

(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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

B. Location Zones

Zone	Area
834	Left Aft Entry Door

C. Procedure

SUBTASK 52-13-00-480-001

CAUTION DO NOT OPERATE THE DOOR IN STABLE WINDS OF MORE THAN 40 KNOTS. DO NOT LET THE DOOR STAY OPEN IN WIND GUSTS THAT ARE MORE THAN 65 KNOTS. STRONG WINDS CAN CAUSE DAMAGE TO THE STRUCTURE OF THE AIRPLANE.

(1) Put the work platform, COM-1523 in front of the door.

SUBTASK 52-13-00-860-001

(2) Make sure the door is safe as follows:

WARNING MAKE SURE THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

(a) Make sure the girt bar is not engaged in the floor-mounted escape slide brackets.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-13-00-860-002

WARNING BE CAREFUL WHEN YOU OPERATE THE DOOR FROM A MAINTENANCE STAND. IT IS NOT EASY TO OPERATE THE DOOR FROM THE SMALL PLATFORM AREA AND DURING BAD WEATHER CONDITIONS. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

(3) Pull the exterior handle outboard from the recess in the door to engage the door drive mechanism.

SUBTASK 52-13-00-860-003

(4) Turn the exterior handle 180 degrees clockwise to unlatch the door.

NOTE: When you turn the handle 180 degrees clockwise, the latch rollers disengage with the latch fittings.

NOTE: The initial movement of the door is inward.

SUBTASK 52-13-00-860-004

(5) Return the exterior handle into the recess of the door.

SUBTASK 52-13-00-860-005

(6) Use the door assist handle to pull the door outboard and forward until the door hold open lock in the upper hinge engages and the door is held in the fully open position.

NOTE: The door will be parallel to the fuselage when fully open.

SUBTASK 52-13-00-860-006

(7) Put the personnel barrier, SPL-2005 across the door opening.

——— END OF TASK ———

TASK 52-13-00-860-802

3. Close the AFT Door with the Exterior Handle

(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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

B. Location Zones

Zone	Area
834	Left Aft Entry Door

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Procedure

SUBTASK 52-13-00-860-007

CAUTION DO NOT OPERATE THE DOOR IN STABLE WINDS OF MORE THAN 40 KNOTS. DO NOT LET THE DOOR STAY OPEN IN WIND GUSTS THAT ARE MORE THAN 65 KNOTS. STRONG WINDS CAN CAUSE DAMAGE TO THE STRUCTURE OF THE AIRPLANE.

(1) Make sure the work platform, COM-1523 is installed in front of the door.

SUBTASK 52-13-00-860-008

(2) Remove the personnel barrier, SPL-2005 from across the door if it is installed.

SUBTASK 52-13-00-860-009

WARNING BE CAREFUL WHEN YOU OPERATE THE DOOR FROM A MAINTENANCE STAND. IT IS NOT EASY TO OPERATE THE DOOR FROM THE SMALL PLATFORM AREA AND DURING BAD WEATHER CONDITIONS. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

(3) Release the door from the locked position by using either the "Up to release" lever on the body torque tube, or the "Down to release" button on the guide arm.

SUBTASK 52-13-00-860-010

(4) Use the assist handle to swing the door into the door opening.

SUBTASK 52-13-00-860-011

(5) Pull the exterior handle outward to clear the handle recess.

SUBTASK 52-13-00-860-012

(6) Turn the exterior handle 180 degrees counterlockwise to close the door.

NOTE: When you turn the handle 180 degrees counterclockwise, the latch rollers engage with the latch fittings.

SUBTASK 52-13-00-860-013

(7) Release the exterior handle into the recess in the door.

(a) Manually put the exterior handle in the fully stowed position into its recess in the door.

SUBTASK 52-13-00-080-001

(8) Remove the stand, work platform, COM-1523 from the door.

END OF TASK

TASK 52-13-00-860-803

4. Open the AFT Door with the Interior Handle

(Figure 202)

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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Reference	Description
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

B. Location Zones

Zone	Area
834	Left Aft Entry Door

C. Procedure

SUBTASK 52-13-00-860-014

CAUTION DO NOT OPERATE THE DOOR IN STABLE WINDS OF MORE THAN 40 KNOTS. DO NOT LET THE DOOR STAY OPEN IN WIND GUSTS THAT ARE MORE THAN 65 KNOTS. STRONG WINDS CAN CAUSE DAMAGE TO THE STRUCTURE OF THE AIRPLANE.

(1) Put the work platform, COM-1523 in front of the door.

SUBTASK 52-13-00-860-015

(2) Make sure the door is safe as follows:

WARNING MAKE SURE THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

(a) Make sure the girt bar is not engaged in the floor-mounted escape slide brackets.

SUBTASK 52-13-00-860-016

WARNING BE CAREFUL WHEN YOU OPERATE THE DOOR FROM A MAINTENANCE STAND. IT IS NOT EASY TO OPERATE THE DOOR FROM THE SMALL PLATFORM AREA AND DURING BAD WEATHER CONDITIONS. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

(3) Turn the interior handle counterclockwise 180 degrees to unlatch the door.

NOTE: When you turn the handle 180 degrees in the open direction, the latch rollers desengage from the latch fittings and the initial movement of the door is inward.

SUBTASK 52-13-00-860-017

(4) Use the door assist handle to push the door outboard and forward until the door hold open lock in the upper hinge engages and the door is held in the fully open position.

NOTE: The door will be parallel to the fuselage when fully open.

SUBTASK 52-13-00-860-018

(5) Put the personnel barrier, SPL-2005 across the door opening.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-13-00-860-804

5. Close the AFT Door with the Interior Handle

(Figure 202)

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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

B. Location Zones

Zone	Area
834	Left Aft Entry Door

C. Procedure

SUBTASK 52-13-00-860-019

CAUTION

DO NOT OPERATE THE DOOR IN STABLE WINDS OF MORE THAN 40 KNOTS. DO NOT LET THE DOOR STAY OPEN IN WIND GUSTS THAT ARE MORE THAN 65 KNOTS. STRONG WINDS CAN CAUSE DAMAGE TO THE STRUCTURE OF THE AIRPLANE.

(1) Make sure the work platform, COM-1523 is installed in front of the door.

SUBTASK 52-13-00-860-020

(2) Remove the personnel barrier, SPL-2005 from across the door opening if it is installed.

SUBTASK 52-13-00-860-021

WARNING

BE CAREFUL WHEN YOU OPERATE THE DOOR FROM A MAINTENANCE STAND. IT IS NOT EASY TO OPERATE THE DOOR FROM THE SMALL PLATFORM AREA AND DURING BAD WEATHER CONDITIONS. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

(3) Release the door hold open lock from the locked position by using either the "Up to release" lever on the body torque tube, or the "Down to release" button on the guide arm.

NOTE: A light push at the door interior handle location towards the opening direction is allowed to release the hold open lever.

SUBTASK 52-13-00-860-022

(4) Use the assist handle to swing the door into the door opening.

SUBTASK 52-13-00-860-023

(5) Turn the interior handle 180 degrees clockwise to fully close the door.

NOTE: When you turn the handle 180 degrees clockwise, the latch rollers engage with the latch fittings.

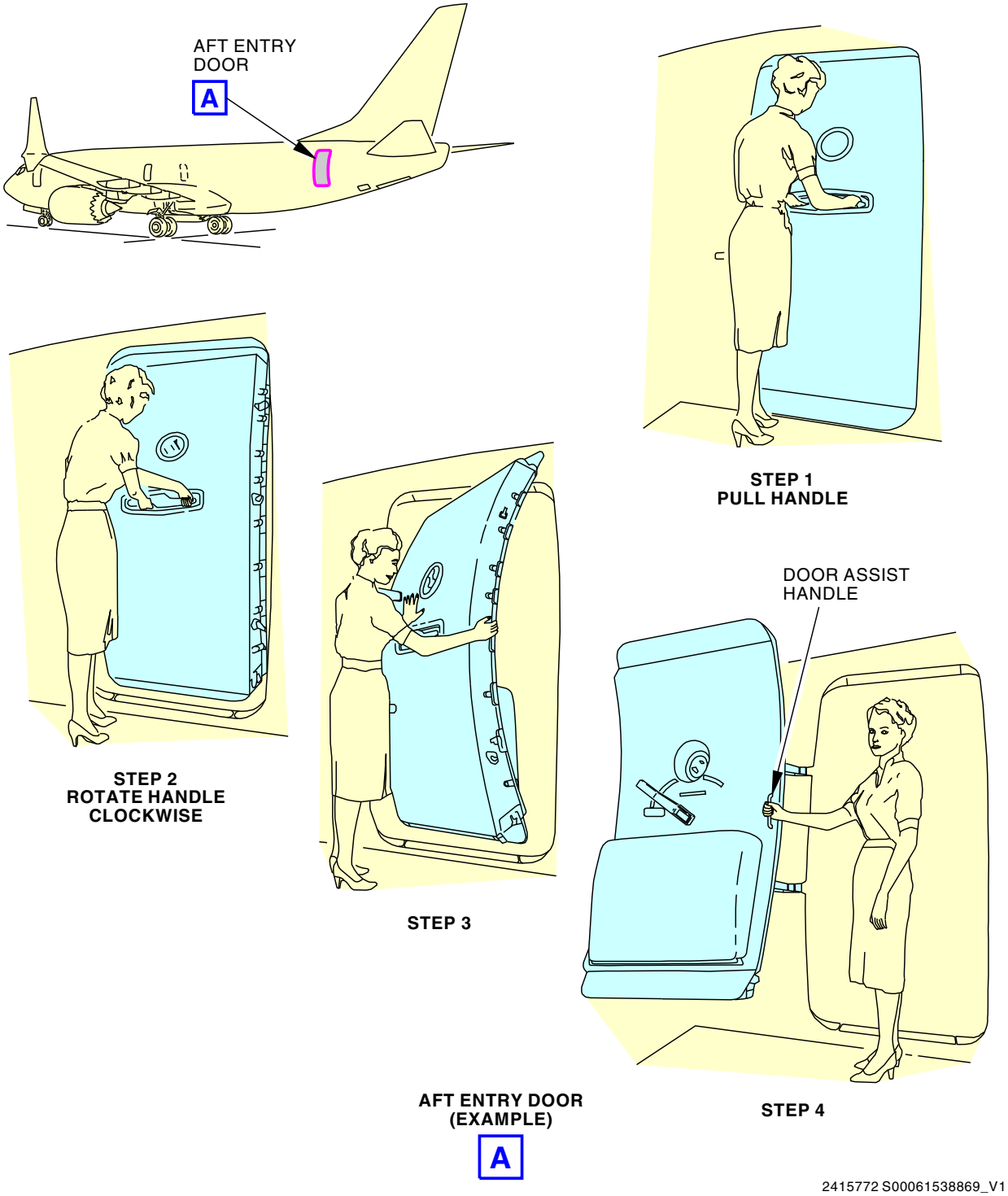
ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-13-00-080-002

(6) Remove the stand, work platform, COM-1523 from the door.

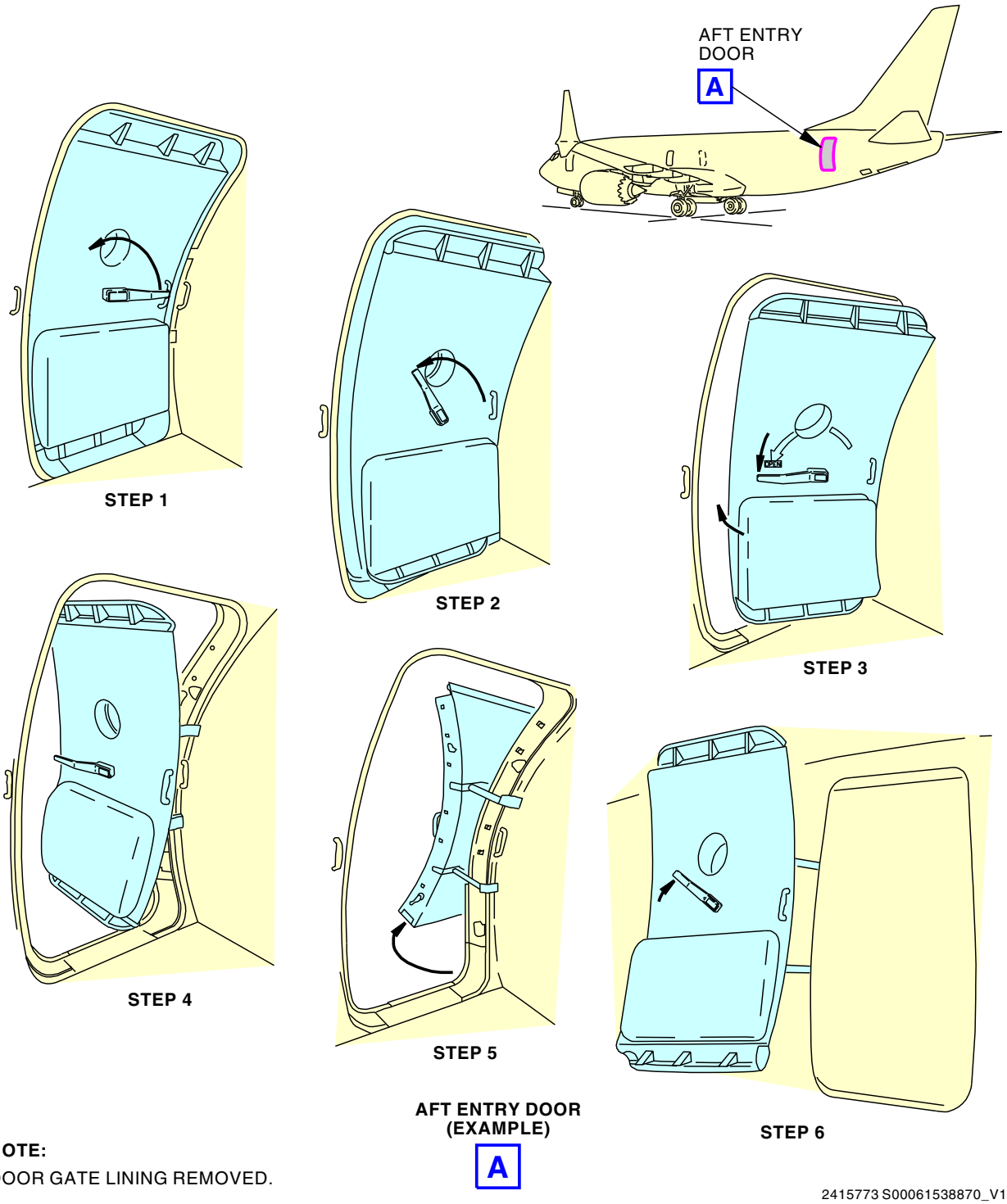
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aft Entry Door Operation from Outside Airplane
Figure 201/52-13-00-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details



NOTE:
DOOR GATE LINING REMOVED.

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Aft Entry Door Operation from Inside Airplane
Figure 202/52-13-00-990-802

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-13-00-600-801

6. Aft Entry Door Corrosion Prevention

A. References

Reference	Title
12-25-12 P/B 301	AFT ENTRY DOOR - SERVICING
52-13-00-200-801	Aft Entry Door Check (P/B 601)
52-13-31-000-801	Aft Entry Door Lining Removal (P/B 401)
52-13-31-400-801	Aft Entry Door Lining Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

C. Location Zones

Zone	Area
834	Left Aft Entry Door

D. General

SUBTASK 52-13-00-800-001

(1) Corrosion may occur on the internal and external surfaces of the door structure. especially the inside lower corners, the connection points, and the door mechanism.

(2) Corrosion has been found on the door torque tube, that is found adjacent to the door in the airplane body. The torque tube for the aft service door, in particular, has been found to contain large amounts of water.

(3) If a door is not opened often from the outside, corrosion has been found on the exterior door handle. The corrosion causes the handle to seize in the recess and prevents the handle from moving outward to unlock the door. Corrosion can also be found in the upper and lower bearings.

(a) If the door handle operates in a stiff or restricted manner, then increase the frequency of the lubrication.

(4) If applicable, stress corrosion cracks have been found on the aft upper stop fitting at the aft airstair door.

(5) Corrosion has been found on the rivets between the web and the intercostal at the aft galley door on some airplanes.

(6) Some items in this section maybe subject to the mandatory requirements for corrosion prevention and control programs for aging airplanes.

(7) Corrosion Prevention

(a) Do this tasks, Aft Entry Door Check, TASK 52-13-00-200-801 to detect the early stages of corrosion.

(b) Look for missing fasteners, white powdery deposits, and discolorations, as signs of corrosion.

1) If signs of corrosion are found, then a corrosion prevention program should be started to prevent the build up of corrosion products.

2) If corrosion products are allowed to build up, then they will cause further corrosion.

3) If corrosion is found, the refer to the Structural Repair Manual for detail instructions for the removal of corrosion.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(c) After the corrosion products are cleaned, make sure that the protective finishes are serviceable.

1) If only minor corrosion is found, then make sure that the area is clean.

2) Apply corrosion inhibiting compound on the affected area.

3) Make sure that the protective finish is restored at the next maintenance opportunity.

(8) Frequency of Application

(a) Periodic inspection is required to areas identified as prone to corrosion and should be scheduled to your Maintenance Planning Document.

(b) Periodic application of BMS 3-23 compounds are necessary to areas identified as prone to corrosion and should be scheduled to your Maintenance Planning Document.

1) Do the prevention treatment to the door at the same recommended interval as the door frame.

2) Do the prevention treatment to the exterior surface of the door at the same recommended interval as the exterior surface of the fuselage.

E. Corrosion Prevention

SUBTASK 52-13-00-620-001

(1) Prevention Treatment

(a) Remove the door liner to get access to the interior surfaces of the door.

1) Aft Entry Door Lining Removal, TASK 52-13-31-000-801

(b) Clean the drains and drain paths.

(c) Aft Entry Door Check, TASK 52-13-00-200-801

1) Remove or repair any corrosion that you find.

(d) Apply corrosion inhibiting compound, G00009 to the interior surfaces of the door.

1) Make sure that the corrosion inhibiting compound, G00009 completely covers the surfaces, with special attention given to the lower corners and the handle mechanism housing.

(e) If it is necessary, apply corrosion inhibiting compound, G00009 to the exterior surfaces of the door.

(f) Lubricate the door. AFT ENTRY DOOR - SERVICING, PAGEBLOCK 12-25-12/301

(g) Install the door lining.

1) Aft Entry Door Lining Installation, TASK 52-13-31-400-801

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AFT ENTRY DOOR - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the aft entry door.

(2) An installation of the aft entry door.

B. The aft entry door is also referred to as the door in this procedure.

TASK 52-13-00-000-801

2. Aft Entry Door Removal

(Figure 401)

A. References

Reference	Title
52-13-31-000-801	Aft Entry Door Lining Removal (P/B 401)
52-13-51-000-801	Aft Entry Door Snubber 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

C. Location Zones

Zone	Area
834	Left Aft Entry Door

D. Access Panels

Number	Name/Location
834FZ	Aft Entry Door - Torque Tube Access

E. Prepare for the Removal

SUBTASK 52-13-00-860-024

(1) Make sure the aft entry door [1] is safe as follows:

(a) Make sure the aft entry door [1] is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure that the work platform, COM-1523, is installed outboard of the door.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-13-00-010-001

(2) Get access to the aft entry door [1] as follows:

(a) Make sure that the aft entry door [1] is closed and latched.

(b) Do this task: Aft Entry Door Lining Removal, TASK 52-13-31-000-801.

(c) Fully open the aft entry door [1].

F. Removal of the Aft Entry Door

SUBTASK 52-13-00-020-001

CAUTION

REMOVE THE SNUBBER BEFORE YOU REMOVE THE DOOR. IF YOU DO NOT REMOVE THE SNUBBER BEFORE YOU REMOVE THE DOOR, DAMAGE TO THE SNUBBER CAN OCCUR.

(1) Do this task: Aft Entry Door Snubber Removal, TASK 52-13-51-000-801

SUBTASK 52-13-00-480-002

(2) Install straps around the stop fittings on the aft entry door [1] to support the aft entry door [1].

SUBTASK 52-13-00-020-002

(3) Disconnect the upper hinge of the aft entry door [1]:

(a) Remove this access panel:

Number	Name/Location
834FZ	Aft Entry Door - Torque Tube Access

(b) Remove the filler [16] to get access to the fastener that attaches the guide arm [11] to the aft entry door [1].

(c) Remove the bolt [8], washers [9], and nut [10] that attach the guide arm [11] to the aft entry door [1].

NOTE: The guide arm [11] will stay with the fuselage.

(d) Remove the bolt [12], washers [13], and nut [14] that attach the upper hinge arm [15] to the fuselage.

NOTE: The hinge arm [15] will stay with the aft entry door [1].

SUBTASK 52-13-00-020-003

(4) Disconnect the lower hinge of the aft entry door [1]:

(a) Remove the bolt [19], washers [20], and nut [21] that attach the lower hinge arm [18] to the fuselage.

NOTE: The hinge arm [18] will stay with the aft entry door [1].

SUBTASK 52-13-00-020-004

WARNING

BE CAREFUL WHEN YOU MOVE THE COMPONENT. THE COMPONENT IS HEAVY. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

(5) Carefully move the aft entry door [1] from the fuselage and remove the aft entry door [1] from the airplane.

NOTE: THE DOOR WEIGHS APPROXIMATELY 140 POUNDS (63.5 KILOGRAMS).

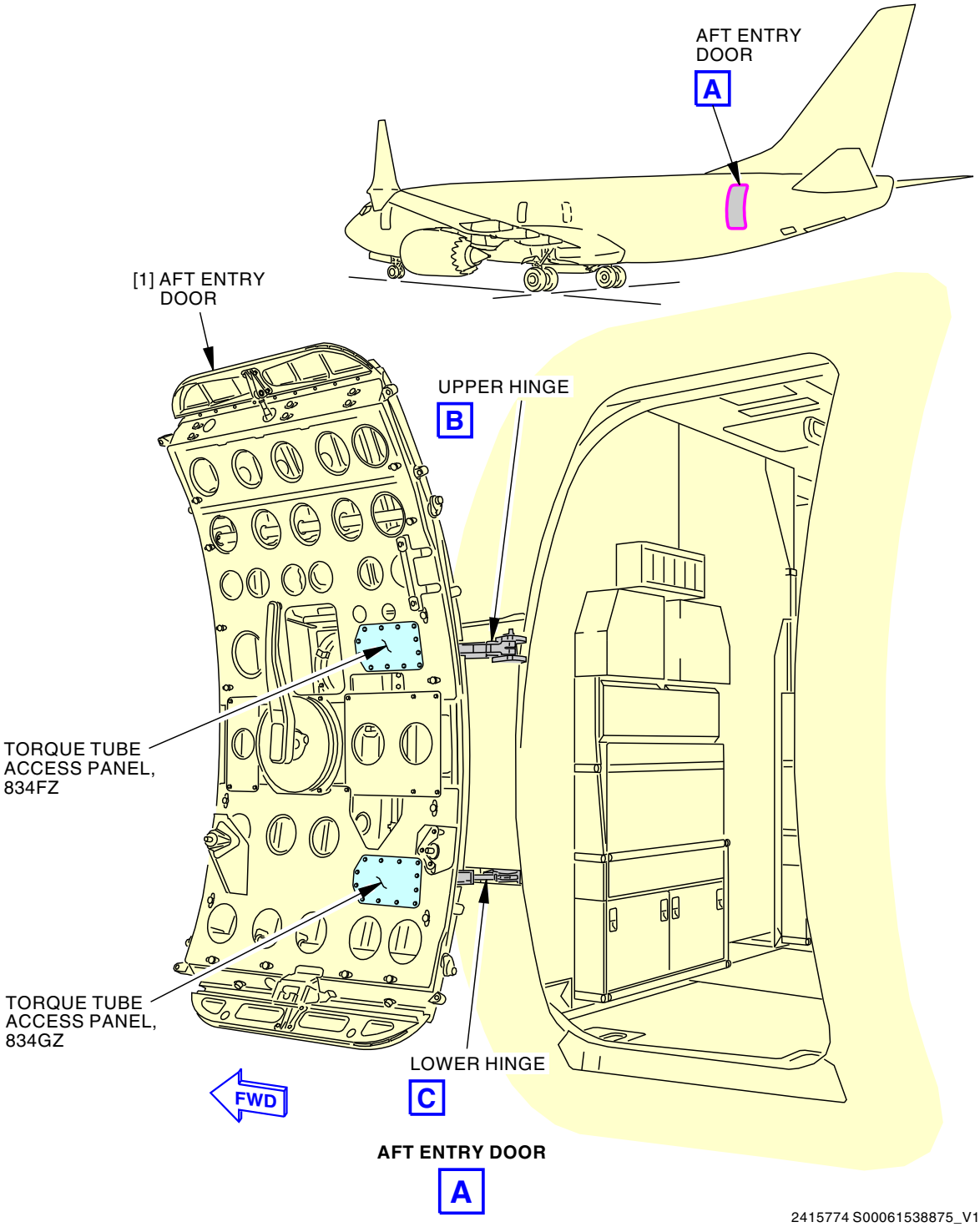
ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-13-00-860-025

(6) If it is necessary, put the personnel barrier, SPL-2005 across the door opening.

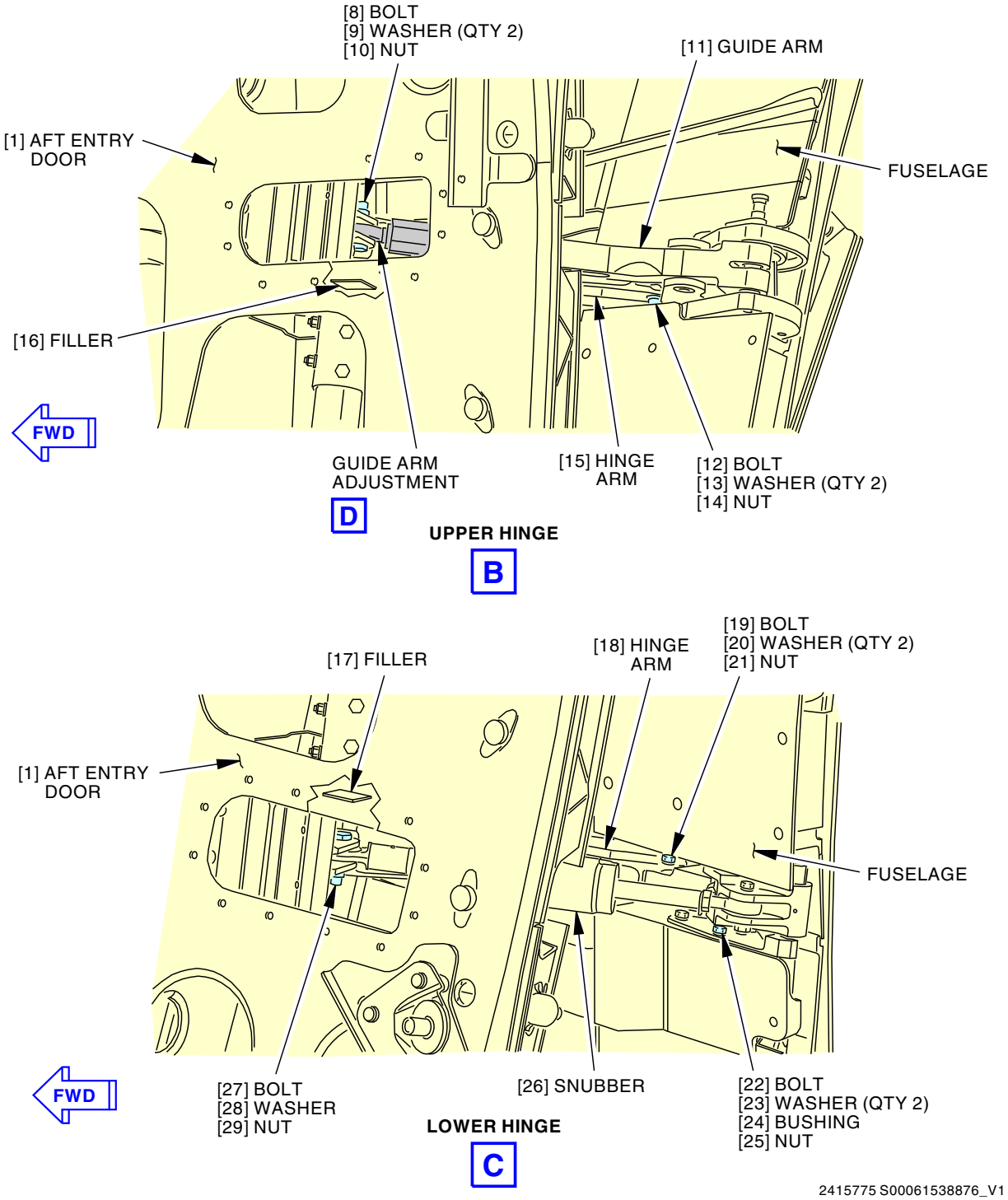
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



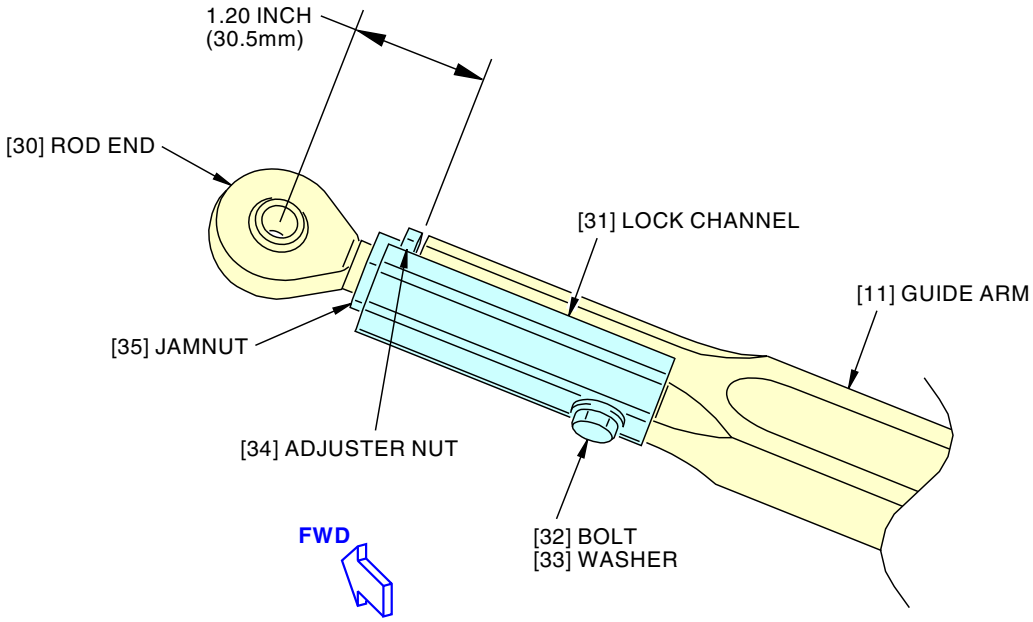
Aft Entry Door Installation
Figure 401/52-13-00-990-819 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aft Entry Door Installation
Figure 401/52-13-00-990-819 (Sheet 2 of 3)

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GUIDE ARM ADJUSTMENT

D

1 INITIAL ADJUSTMENT

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Aft Entry Door Installation
Figure 401/52-13-00-990-819 (Sheet 3 of 3)

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TASK 52-13-00-400-801

3. Aft Entry Door Installation

(Figure 401)

A. References

Reference	Title
52-13-00-200-803	Aft Entry Door Pressure Seal Check (P/B 601)
52-13-00-700-801	Aft Entry Door System Test (P/B 501)
52-13-00-820-801	Aft Entry Door Adjustment (P/B 501)
52-13-51-400-801	Aft Entry Door Snubber 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-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

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	Aft entry door	52-13-00-01A-146	SIA ALL

E. Location Zones

Zone	Area
834	Left Aft Entry Door

F. Access Panels

Number	Name/Location
834FZ	Aft Entry Door - Torque Tube Access

G. Installation of the Aft Entry Door

SUBTASK 52-13-00-860-026

(1) If it is necessary, remove the personnel barrier, SPL-2005 across the door opening.

SUBTASK 52-13-00-420-001

WARNING BE CAREFUL WHEN YOU MOVE THE COMPONENT. THE COMPONENT IS HEAVY. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

(2) Carefully move the aft entry door [1] near the fuselage and align the upper and lower hinges with the fuselage.

NOTE: THE DOOR WEIGHS APPROXIMATELY 140 POUNDS (63.5 KILOGRAMS).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-13-00-700-001

(3) Inspect the pressure seal of the door prior to installation. Do this task: Aft Entry Door Pressure Seal Check, TASK 52-13-00-200-803.

SUBTASK 52-13-00-420-002

(4) Connect the lower hinge of the aft entry door [1] to the fuselage:

(a) Put the lower hinge arm [18] in its correct position.

(b) Install the bolt [19], washers [20], and nut [21] that attach the lower hinge arm [18] to the fuselage.

SUBTASK 52-13-00-020-005

(5) Connect the upper hinge of the aft entry door [1] to the fuselage:

(a) Put the upper hinge arm [15] in its correct position.

(b) Install the bolt [12], washers [13], and nut [14] to attach the upper hinge arm [15] to the fuselage.

(c) Make sure the distance from the rod end [30] of the guide arm [11] to the adjuster nut [34] is as specified.

(d) If it is out of tolerance, adjust the guide arm [11]:

NOTE: This is an initial adjustment for a new guide arm [11] or aft entry door [1].

1) Remove the bolt [32] and washers [33] on the lock channel [31].

2) Remove the lock channel [31].

3) Loosen the jamnut [35].

4) Change the length of the rod end [30] with the adjuster nut [34] to get the correct dimension.

5) Make sure the adjuster nut [34]will align with the lock channel [31].

6) Tighten the jamnut [35].

7) Put the lock channel [31] in its correct position on the guide arm [11].

8) Install the bolt [32] and washers [33] to hold the guide arm [11].

(e) Put the guide arm [11] in its correct position.

1) Make sure the lubrication fitting on the rod end [30] faces inboard.

(f) Install the bolt [8], washers [9], and nut [10] to attach the guide arm [11] to the aft entry door [1].

(g) Make sure the guide arm [11] is installed over the adjuster nut [34].

(h) Install the filler [16] with sealant, A00247 to cover the guide arm [11] attachment.

(i) Install this access panel:

Number	Name/Location
834FZ	Aft Entry Door - Torque Tube Access

SUBTASK 52-13-00-020-006

(6) Do this task: Aft Entry Door Snubber Installation, TASK 52-13-51-400-801

SUBTASK 52-13-00-820-001

(7) Do this task: Aft Entry Door Adjustment, TASK 52-13-00-820-801.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-13-00-710-001

(8) Do this task: Aft Entry Door System Test, TASK 52-13-00-700-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AFT ENTRY DOOR - ADJUSTMENT/TEST

1. General

A. This procedure has these tasks:

(1) An adjustment of the aft entry door

(2) A special adjustment to correct "soft unlatching" of the aft entry door

(3) A system test of the aft entry door.

TASK 52-13-00-820-801

2. Aft Entry Door Adjustment

(Figure 501, Figure 502, Figure 503, Figure 504, Figure 505, Figure 506, Figure 507, Figure 508, Figure 509, Figure 510, Figure 511)

A. General

(1) Do the procedure with airplane at its Standard Basic Empty Weight (SBEW) and the airplane supported on its landing gear.

(2) After the adjustment is completed, make sure that all adjustment points are locked and sealed.

B. References

Reference	Title
52-13-31-000-801	Aft Entry Door Lining Removal (P/B 401)
52-13-31-400-801	Aft Entry Door Lining Installation (P/B 401)
52-71-11-710-801	Entry and Galley Service Door Indication Sensor Test (S194, S195, S199, or S200) (P/B 201)
52-71-11-820-801	Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200) (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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
COM-1557	Gauge - Force Part #: DG-200 Supplier: 92456 Part #: FDIX 100 Supplier: 0BFD9 Part #: FDIX 50 Supplier: 0BFD9 Part #: LG-050 Supplier: 92456 Part #: LG-100 Supplier: 92456 Opt Part #: DPP-500G Supplier: 92456 Opt Part #: DPPH-150 Supplier: 92456 Opt Part #: DPPH-200 Supplier: 92456 Opt Part #: DPPH-50 Supplier: 92456 Opt Part #: FDI 100 Supplier: 0BFD9 Opt Part #: FDI 50 Supplier: 0BFD9 Opt Part #: FDV 100 Supplier: 0BFD9 Opt Part #: FDV 50 Supplier: 0BFD9

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Reference	Description
SPL-2003	Simulator - Escape Slide, Passenger Door Part #: C52006-74 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
D00504	Grease - Petrolatum	VV-P-236
G01912	Lockwire - MS20995NC32, Monel - 0.032 Inch (0.8128 mm) Diameter	NASM20995
G02020	Clay, Modeling	

E. Location Zones

Zone	Area
834	Left Aft Entry Door

F. Access Panels

Number	Name/Location
834AZ	Aft Entry Door - Torque Tube Access
834FZ	Aft Entry Door - Torque Tube Access

G. Prepare for the Adjustment

SUBTASK 52-13-00-860-027

(1) If a new door has been installed:

(a) Make sure that the centering guide is not installed on the door.

(b) Make sure that the stop pins are retracted into the stop fittings or removed.

SUBTASK 52-13-00-860-028

(2) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE BRACKETS OF THE FLOOR-MOUNTED ESCAPE SLIDE. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN OPERATE WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure that a work platform, COM-1523, is installed outboard of the door.

SUBTASK 52-13-00-010-002

(3) Get access to the door as follows:

(a) Make sure that the door is closed and latched.

(b) Do this task: Aft Entry Door Lining Removal, TASK 52-13-31-000-801.

(c) Make sure that the weight equivalent to the escape slide and door lining that equals 77 lb (35 kg) is installed on the door.

1) You may use the escape slide simulator, SPL-2003.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

H. Hinge Flap Adjustment

SUBTASK 52-13-00-820-002

(1) Adjust the hinge flap (Figure 502).

(a) Make sure that the door is closed and latched.

(b) Make sure that the skin clearance and flushness between the upper and lower hinge flaps, fuselage skin, and access panel are as shown in Figure 502.

(c) If it is necessary, adjust as follows:

1) Adjust the skin clearance as follows (Figure 502):

a) Open the door.

b) Remove the bolts and washers that attach the hinge flap to the fuselage structure.

c) Install a new laminated shim or remove laminations from the shim under the hinge on the hinge flap.

d) Apply primer, C00259, to the bare laminations of the shim before installation.

e) Install the bolts and washers to attach the hinge flap to the fuselage structure.

2) Adjust the flushness as follows (View B, Figure 502):

a) Loosen the bolts that attach the hinge flap to the fuselage structure.

b) Move the hinge flap inboard or outboard in the slots for the bolts.

c) Tighten the bolts that attach the hinge flap to the fuselage structure.

I. Guide Arm Adjustment

SUBTASK 52-13-00-820-003

(1) Adjust the guide arm (Figure 503).

(a) Open the door and move it until it is parallel to the contour of the fuselage near the closed position.

(b) If the door is not parallel to the contour of the fuselage at approximately 1 in. (25 mm) from the closed position, adjust as follows:

1) Move the door to the fully open position.

2) Remove this access panel:

Number	Name/Location
834FZ	Aft Entry Door - Torque Tube Access

3) Get access to the lock channel of the guide arm.

4) Remove the bolt and washer on the lock channel.

5) Remove the lock channel.

6) Loosen the jamnut.

7) Turn the adjuster nut to change the length of the rod end to get the correct position of the door.

NOTE: If you shorten the guide arm it will turn the aft edge of the door inboard.

8) Make sure that the adjuster nut will align with the lock channel.

9) Tighten the jamnut.

10) Put the lock channel in its correct position on the guide arm.

11) Install the bolt and washer to hold the lock channel in position.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

12) Install this access panel:

Number	Name/Location
834FZ	Aft Entry Door - Torque Tube Access

J. Snubber Adjustment

SUBTASK 52-13-00-820-004

(1) Adjust the snubber (Figure 504).

(a) Move the door slowly from the cocked position to the closed position and back to the cocked position.

NOTE: The door is in the cocked position when it is the most inboard in its travel, near perpendicular to the fuselage cutout.

(b) Make sure that the snubber does not bottom out and cause the roller to bind in the guide arm at the upper hinge.

(c) Move the door to the fully open position.

(d) Make sure that the snubber is not extended too much by a check that more movement of the stop link is possible.

(e) If it is necessary, adjust as follows (Figure 504):

1) Make sure that the door is fully open.

2) Remove the bolt, washers, bushing, and nut that attach the snubber to the fuselage frame.

3) Remove the lockwire.

4) Loosen the jamnut on the rod end.

5) Turn the rod end to change the length of the snubber to get the correct snubber extension.

6) Tighten the jamnut.

7) Install MS20995NC32 lockwire, G01912.

8) Install the bolt, washers, bushing, and nut to attach the snubber to the fuselage frame.

K. Door Vertical Adjustment

SUBTASK 52-13-00-820-005

(1) Adjust the door vertical adjustment.

(a) Close and latch the door.

(b) Make sure that the stop pins align with the stop pads as shown in Figure 510.

NOTE: This is an alignment of the stop pads with the stop pins. Do not set the stop pin and pad clearance.

(c) Make sure that the forward and aft, upper and lower latch rollers are centered in the latch receivers.

(d) Measure the skin clearance between the upper and lower gates and the fuselage skin along the top and bottom of the door at the locations that follow.

NOTE: Make additional measurements if it is necessary.

1) Three locations evenly spaced along the horizontal edge of the upper and lower gates.

(e) If it is necessary, adjust the door vertically as follows (Figure 505):

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1) Open this access panel:

Number	Name/Location
834AZ	Aft Entry Door - Torque Tube Access

2) Remove the cotter pins on the upper and lower adjuster nuts.

3) Loosen the upper adjuster nut and turn the lower adjuster nut to get the correct door vertical position.

4) Make sure that the lower adjuster nut is aligned with a cotter pin hole.

(f) Measure the skin clearance between the upper and lower gates and the fuselage skin along the top and bottom of the door at the locations that follow:

NOTE: Make additional measurements if it is necessary.

1) Three locations evenly spaced along the horizontal edge of the upper and lower gates.

(g) Make sure that the clearances are as shown in Figure 505.

1) If it is necessary, adjust the door vertically to get the clearances.

(h) Make sure that the stop pins continue to align with the stop pads.

(i) Make sure that the door is bottomed out on the lower adjuster nut.

(j) Tighten the upper adjuster nut hand tight and turn back to align with the nearest cotter pin hole.

NOTE: Do not tighten the nuts too much. If the nuts are tightened too much it can put high end loads on the bearings in the handle mechanism.

(k) Install the new cotter pins in the upper and lower adjuster nuts.

L. Skin Clearance Adjustment

SUBTASK 52-13-00-820-006

(1) Two measurement methods are provided to adjust the door.

(a) Method 1 is the standard measurement method for skin clearance adjustment.

(b) Method 2 is aero-averaging measurement for skin clearance adjustment.

SUBTASK 52-13-00-820-007

(2) Adjust the skin clearance with method 1:

(a) Make sure that the clearances between the door skin and fuselage skin are as shown in Table 501 and Figure 505.

Table 501/52-13-00-993-801 Aerosmoothness Limits - Aft Entry Door (Method 1) (Key to Figure 505)

ZONE	CLEARANCE		FLUSHNESS *[1]	
	NOMINAL Inch (mm)	TOLERANCE Inch (mm)	NOMINAL Inch (mm)	TOLERANCE Inch (mm)
A	0.12 (3.04)	0.05 to 0.28 (1.27 to 7.11)	--	NOT APPLICABLE
B	0.19 (4.82)	0.13 to 0.28 (3.30 to 7.11)	0.00 (0.00)	-0.09 to 0.03 (-2.28 to 0.76)
C	0.12 (3.04)	0.05 to 0.28 (1.27 to 7.11)	--	NOT APPLICABLE
D	0.12 (3.04)	0.06 to 0.18 (1.52 to 4.57)	-0.06 (-1.52)	-0.12 to 0.06 (-3.04 to 1.52)
E	0.12 (3.04)	0.05 to 0.19 (1.27 to 4.82)	--	NOT APPLICABLE
F	0.12 (3.04)	0.06 to 0.18 (1.52 to 4.57)	-0.20 (-5.08)	-0.25 to -0.15 (-6.35 to -3.81)

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Table 501/52-13-00-993-801 Aerosmoothness Limits - Aft Entry Door (Method 1) (Key to Figure 505) (Continued)

ZONE	CLEARANCE		FLUSHNESS *[1]	
	NOMINAL Inch (mm)	TOLERANCE Inch (mm)	NOMINAL Inch (mm)	TOLERANCE Inch (mm)
G	0.12 (3.04)	0.05 to 0.19 (1.27 to 4.82)	--	NOT APPLICABLE
H	0.12 (3.04)	0.06 to 0.18 (1.52 to 4.57)	-0.06 (-1.52)	-0.12 to -0.03 (-3.04 to -0.76)

*[1] A negative flushness shows the door is inboard of the fuselage cutout.

(b) If it is necessary, adjust as follows:

1) Open the door.

2) Trim the edge of the door to get the correct skin clearances.

(c) Make sure that the minimum distance from the edge of the door outer skin to the door frame is as shown in Figure 505.

SUBTASK 52-13-00-820-008

(3) Adjust the skin clearance with method 2 (aero-averaging).

(a) Make sure that the clearances between the door skin and fuselage skin are as shown in Table 502.

Table 502/52-13-00-993-802 Aero-Averaging Limits - Aft Entry Door (Method 2)

ZONE	CLEARANCE		FLUSHNESS *[1]	
	NOMINAL Inch (mm)	TOLERANCE Inch (mm)	NOMINAL Inch (mm)	TOLERANCE Inch (mm)
A	0.12 (3.05)	0.05 to 0.31 (1.27 to 7.87)	--	NOT APPLICABLE
B	0.19 (4.82)	0.13 to 0.31 (3.30 to 7.87)	0.00 (0.00)	-0.12 to 0.06 (-3.05 to 1.52)
C	0.12 (3.05)	0.05 to 0.3 (1.27 to 7.87)	--	NOT APPLICABLE
D	0.12 (3.05)	0.06 to 0.21 (1.52 to 5.33)	-0.06 (-1.52)	-0.15 to 0.06 (-3.81 to 1.52)
E	0.12 (3.05)	0.05 to 0.22 (1.27 to 5.59)	--	NOT APPLICABLE
F	0.12 (3.05)	0.06 to 0.21 (1.52 to 5.33)	-0.20 (-5.08)	-0.28 to -0.12 (-7.11 to -3.05)
G	0.12 (3.05)	0.05 to 0.22 (1.27 to 5.59)	--	NOT APPLICABLE
H	0.12 (3.05)	0.06 to 0.21 (1.52 to 5.33)	-0.6 (-1.52)	-0.15 to 0.00 (-3.81 to -0.00)

*[1] A negative flushness shows the door is inboard of the fuselage cutout.

SUBTASK 52-13-00-820-009

(4) Adjust the skin clearance with method 2 (aero-averaging) (Table 503).

(a) Make sure that the clearances between the door skin and fuselage skin are as shown in Figure 505.

(b) If it is necessary, adjust as follows:

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1) Open the door.
2) Trim the edge of the door to get the correct skin clearances.

(c) Make sure that the minimum distance from the edge of the door outer skin to the door frame is as shown (aero-averaging).

(d) Measure the clearance between the door skin and fuselage skin along the forward and aft edges of the door at the locations that follow:

1) Within ±1.0 in. (±25.4 mm) of each stop fitting along the forward and aft edges of the door.
2) Record the skin clearance for each stop fitting.
3) Use Table 503 to change the clearance to a drag value.

NOTE: A measurement of 0.10 in. (2.54 mm) clearance is a drag value of 0.63.

4) Record the drag value for each measurement from Table 503.

Table 503/52-13-00-993-803 Aft Entry Door Skin Clearance (Aero-averaging)

CLEARANCE Inch (mm)	DRAG VALUE
0.06 (1.52)	0.38
0.07 (1.78)	0.44
0.08 (2.03)	0.50
0.09 (2.29)	0.56
0.10 (2.59)	0.63
0.11 (2.79)	0.69
0.12 (3.05)	0.75
0.13 (3.30)	0.81
0.14 (3.56)	0.88
0.15 (3.81)	0.94
0.16 (4.06)	1.00
0.17 (4.32)	1.06
0.18 (4.57)	1.12
0.19 (4.83)	1.19
0.20 (5.08)	1.25
0.21 (5.33)	1.31

5) Add all the drag values together (sum).

a) Record the sum of the drag dalues as measurement A.

6) Divide measurement A by the number of measurements that you made.

NOTE: If the measurement was made at each of the stop fitting, then divide measurement A (sum of the drag values) by 18 (the number of door stop fittings).

7) Make sure that this average drag value is 1.00 or less.

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M. Skin Flushness Adjustment

SUBTASK 52-13-00-820-010

(1) Two measurement methods are provided to adjust the door flushness.

(a) Method 1 is the standard measurement method for skin flushness adjustment.

(b) Method 2 is aero-averaging measurement for skin flushness adjustment.

SUBTASK 52-13-00-820-011

(2) Adjust the skin flushness with method 1:

(a) Make sure that the flushness between the door skin and fuselage skin are as shown in Table 501 and Figure 505.

(b) As a minimum, measure the flushness between the door skin and fuselage skin along the forward and aft edges of the door at the locations that follow:

1) Within ±1.0 in. (±25.4 mm) of each stop fitting along the forward and aft edges of the door.

NOTE: Make additional measurements if it is necessary. Do not make measurements that are within 8 in. (203 mm) of the body skin lap joint.

2) Three locations evenly spaced along the horizontal edge of the upper and lower gates.

(c) If it is necessary, adjust as follows:

1) Open the door.

2) Loosen the bolts and washers that attach the forward and aft, upper and lower latch receivers to the fuselage frame.

3) Move the latch receivers inboard or outboard on their serrated plates to get the correct door flushness (Figure 507).

4) Tighten the bolts and washers to attach the latch receivers to the fuselage frame.

SUBTASK 52-13-00-820-012

(3) Adjust the skin flushness with method 2 (aero-averaging) (Table 504).

(a) Make sure that the flushness between the door skin and fuselage skin are as shown in Figure 505.

(b) As a minimum, measure the flushness between the door skin and fuselage skin along the forward and aft edges of the door at the locations that follow:

1) Within ±1.0 in. (±25.4 mm) of each stop fitting along the forward and aft edges of the door.

NOTE: Make additional measurements if it is necessary. Do not make measurements that are within 8 in. (203 mm) of the body skin lap joint.

2) Three locations evenly spaced along the horizontal edge of the upper and lower gates.

3) Record the skin flushness for each stop fitting.

4) Use Table 504 to change the flushness to a drag value.

NOTE: A measurement of -0.10 in. (-2.54 mm) flushness at the door fwd edge is a drag value of 0.56.

5) Record the drag value for each measurement from Table 504.

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Table 504/52-13-00-993-804 Aft Entry Door Skin Flushness (Method 2)

DOOR FLUSHNESS		
FWD EDGE Inch (mm)	AFT EDGE Inch (mm)	DRAG VALUE
	0.06 (1.52)	2.10
	0.05 (1.27)	1.89
	0.04 (1.02)	1.69
-0.15 (-3.81)	0.03 (0.76)	1.49
-0.14 (-3.56)	0.02 (0.51)	1.29
-0.13 (-3.30)	0.01 (0.25)	1.10
-0.12 (-3.05)	0.00	0.91
-0.11 (-2.79)	-0.01 (-0.25)	0.73
-0.10 (-2.54)	-0.02 (-0.51)	0.56
-0.09 (-2.29)	-0.03 (-0.76)	0.39
-0.08 (-2.03)	-0.04 (-1.02)	0.23
-0.07 (-1.78)	-0.05 (-1.27)	0.09
-0.06 (-1.52)	-0.06 (-1.52)	0
-0.05 (-1.27)	-0.07 (-1.78)	0.11
-0.04 (-1.02)	-0.08 (-2.03)	0.38
-0.03 (-0.76)	-0.09 (-2.29)	0.70
-0.02 (-0.51)	-0.10 (-2.54)	1.06
-0.01 (-0.25)	-0.11 (-2.79)	1.44
0.00	-0.12 (-3.05)	1.85
	-0.13 (-3.30)	2.23
	-0.14 (-3.56)	2.67
	-0.15 (-3.81)	3.12

6) Add all the drag values together (sum).

a) Record the sum of the drag values as measurement A.

7) Divide measurement A by the number of measurements that you made.

NOTE: If the measurement was made at each of the stop fitting, then divide measurement A (sum of the drag values) by 18 (the number of door stop fittings).

a) Make sure that this average drag value is 1.00 or less.

(c) If the average drag value is greater than 1.00, then adjust the door as follows:

1) Open the door.

2) Loosen the bolts and washers that attach the forward and aft, upper and lower latch receivers to the fuselage frame.

3) Move the latch receivers inboard or outboard on their serrated plates to get the correct door flushness (Figure 507).

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4) Tighten the bolts and washers to attach the latch receivers to the fuselage frame.

N. Latch Adjustment

SUBTASK 52-13-00-820-013

(1) Do the latch adjustment (Figure 507).

(a) If using clay to measure the latch roller clearances, do these steps:

1) Put clay, G02020, in the latch fitting.

2) Put a layer of grease, D00504, on the latch roller.

3) Close and latch the door.

4) Open the door.

5) Make sure that the clearance between the bottom of the latch roller and the latch fitting is correct (View B-B, Figure 507).

6) Remove unwanted material from the surfaces of latch roller and latch fitting.

(b) Make sure that the clearance between the forward and aft, upper and lower latch rollers and latch receivers is as shown in Figure 507.

1) If it is necessary, adjust as follows (Figure 507):

a) Open the door.

b) Loosen the bolts and washers that attach the latch receivers to the fuselage frame.

c) Move the latch receivers up or down on their serrated plates to get the correct clearance between the latch roller and the latch receiver.

d) Tighten the bolts and washers to attach the latch receivers to the fuselage frame.

(c) Close and latch the door.

(d) Make sure that the distance the forward and aft, upper and lower latch rollers engage in the latch receivers is as shown in Figure 507.

(e) If it is necessary, adjust as follows:

1) Open the door.

2) Remove the bolts, washers, and nuts that attach the forward and aft latch cranks to the latch torque tube.

3) Move the adjustment shims from one end of the latch torque tube to the other end to increase or decrease the clearance between the latch crank and latch receiver on one end of the latch torque tube.

4) Install the bolts, washers, and nuts to attach the latch cranks to the latch torque tube.

5) If more adjustment is necessary, do the steps that follow:

a) Remove the nut and adjustment washers that attach the latch roller to the latch crank.

b) Put the adjustment washers on the roller side or the nut side of the latch crank to increase or decrease the distance the latch roller engages in the latch receiver.

c) Install the nut and adjustment washers to attach the latch roller to the latch crank.

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d) Make sure that the latch roller bearing shank is clear of the door frame by 0.02 in. (0.51 mm) minimum after the adjustment.

(f) Make sure that the door is open.

(g) Try to move the latch torque tube forward and aft to do a check for latch roller and latch torque tube end play.

(h) Make sure that the latch roller and latch torque tube end play is 0.02 in. (0.51 mm) maximum.

(i) If it is necessary, adjust as follows (Figure 507):

1) Open the door.

2) Add or remove the horseshoe washers from one of the ends of the latch torque tube to decrease the end play.

3) After you have decreased the end play, do the steps that follow:

a) Turn the horseshoe washer ends until their positions are random.

b) Apply the sealant, A00247 in the spaces between the ends of the horseshoe washers.

c) Make sure that the sealant, A00247 does not stop the latch torque tube support bearing from turning freely.

d) Do this task: Entry and Galley Service Door Indication Sensor Test (S194, S195, S199, or S200), TASK 52-71-11-710-801.

O. Horizontal Control Rod Adjustment

SUBTASK 52-13-00-820-014

(1) Adjust the horizontal control rod (Figure 508).

(a) Unlatch and latch the door.

(b) Make sure that the forward and aft, upper and lower latch rollers move into their latch receivers before the latch torque tubes start to turn.

(c) If it is necessary, adjust the horizontal control rod as follows (Figure 508).

1) Open the door.

2) Remove the bolt, washer, and nut that attach the horizontal control rod to the door hinge torque tube.

3) Loosen the checknut.

4) Turn the rod end to change the length of the horizontal control rod to get the correct latch sequence or exterior handle forces.

NOTE: If you shorten the horizontal control rod, it will move the door outboard and increase the handle retraction force.

5) After the first adjustment, shorten the horizontal control rod an additional 1/2 to 1-1/2 turns necessary to move the door outboard and make sufficient latch roller clearance.

6) Install the bolt, washer, and nut to attach the horizontal control rod end to the door hinge torque tube.

7) Tighten the check nut.

(d) Close and latch the door.

(e) Pull the exterior handle to its extended position.

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(f) Use a force gauge, COM-1557, to measure the force to move the exterior handle back to its retracted position.

(g) Make sure that the force to move the external handle to its retracted position is not more than 20 lb (9 kg).

1) If it is necessary, adjust the horizontal control rod again.

(h) Do this adjustment to make sure that the latch roller will clear the lip of the latch receiver.

NOTE: Use the 10 ±1 lb (4.5 ±0.5 kg) load to simulate the seal drag on the door liner.

1) Apply a 10 ±1 lb (4.5 ±0.5 kg) spring load or equivalent to the door in an inboard direction at the corner stop fitting next to the latch roller.

2) Unlatch and latch the door.

3) Look at each latch roller as it goes into its latch receiver.

4) Make sure that the latch rollers are clear of the entry lip on the latch receiver when you move the exterior handle to the latched position.

(i) If it is necessary, adjust the horizontal control rod again.

(j) Install this access panel:

Number	Name/Location
834AZ	Aft Entry Door - Torque Tube Access

P. Gate Adjustment

SUBTASK 52-13-00-820-015

(1) Do the gate adjustment:

(a) Close and latch the door.

(b) Make sure that the door flushness between the upper and lower gates and the fuselage skin is as shown in Table 501 and Figure 505.

(c) If it is necessary, adjust as follows (Figure 509):

1) Open the door.

2) Remove the bolt, washers, and nut that attach the gate control rod to the gate.

3) Loosen the checknut.

4) Turn the rod end to change the length of the gate control rod to get the correct flushness.

5) Install the bolt, washers, and nut to attach the gate control rod to the gate.

6) Tighten the checknut.

Q. Stop Pin Adjustment

SUBTASK 52-13-00-820-016

(1) Do the stop pin adjustment (Figure 510):

(a) For stop pins that have no access, use clay to measure the pin-to-pad clearance, as follows:

1) Put clay, G02020, on the stop pad.

2) Put a layer of grease, D00504, on the stop pin.

3) Close and latch the door.

4) Open the door.

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5) Make sure that the clearance between the stop pin and stop pad is correct (View A-A, Section C-C Figure 510).

6) Remove unwanted material from the surfaces of all stop pins and stop pads.

(b) If it is necessary, adjust as follows:

1) Turn the stop pin fully outboard until it just touches the stop pad.

2) Turn the stop pin back 1/2 turn and then to the nearest lock groove for the lock spring.

3) Install the lock spring.

(c) Make sure that the stop pins align with the stop pads on the frame and threshold of the door (Views B-B and D-D, Figure 510).

R. Centering Guide Adjustment

SUBTASK 52-13-00-820-017

(1) Do the centering guide adjustment (Figure 511).

(a) Open and close the door.

(b) Make sure that the centering guide body track thickness is not less then 0.070 in. (1.778 mm).

(c) As the door closes, make sure the centering guide goes into the track and is clear of the track as the door closes.

(d) Make sure that the clearance between the centering guide roller and the track when the door is closed and latched is as shown in View A, Figure 511.

(e) If it is necessary, adjust as follows (Figure 511):

1) Loosen the bolts that attach the centering guide to the door frame.

2) Move the centering guide on the serrated plate to get the correct clearance.

NOTE: The centering guide has slots for the bolts to permit adjustment.

3) Tighten the bolts.

S. Hinge Arm Cover Adjustment

SUBTASK 52-13-00-820-018

(1) Adjust the hinge arm cover (Figure 502).

(a) Make sure that the door is closed and latched.

(b) Make sure that the skin clearance and flushness between the upper and lower hinge arm covers and door skin are as shown in Figure 502.

1) If it is necessary, adjust as follows:

2) Adjust the skin clearance as follows:

a) Trim the hinge arm cover to get the correct clearance.

3) Adjust the flushness as follows (View C, Figure 502):

a) The flushness limit is 0.00 ±0.03 in. (0.00 ±0.76 mm).

b) Remove the screws that attach the hinge arm cover to the hinge arm.

c) Remove the shims or add new shims between the hinge arm cover and hinge arm.

d) Install the screws to attach the hinge arm cover to the hinge arm.

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SUBTASK 52-13-00-820-019

(2) Adjust the aft entry door warning system, do this task: Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200), TASK 52-71-11-820-801.

T. Put the Airplane Back to Its Usual Condition

SUBTASK 52-13-00-080-004

(1) Remove the weight or the escape slide simulator, SPL-2003 from the door.

SUBTASK 52-13-00-410-001

(2) Do this task: Aft Entry Door Lining Installation, TASK 52-13-31-400-801.

——— END OF TASK ———

TASK 52-13-00-820-802

3. Aft Entry Door (Soft Unlatching)

(Figure 507, Figure 512)

A. General

(1) Do the procedure with airplane at its Standard Basic Empty Weight (SBEW) and the airplane supported on its landing gear.

(2) If the latch torque tubes are not adjusted correctly, the door handle can move too easily. This can cause the door to open accidentally (soft unlatching). This task is a special procedure to adjust the door if it opens accidentally (soft unlatching).

(3) The soft unlatching adjustment and the vertical adjustment for the aft entry door are related. When you do the soft unlatching adjustment, it affects the vertical adjustment. Make sure that these adjustments are within tolerance before you complete the soft unlatching adjustment procedure.

B. References

Reference	Title
25-66-01-000-801	Escape Slide Pack and Cover Removal (P/B 401)
25-66-01-400-801	Escape Slide Pack and Cover Installation (P/B 401)
52-13-31-000-801	Aft Entry Door Lining Removal (P/B 401)
52-13-31-400-801	Aft Entry Door Lining Installation (P/B 401)
52-71-11-820-801	Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200) (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-2003	Simulator - Escape Slide, Passenger Door Part #: C52006-74 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
D00504	Grease - Petrolatum	VV-P-236
G02020	Clay, Modeling	

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E. Location Zones

Zone	Area
834	Left Aft Entry Door

F. Aft Entry Door (Soft Unlatching)

SUBTASK 52-13-00-010-003

(1) Do this task: Escape Slide Pack and Cover Removal, TASK 25-66-01-000-801.

SUBTASK 52-13-00-010-004

(2) Do this task: Aft Entry Door Lining Removal, TASK 52-13-31-000-801.

SUBTASK 52-13-00-480-003

(3) Attach a 77 lb (35 kg) weight to the door approximately in the middle of the bottom half of the door.

(a) You may use the escape slide simulator, SPL-2003.

SUBTASK 52-13-00-820-020

(4) Do a check of the adjustment of the latch rollers:

(a) Disconnect the push rod from the torque tube.

(b) Move the handle mechanism to the closed position.

NOTE: A wrench can help to move the handle mechanism.

(c) See that the latch rollers align correctly with the latch fittings.

1) Make sure that a 3/32 in. (2 mm) rig pin can easily slide through the hole in the latch roller and into the latch fitting.

(d) If the rig pin cannot easily slide through the hole, adjust the control rods to make the latch roller align correctly with the latch fitting:

1) Disconnect the control rods from the control rod cranks on the upper and lower latch torque tubes.

2) Align the holes in the latch roller with the holes in the latch fitting.

a) Put the 3/32 in. (2 mm) rig pin through the hole in the latch roller and into the hole in the latch fitting.

3) Change the length of the control rods until they align with the control rod cranks.

4) Connect the control rods to the control rod cranks.

(e) Connect the push rod to the torque tube.

(f) Make sure that the latch rollers engage the latch fittings correctly:

1) Put clay, G02020, in the latch fitting.

2) Put a layer of the grease, D00504, on the latch roller.

3) Close and latch the door.

4) Open the door.

5) Measure the depth of the clay to find the latch roller clearance (Figure 507).

a) Make sure that the clearance between the bottom of the latch roller and the latch fitting is 0.04 in. (1.02 mm) - 0.28 in. (7.11 mm).

b) Make sure that the clearance between the back of the latch roller and the latch fitting is not less than 0.005 in. (0.127 mm).

SUBTASK 52-13-00-820-021

(5) Adjust the aft door warning sensors.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) Do this task: Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200), TASK 52-71-11-820-801.

SUBTASK 52-13-00-080-003

(6) Remove the weight or the escape slide simulator, SPL-2003, from the door.

SUBTASK 52-13-00-410-002

(7) Do this task: Aft Entry Door Lining Installation, TASK 52-13-31-400-801.

SUBTASK 52-13-00-410-003

(8) Do this task: Escape Slide Pack and Cover Installation, TASK 25-66-01-400-801.

——— END OF TASK ———

TASK 52-13-00-700-801

4. Aft Entry Door System Test

A. General

(1) The system test is a check that the door is installed and adjusted correctly and that the mechanical systems operate correctly.

(2) Make sure that the installation and adjustment of the door is done. Make sure that the door seal and lining are installed.

B. References

Reference	Title
52-13-00-860-803	Open the AFT Door with the Interior Handle (P/B 201)
52-13-00-860-804	Close the AFT Door with the Interior Handle (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-3898	Adapter - Torque Wrench, Galley and Entry Door Part #: C52008-1 Supplier: 81205

D. Location Zones

Zone	Area
834	Left Aft Entry Door

E. System Test

SUBTASK 52-13-00-940-001

(1) Make sure that the aft entry door is fully closed, latched, and locked.

SUBTASK 52-13-00-730-001

(2) Do a test of the aft entry door as follows:

(a) Make sure that the AFT ENTRY light does not show, on the P5 forward overhead panel, in the flight compartment.

(b) Open the door, do this task: Open the AFT Door with the Interior Handle, TASK 52-13-00-860-803.

(c) Make sure that the AFT ENTRY light, on the P5 forward overhead panel, comes on for the door.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(d) Close and latch the door, do this task: Close the AFT Door with the Interior Handle, TASK 52-13-00-860-804.

(e) Make sure that the AFT ENTRY light goes off.

SUBTASK 52-13-00-730-002

(3) Do a test of the door handle torque as follows:

(a) Install the adapter, SPL-3898, on the interior door handle.

(b) Open the door, do this task: Open the AFT Door with the Interior Handle, TASK 52-13-00-860-803.

(c) Measure the torque on the interior handle perpendicular to the handle cam to close the door.

(d) Make sure that the maximum torque on the interior handle to close the door is 600 in-lb (68 N·m).

NOTE: The maximum torque on the interior handle to close the door without the escape slide pack and door lining, but with 77 lb (35 kg) of weight and the door seal installed, is 500 in-lb (56 N·m).

1) If the maximum handle torque is more than 600 in-lb (68 N·m), do these steps:

NOTE: The most likely cause for the increase in door closing force is the door guide ball is binding in the track.

a) Make sure that the door guide ball is correctly adjusted.

b) Make sure that the stop pins are correctly adjusted.

c) Make sure that the upper and lower gates are correctly adjusted.

d) Adjust the horizontal control rod, do this task: Aft Entry Door Adjustment, TASK 52-13-00-820-801.

NOTE: Do the Horizontal Control Rod Adjustment only.

(e) Close and latch the door, do this task: Close the AFT Door with the Interior Handle, TASK 52-13-00-860-804.

(f) Measure the torque on the interior handle perpendicular to the handle cam to open the door.

(g) Make sure that the maximum torque on the interior handle to open the door is 360 in-lb (41 N·m).

NOTE: In this step the door is only opened to the cocked position.

1) If the maximum handle torque is more than 360 in-lb (41 N·m), do these steps:

a) Make sure that the door is correcly installed.

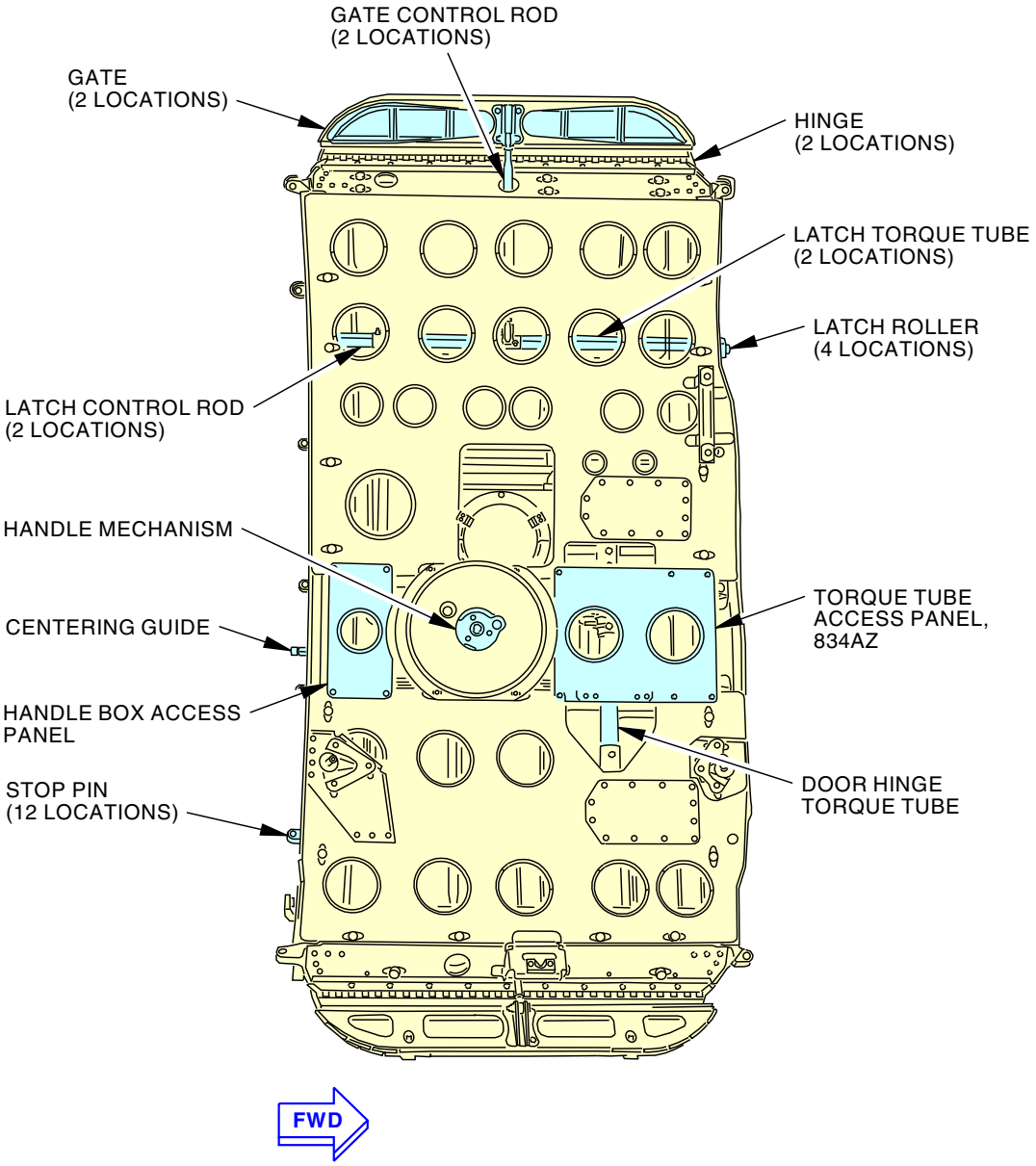
b) Adjust the horizontal control rod, do this task: Aft Entry Door Adjustment, TASK 52-13-00-820-801.

NOTE: Do the Horizontal Control Rod Adjustment only.

(h) Remove the adapter, SPL-3898, from the internal door handle.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

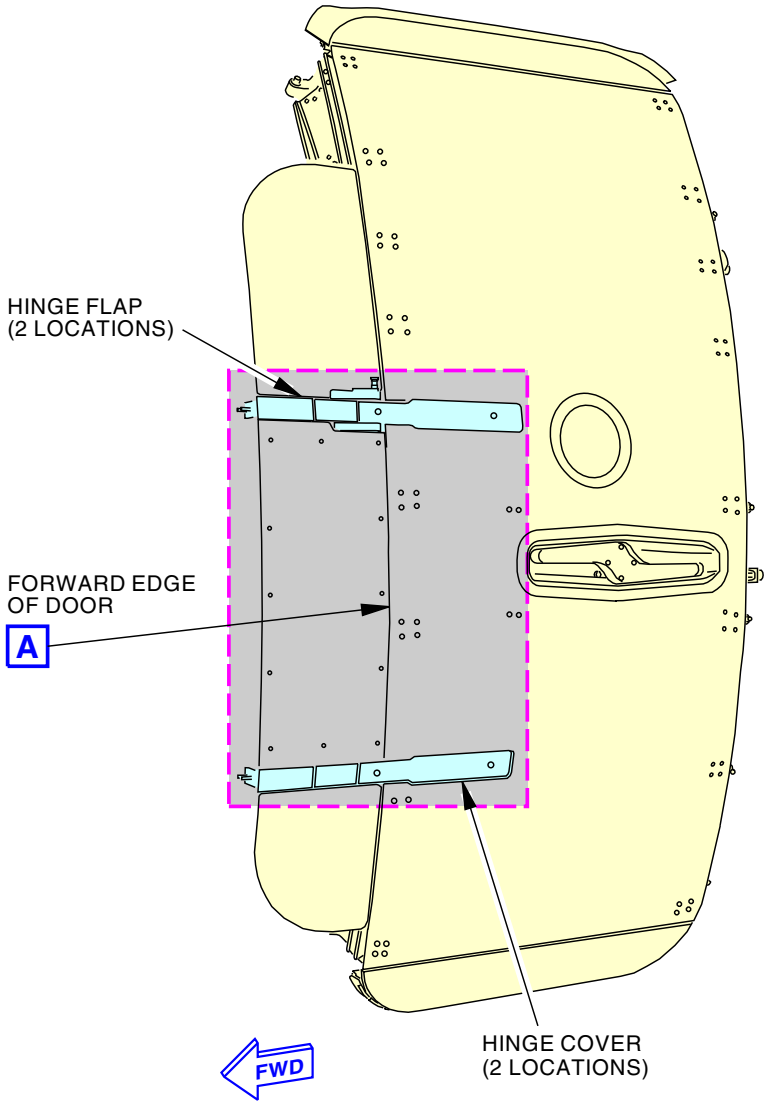


AFT ENTRY DOOR

2415777 S00061538882_V1

Aft Entry Door Adjustment
Figure 501/52-13-00-990-804

ECCN 9E991 BOEING PROPRIETARY - See title page for details

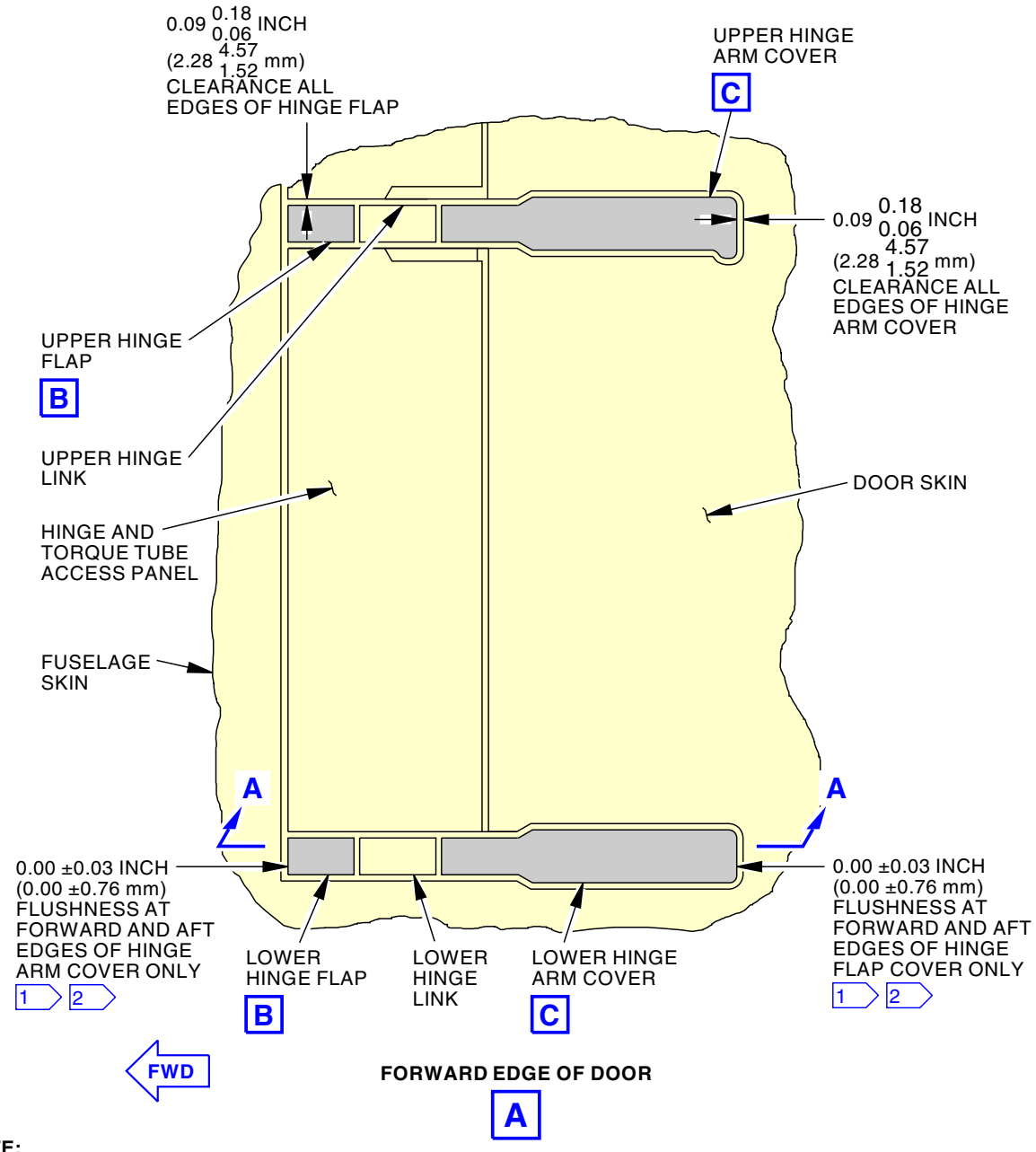


AFT ENTRY DOOR

2415778 S00061538883_V1

Hinge Flap and Hinge Arm Cover Adjustment
Figure 502/52-13-00-990-805 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



NOTE:

DIMENSION STANDARD: NOMINAL UPPER LIMIT LOWER LIMIT

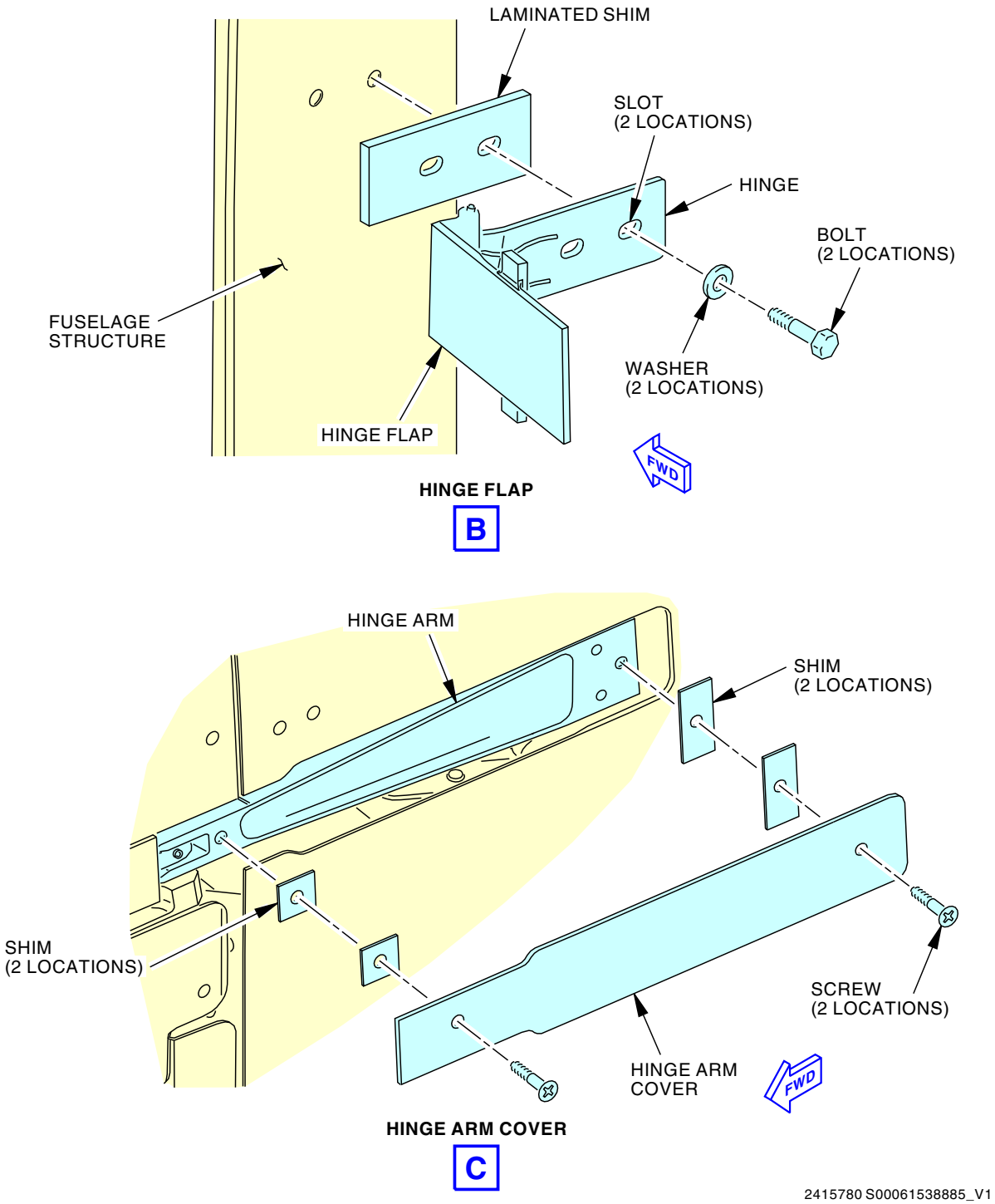
1 FLUSHNESS AT UPPER AND LOWER EDGES IS A TRANSITION FROM THE FORWARD TO THE AFT EDGE.

2 UNLESS SPECIFIED OTHERWISE IN THE PROCEDURE.

2415779 S00061538884_V1

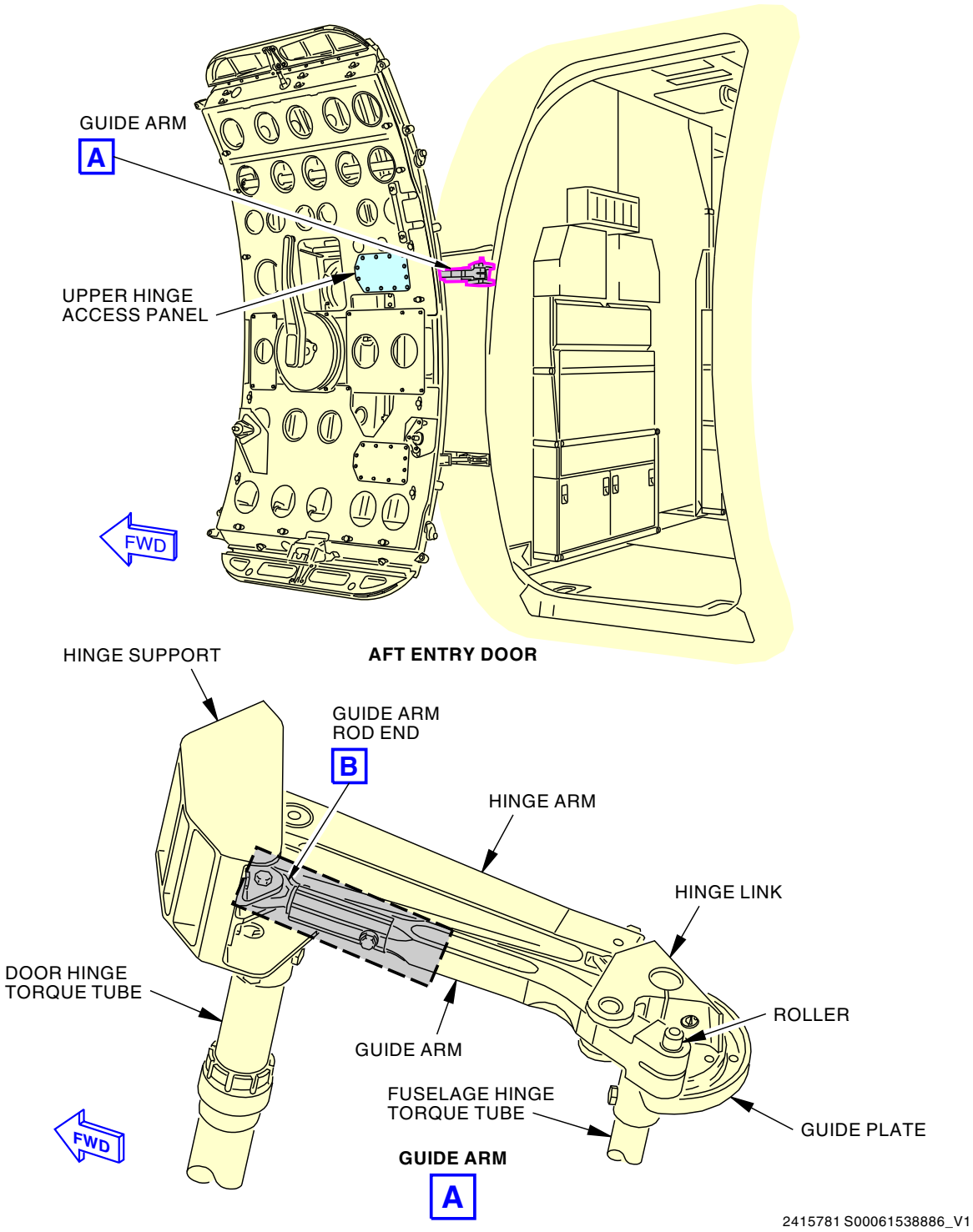
Hinge Flap and Hinge Arm Cover Adjustment
Figure 502/52-13-00-990-805 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



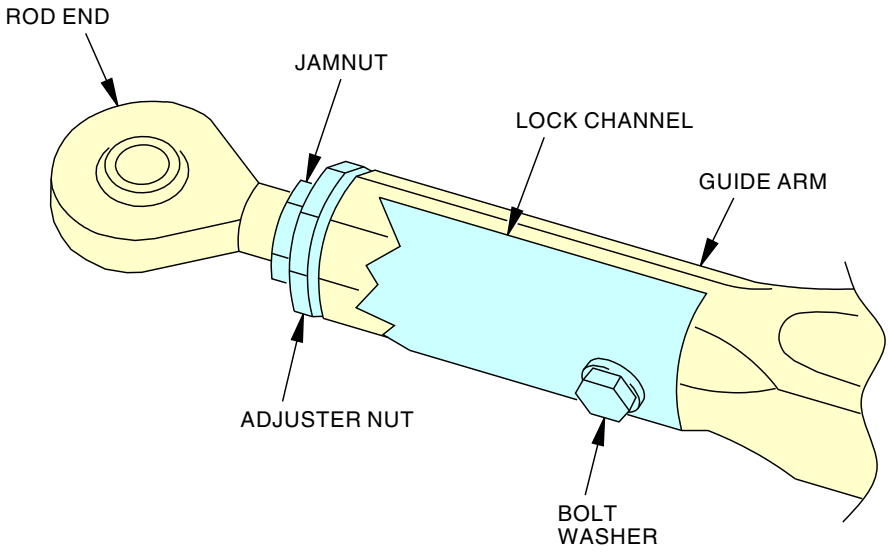
Hinge Flap and Hinge Arm Cover Adjustment
Figure 502/52-13-00-990-805 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Guide Arm Adjustment
Figure 503/52-13-00-990-806 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



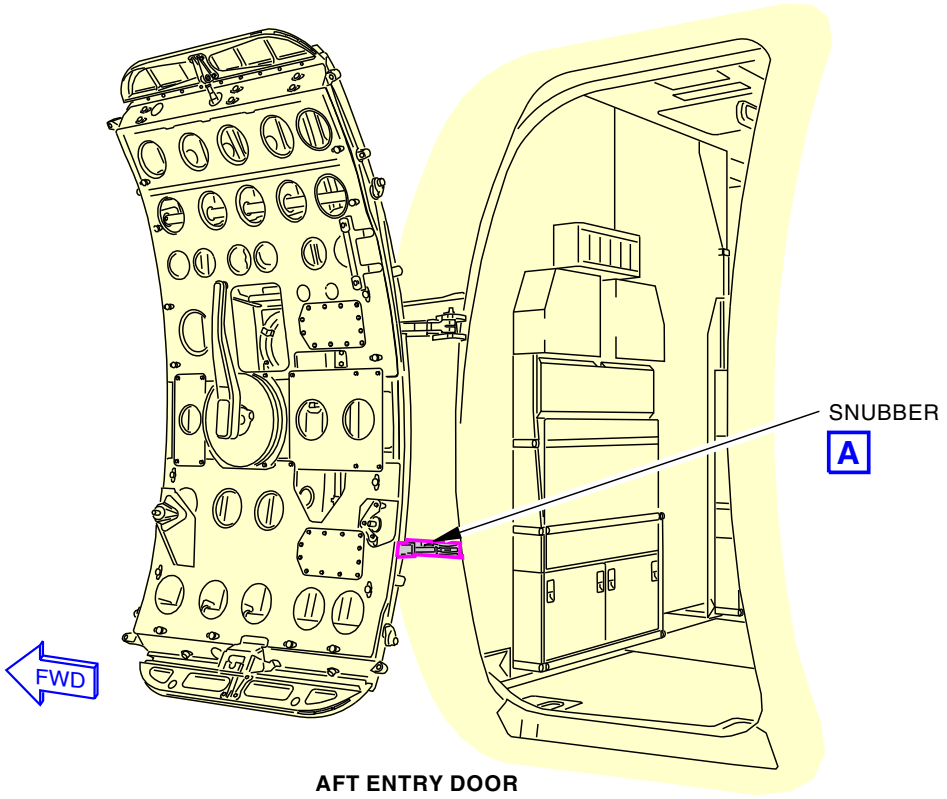
GUIDE ARM ROD END

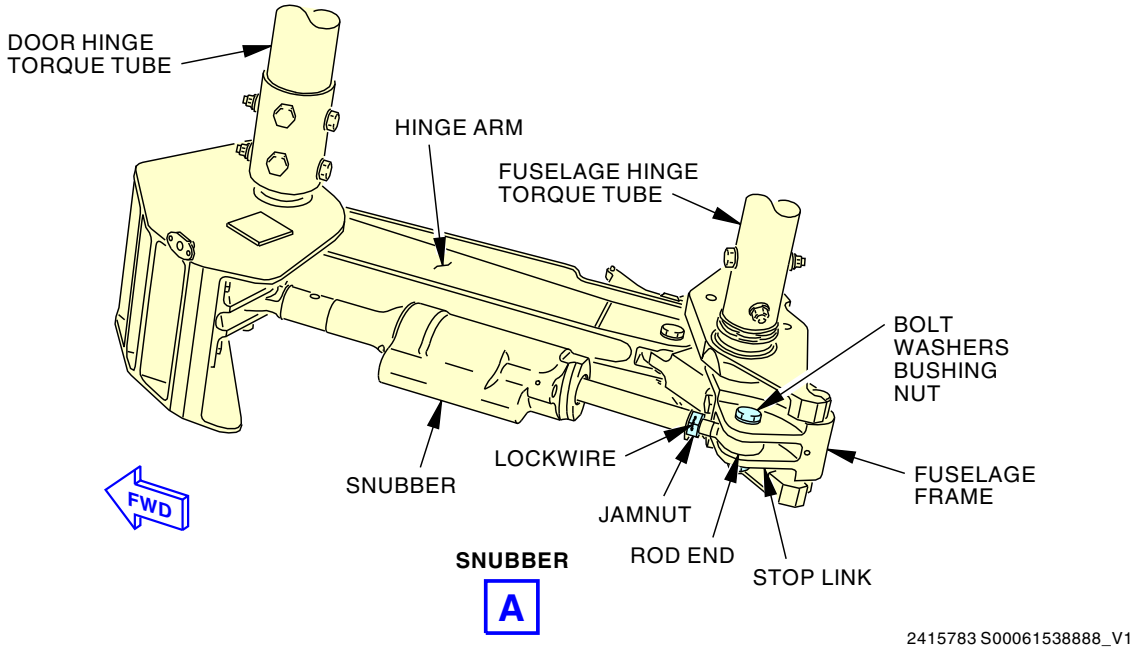
B

2415782 S00061538887_V1

Guide Arm Adjustment
Figure 503/52-13-00-990-806 (Sheet 2 of 2)

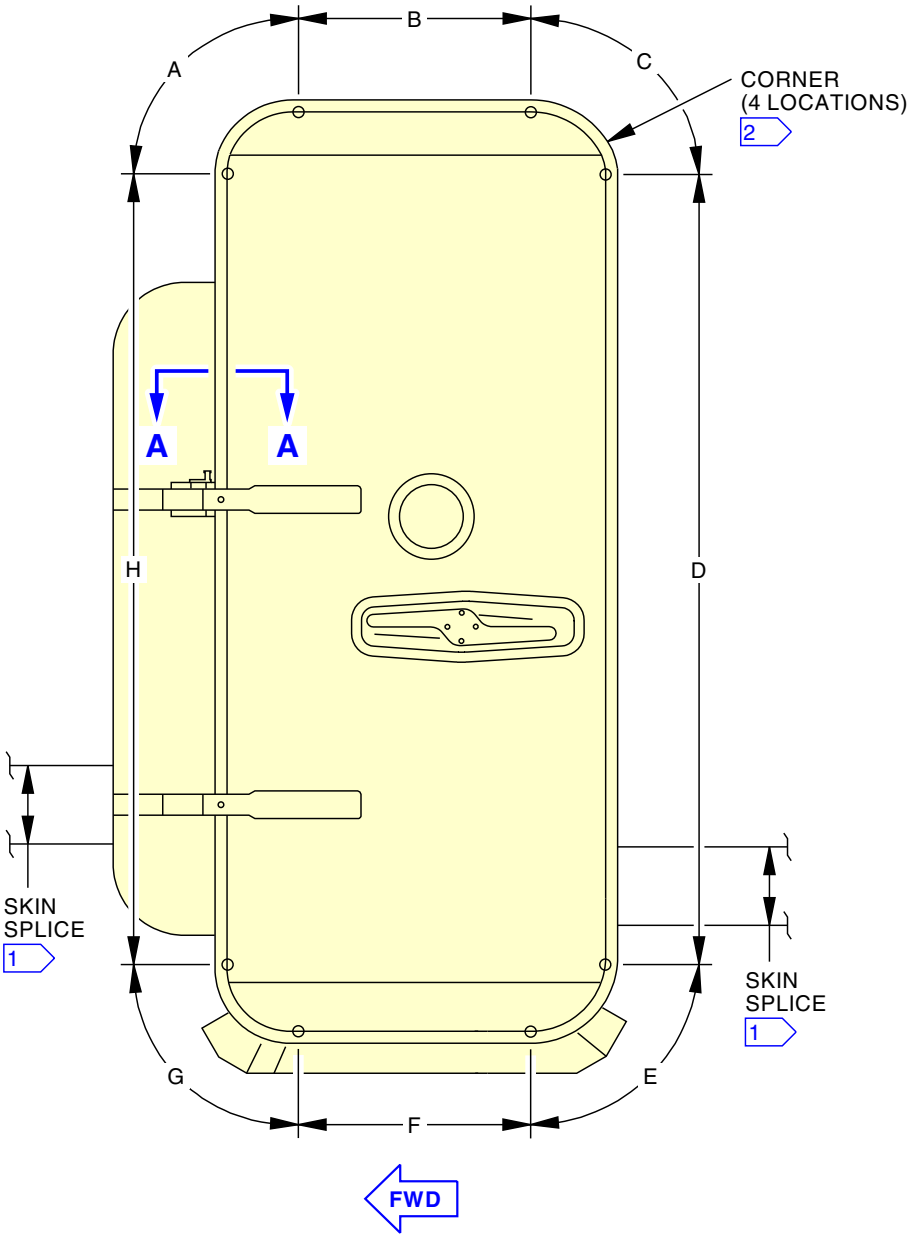
ECCN 9E991 BOEING PROPRIETARY - See title page for details





Snubber Adjustment
Figure 504/52-13-00-990-807

ECCN 9E991 BOEING PROPRIETARY - See title page for details



NOTE:

DIMENSION STANDARD: NOMINAL / UPPER LIMIT / LOWER LIMIT

REFER TO THE METHOD 1 TABLE OR THE METHOD 2 TABLE FOR AERODYNAMIC SMOOTHNESS LIMITS.

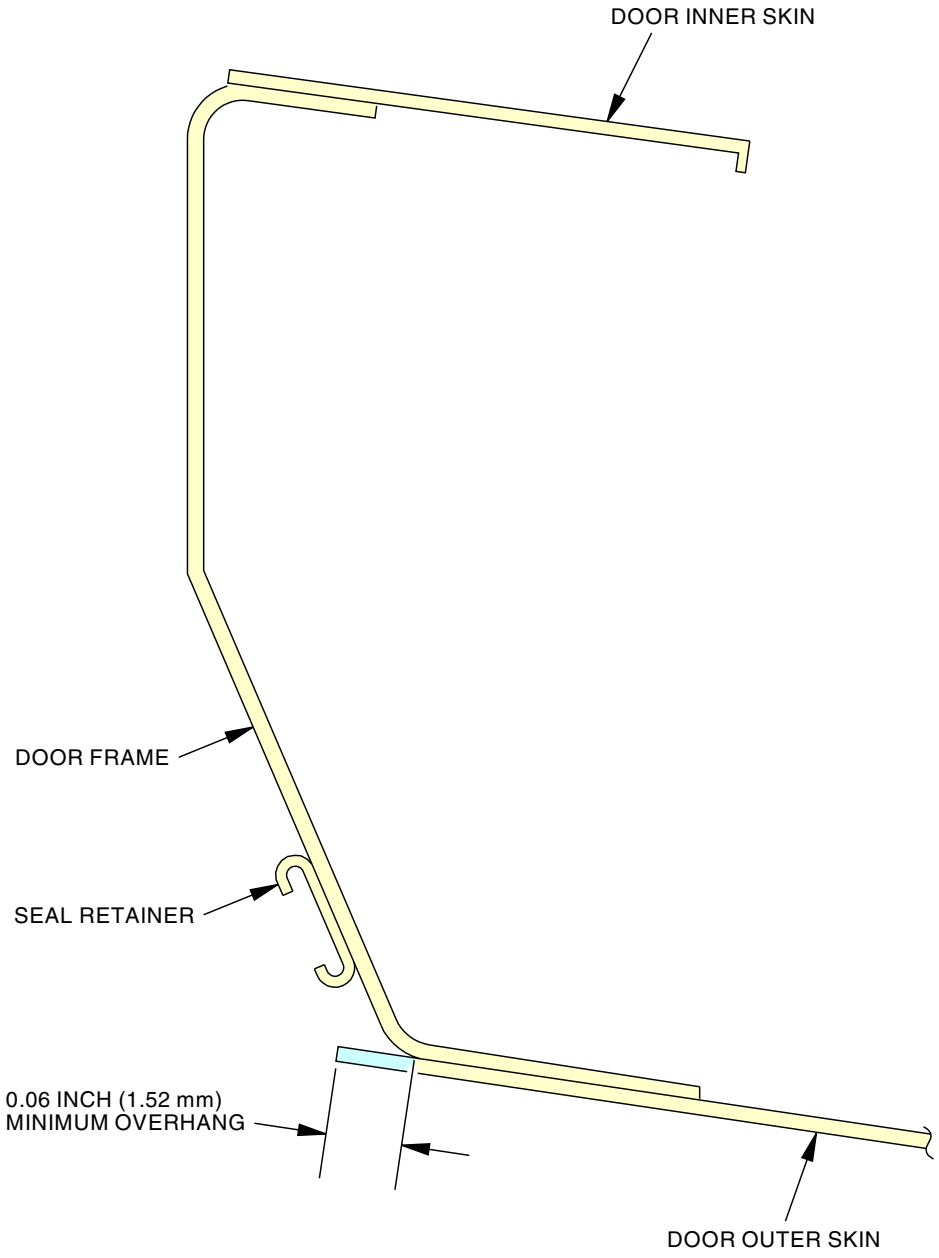
1 THE FLUSHNESS AT SKIN SPLICES WILL BE MORE THAN THE FLUSHNESS SHOWN BY ADDITIONAL SKIN AND BONDING THICKNESS.

2 FLUSHNESS IS NOT APPLICABLE AT CORNERS.

2415784 S00061538889_V1

Aft Entry Door Skin Clearance and Flushness
Figure 505/52-13-00-990-808 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



A-A

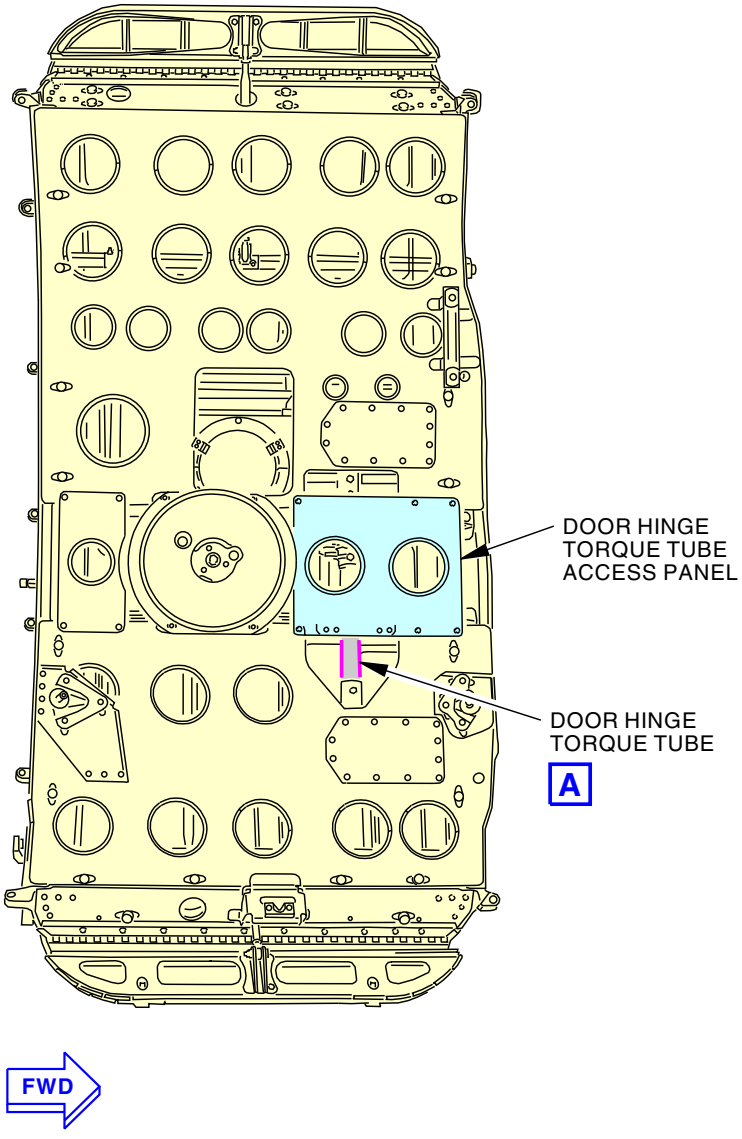
NOTE:

DIMENSION STANDARD: NOMINAL
UPPER LIMIT
LOWER LIMIT

2415785 S00061538890_V1

Aft Entry Door Skin Clearance and Flushness
Figure 505/52-13-00-990-808 (Sheet 2 of 2)

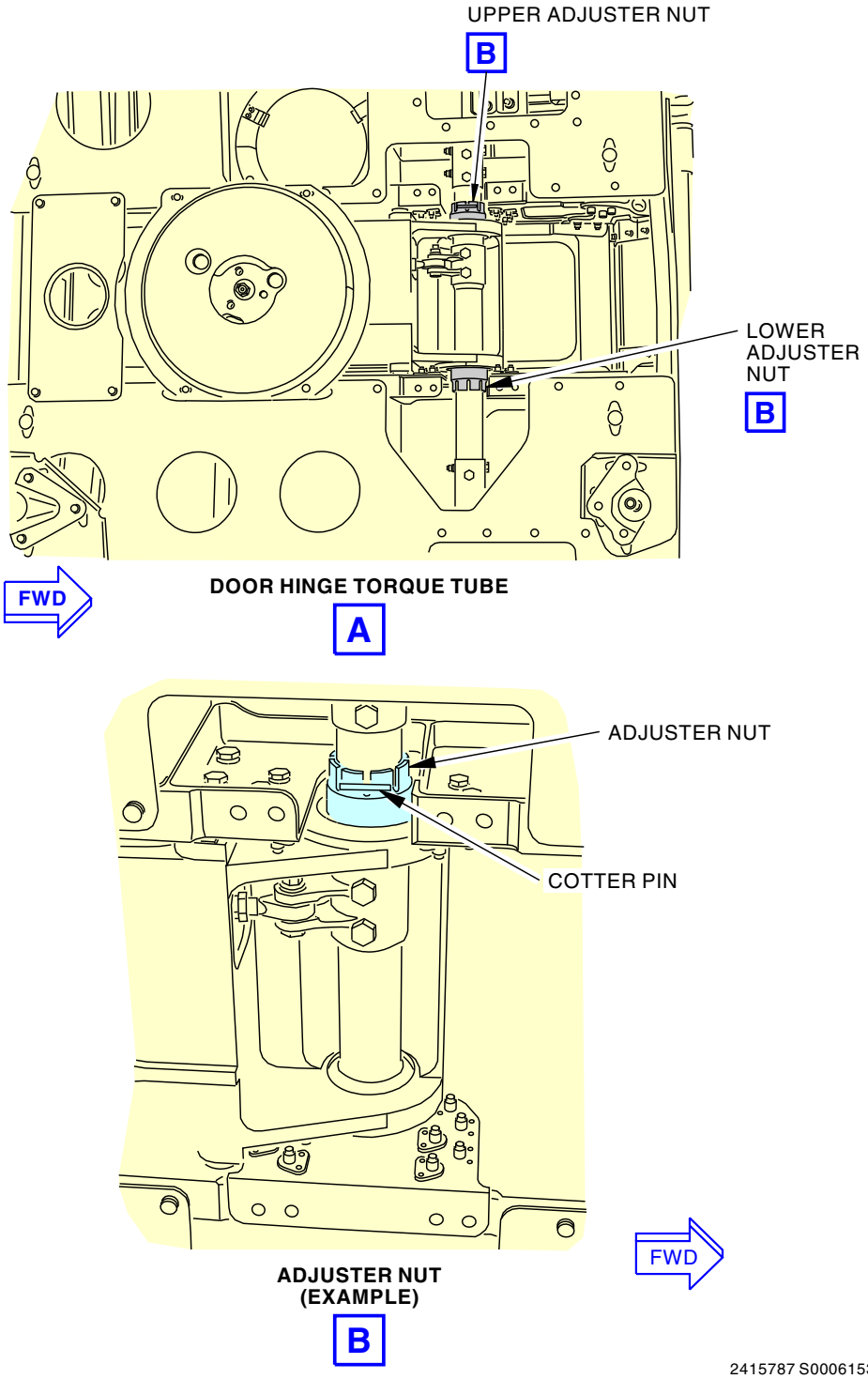
ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415786 S00061538891_V1

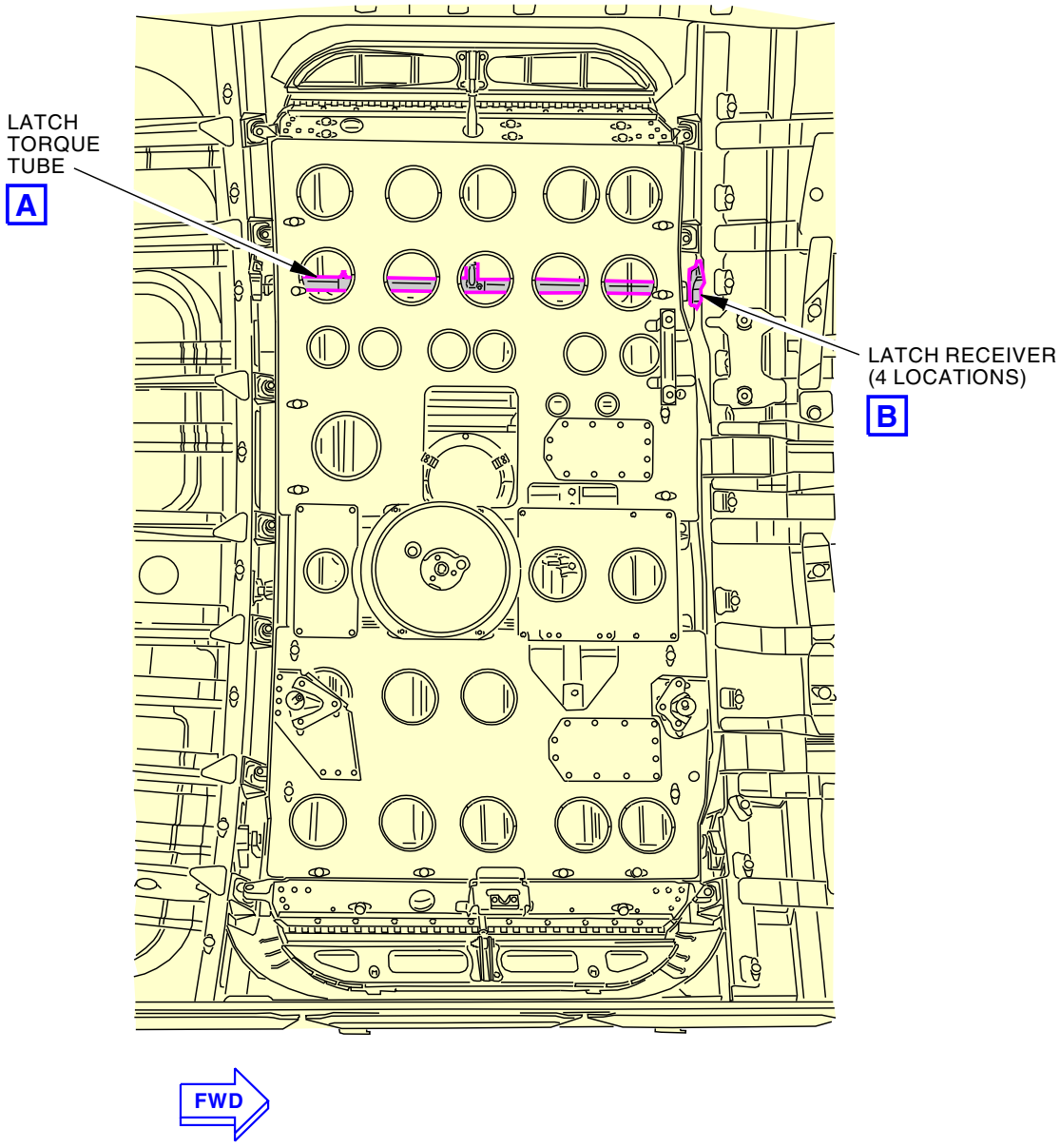
Door Hinge Torque Tube Adjustment
Figure 506/52-13-00-990-809 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



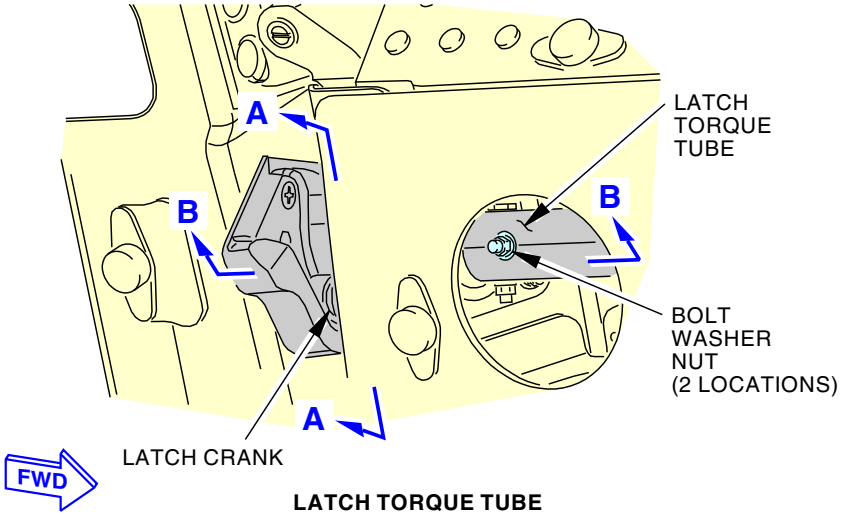
Door Hinge Torque Tube Adjustment
Figure 506/52-13-00-990-809 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



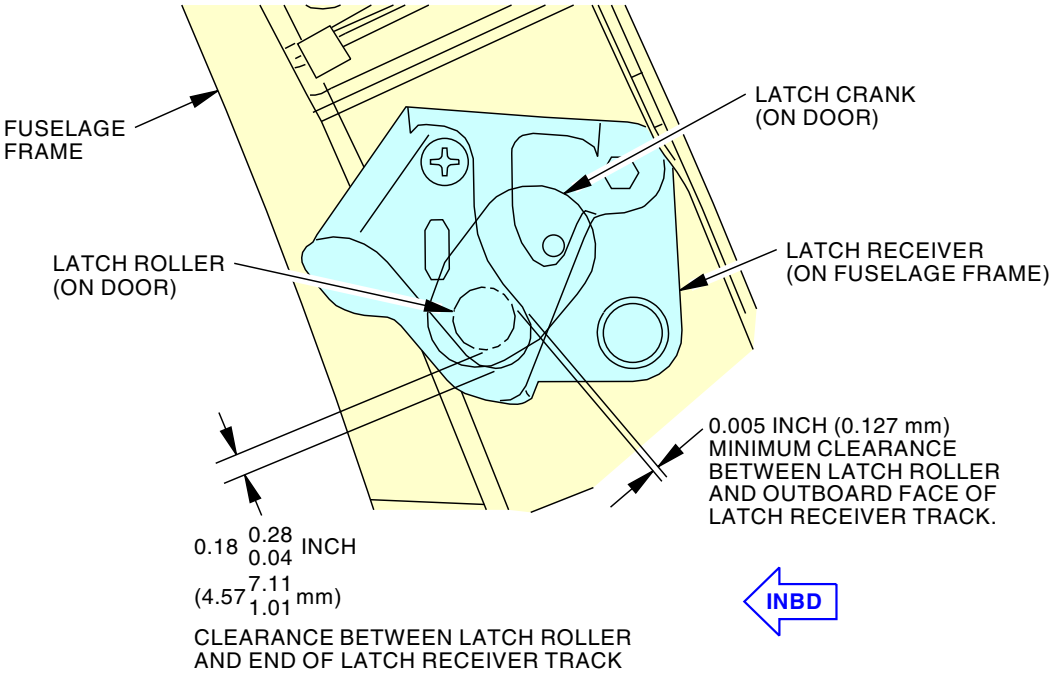
Latch Adjustment
Figure 507/52-13-00-990-810 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



LATCH TORQUE TUBE

A



LATCH ROLLER AND LATCH RECEIVER CLEARANCE

A-A

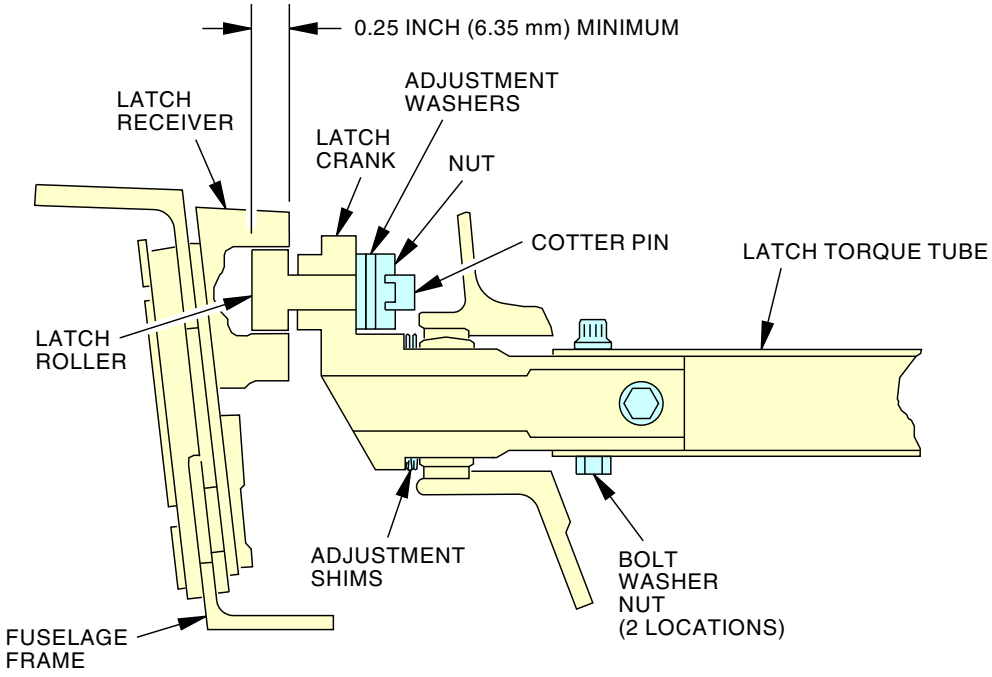
NOTE:

DIMENSION STANDARD: NOMINAL LOWER LIMIT UPPER LIMIT.

2415789 S00061538894_V2

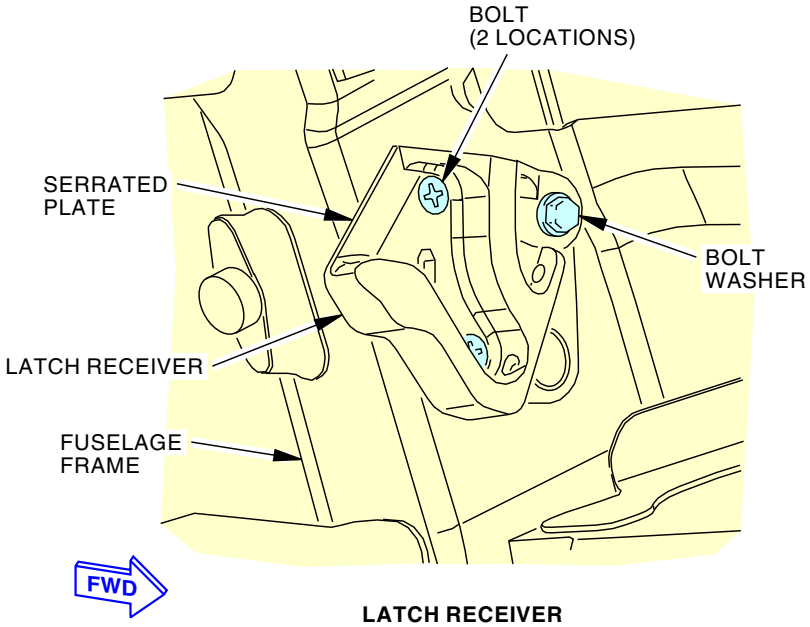
Latch Adjustment
Figure 507/52-13-00-990-810 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



LATCH ROLLER AND LATCH RECEIVER ENGAGEMENT

B-B



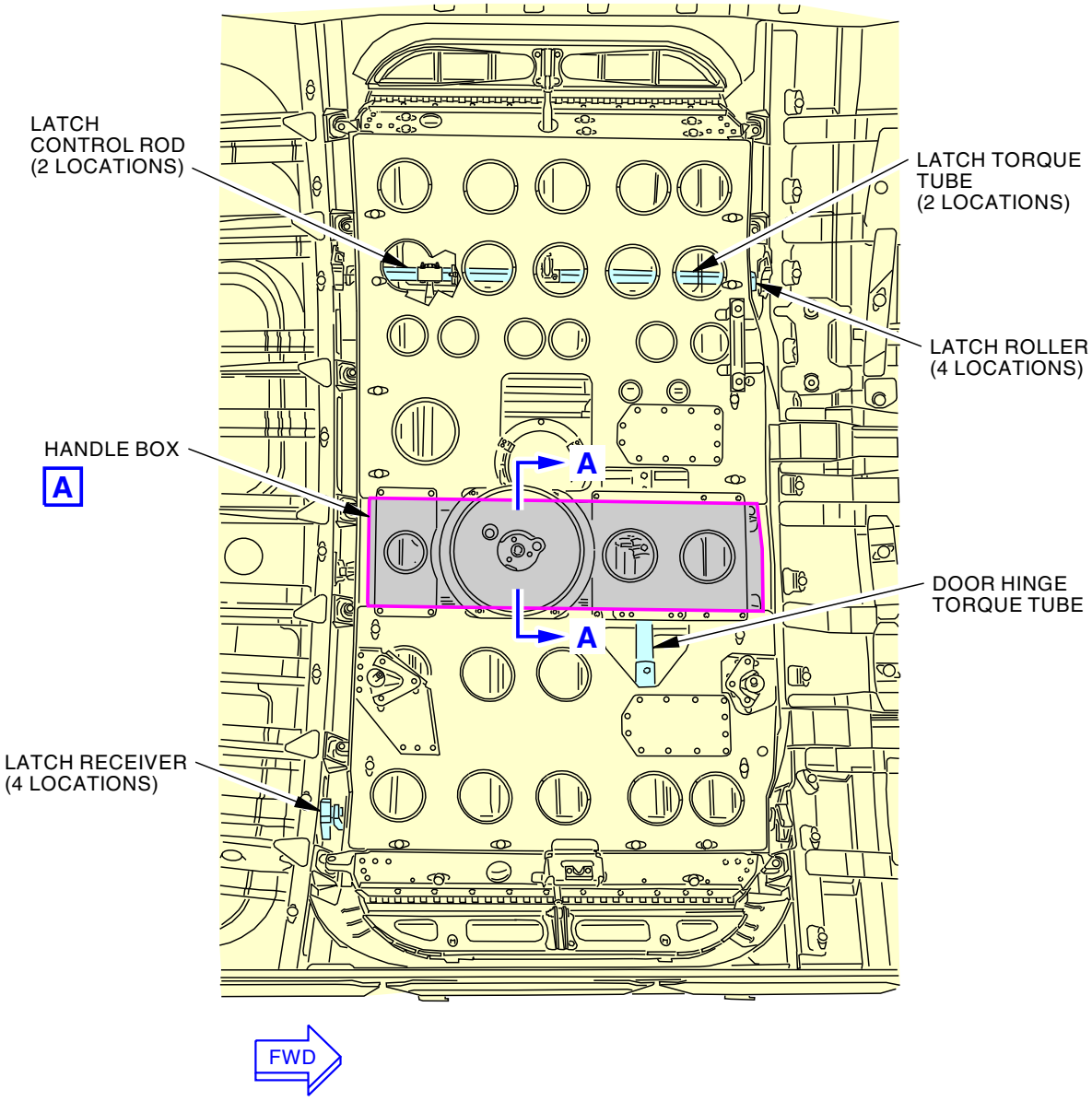
LATCH RECEIVER

B

2415790 S00061538895_V1

Latch Adjustment
Figure 507/52-13-00-990-810 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

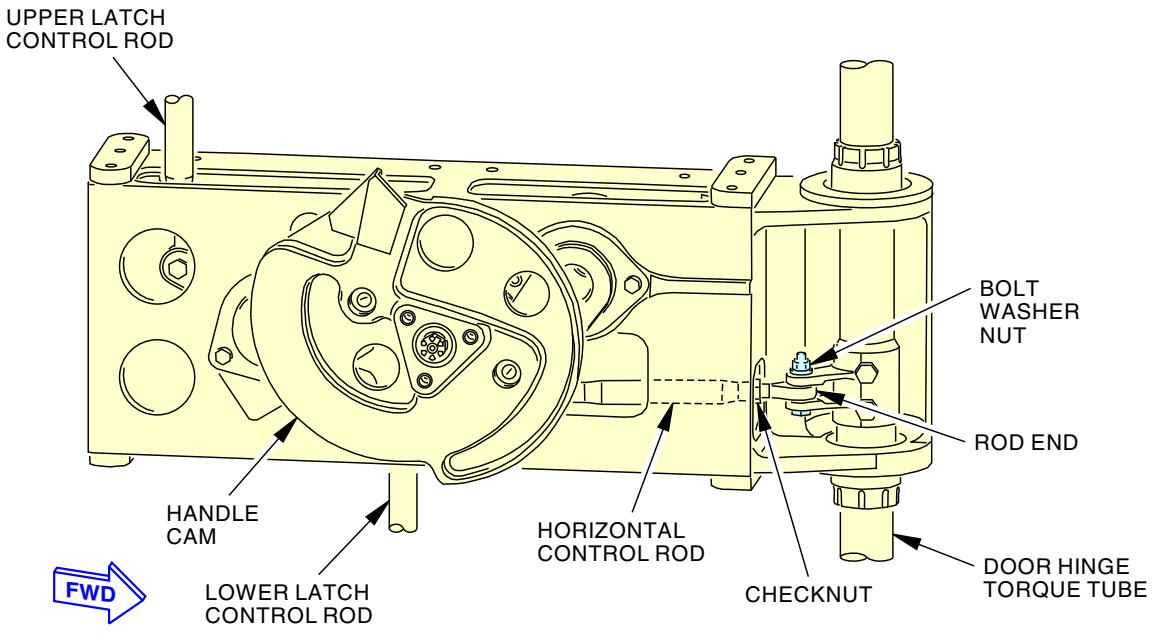


AFT ENTRY DOOR

2415791 S00061538896_V1

Horizontal Control Rod Adjustment
Figure 508/52-13-00-990-811 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



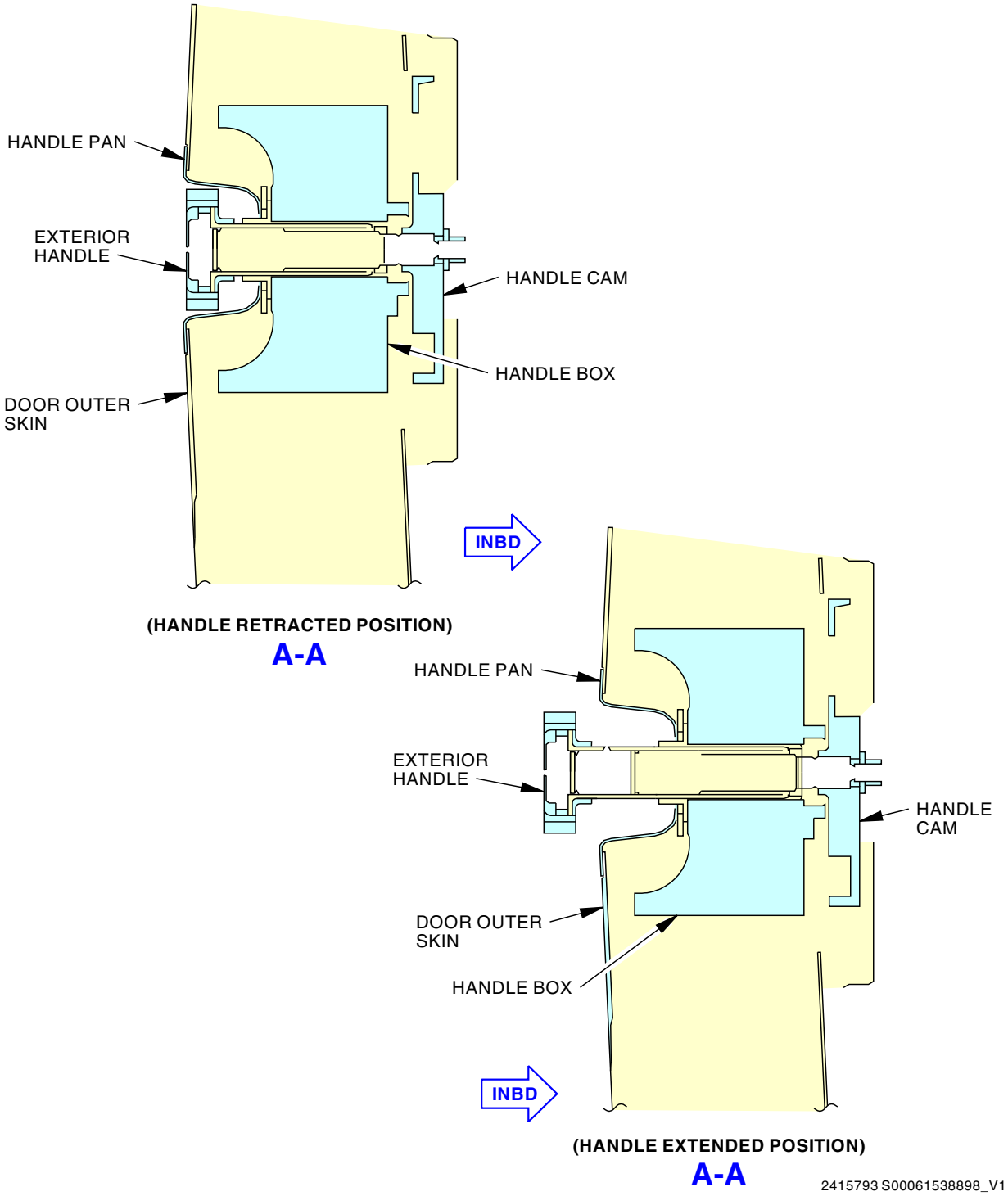
HANDLE BOX

A

2415792 S00061538897_V1

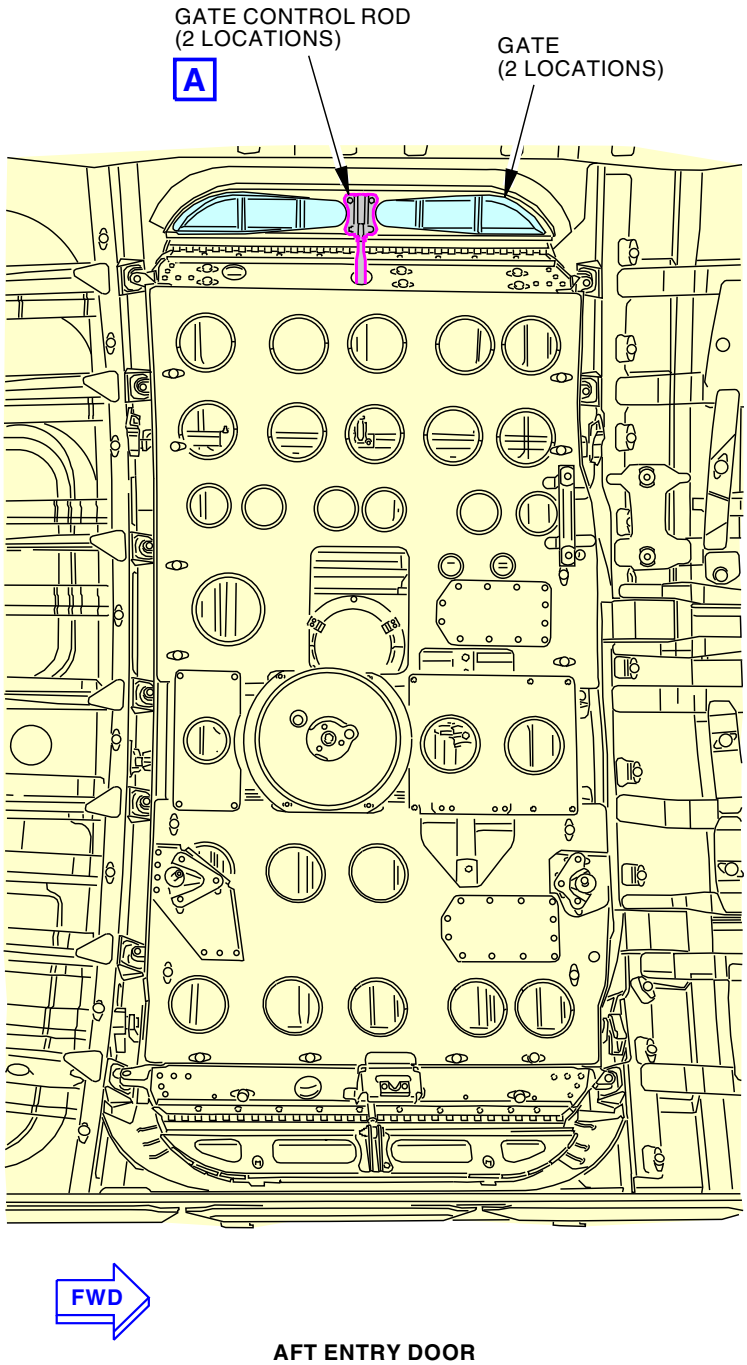
Horizontal Control Rod Adjustment
Figure 508/52-13-00-990-811 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



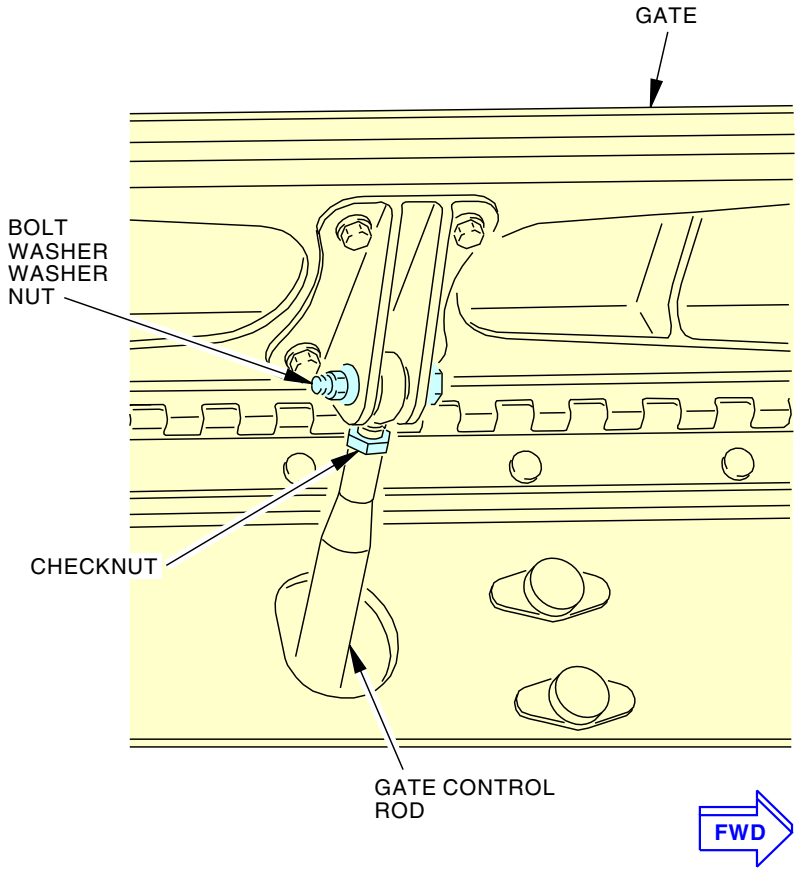
Horizontal Control Rod Adjustment
Figure 508/52-13-00-990-811 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Gate Adjustment
Figure 509/52-13-00-990-812 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



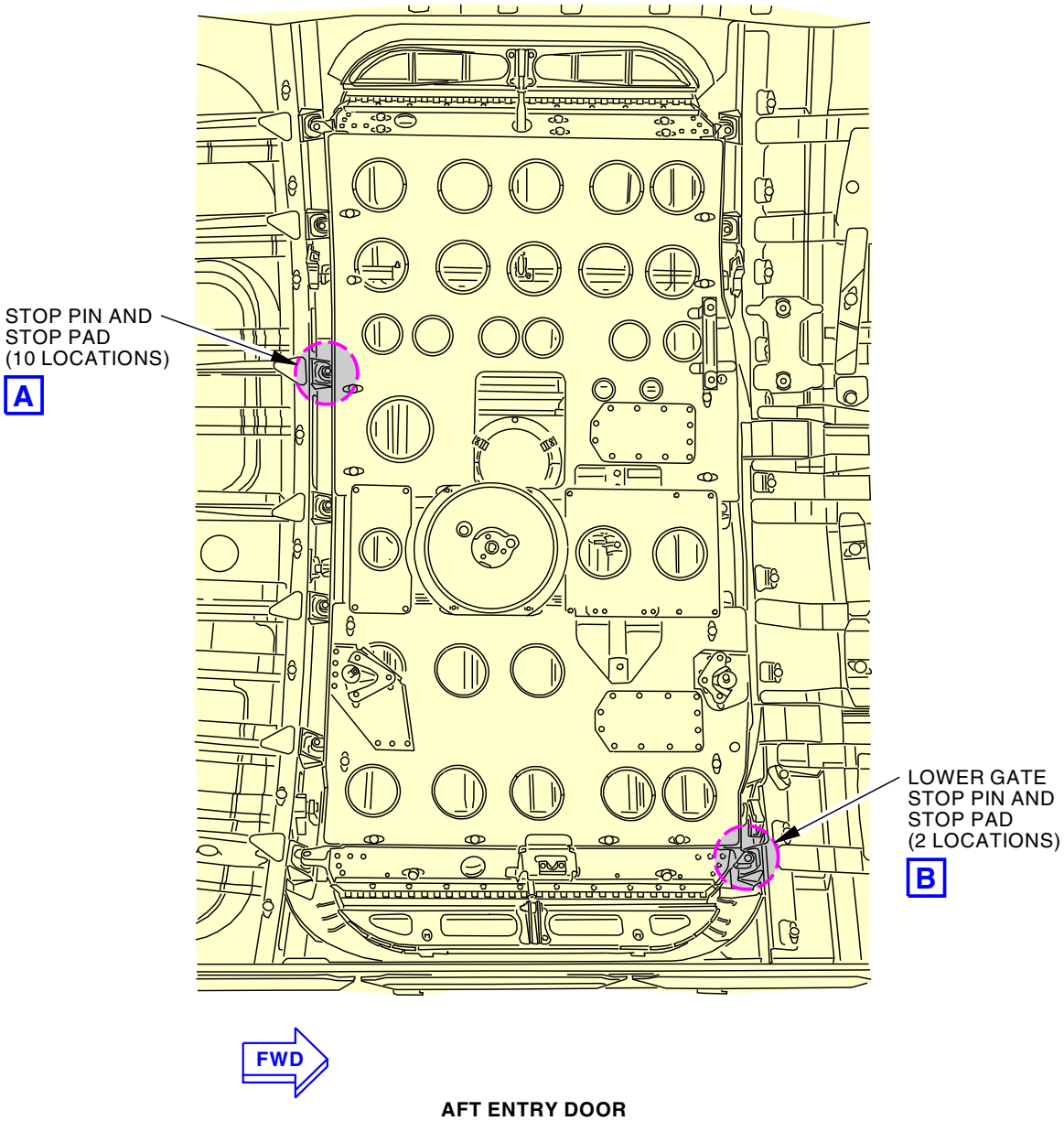
GATE CONTROL ROD
(EXAMPLE)

A

2415795 S00061538900_V1

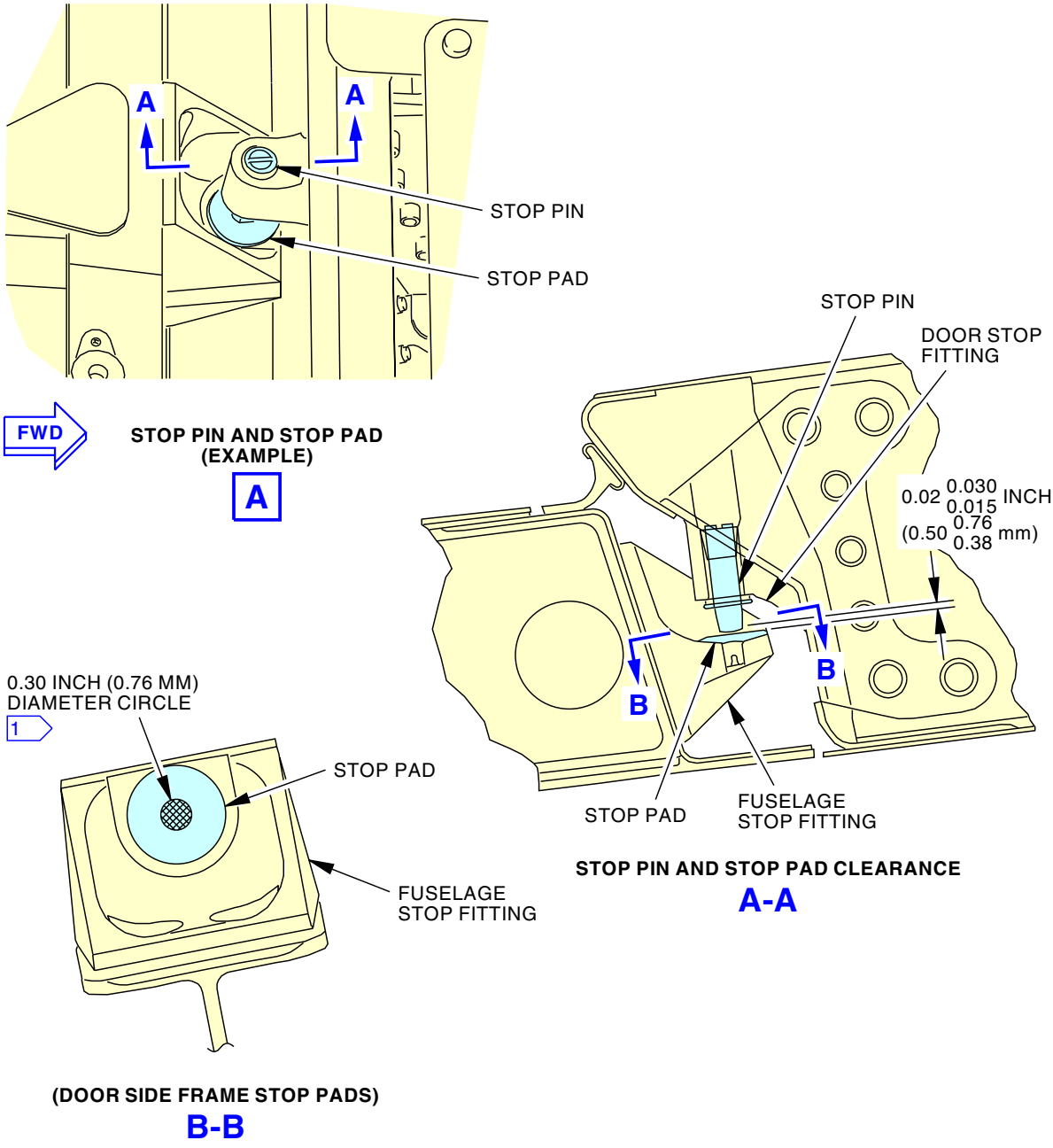
Gate Adjustment
Figure 509/52-13-00-990-812 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Stop Pin Adjustment
Figure 510/52-13-00-990-813 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



NOTE:

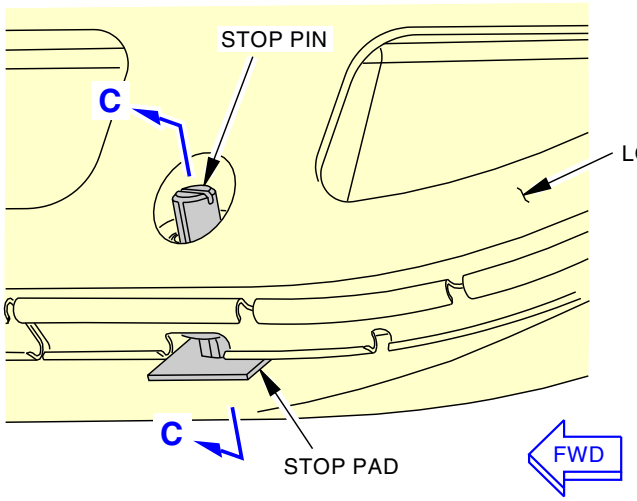
DIMENSION STANDARD: NOMINAL UPPER LIMIT / LOWER LIMIT.

1 STOP PIN CENTER MUST TOUCH STOP PAD CENTER WITHIN THE CIRCLE DIAMETER SHOWN.

2415797 S00061538902_V1

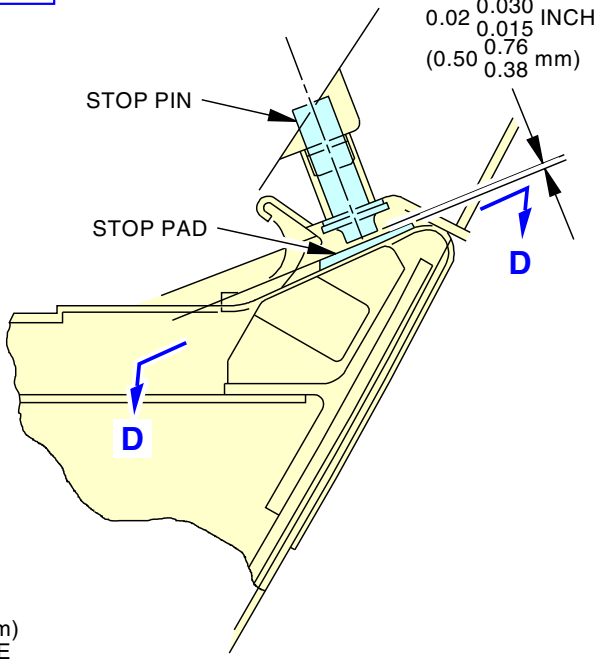
Stop Pin Adjustment
Figure 510/52-13-00-990-813 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



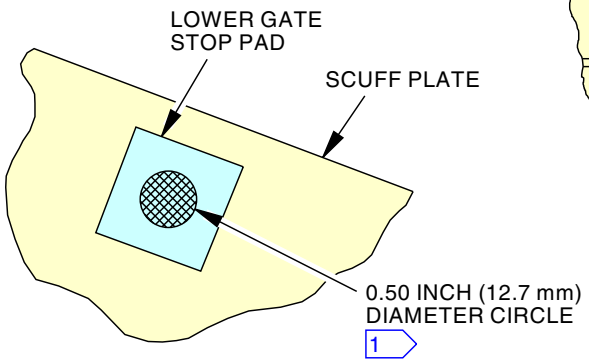
STOP PIN AND STOP PAD ALIGNMENT (LOWER GATE STOP PAD)

B



STOP PIN AND STOP PAD CLEARANCE

C-C



STOP PIN AND STOP PAD ALIGNMENT (LOWER GATE STOP PADS)

D-D

NOTE:

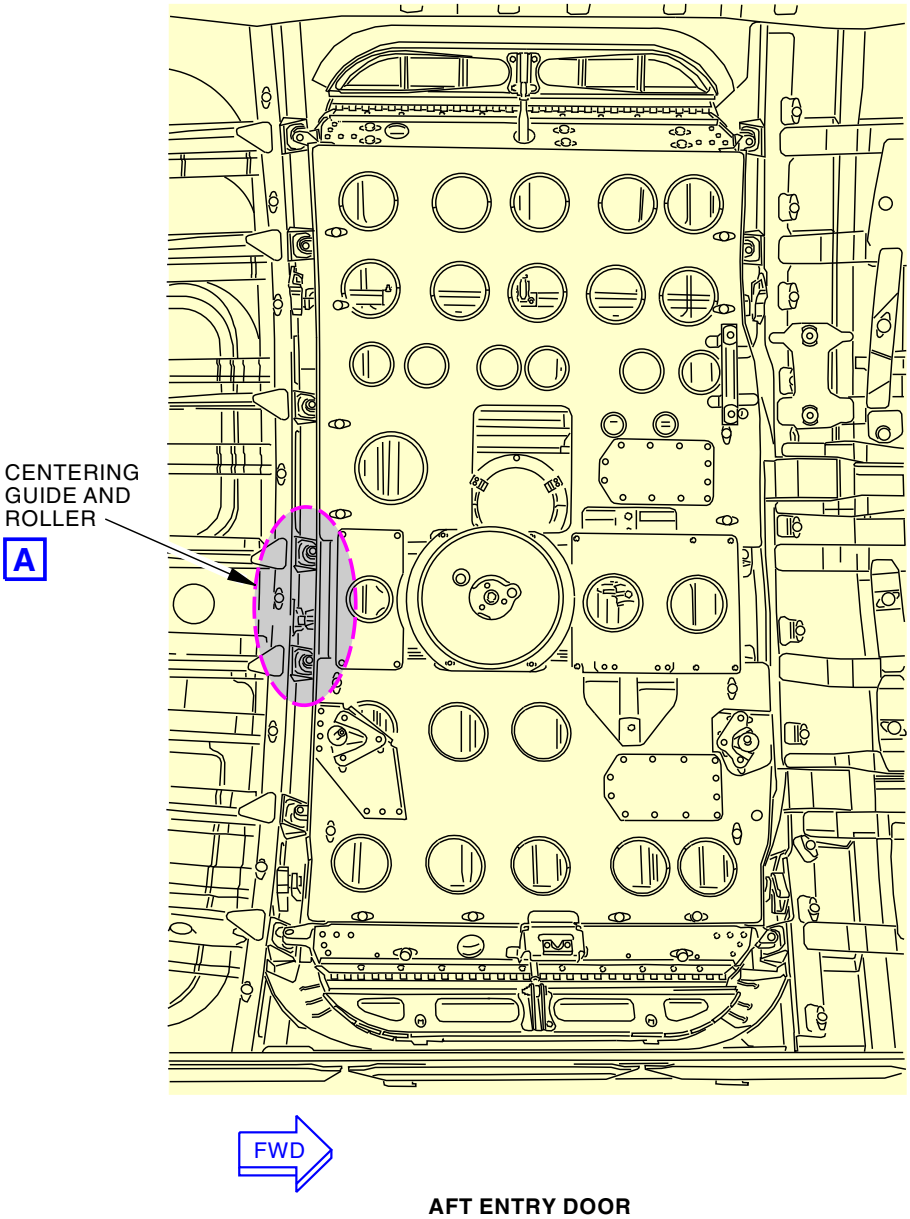
DIMENSION STANDARD: NOMINAL / UPPER LIMIT / LOWER LIMIT

1 STOP PIN CENTER MUST TOUCH STOP PAD CENTER WITHIN THE CIRCLE DIAMETER SHOWN.

2415798 S00061538903_V1

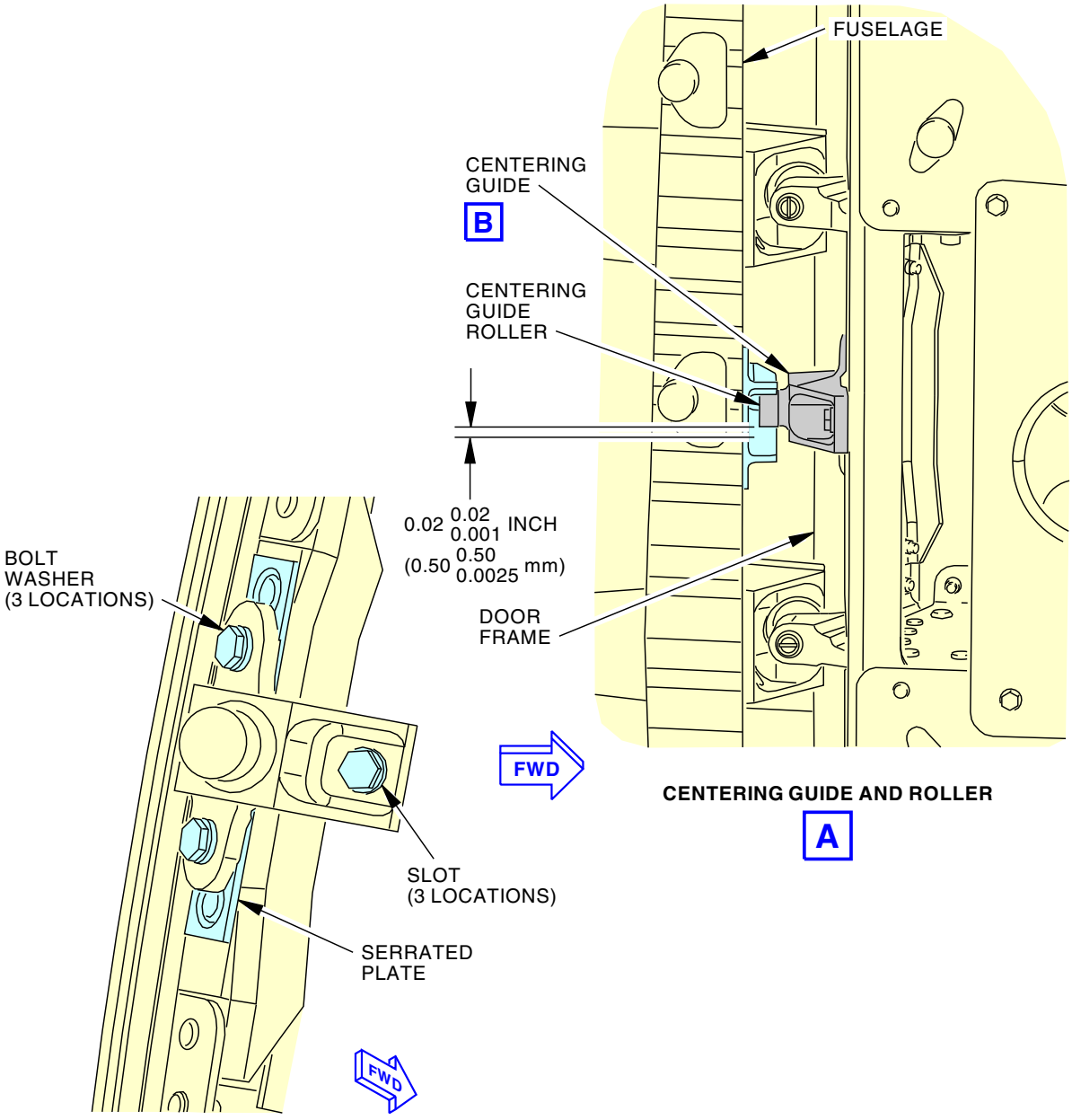
Stop Pin Adjustment
Figure 510/52-13-00-990-813 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Centering Guide Adjustment
Figure 511/52-13-00-990-814 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



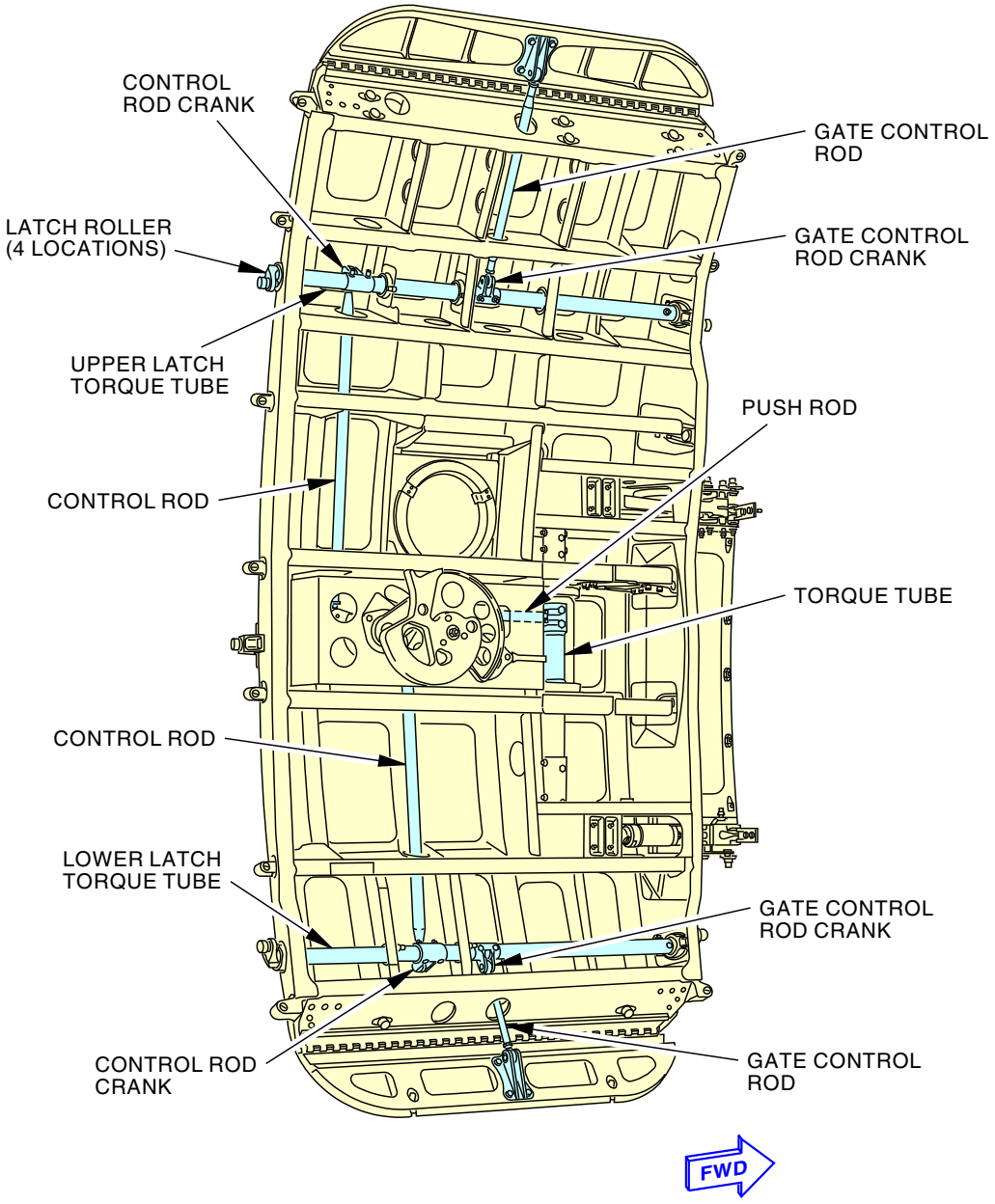
NOTE:

DIMENSION STANDARD: NOMINAL UPPER LIMIT LOWER LIMIT·

2415800 S00061538905_V2

Centering Guide Adjustment
Figure 511/52-13-00-990-814 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

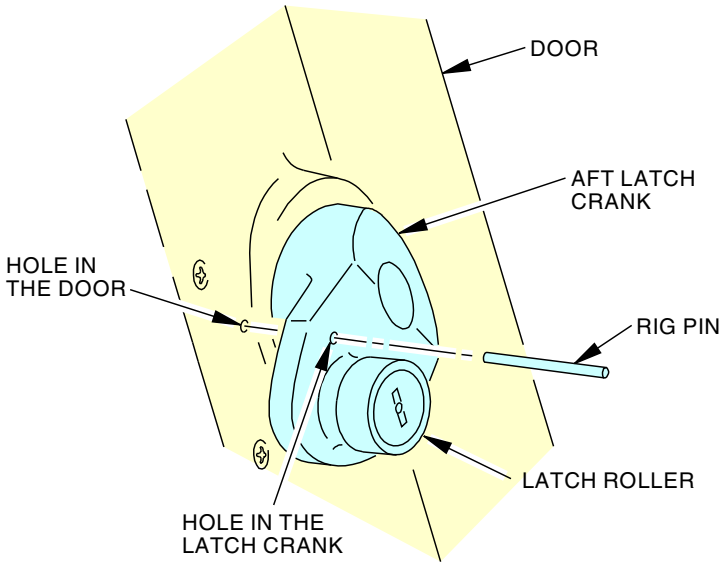


AFT ENTRY DOOR

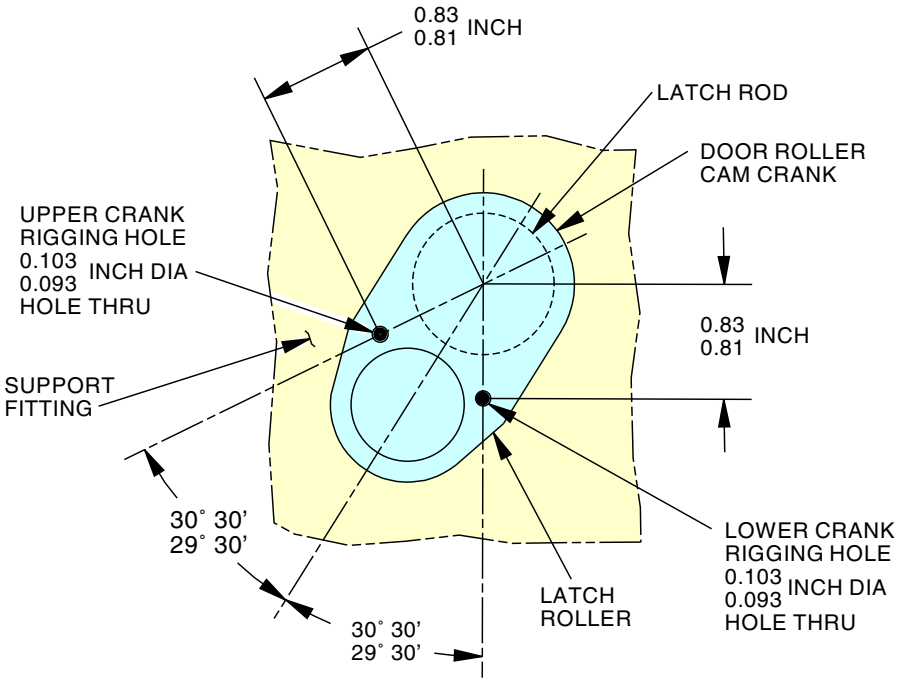
2415801 S00061538906_V1

Aft Entry Door Mechanism
Figure 512/52-13-00-990-815 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



THE HOLE IN THE LATCH CRANK MUST ALIGN WITH THE HOLE IN THE DOOR WHEN THE HANDLE IS IN THE LATCHED POSITION.



2415802 S00061538907_V1

Aft Entry Door Mechanism
Figure 512/52-13-00-990-815 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AFT ENTRY DOOR - INSPECTION/CHECK

1. General

A. This procedure has these tasks:

(1) A check of the aft entry door

(2) A check of the aft entry door centering guide bearing

(3) A check of the aft entry door pressure seal

(4) A vacuum tool leak check of the after entry door seal.

TASK 52-13-00-200-801

2. Aft Entry Door Check

A. References

Reference	Title
52-13-00 P/B 201	AFT ENTRY DOOR - MAINTENANCE PRACTICES
52-13-31-000-801	Aft Entry Door Lining Removal (P/B 401)
52-13-31-400-801	Aft Entry Door Lining 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Location Zones

Zone	Area
834	Left Aft Entry Door

D. Access Panels

Number	Name/Location
834AZ	Aft Entry Door - Torque Tube Access
834BZ	Aft Entry Door - Handle Box and Cam for Handle Box Access
834CZ	Aft Entry Door - Handle Box Access
834DZ	Aft Entry Door - Lower Hinge Access
834EZ	Aft Entry Door - Upper Hinge Access
834FZ	Aft Entry Door - Torque Tube Access
834GZ	AFT Entry Door - Torque Tube Access

E. Prepare for the Inspection

SUBTASK 52-13-00-860-029

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched (PAGEBLOCK 52-13-00/201).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure that the work platform, COM-1523, is installed outboard of the door.

SUBTASK 52-13-00-010-005

(2) Do this task: Aft Entry Door Lining Removal, TASK 52-13-31-000-801.

SUBTASK 52-13-00-010-006

(3) Remove the access panels as necessary to get access to the door components:

Number	Name/Location
834AZ	Aft Entry Door - Torque Tube Access
834BZ	Aft Entry Door - Handle Box and Cam for Handle Box Access
834CZ	Aft Entry Door - Handle Box Access
834DZ	Aft Entry Door - Lower Hinge Access
834EZ	Aft Entry Door - Upper Hinge Access
834FZ	Aft Entry Door - Torque Tube Access
834GZ	AFT Entry Door - Torque Tube Access

SUBTASK 52-13-00-010-007

(4) Open and close the door as necessary to inspect the door components (PAGEBLOCK 52-13-00/201).

F. Aft Entry Door Inspection

SUBTASK 52-13-00-210-001

(1) Do a visual inspection of the external door structure and handle as follows:

(a) Examine the external skin.

1) Look for dents, cracks, and corrosion.

2) Look for burrs.

3) Look for loose and missing fasteners.

(b) Examine the window.

1) Look for cracks.

2) Look for crazing.

(c) Examine the window frame.

1) Look for cracks and corrosion.

(d) Examine the external handle.

1) Look for cracks and corrosion.

2) Look for too much wear.

(e) Examine the handle pan.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

SUBTASK 52-13-00-210-002

(2) Do a visual inspection of the door internal structure and handle mechanism as follows:

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) Examine the internal skin.
  1) Look for dents, cracks, and corrosion.
  2) Look for burrs.
  3) Look for loose and missing fasteners.

(b) Examine the internal frames and brackets.
  1) Look for cracks and corrosion.
  2) Look for loose and missing fasteners.

(c) Examine the drain holes.
  1) Look for blockage.

(d) Examine the handle box.
  1) Look for cracks and corrosion.
  2) Look for too much wear.

(e) Examine the handle housing.
  1) Look for cracks and corrosion.
  2) Look for too much wear.

(f) Examine the internal handle.
  1) Look for cracks and corrosion.
  2) Look for too much wear.

(g) Examine the end gates.
  1) Look for cracks and corrosion.
  2) Look for loose and missing fasteners.

SUBTASK 52-13-00-210-003

(3) Do a visual inspection of the latch mechanism as follows:

(a) Examine the latch control rods.
  1) Look for cracks and corrosion.
  2) Look for too much wear.

(b) Examine the latch torque tubes.
  1) Look for cracks and corrosion.
  2) Look for too much wear.

(c) Examine the latch cranks and latch rollers.
  1) Look for cracks and corrosion.
  2) Look for too much wear.
  3) Look for unwanted particles on the latch rollers.

(d) Examine the gate control rods.
  1) Look for cracks and corrosion.
  2) Look for too much wear.

SUBTASK 52-13-00-210-004

(4) Do a visual inspection of the door stop fittings and stop pins as follows:

(a) Examine the door stop fittings.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1) Look for cracks and corrosion.

(b) Examine the stop pins.

1) Look for cracks and corrosion.

2) Look for unwanted particles on the stop pins.

3) Make sure the retaining springs are installed.

SUBTASK 52-13-00-210-005

(5) Do a visual inspection of the attach structure and hinge mechanism as follows:

(a) Examine the fuselage hinge torque tube.

1) Look for cracks and corrosion.

2) Look for too much wear.

(b) Examine the hinge arms.

1) Look for cracks and corrosion.

2) Look for too much wear.

(c) Examine the hinge arm fasteners.

1) Make sure the bolts fully engage the nuts.

2) Make sure the bolt threads are not damaged.

(d) Examine the door hinge torque tube.

1) Look for cracks and corrosion.

2) Look for too much wear.

NOTE: The nuts and bolts that connect the sleeves to the torque tube may appear loose, because they are not tightened to a clamp up pressure. A small gap between the washer and the sleeve is acceptable.

(e) Examine the guide arm and roller.

1) Look for cracks and corrosion.

2) Look for too much wear.

(f) Examine the guide plates.

1) Look for cracks and corrosion.

2) Look for too much wear.

(g) Examine the guide plate drain holes.

1) Look for blockage.

SUBTASK 52-13-00-210-006

(6) Do a visual inspection of the structure around the door opening as follows:

(a) Examine the fuselage stop fittings and stop pads.

1) Look for cracks and corrosion.

2) Look for wear that is not in the center of the stop pads.

3) Look for unwanted particles on the stop fittings.

(b) Examine the latch receivers.

1) Look for cracks and corrosion.

2) Look for too much wear.

3) Look for unwanted particles in the latch receivers.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(c) Examine the fuselage frame.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 52-13-00-410-004

(1) Install these access panels:

Number	Name/Location
834AZ	Aft Entry Door - Torque Tube Access
834BZ	Aft Entry Door - Handle Box and Cam for Handle Box Access
834CZ	Aft Entry Door - Handle Box Access
834DZ	Aft Entry Door - Lower Hinge Access
834EZ	Aft Entry Door - Upper Hinge Access
834FZ	Aft Entry Door - Torque Tube Access
834GZ	AFT Entry Door - Torque Tube Access

SUBTASK 52-13-00-410-005

(2) Do this task: Aft Entry Door Lining Installation, TASK 52-13-31-400-801.

SUBTASK 52-13-00-860-030

(3) Close and latch the door (PAGEBLOCK 52-13-00/201).

SUBTASK 52-13-00-940-002

(4) Remove the work platform, COM-1523.

END OF TASK

TASK 52-13-00-200-802

3. Aft Entry Door Centering Guide Bearing Check

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
52-13-00 P/B 201	AFT ENTRY 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Location Zones

Zone	Area
834	Left Aft Entry Door

D. Prepare for the Inspection

SUBTASK 52-13-00-860-031

(1) Make sure that the door is safe as follows:

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) Make sure that the door is closed and latched (PAGEBLOCK 52-13-00/201).

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure that the work platform, COM-1523, is installed outboard of the door.

SUBTASK 52-13-00-010-008

(2) Open the door (PAGEBLOCK 52-13-00/201).

E. Aft Entry Door Centering Guide Bearing Inspection

SUBTASK 52-13-00-210-008

(1) Do a visual inspection of the centering guide as follows (Figure 601):

(a) Examine the guide fitting.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

(b) Examine the guide bearing.

1) Look for too much wear.

2) Make sure the bearing is not loose.

3) Look for unwanted particles on the bearing surface.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 52-13-00-860-032

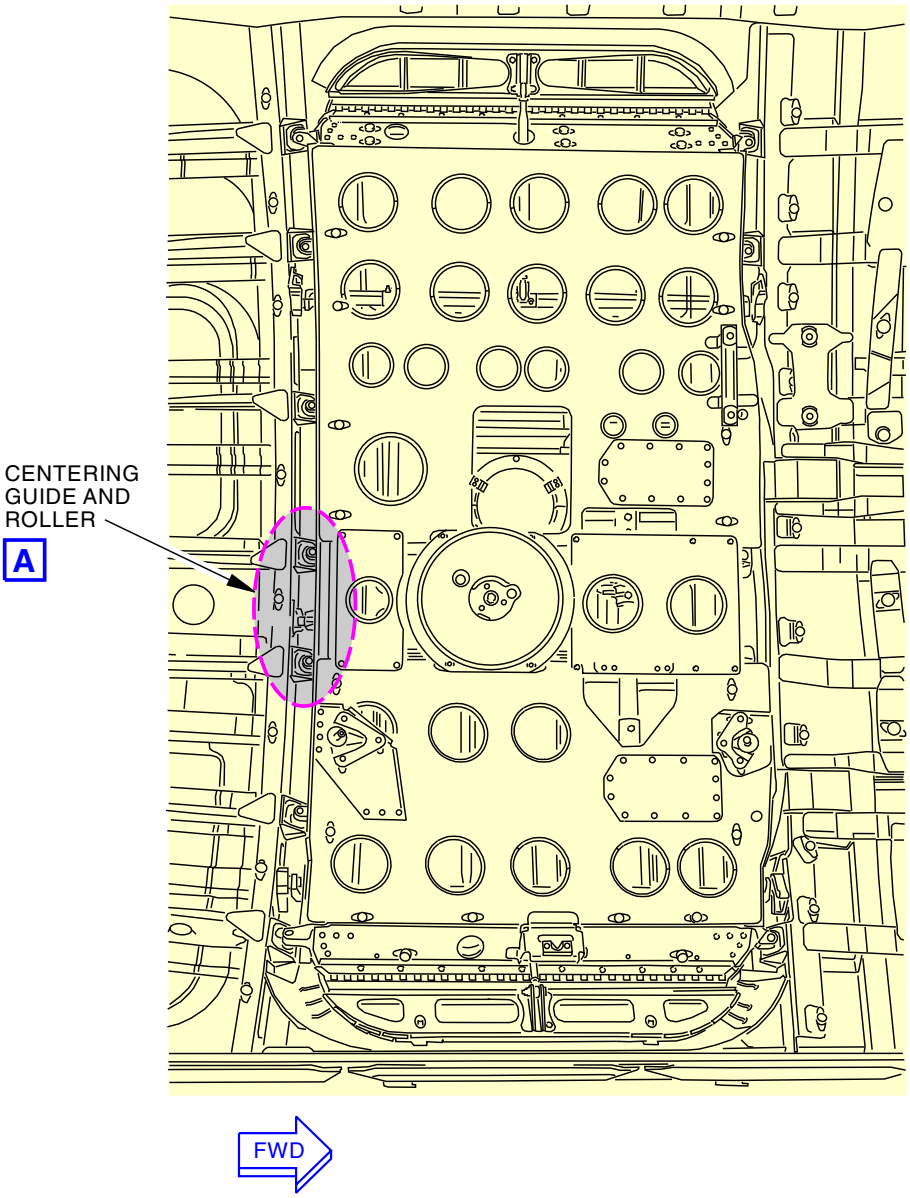
(1) Close and latch the door (PAGEBLOCK 52-13-00/201).

SUBTASK 52-13-00-940-003

(2) Remove the work platform, COM-1523.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

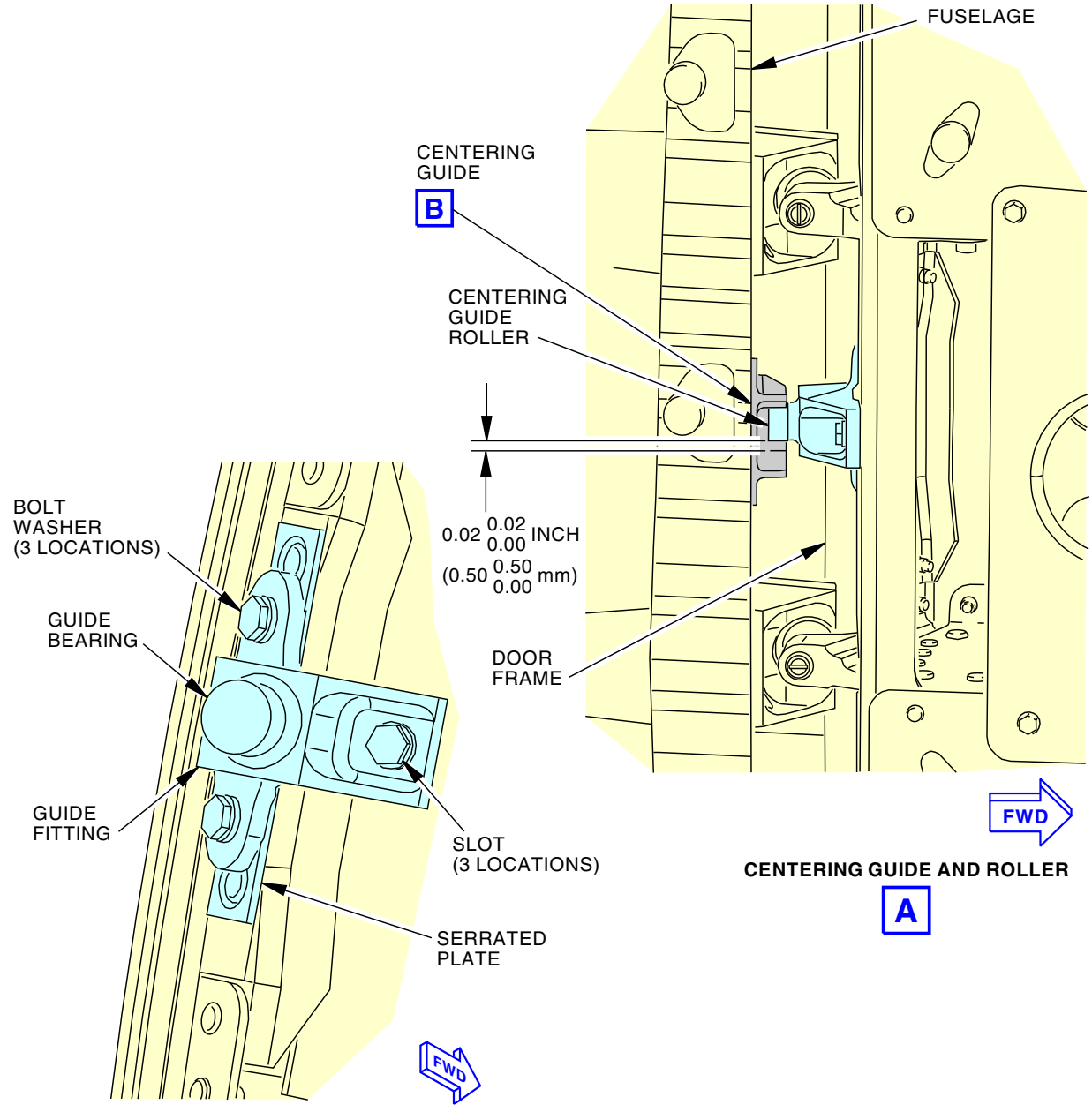


AFT ENTRY DOOR
(FORWARD SERVICE DOOR AND AFT SERVICE DOOR ARE EQUIVALENT)

2415803 S00061538911_V1

Centering Guide Inspection/Check
Figure 601/52-13-00-990-816 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



NOTE:

DIMENSION STANDARD: NOMINAL UPPER LIMIT LOWER LIMIT

2415804 S00061538912_V2

Centering Guide Inspection/Check
Figure 601/52-13-00-990-816 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-13-00-200-803

4. Aft Entry Door Pressure Seal Check

A. References

Reference	Title
52-13-00 P/B 201	AFT ENTRY 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Location Zones

Zone	Area
834	Left Aft Entry Door

D. Prepare for the Inspection

SUBTASK 52-13-00-860-033

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched (PAGEBLOCK 52-13-00/201).

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure that the work platform, COM-1523, is installed outboard of the door.

SUBTASK 52-13-00-010-009

(2) Open the door (PAGEBLOCK 52-13-00/201).

E. Aft Entry Door Pressure Seal Inspection

SUBTASK 52-13-00-210-009

(1) Do a visual inspection of the door pressure seal as follows (Figure 602):

(a) Examine the seal.

1) Look for cracks, holes, and tears.

2) Look for indications of seal deterioration.

3) Make sure that the seal is installed in the seal retainer.

F. Put the Airplane Back to its Usual Condition

SUBTASK 52-13-00-860-034

(1) Close and latch the door (PAGEBLOCK 52-13-00/201).

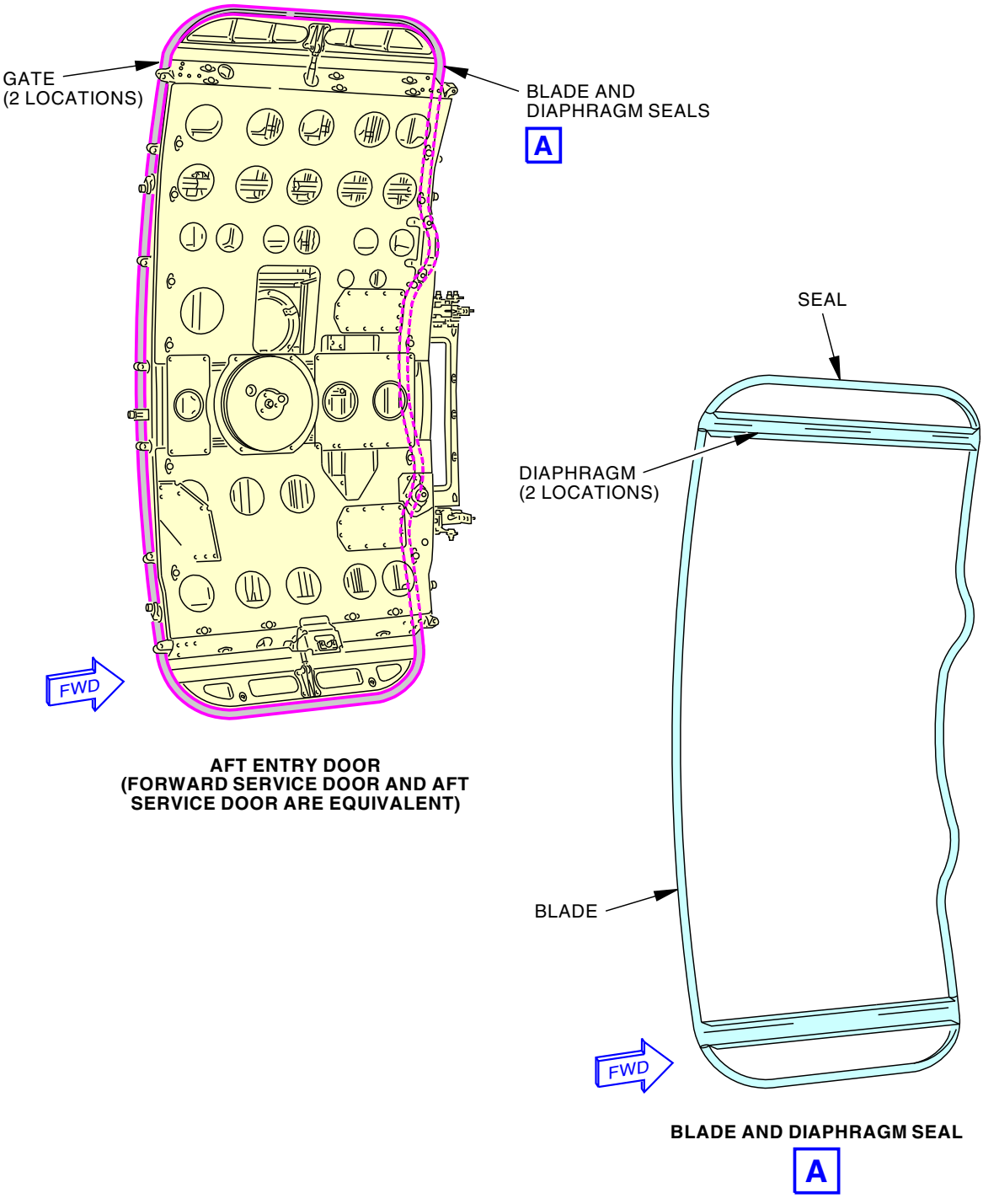
ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-13-00-940-004

(2) Remove the work platform, COM-1523.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Blade and Diaphragm Seals Inspection
Figure 602/52-13-00-990-817

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-13-00-700-802

5. Vacuum Tool Leak Check of the Aft Entry Door Seal

(Figure 603)

A. References

Reference	Title
52-09-10 P/B 801	DOOR SEALS - REPAIRS
52-13-00 P/B 201	AFT ENTRY 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
COM-1797	Stethoscope - Mechanics, 12 Inch Probe Part #: GA111D Supplier: 55719 Opt Part #: GA111C Supplier: 55719
SPL-1473	Probe - Kit, Ultrasonic Leak Part #: B00033 Supplier: 62373 Part #: ST6760A-1 Supplier: 81205
SPL-1474	Generator - Vacuum Part #: ST9999-VBA-1 Supplier: 81205 Part #: ST9999-VBA-201 Supplier: 81205 Opt Part #: ST9999-VBA-301 Supplier: 81205
SPL-1475	Bag - Assembly, Door Vacuum Part #: J51004-1 Supplier: 81205 Opt Part #: ST6760 Supplier: 81205 Opt Part #: ST9999-VB Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
A01024	Compound - Fairing - 3M EC-3587B	BAC5530

D. Location Zones

Zone	Area
831	Forward Entry Door
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
834	Left Aft Entry Door
835	Main Deck Cargo Door
841	Forward Galley Service Door
842	Right Forward Emergency Exit
844	Aft Galley Service Door

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E. Prepare for the Leak Check

SUBTASK 52-13-00-860-035

(1) To prepare for the leak check, do these steps:

(a) Make sure that the door is safe as follows:

WARNING MAKE SURE THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

1) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(b) Open and close the door a minimum of three times (PAGEBLOCK 52-13-00/201).

(c) Close and lock the door (PAGEBLOCK 52-13-00/201).

(d) Put the work platform, COM-1523, outboard of the door.

(e) Calibrate the ultrasonic leak probe, SPL-1473.

(f) Connect the vacuum generator, SPL-1474, to the door vacuum assembly bag, SPL-1475.

(g) Connect the vacuum generator, SPL-1474, to a compressed air source.

(h) Install the door vacuum assembly bag, SPL-1475, over the passenger entry door (Figure 603).

1) Make sure that the door vacuum assembly bag, SPL-1475, covers the entire door and the gap between the door and fuselage.

2) Remove all bubbles and creases from the door vacuum assembly bag, SPL-1475.

F. Aft Entry Door Seal Leak Check

SUBTASK 52-13-00-200-001

(1) Do a check of the noise levels around the interior of the door as follows:

(a) Use the vacuum generator, SPL-1474, to apply approximately 8 in/Hg (27.1 kPa) - 12 in/Hg (40.6 kPa).

1) Apply the vacuum gradually until you get to the 8 in/Hg (27.1 kPa) - 12 in/Hg (40.6 kPa) range.

(b) Hold the ultrasonic leak probe, SPL-1473, approximately 1 in. (25.40 mm) - 2 in. (50.80 mm) from the door surface.

(c) Move the ultrasonic leak probe, SPL-1473, around the edge of the door.

NOTE: The tip of the leak probe must not touch the door surface.

(d) Use the headphones and monitor the noise meter on the ultrasonic leak probe, SPL-1473.

G. Repair the Leak

SUBTASK 52-13-00-360-001

(1) If the noise levels go above the red line on the ultrasonic leak probe, SPL-1473, meter, do these steps:

(a) Determine the exact location of the noise with a stethoscope, COM-1797.

(b) Remove the door vacuum assembly bag, SPL-1475, from the door.

(c) Make sure that the door seal is clean and in a good condition.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(d) Adjust the door seal, do this task.

1) Make sure that the door is safe.

a) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

2) Pull and push the seal in the seal retainer to get a good seal around the edge of the door.

NOTE: Wrinkles in the seal are not permitted.

3) Make sure that there are no leaks between the seal and seal depressor on the door.

4) If it is necessary, adjust as follows:

a) Apply the 3M EC-3587B compound, A01024, to the seal depressor and make smooth.

b) Make sure that the thickness of the 3M EC-3587B compound, A01024, is not more than 0.4 in. (10.2 mm).

(e) If it is necessary, repair or replace the door seal (PAGEBLOCK 52-09-10/801).

(f) Install the door vacuum assembly bag, SPL-1475, again and check for noise leaks.

1) Repeat the installation of the vacuum bag and do a check for leaks to make sure that all the noise leaks have been repaired.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 52-13-00-440-001

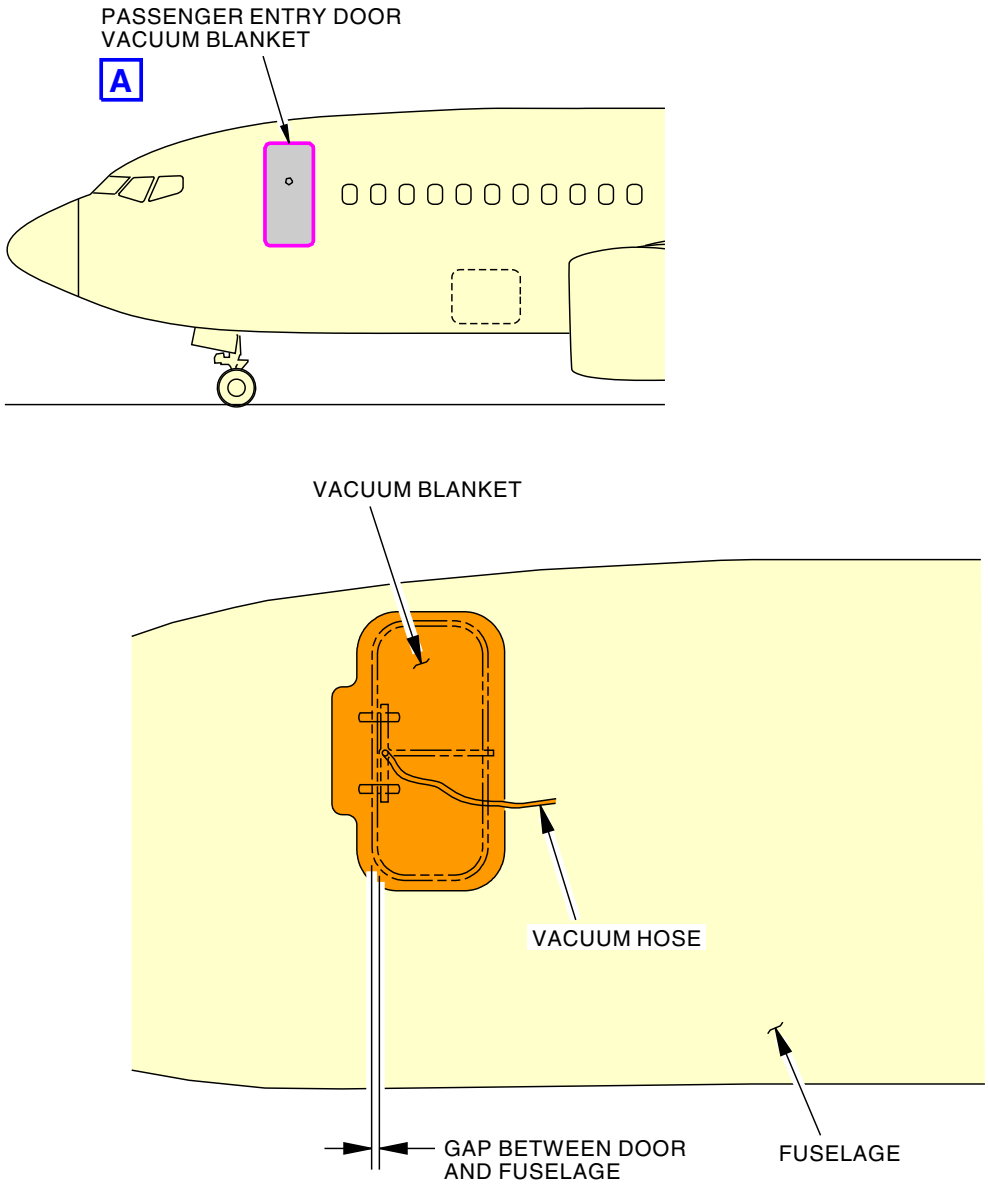
(1) Put the airplane back to its usual condition, do these steps:

(a) Make sure that the door vacuum assembly bag, SPL-1475, is removed from the door.

(b) Remove the work platform, COM-1523.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



PASSENGER ENTRY DOOR VACUUM BLANKET (EXAMPLE)

A

NOTE:

THE VACUUM BLANKET COVERS THE ENTIRE DOOR AND THE GAP BETWEEN THE DOOR AND THE FUSELAGE.

2415749 S00061538809_V1

Passenger Entry Door Pressure Seal Leak check
Figure 603/52-13-00-990-818

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AFT ENTRY DOOR STOP BEARING PLATES - REMOVAL/INSTALLATION

1. General

A. This procedure has the following tasks:

(1) The removal of the aft entry door stop bearing plate.

(2) The installation of the aft entry door stop bearing plate.

TASK 52-13-01-000-801

2. Aft Entry Door Stop Bearing Plate - Removal

Figure 401

A. General

(1) This task includes the steps to remove the aft entry door stop bearing plate.

B. References

Reference	Title
52-13-00-860-801	Open the AFT Door with the Exterior Handle (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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
STD-291	Drift - Light Weight, Metal or Plastic
STD-1242	Hammer - Standard

D. Consumable Materials

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

E. Location Zones

Zone	Area
834	Left Aft Entry Door

F. Prepare for the Removal

SUBTASK 52-13-01-480-001

(1) Install the work platform, COM-1523 outboard of the aft entry door.

SUBTASK 52-13-01-010-001

(2) Open the aft entry door: Open the AFT Door with the Exterior Handle, TASK 52-13-00-860-801.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

G. Aft Entry Door Stop Bearing Plate Removal

SUBTASK 52-13-01-020-001

(1) Remove the stop bearing plate [1].

(a) If necessary, use a standard hammer, STD-1242 and a light weight, metal or plastic drift, STD-291 to remove the stop bearing plate [1].

1) Do not use a metal drift. Only use a plastic one.

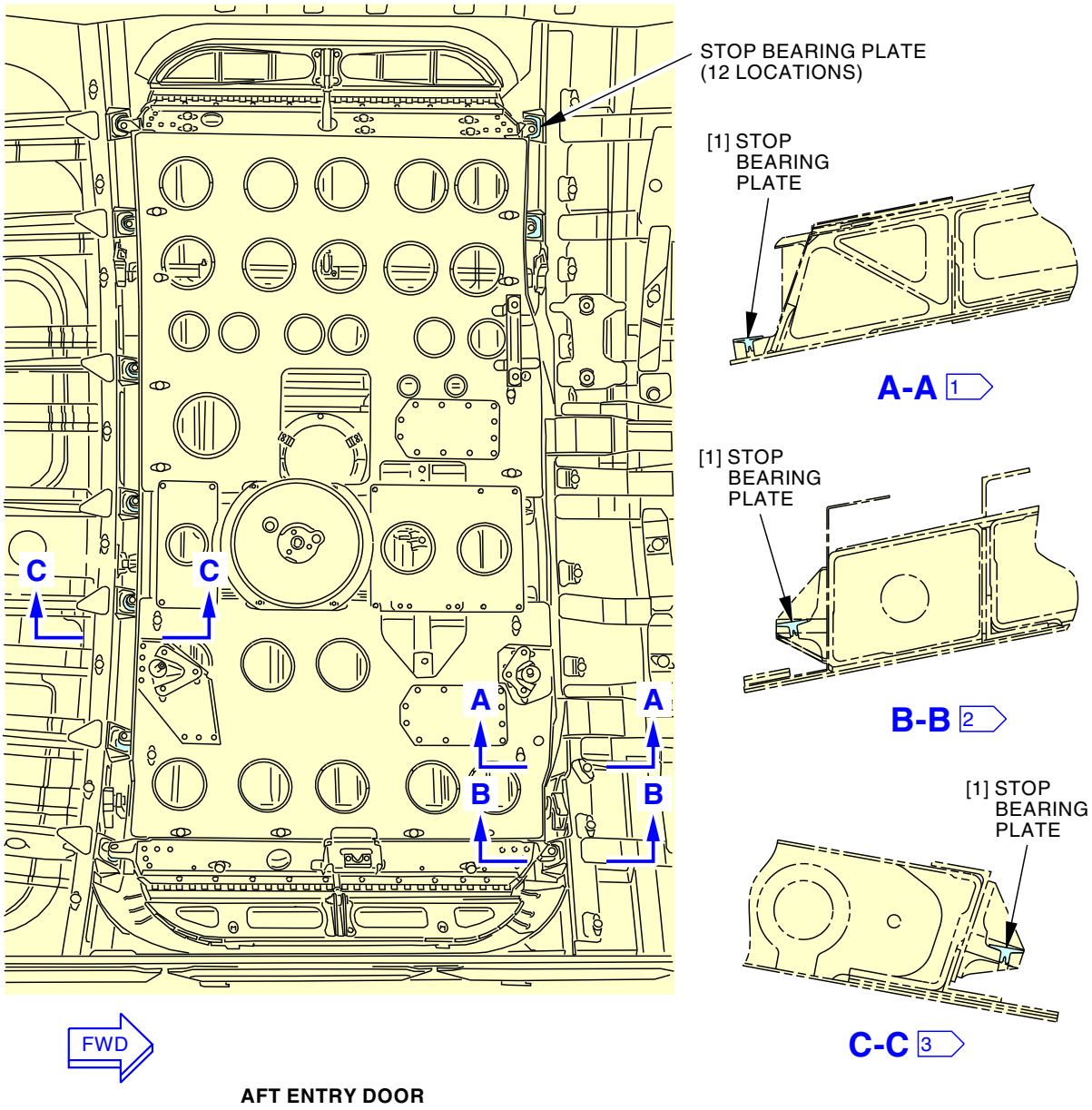
SUBTASK 52-13-01-160-001

(2) Clean the mounting hole with a clean cotton wiper, G00034 that is moist with solvent, B00083.

NOTE: Clean surfaces are necessary to make a good bond.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



AFT ENTRY DOOR

1 TYPICAL FOR ALL FORWARD HINGE BOX PADS
2 TYPICAL FOR ALL FORWARD DOOR STOP PADS
3 TYPICAL FOR ALL AFT DOOR STOP PADS

2415806 S00061538919_V2

Aft Entry Door Stop Bearing Plate Installation
Figure 401/52-13-01-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-13-01-400-801

3. Aft Entry Door Stop Bearing Plate - Installation

Figure 401

A. General

(1) This task includes the steps to install the aft entry door stop bearing plate.

B. References

Reference	Title
52-13-00-860-802	Close the AFT Door with the Exterior Handle (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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
STD-291	Drift - Light Weight, Metal or Plastic
STD-1242	Hammer - Standard

D. Consumable Materials

Reference	Description	Specification
A00551	Sealant - Fuel Tank	BAC5010 Type 44 (BMS5-44, BMS5-45)
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

E. Location Zones

Zone	Area
834	Left Aft Entry Door

F. Prepare for the Installation

SUBTASK 52-13-01-860-001

(1) Do a test of the fit of the stop bearing plate [1] before the installation.

(a) Use hand pressure to install the stop bearing plate [1] into the mounting hole.

(b) Discard the stop bearing plate [1], if you can install it with hand pressure.

(c) Get a new stop bearing plate [1], if needed.

G. Aft Entry Door Stop Bearing Plate Installation

SUBTASK 52-13-01-420-001

(1) Install the stop bearing plate [1] as follows:

(a) Apply a layer of adhesive sealant, A00551 to the stop bearing plate [1] and mounting hole.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) Install the stop bearing plate [1] with a pneumatic rivet gun with a brass set.

NOTE: If the pneumatic rivet gun is not available, use a standard hammer, STD-1242 and a non-metallic light weight, metal or plastic drift, STD-291 to install the stop bearing plate.

(c) Use a clean cotton wiper, G00034 that is moist with solvent, B00083 to remove the unwanted adhesive sealant, A00551 from the stop bearing plate [1] before it dries.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 52-13-01-410-001

(1) Close the aft entry door: Close the AFT Door with the Exterior Handle, TASK 52-13-00-860-802.

SUBTASK 52-13-01-080-001

(2) Remove the work platform, COM-1523.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AFT ENTRY DOOR HINGE ARM - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the aft entry door hinge arm.

(2) An installation of the aft entry door hinge arm.

TASK 52-13-11-000-801

2. Aft Entry Door Hinge Arm Removal

(Figure 401)

A. References

Reference	Title
52-13-00-000-801	Aft Entry Door 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Location Zones

Zone	Area
834	Left Aft Entry Door

D. Access Panels

Number	Name/Location
834AZ	Aft Entry Door - Torque Tube Access
834CZ	Aft Entry Door - Handle Box Access

E. Prepare for the Removal

SUBTASK 52-13-11-860-001

(1) Make sure the door is safe as follows:

(a) Make sure the door is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Install a work platform, COM-1523 outboard of the door.

SUBTASK 52-13-11-010-001

(2) Do this task: Aft Entry Door Removal, TASK 52-13-00-000-801.

SUBTASK 52-13-11-410-001

(3) Get access to the aft entry door [1]:

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Remove this access panel:

Number	Name/Location
834AZ	Aft Entry Door - Torque Tube Access

Remove this access panel:

Number	Name/Location
834CZ	Aft Entry Door - Handle Box Access

F. Removal of the Aft Entry Door Hinge Arm (Preferred Procedure)

(Figure 401)

SUBTASK 52-13-11-020-001

(1) Remove the handle mechanism:

(a) Remove the cover [31] on the interior handle [28] to get access to the fasteners that attach the interior handle [28] to the handle mechanism.

(b) Remove the pins [32], nuts [30], and washers [29] that attach the interior handle [28] to the hub [34].

(c) Remove the interior handle [28] and the bolts [33].

(d) Remove the bolts [36] and washers [23] that attach the cam cover [24] to the handle box [6].

(e) Remove the cam cover [24].

(f) Remove the lockwire, bolts [26], and washers [25] that attach the hub [34] and shim [35] to the handle cam [40].

(g) Remove the hub [34] and shim [35].

(h) Remove the pin [38] on the nut [37] that holds the handle cam [40] to the handle shaft [47].

(i) Hold the exterior handle [10] and remove the nut [37] and washer [39] that hold the handle cam [40] to the handle shaft [47].

NOTE: When you remove the nut [37], the exterior handle [10] and part of the handle mechanism will be loose on the outer side of the aft entry door [1].

(j) Remove the handle cam [40].

(k) From the outer side of the door, remove the exterior handle [10], shims [46], sleeve [44], handle shaft [47], and centering cam [43] as an assembly.

(l) If necessary, disassemble these parts further as follows:

1) Remove the bolts [9], washers [45], and nuts [42] that attach the exterior handle [10] to the centering cam [43] through the shims [46] and sleeve [44].

2) Remove the exterior handle [10].

3) Remove the shim [46] between the exterior handle [10] and the sleeve [44].

4) Remove the centering cam [43].

5) Remove the handle shaft [47] from the sleeve [44].

6) Remove the spring pin [8] from the washer [11] and pin [50].

7) Remove the washer [11] from the end of the pin [50].

8) Remove the lock ring [48] from the handle shaft [47].

9) Remove the nut [51] from the end of the handle shaft [47].

10) Remove the pin [50], and spring [49] from the handle shaft [47].

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(m) Remove the bolts [14], washers [12], and nuts [19] that attach the handle pan [13], seal plate [16], and handle housing [20] to the handle box [6].

(n) Remove the handle pan [13] and seal plate [16] from the external side of the aft entry door [1].

(o) Remove the seal plate [16] from the handle pan [13] and the packing [18] from the seal plate [16].

(p) Remove the handle housing [20] from the handle box [6] and the packing [17] from the handle housing [20].

(q) If necessary, remove the bearing [21] from the handle box [6] as follows:

1) Remove the retaining ring [22] that holds the bearing [21] in the handle box [6].

2) Remove the bearing [21] from the handle box [6].

SUBTASK 52-13-11-020-002

(2) Remove the upper and lower latch control rods [15]:

(a) Remove the bolts [62] and washers [63] that connect the latch control rods [15] to the handle mechanism in the handle box [6].

(b) Remove the bolts [52], washers [53], and nuts [54] that connect the latch control rods [15] to the upper and lower latch torque tubes [56].

(c) Remove the latch control rods [15] from the handle box [6] and aft entry door [1] to make clearance for the handle box [6] removal.

SUBTASK 52-13-11-020-003

(3) Disconnect the door hinge torque tube [59]:

(a) Remove the bolts [70], washers [69], and nuts [75] that go through the upper and lower sleeves [57] on the door hinge torque tube [59].

(b) Move the sleeves [57] toward the center of the door hinge torque tube [59] to make clearance to remove the door hinge torque tube [59] and handle box [6] as an assembly.

SUBTASK 52-13-11-020-004

(4) Remove the handle box [6] and door hinge torque tube [59]:

(a) Remove the bolts [65], fillers [66], washers [67], and nuts [68] that attach the front of the upper and lower splice angles [58] to the beams.

(b) Remove the bolts [76] and washers [77] that attach the upper and lower splice angles [58] to the beams.

(c) Remove the upper and lower splice angles [58] from the beams to get access to the door hinge torque tube [59].

(d) Remove the bolts [60] and washers [61] that attach the top and bottom of the handle box [6] to the beams.

(e) Carefully remove the handle box [6] and door hinge torque tube [59] from the door structure.

(f) If the laminated shim [64] between the top of the handle box [6] and the beam are loose, remove them.

SUBTASK 52-13-11-020-005

(5) Remove the hinge arms [2] from the hinge support:

(a) Loosen the bolts [72] and washers [73] that hold the hinge pin [74] in the hinge arm [2].

(b) Remove the hinge pin [74] from the hinge arm [2].

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(c) Remove the packing [71], washer [78] from the hinge pin [74].

(d) Remove the hinge arm [2].

G. Removal of the Aft Entry Door Hinge Arm (Alternate Procedure)

(Figure 401)

SUBTASK 52-13-11-030-001

(1) Disconnect the door hinge torque tube [59] to remove the splice angle [58]:

(a) Remove the bolts [70], washers [69], and the nuts [75] that go through the upper and lower sleeves [57] on the door hinge torque tube [59].

(b) Remove the bolts [65], fillers [66], washers [67], and the nuts [68] that attach the upper and lower splice angles [58] to the beams.

(c) Remove the bolts [76] and the washers [77] that attach the upper and lower splice angles [58] to the beams.

(d) Remove the upper and lower splice angles [58] from the beams to get access to the hinge torque tube.

SUBTASK 52-13-11-010-002

(2) Disconnect the upper and lower latch control rods [15] from the latch torque tubes [56]:

(a) Remove the bolts [52], washers [53], and the nuts [54] that connect the latch control rods [15] to the upper and lower latch torque tubes [56].

SUBTASK 52-13-11-010-003

(3) Loosen one of these two nuts on the door hinge torque tube:

(a) For the upper hinge arm [2], loosen the nut [85].

1) Do not loosen the lower nut [86].

(b) For the lower hinge arm [2], loosen the lower nut [86].

1) Do not loosen the nut [85].

SUBTASK 52-13-11-020-006

(4) Remove the hinge arm [2] from the hinge support:

(a) Loosen the bolts [72] and the washers [73] that hold the hinge pin [74] in the hinge arm [2].

(b) Remove the hinge pin [74] from the hinge arm [2].

1) Remove the packing [71], washer [78] from the hinge pin [74].

(c) Remove the hinge arm [2].

——— END OF TASK ———

TASK 52-13-11-400-801

3. Aft Entry Door Hinge Arm Installation

(Figure 401)

A. References

Reference	Title
52-13-00-400-801	Aft Entry Door Installation (P/B 401)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
D00633	Grease - Aircraft General Purpose	BMS3-33
G00440	Lockwire - MS20995C41, Corrosion Resistant Steel - 0.041 Inch (1.0414 mm) Diameter	NASM20995

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Aft entry door	52-13-00-01A-146	SIA ALL
2	Hinge arm	52-13-41-05A-005	SIA ALL
17	Packing	52-13-00-13A-150	SIA ALL
18	Packing	52-13-00-16A-688	SIA ALL
32	Pin	52-13-31-03-105	SIA ALL
		52-13-31-04-105	SIA ALL
38	Pin	52-13-00-12A-478	SIA ALL
71	Packing	52-13-00-12A-456	SIA ALL

D. Location Zones

Zone	Area
834	Left Aft Entry Door

E. Access Panels

Number	Name/Location
834AZ	Aft Entry Door - Torque Tube Access
834CZ	Aft Entry Door - Handle Box Access

F. Installation of the Aft Entry Door Hinge Arm (Preferred Procedure)

SUBTASK 52-13-11-420-001

(1) Install the hinge arm [2] in the hinge support:

NOTE: Do this step for each hinge arm.

(a) Put the hinge arm [2] in its correct position in the hinge support.

(b) Do a check of the packing [71] for damage or wear and replace it if necessary.

(c) Apply grease, D00633 to the packing [71] before installation.

(d) Install the washer [78] and new packing [71] on the hinge pin [74].

(e) Apply grease, D00633 to the hinge pin [74] and the bolt [72] before installation.

(f) Install the hinge pin [74] in the hinge arm [2].

(g) Install the bolt [72] and washer [73] to hold the hinge pin [74] in the hinge arm [2].

(h) Apply grease, D00633 in the opening between the hinge arm [2], hinge pin [74] and to any openings between the hinge support and the hinge pin [74].

SUBTASK 52-13-11-420-002

(2) Install the handle box [6] and the door hinge torque tube [59]:

(a) Apply sealant, A00247 to the mating surfaces between the bottom of the handle box [6] and the beam before installation.

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(b) Carefully put the handle box [6] and the door hinge torque tube [59] in their correct position in the door structure.

(c) If the laminated shim [64] between the top of the handle box [6] and the beam were removed, do these steps:

1) Make sure the maximum clearance between the top of the handle box [6] and the beam is 0.01 in. (0.25 mm).

2) Apply sealant, A00247 to the mating surfaces between the handle box [6], laminated shim [64], and beam before installation.

3) Install the laminated shim [64] between the handle box [6] and the beam.

(d) Apply sealant, A00247 to the mating surfaces of the bolts [60], washers [61], handle box [6], and beam before installation.

(e) Install the bolts [60] and washers [61] to attach the top and bottom of the handle box [6] to the beams.

(f) Put the upper and lower splice angles [58] in their correct position on the beams.

(g) Apply compound, C00528 to the holes for the bolts [76] before installation.

(h) Install the bolts [76] and washers [77] to attach the upper and lower splice angles [58] to the beams.

(i) Install the bolts [65], fillers [66], washers [67], and nuts [68] to attach the front of the upper and lower splice angles [58] to the beams.

SUBTASK 52-13-11-420-003

(3) Connect the door hinge torque tube [59]:

(a) Apply grease, D00633 to the mating surfaces of the sleeves [57], hinge pin [74], and door hinge torque tube [59] before installation.

(b) Put the sleeves [57] over the hinge pins [74].

(c) Apply compound, C00528 to the holes for the bolts [70] before installation.

(d) Install the bolts [70], washers [69], and nuts [75] that go through the upper and lower sleeves [57] on the door hinge torque tube [59].

SUBTASK 52-13-11-420-004

(4) Install the upper and lower latch control rods [15]:

(a) Put the latch control rods [15] in their correct positions in the handle box [6] and door.

(b) Apply compound, C00528 to the holes for the bolts [52] and bolts [62] before installation.

(c) Install the bolts [52], washers [53], and nuts [54] to connect the latch control rods [15] to the upper and lower latch torque tubes [56].

(d) Install the bolts [62] and washers [63] to connect the latch control rods [15] to the handle mechanism in the handle box [6].

SUBTASK 52-13-11-420-005

(5) Install the handle mechanism:

(a) Do a check of the packing [17] and packing [18] for damage or wear and replace them if necessary.

(b) Apply grease, D00633 to the packing [17] and packing [18] before installation.

(c) Install the packing [18] in the seal plate [16] and the packing [17] in the handle housing [20].

(d) Put the handle housing [20] in its correct position against the handle box [6].

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(e) Put the seal plate [16] in its correct position against the handle pan [13].

(f) Put the handle pan [13] and seal plate [16] in position on the external side of the aft entry door [1].

(g) Install the bolts [14], washers [12], and nuts [19] to attach the handle pan [13], seal plate [16], and handle housing [20] to the handle box [6].

(h) Install the exterior handle [10], handle shaft [47], shims [46], sleeve [44], and centering cam [43] as an assembly.

1) Make sure the lubrication fitting on the sleeve [44] is in its correct position.

2) If necessary, assemble these parts before installation as follows:

a) Install the pin [50] and spring [49] in the handle shaft [47].

b) Install the nut [51] in the end of the handle shaft [47].

c) Install the lock ring [48] on the handle shaft [47].

d) Install the washer [11] on the end of the pin [50].

e) Install the spring pin [8] through the washer [11] and pin [50].

3) Apply grease, D00633 to the mating surfaces of the handle shaft [47] and sleeve [44] before installation.

4) Install the handle shaft [47] in the sleeve [44].

5) Install the shims [46] between the exterior handle [10] and the sleeve [44].

6) Install the bolts [9], washers [45], and nuts [42] to attach the exterior handle [10] to the centering cam [43] through the shims [46] and sleeve [44].

(i) If necessary, install the bearing [21] and retaining ring [22] in the handle box [6].

1) Put the bearing [21] in position in the handle box [6].

2) Install the retaining ring [22] to hold the bearing [21] in the handle box [6].

(j) Apply grease, D00633 to the mating surfaces of the handle shaft [47] and the handle cam [40] before installation in the handle box [6].

(k) Hold the exterior handle [10] in position on the exterior side of the aft entry door [1].

(l) Install the handle shaft [47] through the handle box [6].

(m) Install the handle cam [40] on the end of the handle shaft [47].

(n) Install the washer [39], nut [37], and new new pin [38] to hold the handle cam [40] to the handle shaft [47].

(o) Put the hub [34] and shim [35] in their correct position against the handle cam [40].

(p) Install the bolts [26], washers [25], and MS20995C41 lockwire, G00440 to attach the hub [34] and shim [35] to the handle cam [40].

(q) Put the cam cover [24] in its correct position against the handle box [6].

(r) Install the bolts [36] and washers [23] to attach the cam cover [24] to the handle box [6].

(s) Put the bolts [33] through the hub [34].

(t) Put the interior handle [28] in its correct position against the hub [34].

(u) Install the washers [29], nuts [30], and new new pins [32] to attach the interior handle [28] to the hub [34].

(v) Install the cover [31] on the interior handle [28].

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G. Installation of the Aft Entry Door Hinge Arm (Alternate Procedure)

SUBTASK 52-13-11-420-006

(1) Install the hinge arm [2] on the hinge support:

(a) Examine the packing [71] to make sure that the packing is serviceable.

1) If it is necessary, replace the packing [71].

(b) Apply grease, D00633 to the packing [71] before installation.

(c) Install the washer [78] and packing [71] on the hinge pin [74].

(d) Apply grease, D00633 to the hinge pin [74] and the bolt [72] before installation.

(e) Put the hinge arm [2] in its correct location

(f) Install the hinge pin [74] in the hinge arm [2].

(g) Tighten the bolts [72] and the washers [73] that hold the hinge pin [74] in the hinge arm [2].

SUBTASK 52-13-11-410-002

(2) Tighten the door hinge torque tube [59]:

(a) Move the door hinge torque tube [59] into its correct position.

(b) Tighten the applicable nut [85] or nut [86] on the door hinge torque tube [59].

1) For the upper hinge arm [2], tighten the nut [85].

2) For the lower hinge arm [2], tighten the lower nut [86].

SUBTASK 52-13-11-410-003

(3) Connect the upper and lower latch control rods [15] to the latch torque tubes [56]:

(a) Install the bolts [52], washers [53], and the nuts [54] that con-nect the latch control rod [15] to the upper and lower latch torque tubes [56].

SUBTASK 52-13-11-410-004

(4) Connect the splice angles [58]:

(a) Use the bolts [76] and the washers [77] that attach the upper and lower splice angles [58] to the beams.

1) Tighten the bolts [76].

(b) Install the bolts [65], fillers [66], washers [67], and the nuts [68] that attach the upper and lower splice angles [58] to the beams.

1) Tighten the nuts [68].

SUBTASK 52-13-11-410-005

(5) Connect the door hinge torque tube [59]:

(a) Install the bolts [70], washers [69], and the nuts [75] that go through the upper and lower sleeves [57] on the door hinge torque tube [59].

1) Tighten the nuts [75].

H. Put the Airplane in its Usual Condition

SUBTASK 52-13-11-410-006

(1) Close access to the door:

Install this access panel:

Number	Name/Location
834CZ	Aft Entry Door - Handle Box Access

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Install this access panel:

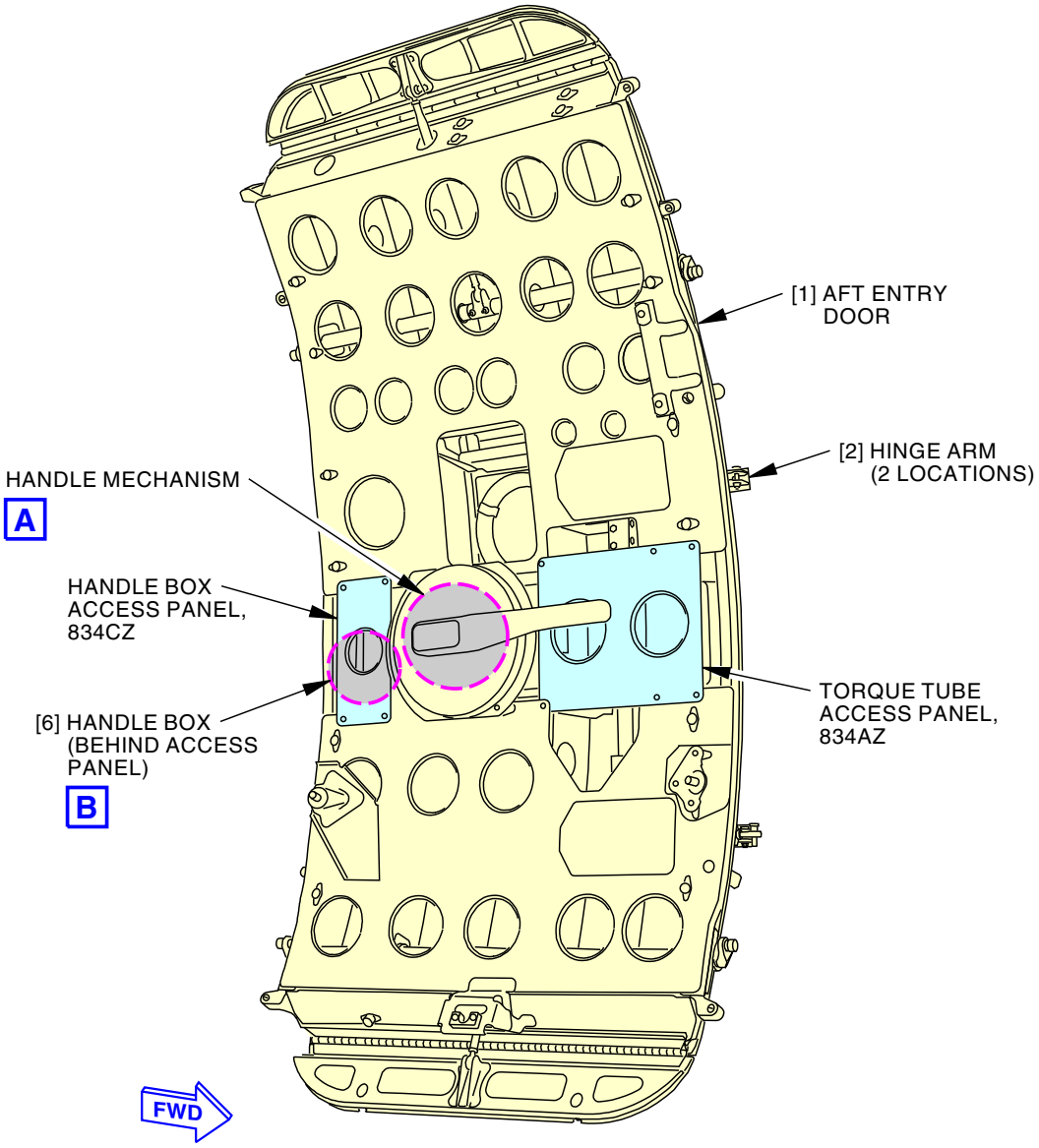
Number	Name/Location
834AZ	Aft Entry Door - Torque Tube Access

SUBTASK 52-13-11-420-007

(2) Do this task: Aft Entry Door Installation, TASK 52-13-00-400-801.

——— END OF TASK ———

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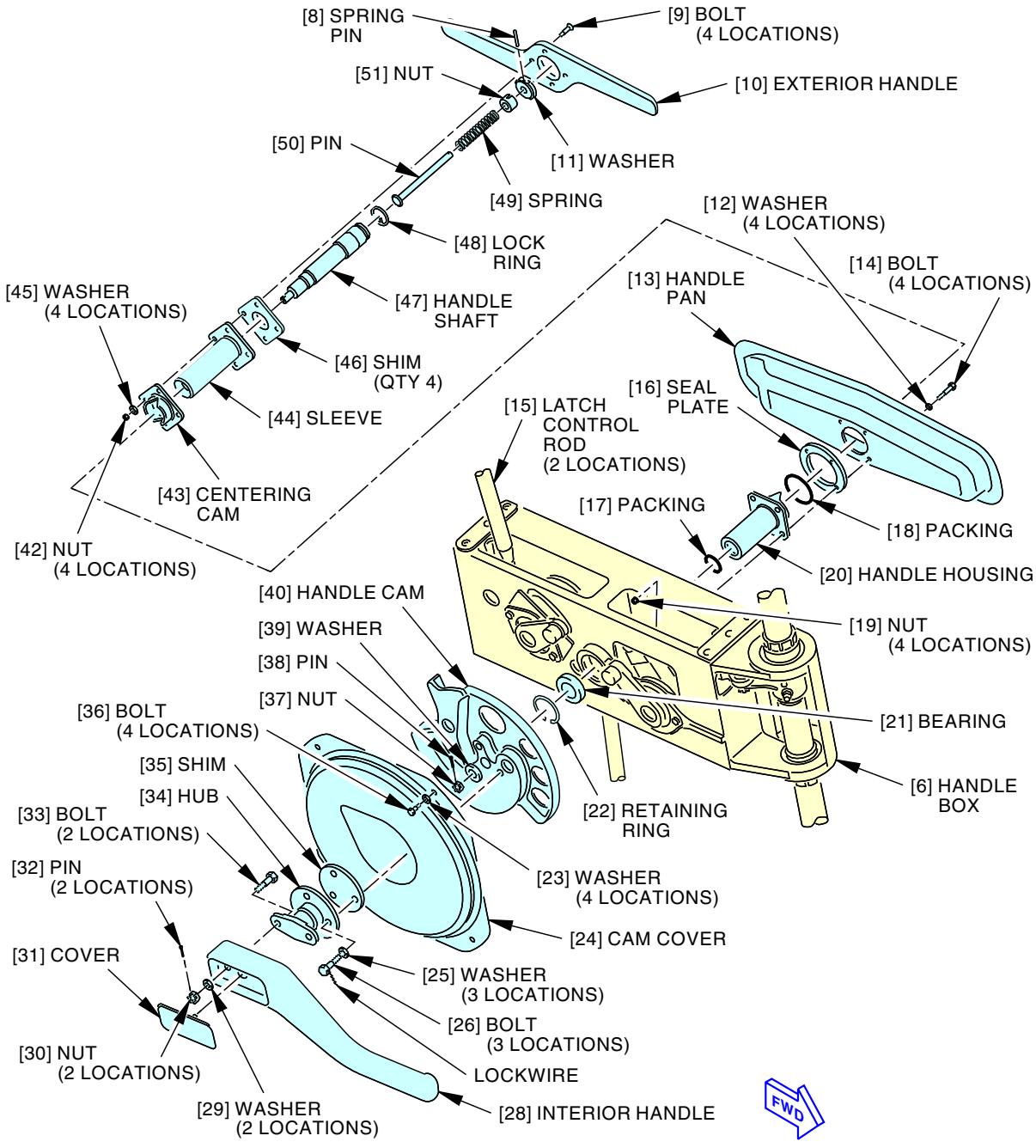


AFT ENTRY DOOR

2415807 S00061538925_V1

Aft Entry Door Hinge Arm Installation
Figure 401/52-13-11-990-801 (Sheet 1 of 5)

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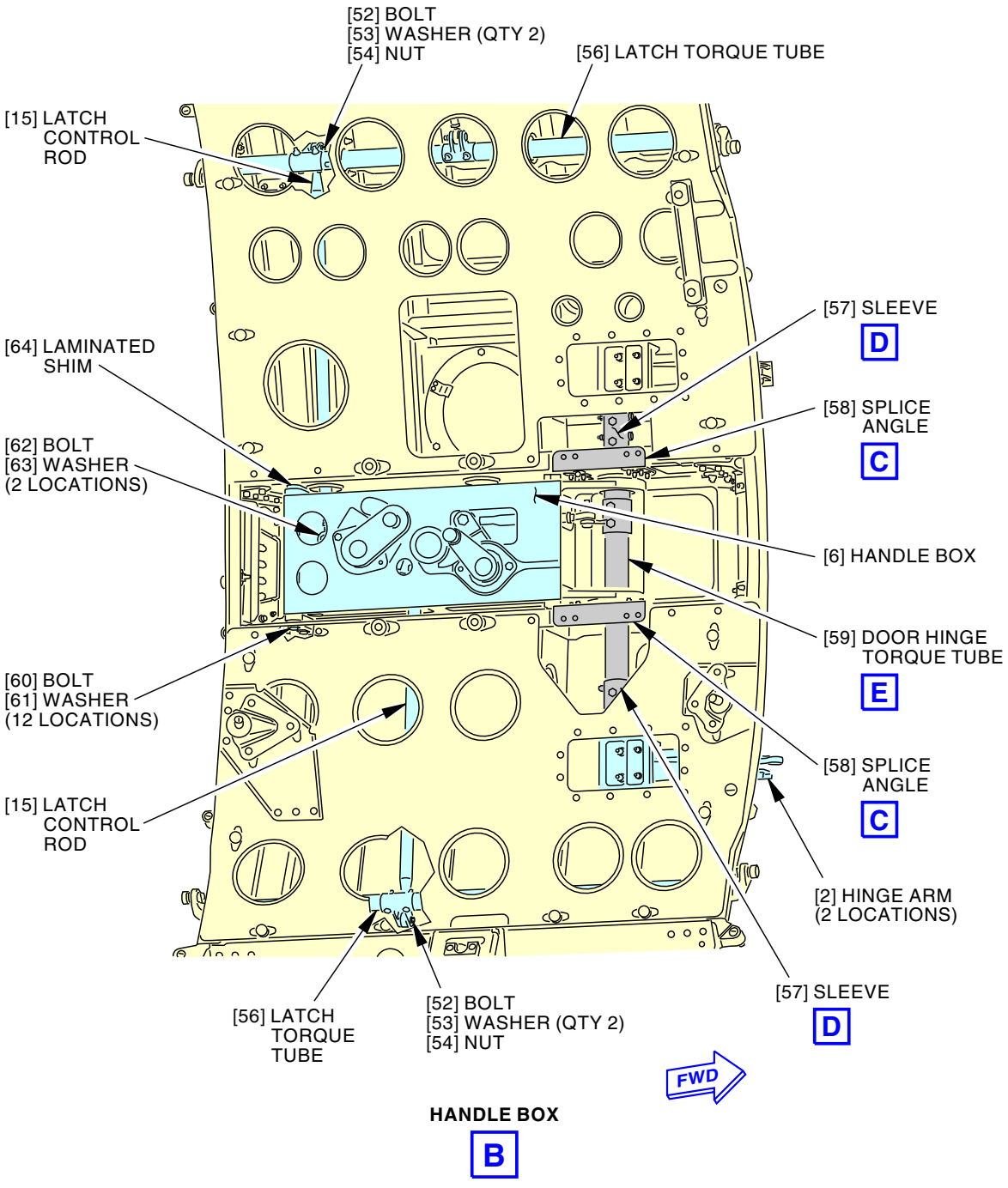


HANDLE MECHANISM (EXPLODED VIEW)

2415808 S00061538926_V1

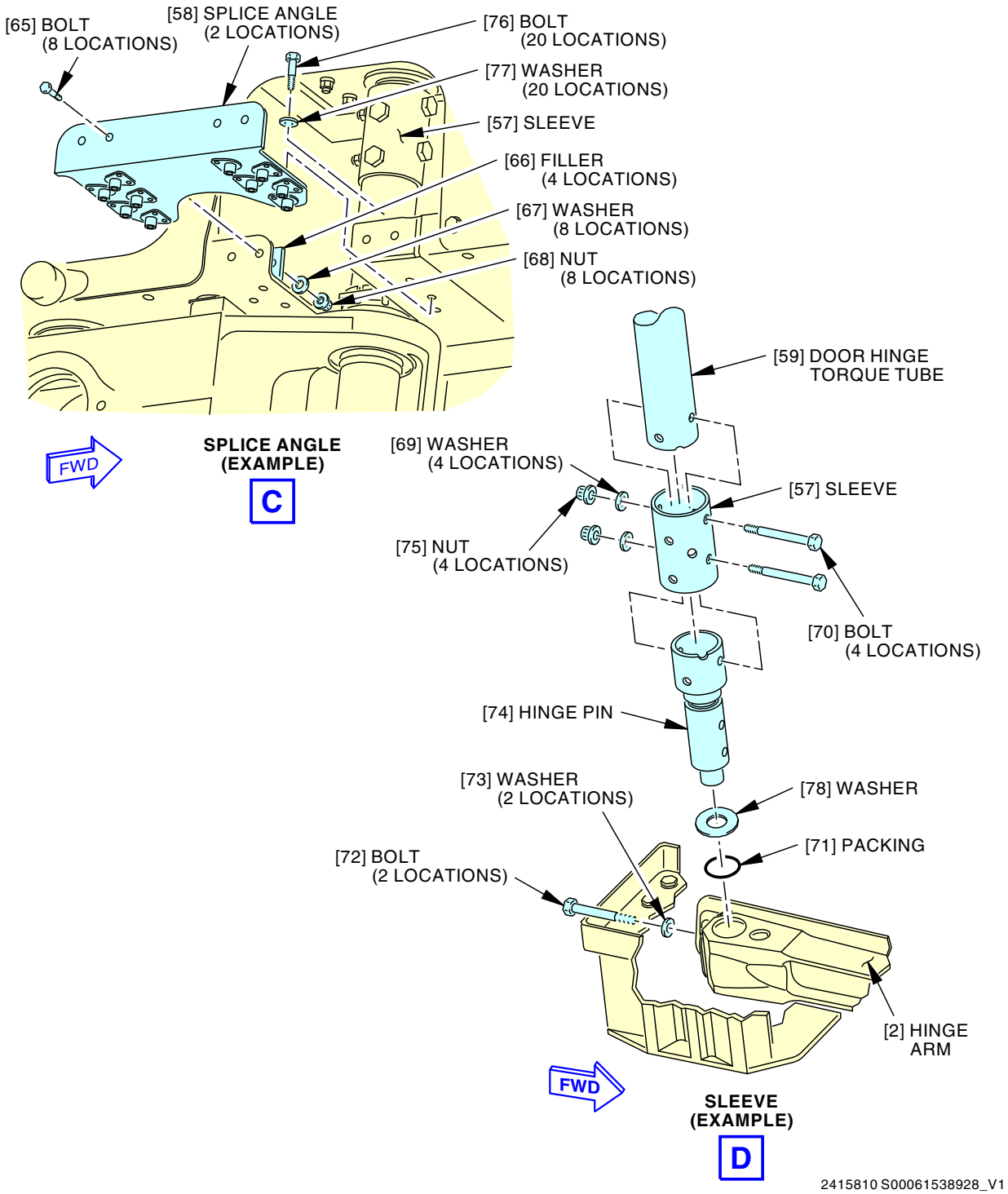
Aft Entry Door Hinge Arm Installation
Figure 401/52-13-11-990-801 (Sheet 2 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



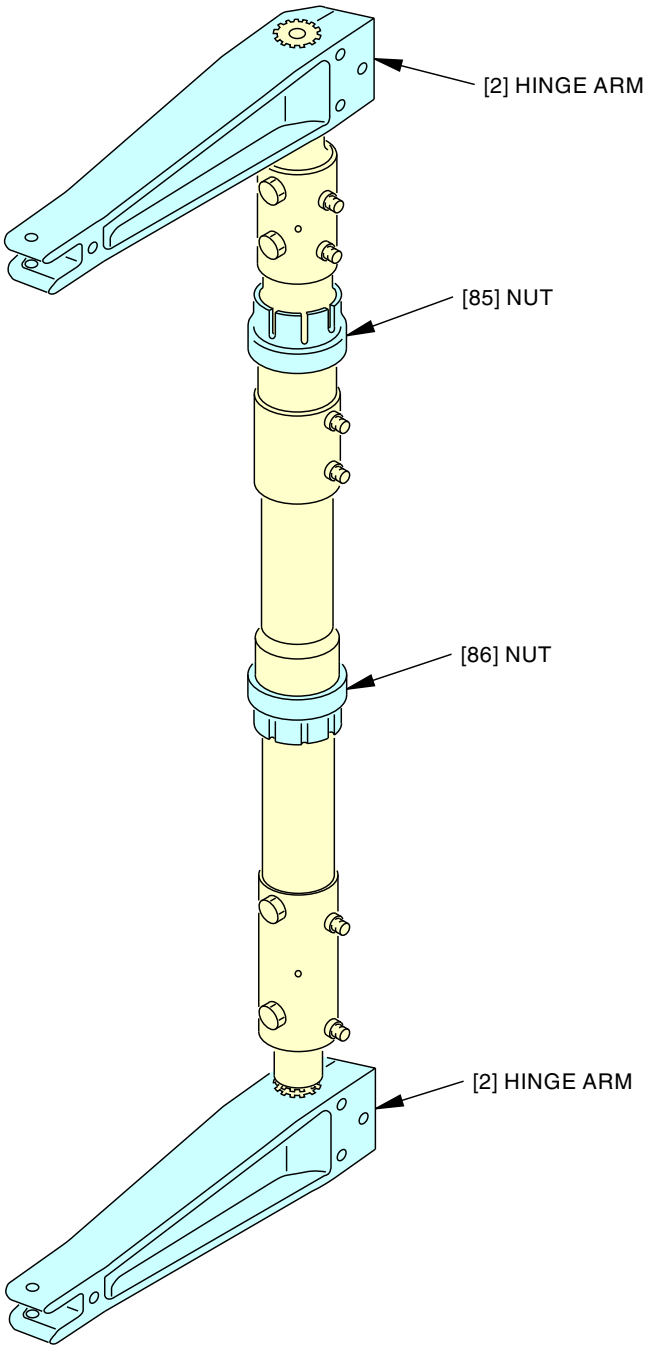
Aft Entry Door Hinge Arm Installation
Figure 401/52-13-11-990-801 (Sheet 3 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aft Entry Door Hinge Arm Installation
Figure 401/52-13-11-990-801 (Sheet 4 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



DOOR HINGE TORQUE TUBE

E

2415811 S00061538929_V1

Aft Entry Door Hinge Arm Installation
Figure 401/52-13-11-990-801 (Sheet 5 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AFT ENTRY DOOR GUIDE ARM AND ROLLER - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the aft entry door guide arm and roller.

(2) An installation of the aft entry door guide arm and roller.

TASK 52-13-21-000-801

2. Aft Entry Door Guide Arm and Roller Removal

(Figure 401)

A. References

Reference	Title
52-13-31-000-801	Aft Entry Door Lining Removal (P/B 401)

B. Location Zones

Zone	Area
834	Left Aft Entry Door

C. Access Panels

Number	Name/Location
834	Aft Entry Door
834FZ	Aft Entry Door - Torque Tube Access

D. Prepare for the Removal

SUBTASK 52-13-21-860-001

(1) Make sure the door is safe as follows:

(a) Make sure the door is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure a stand is installed outboard of the door.

SUBTASK 52-13-21-010-001

(2) Get access to the door as follows:

(a) Do this task: Aft Entry Door Lining Removal, TASK 52-13-31-000-801.

(b) Open this access panel:

Number	Name/Location
834	Aft Entry Door

E. Removal of the Aft Entry Door Guide Arm and Roller

SUBTASK 52-13-21-020-001

(1) Disconnect the guide arm [2] and roller [10] from the upper guide plate [11] and lower guide plate [12]:

(a) AIRPLANES WITH LOCKING GUIDE ARM;

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Remove the bolts [7], washers [13], and nuts [14] that attach the release button [8] to the upper guide plate [11].

1) Remove the release button [8] from the upper guide plate [11].

(b) Remove the bushing [9] from the upper guide plate [11].

(c) Insert a tool in the drain hole in the lower guide plate [12] and push the roller [10] through the guide arm [2] and out the hole in the upper guide plate [11].

SUBTASK 52-13-21-020-002

(2) Disconnect the guide arm [2] from the link [16]:

(a) Remove the clip [15] from the pin [6] that attaches the guide arm [2] to the link [16].

(b) Push the pin [6] up through the guide arm [2] and the link [16].

(c) Remove the guide arm [2] from the link [16].

SUBTASK 52-13-21-020-003

(3) Disconnect the guide arm [2] from the aft entry door [1]:

(a) Remove this access panel:

Number	Name/Location
834FZ	Aft Entry Door - Torque Tube Access

(b) Remove the filler [21] to get access to the fastener that attaches the guide arm [2] to the fitting [19].

(c) Remove the bolt [20], washer [17], and nut [18] that attach the guide arm [2] to the fitting [19].

(d) Remove the guide arm [2] from the aft entry door [1].

——— END OF TASK ———

TASK 52-13-21-400-801

3. Aft Entry Door Guide Arm and Roller Installation

(Figure 401)

A. References

Reference	Title
52-13-00-820-801	Aft Entry Door Adjustment (P/B 501)
52-13-31-400-801	Aft Entry Door Lining Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Aft entry door	52-13-00-01A-146	SIA ALL
2	Guide arm	52-13-11-01-120	SIA ALL
10	Roller	52-13-11-01-115	SIA ALL

D. Location Zones

Zone	Area
834	Left Aft Entry Door

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E. Access Panels

Number	Name/Location
834	Aft Entry Door
834FZ	Aft Entry Door - Torque Tube Access

F. Installation of the Aft Entry Door Guide Arm and Roller

SUBTASK 52-13-21-820-001

(1) Do a preliminary adjustment of the guide arm [2]:

(a) Make sure the distance along the guide arm [2] from the centerline of the rod end [27] to the adjuster nut [22] is as shown (Figure 401).

(b) If necessary, use the adjuster nut [22] to change the length of the guide arm [2] as follows:

NOTE: This is an initial adjustment for a new guide arm [2].

1) Remove the bolt [24] and washer [25] on the lock channel [23].

2) Remove the lock channel [23].

3) Loosen the jamnut [26].

4) Change the length of the guide arm rod end [27] with the adjuster nut [22].

5) Make sure the adjuster nut [22] will align with the lock channel [23].

6) Tighten the jamnut [26].

7) Put the lock channel [23] in its correct position on the guide arm [2].

8) Install the bolt [24] and washer [25] to hold the lock channel [23] in position.

SUBTASK 52-13-21-020-004

(2) Connect the guide arm [2] to the aft entry door [1]:

(a) Put the rod end [27] of the guide arm [2] in position in the fitting [19].

(b) Install the bolt [20], washer [17], and nut [18] to attach the rod end [27] of the guide arm [2] to the fitting [19].

(c) Install the filler [21] with sealant, A00247 to cover the guide arm [2] attachment.

(d) Install this access panel:

Number	Name/Location
834FZ	Aft Entry Door - Torque Tube Access

SUBTASK 52-13-21-420-001

(3) Connect the guide arm [2] to the link [16]:

(a) Put the guide arm [2] in position in the link [16].

(b) Install the pin [6] to attach the guide arm [2] to the link [16].

(c) Install the clip [15] on the end of the pin [6].

SUBTASK 52-13-21-420-002

(4) Connect the guide arm [2] and roller [10] to the upper guide plate [11] and lower guide plate [12]:

(a) Align the hole in the end of the guide arm [2] with the hole in the upper guide plate [11].

(b) Put the roller [10] through the hole in the upper guide plate [11] and into the end of the guide arm [2].

1) Make sure the spring-loaded pin in the roller [10] points up.

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(c) Install the bushing [9] in the upper upper guide plate [11].

(d) AIRPLANES WITH LOCKING GUIDE ARM;

Put the release button [8] in position on the upper guide plate [11].

1) Install the bolts [7], washers [13], and nuts [14] to attach the release button [8] to the upper guide plate [11].

SUBTASK 52-13-21-820-002

(5) Adjust the guide arm [2] (Aft Entry Door Adjustment, TASK 52-13-00-820-801).

(a) Do only the guide arm adjustment.

SUBTASK 52-13-21-410-001

(6) Do this task: Aft Entry Door Lining Installation, TASK 52-13-31-400-801.

SUBTASK 52-13-21-710-001

(7) Do a test on the door as follows:

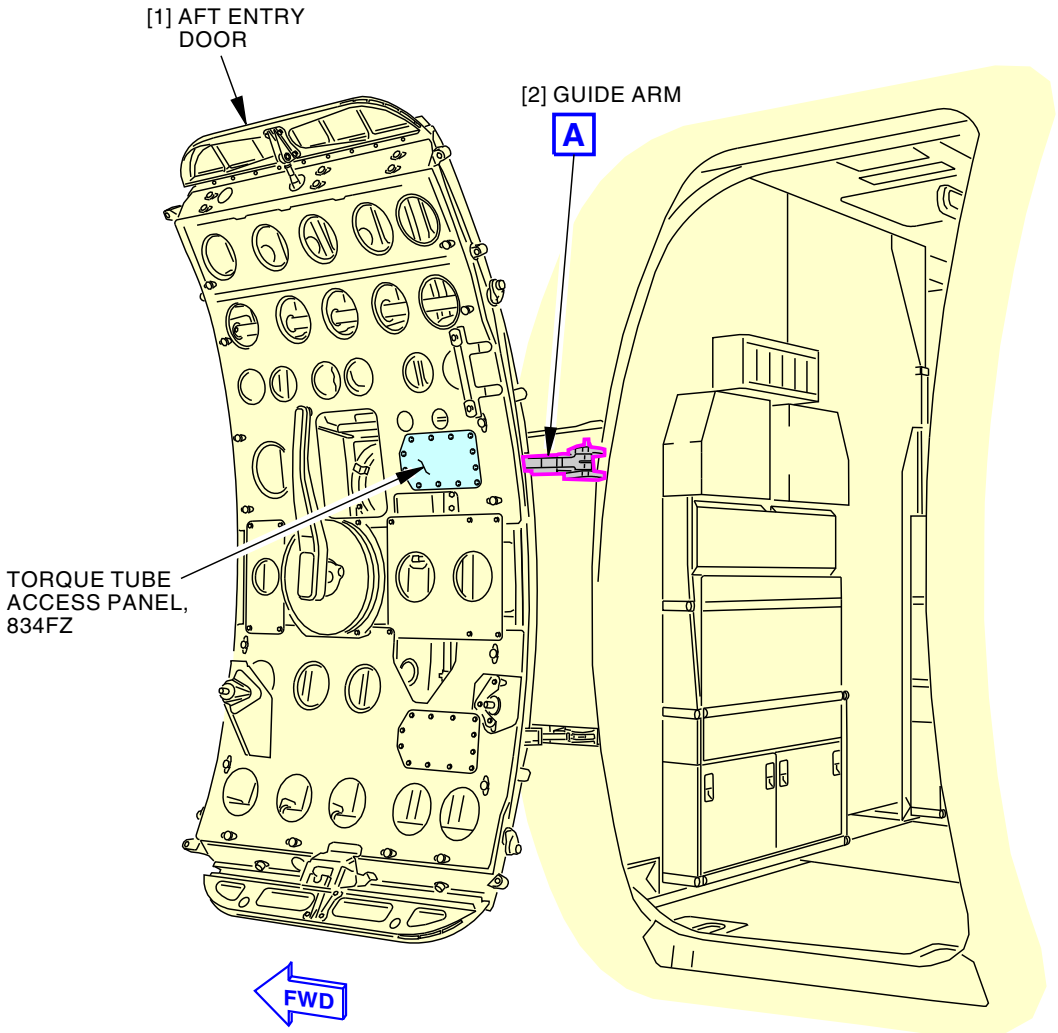
(a) Close this access panel:

Number	Name/Location
834	Aft Entry Door

(b) Make sure the door operates easily and smoothly.

——— END OF TASK ———

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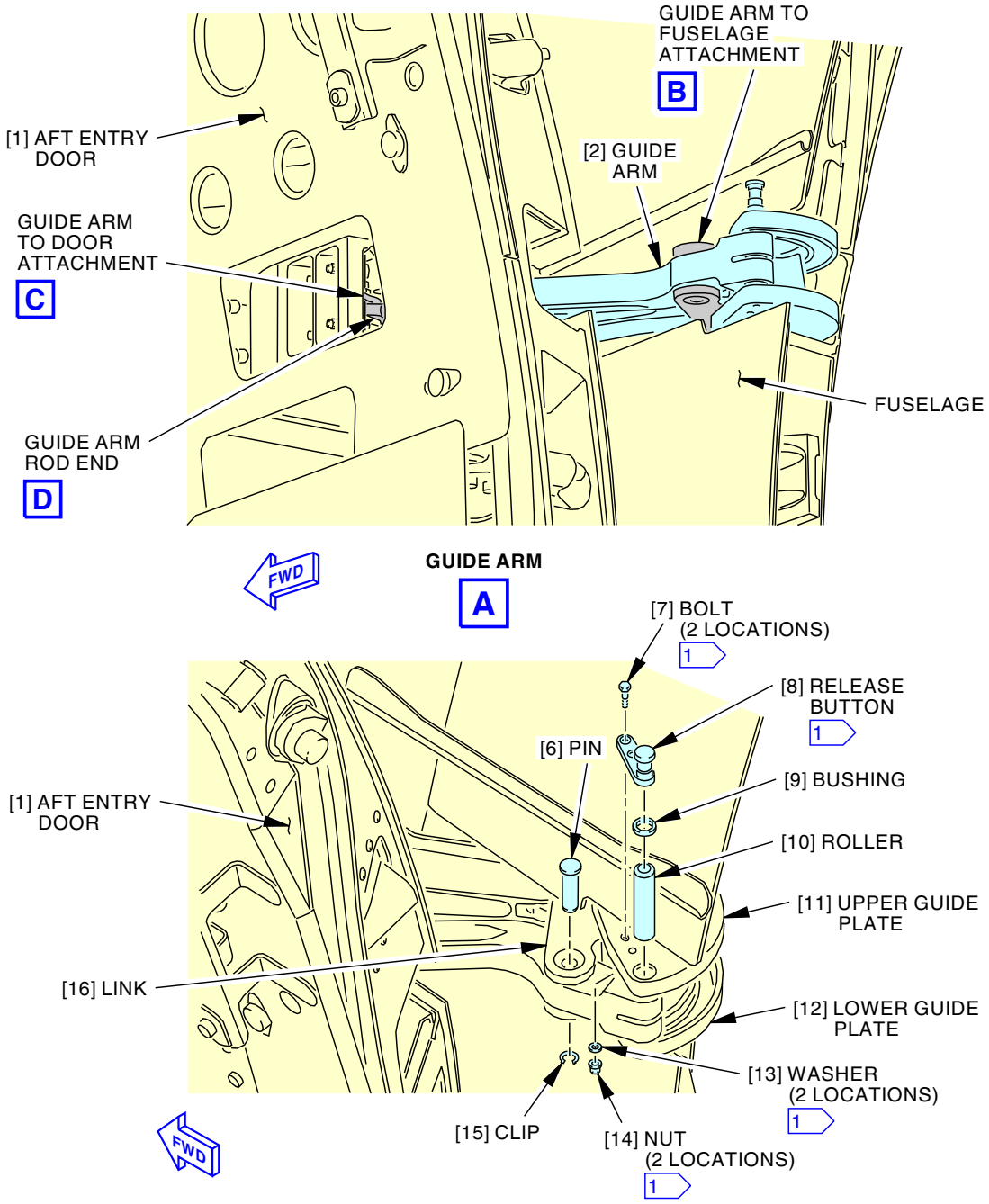


AFT ENTRY DOOR

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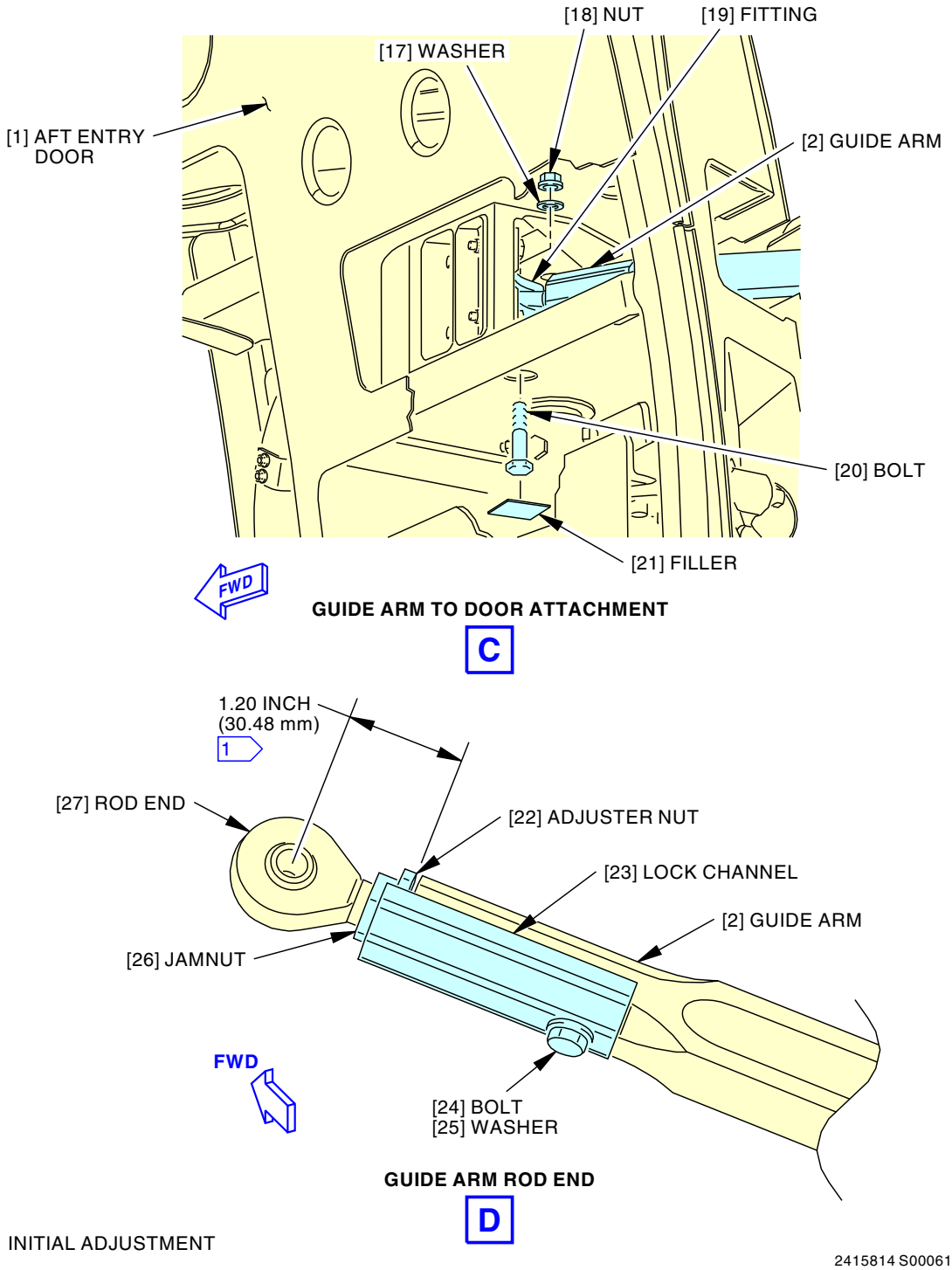
Aft Entry Door Guide Arm and Roller Installation
Figure 401/52-13-21-990-801 (Sheet 1 of 3)

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Aft Entry Door Guide Arm and Roller Installation
Figure 401/52-13-21-990-801 (Sheet 2 of 3)

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Aft Entry Door Guide Arm and Roller Installation
Figure 401/52-13-21-990-801 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AFT ENTRY DOOR LINING - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the aft entry door lining.

(2) An installation of the aft entry door lining.

TASK 52-13-31-000-801

2. Aft Entry Door Lining Removal

(Figure 401)

A. References

Reference	Title
25-66-01-000-801	Escape Slide Pack and Cover 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-5216	Wrench - Spanner, Main Entry Door Assist Handle Part #: F70336-4 Supplier: 81205 Opt Part #: F70336-1 Supplier: 81205

C. Location Zones

Zone	Area
834	Left Aft Entry Door

D. Access Panels

Number	Name/Location
834	Aft Entry Door

E. Prepare for the Removal

SUBTASK 52-13-31-860-001

(1) Make sure that the door is safe:

(a) Make sure that the door is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Put a work platform, COM-1523 outboard of the door.

SUBTASK 52-13-31-010-001

(2) Get access to the door:

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(a) Make sure that the door is closed and latched.

(b) Remove the escape slide pack cover (TASK 25-66-01-000-801).

(c) Fully open this access panel:

Number	Name/Location
834	Aft Entry Door

F. Remove the Aft Entry Door Lining

SUBTASK 52-13-31-020-001

(1) Remove the interior handle [3] from the door:

(a) Remove the cover [9] on the interior handle [3] to get access to the fasteners that attach the interior handle [3] to the hub [4].

(b) Remove the cotter pins [11], nuts [10], and washers [8] that attach the interior handle [3] to the hub [4].

(c) Remove the interior handle [3].

(d) Remove the bolts [5] from the hub [4] if they are loose.

NOTE: The bolts [5] are bonded to the hub [4] and are not necessary to remove when the bond is tight.

SUBTASK 52-13-31-020-002

(2) Remove the cover plate [12] on the door:

(a) Remove the cover plate [12] from the cutout in the door lining [1].

SUBTASK 52-13-31-020-003

(3) Remove the assist handle [2] from the door:

(a) Use the entry door assist handle wrench, SPL-5216 to loosen the handle nuts [16] that attach the assist handle [2] to the door.

NOTE: The loosen direction is clockwise when you face the door lining surface.

(b) Keep the assist handle nuts [16] secure.

(c) Remove the bolts [14], collars [15], and washers [13] that attach the handle nuts [16] to the door.

(d) Remove the handle nuts [16] from the door.

SUBTASK 52-13-31-020-004

(4) Disconnect the door lining [1] from the door:

(a) Remove the nuts [17] that attach the upper part of the door lining [1] to the door.

(b) Remove the nuts [20] that attach the lower part of the door lining [1] to the door.

(c) Remove the screws [19] that attach the lower part of the door lining [1] to the door.

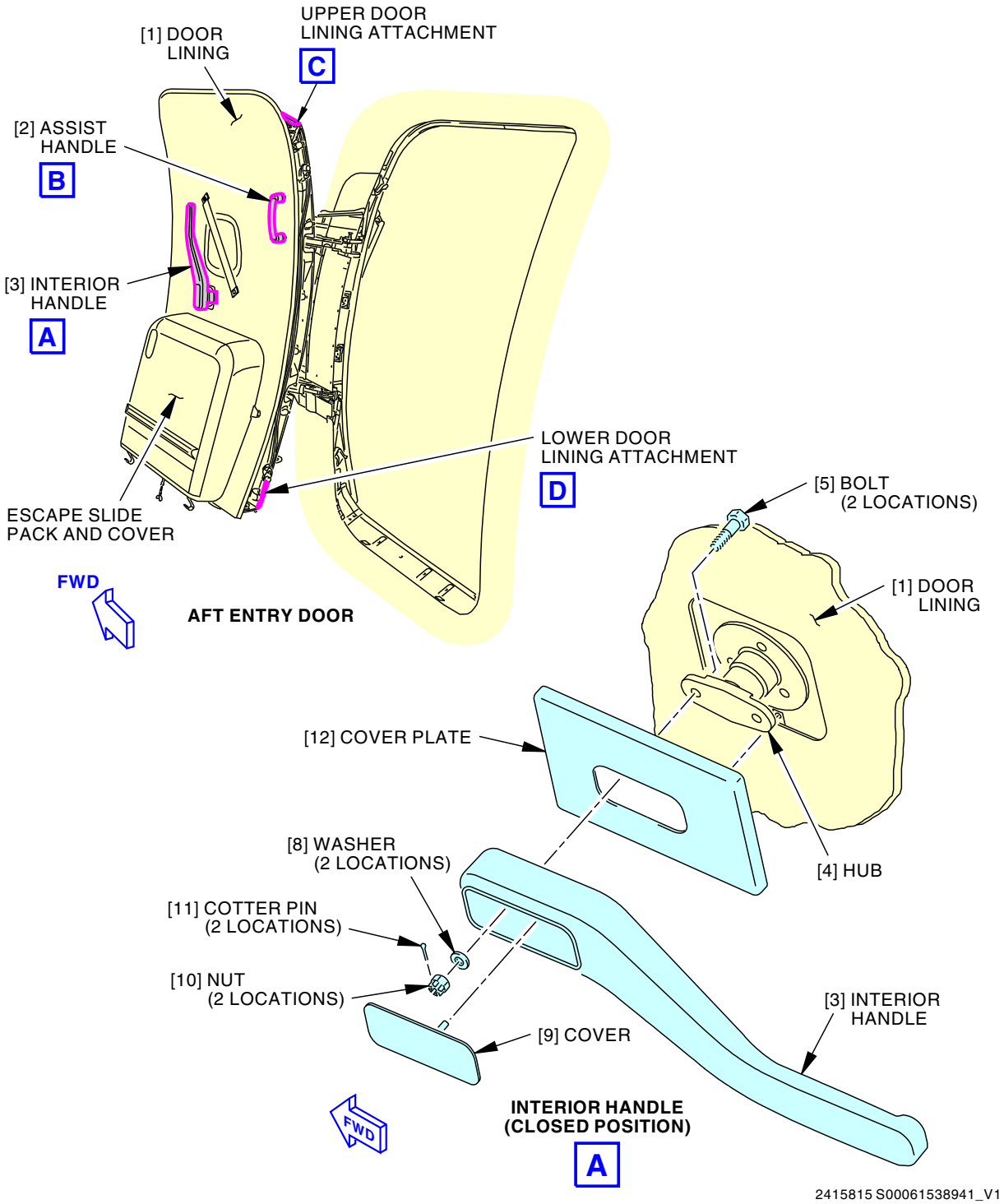
(d) Hold the door lining [1].

(e) Remove the screws [18] that attach the forward and aft edges of the door lining [1] to the door.

(f) Carefully lift the door lining [1] and remove it from the door.

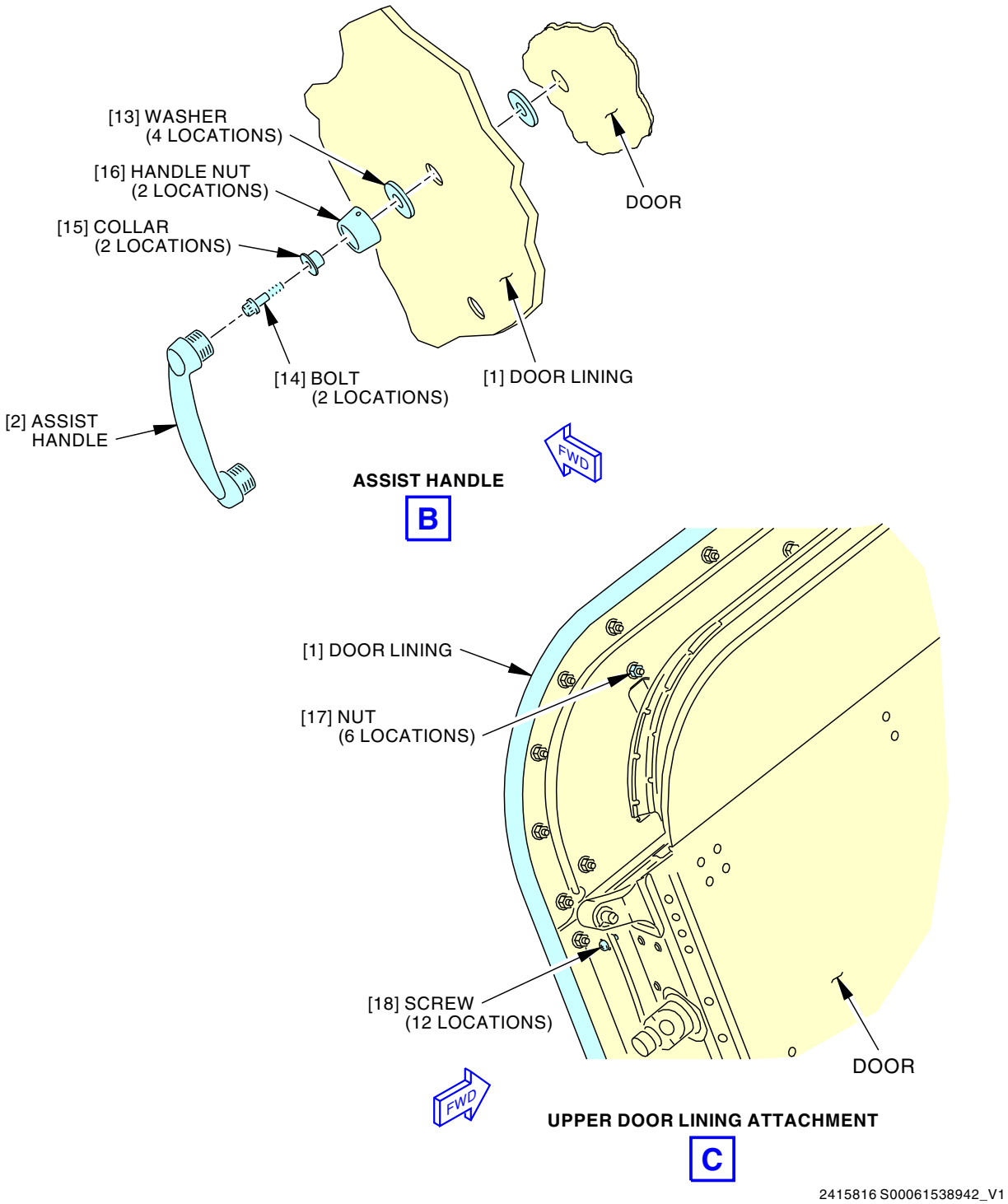
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



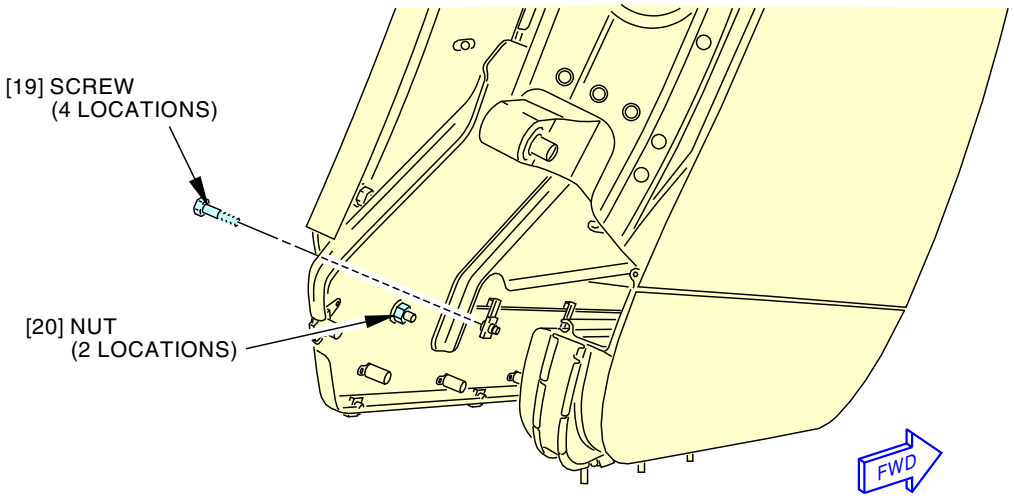
Aft Entry Door Lining Installation
Figure 401/52-13-31-990-802 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aft Entry Door Lining Installation
Figure 401/52-13-31-990-802 (Sheet 2 of 3)

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LOWER DOOR LINING ATTACHMENT

D

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Aft Entry Door Lining Installation
Figure 401/52-13-31-990-802 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-13-31-400-801

3. Aft Entry Door Lining Installation

(Figure 401)

A. References

Reference	Title
25-66-01-400-801	Escape Slide Pack and Cover 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-5216	Wrench - Spanner, Main Entry Door Assist Handle Part #: F70336-4 Supplier: 81205 Opt Part #: F70336-1 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
A00555	Adhesive - For Bonding Decorative Laminate, 2 Part, Sprayable	BMS5-127 Type II

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Door lining	52-13-31-03-240	SIA ALL
		52-13-31-04-245	SIA ALL
11	Cotter pin	52-13-31-03-105	SIA ALL
		52-13-31-04-105	SIA ALL

E. Location Zones

Zone	Area
834	Left Aft Entry Door

F. Access Panels

Number	Name/Location
834	Aft Entry Door

G. Installation of the Aft Entry Door Lining

SUBTASK 52-13-31-420-001

(1) Install the door lining [1] on the door:

(a) Carefully hold the door lining [1] and put it in position on the door.

(b) Install the screws [18] that attach the forward and aft edges of the door lining [1] to the door.

(c) Install the nuts [17] to attach the upper part of the door lining [1] to the door.

(d) Install the nuts [20] to attach the lower part of the door lining [1] to the door.

(e) Install the screws [19] to attach the lower part of the door lining [1] to the door.

SUBTASK 52-13-31-020-005

(2) Install the assist handle [2]:

(a) Put the handle nuts [16] in position on the door lining [1].

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(b) Install the bolts [14], collars [15] , and washers [13] to attach the handle nuts [16] to the door.

(c) Put the assist handle [2] in position against the handle nuts [16].

(d) Tighten the handle nuts [16] counterclockwise with the entry door assist handle wrench, SPL-5216 to attach the assist handle [2] to the door.

SUBTASK 52-13-31-420-002

(3) Install the cover plate [12] on the door:

(a) Put the upper cover plate [12] into the cutout in the door lining [1].

SUBTASK 52-13-31-020-006

(4) Install the interior handle [3]:

(a) Install the bolts [5] in the hub [4] with adhesive, A00555 if loose.

(b) Put the interior handle [3] in the correct position on the bolts [5] in the hub [4].

(c) Install the washers [8], nuts [10], and new cotter pins [11] to attach the interior handle [3] to the hub [4].

(d) Install the cover [9] on the interior handle [3].

H. Put the Airplane Back to Its Usual Condition

SUBTASK 52-13-31-410-001

(1) Install the escape slide pack and cover (TASK 25-66-01-400-801).

SUBTASK 52-13-31-410-002

(2) Close this access panel:

Number	Name/Location
834	Aft Entry Door

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AFT ENTRY DOOR FUSELAGE HINGE TORQUE TUBE - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the aft entry door upper and lower fuselage hinge torque tubes.

(2) An installation of the aft entry door upper and lower fuselage hinge torque tubes.

(3) The aft entry door fuselage hinge torque tube is referred to as the torque tube in this procedure.

TASK 52-13-41-000-801

2. Aft Entry Door Fuselage Hinge Torque Tube Removal

(Figure 401)

A. References

Reference	Title
52-13-00-000-801	Aft Entry Door 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Location Zones

Zone	Area
834	Left Aft Entry Door

D. Access Panels

Number	Name/Location
241AL	Aft Entry Door Hinge and Torque Tube Access Panel

E. Prepare for the Removal

SUBTASK 52-13-41-860-001

(1) Make sure the door is safe as follows:

(a) Make sure the door is closed and latched.

WARNING MAKE SURE THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND INJURIES OR DAMAGE CAN OCCUR.

(b) Make sure the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Install the work platform, COM-1523 outboard of the door.

SUBTASK 52-13-41-010-001

(2) Do this task: Aft Entry Door Removal, TASK 52-13-00-000-801.

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SUBTASK 52-13-41-010-002

(3) To get access to the torque tubes [5] and torque tubes [6], do this step:

Remove this access panel:

Number	Name/Location
241AL	Aft Entry Door Hinge and Torque Tube Access Panel

F. Removal of the Aft Entry Door Fuselage Hinge Torque Tube

SUBTASK 52-13-41-020-001

(1) Disconnect the torque tubes [5] and torque tubes [6] from the upper and lower hinge pins [10] and hinge pins [11]:

NOTE: You can make index marks across the joints to help make the installation easier.

(a) Remove the bolts [7], washers [8], and nuts [9] that attach the torque tube [5] to the hinge pin [10].

(b) Remove the bolts [7], washers [8], and nuts [9] that attach the torque tube [6] to the hinge pin [11].

(c) If it is necessary, remove the lower hinge pin [11].

(2) Remove the torque tubes [5] and torque tubes [6] from the fuselage:

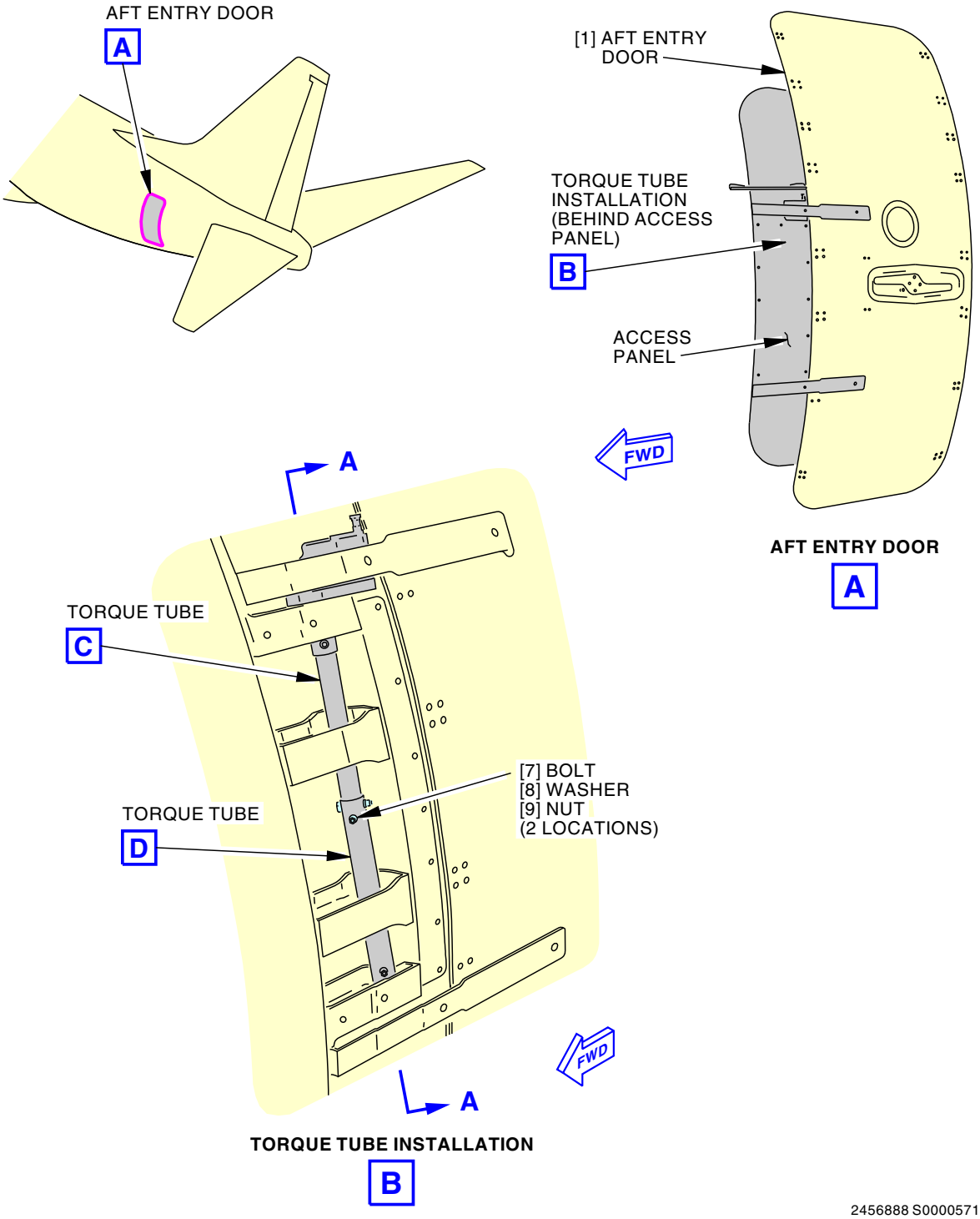
(a) Remove the bolts [7], washers [8], and nuts [9] that connect the torque tubes [5] and torque tubes [6] together.

(b) Push the torque tubes [5] and torque tubes [6] together to make sufficient clearance to remove them from the fuselage structure.

(c) Remove the torque tubes [5] and torque tubes [6] from the airplane.

——— END OF TASK ———

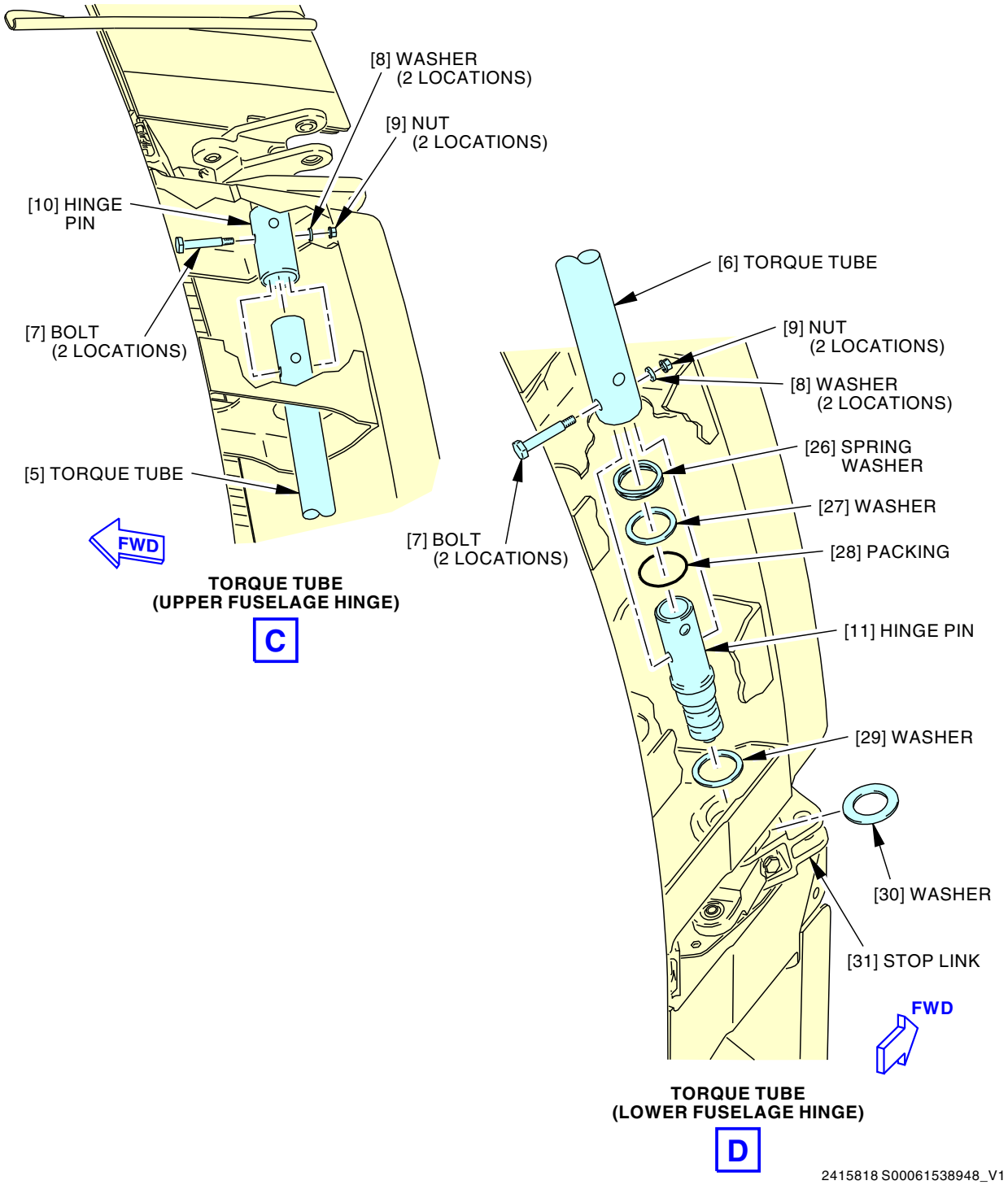
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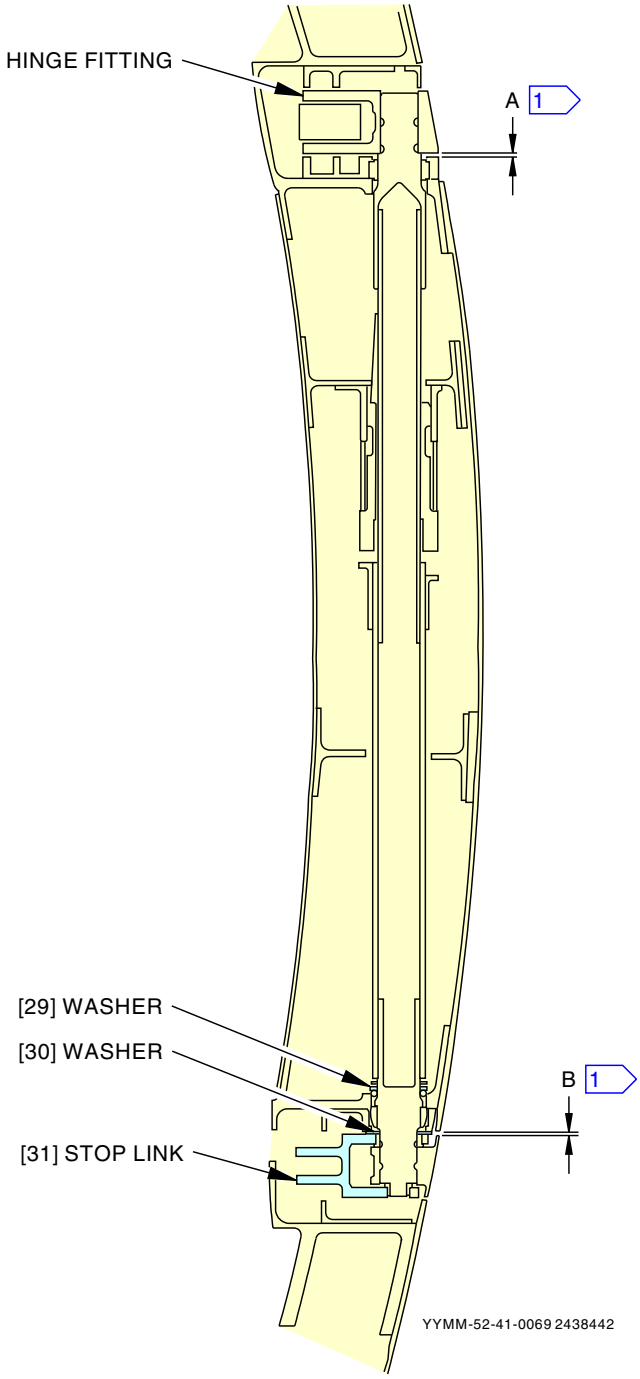
Aft Entry Door Fuselage Hinge Torque Tube Installation
Figure 401/52-13-41-990-802 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aft Entry Door Fuselage Hinge Torque Tube Installation
Figure 401/52-13-41-990-802 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



1 CLEARANCES A AND B MUST BE EQUAL TO ±0.03 INCH (±0.762 mm).

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Aft Entry Door Fuselage Hinge Torque Tube Installation
Figure 401/52-13-41-990-802 (Sheet 3 of 3)

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TASK 52-13-41-400-801

3. Aft Entry Door Fuselage Hinge Torque Tube Installation

(Figure 401)

A. References

Reference	Title
52-13-00-400-801	Aft Entry Door 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
5	Torque tube	52-13-11-01-285	SIA ALL
6	Torque tube	52-13-11-01-285	SIA ALL
10	Hinge pin	52-13-41-03-035	SIA ALL
11	Hinge pin	52-13-41-03-085	SIA ALL
28	Packing	52-13-11-01-245	SIA ALL

E. Location Zones

Zone	Area
834	Left Aft Entry Door

F. Access Panels

Number	Name/Location
241AL	Aft Entry Door Hinge and Torque Tube Access Panel

G. Installation

SUBTASK 52-13-41-420-001

(1) Connect the torque tubes [5] and torque tubes [6]:

(a) Apply grease, D00633 to the mating surfaces of the torque tubes [5] and torque tubes [6].

(b) Put the upper torque tubes [5] into the lower torque tubes [6].

(c) Push the torque tubes [5] and torque tubes [6] together a sufficient distance to fit into the fuselage frame.

SUBTASK 52-13-41-420-002

(2) If the lower hinge pin [11] was removed do the following:

(a) Apply grease, D00633 to the mating surfaces of the hinge pin [11] and stop link [31].

(b) Put the stop link [31] is in its correct position.

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(c) Put the washer [30] on the top of the stop link [31].

(d) Install the washer [29] over the small end of the hinge pin.

(e) Put the lower hinge pin through the fuselage frame and stop link.

(f) Install a new packing [28], nylon washer [27], and spring washer [26] over the hinge pin.

SUBTASK 52-13-41-410-001

(3) Install the torque tubes [5] and torque tubes [6] in the fuselage:

(a) Put the torque tubes [5] and torque tubes [6] in position in the fuselage frame.

(b) Apply grease, D00633 to the mating surfaces of the torque tubes [5] and torque tubes [6] and hinge pins [10] and hinge pins [11].

(c) Pull the torque tubes [5] and torque tubes [6] apart to move the ends of the torque tubes [5] and torque tubes [6] fully over the hinge pins [10] and hinge pins [11].

(d) Align the bolt holes in the mating ends of the torque tubes [5] and torque tubes [6].

(e) Install the bolts [7], washers [8], and nuts [9] to connect the torque tubes [5] and torque tubes [6] together.

NOTE: Make sure the heads of the bolts [7] are inboard.

SUBTASK 52-13-41-420-003

(4) Connect the torque tubes [5] and torque tubes [6] to the upper and lower hinge pins [10] and hinge pins [11]:

(a) Align the bolt holes in the ends of the torque tubes [5] and torque tubes [6] with the bolt holes in the hinge pins [10] and hinge pins [11].

(b) Install the bolts [7], washers [8], and nuts [9] to attach the torque tube [5] to the upper hinge pin [10].

(c) Install the bolts [7], washers [8], and nuts [9] to attach the torque tube [6] to the lower hinge pin [11].

(d) If it is necessary, add washers [29] to get the correct clearance.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 52-13-41-410-002

(1) Install this access panel:

Number	Name/Location
241AL	Aft Entry Door Hinge and Torque Tube Access Panel

SUBTASK 52-13-41-420-004

(2) Do this task: Aft Entry Door Installation, TASK 52-13-00-400-801.

SUBTASK 52-13-41-080-001

(3) Remove the work platform, COM-1523.

——— END OF TASK ———

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AFT ENTRY DOOR SNUBBER/BUMPER - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the aft entry door snubber.

(2) An installation of the aft entry door snubber.

(3) A removal of the aft entry door bumper.

(4) An installation of the aft entry door bumper.

(5) The aft entry door will be call the door in this procedure.

TASK 52-13-51-000-801

2. Aft Entry Door Snubber Removal

(Figure 401)

A. References

Reference	Title
52-13-31-000-801	Aft Entry Door Lining 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Location Zones

Zone	Area
834	Left Aft Entry Door

D. Access Panels

Number	Name/Location
834GZ	AFT Entry Door - Torque Tube Access

E. Prepare for the Removal

SUBTASK 52-13-51-860-001

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Install the work platform, COM-1523 outboard of the door.

(d) Put the aft entry door in the full open position.

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SUBTASK 52-13-51-010-001

(2) If necessary, do this task: Aft Entry Door Lining Removal, TASK 52-13-31-000-801.

SUBTASK 52-13-51-010-002

(3) Remove this access panel:

Number	Name/Location
834GZ	AFT Entry Door - Torque Tube Access

F. Removal of the Aft Entry Door Snubber

SUBTASK 52-13-51-020-001

CAUTION

DO NOT MOVE THE DOOR WITH THE SNUBBER REMOVED. THE DOOR CAN MOVE QUICKLY WITH THE SNUBBER REMOVED. IF THE DOOR MOVES QUICKLY TO THE OPEN OR CLOSED POSITION, IT CAN CAUSE DAMAGE TO THE EQUIPMENT.

(1) Do these steps to remove the snubber [7] from the door:

(a) Remove the bolt [1], washers [2], nut [3], and bushing [4] that attach the snubber [7] to the fuselage.

NOTE: Write down the location of the washers on the bolt.

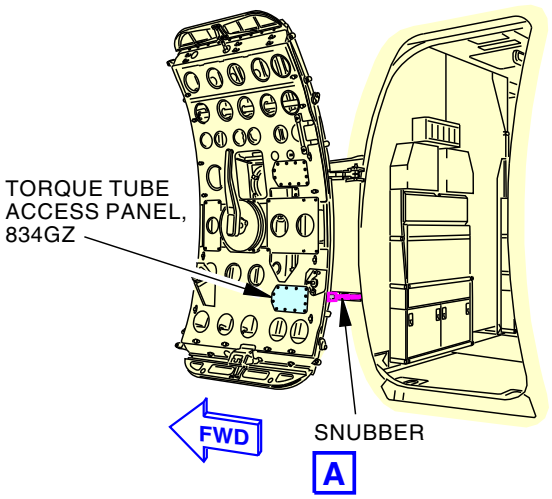
(b) Remove the filler [9] from the snubber attachment fitting [8].

(c) Remove the bolt [10], washer [11] and nut [12] that connects the snubber [7] to the snubber attachment fitting [8].

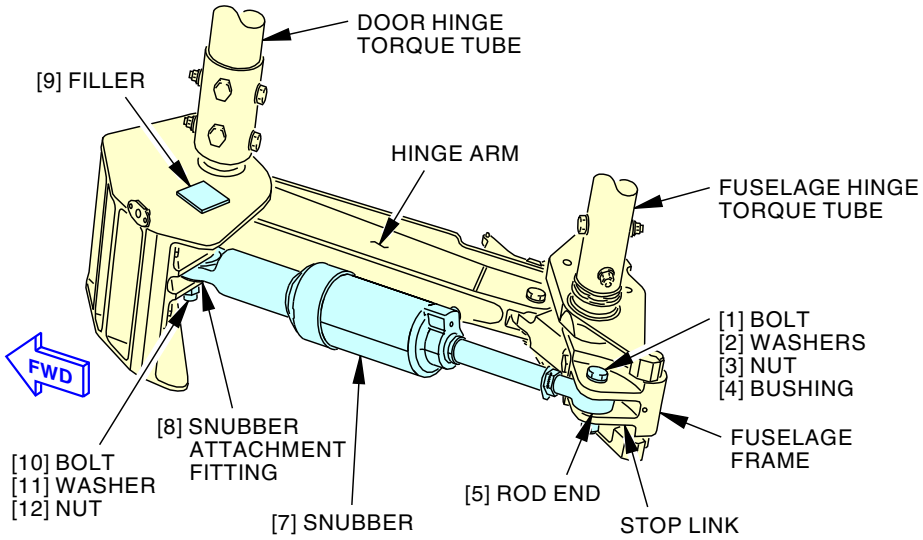
(d) Remove the snubber [7].

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



AFT ENTRY DOOR



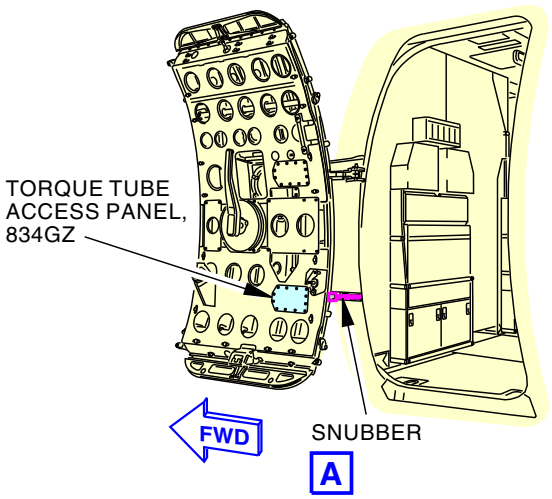
SNUBBER

A

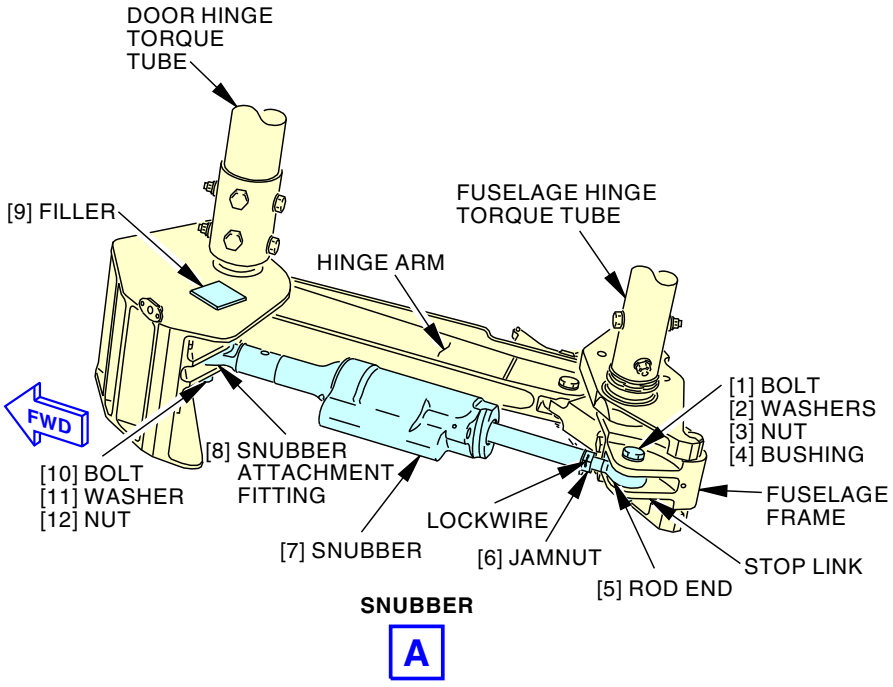
2415820 S00061538954_V1

Snubber Installation
Figure 401/52-13-51-990-802 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



AFT ENTRY DOOR



2921466 S0000703786_V1

Snubber Installation
Figure 401/52-13-51-990-802 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-13-51-400-801

3. Aft Entry Door Snubber Installation

(Figure 401)

A. References

Reference	Title
20-50-11-910-801	Standard Torque Values (P/B 201)
52-13-31-400-801	Aft Entry Door Lining Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
G01912	Lockwire - MS20995NC32, Monel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
7	Snubber	52-13-00-01A-142	SIA ALL

D. Location Zones

Zone	Area
834	Left Aft Entry Door

E. Access Panels

Number	Name/Location
834GZ	AFT Entry Door - Torque Tube Access

F. Installation of the Aft Entry Door Snubber

SIA ALL; AIRPLANES WITH SNUBBER WITH FLUID LEVEL INDICATOR

SUBTASK 52-13-51-420-002

CAUTION DO NOT MOVE THE DOOR WITH THE SNUBBER REMOVED. THE DOOR CAN MOVE QUICKLY WITH THE SNUBBER REMOVED. IF THE DOOR MOVES QUICKLY TO THE OPEN OR CLOSED POSITION, IT CAN CAUSE DAMAGE TO THE EQUIPMENT.

(1) Do these steps to install the snubber [7] on the door:

(a) Connect the snubber [7] to the snubber attachment fitting [8].

1) Install the snubber attachment fitting [8] with the snubber fluid fill plug recess pointed down.

(b) Install the bolt [10], washer [11], and nut [12] to attach the snubber [7] to the snubber attachment fitting [8].

(c) Install the filler [9] onto the snubber attachment fitting [8].

(d) Install the bolt [1], washers [2], nut [3], and bushing [4] to attach the snubber [7] to the fuselage structure.

1) For the torque information, refer to task Standard Torque Values, TASK 20-50-11-910-801.

(e) Do the Snubber Installation Test.

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SIA ALL; AIRPLANES WITH ADJUSTABLE SNUBBER

SUBTASK 52-13-51-420-001

CAUTION DO NOT MOVE THE DOOR WITH THE SNUBBER REMOVED. THE DOOR CAN MOVE QUICKLY WITH THE SNUBBER REMOVED. IF THE DOOR MOVES QUICKLY TO THE OPEN OR CLOSED POSITION, IT CAN CAUSE DAMAGE TO THE EQUIPMENT.

(2) Do these steps to install the snubber [7] on the door:

(a) Set the initial length of the snubber as follows:

1) Loosen the jamnut [6] on the snubber rod end [5].

2) Turn the snubber rod end [5] to set the length of the rod to 0.26 in. (6.604 mm).

NOTE: Measure from the bottom of the rod end where it meets the rod, to the top of the jamnut. This is the part of the rod that extends from the jamnut but does not include the circular rod end at all. It is necessary to measure the straight part of the rod shaft only.

3) Tighten the jamnut [6].

CAUTION MAKE SURE TO INSTALL THE SNUBBER WITH THE WIDE SIDE OF THE SNUBBER INBOARD. IF YOU DO NOT INSTALL THE SNUBBER WITH THE WIDE SIDE INBOARD, THE SNUBBER WILL CONTACT THE HINGE ARM WHEN THE DOOR IS CLOSED. THIS WILL CAUSE DAMAGE TO THE EQUIPMENT.

(b) Connect the snubber [7] to the snubber attachment fitting [8].

(c) Install the bolt [10], washer [11], and nut [12] to attach the snubber [7] to the snubber attachment fitting [8].

(d) Install the filler [9] onto the snubber attachment fitting [8].

(e) Install the bolt [1], washers [2], nut [3], and bushing [4] to attach the snubber [7] to the fuselage structure.

1) For the torque information, refer to task Standard Torque Values, TASK 20-50-11-910-801.

(f) Do the Snubber Installation Test.

SIA ALL

G. Snubber Installation Test

SIA ALL; AIRPLANES WITH SNUBBER WITH FLUID LEVEL INDICATOR

SUBTASK 52-13-51-710-002

(1) Do an installation test on the snubber as follows:

(a) Make sure that the door is fully open with the hold open lock engaged.

(b) Move the door to the closed position.

SIA ALL; AIRPLANES WITH ADJUSTABLE SNUBBER

SUBTASK 52-13-51-710-001

(2) Do an installation test on the snubber as follows:

(a) Make sure that the door is fully open with the hold open lock engaged.

(b) Make sure that more extension is available on the snubber [7].

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SIA ALL; AIRPLANES WITH ADJUSTABLE SNUBBER (Continued)

(c) Move the door to the closed position.

(d) Make sure that the snubber [7] does not bottom out with the door in the closed position.

(e) If required, adjust the length of the snubber [7].

1) Make sure that the jamnut [6] is tight.

2) Install the MS20995NC32 lockwire, G01912 on the jamnut [6].

SIA ALL

H. Put the Airplane Back to its Usual Condition

SUBTASK 52-13-51-410-001

(1) Install this access panel:

Number	Name/Location
834GZ	AFT Entry Door - Torque Tube Access

SUBTASK 52-13-51-410-002

(2) If necessary, do this task: Aft Entry Door Lining Installation, TASK 52-13-31-400-801.

——— END OF TASK ———

TASK 52-13-51-000-803

4. Aft Entry Door Bumper - Removal

(Figure 402)

A. General

(1) This task incudes steps to remove the aft entry door bumpers.

B. Tools/Equipment

Reference	Description
STD-764	Scraper - Non-metallic

C. Location Zones

Zone	Area
834	Left Aft Entry Door

D. Prepare for the Removal

SUBTASK 52-13-51-020-002

(1) Remove the snubber from the aft entry door assembly, do this task: Aft Entry Door Snubber Removal, TASK 52-13-51-000-801.

E. Aft Entry Door Bumper Removal

SUBTASK 52-13-51-000-001

(1) Remove the bumper [20] with a non-metallic scraper, STD-764.

NOTE: Bumper bonded to surface with adhesive.

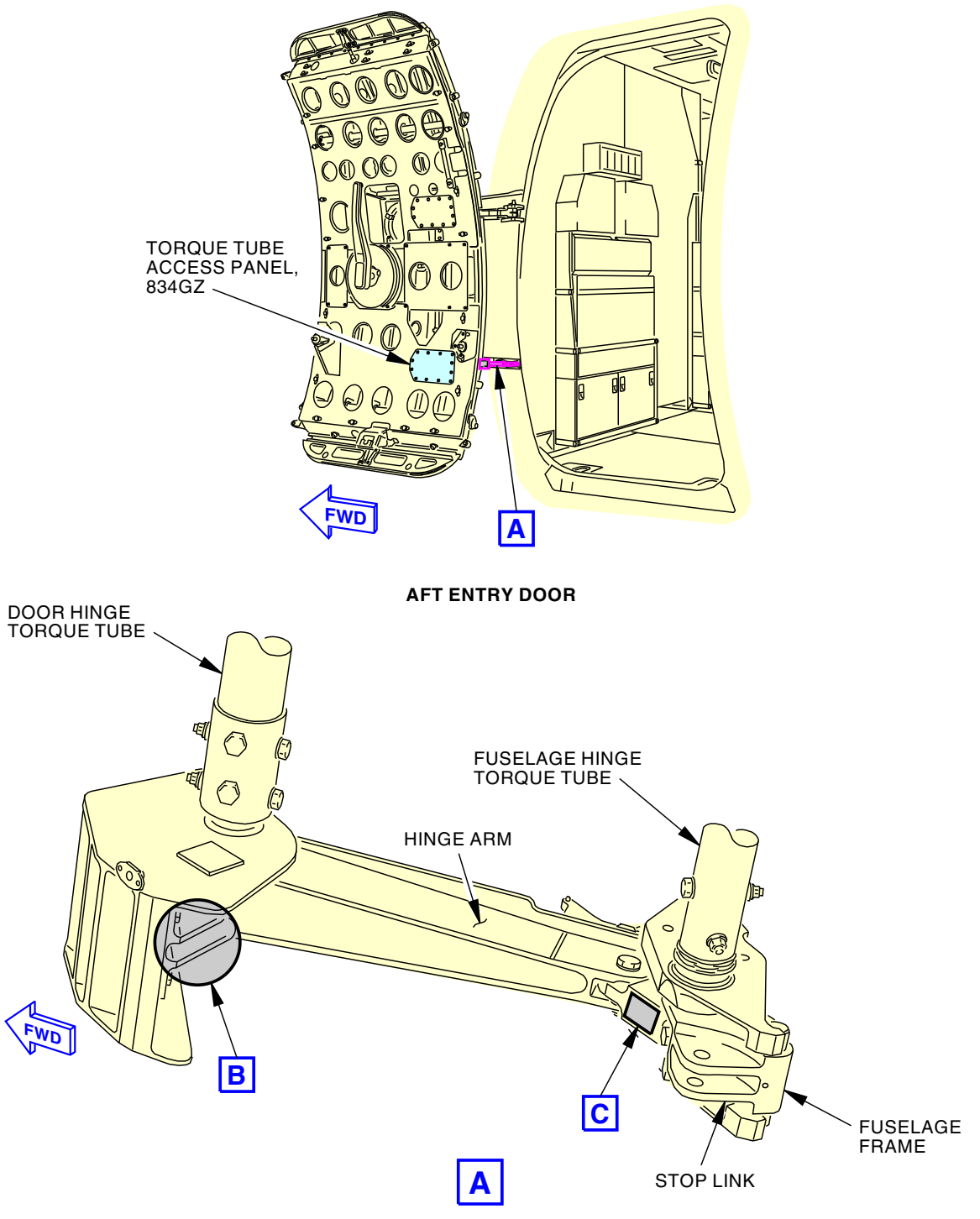
SUBTASK 52-13-51-000-002

(2) Remove the bumper [21] with a non-metallic scraper, STD-764.

NOTE: Bumper bonded to surface with adhesive.

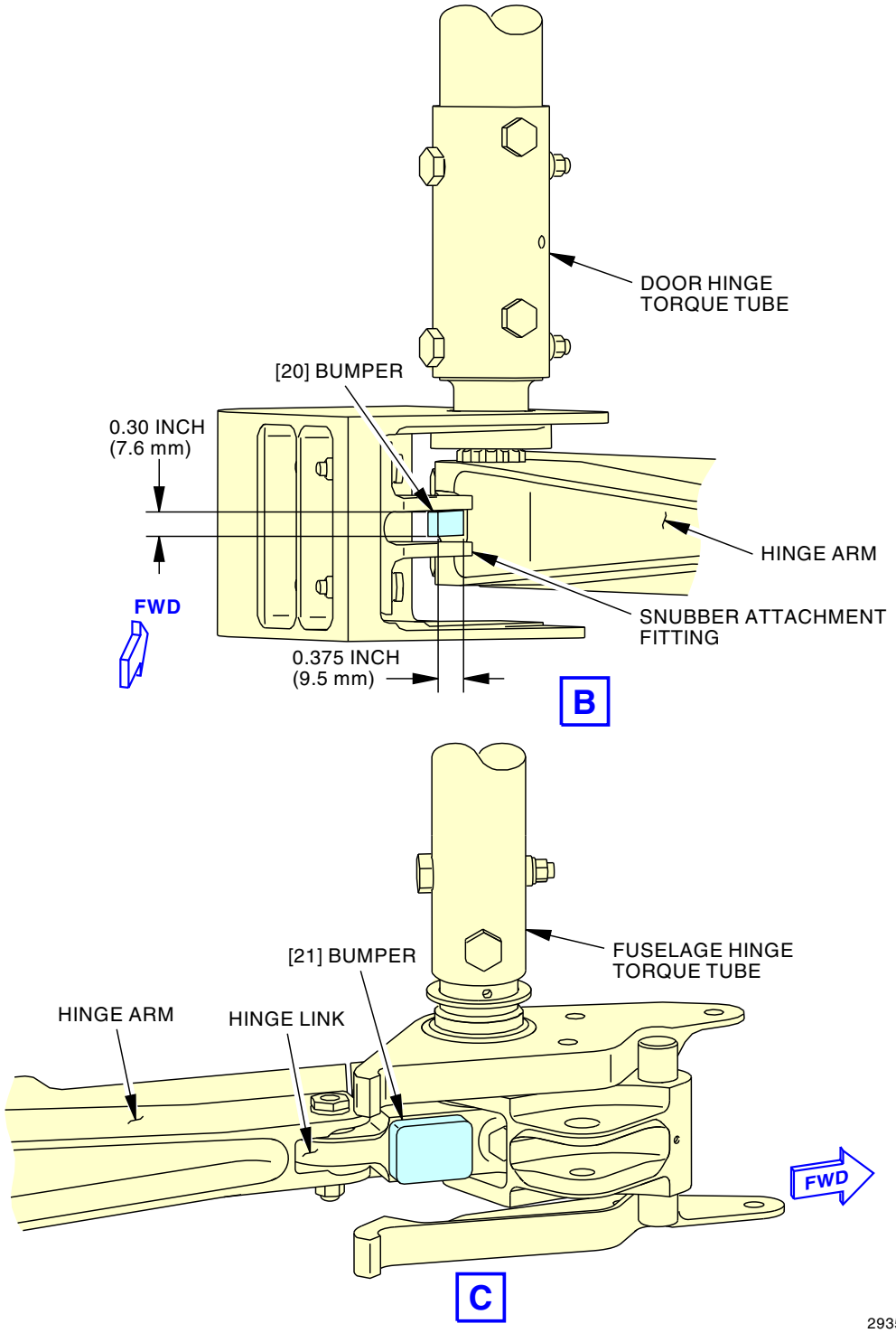
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aft Entry Door Bumper Installation
Figure 402/52-13-51-990-803-001 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aft Entry Door Bumper Installation
Figure 402/52-13-51-990-803-001 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-13-51-400-803

5. Aft Entry Door Bumper - Installation

(Figure 402)

A. General

(1) This task includes the steps to install the aft entry door bumpers.

B. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
B00130	Alcohol - Isopropyl	TT-I-735
B50201	Wipe - Alcohol (Isopropyl Alcohol)	
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)
G50260	Sandpaper - Aluminum Oxide, 220 Grit	

C. Prepare for the Installation

SUBTASK 52-13-51-100-001

(1) If necessary, use sandpaper, G50260, to remove the parting agent from the bonding areas.

SUBTASK 52-13-51-100-002

(2) Clean the bonding surfaces with cotton wiper, G00034, soaked in alcohol, B00130.

(a) Remove excess residue or solvent with a clean dry cotton wiper, G00034.

1) Use alcohol wipes, B50201, to remove any slow evaporating residue solvent.

(b) Repeat the process until the wipers are not dirty and the surface is visibly clean.

D. Aft Entry Door Bumper Installation

SUBTASK 52-13-51-400-001

(1) Apply a continuous layer of adhesive, A00027, to the bonding surfaces of the hinge arm, hinge link, new bumper [20], and new bumper [21].

(a) Make sure that no adhesive is applied outside the bonding areas.

SUBTASK 52-13-51-400-002

(2) Align and attach the bumper [20] to the hinge arm.

NOTE: Exposure to the air for more than two minutes will cause the adhesive to form a skin that interferes with the bond.

SUBTASK 52-13-51-400-005

(3) Align and attach the bumper [21] to the hinge link.

NOTE: Exposure to the air for more than two minutes will cause the adhesive to form a skin that interferes with the bond.

SUBTASK 52-13-51-400-003

(4) Apply pressure to the bumper [20] and bumper [21] to make sure there is a good contact between bonding surfaces.

(a) Do not let the adhesive to squeeze out.

NOTE: Bond line thickness with a minimum of 0.015 in. (0.38 mm) is recommended for the best result.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-13-51-400-004

(5) Let adhesive dry under pressure for a minimum of 24 hours at 65°F (18.3°C) - 100°F (37.8°C).

(a) Do not cover the bond line.

NOTE: A minimum of 20% relative humidity is required. This adhesive requires moisture from the air to cure.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 52-13-51-410-003

(1) Install the snubber on the aft entry door assembly, do this task: Aft Entry Door Snubber Installation, TASK 52-13-51-400-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AFT ENTRY DOOR BUMPER - INSPECTION/CHECK

1. General

A. This procedure has this task:

(1) Inspection of the aft entry door bumpers.

TASK 52-13-51-200-801

2. Aft Entry Door Bumper - Inspection

(Figure 601)

A. General

(1) This task includes steps to perform a visual inspection of aft entry door bumpers.

B. References

Reference	Title
52-13-51-000-803	Aft Entry Door Bumper - Removal (P/B 401)
52-13-51-400-803	Aft Entry Door Bumper - Installation (P/B 401)

C. Access Panels

Number	Name/Location
834	Aft Entry Door

D. Aft Entry Door Bumper Inspection

SUBTASK 52-13-51-010-003

(1) Open this access door:

Number	Name/Location
834	Aft Entry Door

NOTE: You can see the bumpers when the aft entry door is open to maximum width.

(2) Do a visual inspection of the bumpers.

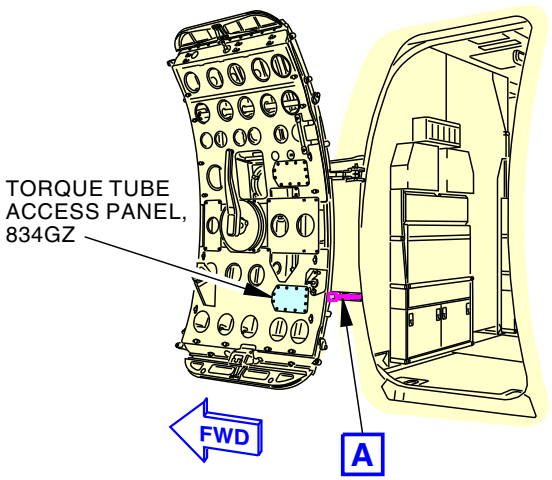
(a) If the bumpers are missing or the position is incorrect, replace the bumpers, do these tasks:

- Aft Entry Door Bumper - Removal, TASK 52-13-51-000-803
- Aft Entry Door Bumper - Installation, TASK 52-13-51-400-803.

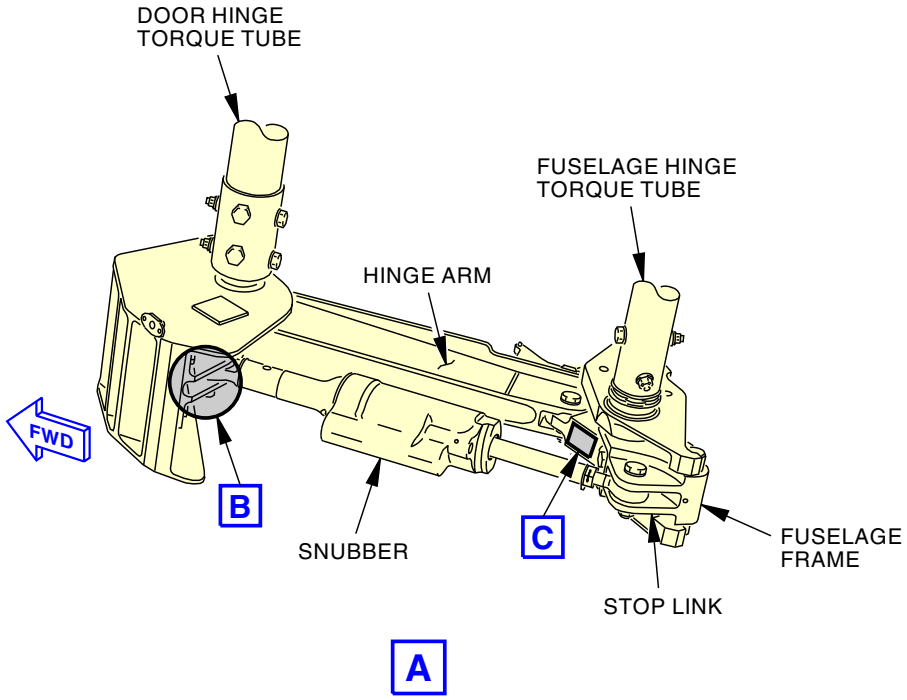
NOTE: Orientation of the bumpers is critical.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



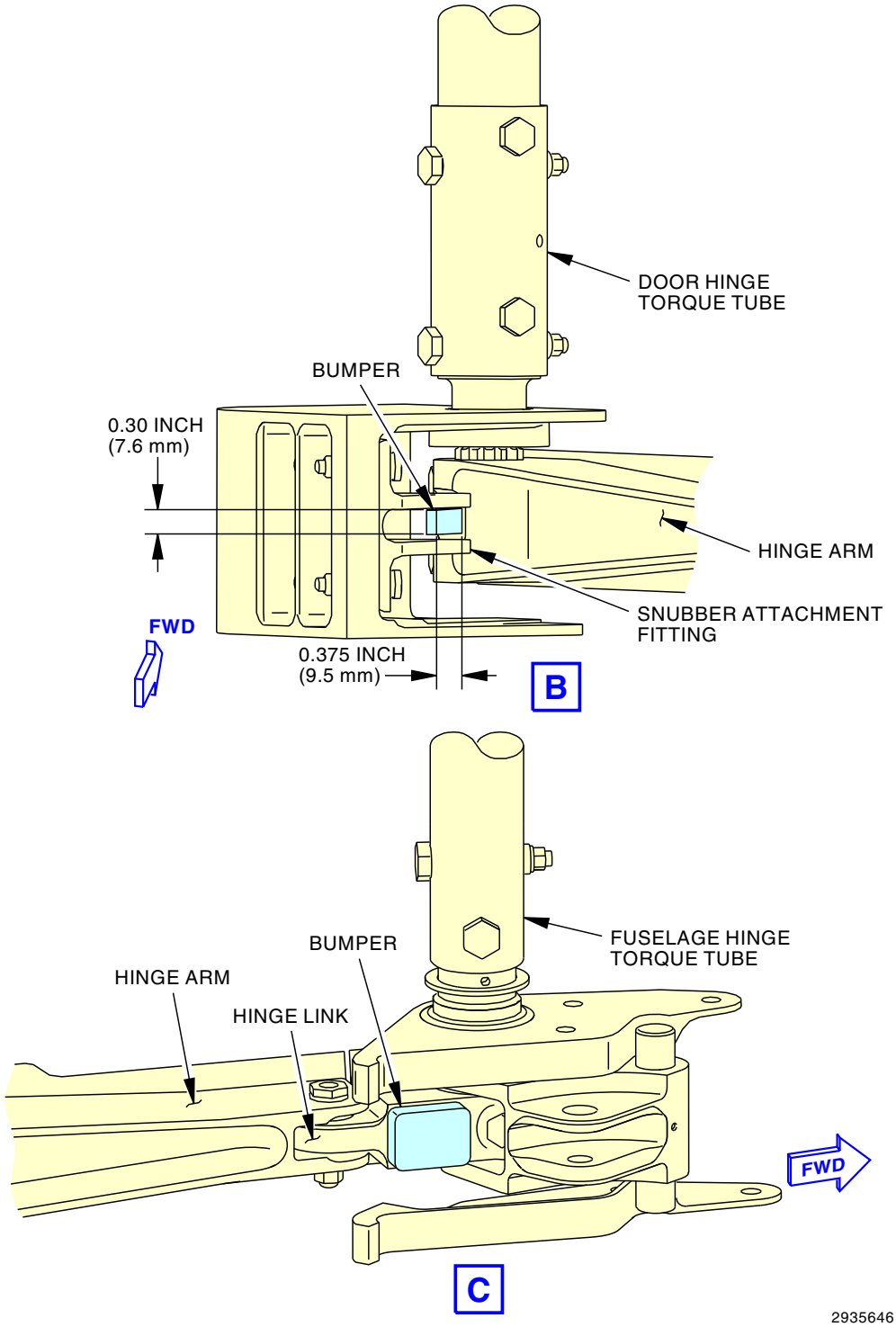
AFT ENTRY DOOR



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Aft Entry Door Bumper Inspection
Figure 601/52-13-51-990-804 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aft Entry Door Bumper Inspection
Figure 601/52-13-51-990-804 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AFT ENTRY DOOR GATE - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the gate from the aft entry door.

(2) An installation of the gate on the aft entry door.

B. There are two gates on the door. This procedure is the same for the top and bottom gates.

TASK 52-13-61-000-801

2. Aft Entry Door Gate Removal

(Figure 401)

A. References

Reference	Title
52-09-12-000-801	Blade and Diaphragm Seals Removal (P/B 401)
52-13-31-000-801	Aft Entry Door Lining 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Location Zones

Zone	Area
834	Left Aft Entry Door

D. Prepare for the Removal

SUBTASK 52-13-61-860-001

(1) Make sure the door is safe as follows:

(a) Make sure the door is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure the work platform, COM-1523 is installed outboard of the door.

SUBTASK 52-13-61-010-001

(2) Get access to the door:

(a) Make sure the door is closed and latched.

(b) Do this task: Aft Entry Door Lining Removal, TASK 52-13-31-000-801.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E. Removal of the Aft Entry Door Gate

SUBTASK 52-13-61-020-001

(1) To remove the blade seal from the gate [3], do this task: Blade and Diaphragm Seals Removal, TASK 52-09-12-000-801.

NOTE: Only do the blade seal removal from the gate [3].

SUBTASK 52-13-61-020-002

(2) Disconnect the rod [2] from the upper or lower gate [3]:

(a) Hold the rod [2] and do not let it fall back into the door frame when the bolt [7] is removed.

NOTE: You can turn the door handle to extend or retract the rod [2].

(b) Remove the bolt [7], washer [6], bushing [8], washer [5], and nut [9] that attach the rod [2] to the gate [3].

(c) Safety the end of the rod [2] to the door frame to hold it in position.

SUBTASK 52-13-61-020-003

(3) To remove the diaphragm seal between the aft entry door [1] and gate [3], do this task: Blade and Diaphragm Seals Removal, TASK 52-09-12-000-801.

NOTE: Only do the diaphragm seal removal.

SUBTASK 52-13-61-020-004

(4) Remove the upper or lower gate [3] from the aft entry door [1]:

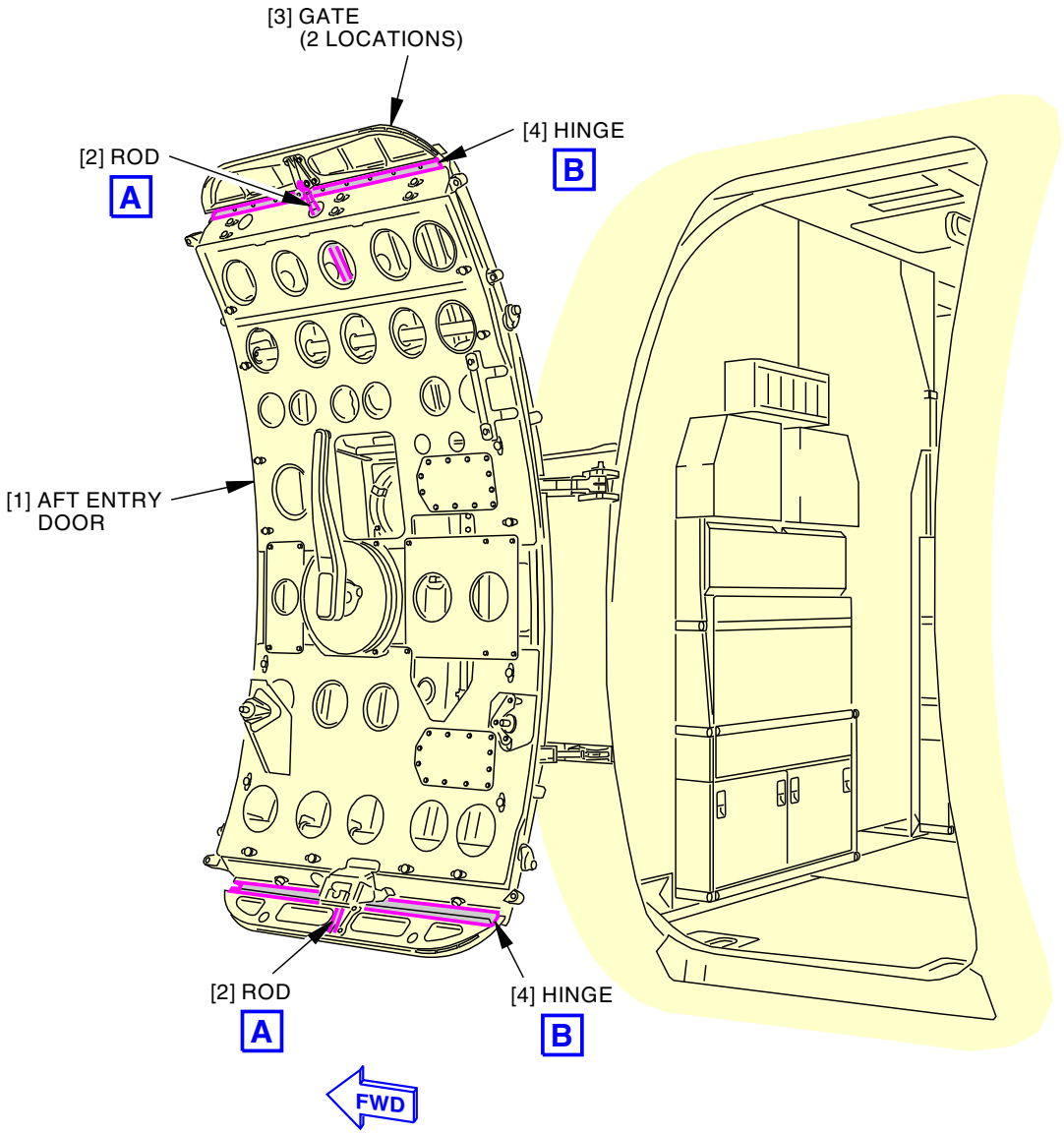
(a) Fold the gate [3] in the outboard direction.

(b) Remove the bolts [10] and washers [11] that attach the hinge [4] to the aft entry door [1].

(c) Remove the gate [3] from the aft entry door [1].

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

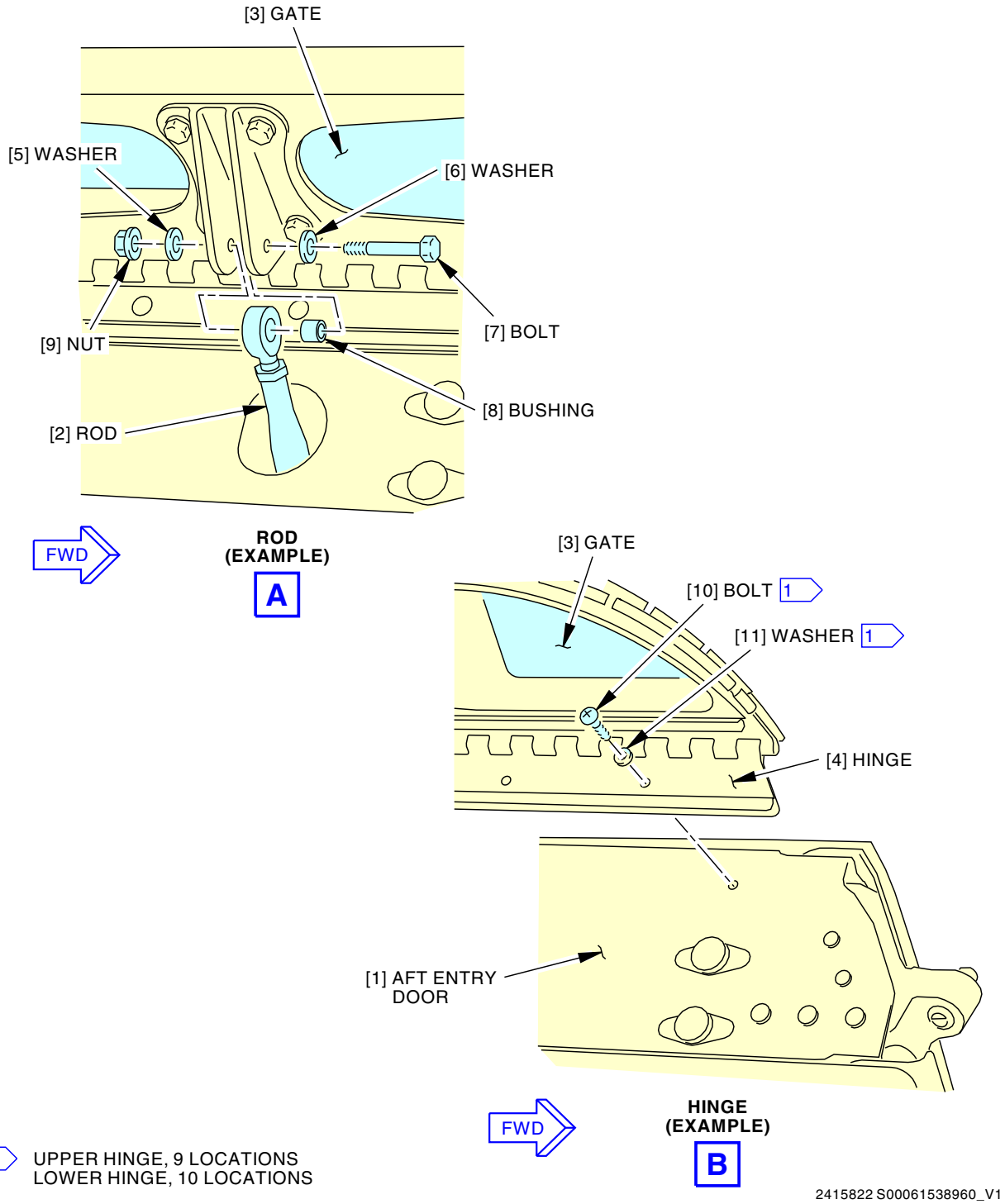


AFT ENTRY DOOR
(LINING REMOVED)

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Aft Entry Door Gate Installation
Figure 401/52-13-61-990-802 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aft Entry Door Gate Installation
Figure 401/52-13-61-990-802 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-13-61-400-801

3. Aft Entry Door Gate Installation

(Figure 401)

A. References

Reference	Title
52-09-12-400-801	Blade and Diaphragm Seals Installation (P/B 401)
52-13-00-820-801	Aft Entry Door Adjustment (P/B 501)
52-13-31-400-801	Aft Entry Door Lining Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
3	Gate	52-13-61-05A-065	SIA ALL
		52-13-61-05A-180	SIA ALL
		52-13-61-06A-070	SIA ALL
		52-13-61-06A-180	SIA ALL

D. Location Zones

Zone	Area
834	Left Aft Entry Door

E. Installation of the Aft Entry Door Gate

SUBTASK 52-13-61-420-001

(1) Connect the upper or lower gate [3] to the aft entry door [1] at the hinge [4]:

(a) Apply sealant, A00247 to the mating surfaces between the hinge [4] and aft entry door [1].

(b) Put the gate [3] in position on the aft entry door [1].

(c) Install the bolts [10] and washers [11] to attach the hinge [4] to the aft entry door [1].

SUBTASK 52-13-61-420-002

(2) Install the diaphragm seal between the aft entry door [1] and upper or lower gate [3]:

(a) Fold the gate [3] outboard.

(b) To install the diaphragm seal between the aft entry door [1] and gate [3], do this task: Blade and Diaphragm Seals Installation, TASK 52-09-12-400-801.

NOTE: Only do the diaphragm seal installation.

SUBTASK 52-13-61-420-003

(3) Connect the rod [2] to the upper or lower gate [3]:

(a) Fold the gate [3] inboard.

(b) Put the rod [2] in its correct position on the gate [3] and hold.

1) Do not let the rod [2] fall back into the door frame when the bolt [7] is installed.

NOTE: You can turn the door handle to extend or retract the rod [2].

(c) Install the bolt [7], washer [6], bushing [8], washer [5], and nut [9] to attach the rod [2] to the gate [3].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-13-61-420-004

(4) To install the blade seal on the upper or lower gate [3], do this task: Blade and Diaphragm Seals Installation, TASK 52-09-12-400-801.

NOTE: Only do the blade seal installation on the gate [3].

SUBTASK 52-13-61-820-001

(5) Adjust the gate [3]. To adjust it, do this task: Aft Entry Door Adjustment, TASK 52-13-00-820-801.

NOTE: Only do the gate [3] adjustment.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 52-13-61-410-001

(1) Do this task: Aft Entry Door Lining Installation, TASK 52-13-31-400-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AFT ENTRY DOOR DRAIN VALVE ASSEMBLY - REMOVAL/INSTALLATION

1. General

A. This procedure has the following tasks:

(1) The removal of the aft entry door drain valve assembly.

(2) The installation of the aft entry door drain valve assembly.

TASK 52-13-62-000-801

2. Aft Entry Door Drain Valve Assembly - Removal

Figure 401

A. General

(1) This task includes the steps to remove the aft entry door drain valve assembly.

B. References

Reference	Title
52-13-00-860-801	Open the AFT Door with the Exterior Handle (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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

D. Location Zones

Zone	Area
834	Left Aft Entry Door

E. Prepare for the Removal

SUBTASK 52-13-62-480-001

(1) Install the work platform, COM-1523 outboard of the aft entry door.

SUBTASK 52-13-62-010-001

(2) Open the aft entry door: Open the AFT Door with the Exterior Handle, TASK 52-13-00-860-801.

F. Aft Entry Door Drain Valve Assembly Removal

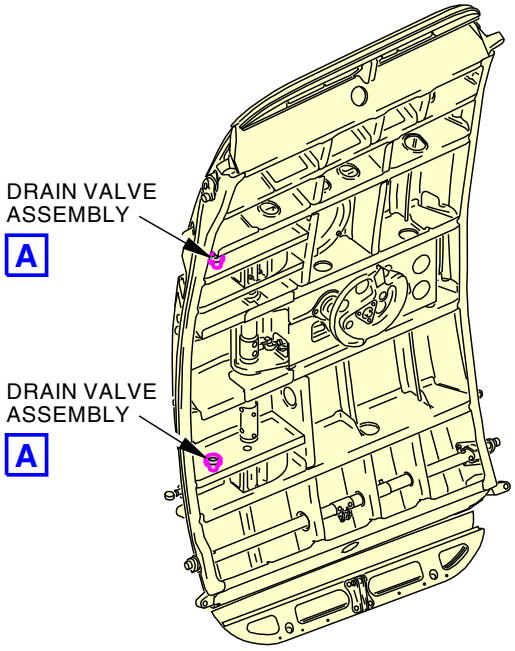
SUBTASK 52-13-62-020-001

(1) Remove the drain valve assembly [1] from the drain valve retainer [2].

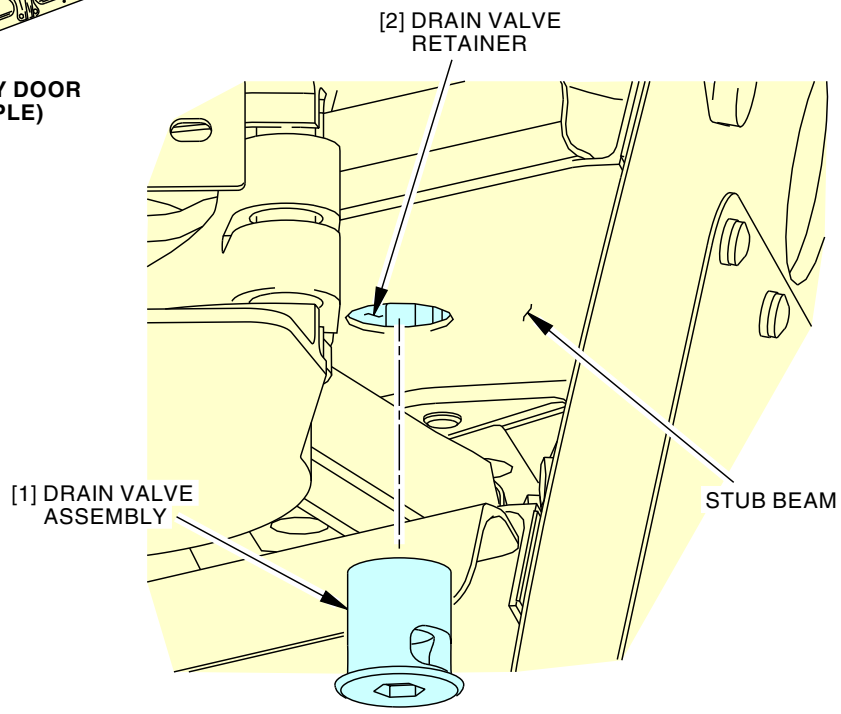
(a) Remove the drain valve assembly [1] from the hinge side.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



AFT ENTRY DOOR (EXAMPLE)



DRAIN VALVE ASSEMBLY (EXAMPLE)

A

2415823 S00061538964_V1

Aft Entry Door Drain Valve Assembly Installation
Figure 401/52-13-62-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-13-62-400-801

3. Aft Entry Door Drain Valve Assembly - Installation

Figure 401

A. General

(1) This task includes the steps to install the aft entry door drain valve assembly.

B. References

Reference	Title
52-13-00-860-802	Close the AFT Door with the Exterior Handle (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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Drain valve assembly	52-13-00-16A-390	SIA ALL
		52-13-00-16A-550	SIA ALL

E. Location Zones

Zone	Area
834	Left Aft Entry Door

F. Aft Entry Door Drain Valve Assembly Installation

SUBTASK 52-13-62-420-001

(1) Install the drain valve assembly [1] into the drain valve retainer [2].

(a) Install the drain valve assembly [1] from the hinge side.

(b) Tighten the drain valve assembly [1] to 8.0 ±2.0 in-lb (0.9 ±0.2 N·m).

G. Put the Airplane Back to Its Usual Condition

SUBTASK 52-13-62-410-001

(1) Close the aft entry door: Close the AFT Door with the Exterior Handle, TASK 52-13-00-860-802.

SUBTASK 52-13-62-080-001

(2) Remove the work platform, COM-1523.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

EMERGENCY EXIT DOOR - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks:

(1) Open the Emergency Exit Door from inside the airplane

(2) Open the Emergency Exit Door from outside the airplane

(3) Close the Emergency Exit Door.

(4) Emergency Exit Door Corrosion Prevention.

B. The opening and closing procedure is the same for each emergency exit door.

TASK 52-22-00-580-801

2. Open the Emergency Exit Door

(Figure 201)

A. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

B. Procedure

SUBTASK 52-22-00-860-001

(1) Open the emergency exit door from inside the airplane:

(a) Remove the clear handle cover from the door.

WARNING IF THE SIDEWALL LINING ABOVE THE DOOR IS REMOVED, KEEP PERSONS AND EQUIPMENT CLEAR OF THE UPPER CUTOUT SILL. THE DOOR COMPONENTS MOVE QUICKLY WHEN THE DOOR HANDLE IS PULLED. THIS CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

WARNING MAKE SURE THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING LOADED TO OPEN AUTOMATICALLY AND INJURIES COULD OCCUR.

WARNING DO NOT HOLD ON TO THE RELEASE HANDLE ONCE YOU HAVE PULLED IT DOWN TO OPEN THE DOOR. THE DOOR IS AUTOMATIC AFTER THE INITIAL PULL ON THE HANDLE AND CAN CAUSE PERSONAL INJURY IF YOU HOLD IT THROUGH THE ENTIRE OPENING OF THE DOOR.

(b) Pull down on the door handle to open the emergency exit door.

NOTE: When the release handle is pulled, the door will initially travel inboard and downward to clear the stop fittings.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(c) Let the emergency exit door travel outboard and open fully outside the airplane.

NOTE: When the door is fully open it is locked in place by the hinge arm lock pawl at 125 degrees around the fixed hinge line.

——— END OF TASK ———

TASK 52-22-00-580-802

3. Open the Emergency Exit Door from the Outside

(Figure 201)

A. General

(1) For normal operation of the emergency exit door it is recommended that opening of the door be accomplished from the inside only. If for some reason it is necessary to open the door from the outside, use this procedure to open the door.

B. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

C. Procedure

SUBTASK 52-22-00-860-002

(1) Open the emergency exit door from outside the airplane:

WARNING IF THE SIDEWALL LINING ABOVE THE DOOR IS REMOVED FROM THE INSIDE OF THE AIRPLANE, KEEP PERSONS AND EQUIPMENT CLEAR OF THE UPPER CUTOUT SILL. THE DOOR COMPONENTS MOVE WHEN THE VENT HANDLE IS PUSHED AND CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

(a) Make sure the upper cutout sill on the inside of the door is clear of personnel and equipment before opening the door.

WARNING GET ASSISTANCE FROM ANOTHER MECHANIC TO HELP BRACE THE DOOR WITH YOUR KNEES BEFORE PUSHING THE VENT PANEL INWARD. THE DOOR OPENS WITH A POWERFUL FORCE AND CAN CAUSE INJURY IF NOT BRACED BEFORE OPENING.

(b) While bracing the door with your knees, push the vent panel inward on the outside of the door to start the opening sequence.

NOTE: When the vent handle is pushed, the door will initially travel inboard and downward to clear the stop fittings.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WARNING LET THE DOOR OPEN SLOWLY BY RELIEVING THE BRACING PRESSURE APPLIED TO THE DOOR PRIOR TO OPENING. IF ALL OF THE PRESSURE IS RELIEVED AT ONCE THE DOOR CAN OPEN RAPIDLY AND CAUSE INJURY.

(c) Slowly relieve the bracing pressure applied to the door with your knees and let the emergency exit door travel outboard and open fully outside the airplane.

NOTE: When the door is fully open it is locked in place by the hinge arm lock pawl at 125 degrees around the fixed hinge line.

END OF TASK

TASK 52-22-00-580-803

4. Close the Emergency Exit Door

(Figure 201)

A. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

B. Procedure

SUBTASK 52-22-00-860-003

(1) Do these steps to close the door:

(a) Lift the outboard edge of the Lower Closeout Panel for the applicable door.

1) Make sure that the Hold-Open Latch engages in the Hold-Open Spring.

(b) Remove the strap cover from the lower door lining.

(c) Pull down and inboard on the strap to close the door.

(d) While the door starts into the door cutout, pull the interior handle down.

NOTE: When the interior handle moves down, it will align the latch rollers with the latch receivers.

NOTE: When the door contacts the cutout, the interior handle will stay in the down position.

WARNING KEEP YOUR FACE AWAY FROM THE INTERIOR HANDLE ON THE LAST PULL TO CLOSE THE DOOR. THE INTERIOR HANDLE CLOSES QUICKLY. IF YOU DO NOT OBEY, INJURY TO PERSONNEL CAN OCCUR.

(e) Pull the strap inward and upward for the final movement to close the door.

NOTE: Both hands on the strap will be necessary for the final movement of the door. On the final movement of the door, the door handle will latch close.

(f) Push outboard on the door handle and release the handle.

NOTE: This step makes sure that the door handle and the external vent door are in fully closed positions.

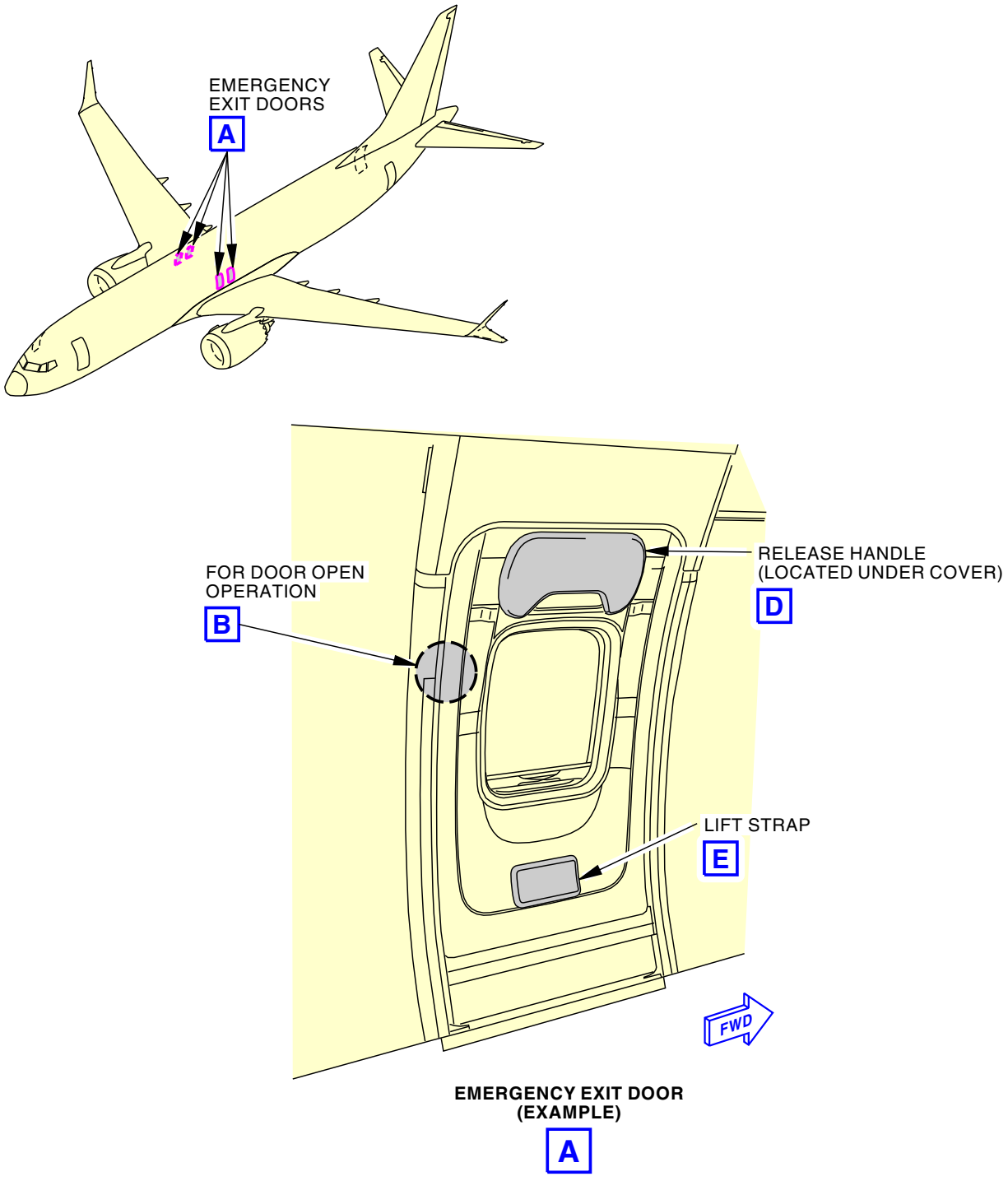
(g) Reinstall the clear handle cover over the handle on the door.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(h) Check that the flight station indication light has gone out.

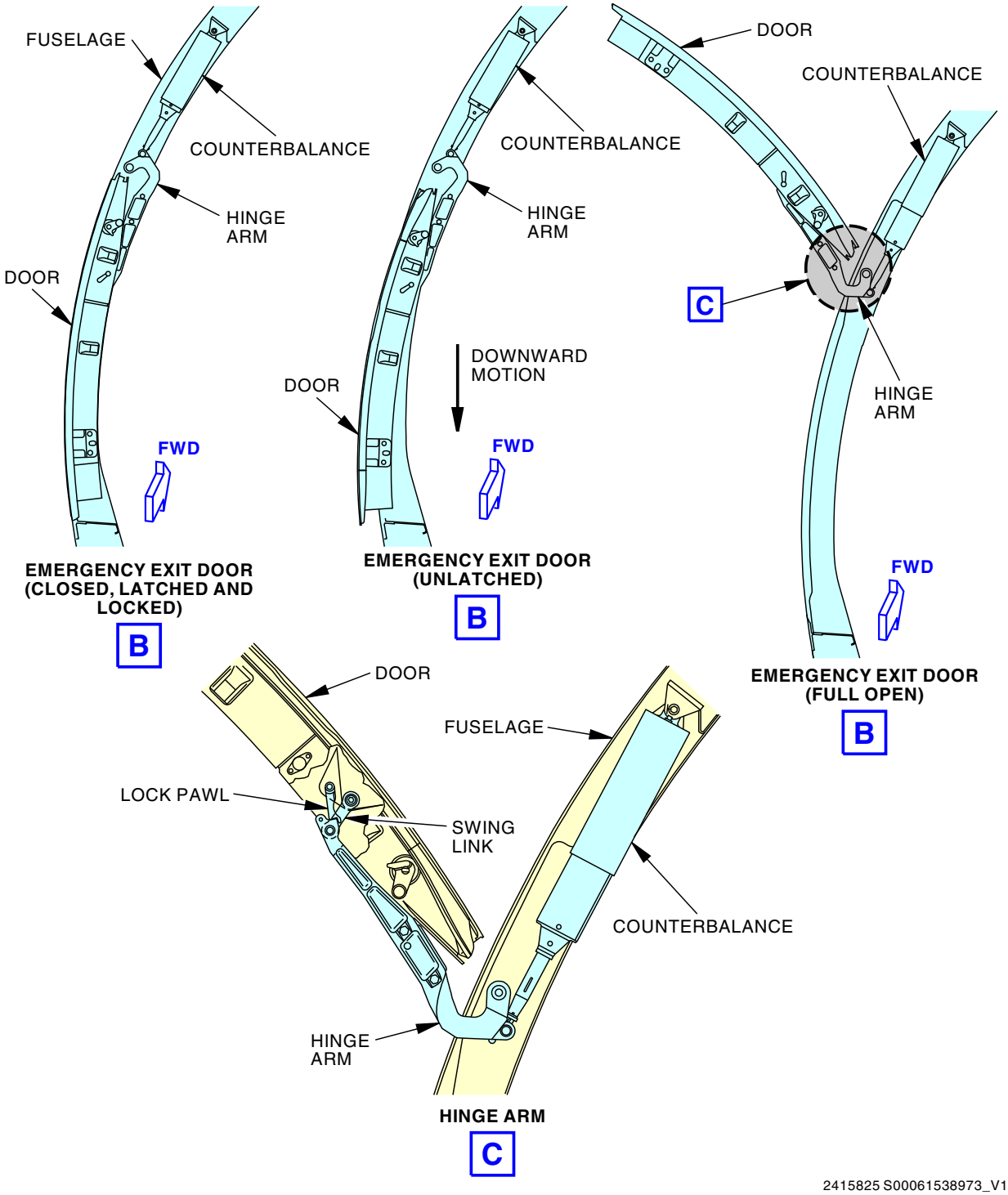
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



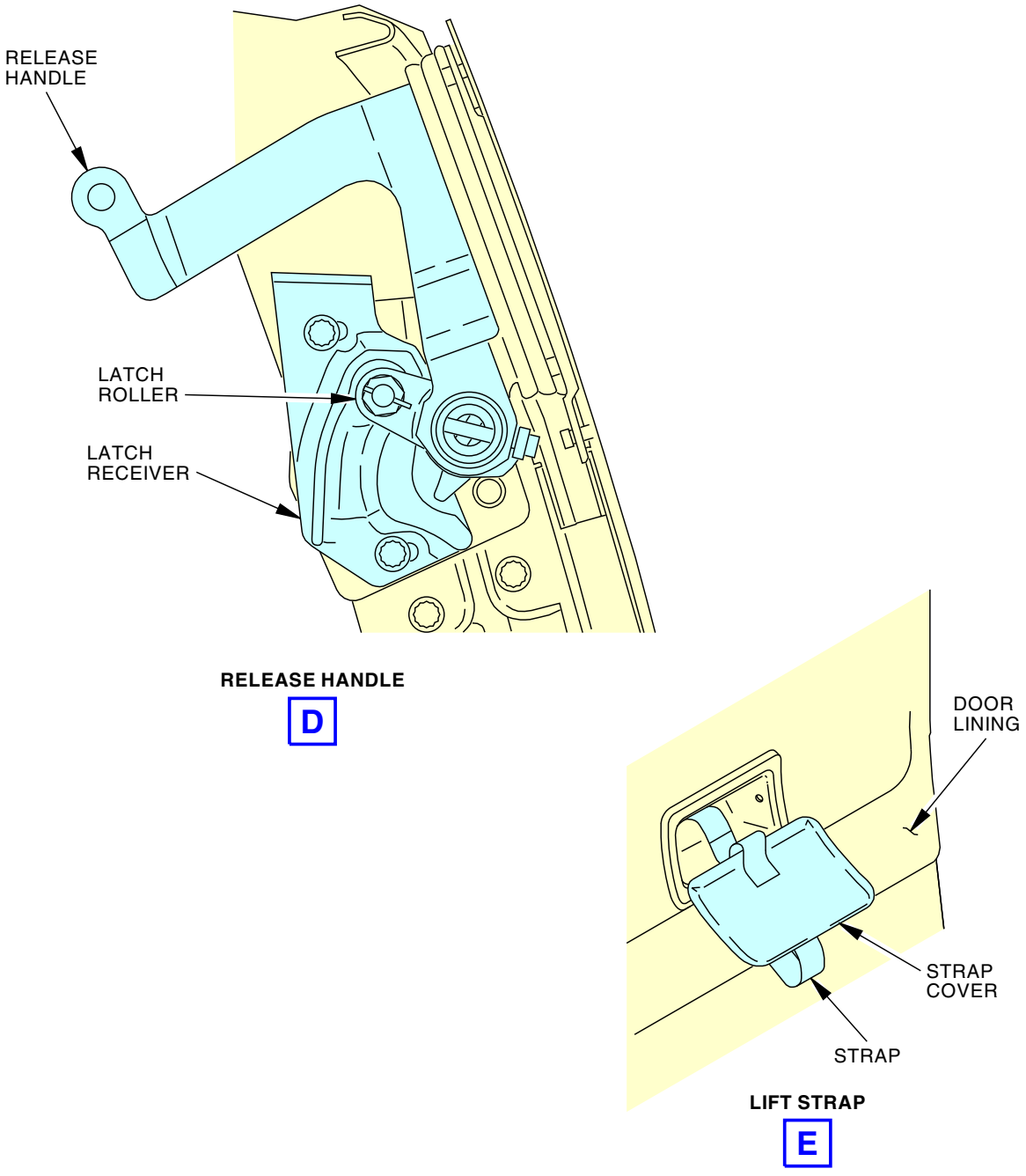
Emergency Exit Door Operation
Figure 201/52-22-00-990-801 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Emergency Exit Door Operation
Figure 201/52-22-00-990-801 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Emergency Exit Door Operation
Figure 201/52-22-00-990-801 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-22-00-600-801

5. Emergency Exit Door Corrosion Protection

A. References

Reference	Title
12-25-22 P/B 301	EMERGENCY EXIT DOOR - SERVICING
52-22-00-200-801	Emergency Exit Door Inspection/Check (P/B 601)
52-22-51-000-801	Emergency Exit Door Lining Removal (P/B 401)
52-22-51-400-801	Emergency Exit Door Lining Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

C. Location Zones

Zone	Area
833	Left Emergency Exit (STA 627.5)
843	Right Emergency Exit (STA 627.5)

D. General

SUBTASK 52-22-00-800-001

(1) Corrosion may occur on the internal and external surfaces of the door structure. especially the inside lower corners, the connection points, and the door mechanism.

(2) Corrosion has been found on the door handle, especially adjacent to the torque tube.

(3) Corrosion has been found on the door frames. Corrosion has been found in the area of the torsion springs.

NOTE: Severe corrosion has been found in the lower lugs of the door frame. In one instance that corrosion had penetrated the frame

(4) Some items in this section maybe subject to the mandatory requirements for corrosion prevention and control programs for aging airplanes.

(5) Corrosion Prevention

(a) Do these tasks, Emergency Exit Door Inspection/Check, TASK 52-22-00-200-801 to detect the early stages of corrosion.

(b) Look for missing fasteners, white powdery deposits, and discolorations, as signs of corrosion.

1) If signs of corrosion are found, then a corrosion prevention program should be started to prevent the build up of corrosion products.

2) If corrosion products are allowed to build up, then they will cause further corrosion.

3) If corrosion is found, the refer to the Structural Repair Manual for detail instructions for the removal of corrosion.

(c) After the corrosion products are cleaned, make sure that the protective finishes are serviceable.

1) If only minor corrosion is found, then make sure that the area is clean.

2) Apply corrosion inhibiting compound on the affected area.

3) Make sure that the protective finish is restored at the next maintenance opportunity.

(6) Frequency of Application

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) Periodic inspection is required to areas identified as prone to corrosion and should be scheduled to your Maintenance Planning Document.

(b) Periodic application of BMS 3-23 compounds are necessary to areas identified as prone to corrosion and should be scheduled to your Maintenance Planning Document.

1) Do the prevention treatment to the exterior surface of the door at the same recommended interval as the exterior surface of the fuselage.

E. Corrosion Prevention

SUBTASK 52-22-00-620-001

(1) Prevention Treatment

(a) Remove the door liner to get access to the interior surfaces of the door.

1) Emergency Exit Door Lining Removal, TASK 52-22-51-000-801

(b) Clean the drains and drain paths.

(c) Emergency Exit Door Inspection/Check, TASK 52-22-00-200-801

1) Remove or repair any corrosion that you find.

(d) Apply corrosion inhibiting compound, G00009 to the interior surfaces of the door.

1) Make sure that the corrosion inhibiting compound, G00009 completely covers the surfaces, with special attention given to the lower corners and the mechanism.

(e) If it is necessary, apply corrosion inhibiting compound, G00009 to the exterior surfaces of the door.

(f) Lubricate the door. EMERGENCY EXIT DOOR - SERVICING, PAGEBLOCK 12-25-22/301

(g) Install the door lining.

1) Emergency Exit Door Lining Installation, TASK 52-22-51-400-801

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

EMERGENCY EXIT DOOR - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Emergency exit door removal

(2) Emergency exit door installation.

B. The removal and installation procedure is the same for each emergency exit door.

TASK 52-22-00-000-801

2. Emergency Exit Door Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the emergency exit door.

B. References

Reference	Title
25-21-20-000-801	Emergency Exit Doorway Lining Removal (P/B 401)

C. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

D. Emergency Exit Door Removal

SUBTASK 52-22-00-010-001

(1) Do this task: Emergency Exit Doorway Lining Removal, TASK 25-21-20-000-801.

SUBTASK 52-22-00-000-001

(2) Remove the emergency exit door [1] from outside the airplane:

WARNING KEEP PERSONS AND EQUIPMENT CLEAR OF THE UPPER SILL CUTOUT ABOVE THE DOOR. THE DOOR COMPONENTS MOVE QUICKLY WHEN YOU PULL THE DOOR HANDLE. IF YOU DO NOT OBEY THIS WARNING, INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT CAN OCCUR.

WARNING MAKE SURE THAT THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING-LOADED TO OPEN AUTOMATICALLY AND CAN CAUSE INJURY TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(a) Pull down on the door handle to open the emergency exit door [1].

(b) Let the emergency exit door [1] open fully.

(c) Remove the mechanism guard [41] from the fuselage structure:

1) Remove bolt [40] and washers [39] that hold the mechanism guard [41] in place.

(d) Remove the bonding jumper [15], bolt [13], washer [12], washer [16] and nut [17].

(e) Cut the wires to disconnect the electrical power from the door.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(f) Remove the snubber [3] from the door:

1) Remove the cotter pin [24], nut [25], washer [26], bushing [22], washer [20], and bolt [21] from the door hinge [11].

(g) Hold the door while you prepare to remove it at the door hinge [11].

(h) Remove the cotter pins [10].

(i) Remove the bolts [5], washers [6], bushings [7], washers [8], nuts [9], and bracket [14].

(j) Remove the counterbalances [4] from the door:

WARNING

REMOVE THE DOOR FROM THE FUSELAGE BEFORE THE COUNTERBALANCES ARE DISCONNECTED FROM THE DOOR HINGE. THE COUNTERBALANCES ARE SPRING LOADED. IF YOU DO NOT OBEY THIS WARNING, INJURY TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

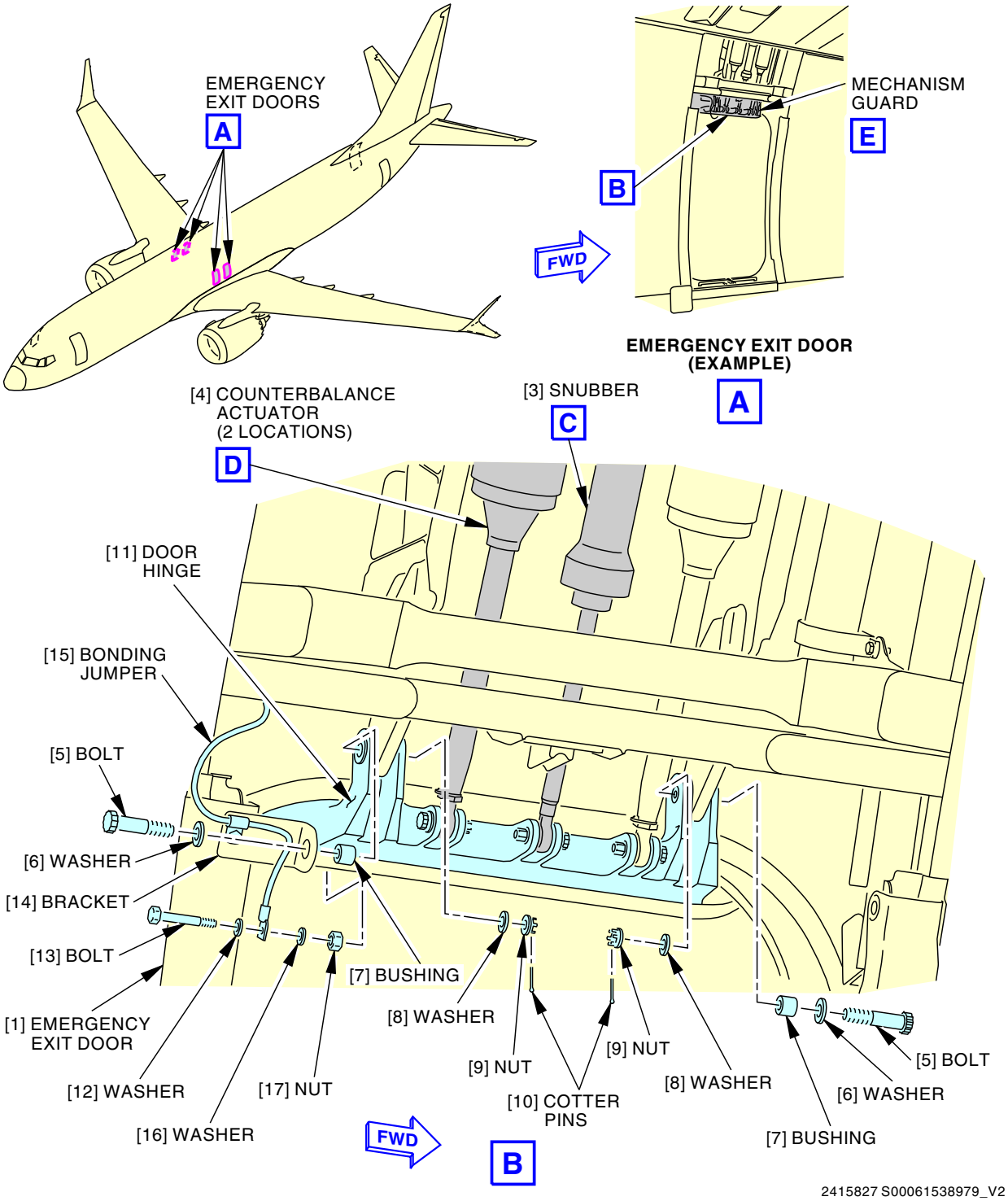
1) Remove cotter pins [30], nuts [32], washers [33], bushings [34], washers [35], and bolts [36].

(k) Remove the emergency exit door [1] from the opening.

(l) Move the emergency exit door [1] away from the structure.

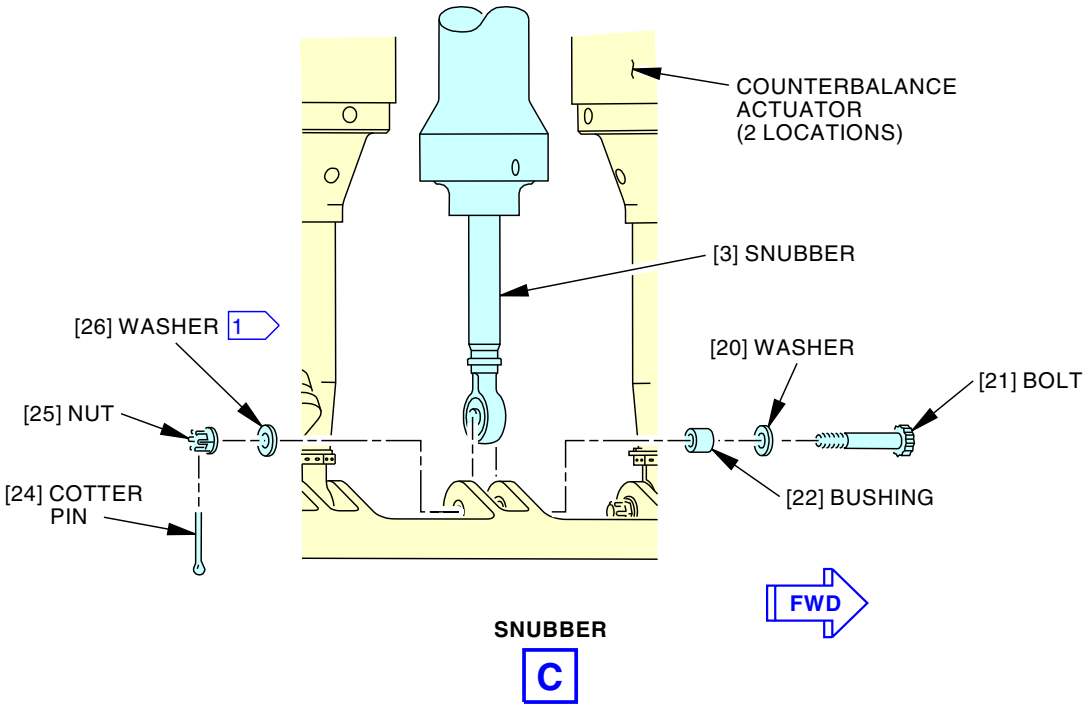
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



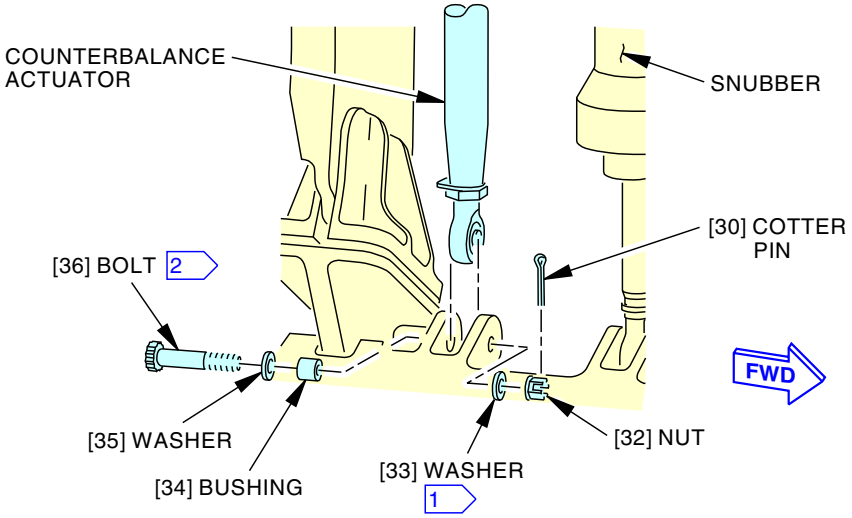
Emergency Exit Door Installation
Figure 401/52-22-00-990-809 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



SNUBBER

C



COUNTERBALANCE ACTUATORS (EXAMPLE)

D

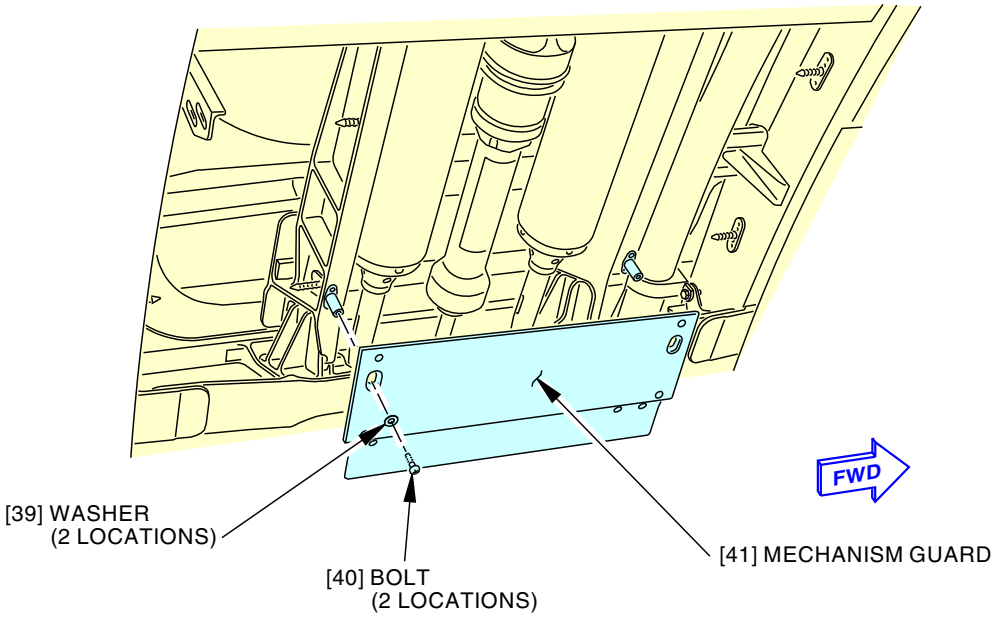
1 MAXIMUM OF 4 WASHERS

2 BOLT HEAD AND BUSHING ARE ON SAME SIDE

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Emergency Exit Door Installation
Figure 401/52-22-00-990-809 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



**MECHANISM GUARD
(EXAMPLE)**

E

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**Emergency Exit Door Installation
Figure 401/52-22-00-990-809 (Sheet 3 of 3)**

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-22-00-400-801

3. Emergency Exit Door Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the emergency exit door.

B. References

Reference	Title
25-21-20-400-801	Emergency Exit Doorway Lining Installation (P/B 401)
52-22-00-200-802	Emergency Exit Door Pressure Seal Check (P/B 601)
52-22-00-730-801	Emergency Exit Door System Test (P/B 501)
52-22-00-820-801	Emergency Exit Door Adjustment (P/B 501)

C. Consumable Materials

Reference	Description	Specification
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Emergency exit door	52-22-00-01-155	SIA ALL
		52-22-00-02-160	SIA ALL
10	Cotter pin	52-22-00-01-015	SIA ALL
		52-22-00-02-015	SIA ALL
24	Cotter pin	52-22-21-01-160	SIA ALL
30	Cotter pin	52-22-21-01-010	SIA ALL

E. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

F. Emergency Exit Door Installation

SUBTASK 52-22-00-420-001

(1) Inspect the pressure seal of the door prior to installation. Do this task: Emergency Exit Door Pressure Seal Check, TASK 52-22-00-200-802.

(a) Install the emergency exit door [1] in the opening:

(b) Hold the door horizontal and put it in the opening.

(c) Attach the counterbalance actuators to the emergency exit door [1]:

WARNING THE COUNTERBALANCES ARE SPRING LOADED. CONNECT THE COUNTERBALANCES TO THE DOOR HINGE BEFORE YOU INSTALL THE DOOR. IF YOU DO NOT OBEY THIS WARNING, DAMAGE TO EQUIPMENT OR INJURY TO PERSONS CAN OCCUR.

1) Install the bolts [36], washers [35], bushings [34], washers [33], and nuts [32].

2) Tighten the nuts [32] to 30 in-lb (3.39 N·m) - 50 in-lb (5.65 N·m).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3) Install the new cotter pins [30].

(d) Attach the snubber [3] to the emergency exit door [1]:

1) Install the bolt [21], washer [20], bushing [22], washer [26], and nut [25].

2) Tighten the nut [25] to 30 in-lb (3.39 N·m) - 50 in-lb (5.65 N·m).

3) Install the new cotter pin [24].

(e) Fit the door hinge [11] to the fuselage with the bolts [5], washers [6], bushings [7], bracket [14], washers [8], and nuts [9].

NOTE: Use a maximum of 4 washers [8] to get the cotter pin, nut alignment.

1) Make sure that the bracket [14] is on the aft door hinge.

(f) Tighten the nuts [9] to 160 in-lb (18 N·m) - 240 in-lb (27 N·m).

(g) Install the new cotter pins [10].

WARNING

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.

(h) Put Cor-Ban 27L Compound, G50237 on bolt [13].

(i) Install the bonding jumper [15], bolt [13], washer [12], washer [16], and nut [17].

(j) Splice the wires to connect the electrical power to the door.

(k) Install the mechanism guard [41] to the fuselage structure:

1) Install the bolt [40] and washers [39] that hold the mechanism guard [41] in its position.

SUBTASK 52-22-00-420-002

(2) Do this task: Emergency Exit Doorway Lining Installation, TASK 25-21-20-400-801.

SUBTASK 52-22-00-710-001

(3) Do this task: Emergency Exit Door Adjustment, TASK 52-22-00-820-801.

SUBTASK 52-22-00-820-001

(4) Do this task: Emergency Exit Door System Test, TASK 52-22-00-730-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

EMERGENCY EXIT DOOR - ADJUSTMENT/TEST

1. General

A. This procedure has these tasks:

(1) An operational test of an emergency exit door

(2) An operational test of the flight lock mechanical switch for the emergency exit door

(3) An operational test of the flight lock engagement for the emergency exit door

(4) An adjustment of an emergency exit door

(5) A system test of an emergency exit door.

B. The procedure is the same for each emergency exit door.

TASK 52-22-00-710-801

2. Emergency Exit Door Operational Test

(Figure 501)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

B. Prepare for the Operational Test

SUBTASK 52-22-00-860-004

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

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
C	1	C00523	HEATERS CAPT PITOT
D	5	C00525	HEATERS F/O PITOT
D	6	C00524	HEATERS AUX PITOT

C. Emergency Exit Door Operational Test

SUBTASK 52-22-00-710-002

(1) Do the operational test of the emergency exit door:

WARNING MAKE SURE THAT THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING-LOADED TO OPEN AUTOMATICALLY AND INJURIES COULD OCCUR.

(a) Pull down on the door handle to open the door.

1) Make sure that the door opens smoothly.

2) Make sure that the door smoothly moves out and up from the door opening.

3) Make sure that the snubber controls the speed of the door through the full open sequence.

4) Make sure that the door hinge arm latch is in the extended position.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

5) Make sure that the door hinge arm lock pawl is locked.

(b) Make sure that the door handle freely moves to the open position.

(c) Move the door into the fuselage opening.

1) Make sure that the handle is held in the open position.

2) Pull the door into the opening with the lifting strap.

3) Make sure that the door hinge lock pawl engages the lock pawl depressor and releases the door hinge.

4) Make sure that the door does not hit the rub strips on the lower stop tracks.

5) Make sure that the lock rollers smoothly engage the lock receivers.

(d) Release the door handle.

1) Make sure that the handle moves automatically to the closed position.

D. Put the Airplane Back to its Usual Condition

SUBTASK 52-22-00-860-005

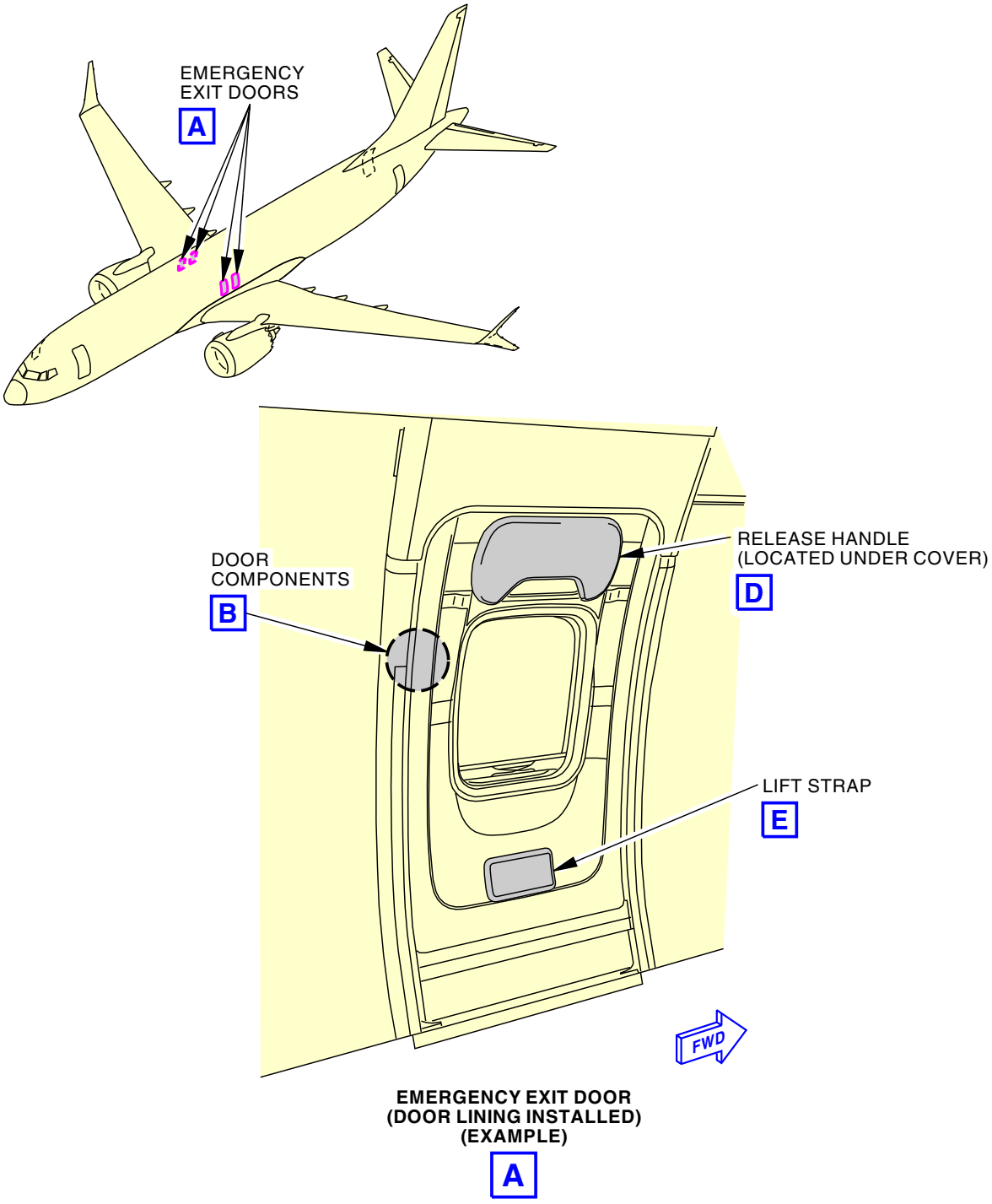
(1) Remove the safety tags and close these circuit breakers:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
C	1	C00523	HEATERS CAPT PITOT
D	5	C00525	HEATERS F/O PITOT
D	6	C00524	HEATERS AUX PITOT

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



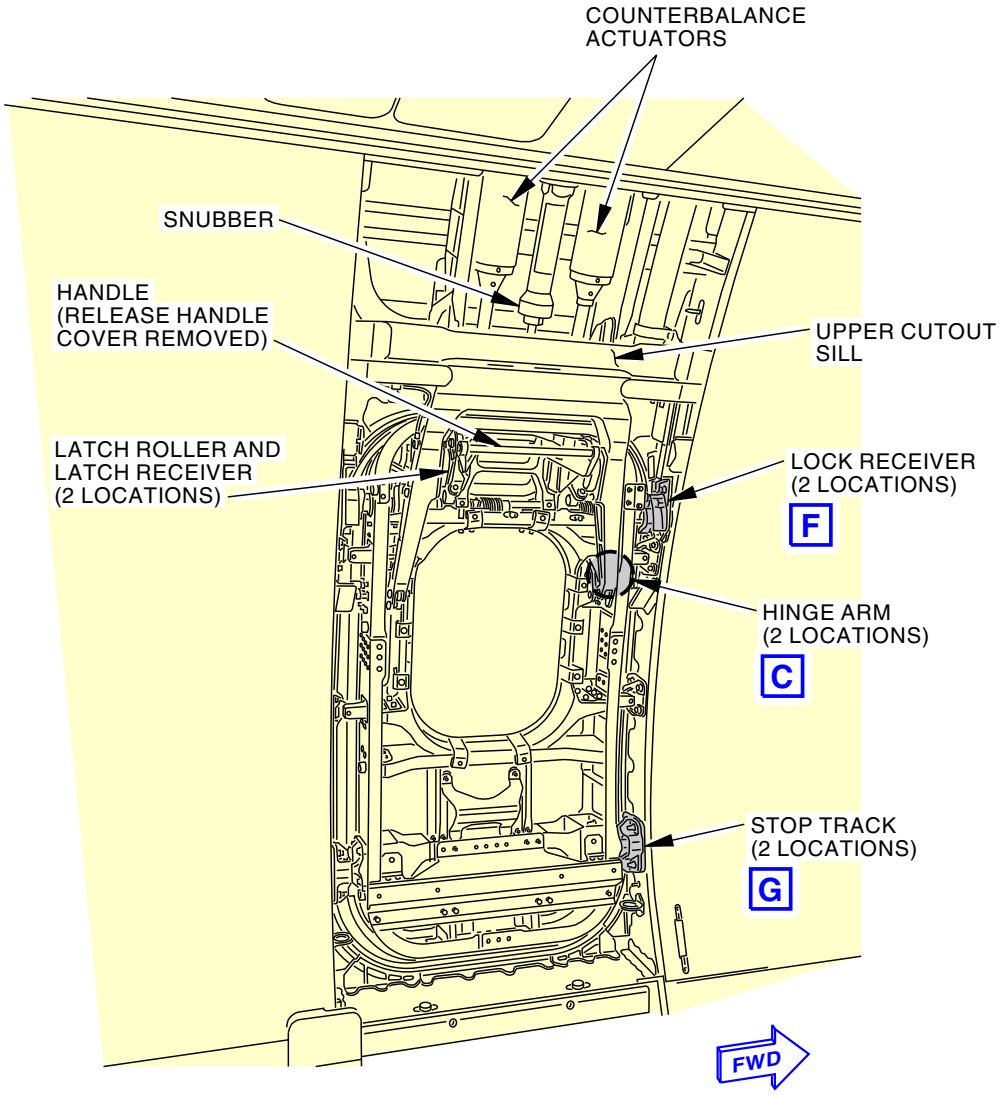
**EMERGENCY EXIT DOOR
(DOOR LINING INSTALLED)
(EXAMPLE)**

A

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**Emergency Exit Door - Operational Test
Figure 501/52-22-00-990-803 (Sheet 1 of 5)**

ECCN 9E991 BOEING PROPRIETARY - See title page for details



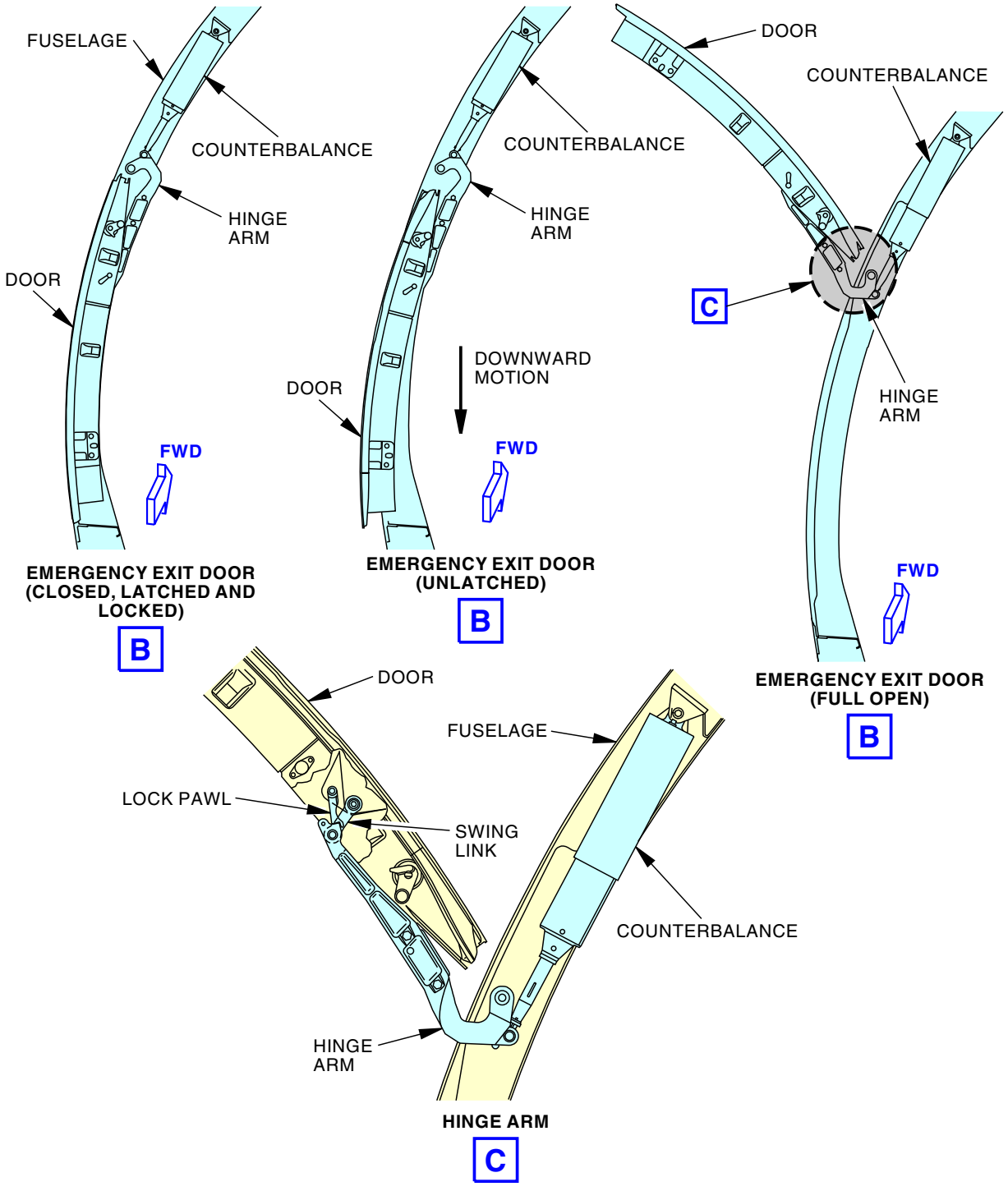
EMERGENCY EXIT DOOR (DOOR LINING REMOVED) (EXAMPLE)

A

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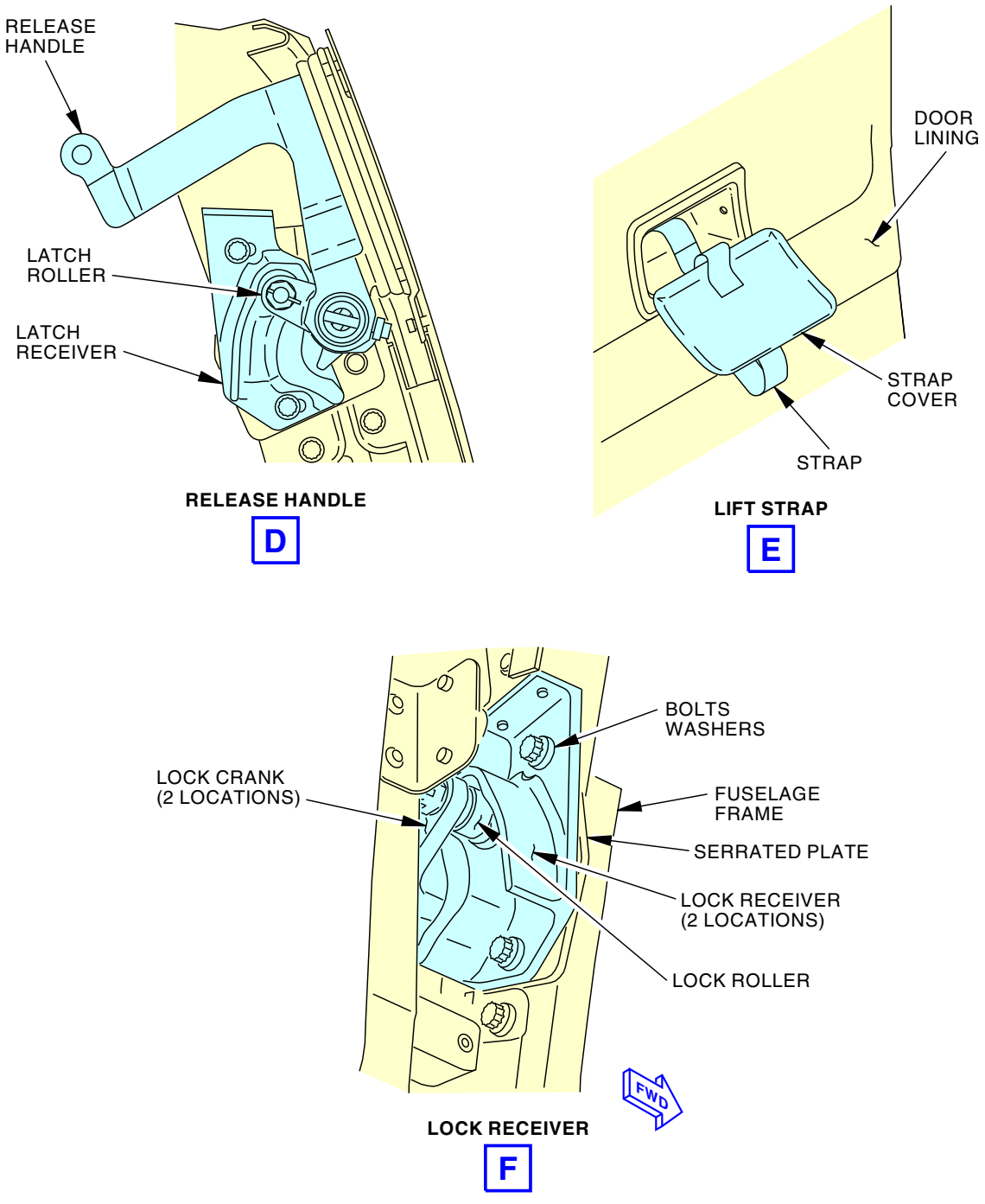
Emergency Exit Door - Operational Test
Figure 501/52-22-00-990-803 (Sheet 2 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Emergency Exit Door - Operational Test
Figure 501/52-22-00-990-803 (Sheet 3 of 5)

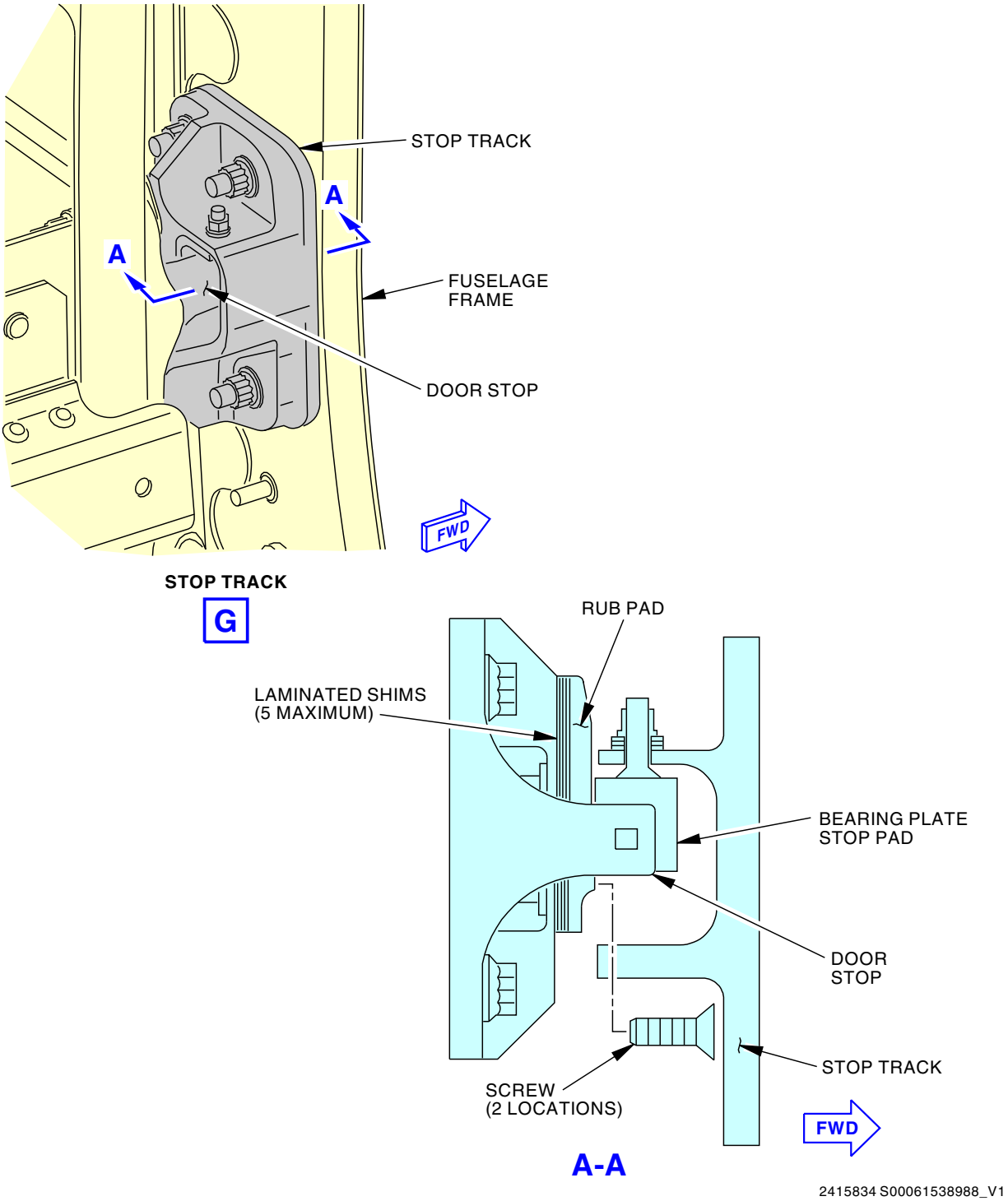
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Emergency Exit Door - Operational Test
Figure 501/52-22-00-990-803 (Sheet 4 of 5)

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Emergency Exit Door - Operational Test
Figure 501/52-22-00-990-803 (Sheet 5 of 5)

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TASK 52-22-00-710-802

3. Emergency Exit Door Flight Lock Mechanical Switch Operational Test

A. References

Reference	Title
36-00-00-860-806	Remove Pressure from the Pneumatic System (P/B 201)

B. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

C. Prepare for the Operational Test

SUBTASK 52-22-00-860-007

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

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
D	1	C01515	OVERWING FLIGHT LOCK-RIGHT
D	2	C01514	OVERWING FLIGHT LOCK-LEFT

SUBTASK 52-22-00-860-008

(2) Do these steps to simulate that the engines are in operation:

NOTE: These steps change the condition of the engine running relays to the engine in operation mode.

(a) Make sure that there is no pneumatic power to the engine starters.

1) If it is necessary, do this task: Remove Pressure from the Pneumatic System, TASK 36-00-00-860-806.

(b) Make sure that the two thrust levers, on the control stand, are in the idle position.

(c) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-2

Row	Col	Number	Name
A	1	C00458	ENGINE 1 IGNITION RIGHT
A	3	C00153	ENGINE 1 IGNITION LEFT

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
C	1	C00523	HEATERS CAPT PITOT
C	7	C01678	WEATHER RADAR RT RIGHT
D	5	C00525	HEATERS F/O PITOT
D	6	C00524	HEATERS AUX PITOT

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

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F/O Electrical System Panel, P6-2

Row	Col	Number	Name
D	4	C00459	ENGINE 2 IGNITION RIGHT
D	6	C00151	ENGINE 2 IGNITION LEFT

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
B	3	C00360	FUEL SPAR VALVE ENG 2
B	4	C00359	FUEL SPAR VALVE ENG 1

(d) Make sure that the two engine start switches, on the P5 forward panel, are in the OFF position.

(e) Put the two engine start levers, on the control stand, to the IDLE position for a minimum of 5 minutes.

WARNING MAKE SURE THAT THE ENGINES ARE NOT RUNNING. IF YOU DO NOT OBEY THIS WARNING, INJURY TO PERSONS OR DAMAGE TO THE EQUIPMENT CAN OCCUR.

(f) Make sure that 3 of the 4 entry/service doors are closed.

WARNING MAKE SURE THAT YOU OPEN THE CIRCUIT BREAKER FOR THE WEATHER RADAR SYSTEM. THE FORWARD MOVEMENT OF A THRUST LEVER CAN CAUSE THE AUTOMATIC OPERATION OF THE SYSTEM. THE OPERATION OF THIS SYSTEM CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT IN THE AREA OF THE NOSE RADOME.

(g) Push the two engine thrust levers fully forward.

D. Operational Test of the Flight Lock Mechanical Switch for the Emergency Exit Door

SUBTASK 52-22-00-710-003

(1) Do the operational test of the flight lock mechanical switch for each emergency exit door:

WARNING MAKE SURE THAT THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING-LOADED TO OPEN AUTOMATICALLY AND CAN CAUSE INJURY TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(a) Remove the emergency exit door handle cover.

(b) Pull down on the door handle.

NOTE: The emergency exit door handle rotation is limited to approximately 15 degrees when the emergency exit is locked.

(c) Make sure that the emergency exit is locked.

(d) Examine the door warning lights on the P5 forward overhead panel:

1) Make sure that the emergency exit light, on the P5 forward overhead panel, goes on when you pull the emergency exit door handle.

2) Move the door handle to the closed and locked position.

3) Make sure that the emergency exit light, on the P5 forward overhead panel, is off.

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(e) Examine the operation of the Engine Run Relays:

1) Open this circuit breaker:

CAPT Electrical System Panel, P18-2

Row	Col	Number	Name
B	3	C01312	ENGINE 1 RUN/PWR

2) Make sure that the emergency exit lights, on the P5 forward overhead panel, do not come on.

3) Pull down on the door handle.

NOTE: The emergency exit door handle rotation is limited to approximately 15 degrees when the emergency exit is locked.

4) Make sure that the emergency exit is locked.

a) Move the door handle to the closed and locked position.

5) Close this circuit breaker:

CAPT Electrical System Panel, P18-2

Row	Col	Number	Name
B	3	C01312	ENGINE 1 RUN/PWR

6) Make sure that the emergency exit lights, on the P5 forward overhead panel, are off.

7) Open this circuit breaker:

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
B	5	C01313	ENGINE 2 RUN/PWR

8) Make sure that the emergency exit lights, on the P5 forward overhead panel, do not come on.

9) Pull down on the door handle.

NOTE: The emergency exit door handle rotation is limited to approximately 15 degrees when the emergency exit is locked.

10) Make sure that the emergency exit is locked.

a) Move the door handle to the closed and locked position.

11) Close this circuit breaker:

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
B	5	C01313	ENGINE 2 RUN/PWR

(f) Make sure that the emergency exit door handle cover is correctly installed.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 52-22-00-860-009

(1) Pull the two engine thrust levers back to the idle position.

SUBTASK 52-22-00-860-010

(2) Put the two engine start levers to the CUTOFF position.

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SUBTASK 52-22-00-860-011

(3) Close these circuit breakers:

CAPT Electrical System Panel, P18-2

Row	Col	Number	Name
A	1	C00458	ENGINE 1 IGNITION RIGHT
A	3	C00153	ENGINE 1 IGNITION LEFT

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
C	1	C00523	HEATERS CAPT PITOT
C	7	C01678	WEATHER RADAR RT RIGHT
D	5	C00525	HEATERS F/O PITOT
D	6	C00524	HEATERS AUX PITOT

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
D	4	C00459	ENGINE 2 IGNITION RIGHT
D	6	C00151	ENGINE 2 IGNITION LEFT

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
B	3	C00360	FUEL SPAR VALVE ENG 2
B	4	C00359	FUEL SPAR VALVE ENG 1

END OF TASK

TASK 52-22-00-710-803

4. Emergency Exit Door Flight Lock Engagement Operational Test

(Figure 502)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
52-22-51-000-801	Emergency Exit Door Lining Removal (P/B 401)
52-22-51-400-801	Emergency Exit Door Lining Installation (P/B 401)

B. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Prepare for the Operational Test

SUBTASK 52-22-00-860-013

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

CAPT Electrical System Panel, P18-2

Row	Col	Number	Name
A	1	C00458	ENGINE 1 IGNITION RIGHT
A	3	C00153	ENGINE 1 IGNITION LEFT

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
C	1	C00523	HEATERS CAPT PITOT
C	7	C01678	WEATHER RADAR RT RIGHT
D	5	C00525	HEATERS F/O PITOT
D	6	C00524	HEATERS AUX PITOT

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
D	4	C00459	ENGINE 2 IGNITION RIGHT
D	6	C00151	ENGINE 2 IGNITION LEFT

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
B	3	C00360	FUEL SPAR VALVE ENG 2
B	4	C00359	FUEL SPAR VALVE ENG 1

SUBTASK 52-22-00-860-014

(2) Make sure that the two engine start switches, on the forward overhead panel, P5, are in the OFF position.

SUBTASK 52-22-00-860-015

(3) Make sure that 3 of the 4 entry/service doors are closed.

SUBTASK 52-22-00-860-016

(4) Make sure that all of the emergency exit door lights, on forward overhead panel, P5, are off.

SUBTASK 52-22-00-010-002

(5) Do this task: Emergency Exit Door Lining Removal, TASK 52-22-51-000-801.

D. Operational test of the Emergency Exit Door Flight Lock

SUBTASK 52-22-00-710-004

(1) Do an operational test of the flight lock for the emergency exit door:

(a) Make sure that the emergency exit doors are closed, latched and locked.

(b) Do these steps to energize the flight lock solenoid:

1) Put the two engine start levers to the IDLE position for a minimum of 5 minutes.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WARNING

MAKE SURE THAT YOU OPEN THE CIRCUIT BREAKER FOR THE WEATHER RADAR SYSTEM. THE FORWARD MOVEMENT OF A THRUST LEVER CAN CAUSE THE AUTOMATIC OPERATION OF THE SYSTEM. THE OPERATION OF THIS SYSTEM CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT IN THE AREA OF THE NOSE RADOME.

2) Push the two engine thrust levers fully forward.

3) Pull down on the door handle.

4) Make sure that the flight lock pawl is fully engaged with the torque tube.

5) Make sure that the emergency exit door lights, on forward overhead panel, P5, are off.

(c) Do these steps to de-energize the flight lock solenoid:

1) Pull the two engine thrust lever to idle position.

2) Pull the two engine start levers back to CUTOFF position.

3) Make sure that the flight lock pawl is not engaged with the torque tube.

4) Make sure that the emergency exit door lights, on the forward overhead panel, P5, are off.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 52-22-00-860-017

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

CAPT Electrical System Panel, P18-2

Row	Col	Number	Name
A	1	C00458	ENGINE 1 IGNITION RIGHT
A	3	C00153	ENGINE 1 IGNITION LEFT

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
C	1	C00523	HEATERS CAPT PITOT
C	7	C01678	WEATHER RADAR RT RIGHT
D	5	C00525	HEATERS F/O PITOT
D	6	C00524	HEATERS AUX PITOT

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
D	4	C00459	ENGINE 2 IGNITION RIGHT
D	6	C00151	ENGINE 2 IGNITION LEFT

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
B	3	C00360	FUEL SPAR VALVE ENG 2

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(Continued)

F/O Electrical System Panel, P6-3

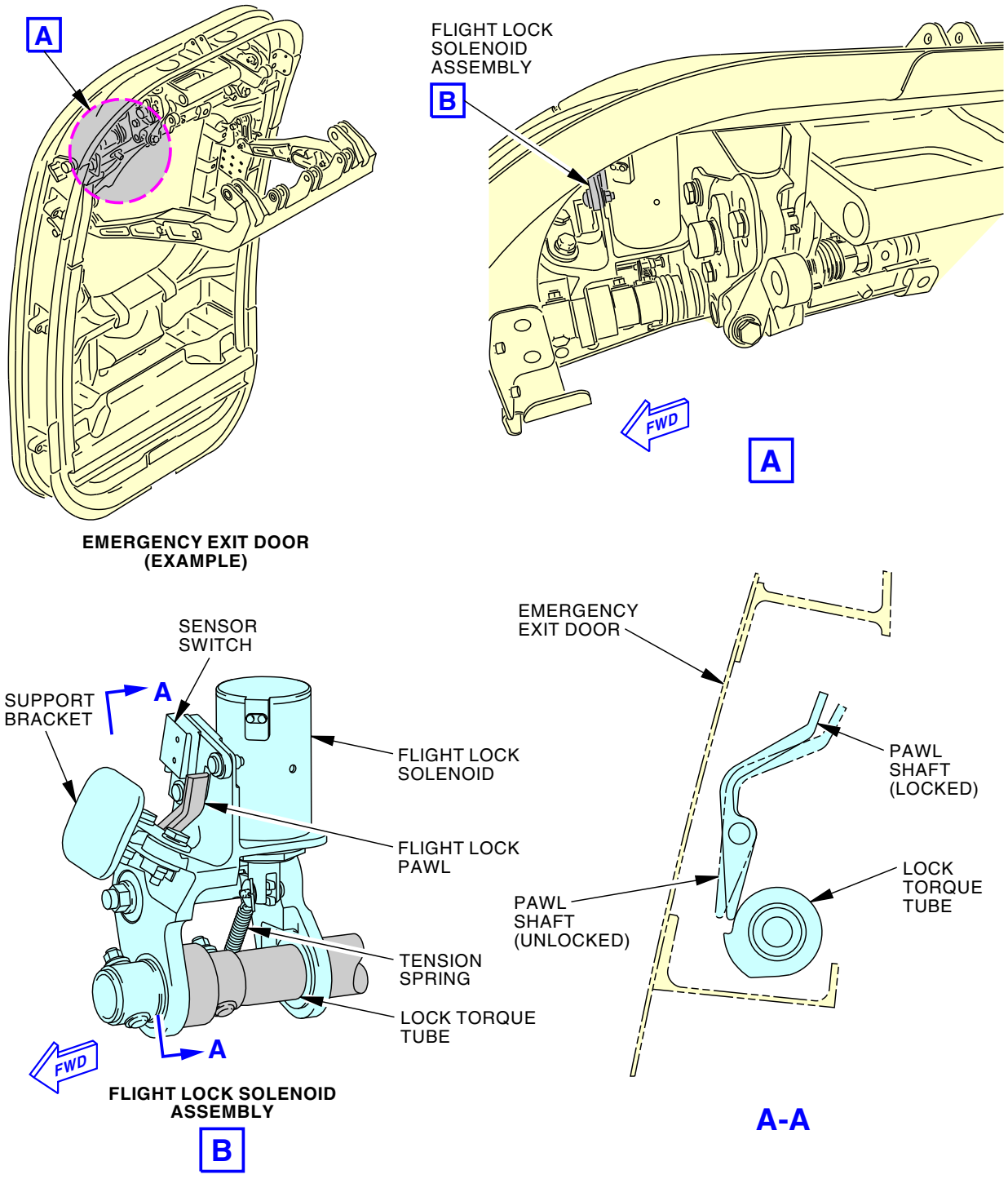
Row	Col	Number	Name
B	4	C00359	FUEL SPAR VALVE ENG 1

SUBTASK 52-22-00-410-001

(2) Do this task: Emergency Exit Door Lining Installation, TASK 52-22-51-400-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Emergency Exit Door Flight Lock Engagement Operational Test
Figure 502/52-22-00-990-804

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-22-00-820-801

5. Emergency Exit Door Adjustment

(Figure 503, Figure 504, Figure 505)

A. General

(1) Do the procedure with the airplane on its landing gear.

(2) The Emergency Exit Door System Test must be completed after any adjustment is made to the door.

B. References

Reference	Title
52-22-51-000-801	Emergency Exit Door Lining Removal (P/B 401)
52-22-51-400-801	Emergency Exit Door Lining Installation (P/B 401)

C. Consumable Materials

Reference	Description	Specification
G01912	Lockwire - MS20995NC32, Monel - 0.032 Inch (0.8128 mm) Diameter	NASM20995
G02020	Clay, Modeling	
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38

D. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

E. Prepare for the Initial Adjustment

SUBTASK 52-22-00-020-001

CAUTION DO NOT OPERATE THE DOOR WITHOUT THE SNUBBER CORRECTLY INSTALLED. IF YOU DO NOT INSTALL THE SNUBBER, THE DOOR CAN OPEN TOO FAST AND CAUSE DAMAGE TO THE DOOR HINGE.

(1) Disconnect the snubber rod end from the door as follows:

(a) Remove cotter pin, nut, washer, bushing, washer and bolt from the door hinge.

SUBTASK 52-22-00-000-002

WARNING REMOVE THE DOOR FROM THE FUSELAGE BEFORE THE COUNTERBALANCES ARE DISCONNECTED FROM THE DOOR HINGE. THE COUNTERBALANCES ARE SPRING LOADED. IF YOU DO NOT OBEY THIS WARNING, INJURY TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

(2) Disconnect the counterbalance actuators from the door.

(a) Remove cotter pins, nuts, washers, bushings, washers, and bolts.

SUBTASK 52-22-00-010-003

(3) Do this task: Emergency Exit Door Lining Removal, TASK 52-22-51-000-801.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

F. Initial Adjustment

SUBTASK 52-22-00-820-002

(1) Do the stop pins adjustment (Figure 503):

(a) Make sure that the door is closed, locked, and has the correct flushness.

(b) Measure the clearance between the stop pins and the stop pads on the forward and aft sides of the door.

(c) If it is necessary, adjust the clearance as follows:

1) Open the door.

2) Remove the nuts on the stop pins.

3) Put one countersunk washer under each stop pin head (Figure 503).

4) Close and lock the door.

5) Push the stop pins into the fuselage stop fittings.

6) Measure and record the clearances between the heads of the stop pins and the countersunk washers you installed.

7) Open the door.

8) Install washers with a thickness equal to the clearance you recorded under the heads of the stop pins.

9) Install and the nuts and washers to hold the stop pins.

10) Tighten the nuts to 50 in-lb (6 N·m) - 80 in-lb (9 N·m).

SUBTASK 52-22-00-820-003

(2) Do the initial lock receiver adjustment:

(a) Close the door.

(b) Make sure that the door is flush with the fuselage.

(c) Make sure that the clearance between the lock roller and the lock receiver is from 0.09 in. (2.29 mm) to 0.21 in. (5.33 mm) (Figure 503).

(d) If it is necessary, adjust as follows:

1) Do the initial adjustment as follows:

a) Open the door.

b) Loosen the bolts and washers that attach the lock receivers to the fuselage frame (Figure 503).

c) Close the door.

d) Push the door against the stop fittings.

e) Move the lock receivers inboard on their serrated plates until they touch the lock rollers.

f) Move the lock receivers back to the nearest serration.

g) Open the door.

h) Tighten the bolts and washers to attach the lock receivers to the fuselage frame.

i) Close the door.

j) Move the door handle from the lock to unlock position.

k) Make sure that the lock roller moves freely.

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SUBTASK 52-22-00-820-004

(3) Do the flushness adjustment:

(a) Close and lock the door.

(b) As a minimum, measure the flushness between the door skin and the fuselage skin, along the edge of the door at the locations that follow:

NOTE: Make additional measurements as required.

1) Within 1 in. (25 mm) of each stop fitting along the forward and aft edges of the door.

2) Along the upper and lower edges of the door adjacent to the tangent points at the door corners.

(c) Make sure that the flushness is from -0.03 in. (-0.76 mm) to -0.12 in. (-3.05 mm) (Figure 505).

(d) If it is necessary, adjust as follows:

1) Adjust the flushness of the door in the sequence specified:

NOTE: It may be necessary to do the Lock Receiver Adjustment to get the door flushness.

2) Adjust the door flushness at the bottom edge as follows (Figure 505):

a) Open the door.

b) Loosen the nuts and washers that attach the lower stop track fitting.

c) Close the door.

d) Move the lower stop fitting inboard or outboard to get the correct door flushness at bottom.

e) Open the door.

f) Tighten the bolts and washers that attach the lower stop fitting.

3) Adjust the door flushness at the top edge as follows:

a) Close the door.

b) Make sure that the bottom door edge has correct adjustment.

c) Measure that the top edge of door misfair at the upper door stop fittings.

d) Open the door.

e) Adjust the washers under the stop pin heads to get the correct alignment.

4) Adjust the door flushness at the center edges as follows:

a) Close the door.

b) Measure the center edges of door misfair at the forward and aft center door stop fittings.

c) Open the door.

d) Adjust washers under stop pin heads to get the correct fair. The correct clearance between the stop pin and fuselage stop is 0 in. (0 mm) - 0.016 in. (0.406 mm).

NOTE: Look at the top and bottom door edges for correct fair.

SUBTASK 52-22-00-820-005

(4) Do the lock roller adjustment:

(a) Close and lock the door.

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(b) Make sure that the distance the lock rollers engage in the lock receivers is from 0.45 in. (11.43 mm) to 0.55 in. (13.97 mm) (Figure 503).

(c) If it is necessary, adjust as follows:

1) Open the door.

2) Remove the nuts, adjustment washers and cotter pins from the lock roller.

3) Add or remove adjustment washers under the lock roller to increase or decrease the roller depth in the lock receiver.

4) Install the nuts, adjustment washers, and cotter pins.

5) If more adjustment is necessary, adjust as follows:

CAUTION

YOU MUST HOLD THE TORQUE TUBE. THE LOCK TORQUE TUBE IS A SPRING LOADED ASSEMBLY. IF YOU DO NOT HOLD THE TORQUE TUBE, THE FORCE IN THE SPRINGS WILL CAUSE THEM TO MOVE OUT OF POSITION. DAMAGE TO THE EQUIPMENT CAN OCCUR.

a) Remove the bolts, washers and nuts that attach the lock crank to the lock torque tube (Figure 503).

b) Remove the lock crank from the torque tube.

c) Move adjustment spacers from one end of the lock torque tube to the opposite end to change the distance the lock roller engages in the lock receiver on one end of the lock torque tube.

d) Make sure that the lock roller and lock torque tube end play is 0.02 in. (0.51 mm) maximum.

e) Install the lock crank in the lock torque tube.

f) Install the bolts, washers and nuts to attach the lock crank to the lock torque tube (Figure 503).

SUBTASK 52-22-00-820-006

(5) Do the door vertical stop pin alignment adjustment:

(a) Measure that the up and down stop pin alignment as follows:

1) Open the door.

2) Put a small quantity of clay, G02020, on the stop pads.

3) Close the door.

(b) Make sure that the stop pins align with the stop pads (Figure 503).

(c) If it is necessary, adjust as follows:

1) Close and lock the door.

2) Remove the lockwire from the adjustment screws located on the forward and aft door intercostal.

3) Loosen the latch roller plate bolts.

4) Make sure that the bottom of the latch roller is contacting the latch track.

5) Use the two adjustment screws to move the door up or down.

NOTE: Each turn of adjustment screw is 0.02 in. (0.51 mm).

a) To raise the door, turn both adjustment screws counterclockwise.

b) To lower the door, turn both adjustment screws clockwise.

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c) To tilt the door forward or aft, turn one adjustment screw clockwise and the opposite adjustment screw counterclockwise.

6) Tighten the latch roller plate bolts.

7) Install the MS20995NC32 lockwire, G01912.

8) Remove the clay, G02020, from the door stops and pins.

(d) If adjustment was not necessary, do as follows:

1) Make sure that the lockwire is attached to the adjustment screws located on the forward and aft door intercostal.

2) If necessary, install the MS20995NC32 lockwire, G01912.

SUBTASK 52-22-00-820-007

(6) Do the door horizontal stop pin alignment adjustment:

(a) Measure the forward and aft stop pin alignment as follows: plate.

1) Open the door.

2) Put a small quantity of clay, G02020, on the stop pads.

3) Close the door.

4) Open the door.

5) Make sure that the stop pins align with the stop pads (Figure 503).

6) If it is necessary adjust as follows:

a) Remove the bolts, washers, and nuts that attach the latch receiver to the hinge arm.

b) Install a new laminated shim or remove laminations from the shim under the latch receiver to get the correct clearance.

WARNING 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.

c) Apply Cor-Ban 27L Compound, G50237, to bare laminations.

d) Install bolts, washers, and nuts that attach the latch receiver.

7) Remove the clay, G02020, from the stop pads and pins.

SUBTASK 52-22-00-000-003

(7) Do the lower rub pad adjustment:

(a) Close the door.

(b) Measure the clearance between the rub pad and the centering block as shown, (Figure 503).

(c) Make sure that the clearance is as specified.

(d) If it is necessary, adjust as follows:

1) Open the door.

2) Remove the bolts, nuts, and washers that attach the rub pad to the door.

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3) Remove the screws that attach the rub pad and laminated shims to the bracket.

4) Install a new laminated shim or remove laminations from the shims under the rub pad to get correct clearance.

WARNING 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.

5) Apply Cor-Ban 27L Compound, G50237, to bare laminations.

6) Install the screws that attach the rub pad and laminated shim to the bracket.

7) Install the bolts, nuts, and washers that attach the rub pad to the door.

G. Prepare for the Final Adjustment

SUBTASK 52-22-00-410-002

CAUTION DO NOT OPERATE THE DOOR WITHOUT THE SNUBBER CORRECTLY INSTALLED. IF YOU DO NOT INSTALL THE SNUBBER, THE DOOR CAN OPEN TOO FAST AND CAUSE DAMAGE TO THE DOOR HINGE.

(1) Connect the snubber rod end to the door:

(a) Install bolt, washer, bushing, washer, nut, and new cotter pin.

(b) Tighten the nut to 30 in-lb (3.4 N·m) - 50 in-lb (5.6 N·m).

SUBTASK 52-22-00-410-003

WARNING THE COUNTERBALANCES ARE SPRING LOADED. CONNECT THE COUNTERBALANCES TO THE DOOR HINGE BEFORE YOU INSTALL THE DOOR. IF YOU DO NOT OBEY THIS WARNING, DAMAGE TO EQUIPMENT OR INJURY TO PERSONS CAN OCCUR.

(2) Connect the counterbalance actuators to the door:

(a) Install bolts, washers, bushings, washers, nuts, and install new cotter pins.

(b) Tighten the nut to 30 in-lb (3.4 N·m) - 50 in-lb (5.6 N·m).

H. Final Adjustment

SUBTASK 52-22-00-010-004

WARNING MAKE SURE THAT THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING-LOADED TO OPEN AUTOMATICALLY AND INJURIES COULD OCCUR.

(1) Fully open the door.

SUBTASK 52-22-00-220-001

(2) Measure the distance from the top edge of the door to the fuselage (Figure 503).

SUBTASK 52-22-00-220-002

(3) Make sure that the limits are as specified.

SUBTASK 52-22-00-820-008

(4) If it is necessary, adjust the counterbalance actuator as follows:

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(a) Disconnect the snubber.

(b) Remove the lockwire on the jamnuts.

(c) Loosen the jamnut.

(d) Adjust rod end to get correct clearance.

(e) Tighten jamnut.

(f) Install the MS20995NC32 lockwire, G01912.

SUBTASK 52-22-00-820-009

(5) Skin Clearance Adjustment (Figure 504):

WARNING MAKE SURE THAT THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING-LOADED TO OPEN AUTOMATICALLY AND INJURIES COULD OCCUR.

(a) Open the door.

(b) Put a small quantity of clay, G02020, on the stop pads.

(c) Close the door.

(d) Make sure that the stop pins are centered on the stop pads in the target area (Figure 503).

(e) If it is necessary, adjust as follows:

1) Do the door vertical stop pin alignment adjustment to get the correct skin clearance.

2) Do the door horizontal stop pin alignment adjustment to get the correct skin clearance.

SUBTASK 52-22-00-820-010

(6) Do the final lock receiver adjustment (Figure 503):

(a) Make sure that the door is closed and locked.

(b) Push on the door handle until the handle seal is compressed.

(c) Make sure that the handle touches the door pressure stop contact surface.

(d) Measure the clearance between the lock rollers and lock receivers.

(e) If it is necessary, adjust as follows:

WARNING MAKE SURE THAT THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING-LOADED TO OPEN AUTOMATICALLY AND INJURIES COULD OCCUR.

1) Open the door.

2) Loosen the bolts that attach the lock receivers to the fuselage frame.

3) Move the lock receivers on their serrated plates to get the correct clearance.

4) Tighten the bolts that attach lock receivers to the fuselage frame.

5) Close the door.

6) Move the door handle from the lock to unlock position.

7) Make sure that the lock rollers move freely.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

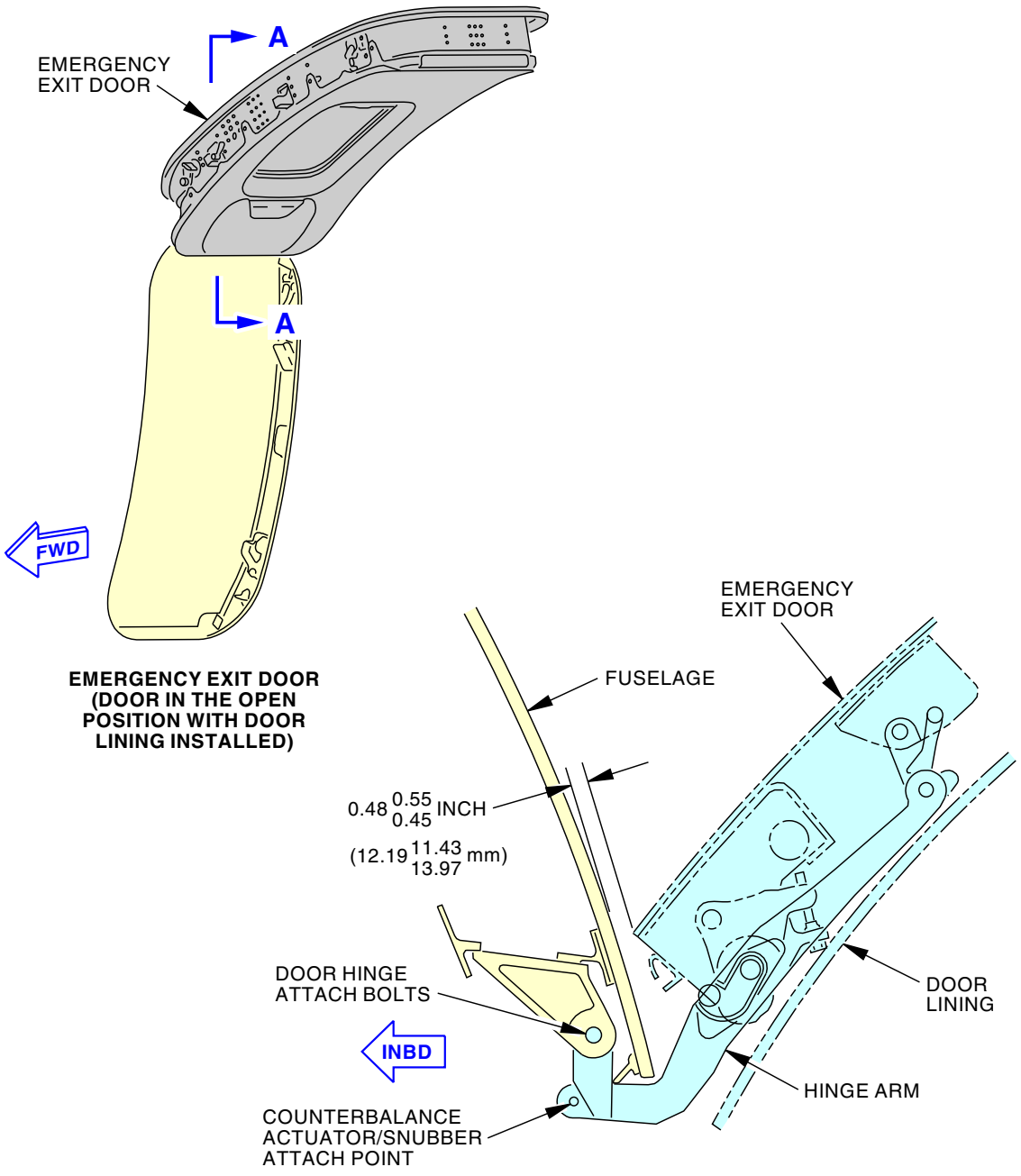
I. Put the Airplane Back to its Usual Condition

SUBTASK 52-22-00-410-004

(1) Do this task: Emergency Exit Door Lining Installation, TASK 52-22-51-400-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



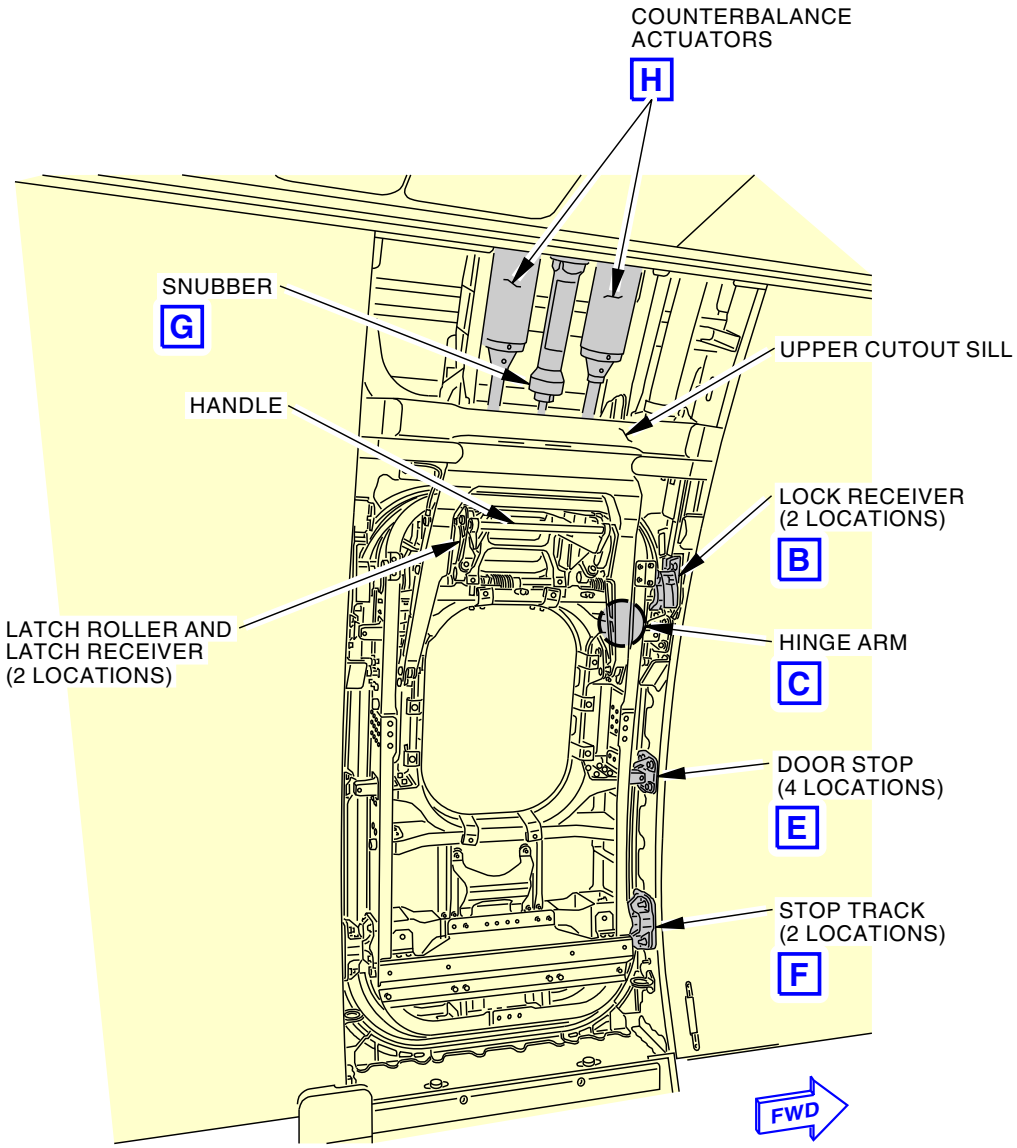
NOTE:

DIMENSION STANDARD: NOMINAL UPPER LIMIT / LOWER LIMIT

2415836 S00061538993_V1

Emergency Exit Door - Adjustment
Figure 503/52-22-00-990-805 (Sheet 1 of 8)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

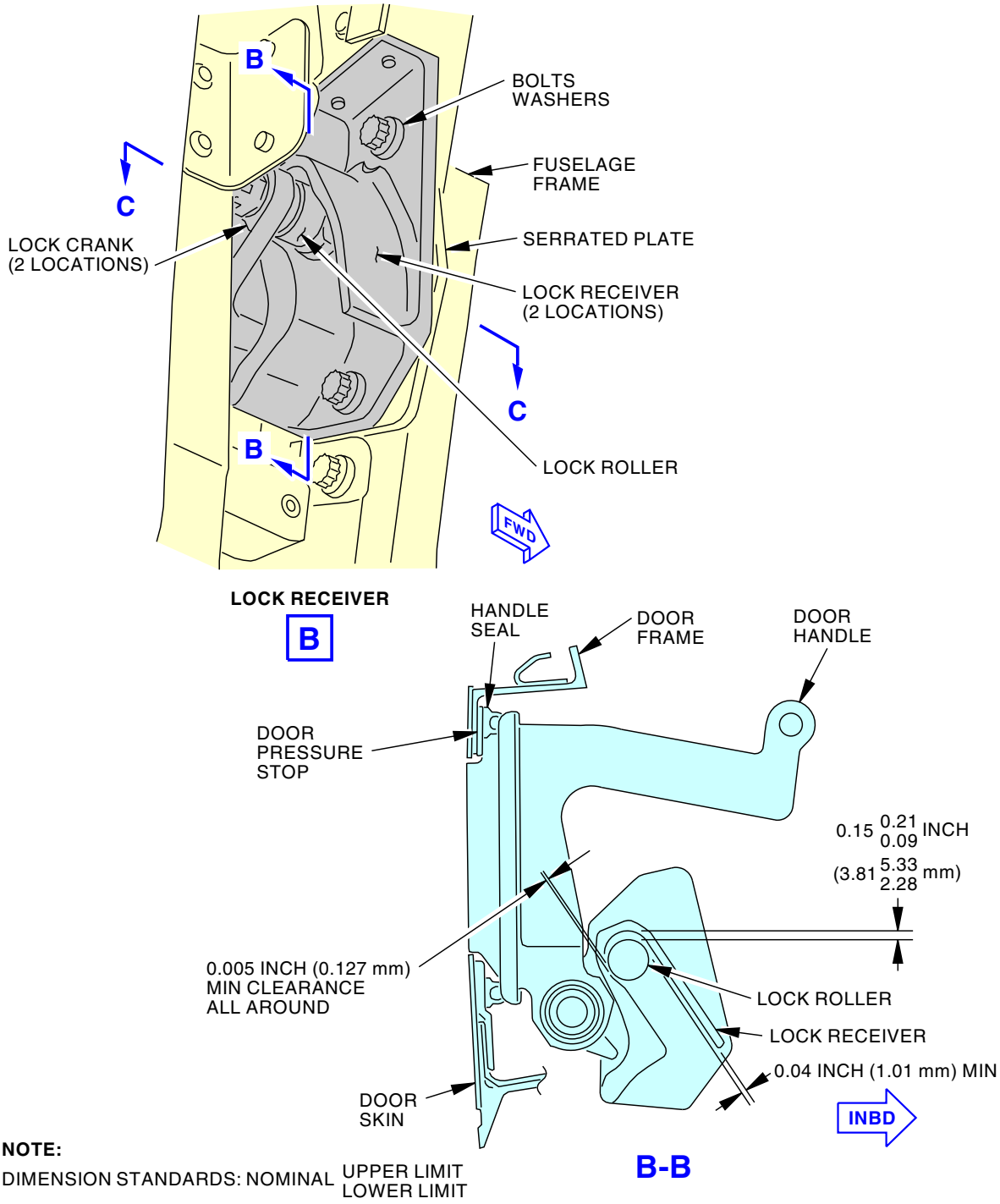


**EMERGENCY EXIT DOOR
(DOOR IN THE CLOSED POSITION
WITH DOOR LINING REMOVED)
(EXAMPLE)**

2415837 S00061538994_V1

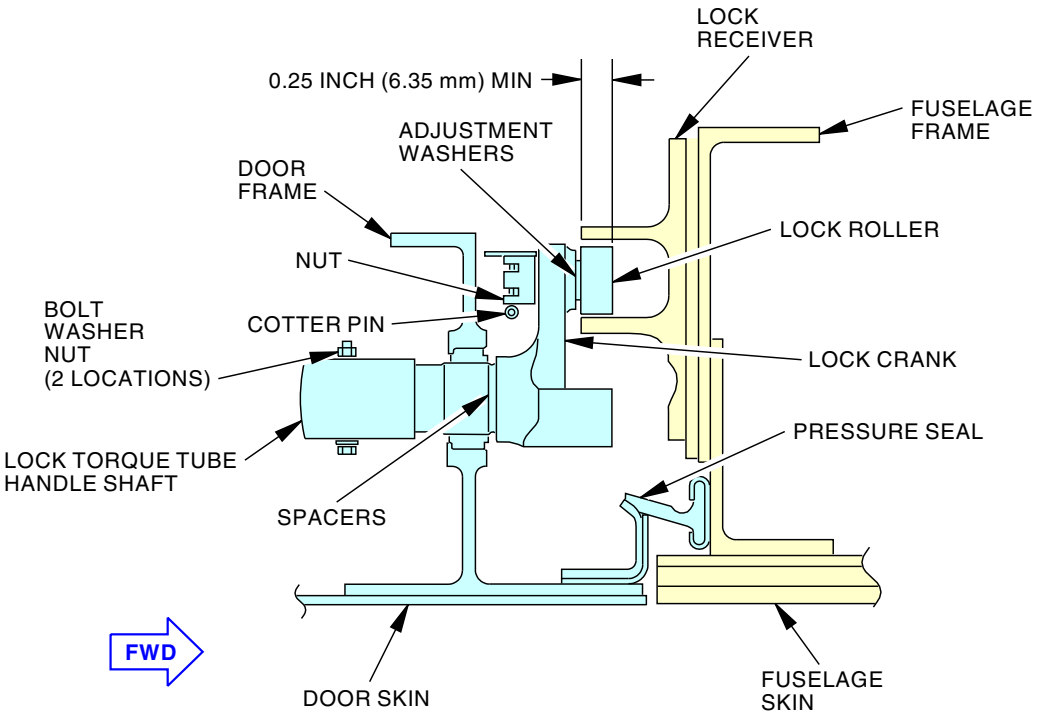
**Emergency Exit Door - Adjustment
Figure 503/52-22-00-990-805 (Sheet 2 of 8)**

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Emergency Exit Door - Adjustment
Figure 503/52-22-00-990-805 (Sheet 3 of 8)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

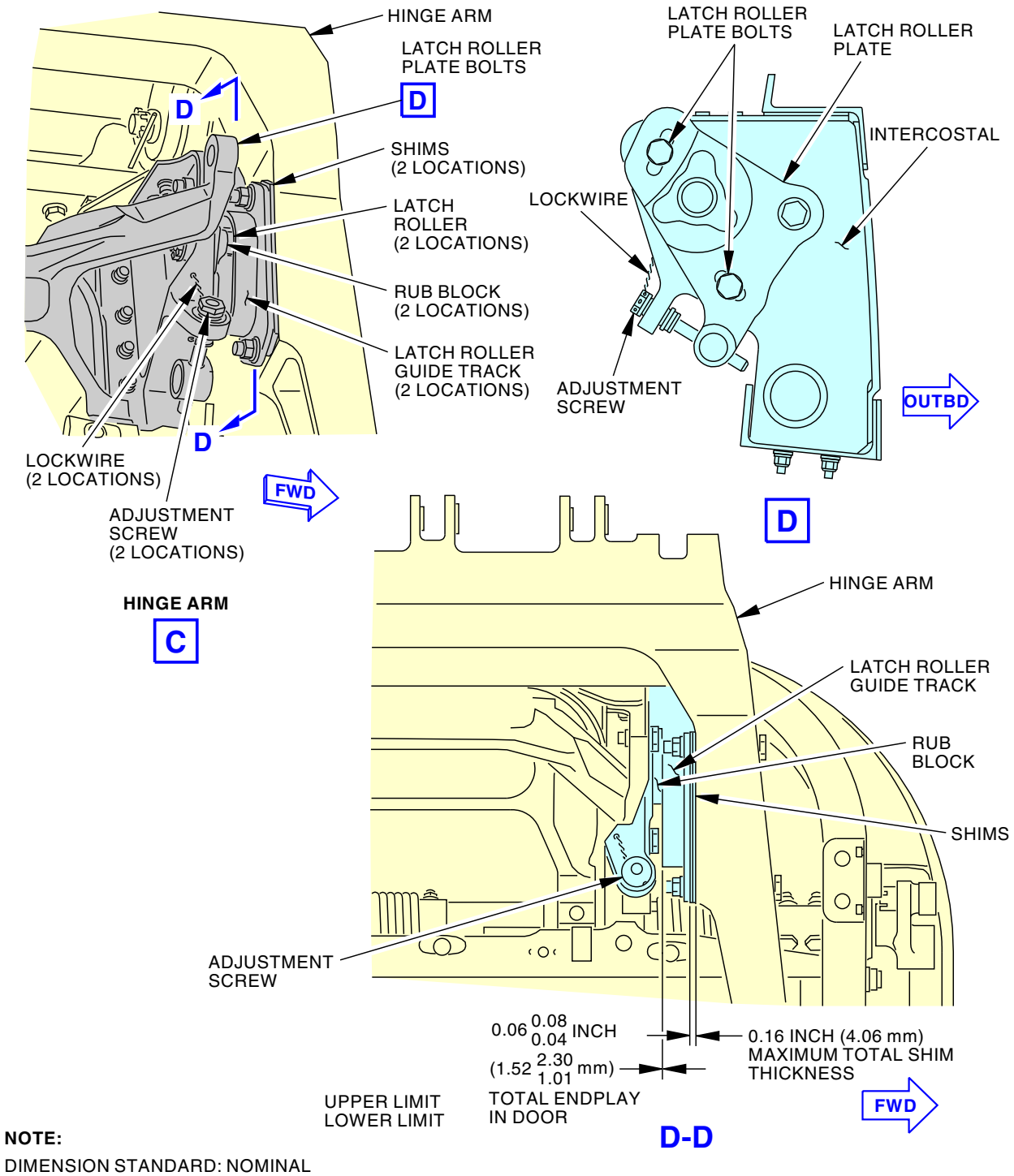


C-C

2415839 S00061538996_V1

Emergency Exit Door - Adjustment
Figure 503/52-22-00-990-805 (Sheet 4 of 8)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



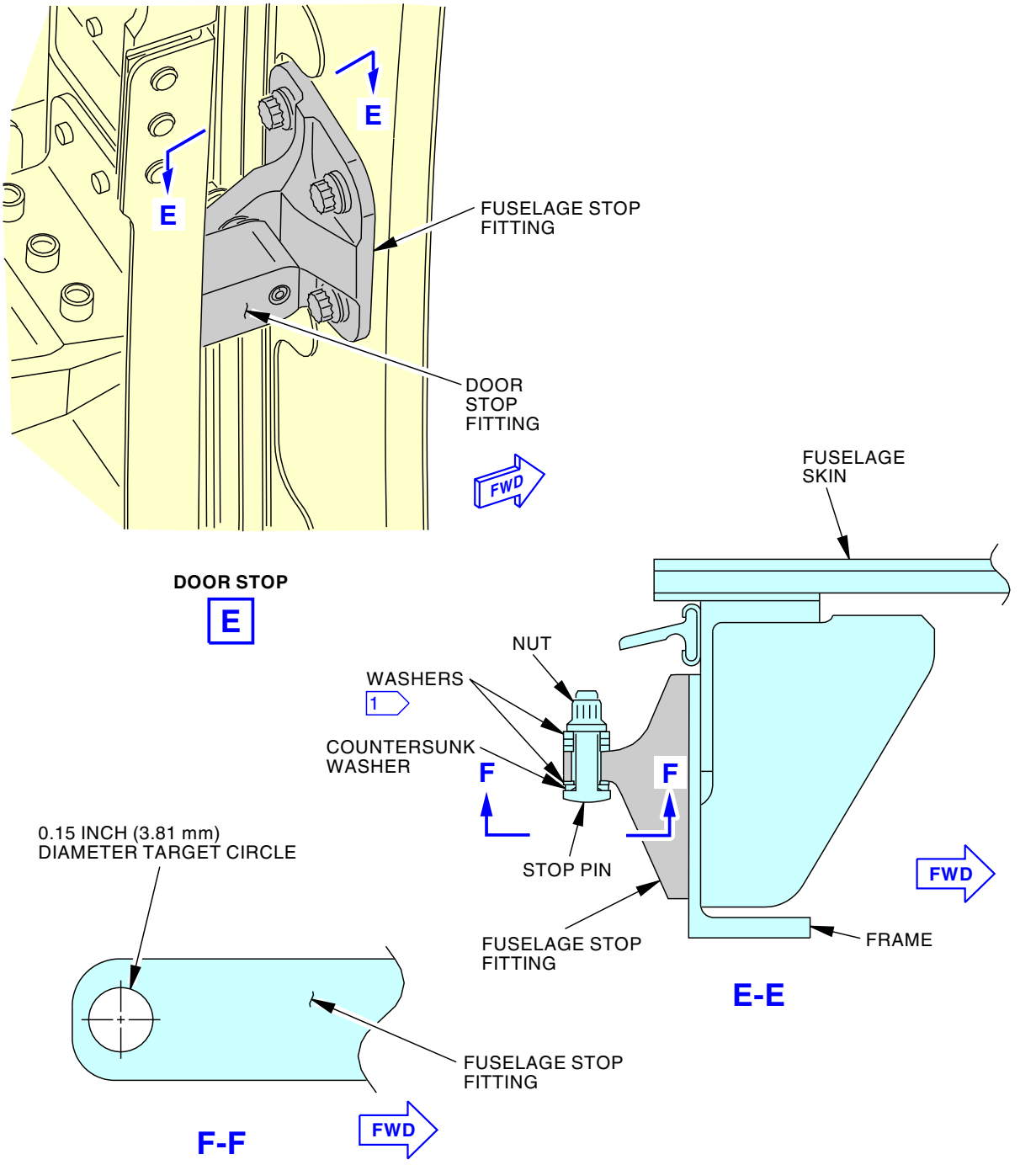
NOTE:

DIMENSION STANDARD: NOMINAL

2415840 S00061538997_V1

Emergency Exit Door - Adjustment
Figure 503/52-22-00-990-805 (Sheet 5 of 8)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

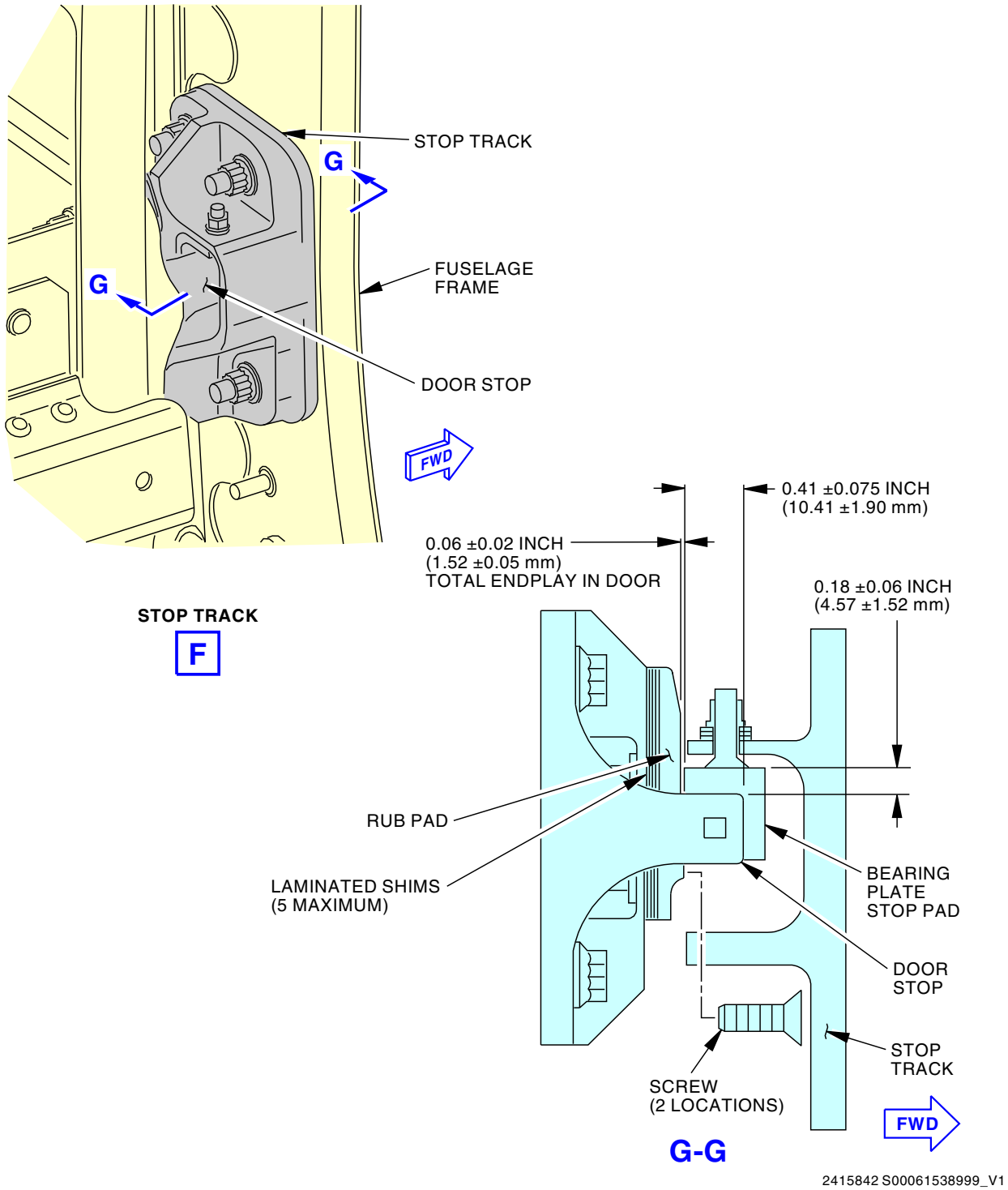


1 ADD WASHER AS NECESSARY TO GET THE CORRECT CLEARANCE BETWEEN THE STOP PIN AND FUSELAGE STOP FITTING.

2415841 S00061538998_V1

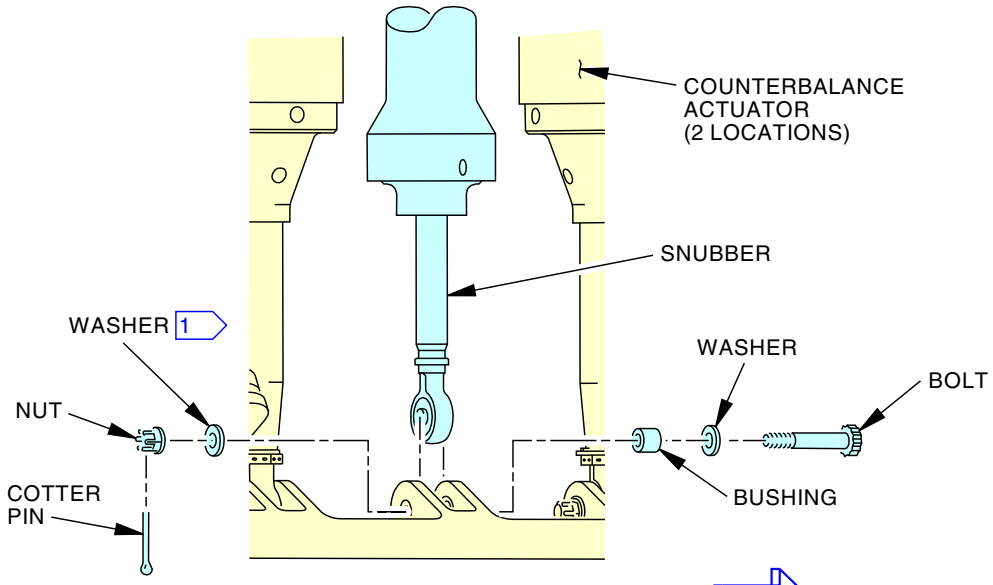
Emergency Exit Door - Adjustment
Figure 503/52-22-00-990-805 (Sheet 6 of 8)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



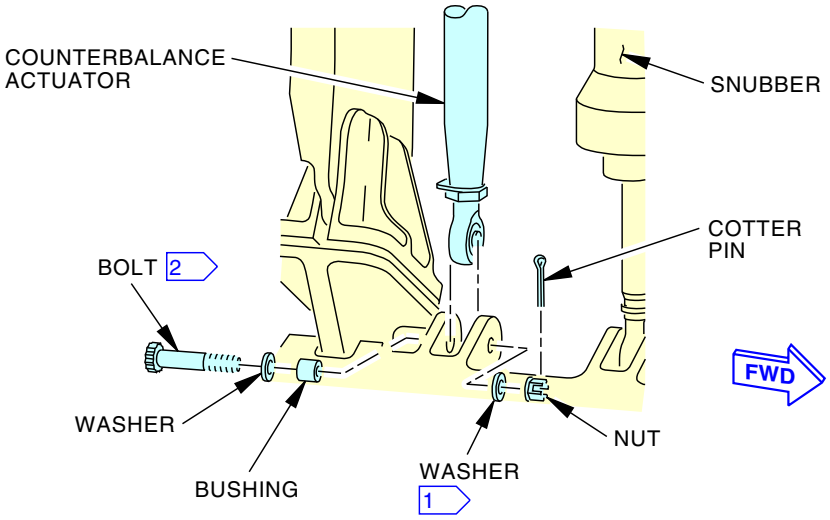
Emergency Exit Door - Adjustment
Figure 503/52-22-00-990-805 (Sheet 7 of 8)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



SNUBBER

G



COUNTERBALANCE ACTUATORS (EXAMPLE)

H

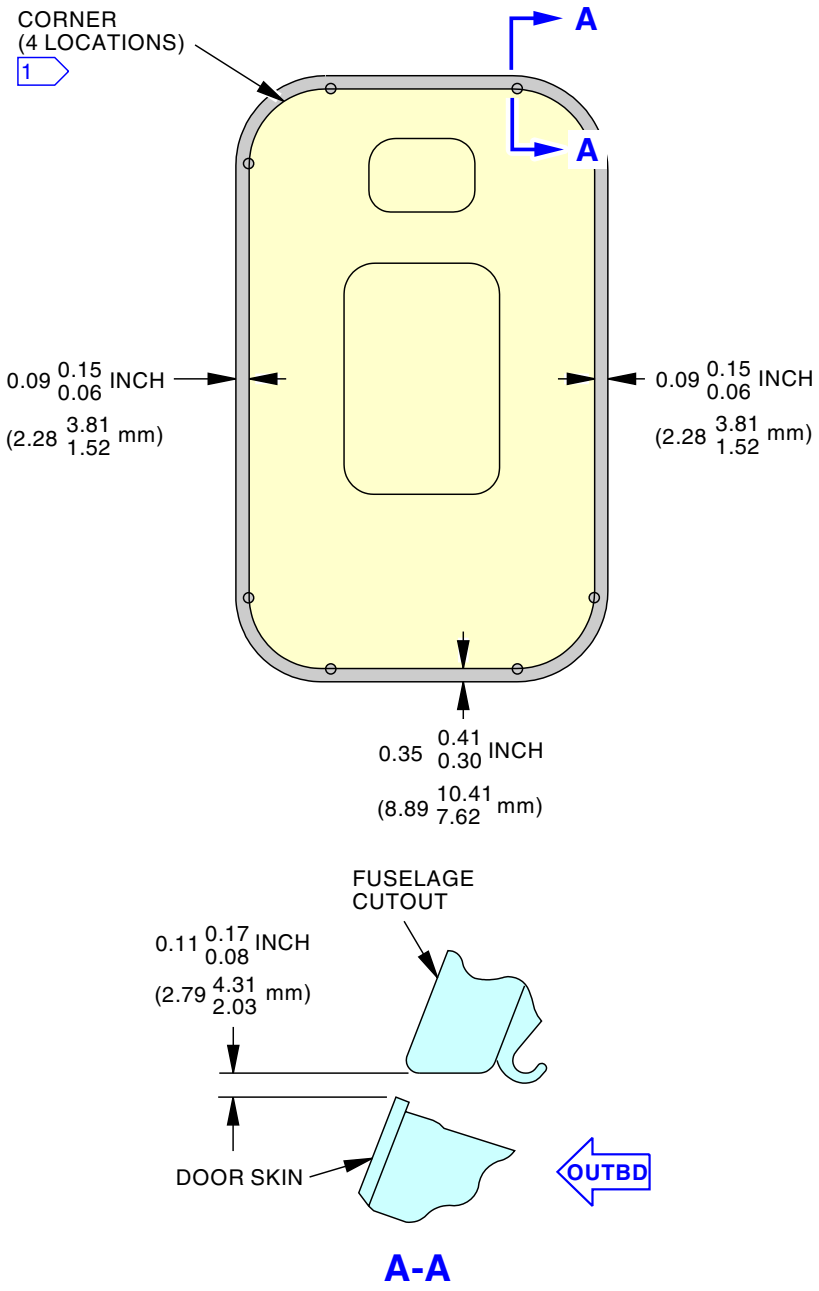
1 MAXIMUM OF 4 WASHERS

2 BOLT HEAD AND BUSHING ARE ON SAME SIDE

2415843 S00061539000_V1

Emergency Exit Door - Adjustment
Figure 503/52-22-00-990-805 (Sheet 8 of 8)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



NOTE:

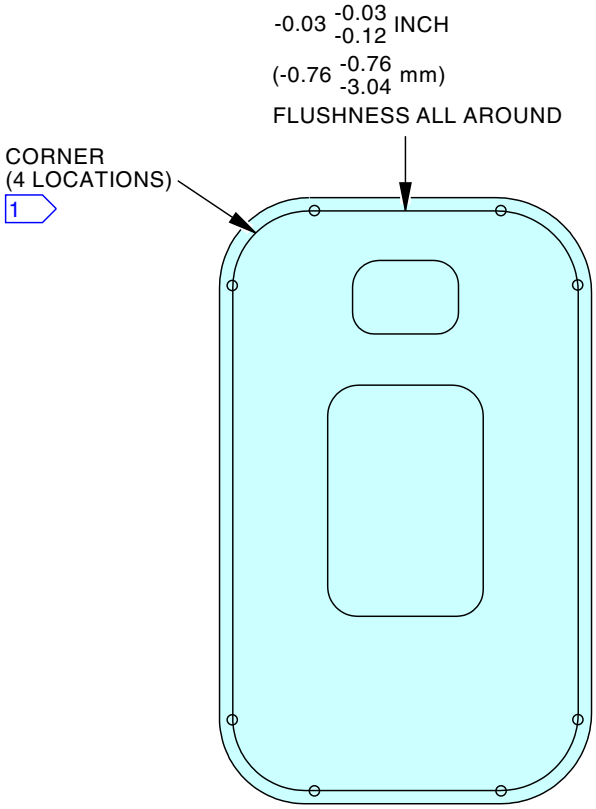
DIMENSION STANDARD: NOMINAL UPPER LIMIT LOWER LIMIT

1 THE SKIN CLEARANCE GRADUALLY CHANGES AROUND THE CORNER FROM THE LOWER TO THE HIGHER SKIN CLEARANCE

2415844 S00061539001_V1

Emergency Exit Door Skin Clearances
Figure 504/52-22-00-990-806

ECCN 9E991 BOEING PROPRIETARY - See title page for details



NOTE:

DIMENSION STANDARD: NOMINAL UPPER LIMIT LOWER LIMIT

NOTE:

A NEGATIVE FLUSHNESS SHOWS THE DOOR IS INBOARD OF THE FUSELAGE CUTOUT.

1 FLUSHNESS IS NOT APPLICABLE AT CORNERS.

2415845 S00061539002_V1

Emergency Exit Door Flushness
Figure 505/52-22-00-990-807

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-22-00-730-801

6. Emergency Exit Door System Test

(Figure 503)

A. General

(1) The system test will make sure that the door is correctly installed, adjusted, and that the mechanical systems operate correctly.

(2) The door seal and lining are installed for the system test.

(3) Do an adjustment if the door does not pass the system test (TASK 52-22-00-820-801).

B. References

Reference	Title
36-00-00-860-806	Remove Pressure from the Pneumatic System (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-1557	Gauge - Force Part #: DG-200 Supplier: 92456 Part #: FDIX 100 Supplier: 0BFD9 Part #: FDIX 50 Supplier: 0BFD9 Part #: LG-050 Supplier: 92456 Part #: LG-100 Supplier: 92456 Opt Part #: DPP-500G Supplier: 92456 Opt Part #: DPPH-150 Supplier: 92456 Opt Part #: DPPH-200 Supplier: 92456 Opt Part #: DPPH-50 Supplier: 92456 Opt Part #: FDI 100 Supplier: 0BFD9 Opt Part #: FDI 50 Supplier: 0BFD9 Opt Part #: FDV 100 Supplier: 0BFD9 Opt Part #: FDV 50 Supplier: 0BFD9

D. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

E. Prepare for the System Test

SUBTASK 52-22-00-840-002

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

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
D	1	C01515	OVERWING FLIGHT LOCK-RIGHT
D	2	C01514	OVERWING FLIGHT LOCK-LEFT

ECCN 9E991 BOEING PROPRIETARY - See title page for details

F. System Test of the Emergency Exit Door

SUBTASK 52-22-00-730-001

(1) Do the system test for the emergency exit door:

(a) Use one of these methods to change the condition of the engine running relays:

1) Either start or stop the engine.

2) Or, do these steps to simulate the engine running:

a) Make sure that there is no pneumatic power to the engine starters (TASK 36-00-00-860-806).

b) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-2

Row	Col	Number	Name
A	1	C00458	ENGINE 1 IGNITION RIGHT
A	3	C00153	ENGINE 1 IGNITION LEFT

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
C	1	C00523	HEATERS CAPT PITOT
C	7	C01678	WEATHER RADAR RT RIGHT
D	5	C00525	HEATERS F/O PITOT
D	6	C00524	HEATERS AUX PITOT

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
D	4	C00459	ENGINE 2 IGNITION RIGHT
D	6	C00151	ENGINE 2 IGNITION LEFT

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
B	3	C00360	FUEL SPAR VALVE ENG 2
B	4	C00359	FUEL SPAR VALVE ENG 1

c) Make sure that both engine start switches are in the OFF position.

d) Put both engine start levers to the IDLE position for a minimum of 5 minutes.

WARNING MAKE SURE THAT THE ENGINES ARE NOT RUNNING. IF YOU DO NOT OBEY THIS WARNING, INJURY TO PERSONS OR DAMAGE TO THE EQUIPMENT CAN OCCUR.

(b) Make sure that three of the four Entry/Service doors are closed.

(c) Make sure that all of the Emergency Exit Doors are closed.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WARNING MAKE SURE THAT YOU OPEN THE CIRCUIT BREAKER FOR THE WEATHER RADAR SYSTEM. THE FORWARD MOVEMENT OF A THRUST LEVER CAN CAUSE THE AUTOMATIC OPERATION OF THE SYSTEM. THE OPERATION OF THIS SYSTEM CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT IN THE AREA OF THE NOSE RADOME.

(d) Push both engine thrust levers fully forward.

(e) If the Master Caution switch light is activated, then the emergency exit lights, on the forward overhead panel, P5, must be on.

(f) Press the Master Caution switch to deactivate the light and turn off the doors indication lights on the glareshield panel, P7.

(g) Pull both engine thrust levers back to idle.

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

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
D	1	C01515	OVERWING FLIGHT LOCK-RIGHT
D	2	C01514	OVERWING FLIGHT LOCK-LEFT

(i) Push both engine thrust levers fully forward.

(j) All of the emergency exit door lights must be off.

(k) Push the Master Caution recall button.

(l) Make sure that the applicable flight lock is operating correctly (TASK 52-22-00-710-803):

(m) Do these steps to check the flight lock solenoid.

1) Make sure that the Master Caution light, and all door warning lights, on the forward overhead panel, P5, are off.

2) Remove the emergency exit door handle cover.

WARNING MAKE SURE THAT THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING-LOADED TO OPEN AUTOMATICALLY AND CAN CAUSE INJURY TO PERSONNEL OR DAMAGE TO EQUIPMENT.

3) Pull down on the emergency exit door handle to make sure that the door is locked.

NOTE: Handle movement is only 15°arc (0.3 rad) with the flight lock solenoid engaged.

4) Make sure that the emergency exit light, on the forward overhead panel, P5, is on.

5) Stow the emergency exit door handle.

6) Make sure that the emergency exit light, on the forward overhead panel, P5, is off.

(n) Pull both engine thrust levers back to idle.

SUBTASK 52-22-00-840-003

(2) Do these steps to return the engine running relays back to the not running condition.

(a) Put both engine start levers to the CUTOFF position.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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

CAPT Electrical System Panel, P18-2

Row	Col	Number	Name
A	1	C00458	ENGINE 1 IGNITION RIGHT
A	3	C00153	ENGINE 1 IGNITION LEFT

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
C	1	C00523	HEATERS CAPT PITOT
C	7	C01678	WEATHER RADAR RT RIGHT
D	5	C00525	HEATERS F/O PITOT
D	6	C00524	HEATERS AUX PITOT

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
D	4	C00459	ENGINE 2 IGNITION RIGHT
D	6	C00151	ENGINE 2 IGNITION LEFT

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
B	3	C00360	FUEL SPAR VALVE ENG 2
B	4	C00359	FUEL SPAR VALVE ENG 1

SUBTASK 52-22-00-730-002

(3) If the door does not pass the system test, adjust the door (TASK 52-22-00-820-801).

SUBTASK 52-22-00-820-012

(4) Do a test of the door handle:

(a) Close and lock the door.

WARNING YOU MUST HAVE THE AID OF ONE MORE PERSON TO KEEP THE DOOR IN THE CLOSED POSITION. IF YOU DO NOT OBEY THIS INSTRUCTION, THE DOOR CAN OPEN QUICKLY AND INJURY TO PERSONS CAN OCCUR.

(b) Use the force gauge, COM-1557, to move the handle to the open position.

(c) Make sure that the force is 18 lbf (80 N) - 28 lbf (125 N) with the door lining installed.

(d) To adjust the door handle force, do this task: Emergency Exit Door Adjustment, TASK 52-22-00-820-801.

1) Do the door flushness adjustment.

NOTE: Adjustment of the door inboard will correct high handle force at the end of handle travel.

(e) Close and lock door.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

EMERGENCY EXIT DOOR - INSPECTION/CHECK

1. General

A. This procedure has these tasks:

(1) Emergency Exit Door Inspection/Check

(2) Emergency Exit Door Pressure Seal Check

(3) Emergency Exit Door Latch Components Detailed Inspection

(4) Emergency Exit Door Flight Locks Detailed Inspection.

B. This procedure is the same for each emergency exit door.

TASK 52-22-00-200-801

2. Emergency Exit Door Inspection/Check

A. References

Reference	Title
52-22-00-580-801	Open the Emergency Exit Door (P/B 201)
52-22-00-580-803	Close the Emergency Exit Door (P/B 201)
52-22-51-000-801	Emergency Exit Door Lining Removal (P/B 401)
52-22-51-400-801	Emergency Exit Door Lining Installation (P/B 401)

B. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

C. Prepare for the Inspection

SUBTASK 52-22-00-010-005

(1) Do this task: Emergency Exit Door Lining Removal, TASK 52-22-51-000-801.

SUBTASK 52-22-00-010-006

WARNING MAKE SURE THAT THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING-LOADED TO OPEN AUTOMATICALLY AND CAN CAUSE INJURY TO PERSONNEL OR DAMAGE TO EQUIPMENT.

WARNING BEFORE YOU RELEASE THE DOOR HANDLE, MAKE SURE THAT THE DOOR WILL NOT HIT PERSONNEL OR EQUIPMENT. THE SPRING WILL CAUSE THE DOOR TO OPEN AUTOMATICALLY. INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT CAN OCCUR.

(2) Open and close the door as necessary to get access to the door components (TASK 52-22-00-580-801, TASK 52-22-00-580-803).

D. Emergency Exit Door Inspection

SUBTASK 52-22-00-210-001

(1) Do a visual inspection of the door external structure and handle mechanism as follows:

(a) Examine the external skin.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1) Look for cracks and corrosion.
2) Look for burrs.
3) Look for loose and missing fasteners.

(b) Examine the external handle.
1) Look for cracks and corrosion.
2) Look for too much wear.

SUBTASK 52-22-00-210-002

(2) Do a visual inspection of the attach structure as follows:
(a) Examine the hinge arm.
1) Look for cracks and corrosion.
2) Look for too much wear.
(b) Examine the door hinge lock pawl.
1) Look for cracks and corrosion
2) Make sure the bolts fully engage the nuts.
(c) Examine the hinge arm fasteners.
1) Make sure the bolts fully engage the nuts.
2) Make sure the bolt threads are not damaged.

SUBTASK 52-22-00-210-003

(3) Do a visual inspection of the door internal structure and door handle as follows:
(a) Examine the internal frames.
1) Look for cracks and corrosion.
2) Look for loose and missing fasteners.
(b) Examine the internal skin.
1) Look for cracks and corrosion.
2) Look for burrs.
3) Look for loose and missing fasteners.
(c) Examine the window.
1) Look for cracks.
(d) Examine the window frame.
1) Look for cracks and corrosion.
(e) Examine the door handle.
1) Look for cracks and corrosion.
2) Look for too much wear.
(f) Examine the handle housing.
1) Look for cracks and corrosion.
(g) Examine the lock shaft torque tube.
1) Make sure the bolts fully engage the nuts.
2) Make sure the shaft torque tube is not binding.
3) Look for cracks and corrosion.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(h) Examine the latch cranks and latch rollers.
1) Look for cracks and corrosion.
2) Look for too much wear.
3) Look for unwanted particles on the latch rollers.

(i) Examine the lock cranks and lock rollers.
1) Look for cracks and corrosion.
2) Look for too much wear.
3) Look for unwanted particles on the lock rollers.

SUBTASK 52-22-00-210-004

(4) Do a visual inspection of the counterbalance and snubber as follows:
(a) Examine the counterbalance.
1) Make sure the counterbalance actuators are correctly attached.
2) Look for cracks or corrosion.

(b) Examine the snubber.
1) Make sure the snubber is correctly attached.
2) Make sure the snubber is not leaking fluid.
3) Look for cracks or corrosion.

SUBTASK 52-22-00-210-005

(5) Do a visual inspection of the fuselage frame as follows:
(a) Examine the fuselage stop fittings and stop pads.
1) Look for cracks and corrosion.
2) Look for wear that is not in the center of the stop pads.
3) Look for unwanted particles on the stop fittings.

(b) Examine the latch receivers.
1) Look for cracks, corrosion, and too much wear.
2) Look for unwanted particles in the latch receivers.

(c) Examine the stop track.
1) Look for cracks and corrosion.
2) Look for unwanted particles on the stop track.

(d) Examine the structure around the door opening.
1) Look for cracks and corrosion.
2) Look for loose and missing fasteners.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 52-22-00-210-006

(1) Do this task: Emergency Exit Door Lining Installation, TASK 52-22-51-400-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-22-00-200-802

3. Emergency Exit Door Pressure Seal Check

A. References

Reference	Title
52-22-00-580-801	Open the Emergency Exit Door (P/B 201)
52-22-00-580-803	Close the Emergency Exit Door (P/B 201)

B. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

C. Prepare for the Inspection

SUBTASK 52-22-00-010-007

WARNING BEFORE YOU RELEASE THE DOOR HANDLE, MAKE SURE THAT THE DOOR WILL NOT HIT PERSONNEL OR EQUIPMENT. THE SPRING WILL CAUSE THE DOOR TO OPEN AUTOMATICALLY. INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT CAN OCCUR.

(1) Do this task: Open the Emergency Exit Door, TASK 52-22-00-580-801.

D. Emergency Exit Door Pressure Seal Inspection

SUBTASK 52-22-00-210-007

(1) Do a visual inspection of the door pressure seal as follows:

(a) Examine the seal.

1) Look for cracks, holes, and tears.

2) Look for indications of seal deterioration.

3) Make sure the seal is installed in the seal retainer.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 52-22-00-410-005

(1) Do this task: Close the Emergency Exit Door, TASK 52-22-00-580-803.

——— END OF TASK ———

TASK 52-22-00-210-801

4. Emergency Exit Door Latch Components Detailed Inspection

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
52-22-00-580-801	Open the Emergency Exit Door (P/B 201)
52-22-00-580-803	Close the Emergency Exit Door (P/B 201)
52-22-51-000-801	Emergency Exit Door Lining Removal (P/B 401)
52-22-51-400-801	Emergency Exit Door Lining Installation (P/B 401)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

C. Emergency Exit Door Latch Components Detailed Inspection

SUBTASK 52-22-00-010-008

(1) Do this task: Emergency Exit Door Lining Removal, TASK 52-22-51-000-801.

SUBTASK 52-22-00-010-009

WARNING BEFORE YOU RELEASE THE DOOR HANDLE, MAKE SURE THAT THE DOOR WILL NOT HIT PERSONNEL OR EQUIPMENT. THE SPRING WILL CAUSE THE DOOR TO OPEN AUTOMATICALLY. INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT CAN OCCUR.

(2) Open and close the door as necessary to get access to the door components (TASK 52-22-00-580-801, TASK 52-22-00-580-803).

SUBTASK 52-22-00-210-008

(3) Do a detailed inspection of the latch rollers, links and pivot fittings for the emergency exit door:

(a) Look for cracks and corrosion.

(b) Look for too much wear.

(c) Look for unwanted particles.

SUBTASK 52-22-00-410-006

(4) Do this task: Emergency Exit Door Lining Installation, TASK 52-22-51-400-801.

——— END OF TASK ———

TASK 52-22-00-210-802

5. Emergency Exit Door Flight Locks Detailed Inspection

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
52-22-51-000-801	Emergency Exit Door Lining Removal (P/B 401)
52-22-51-400-801	Emergency Exit Door Lining Installation (P/B 401)

B. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

C. Emergency Exit Door Flight Locks Detailed Inspection

SUBTASK 52-22-00-010-010

(1) Do this task: Emergency Exit Door Lining Removal, TASK 52-22-51-000-801.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-22-00-210-009

(2) Do a detailed inspection of the flight locks on the emergency exit door:

(a) Look for cracks and corrosion.

(b) Look for too much wear.

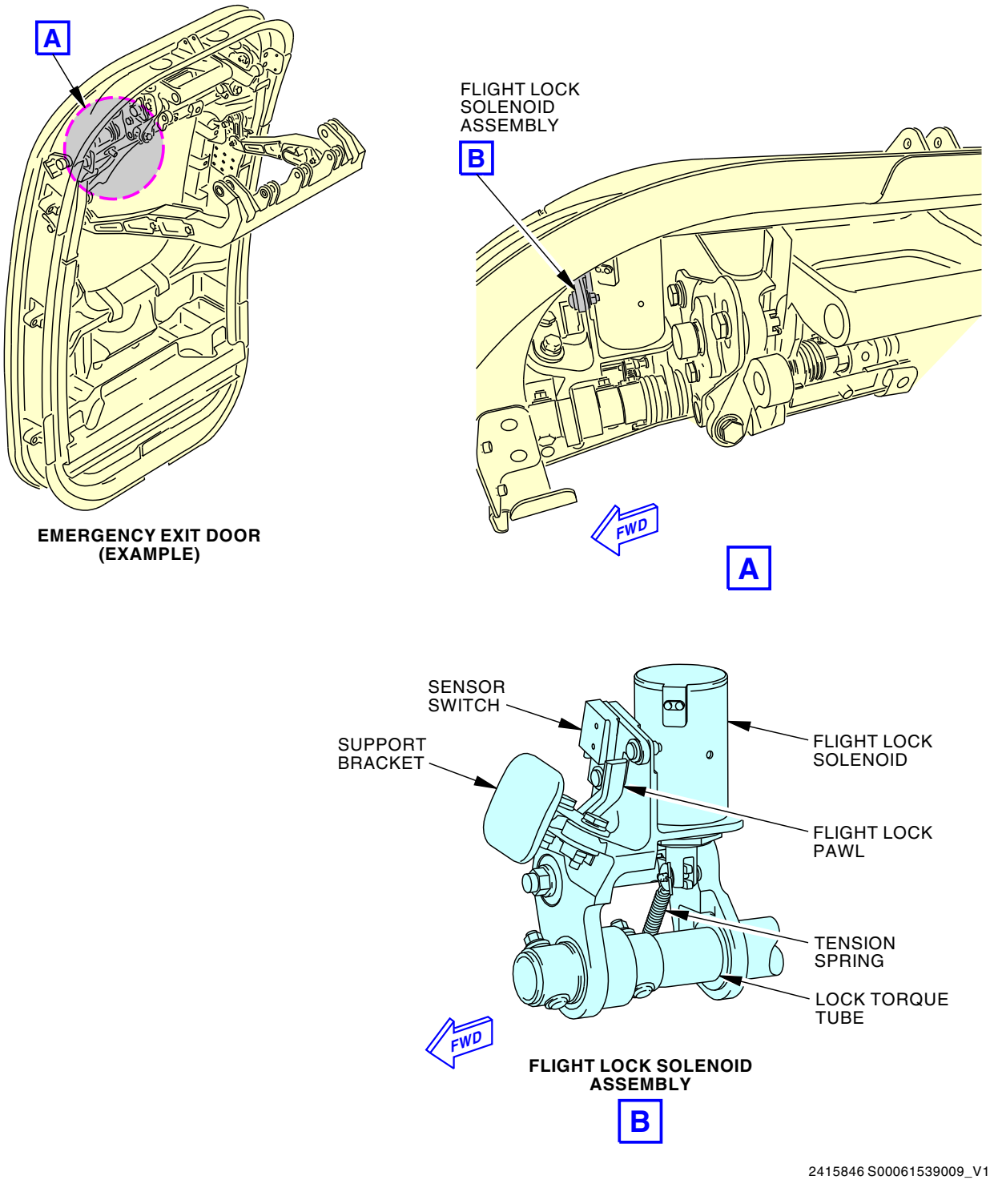
(c) Look for unwanted particles.

SUBTASK 52-22-00-410-007

(3) Do this task: Emergency Exit Door Lining Installation, TASK 52-22-51-400-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Emergency Exit Door Flight Locks Detailed Inspection
Figure 601/52-22-00-990-808

ECCN 9E991 BOEING PROPRIETARY - See title page for details

EMERGENCY EXIT DOOR STOP BEARING PLATE - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) The emergency exit door stop bearing plate removal.

(2) The emergency exit door stop bearing plate installation.

B. This procedure is applicable for each emergency exit door stop bearing plate.

TASK 52-22-01-000-801

2. Emergency Exit Door Stop Bearing Plate Removal

(Figure 401)

A. References

Reference	Title
20-10-02-900-801	Bearings and Bushings - Removal/Installation (P/B 401)
52-22-00 P/B 201	EMERGENCY EXIT DOOR - MAINTENANCE PRACTICES

B. Consumable Materials

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

C. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

D. Prepare for the Removal

SUBTASK 52-22-01-010-001

(1) Open the emergency exit door (EMERGENCY EXIT DOOR - MAINTENANCE PRACTICES, PAGEBLOCK 52-22-00/201).

E. Emergency Exit Door Stop Bearing Plate Removal

SUBTASK 52-22-01-020-001

(1) Remove the door stop bearing plate (TASK 20-10-02-900-801).

(a) If it is necessary, use a bearing removal tool to remove the stop bearing plate.

NOTE: See Standard Overhaul Practices Manual (SOPM) 20-50-03 for the most applicable BAC5435.

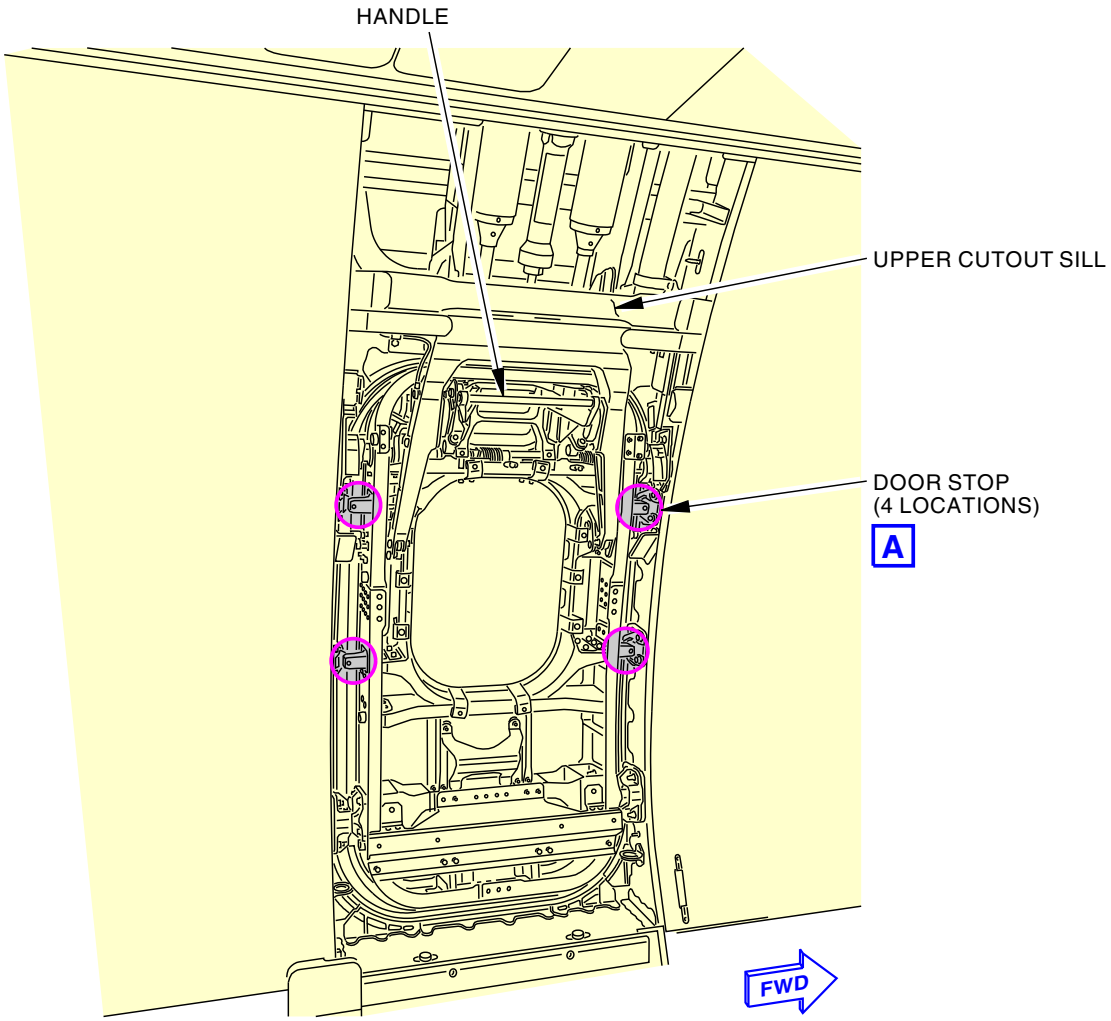
SUBTASK 52-22-01-100-001

(2) Clean the mounting hole with clean cotton wiper, G00034, that is moist with solvent, B00083.

NOTE: Clean surfaces are necessary to make a good bond.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

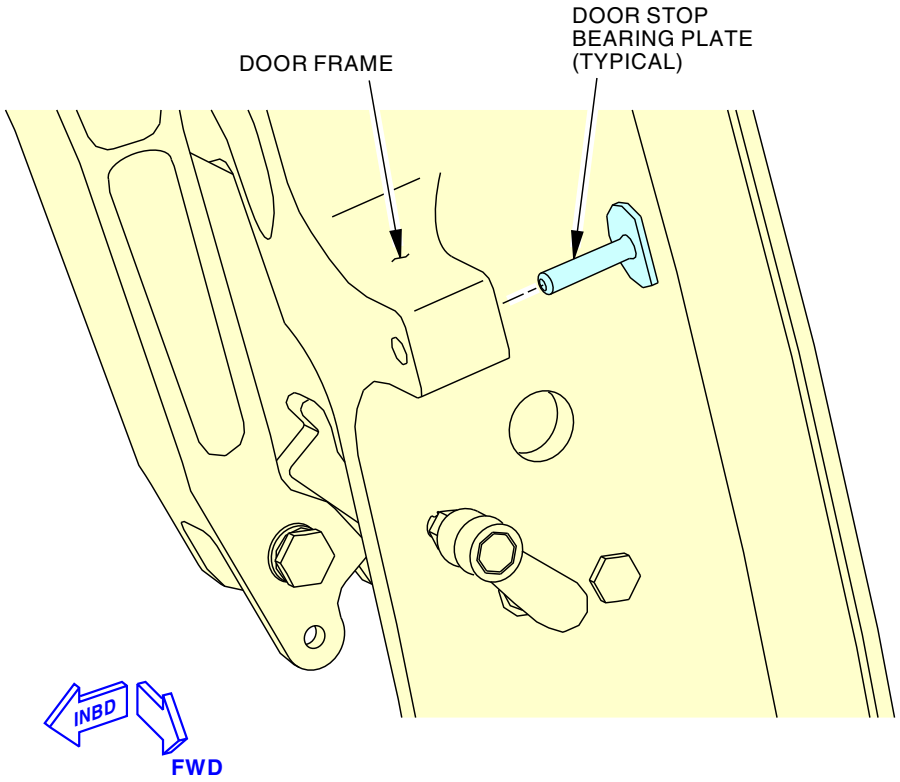


**EMERGENCY EXIT DOOR
(DOOR IN THE CLOSED POSITION
WITH DOOR LINING REMOVED)
(EXAMPLE)**

2965424 S0000744262_V1

**Door Stop Bearing Plate Installation
Figure 401/52-22-01-990-801 (Sheet 1 of 2)**

ECCN 9E991 BOEING PROPRIETARY - See title page for details



DOOR STOP BEARING PLATE INSTALLATION

A

2965425 S0000744263_V1

Door Stop Bearing Plate Installation
Figure 401/52-22-01-990-801 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-22-01-400-801

3. Emergency Exit Door Stop Bearing Plate Installation

(Figure 401)

A. References

Reference	Title
20-10-02-900-801	Bearings and Bushings - Removal/Installation (P/B 401)
52-22-00-580-803	Close the Emergency Exit Door (P/B 201)
52-22-00-730-801	Emergency Exit Door System Test (P/B 501)
52-22-00-820-801	Emergency Exit Door Adjustment (P/B 501)

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
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

C. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

D. Prepare for the Installation

SUBTASK 52-22-01-420-001

(1) Do a test of the fit of the stop bearing plate before the installation.

(a) Use hand pressure to install the stop bearing plate into the mounting hole.

(b) Discard the stop bearing plate, if you can install it with hand pressure.

(c) Get a new stop bearing plate, if necessary.

E. Emergency Exit Door Stop Bearing Plate Installation

SUBTASK 52-22-01-420-002

(1) Install the stop bearing plate as follows:

(a) Apply a layer of sealant, A00247, to the stop bearing plate and mounting hole.

(b) Install the door stop bearing plate with the anvil swage (TASK 20-10-02-900-801).

NOTE: See Standard Overhaul Practices Manual (SOPM) 20-50-03 for the most applicable BAC5435.

NOTE: It is recommended to use anvils that are 45 degrees to start the swage, and 60 degrees to finish and set the bearing plate to the door stop assembly. The flat side of the shank end must be parallel to the flat side of the door stop within +/- 0.010 in. (0.254 mm).

(c) Make sure that the bearing plate is not manually movable by hand pressure.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(d) Use clean cotton wiper, G00034, that is moist with solvent, B00083, to remove unwanted sealant, A00247, from the stop bearing plate before it dries.

SUBTASK 52-22-01-820-001

(2) Do this task: Emergency Exit Door Adjustment, TASK 52-22-00-820-801.

SUBTASK 52-22-01-730-001

(3) Do this task: Emergency Exit Door System Test, TASK 52-22-00-730-801.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 52-22-01-410-001

(1) Do this task: Close the Emergency Exit Door, TASK 52-22-00-580-803.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

EMERGENCY EXIT DOOR COUNTERBALANCE ACTUATOR - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Emergency exit door counterbalance actuator removal

(2) Emergency exit door counterbalance actuator installation.

B. This procedure is the same for each emergency exit door counterbalance actuator.

C. The emergency exit door counterbalance actuator is referred to as the counterbalance actuator in this procedure.

TASK 52-22-21-000-801

2. Emergency Exit Door Counterbalance Actuator Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the emergency exit door counterbalance actuator.

B. References

Reference	Title
25-21-20-000-801	Emergency Exit Doorway Lining Removal (P/B 401)
25-24-31-000-801	Overhead Stowage Bin - Removal (P/B 401)
25-24-31-000-802	Overhead Stowage Bin Module - Removal (P/B 401)
52-22-00-000-801	Emergency Exit Door Removal (P/B 401)
52-22-51-000-801	Emergency Exit Door Lining Removal (P/B 401)

C. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

D. Prepare for the Removal

SUBTASK 52-22-21-010-001

(1) Do this task: Emergency Exit Doorway Lining Removal, TASK 25-21-20-000-801.

SUBTASK 52-22-21-020-001

(2) Do this task: Overhead Stowage Bin Module - Removal, TASK 25-24-31-000-802 or Overhead Stowage Bin - Removal, TASK 25-24-31-000-801.

SUBTASK 52-22-21-020-002

(3) Do this task: Emergency Exit Door Lining Removal, TASK 52-22-51-000-801.

E. Emergency Exit Door Counterbalance Actuator Removal

SUBTASK 52-22-21-000-001

WARNING MAKE SURE THAT THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING-LOADED TO OPEN AUTOMATICALLY AND CAN CAUSE INJURY TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(1) Pull down on the door handle and open the door.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-22-21-000-002

(2) Do this task: Emergency Exit Door Removal, TASK 52-22-00-000-801.

SUBTASK 52-22-21-020-003

(3) Remove the mechanism guard [1] from the fuselage structure.

(a) Remove the bolts [2] and washers [3] that hold the mechanism guard [1] in place.

SUBTASK 52-22-21-020-004

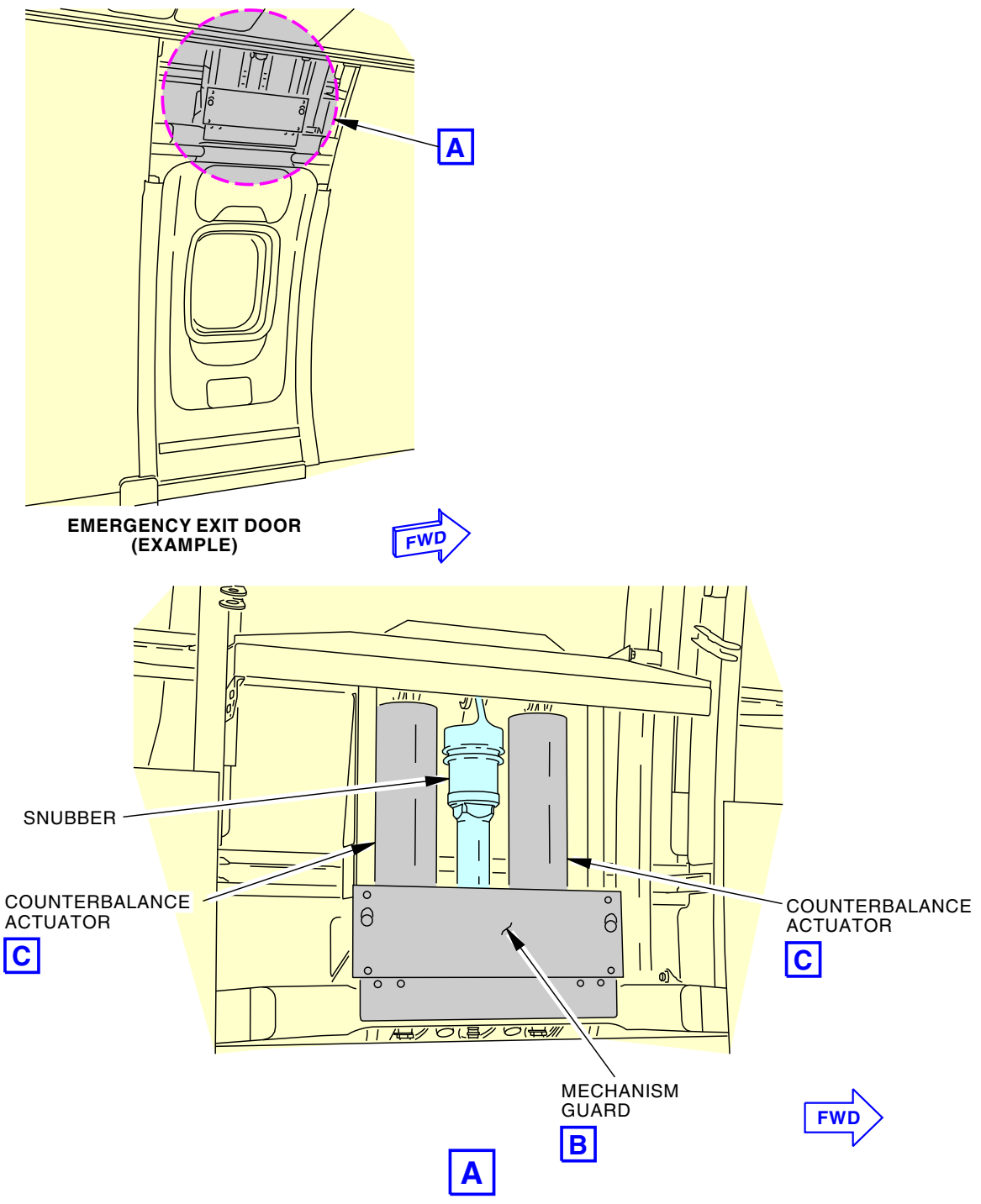
(4) Disconnect the counterbalance actuator [15] from the fuselage structure:

(a) Remove the cotter pin [16].

(b) Remove the bolt [6], washer [7], bushing [5], washers [4], and nut [17] that attach the counterbalance actuator [15] to the fuselage structure.

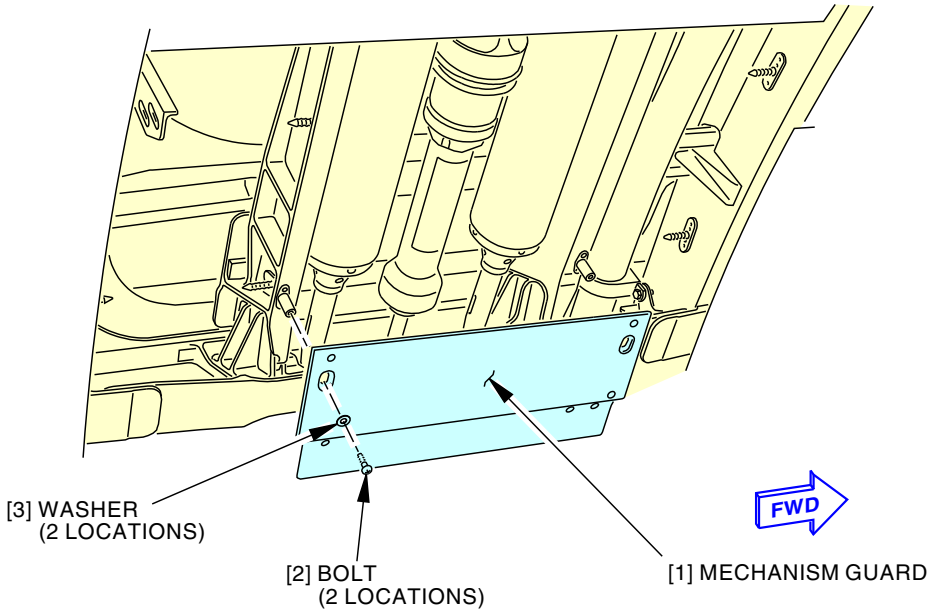
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Emergency Exit Door Counterbalance Actuator Installation
Figure 401/52-22-21-990-802 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



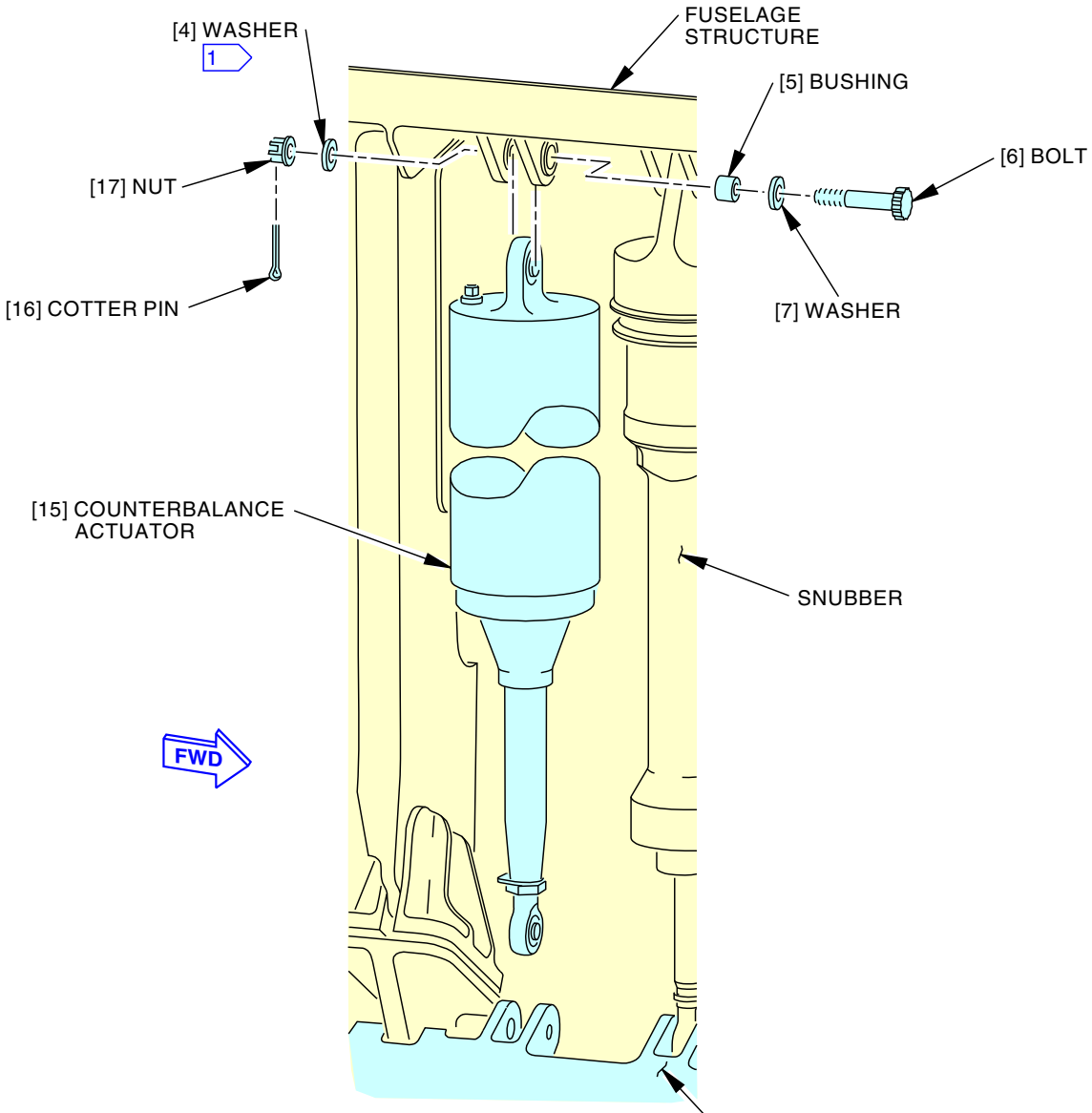
MECHANISM GUARD
(EXAMPLE)

B

2415848 S00061539015_V1

Emergency Exit Door Counterbalance Actuator Installation
Figure 401/52-22-21-990-802 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



COUNTERBALANCE ACTUATOR (EXPLODED VIEW) (EXAMPLE)

C

1 MAXIMUM OF 4 WASHERS.

2415849 S00061539016_V1

Emergency Exit Door Counterbalance Actuator Installation
Figure 401/52-22-21-990-802 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-22-21-400-801

3. Emergency Exit Door Counterbalance Actuator Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the emergency exit door counterbalance actuator.

B. References

Reference	Title
25-21-20-400-801	Emergency Exit Doorway Lining Installation (P/B 401)
25-24-31-400-801	Overhead Stowage Bin - Installation (P/B 401)
25-24-31-400-802	Overhead Stowage Bin Module - Installation (P/B 401)
52-22-00-400-801	Emergency Exit Door Installation (P/B 401)
52-22-00-820-801	Emergency Exit Door Adjustment (P/B 501)
52-22-51-400-801	Emergency Exit Door Lining Installation (P/B 401)

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
15	Counterbalance actuator	52-22-21-01-065	SIA ALL
		52-22-21-01-215	SIA ALL
16	Cotter pin	52-22-21-01-010	SIA ALL
		52-22-21-01-160	SIA ALL

D. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

E. Emergency Exit Door Counterbalance Actuator Installation

SUBTASK 52-22-21-420-001

(1) Connect the counterbalance actuator [15] to the fuselage structure:

(a) Put the counterbalance actuator [15] in its correct position.

(b) Install the bolt [6], washer [7], bushing [5], washers [4], and nut [17] that attach the counterbalance actuator [15] to the fuselage structure.

(c) Tighten the nut [17] to 60 in-lb (6.78 N·m) - 95 in-lb (10.73 N·m).

(d) Install a new cotter pin [16].

SUBTASK 52-22-21-400-001

(2) Do this task: Emergency Exit Door Installation, TASK 52-22-00-400-801.

SUBTASK 52-22-21-420-002

(3) Install the mechanism guard [1] to the fuselage structure.

(a) Install the bolts [2] and washers [3] that hold the mechanism guard [1] in place.

SUBTASK 52-22-21-400-002

(4) To adjust the counterbalance, do this task: Emergency Exit Door Adjustment, TASK 52-22-00-820-801.

NOTE: Only do the Counterbalance Adjustment procedure.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-22-21-710-001

(5) Do a test on the counterbalance actuator [15]:

(a) Open and close the door.

(b) Make sure that the door opens automatically.

(c) Make sure that the door closes smoothly.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 52-22-21-080-001

(1) Do this task: Emergency Exit Door Lining Installation, TASK 52-22-51-400-801.

SUBTASK 52-22-21-420-003

(2) Do this task: Emergency Exit Doorway Lining Installation, TASK 25-21-20-400-801.

SUBTASK 52-22-21-420-004

(3) Do this task: Overhead Stowage Bin - Installation, TASK 25-24-31-400-801 or Overhead Stowage Bin Module - Installation, TASK 25-24-31-400-802.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

EMERGENCY EXIT DOOR SNUBBER - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Emergency exit door snubber removal

(2) Emergency exit door snubber installation.

B. The emergency exit door snubber is referred to as the snubber is this procedure.

C. This procedure is the same for each emergency exit door.

TASK 52-22-31-000-801

2. Emergency Exit Door Snubber Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the emergency exit door snubber.

B. References

Reference	Title
25-21-20-000-801	Emergency Exit Doorway Lining Removal (P/B 401)
25-24-31-000-801	Overhead Stowage Bin - Removal (P/B 401)
25-24-31-000-802	Overhead Stowage Bin Module - Removal (P/B 401)

C. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

D. Prepare for the Removal

SUBTASK 52-22-31-010-001

(1) Get access to the snubber [8] as follows:

(a) Do this task: Overhead Stowage Bin Module - Removal, TASK 25-24-31-000-802 or Overhead Stowage Bin - Removal, TASK 25-24-31-000-801.

(b) Do this task: Emergency Exit Doorway Lining Removal, TASK 25-21-20-000-801.

E. Emergency Exit Door Snubber Removal

SUBTASK 52-22-31-020-001

WARNING KEEP PERSONS AND EQUIPMENT CLEAR OF THE UPPER SILL CUTOUT ABOVE THE DOOR. THE DOOR COMPONENTS MOVE QUICKLY WHEN YOU PULL THE DOOR HANDLE. IF YOU DO NOT OBEY THIS WARNING, INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT CAN OCCUR.

WARNING MAKE SURE THAT THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING-LOADED TO OPEN AUTOMATICALLY AND CAN CAUSE INJURY TO PERSONNEL OR DAMAGE TO EQUIPMENT.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(WARNING PRECEDES)

CAUTION IF THE SNUBBER IS DEFECTIVE, HOLD THE DOOR WITH SUFFICIENT WEIGHT. WHEN YOU OPEN THE DOOR, IF THE SNUBBER DOES NOT OPERATE CORRECTLY, DAMAGE TO THE DOOR HINGE CAN OCCUR.

(1) Pull down on the door handle to open the door.

SUBTASK 52-22-31-020-002

(2) Open the door.

SUBTASK 52-22-31-020-003

(3) Remove the mechanism guard [1] from the fuselage structure:

(a) Remove the bolts [2] and washers [3] from the mechanism guard [1].

(b) Remove the mechanism guard [1].

SUBTASK 52-22-31-020-004

(4) Disconnect the snubber [8] from the door hinge arm [12]:

(a) Remove the cotter pin [13].

(b) Remove the bolt [10], washer [9], bushing [11], washer [15], and nut [14] that attach the snubber [8] to the hinge arm [12].

SUBTASK 52-22-31-020-005

(5) Disconnect the snubber [8] from the fuselage structure:

(a) Remove the cotter pin [4].

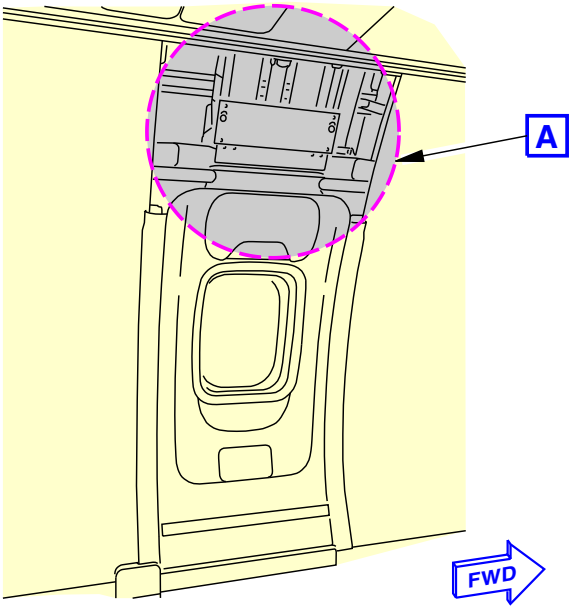
(b) Remove the bolt [5], washer [6], bushing [7], washer [16], and nut [17] that attach the snubber [8] to the fuselage structure.

SUBTASK 52-22-31-020-006

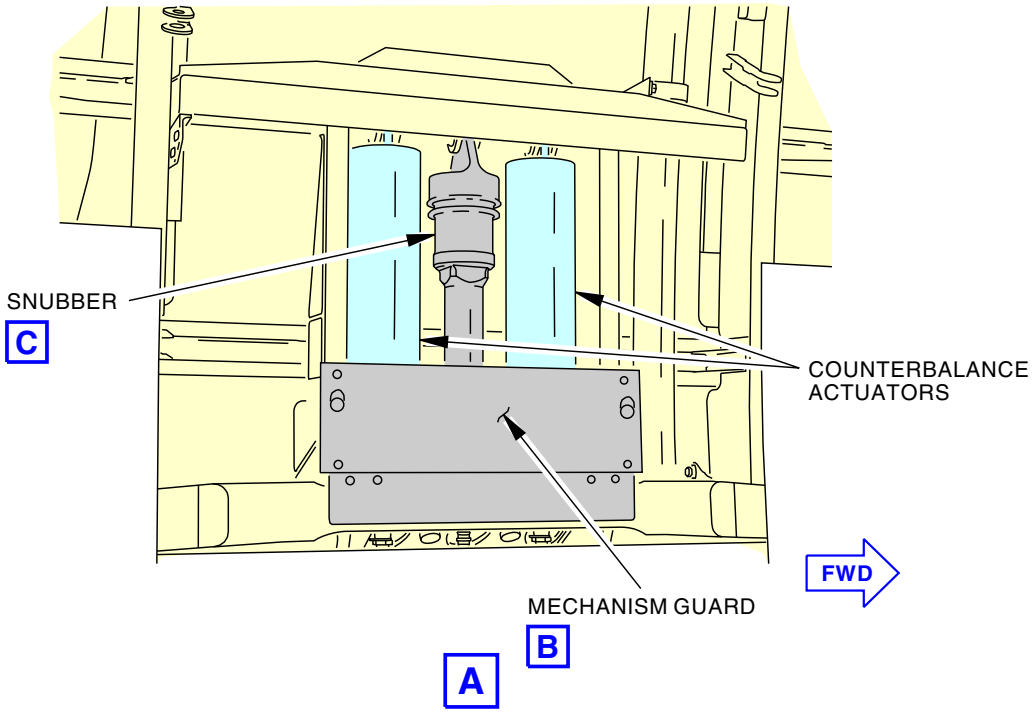
(6) Remove the snubber [8] from the fuselage structure.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



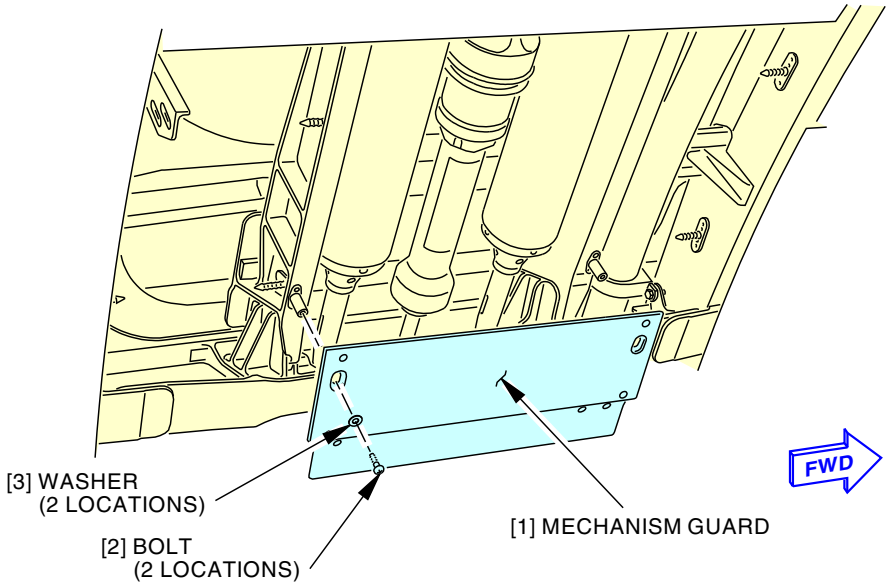
EMERGENCY EXIT DOOR
(EXAMPLE)



2415850 S00061539021_V1

Emergency Exit Door Snubber Installation
Figure 401/52-22-31-990-802 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



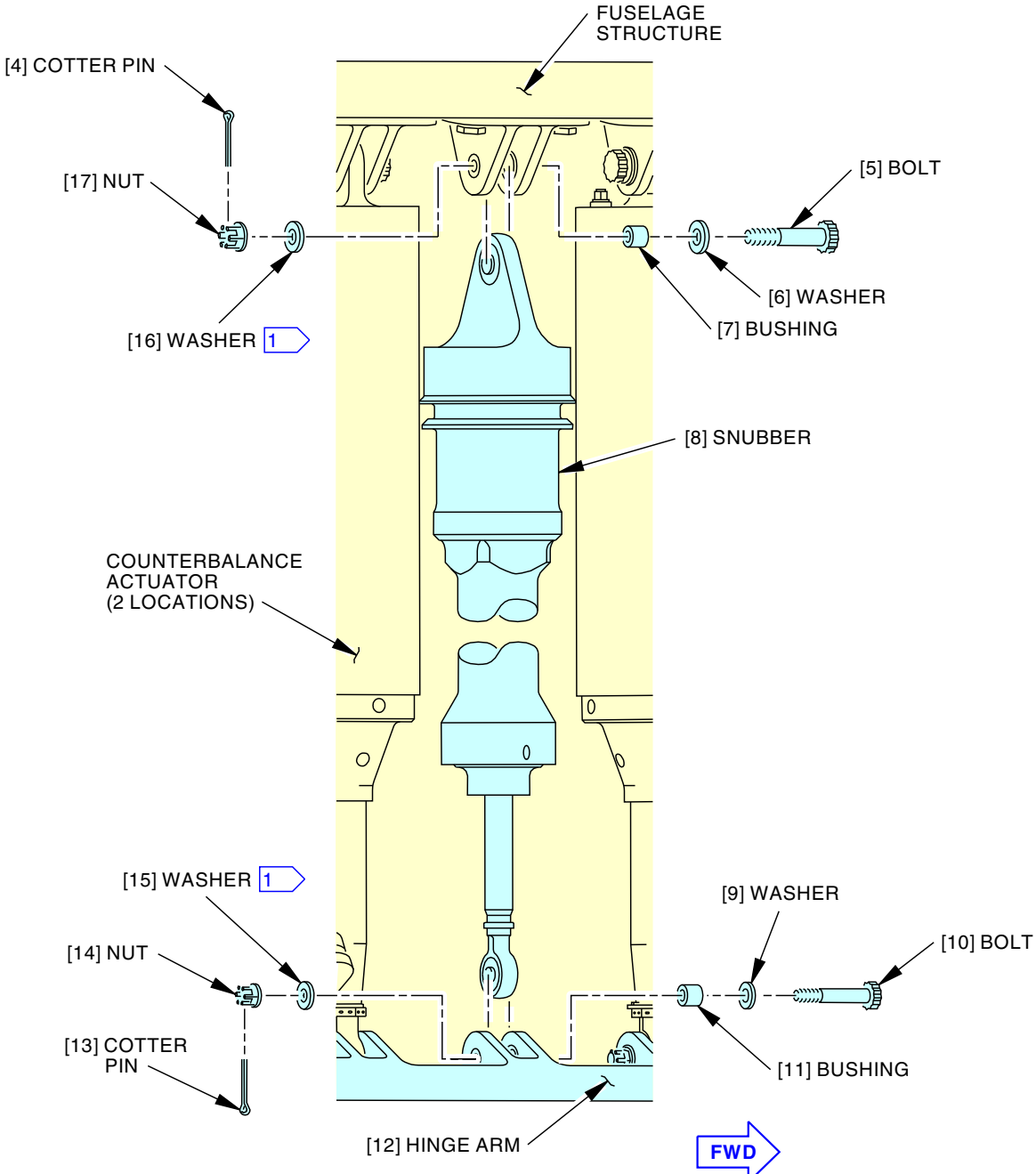
MECHANISM GUARD
(EXAMPLE)

B

2415851 S00061539022_V1

Emergency Exit Door Snubber Installation
Figure 401/52-22-31-990-802 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Emergency Exit Door Snubber Installation
Figure 401/52-22-31-990-802 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-22-31-400-801

3. Emergency Exit Door Snubber Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the emergency exit door snubber.

B. References

Reference	Title
25-21-20-400-801	Emergency Exit Doorway Lining Installation (P/B 401)
25-24-31-400-801	Overhead Stowage Bin - Installation (P/B 401)
25-24-31-400-802	Overhead Stowage Bin Module - Installation (P/B 401)
52-22-51-400-801	Emergency Exit Door Lining Installation (P/B 401)

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
4	Cotter pin	52-22-21-01-010	SIA ALL
8	Snubber	52-22-21-01-070	SIA ALL
		52-22-21-01-220	SIA ALL
13	Cotter pin	52-22-21-01-160	SIA ALL

D. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

E. Emergency Exit Door Snubber Installation

SUBTASK 52-22-31-400-001

(1) Connect the snubber [8] to the fuselage structure:

(a) Hold the snubber [8] in its correct position.

(b) Install the bolt [5], washer [6], bushing [7], washer [16], and nut [17] that attach the snubber [8] to the fuselage structure.

NOTE: Use a maximum of 4 washers for cotter-pin, nut alignment.

(c) Tighten the nut [17] to 60 in-lb (6.8 N·m) - 95 in-lb (10.7 N·m).

(d) Install the new cotter pin [4].

SUBTASK 52-22-31-420-001

(2) Connect the snubber [8] to the door hinge arm [12] as follows:

(a) Install the bolt [10], washer [9], bushing [11], washer [15], and nut [14] that attach the snubber [8] to the hinge arm [12].

NOTE: Use a maximum of 4 washers for cotter-pin, nut alignment.

(b) Tighten the nut [14] to 30 in-lb (3.4 N·m) - 50 in-lb (5.6 N·m).

(c) Install the new cotter pin [13].

SUBTASK 52-22-31-420-002

(3) Install the mechanism guard [1] to the fuselage structure:

(a) Put the mechanism guard [1] in its position.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) Install the bolts [2] and washers [3] that hold the mechanism guard [1] in place.

F. Emergency Exit Door Snubber Installation Test

SUBTASK 52-22-31-710-001

(1) Do a test on the snubber:

(a) Open and close the door.

(b) Make sure that the door opens and closes smoothly.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 52-22-31-080-001

(1) Close access to the snubber [8]:

(a) Do this task: Emergency Exit Door Lining Installation, TASK 52-22-51-400-801.

(b) Do this task: Emergency Exit Doorway Lining Installation, TASK 25-21-20-400-801.

(c) Do this task: Overhead Stowage Bin - Installation, TASK 25-24-31-400-801 or Overhead Stowage Bin Module - Installation, TASK 25-24-31-400-802.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

EMERGENCY EXIT DOOR FLIGHT LOCK SOLENOID ASSEMBLY - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Emergency exit door flight lock solenoid removal

(2) Emergency exit door flight lock solenoid installation

(3) Emergency exit door flight lock switch removal

(4) Emergency exit door flight lock switch installation.

B. The emergency exit door flight lock soleniod, indication switch and the switch plate are referred to as the flight lock soleniod assembly in this procedure.

C. This procedure is the same for each emergency exit door.

TASK 52-22-41-000-801

2. Emergency Exit Door Fight Lock Solenoid Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the emergency exit door flight lock solenoid.

B. References

Reference	Title
52-22-00-000-801	Emergency Exit Door Removal (P/B 401)
52-22-51-000-801	Emergency Exit Door Lining 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-2002	Adapter - Torque Wrench, Automatic Overwing Exit Hatch Part #: C52007-1 Supplier: 81205

D. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

E. Prepare for the Removal

SUBTASK 52-22-41-020-009

(1) Do this task: Emergency Exit Door Lining Removal, TASK 52-22-51-000-801.

SUBTASK 52-22-41-020-001

(2) Do this task: Emergency Exit Door Removal, TASK 52-22-00-000-801.

SUBTASK 52-22-41-020-002

(3) Make sure that the lock pawls [2] engage both legs of the hinge arm.

SUBTASK 52-22-41-020-003

(4) Push the door hinge arm [1] towards the bottom of the door.

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SUBTASK 52-22-41-010-001

(5) Remove the latch roller [6].

(a) Pull the hinge arm latch receivers away from the latch rollers.

(b) Remove the cotter pin [8], nut [9], washers [7], and latch roller [6] from the door.

F. Emergency Exit Door Fight Lock Solenoid Removal

SUBTASK 52-22-41-020-004

(1) Remove the flight lock solenoid [5].

(a) Remove the bolts [3] and washers [4] from the torque link.

(b) Move the torque link to the side.

(c) Remove the cotter pin [11] and washer [12] from the flight lock solenoid [5].

(d) Remove the spring [13] and pin [14] from the flight lock solenoid [5].

(e) Move the flight lock solenoid [5] out of the door to get access to the solenoid nut [15].

(f) Disconnect the wires from the indication switch [10] to the flight lock solenoid [5].

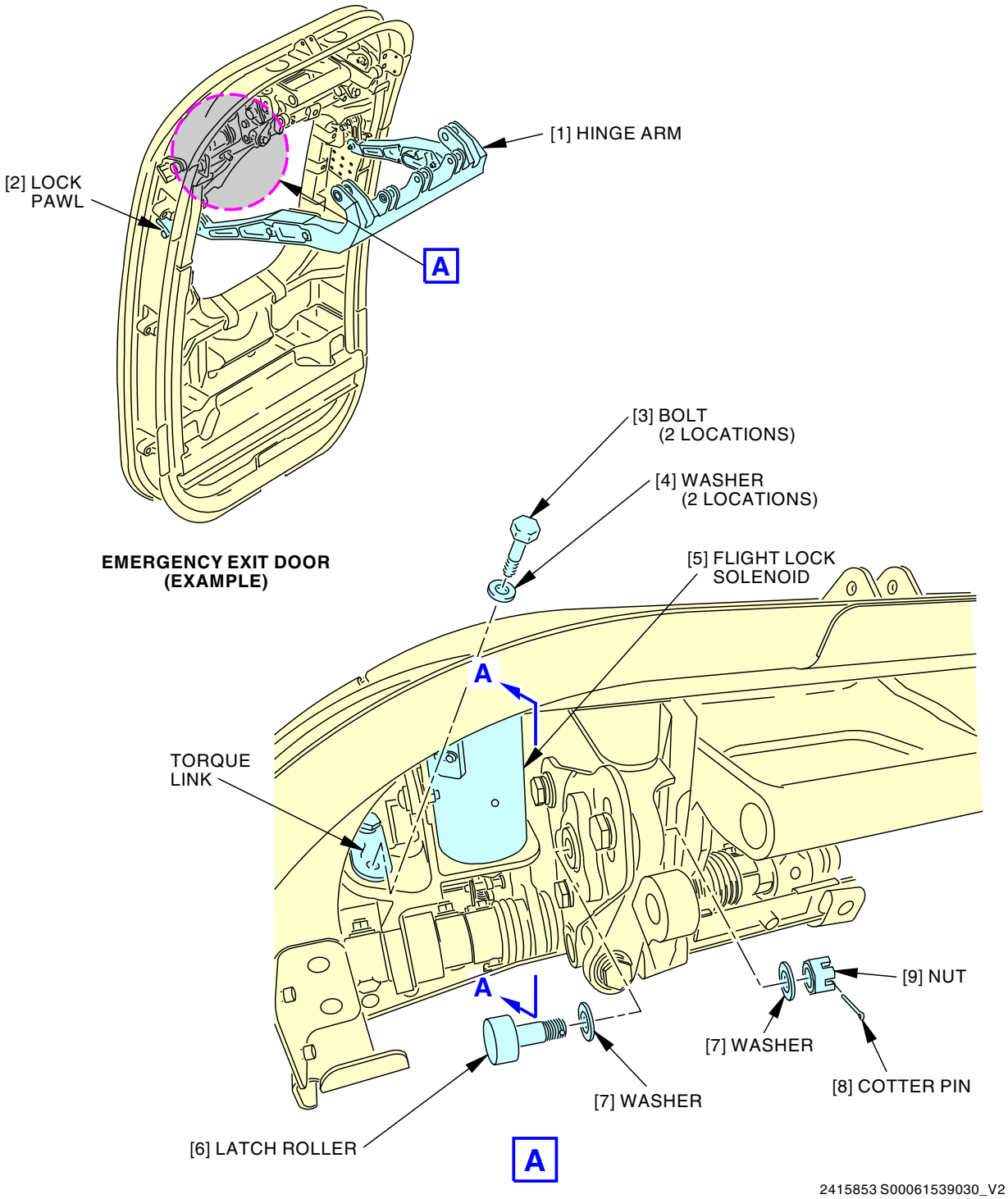
(g) Use the torque wrench adapter, SPL-2002, to remove the solenoid nut [15].

(h) Remove the solenoid washer [16] and solenoid nut [15].

(i) Remove the flight lock solenoid [5].

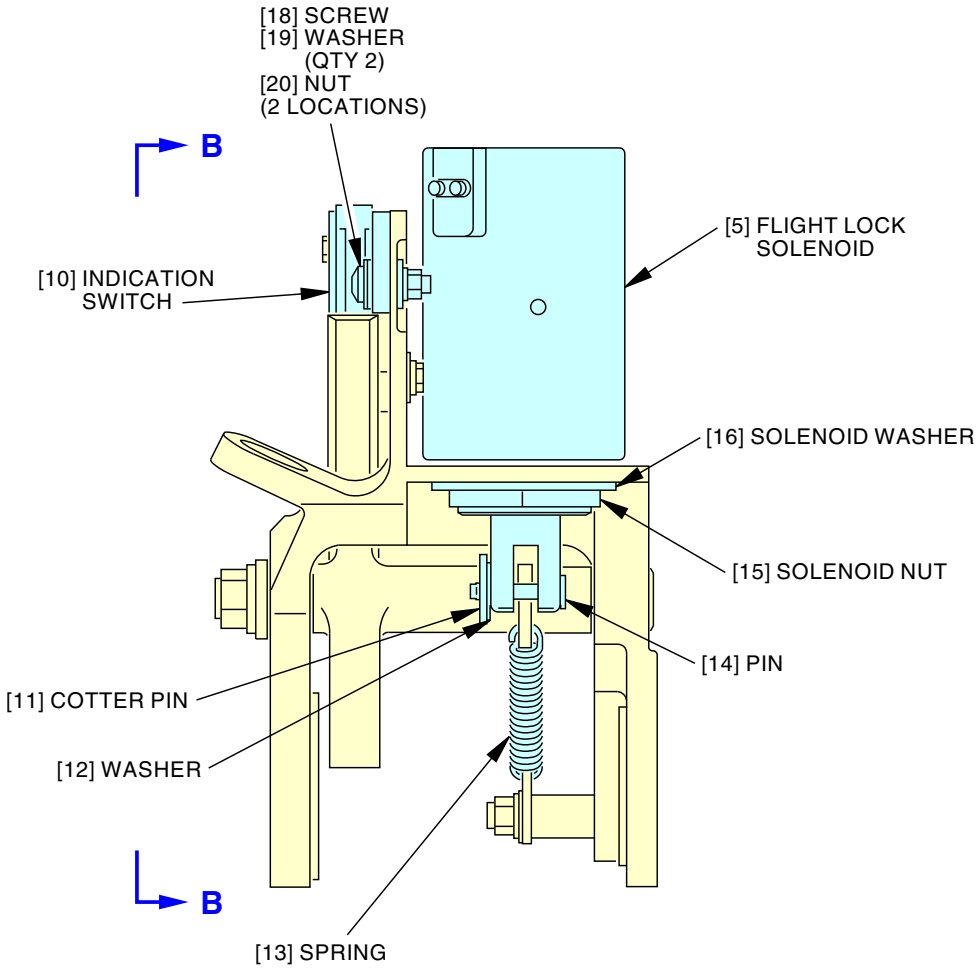
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Emergency Exit Door Flight Lock Solenoid Assembly
Figure 401/52-22-41-990-802 (Sheet 1 of 3)

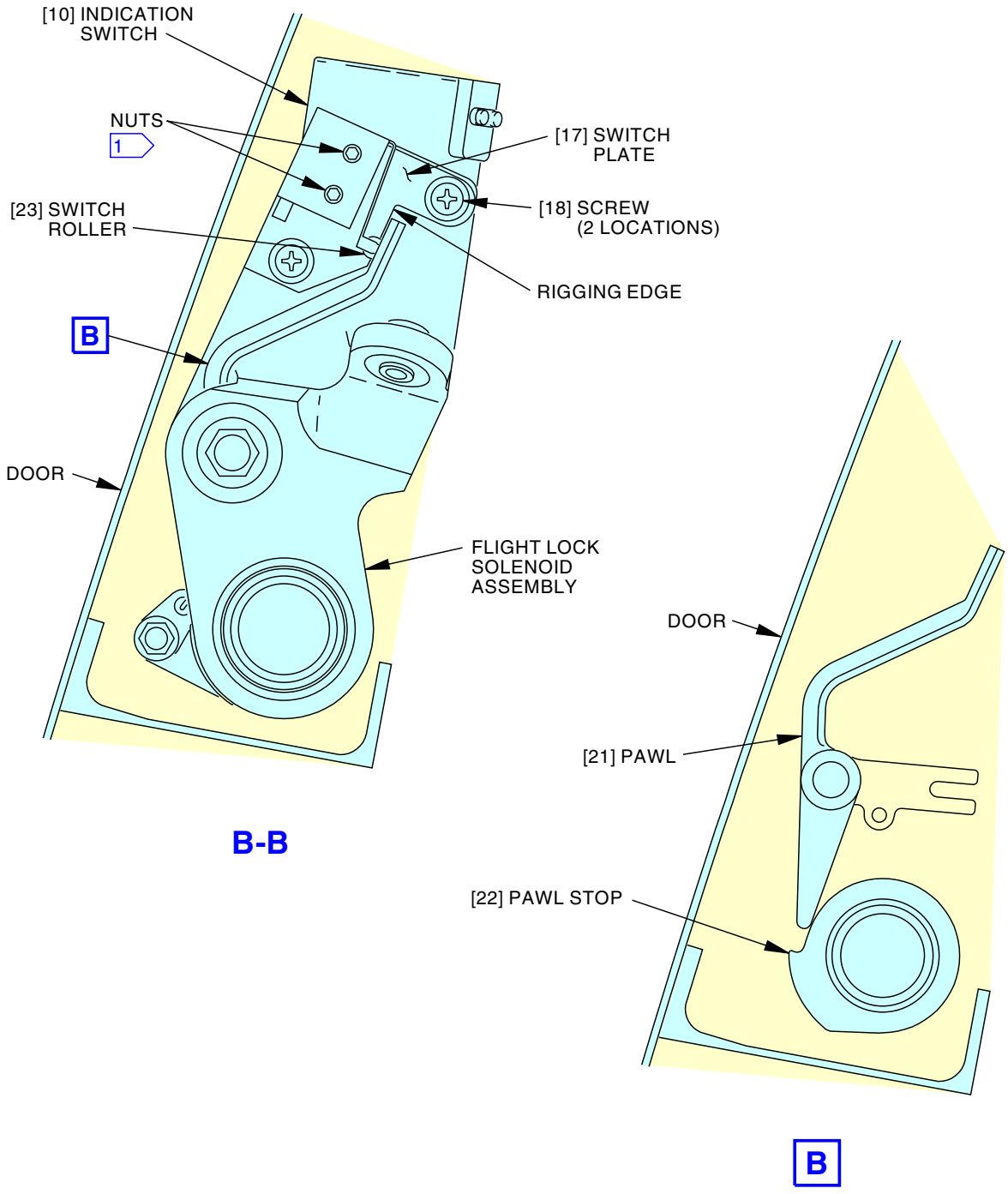
ECCN 9E991 BOEING PROPRIETARY - See title page for details



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Emergency Exit Door Flight Lock Solenoid Assembly
Figure 401/52-22-41-990-802 (Sheet 2 of 3)

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1 DO NOT MOVE THE NUTS

2415855 S00061539032_V1

Emergency Exit Door Flight Lock Solenoid Assembly
Figure 401/52-22-41-990-802 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-22-41-400-801

3. Emergency Exit Door Flight Lock Solenoid Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the emergency exit door flight lock solenoid.

B. References

Reference	Title
52-22-00-400-801	Emergency Exit Door Installation (P/B 401)
52-22-51-400-801	Emergency Exit Door Lining 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-2002	Adapter - Torque Wrench, Automatic Overwing Exit Hatch Part #: C52007-1 Supplier: 81205

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
5	Flight lock solenoid	52-22-41-01-190	SIA ALL
8	Cotter pin	52-22-41-01-105	SIA ALL
11	Cotter pin	52-22-41-01-155	SIA ALL

E. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

F. Emergency Exit Door Flight Lock Solenoid Installation

SUBTASK 52-22-41-420-001

(1) Install the flight lock solenoid [5].

(a) Remove and discard the packing rubber stop, washer, and C clip from the solenoid packing before assembly.

(b) Put the flight lock solenoid [5] in its position.

(c) Install the solenoid washer [16] and solenoid nut [15].

(d) Use the torque wrench adapter, SPL-2002, to tighten the solenoid nut [15] to 125 in-lb (14.12 N·m) - 150 in-lb (16.95 N·m).

(e) Connect the wires from the indication switch [10] to the flight lock solenoid [5].

(f) Install the pin [14] and spring [13].

(g) Install the washer [12] and new cotter pin [11].

(h) Install the bolts [3] and washers [4] in the solenoid torque link.

SUBTASK 52-22-41-400-001

(2) Install the latch roller [6] with the washers [7], nut [9], and new cotter pin [8].

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SUBTASK 52-22-41-400-002

(3) Push the hinge arm [1] latch receiver into the latch roller [6].

SUBTASK 52-22-41-210-001

(4) Make sure that the lock pawls [2] are disengaged on both legs of the hinge arm.

SUBTASK 52-22-41-420-002

(5) Push the door hinge arm towards the top of the door.

SUBTASK 52-22-41-420-003

(6) Do this task: Emergency Exit Door Installation, TASK 52-22-00-400-801.

SUBTASK 52-22-41-420-004

(7) Do this task: Emergency Exit Door Lining Installation, TASK 52-22-51-400-801.

——— END OF TASK ———

TASK 52-22-41-020-801

4. Emergency Exit Door Flight Lock Switch Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the emergency exit door flight lock switch.

B. References

Reference	Title
52-22-00-000-801	Emergency Exit Door Removal (P/B 401)

C. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

D. Prepare for the Removal

SUBTASK 52-22-41-020-005

(1) If it is necessary, remove the emergency exit door to get access to the flight lock solenoid assembly. To do this, do this task: Emergency Exit Door Removal, TASK 52-22-00-000-801.

NOTE: It can be easier to remove the door from the airplane, than work with the door in place.

SUBTASK 52-22-41-210-002

(2) Make sure that the lock pawls [2] engage both legs of the hinge arm.

SUBTASK 52-22-41-860-001

(3) Push the door hinge arm [1] towards the bottom of the door.

SUBTASK 52-22-41-020-006

(4) Remove the latch roller [6]:

(a) Pull the hinge arm latch receivers away from the latch roller [6].

(b) Remove the cotter pin [8], nut [9], washers [7], and latch roller [6] from the door.

E. Emergency Exit Door Flight Lock Switch Removal

SUBTASK 52-22-41-020-007

(1) Get access to the switch plate [17]:

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) Remove the bolts [3] and washers [4] from the torque link.

(b) Move the torque link to the side.

(c) Move the flight lock solenoid assembly away from the door to get to the switch plate [17].

SUBTASK 52-22-41-020-008

(2) Remove the switch plate [17]:

NOTE: The indication switch and switch plate are preset. Replace the switch and switch plate as a unit.

(a) Disconnect the connectors.

(b) Remove the screws [18], washers [19], and nuts [20] that hold the switch plate [17] in position.

(c) Remove the switch plate [17] from the flight lock solenoid assembly.

——— END OF TASK ———

TASK 52-22-41-420-801

5. Emergency Exit Door Flight Lock Switch Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the emergency exit door flight lock switch.

B. References

Reference	Title
52-22-00-400-801	Emergency Exit Door Installation (P/B 401)
52-22-00-730-801	Emergency Exit Door System Test (P/B 501)

C. Tools/Equipment

Reference	Description
STD-1107	Gauge - Feeler, 0.0 - 0.5 Inch, Readable to 1/1000th

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
8	Cotter pin	52-22-41-01-105	SIA ALL
17	Switch plate	52-22-41-01-185	SIA ALL

E. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

F. Emergency Exit Door Flight Lock Switch Installation

SUBTASK 52-22-41-420-005

(1) Install the switch plate [17]:

NOTE: The indication switch and switch plate are preset. Replace the switch and switch plate as a unit.

(a) Replace the connectors splices.

(b) Put the switch plate [17] in its correct position.

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WARNING DO NOT TRY TO MOVE THE NUTS THAT HOLD THE INDICATION SWITCH TO THE SWITCH PLATE. TO MAKE AN ADJUSTMENT, MOVE THE SWITCH PLATE. IF YOU DO NOT OBEY THIS WARNING, DAMAGE TO EQUIPMENT OR INJURIES TO PERSONS CAN OCCUR.

(c) Install the screws [18], washers [19], and nuts [20] that hold the switch plate [17] in its correct position.

NOTE: Install the nuts [20] sufficiently to hold the switch plate [17] in position.

SUBTASK 52-22-41-820-001

(2) Adjust the switch plate [17]:

(a) Push and hold the pawl [21] against the pawl stop [22].

(b) Adjust the clearance between the pawl [21] and the rigging edge of the switch plate [17].

NOTE: The switch roller [23] will be compressed by the pawl [21].

1) Move the 0.0 - 0.5 Inch feeler gauge, STD-1107 gently between the switch roller [23] and the pawl [21].

2) Push the 0.0 - 0.5 Inch feeler gauge, STD-1107 to the rigging edge of the switch plate [17].

NOTE: The pawl [21] must not touch the switch plate [17].

3) Make sure that the clearance is 0.016 in. (0.406 mm) between the rigging edge of the switch plate [17] and the pawl [21].

NOTE: Do not measure the clearance at the radius of the pawl [21].

4) Tighten the two screws [18] evenly.

(c) Do these steps to make sure the minimum clearance is correct:

1) Use a 0.0 - 0.5 Inch feeler gauge, STD-1107 to measure the clearance between the pawl [21] and the rigging edge of the switch plate [17].

NOTE: The switch roller [23] will be compressed by the pawl [21].

2) Move the 0.0 - 0.5 Inch feeler gauge, STD-1107 gently between the switch roller [23] and the pawl [21].

3) Push the 0.0 - 0.5 Inch feeler gauge, STD-1107 to the rigging edge of the switch plate [17].

4) Make sure that a 0.011 in. (0.279 mm) 0.0 - 0.5 Inch feeler gauge, STD-1107 will move between the rigging edge of the switch plate [17] and the pawl [21].

NOTE: Do not measure the clearance at the radius of the pawl [21].

a) Do the clearance adjustment of 0.016 in. (0.406 mm) again if the 0.0 - 0.5 Inch feeler gauge, STD-1107 does not move between the pawl [21] and switch plate [17].

(d) Do these steps to make sure that the maximum clearance is correct:

1) Use a 0.0 - 0.5 Inch feeler gauge, STD-1107 to measure the clearance between the pawl [21] and the rigging edge of the switch plate [17].

NOTE: The switch roller [23] will be compressed by the pawl [21].

2) Move the 0.0 - 0.5 Inch feeler gauge, STD-1107 gently between the switch roller [23] and the pawl [21].

3) Push the 0.0 - 0.5 Inch feeler gauge, STD-1107 to the rigging edge of the switch plate [17].

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4) Make sure that a 0.021 in. (0.533 mm) 0.0 - 0.5 Inch feeler gauge, STD-1107 will not move between the rigging edge of the switch plate [17] and pawl [21].

NOTE: Do not measure the clearance at the radius of the pawl [21].

a) Do the clearance adjustment of 0.016 in. (0.406 mm) again if the 0.0 - 0.5 Inch feeler gauge, STD-1107 moves between the pawl [21] and switch plate [17].

(e) Connect the connectors.

SUBTASK 52-22-41-420-006

(3) Install the latch roller [6] with the washers [7], nut [9], and new cotter pin [8].

SUBTASK 52-22-41-420-007

(4) Push the hinge arm [1] latch receiver into the latch roller [6].

SUBTASK 52-22-41-210-003

(5) Make sure that the lock pawls [2] are disengaged on both legs of the hinge arm.

SUBTASK 52-22-41-860-002

(6) Push the door hinge arm towards the top of the door.

G. Put the Airplane Back to Its Usual Condition.

SUBTASK 52-22-41-420-008

(1) If it is necessary, do this task: Emergency Exit Door Installation, TASK 52-22-00-400-801.

SUBTASK 52-22-41-710-001

(2) Do this task: Emergency Exit Door System Test, TASK 52-22-00-730-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

EMERGENCY EXIT DOOR LINING - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the emergency exit door lining

(2) An installation of the emergency exit door lining.

B. The emergency exit door lining is referred to as the door lining in this procedure.

C. This procedure is the same for each emergency exit door.

TASK 52-22-51-000-801

2. Emergency Exit Door Lining Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the emergency exit door lining.

B. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

C. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door

D. Prepare for the Removal

SUBTASK 52-22-51-010-001

(1) To get access to the P91 panel, open this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

SUBTASK 52-22-51-860-001

WARNING

WHEN YOU OPEN THE P91 AND P92 PANELS, MAKE SURE THAT THE OUTER DOOR STAYS AS OPEN AS POSSIBLE. IF THE OUTER DOOR TURNS IN, THE ATTACHED DOOR COMPONENTS COULD TOUCH THE INNER DOOR COMPONENTS. THIS CAN CAUSE AN ARC CONDITION WHEN YOU SUPPLY POWER. IF YOU DO NOT OBEY, DAMAGE TO EQUIPMENT AND INJURY TO PERSONNEL CAN OCCUR.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(WARNING PRECEDES)

WARNING

DO NOT TOUCH THE CONDUCTORS IN THE P91 AND P92 PANELS. BE CAREFUL WHEN YOU GET ACCESS TO THE CIRCUIT BREAKERS ON THE INNER SIDE OF THE P91 AND P92 PANELS (ROW F). IF IT IS POSSIBLE, REMOVE AIRPLANE ELECTRICAL POWER FIRST. THE P91 AND P92 PANELS HAVE HIGH VOLTAGES AND CURRENTS. ELECTRICAL VOLTAGE AND CURRENT CAN KILL YOU OR CAUSE INJURIES.

(2) Open this circuit breaker and install safety tag:

Power Distribution Panel Number 1, P91

Row	Col	Number	Name
D	9	C01280	DOOR AREA HTR-FWD

E. Emergency Exit Door Lining Removal

SUBTASK 52-22-51-000-001

(1) Remove the door lining [8]:

(a) If it is necessary, remove the armrest pad, armrest cover, and bracket.

(b) Remove the screws [3] that attach the cover assembly [1] and closing strap [2] to the stowage pouch.

(c) Remove the cover assembly [1] and closing strap [2].

(d) Remove the cover [10] from the door to get access to the release handle.

WARNING

DO NOT MOVE THE INTERIOR OR EXTERIOR DOOR HANDLES. THE DOOR WILL OPEN AUTOMATICALLY. INJURY TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

WARNING

MAKE SURE THAT THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING-LOADED TO OPEN AUTOMATICALLY AND INJURIES COULD OCCUR.

(e) Open the door.

(f) Remove the screw [11], washer [6], washer [12], and nut [7] that attach the release handle to the door structure.

1) Pull down on the release handle to get access to the screw [11].

WARNING

OBEY THE PRECAUTIONS. IF YOU DO NOT OBEY THE PRECAUTIONS, INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

(g) If it is necessary to close the door without installation of the door lining, make sure that the door release and lift handles are installed.

1) Use the door release handle to open the door.

2) Do not use hands or tools to release the door locking mechanism.

3) Keep hands clear of the door counterbalances, snubber and locking mechanism.

(h) Remove the release handle pan [9].

(i) Remove the screws [5] and washers [4] that hold the door lining [8] to the door structure.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(j) Remove the door lining [8].

(k) Disconnect the door lining electric heater.

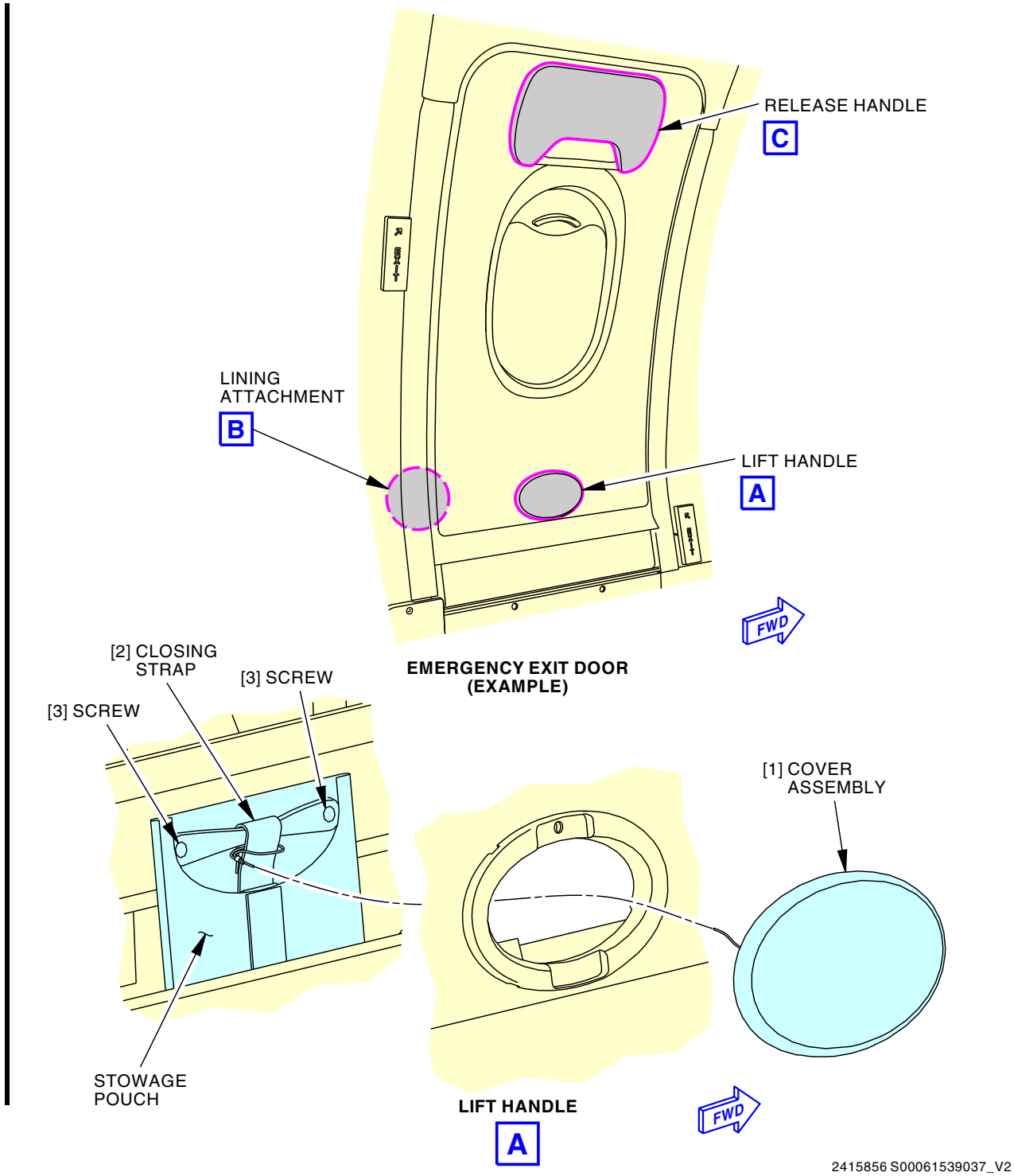
(l) Remove the door lining from the door frame.

SUBTASK 52-22-51-020-001

(2) If it is necessary, remove the door insulation.

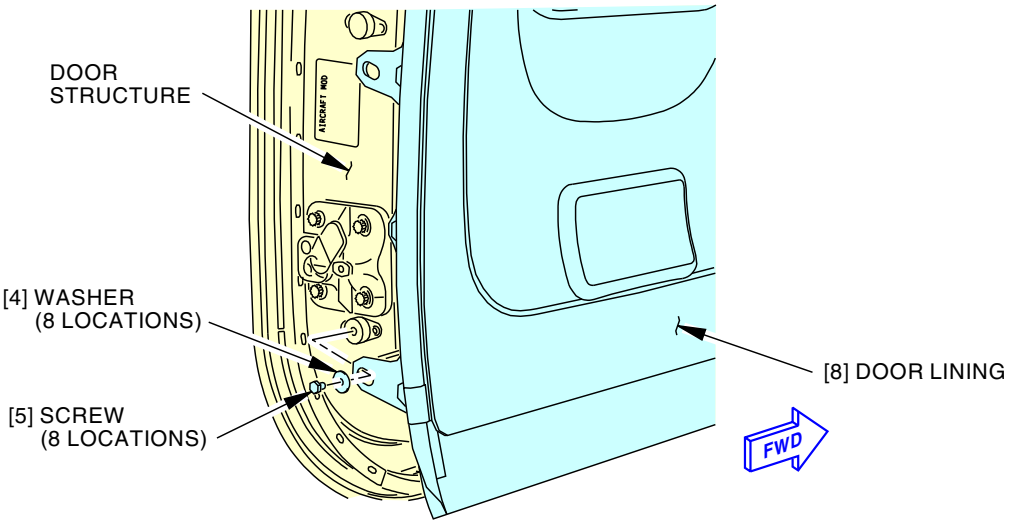
END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



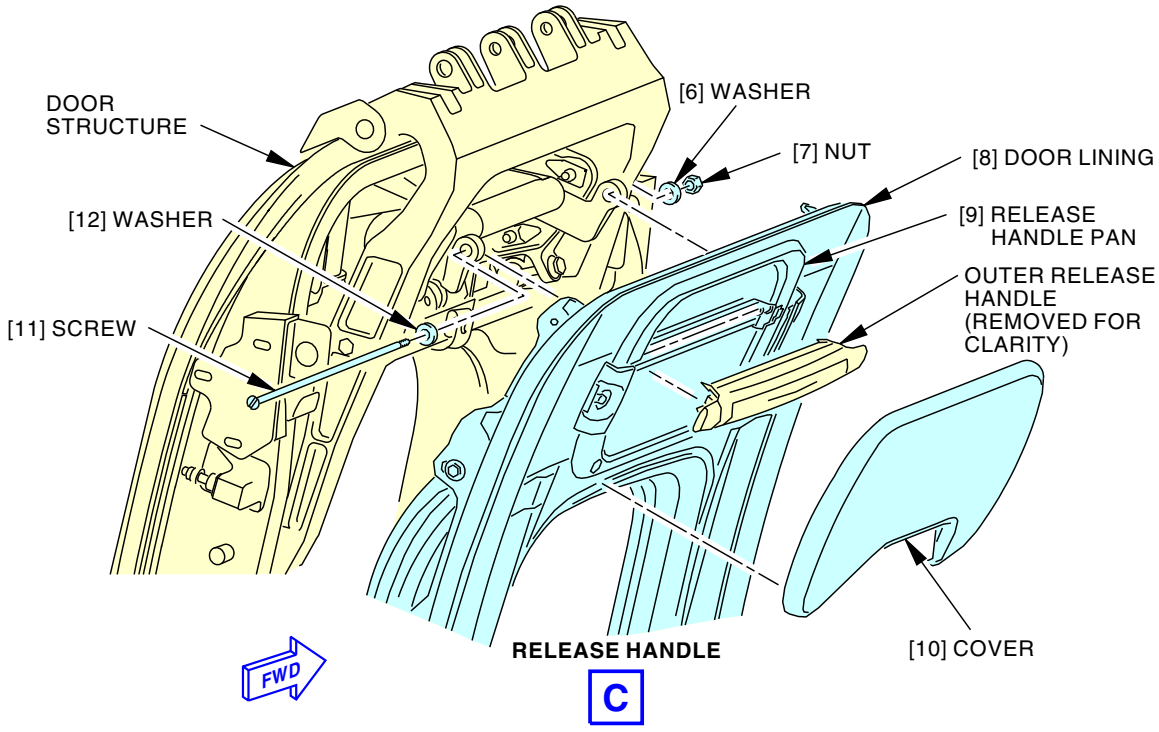
Emergency Exit Door Lining Installation
Figure 401/52-22-51-990-802 (Sheet 1 of 2)

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**LINING ATTACHMENT
(EXAMPLE)**

B



RELEASE HANDLE

C

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**Emergency Exit Door Lining Installation
Figure 401/52-22-51-990-802 (Sheet 2 of 2)**

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TASK 52-22-51-400-801

3. Emergency Exit Door Lining Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the emergency exit door lining.

B. References

Reference	Title
21-45-00-700-802	Emergency Exit Hatch Heaters Operational Test (P/B 501)

C. Consumable Materials

Reference	Description	Specification
A50544	Adhesive - Urethane Adhesive for Bonding	BMS5-105, Type II, Class 1 or 3

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
8	Door lining	52-22-51-01-132	SIA ALL

E. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

F. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door

G. Emergency Exit Door Lining Installation

SUBTASK 52-22-51-400-001

(1) If it is removed, install the door insulation in the door frame.

SUBTASK 52-22-51-410-001

(2) Install the emergency exit door lining:

(a) Put the door lining [8] in the correct position.

(b) Connect the door lining electric heater.

(c) Install the screws [5] and washers [4] that hold the door lining [8] to the door structure.

(d) Install the screws [3] that attach the cover assembly [1] and closing strap [2] to the stowage pouch.

1) Stow the closing strap [2] in the stowage pouch.

2) Insert the cover assembly [1] through the access opening in door lining [8].

(e) Install the release handle pan [9].

(f) Install the screw [11], washer [6], washer [12], and nut [7] that attach the release handle to the door structure.

(g) Close the door.

(h) Install the cover [10] over the door release handle.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(i) If it is necessary, install the bracket, armrest cover, and armrest pad.

1) Install the armrest pad on the armrest cover, do these steps:

a) Apply a continuous bead of adhesive, A50544, approximately 3/16 in. (5 mm) in the diameter around the upper surface of the armrest cover common to the contact area of the pad.

b) Attach the armrest pad on the armrest cover.

c) Apply pressure to the armrest pad.

d) Remove the excess of adhesive.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 52-22-51-860-002

WARNING

WHEN YOU OPEN THE P91 AND P92 PANELS, MAKE SURE THAT THE OUTER DOOR STAYS AS OPEN AS POSSIBLE. IF THE OUTER DOOR TURNS IN, THE ATTACHED DOOR COMPONENTS COULD TOUCH THE INNER DOOR COMPONENTS. THIS CAN CAUSE AN ARC CONDITION WHEN YOU SUPPLY POWER. IF YOU DO NOT OBEY, DAMAGE TO EQUIPMENT AND INJURY TO PERSONNEL CAN OCCUR.

WARNING

DO NOT TOUCH THE CONDUCTORS IN THE P91 AND P92 PANELS. BE CAREFUL WHEN YOU GET ACCESS TO THE CIRCUIT BREAKERS ON THE INNER SIDE OF THE P91 AND P92 PANELS (ROW F). IF IT IS POSSIBLE, REMOVE AIRPLANE ELECTRICAL POWER FIRST. THE P91 AND P92 PANELS HAVE HIGH VOLTAGES AND CURRENTS. ELECTRICAL VOLTAGE AND CURRENT CAN KILL YOU OR CAUSE INJURIES.

(1) Remove the safety tag and close this circuit breaker:

Power Distribution Panel Number 1, P91

Row	Col	Number	Name
D	9	C01280	DOOR AREA HTR-FWD

SUBTASK 52-22-51-410-003

(2) Close this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

SUBTASK 52-22-51-710-001

(3) Do this task: Emergency Exit Hatch Heaters Operational Test, TASK 21-45-00-700-802.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CARGO DOOR - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks:

(1) Open the cargo door

(2) Open the Cargo Door when the Lock Mechanism will not Operate

(3) Close the cargo door.

(4) Cargo Door Corrosion Prevention.

B. This procedure is the same for the forward and aft cargo door.

TASK 52-31-00-580-801

2. Open the Cargo Door

(Figure 201)

A. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

B. Procedure

SUBTASK 52-31-00-580-001

(1) Open the cargo door:

(a) Pull the door handle out of its recess.

(b) Rotate the handle counterclockwise to unlatch the door.

NOTE: Rotating the handle counterclockwise disengages the door latch mechanisms.

NOTE: The door will now begin to move inboard by the action of the counterbalance mechanism.

(c) Return the handle to its recess in the door.

(d) Push the door inboard to open it.

NOTE: When you begin to push the door inboard, the door counterbalance will lift the door to the fully open position and hold it there.

——— END OF TASK ———

TASK 52-31-00-580-802

3. Close the Cargo Door

(Figure 201)

A. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

B. Prepare to Close the Cargo Door

SUBTASK 52-31-00-860-001

(1) Before you close the door from the outside, examine these things:

(a) To prevent cargo from contacting the door components, secure all cargo nets.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) Make sure the door frame is clear of any obstructions, dirt and debris.

C. Close the Cargo Door

SUBTASK 52-31-00-580-002

(1) Close the cargo door:

(a) Pull the soft-grip bungee lanyard at the forward edge of the door.

NOTE: This will pull the door out of the uplock and lower the door until you can reach the handle.

(b) When you can reach the door handle, release the lanyard and the bungee will retract the lanyard back into the cargo compartment.

(c) Pull the door handle out of the recess and rotate the handle counterclockwise.

NOTE: When you rotate the handle counterclockwise, the latch rollers are aligned to enter the latch receivers.

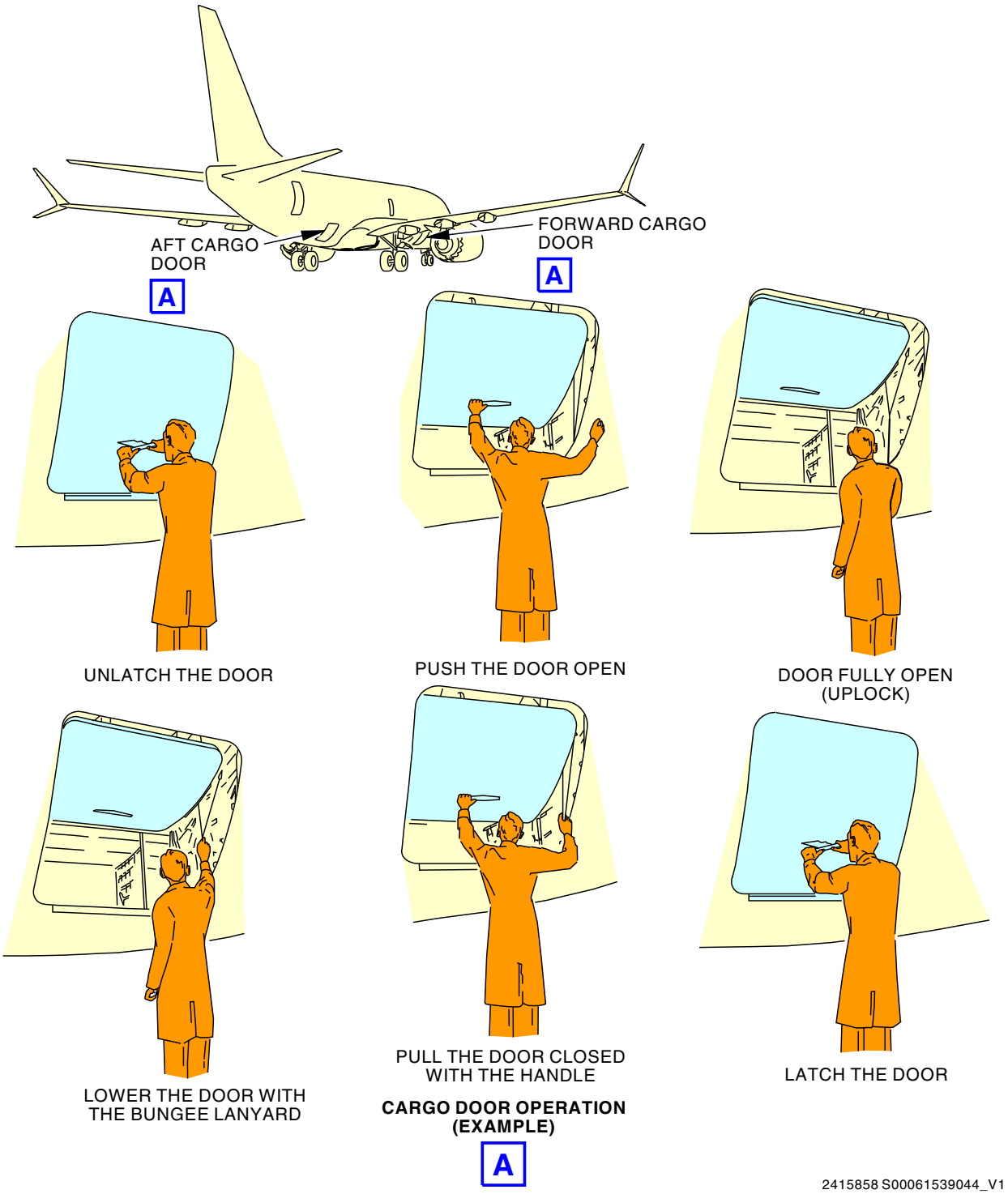
(d) Pull the door to the closed position with the handle.

(e) Turn the handle clockwise to fully close and latch the door.

(f) Return the handle to its recess.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Cargo Doors Operation Maintenance Practice
Figure 201/52-31-00-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-31-00-580-803

4. Open the Cargo Door when the Lock Mechanism will not Operate

A. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

B. Procedure

SUBTASK 52-31-00-580-003

(1) Do these steps to open the cargo door:

(a) Open the access panel on the outer skin of the door to get access to the latch torque tube.

(b) Turn the torque tube to unlatch the door..

——— END OF TASK ———

TASK 52-31-00-600-801

5. Cargo Door Corrosion Prevention

A. References

Reference	Title
12-25-31-640-801	Cargo Door Servicing (P/B 301)
52-31-00-200-801	Cargo Door Check (P/B 601)

B. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23
G00834	Cloth - Lint-free Cotton	

C. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

D. General

SUBTASK 52-31-00-800-001

(1) Corrosion may occur on the internal and external surfaces of the door structure. especially the inside lower corners, the connection points, and the door mechanism.

(2) Corrosion and cracks have been found on the stop fittings that are mounted on the door.

(3) Corrosion and cracks have been found on the door balance springs.

(4) Corrosion and cracks have been found on the door balance mechanism cables. Cables with corrosion were found without lubrication.

(a) Make sure to lubricate these cables.

(5) Corrosion, cracks, and weak handle latch springs have been found.

(6) Some items in this section maybe subject to the mandatory requirements for corrosion prevention and control programs for aging airplanes.

(7) Corrosion Prevention

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(a) Do these tasks, Cargo Door Check, TASK 52-31-00-200-801 to detect the early stages of corrosion.

(b) Look for missing fasteners, white powdery deposits, and discolorations, as signs of corrosion.

1) If signs of corrosion are found, then a corrosion prevention program should be started to prevent the build up of corrosion products.

2) If corrosion products are allowed to build up, then they will cause further corrosion.

3) If corrosion is found, the refer to the Structural Repair Manual for detail instructions for the removal of corrosion.

(c) After the corrosion products are cleaned, make sure that the protective finishes are serviceable.

1) If only minor corrosion is found, then make sure that the area is clean.

2) Apply corrosion inhibiting compound on the affected area.

3) Make sure that the protective finish is restored at the next maintenance opportunity.

(8) Frequency of Application

(a) Periodic inspection is required to areas identified as prone to corrosion and should be scheduled to your Maintenance Planning Document.

(b) Periodic application of BMS 3-23 compounds are necessary to areas identified as prone to corrosion and should be scheduled to your Maintenance Planning Document.

1) Do the prevention treatment to the exterior surface of the door at the same recommended interval as the exterior surface of the fuselage.

E. Corrosion Prevention

SUBTASK 52-31-00-620-001

(1) Prevention Treatment

(a) Remove the door liner to get access to the interior surfaces of the door.

(b) Clean the drains and drain paths.

(c) Cargo Door Check, TASK 52-31-00-200-801

1) Remove or repair any corrosion that you find.

(d) Apply corrosion inhibiting compound, G00009 to the interior surfaces of the door.

1) Make sure that the corrosion inhibiting compound, G00009 completely covers the surfaces, with special attention given to the lower corners and the mechanism.

(e) Apply corrosion inhibiting compound, G00009 to the door frame and the upper and lower web.

(f) If it is necessary, apply corrosion inhibiting compound, G00009 to the exterior surfaces of the door.

(g) Lubricate the door. Cargo Door Servicing, TASK 12-25-31-640-801

(h) If the door has cables, then do these steps:

1) Use a clean lint-free cloth, G00834 to remove grease and corrosion inhibiting compound, G00009 from the cable.

2) Examine the cables to make sure that it is serviceable.

3) Use a clean lint-free cloth, G00834 to apply a thin layer of grease, D00633 to the cables.

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(i) Install the door lining.

(j) Cargo doors with drain valves, do these steps:

1) Clean the drain hole.

2) Examine the drain seal or plunger for alignment and freedom of movement.

a) If it is necessary, remove the drain valve from the door and clean the debris.

<1> If it is necessary, replace the drain valve.

b) Install the drain valve.

CAUTION DO NOT APPLY MORE THAN THE MAXIMUM SPECIFIED TORQUE WHEN YOU TIGHTEN THE PARTS. DAMAGE TO THE PARTS CAN OCCUR IF YOU APPLY TOO MUCH TORQUE.

<1> Tighten the fasteners to 10 to 15 pound inches (1.1-1.7 Nm).

——— END OF TASK ———

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CARGO DOOR - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Cargo door removal

(2) Cargo door installation.

B. This procedure is the same for the forward and aft cargo door.

TASK 52-31-00-000-801

2. Cargo Door Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the cargo door.

B. Tools/Equipment

Reference	Description
STD-1166	Block - Wood, 1 to 3 Inch Thick, More Than 6 Inch Length
STD-11995	Nut - Plain, Hexagon, Per AN315-6R Specifications
STD-11996	Washer - Flat, Per NAS1149C0763R Specifications

C. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

D. Prepare for the Removal

SUBTASK 52-31-00-010-001

(1) Get access to the door as follows:

(a) Close and latch the door.

(b) Remove the door lining.

SUBTASK 52-31-00-860-002

(2) Safety the counterbalance [4] as follows:

(a) Make sure the door is closed and latched.

(b) Remove the screw [11], washer [12], and sleeve [10] from the guide pin [5].

(c) Install a washer, STD-11996, and nut, STD-11995, on the guide pin [5] against the adjustment nut [13].

NOTE: Install the nut loosely. This will hold the spring in the counterbalance [4] and stop its operation.

E. Cargo Door Removal

SUBTASK 52-31-00-020-001

(1) Disconnect the lanyard [9] from the fuselage structure:

(a) Disengage the split rings [8] that connect the lanyard [9] to the cargo compartment ceiling.

(b) Remove the bolt [42], washer [43], and nut [44] that connect the lanyard [9] to the forward fuselage structure.

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(c) Safety the lanyard [9] to the cargo door [1].

SUBTASK 52-31-00-020-002

(2) Disconnect the cable [21] and sheave [20] from the cargo compartment ceiling as follows:

(a) Unlatch and open the cargo door [1] 1 in. (25 mm) - 2 in. (51 mm).

(b) Install a wood block, STD-1166, under the lower stops to hold the cargo door [1] up.

(c) Make sure the cable [21] is loose.

(d) Remove the lockwire [15] from the alignment bolt [16].

(e) Remove the alignment bolt [16] and retainer ring [18].

(f) Remove the cotter pin [22], pin [14], and washer [19].

(g) Safety the cable [21] and sheave [20] to the cargo door [1].

(h) Remove the wood block, STD-1166.

SUBTASK 52-31-00-210-001

(3) Do a visual inspection of the cargo door counterbalance system to make sure it is disconnected.

SUBTASK 52-31-00-020-003

(4) Disconnect the snubber [2] from the door structure:

(a) Close and latch the door.

(b) Remove the bolt [23], washers [24], and nut [25] that attach the snubber [2] to the door structure.

(c) Remove the spacer [26].

(d) Remove the snubber [2] from the cargo door [1] and safety it away from the cargo door [1].

SUBTASK 52-31-00-020-004

(5) Disconnect the hinge arm [3] from the door structure:

(a) Remove the bolts [27], bolts [30], washers [28], washers [31], and shims [29] that attach the hinge arms [3] to the door structure.

(b) Disconnect the hinge arms [3] and carefully move them away from the cargo door [1].

SUBTASK 52-31-00-020-005

WARNING

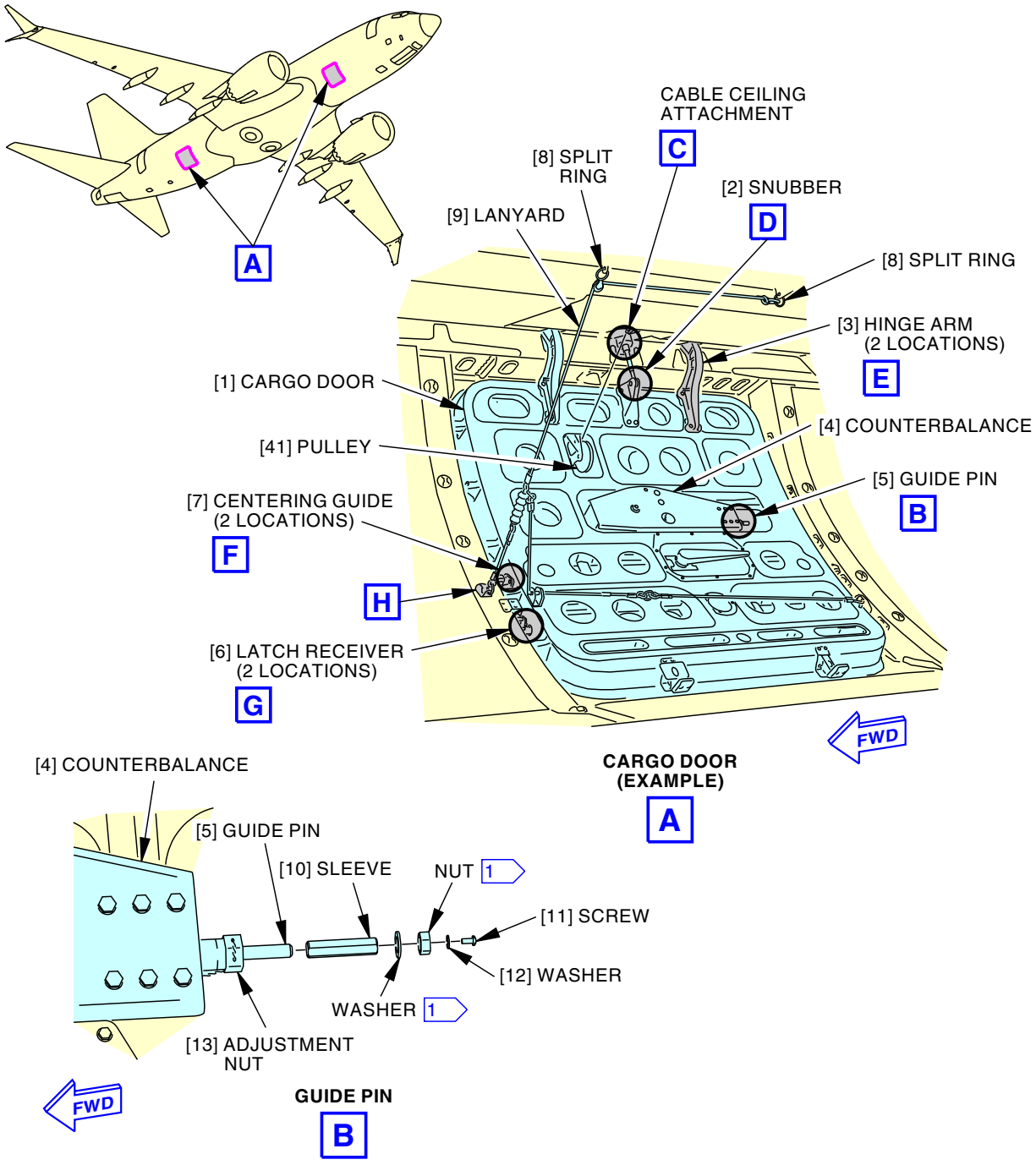
BE CAREFUL WHEN YOU MOVE THE DOOR . THE DOOR IS HEAVY. INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

(6) Carefully lift the cargo door [1] from the fuselage frame and remove from the airplane.

NOTE: The door weights approximately 112 lb (51 kg).

END OF TASK

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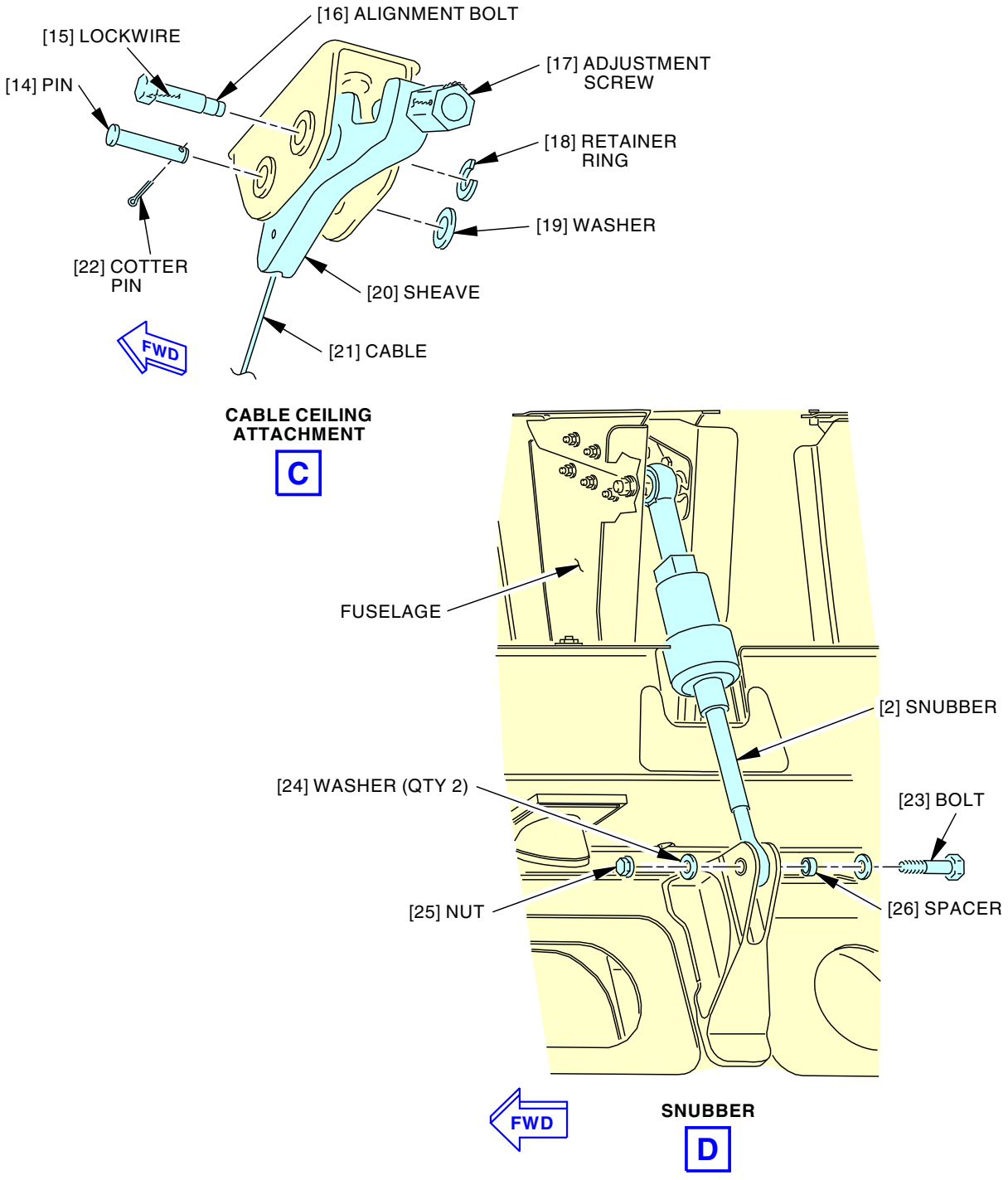


1 INSTALL THE WASHER AND NUT TO SAFETY THE COUNTERBALANCE.

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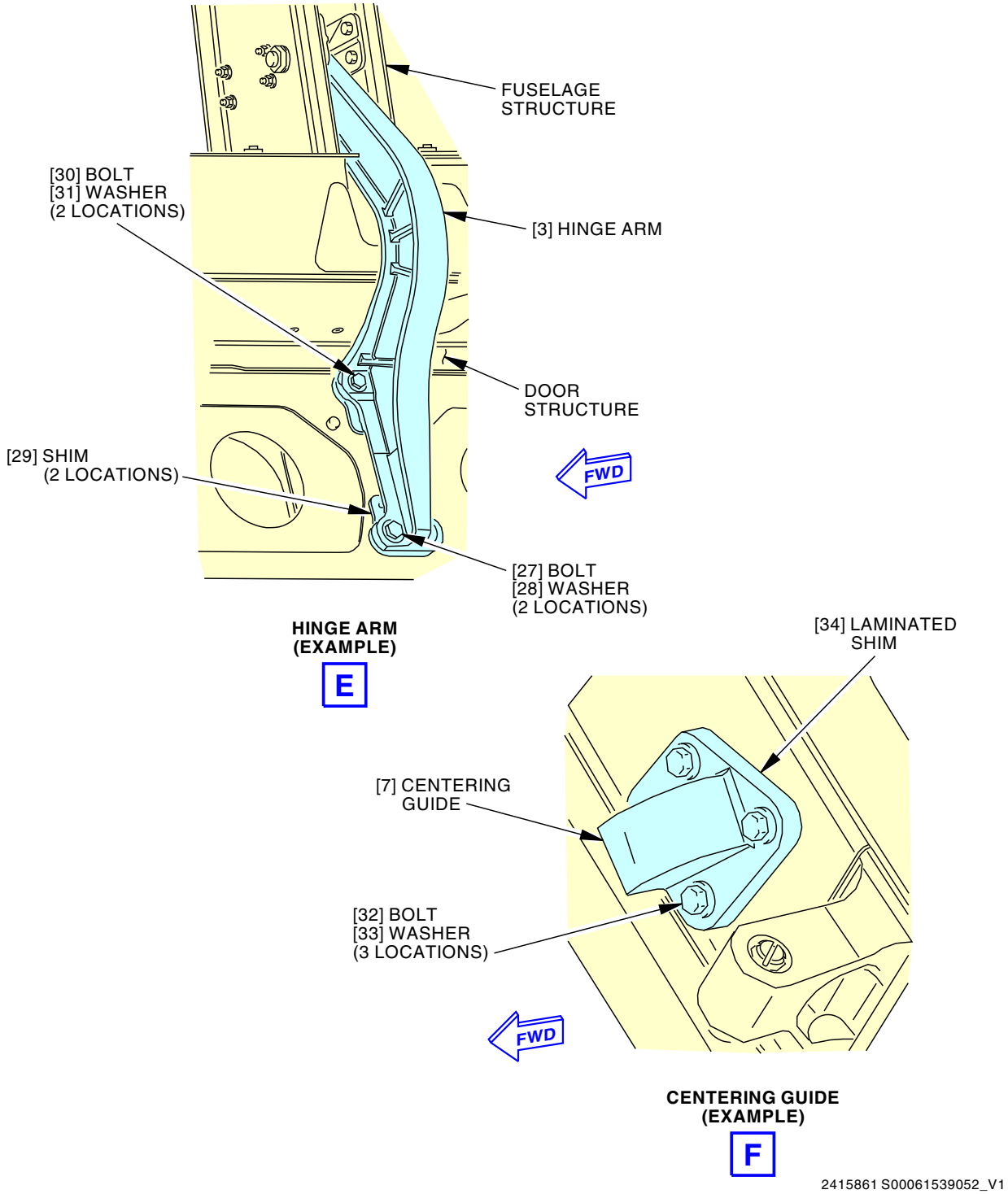
Cargo Door Installation
Figure 401/52-31-00-990-811 (Sheet 1 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



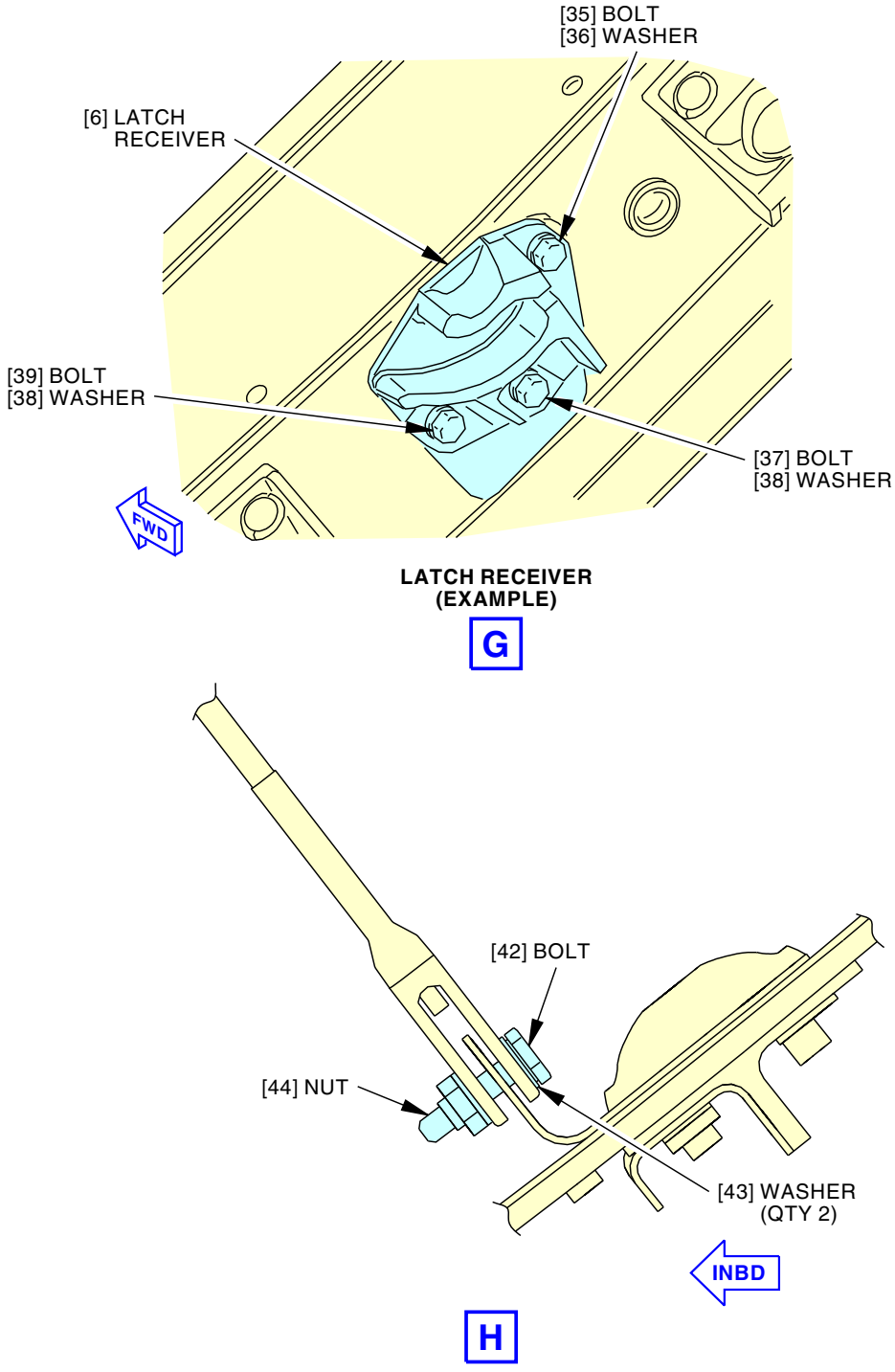
Cargo Door Installation
Figure 401/52-31-00-990-811 (Sheet 2 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Cargo Door Installation
Figure 401/52-31-00-990-811 (Sheet 3 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Cargo Door Installation
Figure 401/52-31-00-990-811 (Sheet 4 of 4)

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TASK 52-31-00-400-801

3. Cargo Door Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the cargo door.

B. References

Reference	Title
05-51-91-790-801	Cabin Pressure Leak Test (P/B 201)
52-31-00-200-802	Cargo Door Pressure Seal Check (P/B 601)
52-31-00-700-801	Cargo Door System Test (P/B 501)
52-31-00-820-801	Cargo Door Adjustment (P/B 501)

C. Tools/Equipment

Reference	Description
STD-11995	Nut - Plain, Hexagon, Per AN315-6R Specifications
STD-11996	Washer - Flat, Per NAS1149C0763R Specifications

D. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33
G01048	Lockwire - MS20995C32, Corrosion Resistant Steel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Cargo door	52-31-00-01B-416	SIA ALL
		52-31-00-14-560	SIA ALL
		52-31-00-14-561	SIA ALL
22	Cotter pin	52-31-00-01B-275	SIA ALL
		52-31-00-14-365	SIA ALL
29	Shim	52-31-00-09B-080	SIA ALL
		52-31-00-15-070	SIA ALL

F. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

G. Prepare for the Installation

SUBTASK 52-31-00-010-002

(1) Prepare the cargo door [1] and the fuselage frame for installation and adjustment:

NOTE: These steps are for a new or repaired cargo door [1] and will make it easier to put the cargo door [1] in the fuselage frame and to connect and adjust the mechanisms.

(a) Remove the bolts [32], and washers [33] that attach the forward and aft centering guides [7] to the cargo door [1].

(b) Remove the centering guides [7] and laminated shim [34] from the cargo door [1].

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(c) Loosen the bolt [35], bolt [37], bolt [39], washer [36], and washer [38] that attach the forward and aft latch receivers [6] to the fuselage frame.

(d) Remove the lock springs.

(e) Turn the stop pins inboard on the forward and aft edges of the cargo door [1].

H. Cargo Door Installation

SUBTASK 52-31-00-420-001

WARNING

BE CAREFUL WHEN YOU MOVE THE DOOR . THE DOOR IS HEAVY. INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

(1) Carefully move the cargo door [1] into the fuselage frame and into the door closed position.

NOTE: The door weights approximately 112 lb (51 kg).

(a) Inspect the pressure seal of the door prior to installation, do this task: Cargo Door Pressure Seal Check, TASK 52-31-00-200-802.

SUBTASK 52-31-00-420-002

(2) Connect the hinge arm [3] to the door structure:

(a) Put the hinge arm [3] in their correct position on the door structure.

(b) Do a check on the length of the bolts [27], bolts [30] with the new laminated shims [29] thickness.

1) If necessary, install new bolts [27], bolts [30] of a different length.

(c) Install the bolts [27], bolts [30], washers [28], washers [31], and shims [29] that attach the hinge arms [3] to the door structure.

SUBTASK 52-31-00-410-001

(3) Install the cargo door [1] and fuselage frame components as follows:

(a) Put the forward and aft centering guides [7] and laminated shim [34] in their correct position on the cargo door [1].

(b) Install the bolts [32], and washers [33] that attach the forward and aft centering guides [7] to the cargo door [1].

(c) If more adjustment is not necessary, tighten the bolt [35], bolt [37], bolt [39], washer [36], and washer [38] that attach the forward and aft latch receivers [6] to the fuselage frame.

SUBTASK 52-31-00-420-003

(4) Connect the snubber [2] to the door structure:

(a) Install the spacer [26].

(b) Install the bolt [23], washers [24], and nut [25] that attach the snubber [2] to the door structure.

SUBTASK 52-31-00-420-004

(5) Connect the cable [21] and sheave [20] to the cargo compartment ceiling:

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WARNING MAKE SURE THAT YOU SAFETY THE COUNTERBALANCE BEFORE YOU CONNECT THE COUNTERBALANCE OR CABLE. THERE IS A VERY STRONG SPRING IN THE COUNTERBALANCE AND CABLE. INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

(a) Make sure that the washer, STD-11996 and the nut, STD-11995, are installed on the guide pin [5] against the adjustment nut [13] on the end of the counterbalance [4].

NOTE: This will hold the spring in the counterbalance [4] and stop its operation.

(b) Make sure that the cable [21] is installed through the pulley [41] on the cargo door [1].

(c) Apply a light coat of grease, D00633, to the pin [14], alignment bolt [16] and the mating surfaces.

(d) Install the pin [14], washer [19], and new cotter pin [22] to attach the cable [21] and sheave [20] to the cargo compartment ceiling.

(e) Install the alignment bolt [16] and retainer ring [18] that attach the cable [21] and sheave [20] to the cargo compartment ceiling.

(f) Install the MS20995C32 lockwire, G01048, between the alignment bolt [16] and the adjustment screw [17].

(g) Connect the lanyard [9] to the fuselage structure:

1) Engage the split rings [8] to connect the lanyard [9] to the cargo compartment ceiling.

2) Install the bolt [42], washer [43], and nut [44] to connect the lanyard [9] to the forward fuselage structure.

SUBTASK 52-31-00-820-001

(6) Do this task: Cargo Door Adjustment, TASK 52-31-00-820-801.

SUBTASK 52-31-00-730-001

(7) Do this task: Cargo Door System Test, TASK 52-31-00-700-801.

SUBTASK 52-31-00-790-001

(8) Do this task: Cabin Pressure Leak Test, TASK 05-51-91-790-801.

I. Put the Airplane Back to Its Usual Condition

SUBTASK 52-31-00-410-002

(1) If removed, install the door lining.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CARGO DOOR - ADJUSTMENT/TEST

1. General

A. This procedure has these tasks:

(1) An adjustment of the cargo door.

(2) A system test of the cargo door.

B. This procedure is the same for the forward or aft cargo door.

TASK 52-31-00-820-801

2. Cargo Door Adjustment

(Figure 501, Figure 502, Figure 503, Figure 504, Figure 505, Figure 506, Figure 507)

A. General

(1) Do the adjustment task with no load on the cargo door or the fuselage frame. Do the task with airplane at its Operational Empty Weight (OEW) and the airplane supported on its landing gear.

(2) After the adjustment is completed, make sure that all adjustment points are locked and sealed.

B. References

Reference	Title
52-71-31-820-801	Cargo Door Indication Switch - Adjustment (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-1557	Gauge - Force Part #: DG-200 Supplier: 92456 Part #: FDIX 100 Supplier: 0BFD9 Part #: FDIX 50 Supplier: 0BFD9 Part #: LG-050 Supplier: 92456 Part #: LG-100 Supplier: 92456 Opt Part #: DPP-500G Supplier: 92456 Opt Part #: DPPH-150 Supplier: 92456 Opt Part #: DPPH-200 Supplier: 92456 Opt Part #: DPPH-50 Supplier: 92456 Opt Part #: FDI 100 Supplier: 0BFD9 Opt Part #: FDI 50 Supplier: 0BFD9 Opt Part #: FDV 100 Supplier: 0BFD9 Opt Part #: FDV 50 Supplier: 0BFD9
STD-11995	Nut - Plain, Hexagon, Per AN315-6R Specifications
STD-11996	Washer - Flat, Per NAS1149C0763R Specifications

D. Consumable Materials

Reference	Description	Specification
A00159	Compound - Sealing, Thread-Locking, Anaerobic, Single-Component (100-200 In-lbs)	ASTM D5363 Grp 3 Cl 2 Grd 1 (SUPERSEDES MIL-S-46163)
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I

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(Continued)

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

E. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

F. Prepare for the Adjustment

SUBTASK 52-31-00-010-003

(1) Remove the cargo door lining.

SUBTASK 52-31-00-860-003

(2) Safety the counterbalance (View A, Figure 504):

(a) Make sure that the cargo door is closed and latched.

(b) Remove the screw, washer, and sleeve from the guide pin.

(c) Install a washer, STD-11996, and nut, STD-11995, on the guide pin against the adjustment nut.

NOTE: Install the nut finger tight only. This will hold the spring in the counterbalance and stop its operation.

G. Hinge Arm Adjustment

SUBTASK 52-31-00-820-002

(1) Adjust the hinge arm:

(a) Make sure that the cargo door is closed and latched.

(b) Make sure that the clearance between the fuselage skin and the forward cargo door skin is as specified (Table 501, Table 505, and Figure 502).

(c) Make sure that the clearance between the fuselage skin and the aft cargo door skin is as specified (Table 502, Table 506, and Figure 502).

Table 501/52-31-00-993-801 Aerosmoothness Limits - Forward Cargo Door (Key to Fig. 502)

ZONE	CLEARANCE		FLUSHNESS	
	NOMINAL Inch (mm)	TOLERANCE Inch (mm)	NOMINAL Inch (mm)	TOLERANCE Inch (mm)
A	0.10 (2.54)	0.06 to 0.15 (1.52 to 3.81)	- -	NOT APPLICABLE
B	0.10 (2.54)	0.06 to 0.15 (1.52 to 3.81)	-0.10 (-2.54)	-0.15 to -0.05 (-3.80 to -1.27)
C	0.10 (2.54)	0.06 to 0.15 (1.52 to 3.81)	- -	NOT APPLICABLE
D	0.10 (2.54)	0.06 to 0.15 (1.52 to 3.81)	-0.10 (-2.54)	-0.15 to -0.05 (-3.80 to -1.27)
E	- -	NOT APPLICABLE	- -	NOT APPLICABLE
F	0.25 (6.35)	0.22 to 0.28 (5.58 to 7.11)	-0.14 (-3.55)	-0.20 to -0.08 (-5.08 to -2.03)
G	- -	NOT APPLICABLE	- -	NOT APPLICABLE
H	0.10 (2.54)	0.06 to 0.15 (1.52 to 3.81)	-0.10 (-2.54)	-0.15 to -0.05 (-3.80 to -1.27)

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Table 502/52-31-00-993-802 Aerosmoothness Limits - Aft Cargo Door (Key to Fig. 502)

ZONE	CLEARANCE		FLUSHNESS	
	NOMINAL Inch (mm)	TOLERANCE Inch (mm)	NOMINAL Inch (mm)	TOLERANCE Inch (mm)
A	- -	NOT APPLICABLE	- -	NOT APPLICABLE
B	0.10 (2.54)	0.06 to 0.15 (1.52 to 3.81)	-0.10 (-2.54)	-0.15 to -0.05 (-3.81 to -1.27)
C	0.10 (2.54)	0.06 to 0.15 (1.52 to 3.81)	- -	NOT APPLICABLE
D	0.10 (2.54)	0.06 to 0.15 (1.52 to 3.81)	-0.10 (-2.54)	-0.15 to -0.05 (-3.81 to -1.27)
E	- -	NOT APPLICABLE	- -	NOT APPLICABLE
F	0.25 (6.35)	0.22 to 0.28 (5.58 to 7.11)	-0.14 (-3.55)	-0.20 to -0.08 (-5.08 to -2.03)
G	- -	NOT APPLICABLE	- -	NOT APPLICABLE
H	0.18 (4.57)	0.15 to 0.21 (3.81 to 5.33)	-0.10 (-2.54)	-0.15 to -0.05 (-3.81 to -1.27)

Table 503/52-31-00-993-803 Aero-Averaging Limits - Forward Cargo Door (Method 2)

ZONE	CLEARANCE		FLUSHNESS	
	NOMINAL Inch (mm)	TOLERANCE Inch (mm)	NOMINAL Inch (mm)	TOLERANCE Inch (mm)
A	0.10 (2.54)	0.06 to 0.18 (1.52 to 4.57)	--	NOT APPLICABLE
B	0.10 (2.54)	0.06 to 0.18 (1.52 to 4.57)	-0.10 (-2.54)	-0.18 to -0.02 (-4.57 to -0.51)
C	0.10 (2.54)	0.06 to 0.18 (1.52 to 4.57)	--	NOT APPLICABLE
D	0.10 (2.54)	0.06 to 0.18 (1.52 to 4.57)	-0.10 (-2.54)	-0.18 to -0.02 (-4.57 to -0.51)
E	--	NOT APPLICABLE	--	NOT APPLICABLE
F	0.25 (6.35)	0.22 to 0.31 (5.59 to 7.87)	-0.14 (-3.56)	-0.23 to -0.05 (-5.84 to -1.27)
G	--	NOT APPLICABLE	--	NOT APPLICABLE
H	0.10 (2.54)	0.06 to 0.18 (1.52 to 4.57)	-0.10 (-2.54)	-0.18 to -0.02 (-4.57 to -0.51)

Table 504/52-31-00-993-804 Aero-Averaging Limits - Aft Cargo Door (Method 2)

ZONE	CLEARANCE		FLUSHNESS	
	NOMINAL Inch (mm)	TOLERANCE Inch (mm)	NOMINAL Inch (mm)	TOLERANCE Inch (mm)
A	--	NOT APPLICABLE	--	NOT APPLICABLE
B	0.10 (2.54)	0.06 to 0.18 (1.52 to 4.57)	-0.10 (-2.54)	-0.18 to -0.02 (-4.57 to -0.51)
C	0.10 (2.54)	0.06 to 0.18 (1.52 to 4.57)	--	NOT APPLICABLE
D	0.10 (2.54)	0.06 to 0.18 (1.52 to 4.57)	-0.10 (-2.54)	-0.18 to -0.02 (-4.57 to -0.51)
E	--	NOT APPLICABLE	--	NOT APPLICABLE
F	0.25 (6.35)	0.22 to 0.31 (5.59 to 7.87)	-0.14 (-3.56)	-0.23 to -0.05 (-5.84 to -1.27)
G	--	NOT APPLICABLE	--	NOT APPLICABLE
H	0.18 (4.57)	0.15 to 0.24 (3.81 to 6.10)	-0.10 (-2.54)	-0.18 to -0.02 (-4.57 to -0.51)

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(d) Make sure that the clearance between the forward and aft latch rollers and latch receivers is as specified (Figure 503).

(e) If it is necessary, adjust as follows:

1) Loosen the bolts, washers, and shims that attach the forward and aft hinge arms to the cargo door.

2) Move the hinge arms on their serrated plates forward, aft, up or down to get the correct skin clearance.

3) Move the hinge arms on their serrated plates up or down to get the correct clearance between the latch roller and the latch receiver.

4) Tighten the bolts, washers, and shims to attach the forward and aft hinge arms to the cargo door.

H. Skin Clearance Adjustment

SUBTASK 52-31-00-820-003

(1) Two measurement methods are provided to adjust the door:

(a) Method 1 is the Standard measurement method for skin clearance adjustment.

(b) Method 2 is Aero-Averaging measurement for skin clearance adjustment.

SUBTASK 52-31-00-820-004

(2) Adjust the skin clearance with Method 1 (Figure 502):

(a) Make sure that the clearances between the door skin and fuselage skin are as specified (Table 502 or Table 501).

(b) As a minimum, measure the clearance between the cargo door skin and fuselage skin along each edge of the cargo door at the locations that follow:

1) Within ±1 in. (25.4 mm) of each stop fitting along the forward and aft edges of the door.

2) Within ±1 in. (25.4 mm) of the hinge arm and snubber centerlines on the top edge of the door.

3) Within ±1 in. (25.4 mm) of the lower stop and intercostal centerlines on the bottom edge of the cargo door along the forward and aft edges of the door.

(c) If it is necessary, adjust as follows:

1) Open the door.

2) Trim the edge of the door to get the correct skin clearances.

(d) Make sure that the minimum distance from the edge of the door outer skin to the door frame is as specified (Figure 502).

SUBTASK 52-31-00-820-005

(3) Adjust the skin clearance with Method 2 (Aero-Averaging) (Figure 502):

(a) Make sure that the clearances between the door skin and fuselage skin are as specified (Table 504 or Table 503).

(b) If it is necessary, adjust as follows:

1) Open the door.

2) Trim the edge of the door to get the correct skin clearances.

(c) Make sure that the minimum distance from the edge of the door outer skin to the door frame are as specified (Table 504 or Table 503).

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(d) Measure the clearance between the door skin and fuselage skin along the forward and aft edges of the door at the locations that follow:

NOTE: Do not take additional measurements.

1) Within ±1 in. (25 mm) of each stop fitting along the forward and aft edges of the door.
2) Record the skin clearance for each stop fitting.
3) Change the clearance to a Drag value as specified (Table 506 or Table 505).

   NOTE: A forward cargo door measurement of 0.10 in. (2.54 mm) clearance is a Drag value of 0.77.

4) Record the Drag value for each measurement (Table 506 or Table 505).

   NOTE: There are two tables. Use the correct door table for the measurement that is recorded.

Table 505/52-31-00-993-805 Forward Cargo Door Skin Clearance (Aero-Averaging)

CLEARANCE Inch (mm)	DRAG VALUE
0.06 (1.52)	0.46
0.07 (1.78)	0.54
0.08 (2.03)	0.62
0.09 (2.29)	0.69
0.10 (2.54)	0.77
0.11 (2.79)	0.85
0.12 (3.05)	0.92
0.13 (3.30)	1.00
0.14 (3.56)	1.08
0.15 (3.81)	1.15
0.16 (4.06)	1.23
0.17 (4.32)	1.31
0.18 (4.57)	1.39

Table 506/52-31-00-993-806 Aft Cargo Door Skin Clearance (Aero-Averaging)

DOOR FORWARD EDGE		DOOR AFT EDGE	
CLEARANCE Inch (mm)	DRAG VALUE	CLEARANCE Inch (mm)	DRAG VALUE
0.06 (1.52)	0.46	0.15 (3.81)	0.75
0.07 (1.78)	0.54	0.16 (4.06)	0.80
0.08 (2.03)	0.62	0.17 (4.32)	0.85
0.09 (2.29)	0.69	0.18 (4.57)	0.90
0.10 (2.54)	0.77	0.19 (4.83)	0.95
0.11 (2.79)	0.85	0.20 (5.08)	1.00

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Table 506/52-31-00-993-806 Aft Cargo Door Skin Clearance (Aero-Averaging) (Continued)

DOOR FORWARD EDGE		DOOR AFT EDGE	
CLEARANCE Inch (mm)	DRAG VALUE	CLEARANCE Inch (mm)	DRAG VALUE
0.12 (3.05)	0.92	0.21 (5.33)	1.05
0.13 (3.30)	1.00	0.22 (5.58)	1.10
0.14 (3.56)	1.08	0.23 (5.84)	1.15
0.15 (3.81)	1.15	0.24 (6.09)	1.20
0.16 (4.06)	1.23	-	-
0.17 (4.32)	1.31	-	-
0.18 (4.57)	1.39	-	-

5) Add all the Drag Values together (sum) and record this as measurement A.
   a) Record the sum of the Drag Values as Measurement A.
6) Divide Measurement A by the number of measurements that you made.

   NOTE: If the measurement was made at each of the stop fitting, then divide Measurement A (sum of the Drag Values) by 10 (the number of door stop fittings).
7) Make sure that this average drag value is 1.00 or less.

I. Counterbalance Adjustment

SUBTASK 52-31-00-820-006

(1) Adjust the counterbalance (Figure 504):
   (a) Adjust the cable length as follows:
      1) Make sure that the cargo door is closed and latched.
      2) For the forward cargo door, make sure that the groove on the cam axle shaft is aligned with the FWD mark on the counterbalance 5 degrees clockwise and 0 degrees counterclockwise.
      3) For the aft cargo door, make sure that the groove on the cam axle shaft is aligned with the AFT mark on the counterbalance 5 degrees clockwise and 0 degrees counterclockwise.
      4) If it is necessary, adjust as follows:
         a) Remove the lockwire between the adjustment screw and the alignment bolt at the cable and cargo compartment ceiling attachment.
         b) Remove the lockwire between the adjustment screw and the sheave.
         c) Turn the adjustment screw to change the length of the cable and the alignment of the groove on the cam axle shaft with the applicable mark on the counterbalance.
         d) When cable length adjustments are made, open the cargo door 1 in. (25 mm) to 2 in. (51 mm) to put a load on the safety nut and let the cable untwist while loose.
   (b) Make the counterbalance operable as follows:
      1) Make sure that the cargo door is closed and latched.

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2) Remove the washer, STD-11996, and nut, STD-11995, from the guide pin.

NOTE: Do not remove the adjustment nut.

3) Apply a light coat of grease, D00633, to the outer surface of the sleeve.

4) Apply compound, A00159, to the screw.

5) Install the screw, washer, and sleeve on the guide pin.

(c) Adjust the cable alignment as follows:

1) Open the cargo door.

2) Make sure that the clearance between the cable and the two sides of the pulley is as specified (Figure 504).

3) If it is necessary, adjust as follows:

a) Turn the alignment bolt to move the sheave forward or aft to get the correct clearance.

4) Install the lockwire between the alignment bolt and the adjustment screw.

5) Install the lockwire between the adjustment screw [10] and the sheave.

(d) Adjust the force to open and close the cargo door:

1) Measure the force to lift the cargo door to the open position as follows:

a) With a force gauge, COM-1557, lift the cargo door.

b) Measure the force at the external handle normal to the cargo door skin.

c) Make sure that the maximum force to lift the cargo door is no more than 25 lbf (111 N).

d) Make sure that the cargo door is held against the bumper on the cargo compartment ceiling and that it can stay in that position.

2) Measure the force to lower the cargo door as follows:

a) With a force gauge, COM-1557, lower the cargo door until the latch rollers touch the latch receivers (Figure 503).

b) Measure the force at the external handle normal to the cargo door skin.

c) Make sure that the maximum force to lower the cargo door is no more than 35 lbf (156 N).

3) If it is necessary, adjust as follows:

a) Turn the adjustment nut on the counterbalance to change the compression of the spring and get the correct forces.

4) Install the lockwire on the adjustment nut.

J. Flushness Adjustment

SUBTASK 52-31-00-820-007

(1) Two measurement methods are provided to adjust the door.

(a) Method 1 is the Standard measurement method for skin flushness adjustment.

(b) Method 2 is Aero-Averaging measurement for skin flushness adjustment.

SUBTASK 52-31-00-820-008

(2) Adjust the skin flushness using Method 1 (Figure 502):

(a) Close and latch the cargo door.

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(b) As a minimum, measure the flushness between the cargo door skin and fuselage skin along each edge of the cargo door at the locations that follow:

NOTE: Make additional measurements if necessary.

1) Within ±1 in. (25.4 mm) of each stop fitting along the forward and aft edges of the cargo door.
2) Within ±1 in. (25.4 mm) of the hinge arm and snubber centerlines on the top edge of the cargo door.
3) Within ±1 in. (25.4 mm) of the lower stop and intercostal centerlines on the bottom edge of the cargo door.

(c) Make sure that the flushness between the fuselage skin and the forward cargo door skin are as specified (Table 501 and Figure 502).

(d) Make sure that the flushness between the fuselage skin and the aft cargo door skin are as specified (Table 502 and Figure 502).

(e) If it is necessary, adjust as follows (Figure 505):

1) Open the cargo door.
2) Do the latch adjustment to get the correct skin flushness.

SUBTASK 52-31-00-820-009

(3) Adjust the skin flushness using Method 2 (Aero-Averaging) (Figure 502):

(a) Make sure that the flushness between the door skin and fuselage skin along the forward and aft edges of the door are as specified (Table 504, Table 503, and Figure 502).

(b) As a minimum, measure the flushness between the door skin and fuselage skin along the forward and aft edges of the door at the locations that follow:

1) Within ±1 in. (25.4 mm) of each stop fitting along the forward and aft edges of the door.

NOTE: Do not take additional measurements.

2) Record the skin flushness for each stop fitting.
3) Change the flushness to a Drag value (Table 507).

NOTE: A measurement of -0.10 in. (-2.54 mm) flushness at the door fwd edge is a Drag value of 0.00.

4) Record the Drag value for each measurement (Table 507).

Table 507/52-31-00-993-807 Forward and Aft Cargo Door Skin Flushness (Aero-Averaging)

DOOR FLUSHNESS		
FWD EDGE Inch (mm)	AFT EDGE Inch (mm)	Drag Value
-0.18 (-4.57)	-0.02 (-0.51)	1.59
-0.17 (-4.31)	-0.03 (-0.76)	1.35
-0.16 (-4.06)	-0.04 (-1.02)	1.13
-0.15 (-3.81)	-0.05 (-1.27)	0.90
-0.14 (-3.56)	-0.06 (-1.52)	0.69
-0.13 (-3.30)	-0.07 (-1.78)	0.48
-0.12 (-3.05)	-0.08 (-2.03)	0.29

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Table 507/52-31-00-993-807 Forward and Aft Cargo Door Skin Flushness (Aero-Averaging) (Continued)

DOOR FLUSHNESS		
FWD EDGE Inch (mm)	AFT EDGE Inch (mm)	Drag Value
-0.11 (-2.79)	-0.09 (-2.29)	0.12
-0.10 (-2.54)	-0.10 (-2.54)	0.00
-0.09 (-2.29)	-0.11 (-2.79)	0.13
-0.08 (-2.03)	-0.12 (-3.05)	0.46
-0.07 (-1.78)	-0.13 (-3.30)	0.86
-0.06 (-1.52)	-0.14 (-3.56)	1.30
-0.05 (-1.27)	-0.15 (-3.81)	1.78
-0.04 (-1.02)	-0.16 (-4.06)	2.29
-0.03 (-0.76)	-0.17 (-4.31)	2.82
-0.02 (-0.51)	-0.18 (-4.57)	3.38

5) Add all of the Drag Values together (sum).

a) Record the sum of the Drag Values as Measurement A.

6) Divide measurement A by number of measurements that you made.

NOTE: If the measurement was made at each of the stop fitting, then divide Measurement A (sum of the Drag Values) by 10 (the number of door stop fittings).

a) Make sure that this average Drag Value is 1.00 of less.

(c) If this average Drag Value is greater than 1.00, then adjust the door as follows:

1) Open the door.

2) Do the latch adjustment to get the correct skin flushness.

K. Latch Adjustment

SUBTASK 52-31-00-820-010

(1) Do the latch adjustment (Figure 505):

(a) Close and latch the cargo door.

(b) Make sure that the clearance between the forward and aft latch crank and latch receiver is as specified (Figure 505).

(c) If it is necessary, adjust as follows:

1) Open the cargo door.

2) Remove the bolts, washers, and nuts that attach the latch crank to the latch torque tube.

3) Move the adjustment washers from one end of the latch torque tube to the other end to increase or decrease the clearance between the latch crank and latch receiver.

4) Install the bolts, washers, and nuts to attach the latch crank to the latch torque tube.

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5) Make sure that when the clearance at one end of the cargo door is 0.00 in. (0.00 mm), the clearance at the other end is 0.04 in. (1.02 mm) to 0.08 in. (2.03 mm).

NOTE: The cargo door can move forward and aft during normal operation.

6) If more adjustment is necessary, do the steps that follow:

a) Remove the bolts, washers, and serrated plates, that attach the forward and aft latch receivers to the fuselage frame.

b) Install a new laminated shim or remove laminations from the shim under the latch receivers to get the correct adjustment.

c) Apply primer, C00259, to the bare laminations of the shim before installation.

d) Install the bolts, washers, and serrated plates to attach the latch receivers to the fuselage frame.

(d) Make sure that the cargo door is closed and latched.

(e) Try to move the latch torque tube forward and aft to do a check for latch roller and latch torque tube end-play.

(f) Make sure that the latch roller and latch torque tube end play is 0.015 in. (0.38 mm) maximum.

(g) If it is necessary, adjust as follows:

1) Remove the bolts, washers, and nuts, that attach the latch crank to the latch torque tube.

2) Add or remove the adjustment washers from one of the ends of the latch torque to decrease the end play.

3) Install the bolts, washers, and nuts to attach the latch crank to the latch torque tube.

L. Centering Guide Adjustment

SUBTASK 52-31-00-820-011

(1) Do the centering guide adjustment (Figure 506):

(a) Open and close the cargo door.

(b) As the cargo door closes and the latch rollers go into the latch receivers, measure the clearance between the forward and aft centering guides and guide rollers.

(c) Make sure that the clearance between the centering guide and guide roller is as shown.

(d) When the cargo door is closed, make sure that the forward and aft guide rollers do not touch the centering guides.

(e) If it is necessary, adjust as follows:

1) Open the cargo door.

2) Remove the bolts and washers that attach the forward and aft centering guides to the cargo door.

3) Install a new laminated shim or remove laminations from the shim under the centering guides to get the correct clearance.

4) Apply primer, C00259, to the bare laminations of the shim before installation.

5) Install the bolts and washers to attach the centering guides to the cargo door.

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M. Stop Pin Adjustment

SUBTASK 52-31-00-820-012

(1) Do the stop pin adjustment (Figure 507):

(a) Close and latch the cargo door.

(b) Make sure that the clearance between the stop pins and stop pads on the cargo door is as specified in Table 508:

Table 508/52-31-00-993-808 Stop Pin Adjustment

	FWD STOP PIN CLEARANCE		AFT STOP PIN CLEARANCE	
	NOMINAL IN (mm)	TOLERANCE IN (mm)	NOMINAL IN (mm)	TOLERANCE IN (mm)
BEAM A	0.020 in. (0.51 mm)	0.010 in. (0.25 mm) - 0.040 in. (1.02 mm)	0.020 in. (0.51 mm)	0.010 in. (0.25 mm) - 0.040 in. (1.02 mm)
BEAM B	0.020 in. (0.51 mm)	0.010 in. (0.25 mm) - 0.040 in. (1.02 mm)	0.020 in. (0.51 mm)	0.010 in. (0.25 mm) - 0.040 in. (1.02 mm)
BEAM C	0.020 in. (0.51 mm)	0.010 in. (0.25 mm) - 0.040 in. (1.02 mm)	0.020 in. (0.51 mm)	0.010 in. (0.25 mm) - 0.040 in. (1.02 mm)
BEAM D*[1]	0.040 in. (1.02 mm)	0.025 in. (0.64 mm) - 0.065 in. (1.65 mm)	0.040 in. (1.02 mm)	0.025 in. (0.64 mm) - 0.065 in. (1.65 mm)
BEAM E*[1]	0.040 in. (1.02 mm)	0.025 in. (0.64 mm) - 0.065 in. (1.65 mm)	0.040 in. (1.02 mm)	0.025 in. (0.64 mm) - 0.065 in. (1.65 mm)
THRESHOLD*[1]	0.040 in. (1.02 mm)	0.025 in. (0.64 mm) - 0.065 in. (1.65 mm)	0.040 in. (1.02 mm)	0.025 in. (0.64 mm) - 0.065 in. (1.65 mm)

*[1] Stop pin gaps at beams D, E, and threshold must be within 0.030 in. (0.76 mm) of the adjacent stop pin gap.

(c) If it is necessary, adjust as follows:

1) Position the door in the opening with the latch rollers at the latch receivers' overcenter high point (Top Dead Center) (View B, Figure 507).

2) Turn the stop pins fully outboard until they just touch the stop pads.

3) Open the door to a position to provide access.

4) Turn the stop pins back to the nearest lock groove.

5) Install the lock spring.

6) Close and lock the cargo door.

7) Measure the stop pin and stop pad clearance (Table 508).

NOTE: Stop pin gaps at beams D, E, and Threshold must be within 0.030 in. (0.762 mm) of the adjacent stop pin gap. The gap at beam D must be within 0.030 in. (0.762 mm) of the gap at beam C. The gap at beam E must be within 0.030 in. (0.762 mm) of the gap at beam D. The gap at the Threshold must be within 0.030 in. (0.762 mm) of the gap at beam E.

(d) Make sure that the stop pins align with the stop pads on the forward and aft edges of the cargo door as specified (View B-B, Figure 507).

SUBTASK 52-31-00-820-013

(2) Do this task: Cargo Door Indication Switch - Adjustment, TASK 52-71-31-820-801.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

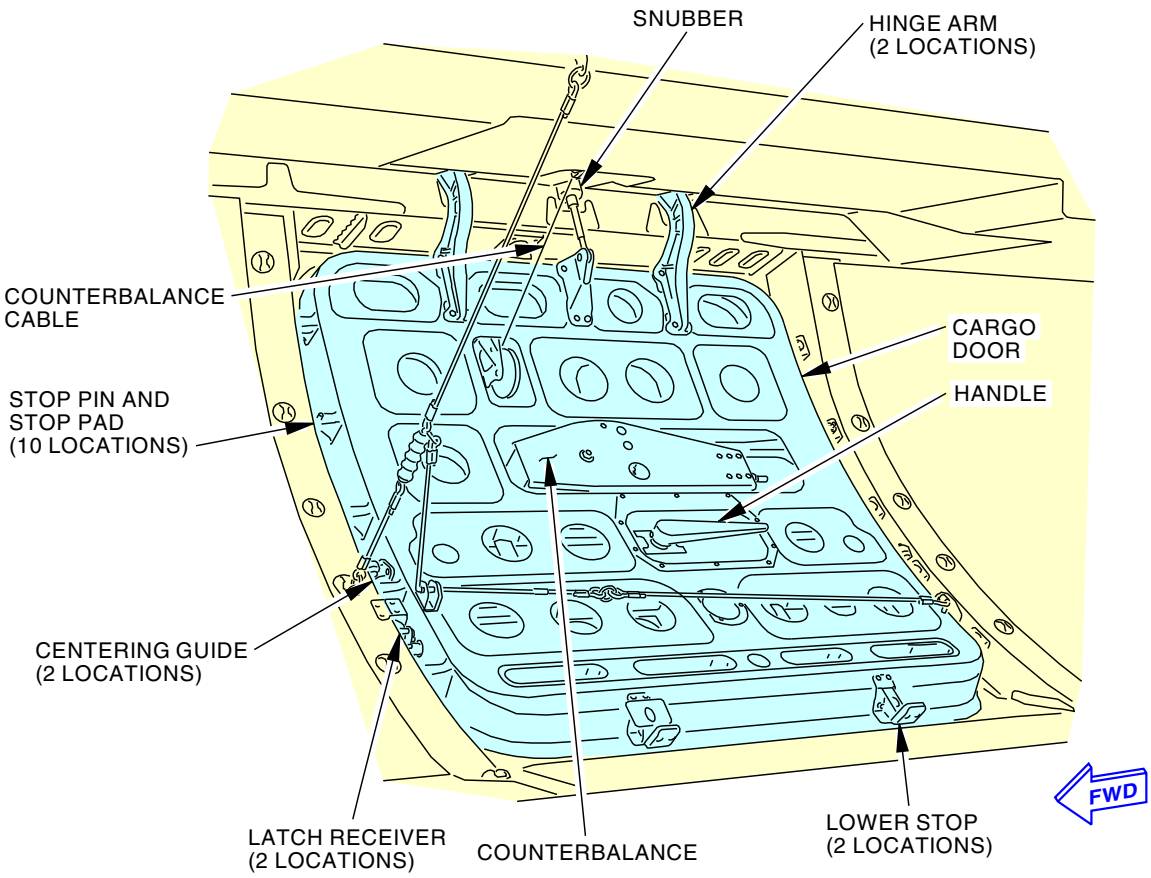
N. Put the Airplane Back to Its Usual Condition

SUBTASK 52-31-00-410-003

(1) Install the cargo door lining.

——— END OF TASK ———

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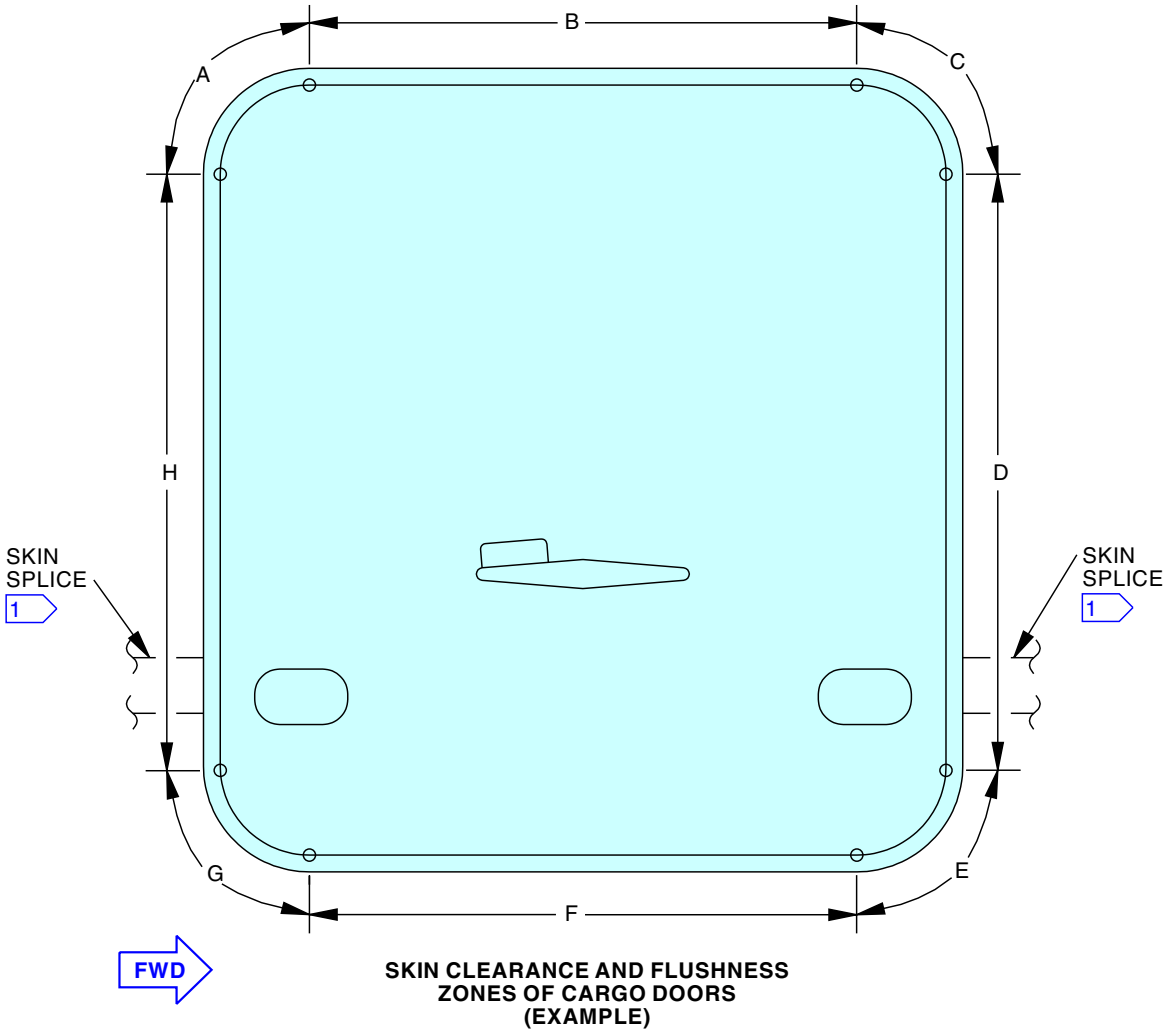


CARGO DOOR
(LINING REMOVED, EXAMPLE)

2415863 S00061539057_V1

Cargo Door Adjustment
Figure 501/52-31-00-990-812

ECCN 9E991 BOEING PROPRIETARY - See title page for details



SKIN CLEARANCE AND FLUSHNESS ZONES OF CARGO DOORS (EXAMPLE)

NOTE:

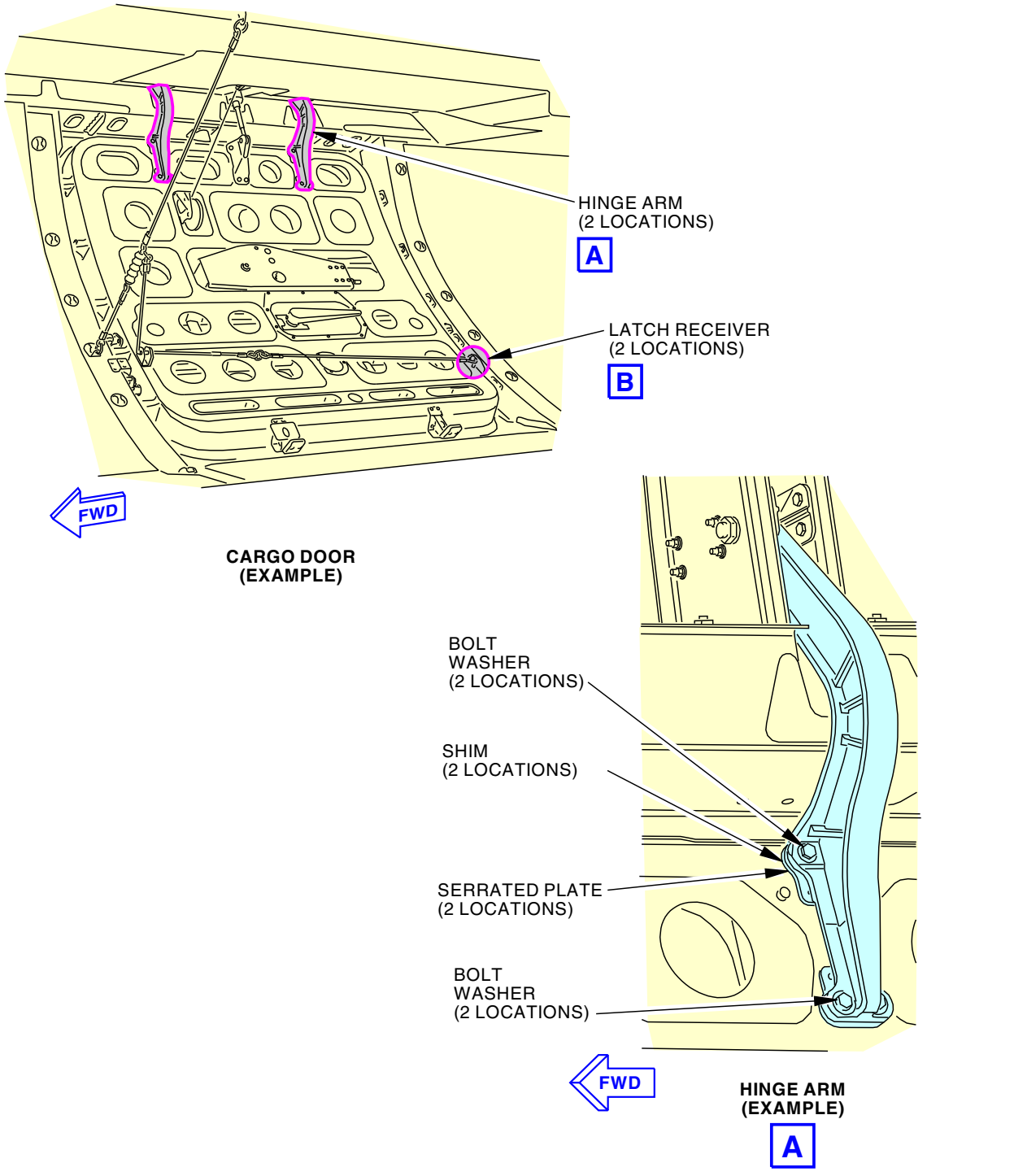
REFER TO AEROSMOOTHNESS LIMITS TABLES.

1 THE FLUSHNESS AT SKIN SPLICES WILL BE MORE THAN THE FLUSHNESS SHOWN BY THE ADDITIONAL SKIN AND BONDING THICKNESS.

2415864 S00061539058_V1

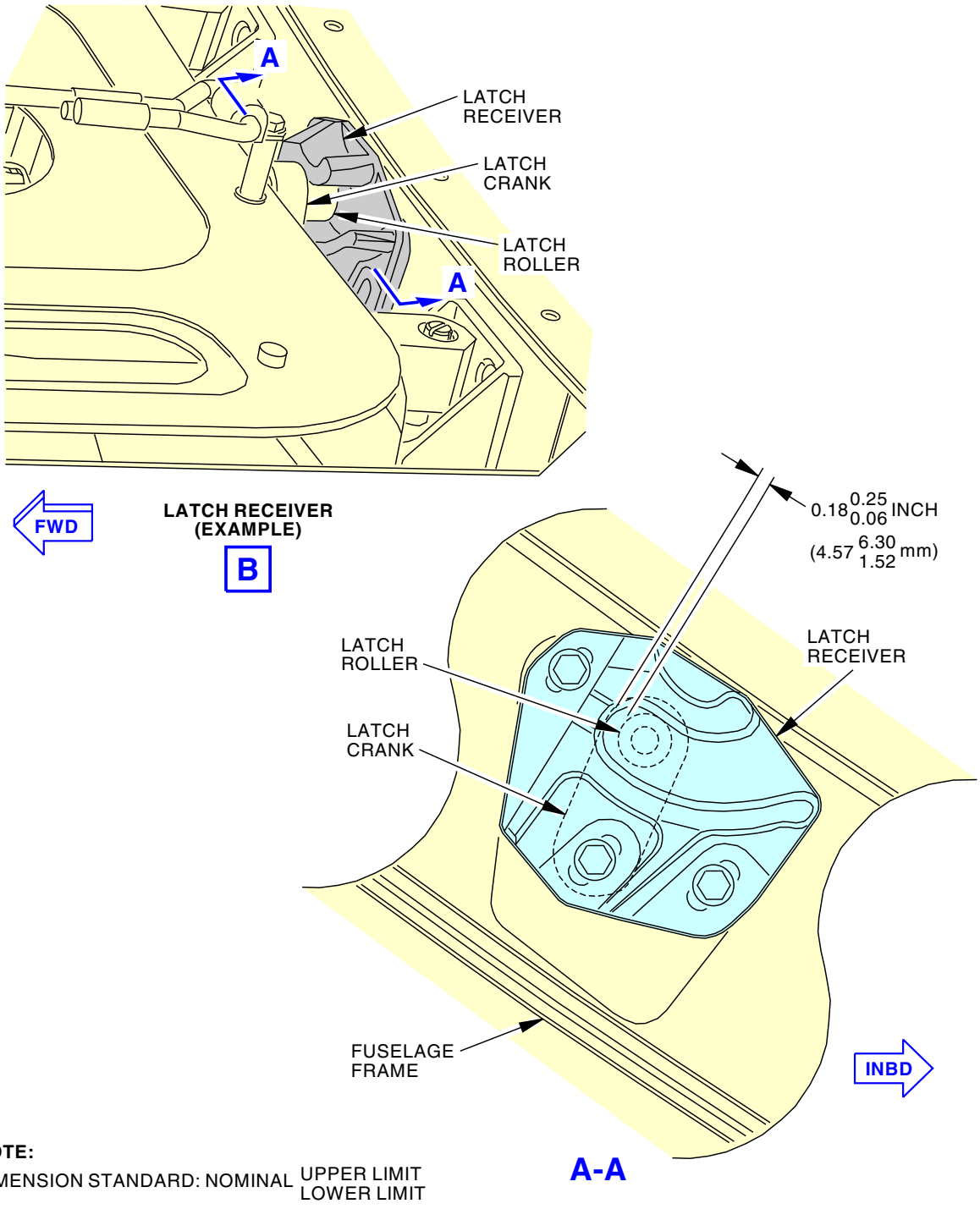
Cargo Door Skin Clearances
Figure 502/52-31-00-990-813

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Hinge Arm Adjustment
Figure 503/52-31-00-990-814 (Sheet 1 of 2)

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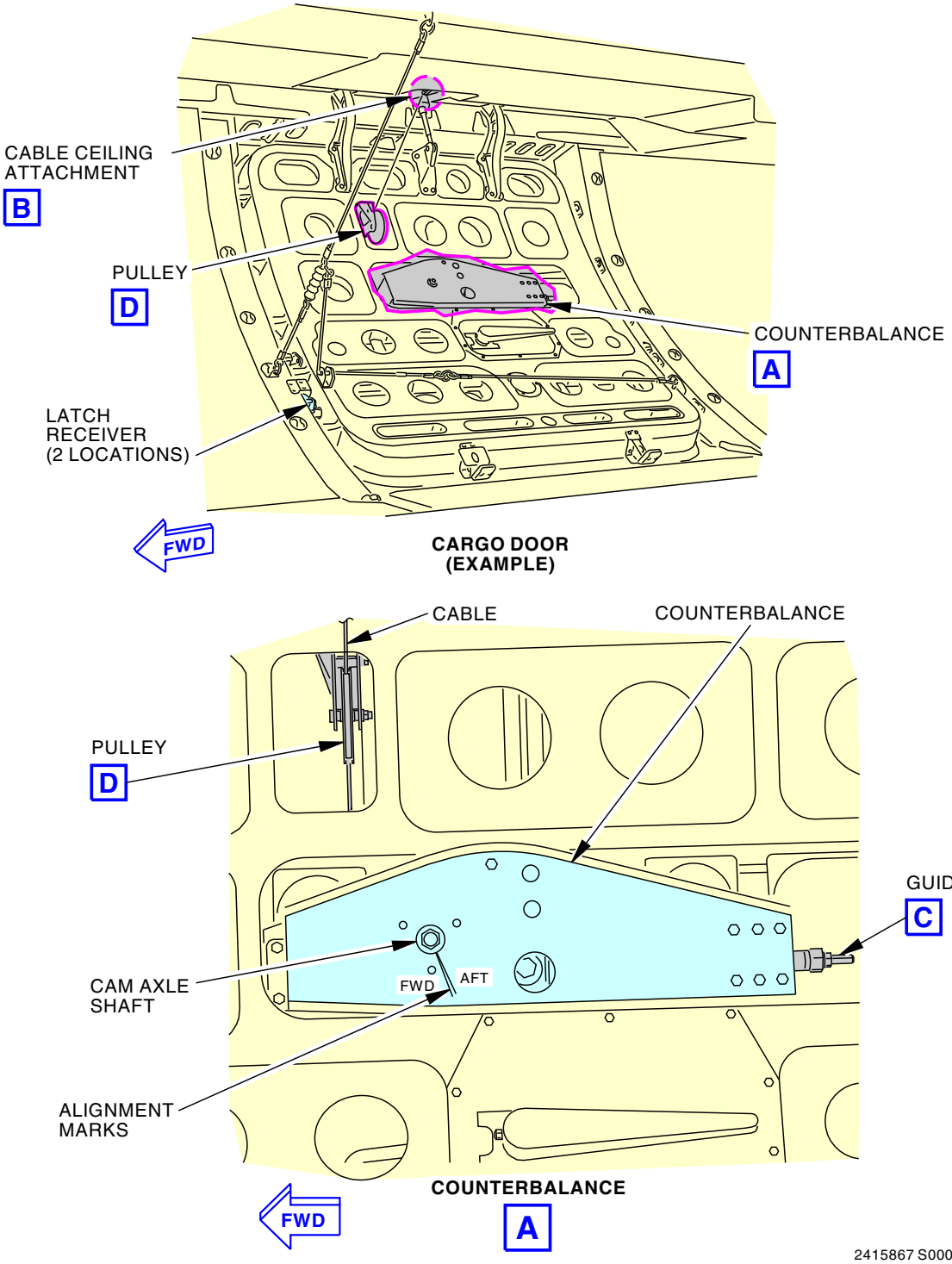
NOTE:

DIMENSION STANDARD: NOMINAL UPPER LIMIT LOWER LIMIT

2415866 S00061539060_V1

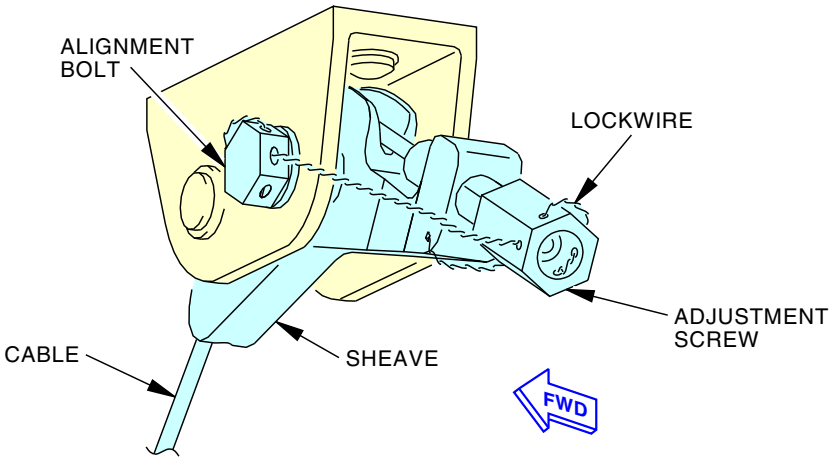
Hinge Arm Adjustment
Figure 503/52-31-00-990-814 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



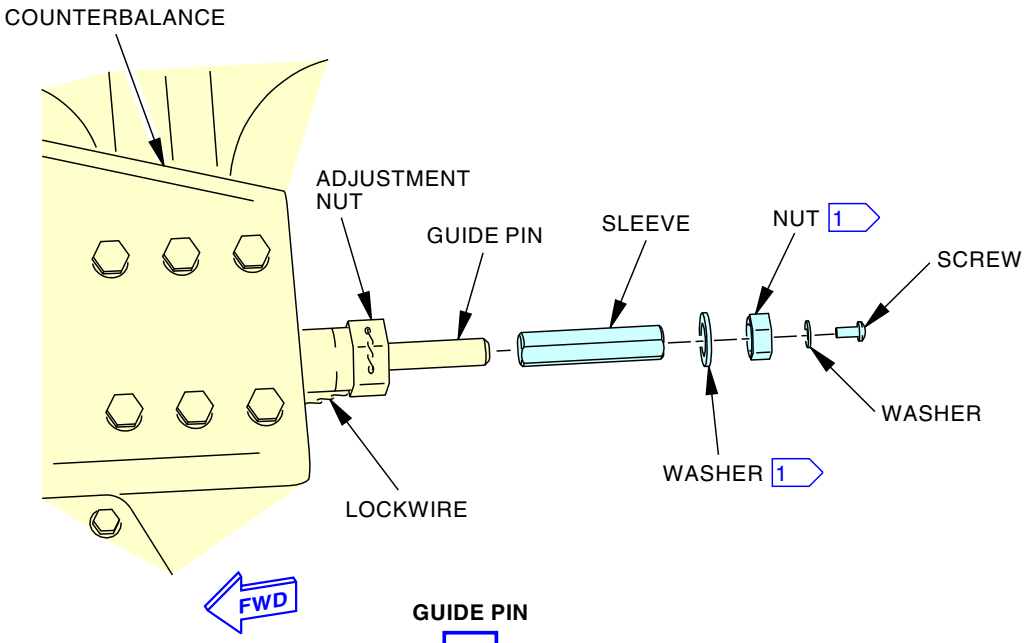
Counterbalance Mechanism Adjustment
Figure 504/52-31-00-990-815 (Sheet 1 of 3)

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CABLE CEILING ATTACHMENT

B



GUIDE PIN

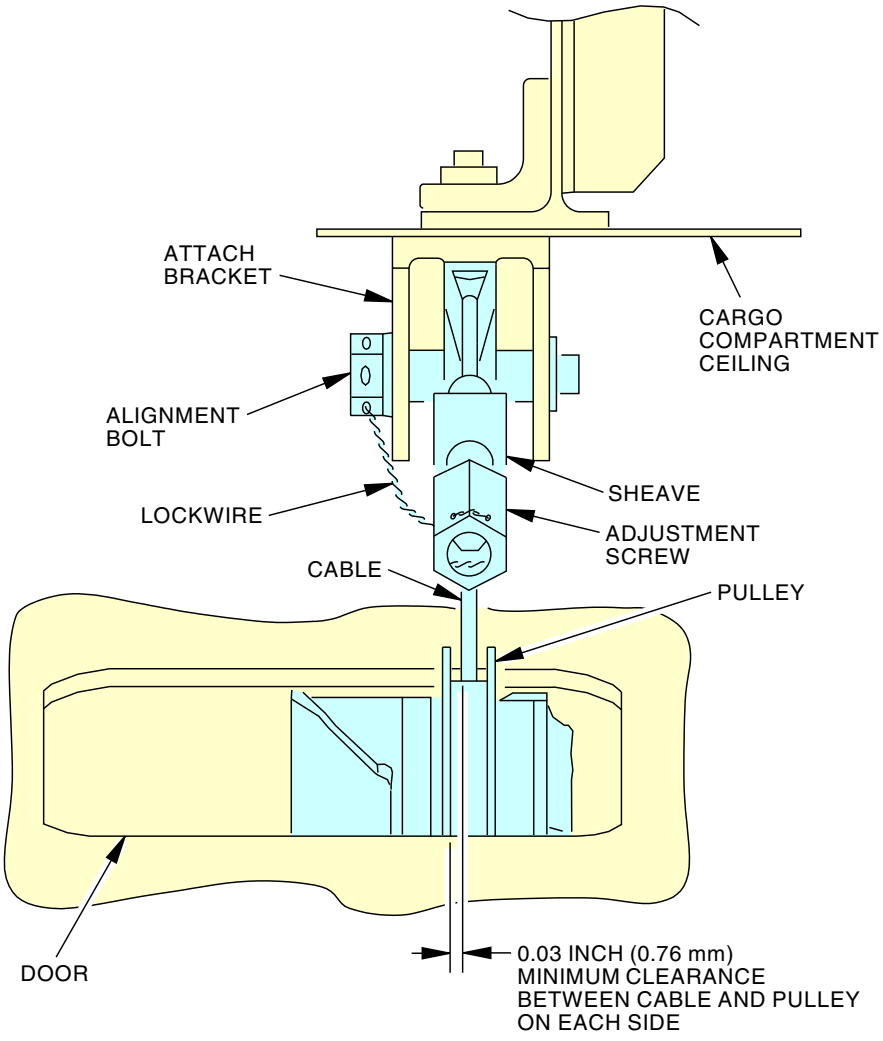
C

1 INSTALL THE WASHER AND NUT TO SAFETY THE COUNTERBALANCE.

2415868 S00061539062_V3

Counterbalance Mechanism Adjustment
Figure 504/52-31-00-990-815 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



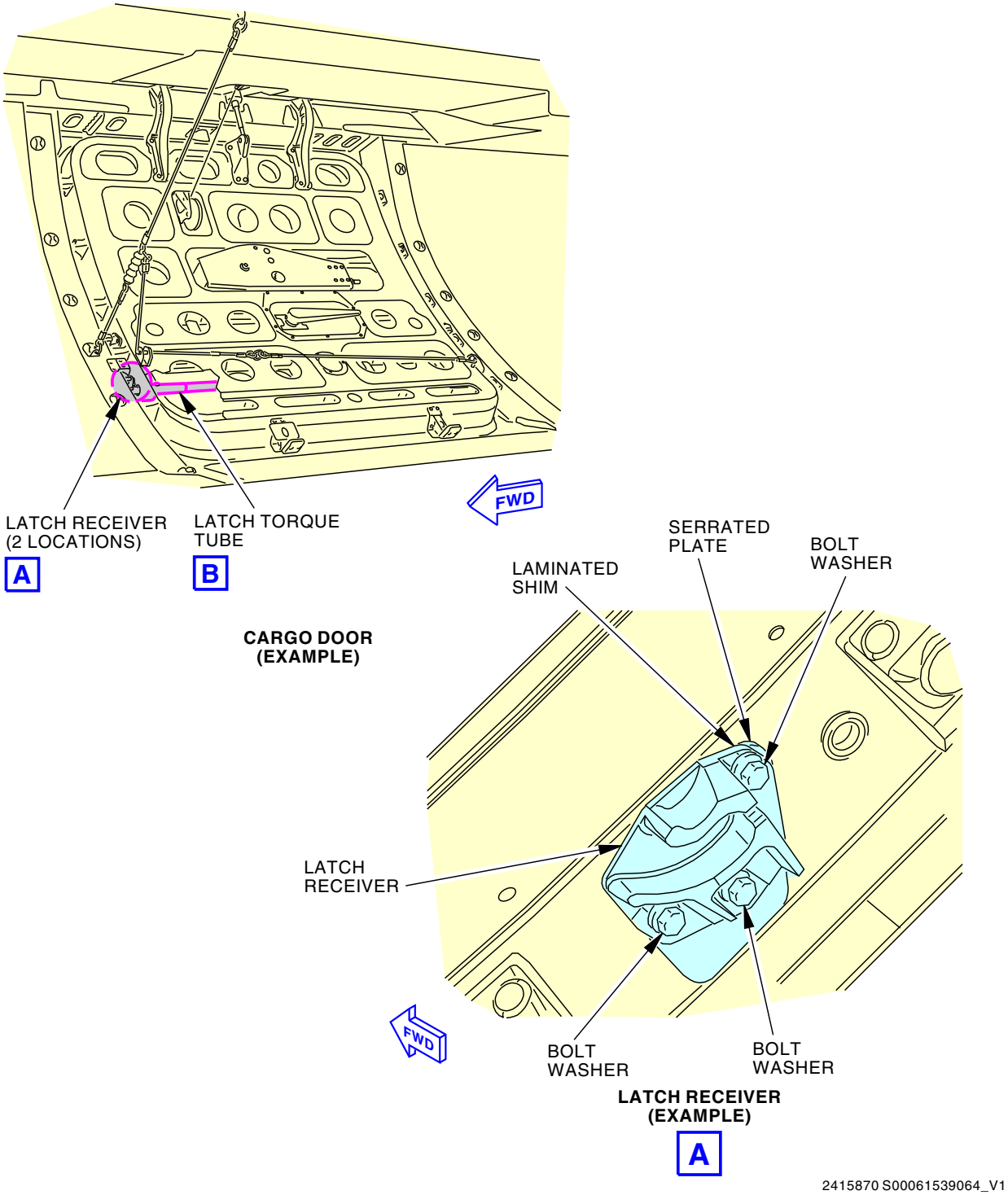
PULLEY

D

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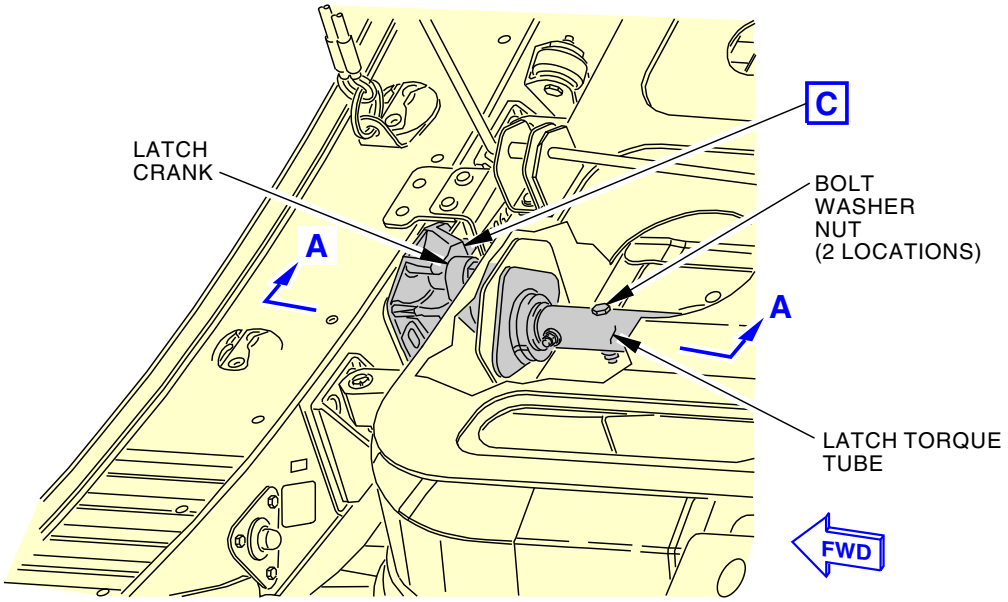
Counterbalance Mechanism Adjustment
Figure 504/52-31-00-990-815 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

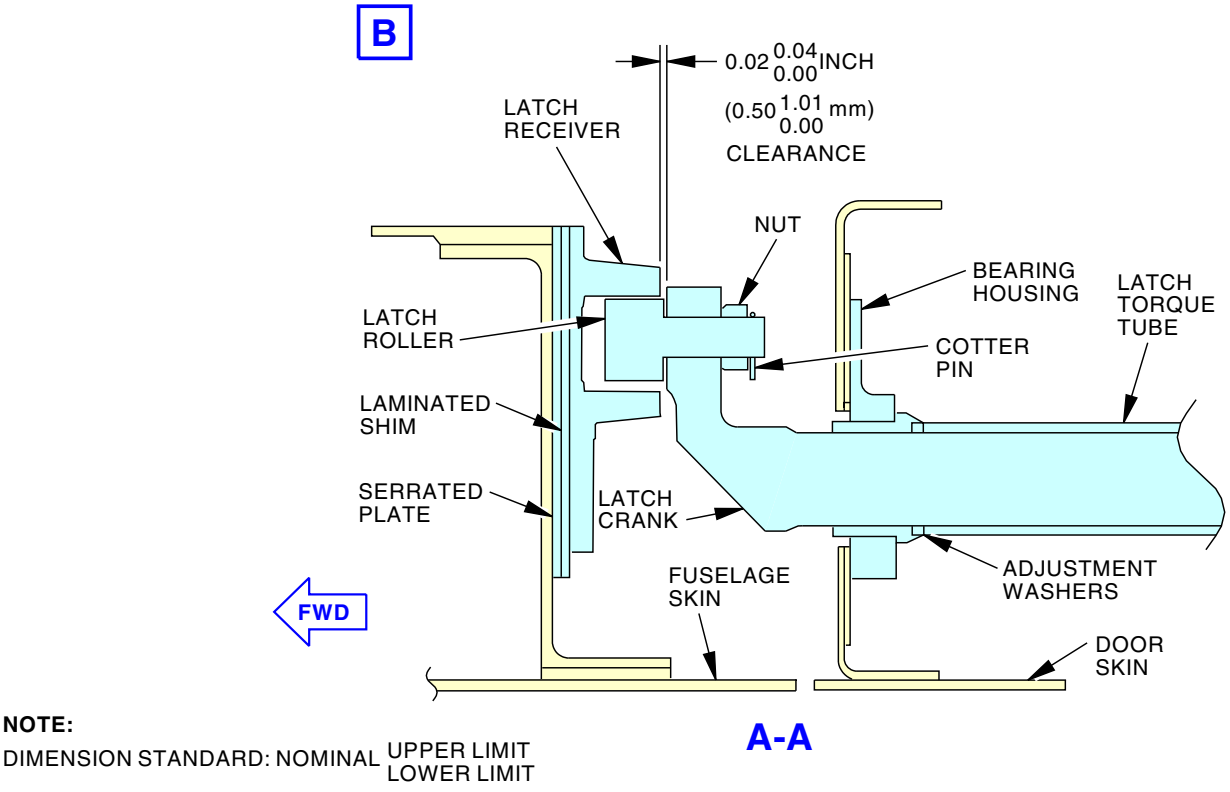


Flushness and Latch Adjustment
Figure 505/52-31-00-990-816 (Sheet 1 of 3)

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LATCH TORQUE TUBE



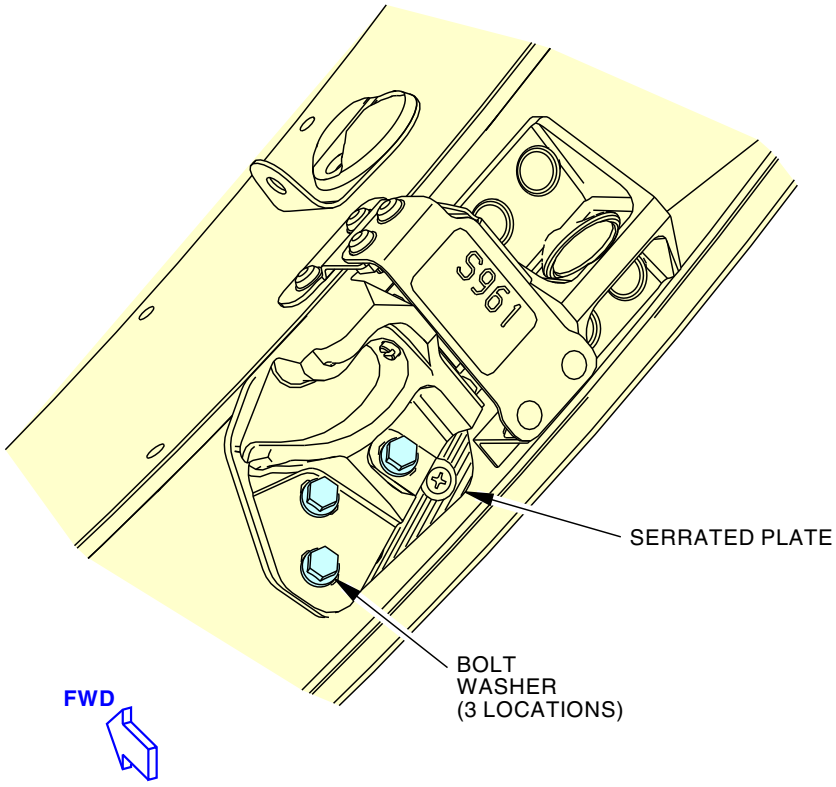
NOTE:

DIMENSION STANDARD: NOMINAL UPPER LIMIT LOWER LIMIT

2415871 S00061539065_V3

Flushness and Latch Adjustment
Figure 505/52-31-00-990-816 (Sheet 2 of 3)

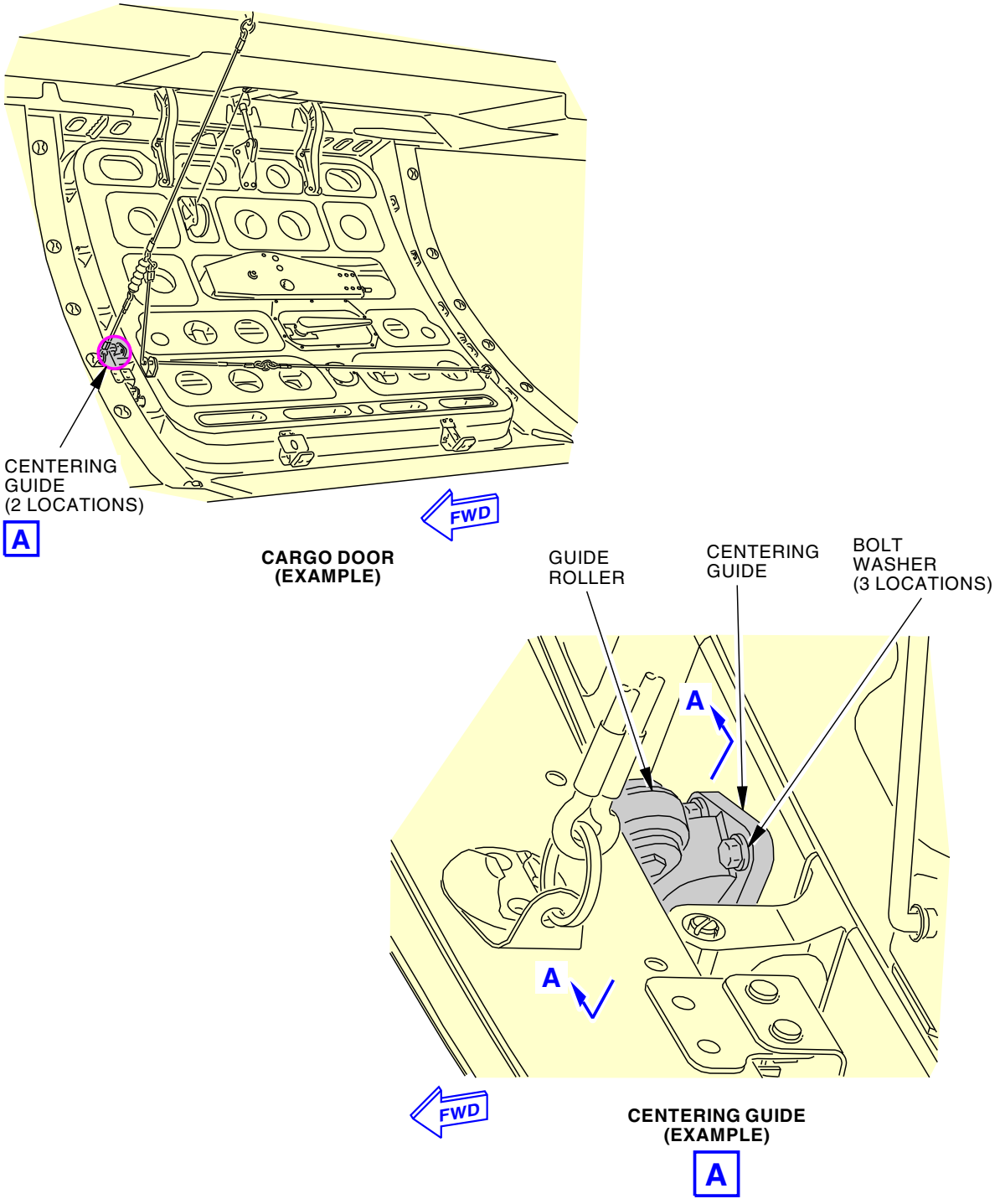
ECCN 9E991 BOEING PROPRIETARY - See title page for details



2835765 S0000660286_V2

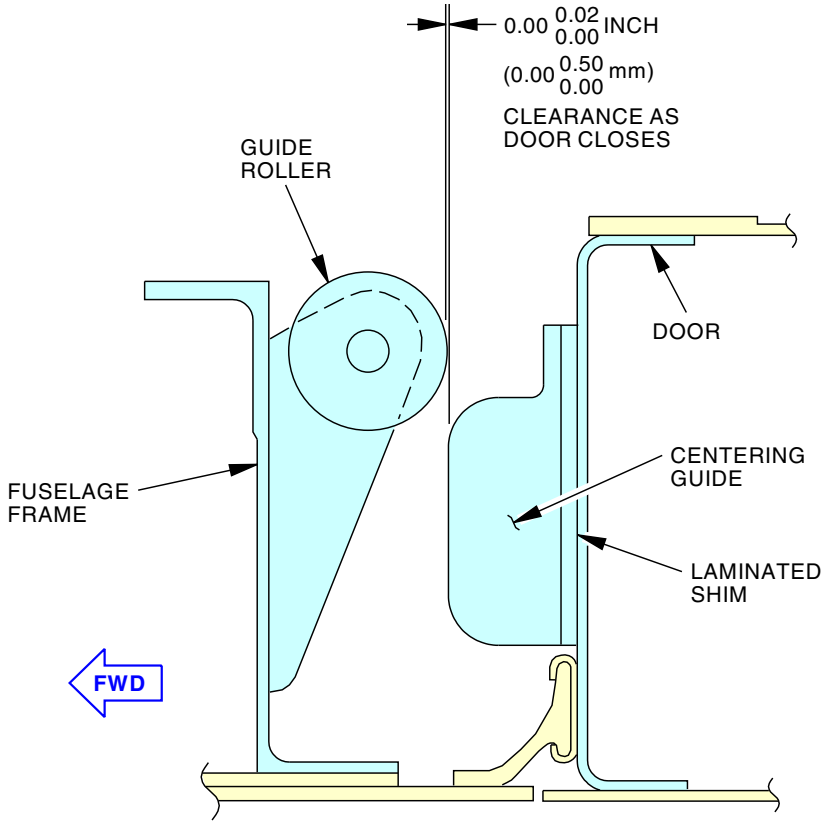
Flushness and Latch Adjustment
Figure 505/52-31-00-990-816 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Centering Guide Adjustment
Figure 506/52-31-00-990-817 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



A-A

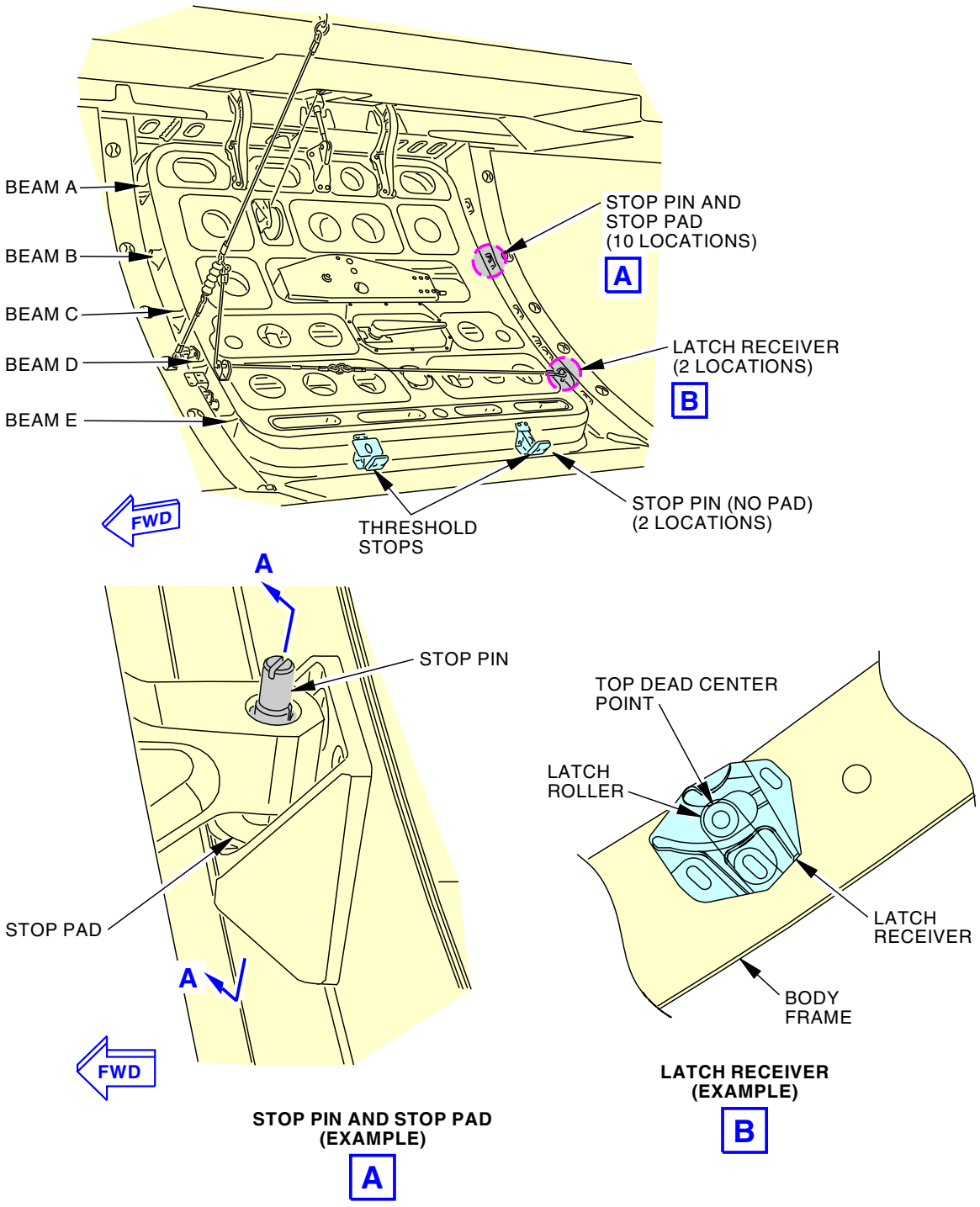
NOTE:

DIMENSION STANDARD: NOMINAL UPPER LIMIT LOWER LIMIT

2415873 S00061539067_V1

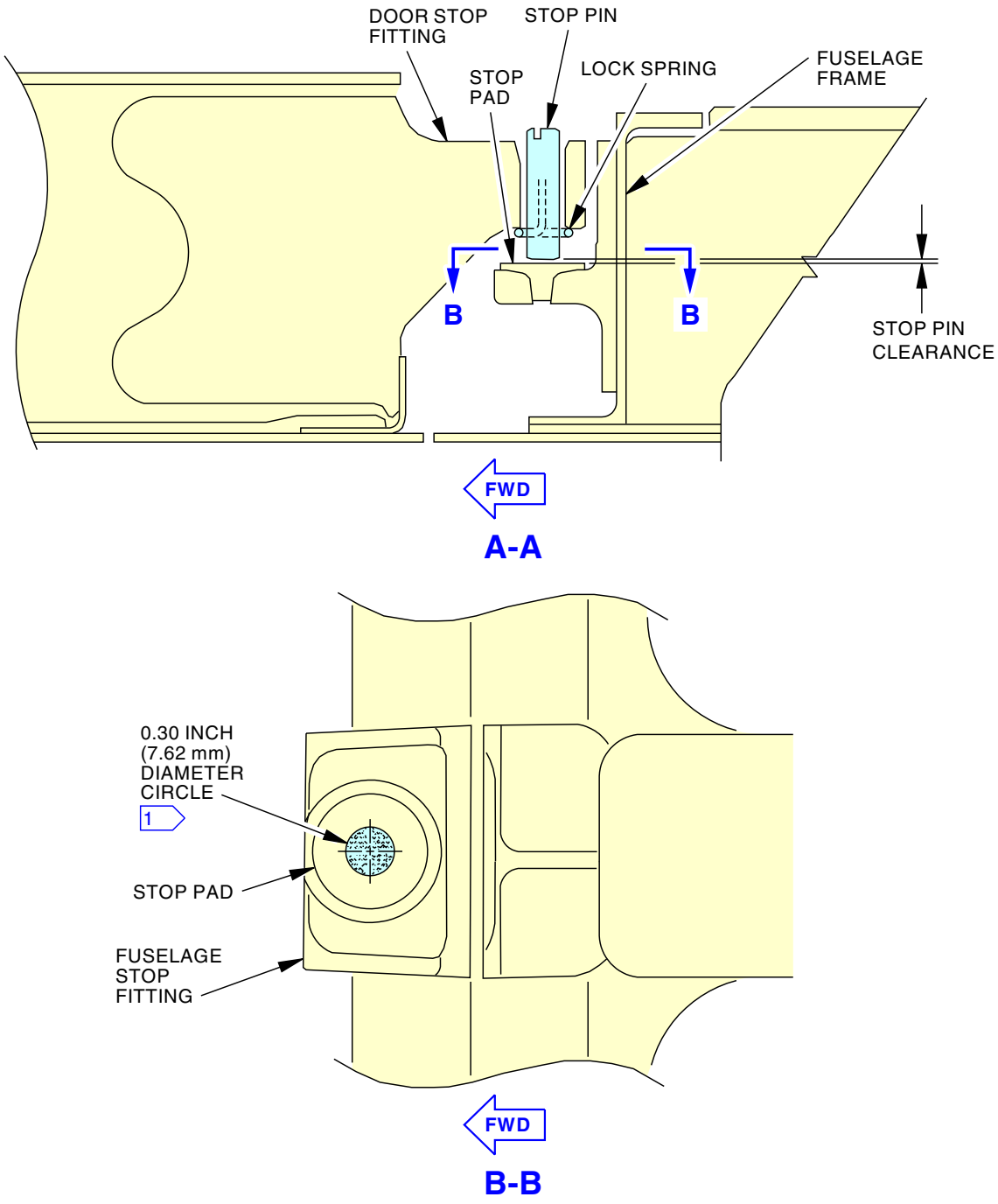
Centering Guide Adjustment
Figure 506/52-31-00-990-817 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Stop Pin Adjustment
Figure 507/52-31-00-990-818 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



1 STOP PIN CENTER MUST TOUCH STOP PAD CENTER WITHIN A 0.30 INCH (7.62 mm) DIAMETER CIRCLE.

2415875 S00061539069_V2

Stop Pin Adjustment
Figure 507/52-31-00-990-818 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-31-00-700-801

3. Cargo Door System Test

(Figure 501)

A. General

(1) The system test is a check that the cargo door is installed and adjusted correctly and that the mechanical systems operate correctly.

(2) Make sure the installation and adjustment of the cargo door is done. Make sure the cargo door seal and lining are installed.

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-1557	Gauge - Force Part #: DG-200 Supplier: 92456 Part #: FDIX 100 Supplier: 0BFD9 Part #: FDIX 50 Supplier: 0BFD9 Part #: LG-050 Supplier: 92456 Part #: LG-100 Supplier: 92456 Opt Part #: DPP-500G Supplier: 92456 Opt Part #: DPPH-150 Supplier: 92456 Opt Part #: DPPH-200 Supplier: 92456 Opt Part #: DPPH-50 Supplier: 92456 Opt Part #: FDI 100 Supplier: 0BFD9 Opt Part #: FDI 50 Supplier: 0BFD9 Opt Part #: FDV 100 Supplier: 0BFD9 Opt Part #: FDV 50 Supplier: 0BFD9

C. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

D. Cargo Door System Test

SUBTASK 52-31-00-730-002

(1) Do the system test for the cargo door warning:

(a) Make sure the forward and aft cargo doors are fully closed, latched, and locked.

(b) Make sure that the FWD CARGO or AFT CARGO light does not show on the Forward Overhead Panel, P5, in the flight compartment.

(c) Open the cargo door.

(d) Make sure the FWD CARGO or AFT CARGO light on the Forward Overhead Panel, P5, comes on for the cargo door.

(e) Close the cargo door.

(f) Make sure the FWD CARGO or AFT CARGO light goes off.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-31-00-730-003

(2) Do the cargo door handle torque test:

NOTE: The torque values used in this test are found by measuring the force of rotating the handle using the force gauge, COM-1557 and multiplying that value by the distance from the measurement point to the center of the handle. Torque = Distance x Force.

(a) Open the cargo door.

(b) Measure the torque on the interior handle to close the cargo door with force gauge, COM-1557.

1) Make sure the maximum torque on the interior handle to close the cargo door is 300 in-lb (34 N·m).

(c) Measure the torque on the exterior handle to close the cargo door with force gauge, COM-1557.

1) Make sure the maximum torque on the exterior handle to close the cargo door is 400 in-lb (45 N·m).

(d) Close and latch the cargo door.

(e) Measure the torque on the interior handle to open the cargo door with force gauge, COM-1557.

1) Make sure the maximum torque on the interior handle to open the cargo door is 270 in-lb (31 N·m).

(f) Measure the torque on the exterior handle to open the cargo door with force gauge, COM-1557.

1) Make sure the maximum torque on the exterior handle to open the cargo door is 360 in-lb (41 N·m).

SUBTASK 52-31-00-200-001

(3) If the maximum torque is more than specified, do these steps:

(a) Make sure the clearance between the fuselage skin and door skin is correct .

(b) Make sure the flushness adjustment is correct.

(c) Make sure the stop pin adjustment is correct .

(d) Make sure the latch adjustment is correct .

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CARGO DOOR - INSPECTION/CHECK

1. General

A. This procedure has these tasks:

(1) A check of the forward or aft cargo door

(2) A check of the forward or aft cargo door pressure seal.

B. This procedure is the same for each cargo door.

TASK 52-31-00-200-801

2. Cargo Door Check

A. References

Reference	Title
52-31-14 P/B 401	CARGO DOOR HANDLE MECHANISM - REMOVAL/INSTALLATION

B. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

C. Access Panels

Number	Name/Location
821BZ	Panel Assy - Forward Cargo Door - Handle Box Cover Plate
822BZ	Panel Assy - Aft Cargo Door - Handle Box Cover Plate

D. Prepare for the Inspection

SUBTASK 52-31-00-010-004

(1) Remove the door lining.

SUBTASK 52-31-00-010-005

(2) Open and close the door as necessary to get access to the door components.

SUBTASK 52-31-00-860-005

(3) Open these access panels:

Number	Name/Location
821BZ	Panel Assy - Forward Cargo Door - Handle Box Cover Plate
822BZ	Panel Assy - Aft Cargo Door - Handle Box Cover Plate

E. Cargo Door Inspection

SUBTASK 52-31-00-210-002

(1) Do a visual inspection of the door external structure and handle mechanism as follows:

(a) Examine the external skin.

1) Look for cracks and corrosion.

2) Look for burrs.

3) Look for loose and missing fasteners.

(b) Examine the external handle.

1) Look for cracks and corrosion.

2) Look for too much wear.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-31-00-210-003

(2) Do a visual inspection of the latch mechanism and centering guides as follows:

(a) Examine the latch cranks and latch rollers.

1) Look for cracks and corrosion.

2) Look for too much wear.

3) Look for unwanted particles on the latch rollers.

(b) Examine the centering guides.

1) Look for cracks and corrosion.

2) Look for too much wear.

SUBTASK 52-31-00-210-004

(3) Do a visual inspection of the door stop fittings and stop pins as follows:

(a) Examine the door stop fittings.

1) Look for cracks and corrosion.

(b) Examine the stop pins.

1) Look for cracks and corrosion.

2) Look for unwanted particles on the stop pins.

3) Make sure that the spring locks are installed.

SUBTASK 52-31-00-210-005

(4) Do a visual inspection of the attach structure as follows:

(a) Examine the hinge arms.

1) Look for cracks and corrosion.

2) Look for too much wear.

(b) Examine the hinge arm fasteners.

1) Make sure that the bolts fully engage the nuts.

2) Make sure that the bolt threads are not damaged.

SUBTASK 52-31-00-210-006

(5) Do a visual inspection of the door internal structure and handle mechanism as follows:

(a) Examine the internal frames.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

(b) Examine the internal skin.

1) Look for cracks and corrosion.

2) Look for burrs.

3) Look for loose and missing fasteners.

(c) Examine the internal handle.

1) Look for cracks and corrosion.

2) Look for too much wear.

(d) Examine the handle spring.

NOTE: It is recommended to remove, inspect, and reinstall the handle spring (PAGEBLOCK 52-31-14/401).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1) Look for cracks and corrosion.

(e) Examine the handle housing.

1) Look for cracks and corrosion.

SUBTASK 52-31-00-210-007

(6) Do a visual inspection of the cargo door counterbalance mechanism as follows:

(a) Examine the cable assembly.

1) Look for broken wires in the cable.

NOTE: Replace the cable if there is more than one broken wire for each 10 inches of cable length.

2) Make sure that the ends of the cable are attached correctly.

3) Make sure that the cable is correctly aligned.

(b) Examine the pulley.

1) Look for cracks and corrosion.

2) Look for uneven wear caused by the cable.

3) Look for loose and missing fasteners.

(c) Examine the counterbalance.

1) Make sure that the counterbalance is correctly attached.

2) Look at the cam and the roller bearing for too much wear and plating that has flakes.

3) Look for cracks or corrosion.

SUBTASK 52-31-00-210-008

(7) Do a visual inspection of the lanyard assembly.

(a) Examine the lanyard assembly.

1) Make sure that the cables are in good condition.

2) Make sure that the cables are attached correctly.

SUBTASK 52-31-00-210-009

(8) Do a visual inspection of the fuselage frame as follows:

(a) Examine the fuselage stop fittings and stop pads.

1) Look for cracks and corrosion.

2) Look for wear that is not in the center of the stop pads.

3) Look for unwanted particles on the stop fittings.

(b) Examine the latch receivers.

1) Look for cracks, corrosion, and too much wear.

2) Look for unwanted particles in the latch receivers.

(c) Examine the centering guides.

1) Look for cracks and corrosion.

2) Look for unwanted particles on the centering guide rollers.

(d) Examine the structure around the door opening.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

F. Put the Airplane Back to Its Usual Condition

SUBTASK 52-31-00-410-005

(1) Close these access panels:

Number	Name/Location
821BZ	Panel Assy - Forward Cargo Door - Handle Box Cover Plate
822BZ	Panel Assy - Aft Cargo Door - Handle Box Cover Plate

SUBTASK 52-31-00-210-010

(2) Install the door lining.

——— END OF TASK ———

TASK 52-31-00-200-802

3. Cargo Door Pressure Seal Check

(Figure 601)

A. References

Reference	Title
52-31-00-580-801	Open the Cargo Door (P/B 201)
52-31-00-580-802	Close the Cargo Door (P/B 201)

B. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

C. Prepare for Inspection

SUBTASK 52-31-00-010-006

WARNING MAKE SURE THAT ALL PERSONNEL AND EQUIPMENT ARE CLEAR OF THE PATH OF THE DOOR. THE MOVEMENT OF THE DOOR CAN CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(1) Open the cargo door.

(a) Do this task: Open the Cargo Door, TASK 52-31-00-580-801.

D. Cargo Door Pressure Seal Inspection

SUBTASK 52-31-00-210-011

(1) Do a visual inspection of the door pressure seal.

(a) Examine the blade seal [1] and seal retainer [2].

1) Look at the blade seal [1] for cracks, holes, and tears.

2) Look a the blade seal [1] for indications of seal deterioration.

3) Make sure that the seal is installed correctly in the seal retainer [2].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E. Put the Airplane Back to Its Usual Condition

SUBTASK 52-31-00-410-004

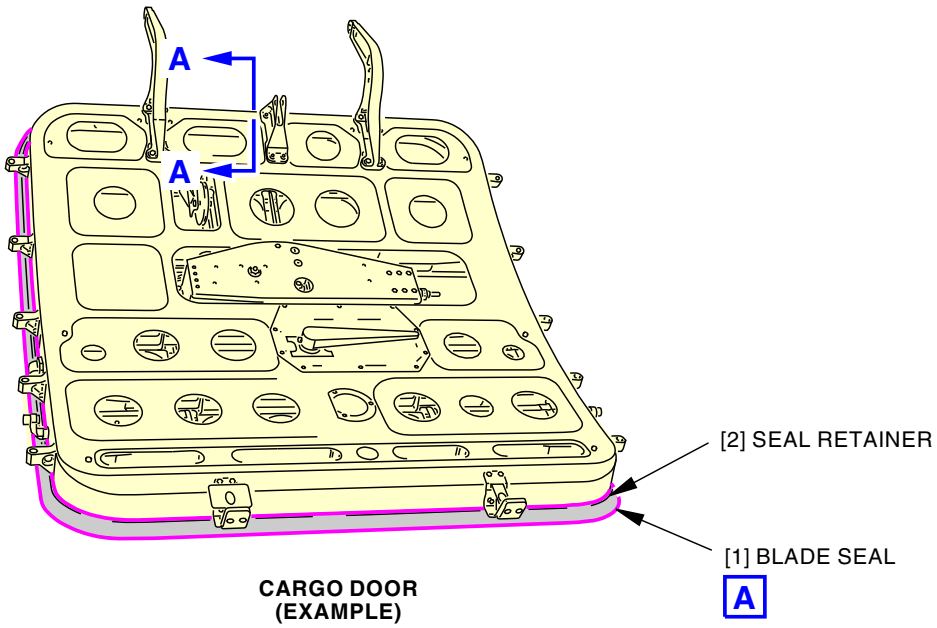
WARNING MAKE SURE THAT ALL PERSONNEL AND EQUIPMENT ARE CLEAR OF THE PATH OF THE DOOR. THE MOVEMENT OF THE DOOR CAN CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(1) Close the cargo door.

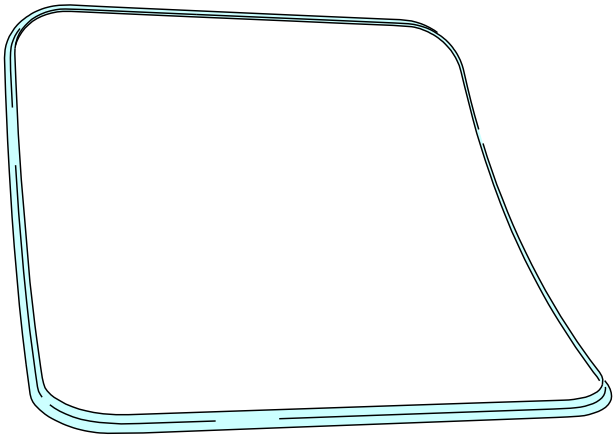
(a) Do this task: Close the Cargo Door, TASK 52-31-00-580-802.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

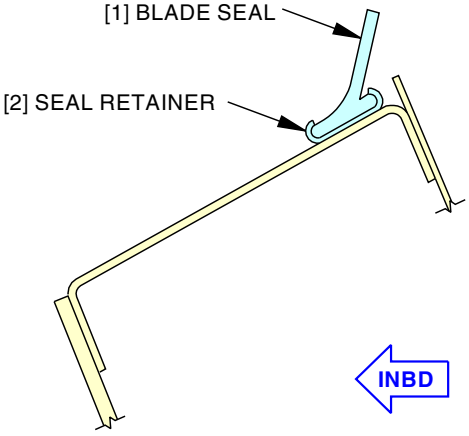


CARGO DOOR
(EXAMPLE)



BLADE SEAL

A



A-A

2415698 S00061538713_V1

Cargo Door Pressure Seal Check
Figure 601/52-31-00-990-810

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CARGO DOOR COUNTERBALANCE MECHANISM - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Cargo door counterbalance removal

(2) Cargo door counterbalance installation.

B. This procedure is the same for the forward and aft cargo door.

C. The cargo door counterbalance is referred to as the counterbalance in this procedure.

TASK 52-31-12-000-801

2. Cargo Door Counterbalance Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the cargo door counterbalance.

B. Tools/Equipment

Reference	Description
STD-1166	Block - Wood, 1 to 3 Inch Thick, More Than 6 Inch Length
STD-11995	Nut - Plain, Hexagon, Per AN315-6R Specifications
STD-11996	Washer - Flat, Per NAS1149C0763R Specifications

C. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

D. Prepare for the Removal

SUBTASK 52-31-12-010-001

(1) Get access to the counterbalance [2]:

(a) Attach a DO-NOT-OPERATE tag to the exterior handle of the door.

(b) Open the door and go into the cargo compartment.

(c) Close and latch the door.

(d) Remove the door lining over the counterbalance [2].

SUBTASK 52-31-12-860-001

WARNING OBEY THE SAFETY PRECAUTIONS. IF YOU DO NOT OBEY THE SAFETY PRECAUTIONS, YOU CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

(2) Make sure that the counterbalance [2] does not operate, secure the counterbalance [2] as follows::

NOTE: It is not safe for personnel to remove the counterbalance while the cable is under tension.

(a) Make sure that the door is closed and latched.

(b) Remove the screw [17], washer [18], and sleeve [15] from the guide pin [3].

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(c) Install a washer [27], washer, STD-11996 and nut [11], nut, STD-11995 on the guide pin [3] against the adjustment nut [20].

NOTE: Install the nut finger tight only. This will hold the spring in the counterbalance [2] and stop its operation.

E. Cargo Door Counterbalance Removal

SUBTASK 52-31-12-020-001

WARNING MAKE SURE THAT YOU SAFETY THE COUNTERBALANCE BEFORE YOU CONNECT THE COUNTERBALANCE OR CABLE. THERE IS A VERY STRONG SPRING IN THE COUNTERBALANCE AND CABLE. INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

(1) Disconnect the counterbalance [2] from the door:

(a) Unlatch and open the door 1-2 inches.

(b) Install a wood block, STD-1166 under the lower stops to hold the door up.

(c) Make sure that the cable [1] is loose.

(d) Remove the bolts [7] and washers [6] that attach the forward end of the counterbalance [2] to the door.

(e) Hold the counterbalance [2] and remove the bolts [4] and washers [5] that attach the middle of the counterbalance [2] to the door.

SUBTASK 52-31-12-020-002

(2) Disconnect the cable [1] from the counterbalance [2]:

(a) Pull the counterbalance [2] away from the door to get access to the back of the counterbalance [2] where the cable [1] is attached.

(b) Loosen the screws [16] that attach the cable guides [19] to the counterbalance [2].

NOTE: Only loosen the two screws [16] that are adjacent to the end of the cable [1].

(c) Remove the screw [21] and washer [22] on the retainer [23] that keeps the end of the cable [1] around the drum [24] of the counterbalance [2].

(d) Disengage the cable [1] from the drum [24].

(e) Remove the counterbalance [2] from the door.

SUBTASK 52-31-12-020-003

(3) Disconnect the cable [1] and sheave [25] from the cargo compartment ceiling and remove from the door:

NOTE: Only do these steps if it is necessary to remove the cable [1].

(a) Remove the lockwire from the alignment bolt [10].

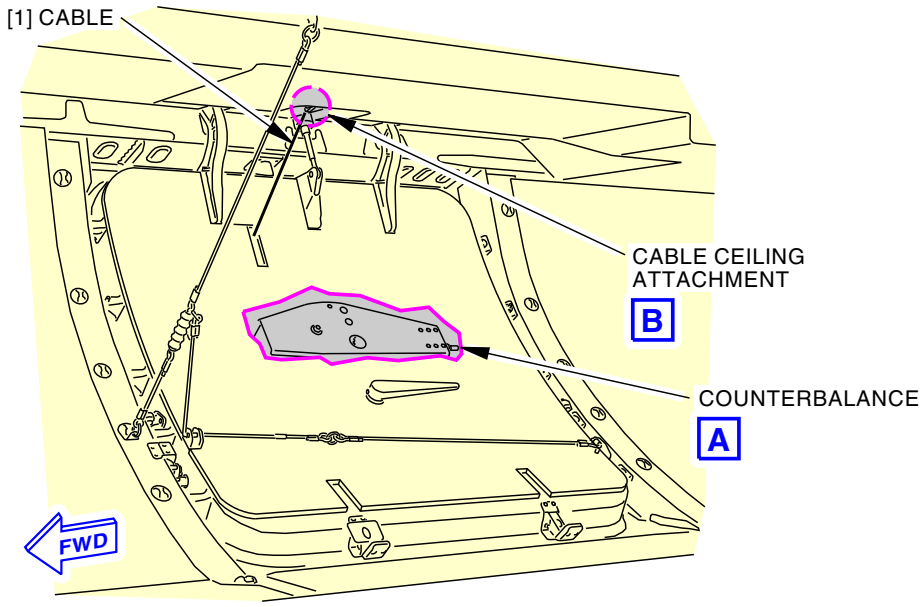
(b) Remove the alignment bolt [10] and retainer ring [12] that attach the cable [1] and sheave [25] to the cargo compartment ceiling.

(c) Remove the cotter pin [14], pin [9], and washer [13] that attach the cable [1] and sheave [25] to the ceiling.

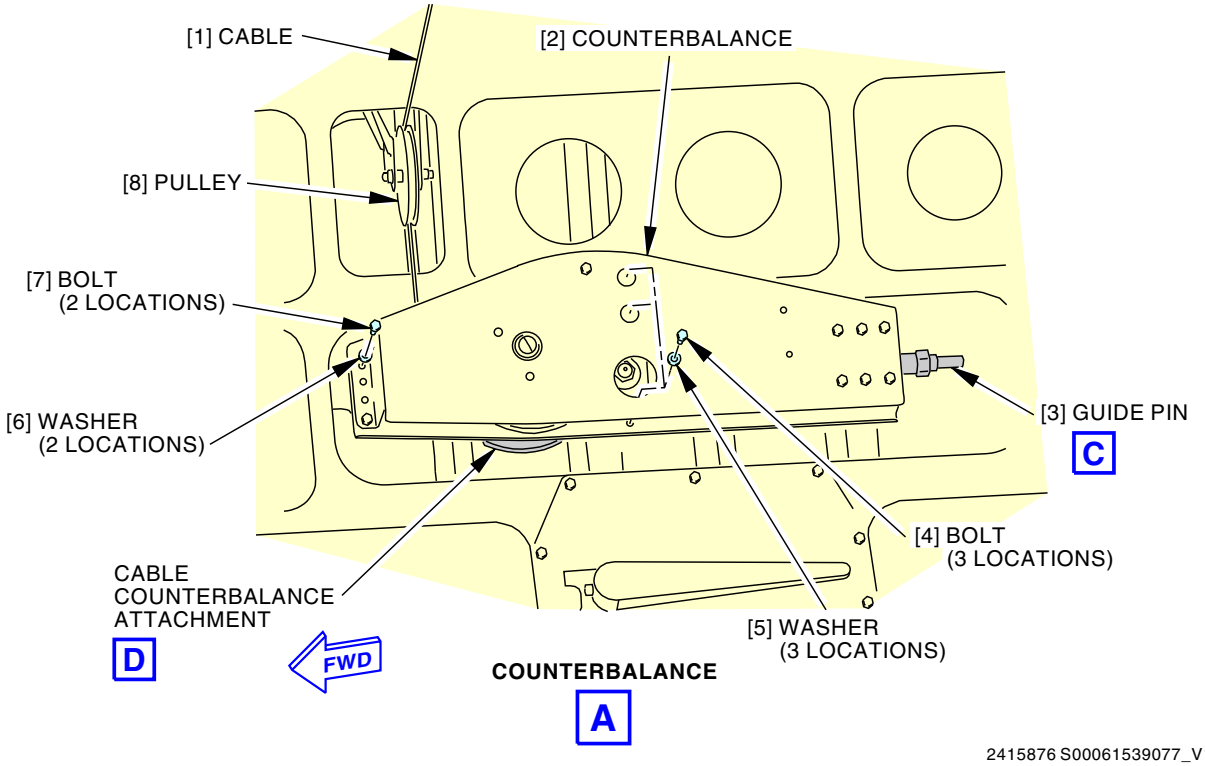
(d) Remove the cable [1] from the pulley [8] and door.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

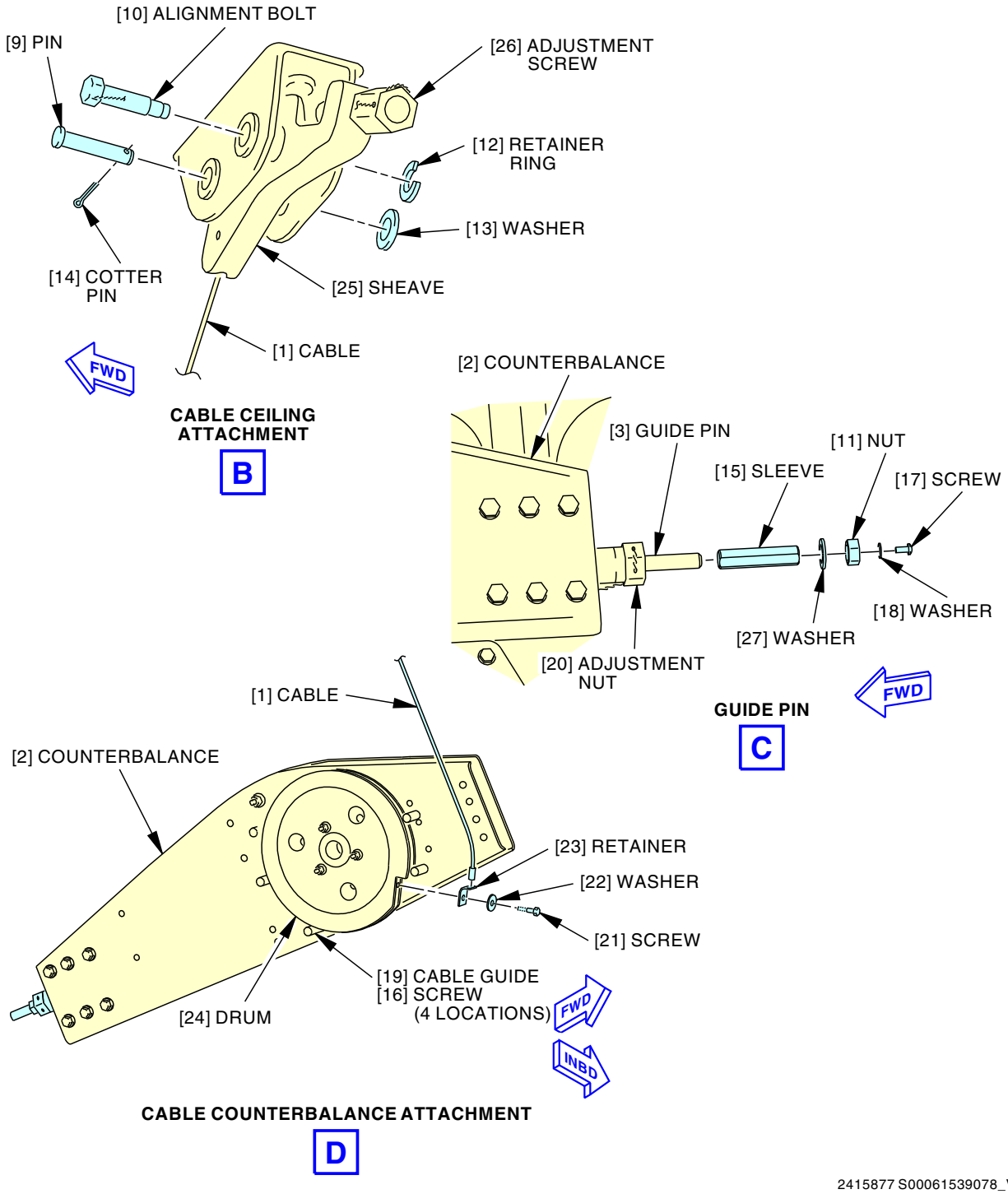


CARGO DOOR (EXAMPLE)



Cargo Door Counterbalance Installation
Figure 401/52-31-12-990-803 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Cargo Door Counterbalance Installation
Figure 401/52-31-12-990-803 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-31-12-400-801

3. Cargo Door Counterbalance Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the cargo door counterbalance.

B. References

Reference	Title
52-31-00-820-801	Cargo Door Adjustment (P/B 501)

C. Tools/Equipment

Reference	Description
STD-11995	Nut - Plain, Hexagon, Per AN315-6R Specifications
STD-11996	Washer - Flat, Per NAS1149C0763R Specifications

D. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33
G01048	Lockwire - MS20995C32, Corrosion Resistant Steel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
2	Counterbalance	52-31-00-09B-395	SIA ALL
		52-31-00-15-415	SIA ALL
14	Cotter pin	52-31-00-01B-275	SIA ALL
		52-31-00-14-365	SIA ALL

F. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

G. Prepare for the Installation

SUBTASK 52-31-12-860-002

WARNING MAKE SURE THAT YOU SAFETY THE COUNTERBALANCE BEFORE YOU CONNECT THE COUNTERBALANCE OR CABLE. THERE IS A VERY STRONG SPRING IN THE COUNTERBALANCE AND CABLE. INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

(1) Make sure that the washer [27], washer, STD-11996 and nut [11], nut, STD-11995 are installed on the guide pin [3] against the adjustment nut [20] on the end of the counterbalance [2].

NOTE: This will hold the spring in the counterbalance [2] and stop its operation.

H. Cargo Door Counterbalance Installation

SUBTASK 52-31-12-420-001

(1) Connect the cable [1] and sheave [25] to the cargo compartment ceiling and install on the door:

NOTE: Only do these steps if it is necessary to install the cable [1].

(a) Install the cable [1] through the pulley [8] and the door.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) Apply a light coat of the grease, D00633 to the pin [9] and alignment bolt [10] and mating surfaces.

(c) Install the pin [9], washer [13], and new cotter pin [14] that attach the cable [1] and sheave [25] to the cargo compartment ceiling.

(d) Install the alignment bolt [10] and retainer ring [12] that attach the cable [1] and sheave [25] to the ceiling.

(e) Install the MS20995C32 lockwire, G01048 between the alignment bolt [10] and the cable adjustment screw [26].

SUBTASK 52-31-12-420-002

(2) Connect the cable [1] to the counterbalance [2]:

(a) Make sure that the door is open 1-2 inches and a block is installed under the lower door stops.

(b) Hold the counterbalance [2] near its correct position and make sure you can get access to the back of the counterbalance [2] where the cable [1] is attached.

(c) Make sure that the cable [1] is attached to the cargo compartment ceiling and installed correctly through the pulley [8].

(d) Engage the cable [1] with the drum [24] in the counterbalance [2].

(e) Install the screw [21] and washer [22] on the retainer [23] to keep the end of the cable [1] around the drum [24] on the counterbalance [2].

(f) Tighten the screws [16] that attach the cable guides [19] to the counterbalance [2].

SUBTASK 52-31-12-420-003

(3) Connect the counterbalance [2] to the door:

(a) Put the counterbalance [2] in its correct position on the door and hold.

(b) Install the bolts [4] and washers [5] that attach the middle of the counterbalance [2] to the door.

(c) Install the bolts [7] and washers [6] that attach the forward end of the counterbalance [2] to the door.

SUBTASK 52-31-12-820-001

(4) Do this task: Cargo Door Adjustment, TASK 52-31-00-820-801.

(5) When the door is installed and counterbalance cable is connected to the sheave on the ceiling, do the following:

(a) Make sure that the washer [27], washer, STD-11996 and nut [11], nut, STD-11995 are removed from the guide pin [3].

(b) Make sure that the sleeve [15], washer [18], and screw [17] are installed on the guide pin [3].

SUBTASK 52-31-12-410-001

(6) Close access to the counterbalance [2] as follows:

(a) Install the door lining.

(b) Remove the DO-NOT-OPERATE tag from the exterior handle.

SUBTASK 52-31-12-710-001

(7) Do a test on the counterbalance [2] as follows:

(a) Open and close the door.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) Make sure that the door opens easily and smoothly.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CARGO DOOR COUNTERBALANCE MECHANISM - REPAIRS

1. General

A. This procedure has this task:

(1) A replacement of a broken forward or aft cargo door counterbalance cable.

B. The counterbalance mechanism on each cargo door is the same, but the length of the counterbalance cables is different.

TASK 52-31-12-000-802

2. Broken Cargo Door Counterbalance Cable Replacement

(Figure 801)

A. References

Reference	Title
52-31-12-000-801	Cargo Door Counterbalance Removal (P/B 401)
52-31-12-400-801	Cargo Door Counterbalance Installation (P/B 401)

B. Tools/Equipment

Reference	Description
STD-858	Tag - DO NOT OPERATE
STD-11995	Nut - Plain, Hexagon, Per AN315-6R Specifications
STD-11996	Washer - Flat, Per NAS1149C0763R Specifications
STD-13650	Nut - Plan, Hexagon, Drilled Jam, Thin per NAS1423-8

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
19	Bearing	52-31-12-01B-235	SIA ALL
		52-31-12-02-235	SIA ALL
23	Nut	52-31-12-01B-120	SIA ALL
		52-31-12-02-120	SIA ALL

D. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

E. Broken Cargo Door Counterbalance Cable Replacement

SUBTASK 52-31-12-010-002

(1) Get access to the counterbalance mechanism as follows:

(a) Attach the DO NOT OPERATE tag, STD-858, to the exterior handle of the door.

(b) Open the door and go into the cargo compartment.

(c) Close and latch the door.

(d) Remove the door lining over the counterbalance [5].

SUBTASK 52-31-12-860-003

(2) Safety the counterbalance [5] (Figure 801):

NOTE: Two persons are necessary to do this procedure: one person to hold the counterbalance drum and one person to safety the spring in the counterbalance.

(a) Make sure that the door is closed and latched.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) Remove the screw [7] and washer [6] from the guide pin [11].

(c) Reach behind the counterbalance [5] and hold the cable drum [1] on the back side of the counterbalance [5] with your hand.

WARNING HOLD THE DRUM AND THE WRENCH ON THE NUT FOR THE CAM AXLE SHAFT TIGHTLY. THERE IS A VERY STRONG SPRING IN THE COUNTERBALANCE THAT CAN CAUSE INJURY TO PERSONNEL.

(d) Remove the nut [23] on the cam axle shaft [2].

1) Replace the nut [23] with nut, STD-13650.

(e) Release the cable drum [1] and remove your hand from behind the counterbalance [5].

(f) Hold a wrench tightly and turn the cam axle shaft [2] clockwise 90 degrees.

NOTE: When the cam axle shaft is turned, the spring is compressed and the guide pin will come out of the aft side of the counterbalance.

(g) Remove the sleeve [10] from the guide pin [11].

(h) Install a washer [3] (washer, STD-11996) and nut [4] (nut, STD-11995) on the guide pin [11] against the adjustment nut [12].

1) Install the nut [4] (nut, STD-11995) finger tight only.

NOTE: This will hold the spring in the counterbalance and stop its operation.

(i) If it is necessary, continue to turn the cam axle shaft [2] clockwise until you can install the washer [3] (washer, STD-11996) and nut [4] (nut, STD-11995) on the guide pin [11] against the adjustment nut [12].

(j) Release the cam axle shaft [2] and cable drum [1].

(k) Remove the nut, STD-13650, from the cam axle shaft [2].

1) Replace the nut, STD-13650, with the correct self-locking nut [23].

(l) Tighten the nut [23] to 290 in-lb (33 N·m) - 510 in-lb (58 N·m).

SUBTASK 52-31-12-020-004

(3) Remove the broken cable from the cargo door counterbalance (TASK 52-31-12-000-801).

SUBTASK 52-31-12-960-001

(4) Replace the bearing [19] installed on the idler crank [20] (Figure 801):

NOTE: It is necessary to replace the bearing because damage can occur to the bearing when the cable breaks.

(a) Remove the bolts [13], washers [14], nuts [15], bolts [16], and washers [17] that hold the top and bottom sides of the counterbalance [5] to the block [25].

(b) Remove the bolt [9], washer [8], washer [26], and nut [27] that attach the idler crank [20] to the counterbalance [5].

(c) Remove the idler crank [20] and block [25] from the counterbalance [5] at the same time.

(d) Remove the bolt [24], bearing [19], washer [22], and nut [21] from the idler crank [20].

(e) Install the new bearing [19].

(f) Install the bolt [24], washer [22], and nut [21] through the idler crank [20].

(g) Put the block [25] and idler crank [20] in their correct position in the counterbalance [5] at the same time.

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(h) Install the bolt [9], washer [8], washer [26], and nut [27] to attach the idler crank [20] to the counterbalance [5].

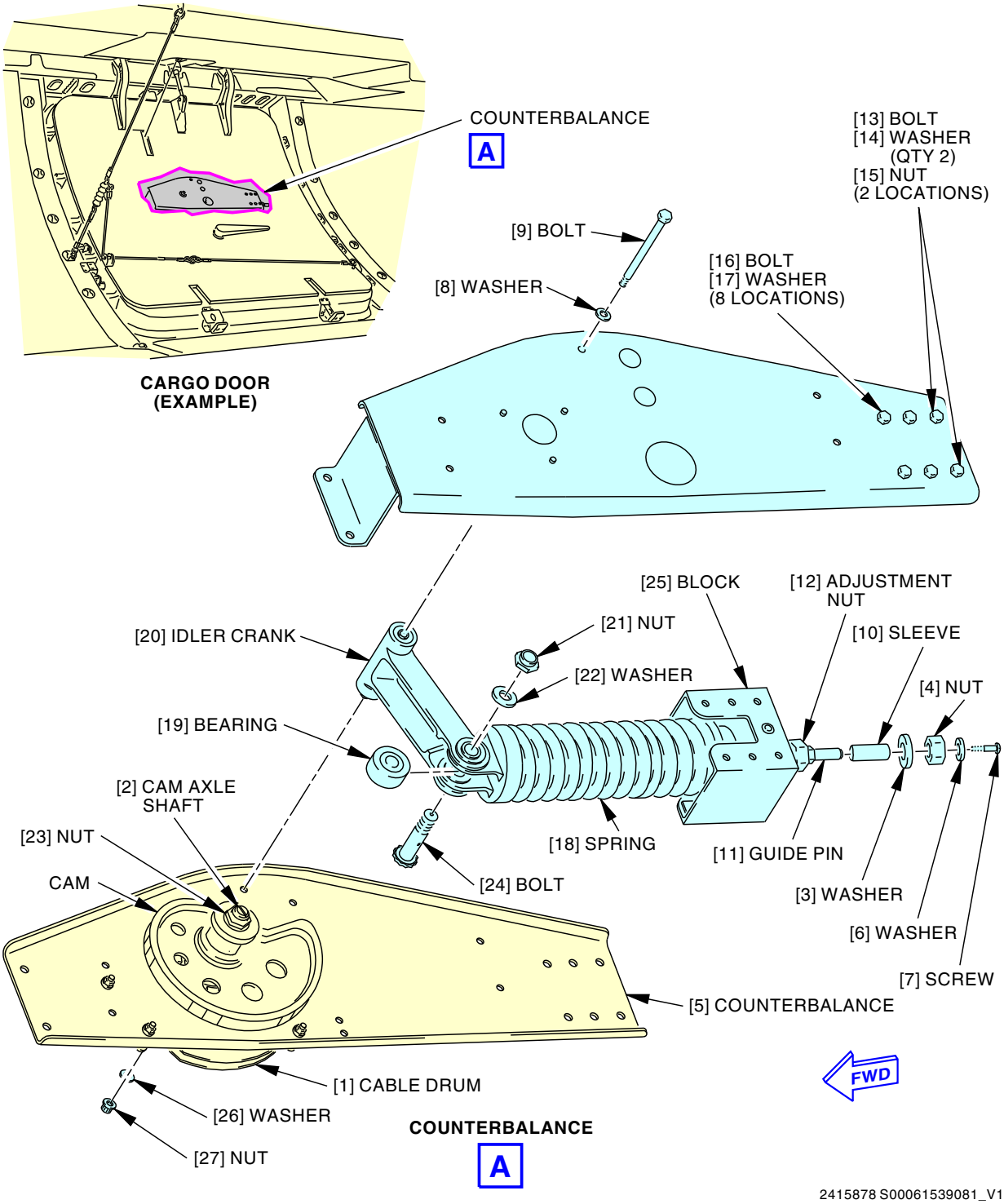
(i) Install the bolts [13], washers [14], nuts [15], bolts [16], and washers [17] to attach the block [25] to the counterbalance [5].

SUBTASK 52-31-12-820-002

(5) Install a new cable to the cargo door counterbalance [5] (TASK 52-31-12-400-801).

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Broken Cargo Door Counterbalance Cable Replacement
Figure 801/52-31-12-990-802

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CARGO DOOR SNUBBER - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Cargo door snubber removal

(2) Cargo door snubber installation.

B. This procedure is the same for each cargo door.

C. The cargo door snubber is referred to as the snubber in this procedure.

TASK 52-31-13-000-801

2. Cargo Door Snubber Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the cargo door snubber.

B. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

C. Prepare for the Removal

SUBTASK 52-31-13-010-001

(1) Get access to the snubber [1] as follows:

(a) Attach a DO-NOT-OPERATE tag to the exterior handle.

(b) Open the door and go into the cargo compartment.

(c) Close and latch the door.

D. Cargo Door Snubber Removal

SUBTASK 52-31-13-020-001

(1) Disconnect the snubber [1] from the door structure:

(a) Remove the bolt [6], washers [7], and nut [8] that attach the snubber [1] to the door structure.

(b) If it is necessary, remove the bushing [9] from the fitting [10].

SUBTASK 52-31-13-020-002

(2) Disconnect the snubber [1] from the fuselage structure:

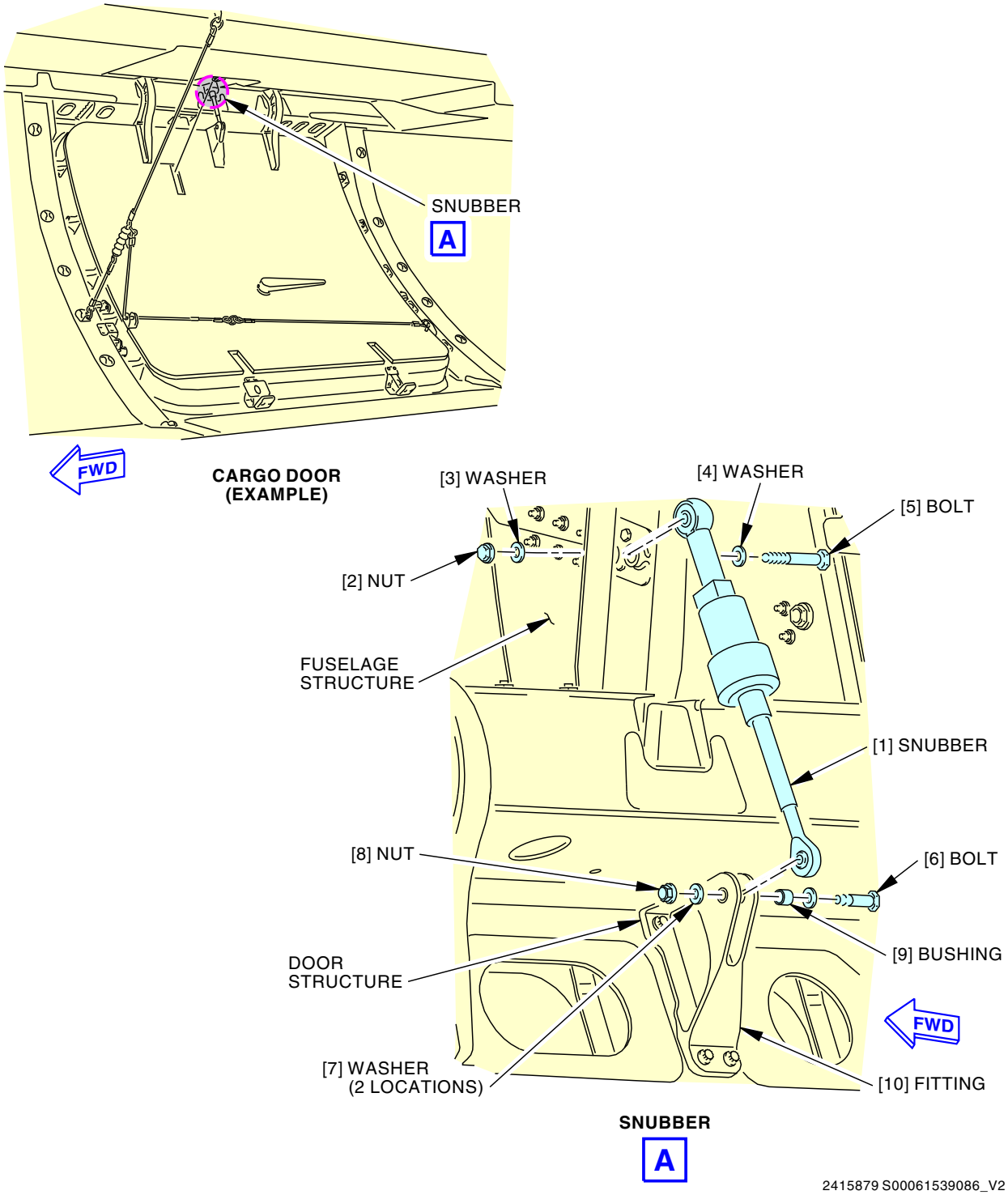
(a) Remove the bolt [5], washer [4], washer [7], and nut [2] that attach the snubber [1] to the fuselage structure.

SUBTASK 52-31-13-020-003

(3) Remove the snubber [1] from the door.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Cargo Door Snubber Installation
Figure 401/52-31-13-990-804

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-31-13-400-801

3. Cargo Door Snubber Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the cargo door snubber.

B. References

Reference	Title
52-31-13-710-801	Cargo Door Snubber Operational Test (P/B 501)

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Snubber	52-31-13-01B-040	SIA ALL
		52-31-13-02-040	SIA ALL

D. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

E. Cargo Door Snubber Installation

SUBTASK 52-31-13-420-001

(1) Connect the snubber [1] to the fuselage structure:

(a) Hold the snubber [1] in its correct position.

(b) Install the bolt [5], washer [4], washer [7], and nut [2] that attach the snubber [1] to the fuselage structure.

SUBTASK 52-31-13-420-002

(2) Connect the snubber [1] to the door structure:

(a) If you removed it, install the bushing [9] in the fitting [10].

(b) Install the bolt [6], washers [7], and nut [8] that attach the snubber [1] to the door structure.

SUBTASK 52-31-13-080-001

(3) Remove the DO-NOT-OPERATE tag from the exterior handle.

SUBTASK 52-31-13-710-001

(4) Do this task: Cargo Door Snubber Operational Test, TASK 52-31-13-710-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CARGO DOOR SNUBBER - ADJUSTMENT/TEST

1. General

A. This procedure has these tasks:

(1) An operational test of the forward or aft cargo door snubber

(2) A functional test of the forward or aft cargo door snubber.

B. This procedure is the same for each cargo door.

TASK 52-31-13-710-801

2. Cargo Door Snubber Operational Test

(Figure 501)

A. References

Reference	Title
52-31-13-000-801	Cargo Door Snubber Removal (P/B 401)
52-31-13-400-801	Cargo Door Snubber Installation (P/B 401)

B. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

C. Cargo Door Snubber Operational Test

SUBTASK 52-31-13-710-002

(1) Do an operational test on the usual operation of the snubber [1]:

(a) Open the cargo door.

(b) Go into the cargo compartment.

(c) Make sure the door closes and opens easily and smoothly.

(d) Examine the snubber [1] carefully and make sure it has no leaks.

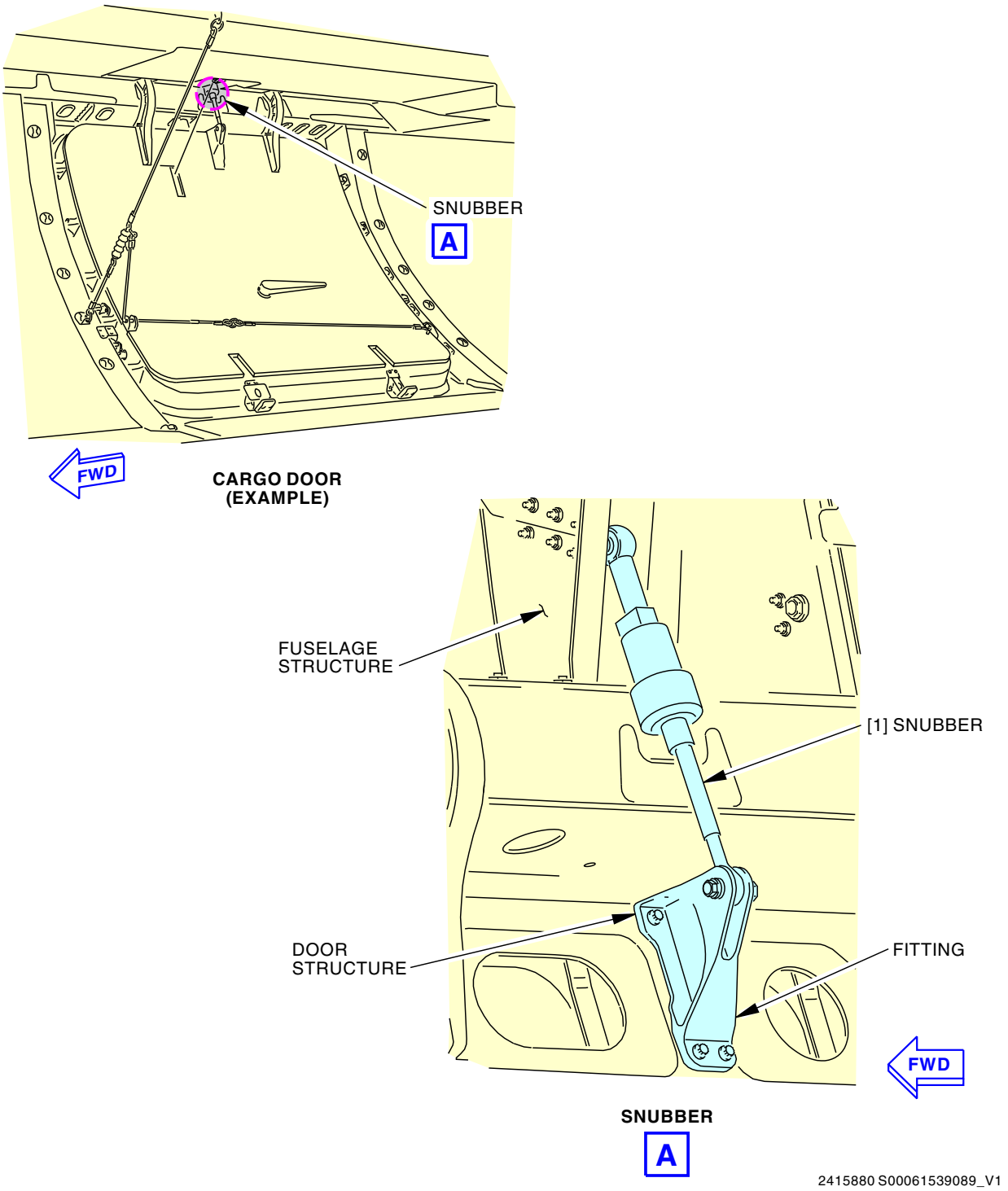
(e) If the snubber [1] has leaks, replace it:

1) Cargo Door Snubber Removal, TASK 52-31-13-000-801

2) Cargo Door Snubber Installation, TASK 52-31-13-400-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Cargo Door Snubber Operational Test
Figure 501/52-31-13-990-802

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-31-13-710-802

3. Cargo Door Snubber Functional Test

(Figure 502)

A. References

Reference	Title
52-31-13-000-801	Cargo Door Snubber Removal (P/B 401)
52-31-13-400-801	Cargo Door Snubber Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
A00159	Compound - Sealing, Thread-Locking, Anaerobic, Single-Component (100-200 In-lbs)	ASTM D5363 Grp 3 Cl 2 Grd 1 (SUPERSEDES MIL-S-46163)
D00633	Grease - Aircraft General Purpose	BMS3-33
G01048	Lockwire - MS20995C32, Corrosion Resistant Steel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

C. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

D. Cargo Door Snubber Functional Test

SUBTASK 52-31-13-020-004

(1) Disconnect the counterbalance assembly [2]:

(a) Close and latch the door.

(b) Remove the door lining over the counterbalance assembly [2].

(c) Safety the counterbalance assembly [2] as follows:

1) Remove the screw [9], washer [8], and sleeve [5] from the guide pin [3] on the aft end of the counterbalance assembly [2].

2) Install a washer [7] and a nut [6] on the guide pin [3] against the adjustment nut [4].

NOTE: Install the nut finger tight only. This will hold the spring in the counterbalance assembly and stop its operation.

(d) Disconnect the cable [17] and sheave [16] from the cargo compartment ceiling as follows:

1) Unlatch and open the door 1 in. (25.4 mm) - 2 in. (50.8 mm).

2) Install a block, approximately 2 in. (50.8 mm) thick and 4 in. (101.6 mm) wide, under the lower stops to hold the door up.

3) Make sure the cable [17] is loose.

4) Remove the lockwire and remove the alignment bolt [12] and retaining ring [14] that attach the cable [17] and sheave [16] to the cargo compartment ceiling.

5) Remove the cotter pin [11], pin [10], and washer [15] that attach the cable [17] and sheave [16] to the ceiling.

6) Safety the cable [17] and sheave [16] to the door.

7) Remove the block from under the lower stops.

SUBTASK 52-31-13-710-003

(2) Do a test on the snubber [1]:

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) Lift the door to the fully open position and attach the cargo door support strap to the lower stop to hold the door open.

(b) Install a foam pad across the door opening.

NOTE: The foam pad will prevent damage to the door opening if the snubber is defective and the door falls too quickly.

WARNING STAY AWAY FROM THE DOOR AND DOOR OPENING WHEN YOU RELEASE THE DOOR FROM THE STRAP. IF THE SNUBBER DOES NOT OPERATE CORRECTLY, THE DOOR CAN FALL QUICKLY. THIS CAN CAUSE INJURY TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(c) Release the door from the cargo door support strap and let the door fall.

(d) Measure the time it takes for the door to close at the bottom edge of the door.

(e) If the door closes in less than 1.2 seconds, replace the snubber [1]:

1) Cargo Door Snubber Removal, TASK 52-31-13-000-801

2) Cargo Door Snubber Installation, TASK 52-31-13-400-801.

(f) If the movement of the door was not smooth and at a constant speed, replace the snubber [1]:

1) Cargo Door Snubber Removal, TASK 52-31-13-000-801

2) Cargo Door Snubber Installation, TASK 52-31-13-400-801.

(g) Carefully examine the snubber [1] for leaks.

(h) If the snubber [1] has leaks, replace it:

1) Cargo Door Snubber Removal, TASK 52-31-13-000-801

2) Cargo Door Snubber Installation, TASK 52-31-13-400-801.

(i) Remove the foam pad.

SUBTASK 52-31-13-420-003

WARNING MAKE SURE THAT YOU SAFETY THE COUNTERBALANCE BEFORE YOU CONNECT THE COUNTERBALANCE OR CABLE. THERE IS A VERY STRONG SPRING IN THE COUNTERBALANCE AND CABLE. INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

(3) Connect the counterbalance assembly [2]:

(a) Connect the cable [17] and sheave [16] to the cargo compartment ceiling as follows:

1) Unlatch and open the door 1 in. (25.4 mm) - 2 in. (50.8 mm).

2) Install a block, approximately 2 in. (50.8 mm) thick and 4 in. (101.6 mm) wide, under the lower stops to hold the door up.

3) Apply a light coat of the grease, D00633, to the pin [10], alignment bolt [12], and mating surfaces.

4) Install the pin [10], washer [15], and new cotter pin [11] to attach the cable [17] and sheave [16] to the cargo compartment ceiling.

5) Install the alignment bolt [12] and retaining ring [14] to attach the cable [17] and sheave [16] to the cargo compartment ceiling.

6) Install the new MS20995C32 lockwire, G01048, between the alignment bolt [12] and adjustment screw [13].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

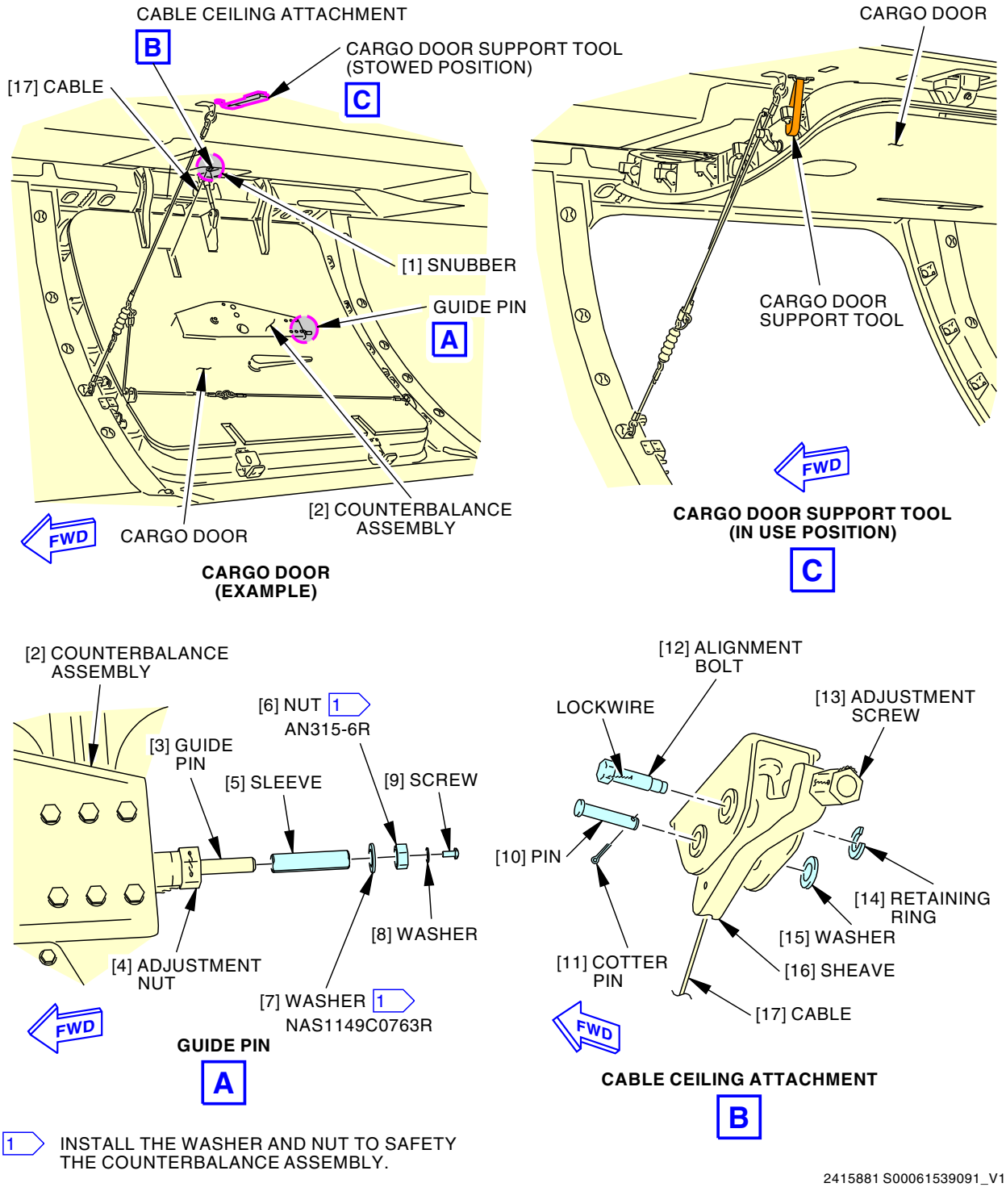
(b) Make the counterbalance assembly [2] operable as follows:

1) Close and latch the door.
2) Remove the washer [7] and nut [6] on the guide pin [3] against the adjustment nut [4].
3) Apply a light coat of the grease, D00633, to the outer surface of the sleeve [5].
4) Apply the compound, A00159, to the screw [9].
5) Install the screw [9], washer [8], and sleeve [5] on the guide pin [3].

(c) Install the door lining over the counterbalance assembly [2].

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



1 INSTALL THE WASHER AND NUT TO SAFETY THE COUNTERBALANCE ASSEMBLY.

2415881 S00061539091_V1

Cargo Door Snubber Test
Figure 502/52-31-13-990-803

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CARGO DOOR HANDLE MECHANISM - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Cargo door handle mechanism removal

(2) Cargo door handle mechanism installation.

B. This procedure is the same for the forward or aft cargo door.

TASK 52-31-14-000-801

2. Cargo Door Handle Mechanism Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the cargo door handle mechanism.

B. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
12	Hinge	52-31-51-50E-105	SIA 001-003

C. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

D. Prepare for the Removal

SUBTASK 52-31-14-010-001

(1) Get access to the handle mechanism as follows:

(a) Open the door and go into the cargo compartment.

(b) Close the door, but do not latch it.

(c) Remove the door lining over the handle mechanism.

E. Cargo Door Handle Mechanism Removal

SUBTASK 52-31-14-020-001

(1) Remove the interior handle [1]:

(a) Remove the locknut [29], washer [30], and bolt [2] that attach the interior handle [1] to the actuator [27].

(b) Remove the interior handle [1] from the actuator [27].

(c) Remove the screws [3] and washers [4] that attach the panel [5] to the door structure.

(d) Remove the panel [5] and collar [28] from the door structure.

(e) Disconnect the spring [7] from the actuator [27].

(f) Remove the lockwire and screws [24] that attach the fitting [23] to the actuator [27].

(g) Remove the fitting [23] from the actuator [27].

(h) Remove the bolt [6], washers [8], washer [32] (if installed), washers [22], castellated nut [9], and cotter pin [10] that attach the rod [21] to the actuator [27].

(i) Remove the actuator [27], quad ring [20], and inserts [26] as an assembly from the housing [19].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1) Do not remove the inserts [26] from the actuator [27] unless they are damaged and replacement is necessary.

(j) Remove and discard the quad ring [20] from the actuator [27].

(k) Move the spring [16] away from the spring keeper [17] and remove the spring keeper [17] from the housing [19].

1) Let the spring [16] retract into the sleeve [15].

SUBTASK 52-31-14-020-002

(2) Remove the exterior handle [14]:

(a) Open the door and go to the exterior of the airplane.

(b) Close the door, but do not latch it.

(c) Remove the exterior handle [14] from the housing [19].

(d) Remove and discard the bearing stud [13] from the exterior handle [14].

1) If necessary, use a drill to remove any material that remains in the stud boss of the handle [14].

(e) Remove and discard the wedge [31] from the exterior handle [14].

(f) Keep the sleeve [15] and the exterior handle [14] as an assembly.

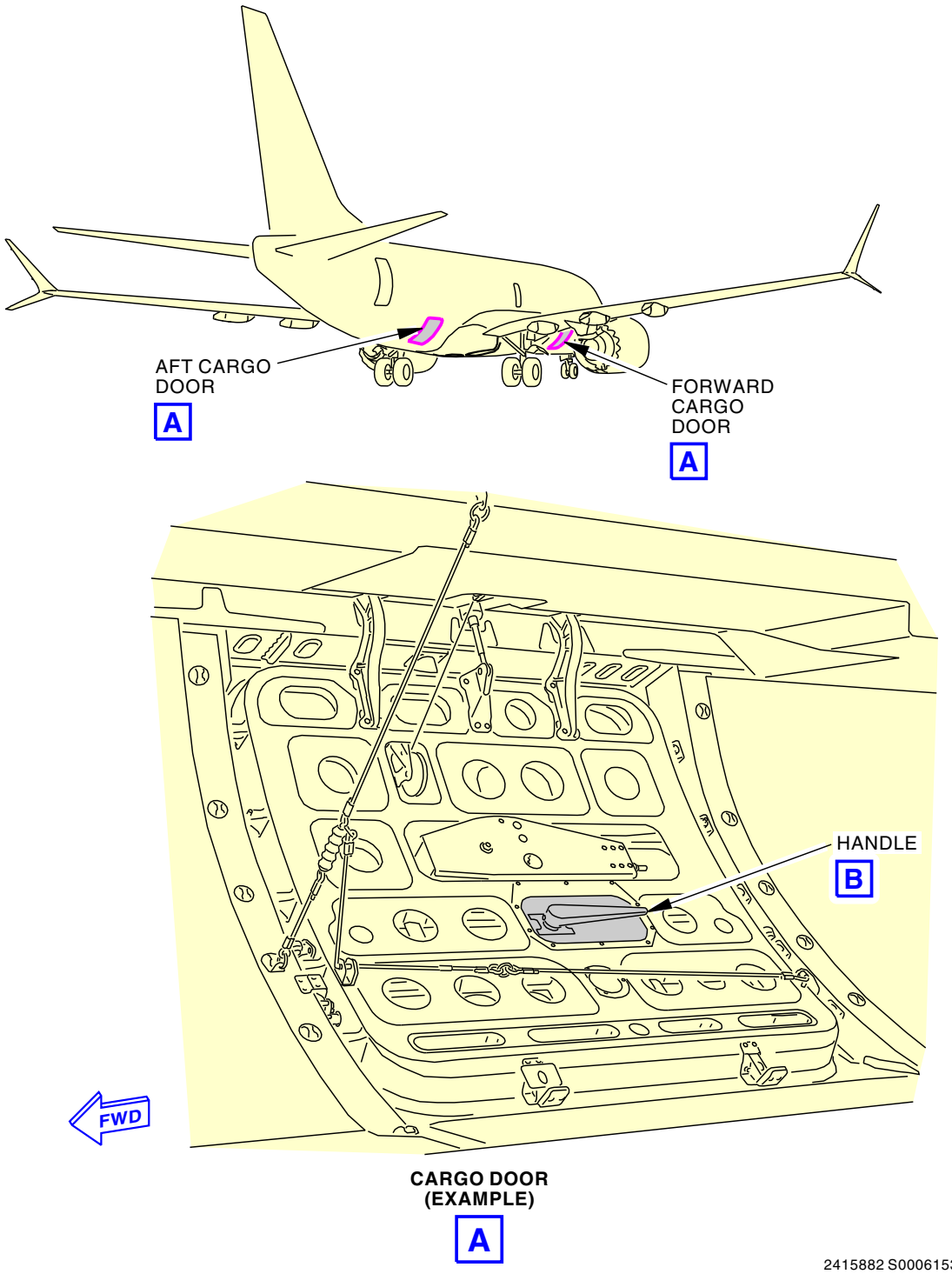
NOTE: The sleeve [15] and the exterior handle [14] are aligned and secured by a pin. It is not necessary to disassemble them. If replacement of either component is necessary, replace the exterior handle assembly.

(g) Do not remove the rivets [11] or hinge [12] unless they are damaged and replacement is necessary.

(h) Do not disassemble the hinge [12] unless it is damaged and replacement is necessary.

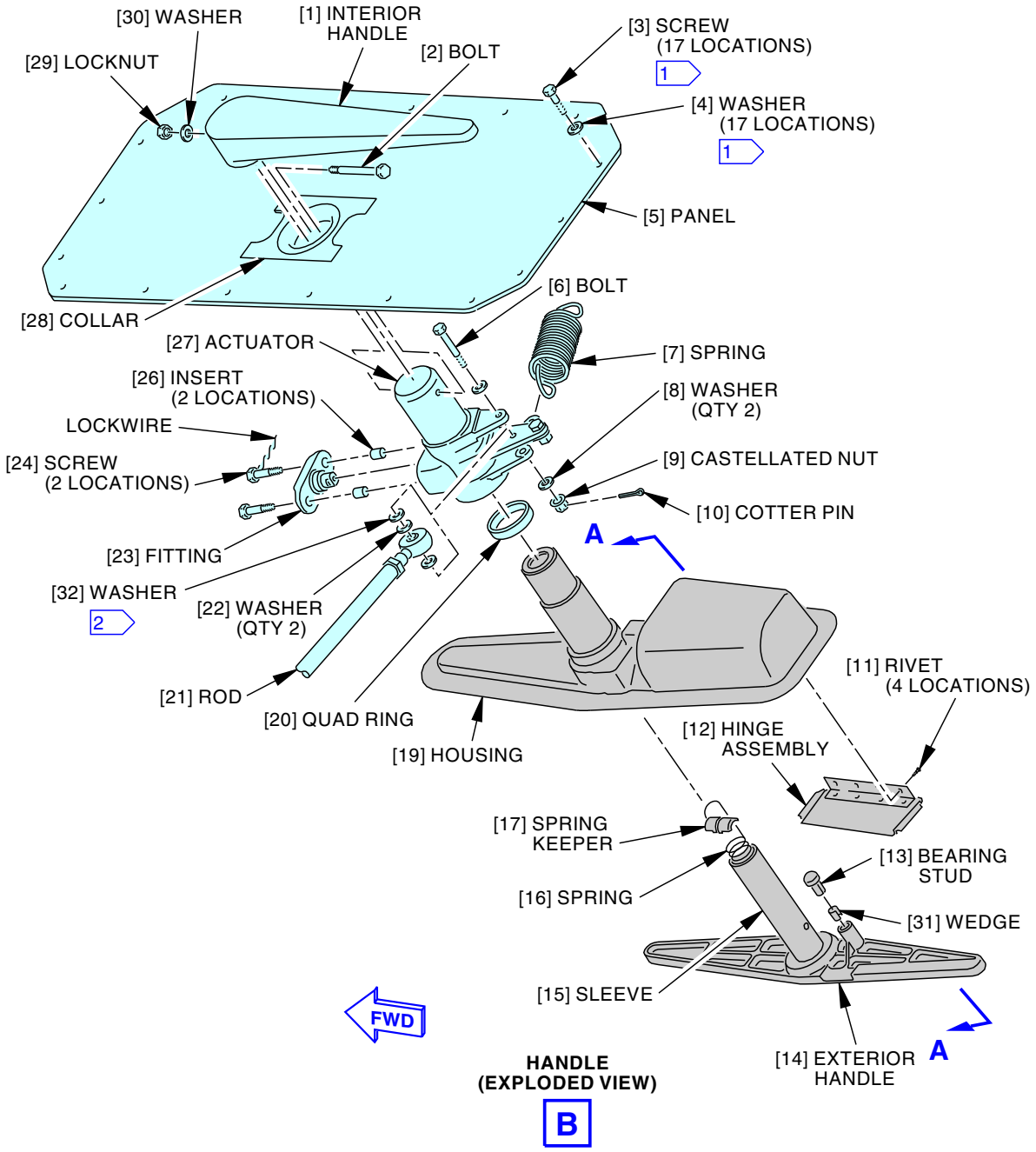
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Cargo Door Handle Mechanism Installation
Figure 401/52-31-14-990-802 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



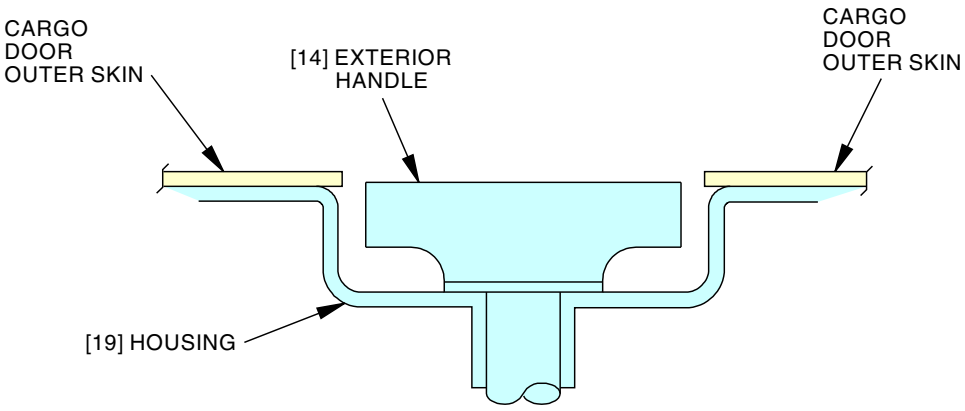
1 AFT CARGO DOOR PANEL IS SHOWN. FORWARD CARGO DOOR PANEL IS SIMILAR BUT HAS ONLY 10 SCREWS [3] AND 10 WASHERS [4].

2 INSTALL A MAXIMUM OF 2 WASHERS AS REQUIRED. MAINTAIN MAXIMUM 0.010 INCH (0.25 mm) GAP AFTER INSTALLATION.

2415883 S00061539097_V2

Cargo Door Handle Mechanism Installation
Figure 401/52-31-14-990-802 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415884 S00061539098_V1

Cargo Door Handle Mechanism Installation
Figure 401/52-31-14-990-802 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-31-14-400-801

3. Cargo Door Handle Mechanism Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the cargo door handle mechanism.

B. References

Reference	Title
52-31-00-700-801	Cargo Door System Test (P/B 501)

C. Consumable Materials

Reference	Description	Specification
C00057	Primer - Zinc Chromate	TT-P-1757B
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)
D00091	Oil - General Purpose, Low Temperature, Lubricating	MIL-PRF-7870 (NATO O-142)
G01048	Lockwire - MS20995C32, Corrosion Resistant Steel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Interior handle	52-31-14-05-010	SIA ALL
		52-31-14-15-005	SIA ALL
11	Rivet	52-31-14-05-095	SIA ALL
		52-31-14-15-090	SIA ALL
12	Hinge	52-31-51-50E-105	SIA 001-003
13	Bearing stud	52-31-14-05-088	SIA ALL
		52-31-14-15-075	SIA ALL
		52-31-14-15-082	SIA ALL
14	Exterior handle	52-31-14-05-068	SIA ALL
		52-31-14-15-060	SIA ALL
		52-31-14-15-062	SIA ALL
20	Quad ring	52-31-14-05-045	SIA ALL
		52-31-14-15-040	SIA ALL
26	Insert	52-31-14-05-050	SIA ALL
		52-31-14-15-045	SIA ALL
31	Wedge	52-31-14-15-080	SIA ALL

E. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

ECCN 9E991 BOEING PROPRIETARY - See title page for details

F. Prepare for the Installation

SUBTASK 52-31-14-410-001

(1) Get access to the handle mechanism as follows:

(a) Go to the exterior of the airplane.

(b) Close the cargo door but do not latch it.

G. Cargo Door Handle Mechanism Installation

SUBTASK 52-31-14-420-001

(1) Install the exterior handle [14]:

(a) Press the new bearing stud [13] and new wedge [31] into the boss in the exterior handle [14].

(b) Make sure there is no clearance between the top of the boss and the shoulder of the bearing stud [13].

(c) If the hinge [12] is not installed, install new rivets [11] that attach the hinge [12] to the housing [19].

(d) Apply a light layer of oil, D00091 to the outer surface of the sleeve [15].

(e) Install the exterior handle [14] in the housing [19].

SUBTASK 52-31-14-420-002

(2) Install the interior handle [1]:

(a) Open the door and go to the interior of the airplane.

(b) Close the door, but do not latch it.

(c) Extend the spring [16] and install the spring keeper [17] on the housing [19] and under the spring [16].

(d) If the inserts [26] are not installed, install new inserts [26] in the actuator [27] one-half to three-quarter turns below the surface and remove the tang.

(e) Install a new quad ring [20] on the actuator [27].

(f) Lubricate the mating surfaces of the actuator [27] and the housing [19] with grease, D00013.

(g) Install the actuator [27], quad ring [20], and two inserts [26] over the shaft of the housing [19].

(h) Align the hole in the actuator [27] with the slot in the housing [19] and the sleeve [15].

(i) Install the fitting [23] on the actuator [27].

(j) Apply primer, C00057 or compound, C00528 to the threads of the screws [24]

(k) Install the screws [24] and MS20995C32 lockwire, G01048 that attach the fitting [23] to the actuator [27].

(l) Connect the spring [7] to the hole in the actuator [27].

(m) Install the bolt [6], washers [8], washers [22], castellated nut [9], and cotter pin [10] that attach the rod [21] to the actuator [27].

1) If necessary, install the washers [32] to maintain maximum 0.01 in. (0.25 mm) gap after installation.

(n) Install the collar [28] and the panel [5] on the door structure.

(o) Install the screws [3] and washers [4] that attach the panel [5] to the door structure.

(p) Install the interior handle [1] in its correct position on the actuator [27].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(q) Install the bolt [2], washer [30], and locknut [29] that attach the interior handle [1] to the actuator [27].

SUBTASK 52-31-14-840-001

(3) Install the door lining over the handle mechanism.

SUBTASK 52-31-14-730-001

(4) Do this task: Cargo Door System Test, TASK 52-31-00-700-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

GALLEY SERVICE DOORS - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks:

(1) Open the Galley Service Door with the exterior handle.

(2) Close the Galley Service Door with the exterior handle.

(3) Open the Galley Service Door with the interior handle.

(4) Close the Galley Service Door with the interior handle.

(5) Galley Service Door Corrosion Prevention.

TASK 52-41-00-860-801

2. Open the Galley Service Door with the Exterior Handle

(Figure 201)

A. References

Reference	Title
25-66-00-040-801	Door-Mounted Escape System - Deactivation (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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

C. Location Zones

Zone	Area
844	Aft Galley Service Door

D. Procedure

SUBTASK 52-41-00-480-001

CAUTION DO NOT OPERATE THE DOOR IN STABLE WINDS OF MORE THAN 40 KNOTS. DO NOT LET THE DOOR STAY OPEN IN WIND GUSTS THAT ARE MORE THAN 65 KNOTS. STRONG WINDS CAN CAUSE DAMAGE TO THE STRUCTURE OF THE AIRPLANE.

(1) Put the work platform, COM-1523 in front of the door.

SUBTASK 52-41-00-860-001

(2) Make sure that the door is safe as follows:

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WARNING MAKE SURE THAT THE GIRT BAR DOES NOT ENGAGE IN THE FLOOR-MOUNTED ESCAPE SLIDE-BRACKETS. IF THE GIRT BAR DOES ENGAGE IN THE BRACKETS, THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR. IF YOU DO NOT OBEY, DAMAGE TO EQUIPMENT AND INJURY TO PERSONNEL CAN OCCUR.

(a) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

WARNING MAKE SURE THAT YOU INSTALL THE GIRT BAR IN THE GIRT BAR RETAINER CLIPS. IF YOU DO NOT INSTALL THE GIRT BAR IN THE GIRT BAR RETAINER CLIPS, ACCIDENTAL INFLATION OF THE ESCAPE SLIDE CAN OCCUR. THIS CAN CAUSE INJURY TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the slide girt bar is stowed and attached in the girt bar retainer clips (TASK 25-66-00-040-801).

SUBTASK 52-41-00-860-002

WARNING BE CAREFUL WHEN YOU OPERATE THE DOOR FROM A MAINTENANCE STAND. IT IS NOT EASY TO OPERATE THE DOOR FROM THE SMALL PLATFORM AREA AND DURING BAD WEATHER CONDITIONS. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

(3) Pull the exterior handle outboard from the recess in the door to engage the door drive mechanism.

SUBTASK 52-41-00-860-003

(4) Turn the exterior handle 180 degrees counterclockwise to unlatch the door.

NOTE: When you turn the handle 180 degrees counterclockwise, the latch rollers disengage with the latch fittings.

NOTE: The initial movement of the door is inward.

SUBTASK 52-41-00-860-004

(5) Return the exterior handle into the recess of the door.

SUBTASK 52-41-00-860-005

(6) Use the door assist handle to pull the door outboard and forward until the door hold open lock in the upper hinge engages and the door is held in the fully open position.

NOTE: The door will be parallel to the fuselage when fully open.

SUBTASK 52-41-00-860-006

(7) Put the personnel barrier, SPL-2005 across the door opening.

——— END OF TASK ———

TASK 52-41-00-860-802

3. Close the Galley Service Door with the Exterior Handle

(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.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Reference	Description
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

B. Location Zones

Zone	Area
844	Aft Galley Service Door

C. Procedure

SUBTASK 52-41-00-860-007

CAUTION DO NOT OPERATE THE DOOR IN STABLE WINDS OF MORE THAN 40 KNOTS. DO NOT LET THE DOOR STAY OPEN IN WIND GUSTS THAT ARE MORE THAN 65 KNOTS. STRONG WINDS CAN CAUSE DAMAGE TO THE STRUCTURE OF THE AIRPLANE.

(1) Make sure the work platform, COM-1523 is installed in front of the door.

SUBTASK 52-41-00-860-008

(2) Remove the personnel barrier, SPL-2005 from across the door if it is installed.

SUBTASK 52-41-00-860-009

WARNING BE CAREFUL WHEN YOU OPERATE THE DOOR FROM A MAINTENANCE STAND. IT IS NOT EASY TO OPERATE THE DOOR FROM THE SMALL PLATFORM AREA AND DURING BAD WEATHER CONDITIONS. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

(3) Release the door from the locked position by using either the "Up to release" lever on the body torque tube, or the "Down to release" button on the guide arm.

SUBTASK 52-41-00-860-010

(4) Use the assist handle to swing the door into the door opening.

SUBTASK 52-41-00-860-011

(5) Pull the exterior handle outward to clear the handle recess.

SUBTASK 52-41-00-860-012

(6) Turn the exterior handle 180 degrees clockwise to close the door.

NOTE: When you turn the handle 180 degrees clockwise, the latch rollers engage with the latch fittings.

SUBTASK 52-41-00-860-013

(7) Release the exterior handle into the recess in the door.

(a) Manually put the exterior handle in the fully stowed position into its recess in the door.

SUBTASK 52-41-00-080-001

(8) Remove the stand, work platform, COM-1523 from the door.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-41-00-860-803

4. Open the Galley Service Door with the Interior Handle

(Figure 202)

A. References

Reference	Title
25-66-00-040-801	Door-Mounted Escape System - Deactivation (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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

C. Location Zones

Zone	Area
844	Aft Galley Service Door

D. Procedure

SUBTASK 52-41-00-860-014

CAUTION

DO NOT OPERATE THE DOOR IN STABLE WINDS OF MORE THAN 40 KNOTS. DO NOT LET THE DOOR STAY OPEN IN WIND GUSTS THAT ARE MORE THAN 65 KNOTS. STRONG WINDS CAN CAUSE DAMAGE TO THE STRUCTURE OF THE AIRPLANE.

(1) Put the work platform, COM-1523 in front of the door.

SUBTASK 52-41-00-860-015

(2) Make sure that the door is safe as follows:

WARNING

MAKE SURE THAT THE GIRT BAR DOES NOT ENGAGE IN THE FLOOR-MOUNTED ESCAPE SLIDE-BRACKETS. IF THE GIRT BAR DOES ENGAGE IN THE BRACKETS, THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR. IF YOU DO NOT OBEY, DAMAGE TO EQUIPMENT AND INJURY TO PERSONNEL CAN OCCUR.

(a) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

WARNING

MAKE SURE THAT YOU INSTALL THE GIRT BAR IN THE GIRT BAR RETAINER CLIPS. IF YOU DO NOT INSTALL THE GIRT BAR IN THE GIRT BAR RETAINER CLIPS, ACCIDENTAL INFLATION OF THE ESCAPE SLIDE CAN OCCUR. THIS CAN CAUSE INJURY TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the slide girt bar is stowed and attached in the girt bar retainer clips (TASK 25-66-00-040-801).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-41-00-860-016

WARNING BE CAREFUL WHEN YOU OPERATE THE DOOR FROM A MAINTENANCE STAND. IT IS NOT EASY TO OPERATE THE DOOR FROM THE SMALL PLATFORM AREA AND DURING BAD WEATHER CONDITIONS. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

(3) Turn the interior handle clockwise 180 degrees to unlatch the door.

NOTE: When you turn the handle 180 degrees clockwise, the latch rollers disengage from the latch fittings and the initial movement of the door is inward.

SUBTASK 52-41-00-860-017

(4) Use the door assist handle to push the door outboard and forward until the door hold open lock in the upper hinge engages and the door is held in the fully open position.

NOTE: The door will be parallel to the fuselage when fully open.

SUBTASK 52-41-00-860-018

(5) Put the personnel barrier, SPL-2005 across the door opening.

END OF TASK

TASK 52-41-00-860-804

5. Close the Galley Service Door with the Interior Handle

(Figure 202)

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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

B. Location Zones

Zone	Area
844	Aft Galley Service Door

C. Procedure

SUBTASK 52-41-00-860-019

CAUTION DO NOT OPERATE THE DOOR IN STABLE WINDS OF MORE THAN 40 KNOTS. DO NOT LET THE DOOR STAY OPEN IN WIND GUSTS THAT ARE MORE THAN 65 KNOTS. STRONG WINDS CAN CAUSE DAMAGE TO THE STRUCTURE OF THE AIRPLANE.

(1) Make sure the work platform, COM-1523 is installed in front of the door.

SUBTASK 52-41-00-860-020

(2) Remove the personnel barrier, SPL-2005 from across the door opening if it is installed.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-41-00-860-021

WARNING BE CAREFUL WHEN YOU OPERATE THE DOOR FROM A MAINTENANCE STAND. IT IS NOT EASY TO OPERATE THE DOOR FROM THE SMALL PLATFORM AREA AND DURING BAD WEATHER CONDITIONS. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

(3) Release the door hold open lock from the locked position by using either the "Up to release" lever on the body torque tube, or the "Down to release" button on the guide arm.

NOTE: A light push at the door interior handle location towards the opening direction is allowed to release the hold open lever.

SUBTASK 52-41-00-860-022

(4) Use the assist handle to swing the door into the door opening.

SUBTASK 52-41-00-860-023

(5) Turn the interior handle 180 degrees counterclockwise to fully close the door.

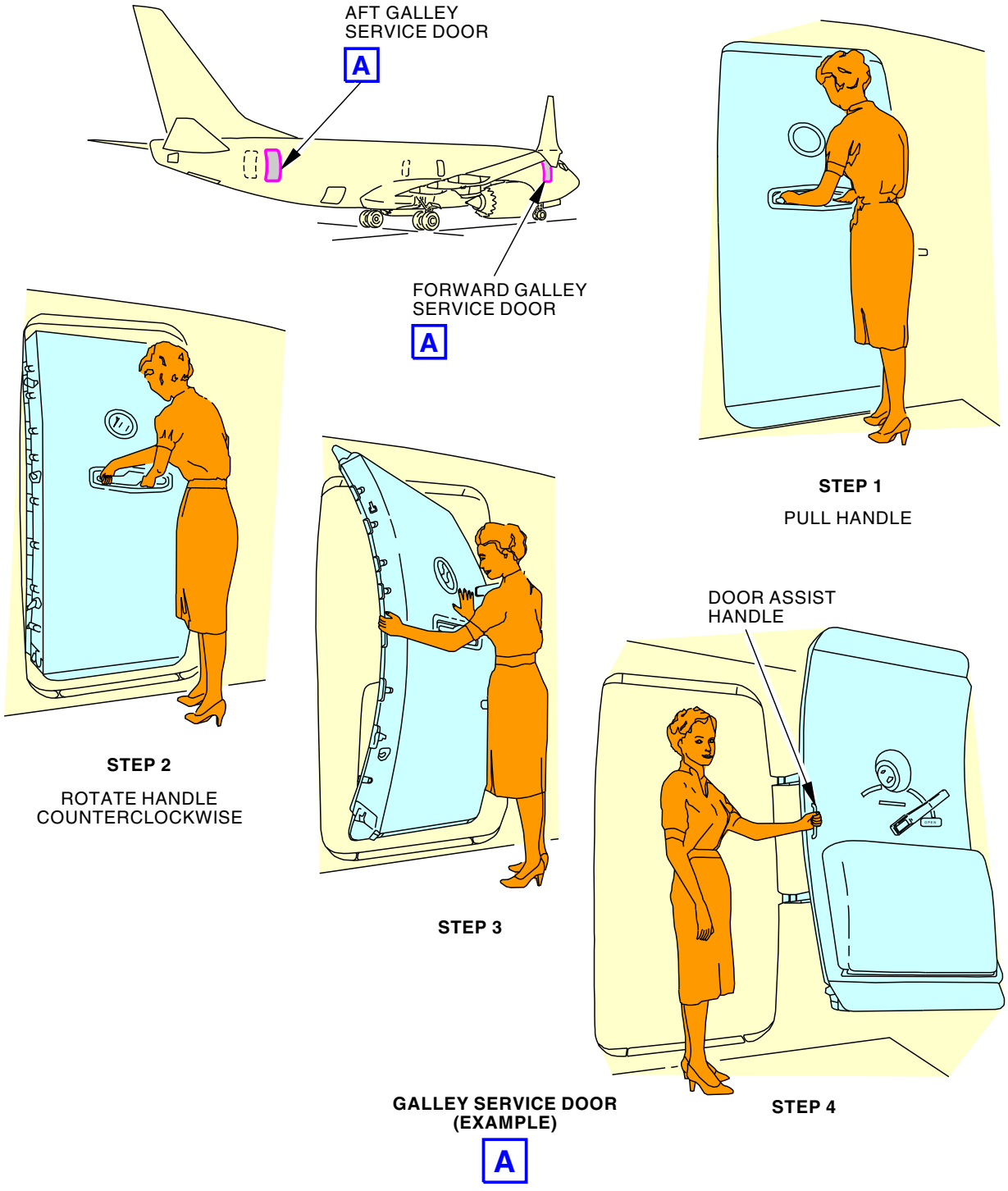
NOTE: When you turn the handle 180 degrees counterclockwise, the latch rollers engage with the latch fittings.

SUBTASK 52-41-00-080-002

(6) Remove the stand, work platform, COM-1523 from the door.

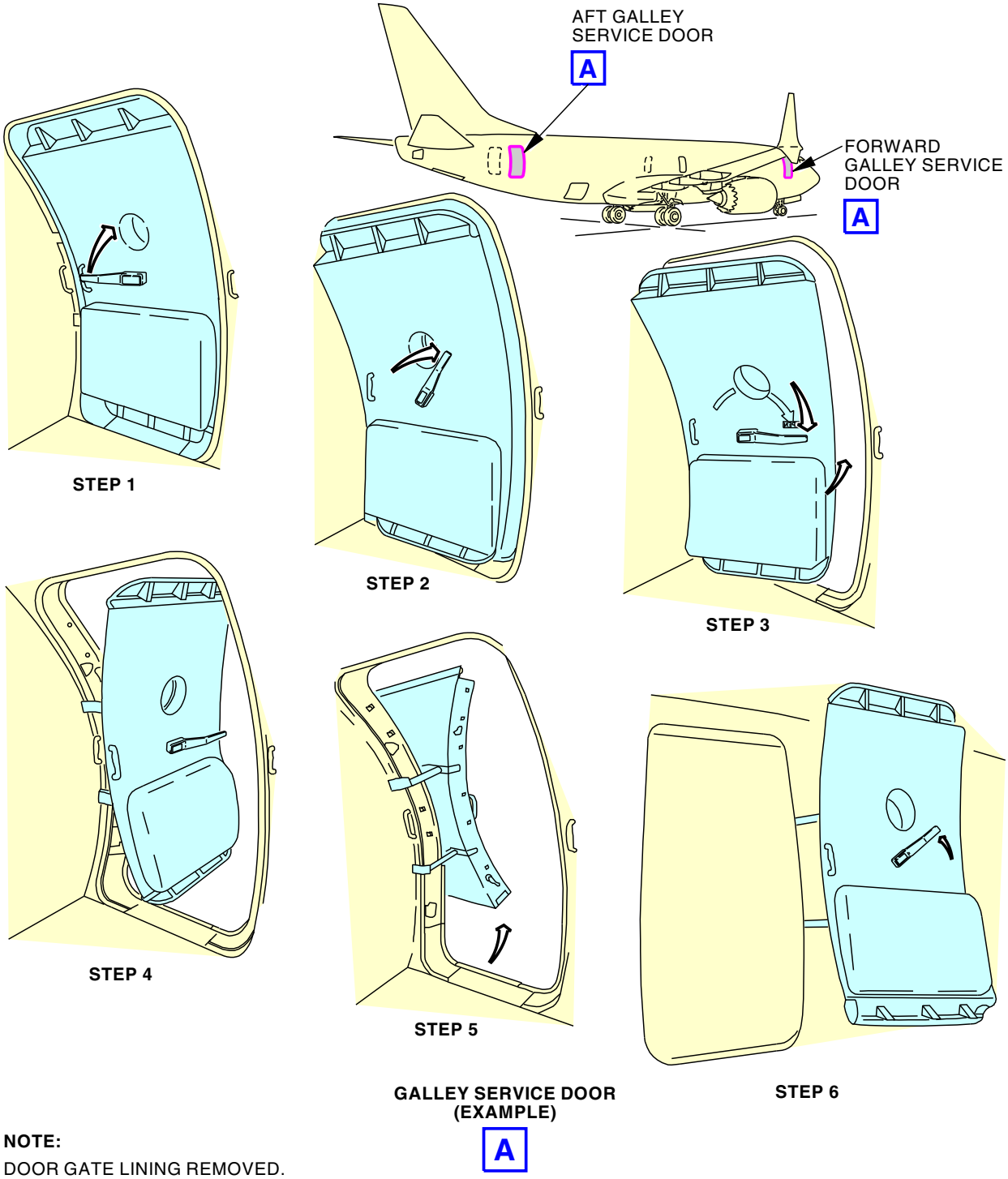
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Galley Service Door Operation from Outside Airplane
Figure 201/52-41-00-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details



NOTE:
DOOR GATE LINING REMOVED.

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Galley Service Door Operation from Inside Airplane
Figure 202/52-41-00-990-802

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-41-00-600-801

6. Galley Service Doors Corrosion Prevention

A. References

Reference	Title
12-25-13 P/B 301	GALLEY SERVICE DOORS - SERVICING
52-41-00-200-801	Galley Service Door Check (P/B 601)
52-41-31-000-801	Galley Service Door Lining Removal (P/B 401)
52-41-31-400-801	Galley Service Door Lining Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

C. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

D. General

SUBTASK 52-41-00-800-001

(1) Corrosion may occur on the internal and external surfaces of the door structure. especially the inside lower corners, the connection points, and the door mechanism.

(2) Corrosion has been found on the door torque tube, that is found adjacent to the door in the airplane body. The torque tube for the aft service door, in particular, has been found to contain large amounts of water.

(3) If a door is not opened often from the outside, corrosion has been found on the exterior door handle. The corrosion causes the handle to seize in the recess and prevents the handle from moving outward to unlock the door. Corrosion can also be found in the upper and lower bearings.

(a) If the door handle operates in a stiff or restricted manner, then increase the frequency of the lubrication.

(4) If applicable, stress corrosion cracks have been found on the aft upper stop fitting at the aft airstair door.

(5) Corrosion has been found on the rivets between the web and the intercostal at the aft galley door on some airplanes.

(6) Some items in this section maybe subject to the mandatory requirements for corrosion prevention and control programs for aging airplanes.

(7) Corrosion Prevention

(a) Do these tasks, Galley Service Door Check, TASK 52-41-00-200-801 to detect the early stages of corrosion.

(b) Look for missing fasteners, white powdery deposits, and discolorations, as signs of corrosion.

1) If signs of corrosion are found, then a corrosion prevention program should be started to prevent the build up of corrosion products.

2) If corrosion products are allowed to build up, then they will cause further corrosion.

3) If corrosion is found, the refer to the Structural Repair Manual for detail instructions for the removal of corrosion.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(c) After the corrosion products are cleaned, make sure that the protective finishes are serviceable.

1) If only minor corrosion is found, then make sure that the area is clean.

2) Apply corrosion inhibiting compound on the affected area.

3) Make sure that the protective finish is restored at the first opportunity that is consistent with the airplanes maintenance schedule.

(8) Frequency of Application

(a) Periodic inspection is required to areas identified as prone to corrosion and should be scheduled to your Maintenance Planning Document.

(b) Periodic application of BMS 3-23 compounds are necessary to areas identified as prone to corrosion and should be scheduled to your Maintenance Planning Document.

1) Do the prevention treatment to the door at the same recommended interval as the door frame.

2) Do the prevention treatment to the exterior surface of the door at the same recommended interval as the exterior surface of the fuselage.

E. Corrosion Prevention

SUBTASK 52-41-00-620-001

(1) Prevention Treatment

(a) Remove the door liner to get access to the interior surfaces of the door.

1) Galley Service Door Lining Removal, TASK 52-41-31-000-801

(b) Clean the drains and drain paths.

(c) Galley Service Door Check, TASK 52-41-00-200-801

1) Remove or repair any corrosion that you find.

(d) Apply corrosion inhibiting compound, G00009 to the interior surfaces of the door.

1) Make sure that the corrosion inhibiting compound, G00009 completely covers the surfaces, with special attention given to the lower corners and the handle mechanism housing.

(e) If it is necessary, apply corrosion inhibiting compound, G00009 to the exterior surfaces of the door.

(f) Lubricate the door. GALLEY SERVICE DOORS - SERVICING, PAGEBLOCK 12-25-13/301

(g) Install the door lining.

1) Galley Service Door Lining Installation, TASK 52-41-31-400-801

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

GALLEY SERVICE DOOR - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Galley service door removal

(2) Galley service door installation.

B. This procedure is the same for the forward or aft galley service door.

C. The galley service door is referred to as the door in this procedure.

TASK 52-41-00-000-801

2. Galley Service Door Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the galley service door.

B. References

Reference	Title
52-41-31-000-801	Galley Service Door Lining Removal (P/B 401)
52-41-51-000-801	Galley Service Door Snubber 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

D. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Access Panels

Number	Name/Location
841FZ	Forward Galley Service Door - Torque Tube Access
844FZ	Aft Galley Service Door - Torque Tube Access

F. Prepare for the Removal

SUBTASK 52-41-00-860-024

(1) Make sure that the galley service door [1] is safe as follows:

(a) Make sure that the galley service door [1] is closed and latched.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Install the work platform, COM-1523 outboard of the galley service door [1].

SUBTASK 52-41-00-010-001

(2) Get access to the galley service door [1] as follows:

(a) Make sure that the galley service door [1] is closed and latched.

(b) Do this task: Galley Service Door Lining Removal, TASK 52-41-31-000-801.

(c) Fully open the galley service door [1].

G. Galley Service Door Removal

SUBTASK 52-41-00-020-001

CAUTION REMOVE THE SNUBBER BEFORE YOU REMOVE THE DOOR. IF YOU DO NOT REMOVE THE SNUBBER BEFORE YOU REMOVE THE DOOR, DAMAGE TO THE SNUBBER CAN OCCUR.

(1) Do this task: Galley Service Door Snubber Removal, TASK 52-41-51-000-801.

SUBTASK 52-41-00-480-002

(2) Support the galley service door [1] as follows:

(a) Install straps around the stop fittings on the galley service door [1] to hold the weight of the door from a position above the door.

SUBTASK 52-41-00-020-002

(3) Disconnect the upper hinge of the galley service door [1]:

(a) Remove the applicable upper access panels:

Number	Name/Location
841FZ	Forward Galley Service Door - Torque Tube Access
844FZ	Aft Galley Service Door - Torque Tube Access

(b) Remove the filler [12] to get access to the fastener that attaches the guide arm [8] to the galley service door [1].

(c) Remove the bolt [9], washers [10], and nut [11] that attach the guide arm [8] to the galley service door [1].

NOTE: The guide arm [8] will stay with the fuselage.

(d) Remove the bolt [14], washers [15], and nut [16] that attach the upper hinge arm [13] to the fuselage.

NOTE: The upper hinge arm [13] will stay with the galley service door [1].

SUBTASK 52-41-00-020-003

(4) Disconnect the lower hinge of the galley service door [1]:

(a) Remove the bolt [17], washers [18], and nut [19] that attach the lower hinge arm [20] to the fuselage.

NOTE: The lower hinge arm [20] will stay with the galley service door [1].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-41-00-020-004

(5) Remove the galley service door [1] from the airplane as follows:

WARNING

BE CAREFUL WHEN YOU MOVE THE DOOR . THE DOOR IS HEAVY. INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

(a) Carefully move the galley service door [1] from the fuselage and remove from the airplane.

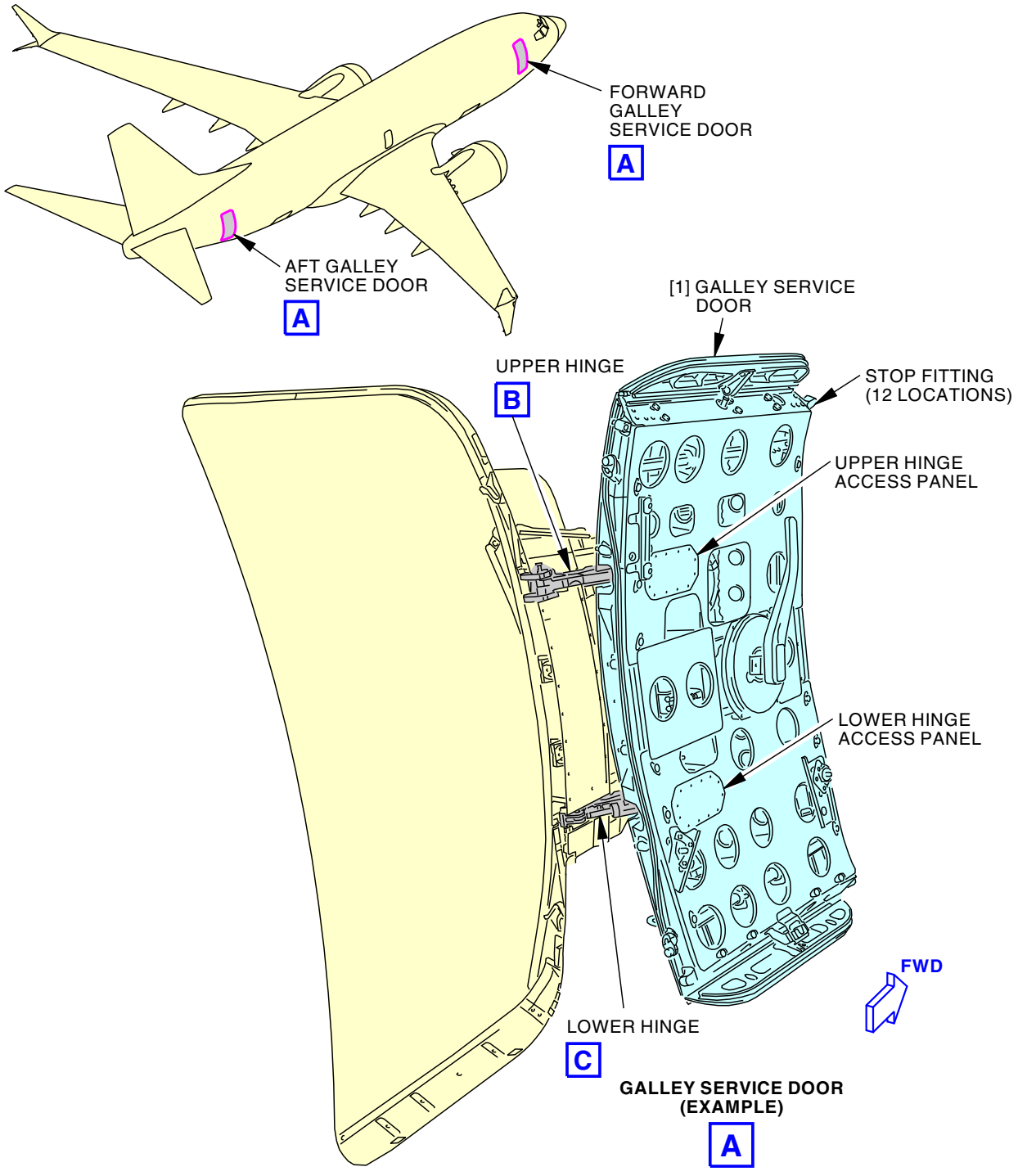
NOTE: The door weights approximately 140 lb (64 kg).

SUBTASK 52-41-00-860-025

(6) If it is necessary, put the personnel barrier, SPL-2005 across the door opening.

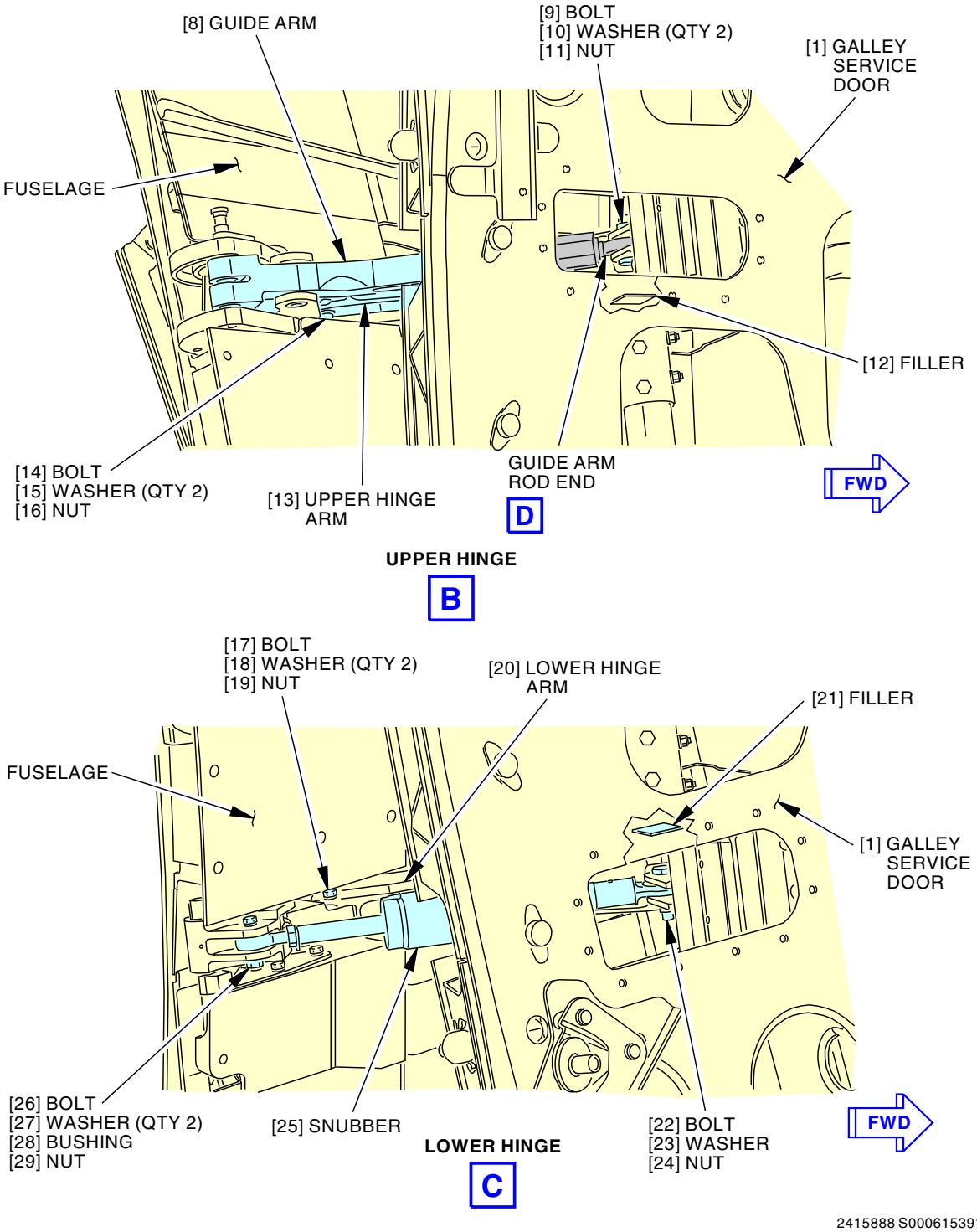
END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



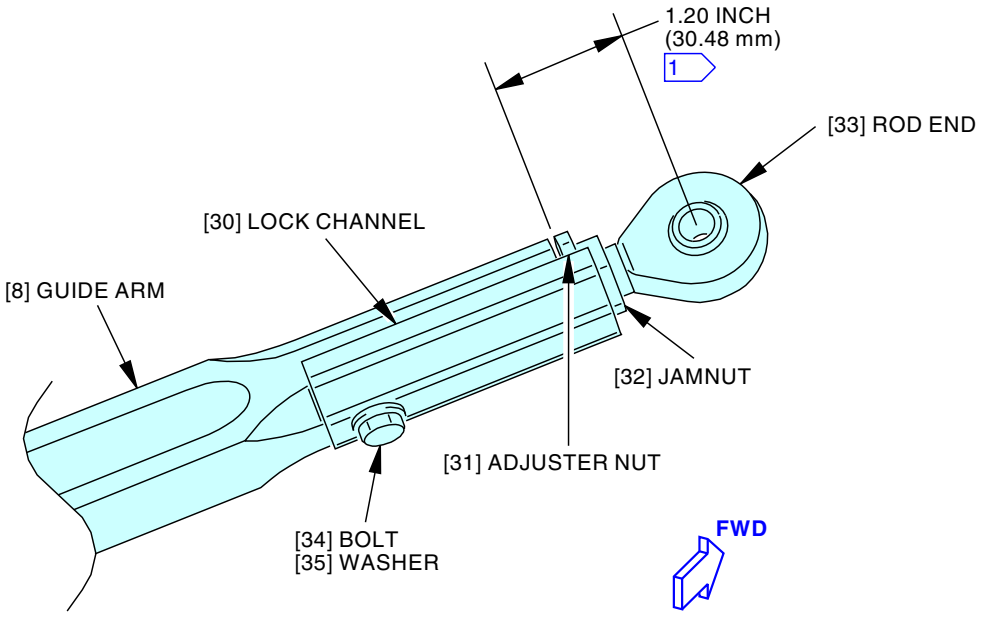
Galley Service Door Installation
Figure 401/52-41-00-990-818 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Galley Service Door Installation
Figure 401/52-41-00-990-818 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



GUIDE ARM ROD END ADJUSTMENT

D

1 INITIAL ADJUSTMENT

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Galley Service Door Installation
Figure 401/52-41-00-990-818 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-41-00-400-801

3. Galley Service Door Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the galley service door.

B. References

Reference	Title
52-41-00-200-803	Galley Service Door Pressure Seal Check (P/B 601)
52-41-00-700-801	Galley Service Door System Test (P/B 501)
52-41-00-820-801	Galley Service Door Adjustment (P/B 501)
52-41-31-400-801	Galley Service Door Lining Installation (P/B 401)
52-41-51-400-801	Galley Service Door Snubber 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-2005	Personnel Barrier - Passenger and Galley Door Part #: C52012-59 Supplier: 81205 Part #: C52012-66 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Galley service door	52-41-00-04B-121	SIA ALL
		52-41-00-08A-146	SIA ALL

F. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

G. Access Panels

Number	Name/Location
841FZ	Forward Galley Service Door - Torque Tube Access
844FZ	Aft Galley Service Door - Torque Tube Access

H. Galley Service Door Installation

SUBTASK 52-41-00-860-026

(1) If it is necessary, remove the personnel barrier, SPL-2005 across the door opening.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-41-00-420-001

WARNING

BE CAREFUL WHEN YOU MOVE THE DOOR . THE DOOR IS HEAVY. INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

(2) Carefully move the galley service door [1] near the fuselage and align the upper and lower hinges with the fuselage.

NOTE: The door weights approximately 140 lb (64 kg).

SUBTASK 52-41-00-700-001

(3) Inspect the pressure seal of the door prior to installation. Do this task: Galley Service Door Pressure Seal Check, TASK 52-41-00-200-803.

SUBTASK 52-41-00-420-002

(4) Connect the lower hinge of the galley service door [1]:

(a) Put the lower hinge arm [20] in its correct position.

(b) Install the bolt [17], washers [18], and nut [19] that attach the lower hinge arm [20] to the fuselage.

SUBTASK 52-41-00-020-005

(5) Connect the upper hinge of the galley service door [1]:

(a) Put the upper hinge arm [13] in its correct position.

(b) Install the bolt [14], washers [15], and nut [16] that attach the upper hinge arm [13] to the fuselage.

(c) Make sure that the distance from the centerline of the rod end [33] to the adjuster nut [31] is as specified.

(d) If it is out of tolerance, adjust the guide arm [8]:

NOTE: This is an initial adjustment for a new guide arm [8] or galley service door [1].

1) Remove the bolt [34] and washer [35] from the lock channel [30].

2) Remove the lock channel [30].

3) Loosen the jamnut [32].

4) Change the length of the guide arm rod end [33] with the adjuster nut [31] to get the correct position of the galley service door [1].

5) Make sure that the adjuster nut [31] will align with the lock channel [30].

6) Tighten the jamnut [32].

7) Put the lock channel [30] in its correct position on the guide arm [8].

8) Install the bolt [34] and washer [35] to hold the lock channel [30].

(e) Put the guide arm [8] in its correct position.

1) Make sure that the lubrication fitting on the rod end [33] points inboard.

(f) Install the bolt [9], washers [10], and nut [11] that attach the guide arm [8] to the galley service door [1].

(g) Make sure that the lock channel [30] is installed over the adjuster nut [31].

(h) Install the filler [12] with sealant, A00247 to cover the guide arm [8] attachment.

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(i) Install the applicable upper access panels:

Number	Name/Location
841FZ	Forward Galley Service Door - Torque Tube Access
844FZ	Aft Galley Service Door - Torque Tube Access

SUBTASK 52-41-00-020-006

(6) Do this task: Galley Service Door Snubber Installation, TASK 52-41-51-400-801.

I. Put the Airplane Back to Its Usual Condition

SUBTASK 52-41-00-410-001

(1) Do this task: Galley Service Door Lining Installation, TASK 52-41-31-400-801.

SUBTASK 52-41-00-820-001

(2) Do this task: Galley Service Door Adjustment, TASK 52-41-00-820-801.

SUBTASK 52-41-00-730-001

(3) Do this task: Galley Service Door System Test, TASK 52-41-00-700-801.

SUBTASK 52-41-00-080-003

(4) Remove the work platform, COM-1523 from the galley service door [1].

——— END OF TASK ———

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GALLEY SERVICE DOOR - ADJUSTMENT/TEST

1. General

A. This procedure has these tasks:

(1) An adjustment of the galley service door.

(2) An adjustment for "Soft unlatching".

(3) A system test of the galley service door.

B. This procedure is the same for the forward or aft galley service door.

TASK 52-41-00-820-801

2. Galley Service Door Adjustment

(Figure 501, Figure 502, Figure 503, Figure 504, Figure 505, Figure 506, Figure 507, Figure 508, Figure 509, Figure 510, Figure 511)

A. General

(1) Do the task with airplane at its Standard Basic Empty Weight (SBEW) and airplane supported on its landing gear.

(2) After the adjustment is completed, make sure that all adjustment points are locked and sealed.

B. References

Reference	Title
52-41-31-000-801	Galley Service Door Lining Removal (P/B 401)
52-41-31-400-801	Galley Service Door Lining Installation (P/B 401)
52-71-11-710-801	Entry and Galley Service Door Indication Sensor Test (S194, S195, S199, or S200) (P/B 201)
52-71-11-820-801	Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200) (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-1557	Gauge - Force Part #: DG-200 Supplier: 92456 Part #: FDIX 100 Supplier: 0BFD9 Part #: FDIX 50 Supplier: 0BFD9 Part #: LG-050 Supplier: 92456 Part #: LG-100 Supplier: 92456 Opt Part #: DPP-500G Supplier: 92456 Opt Part #: DPPH-150 Supplier: 92456 Opt Part #: DPPH-200 Supplier: 92456 Opt Part #: DPPH-50 Supplier: 92456 Opt Part #: FDI 100 Supplier: 0BFD9 Opt Part #: FDI 50 Supplier: 0BFD9 Opt Part #: FDV 100 Supplier: 0BFD9 Opt Part #: FDV 50 Supplier: 0BFD9
SPL-2003	Simulator - Escape Slide, Passenger Door Part #: C52006-74 Supplier: 81205

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D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
D00504	Grease - Petrolatum	VV-P-236
G02020	Clay, Modeling	

E. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

F. Access Panels

Number	Name/Location
841AZ	Forward Galley Service Door - Torque Tube Access
841FZ	Forward Galley Service Door - Torque Tube Access
844AZ	Aft Galley Service Door - Torque Tube Access
844FZ	Aft Galley Service Door - Torque Tube Access

G. Prepare for the Adjustment

SUBTASK 52-41-00-860-027

(1) If a new door was installed, do these steps:

(a) Make sure that the centering guide is not installed on the door.

(b) Make sure that the stop pins are retracted into the stop fittings or removed.

SUBTASK 52-41-00-860-028

(2) Make sure that the door is safe.

(a) Make sure that the door is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure that a stand is installed outboard of the door.

SUBTASK 52-41-00-010-002

(3) Get access to the door.

(a) Make sure that the door is closed and latched.

(b) Do this task: Galley Service Door Lining Removal, TASK 52-41-31-000-801.

(c) Install the escape slide simulator, SPL-2003, or equivalent weight of the escape slide and door lining that equals 77 lb (35 kg).

H. Hinge Flap Adjustment

SUBTASK 52-41-00-820-002

(1) Adjust the hinge flap.

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(a) Make sure that the door is closed and latched.

(b) Make sure that the skin clearance and flushness between the upper and lower hinge flaps, fuselage skin, and access panel are as shown in Table 501 and Figure 502.

Table 501/52-41-00-993-801 Aerosmoothness Limits - Hinge Covers at Forward Edge of Galley Service Door (Key to Figure 502)

ZONE	CLEARANCE		FLUSHNESS*[1]	
	NOMINAL	TOLERANCE	NOMINAL	TOLERANCE
A	0.09 in. (2.29 mm)	0.06 in. (1.52 mm) to 0.18 in. (4.57 mm)	0.00 in. (0.00 mm)	-0.03 in. (-0.76 mm) to 0.03 in. (0.76 mm)
B	0.09 in. (2.29 mm)	0.06 in. (1.52 mm) to 0.18 in. (4.57 mm)	0.00 in. (0.00 mm)	-0.03 in. (-0.76 mm) to 0.03 in. (0.76 mm)
C	0.09 in. (2.29 mm)	0.06 in. (1.52 mm) to 0.18 in. (4.57 mm)	0.00 in. (0.00 mm)	-0.06 in. (-1.52 mm) to 0.06 in. (1.52 mm)
D	0.09 in. (2.29 mm)	0.06 in. (1.52 mm) to 0.18 in. (4.57 mm)	0.00 in. (0.00 mm)	-0.03 in. (-0.76 mm) to 0.03 in. (0.76 mm)
E	0.09 in. (2.29 mm)	0.06 in. (1.52 mm) to 0.18 in. (4.57 mm)	0.00 in. (0.00 mm)	-0.03 in. (-0.76 mm) to 0.03 in. (0.76 mm)
F	0.09 in. (2.29 mm)	0.06 in. (1.52 mm) to 0.18 in. (4.57 mm)	0.00 in. (0.00 mm)	-0.03 in. (-0.76 mm) to 0.03 in. (0.76 mm)
G	0.09 in. (2.29 mm)	0.06 in. (1.52 mm) to 0.18 in. (4.57 mm)	0.00 in. (0.00 mm)	-0.06 in. (-1.52 mm) to 0.06 in. (1.52 mm)
H	0.09 in. (2.29 mm)	0.06 in. (1.52 mm) to 0.18 in. (4.57 mm)	0.00 in. (0.00 mm)	-0.03 in. (-0.76 mm) to 0.03 in. (0.76 mm)

*[1] Flushness from the forward edge to the aft edge of the hinge cover must be a smooth transition.

(c) Adjust the door skin clearance.

1) Open the door.

2) Remove the bolts and washers that attach the hinge flap to the fuselage structure.

3) Install a new laminated shim or remove laminations from the shim under the hinge on the hinge flap.

4) Apply primer, C00259, to the bare laminations of the laminated shim before installation.

5) Install the bolts and washers to attach the hinge flap to the fuselage structure.

(d) Adjust the door flushness.

1) Loosen the bolts that attach the hinge flap to the fuselage structure.

2) Move the hinge flap inboard or outboard in the slots for the bolts.

3) Tighten the bolts that attach the hinge flap to the fuselage structure.

I. Guide Arm Adjustment

SUBTASK 52-41-00-820-003

(1) Adjust the guide arm (Figure 503).

(a) Open the door.

(b) Move the door until it is parallel to the contour of the fuselage near the closed position.

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(c) If the door is not parallel to the contour of the fuselage at approximately 1.0 in. (25.4 mm) from the closed position, adjust the door.

1) Move the door to the fully open position.

2) Remove the applicable upper access panels:

Number	Name/Location
841FZ	Forward Galley Service Door - Torque Tube Access
844FZ	Aft Galley Service Door - Torque Tube Access

3) Get access to the guide arm door lock channel.

4) Remove the bolt and washer on the lock channel.

5) Remove the lock channel.

6) Loosen the jam nut.

7) Turn the adjuster nut to change the length of the guide arm rod end to get the correct position of the door.

NOTE: When the guide arm is made shorter, the door moves inboard. When the guide arm is made longer, it moves the door outboard.

8) Make sure that the adjuster nut aligns with the lock channel.

9) Tighten the jam nut.

10) Put the lock channel in the correct position on the guide arm.

11) Install the bolt and washer to secure the lock channel in position.

12) Install the applicable upper access panels:

Number	Name/Location
841FZ	Forward Galley Service Door - Torque Tube Access
844FZ	Aft Galley Service Door - Torque Tube Access

J. Door Vertical Adjustment

SUBTASK 52-41-00-820-005

CAUTION

MAKE SURE THAT YOU HAND-TIGHTEN THE ADJUSTER NUTS ON THE TORQUE TUBE. IF YOU TIGHTEN THE NUTS TOO MUCH, THEN IT CAN PUT HIGH END LOADS ON THE BEARINGS IN THE DOOR HANDLE MECHANISM. IF YOU DO NOT OBEY THE INSTRUCTIONS, DAMAGE TO EQUIPMENT CAN OCCUR.

(1) Adjust the door vertically.

(a) Close and latch the door.

(b) Make sure that the stop pins align with the stop pads (Figure 509).

NOTE: This is an alignment of the stop pads with the stop pins. Do not set the stop pin and pad clearance.

(c) If it is necessary, adjust the door vertically (Table 502 and Figure 504):

1) Open these access panels:

Number	Name/Location
841AZ	Forward Galley Service Door - Torque Tube Access
844AZ	Aft Galley Service Door - Torque Tube Access

2) Remove the cotter pins on the upper adjuster nut and lower adjuster nut.

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3) Loosen the upper adjuster nut and turn the lower adjuster nut to get the correct door vertical position.

4) Make sure that the lower adjuster nut is aligned with a cotter pin hole.

(d) Measure the skin clearance between the upper and lower gates and the fuselage skin along the top and bottom of the door at the locations as follows:

1) If it is necessary, make additional measurements.

2) Three locations evenly spaced along the horizontal edge of the upper and lower gates.

(e) Make sure that the clearances are as shown in Table 502 and Figure 504.

1) If it is necessary, adjust the door vertically to get the correct clearances.

(f) Make sure that the stop pins continue to align with the stop pads.

(g) Make sure that the door is bottomed out on the lower adjuster nut.

(h) Tighten the upper adjuster nut hand tight and turn back to align with the nearest cotter pin hole.

(i) Install the new cotter pins in the upper adjuster nut and lower adjuster nut.

K. Skin Clearance Adjustment

SUBTASK 52-41-00-820-006

(1) Adjust the door, do one of these methods:

(a) Method 1 is the Standard measurement method for skin clearance adjustment.

(b) Method 2 is the Aero-Averaging measurement for skin clearance adjustment.

SUBTASK 52-41-00-820-007

(2) Adjust the skin clearance with Method 1.

(a) Make sure that the clearances between the door skin and fuselage skin are as shown in Table 502 and Figure 504.

Table 502/52-41-00-993-802 Aerosmoothness Limits - Galley Service Door (Method 1) (Key to Figure 505)

ZONE	CLEARANCE		FLUSHNESS	
	NOMINAL	TOLERANCE	NOMINAL	TOLERANCE
A	0.12 in. (3.05 mm)	0.05 in. (1.27 mm) to 0.31 in. (7.87 mm)	--	NOT APPLICABLE
B (FORWARD DOOR)	0.19 in. (4.83 mm)	0.13 in. (3.30 mm) to 0.31 in. (7.87 mm)	-0.07 in. (-1.78 mm)	-0.09 in. (-2.29 mm) to -0.05 in. (-1.27 mm)
B (AFT DOOR)	0.19 in. (4.83 mm)	0.13 in. (3.30 mm) to 0.31 in. (7.87 mm)	0.00 in. (0.00 mm)	-0.09 in. (-2.29 mm) to 0.03 in. (0.76 mm)
SIA 014				
B (AFT DOOR)	0.19 in. (4.83 mm)	0.13 in. (3.30 mm) to 0.34 in. (8.64 mm)	0.00 in. (0.00 mm)	-0.09 in. (-2.29 mm) to 0.03 in. (0.76 mm)
SIA ALL				
C	0.12 in. (3.05 mm)	0.05 in. (1.27 mm) to 0.31 in. (7.87 mm)	--	NOT APPLICABLE

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Table 502/52-41-00-993-802 Aerosmoothness Limits - Galley Service Door (Method 1) (Key to Figure 505) (Continued)

ZONE	CLEARANCE		FLUSHNESS	
	NOMINAL	TOLERANCE	NOMINAL	TOLERANCE
D	0.12 in. (3.05 mm)	0.06 in. (1.52 mm) to 0.18 in. (4.57 mm)	-0.06 in. (-1.52 mm)	-0.12 in. (-3.05 mm) to -0.03 in. (-0.76 mm)
E	0.12 in. (3.05 mm)	0.05 in. (1.27 mm) to 0.22 in. (5.59 mm)	--	NOT APPLICABLE
F (FORWARD DOOR)	0.12 in. (3.05 mm)	0.06 in. (1.52 mm) to 0.21 in. (5.33 mm)	-0.25 in. (-6.35 mm)	-0.30 in. (-7.62 mm) to -0.20 in. (-5.08 mm)
F (AFT DOOR)	0.12 in. (3.05 mm)	0.06 in. (1.52 mm) to 0.21 in. (5.33 mm)	-0.20 in. (-5.08 mm)	-0.25 in. (-6.35 mm) to -0.15 in. (-3.81 mm)
SIA 014				
F (AFT DOOR)	0.12 in. (3.05 mm)	0.06 in. (1.52 mm) to 0.22 in. (5.59 mm)	-0.20 in. (-5.08 mm)	-0.25 in. (-6.35 mm) to -0.15 in. (-3.81 mm)
SIA ALL				
G	0.12 in. (3.05 mm)	0.05 in. (1.27 mm) to 0.22 in. (5.59 mm)	--	NOT APPLICABLE
H	0.12 in. (3.05 mm)	0.06 in. (1.52 mm) to 0.18 in. (4.57 mm)	-0.06 in. (-1.52 mm)	-0.12 in. (-3.05 mm) to 0.06 in. (1.52 mm)

(b) If it is necessary, adjust as follows:

1) Open the door.

2) Trim the edge of the door to get the correct skin clearances.

(c) Make sure that the minimum distance from the edge of the door outer skin to the door frame is as shown in Table 502 and Figure 504.

SUBTASK 52-41-00-820-008

(3) Adjust the skin clearance with Method 2 (Aero-Averaging).

(a) Make sure that the clearances between the door skin and fuselage skin are as shown in Table 503.

Table 503/52-41-00-993-803 Aero-Averaging Limits - Galley Service Door (Method 2)

ZONE	CLEARANCE		FLUSHNESS	
	NOMINAL	TOLERANCE	NOMINAL	TOLERANCE
A	0.12 in. (3.05 mm)	0.05 in. (1.27 mm) to 0.31 in. (7.87 mm)	--	NOT APPLICABLE
B (FORWARD DOOR)	0.19 in. (4.83 mm)	0.13 in. (3.30 mm) to 0.31 in. (7.87 mm)	-0.07 in. (-1.78 mm)	-0.12 in. (-3.05 mm) to -0.02 in. (-0.51 mm)
B (AFT DOOR)	0.19 in. (4.83 mm)	0.13 in. (3.30 mm) to 0.31 in. (7.87 mm)	0.00 in. (0.00 mm)	-0.12 in. (-3.05 mm) to 0.06 in. (1.52 mm)
SIA 014				
B (AFT DOOR)	0.19 in. (4.83 mm)	0.13 in. (3.30 mm) to 0.34 in. (8.64 mm)	0.00 in. (0.00 mm)	-0.12 in. (-3.05 mm) to 0.06 in. (1.52 mm)

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SIA 014 (Continued)

Table 503/52-41-00-993-803 Aero-Averaging Limits - Galley Service Door (Method 2) (Continued)

ZONE	CLEARANCE		FLUSHNESS	
	NOMINAL	TOLERANCE	NOMINAL	TOLERANCE
SIA ALL				
C	0.12 in. (3.05 mm)	0.05 in. (1.27 mm) to 0.31 in. (7.87 mm)	--	NOT APPLICABLE
D	0.12 in. (3.05 mm)	0.06 in. (1.52 mm) to 0.21 in. (5.33 mm)	-0.06 in. (-1.52 mm)	-0.15 in. (-3.81 mm) to 0.00 in. (0.00 mm)
E	0.12 in. (3.05 mm)	0.05 in. (1.27 mm) to 0.22 in. (5.59 mm)	--	NOT APPLICABLE
F (FORWARD DOOR)	0.12 in. (3.05 mm)	0.06 in. (1.52 mm) to 0.21 in. (5.33 mm)	-0.25 in. (-6.35 mm)	-0.33 in. (-8.38 mm) to -0.17 in. (-4.32 mm)
F (AFT DOOR)	0.12 in. (3.05 mm)	0.06 in. (1.52 mm) to 0.21 in. (5.33 mm)	-0.20 in. (-5.08 mm)	-0.28 in. (-7.11 mm) to -0.12 in. (-3.05 mm)
SIA 014				
F (AFT DOOR)	0.12 in. (3.05 mm)	0.06 in. (1.52 mm) to 0.22 in. (5.59 mm)	-0.20 in. (-5.08 mm)	-0.28 in. (-7.11 mm) to -0.12 in. (-3.05 mm)
SIA ALL				
G	0.12 in. (3.05 mm)	0.05 in. (1.27 mm) to 0.22 in. (5.59 mm)	--	NOT APPLICABLE
H	0.12 in. (3.05 mm)	0.06 in. (1.52 mm) to 0.21 in. (5.33 mm)	-0.06 in. (-1.52 mm)	-0.15 in. (-3.81 mm) to 0.06 in. (1.52 mm)

SUBTASK 52-41-00-820-009

(4) Adjust the skin clearance with Method 2 (Aero-Averaging).

(a) Make sure that the clearances between the door skin and fuselage skin are as shown in Table 504 and Figure 504.

(b) If it is necessary, adjust as follows:

1) Open the door.

2) Trim the edge of the door to get the correct skin clearances.

(c) Make sure that the minimum distance from the edge of the door outer skin to the door frame is as shown in Table 504 and Figure 504.

(d) Measure the clearance between the door skin and fuselage skin along the forward and aft edges of the door at the locations as follows:

1) Less than 1 in. (25 mm) from the centre of each stop fitting along the forward and aft edges of the door.

2) Record the skin clearance for each stop fitting.

3) Change the clearance to a drag value (Table 504).

NOTE: A measurement of 0.10 in. (2.54 mm) clearance is a drag value of 0.63.

4) Record the drag value for each measurement (Table 504).

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Table 504/52-41-00-993-804 Galley Service Door Skin Clearance (Aero-Averaging)

CLEARANCE	DRAG VALUE
0.06 in. (1.52 mm)	0.38
0.07 in. (1.78 mm)	0.44
0.08 in. (2.03 mm)	0.50
0.09 in. (2.29 mm)	0.56
0.10 in. (2.54 mm)	0.63
0.11 in. (2.79 mm)	0.69
0.12 in. (3.05 mm)	0.75
0.13 in. (3.30 mm)	0.81
0.14 in. (3.56 mm)	0.88
0.15 in. (3.81 mm)	0.94
0.16 in. (4.06 mm)	1.00
0.17 in. (4.32 mm)	1.06
0.18 in. (4.57 mm)	1.12
0.19 in. (4.83 mm)	1.19
0.20 in. (5.08 mm)	1.25
0.21 in. (5.33 mm)	1.31

5) Add all the drag values together (sum).
   a) Record the sum of the drag values as measurement A.
6) Divide measurement A by the number of made measurements.

   NOTE: If the measurement was made at each of the stop fittings, then divide measurement A (sum of the drag values) by 18 (the number of door stop fittings).
7) Make sure that the average drag value is 1.00 or less.

L. Skin Flushness Adjustment

SUBTASK 52-41-00-820-010

(1) Adjust the door, do one of these methods:
   (a) Method 1 is the Standard measurement method for skin flushness adjustment.
   (b) Method 2 is the Aero-Averaging measurement for skin flushness adjustment.

SUBTASK 52-41-00-820-011

(2) Adjust the skin flushness with Method 1.
   (a) Make sure that the flushness between the door skin and fuselage skin along the forward and aft edges of the door are as shown in Table 502 and Figure 504.
   (b) As a minimum, measure the flushness between the door skin and fuselage skin along the forward and aft edges of the door at the locations as follows:
      1) Less than 1 in. (25 mm) from the centre of each stop fitting along the forward and aft edges of the door.

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a) If it is necessary, make additional measurements.

NOTE: Do not make measurements that are within 8.0 in. (203.2 mm) of the body skin lap joint.

2) Three locations evenly spaced along the horizontal edge of the upper and lower gates.

(c) If it is necessary, adjust as follows:

1) Open the door.

2) Loosen the bolts and washers that attach the forward and aft, upper and lower latch receivers to the fuselage frame.

3) Move the latch receivers inboard or outboard on their serrated plates to get the correct door flushness (Figure 506).

4) Tighten the bolts and washers to attach the latch receivers to the fuselage frame.

SUBTASK 52-41-00-820-012

(3) Adjust the skin flushness with Method 2 (Aero-Averaging).

(a) Make sure that the flushness between the door skin and fuselage skin along the forward and aft edges of the door are within tolerance (Table 505 and Figure 504).

(b) As a minimum, measure the flushness between the door skin and fuselage skin along the forward and aft edges of the door at the locations as follows:

1) Less than 1 in. (25 mm) from the centre of each stop fitting along the forward and aft edges of the door.

a) If it is necessary, make additional measurements.

NOTE: Do not make measurements that are within 8.0 in. (203.2 mm) of the body skin lap joint.

2) Three locations evenly spaced along the horizontal edge of the upper and lower gates.

3) Record the skin flushness for each stop fitting.

4) Change the flushness to a drag value (Table 505).

NOTE: A measurement of -0.10 in. (-2.54 mm) flushness at the door fwd edge is a drag value of 0.56.

5) Record the drag value for each measurement (Table 505).

Table 505/52-41-00-993-805 Galley Service Door Skin Flushness (Aero-Averaging)

DOOR FLUSHNESS		DRAG VALUE
FWD EDGE	AFT EDGE	
	0.06 in. (1.52 mm)	2.10
	0.05 in. (1.27 mm)	1.89
	0.04 in. (1.02 mm)	1.69
-0.15 in. (-3.81 mm)	0.03 in. (0.76 mm)	1.49
-0.14 in. (-3.56 mm)	0.02 in. (0.51 mm)	1.29
-0.13 in. (-3.30 mm)	0.01 in. (0.25 mm)	1.10
-0.12 in. (-3.05 mm)	0.00 in. (0.00 mm)	0.91

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Table 505/52-41-00-993-805 Galley Service Door Skin Flushness (Aero-Averaging) (Continued)

DOOR FLUSHNESS		DRAG VALUE
FWD EDGE	AFT EDGE	
-0.11 in. (-2.79 mm)	-0.01 in. (-0.25 mm)	0.73
-0.10 in. (-2.54 mm)	-0.02 in. (-0.51 mm)	0.56
-0.09 in. (-2.29 mm)	-0.03 in. (-0.76 mm)	0.39
-0.08 in. (-2.03 mm)	-0.04 in. (-1.02 mm)	0.23
-0.07 in. (-1.78 mm)	-0.05 in. (-1.27 mm)	0.09
-0.06 in. (-1.52 mm)	-0.06 in. (-1.52 mm)	0
-0.05 in. (-1.27 mm)	-0.07 in. (-1.78 mm)	0.11
-0.04 in. (-1.02 mm)	-0.08 in. (-2.03 mm)	0.38
-0.03 in. (-0.76 mm)	-0.09 in. (-2.29 mm)	0.70
-0.02 in. (-0.51 mm)	-0.10 in. (-2.54 mm)	1.06
-0.01 in. (-0.25 mm)	-0.11 in. (-2.79 mm)	1.44
0.00 in. (0.00 mm)	-0.12 in. (-3.05 mm)	1.85
	-0.13 in. (-3.30 mm)	2.23
	-0.14 in. (-3.56 mm)	2.67
	-0.15 in. (-3.81 mm)	3.12

6) Add all the drag values together (sum).
   a) Record the sum of the drag values as measurement A.
7) Divide measurement A by the number of made measurements.

   NOTE: If the measurement was made at each of the stop fitting, then divide measurement A (sum of the drag values) by 18 (the number of door stop fittings).

   a) Make sure that the average drag value is 1.00 or less.

(c) If the average drag value is greater than 1.00, adjust the door.
1) Open the door.
2) Loosen the bolts and bolt with washers that attach the forward and aft, upper and lower latch receivers to the fuselage frame.
3) Move the latch receivers inboard or outboard on their serrated plates to get the correct door flushness (Figure 506).
4) Adjust the door to get the correct skin flushness.

M. Latch Adjustment

SUBTASK 52-41-00-820-013

(1) Do the latch adjustment (Figure 506).
(a) If use clay to measure the latch roller clearances, do these steps:
1) Put clay, G02020, in the latch fitting.
2) Put a layer of grease, D00504, on the latch roller.
3) Close and latch the door.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

4) Open the door.

5) Make sure that the clearance between the bottom of the latch roller and latch fitting is as shown in View B-B, Figure 506.

6) Remove unwanted material from the surfaces of latch roller and latch fitting.

(b) Make sure that the clearance between the forward and aft, upper and lower latch rollers and latch receivers is as shown in Figure 506.

(c) If it is necessary, adjust as follows:

1) Open the door.

2) Loosen the bolts and bolts with washers that attach the latch receivers to the fuselage frame.

3) Move the latch receivers up or down on their serrated plates to get the correct clearance between the latch roller and latch receiver.

NOTE: Turn the stop pins inboard as necessary.

4) Tighten the bolts and bolts with washers to attach the latch receivers to the fuselage frame.

(d) Close and latch the door.

(e) Make sure that the distance the forward and aft, upper and lower latch rollers engage in the latch receivers is as shown in Figure 506.

(f) If it is necessary, adjust as follows:

1) Open the door.

2) Remove the bolts, washers and nuts that attach the forward and aft latch cranks to the latch torque tube.

3) Move the adjustment shims from one end of the latch torque tube to the other end to increase or decrease the clearance between the latch crank and latch receiver.

4) Install the bolts, washers and nuts to attach the latch cranks to the latch torque tube.

5) If more adjustment is necessary, do these steps:

a) Remove the bolt, latch roller adjustment washers, and nut that attach the latch roller to the latch crank.

b) Move the latch roller adjustment washers from the roller side to the nut side.

c) Install the bolt, latch roller adjustment washers, and nut to attach the latch roller to the latch crank.

d) Make sure that the latch roller bearing shank is clear of the door frame by 0.02 in. (0.51 mm) minimum after the adjustment.

(g) Make sure that the door is open.

(h) Try to move the latch torque tube forward and aft to do a check for latch roller and latch torque tube end play.

(i) Make sure that the latch roller and latch torque tube end play is 0.02 in. (0.51 mm) maximum.

1) If it is necessary, adjust as follows:

a) Open the door.

b) Add or remove the horseshoe washers from one of the ends of the latch torque tube to decrease the end play.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

c) After you have decreased the end play, do these steps:

<1> Turn the horseshoe washers ends until their positions are random.

<2> Apply sealant, A00247, in the spaces between the ends of the horseshoe washers.

<3> Make sure that sealant, A00247, does not prevent the latch torque tube support bearing from turning freely.

<4> Do this task: Entry and Galley Service Door Indication Sensor Test (S194, S195, S199, or S200), TASK 52-71-11-710-801.

N. Horizontal Control Rod Adjustment

SUBTASK 52-41-00-820-014

(1) Adjust the horizontal control rod (Figure 507).

(a) Unlatch and latch the door.

(b) Make sure that the forward and aft, upper and lower latch rollers move into their latch receivers before the latch torque tubes start to turn.

(c) If it is necessary, adjust the horizontal control rod as follows:

1) Open the door.

2) Remove the bolt, washer, and nut that attach the horizontal control rod end to the door hinge torque tube.

3) Loosen the checknut.

4) Turn the rod end to change the length of the horizontal control rod to get the correct latch sequence or exterior handle forces.

NOTE: If you shorten the horizontal control rod, it will move the door outboard and increase the handle retraction force.

5) After the first adjustment, shorten the horizontal control rod an additional 1/2 to 1-1/2 turns if it is necessary to move the door outboard and make sufficient latch roller clearance.

6) Install the bolt, washer, and nut to attach the horizontal control rod end to the door hinge torque tube.

7) Tighten the checknut when the horizontal control rod adjustments are done.

(d) Close and latch the door.

(e) Pull the exterior handle to its extended position.

(f) Use a force gauge, COM-1557, to measure the force to move the exterior handle back to its retracted position.

(g) Make sure that the force to move the handle to its retracted position is not more than 20 lb (9 kg).

(h) If it is necessary, adjust the horizontal control rod again.

(i) Do this adjustment to make sure that the latch roller will clear the lip of the latch receiver:

NOTE: Use the 9 lb (4 kg) to 11 lb (5 kg) load to simulate the seal drag of the door liner.

1) Apply a 9 lb (4 kg) to 11 lb (5 kg) spring load or equivalent to the door in an inboard direction at the corner stop fitting next to the latch roller.

2) Unlatch and latch the door.

3) Look at each latch roller as it goes into its latch receiver.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

4) Make sure that the latch rollers are clear of the entry lip on the latch receiver when you move the exterior handle to the latched position.

(j) If it is necessary, adjust the horizontal control rod again.

(k) Install the applicable access panels:

Number	Name/Location
841AZ	Forward Galley Service Door - Torque Tube Access
844AZ	Aft Galley Service Door - Torque Tube Access

O. Gate Adjustment

SUBTASK 52-41-00-820-015

(1) Do the gate adjustment.

(a) Close and latch the door.

(b) Make sure that the door flushness between the upper and lower gates and the fuselage skin is as shown in Figure 508.

(c) If it is necessary, adjust as follows:

1) Open the door.

2) Remove the bolt, washers, and nut that attach the gate control rod to the gate.

3) Loosen the checknut.

4) Turn the rod end to change the length of the gate control rod to get the correct flushness.

NOTE: The lubrication fitting must point inboard after the adjustment.

5) Install the bolt, washers, and nut to attach the gate control rod to the gate.

6) Tighten the checknut.

P. Stop Pin Adjustment

SUBTASK 52-41-00-820-016

(1) Adjust the stop pin (Figure 509).

(a) If use clay to measure the pin-to-pad clearance of inaccessible stop pins, do these steps:

1) Put clay, G02020, on the stop pad.

2) Put a layer of grease, D00504, on the stop pin.

3) Close and latch the door.

4) Open the door.

5) Make sure that the clearance between the stop pin and stop pad is as shown in View A-A, Figure 509.

6) Remove unwanted material from the surfaces of all stop pins and stop pads.

(b) If it is necessary, adjust the stop pins.

1) Turn the stop pin fully outboard until it just touches the stop pad.

2) Turn the stop pin back 1/2 turn and then to the nearest lock groove for the lock spring.

3) Install the lock spring.

(c) Make sure that the stop pins align with the stop pads on the forward and aft edges of the door as shown in View B-B, Figure 509.

(d) Put sealant, A00247, or sealant, A02315, on the door stop pins

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Q. Centering Guide Adjustment

SUBTASK 52-41-00-820-017

(1) Adjust the centering guide (Figure 510).

(a) Open and close the door.

(b) As the door closes, make sure that the centering guide goes into the track and is clear of the track as the door closes.

(c) Make sure that the clearance between the centering guide roller and track is as shown in Figure 510.

(d) Make sure that the centering guide body track thickness is not less then 0.070 in. (1.778 mm).

(e) Adjust the centering guide.

1) Loosen the bolt and washer that attach the centering guide to the door frame.

2) Move the centering guide on the serrated plate to get the correct clearance.

NOTE: The centering guide has slots for the bolts to permit adjustment.

3) Tighten the bolt and washer.

R. Hinge Arm Cover Adjustment

SUBTASK 52-41-00-820-018

(1) Adjust the hinge arm cover (Figure 502).

(a) Make sure that the door is closed and latched.

(b) Make sure that the skin clearance and flushness between the upper and lower hinge arm covers and door skin are as shown in View A, Figure 502.

1) Trim the hinge arm cover to get the correct clearance.

2) Adjust the door flushness.

a) Remove the screws that attach the hinge arm cover to the hinge arm.

b) Remove or add new shims between the hinge arm cover and hinge arm to get the correct clearance.

c) Install the screws to attach the hinge arm cover to the hinge arm.

SUBTASK 52-41-00-820-019

(2) Adjust the galley service door warning system (TASK 52-71-11-820-801).

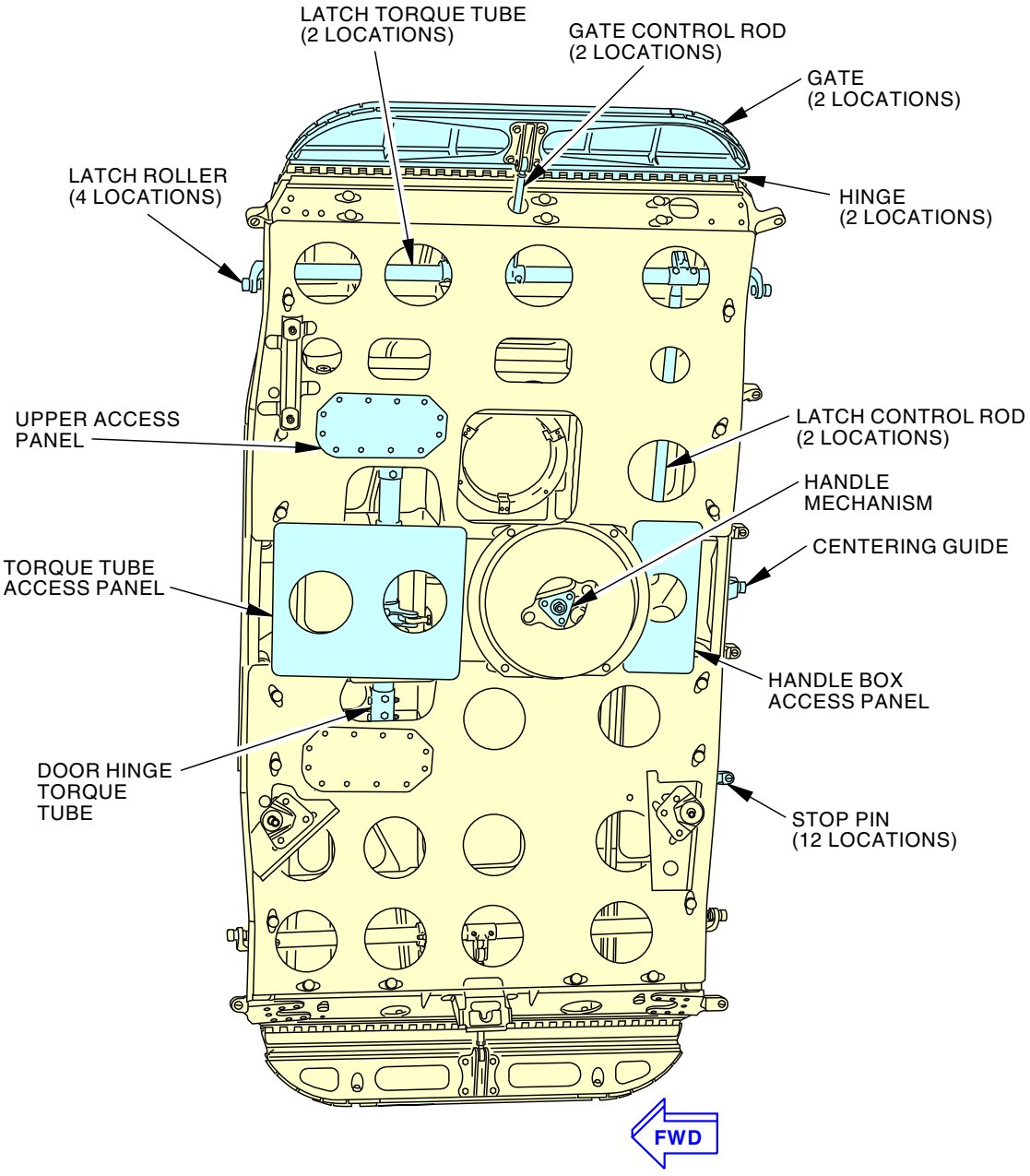
S. Put the Airplane Back to Its Usual Condition

SUBTASK 52-41-00-410-002

(1) Do this task: Galley Service Door Lining Installation, TASK 52-41-31-400-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

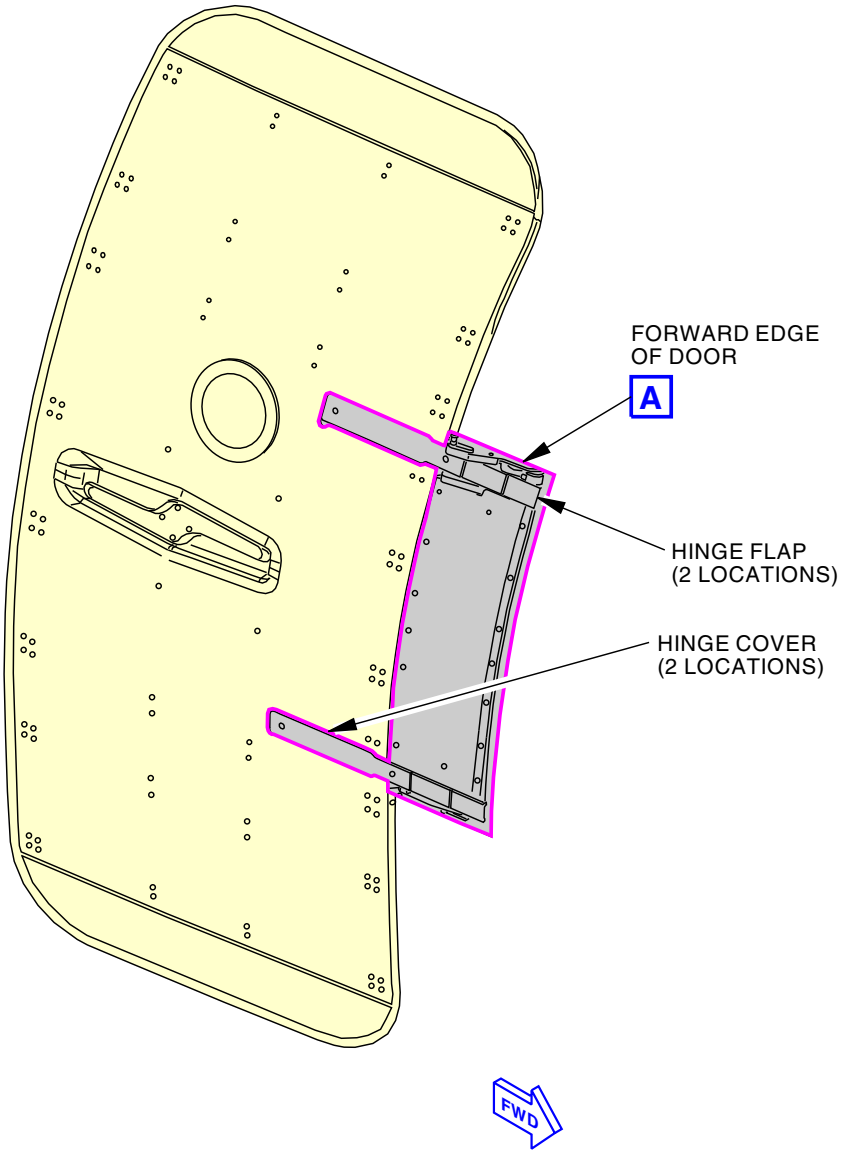


GALLEY SERVICE DOOR
(EXAMPLE)

2415890 S00061539119_V1

Galley Service Door Adjustment
Figure 501/52-41-00-990-819

ECCN 9E991 BOEING PROPRIETARY - See title page for details

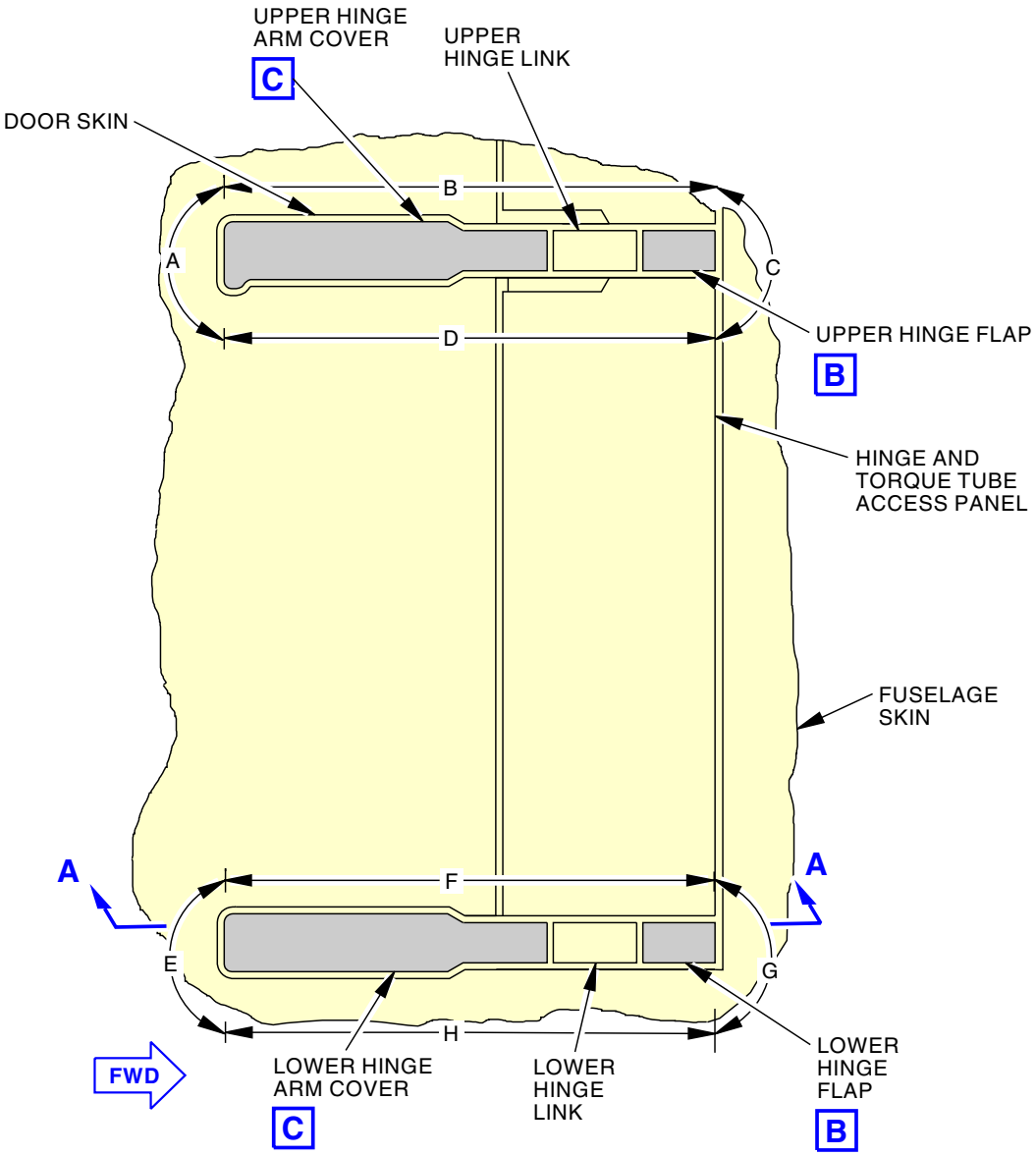


**GALLEY SERVICE DOOR
(EXAMPLE)**

2415891 S00061539120_V1

**Hinge Flap and Hinge Arm Cover Adjustment
Figure 502/52-41-00-990-820 (Sheet 1 of 3)**

ECCN 9E991 BOEING PROPRIETARY - See title page for details



FORWARD EDGE OF THE GALLEY SERVICE DOOR (EXAMPLE)

A

NOTE:

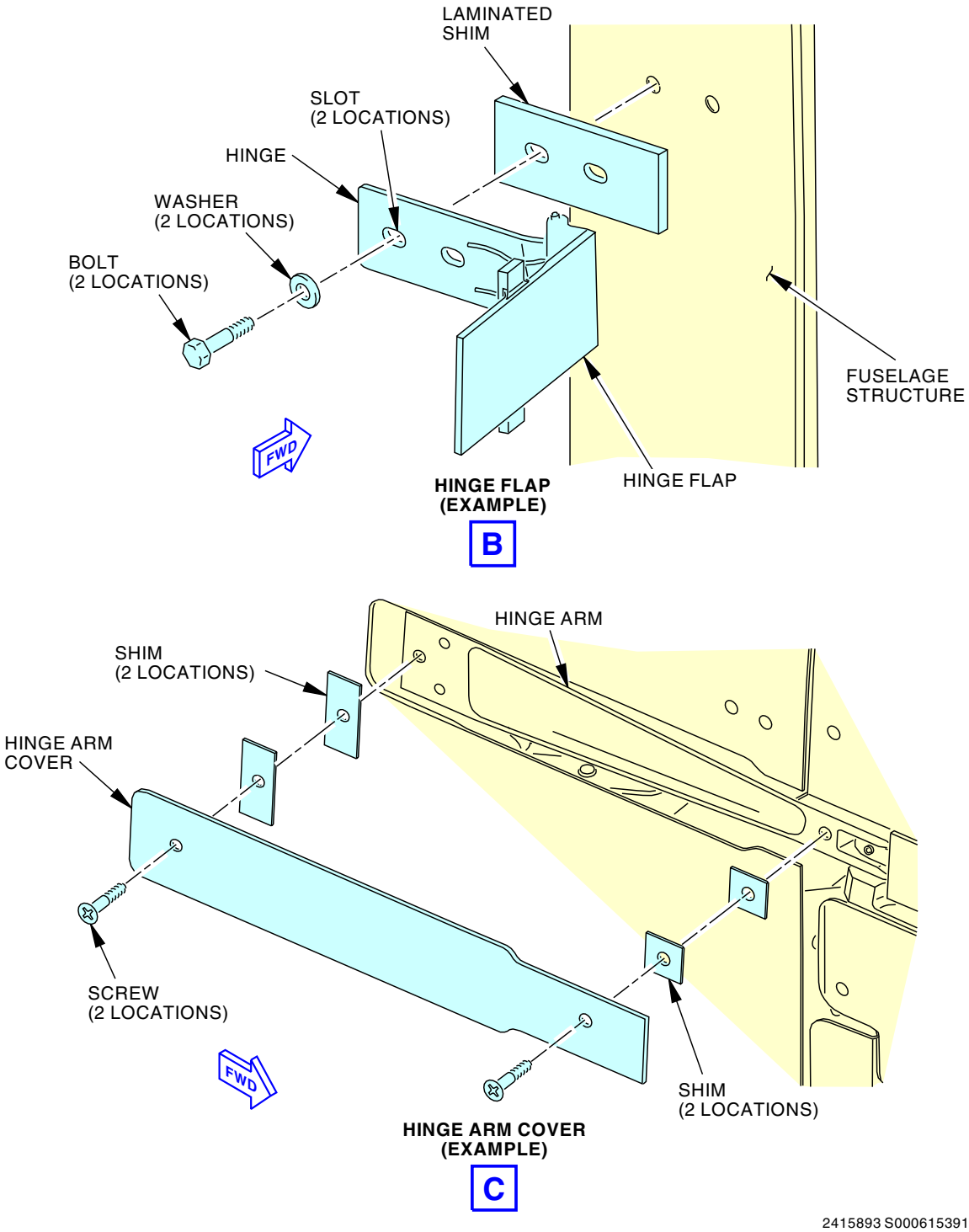
DIMENSION STANDARD: NOMINAL UPPER LIMIT LOWER LIMIT

FLUSHNESS AT UPPER AND LOWER EDGES IS A TRANSITION FROM THE FORWARD TO THE AFT EDGE.

2415892 S00061539121_V1

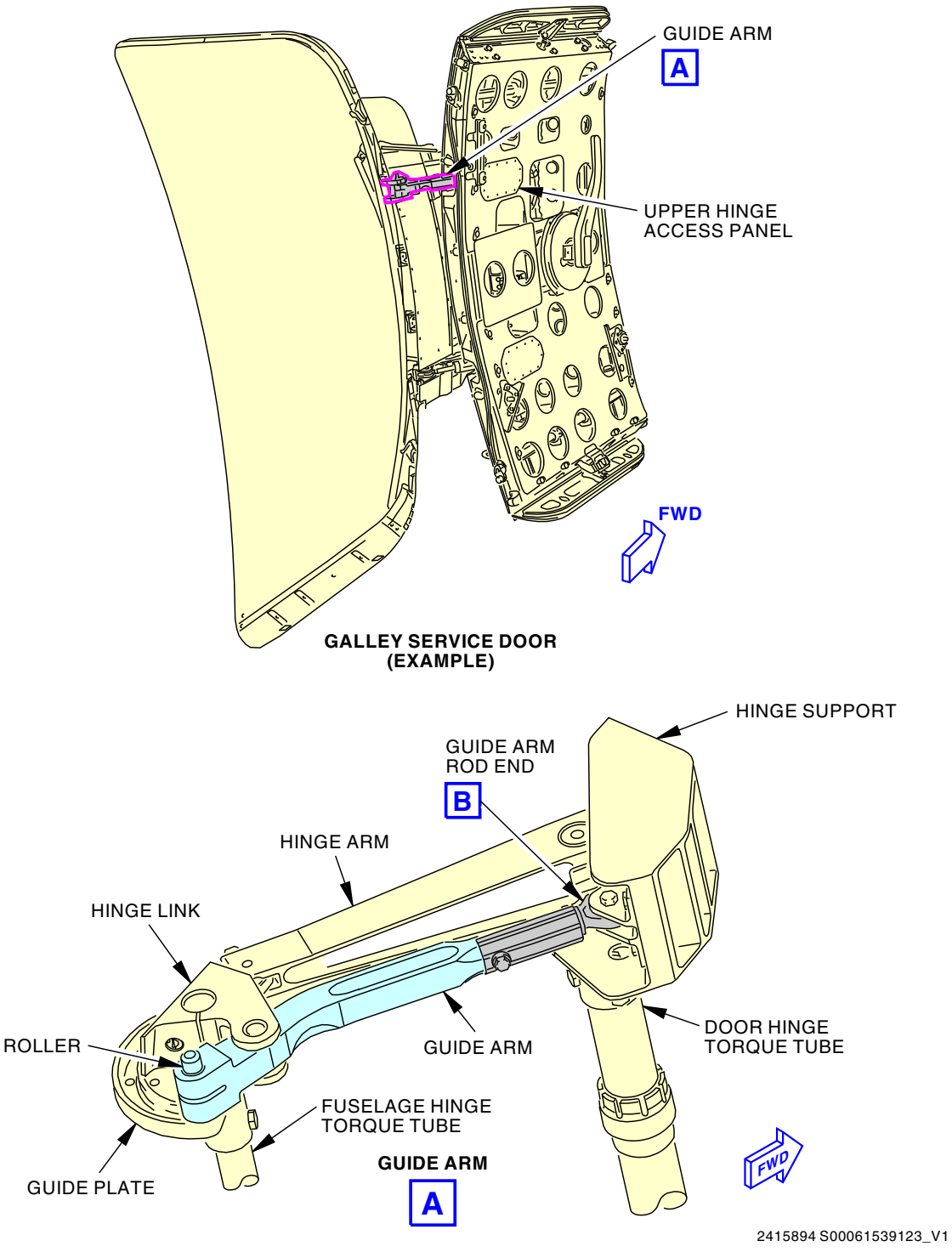
Hinge Flap and Hinge Arm Cover Adjustment
Figure 502/52-41-00-990-820 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



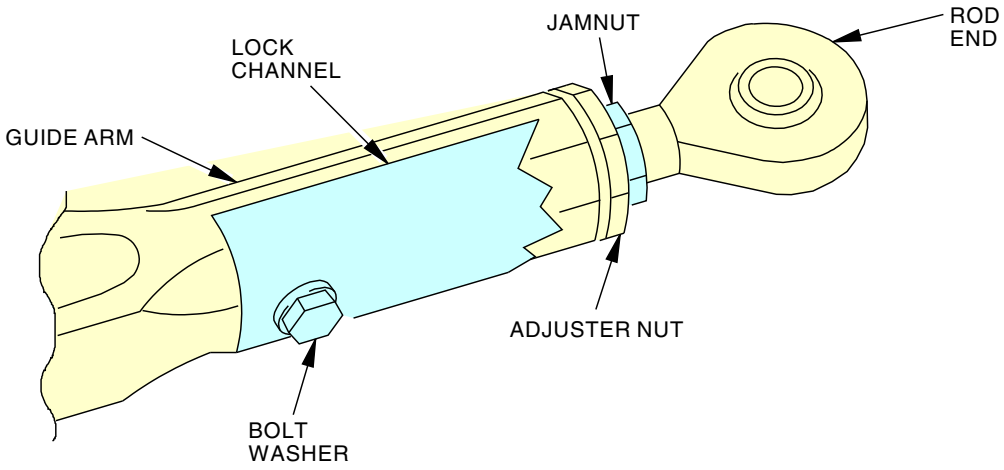
Hinge Flap and Hinge Arm Cover Adjustment
Figure 502/52-41-00-990-820 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Guide Arm Adjustment
Figure 503/52-41-00-990-821 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



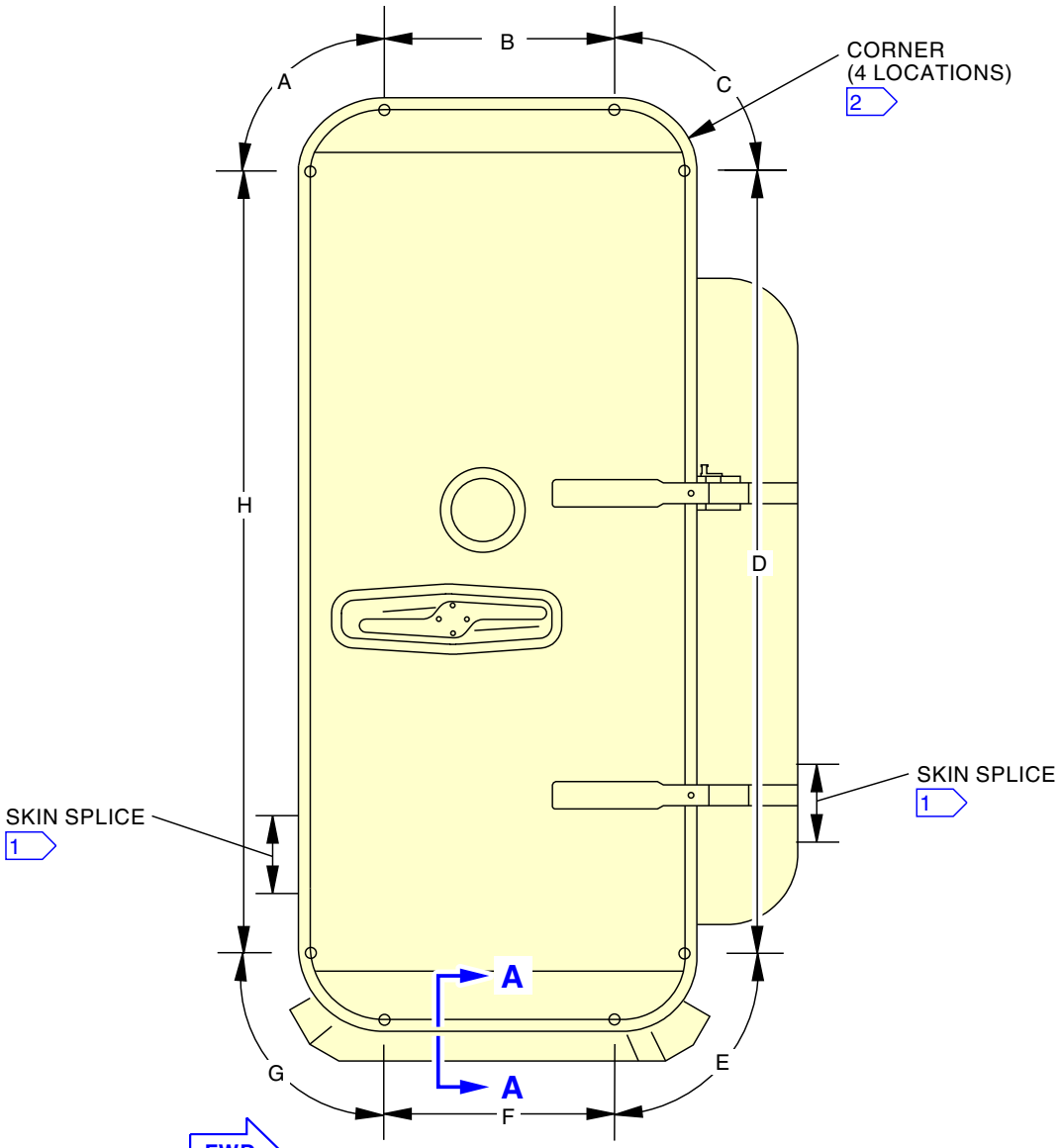
GUIDE ARM ROD END

B

2415895 S00061539124_V3

Guide Arm Adjustment
Figure 503/52-41-00-990-821 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



GALLEY SERVICE DOOR (EXAMPLE)

NOTE:

DIMENSION STANDARD: NOMINAL / UPPER LIMIT / LOWER LIMIT

A NEGATIVE FLUSHNESS SHOWS THE DOOR IS INBOARD OF THE FUSELAGE CUTOUT.

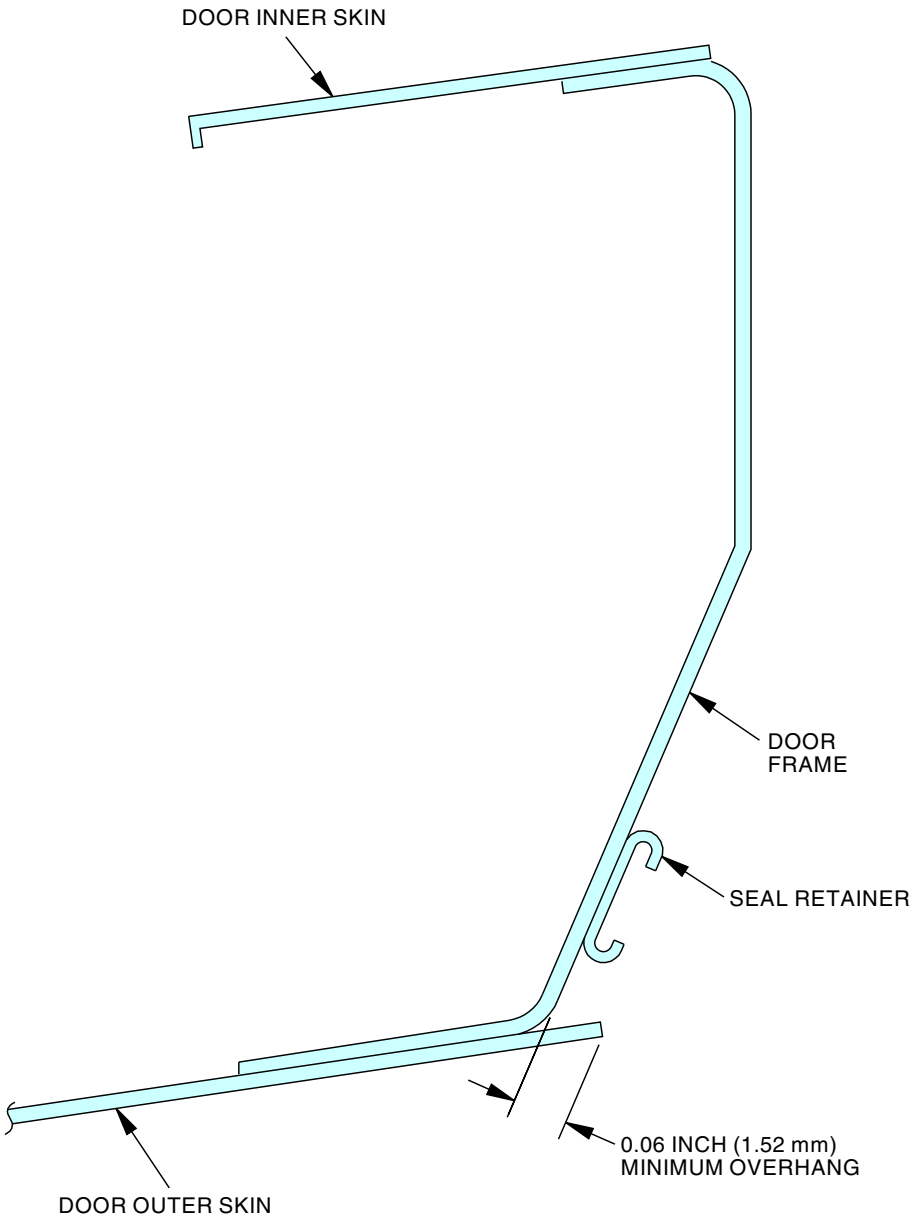
1 THE FLUSHNESS AT SKIN SPLICES WILL BE MORE THAN THE FLUSHNESS SHOWN BY THE ADDITIONAL SKIN AND BONDING THICKNESS.

2 FLUSHNESS IS NOT APPLICABLE AT CORNERS.

2415897 S00061539126_V1

Galley Service Door Skin Clearance and Flushness
Figure 504/52-41-00-990-823 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

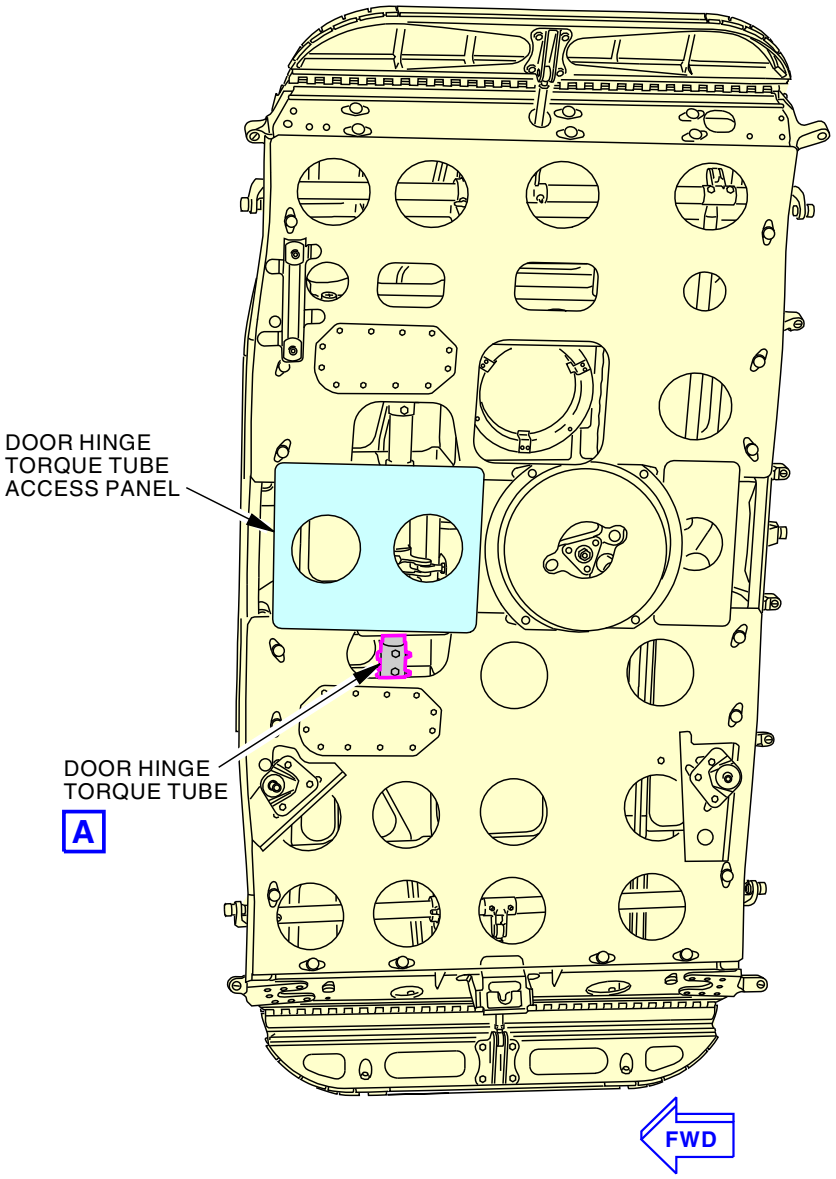


A-A

2415898 S00061539127_V1

Galley Service Door Skin Clearance and Flushness
Figure 504/52-41-00-990-823 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

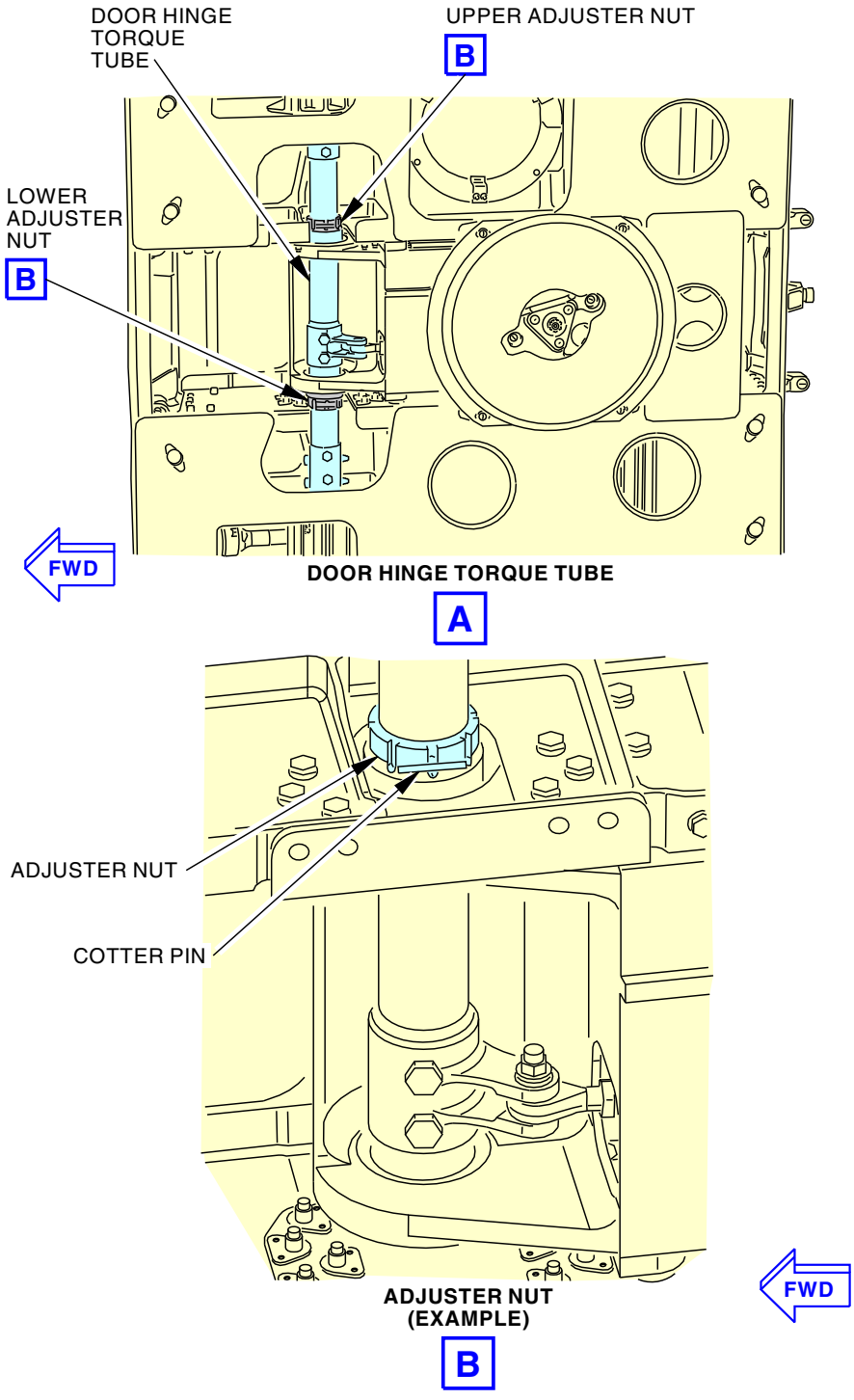


**GALLEY SERVICE DOOR
(EXAMPLE)**

2415899 S00061539128_V1

**Door Hinge Torque Tube Adjustment
Figure 505/52-41-00-990-824 (Sheet 1 of 2)**

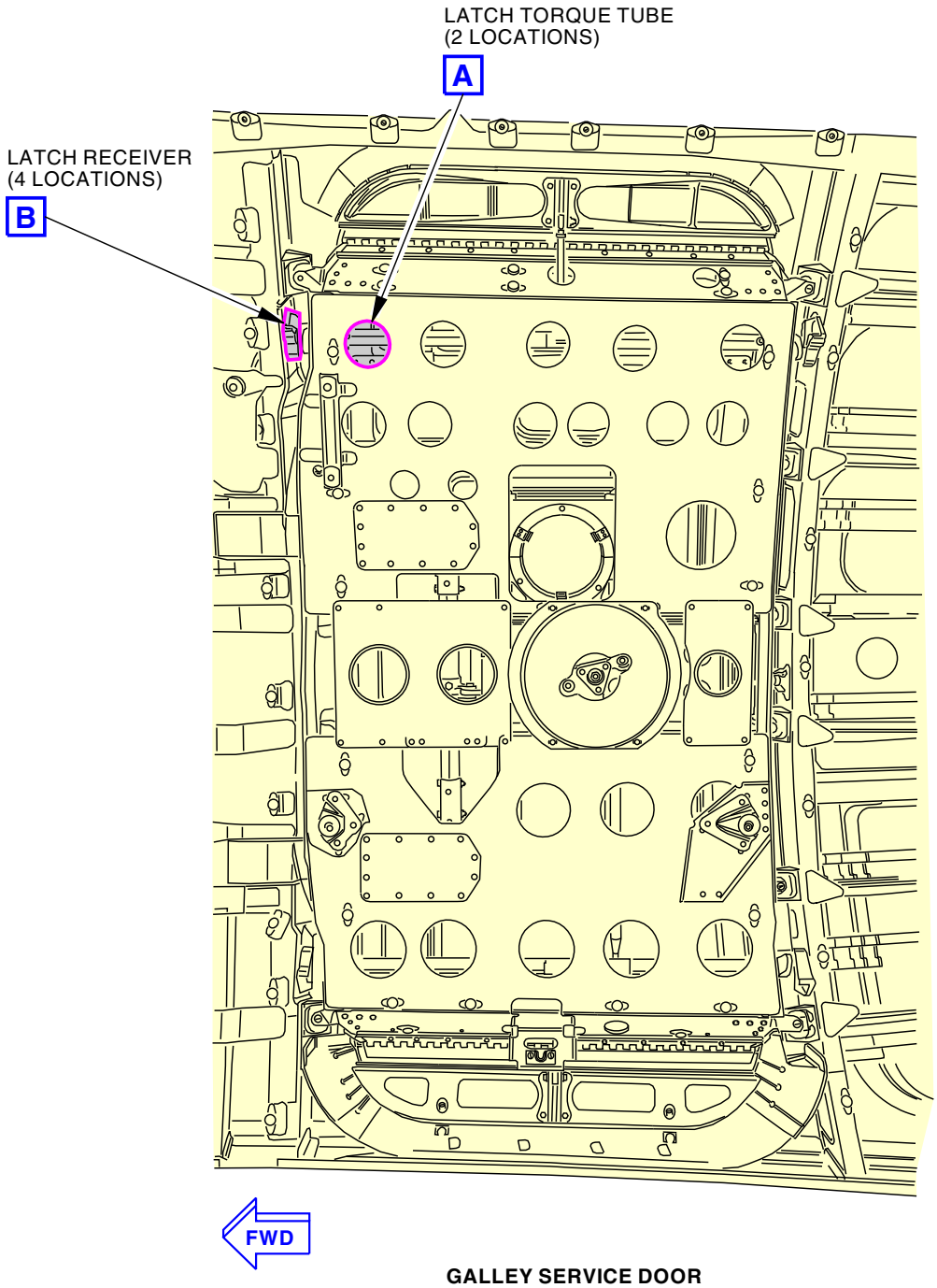
ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415900 S00061539129_V1

Door Hinge Torque Tube Adjustment
Figure 505/52-41-00-990-824 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

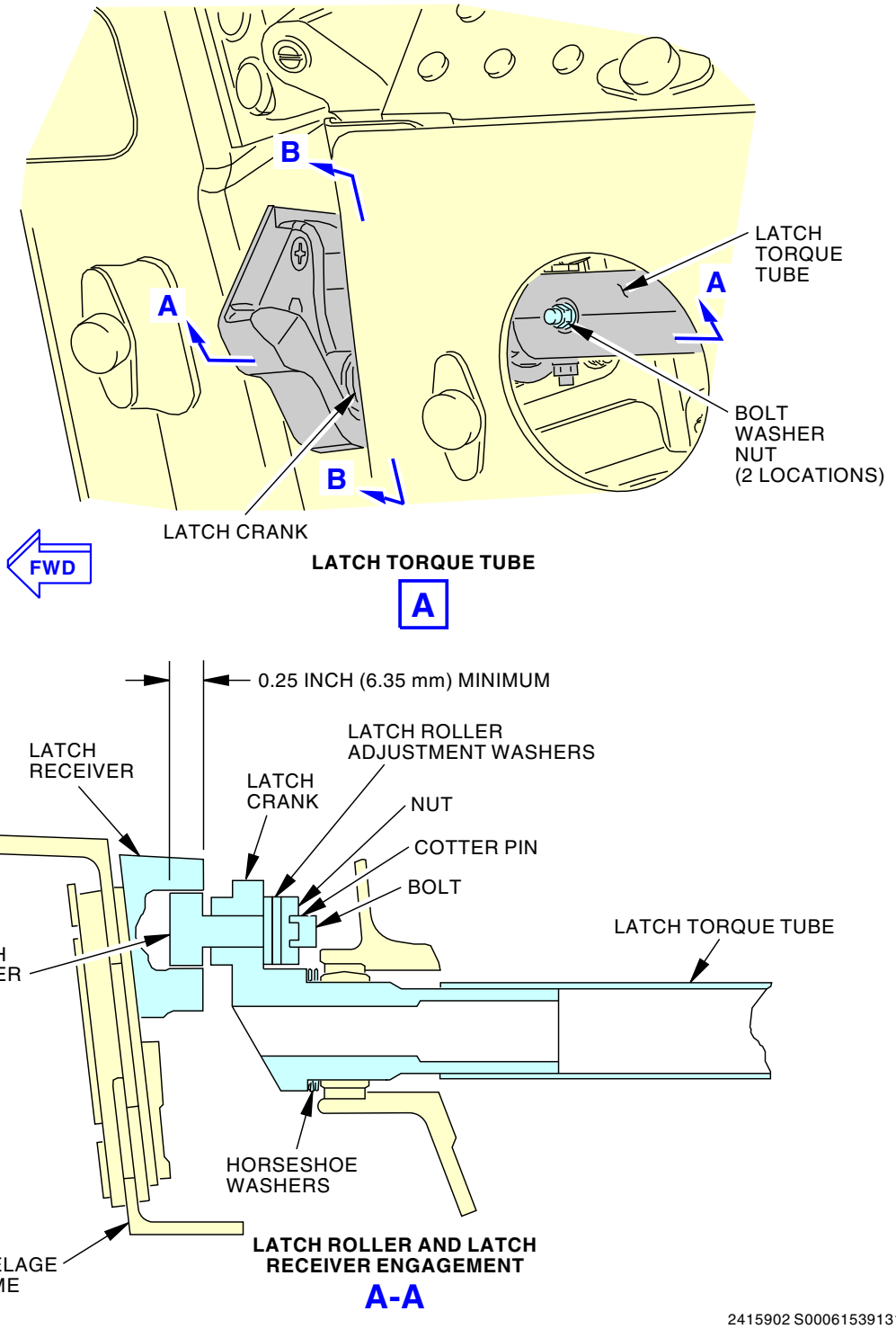


**GALLEY SERVICE DOOR
(EXAMPLE)**

2415901 S00061539130_V1

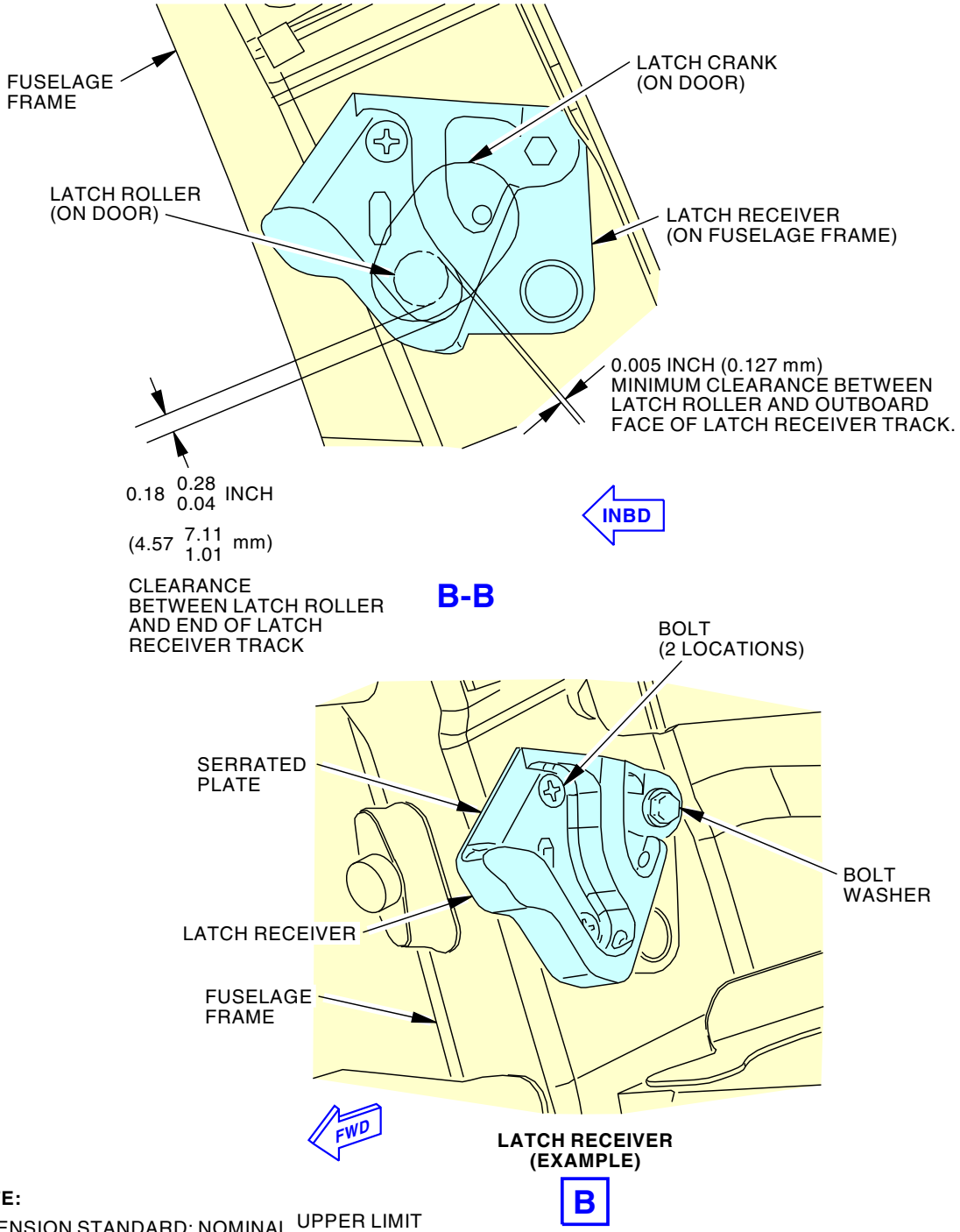
**Latch Adjustment
Figure 506/52-41-00-990-825 (Sheet 1 of 3)**

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Latch Adjustment
Figure 506/52-41-00-990-825 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



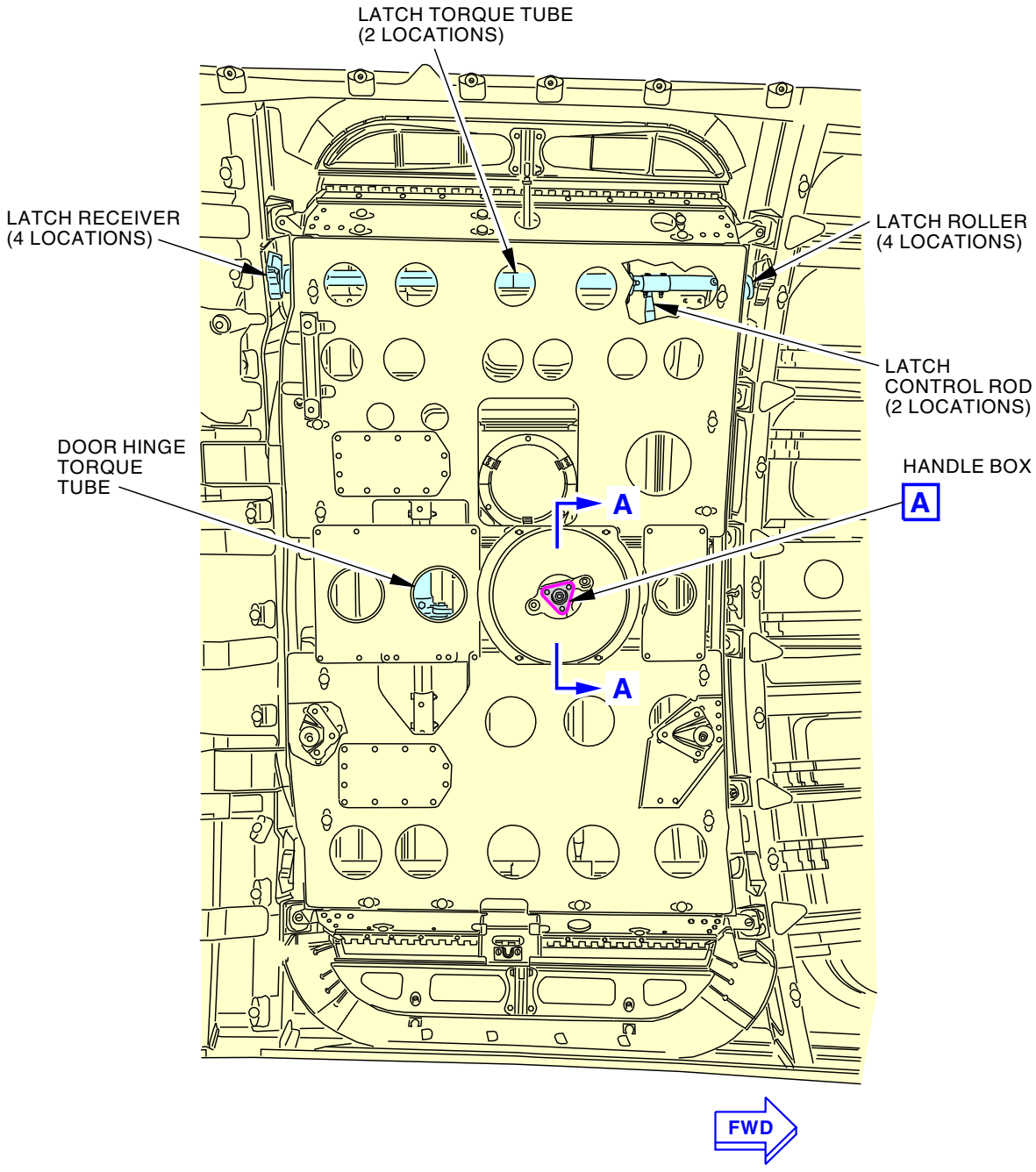
NOTE:

DIMENSION STANDARD: NOMINAL UPPER LIMIT LOWER LIMIT

2415903 S00061539132_V3

Latch Adjustment
Figure 506/52-41-00-990-825 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

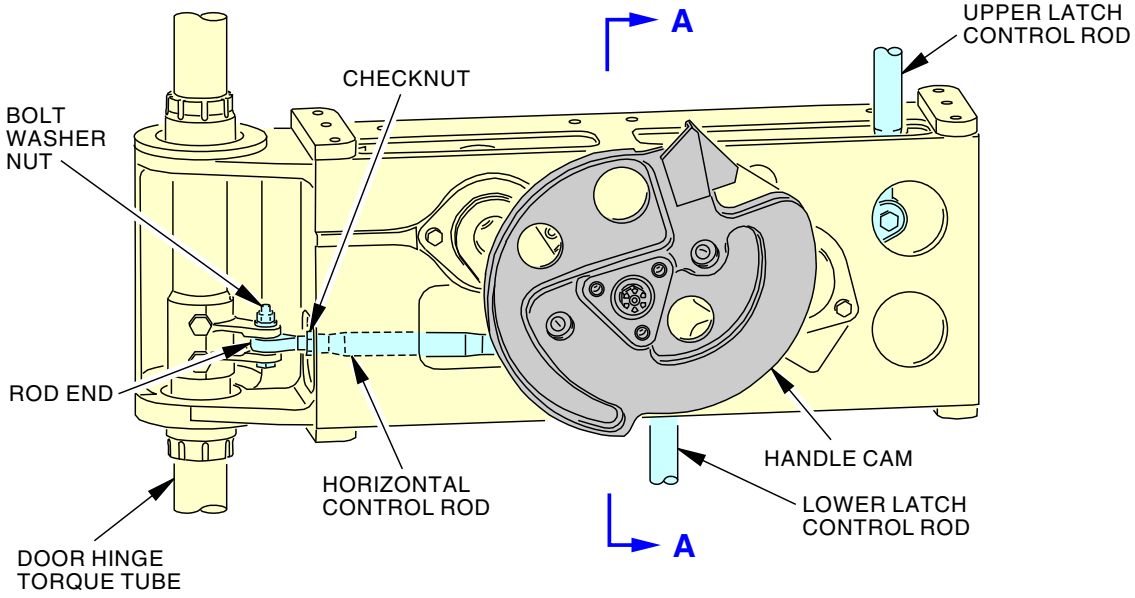


GALLEY SERVICE DOOR
(EXAMPLE)

2415904 S00061539133_V1

Horizontal Control Rod Adjustment
Figure 507/52-41-00-990-826 (Sheet 1 of 3)

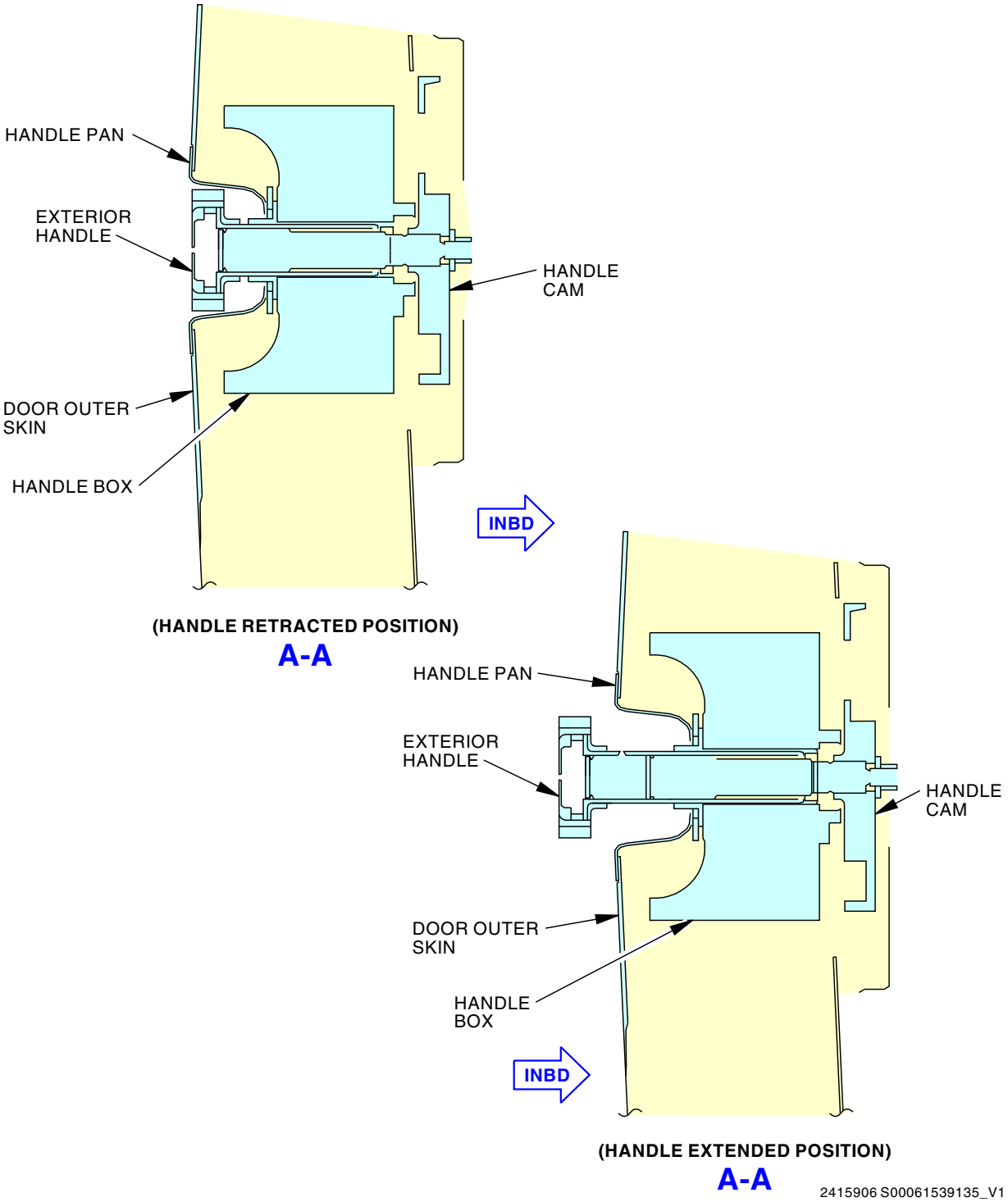
ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415905 S00061539134_V3

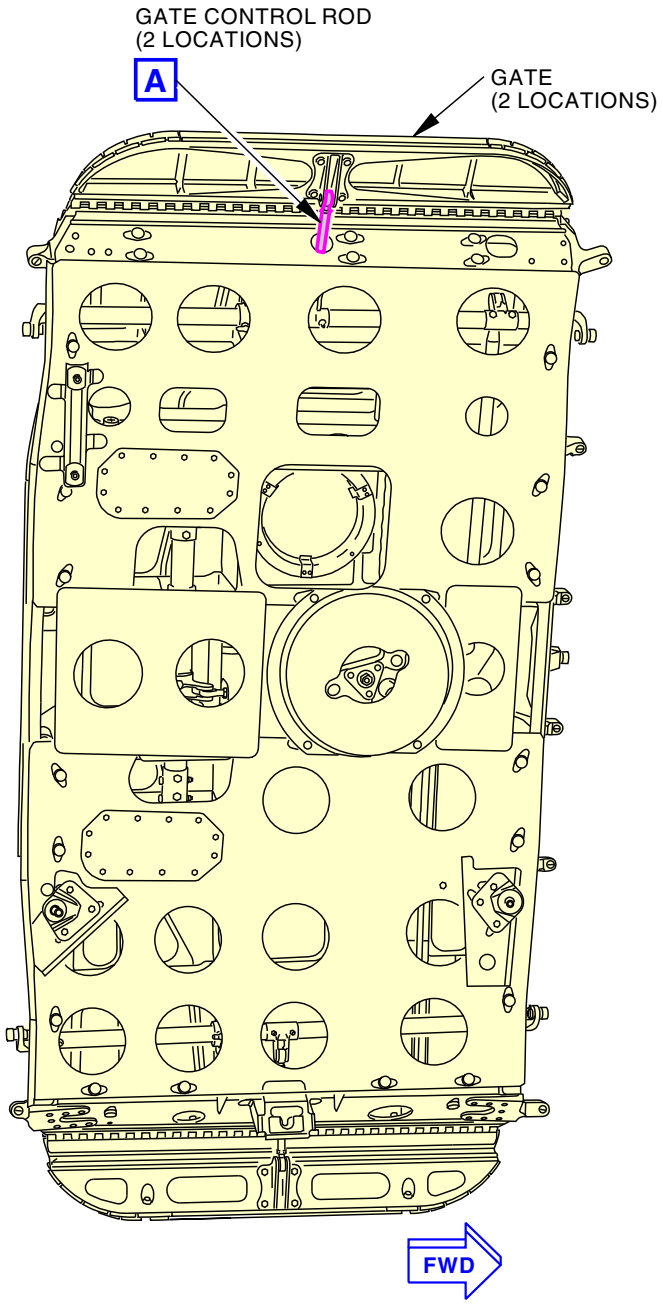
Horizontal Control Rod Adjustment
Figure 507/52-41-00-990-826 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Horizontal Control Rod Adjustment
Figure 507/52-41-00-990-826 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

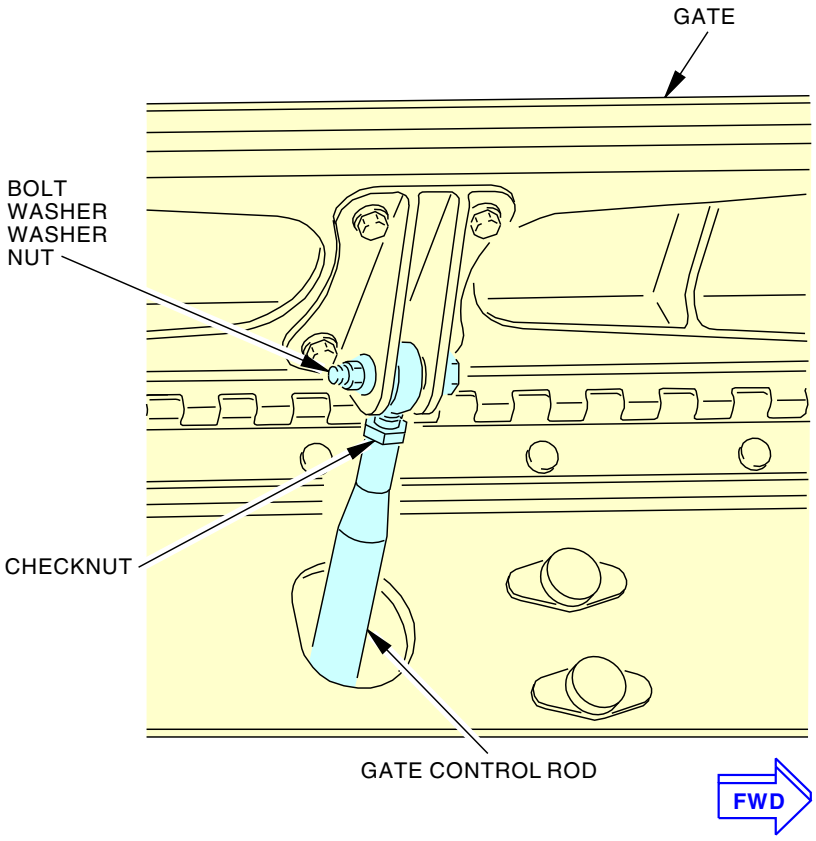


**GALLEY SERVICE DOOR
(EXAMPLE)**

2415907 S00061539136_V1

**Gate Adjustment
Figure 508/52-41-00-990-827 (Sheet 1 of 2)**

ECCN 9E991 BOEING PROPRIETARY - See title page for details



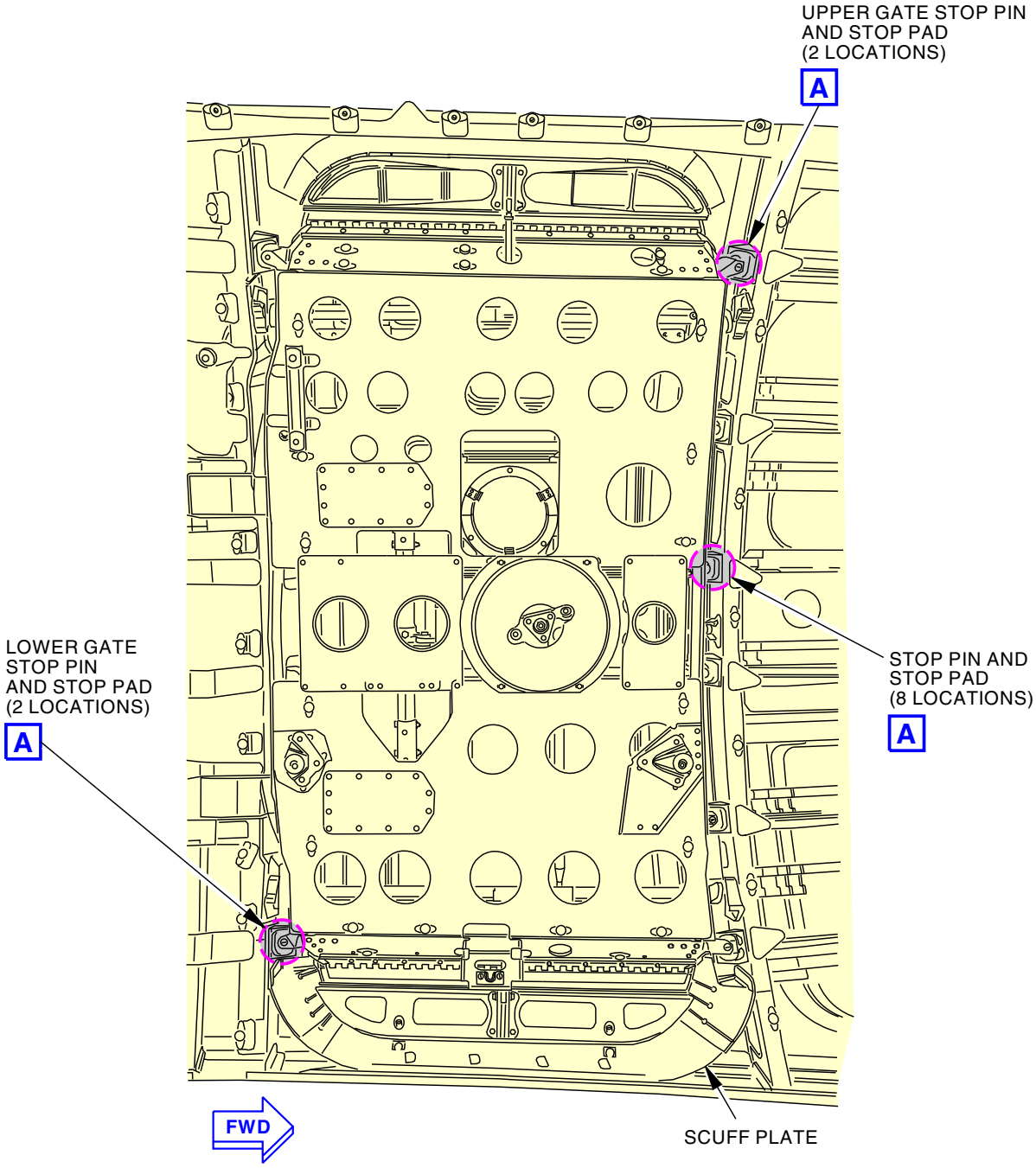
GATE CONTROL ROD
(EXAMPLE)

A

2415908 S00061539137_V3

Gate Adjustment
Figure 508/52-41-00-990-827 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

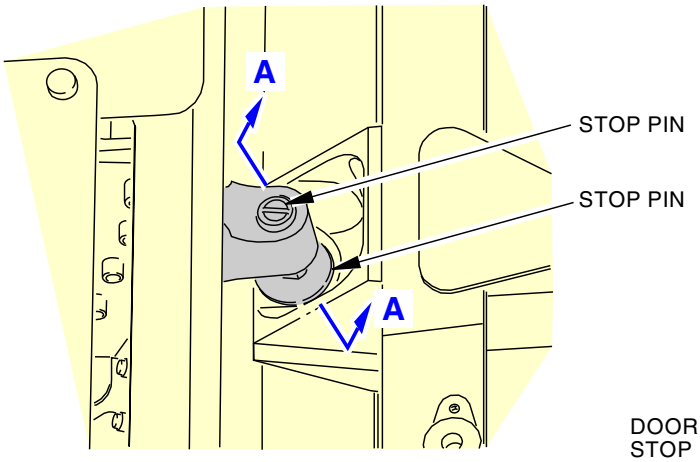


GALLEY SERVICE DOOR
(EXAMPLE)

2415909 S00061539138_V1

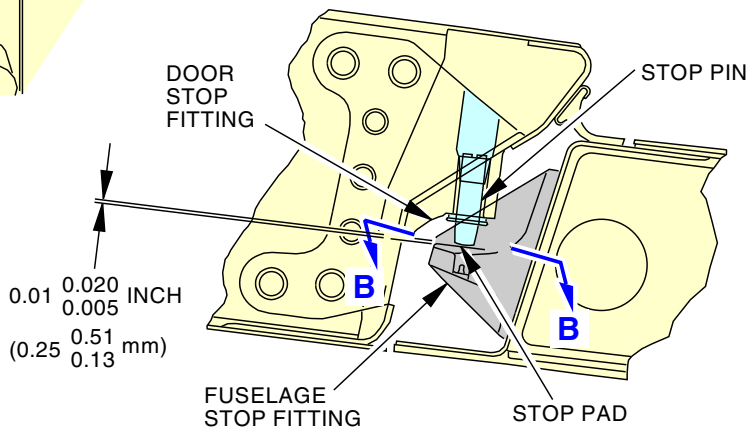
Stop Pin Adjustment
Figure 509/52-41-00-990-828 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



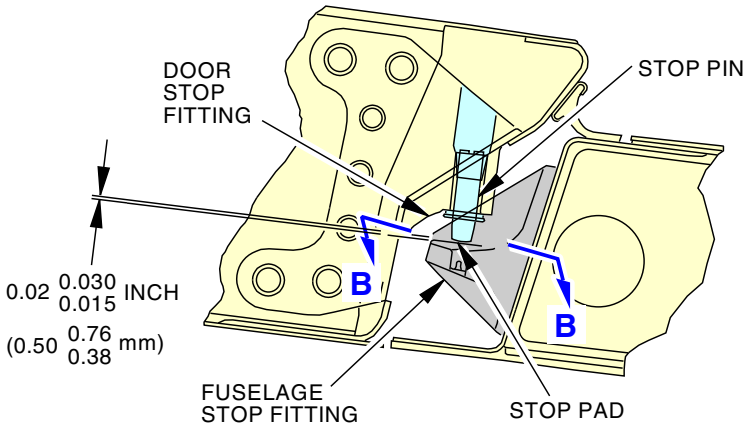
STOP PIN AND STOP PAD (EXAMPLE)

A



STOP PIN AND PAD CLEARANCE (FORWARD DOOR)

A-A



STOP PIN AND PAD CLEARANCE (AFT DOOR)

A-A

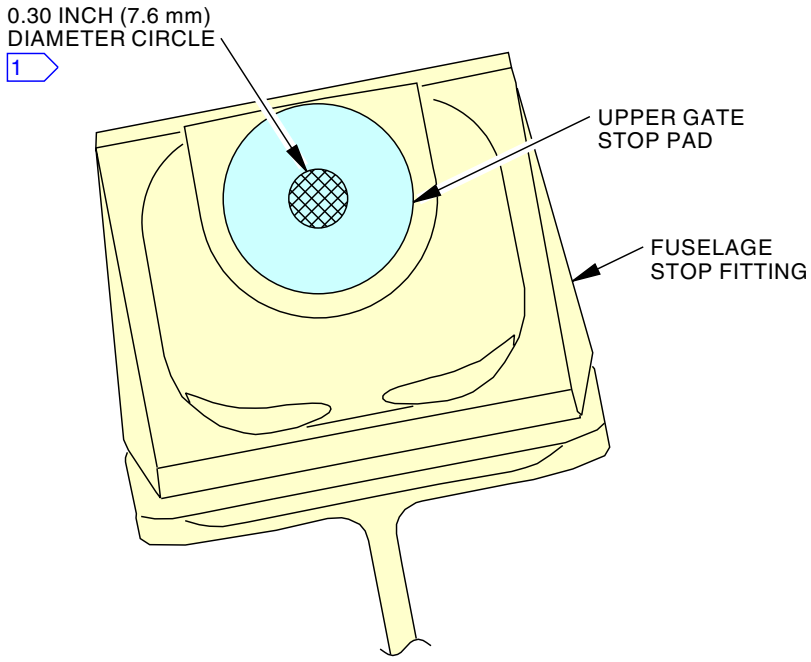
NOTE:

DIMENSION STANDARD: NOMINAL UPPER LIMIT LOWER LIMIT

2415910 S00061539139_V2

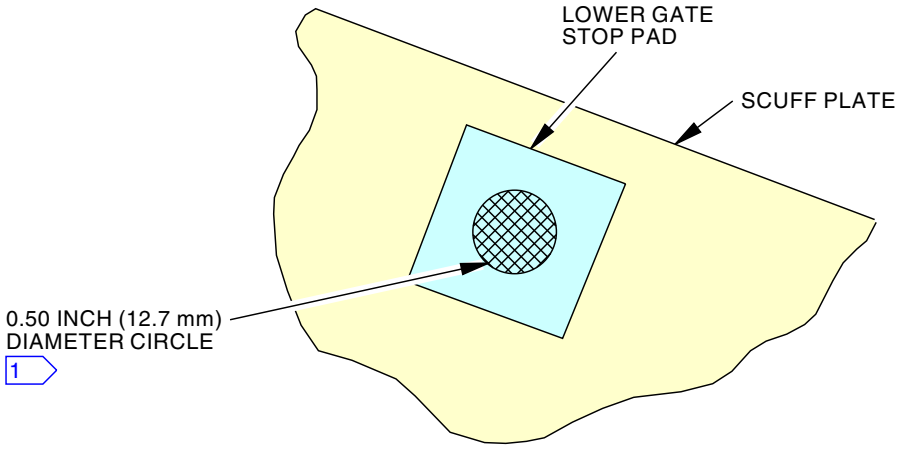
Stop Pin Adjustment
Figure 509/52-41-00-990-828 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



STOP PIN AND STOP PAD ALIGNMENT
(UPPER GATE AND DOOR STOP PADS)

B-B



STOP PIN AND STOP PAD ALIGNMENT
(LOWER GATE STOP PADS)

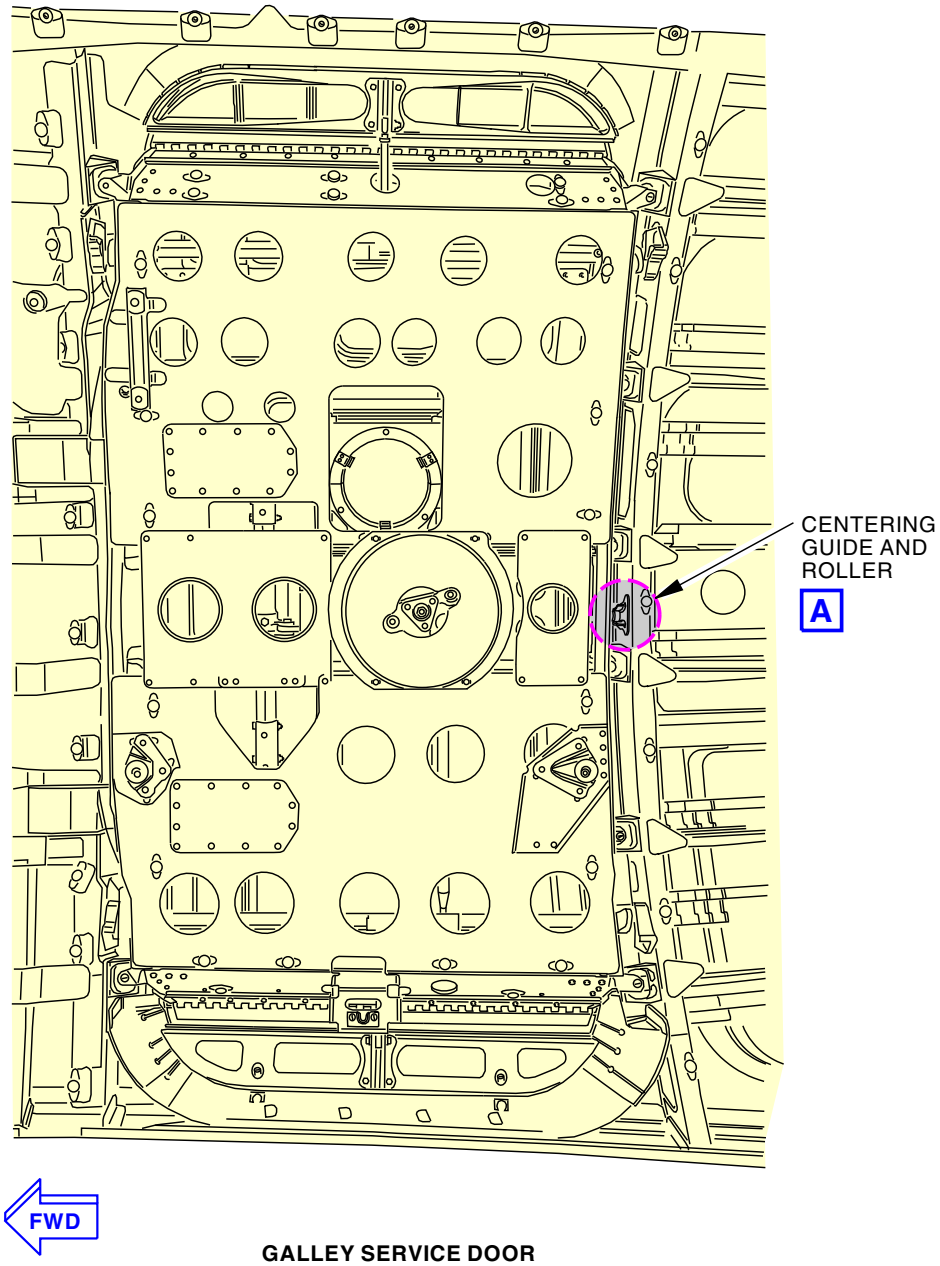
B-B

1 STOP PIN CENTER MUST TOUCH STOP PAD CENTER WITHIN THE CIRCLE DIAMETER SHOWN.

2415911 S00061539140_V1

Stop Pin Adjustment
Figure 509/52-41-00-990-828 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

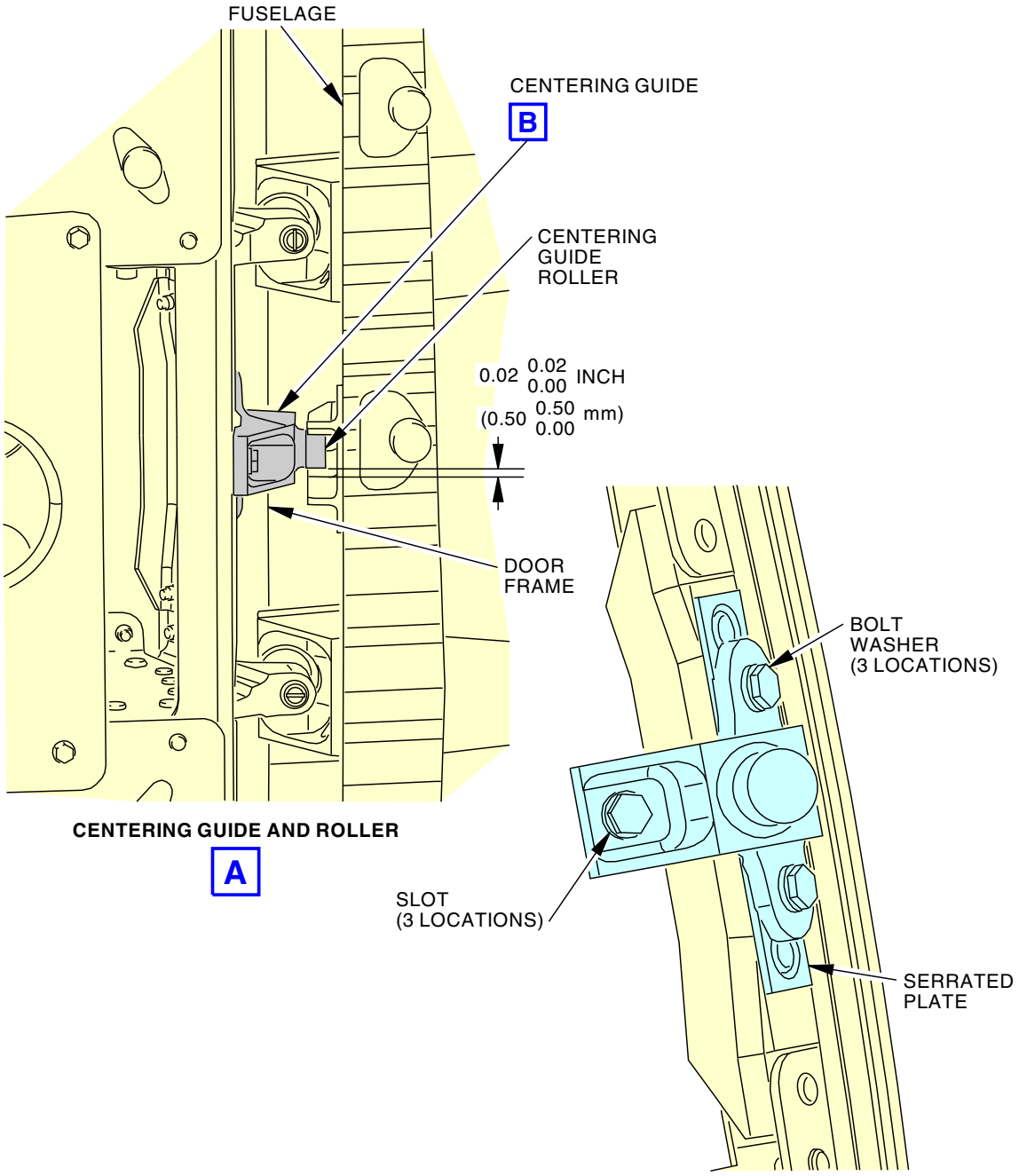


**GALLEY SERVICE DOOR
(EXAMPLE)**

2415912 S00061539141_V1

**Centering Guide Adjustment
Figure 510/52-41-00-990-829 (Sheet 1 of 2)**

ECCN 9E991 BOEING PROPRIETARY - See title page for details



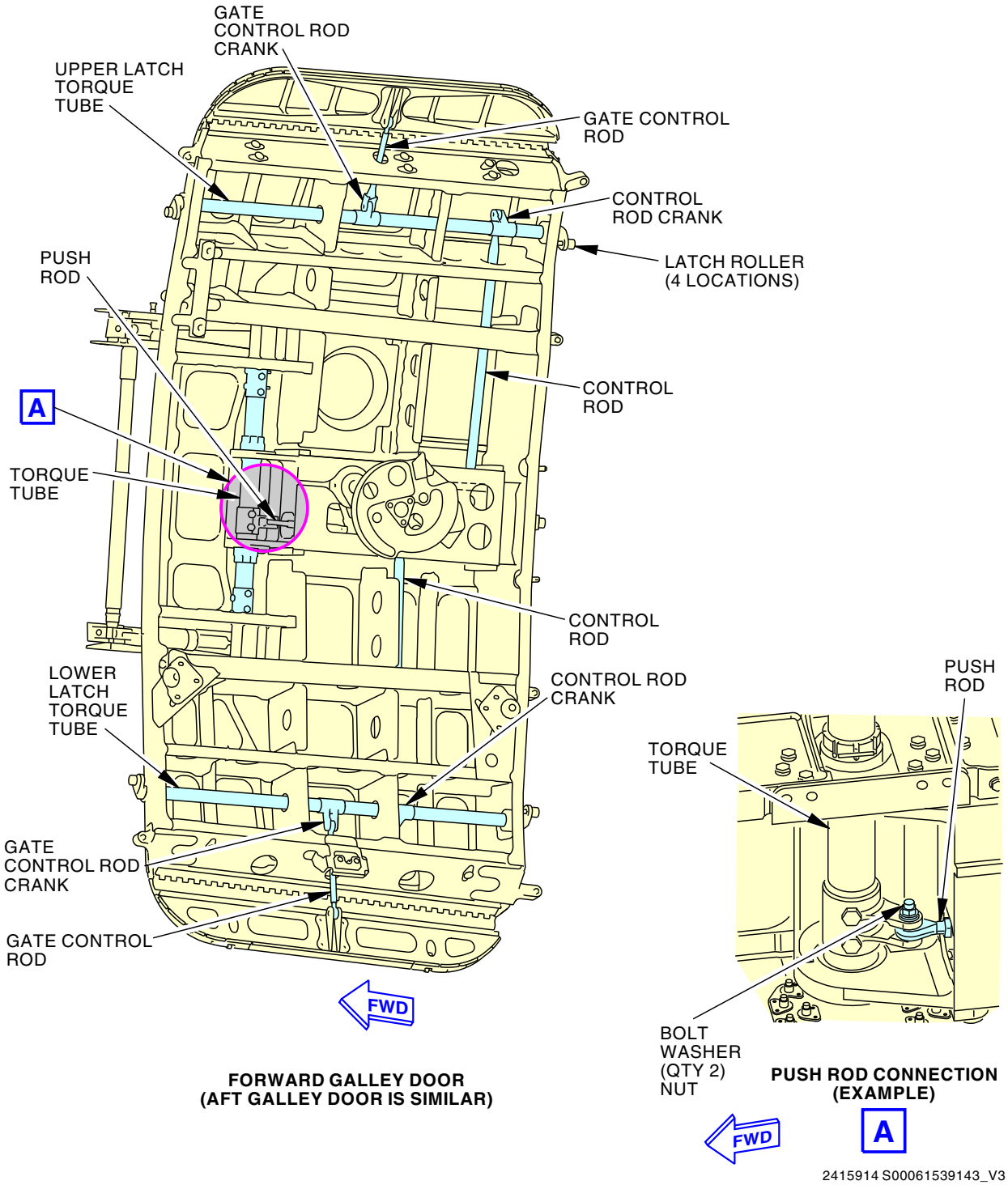
NOTE:

DIMENSION STANDARD: NOMINAL UPPER LIMIT LOWER LIMIT

2415913 S00061539142_V3

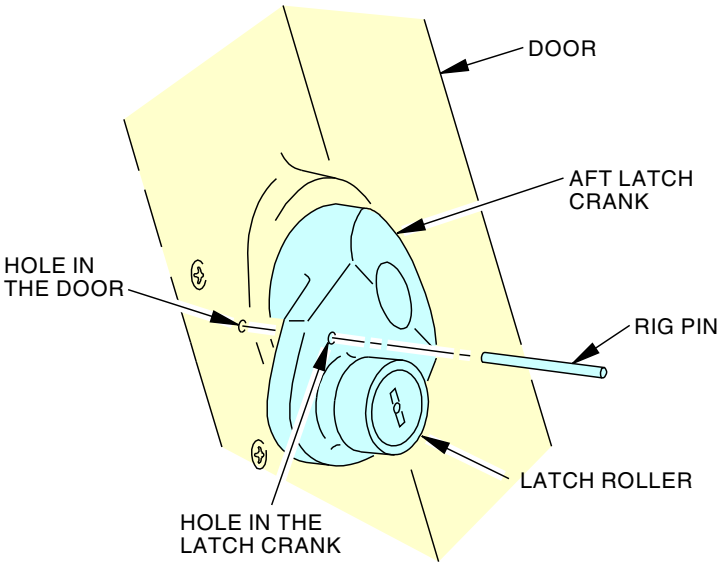
Centering Guide Adjustment
Figure 510/52-41-00-990-829 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

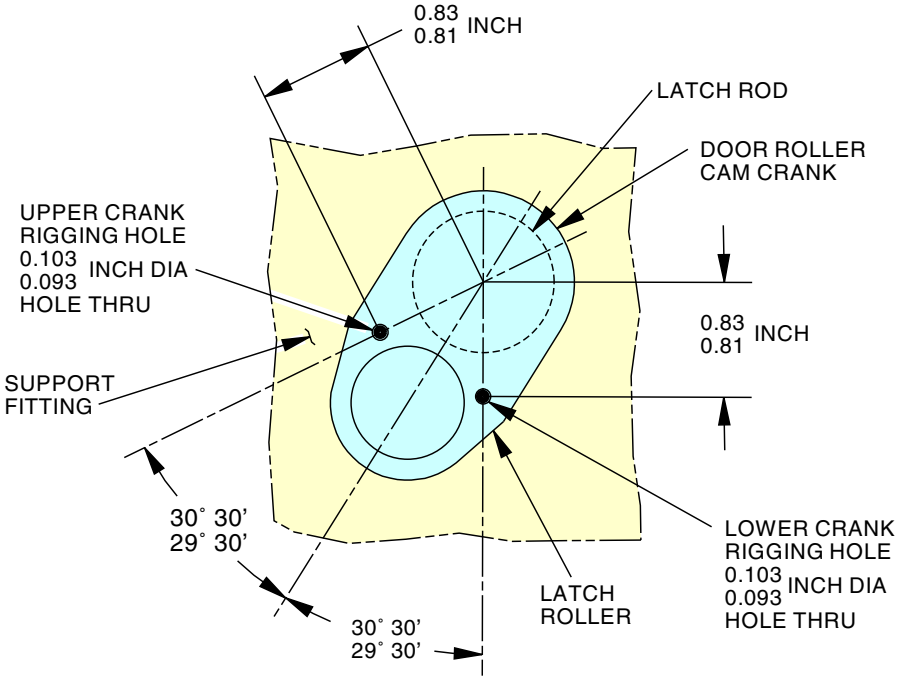


Galley Service Door Mechanism
Figure 511/52-41-00-990-830 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



THE HOLE IN THE LATCH CRANK MUST ALIGN WITH THE HOLE IN THE DOOR WHEN THE HANDLE IS IN THE LATCHED POSITION.



2415802 S00061538907_V1

Galley Service Door Mechanism
Figure 511/52-41-00-990-830 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-41-00-820-802

3. Galley Service Door (Soft Unlatching)

(Figure 506, Figure 511)

A. General

(1) Do the procedure with airplane at its Standard Basic Empty Weight (SBEW) and the airplane supported on its landing gear.

(2) If the latch torque tubes are not adjusted correctly, the door handle can move too easily. This can cause the door to open accidentally (soft unlatching). This task is a special procedure to adjust the door if it opens accidentally (soft unlatching).

(3) The soft unlatching adjustment and the vertical adjustment for the aft entry door are related. When you do the soft unlatching adjustment, it affects the vertical adjustment. Make sure that these adjustments are within tolerance before you complete the soft unlatching adjustment procedure.

B. References

Reference	Title
25-66-01-000-801	Escape Slide Pack and Cover Removal (P/B 401)
25-66-01-400-801	Escape Slide Pack and Cover Installation (P/B 401)
52-41-31-000-801	Galley Service Door Lining Removal (P/B 401)
52-41-31-400-801	Galley Service Door Lining Installation (P/B 401)
52-71-11-820-801	Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200) (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-2003	Simulator - Escape Slide, Passenger Door Part #: C52006-74 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
D00672 [CP5070]	Vaseline - Pure Mineral	V V-P-236
G02020	Clay, Modeling	

E. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

F. Galley Service Door (Soft Unlatching)

SUBTASK 52-41-00-010-003

(1) Do this task: Escape Slide Pack and Cover Removal, TASK 25-66-01-000-801.

SUBTASK 52-41-00-010-004

(2) Do this task: Galley Service Door Lining Removal, TASK 52-41-31-000-801.

SUBTASK 52-41-00-480-003

(3) Attach a 77 lb (35 kg) weight to the door approximately in the middle of the bottom half of the door.

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(a) You may use the escape slide simulator, SPL-2003.

SUBTASK 52-41-00-820-020

(4) Do a check of the adjustment of the latch rollers:

(a) Disconnect the push rod from the torque tube.

1) Remove the bolt, two washers and nut.

(b) Move the handle mechanism to the closed position.

NOTE: A wrench can help to move the handle mechanism.

(c) See that the latch rollers align correctly with the latch fittings.

1) Make sure that a 3/32 in. (2 mm) rig pin can easily slide through the hole in the latch roller and into the latch fitting.

(d) If the rig pin cannot easily slide through the hole, adjust the control rods to make the latch roller align correctly with the latch fitting:

1) Disconnect the control rods from the control rod cranks on the upper and lower latch torque tubes.

2) Align the holes in the latch roller with the holes in the latch fitting.

a) Put the 3/32 in. (2 mm) rig pin through the hole in the latch roller and into the hole in the latch fitting.

3) Change the length of the control rods until they align with the control rod cranks.

4) Connect the control rods to the control rod cranks.

(e) Connect the push rod to the torque tube.

1) Install the bolt, two washers and nut.

(f) Make sure that the latch rollers engage the latch fittings correctly:

1) Put clay, G02020, in the latch fitting.

2) Put a layer of vaseline, D00672 [CP5070], on the latch roller.

3) Close and latch the door.

4) Open the door.

5) Measure the depth of the clay to find the latch roller clearance (Figure 506).

a) Make sure that the clearance between the bottom of the latch roller and the latch fitting is 0.04 in. (1.02 mm) - 0.28 in. (7.11 mm).

b) Make sure that the clearance between the bottom of the latch roller and the latch fitting is not less than 0.005 in. (0.127 mm).

SUBTASK 52-41-00-820-021

(5) Adjust the galley service door sensors.

(a) Do this task: Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200), TASK 52-71-11-820-801.

SUBTASK 52-41-00-080-004

(6) Remove the weight or the escape slide simulator, SPL-2003, from the door.

SUBTASK 52-41-00-410-003

(7) Do this task: Galley Service Door Lining Installation, TASK 52-41-31-400-801.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-41-00-410-004

(8) Do this task: Escape Slide Pack and Cover Installation, TASK 25-66-01-400-801.

——— END OF TASK ———

TASK 52-41-00-700-801

4. Galley Service Door System Test

A. General

(1) The system test is a check that the door is installed and adjusted correctly and that the mechanical systems operate correctly.

(2) Make sure that the installation and adjustment of the door is done. Make sure that the door seal and lining are installed.

B. References

Reference	Title
52-41-00-860-803	Open the Galley Service Door with the Interior Handle (P/B 201)
52-41-00-860-804	Close the Galley Service Door with the Interior Handle (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-3898	Adapter - Torque Wrench, Galley and Entry Door Part #: C52008-1 Supplier: 81205

D. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Galley Service Door System Test

SUBTASK 52-41-00-730-002

(1) Do the warning system test for the galley service door as follows:

(a) Make sure that the forward and aft galley service doors are fully closed, latched, and locked.

(b) Make sure that the FWD SERVICE or AFT SERVICE light does not show, on the P5 forward overhead panel, in the flight compartment.

(c) Open the door, do this task: Open the Galley Service Door with the Interior Handle, TASK 52-41-00-860-803.

(d) Make sure that the FWD SERVICE or AFT SERVICE light, on the P5 forward overhead panel, comes on for the door.

(e) Close and latch the door, do this task: Close the Galley Service Door with the Interior Handle, TASK 52-41-00-860-804.

(f) Make sure that the FWD SERVICE or AFT SERVICE light goes off.

SUBTASK 52-41-00-730-003

(2) Do the door handle torque test as follows:

(a) Install the adapter, SPL-3898, on the interior door handle.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) Open the door, do this task: Open the Galley Service Door with the Interior Handle, TASK 52-41-00-860-803.

(c) Measure the torque on the interior handle perpendicular to the handle cam to close the door.

(d) Make sure that the maximum torque on the interior handle to close the door is 600 in-lb (68 N·m).

1) If the maximum handle torque is more than 600 in-lb (68 N·m), do these steps:

NOTE: The most likely cause for the increase in door closing force is the door guide ball is binding in the track.

a) Make sure that the door guide ball is correctly adjusted.

b) Make sure that the stop pins are correctly adjusted.

c) Make sure that the upper and lower gates are correctly adjustment.

d) Adjust the horizontal control rod, do this task: Galley Service Door Adjustment, TASK 52-41-00-820-801.

NOTE: Do the horizontal control rod adjustment only.

(e) Close and latch the door, do this task: Close the Galley Service Door with the Interior Handle, TASK 52-41-00-860-804.

(f) Measure the torque on the interior handle perpendicular to the handle cam to open the door.

(g) Make sure that the maximum torque on the interior handle to open the door is 360 in-lb (41 N·m).

1) If the maximum handle torque is more than 360 in-lb (41 N·m), do these steps:

a) Make sure that the door is correctly installed.

b) Adjust the horizontal control rod, do this task: Galley Service Door Adjustment, TASK 52-41-00-820-801.

NOTE: Do the horizontal control rod adjustment only.

(h) Remove the adapter, SPL-3898, from the internal door handle.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

GALLEY SERVICE DOOR - INSPECTION/CHECK

1. General

A. This procedure has these tasks:

(1) A check of the galley service door

(2) A check of the galley service door centering guide bearing

(3) A check of the galley service door pressure seal.

B. This procedure is the same for the forward and aft galley service door.

TASK 52-41-00-200-801

2. Galley Service Door Check

A. References

Reference	Title
52-41-00 P/B 201	GALLEY SERVICE DOORS - MAINTENANCE PRACTICES
52-41-31-000-801	Galley Service Door Lining Removal (P/B 401)
52-41-31-400-801	Galley Service Door Lining Installation (P/B 401)

B. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

C. Access Panels

Number	Name/Location
841AZ	Forward Galley Service Door - Torque Tube Access
841BZ	Forward Galley Service Door - Handle Box and Cam for Handle Box Access
841CZ	Forward Galley Service Door - Handle Box Access
841DZ	Forward Galley Service Door - Lower Hinge Access
841EZ	Forward Galley Service Door - Upper Hinge Access
841FZ	Forward Galley Service Door - Torque Tube Access
841GZ	Forward Galley Service Door - Torque Tube Access
844AZ	Aft Galley Service Door - Torque Tube Access
844BZ	Aft Galley Service Door - Handle Box and Cam for Handle Box Access
844CZ	Aft Galley Service Door - Handle Box Access
844DZ	Aft Galley Service Door - Lower Hinge Access
844EZ	Aft Galley Service Door - Upper Hinge Access
844FZ	Aft Galley Service Door - Torque Tube Access
844GZ	Aft Galley Service Door - Torque Tube Access

D. Prepare for the Inspection

SUBTASK 52-41-00-860-030

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched (PAGEBLOCK 52-41-00/201).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure that the stand is installed outboard of the door.

SUBTASK 52-41-00-010-005

(2) Do this task: Galley Service Door Lining Removal, TASK 52-41-31-000-801.

SUBTASK 52-41-00-010-006

(3) Remove the applicable access panels to get access to the door components:

(a) For the forward galley service door, open these access panels:

Number	Name/Location
841AZ	Forward Galley Service Door - Torque Tube Access
841BZ	Forward Galley Service Door - Handle Box and Cam for Handle Box Access
841CZ	Forward Galley Service Door - Handle Box Access
841DZ	Forward Galley Service Door - Lower Hinge Access
841EZ	Forward Galley Service Door - Upper Hinge Access
841FZ	Forward Galley Service Door - Torque Tube Access
841GZ	Forward Galley Service Door - Torque Tube Access

(b) For the aft galley service door, open these access panels:

Number	Name/Location
844AZ	Aft Galley Service Door - Torque Tube Access
844BZ	Aft Galley Service Door - Handle Box and Cam for Handle Box Access
844CZ	Aft Galley Service Door - Handle Box Access
844DZ	Aft Galley Service Door - Lower Hinge Access
844EZ	Aft Galley Service Door - Upper Hinge Access
844FZ	Aft Galley Service Door - Torque Tube Access
844GZ	Aft Galley Service Door - Torque Tube Access

SUBTASK 52-41-00-010-008

(4) Open and close the galley service door as necessary to inspect the door components (PAGEBLOCK 52-41-00/201).

E. Galley Service Door Inspection

SUBTASK 52-41-00-210-001

(1) Do a visual inspection of the external door structure and handle as follows:

(a) Examine the external skin.

1) Look for dents, cracks, and corrosion.

2) Look for burrs.

3) Look for loose and missing fasteners.

(b) Examine the window.

1) Look for cracks.

2) Look for crazing.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(c) Examine the window frame.
1) Look for cracks and corrosion.
(d) Examine the external handle.
1) Look for cracks and corrosion.
2) Look for too much wear.
(e) Examine the handle pan.
1) Look for cracks and corrosion.
2) Look for loose and missing fasteners.

SUBTASK 52-41-00-210-002

(2) Do a visual inspection of the door internal structure and handle mechanism as follows:
(a) Examine the internal skin.
1) Look for dents, cracks, and corrosion.
2) Look for burrs.
3) Look for loose and missing fasteners.
(b) Examine the internal frames and brackets.
1) Look for cracks and corrosion.
2) Look for loose and missing fasteners.
(c) Examine the drain holes.
1) Look for blockage.
(d) Examine the handle box.
1) Look for cracks and corrosion.
2) Look for too much wear.
(e) Examine the handle housing.
1) Look for cracks and corrosion.
2) Look for too much wear.
(f) Examine the internal handle.
1) Look for cracks and corrosion.
2) Look for too much wear.
(g) Examine the end gates.
1) Look for cracks and corrosion.
2) Look for loose and missing fasteners.

SUBTASK 52-41-00-210-003

(3) Do a visual inspection of the latch mechanism as follows:
(a) Examine the latch control rods.
1) Look for cracks and corrosion.
2) Look for too much wear.
(b) Examine the latch torque tubes.
1) Look for cracks and corrosion.
2) Look for too much wear.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(c) Examine the latch cranks and latch rollers.

1) Look for cracks and corrosion.

2) Look for too much wear.

3) Look for unwanted particles on the latch rollers.

(d) Examine the gate control rods.

1) Look for cracks and corrosion.

2) Look for too much wear.

SUBTASK 52-41-00-210-004

(4) Do a visual inspection of the door stop fittings and stop pins as follows:

(a) Examine the door stop fittings.

1) Look for cracks and corrosion.

(b) Examine the stop pins.

1) Look for cracks and corrosion.

2) Look for unwanted particles on the stop pins.

3) Make sure that the retaining springs are installed.

SUBTASK 52-41-00-210-005

(5) Do a visual inspection of the attach structure and hinge mechanism as follows:

(a) Examine the fuselage hinge torque tube.

1) Look for cracks and corrosion.

2) Look for too much wear.

(b) Examine the hinge arms.

1) Look for cracks and corrosion.

2) Look for too much wear.

(c) Examine the hinge arm fasteners.

1) Make sure that the bolts fully engage the nuts.

2) Make sure that the bolt threads are not damaged.

(d) Examine the door hinge torque tube.

1) Look for cracks and corrosion.

2) Look for too much wear.

NOTE: The nuts and bolts that connect the sleeves to the torque tube may appear loose, because they are not tightened to a clamp up pressure. A small gap between the washer and the sleeve is acceptable.

(e) Examine the guide arm and roller.

1) Look for cracks and corrosion.

2) Look for too much wear.

(f) Examine the guide plates.

1) Look for cracks and corrosion.

2) Look for too much wear.

(g) Examine the guide plate drain holes.

1) Look for blockage.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-41-00-210-006

(6) Do a visual inspection of the structure around the door opening as follows:

(a) Examine the fuselage stop fittings and stop pads.

1) Look for cracks and corrosion.

2) Look for wear that is not in the center of the stop pads.

3) Look for unwanted particles on the stop fittings.

(b) Examine the latch receivers.

1) Look for cracks and corrosion.

2) Look for too much wear.

3) Look for unwanted particles in the latch receivers.

(c) Examine the fuselage frame.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 52-41-00-010-009

(1) Install the applicable access panels if they are removed:

(a) For the forward galley service door, close these access panels:

Number	Name/Location
841AZ	Forward Galley Service Door - Torque Tube Access
841BZ	Forward Galley Service Door - Handle Box and Cam for Handle Box Access
841CZ	Forward Galley Service Door - Handle Box Access
841DZ	Forward Galley Service Door - Lower Hinge Access
841EZ	Forward Galley Service Door - Upper Hinge Access
841FZ	Forward Galley Service Door - Torque Tube Access
841GZ	Forward Galley Service Door - Torque Tube Access

(b) For the aft galley service door, close these access panels:

Number	Name/Location
844AZ	Aft Galley Service Door - Torque Tube Access
844BZ	Aft Galley Service Door - Handle Box and Cam for Handle Box Access
844CZ	Aft Galley Service Door - Handle Box Access
844DZ	Aft Galley Service Door - Lower Hinge Access
844EZ	Aft Galley Service Door - Upper Hinge Access
844FZ	Aft Galley Service Door - Torque Tube Access
844GZ	Aft Galley Service Door - Torque Tube Access

SUBTASK 52-41-00-210-007

(2) Do this task: Galley Service Door Lining Installation, TASK 52-41-31-400-801.

SUBTASK 52-41-00-860-031

(3) Close and latch the door (PAGEBLOCK 52-41-00/201).

SUBTASK 52-41-00-940-001

(4) Remove the stand.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-41-00-200-802

3. Galley Service Door Centering Guide Bearing Check

(Figure 601)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
52-41-00 P/B 201	GALLEY SERVICE DOORS - 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

D. Prepare for the Inspection

SUBTASK 52-41-00-860-032

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched (PAGEBLOCK 52-41-00/201).

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure that the work platform, COM-1523, is installed outboard of the door.

SUBTASK 52-41-00-010-010

(2) Open the door (PAGEBLOCK 52-41-00/201).

E. Galley Service Door Centering Guide Bearing Inspection

SUBTASK 52-41-00-210-008

(1) Do a visual inspection of the centering guide as follows:

(a) Examine the guide fitting.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

(b) Examine the guide bearing.

1) Look for too much wear.

2) Make sure that the bearing is not loose.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3) Look for unwanted particles on the bearing surface.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 52-41-00-860-033

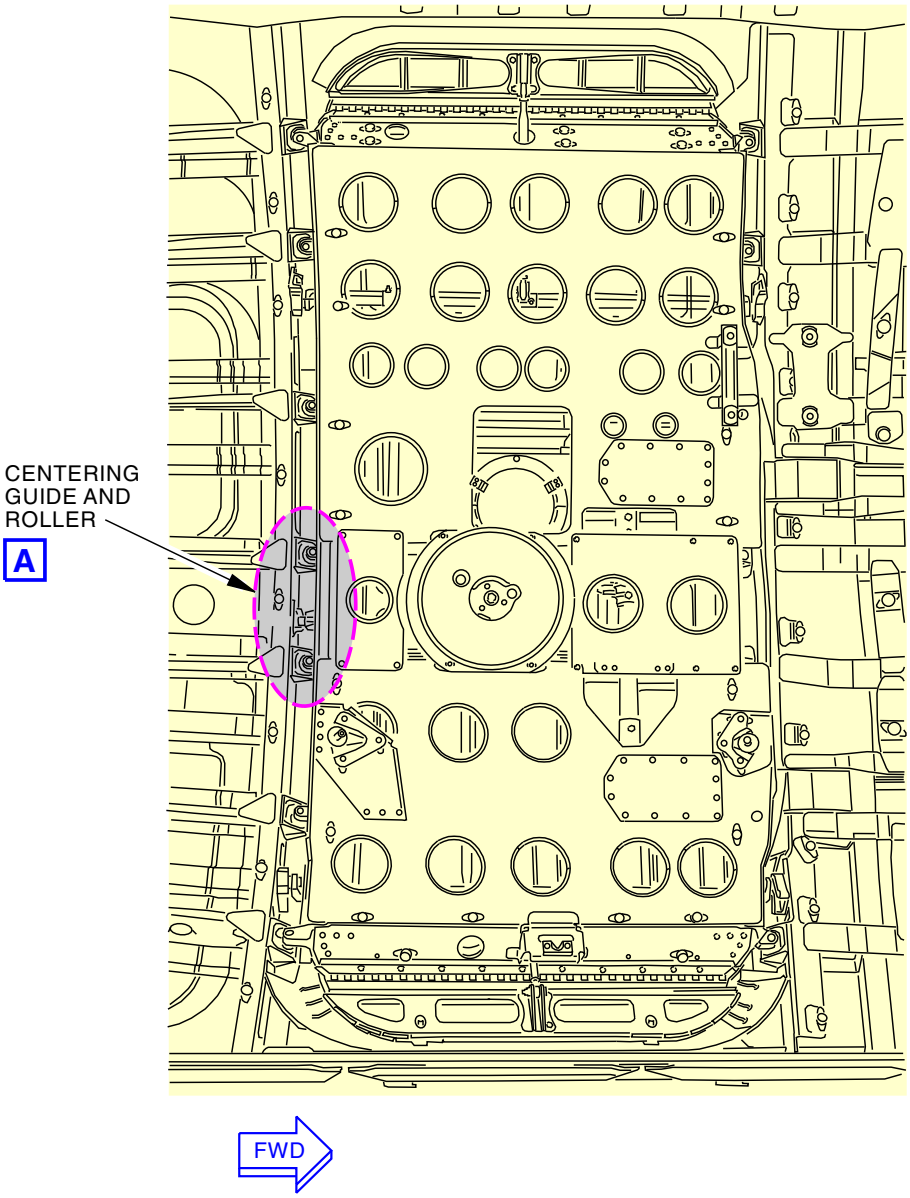
(1) Close and latch the door (PAGEBLOCK 52-41-00/201).

SUBTASK 52-41-00-940-002

(2) Remove the work platform, COM-1523.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

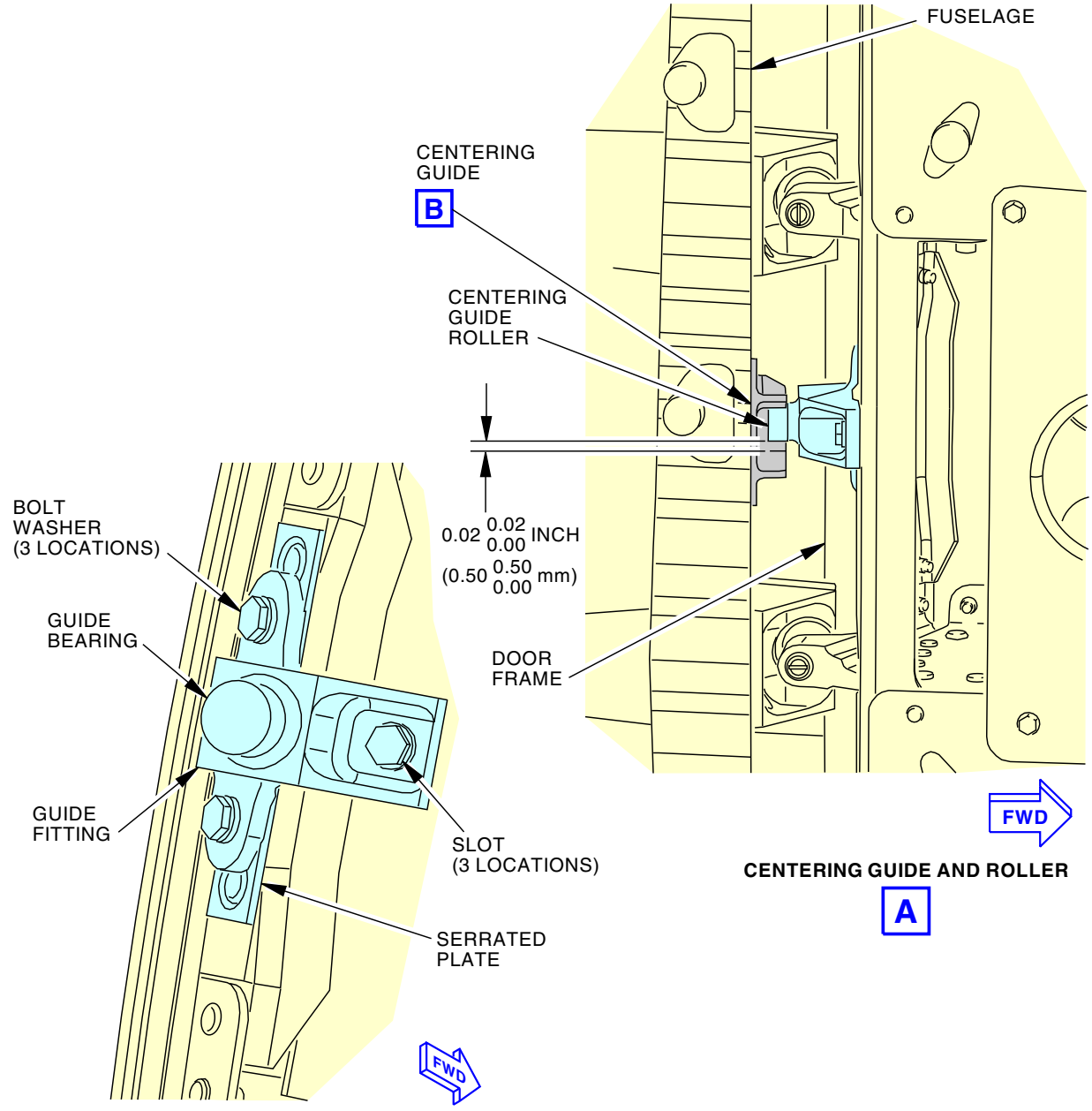


AFT ENTRY DOOR
(FORWARD SERVICE DOOR AND AFT SERVICE DOOR ARE EQUIVALENT)

2415803 S00061538911_V1

Centering Guide Inspection/Check
Figure 601/52-41-00-990-816 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



NOTE:

DIMENSION STANDARD: NOMINAL UPPER LIMIT LOWER LIMIT

2415804 S00061538912_V2

Centering Guide Inspection/Check
Figure 601/52-41-00-990-816 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-41-00-200-803

4. Galley Service Door Pressure Seal Check

(Figure 602)

A. References

Reference	Title
52-41-00 P/B 201	GALLEY SERVICE DOORS - 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

C. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

D. Prepare for the Inspection

SUBTASK 52-41-00-860-034

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched (PAGEBLOCK 52-41-00/201).

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure that the work platform, COM-1523, is installed outboard of the door.

SUBTASK 52-41-00-010-011

(2) Open the door (PAGEBLOCK 52-41-00/201).

E. Galley Service Door Pressure Seal Inspection

SUBTASK 52-41-00-210-009

(1) Do a visual inspection of the door pressure seal as follows:

(a) Examine the seal.

1) Look for cracks, holes, and tears.

2) Look for indications of seal deterioration.

3) Make sure that the seal is correctly installed in the seal retainer.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 52-41-00-860-035

(1) Close and latch the door (PAGEBLOCK 52-41-00/201).

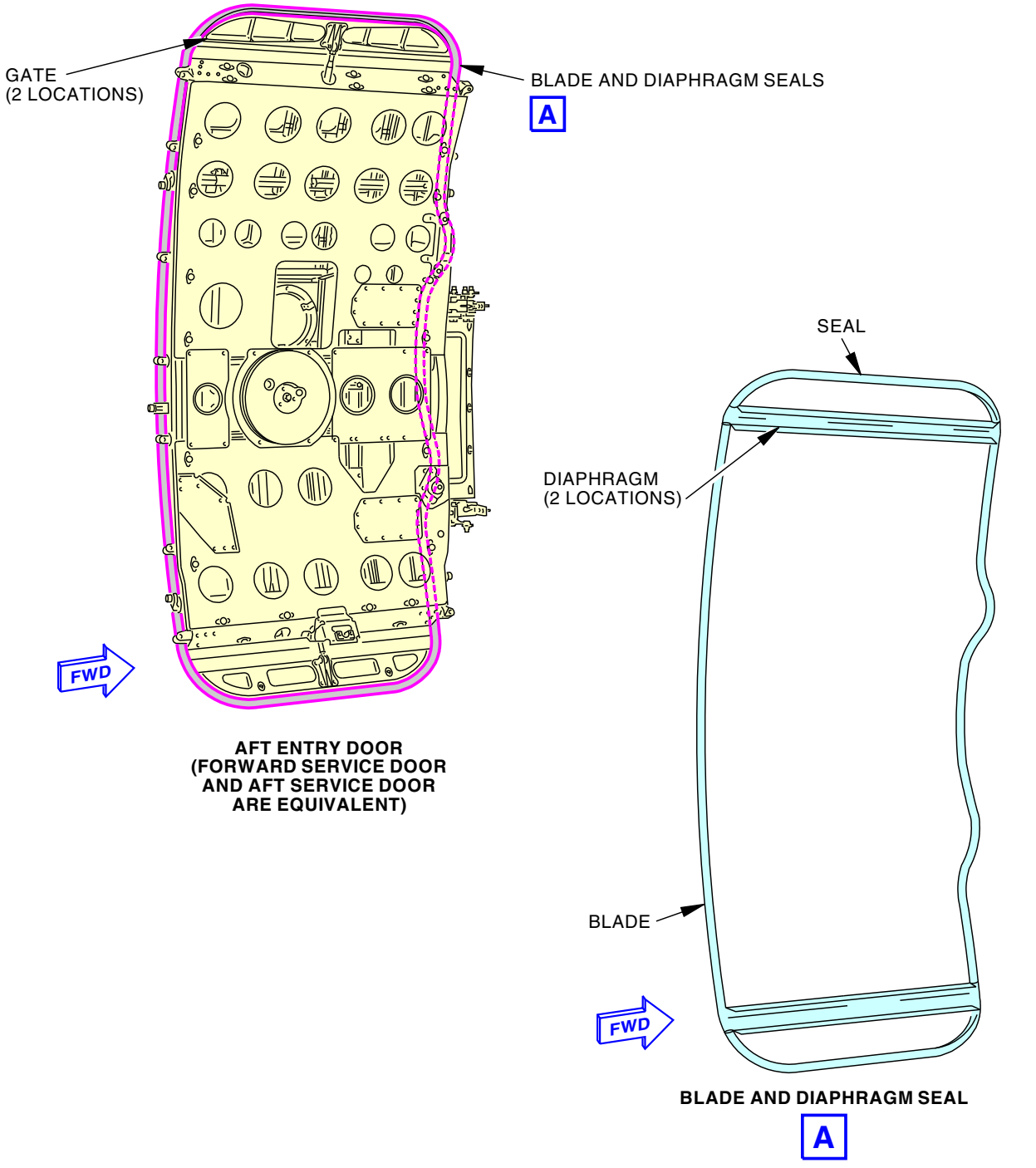
ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-41-00-940-003

(2) Remove the work platform, COM-1523.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Blade and Diaphragm Seals Inspection
Figure 602/52-41-00-990-817

ECCN 9E991 BOEING PROPRIETARY - See title page for details

GALLEY SERVICE DOORS STOP BEARING PLATES - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Galley service door stop bearing plate removal

(2) Galley service door stop bearing plate installation.

TASK 52-41-01-000-801

2. Galley Service Door Stop Bearing Plate Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the galley service door stop bearing plate.

B. References

Reference	Title
52-41-00 P/B 201	GALLEY SERVICE DOORS - 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
STD-291	Drift - Light Weight, Metal or Plastic
STD-1242	Hammer - Standard

D. Consumable Materials

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

E. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

F. Prepare for the Removal

SUBTASK 52-41-01-860-001

(1) Install the work platform, COM-1523 outboard of the door.

SUBTASK 52-41-01-860-002

(2) Open the galley service door (PAGEBLOCK 52-41-00/201).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

G. Galley Service Door Stop Bearing Plate Removal

SUBTASK 52-41-01-020-001

(1) If necessary, use a standard hammer, STD-1242 and a non-metallic light weight, metal or plastic drift, STD-291 to remove the stop bearing plate [1].

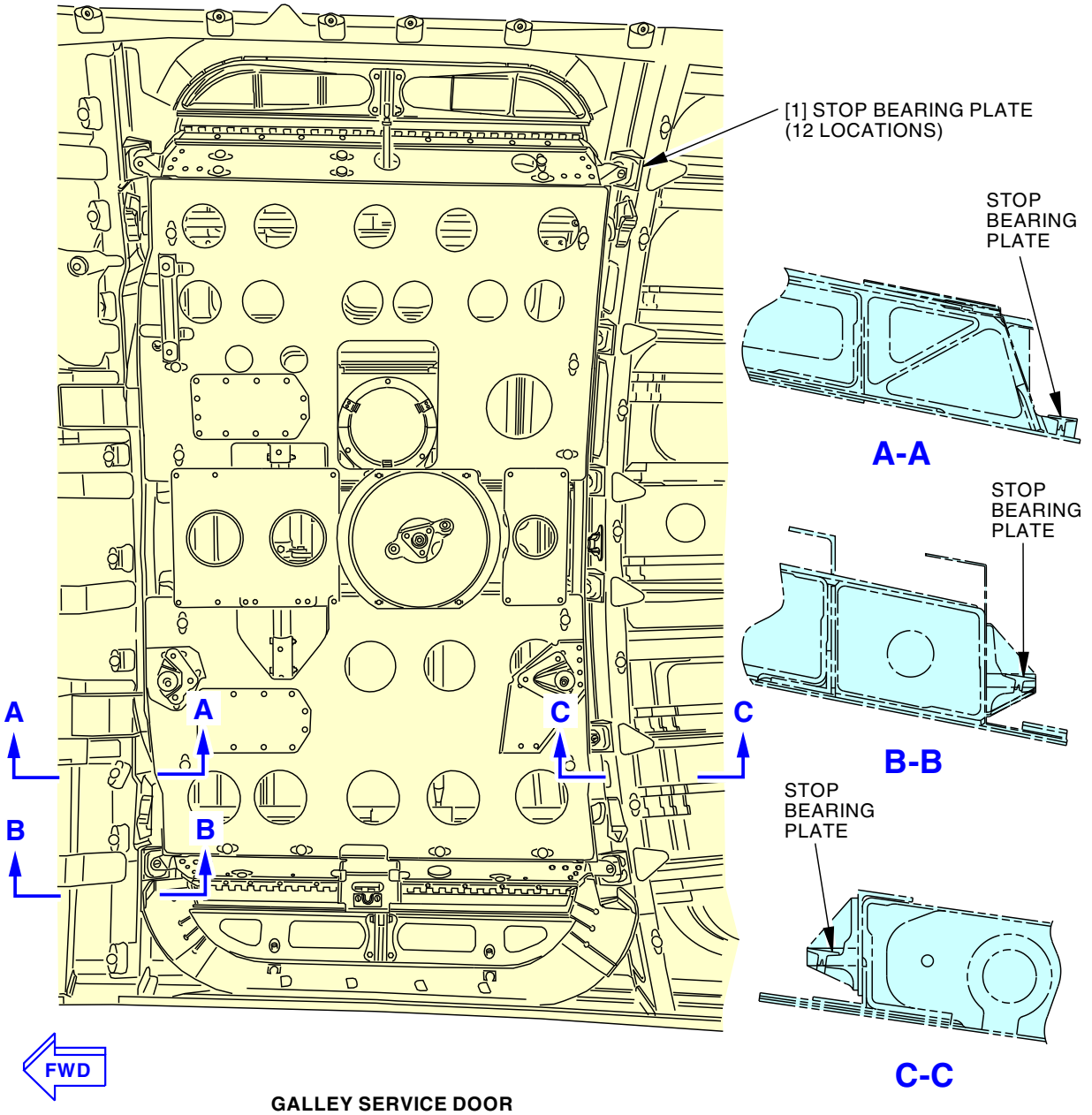
SUBTASK 52-41-01-020-002

(2) Clean the mounting hole with a clean cotton wiper, G00034 that is moist with solvent, B00083.

NOTE: Clean surfaces are necessary to make a good bond.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



GALLEY SERVICE DOOR
(EXAMPLE)

2415916 S00061539153_V2

Galley Service Door Stop Bearing Plate Installation
Figure 401/52-41-01-990-802

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-41-01-400-801

3. Galley Service Door Stop Bearing Plate Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the galley service door stop bearing plate.

B. References

Reference	Title
52-41-00 P/B 201	GALLEY SERVICE DOORS - 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
STD-1242	Hammer - Standard

D. Consumable Materials

Reference	Description	Specification
A00551	Sealant - Fuel Tank	BAC5010 Type 44 (BMS5-44, BMS5-45)
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Stop bearing plate	52-41-01-01-005	SIA ALL

F. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

G. Prepare for the installation

SUBTASK 52-41-01-420-001

(1) Do a test of the fit of the stop bearing plate [1] before the installation.

(a) Use hand pressure to install the stop bearing plate [1] into the mounting hole.

(b) Discard the stop bearing plate [1], if you can install it with hand pressure.

(c) Get a new stop bearing plate [1], if needed.

NOTE: When hand pressure is not sufficient to install the stop bearing plate [1], a new stop bearing plate [1] is not necessary.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

H. Galley Service Door Stop Bearing Plate Installation

SUBTASK 52-41-01-420-002

(1) Install the stop bearing plate [1].

(a) Apply a layer of adhesive sealant, A00551 to the stop bearing plate [1] and to the mounting hole.

(b) Install the stop bearing plate [1] with a pneumatic rivet gun with a brass set.

NOTE: If the pneumatic rivet gun is not available, use a standard hammer, STD-1242 and a non-metallic drift to install the stop bearing plate.

(c) Use a clean cotton wiper, G00034 that is moist with solvent, B00083 to remove the unwanted adhesive sealant, A00551 from the stop bearing plate [1] before it dries.

I. Put the Airplane Back to Its Usual Condition

SUBTASK 52-41-01-940-001

(1) Close the galley service door (PAGEBLOCK 52-41-00/201).

SUBTASK 52-41-01-940-002

(2) Remove the work platform, COM-1523.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

GALLEY SERVICE DOOR HINGE ARM - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the galley service door hinge arm

(2) An installation of the galley service door hinge arm.

B. This procedure is the same for the forward or aft galley service door.

TASK 52-41-11-000-801

2. Galley Service Door Hinge Arm Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the galley service door hinge arm.

B. References

Reference	Title
52-41-00-000-801	Galley Service Door 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

D. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Access Panels

Number	Name/Location
841AZ	Forward Galley Service Door - Torque Tube Access
841CZ	Forward Galley Service Door - Handle Box Access
844AZ	Aft Galley Service Door - Torque Tube Access
844CZ	Aft Galley Service Door - Handle Box Access

F. Prepare for the Removal

SUBTASK 52-41-11-860-001

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE BRACKETS OF THE FLOOR-MOUNTED ESCAPE SLIDE. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN OPERATE WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Install the work platform, COM-1523, outboard of the door.

SUBTASK 52-41-11-010-001

(2) Do this task: Galley Service Door Removal, TASK 52-41-00-000-801.

SUBTASK 52-41-11-410-001

(3) Get access to the galley service door [1] as follows:

(a) Remove the applicable torque tube access panels:

Number	Name/Location
841AZ	Forward Galley Service Door - Torque Tube Access
844AZ	Aft Galley Service Door - Torque Tube Access

(b) Remove the applicable handle box access panels:

Number	Name/Location
841CZ	Forward Galley Service Door - Handle Box Access
844CZ	Aft Galley Service Door - Handle Box Access

G. Galley Service Door Hinge Arm Removal

SUBTASK 52-41-11-020-001

(1) Remove the handle mechanism:

(a) If it is necessary, remove the interior handle [27] as follows:

1) Remove the cover [23] on the interior handle [27] to get access to the fasteners that attach the interior handle [27] to the handle mechanism.

2) Remove the cotter pins [25], nuts [24], and washers [26] that attach the interior handle [27] to the adapter [28].

3) Remove the interior handle [27].

4) Remove the bolts [31] from the adapter [28] if they are loose.

NOTE: The bolts are bonded to the adapter and it is not necessary to remove them if the bond is tight.

(b) Remove the bolts [29] and washers [30] that attach the cam cover [32] to the handle box [4].

(c) Remove the cam cover [32].

(d) Remove the lockwire, bolts [21], and washers [20] that attach the adapter [28] to the handle cam [19].

(e) Remove the adapter [28].

(f) Remove the cotter pin [33] on the nut [34] that holds the handle shaft [41].

(g) Hold the exterior handle [9] and remove the nut [34] and washer [35] that hold the handle shaft [41] to the handle cam [19].

NOTE: When you remove the nut, exterior handle, and part of the handle mechanism will be loose on the outer side of the galley service door.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(h) Remove the handle cam [19] and washer [17].

(i) From the outer side of the door, remove the exterior handle [9], shims [10], sleeve [11], handle shaft [41], and centering cam [40] as an assembly.

(j) If it is necessary, disassemble the exterior handle [9] and its components:

1) Remove the bolts [8], washers [12], and nuts [39] that attach the exterior handle [9] to the centering cam [40] through the shims [10] and sleeve [11].

2) Remove the exterior handle [9].

3) Remove the shims [10] between the exterior handle [9] and the sleeve [11].

4) Remove the centering cam [40].

5) Remove the handle shaft [41] from the sleeve [11].

(k) Remove the bolts [13] and washers [14] that go through the handle pan [38], seal plate [15], and handle housing [36].

SUBTASK 52-41-11-020-002

(2) Remove the upper and lower latch control rods [18]:

(a) Remove the bolts [58] and nuts [59] that connect the latch control rod [18] to the handle mechanism in the handle box [4].

(b) Remove the bolts [54], washers [55], and nuts [56] that connect the latch control rod [18] to the upper and lower latch torque tube [57].

(c) Remove the latch control rods [18] from the handle box [4] and galley service door [1] to make clearance for the handle box [4] removal.

SUBTASK 52-41-11-020-003

(3) Disconnect the door hinge torque tube [46]:

NOTE: The index marks across the joints can help to make the installation easier.

(a) Remove the bolts [66], washers [68], and nuts [67] that go through the upper and sleeves [42] on the door hinge torque tube [46].

(b) Move the sleeve [42] toward the center of the door hinge torque tube [46] to make clearance to remove the door hinge torque tube [46] and handle box [4] at the same time.

SUBTASK 52-41-11-020-004

(4) Remove the handle box [4] and door hinge torque tube [46]:

(a) Remove the bolts [50], fillers [51], washers [53], and nuts [52] that attach the front of the upper and lower splice angles [47] to the beams.

(b) Remove the bolts [48] and washers [49] that attach the upper and lower splice angles [47] to the beams.

(c) Remove the upper and lower splice angles [47] from the beams to get access to the door hinge torque tube [46].

(d) Remove the bolts [44] and washers [45] that attach the top and bottom of the handle box [4] to the beams.

(e) Carefully remove the handle box [4] and door hinge torque tube [46] from the door structure.

(f) If the laminated shim [43] between the top of the handle box [4] and the beam are loose, remove them.

(g) Remove the handle housing [36] from the handle box [4] and the packing [16] in the handle housing [36].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(h) Remove the seal plate [15] from the handle pan [38] and the packing [37] in the seal plate [15].

SUBTASK 52-41-11-020-005

(5) Remove the hinge arm [60] from the hinge support [63]:

NOTE: This step is necessary for each hinge arm [2].

(a) Loosen the bolts [62] and washers [61] that hold the hinge pin [65] in the hinge arm [60].

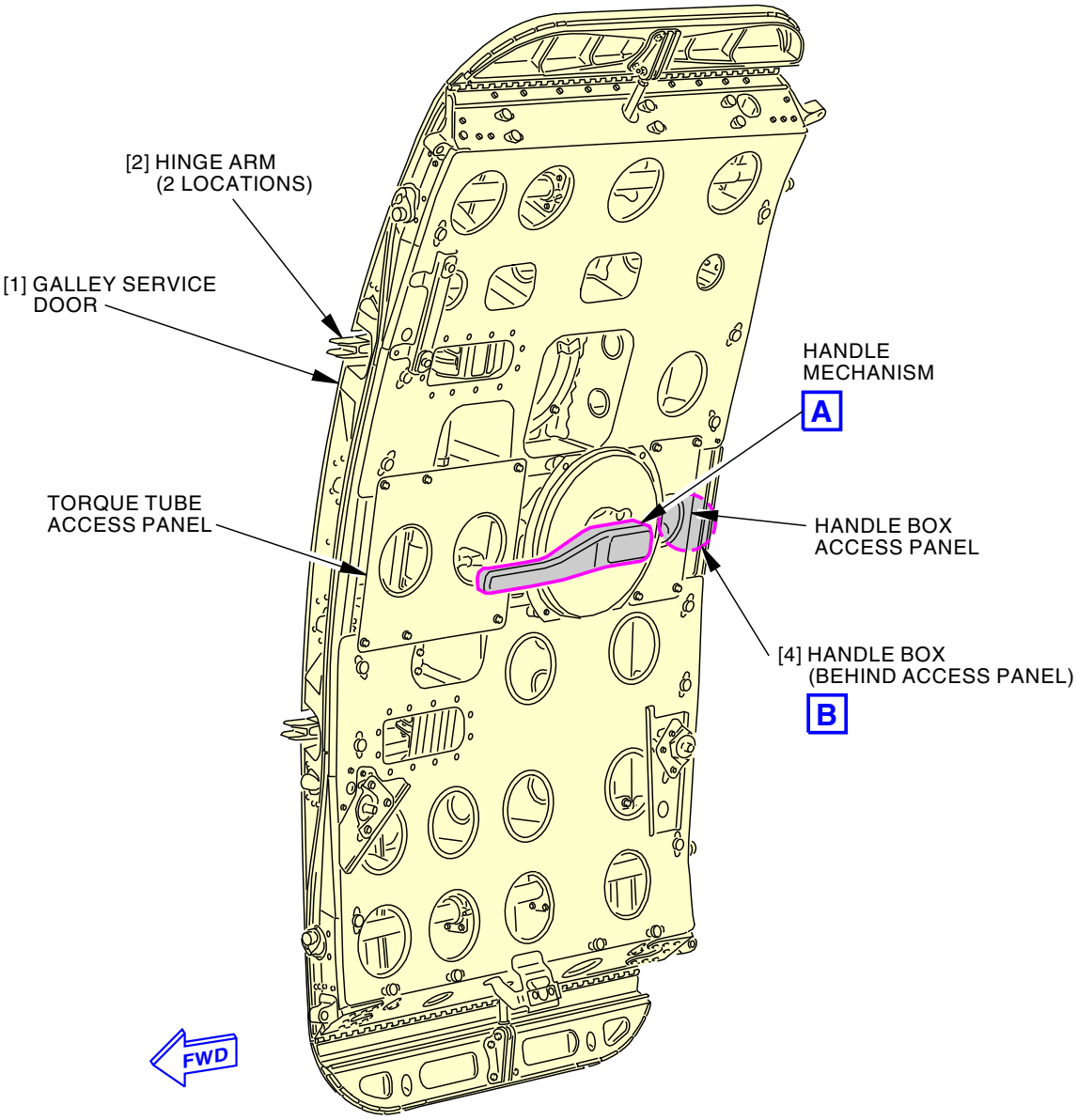
(b) Remove the hinge pin [65] from the hinge arm [60].

(c) Remove the packing [64], washer [70], and compression spring [69] from the hinge pin [65].

(d) Remove the hinge arm [60].

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

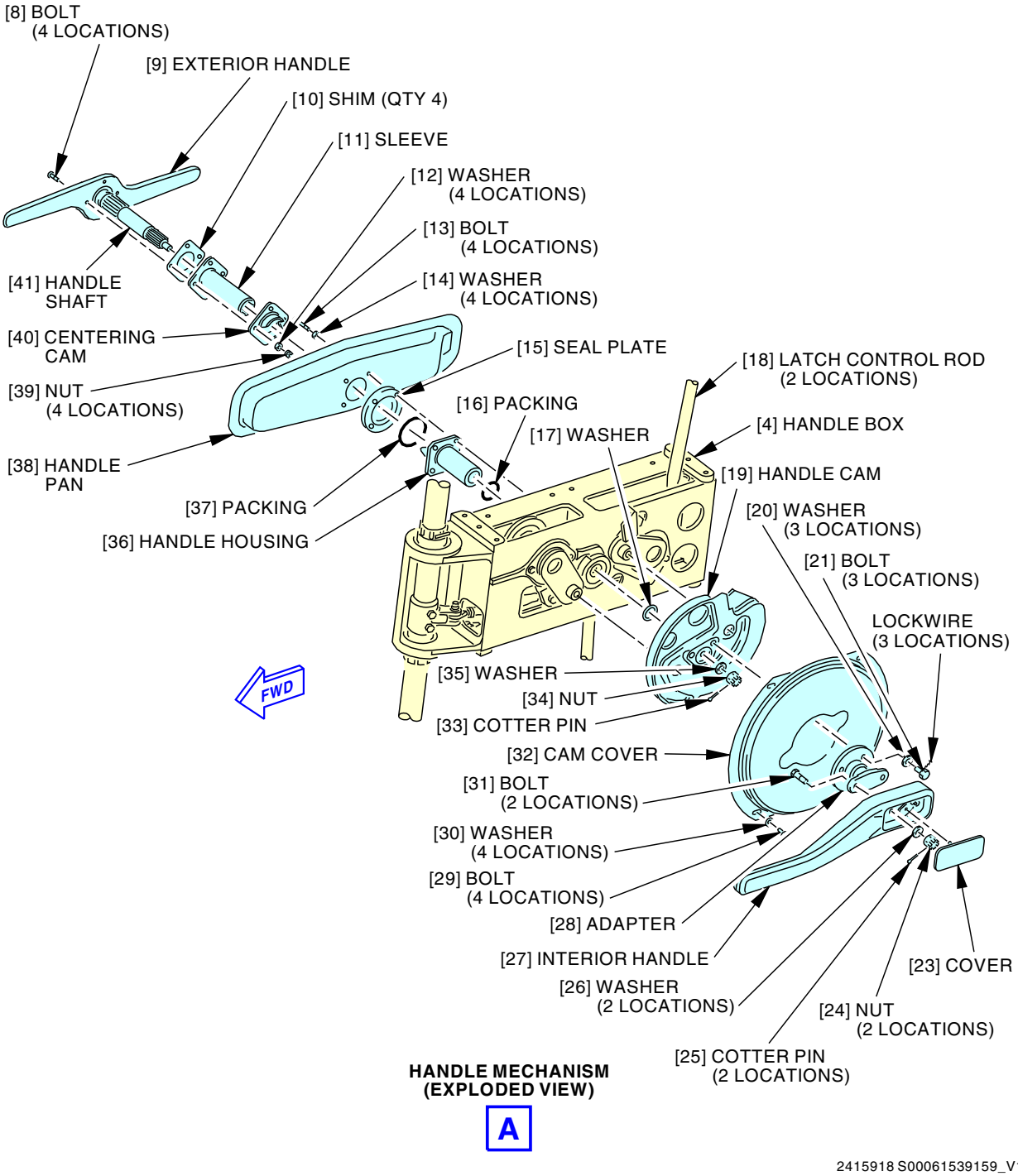


GALLEY SERVICE DOOR
(EXAMPLE)

2415917 S00061539158_V1

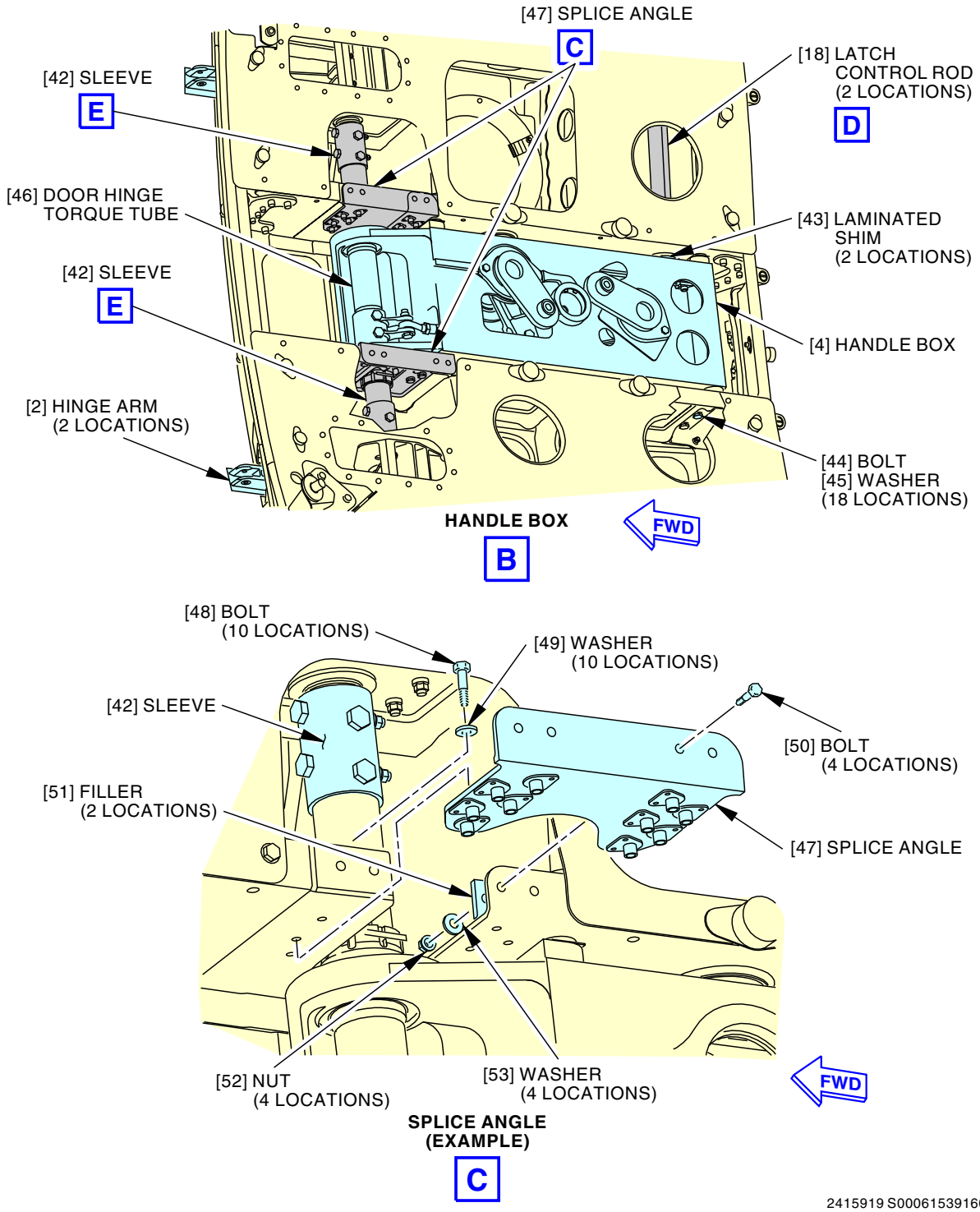
Galley Service Door Hinge Arm Installation
Figure 401/52-41-11-990-802 (Sheet 1 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



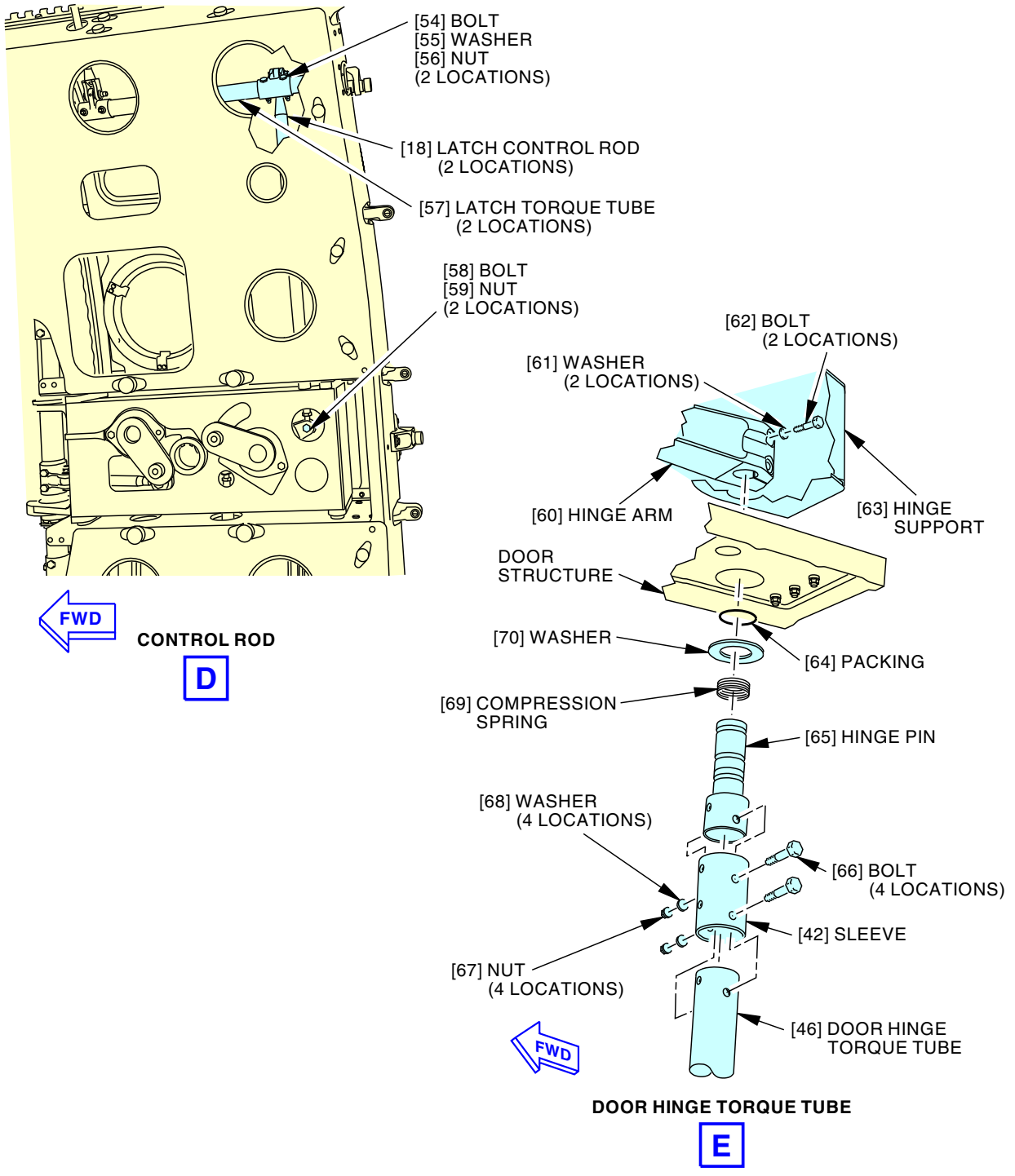
Galley Service Door Hinge Arm Installation
Figure 401/52-41-11-990-802 (Sheet 2 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Galley Service Door Hinge Arm Installation
Figure 401/52-41-11-990-802 (Sheet 3 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Galley Service Door Hinge Arm Installation
Figure 401/52-41-11-990-802 (Sheet 4 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-41-11-400-801

3. Galley Service Door Hinge Arm Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the galley service door hinge arm.

B. References

Reference	Title
52-41-00-400-801	Galley Service Door 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A00555	Adhesive - For Bonding Decorative Laminate, 2 Part, Sprayable	BMS5-127 Type II
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
D00633	Grease - Aircraft General Purpose	BMS3-33
G00440	Lockwire - MS20995C41, Corrosion Resistant Steel - 0.041 Inch (1.0414 mm) Diameter	NASM20995

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
2	Hinge arm	52-41-41-01B-015	SIA ALL
		52-41-41-02A-015	SIA ALL
16	Packing	52-41-00-10B-140	SIA ALL
		52-41-00-11A-140	SIA ALL
25	Cotter pin	52-41-31-06-080	SIA ALL
33	Cotter pin	52-41-00-05A-590	SIA ALL
37	Packing	52-41-00-03B-795	SIA ALL
		52-41-00-07A-775	SIA ALL
64	Packing	52-41-00-01B-545	SIA ALL
		52-41-00-05A-490	SIA ALL

F. Location Zones

Zone	Area
841	Forward Galley Service Door

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Zone	Area
844	Aft Galley Service Door

G. Access Panels

Number	Name/Location
841AZ	Forward Galley Service Door - Torque Tube Access
841CZ	Forward Galley Service Door - Handle Box Access
844AZ	Aft Galley Service Door - Torque Tube Access
844CZ	Aft Galley Service Door - Handle Box Access

H. Galley Service Door Hinge Arm Installation

SUBTASK 52-41-11-420-001

(1) Install the hinge arm [60] in the hinge support [63]:

NOTE: This step is necessary for each hinge arm [2].

(a) Put the hinge arm [60] in its correct position in the hinge support [63].

(b) Do a check of the packing [64] for damage or wear.

1) If it is necessary replace the packing [64].

(c) Apply grease, D00633, to the packing [64] before installation.

(d) Install the compression spring [69], washer [70], and packing [64] on the hinge pin [65].

(e) Apply grease, D00633, to the hinge pin [65] and bolts [62] before installation.

(f) Install the hinge pin [65] in the hinge arm [60].

(g) Tighten the bolts [62] and washers [61] to hold the hinge pin [65] in the hinge arm [60].

(h) Apply grease, D00633, in the opening between the hinge arm [60] and hinge pin [65] and to any openings between the hinge support [63] and the hinge pin [65].

SUBTASK 52-41-11-420-002

(2) Install the handle box [4] and door hinge torque tube [46]:

(a) Do a check of the packing [16] and packing [37] for damage or wear.

1) If it is necessary replace the packing [16] and packing [37].

(b) Apply grease, D00633, to the packing [16] and packing [37] before installation.

(c) Install the packing [37] in the seal plate [15] and the packing [16] in the handle housing [36].

(d) Put the seal plate [15] in its correct position against the handle pan [38].

(e) Put the handle housing [36] in its correct position against the seal plate [15].

(f) Apply sealant, A00247, to the mating surfaces between the bottom of the handle box [4] and beam before installation.

(g) Carefully put the handle box [4] and door hinge torque tube [46] in their correct position in the door structure.

(h) If the laminated shim [43] between the top of the handle box [4] and the beam were removed, do these steps:

1) Make sure that the maximum clearance between the top of the handle box [4] and the beam is 0.01 in. (0.25 mm).

2) Apply sealant, A00247, to the mating surfaces between the handle box [4], laminated shim [43], and beam before installation.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3) Install the laminated shim [43] between the handle box [4] and the beam.

(i) Apply sealant, A00247, to the mating surfaces of the bolts [44] and washers [45], handle box [4], and beam before installation.

(j) Install the bolts [44] and washers [45] to attach the top and bottom of the handle box [4] to the beams.

(k) Put the upper and lower splice angles [47] in their correct position on the beams.

(l) Apply compound, C00528, to the holes for the bolts [48] before installation.

(m) Install the bolts [48] and washers [49] that attach the upper and lower splice angles [47] to the beams.

(n) Install the bolts [50], fillers [51], washers [53], and nuts [52] that attach the front of the upper and splice angles [47] to the beams.

SUBTASK 52-41-11-420-003

(3) Connect the door hinge torque tube [46]:

(a) Apply grease, D00633, to the mating surfaces of the sleeves [42], hinge pins [65], and door hinge torque tube [46] before installation.

(b) Align the splines and move the sleeves [42] over the hinge pins [65].

(c) Apply compound, C00528, to the holes for the bolts [66] before installation.

(d) Install the bolts [66], washers [68], and nuts [67] that go through the upper and sleeves [42] on the door hinge torque tube [46].

(e) Tighten the nuts [67] to 30 in-lb (3.39 N·m) - 40 in-lb (4.52 N·m).

1) Make sure that the nuts [67] bottom out on the threads of the bolts [66].

2) Make sure that the maximum gap is 0.016 in. (0.41 mm) between the sleeves [42] and washers [68].

3) Install more washers [68] if necessary.

SUBTASK 52-41-11-420-004

(4) Install the upper and lower latch control rods [18]:

(a) Put the latch control rods [18] in their correct positions in the handle box [4] and door.

(b) Apply compound, C00528, to the holes for the bolts [54] and bolts [58] before installation.

(c) Install the bolts [54], washers [55], and nuts [56] to connect the latch control rods [18] to the upper and lower latch torque tube [57].

(d) Install the bolts [58] and nuts [59] to connect the latch control rods [18] to the handle mechanism in the handle box [4].

SUBTASK 52-41-11-420-005

(5) Install the handle mechanism:

(a) Install the bolts [13] and washers [14] that go through the handle pan [38], seal plate [15], and handle housing [36].

(b) Install the exterior handle [9], shims [10], sleeve [11], handle shaft [41], and centering cam [40] as an assembly.

1) Make sure that the lubrication fitting on the sleeve [11] is in its correct position.

2) If necessary, assemble these parts before installation as follows:

a) Apply grease, D00633, to the mating surfaces of the handle shaft [41] and sleeve [11] before installation.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

b) Install the handle shaft [41] in the sleeve [11].

c) Install the shims [10] between the exterior handle [9] and the sleeve [11].

d) Install the bolts [8], washers [12], and nuts [39] that attach the exterior handle [9] to the centering cam [40] through the shims [10] and sleeve [11].

(c) Hold the exterior handle [9] in its position.

(d) From the inner side of the door, apply grease, D00633, to the mating surfaces of the handle shaft [41] and handle cam [19] before installation.

(e) Install the handle cam [19].

(f) Install the washer [35], nut [34], and new cotter pin [33] to hold the handle shaft [41] to the handle cam [19].

(g) Put the adapter [28] in its correct position against the handle cam [19].

(h) Install the bolts [21], washers [20], and MS20995C41 lockwire, G00440, to attach the adapter [28] to the handle cam [19].

(i) Put the cam cover [32] in its correct position against the handle box [4].

(j) Install the bolts [29] and washers [30] that attach the cam cover [32] to the handle box [4].

(k) If it is necessary, install the interior handle [27] as follows:

NOTE: The interior handle must be removed to install the door lining.

1) Install the bolts [31] in the adapter [28] with adhesive, A00555, if they are loose.

2) Put the interior handle [27] in its correct position over the bolts [31] in the adapter [28].

3) Install the washers [26], nuts [24], and new cotter pins [25] that attach the interior handle [27] to the adapter [28].

4) Install the cover [23] on the interior handle [27].

I. Put the Airplane Back to Its Usual Condition

SUBTASK 52-41-11-410-002

(1) Install the applicable handle box access panels:

Number	Name/Location
841CZ	Forward Galley Service Door - Handle Box Access
844CZ	Aft Galley Service Door - Handle Box Access

SUBTASK 52-41-11-410-003

(2) Install the applicable torque tube access panels:

Number	Name/Location
841AZ	Forward Galley Service Door - Torque Tube Access
844AZ	Aft Galley Service Door - Torque Tube Access

SUBTASK 52-41-11-420-006

(3) Do this task: Galley Service Door Installation, TASK 52-41-00-400-801.

SUBTASK 52-41-11-480-001

(4) Remove the work platform, COM-1523, from the door.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

GALLEY SERVICE DOOR GUIDE ARM AND ROLLER - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Galley service door guide arm and roller removal

(2) Galley service door guide arm and roller installation.

B. This procedure is the same for the forward or aft galley service door.

TASK 52-41-21-000-801

2. Galley Service Door Guide Arm and Roller Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the galley service door guide arm and roller.

B. References

Reference	Title
52-41-31-000-801	Galley Service Door Lining 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

D. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Access Panels

Number	Name/Location
841FZ	Forward Galley Service Door - Torque Tube Access
844FZ	Aft Galley Service Door - Torque Tube Access

F. Prepare for the Removal

SUBTASK 52-41-21-860-001

(1) Make sure that the galley service door [2] is safe as follows:

(a) Make sure that the galley service door [2] is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(c) Make sure that the work platform, COM-1523 is installed outboard of the galley service door [2].

SUBTASK 52-41-21-010-001

(2) Get access to the galley service door [2] as follows:

(a) Do this task: Galley Service Door Lining Removal, TASK 52-41-31-000-801.

(b) Make sure that the galley service door [2] is fully open.

G. Galley Service Door Guide Arm and Roller Removal

SUBTASK 52-41-21-020-001

(1) Disconnect the guide arm [1] and roller [14] from the lower guide plate [12] and upper guide plate [13]:

(a) AIRPLANES WITH LOCKING GUIDE ARM;

Remove the release button [16]:

1) Remove the bolts [6], washers [11], and nuts [10] that attach the release button [16] to the upper guide plate [13].

2) Remove the release button [16] from the upper guide plate [13].

(b) Remove the bushing [15] from the upper guide plate [13].

(c) Insert a tool in the drain hole in the lower guide plate [12] and push the roller [14] through the guide arm [1] and out the hole in the upper guide plate [13].

SUBTASK 52-41-21-020-002

(2) Disconnect the guide arm [1] from the torque tube upper link [8]:

(a) Remove the clip [9] from the pin [7] that attaches the guide arm [1] to the torque tube upper link [8].

(b) Push the pin [7] up through the guide arm [1] and fuselage hinge torque tube upper link [8].

(c) Disconnect the guide arm [1] from the torque tube upper link [8].

SUBTASK 52-41-21-020-003

(3) Disconnect the guide arm [1] from the galley service door [2]:

(a) Remove the applicable upper access panels:

Number	Name/Location
841FZ	Forward Galley Service Door - Torque Tube Access
844FZ	Aft Galley Service Door - Torque Tube Access

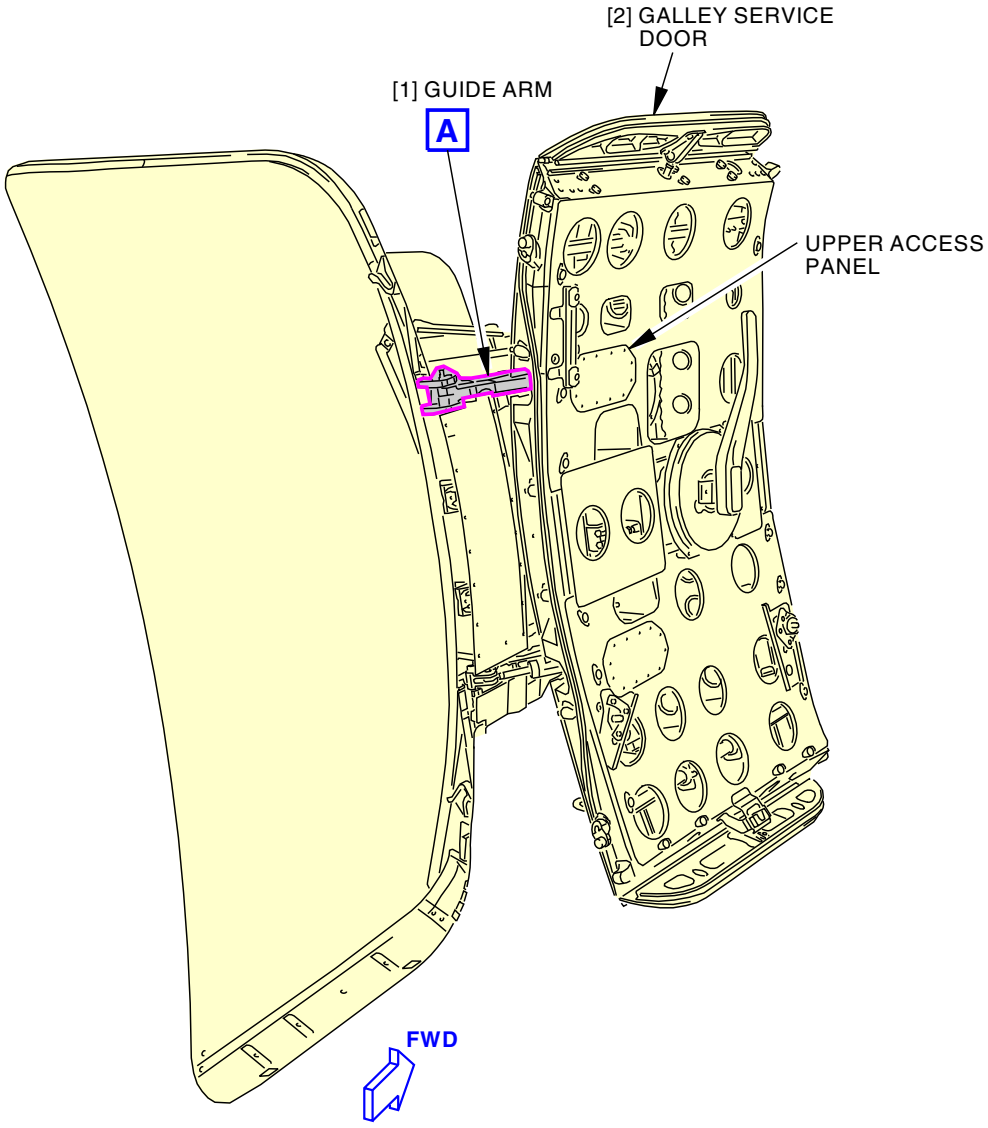
(b) Remove the filler [19] to get access to the fastener that attaches the guide arm [1] to the fitting [18].

(c) Remove the bolt [20], washer [21], and nut [17] that attach the guide arm [1] to the fitting [18].

(d) Remove the guide arm [1] from the galley service door [2].

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

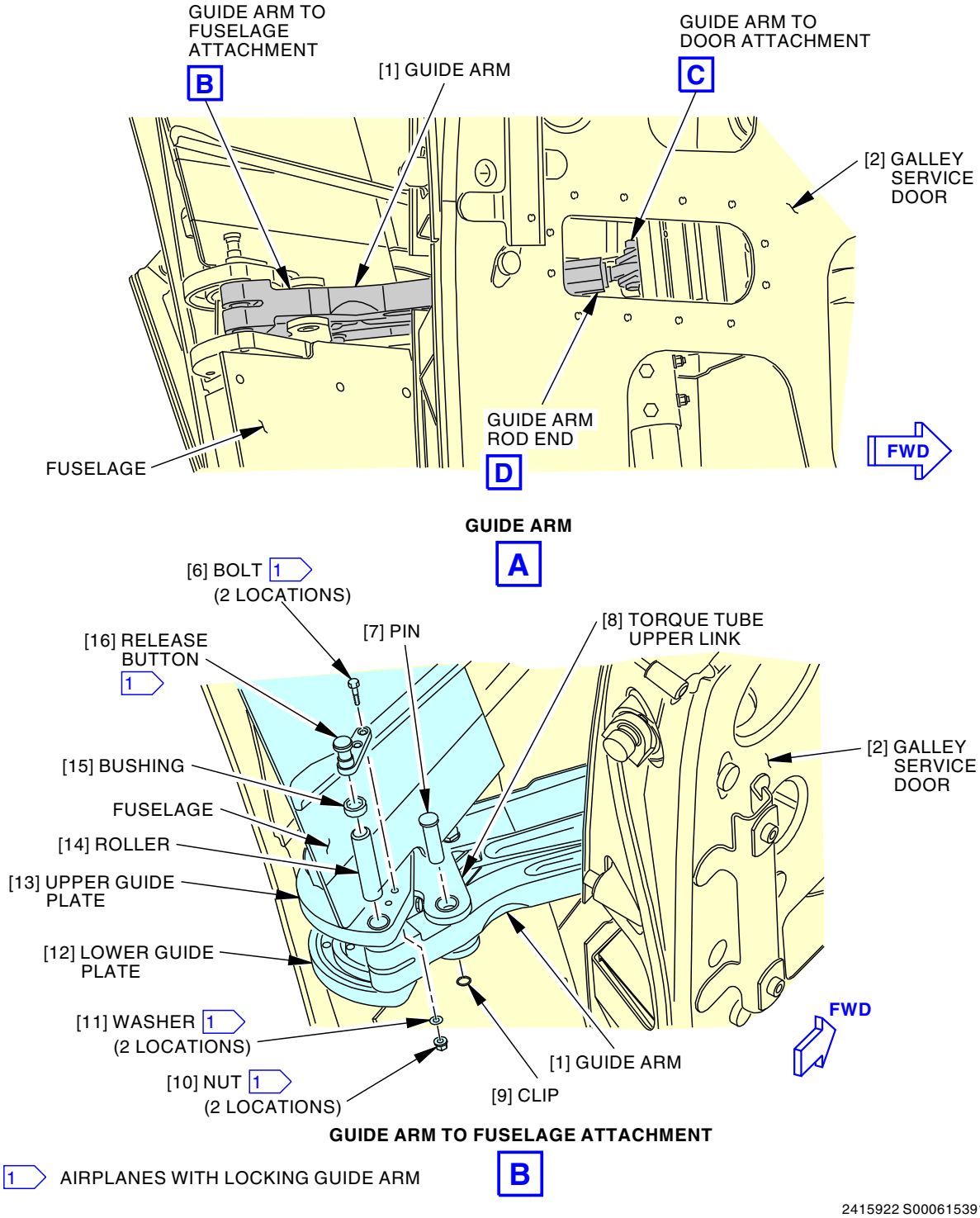


GALLEY SERVICE DOOR (EXAMPLE)

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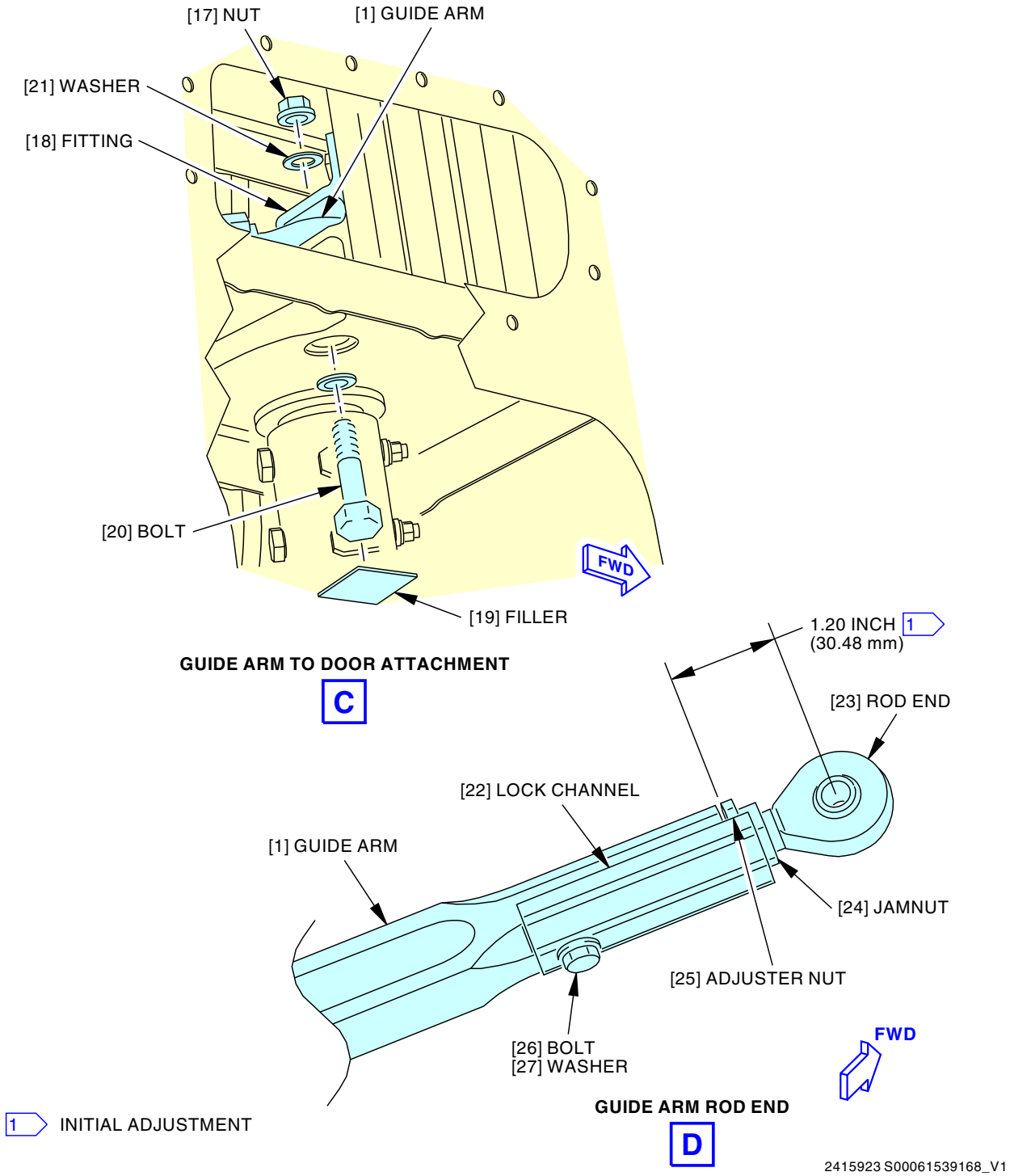
Galley Service Door Guide Arm and Roller Installation
Figure 401/52-41-21-990-802 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Galley Service Door Guide Arm and Roller Installation
Figure 401/52-41-21-990-802 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Galley Service Door Guide Arm and Roller Installation
Figure 401/52-41-21-990-802 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-41-21-400-801

3. Galley Service Door Guide Arm and Roller Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the galley service door guide arm and roller.

B. References

Reference	Title
52-41-00-820-801	Galley Service Door Adjustment (P/B 501)
52-41-31-400-801	Galley Service Door Lining Installation (P/B 401)

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	Guide arm	52-41-11-03-120	SIA ALL
		52-41-11-07-125	SIA ALL
14	Roller	52-41-11-03-115	SIA ALL
		52-41-11-07-120	SIA ALL

E. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

F. Access Panels

Number	Name/Location
841FZ	Forward Galley Service Door - Torque Tube Access
844FZ	Aft Galley Service Door - Torque Tube Access

G. Galley Service Door Guide Arm and Roller Installation

SUBTASK 52-41-21-820-001

(1) Do a preliminary adjustment of the guide arm [1] as follows:

(a) Make sure that the distance along the guide arm [1] from the rod end [23] centerline to the adjuster nut [25] is as shown.

(b) If necessary, use the adjuster nut [25] to change the length of the guide arm [1] as follows:

NOTE: This is an initial adjustment for a new guide arm [1].

1) Remove the bolt [26] and washer [27] on the lock channel [22].
2) Remove the lock channel [22].
3) Loosen the jamnut [24].
4) Change the length of the guide arm rod end [23] with the adjuster nut [25].
5) Make sure that the adjuster nut [25] will align with the lock channel [22].
6) Tighten the jamnut [24].
7) Put the lock channel [22] in its correct position on the guide arm [1].

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8) Install the bolt [26] and washer [27] to hold the lock channel [22] in position.

SUBTASK 52-41-21-020-004

(2) Connect the guide arm [1] to the galley service door [2]:

(a) Put the rod end [23] of the guide arm [1] in position in the fitting [18].

1) Make sure that the lubrication fitting on the rod end [23] points inboard.

(b) Install the bolt [20], washer [21], and nut [17] that attach the rod end [23] of the guide arm [1] to the fitting [18].

(c) Install the filler [19] with sealant, A00247 to cover the guide arm [1] attachment.

(d) Install the applicable upper access panels:

Number	Name/Location
841FZ	Forward Galley Service Door - Torque Tube Access
844FZ	Aft Galley Service Door - Torque Tube Access

SUBTASK 52-41-21-420-001

(3) Connect the guide arm [1] to the fuselage hinge torque tube upper link [8]:

(a) Put the guide arm [1] in position in the fuselage hinge torque tube upper link [8].

(b) Install the pin [7] to attach the guide arm [1] to the torque tube upper link [8].

(c) Install the clip [9] on the end of the pin [7].

SUBTASK 52-41-21-420-002

(4) Connect the guide arm [1] and roller [14] to the lower guide plate [12] and upper guide plate [13]:

(a) Align the hole in the end of the guide arm [1] with the hole in the upper guide plate [13].

(b) Put the roller [14] through the hole in the upper guide plate [13] and into the end of the guide arm [1].

NOTE: Make sure that the spring loaded pin in the roller [14] is pointing up.

(c) Install the bushing [15] in the upper guide plate [13].

(d) AIRPLANES WITH LOCKING GUIDE ARM;

Install the release button [16]:

1) Put the release button [16] in position on the upper guide plate [13].

2) Install the bolts [6], washers [11], and nuts [10] that attach the release button [16] to the upper guide plate [13].

SUBTASK 52-41-21-820-002

(5) Adjust the guide arm [1] (TASK 52-41-00-820-801).

NOTE: Do only the guide arm adjustment.

SUBTASK 52-41-21-410-001

(6) Do this task: Galley Service Door Lining Installation, TASK 52-41-31-400-801.

SUBTASK 52-41-21-710-001

(7) Do a test on the galley service door [2] as follows:

(a) Open and close the door.

(b) Make sure that the door opens easily and smoothly.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

GALLEY SERVICE DOOR LINING - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Galley service door lining removal

(2) Galley service door lining installation.

B. This procedure is the same for each galley service door.

TASK 52-41-31-000-801

2. Galley Service Door Lining Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the galley service door lining.

B. References

Reference	Title
25-66-01-000-801	Escape Slide Pack and Cover 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-5216	Wrench - Spanner, Main Entry Door Assist Handle Part #: F70336-4 Supplier: 81205 Opt Part #: F70336-1 Supplier: 81205

D. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Prepare for the Removal

SUBTASK 52-41-31-860-001

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched.

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Make sure that the work platform, COM-1523 is installed outboard of the door.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-41-31-010-001

(2) Get access to the door as follows:

(a) Make sure that the door is closed and latched.

(b) Do this task: Escape Slide Pack and Cover Removal, TASK 25-66-01-000-801.

(c) Fully open the door.

F. Galley Service Door Lining Removal

SUBTASK 52-41-31-020-001

(1) Remove the interior handle [3] from the door:

(a) Remove the cover [11] on the interior handle [3] to get access to the fasteners that attach the interior handle [3] to the hub [5].

(b) Remove the new cotter pins [9], nuts [10], and washers [8] that attach the interior handle [3] to the hub [5].

(c) Remove the interior handle [3].

(d) Remove the bolts [4] from the hub [5] if they are loose.

NOTE: The bolts [4] are bonded to the hub [5] and it is not necessary to remove them if the bond is tight.

SUBTASK 52-41-31-020-002

(2) Remove the cover plate [12] from the cutout on the door lining [1].

SUBTASK 52-41-31-020-003

(3) Remove the assist handle [2] from the door (detail B).

(a) Loosen the handle nuts [14] with the entry door assist handle wrench, SPL-5216 that attach the assist handle [2] to the door.

NOTE: Make sure that the loosen direction is correct. The loosen direction is clockwise when you face the door lining surface.

(b) Remove the assist handle [2] from the door.

(c) Hold the handle nuts [14] and remove the bolts [16], collars [15], and washers [13] that attach the handle nuts [14] to the door.

(d) Remove the handle nuts [14] from the door.

SUBTASK 52-41-31-020-004

(4) Disconnect the door lining [1] from the door:

(a) Remove the nuts [17] that attach the upper part of the door lining [1] to the door.

(b) Remove the nuts [20] that attach the lower part of the door lining [1] to the door.

(c) Remove the screws [19] that attach the lower part of the door lining [1] to the door.

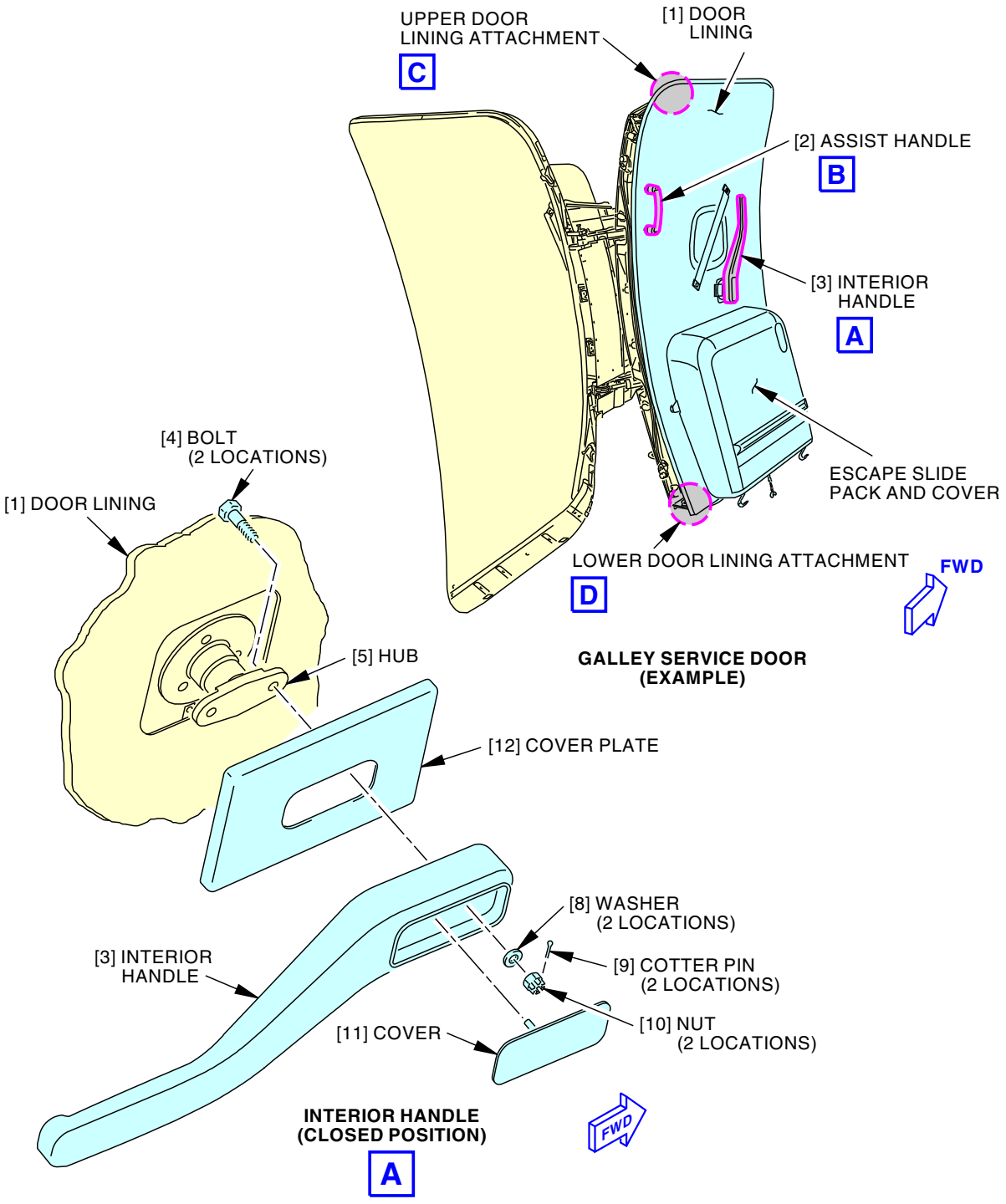
(d) Hold the door lining [1].

(e) Remove the screws [18] that attach the forward and aft edges of the door lining [1] to the door.

(f) Carefully lift the door lining [1] and remove it from the door.

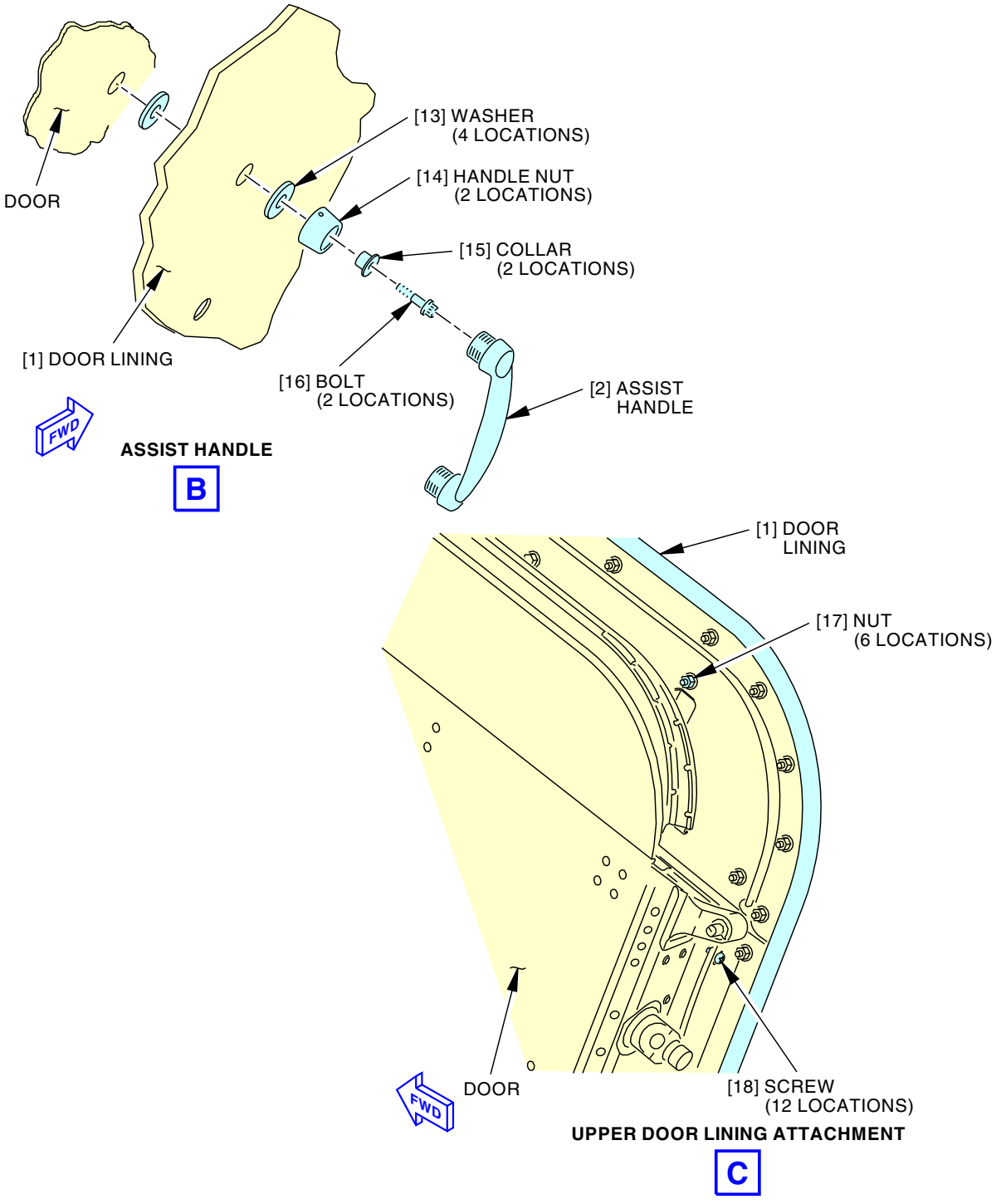
END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



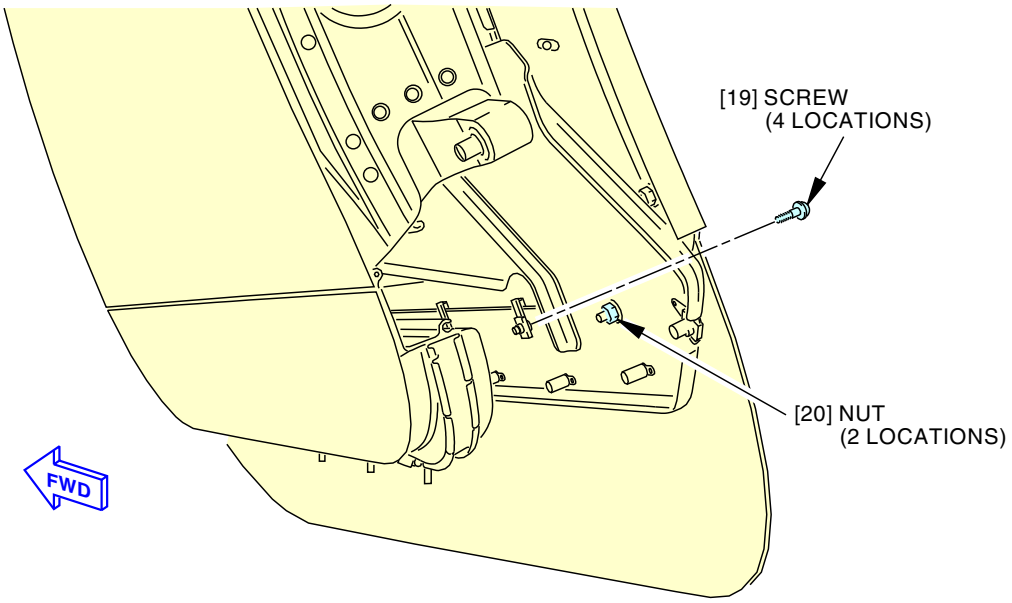
Galley Service Door Lining Installation
Figure 401/52-41-31-990-802 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Galley Service Door Lining Installation
Figure 401/52-41-31-990-802 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



LOWER DOOR LINING ATTACHMENT

D

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Galley Service Door Lining Installation
Figure 401/52-41-31-990-802 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-41-31-400-801

3. Galley Service Door Lining Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the galley service door guide lining.

B. References

Reference	Title
25-66-01-400-801	Escape Slide Pack and Cover 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497
SPL-5216	Wrench - Spanner, Main Entry Door Assist Handle Part #: F70336-4 Supplier: 81205 Opt Part #: F70336-1 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
A00555	Adhesive - For Bonding Decorative Laminate, 2 Part, Sprayable	BMS5-127 Type II

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Door lining	52-41-31-06-250	SIA ALL
		52-41-31-06-455	SIA ALL
9	Cotter pin	52-41-31-06-080	SIA ALL

F. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

G. Galley Service Door Lining Installation

SUBTASK 52-41-31-420-001

(1) Install the door lining [1] on the door:

(a) Carefully hold the door lining [1] and put it in position on the door.

(b) Install the screws [18] that attach the forward and aft edges of the door lining [1] to the door.

(c) Install the nuts [17] that attach the upper part of the door lining [1] to the door.

(d) Install the nuts [20] that attach the lower part of the door lining [1] to the door.

(e) Install the screws [19] that attach the lower part of the door lining [1] to the door.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-41-31-020-005

(2) Install the assist handle [2] (detail B).

(a) Put the handle nuts [14] in position on the door lining [1].

(b) Install the bolts [16], collars [15], and washers [13] that attach the handle nuts [14] to the door.

(c) Put the assist handle [2] in position against the handle nuts [14].

(d) Tighten the handle nuts [14] with the entry door assist handle wrench, SPL-5216 that attach the assist handle [2] to the door.

SUBTASK 52-41-31-410-001

(3) Install the cover plate [12] on the door:

(a) Put the cover plate [12] into the cutout in the door lining [1].

SUBTASK 52-41-31-020-006

(4) Install the interior handle [3]:

(a) Install the bolts [4] in the hub [5] with adhesive, A00555 if they are loose.

(b) Put the interior handle [3] in position over the bolts [4] in the hub [5].

(c) Install the washers [8], nuts [10], and new cotter pins [9] that attach the interior handle [3] to the hub [5].

(d) Install the cover [11] on the interior handle [3].

H. Put the Airplane Back to Its Usual Condition

SUBTASK 52-41-31-410-002

(1) Do this task: Escape Slide Pack and Cover Installation, TASK 25-66-01-400-801.

SUBTASK 52-41-31-080-001

(2) Remove the work platform, COM-1523.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

GALLEY SERVICE DOOR FUSELAGE HINGE TORQUE TUBE - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Galley service door fuselage hinge torque tube removal

(2) Galley service door fuselage hinge torque tube installation.

B. This procedure is the same for the forward or aft galley service door.

C. The galley service door fuselage hinge torque tube is referred to as the torque tube in this procedure.

TASK 52-41-41-000-801

2. Galley Service Door Fuselage Hinge Torque Tube Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the galley service door fuselage hinge torque tube.

B. References

Reference	Title
52-41-00-000-801	Galley Service Door 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

D. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Access Panels

Number	Name/Location
222AR	Forward Galley Service Door Hinge and Torque Tube Access Panel
242AR	Aft Galley Service Door Hinge and Torque Tube Access Panel

F. Prepare for the Removal

SUBTASK 52-41-41-860-001

(1) Make sure that the galley service door [1] is safe as follows:

(a) Make sure that the galley service door [1] is closed and latched.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Install the work platform, COM-1523 outboard of the galley service door [1].

SUBTASK 52-41-41-010-001

(2) Do this task: Galley Service Door Removal, TASK 52-41-00-000-801.

SUBTASK 52-41-41-010-002

(3) Remove the applicable access panels to get access to the torque tubes [5] and [6]:

Number	Name/Location
222AR	Forward Galley Service Door Hinge and Torque Tube Access Panel
242AR	Aft Galley Service Door Hinge and Torque Tube Access Panel

G. Galley Service Door Fuselage Hinge Torque Tube Removal

SUBTASK 52-41-41-020-001

(1) Disconnect the torque tube [5] and torque tube [6] from the upper hinge pin [10] and lower hinge pin [11]:

NOTE: You can make index marks across the joints to help make the installation easier.

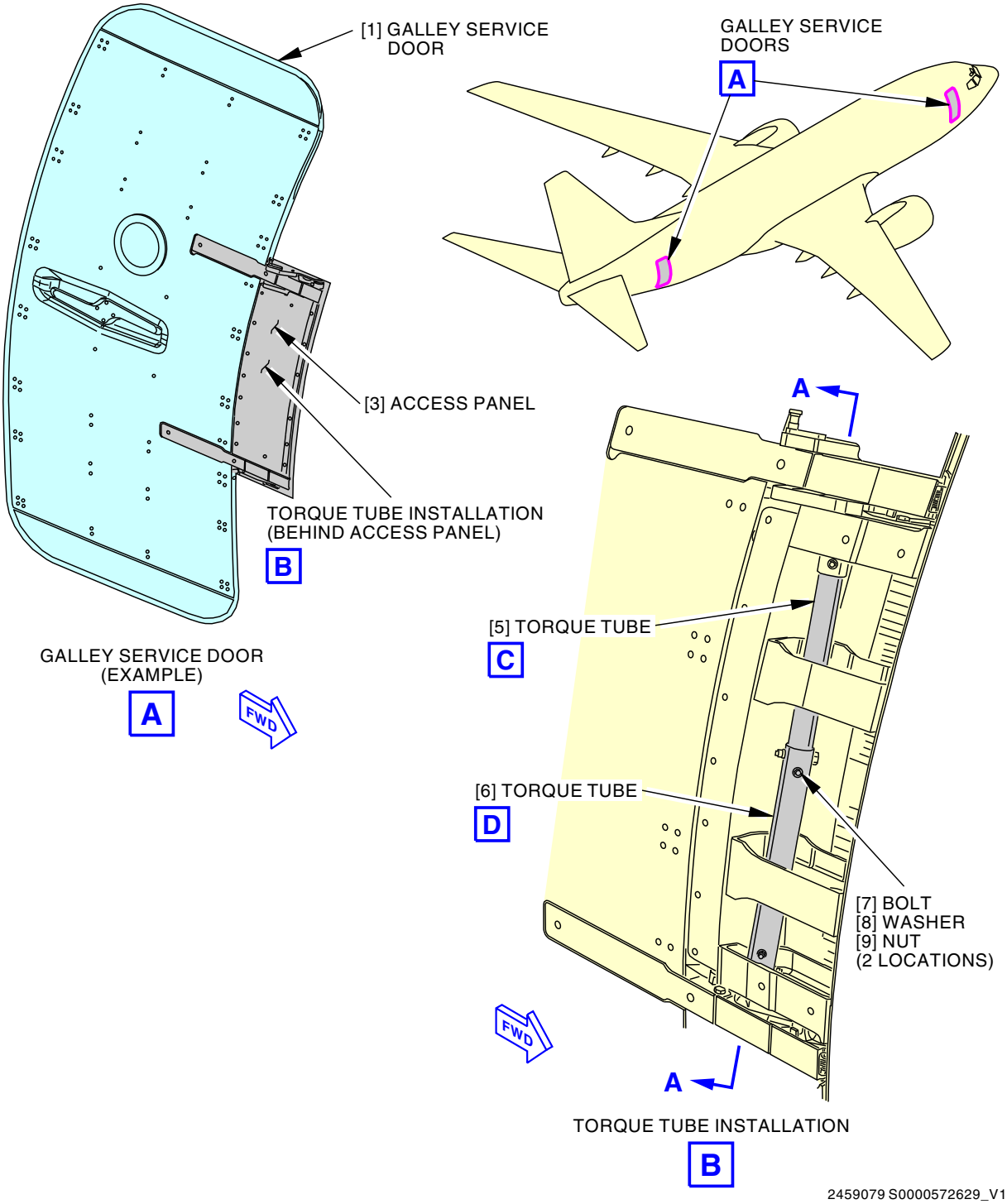
(a) Remove the bolts [7], washers [8], and nuts [9] that attach the torque tube [5] to the upper hinge pin [10].

(b) Remove the bolts [7], washers [8], and nuts [9] that attach the torque tube [6] to the lower hinge pin [11].

(c) If it is necessary, remove the lower hinge pin [11].

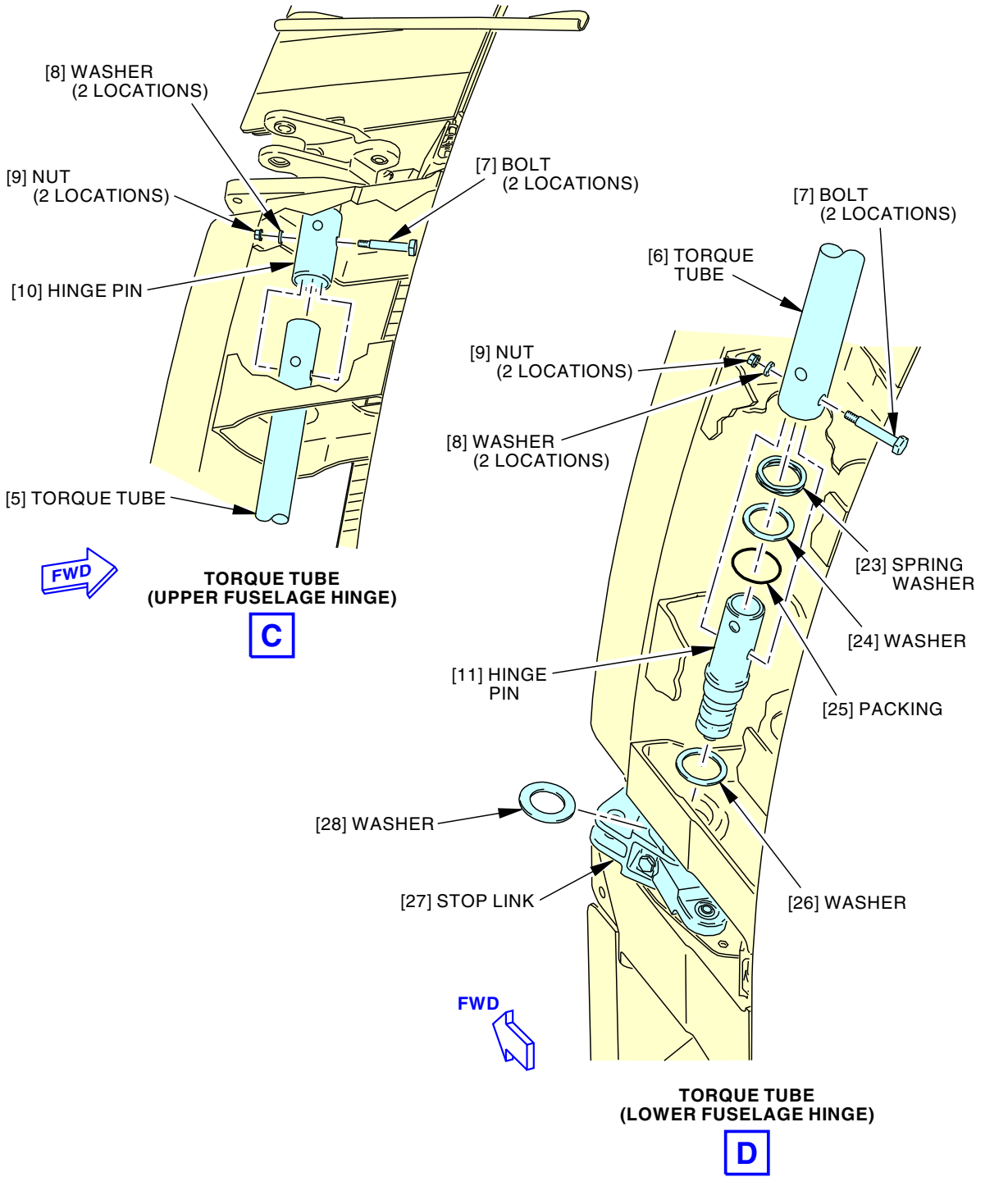
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



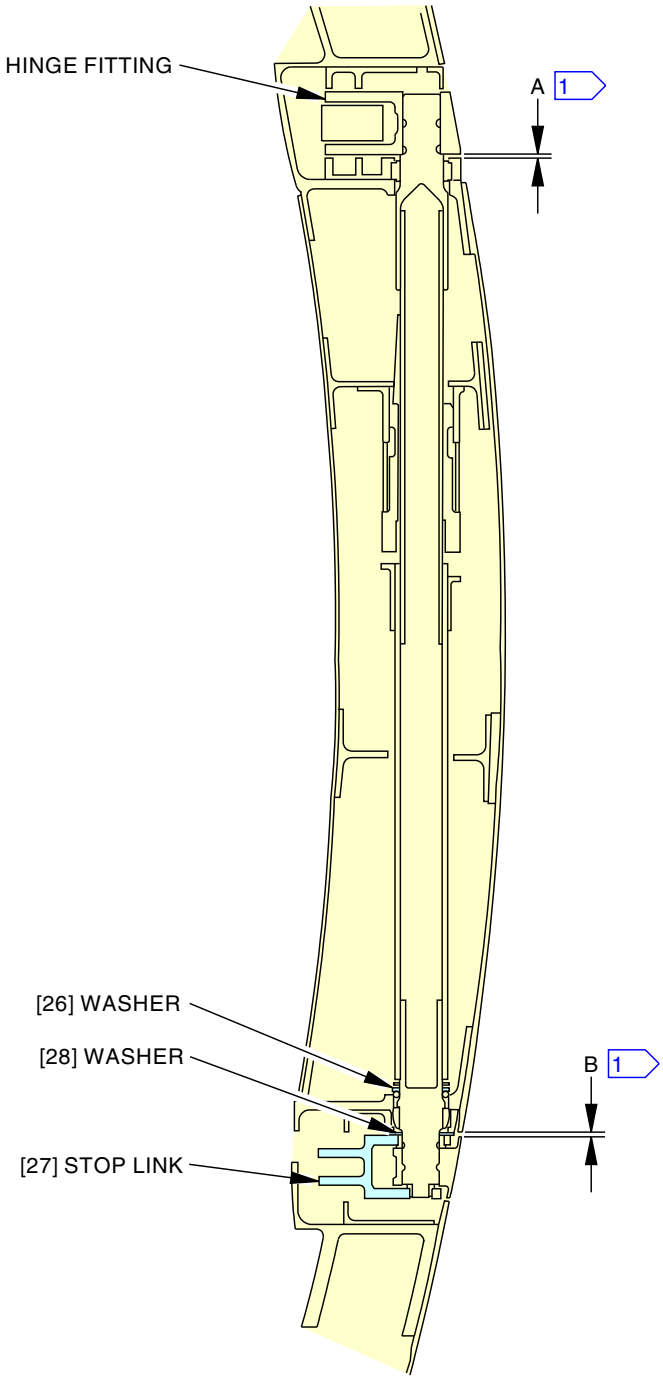
Galley Service Door Fuselage Hinge Torque Tube Installation
Figure 401/52-41-41-990-802 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Galley Service Door Fuselage Hinge Torque Tube Installation
Figure 401/52-41-41-990-802 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



1 CLEARANCES A AND B MUST BE EQUAL TO ±0.03 INCH (±0.762 mm)

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Galley Service Door Fuselage Hinge Torque Tube Installation
Figure 401/52-41-41-990-802 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-41-41-400-801

3. Galley Service Door Fuselage Hinge Torque Tube Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the galley service door fuselage hinge torque tube.

B. References

Reference	Title
52-41-00-400-801	Galley Service Door 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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

D. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
5	Torque tube	52-41-41-03-110	SIA ALL
		52-41-41-04-090	SIA ALL
6	Torque tube	52-41-41-03-115	SIA ALL
		52-41-41-04-085	SIA ALL
25	Packing	52-41-11-03-280	SIA ALL
		52-41-11-07-245	SIA ALL

F. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

G. Access Panels

Number	Name/Location
222AR	Forward Galley Service Door Hinge and Torque Tube Access Panel
242AR	Aft Galley Service Door Hinge and Torque Tube Access Panel

H. Galley Service Door Fuselage Hinge Torque Tube Installation

SUBTASK 52-41-41-420-001

(1) Connect the torque tube [5] and torque tube [6]:

(a) Apply grease, D00633 to the mating surfaces of the torque tube [5] and torque tube [6].

(b) Put the upper torque tube [5] into the lower torque tube [6].

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(c) Push the torque tube [5] and torque tube [6] together a sufficient distance to fit into the fuselage frame.

SUBTASK 52-41-41-420-002

(2) If the lower hinge pin [11] was removed, do these steps:

(a) Apply grease, D00633 to the mating surfaces of the hinge pin [11] and stop link [27].

(b) Put the stop link [27] is in its correct position.

(c) Put the washer [28] on the top of the stop link [27].

(d) Install the washer [26] over the small end of the hinge pin [11].

(e) Put the lower hinge pin [11] through the fuselage frame and stop link [27].

(f) Install a new packing [25], nylon washer [24], and spring washer [23] over the hinge pin [11].

SUBTASK 52-41-41-420-003

(3) Connect the torque tube [5] and torque tube [6] to the upper hinge pin [10] and lower hinge pin [11]:

(a) Align the bolt holes in the ends of the torque tube [5] and torque tube [6] with the bolt holes in the upper hinge pin [10] and lower hinge pin [11].

(b) Install the bolts [7], washers [8], and nuts [9] that attach the torque tube [5] to the upper hinge pin [10].

(c) Install the bolts [7], washers [8], and nuts [9] that attach the torque tube [6] to the lower hinge pin [11].

(d) If it is necessary, add washers [26] to get the correct clearance.

I. Put the Airplane Back to Its Usual Condition

SUBTASK 52-41-41-410-001

(1) Install the applicable access panels:

Number	Name/Location
222AR	Forward Galley Service Door Hinge and Torque Tube Access Panel
242AR	Aft Galley Service Door Hinge and Torque Tube Access Panel

SUBTASK 52-41-41-420-004

(2) Do this task: Galley Service Door Installation, TASK 52-41-00-400-801.

SUBTASK 52-41-41-080-001

(3) Remove the work platform, COM-1523.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

GALLEY SERVICE DOOR SNUBBER/BUMPER - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Galley service door snubber removal

(2) Galley service door snubber installation

(3) Galley service door bumper removal

(4) Galley service door bumper installation.

B. The galley service door will be call the door in this procedure.

TASK 52-41-51-000-801

2. Galley Service Door Snubber Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the galley service door snubber.

B. References

Reference	Title
52-41-31-000-801	Galley Service Door Lining 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
COM-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

D. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Access Panels

Number	Name/Location
841GZ	Forward Galley Service Door - Torque Tube Access
844GZ	Aft Galley Service Door - Torque Tube Access

F. Prepare for the Removal

SUBTASK 52-41-51-860-001

(1) Make sure that the door is safe as follows:

(a) Make sure that the door is closed and latched.

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WARNING MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR AND CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

(c) Install the work platform, COM-1523 outboard of the door.

(d) Put the galley service door in the full open position.

SUBTASK 52-41-51-010-001

(2) If necessary, do this task: Galley Service Door Lining Removal, TASK 52-41-31-000-801.

SUBTASK 52-41-51-010-002

(3) Remove the access panels:

Number	Name/Location
841GZ	Forward Galley Service Door - Torque Tube Access
844GZ	Aft Galley Service Door - Torque Tube Access

G. Galley Service Door Snubber Removal

SUBTASK 52-41-51-020-001

CAUTION DO NOT MOVE THE DOOR WITH THE SNUBBER REMOVED. THE DOOR CAN MOVE QUICKLY WITH THE SNUBBER REMOVED. IF THE DOOR MOVES QUICKLY TO THE OPEN OR CLOSED POSITION, IT CAN CAUSE DAMAGE TO THE EQUIPMENT.

(1) Do these steps to remove the snubber [7] from the door:

(a) Remove the bolt [1], washers [2], nut [3], and bushing [4] that attach the snubber [7] to the fuselage structure.

NOTE: Write down the location of the washers on the bolt.

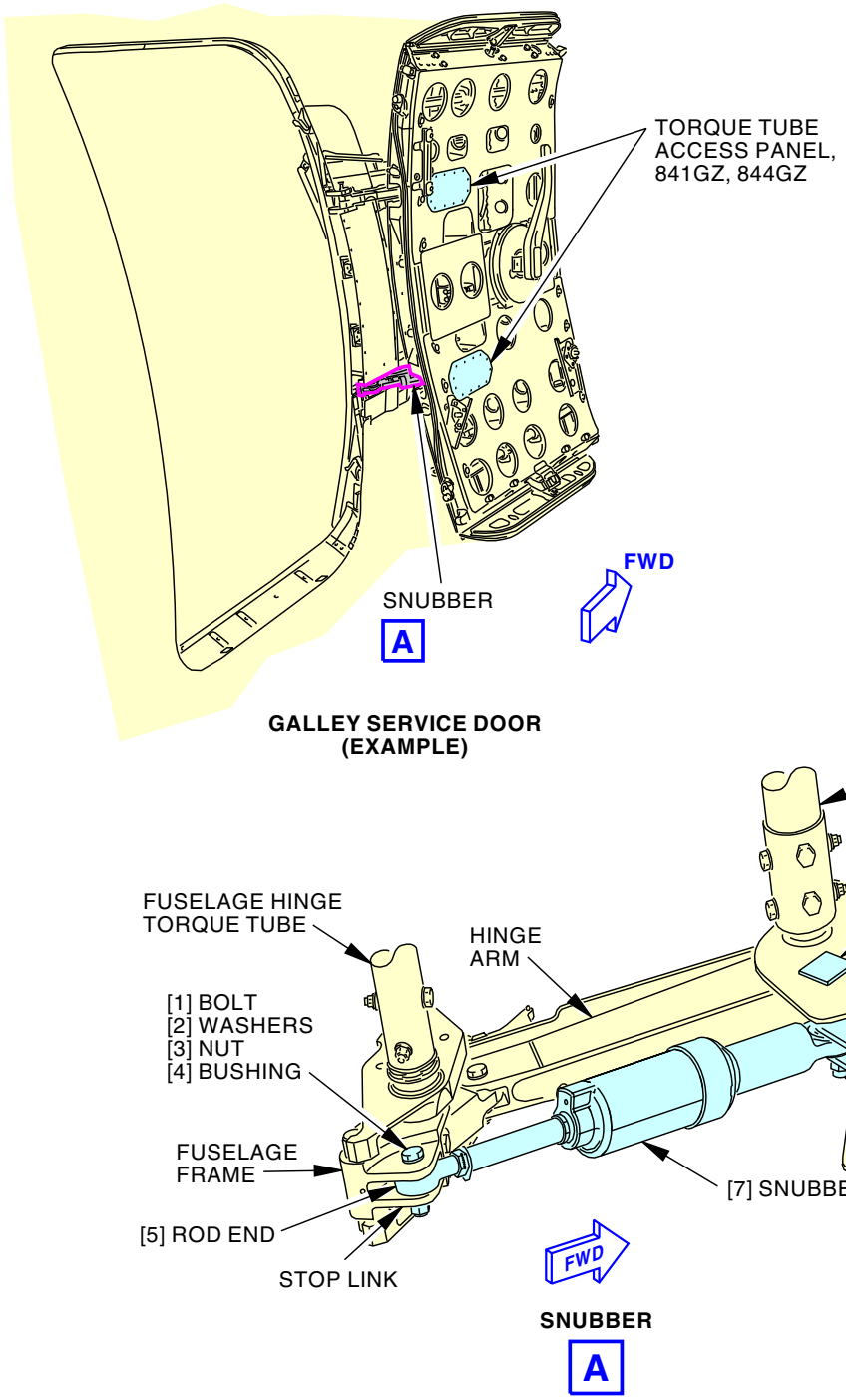
(b) Remove the filler [9] from the snubber attachment fitting [8].

(c) Remove the bolt [10], washer [11], and nut [12] that attach the snubber [7] to the snubber attachment fitting [8].

(d) Remove the snubber [7] and the snubber attachment fitting [8].

——— END OF TASK ———

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Galley Service Door Snubber Installation
Figure 401/52-41-51-990-802

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-41-51-400-801

3. Galley Service Door Snubber Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the galley service door snubber.

B. References

Reference	Title
20-50-11-910-801	Standard Torque Values (P/B 201)
52-41-31-400-801	Galley Service Door Lining Installation (P/B 401)

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
7	Snubber	52-41-00-04B-090	SIA ALL
		52-41-00-04B-095	SIA ALL
		52-41-00-08A-142	SIA ALL

D. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Access Panels

Number	Name/Location
841GZ	Forward Galley Service Door - Torque Tube Access
844GZ	Aft Galley Service Door - Torque Tube Access

F. Galley Service Door Snubber Installation

SUBTASK 52-41-51-420-001

CAUTION

DO NOT MOVE THE DOOR WITH THE SNUBBER REMOVED. THE DOOR CAN MOVE QUICKLY WITH THE SNUBBER REMOVED. IF THE DOOR MOVES QUICKLY TO THE OPEN OR CLOSED POSITION, IT CAN CAUSE DAMAGE TO THE EQUIPMENT.

(1) Do these steps to install the snubber [7] on the door:

CAUTION

MAKE SURE TO INSTALL THE SNUBBER WITH THE WIDE SIDE OF THE SNUBBER INBOARD. IF YOU DO NOT INSTALL THE SNUBBER WITH THE WIDE SIDE INBOARD, THE SNUBBER WILL CONTACT THE HINGE ARM WHEN THE DOOR IS CLOSED. THIS WILL CAUSE DAMAGE TO THE EQUIPMENT.

(a) Connect the snubber [7] to the snubber attachment fitting [8].

1) Install the snubber attachment fitting [8] with the snubber fluid fill plug recess pointed down.

(b) Install the bolt [10], washer [11], and nut [12] that attach the snubber [7] to the snubber attachment fitting [8].

(c) Install the filler [9] onto the snubber attachment fitting [8].

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(d) Install the bolt [1], washers [2], nut [3], and bushing [4] that attach the snubber [7] to the fuselage structure. For torque information, see this task: Standard Torque Values, TASK 20-50-11-910-801.

(e) Do an installation test on the snubber.

G. Galley Service Door Snubber Installation Test

SUBTASK 52-41-51-710-001

(1) Do an installation test on the snubber as follows:

(a) Make sure that the door is fully open with the hold open lock engaged.

(b) Make sure that more extension is available on the snubber [7].

(c) Move the door to the closed position.

(d) Make sure that the snubber [7] does not bottom out with the door in the closed position.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 52-41-51-410-001

(1) Install these access panels:

Number	Name/Location
841GZ	Forward Galley Service Door - Torque Tube Access
844GZ	Aft Galley Service Door - Torque Tube Access

SUBTASK 52-41-51-410-002

(2) If necessary, do this task: Galley Service Door Lining Installation, TASK 52-41-31-400-801.

——— END OF TASK ———

TASK 52-41-51-000-802

4. Galley Service Door Bumper - Removal

(Figure 402)

A. General

(1) This task incudes steps to remove the galley service door bumpers.

B. Tools/Equipment

Reference	Description
STD-764	Scraper - Non-metallic

C. Location Zones

Zone	Area
844	Aft Galley Service Door

D. Prepare for the Removal

SUBTASK 52-41-51-000-001

(1) Remove the snubber from the galley service door assembly, do this task: Galley Service Door Snubber Removal, TASK 52-41-51-000-801.

E. Galley Service Door Bumper Removal

SUBTASK 52-41-51-000-002

(1) Remove the bumper [20] with a non-metallic scraper, STD-764.

NOTE: Bumper bonded to surface with adhesive.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

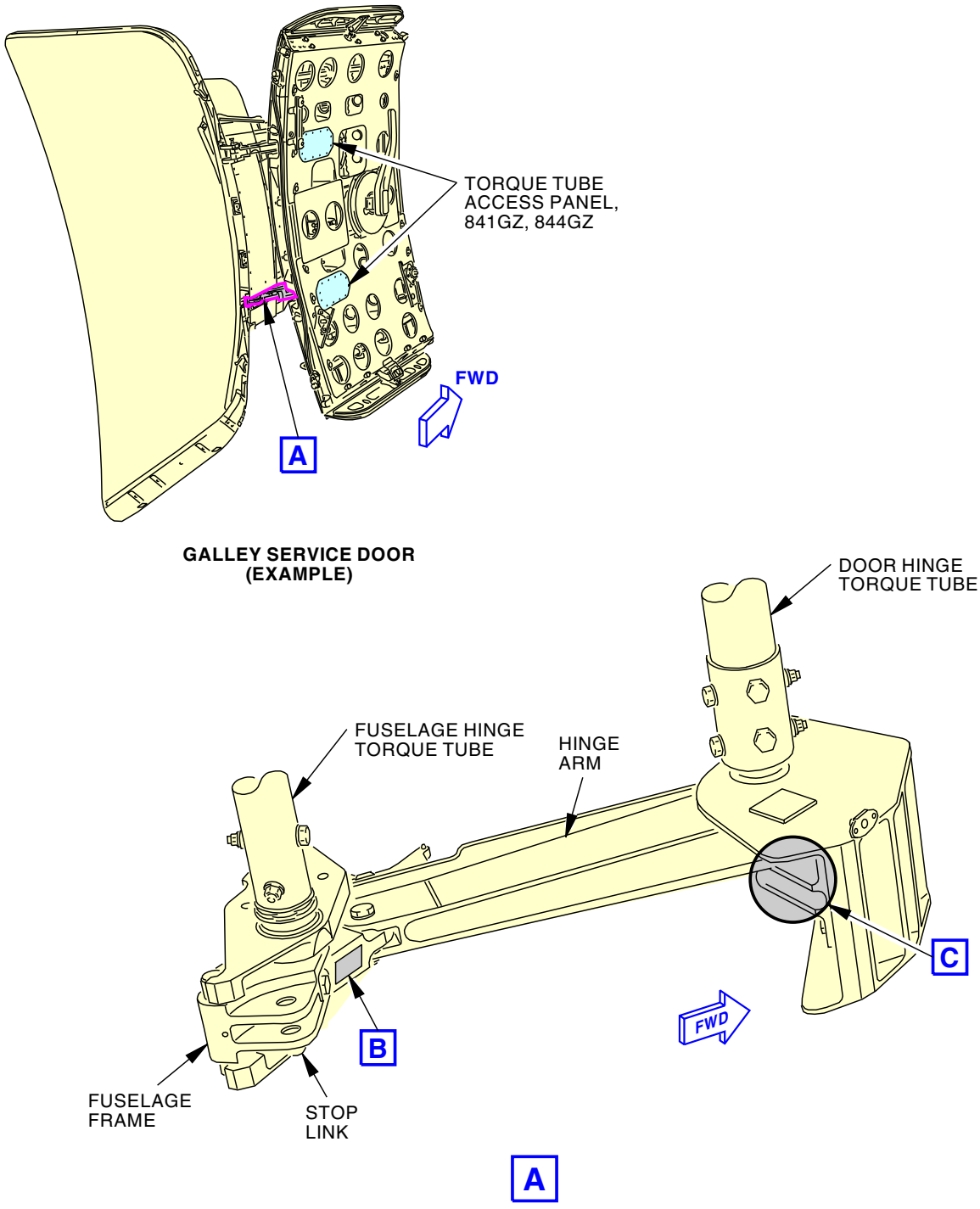
SUBTASK 52-41-51-000-003

(2) Remove the bumper [21] with a non-metallic scraper, STD-764.

NOTE: Bumper bonded to surface with adhesive.

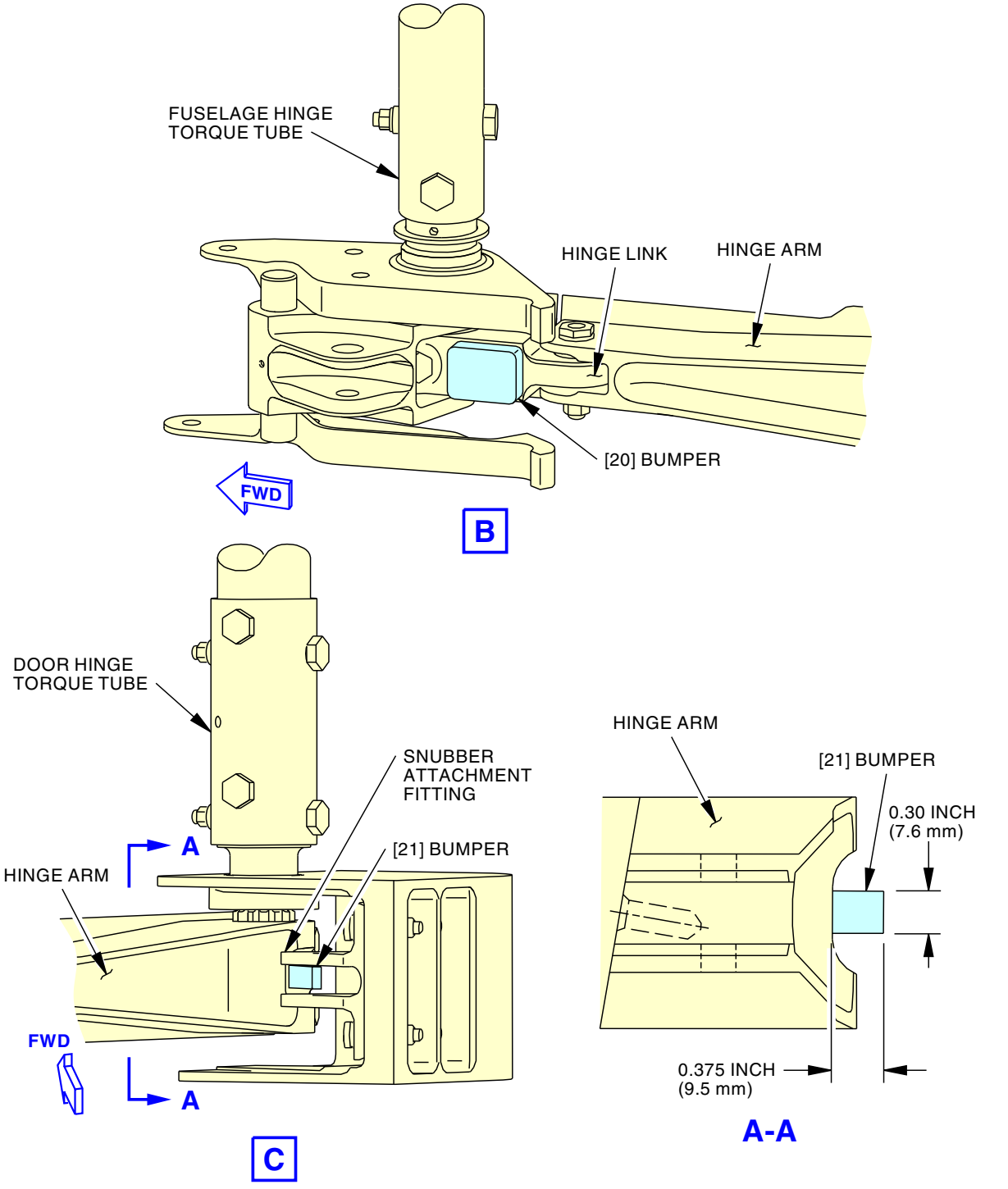
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Galley Service Door Bumper Installation
Figure 402/52-41-51-990-803 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Galley Service Door Bumper Installation
Figure 402/52-41-51-990-803 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-41-51-400-802

5. Galley Service Door Bumper - Installation

(Figure 402)

A. General

(1) This task includes the steps to install the galley service door bumpers.

B. Consumable Materials

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010 Type 60
B00130	Alcohol - Isopropyl	TT-I-735
B50201	Wipe - Alcohol (Isopropyl Alcohol)	
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)
G50260	Sandpaper - Aluminum Oxide, 220 Grit	

C. Prepare for the Installation

SUBTASK 52-41-51-100-001

(1) If necessary, use sandpaper, G50260, to remove the parting agent from the bonding areas.

SUBTASK 52-41-51-100-002

(2) Clean the bonding surfaces with cotton wiper, G00034, soaked in alcohol, B00130.

(a) Remove excess residue or solvent with a clean dry cotton wiper, G00034.

1) Use alcohol wipes, B50201, to remove any slow evaporating residue solvent.

(b) Repeat the process until the wipers are not dirty and the surface is visibly clean.

D. Galley Service Door Bumper Installation

SUBTASK 52-41-51-400-001

(1) Apply a continuous layer of the adhesive, A00027, to the bonding surfaces of the hinge arm, hinge link, new bumper [20], and new bumper [21].

(a) Make sure that no adhesive is applied outside the bond areas.

SUBTASK 52-41-51-400-002

(2) Align and attach the bumper [20] to the hinge link.

NOTE: Exposure to the air for more than two minutes will cause the adhesive to form a skin that interferes with the bond.

SUBTASK 52-41-51-400-003

(3) Align and attach the bumper [21] to the hinge arm.

NOTE: Exposure to the air for more than two minutes will cause the adhesive to form a skin that interferes with the bond.

SUBTASK 52-41-51-400-004

(4) Apply pressure to the bumper [20] and bumper [21] to make sure there is a good contact between bonding surfaces.

(a) Do not let the adhesive to squeeze out.

NOTE: Bond line thickness with a minimum of 0.015 in. (0.38 mm) is recommended for the best result.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-41-51-400-005

(5) Let adhesive dry under pressure for a minimum of 24 hours at 65°F (18.3°C) - 100°F (37.8°C).

(a) Do not cover the bond line.

NOTE: A minimum of 20% relative humidity is required. This adhesive requires moisture from the air to cure.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 52-41-51-400-006

(1) Install the snubber on the galley service door assembly, do this task: Galley Service Door Snubber Installation, TASK 52-41-51-400-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

GALLEY SERVICE DOOR BUMPER INSPECTION/CHECK

1. General

A. This procedure has this task:

(1) Inspection of the galley service door bumpers.

TASK 52-41-51-200-801

2. Galley Service Door Bumper - Inspection

(Figure 601)

A. General

(1) This task includes steps to perform a visual inspection of galley service door bumpers.

B. References

Reference	Title
52-41-51-000-802	Galley Service Door Bumper - Removal (P/B 401)
52-41-51-400-802	Galley Service Door Bumper - Installation (P/B 401)

C. Access Panels

Number	Name/Location
844	Aft Galley Service Door

D. Galley Service Door Bumper Inspection

SUBTASK 52-41-51-010-003

(1) Open this access panel:

Number	Name/Location
844	Aft Galley Service Door

SUBTASK 52-41-51-211-001

(2) Do a visual inspection of the bumpers.

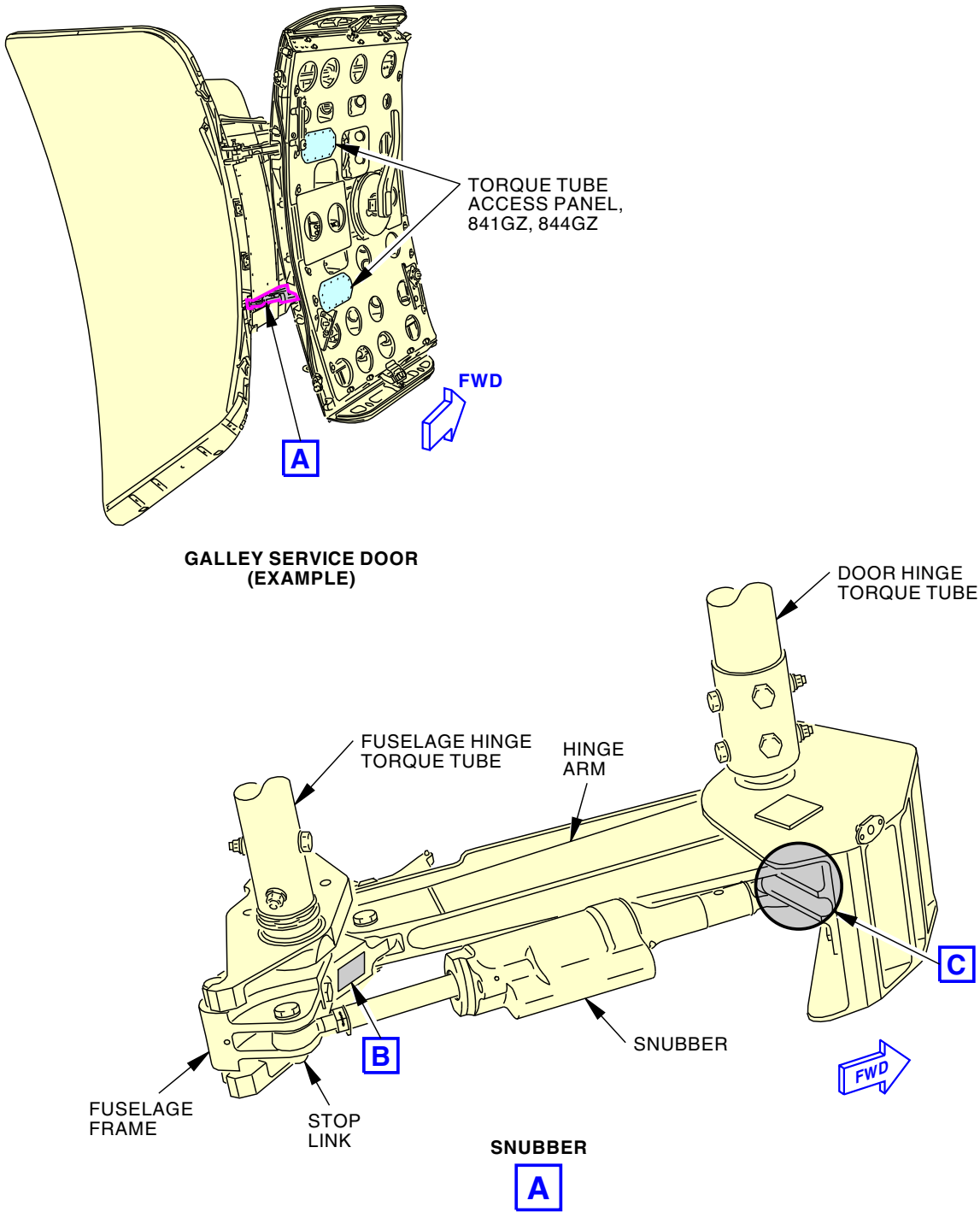
(a) If the bumpers are missing or the position is incorrect, replace the bumpers, do these tasks:

- Galley Service Door Bumper - Removal, TASK 52-41-51-000-802
- Galley Service Door Bumper - Installation, TASK 52-41-51-400-802.

NOTE: Orientation of the bumpers is critical.

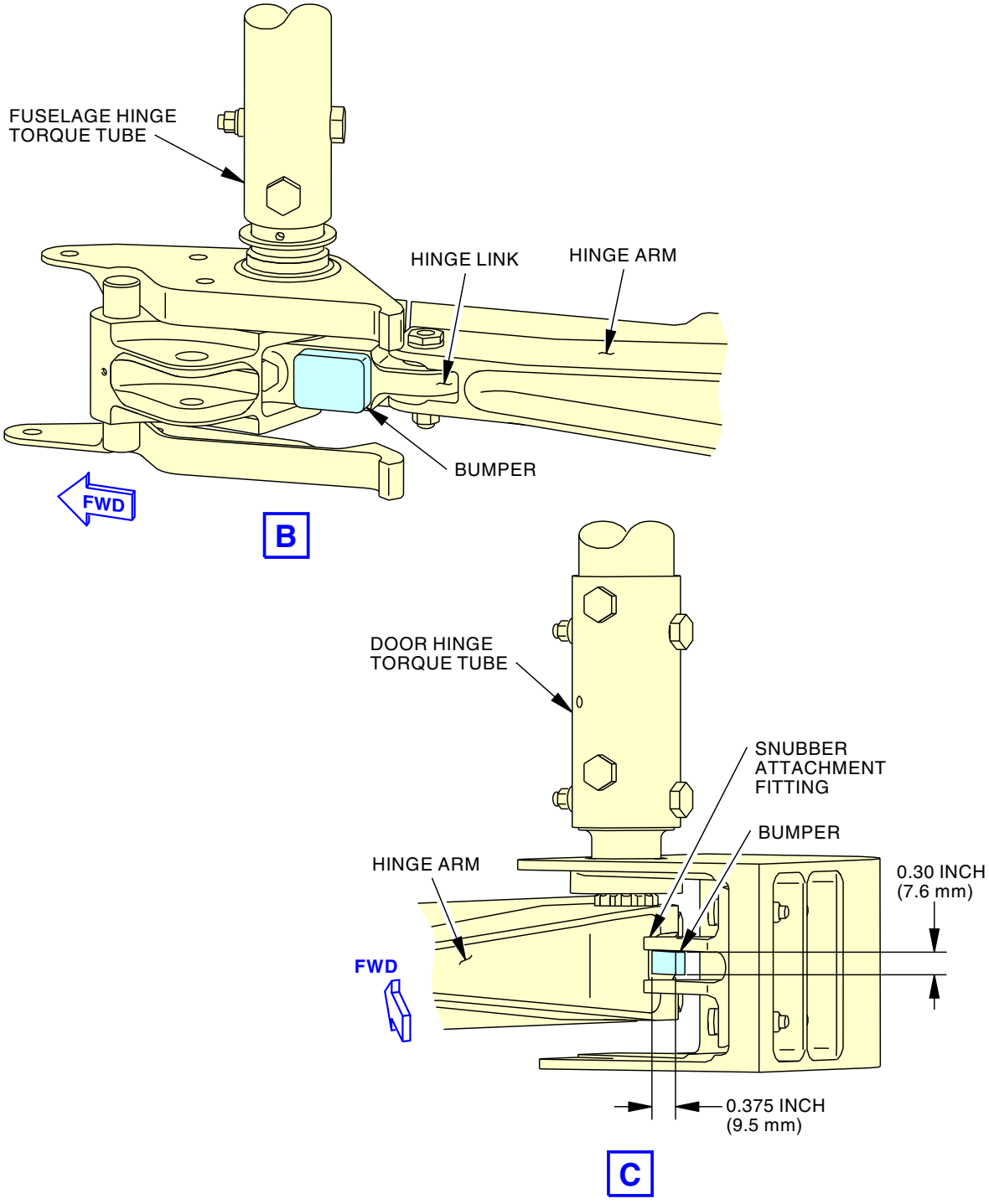
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Galley Service Door Bumper Inspection
Figure 601/52-41-51-990-804 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Galley Service Door Bumper Inspection
Figure 601/52-41-51-990-804 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

GALLEY SERVICE DOOR GATE - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Galley service door gate removal

(2) Galley service door gate installation.

B. The removal and installation procedures are the same for the forward or aft galley service door gates.

TASK 52-41-61-000-801

2. Galley Service Door Gate Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the galley service door gate.

B. References

Reference	Title
52-09-12-000-801	Blade and Diaphragm Seals Removal (P/B 401)
52-41-31-000-801	Galley Service Door Lining 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
COM-1540	Stand - Work, General Purpose Part #: AM-1737 Supplier: 9M323 Opt Part #: MODEL 136 Supplier: 2S363

D. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Prepare for Removal

SUBTASK 52-41-61-840-001

(1) Make sure that the door is safe as follows:

(a) The door is closed and latched.

WARNING MAKE SURE THE GIRT BAR IS NOT ENGAGED IN THE FLOOR-MOUNTED ESCAPE SLIDE BRACKETS. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN DEPLOY WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

(b) Make sure that the girt bar is not engaged in the floor-mounted escape slide brackets.

SUBTASK 52-41-61-860-001

(2) Put a work stand, COM-1540 outboard of the door.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-41-61-010-001

(3) Do this task: Galley Service Door Lining Removal, TASK 52-41-31-000-801.

F. Galley Service Door Gate Removal

SUBTASK 52-41-61-010-002

(1) Remove only the blade [6] from the gate [3].

(a) Do this task: Blade and Diaphragm Seals Removal, TASK 52-09-12-000-801.

NOTE: Only do the procedure to remove the blade seal from the gate.

SUBTASK 52-41-61-020-001

(2) Disconnect the rod [2] from the upper or lower gate [3].

(a) Hold the rod [2]. Do not let the rod [2] fall back in the door frame when the bolt [8] is removed.

NOTE: Turn the door handle to extend or retract the rod [2].

(b) Remove the bolt [8], washer [7], bushing [9], washer [11], and nut [10] that attach the rod [2] to the gate [3].

(c) Safety the end of the rod [2] to the door frame to hold it in its position.

SUBTASK 52-41-61-010-003

(3) Remove the upper or lower gate [3] from the galley service door [1].

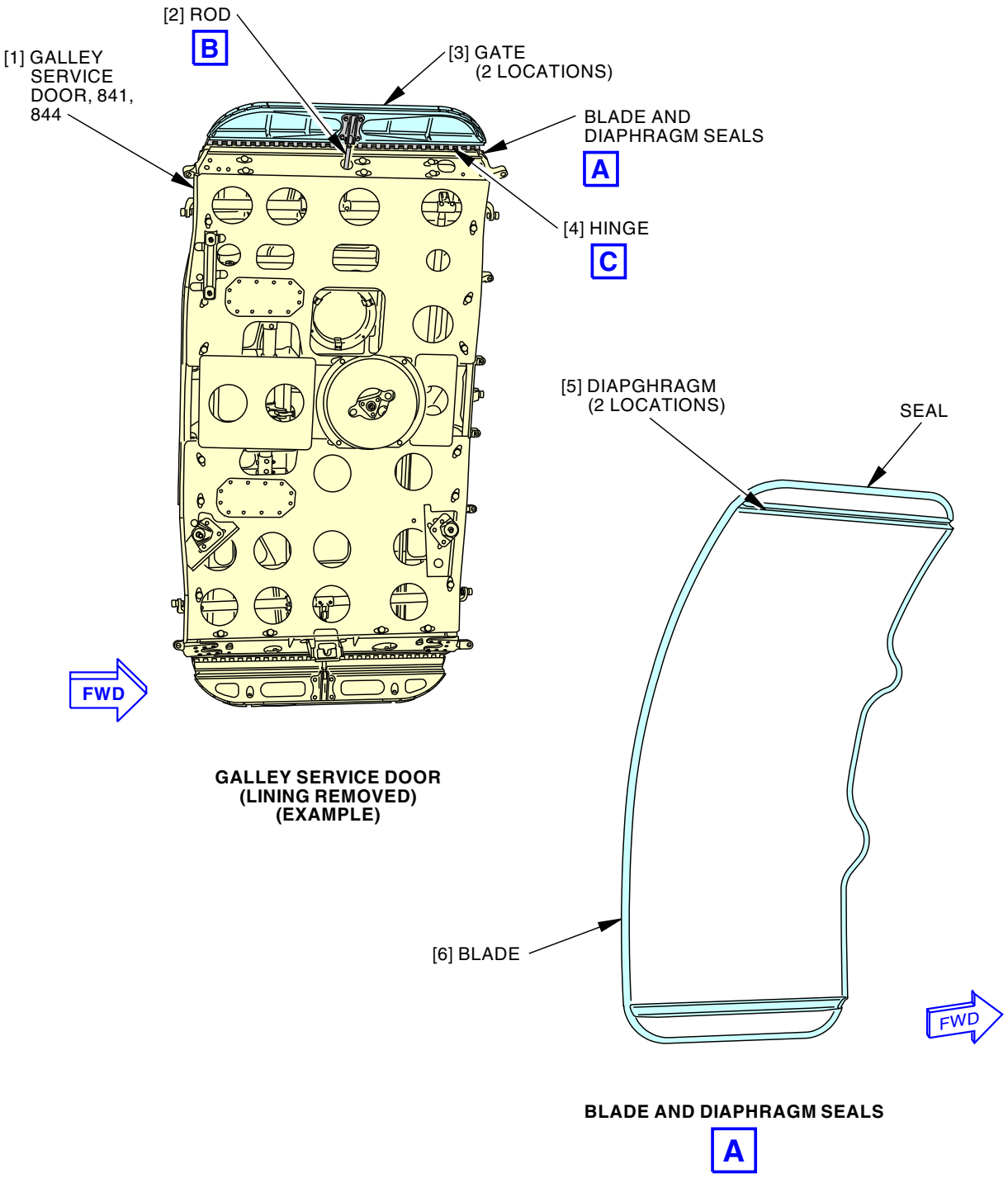
(a) Fold the gate [3] in the outboard direction.

(b) Remove the 11 bolts [12] and washers [13] that attach the hinge [4] to the galley service door [1].

(c) Remove the gate [3] from the galley service door [1].

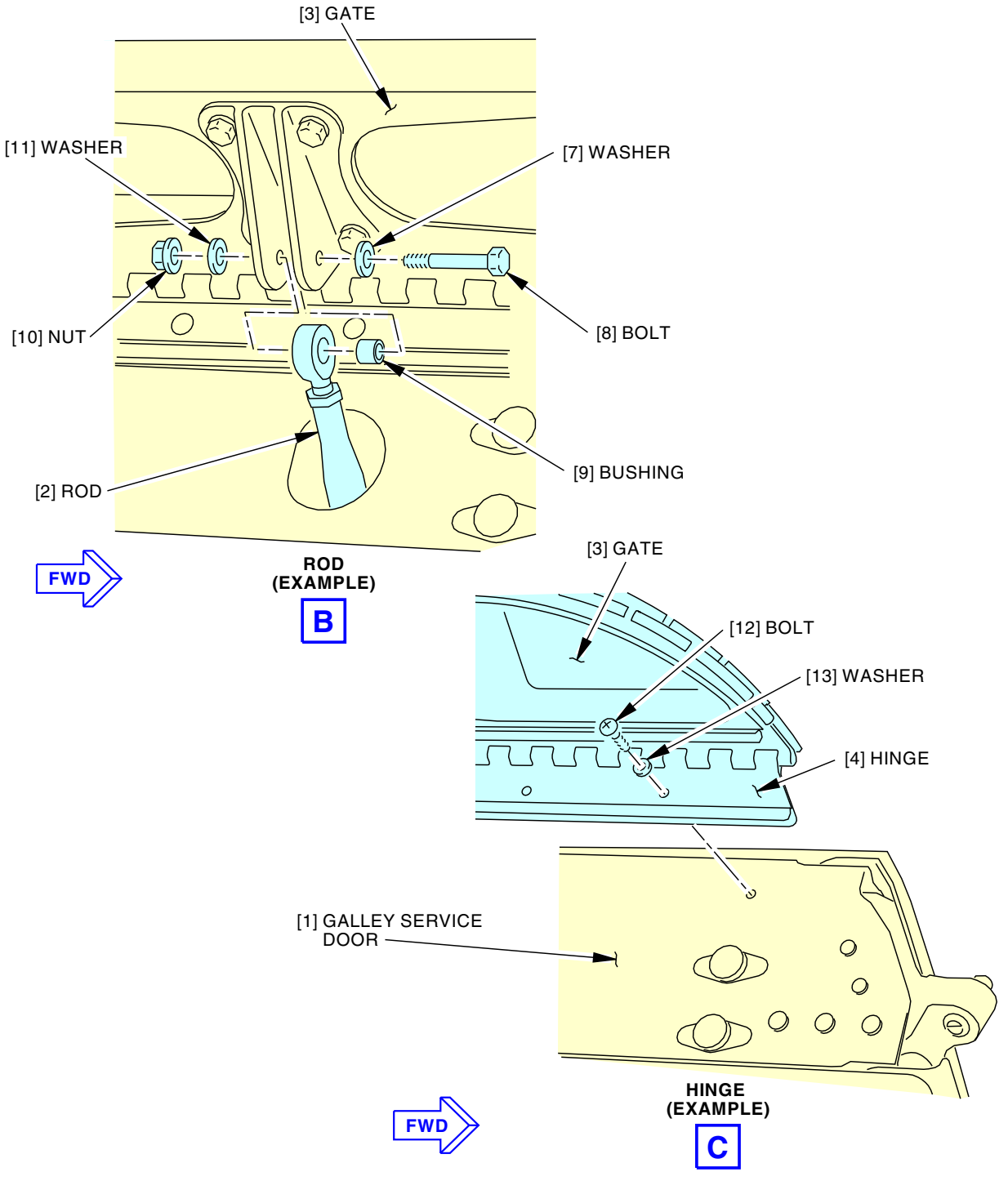
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Galley Service Door Gate Installation
Figure 401/52-41-61-990-802 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Galley Service Door Gate Installation
Figure 401/52-41-61-990-802 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-41-61-400-801

3. Galley Service Door Gate Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the galley service door gate.

B. References

Reference	Title
52-09-12-400-801	Blade and Diaphragm Seals Installation (P/B 401)
52-41-00-820-801	Galley Service Door Adjustment (P/B 501)
52-41-31-400-801	Galley Service Door Lining Installation (P/B 401)

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
3	Gate	52-41-11-01B-390	SIA ALL
		52-41-11-01B-515	SIA ALL
		52-41-11-01B-595	SIA ALL
		52-41-11-01B-720	SIA ALL
		52-41-11-02A-190	SIA ALL
		52-41-11-02A-470	SIA ALL
		52-41-11-02A-590	SIA ALL
		52-41-11-02A-680	SIA ALL

E. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

F. Galley Service Door Gate Installation

SUBTASK 52-41-61-420-001

(1) Connect the upper or lower gate [3] to the galley service door [1] at the hinge [4].

(a) Apply sealant, A00247 to the mating surfaces between the hinge [4] and galley service door [1].

(b) Put the gate [3] in its position on the galley service door [1].

(c) Install the 11 bolts [12] and washers [13] that attach the hinge [4] to the galley service door [1].

SUBTASK 52-41-61-410-001

(2) Install only the diapghragm [5] between the galley service door [1] and upper or lower gate [3].

(a) Fold the gate [3] outboard.

(b) Install the diapghragm [5] between the galley service door [1] and gate [3].

1) Do this task: Blade and Diaphragm Seals Installation, TASK 52-09-12-400-801.

NOTE: Only do the diaphragm seal installation procedure.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-41-61-420-002

(3) Connect the rod [2] to the upper or lower gate [3].

(a) Fold the gate [3] inboard.

(b) Align the rod [2] in its correct position on the gate [3].

1) Hold the rod [2]. Do not let the rod [2] fall back in the door frame.

NOTE: Turn the door handle to extend or retract the rod [2].

(c) Install the bolt [8], washer [7], bushing [9], washer [11], and nut [10] that attach the rod [2] to the gate [3].

SUBTASK 52-41-61-410-002

(4) Install only the blade [6] on the upper or lower gate [3].

(a) Do this task: Blade and Diaphragm Seals Installation, TASK 52-09-12-400-801.

NOTE: Only do the blade seal installation on the gate [3].

SUBTASK 52-41-61-820-001

(5) Adjust the gate [3].

(a) Do this task: Galley Service Door Adjustment, TASK 52-41-00-820-801.

NOTE: Only do the gate [3] adjustment.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 52-41-61-410-003

(1) Do this task: Galley Service Door Lining Installation, TASK 52-41-31-400-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

GALLEY SERVICE DOOR DRAIN VALVE ASSEMBLY - REMOVAL/INSTALLATION

1. General

A. This procedure has the following tasks:

(1) Galley service door drain valve assembly removal

(2) Galley service door drain valve assembly installation.

B. The removal and installation procedures are the same for the forward and aft galley service door drain valve assemblies.

TASK 52-41-62-000-801

2. Galley Service Door Drain Valve Assembly Removal

Figure 401

A. General

(1) This task gives the instructions to remove the galley service door drain valve assembly.

B. References

Reference	Title
52-41-00-860-801	Open the Galley Service Door with the Exterior Handle (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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

D. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Prepare for the Removal

SUBTASK 52-41-62-480-001

(1) Install the work platform, COM-1523 outboard of the galley service door.

SUBTASK 52-41-62-010-001

(2) Open the galley service door (TASK 52-41-00-860-801).

F. Galley Service Door Drain Valve Assembly Removal

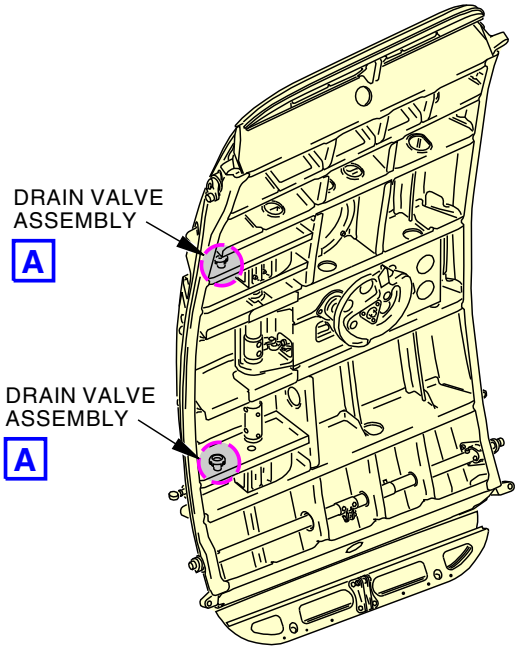
SUBTASK 52-41-62-020-001

(1) Remove the drain valve assembly [1] from the drain valve retainer [2].

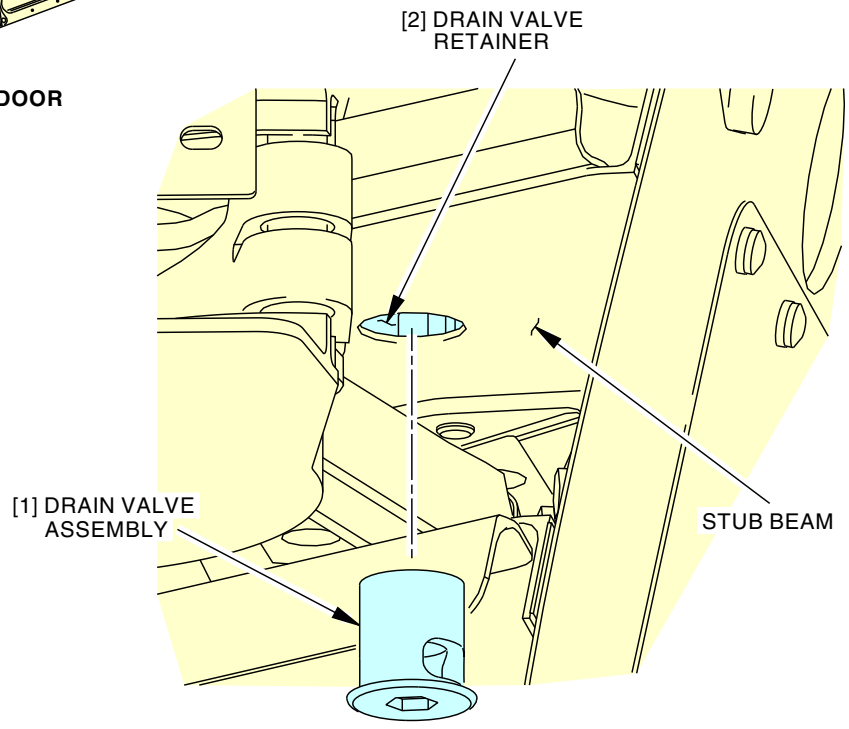
(a) Remove the drain valve assembly [1] from the hinge side.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



GALLEY SERVICE DOOR (EXAMPLE)



DRAIN VALVE ASSEMBLY (EXAMPLE)

A

2415933 S00061539197_V1

Galley Service Door Valve Assembly Installation
Figure 401/52-41-62-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-41-62-400-801

3. Galley Service Door Drain Valve Assembly Installation

Figure 401

A. General

(1) This task gives the instructions to install the galley service door drain valve assembly.

B. References

Reference	Title
52-41-00-860-802	Close the Galley Service Door with the Exterior Handle (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-1523	Stand and Personnel Lifting Equipment - General Purpose Part #: B-14 Supplier: 05060 Part #: B-9 Supplier: 05060 Part #: Z-45-25J Supplier: 59497

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Drain valve assembly	52-41-00-01B-930	SIA ALL
		52-41-00-05A-885	SIA ALL

E. Location Zones

Zone	Area
841	Forward Galley Service Door
844	Aft Galley Service Door

F. Galley Service Door Drain Valve Assembly Installation

SUBTASK 52-41-62-420-001

(1) Install the drain valve assembly [1] into the drain valve retainer [2].

(a) Install the drain valve assembly [1] from the hinge side.

(b) Tighten the drain valve assembly [1] to 8.0 ±2.0 in-lb (0.9 ±0.2 N·m).

G. Put the Airplane Back to Its Usual Condition

SUBTASK 52-41-62-410-001

(1) Close the galley service door (TASK 52-41-00-860-802).

SUBTASK 52-41-62-080-001

(2) Remove the work platform, COM-1523.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AUXILIARY POWER UNIT (APU) COWL DOOR - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the Auxiliary Power Unit (APU) cowl door

(2) An installation of the Auxiliary Power Unit (APU) cowl door.

TASK 52-48-21-000-801

2. Auxiliary Power Unit (APU) Cowl Door Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the Auxiliary Power Unit (APU) cowl door.

B. References

Reference	Title
26-15-01-000-801	APU Overheat Detector Element Removal (P/B 401)

C. Location Zones

Zone	Area
315	APU Compartment - Left
316	APU Compartment - Right

D. Prepare for the Removal

SUBTASK 52-48-21-010-001

(1) Open the APU cowl door [1]:

(a) Hold the APU cowl door [1] and release the latches [2].

1) Use this sequence: forward latch, aft latch, middle latch.

(b) Slowly let the APU cowl door [1] open.

(c) Make sure that the ends of the hold-open rods [5] are safely held to the APU cowl door [1] by the spring clips [4] and retention cables [3].

E. Auxiliary Power Unit (APU) Cowl Door Removal

SUBTASK 52-48-21-020-001

(1) Disconnect the APU fire detection electrical connector [6] from the APU cowl door [1] (TASK 26-15-01-000-801).

SUBTASK 52-48-21-020-002

(2) Disconnect the APU cowl door [1] at the hinges [7]:

(a) Remove the bolts [12] and washers [13] that connect the bonding jumper [11] to the APU cowl door [1].

CAUTION HOLD THE DOOR TIGHTLY. THE LEVER ARM HOLDS THE HINGE TO THE HINGE PIVOT BOLT WHEN THE DOOR IS OPEN. IF YOU DO NOT OBEY THIS PRECAUTION, DAMAGE TO THE DOOR CAN OCCUR.

(b) Hold the APU cowl door [1] in the open position.

(c) Remove the bolts [14] and nuts [15] that attach the lower end of the lever arms [9] to the hinges [7].

(d) Make sure to turn the lower end of the lever arms [9] into the hinge fittings [10].

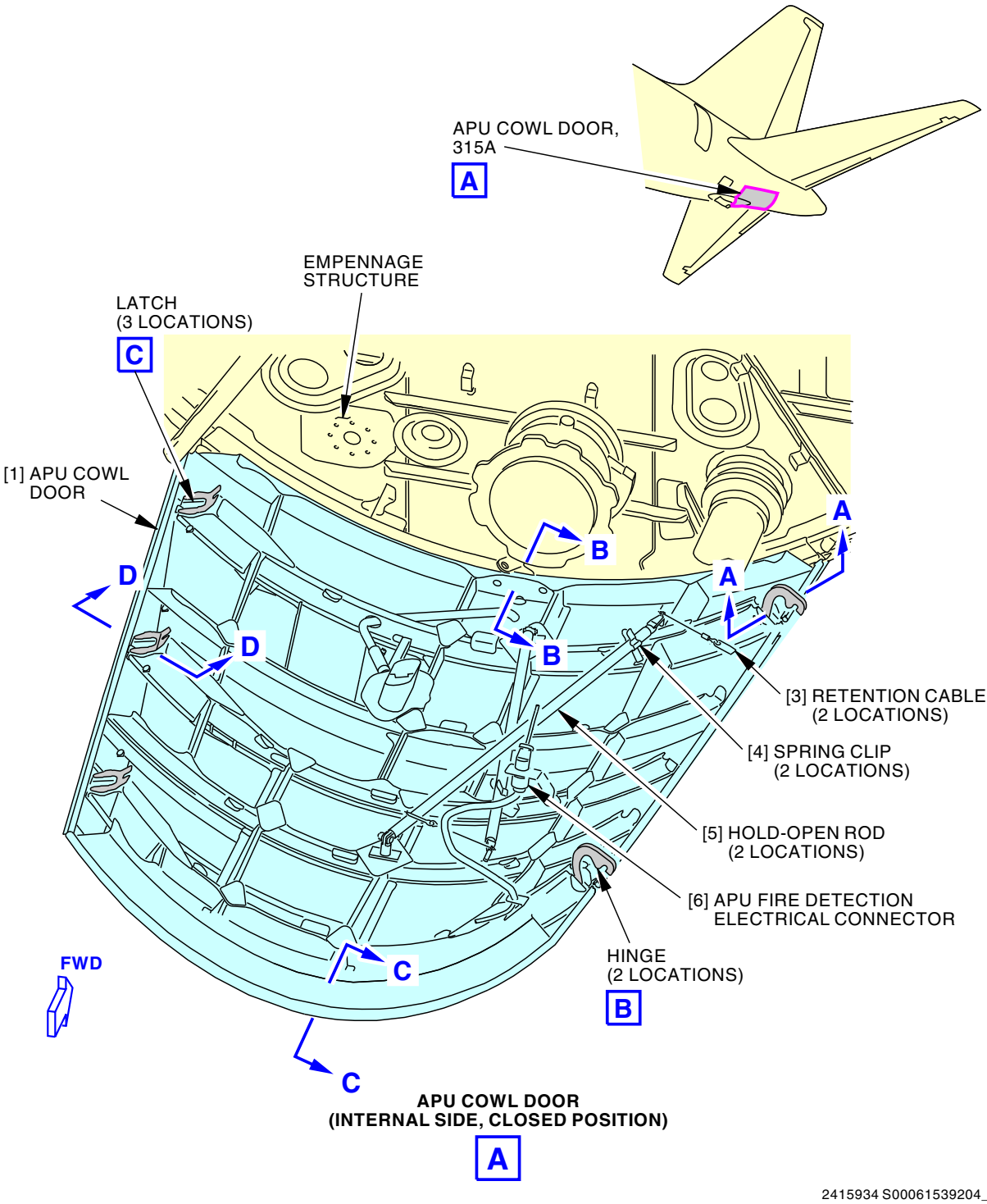
ECCN 9E991 BOEING PROPRIETARY - See title page for details

(e) Move the APU cowl door [1] horizontally inboard until the hinges [7] are clear of the hinge fittings [10].

(f) Remove the APU cowl door [1] from the airplane.

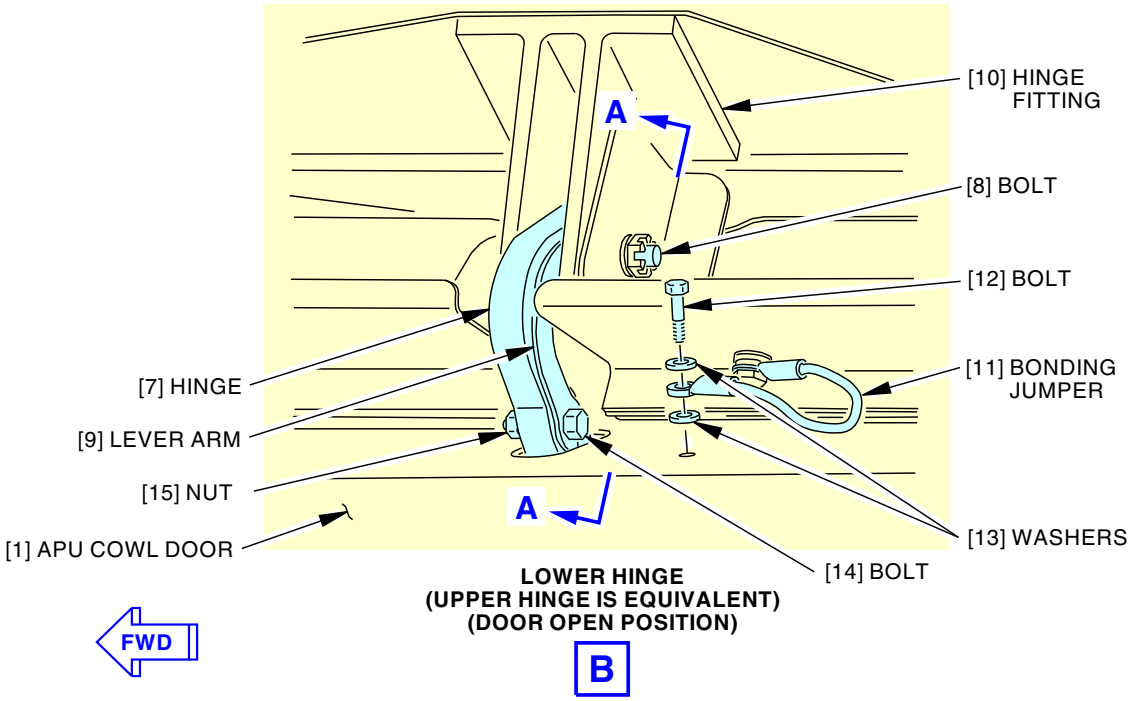
——— END OF TASK ———

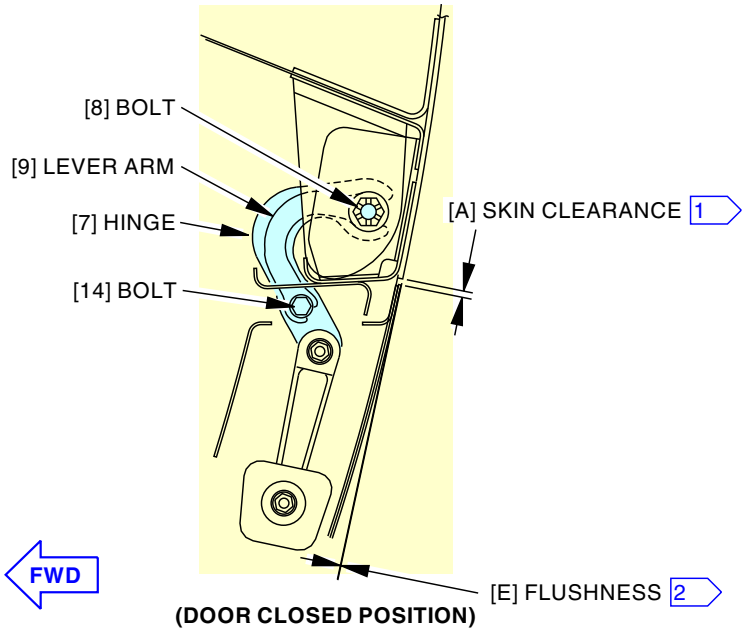
ECCN 9E991 BOEING PROPRIETARY - See title page for details



Auxiliary Power Unit (APU) Cowl Door Installation
Figure 401/52-48-21-990-802 (Sheet 1 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details





NOTE:

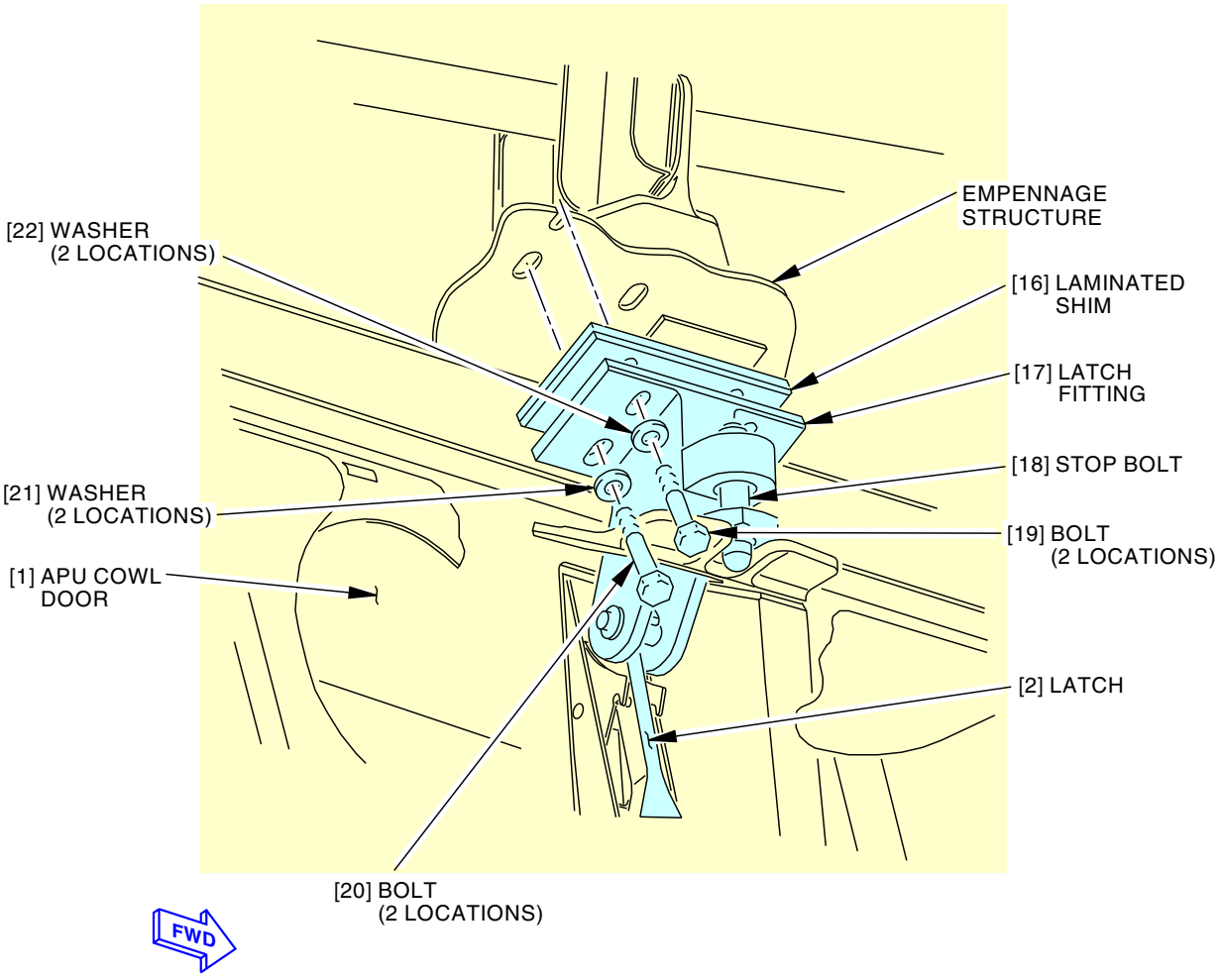
1 FOR SKIN CLEARANCE REFER TO TABLE 401 IN THE PROCEDURE

2 FOR FLUSHNESS REFER TO TABLE 402 IN THE PROCEDURE

2415935 S00061539205_V5

Auxiliary Power Unit (APU) Cowl Door Installation
Figure 401/52-48-21-990-802 (Sheet 2 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



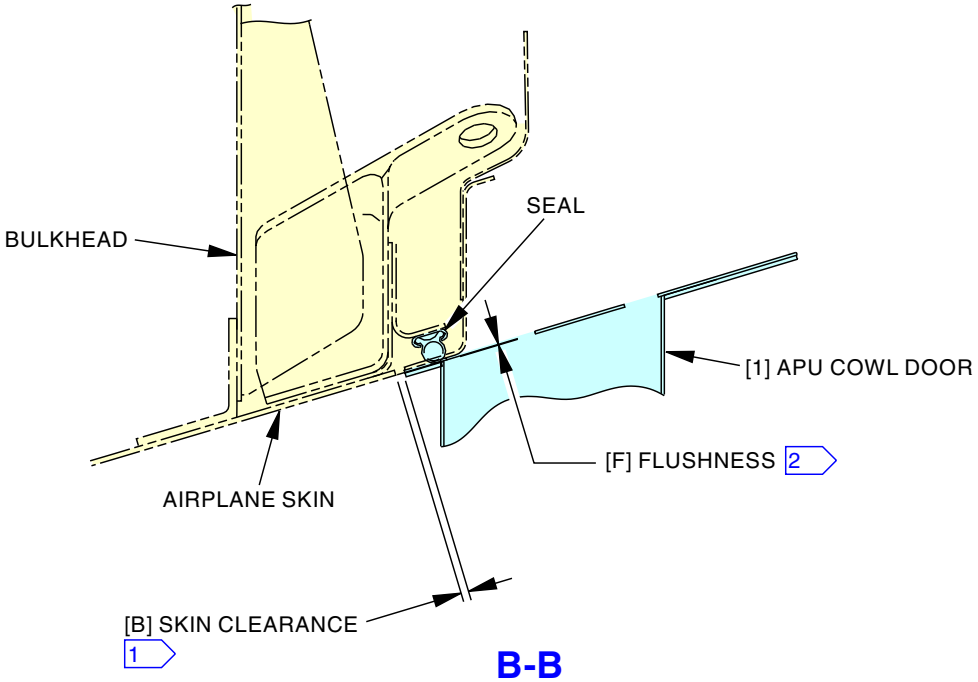
UPPER LATCH
(MIDDLE AND LOWER LATCHES ARE EQUIVALENT)
(DOOR CLOSED POSITION)

C

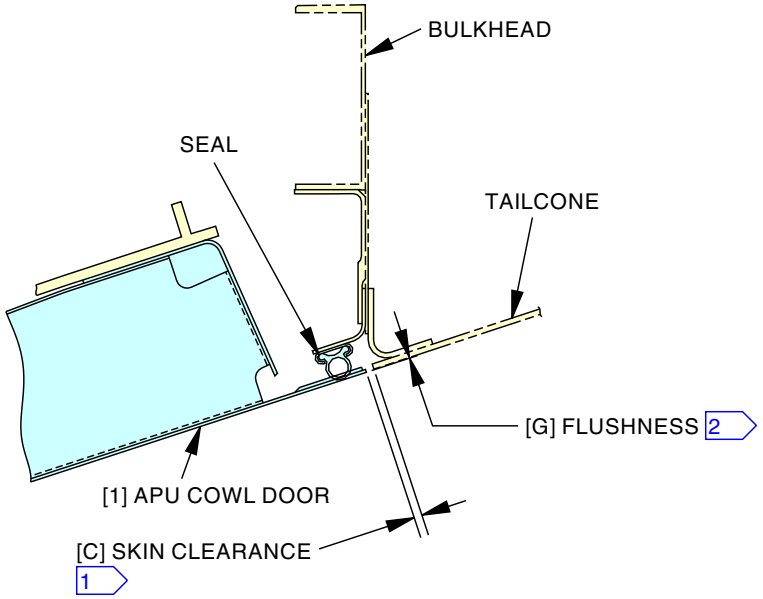
2415936 S00061539206_V3

Auxiliary Power Unit (APU) Cowl Door Installation
Figure 401/52-48-21-990-802 (Sheet 3 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



B-B

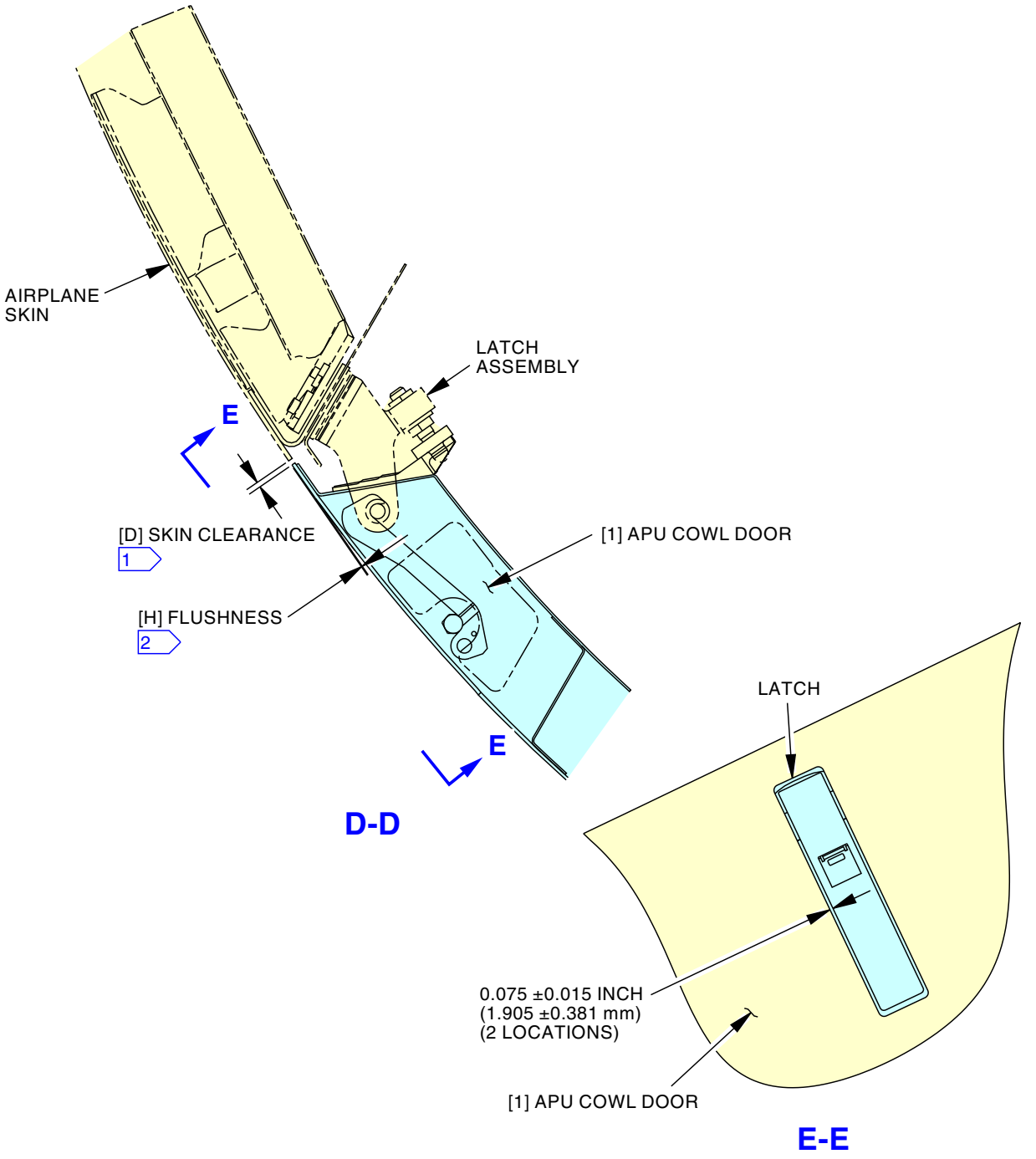


C-C

2415937 S00061539207_V3

Auxiliary Power Unit (APU) Cowl Door Installation
Figure 401/52-48-21-990-802 (Sheet 4 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Auxiliary Power Unit (APU) Cowl Door Installation
Figure 401/52-48-21-990-802 (Sheet 5 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-48-21-400-801

3. Auxiliary Power Unit (APU) Cowl Door Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the Auxiliary Power Unit (APU) cowl door.

B. References

Reference	Title
26-15-01-400-801	APU Overheat Detector Element Installation (P/B 401)
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES
SWPM 20-20-00, Paragraph 2.A.	Cleaning Procedure 1
SWPM 20-20-10 Paragraph 4.F	Category 2 Fay Sealed Direct Ground Stud Installation

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-614	Bonding Meters - Non-Intrinsically Safe (For use in outside Class I, Divisions I & II non-hazardous locations. For hazardous locations, use COM-1550). Part #: 247000 Supplier: 00426 Part #: 620LK Supplier: 1CRL2 Part #: BLR-0003-XX Supplier: KC432 Part #: BT51 Supplier: 00426 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659 Opt Part #: 247001 Supplier: 00426

D. Consumable Materials

Reference	Description	Specification
A50110	Sealant - Fuel Tank	BMS5-45 Class B-2
A50155	Sealant - Fuel Tank	BMS5-45 Class C
A50231	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class B
A50296	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class C
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
C00064	Coating - Aluminum Chemical Conversion	BAC5719 Type II Class A (MIL-DTL-5541 Class 1A)
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	APU cowl door	52-48-21-05-080	SIA ALL
16	Laminated shim	52-48-21-02-050	SIA ALL

F. Location Zones

Zone	Area
315	APU Compartment - Left
316	APU Compartment - Right

G. Auxiliary Power Unit (APU) Cowl Door Installation

SUBTASK 52-48-21-410-001

(1) Connect the APU cowl door [1] at the hinges [7].

(a) Hold the APU cowl door [1] in the open position.

(b) Align the hinges [7] on the APU cowl door [1] with the hinge fittings [10] on the empennage structure.

(c) Lower the APU cowl door [1] until the hinges [7] touch the bolts [8] in the hinge fittings [10].

(d) Move the APU cowl door [1] horizontally outboard until the hinges [7] touch the bolts [8].

(e) Make sure that the APU cowl door [1] is correctly installed in its position.

(f) Attach the lower end of the lever arms [9] to the hinges [7] with bolts [14] and nuts [15].

SIA 001-011, 013

(g) Install the bolts [12] and washers [13] to connect the bonding jumpers [11] to the APU cowl door [1].

1) Use cotton wiper, G00034, moist in solvent, B00184, to clean the mating surfaces of the APU cowl door [1], washers [13], bolts [12], and bonding jumpers [11].

2) Install the bolts [12], washers [13], and bonding jumpers [11].

3) Torque the bolts [12] to 28 in-lb (3.2 N·m) - 35 in-lb (4.0 N·m).

4) Measure the electrical resistance between the bonding jumpers [11] and APU cowl door [1] (SWPM 20-20-00).

a) Use a non-intrinsically safe bonding meter, COM-614.

b) Make sure that the electrical bonding resistance is 0.001 ohm (1.0 milliohm) or less.

5) Manually apply finish with coating, C00064.

a) Apply primer, C00259, to the bolts [12], washers [13], and bonding jumpers [11].

SIA 012, 014-999

(h) Install the bolts [12] and washers [13] to connect the bonding jumpers [11] to the APU cowl door [1].

1) Clean the surface of the APU cowl door [1], washers [13], bolts [12], and bonding jumpers [11] (SWPM 20-20-00, Paragraph 2.A.).

2) Use cotton wiper, G00034, moist in solvent, B00184, to clean the mating surfaces of the APU cowl door [1], washers [13], bolts [12], and bonding jumpers [11].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SIA 012, 014-999 (Continued)

3) Apply sealant, A50110, or sealant, A50155, or sealant, A50231, or sealant, A50296, to the mating surfaces of the bolts [12], washers [13], and bonding jumpers [11] (SWPM 20-20-10 Paragraph 4.F).
4) Install the bolts [12], washers [13], and bonding jumpers [11].
5) Torque the bolts [12] to 28 in-lb (3.2 N·m) - 35 in-lb (4.0 N·m).
   a) Make sure that there is squeeze out around all the interfaces of each component.
6) Measure the electrical resistance between the bonding jumpers [11] and APU cowl door [1] (SWPM 20-20-00).
   a) Use a non-intrinsically safe bonding meter, COM-614.
   b) Make sure that the electrical bonding resistance is 0.001 ohm (1.0 milliohm) or less.
7) Manually apply finish with coating, C00064.
   a) Apply primer, C00259, to the bolts [12], washers [13], and bonding jumpers [11].

SIA ALL

SUBTASK 52-48-21-420-001

(2) Connect the APU fire detection electrical connector [6] to the APU cowl door [1] (TASK 26-15-01-400-801).

SUBTASK 52-48-21-820-001

(3) Adjust the APU cowl door [1] as follows:
   (a) Close and latch the APU cowl door [1].
      1) Use this sequence: middle latch, aft latch, forward latch.
   (b) Make sure that the skin clearances between the empennage and the door are as shown on Table 401 and the door fits in the cutout (Views A-A, B-B, C-C, and D-D, Figure 401).

Table 401/52-48-21-993-801 APU Cowl Door Installation Skin Clearances

CLEARANCE	SECTION	SKIN CLEARANCE
SIA 001-011, 013		
A	A-A	0.135 ±0.045 in. (3.429 ±1.143 mm)
SIA 012, 014-999		
A	A-A	0.120 ±0.060 in. (3.048 ±1.524 mm)
SIA ALL		
B	B-B	0.120 ±0.060 in. (3.048 ±1.524 mm)
C	C-C	0.120 ±0.060 in. (3.048 ±1.524 mm)
D	D-D	0.120 ±0.060 in. (3.048 ±1.524 mm)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(c) Make sure that the flushness of the door is as shown on Table 402 for Views A-A, B-B, C-C, and D-D, Figure 401.

NOTE: A positive (+) misfair indicates that the door is outboard of the body skin. A negative (-) misfair indicates that the door is inboard of the body skin.

NOTE: Point locations are defined by fuselage station (STA), Left-Hand Buttock Line (LBL) and Right-Hand Buttock Line (RBL).

Table 402/52-48-21-993-803 APU Cowl Door Installation Flushness

FLUSHNESS	SECTION	POINT LOCATION	FLUSHNESS AT SINGLE POINT LOCATION
E	A-A	STA 1093	-0.018 ±0.072 in. (-0.457 ±1.829 mm)
E	A-A	STA 1100	-0.018 ±0.072 in. (-0.457 ±1.829 mm)
E	A-A	STA 1123	-0.013 ±0.077 in. (-0.330 ±1.956 mm)
E	A-A	STA 1145	-0.018 ±0.072 in. (-0.457 ±1.829 mm)
E	A-A	STA 1153	-0.018 ±0.072 in. (-0.457 ±1.829 mm)
F	B-B	LBL 24	0.002 ±0.072 in. (0.051 ±1.829 mm)
F	B-B	LBL 10.5	0.002 ±0.072 in. (0.051 ±1.829 mm)
F	B-B	RBL 10.5	0.002 ±0.072 in. (0.051 ±1.829 mm)
F	B-B	RBL 21	0.002 ±0.072 in. (0.051 ±1.829 mm)
G	C-C	LBL 17	-0.0205 ±0.0795 in. (-0.5207 ±2.0193 mm)
G	C-C	LBL 8.5	-0.0205 ±0.0795 in. (-0.5207 ±2.0193 mm)
G	C-C	BL 0	-0.031 ±0.069 in. (-0.787 ±1.753 mm)
G	C-C	LBL 8.5	-0.0205 ±0.0795 in. (-0.5207 ±2.0193 mm)
G	C-C	LBL 14.5	-0.0205 ±0.0795 in. (-0.5207 ±2.0193 mm)
H	D-D	STA 1093	-0.078 ±0.132 in. (-1.981 ±3.353 mm)
H	D-D	STA 1100	-0.062 ±0.148 in. (-1.575 ±3.759 mm)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Table 402/52-48-21-993-803 APU Cowl Door Installation Flushness (Continued)

FLUSHNESS	SECTION	POINT LOCATION	FLUSHNESS AT SINGLE POINT LOCATION
H	D-D	STA 1123	-0.057 ±0.153 in. (-1.448 ±3.886 mm)
H	D-D	STA 1145	-0.058 ±0.152 in. (-1.473 ±3.861 mm)
H	D-D	STA 1153	-0.078 ±0.132 in. (-1.981 ±3.353 mm)

SUBTASK 52-48-21-280-001

(4) Adjust the latches [2] as follows:

(a) Move the door 0.210 in. (5.334 mm) to the closed position.

CAUTION DO NOT USE MORE THAN HAND PRESSURE WHEN YOU CLOSE THE LATCHES. DO NOT USE TOOLS. IF YOU USE MORE THAN HAND PRESSURE, YOU CAN CAUSE DAMAGE TO THE LATCHES.

(b) Close the latches [2].

(c) Make sure that the force to close each latches [2] is 20 ±5 lbf (89 ±22 N) with the other latches [2] closed.

(d) If the force is out of tolerance, do one of these adjustments:

1) Adjust the stop bolt [18] to get the correct force.

NOTE: The head of the stop bolt [18] can be reversed to get the maximum clearance to the door structure.

2) Adjust the laminated shim [16] under the latch fitting [17].

a) Remove the bolts [19], bolts [20], washers [22], and washers [21] to get access to the laminated shim [16] between the latch fitting [17] and the empennage structure.

b) Install a new laminated shim [16] or remove laminations from the laminated shim [16] to get the correct force.

c) Apply primer, C00259, to the bare laminations of the laminated shim [16] before installation.

d) Install the bolts [19], bolts [20], washers [22], and washers [21] that hold the laminated shim [16] between the latch fitting [17] and empennage structure.

SUBTASK 52-48-21-280-002

(5) If it is necessary, adjust the lever arms [9].

(a) Loosen the fasteners.

(b) Reposition the serrated washers.

(c) Re-torque the fasteners.

(d) Open and close the APU cowl door [1].

(e) Make sure that the APU cowl door [1] operates smoothly.

(f) Make sure that the door release mechanism operates smoothly.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

H. Auxiliary Power Unit (APU) Cowl Door Installation Test

SUBTASK 52-48-21-710-001

(1) Do a test on the APU cowl door [1] as follows:

(a) Open and close and latch the APU cowl door [1].

(b) Make sure that the latches [2] operate correctly.

(c) Make sure that the APU cowl door [1] opens and closes smoothly.

(d) Make sure that the hold-open rods [5] operate correctly.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FORWARD ACCESS DOOR - MAINTENANCE PRACTICES

1. General

A. This procedure contains one task, Forward Access Door Corrosion Prevention.

TASK 52-48-31-600-801

2. Forward Access Door Corrosion Prevention

A. References

Reference	Title
12-25-41-640-802	Forward Access Door Servicing (P/B 301)

B. Consumable Materials

Reference	Description	Specification
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

C. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

D. General

SUBTASK 52-48-31-800-001

(1) Corrosion may occur on the internal and external surfaces of the door structure. Especially the connection points and the door mechanism.

(2) The door and the door frame should be treated at the same time.

(3) Some items in this section maybe subject to the mandatory requirements for corrosion prevention and control programs for aging airplanes.

(4) Corrosion Prevention

(a) Inspect the door.

(b) Look for missing fasteners, white powdery deposits, and discolorations, as signs of corrosion.

1) If signs of corrosion are found, then a corrosion prevention program should be started to prevent the build up of corrosion products.

2) If corrosion products are allowed to build up, then they will cause further corrosion.

(c) After the corrosion products are cleaned, make sure that the protective finishes are serviceable.

1) If only minor corrosion is found, then make sure that the area is clean.

2) Apply corrosion inhibiting compound on the affected area.

3) Make sure that the protective finish is restored at the next maintenance opportunity.

(5) Frequency of Application

(a) Periodic inspection is required to areas identified as prone to corrosion and should be scheduled to your Maintenance Planning Document.

(b) Periodic application of BMS 3-23 compounds are necessary to areas identified as prone to corrosion and should be scheduled to your Maintenance Planning Document.

1) Do the prevention treatment to the exterior surface of the door at the same recommended interval as the exterior surface of the fuselage.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E. Corrosion Prevention

SUBTASK 52-48-31-620-001

(1) Prevention Treatment

(a) Clean the drains and drain paths.

(b) Examine the door to find corrosion and damage to the protective finish.

1) Remove or repair any corrosion that you find.

(c) Apply corrosion inhibiting compound, G00009 to the interior surfaces of the door.

1) Make sure that the corrosion inhibiting compound, G00009 completely covers the surfaces.

(d) Apply corrosion inhibiting compound, G00009 to the door frame and the upper and lower web.

(e) If it is necessary, apply corrosion inhibiting compound, G00009 to the exterior surfaces of the door.

(f) Lubricate the door. Forward Access Door Servicing, TASK 12-25-41-640-802

(g) Doors with drain valves, do these steps:

1) Clean the drain hole.

2) Examine the drain seal or plunger for alignment and freedom of movement.

a) If it is necessary, remove the drain valve from the door and clean the debris.

<1> If it is necessary, replace the drain valve.

b) Install the drain valve.

CAUTION DO NOT APPLY MORE THAN THE MAXIMUM SPECIFIED TORQUE WHEN YOU TIGHTEN THE PARTS. DAMAGE TO THE PARTS CAN OCCUR IF YOU APPLY TOO MUCH TORQUE.

<1> Tighten the fasteners to 10 to 15 pound inches (1.1-1.7 Nm).

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FORWARD ACCESS DOOR - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the forward access door

(2) An installation of the forward access door.

TASK 52-48-31-000-801

2. Forward Access Door Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the forward access door.

B. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

C. Prepare for the Removal

SUBTASK 52-48-31-010-001

(1) Open the forward access door [1] and engage the hold-open fitting [2].

D. Forward Access Door Removal

SUBTASK 52-48-31-020-001

(1) Remove the forward access door [1].

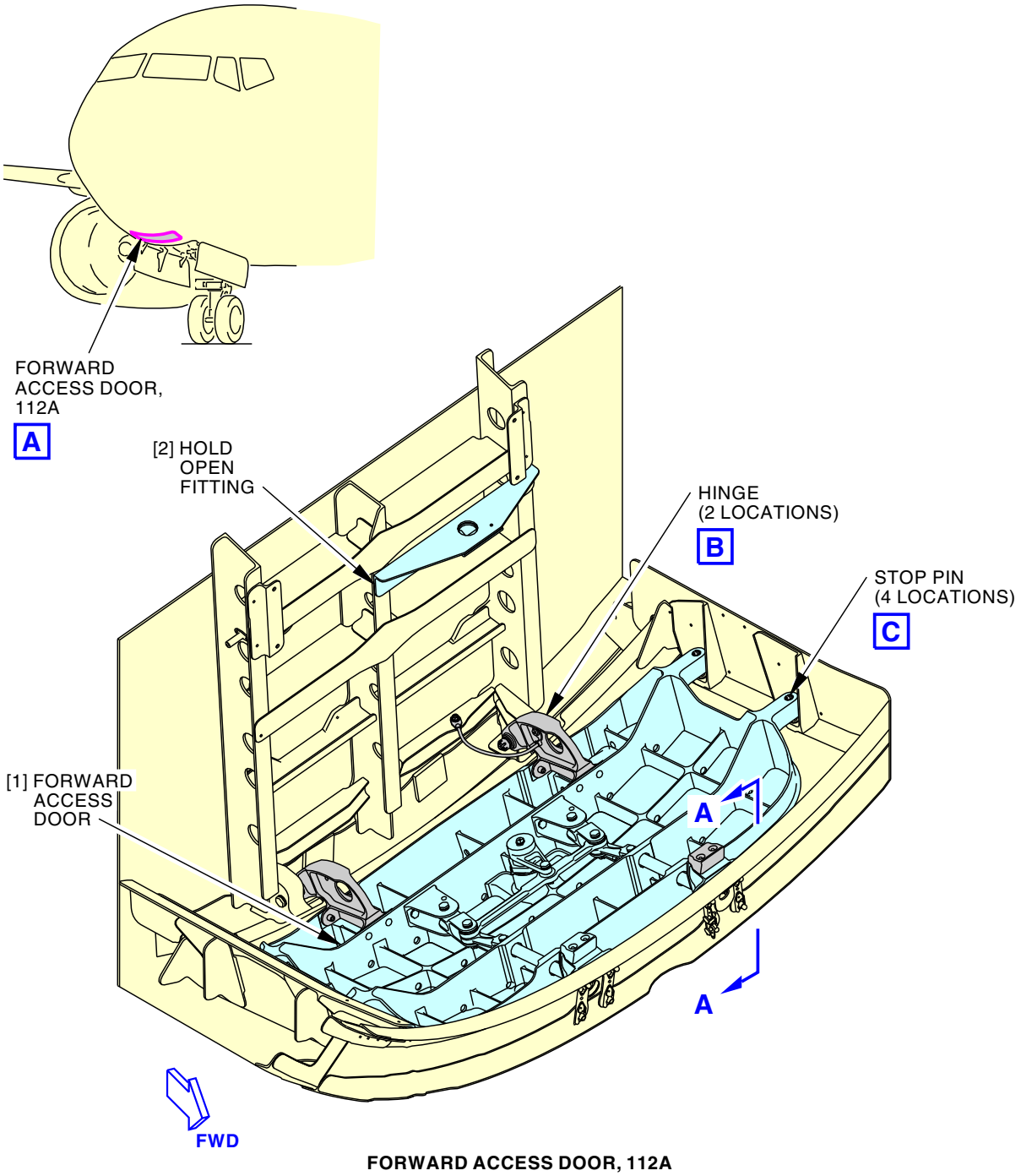
(a) Disconnect the nut [5], washer [4] and terminal lug of the jumper [3] from the structure.

(b) Remove the bolts [8], washers [9], bushings [10], washers [11], washers [12], washers [13], washers [16], nuts [14], and cotter pins [15] that attach the hinge arms [6] to the hinge support fittings [7].

(c) Remove the forward access door [1] from the airplane.

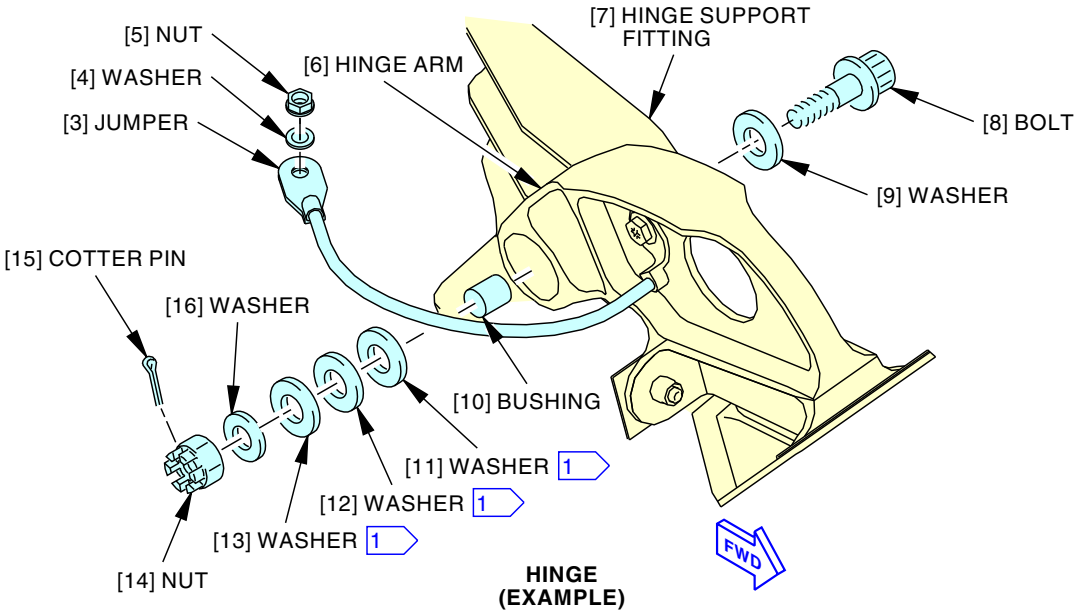
END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



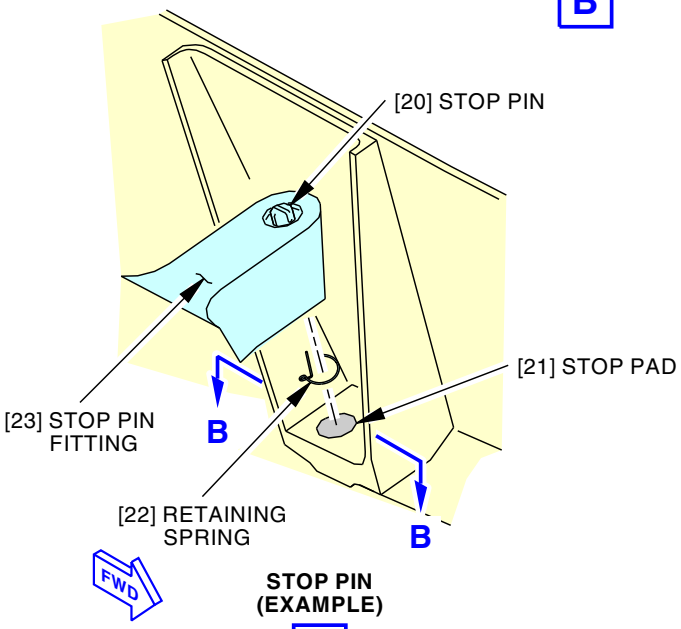
Forward Access Door Installation
Figure 401/52-48-31-990-803 (Sheet 1 of 3)

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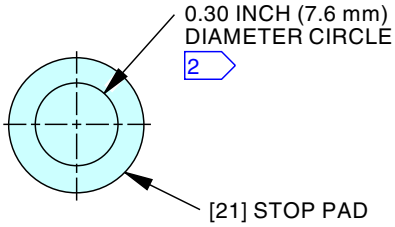
HINGE (EXAMPLE)

B



STOP PIN (EXAMPLE)

C



STOP PIN AND STOP PAD ALIGNMENT

B-B

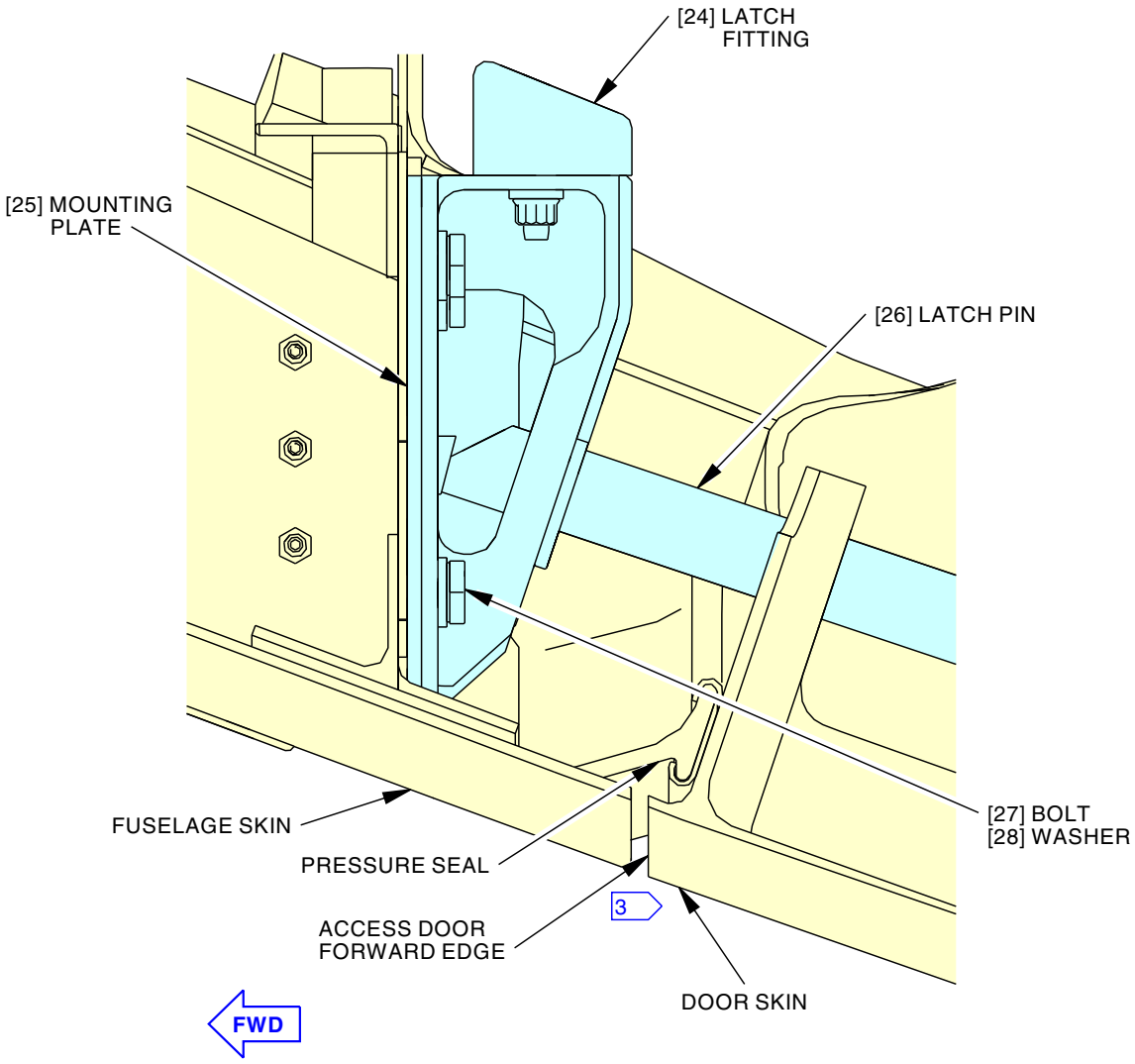
1 RELOCATE THESE WASHERS FROM ONE SIDE TO THE OTHER SIDE AS REQUIRED TO PUT THE DOOR IN THE CENTER OF THE CUTOUT.

2 THE CENTER OF THE STOP PIN MUST TOUCH THE CENTER OF THE STOP PAD IN THE CIRCLE SHOWN.

2415941 S00061539217_V2

Forward Access Door Installation
Figure 401/52-48-31-990-803 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



LATCH FITTING

A-A

3 DOOR TO CUTOUT SKIN GAPS 0.120 ±0.060 INCH (3.05 ±1.52 mm), AROUND THE ENTIRE DOOR EDGE. DOOR TO CUTOUT SKIN FLUSHNESS -0.065 ±0.015 INCH (-1.65 ±0.38 mm), AROUND THE ENTIRE DOOR EDGE.

2415942 S00061539218_V2

Forward Access Door Installation
Figure 401/52-48-31-990-803 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-48-31-400-801

3. Forward Access Door Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the forward access door.

(2) Make sure that the airplane fuselage is supported by its landing gear.

B. References

Reference	Title
52-71-41-710-801	Forward Access Door Indication Switch Test (P/B 201)
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES

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-614	Bonding Meters - Non-Intrinsically Safe (For use in outside Class I, Divisions I & II non-hazardous locations. For hazardous locations, use COM-1550). Part #: 247000 Supplier: 00426 Part #: 620LK Supplier: 1CRL2 Part #: BLR-0003-XX Supplier: KC432 Part #: BT51 Supplier: 00426 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659 Opt Part #: 247001 Supplier: 00426
COM-754	Scale - Spring, 0-150 Pounds, With Hook and Pad Adapter Kit Part #: DG-200 Supplier: 92456 Opt Part #: DPPH-150 Supplier: 92456

D. Consumable Materials

Reference	Description	Specification
B00130	Alcohol - Isopropyl	TT-I-735
D00504	Grease - Petrolatum	VV-P-236
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)
G02020	Clay, Modeling	

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Forward access door	52-48-31-01-070	SIA ALL
15	Cotter pin	52-48-31-01-005	SIA ALL

F. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

ECCN 9E991 BOEING PROPRIETARY - See title page for details

G. Prepare for the Installation

SUBTASK 52-48-31-820-001

(1) If you will install a different forward access door [1], move the latch fittings [24] to the lowest position:

NOTE: This step lets the forward access door be adjusted without interference from the latch fittings.

(a) Loosen the bolts [27] that attach the latch fittings [24] to the mounting plates [25].

(b) Move the latch fittings [24] to the lowest position.

(c) Tighten the bolts [27] that attach the latch fittings [24] to the mounting plates [25].

SUBTASK 52-48-31-820-002

(2) Adjust the stop pins [20] to extend 0.20 in. (5.08 mm) from the stop pin fittings [23] .

(a) Remove the retaining springs [22] in the stop pins [20].

(b) Turn the stop pins [20] to get the correct length.

(c) Install the retaining springs [22] in the stop pins [20].

H. Forward Access Door Installation

SUBTASK 52-48-31-420-001

(1) Attach the forward access door [1] to the hinge support fittings [7]:

(a) Hold the forward access door [1] in a fully opened position, engaged in the hold-open fitting [2].

NOTE: There is no access to the attaching parts with the forward access door in a fully open position.

(b) Align the hinge arms [6] with the hinge support fittings [7].

(c) Loosely install the bolts [8], washers [9], bushings [10], washers [11], washers [12], washers [13], washers [16], and nuts [14] to attach the hinge arms [6] to the hinge support fittings [7].

1) Install the bolts [8] with the heads outboard.

SUBTASK 52-48-31-820-003

(2) Close the forward access door [1] and visually check the initial fit.

(a) Make sure that the clearances around the forward access door [1] are visually equal.

(b) Make sure that the forward access door [1] and door surround structure do not touch.

SUBTASK 52-48-31-820-006

(3) Do a check of the forward access door [1] clearance:

NOTE: A check of the forward access door skin clearance can be completed by Method 1 or Method 2 (Aero-Averaging).

(a) To do a check of the clearance with Method 1, do these steps:

1) Close the forward access door [1].

2) Measure the distance from the forward access door skin to the fuselage skin.

3) Make sure that the skin clearance is within tolerance (Table 401).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Table 401/52-48-31-993-805 Aerosmoothness Limits - Forward Access Door (Method 1)

	CLEARANCE *[1]		FLUSHNESS *[2]	
	NOMINAL inch (mm)	TOLERANCE inch (mm)	NOMINAL inch (mm)	TOLERANCE inch (mm)
FORWARD ACCESS DOOR	0.12 in. (3.05 mm)	0.06 in. (1.52 mm) - 0.18 in. (4.57 mm)	-0.065 in. (-1.65 mm)	-0.050 in. (-1.27 mm) - -0.080 in. (-2.03 mm)

*[1] SKIN CLEARANCE ALL AROUND THE FORWARD ACCESS DOOR.

*[2] FLUSHNESS ALL AROUND THE FORWARD ACCESS DOOR.

(b) To do a check of the clearance with Method 2, do these steps:

1) Close the forward access door [1].

2) Measure the distance from the forward access door skin to the fuselage skin.

3) Make sure that the skin clearance is within tolerance (Table 402).

Table 402/52-48-31-993-806 Aero-Averaging Limits - Forward Access Door (Method 2)

	CLEARANCE *[1]		FLUSHNESS *[2]	
	NOMINAL inch (mm)	TOLERANCE inch (mm)	NOMINAL inch (mm)	TOLERANCE inch (mm)
FORWARD ACCESS DOOR	0.12 in. (3.05 mm)	0.06 in. (1.52 mm) - 0.21 in. (5.33 mm)	-	-

*[1] SKIN CLEARANCE ALL AROUND THE FORWARD ACCESS DOOR.

*[2] FLUSHNESS ALL AROUND THE FORWARD ACCESS DOOR.

(c) To make sure that the forward access door [1] is sufficiently adjusted by Method 2, do these steps:

1) Close the forward access door [1].

2) Measure the clearance between the forward access door skin and fuselage skin along the forward and aft edges of the forward access door [1] at the locations that follow:

a) Make five marks that are spaced equally along the forward edge of the forward access door [1].

NOTE: Include the forward access door corner tangent points.

b) Make five marks that are spaced equally along the aft edge of the forward access door [1].

NOTE: Include the forward access door corner tangent points.

c) Measure the skin clearance within 1 in. (25 mm) of each mark along the forward and aft edges of the forward access door [1].

d) Record the skin clearance for each measurement.

e) Change the clearance to a drag value (Table 403).

NOTE: A measurement of 0.10 in. (2.54 mm) clearance is a drag value of 0.63.

f) Record the drag value for each measurement (Table 403).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Table 403/52-48-31-993-807 Forward Access Door Skin Clearance (Method 2)

CLEARANCE inch (mm)	DRAG VALUE
0.06 in. (1.52 mm)	0.38
0.07 in. (1.78 mm)	0.44
0.08 in. (2.03 mm)	0.50
0.09 in. (2.29 mm)	0.56
0.10 in. (2.54 mm)	0.63
0.11 in. (2.79 mm)	0.69
0.12 in. (3.05 mm)	0.75
0.13 in. (3.30 mm)	0.81
0.14 in. (3.56 mm)	0.88
0.15 in. (3.81 mm)	0.94
0.16 in. (4.06 mm)	1.00
0.17 in. (4.32 mm)	1.06
0.18 in. (4.57 mm)	1.12
0.19 in. (4.83 mm)	1.19
0.20 in. (5.08 mm)	1.25
0.21 in. (5.33 mm)	1.31

g) Add all the drag values together (sum).

<1> Record the sum of the drag values as measurement A.

h) Divide measurement A by the number of measurements that you made.

i) Make sure that the average drag value is 1.00 or less.

SUBTASK 52-48-31-820-007

(4) If the skin clearance is not within tolerance or the average drag value is greater that 1.00, adjust the skin clearance as follows:

(a) Remove the nuts [14].

(b) Relocate the washers [11], washers [12], and washers [13] on the bolts [8] from one hinge arm [6] to the other until you get the correct clearance.

(c) Do not violate stop pin [20]/stop pad [21] alignment requirements.

(d) Install the nuts [14].

1) After you tighten the nuts [14], make sure that you can turn the washers [11], washers [12], washers [13].

SUBTASK 52-48-31-820-008

(5) Adjust the flushness of the forward access door [1] and gap of the stop pins [20].

NOTE: A check of the forward access door flushness can be completed by Method 1 or Method 2 (Aero-Averaging).

(a) Close, but do not latch, the forward access door [1].

(b) Use the spring scale, COM-754, to pull down on the forward access door handle with approximately enough force, 150 lb (68.04 kg) maximum, to compress the pressure seal and make the stop pins [20] touch the stop pads [21].

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(c) If you will use Method 1 to do a check of the flushness, make sure that your measurements are within tolerance (Table 401).

(d) If you will use Method 2 to do a check of the flushness, measure the flushness between the forward access door skin and fuselage skin along the forward and aft edges of the forward access door at the locations that follow:

1) Make five marks that are spaced equally along the forward edge of the forward access door.

NOTE: Include the forward access door corner tangent points.

2) Make five marks that are spaced equally along the aft edge of the forward access door.

NOTE: Include the forward access door corner tangent points.

3) Measure the skin flushness within 1 in. (25 mm) of each mark along the forward and aft edges of the forward access door.

4) Record the skin flushness for each measurement.

5) Change the flushness to a drag value (Table 404).

NOTE: A measurement of -0.10 in. (-2.54 mm) flushness at the door fwd edge is a drag value of 0.65.

6) Record the drag value for each measurement (Table 404).

Table 404/52-48-31-993-804 Forward Access Door Skin Flushness (Method 2)

Door Flushness		
Fwd Edge inch (mm)	**Aft Edge inch (mm)**	**Drag Value**
-0.13 in. (-3.30 mm)	0.02 in. (0.51 mm)	1.67
-0.12 in. (-3.05 mm)	0.00 in. (0.00 mm)	1.33
-0.11 in. (-2.79 mm)-	-0.02 in. (-0.51 mm)	1
-0.10 in. (-2.54 mm)	-0.04 in. (-1.02 mm)	0.65
-0.09 in. (-2.29 mm)	-0.05 in. (-1.27 mm)	0.43
-0.08 in. (-2.03 mm)	-0.06 in. (-1.52 mm)	0.19
-0.07 in. (-1.78 mm)	-0.07 in. (-1.78 mm)	0.00
-0.06 in. (-1.52 mm)	-0.08 in. (-2.03 mm)	0.06
-0.05 in. (-1.27 mm)	-0.09 in. (-2.29 mm)	0.19
-0.04 in. (-1.02 mm))	-0.10 in. (-2.54 mm)	0.56
-0.03 in. (-0.76 mm)	-0.11 in. (-2.79 mm)	0.90
-0.02 in. (-0.51 mm)	-0.12 in. (-3.05 mm)	1.28
-0.01 in. (-0.25 mm)	-0.13 in. (-3.30 mm)	1.90

7) Add all of the drag values together (sum).

a) Record the sum of the drag values as Measurement A.

8) Divide measurement A by the number of measurements that you made.

9) Make sure that the average drag value is 1.00 or less.

(e) If the skin flushness is not within tolerance or if the average drag value is greater than 1.00, adjust the forward access door [1] as follows:

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1) Remove the spring scale, COM-754.
2) Open the forward access door [1].
3) Remove the retaining springs [22] from the stop pins [20].
4) Turn the stop pins [20] to get the correct flushness.
5) Install the retaining springs [22] in the stop pins [20].

(f) Do a check of the clearance between the stop pins [20] and stop pads [21].

1) Open the forward access door [1].
2) Put a small quantity of clay, G02020, on the stop pads [21].

NOTE: A small quantity of grease, D00504, on the stop pins will prevent clay, G02020, from pulling off the stop pads.

3) Close, but do not latch, the forward access door [1].
4) Use the spring scale, COM-754, to pull down on the forward access door handle with approximately enough force, 150 lb (68.04 kg) maximum, to compress the pressure seal and make the stop pins [20] touch the stop pads [21].
5) Open the forward access door [1].
6) Measure the thickness of clay, G02020, remaining on the stop pads [21].
7) Make sure that the thickness is -0.050 in. (-1.27 mm) - -0.080 in. (-2.03 mm).
8) If it is out of tolerance, do these steps:
   a) Remove the retaining springs [22] from the stop pins [20].
   b) Turn the stop pins [20] to get the correct clearance.
   c) Install the retaining springs [22] in the stop pins [20].

(g) Do a check of the alignment the stop pins [20] and stop pads [21].

1) Make sure that the centers of the stop pins [20] touch the stop pads [21] in a 0.30 in. (7.6 mm) diameter circle at the center of the stop pads [21] (View C, Figure 401).

(h) If it is necessary, align the stop pins [20] with the stop pads [21].

1) Remove the nuts [14].
2) Add or remove the washers [11], washers [12], and washers [13] on the bolts [8] until the stop pins [20] align with the stop pads [21].
   a) Do not make the skin clearance incorrect.
   b) Adjust the hinge arms [6] equally to prevent load in the hinge arms [6].
3) Install the nuts [14].
   a) After you tighten the nuts [14], make sure that you can turn the washers [11], washers [12], and washers [13].

SUBTASK 52-48-31-420-004

(6) Install the new cotter pins [15] in the nuts [14].

SUBTASK 52-48-31-820-009

(7) Do a check of the hinge pins clearance.

NOTE: This step makes sure that the hinge pins do not carry a load in flight.

(a) Close and latch the forward access door [1].

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(b) Use the spring scale, COM-754, to pull the forward access door [1] down at the handle with enough force, 150 lb (68.04 kg) maximum, to compress the pressure seal and make the stop pins [20] touch the stop pads [21].

(c) Measure the flushness at the aft edge of the forward access door [1].

(d) Release the handle.

(e) Remove the spring scale, COM-754.

(f) Push the aft edge of the door up.

(g) Measure the flushness at the aft edge of the forward access door [1] again.

(h) Make sure that the difference between the two flushness dimensions is 0.10 ±0.07 in. (2.54 ±1.78 mm).

(i) If the dimension is not in tolerance, repeat the steps to adjust the stop pins [20].

1) Do not make the skin flushness incorrect.

SUBTASK 52-48-31-820-010

(8) Do a check of the latch pin [26] and latch fitting [24] clearance.

NOTE: This step makes sure that the latch pins do not carry a load in flight.

(a) Close and unlatch the forward access door [1].

NOTE: The latch pins are retracted from the latch fittings.

(b) Use the spring scale, COM-754, to pull the forward access door [1] down at the handle with enough force, 150 lb (68.04 kg) maximum, to compress the pressure seal and make the stop pins [20] touch the stop pads [21].

(c) Measure and record the flushness at the forward edge of the forward access door [1].

(d) Remove the spring scale, COM-754, from the forward access door [1].

(e) Move the handle to the latched position.

NOTE: The latch pins extend into the latch fittings.

(f) Make sure that the latch pins [26] do not have a load on them.

NOTE: The latch pins move freely.

(g) Push up on the forward edge of the latched door until the latch pins [26] touch the latch fittings [24].

(h) Measure and record the flushness at the forward edge of the forward access door [1].

(i) Make sure that the difference between the two flushness dimensions is 0.030 in. (0.76 mm) - 0.105 in. (2.67 mm).

(j) If the flushness dimension is not in tolerance, adjust the latch fittings [24] position.

1) Open the forward access door [1].

2) Loosen the bolts [27] and washers [28] that attach the latch fittings [24] to the mounting plates [25].

3) Move the latch fittings [24] inboard or outboard as necessary and tighten the bolts [27].

4) Repeat the steps to do a check of the latch pins [26] and latch fittings [24] clearances.

5) Close the forward access door [1].

SUBTASK 52-48-31-420-003

(9) Install the nut [5] and washer [4] to connect the terminal lug of the jumper [3] to the structure.

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(a) Use cotton wiper, G00034, moist in alcohol, B00130, to clean the mating surfaces of the airplane structure, nut [5], washer [4], and terminal lug of the jumper [3].

(b) Install the nut [5], washer [4], and terminal lug of the jumper [3].

(c) Tighten the nut [5] to 28 in-lb (3 N·m) - 35 in-lb (4 N·m).

(d) Measure the electrical resistance between the terminal lug of the jumper [3] and airplane structure (SWPM 20-20-00).

1) Use a non-intrinsically safe bonding meter, COM-614.

2) Make sure that the electrical bonding resistance is 0.001 ohm (1.0 milliohm) or less.

SUBTASK 52-48-31-820-011

(10) Do this task: Forward Access Door Indication Switch Test, TASK 52-71-41-710-801.

I. Forward Access Door Installation Test

SUBTASK 52-48-31-820-012

(1) Do a test of the forward access door [1] as follows:

(a) Unlatch, open, and engage the hold-open fitting [2].

(b) Disengage the hold-open fitting [2], close and latch the forward access door [1].

(c) Make sure that the handle and latch pins [26] operate correctly and forward access door [1] opens and closes smoothly.

(d) Make sure that the pressure seal is installed correctly.

——— END OF TASK ———

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FORWARD ACCESS DOOR - INSPECTION/CHECK

1. General

A. This procedure has these tasks:

(1) An inspection of the forward access door.

(2) An inspection of the forward access door pressure seal.

TASK 52-48-31-200-801

2. Forward Access Door Check

A. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

B. Access Panels

Number	Name/Location
112A	Forward Access Door

C. Prepare for the Inspection

SUBTASK 52-48-31-840-001

(1) Open this access panel:

Number	Name/Location
112A	Forward Access Door

(a) Engage the hold-open fitting.

NOTE: It may be necessary to disengage the hold-open fitting to do part of the inspection.

D. Forward Access Door Inspection

SUBTASK 52-48-31-210-001

(1) Do a visual inspection of the external door structure and handle as follows:

(a) Examine the external skin.

1) Look for dents, cracks, and corrosion.

2) Look for burrs.

3) Look for loose and missing fasteners.

(b) Examine the external handle.

1) Look for cracks and corrosion.

2) Look for too much wear.

SUBTASK 52-48-31-210-002

(2) Do a visual inspection of the door internal structure as follows:

(a) Examine the internal skin.

1) Look for dents, cracks, and corrosion.

2) Look for burrs.

3) Look for loose and missing fasteners.

(b) Examine the internal frames and brackets.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-48-31-210-003

(3) Do a visual inspection of the latch mechanism as follows:

(a) Examine the latch pin.

1) Look for cracks and corrosion.

2) Look for too much wear.

3) Look for unwanted particles on the latch pin.

SUBTASK 52-48-31-210-004

(4) Do a visual inspection of the stop fittings and stop pins as follows:

(a) Examine the stop fittings.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

(b) Examine the stop pins.

1) Look for cracks and corrosion.

2) Look for unwanted particles on the stop pins.

3) Make sure the retaining springs are installed.

SUBTASK 52-48-31-210-005

(5) Do a visual inspection of the attach structure and hinge mechanism as follows:

(a) Examine the hinge arms.

1) Look for cracks and corrosion.

2) Look for too much wear.

(b) Examine the hinge arm fasteners.

1) Make sure the bolts fully engage the nuts.

2) Make sure the bolt threads are not damaged.

SUBTASK 52-48-31-210-006

(6) Do a visual inspection of the structure around the door opening as follows:

(a) Examine the latch receptacle.

1) Look for cracks and corrosion.

2) Look for too much wear.

(b) Examine the fuselage frame.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 52-48-31-840-002

(1) Close and latch this access panel:

Number	Name/Location
112A	Forward Access Door

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-48-31-200-802

3. Forward Access Door Pressure Seal Check

(Figure 601)

A. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

B. Access Panels

Number	Name/Location
112A	Forward Access Door

C. Prepare for the Inspection

SUBTASK 52-48-31-010-002

(1) Open this access panel:

Number	Name/Location
112A	Forward Access Door

(a) Engage the hold-open lock.

D. Forward Access Door Pressure Seal Inspection

SUBTASK 52-48-31-210-007

(1) Do a visual inspection of the door pressure seal as follows:

(a) Examine the seal.

1) Look for cracks, holes, and tears.

2) Look for indications of seal deterioration.

3) Make sure the seal is installed in the seal retainer.

E. Put the Airplane Back to Its Usual Condition

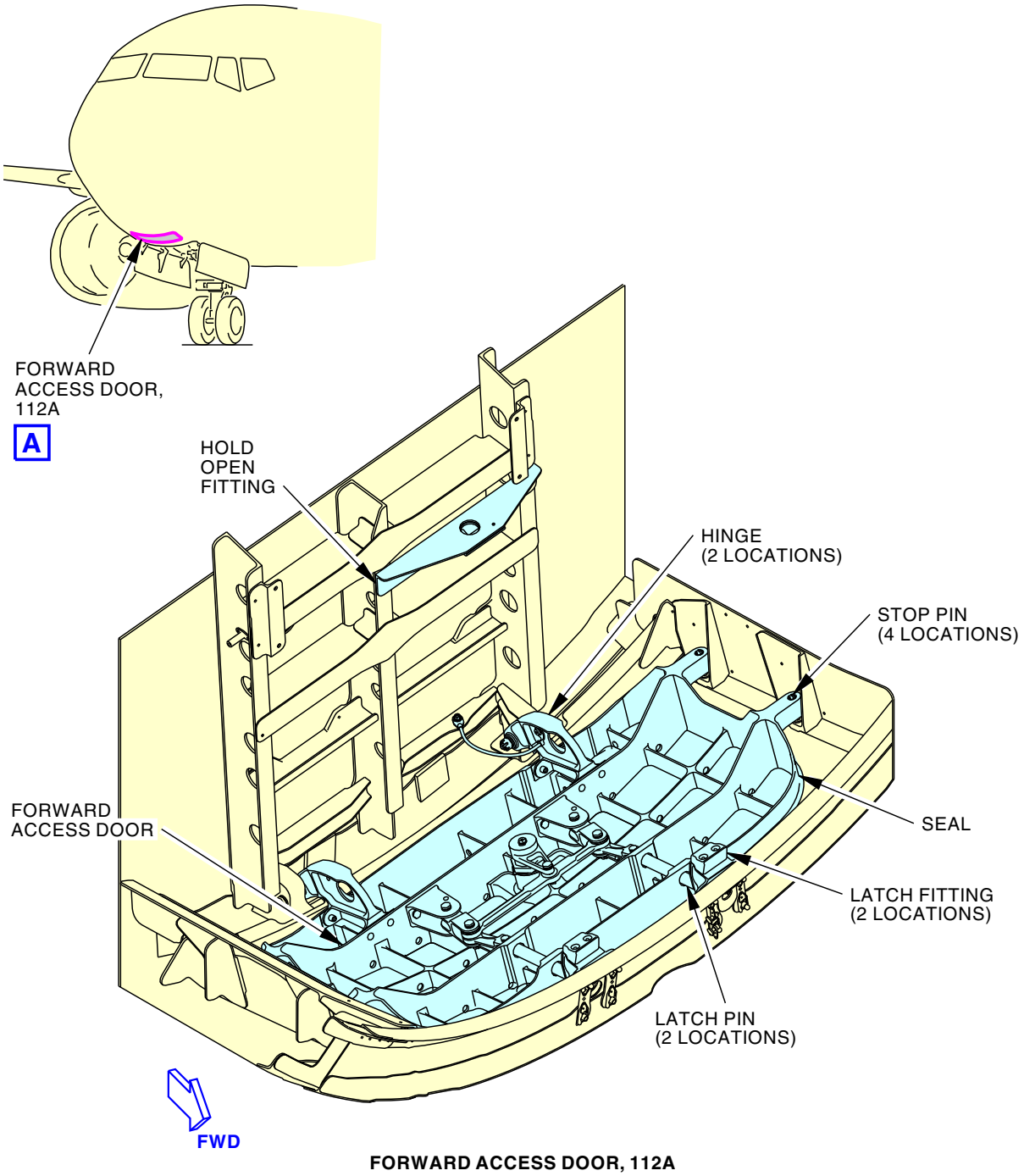
SUBTASK 52-48-31-840-003

(1) Close and latch this access panel:

Number	Name/Location
112A	Forward Access Door

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



FORWARD ACCESS DOOR, 112A

A

2415943 S00061539222_V1

Forward Access Door Pressure Seal Check
Figure 601/52-48-31-990-802

ECCN 9E991 BOEING PROPRIETARY - See title page for details

ELECTRONIC EQUIPMENT ACCESS DOOR - MAINTENANCE PRACTICES

1. General

A. This procedure has two tasks. The first task is to Open the Electronic Equipment Door When The Door Latch Will Not Operate. The second task is the Electronic Equipment Door Corrosion Prevention.

TASK 52-48-41-010-801

2. Open the Electronic Equipment Door when the Door Handle will not Move

A. General

(1) It is recommended, but not necessary, that two persons do this task. One person will go into the electronic equipment bay compartment through the steps given in this task. One person will open the electronic equipment access door from outside the airplane.

B. References

Reference	Title
24-22-00-860-801	Supply Electrical Power (P/B 201)
24-22-00-860-802	Remove Electrical Power (P/B 201)
24-31-11-000-801-002	Battery Removal (P/B 401)
24-31-11-400-801-002	Battery Installation (P/B 401)
50-11-01-000-801	Forward Cargo Compartment Forward Bulkhead Liner Removal (P/B 401)
50-11-01-400-801	Forward Cargo Compartment Forward Bulkhead Liner Installation (P/B 401)

C. Tools/Equipment

Reference	Description
STD-10670	Pliers

D. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right

E. Gain Access to the Electronic Equipment Bay Compartment

SUBTASK 52-48-41-010-001

(1) Remove the lower panel assembly: Forward Cargo Compartment Forward Bulkhead Liner Removal, TASK 50-11-01-000-801.

(2) Make sure the electrical power is off: Remove Electrical Power, TASK 24-22-00-860-802.

(3) Do this task: Battery Removal, TASK 24-31-11-000-801-002.

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F. Prepare to enter the Electronic Equipment Bay Compartment

SUBTASK 52-48-41-943-001

CAUTION REMOVE ALL OBJECTS FROM YOUR POCKETS AND FROM YOUR BODY. LOOSE OBJECTS CAN FALL INTO THE ELECTRONIC EQUIPMENT COMPARTMENT. THIS CAN CAUSE DAMAGE TO THE AIRPLANE.

(1) Remove all items from your pockets.

(2) Remove all rings, earrings, watch, and other items that can separate from the body.

CAUTION USE TAPE TO SEAL ALL OPENINGS AND FLAPS ON YOUR CLOTHING. OPEN EDGES OF CLOTHING CAN CATCH ON WIRE BUNDLES. THIS CAN PULL WIRES LOOSE. THIS CAN CAUSE DAMAGE TO THE AIRPLANE.

(3) Use masking tape to seal all open cuffs, collars, fabric flaps, pockets, buttons, and zippers.

G. Access the Electronic Equipment Bay Compartment Door

SUBTASK 52-48-41-800-001

CAUTION DO NOT PUT PRESSURE ON THE WIRE BUNDLES, ELECTRONIC SYSTEMS, OR STRUCTURES IN THE COMPARTMENT. PRESSURE CAN CAUSE DAMAGE TO WIRE BUNDLES AND ELECTRICAL CONNECTIONS.

(1) Carefully go into the electronic equipment bay compartment through the space that was made when you removed the airplane batteries.

(2) Use pliers, STD-10670 to turn the shaft of the door handle counterclockwise until the bolt head and nut points forward and aft.

(3) Use the external handle to open the electronic equipment access door.

(4) Check the door for damage.

(5) Make sure that the door closes and opens smoothly.

H. Put the Airplane Back to its Usual Condition

SUBTASK 52-48-41-410-001

(1) Do this task: Battery Installation, TASK 24-31-11-400-801-002.

SUBTASK 52-48-41-861-001

(2) Do this task: Supply Electrical Power, TASK 24-22-00-860-801.

SUBTASK 52-48-41-410-002

(3) Replace the lower panel assembly: Forward Cargo Compartment Forward Bulkhead Liner Installation, TASK 50-11-01-400-801.

END OF TASK

TASK 52-48-41-600-801

3. Electronic Equipment Door Corrosion Prevention

A. References

Reference	Title
12-25-41-640-801	Electronic Equipment Access Door Servicing (P/B 301)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B. Consumable Materials

Reference	Description	Specification
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

C. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

D. General

SUBTASK 52-48-41-800-002

(1) Corrosion may occur on the internal and external surfaces of the door structure. Especially the connection points and the door mechanism.

(2) The door and the door frame should be treated at the same time.

(3) Some items in this section maybe subject to the mandatory requirements for corrosion prevention and control programs for aging airplanes.

(4) Corrosion Prevention

(a) Inspect the door.

(b) Look for missing fasteners, white powdery deposits, and discolorations, as signs of corrosion.

1) If signs of corrosion are found, then a corrosion prevention program should be started to prevent the build up of corrosion products.

2) If corrosion products are allowed to build up, then they will cause further corrosion.

(c) After the corrosion products are cleaned, make sure that the protective finishes are serviceable.

1) If only minor corrosion is found, then make sure that the area is clean.

2) Apply corrosion inhibiting compound on the affected area.

3) Make sure that the protective finish is restored at the next maintenance opportunity.

(5) Frequency of Application

(a) Periodic inspection is required to areas identified as prone to corrosion and should be scheduled to your Maintenance Planning Document.

(b) Periodic application of BMS 3-23 compounds are necessary to areas identified as prone to corrosion and should be scheduled to your Maintenance Planning Document.

1) Do the prevention treatment to the exterior surface of the door at the same recommended interval as the exterior surface of the fuselage.

E. Corrosion Prevention

SUBTASK 52-48-41-620-001

(1) Prevention Treatment

(a) Clean the drains and drain paths.

(b) Examine the door to find corrosion and damage to the protective finish.

1) Remove or repair any corrosion that you find.

(c) Apply corrosion inhibiting compound, G00009 to the interior surfaces of the door.

1) Make sure that the corrosion inhibiting compound, G00009 completely covers the surfaces.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(d) Apply corrosion inhibiting compound, G00009 to the door frame and the upper and lower web.

(e) If it is necessary, apply corrosion inhibiting compound, G00009 to the exterior surfaces of the door.

(f) Lubricate the door. Electronic Equipment Access Door Servicing, TASK 12-25-41-640-801

(g) Doors with drain valves, do these steps:

1) Clean the drain hole.

2) Examine the drain seal or plunger for alignment and freedom of movement.

a) If it is necessary, remove the drain valve from the door and clean the debris.

<1> If it is necessary, replace the drain valve.

b) Install the drain valve.

CAUTION DO NOT APPLY MORE THAN THE MAXIMUM SPECIFIED TORQUE WHEN YOU TIGHTEN THE PARTS. DAMAGE TO THE PARTS CAN OCCUR IF YOU APPLY TOO MUCH TORQUE.

<1> Tighten the fasteners to 10 to 15 pound inches (1.1-1.7 Nm).

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

ELECTRONIC EQUIPMENT ACCESS DOOR - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Electronic equipment access door removal

(2) Electronic equipment access door installation.

B. The electronic equipment access door is referred to as the "door" in this procedure.

TASK 52-48-41-000-801

2. Electronic Equipment Access Door Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the electronic equipment access door.

(2) This task has two procedures for the removal of the Electronic Equipment (E/E) Access Door. Procedure number 1 requires one person working from inside the E/E bay. Procedure number 2 requires two people. One person works from inside the E/E bay and the other person outside the E/E bay door to assist.

B. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

C. Prepare for the Removal

SUBTASK 52-48-41-010-002

(1) Open the door [7]:

(a) Push the release trigger [2] to release the handle [1].

(b) Turn the handle [1] to unlatch the door [7].

WARNING

TO PREVENT THE DOOR-BIND IN THE TRACKS, DO NOT LIFT THE DOOR AROUND THE EDGES. USE TWO HANDS WITH A LIGHT FORCE AND EQUAL PRESSURE TO LIFT THE DOOR. LET THE DOOR FOLLOW THE ROLLER TRACKS UP AND OUTBOARD. TOO MUCH FORCE CAN CAUSE DAMAGE TO THE DOOR ROLLERS. IF YOU DO NOT OBEY THIS WARNING, INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

(c) Move the door [7] to the fully open position.

D. Electronic Equipment Access Door Removal (Procedure 1)

SUBTASK 52-48-41-020-001

(1) Remove the forward and aft folding track assemblies [3] from the electrical and electronics compartment:

(a) Release the latches [8] that hold the folding track assemblies [3] in the extended position.

(b) Remove the bolts [13], washers [14], washers [17], and nuts [18] that attach the springs [15] and upper hinge lugs [16] to the attach stanchions.

(c) Lift the folding track assemblies [3] out of the lower hinge lugs [5].

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SUBTASK 52-48-41-020-002

(2) Remove the door [7] from the fixed tracks [4]:

(a) Hold the door [7] and move it towards the closed position until the roller trucks [19] and the right aft roller truck [24] disengage from the fixed tracks [4].

(b) Remove the door [7] from the airplane.

E. Electronic Equipment Access Door Removal (Procedure 2)

SUBTASK 52-48-41-020-003

(1) Remove the door [7] from the fixed tracks [4]:

WARNING TO PREVENT THE DOOR-BIND IN THE TRACKS, DO NOT LIFT THE DOOR AROUND THE EDGES. USE TWO HANDS WITH A LIGHT FORCE AND EQUAL PRESSURE TO LIFT THE DOOR. LET THE DOOR FOLLOW THE ROLLER TRACKS UP AND OUTBOARD. TOO MUCH FORCE CAN CAUSE DAMAGE TO THE DOOR ROLLERS. IF YOU DO NOT OBEY THIS WARNING, INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

(a) Open the door [7] and enter the electronic equipment bay.

WARNING DO NOT LOCK THE DOOR FROM THE OUTSIDE. THE ELECTRONIC EQUIPMENT ACCESS-DOOR DOES NOT HAVE A HANDLE ON THE INSIDE TO UNLOCK THE DOOR. IF THE DOOR IS LOCKED, INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

(b) Put the door in the close position.

(c) Release the latches [8] that hold the folding track assembliess [3] in the extended position.

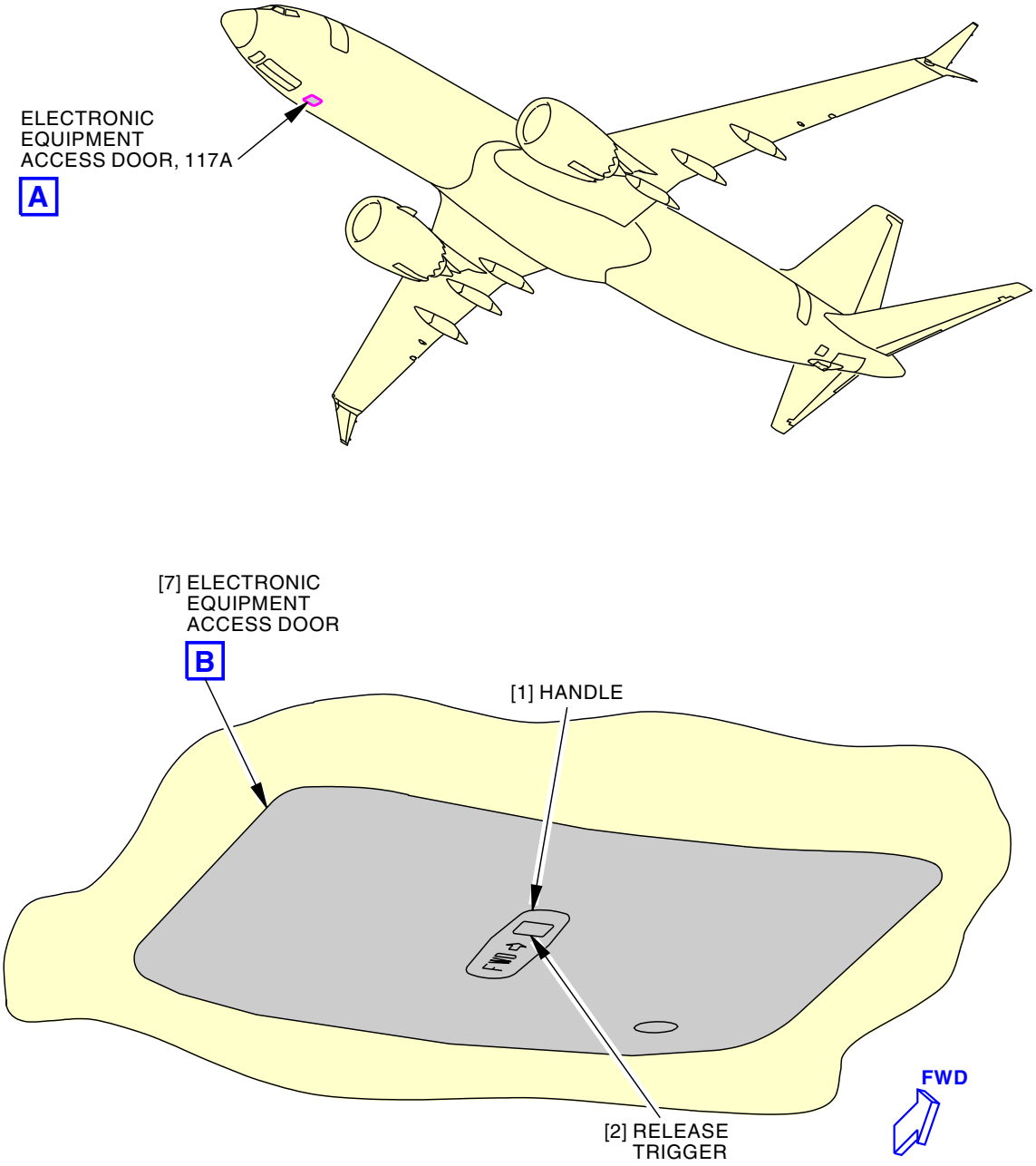
(d) Fold the forward and aft track.

(e) Lift and pull the door [7] until the rollers disengage from the fixed tracks.

(f) Remove the door [7] from the airplane.

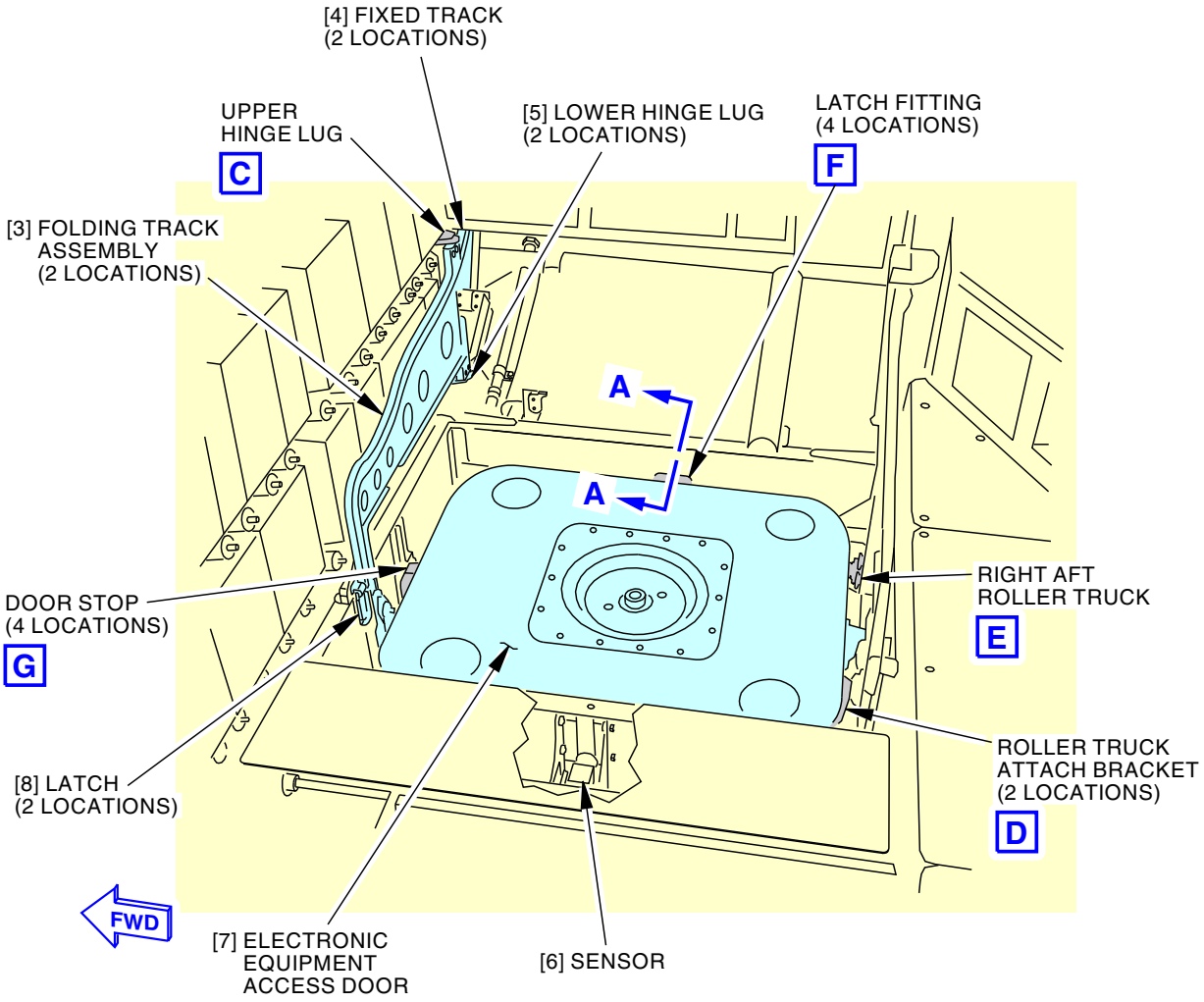
END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Electronic Equipment Access Door Installation
Figure 401/52-48-41-990-804 (Sheet 1 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



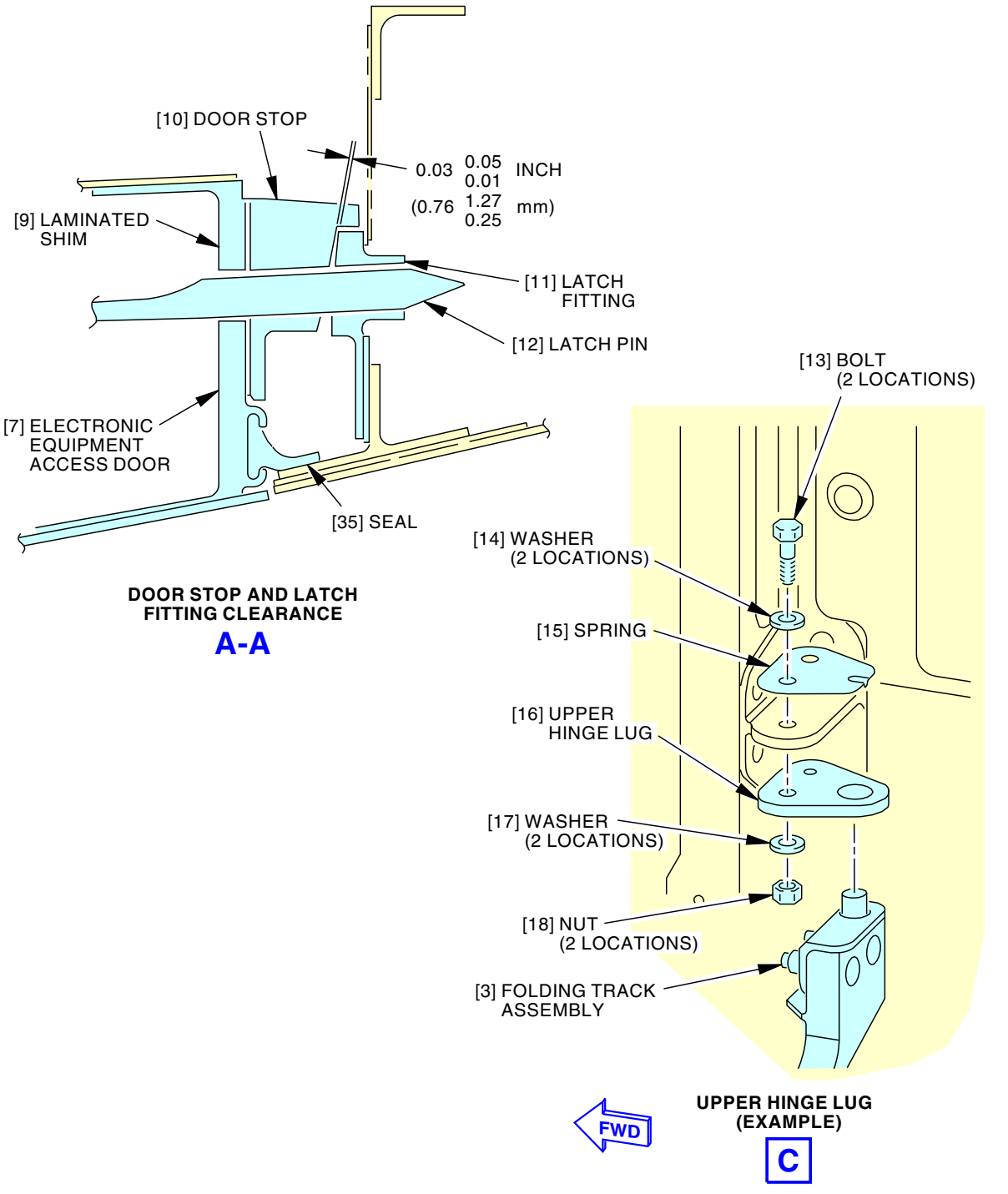
**ELECTRONIC EQUIPMENT ACCESS DOOR
(INTERNAL VIEW, DOOR CLOSED POSITION)
(EXAMPLE)**

B

2415945 S00061539232_V3

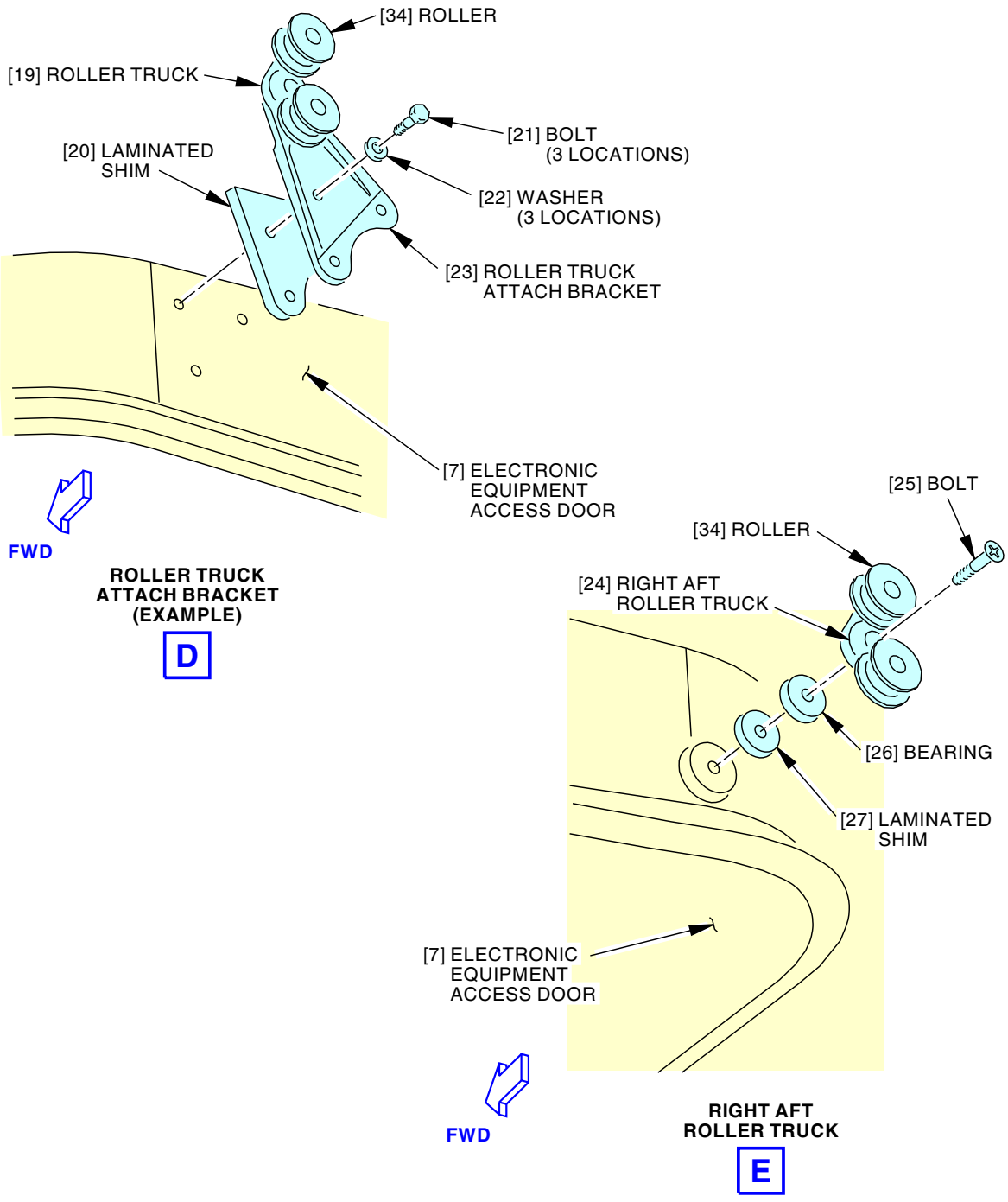
**Electronic Equipment Access Door Installation
Figure 401/52-48-41-990-804 (Sheet 2 of 5)**

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Electronic Equipment Access Door Installation
Figure 401/52-48-41-990-804 (Sheet 3 of 5)

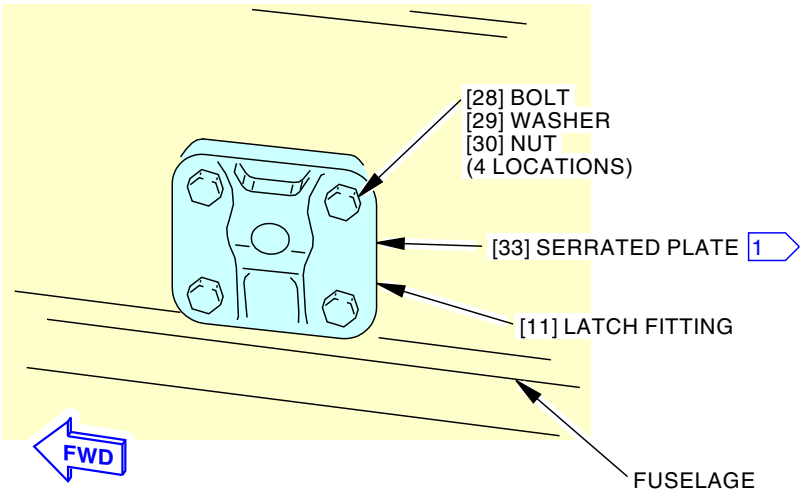
ECCN 9E991 BOEING PROPRIETARY - See title page for details



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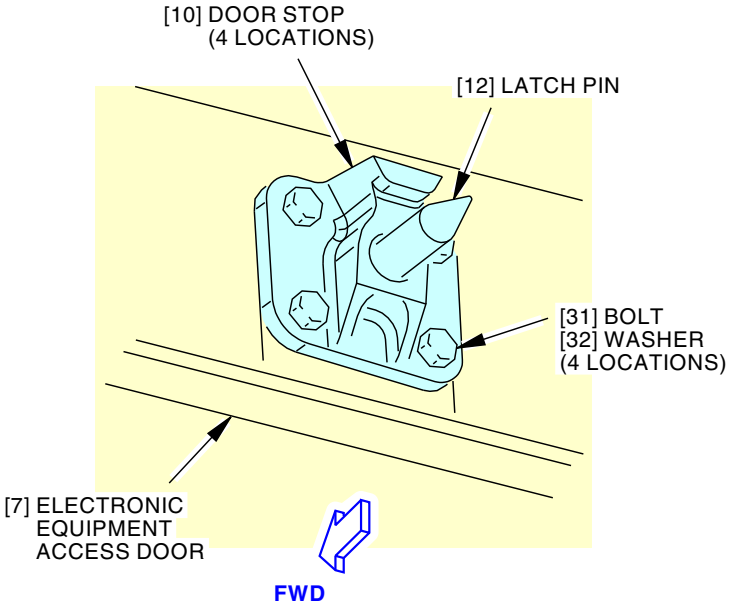
Electronic Equipment Access Door Installation
Figure 401/52-48-41-990-804 (Sheet 4 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



LATCH FITTING (EXAMPLE)

F



DOOR STOP (EXAMPLE)

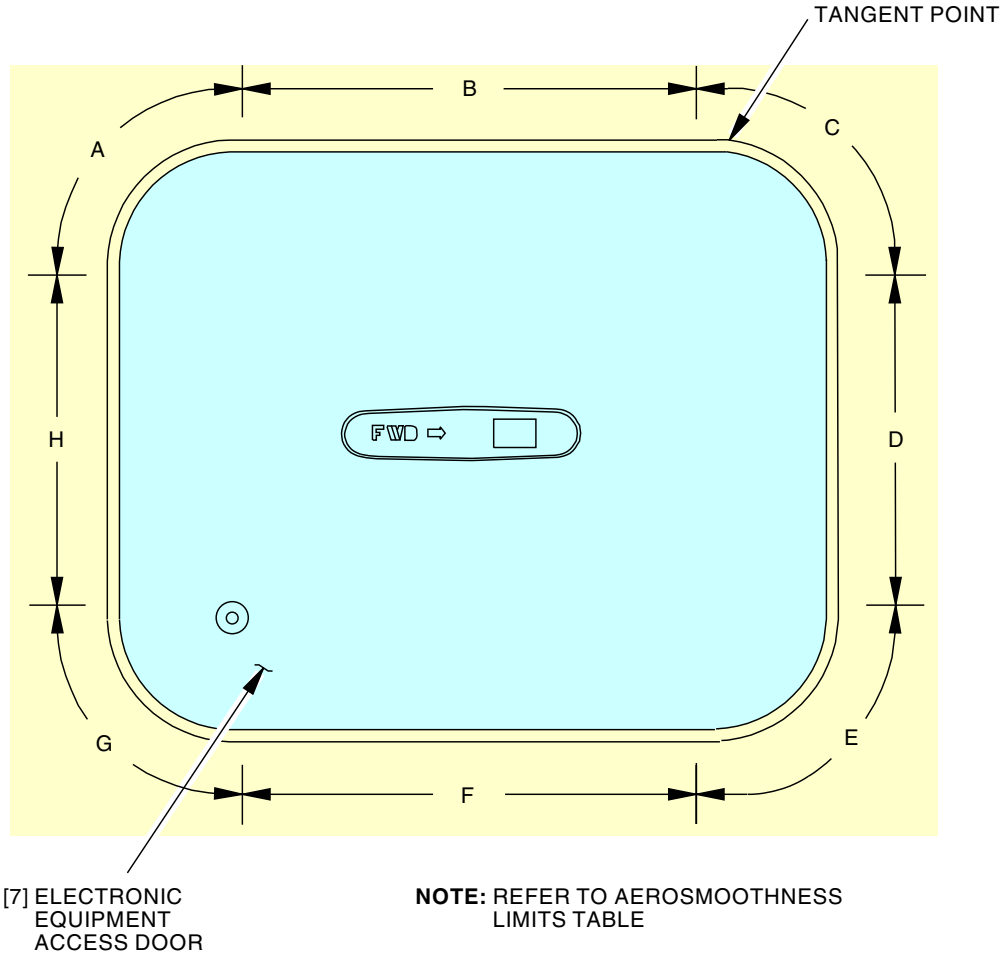
G

1 LEFT AND RIGHT LATCH FITTINGS ONLY

2415948 S00061539235_V1

Electronic Equipment Access Door Installation
Figure 401/52-48-41-990-804 (Sheet 5 of 5)

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SKIN CLEARANCE AND FLUSHNESS ZONES

2415949 S00061539236_V1

Electronic Equipment Access Door Skin Clearance and Flushness
Figure 402/52-48-41-990-805

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TASK 52-48-41-400-801

3. Electronic Equipment Access Door Installation

(Figure 401 and Figure 402)

A. General

(1) This task gives the instructions to install the electronic equipment access door.

(2) Make sure that the airplane is supported by its landing gear.

B. References

Reference	Title
52-71-42-710-801	Electronic Equipment Access Door Indication Switch Test (P/B 201)

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
7	Door	52-48-41-03-005	SIA ALL
20	Laminated shims	52-48-41-03-310	SIA ALL
		52-48-41-03-315	SIA ALL
27	Laminated shim	52-48-41-03-365	SIA ALL

E. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

F. Prepare for the Installation

SUBTASK 52-48-41-840-001

(1) Remove the forward and aft roller truck attach brackets [23] and the right aft roller truck [24] from the door [7] (Figure 401):

(a) Remove the bolts [21] and washers [22] that attach the roller truck attach brackets [23] and the laminated shims [20] to the door [7].

(b) Remove the roller truck attach brackets [23] and the laminated shims [20] from the door [7].

(c) Remove the bolt [25] and the bearing [26] that attach the right aft roller truck [24] and the laminated shim [27] to the door [7].

(d) Remove the right aft roller truck [24] and the laminated shim [27] from the door [7].

SUBTASK 52-48-41-840-002

(2) Move the handle [1] to the unlatched position.

G. Electronic Equipment Access Door Installation

SUBTASK 52-48-41-420-001

(1) Install the door [7] in the fuselage frame as follows:

(a) Hold the door [7].

(b) Put the door [7] in its correct position in the fuselage frame.

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(c) Latch the door [7].

(d) Make sure that the latch pins [12] are engaged in the latch fitings [11].

(e) If necessary, adjust the latch fitings [11] (Figure 401):

1) For the forward and aft latch fitings [11], loosen the bolts [28], washers [29], and nuts [30] that attach the latch fitings [11] to the latch supports on the fuselage frame.

2) For the left and right latch fitings [11], loosen the bolts [28], washers [29], and nuts [30] that attach the latch fitings [11] and serrated plates [33] to the fuselage frame.

3) Move the latch fitings [11] on the serrated plates [33] or serrated latch supports until the latch pins [12] engage the latch fitings [11].

4) Tighten the bolts [28], washers [29], and nuts [30] that attach the latch fitings [11] to the fuselage frame.

SUBTASK 52-48-41-820-001

(2) Adjust the door stops [10].

NOTE: Do these steps for each door stop [10].

(a) Close and latch the door [7].

(b) Measure the clearance between the door stop [10] and the latch fiting [11].

(c) Make sure that the clearance is as shown, (Figure 401). If necessary, adjust as follows:

1) Remove the bolts [31] and washers [32] that attach the door stop [10] and the laminated shim [9] to the door [7].

2) Remove laminations from the laminated shim [9] or install a new laminated shims [20] to get the correct clearance.

3) Apply the sealant, A00247 to both sides of the laminated shim [9].

4) Install the bolts [31] and washers [32] that attach the door stop [10] and the laminated shim [9] to the door [7].

SUBTASK 52-48-41-820-002

(3) Two measurement methods are provided to adjust the door.

(a) Method 1 is the Standard measurement method for skin clearance and flushness adjustment.

(b) Method 2 is Aero-Averaging measurement for skin clearance adjustment.

SUBTASK 52-48-41-820-003

(4) Adjust the skin clearance and the flushness of the door [7] with Method 1:

(a) Close and latch the door [7].

(b) As a minimum, measure the clearance and flushness between the door skin and the fuselage skin along each edge of the door [7] at the locations that follow:

NOTE: Make additional measurements if necessary.

1) Within ±1.0 inch of the door stops [10].

2) Within ±1.0 inch of the tangent point of the door corners.

(c) Make sure that the skin clearance is as shown (Table 401) and (Figure 402).

(d) Make sure that the flushness of the door and fuselage cutout is as shown (Table 401) and (Figure 402).

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Table 401/52-48-41-993-801 Aerosmoothness Limits - Electronic Equipment Access Door (Key to Figure 402)

	CLEARANCE		FLUSHNESS	
ZONE	NOMINAL inch (mm)	TOLERANCE inch (mm)	NOMINAL inch (mm)	TOLERANCE inch (mm)
A THRU H	0.09 (2.29)	0.06 to 0.12 (1.52 to 3.04)	-0.06 (-1.52)	-0.09 to -0.03 (-2.29 to -0.76)

1) If it is necessary, adjust as follows (Figure 401):
   a) For the forward and aft latch fitings [11], loosen the bolts [28], washers [29], and nuts [30] that attach the latch fitings [11] to the latch supports on the fuselage frame.
   b) For the left and right latch fitings [11], loosen the bolts [28], washers [29], and nuts [30] that attach the latch fitings [11] and serrated plates [33] to the fuselage frame.
   c) Move the latch fitings [11] on the serrated plates [33] or the serrated latch supports to get the correct flushness.
   d) Tighten the bolts [28], washers [29], and nuts [30] that attach the latch fitings [11] to the fuselage frame.
2) If it is necessary, carefully cut the door skin to get the correct skin clearance.

SUBTASK 52-48-41-820-004

(5) Adjust the skin clearance with Method 2 (Aero-Averaging).
   (a) Make sure that the skin clearance is as shown in Table 402.

Table 402/52-48-41-993-802 Aero-Averaging Limits - Electronic Equipment Access Door (Method 2)

	CLEARANCE		FLUSHNESS	
ZONE	NOMINAL inch (mm)	TOLERANCE inch (mm)	NOMINAL inch (mm)	TOLERANCE inch (mm)
A THRU H	0.09 (2.29)	0.06 to 0.15 (1.52 to 3.81)	-0.06 (-1.52)	-0.12 to 0.00 (-3.05 to 0.00)

SUBTASK 52-48-41-820-005

(6) Adjust the skin clearances with Method 2 (Aero-Averaging) (Table 403).
   (a) Measure the clearance between the door skin and fuselage skin along the forward and aft edges of the door at the locations that follow:
      1) Make five marks that are spaced equally along the forward edge of the door.
         NOTE: Include the door corner tanget points.
      2) Make five marks that are spaced equally along the aft edge of the door.
         NOTE: Include the door corner tanget points.
      3) Measure the skin clearance within ±1.0 inch (±25.4mm) of each mark along the forward and aft edges of the door.
      4) Record the skin clearance for each measurement.
      5) Use the (Table 403) to change the clearance to a Drag value.
         NOTE: A measurement of 0.10 inch (2.54mm) clearance is a Drag value of 0.92.

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6) Record the Drag value for each measurement from (Table 403).

Table 403/52-48-41-993-803 Electronic Equipment Access Door Skin Clearance (Aero-averaging)

CLEARANCE Inch (mm)	DRAG VALUE
0.06 (1.52)	0.59
0.07 (1.78)	0.67
0.08 (2.03)	0.75
0.09 (2.29)	0.84
0.10 (2.54)	0.92
0.11 (2.79)	1.00
0.12 (3.05)	1.08
0.13 (3.30)	1.17
0.14 (3.56)	1.25
0.15 (3.81)	1.33

7) Add all the Drag Values together (sum).
   a) Record the sum of the Drag Value as Measurement A.
8) Divide Measurement A by the number of measurements that you made.
9) Make sure that the average Drag Value is 1.00 or less.

(b) Make sure that the minimum clearance is as shown (Table 401) and (Figure 402).
1) If it is necessary, adjust as follows, (Figure 401):
   a) For the forward and aft latch fitings [11], loosen the bolts [28], washers [29], and nuts [30] that attach the latch fitings [11] to the latch supports on the fuselage frame.
   b) For the left and right latch fitings [11], loosen the bolts [28], washers [29], and nuts [30] that attach the latch fitings [11] and serrated plates [33] to the fuselage frame.
   c) Move the latch fitings [11] on the serrated plates [33] or the serrated latch supports to get the correct flushness.
   d) Tighten the bolts [28], washers [29], and nuts [30] that attach the latch fitings [11] to the fuselage frame.
2) If it is necessary, carefully cut the door skin to get the correct skin clearance.

SUBTASK 52-48-41-820-006

(7) Adjust the skin flushness using Method 2 (Aero-Averaging) (Table 404):
(a) Make sure that the flushness between the door skin and fuselage skin along the forward and aft edges of the door are as shown (Table 401) and (Figure 402).
(b) As a minimum, measure the flushness between the door skin and fuselage skin along the forward and aft edges of the door at the locations that follow:
1) Make five marks that are spaced equally along the forward edge of the door.
   NOTE: Include the door corner tanget points.
2) Make five marks that are spaced equally along the aft edge of the door.
   NOTE: Include the door corner tanget points.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3) Measure the skin flushness within ±1.0 inch (±25.4mm) of each mark along the forward and aft edges of the door.

4) Record the skin flushness for each measurement.

5) Use the (Table 404) to change the flushness to a Drag value.

NOTE: A measurement of -0.06 inch (-1.52mm) flushness is a Drag value of 0.

6) Record the Drag value for each measurement from (Table 404).

Table 404/52-48-41-993-804 Electronic Equipment Access Door Skin Flushness (Aero-Averaging)

Door Flushness		
Fwd Edge Inch (mm)	**Aft Edge Inch (mm)**	**Drag Value**
-0.12 (-3.05)	0.00	1.68
-0.11 (-2.79)	-0.01 (-0.25)	1.36
-0.10 (-2.54)	-0.02 (-0.51)	1.04
-0.09 (-2.29)	-0.03 (-0.76)	0.71
-0.08 (-2.03)	-0.04 (-1.02)	0.43
-0.07 (-1.78)	-0.05 (-1.27)	0.18
-0.06 (-1.52)	-0.06 (-1.52)	0
-0.05 (-1.27)	-0.07 (-1.78)	0.18
-0.04 (-1.02)	-0.08 (-2.03)	0.68
-0.03 (-0.76)	-0.09 (-2.29)	1.25
-0.02 (-0.51)	-0.10 (-2.54)	1.89
-0.01 (-0.25)	-0.11 (-2.79)	2.61
0.00	-0.12 (-3.05)	3.36

7) Add all the Drag Values together (sum).

a) Record the sum of the Drag Values as Measurement A.

8) Divide Measurement A by the number of measurements that you made.

a) Make sure that the average Drag Value is 1.00 or less.

(c) If the average Drag Value is greater than 1.00, then adjust the door as follows:

1) Open the door.

2) Adjust the door to get the correct skin flushness.

SUBTASK 52-48-41-820-007

(8) Do a test of the door warning sensor [6] as follows:

(a) Do this task: Electronic Equipment Access Door Indication Switch Test, TASK 52-71-42-710-801.

SUBTASK 52-48-41-420-002

(9) Install the forward and aft roller truck attach brackets [23] and the right aft roller truck [24] on the door [7] (Figure 401):

(a) Remove the door [7] from the fuselage frame.

(b) Install the bolts [21] and washers [22] to attach the roller truck attach brackets [23] and the laminated shims [20] to the door [7].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(c) Install the bolt [25] and the bearing [26] to attach the right aft roller truck [24] and the laminated shim [27] to the door [7].

SUBTASK 52-48-41-420-003

(10) Install the door [7] in the fixed tracks [4]:

(a) Hold the door [7].

(b) Put the door [7] through the opening in the fuselage frame.

(c) Align the roller [34] with the ends of the fixed tracks [4].

(d) Put the roller [34] into the fixed tracks [4].

(e) Move the door [7] outboard to the open position to fully engage the rollers [34] in the fixed tracks [4].

SUBTASK 52-48-41-410-003

(11) Install the folding track assemblies [3] in the electrical and electronic equipment compartment (Figure 401):

(a) Put the folding track assemblies [3] into the lower hinge lugs [5].

(b) Put the upper hinge lugs [16] and springs [15] in position above the folding track assemblies [3].

(c) Apply the sealant, A00247 to the bolts [13], washers [14], washers [17], and nuts [18].

(d) Install the bolts [13], washers [14], washers [17], and nuts [18] that attach the springs [15] and upper hinge lugs [16] to the attach stanchions.

(e) Engage the latches [8] to hold the folding track assemblies [3] in the extended position.

SUBTASK 52-48-41-820-008

(12) Adjust the roller trucks [19] (Figure 401):

(a) Close and latch the door [7].

(b) Make sure that the roller trucks [19] are centered in the folding track assemblies [3]. If necessary, adjust as follows:

1) Remove the bolts [21] and washers [22] that attach the roller truck attach brackets [23] and the laminated shims [20] to the door [7].

2) Remove the bolt [25] and the bearing [26] that attach the right aft roller truck [24] and the laminated shim [27] to the door [7].

3) Remove laminations from the laminated shims [20] and laminated shim [27] or install new laminated shims [20] and laminated shim [27] to get the correct clearance.

4) Apply sealant, A00247 to both sides of the laminated shims [20] and laminated shim [27].

5) Install the bolts [21] and washers [22] that attach the roller truck attach brackets [23] and the laminated shims [20] to the door [7].

6) Install the bolt [25] and the bearing [26] that attach the right aft roller truck [24] and the laminated shim [27] to the door [7].

SUBTASK 52-48-41-820-009

(13) Do a test on the door [7] as follows:

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WARNING

TO PREVENT THE DOOR-BIND IN THE TRACKS, DO NOT LIFT THE DOOR AROUND THE EDGES. USE TWO HANDS WITH A LIGHT FORCE AND EQUAL PRESSURE TO LIFT THE DOOR. LET THE DOOR FOLLOW THE ROLLER TRACKS UP AND OUTBOARD. TOO MUCH FORCE CAN CAUSE DAMAGE TO THE DOOR ROLLERS. IF YOU DO NOT OBEY THIS WARNING, INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

(a) Close and latch the door [7].

(b) Make sure that the handle [1] and latch pins [12]operate correctly and the door [7] opens and closes smoothly.

(c) Make sure that the seal [35] is installed correctly.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

ELECTRONIC EQUIPMENT ACCESS DOOR - INSPECTION/CHECK

1. General

A. This procedure has these tasks:

(1) An inspection of the electronic equipment access door.

(2) An inspection of the electronic equipment access door pressure seal.

TASK 52-48-41-200-801

2. Electronic Equipment Access Door Check

A. References

Reference	Title
52-48-41-000-801	Electronic Equipment Access Door Removal (P/B 401)
52-48-41-400-801	Electronic Equipment Access Door Installation (P/B 401)

B. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

C. Prepare for the Check

SUBTASK 52-48-41-840-003

(1) Do this task: Electronic Equipment Access Door Removal, TASK 52-48-41-000-801.

D. Electronic Equipment Access Door Check

SUBTASK 52-48-41-210-001

(1) Do a visual inspection of the external door structure and handle:

(a) Examine the external skin.

1) Look for dents, cracks, and corrosion.

2) Look for burrs.

3) Look for loose and missing fasteners.

(b) Examine the external handle.

1) Look for cracks and corrosion.

2) Look for too much wear.

SUBTASK 52-48-41-210-002

(2) Do a visual inspection of the door internal structure:

(a) If applicable, examine the internal skin.

NOTE: Newer electronic equipment access doors do not have the internal skin.

1) Look for dents, cracks, and corrosion.

2) Look for burrs.

3) Look for loose and missing fasteners.

(b) Examine the internal frames and brackets.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-48-41-210-003

(3) Do a visual inspection of the latch mechanism:

(a) Examine the latch pins.

1) Look for cracks and corrosion.

2) Look for too much wear.

3) Look for unwanted particles on the latch pins.

SUBTASK 52-48-41-210-004

(4) Do a visual inspection of the stop fittings:

(a) Examine the stop fittings.

1) Look for cracks and corrosion.

SUBTASK 52-48-41-210-005

(5) Do a visual inspection of the roller trucks and track assembly:

(a) Examine the roller truck attach brackets.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

(b) Examine the roller trucks.

1) Look for cracks and corrosion.

2) Look for too much wear on the rollers.

3) Make sure there are no unwanted particles on the rollers.

(c) Examine the tracks.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

3) Make sure there are no unwanted particles on the tracks.

(d) Examine the folding portion of the tracks.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

SUBTASK 52-48-41-210-006

(6) Do a visual inspection of the structure around the door opening:

(a) Examine the latch receptacles.

1) Look for cracks and corrosion.

2) Look for too much wear.

(b) Examine the fuselage frame.

1) Look for cracks and corrosion.

2) Look for loose and missing fasteners.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 52-48-41-860-001

(1) Do this task: Electronic Equipment Access Door Installation, TASK 52-48-41-400-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-48-41-200-802

3. Electronic Equipment Access Door Pressure Seal Check

(Figure 601)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

B. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door

C. Prepare for the Inspection

SUBTASK 52-48-41-010-003

(1) Open this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

D. Electronic Equipment Access Door Pressure Seal Check

SUBTASK 52-48-41-210-007

(1) Do a visual inspection of the door pressure seal as follows:

(a) Examine the seal.

1) Look for cracks, holes, and tears.

2) Look for indications of seal deterioration.

3) Make sure the seal is installed in the seal retainer.

E. Put the Airplane Back to Its Usual Condition

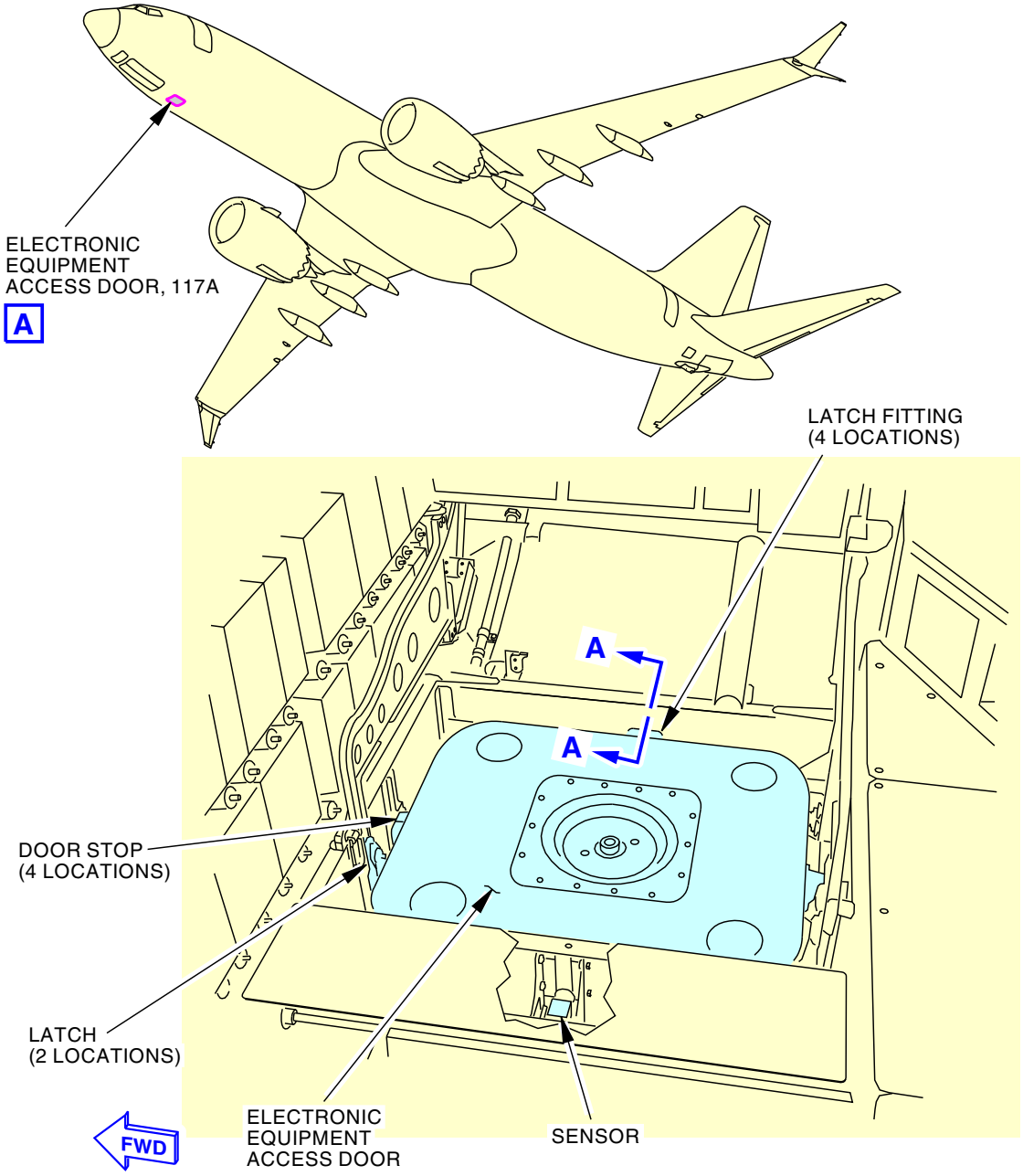
SUBTASK 52-48-41-410-004

(1) Close this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



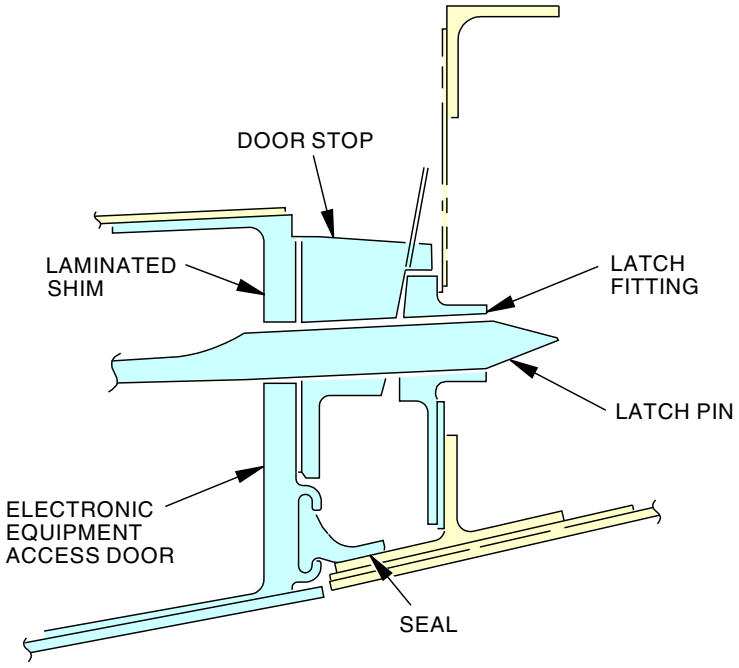
ELECTRONIC EQUIPMENT ACCESS DOOR
(INTERNAL VIEW, DOOR CLOSED POSITION)
(EXAMPLE)

A

2415950 S00061539240_V2

Electronic Equipment Access Door Pressure Seal Check
Figure 601/52-48-41-990-803 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



DOOR SEAL
A-A

2415951 S00061539241_V1

Electronic Equipment Access Door Pressure Seal Check
Figure 601/52-48-41-990-803 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

ENVIRONMENTAL CONTROL SYSTEMS (ECS) ACCESS AND HIGH PRESSURE DOORS- REMOVAL/ INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the Environmental Control System (ECS) access door

(2) An installation of the ECS access door

(3) A removal of the ECS high pressure door

(4) An installation of the ECS high pressure door.

B. The removal and installation procedure for the left and right ECS access doors are the same.

TASK 52-48-42-000-801

2. Environmental Control Systems (ECS) Access Door Removal

(Figure 401)

A. General

(1) This task gives the instructions to remove the Environmental Control System (ECS) access door.

B. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box

C. Access Panels

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door
192DR	ECS High Pressure Access Door

D. Environmental Control Systems (ECS) Access Door Removal

SUBTASK 52-48-42-010-001

(1) Open the applicable ECS doors:

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door
192DR	ECS High Pressure Access Door

SUBTASK 52-48-42-020-001

(2) Remove the bolt [7], washers [6], and nut [5] to disconnect the ground strap [8] from the hinges [3] and hinge [4] at four locations (View B, Figure 401).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-48-42-020-002

CAUTION

GET SUFFICIENT AID FROM TWO PERSONS TO HOLD THE COMPONENT DURING REMOVAL AND INSTALLATION. THIS WILL PREVENT DAMAGE TO THE COMPONENT.

(3) Remove the cotter pins [9], nuts [10], washers [11], and pin [12] to disconnect the hinge [3] from the hinge fitting at each location (View A-A, Figure 401).

NOTE: Get aid from a minimum of two persons to hold the ECS door in its position while you disconnect the hinges.

(a) Discard the cotter pins [9].

SUBTASK 52-48-42-020-003

CAUTION

GET SUFFICIENT AID FROM TWO PERSONS TO HOLD THE COMPONENT DURING REMOVAL AND INSTALLATION. THIS WILL PREVENT DAMAGE TO THE COMPONENT.

(4) Remove the cotter pins [13], nuts [14], washers [15], pin [16], and spacers to disconnect the hinge [4] from the hinge fitting (View B-B, Figure 401).

NOTE: Get aid from a minimum of two persons to hold the ECS door in its position while you disconnect the hinge.

NOTE: An assembly will use either bushing or washers [18] and washers [19] as spacers.

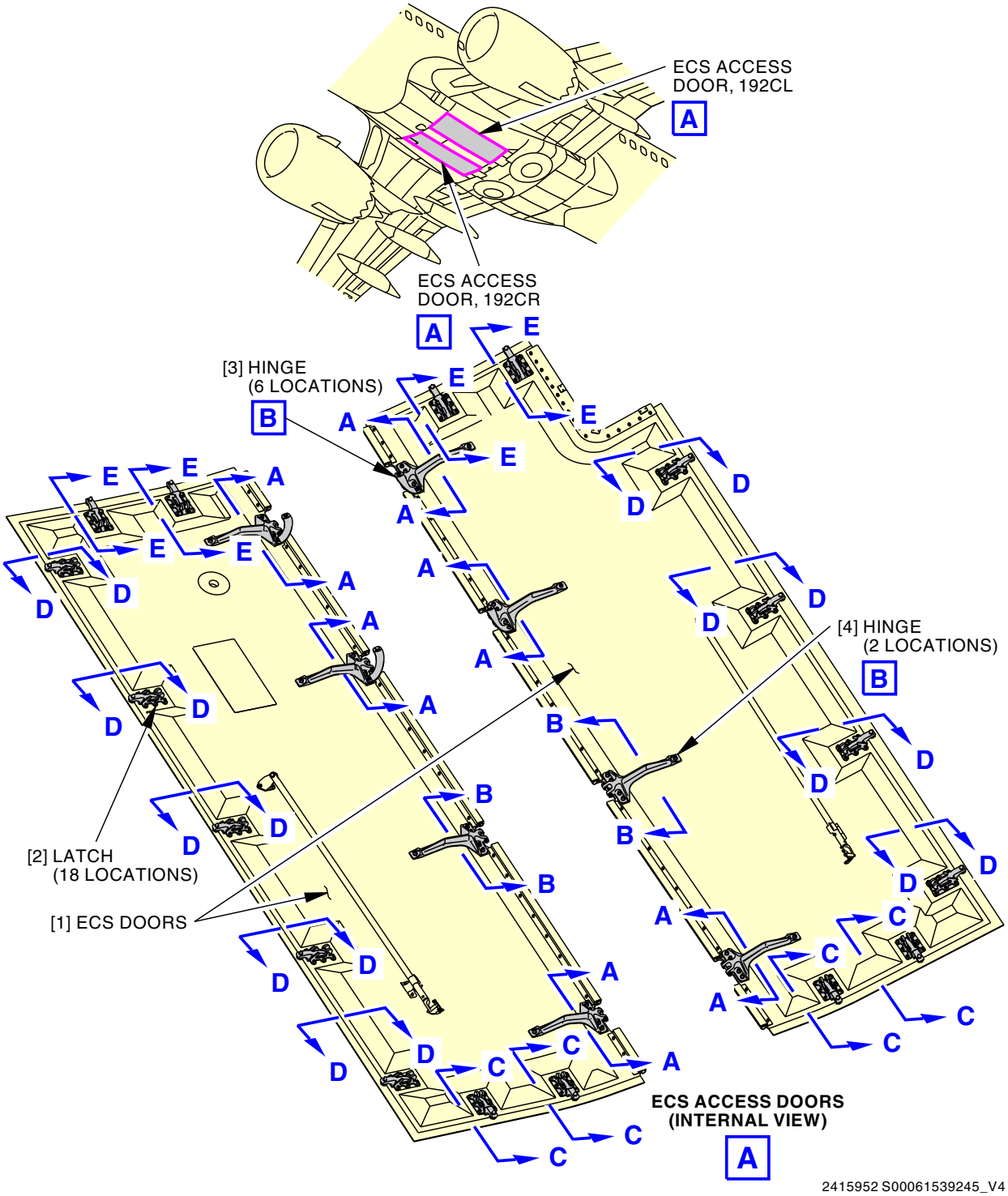
(a) Discard the cotter pins [13].

SUBTASK 52-48-42-020-004

(5) Remove the ECS door [1] from the airplane.

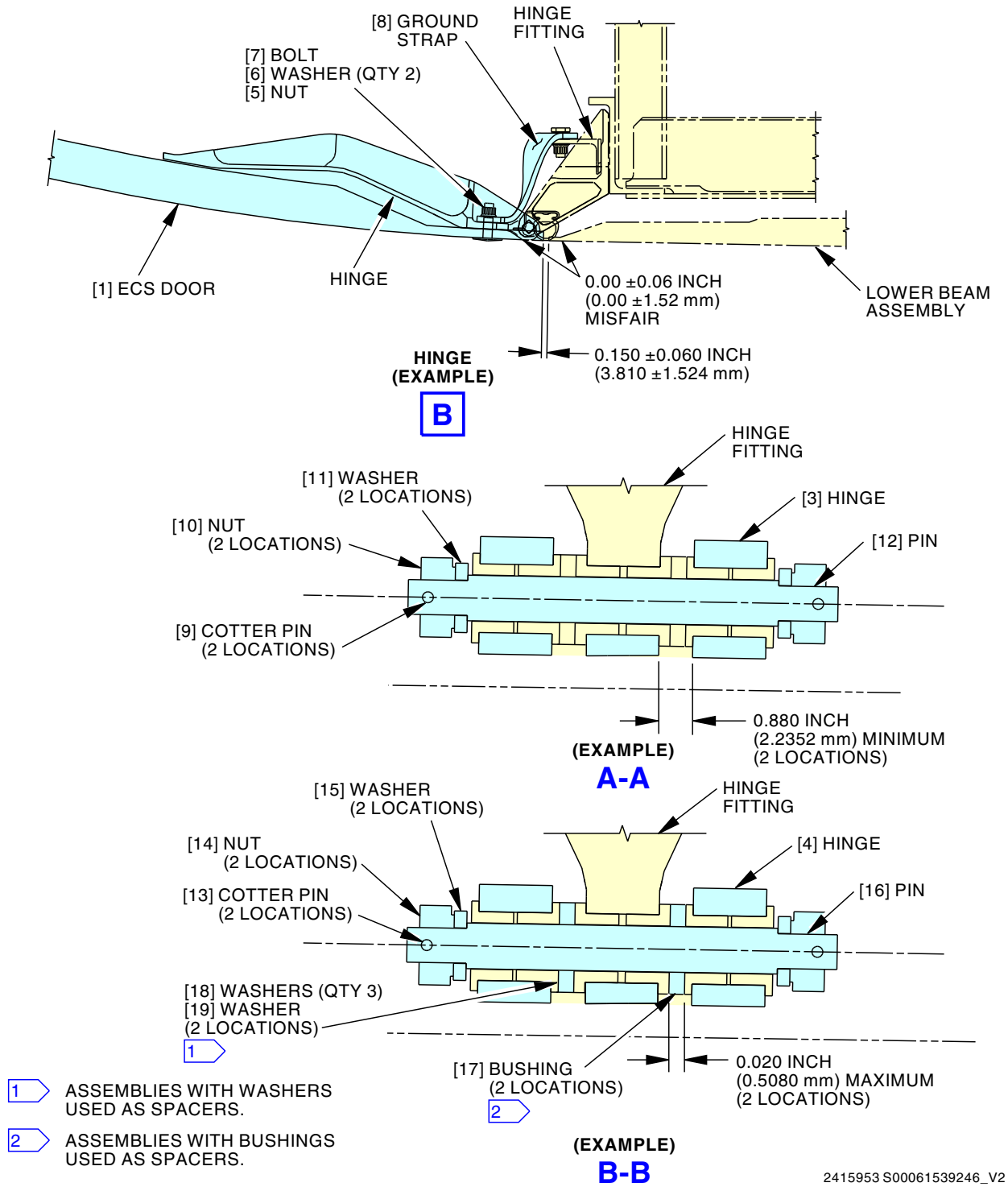
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Environmental Control Systems (ECS) Access Door Installation
Figure 401/52-48-42-990-801 (Sheet 1 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

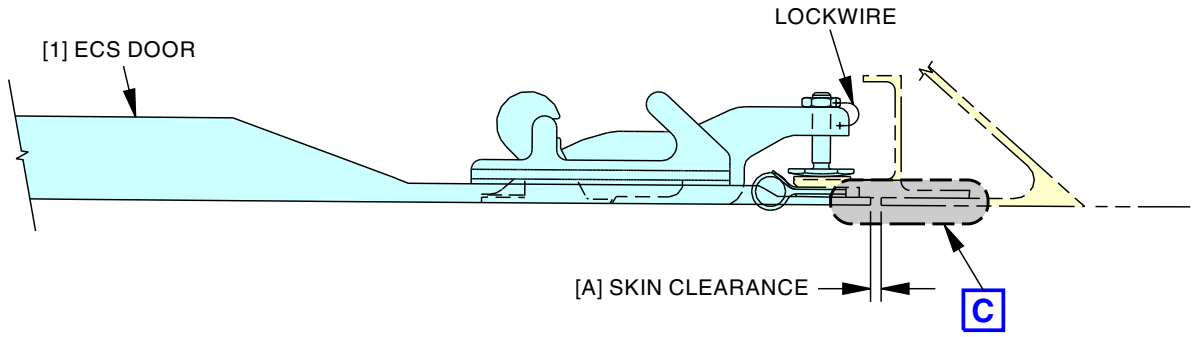


1 ASSEMBLIES WITH WASHERS USED AS SPACERS.

2 ASSEMBLIES WITH BUSHINGS USED AS SPACERS.

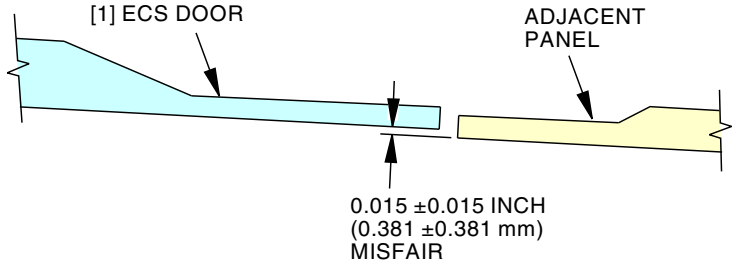
Environmental Control Systems (ECS) Access Door Installation
Figure 401/52-48-42-990-801 (Sheet 2 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



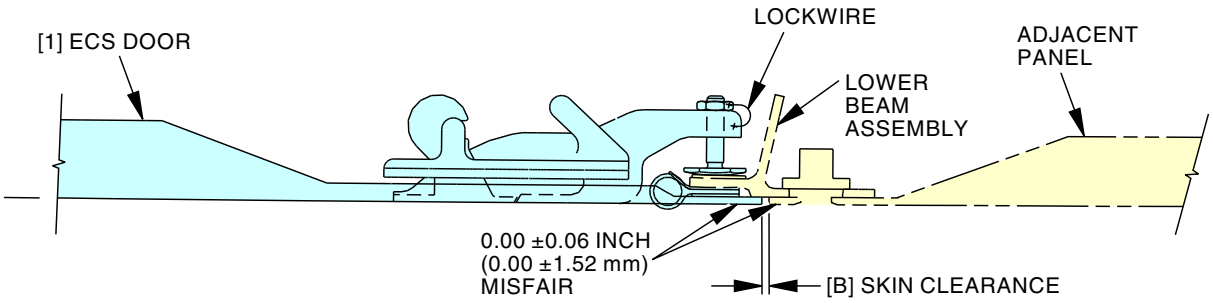
(EXAMPLE)

C-C



AFT LATCHES
(EXAMPLE)

C



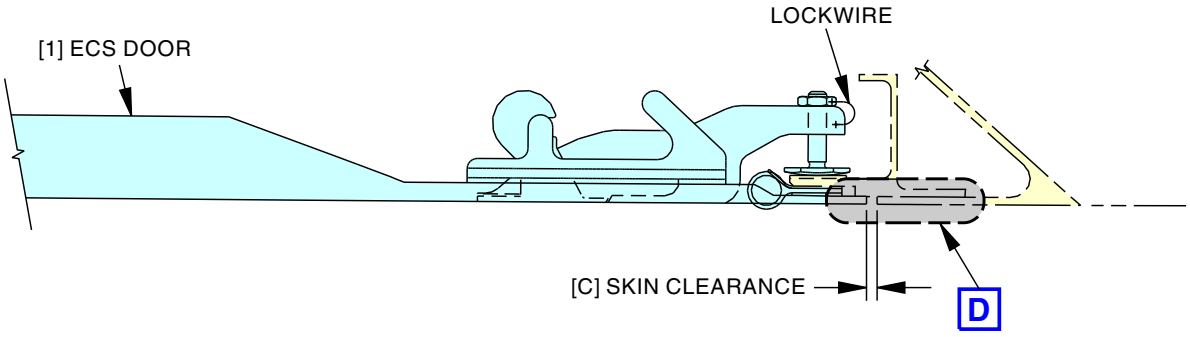
(EXAMPLE)

D-D

2415954 S00061539247_V3

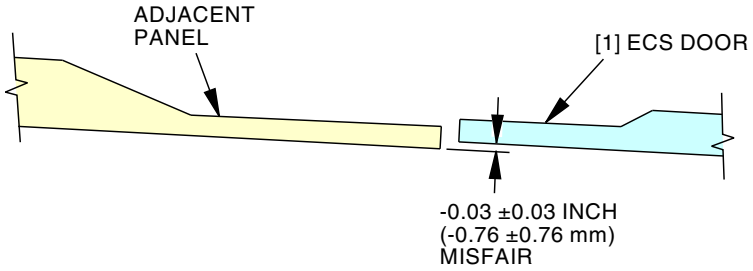
Environmental Control Systems (ECS) Access Door Installation
Figure 401/52-48-42-990-801 (Sheet 3 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



(EXAMPLE)

E-E



FORWARD LATCHES
(EXAMPLE)

D

2983751 S0000761471_V1

Environmental Control Systems (ECS) Access Door Installation
Figure 401/52-48-42-990-801 (Sheet 4 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-48-42-400-801

3. Environmental Control Systems (ECS) Access Door Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the Environmental Control System (ECS) access door.

B. References

Reference	Title
20-10-34-120-801	Hand Clean Metal Surfaces with Abrasives (P/B 701)
20-10-44-400-801	Lockwire, Cotter Pins, and Lockrings - Installation (P/B 401)
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES

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-1793	Multimeter - Digital/Analog (or equivalent meter meets task requirements) Part #: 117 Supplier: 89536 Part #: 260-8XPI Supplier: 55026 Part #: 287 Supplier: 89536 Part #: 289 Supplier: 89536 Part #: 87V Supplier: 89536 Part #: FLUKE 27 II Supplier: 89536 Part #: FLUKE-77-4 Supplier: 89536 Opt Part #: 187 Supplier: 89536 Opt Part #: 189 Supplier: 89536 Opt Part #: 21 Supplier: 89536 Opt Part #: 27 Supplier: 89536 Opt Part #: 77 SERIES III Supplier: 89536 Opt Part #: 87 Supplier: 89536 Opt Part #: FLUKE 27 Supplier: 89536 Opt Part #: MODEL 27 Supplier: 89536

D. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
D00633	Grease - Aircraft General Purpose	BMS3-33

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	ECS door	52-48-42-01-055	SIA ALL
		52-48-42-02-070	SIA ALL
9	Cotter pin	52-48-42-01-005	SIA ALL
		52-48-42-02-030	SIA ALL
13	Cotter pin	52-48-42-01-005	SIA ALL
		52-48-42-02-030	SIA ALL

ECCN 9E991 BOEING PROPRIETARY - See title page for details

F. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box

G. Access Panels

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door
192DR	ECS High Pressure Access Door

H. Prepare for the Installation

SUBTASK 52-48-42-210-001

(1) Make sure that the latches [2] are installed on the ECS door [1].

NOTE: There are a total of nine latches on the left ECS door (192CL).

NOTE: There are a total of eight latches on the right ECS door (192CR).

(a) Make sure that each latch assembly contains a lockwire.

SUBTASK 52-48-42-210-002

(2) Make sure that the hinges [3] and hinge [4] are installed on the ECS door [1].

NOTE: There are a total of four hinges on the ECS door.

I. Environmental Control Systems (ECS) Access Door Installation

SUBTASK 52-48-42-420-001

CAUTION

GET SUFFICIENT AID FROM TWO PERSONS TO HOLD THE COMPONENT DURING REMOVAL AND INSTALLATION. THIS WILL PREVENT DAMAGE TO THE COMPONENT.

(1) Put the ECS door [1] in its usual position on the airplane.

SUBTASK 52-48-42-420-002

(2) Do these steps to install the hinges [3] (View A-A, Figure 401):

(a) Put a thin layer of grease, D00633, on the pin [12] and bushings on the hinge fitting and hinge [3].

(b) Install the pin [12], washers [11], and nuts [10] to connect the hinge [3] to the hinge fitting at each location.

1) Tighten the nuts [10] with your fingers.

2) Install one of the following combination of washers [11] to make sure that the cotter pins [9] are installed correctly:

- Two (2) BACW10BP3DP washers per side.
- One (1) BACW10BP3DP washer and one (1) BACW10BP3NDP washer per side.

3) Install the new cotter pins [9] (TASK 20-10-44-400-801).

SUBTASK 52-48-42-420-003

(3) Do these steps to install the hinge [4] (View B-B, Figure 401):

(a) Put a thin layer of grease, D00633, on the pin [16] and bushings on the hinge fitting and hinge [4].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) Install the pin [16], washers [15], spacers, and nuts [14] to connect the hinge [4] to the hinge fitting.

NOTE: The spacers will be either bushing or washers [18] and washers [19], depending on the hinge assembly.

1) Tighten the nuts [14] with your fingers.

2) On assemblies with bushing [17] as spacers, install one of the following combination of washers [15] to make sure that the cotter pins [13] are installed correctly:

- Two (2) BACW10BP3DP washers per side.
- One (1) BACW10BP3DP washer and one (1) BACW10BP3NDP washer per side.

3) Make sure that the distance between the two hinge halves is no more than 0.020 in. (0.508 mm) (View B-B, Figure 401).

4) Install the new cotter pins [13] (TASK 20-10-44-400-801).

SUBTASK 52-48-42-420-004

(4) Do these steps to connect the ground strap [8] to the hinges [3] and hinge [4]:

(a) Do this task to prepare the bonding surface: Hand Clean Metal Surfaces with Abrasives, TASK 20-10-34-120-801.

NOTE: When removing finishes and epoxy below the head of the fastener on the ECS door, use caution not to damage the graphite plies.

(b) Install the bolt [7], washers [6], and nut [5] to connect the ground strap [8] to the hinges [3] and hinge [4].

1) Make sure that one washer [6] is installed below the nut [5] and one washer [6] is installed below the ground strap [8].

2) Tighten the nut [5] to 60 in-lb (6.8 N·m) - 65 in-lb (7.3 N·m).

(c) Measure the electrical bonding resistance between the ECS door [1] and keel chord (SWPM 20-20-00).

1) Use a digital/analog multimeter, COM-1793.

2) Make sure that the electrical bonding resistance is 100 ohms or less.

3) If the resistance is greater than required, remove the fasteners from the ground strap assembly and repeat the steps above.

(d) Seal all of the fasteners and ground strap terminal with sealant, A02315.

J. Environmental Control Systems (ECS) Access Door Installation Check

SUBTASK 52-48-42-211-001

(1) Do a check of the ECS door [1] as follows:

(a) Open and close the ECS door [1].

(b) Make sure that the ECS door [1], hinges [3], hinge [4], and latches [2] operate correctly.

SUBTASK 52-48-42-820-001

(2) Adjust the latches [2] as follows:

NOTE: Do these steps for each latch.

NOTE: There are a total of nine latches on the left ECS door.

NOTE: There are a total of eight latches on the right ECS door.

(a) Push and hold the edge of the ECS door [1] aligned with the adjacent structure.

(b) Lock the latches [2].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(c) For the forward and aft latches [2], check the following (Figure 401):

1) Make sure that the clearance between the ECS door [1] and adjacent structure (Views C-C, D-D, and E-E, Figure 401).

Table 401/52-48-42-993-801 ECS Door Installation Skin Clearances

CLEARANCE	SECTION	SKIN CLEARANCE
A	C-C	0.140 ±0.060 in. (3.556 ±1.524 mm)
B	D-D	0.100 +0.070 / -0.030 in. (2.540 +1.778 / -0.762 mm)
C	E-E	0.140 ±0.060 in. (3.556 ±1.524 mm)

2) For the forward latches, make sure that the skin flushness (View D, Figure 401).

3) For the aft latches, make sure that the skin flushness (View C, Figure 401).

(d) For the outboard latches [2], check the following (View D-D, Figure 401):

1) Make sure that the clearance between the ECS door [1] and adjacent structure is as shown on Table 401 (View D-D, Figure 401).

2) Makes sure that the skin flushness (View D-D, Figure 401).

SUBTASK 52-48-42-820-002

(3) Adjust the hinges [3] as follows (View A-A, Figure 401):

(a) With the ECS door [1] closed and latched, make sure that the hinges [3] have a minimum gap of 0.088 in. (2.235 mm) between the two mating hinge halves (View A-A, Figure 401).

(b) Make sure that the skin flushness (View B, Figure 401).

SUBTASK 52-48-42-820-003

(4) Adjust the hinge [4] as follows (View B-B, Figure 401):

(a) With the ECS door [1] closed and latched, make sure that the distance between the two mating hinge halves is no more than 0.020 in. (0.508 mm) (View B-B, Figure 401).

(b) On assemblies with bushings [17] installed, adjust if necessary to make sure that the clearance between the forward edge of the ECS door [1] and forward adjacent panel at the front spar is as shown on Table 401 (View E-E, Figure 401).

1) It is optional to use the washers BACW10BP4NDP and BACW10BP4DP in place of the bushing [17] as long as the distance between the two mating hinge halves in no more than 0.020 in. (0.508 mm).

NOTE: The washer listed above can be used in any combination.

(c) On assemblies with washers [18] and washers [19] installed, adjust if necessary to make sure that the clearance between the aft edge of the ECS door [1] and forward adjacent panel at the rear spar is as shown on Table 401 (View E-E, Figure 401).

1) Use the washers [18] and washers [19] in any combination as long as the distance between the two mating hinge halves in no more than 0.020 in. (0.508 mm).

(d) Make sure that the skin flushness (View B, Figure 401).

SUBTASK 52-48-42-211-002

(5) Do a final check of the ECS door [1] as follows:

(a) Open and close the ECS door [1].

(b) Make sure that the ECS door [1], hinges [3], hinge [4], and latches [2] operate correctly.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

K. Put the Airplane Back to Its Usual Condition

SUBTASK 52-48-42-410-001

(1) Close applicable ECS doors:

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door
192DR	ECS High Pressure Access Door

——— END OF TASK ———

TASK 52-48-42-000-802

4. Environmental Control Systems (ECS) High Pressure Door Removal

A. General

(1) This task gives the instructions to remove the Environmental Control Systems (ECS) high pressure door.

B. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box

C. Access Panels

Number	Name/Location
192CR	ECS Access Door
192DR	ECS High Pressure Access Door

D. Environmental Control Systems (ECS) High Pressure Door Removal

SUBTASK 52-48-42-010-002

(1) Open these access panels:

Number	Name/Location
192CR	ECS Access Door
192DR	ECS High Pressure Access Door

(a) Release the four latches [6] on the ECS high pressure door [1].

(b) Lower the ECS high pressure door [1] to the open position to get access to the two hinges [2].

SUBTASK 52-48-42-020-005

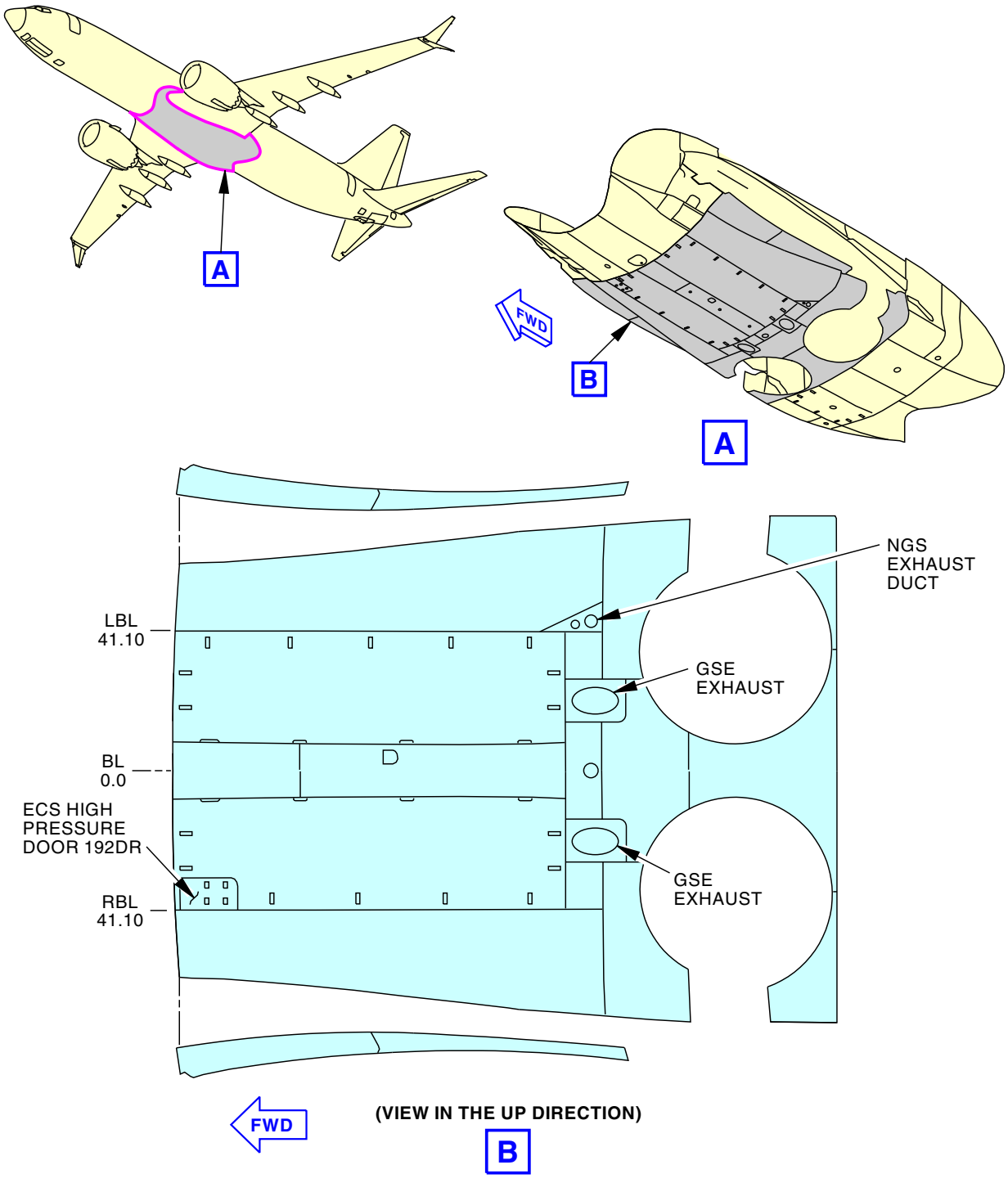
(2) Remove the two bolts [5], washers [4], and nuts [3] that attach the two hinges [2] to the structure.

SUBTASK 52-48-42-020-006

(3) Remove the ECS high pressure door [1].

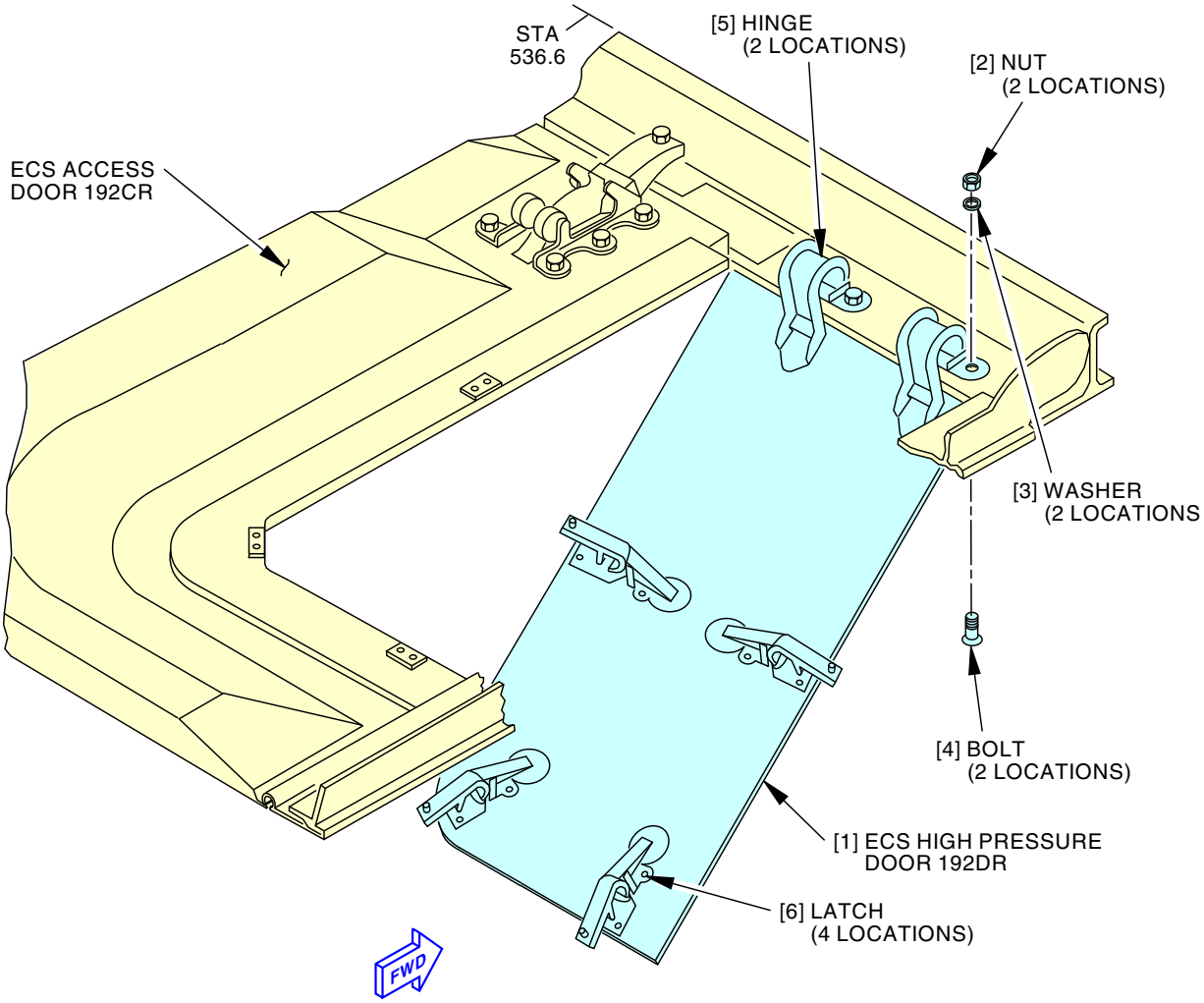
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Environmental Control System (ECS) High Pressure Door Installation
Figure 402/52-48-42-990-802 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



ECS HIGH PRESSURE DOOR

C

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Environmental Control System (ECS) High Pressure Door Installation
Figure 402/52-48-42-990-802 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-48-42-400-802

5. Environmental Control System (ECS) High Pressure Door Installation

(Figure 402)

A. General

(1) This task gives the instructions to install the Environmental Control Systems (ECS) high pressure door.

B. References

Reference	Title
52-48-42-820-801	Environmental Control Systems (ECS) High Pressure Door Adjustment (P/B 501)
SRM 51-00-00-0G-0	Structures

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	ECS high pressure door	52-48-42-10-007	SIA ALL

D. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box

E. Access Panels

Number	Name/Location
192CR	ECS Access Door
192DR	ECS High Pressure Access Door

F. Prepare for Installation

SUBTASK 52-48-42-210-003

(1) Inspect the adjacent structure for vibration damage.

(a) Repair all structural damage, see the Structural Repair Manual (Structures/SRM PROCEDURE 51-00-00-0G-0).

SUBTASK 52-48-42-420-005

(2) Make sure that the four latches [6] and the two hinges [2] are installed on the ECS high pressure door [1].

G. Environmental Control System (ECS) High Pressure Door Installation

SUBTASK 52-48-42-820-004

(1) Align the ECS high pressure door [1] in the correct position.

SUBTASK 52-48-42-420-006

(2) Install the two bolts [5], washers [4], and nuts [3] that attach the two hinges [2] to the structure.

SUBTASK 52-48-42-410-002

(3) Close and latch the ECS high pressure door [1].

H. ECS High Pressure Door Adjustment

SUBTASK 52-48-42-820-006

(1) Adjust the ECS high pressure door [1].

(a) Do this task: Environmental Control Systems (ECS) High Pressure Door Adjustment, TASK 52-48-42-820-801.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

I. Put the Airplane Back to its Usual Condition

SUBTASK 52-48-42-410-003

(1) Close these access panels:

Number	Name/Location
192CR	ECS Access Door
192DR	ECS High Pressure Access Door

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

ENVIRONMENTAL CONTROL SYSTEMS (ECS) HIGH PRESSURE DOOR - ADJUSTMENT

1. General

A. This task has this procedure:

(1) Environmental Control Systems (ECS) High Pressure Door Adjustment.

TASK 52-48-42-820-801

2. Environmental Control Systems (ECS) High Pressure Door Adjustment

A. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box

B. ECS High Pressure Door Adjustment

SUBTASK 52-48-42-820-007

(1) Adjust the four latches on the ECS high pressure door one latch at a time.

(a) Close the ECS high pressure door.

(b) Close the latch to be adjusted.

(c) Open the three latches that are not being adjusted.

(d) Apply light hand pressure at the latch centerline between the button used to close the latch and the edge of the door to determine if the latch moves freely.

NOTE: When the latch moves freely it lets the door move and vibrate until the gap between the door and the support structure is removed.

(e) If the latch moves freely, adjust the threaded bolt until the latch does not move freely.

(f) Turn the threaded bolt clockwise an additional 1/4-turn.

(g) Apply a regular force to the button used to close the latch.

(h) Make sure that the trigger force is not more than 40 lbf (178 N) to close the latch.

(i) If the force is more than 40 lbf (178 N), turn the threaded bolt counterclockwise to reduce the force on the latch.

(j) Apply light hand pressure to make sure that the latch does not move freely.

(k) Turn the threaded bolt clockwise an additional 1/4-turn.

(l) Make sure that the trigger force is not more than 40 lbf (178 N) to close the latch.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FORWARD FAIRING ACCESS DOOR - REMOVAL/INSTALLATION

1. General

A. This procedure has the following tasks:

(1) A removal of the forward fairing access door.

(2) An installation of the forward fairing access door.

TASK 52-49-01-000-801

2. Forward Fairing Access Door - Removal

(Figure 401)

A. General

(1) This task includes the steps to remove the forward fairing access door.

B. Location Zones

Zone	Area
191	Lower Wing-To-Body Fairing - Forward of Wing Box

C. Access Panels

Number	Name/Location
191E	Low Pressure ECS Panel - Forward

D. Forward Fairing Access Door Removal

SUBTASK 52-49-01-010-001

(1) Open the forward fairing access door [7]:

Number	Name/Location
191E	Low Pressure ECS Panel - Forward

SUBTASK 52-49-01-020-001

(2) Remove the bolt [9], two washers [8], jumper [5], and self-locking nut [4] from the hinge [6].

SUBTASK 52-49-01-020-002

(3) Remove the jumper [5].

SUBTASK 52-49-01-020-003

(4) Remove the five bolts [2], washers [3], and self-locking nuts [4] from the two hinges [6].

SUBTASK 52-49-01-020-004

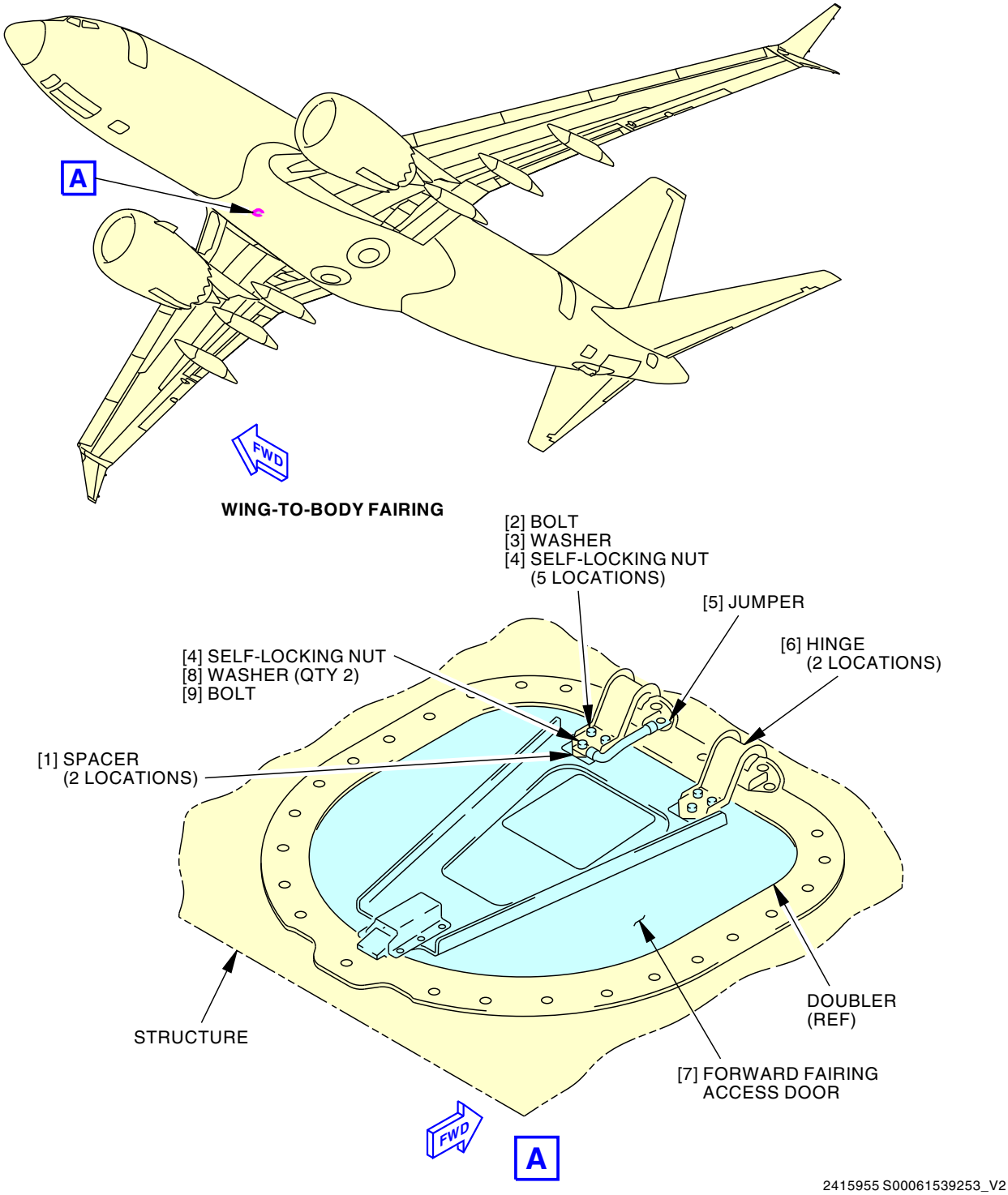
(5) Remove the two spacers [1].

SUBTASK 52-49-01-020-005

(6) Remove the forward fairing access door [7].

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Forward Fairing Access Door Installation
Figure 401/52-49-01-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-49-01-400-801

3. Forward Fairing Access Door - Installation

(Figure 401)

A. General

(1) This task includes the steps to install the forward fairing access door.

B. References

Reference	Title
28-11-00-600-801	Apply the Corrosion Resistant Finish (Topcoat) (P/B 701)
51-21-72-370-804	BMS10-11 Primer - Application (P/B 701)
51-22-00-390-808	Fastener Seal Application (P/B 201)
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES

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-614	Bonding Meters - Non-Intrinsically Safe (For use in outside Class I, Divisions I & II non-hazardous locations. For hazardous locations, use COM-1550). Part #: 247000 Supplier: 00426 Part #: 620LK Supplier: 1CRL2 Part #: BLR-0003-XX Supplier: KC432 Part #: BT51 Supplier: 00426 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659 Opt Part #: 247001 Supplier: 00426

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A50231	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class B
A50359	Sealant - Low Density, Non-Chromate Type	BMS5-142 Type II Class B
C00064	Coating - Aluminum Chemical Conversion	BAC5719 Type II Class A (MIL-DTL-5541 Class 1A)
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
7	Forward fairing access door	53-51-51-04-210	SIA ALL

F. Location Zones

Zone	Area
191	Lower Wing-To-Body Fairing - Forward of Wing Box

ECCN 9E991 BOEING PROPRIETARY - See title page for details

G. Access Panels

Number	Name/Location
191E	Low Pressure ECS Panel - Forward

H. Prepare for the Installation

SUBTASK 52-49-01-110-001

(1) Prepare an electrical bond through the clearance-fit fasteners to the forward fairing access door [7] and the hinge [6] (SWPM 20-20-00, Paragraph 11).

SUBTASK 52-49-01-390-001

(2) Apply sealant, A00247 to the five bolts [2], washers [3], and self-locking nuts [4] (TASK 51-22-00-390-808, Procedure 3).

SUBTASK 52-49-01-410-001

(3) Align the forward fairing access door [7] and spacers [1] with the hinges [6].

I. Forward Fairing Access Door Installation

SUBTASK 52-49-01-420-003

(1) Install the five bolts [2], washers [3], and self-locking nuts [4] to the hinges [6] and forward fairing access door [7].

(a) Tighten the self-locking nuts [4] to 15 in-lb (1.7 N·m).

SUBTASK 52-49-01-420-002

(2) Install the bolt [9], two washers [8], jumper [5], and self-locking nut [4] to the hinge [6].

NOTE: The washers [8] go between the hinge [6] and jumper [5], and between the jumper [5] and self-locking nut [4].

(a) Tighten the self-locking nuts [4] to 15 in-lb (1.7 N·m).

SUBTASK 52-49-01-760-001

(3) Measure the electrical bonding resistance between the bolt [9] and the structure with a non-intrinsically safe bonding meter, COM-614 (SWPM 20-20-00, Paragraph 11).

(a) Make sure that the electrical bonding resistance is 0.001 ohm (1.0 milliohm) or less.

SUBTASK 52-49-01-760-002

(4) Measure the electrical bonding resistance between the self-locking nut [4] and the terminal of the jumper [5] with a non-intrinsically safe bonding meter, COM-614 (SWPM 20-20-00, Paragraph 11).

(a) Make sure that the electrical bonding resistance is 0.0015 ohm (1.5 milliohms) or less.

SUBTASK 52-49-01-350-001

(5) Apply coating, C00064 to the bare metal areas on the forward fairing access door [7] (TASK 28-11-00-600-801).

SUBTASK 52-49-01-350-002

(6) Apply two coats of primer, C00259 to the bare metal surface on the forward fairing access door [7] (TASK 51-21-72-370-804).

SUBTASK 52-49-01-420-004

(7) Apply a fastener fillet seal with sealant, A50231 or sealant, A50359 to the bolt [2], washers [8], jumper [5], and self-locking nut [4] (TASK 51-22-00-390-808).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-49-01-410-002

(8) Close the forward fairing access door [7]:

Number	Name/Location
191E	Low Pressure ECS Panel - Forward

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

EXTERNAL POWER RECEPTACLE ACCESS DOOR - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the external power receptacle access door

(2) An installation of the external power receptacle access door.

TASK 52-49-02-000-801

2. External Power Receptacle Access Door - Removal

(Figure 401)

A. General

(1) This task includes the steps to remove the external power receptacle access door.

B. References

Reference	Title
24-22-00-860-802	Remove Electrical Power (P/B 201)

C. Location Zones

Zone	Area
116	Nose Landing Gear Wheel Well - Right

D. Access Panels

Number	Name/Location
114AR	External Power Receptacle Door

E. Prepare for the Removal

SUBTASK 52-49-02-860-001

(1) Do this task: Remove Electrical Power, TASK 24-22-00-860-802.

SUBTASK 52-49-02-010-001

(2) Open this access panel:

Number	Name/Location
114AR	External Power Receptacle Door

SUBTASK 52-49-02-020-001

(3) Remove external power plug from the receptacle, if it is installed.

F. External Power Receptacle Access Door Removal

SUBTASK 52-49-02-020-002

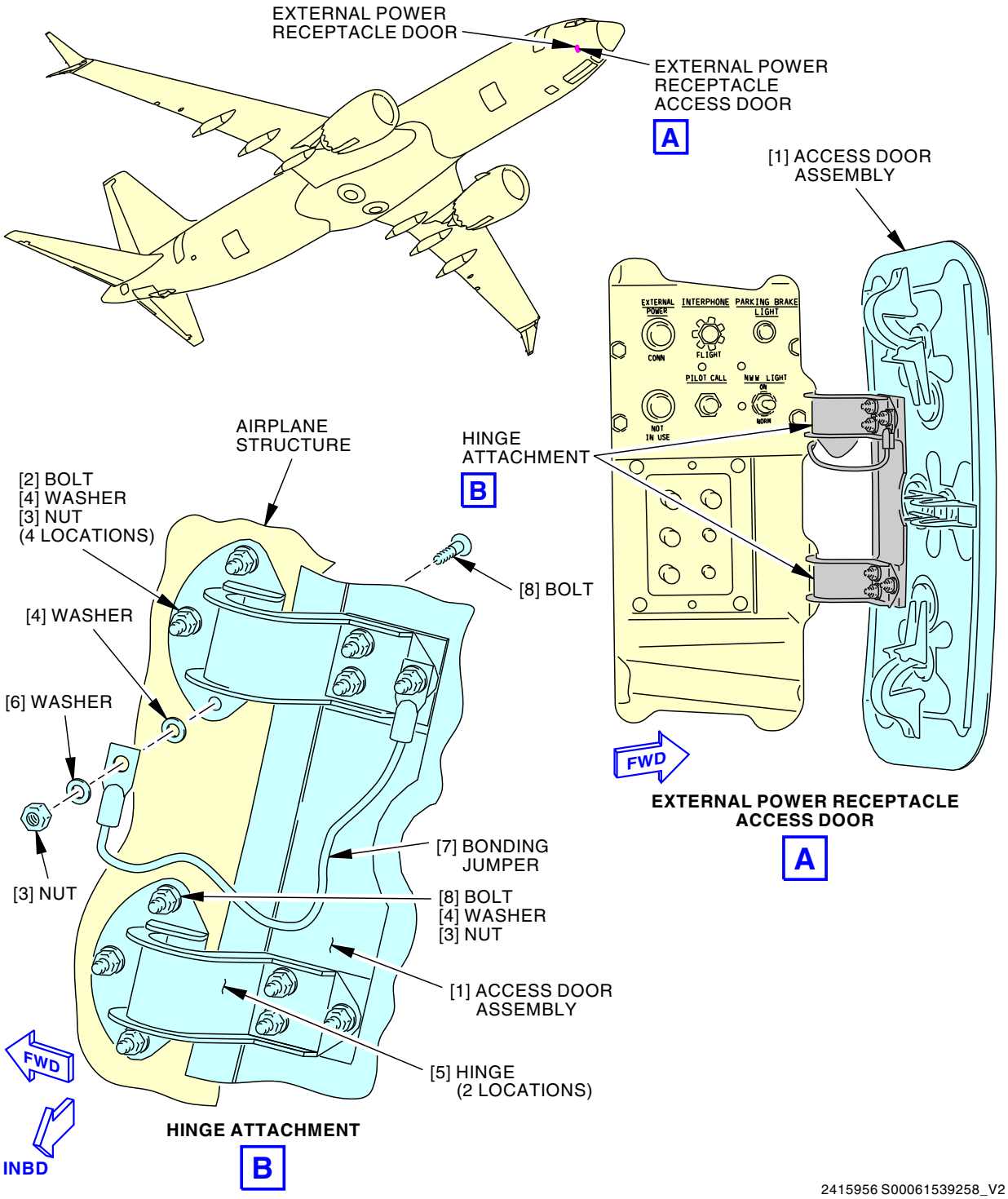
(1) Remove the nut [3], washer [6], bonding jumper [7], washer [4], and bolt [8] from the hinge [5].

(2) Remove the nuts [3], washers [4], bolt [8], and bolts [2] from the hinges [5].

(3) Remove the access door assembly [1].

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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External Power Receptacle Access Door Installation
Figure 401/52-49-02-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-49-02-400-801

3. External Power Receptacle Access Door - Installation

(Figure 401)

A. General

(1) This task includes the steps to install the external power receptacle access door.

B. References

Reference	Title
24-22-00-860-801	Supply Electrical Power (P/B 201)
51-21-73-370-803	BMS10-11 Topcoat Application (P/B 701)
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES

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-614	Bonding Meters - Non-Intrinsically Safe (For use in outside Class I, Divisions I & II non-hazardous locations. For hazardous locations, use COM-1550). Part #: 247000 Supplier: 00426 Part #: 620LK Supplier: 1CRL2 Part #: BLR-0003-XX Supplier: KC432 Part #: BT51 Supplier: 00426 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659 Opt Part #: 247001 Supplier: 00426

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
G50961	Coating - Corrosion Inhibiting Epoxy Primer - (BAC 377 Yellow Color)	BMS10-11 Type I

E. Location Zones

Zone	Area
116	Nose Landing Gear Wheel Well - Right

F. Access Panels

Number	Name/Location
114AR	External Power Receptacle Door

G. External Power Receptacle Access Door Installation

SUBTASK 52-49-02-410-001

(1) Put the access door assembly [1] in position.

SUBTASK 52-49-02-390-002

(2) Apply two coats of coating, G50961, to the mating surfaces of the hinges [5] (TASK 51-21-73-370-803).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-49-02-400-001

(3) Install the bolt [8], bolts [2], washers [4], and nuts [3] to the hinges [5].

(a) Tighten the nuts [3] to 30 ±5 in-lb (3.4 ±0.6 N·m).

SUBTASK 52-49-02-400-002

(4) Install the bolt [8], washer [4], bonding jumper [7], washer [6], and nut [3] to the hinge [5].

(a) Tighten the nut [3] to 30 ±5 in-lb (3.4 ±0.6 N·m).

SUBTASK 52-49-02-760-001

(5) Measure the electrical bonding resistance between the airplane structure and access door assembly [1] (SWPM 20-20-00).

(a) Use an non-intrinsically safe bonding meter, COM-614.

(b) Make sure that the electrical bonding resistance is 0.0010 ohm (1 milliohm) or less.

SUBTASK 52-49-02-390-001

(6) Seal the nut [3] on the bonding jumper [7] with sealant, A00247.

H. External Power Receptacle Access Door Installation Test

SUBTASK 52-49-02-710-001

(1) Do a test on the access door assembly [1]:

(a) Open and close the access door assembly [1].

(b) Make sure that the access door assembly [1] operates smoothly.

(c) Make sure that the latches operate correctly.

I. Put the Airplane Back to Its Usual Condition

SUBTASK 52-49-02-410-002

(1) Close this access panel:

Number	Name/Location
114AR	External Power Receptacle Door

SUBTASK 52-49-02-860-002

(2) Do this task: Supply Electrical Power, TASK 24-22-00-860-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WASTE TANK SERVICE PANEL - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Waste Tank Service Panel Removal

(2) Waste Tank Service Panel Installation

(3) Waste Tank Service Panel Fit Check.

B. The waste tank service panel is referred to as the "panel" in this procedure.

TASK 52-49-07-000-801

2. Waste Tank Service Panel Removal

(Figure 401)

A. Location Zones

Zone	Area
143	Area Below Aft Cargo Compartment - Left

B. Access Panels

Number	Name/Location
145AL	Waste Service Door

C. Procedure

SUBTASK 52-49-07-010-001

(1) Open this access panel:

Number	Name/Location
145AL	Waste Service Door

SUBTASK 52-49-07-010-002

(2) Remove the bolt [5], two plain washers [6], jumper [4], and nut [7] from the waste tank service door [1].

SUBTASK 52-49-07-020-001

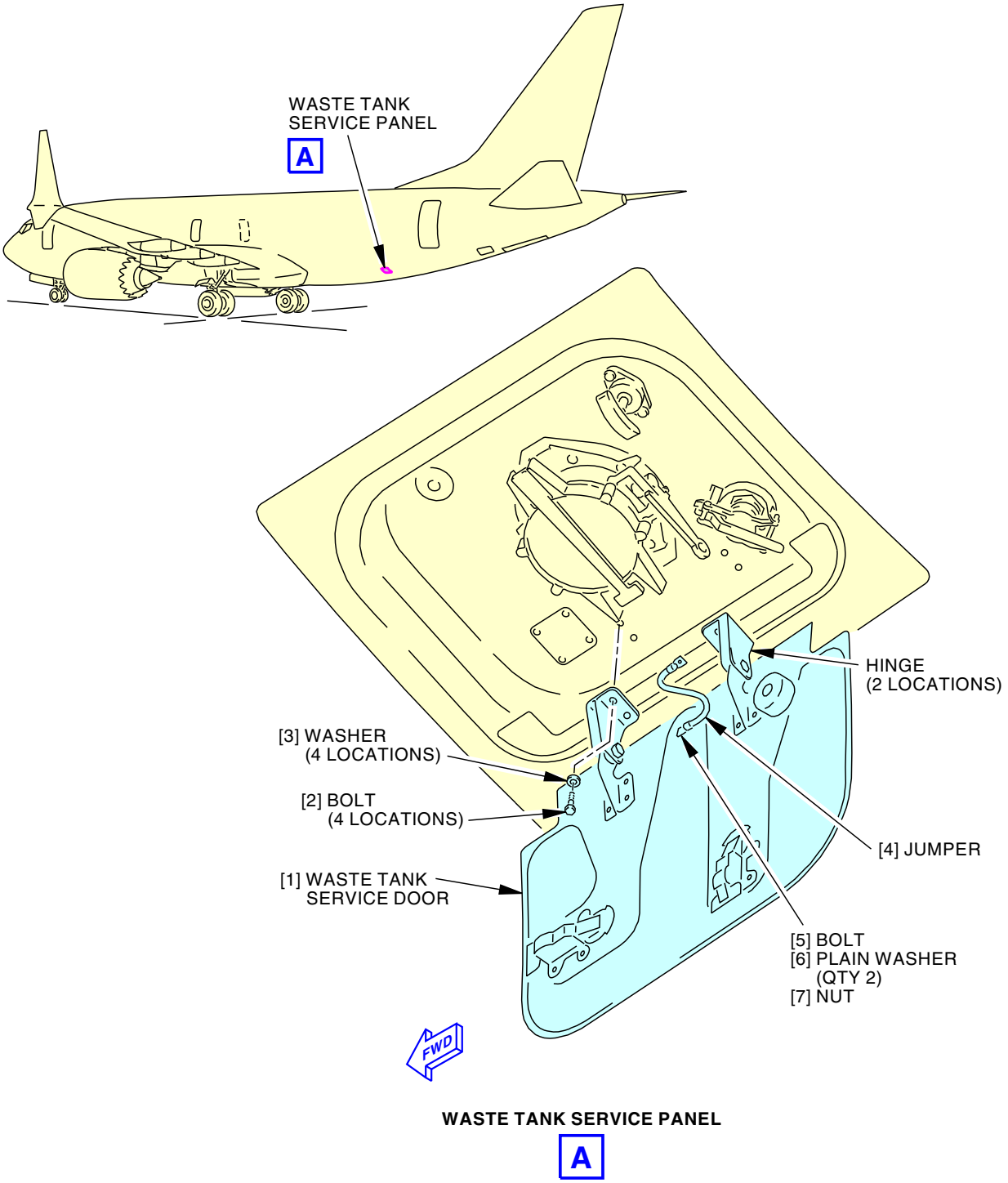
(3) Remove the waste tank service door [1].

(a) Remove the four bolts [2] and washers [3] from the hinges that attach the waste tank service door [1] to the fuselage.

(b) Remove the waste tank service door [1].

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Waste Tank Service Panel Installation
Figure 401/52-49-07-990-802

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-49-07-400-801

3. Waste Tank Service Panel Installation

(Figure 401)

A. References

Reference	Title
SWPM 20-20-10	REPLACEMENT OF GROUND STUDS AND BONDING JUMPER INSTALLATION

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-614	Bonding Meters - Non-Intrinsically Safe (For use in outside Class I, Divisions I & II non-hazardous locations. For hazardous locations, use COM-1550). Part #: 247000 Supplier: 00426 Part #: 620LK Supplier: 1CRL2 Part #: BLR-0003-XX Supplier: KC432 Part #: BT51 Supplier: 00426 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659 Opt Part #: 247001 Supplier: 00426

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	Waste tank service door	52-49-07-01-230	SIA ALL

E. Location Zones

Zone	Area
143	Area Below Aft Cargo Compartment - Left

F. Waste Tank Service Panel Installation

SUBTASK 52-49-07-420-001

(1) Install the waste tank service door [1]:

(a) Apply sealant, A00247 to the surface of the hinge assemblies that attach the waste tank service door [1] to the fuselage.

(b) Apply between the applicable surfaces.

(c) Attach the waste tank service door [1] to the fuselage with the four bolts [2] and washers [3].

NOTE: Install the bolts wet, with sealant, A00247.

(d) Tighten the bolts [2].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-49-07-420-002

(2) Install the bolt [5], two plain washers [6], jumper [4], and nut [7] on the waste tank service door [1].

SUBTASK 52-49-07-420-003

(3) Tighten the nut [7] to 30 ±1 in-lb (3.4 ±0.1 N·m).

SUBTASK 52-49-07-760-001

(4) Measure the electrical bonding resistance between the terminal of the jumper [4] and structure with an non-intrinsically safe bonding meter, COM-614 (SWPM 20-20-10).

(a) Make sure that the electrical bonding resistance is 0.001 ohm (1 milliohm) or less.

SUBTASK 52-49-07-410-001

(5) Close and latch the waste tank service door [1].

——— END OF TASK ———

TASK 52-49-07-000-802

4. Waste Tank Service Panel Fit Check

(Figure 401)

A. Location Zones

Zone	Area
143	Area Below Aft Cargo Compartment - Left

B. Procedure

SUBTASK 52-49-07-200-001

(1) Do a check on the panel for correct flushness and clearance.

(a) With the latch open, the panel must rotate freely to contour within +0.010 or -0.02 inch (+0.254 or -0.508mm) at the latch location.

(b) With the panel closed and faired with the fuselage at the latch location, the latch should rotate freely.

(c) Adjust shims as required to maintain a maximum of 0.01 inch (0.254mm) between the rub block and latch bolt.

NOTE: Maximum shim thickness is 0.063 inch (1.60mm). Remove 0.003 inch (.076mm). laminations as required to fill gap.

(d) The latch bolt should overlap the rub block by a minimum of 0.25 inch (6.35mm).

(e) Make sure the latch buttons and outer perimeter of the panel is flush within ± 0.02 inch (0.508mm) when closed.

NOTE: If you install a new door, it may be necessary to trim the panel edges to fit the cutout.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WATER SERVICE PANEL - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Water Service Panel Removal

(2) Water Service Panel Installation

(3) Water Service Panel Fit Check.

B. The water service panel is referred to as the "panel" in this procedure.

TASK 52-49-09-000-801

2. Water Service Panel Removal

(Figure 401)

A. Location Zones

Zone	Area
143	Area Below Aft Cargo Compartment - Left

B. Access Panels

Number	Name/Location
146AR	Water Service Door

C. Procedure

SUBTASK 52-49-09-010-001

(1) Open this access panel:

Number	Name/Location
146AR	Water Service Door

SUBTASK 52-49-09-020-001

(2) Remove the panel [1]:

(a) Disconnect the bonding jumper from the panel.

(b) Remove the screws [4], washers [2], and nuts [3] that attach the panel to the fuselage.

(c) Remove the panel [1].

——— END OF TASK ———

TASK 52-49-09-400-801

3. Water Service Panel Installation

A. References

Reference	Title
SWPM 20-20-10	REPLACEMENT OF GROUND STUDS AND BONDING JUMPER INSTALLATION

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Panel	52-49-09-01-124	SIA ALL

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

AMM Item	Description	AIPC Reference	AIPC Effectivity
1 (cont.)		52-49-09-01-395	SIA ALL

D. Location Zones

Zone	Area
143	Area Below Aft Cargo Compartment - Left

E. Procedure

SUBTASK 52-49-09-420-001

(1) Install the panel [1]:

(a) Apply sealant, A00247 to the surface of the hinge assemblies that attach the panel to the fuselage.

(b) Apply between the applicable surfaces.

(c) Attach the panel to the fuselage with the screws [4], washers [2], and nuts [3].

NOTE: Install the screws wet, with sealant, A00247.

(d) Tighten the nuts [3].

(e) Connect the bonding jumper to the panel [1] (SWPM 20-20-10).

1) Check the bonding resistance and make sure that it does not exceed 0.001 Ohms.

(f) Close and latch the panel.

NOTE: You may need to adjust the brackets on the door so they don't make contact with the water tank fill handle or the drain handle.

——— END OF TASK ———

TASK 52-49-09-000-802

4. Water Service Panel Fit Check

A. Location Zones

Zone	Area
143	Area Below Aft Cargo Compartment - Left

B. Procedure

SUBTASK 52-49-09-200-001

(1) Do a check on the panel for correct flushness and clearance.

(a) Adjust the latch screw and jamnut on the latch until the panel skin is tight against the panel stop doubler.

(b) Latch buttons must open with moderate thumb pressure.

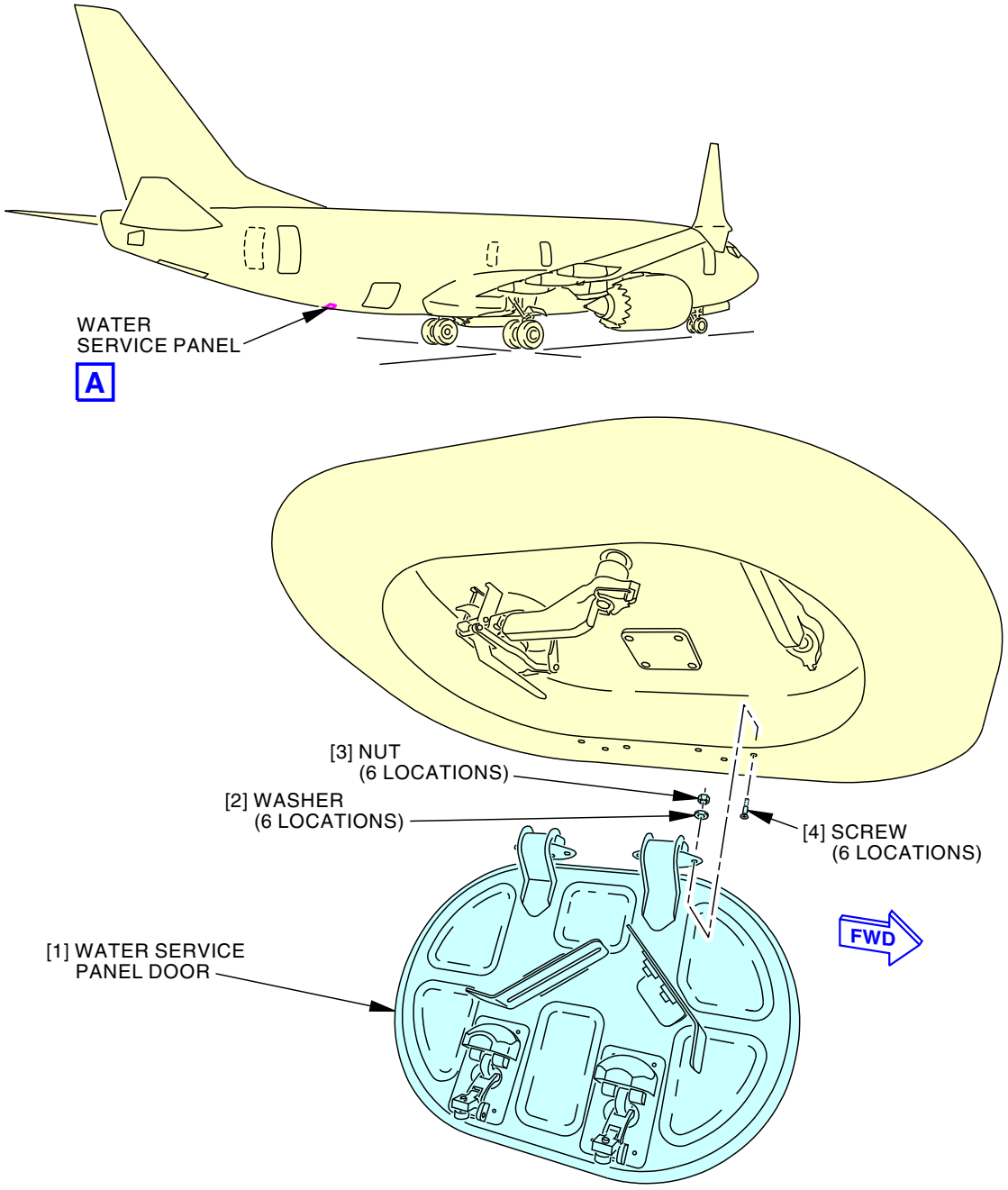
(c) The latches must open and close freely with the latches open.

(d) Make sure the latch buttons and outer perimeter of the panel is flush within 0.00 ±0.02 in. (0.000 ±0.508 mm) when closed.

NOTE: If you install a new door, it may be necessary to trim the panel edges to fit the cutout.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



WATER SERVICE PANEL

A

2415958 S00061539271_V1

Water Service Panel Installation
Figure 401/52-49-09-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SECTION 48 ACCESS AND BLOWOUT DOOR - REMOVAL/INSTALLATION

1. General

A. This procedure contains these tasks:

(1) A removal of the section 48 access and blowout door.

(2) An installation of the section 48 access and blowout door.

B. The section 48 access and blowout door is referred to as the "door" in this procedure.

TASK 52-49-11-000-801

2. Section 48 Access and Blowout Door Removal

(Figure 401)

A. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left

B. Prepare for the Removal

SUBTASK 52-49-11-010-001

(1) Open the door [1].

SUBTASK 52-49-11-480-001

(2) Install straps to support the door [1].

C. Section 48 Access and Blowout Door Removal

SUBTASK 52-49-11-020-001

(1) Remove the door [1]:

(a) Remove the bolt [2] that attaches the strut [3] to the strut support [13].

NOTE: Do not remove the lockwire or rod ends from the strut.

(b) Remove the bolt [7], washers [8], and nut [6] that attach the bonding jumper [5] to the empennage structure.

(c) Remove the bolts [11], washers [10], nylon washers [4], and nuts [9] that attach the hinges [12] to the empennage structure.

(d) Remove the door [1] from the airplane.

——— END OF TASK ———

TASK 52-49-11-400-801

3. Section 48 Access and Blowout Door Installation

(Figure 401)

A. References

Reference	Title
52-49-11-720-801	Section 48 Access and Blowout Door Test (P/B 501)
SWPM 20-20-10	REPLACEMENT OF GROUND STUDS AND BONDING JUMPER INSTALLATION

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.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Reference	Description
COM-1550	Bonding Meter - 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 #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659
STD-1107	Gauge - Feeler, 0.0 - 0.5 Inch, Readable to 1/1000th

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A50110	Sealant - Fuel Tank	BMS5-45 Class B-2
G01912	Lockwire - MS20995NC32, Monel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Door	52-49-11-01-292	SIA ALL

E. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left

F. Section 48 Access and Blowout Door Installation

SUBTASK 52-49-11-420-001

(1) Install the door [1]:

(a) Install the bolts [11], washers [10], nylon washers [4], and nuts [9] to attach the hinges [12] to the empennage structure.

SUBTASK 52-49-11-760-001

(2) Install the bonding jumper [5] to the empennage structure. (SWPM 20-20-10, Category 2)

(a) Clean the bolt [7], washers [8], nut [6], bonding jumper [5] and empennage structure.

(b) Install the bolt [7], washers [8] and nut [6] that attach the bonding jumper [5] to the empennage structure.

(c) Use an intrinsically safe approved bonding meter, COM-1550 to make sure that the resistance between the bonding jumper [5] and the empennage structure is not more than 0.001 ohm.

(d) Apply a fillet seal of sealant, A00247 or sealant, A50110 on the bonding jumper fasteners.

SUBTASK 52-49-11-820-001

(3) Adjust the door [1]:

WARNING STAY OFF THE DOOR. YOUR WEIGHT CAN RELEASE THE SPRING-LOADED LATCHES. IF YOU FALL THROUGH THE DOOR, INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT CAN OCCUR.

(a) Close the door [1].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) Align the door [1] in the empennage structure.

(c) Adjust the latch roller [14] and the top edge of the latch stop [15]:

1) Make sure the outboard and inboard latch rollers [14] share equal door load.

2) For the inboard latch assembly, insert a 0.020 in. (0.508 mm) 0.0 - 0.5 Inch feeler gauge, STD-1107 between the latch roller [14] and latch stop [15].

NOTE: This will preload the inboard door latch.

3) For the outboard latch assembly, insert a 0.0 - 0.5 Inch feeler gauge, STD-1107.

4) Measure a clearance of 0.011 ±0.009 in. (0.279 ±0.229 mm) between the outboard latch roller [14] and latch stop [15].

5) If it is necessary, adjust the clearance on the outboard latch assembly:

a) Loosen the bolts [17], washers [18] and nuts [19] that attach the serrated plate [16] to the fuselage.

b) Insert a 0.020 in. (0.508 mm) 0.0 - 0.5 Inch feeler gauge, STD-1107 on the inboard latch assembly between the latch roller [14] and latch stop [15].

NOTE: This will preload the inboard door latch.

c) Move the serrated plate [16] to get a clearance of 0.011 ±0.009 in. (0.279 ±0.229 mm) between the outboard latch roller [14] and latch stop [15].

d) Tighten the bolts [17], washers [18] and nuts [19] that attach the serrated plate [16] to the fuselage.

(d) Close the door [1].

(e) Make sure that the skin clearance between the door and empennage is as shown.

(f) Adjust the door [1] again if it is necessary.

SUBTASK 52-49-11-420-002

(4) Connect the strut [3] to the empennage structure:

(a) Install the bolt [2] that attaches the strut [3] to the strut support [13].

(b) Do a check of the strut [3]:

1) Close the door [1].

2) Make sure that the strut [3] does not strike the fuselage opening.

3) Make sure that the hinge [12] does not strike the fuselage.

4) Open the door [1].

5) Extend the strut [3] to fully compress the inside spring.

6) Make sure that there is sufficient clearance between the forward edge of the door [1] and the fuselage when the strut [3] is in its maximum open position.

(c) If it is necessary, adjust the strut [3] length as follows:

1) Make sure that the door skin clearance is correct, (Figure 401).

2) Remove the bolt [2] that attaches the strut [3] to the strut support .

3) Remove the strut [3].

4) Remove the lockwire from rod end locknut [20].

5) Loosen the locknut [20].

6) Put the retaining pin into the holes on the top side of the strut [3] to fix the strut [3] tube length, (Figure 401).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

7) Adjust rod end to get sufficient clearance between the forward edge of the door [1] and the fuselage.

8) Tighten the locknut [20] at end of strut to 72.5 ±12.5 in-lb (8.2 ±1.4 N·m).

9) Install the MS20995NC32 lockwire, G01912.

10) Install the bolt [2] that attaches the strut [3] to the strut support [13].

(d) Tighten the bolt [2] to 27.5 ±2.5 in-lb (3.1 ±0.3 N·m).

SUBTASK 52-49-11-710-001

(5) Do this task: Section 48 Access and Blowout Door Test, TASK 52-49-11-720-801.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 52-49-11-080-001

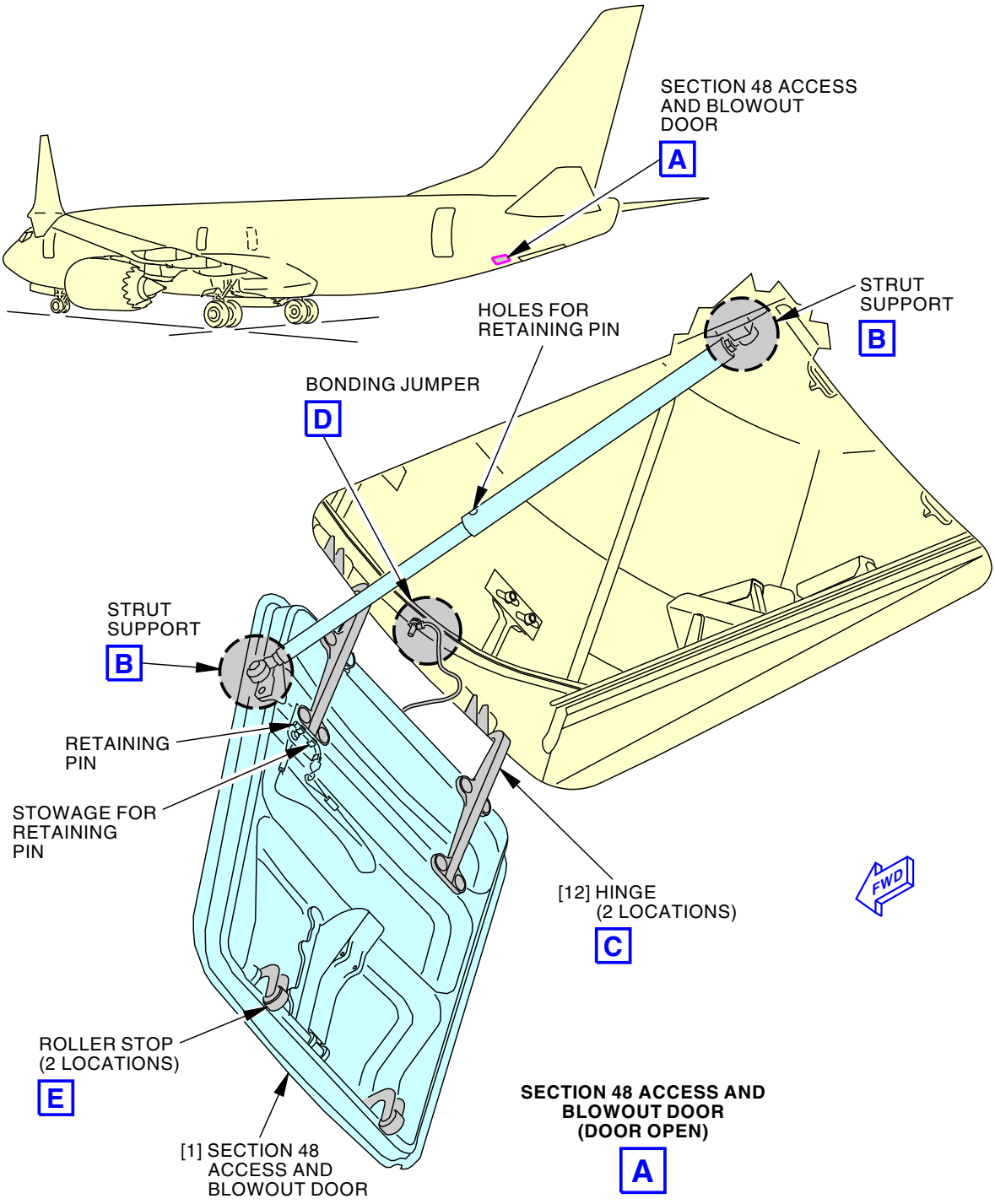
(1) Remove the strap from the door.

SUBTASK 52-49-11-010-002

(2) Close the door [1].

——— END OF TASK ———

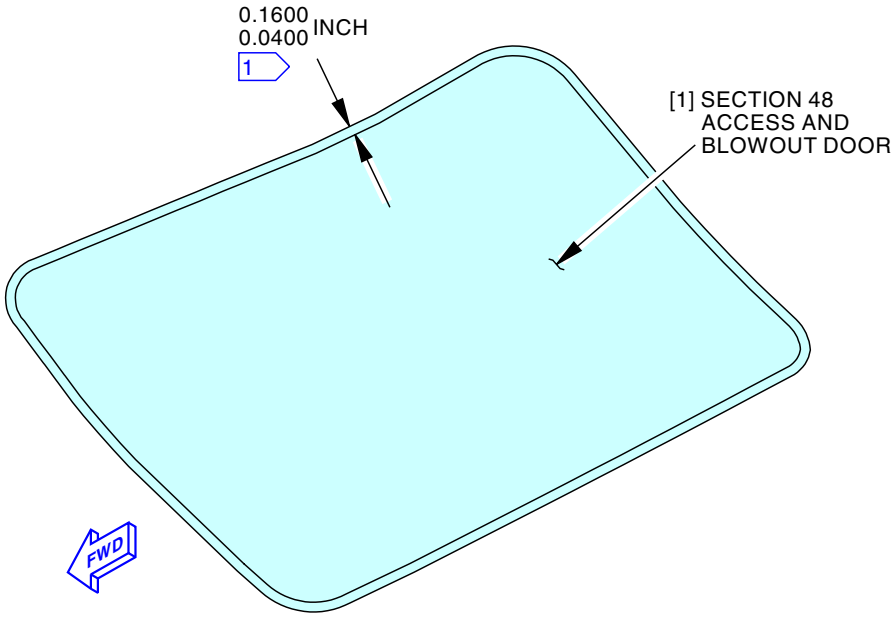
ECCN 9E991 BOEING PROPRIETARY - See title page for details



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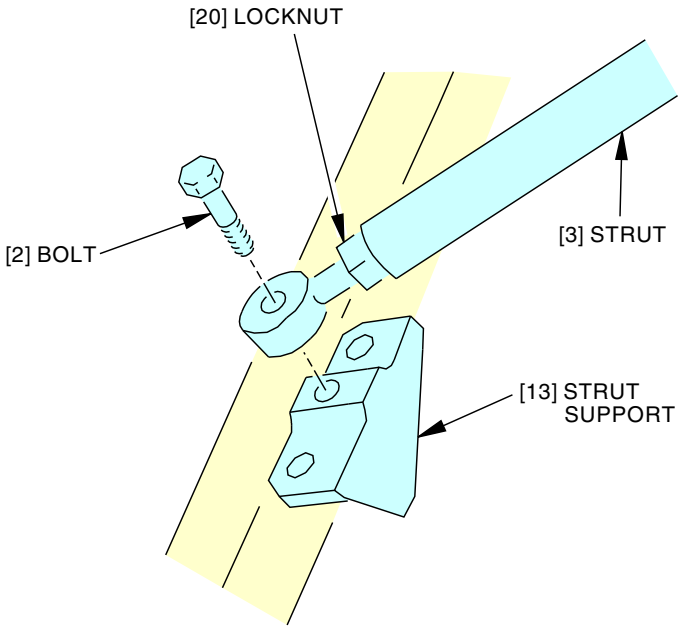
Section 48 Access and Blowout Door Installation
Figure 401/52-49-11-990-801 (Sheet 1 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



SECTION 48 ACCESS AND BLOWOUT DOOR (DOOR CLOSED)

A



STRUT SUPPORT (EXAMPLE)

B

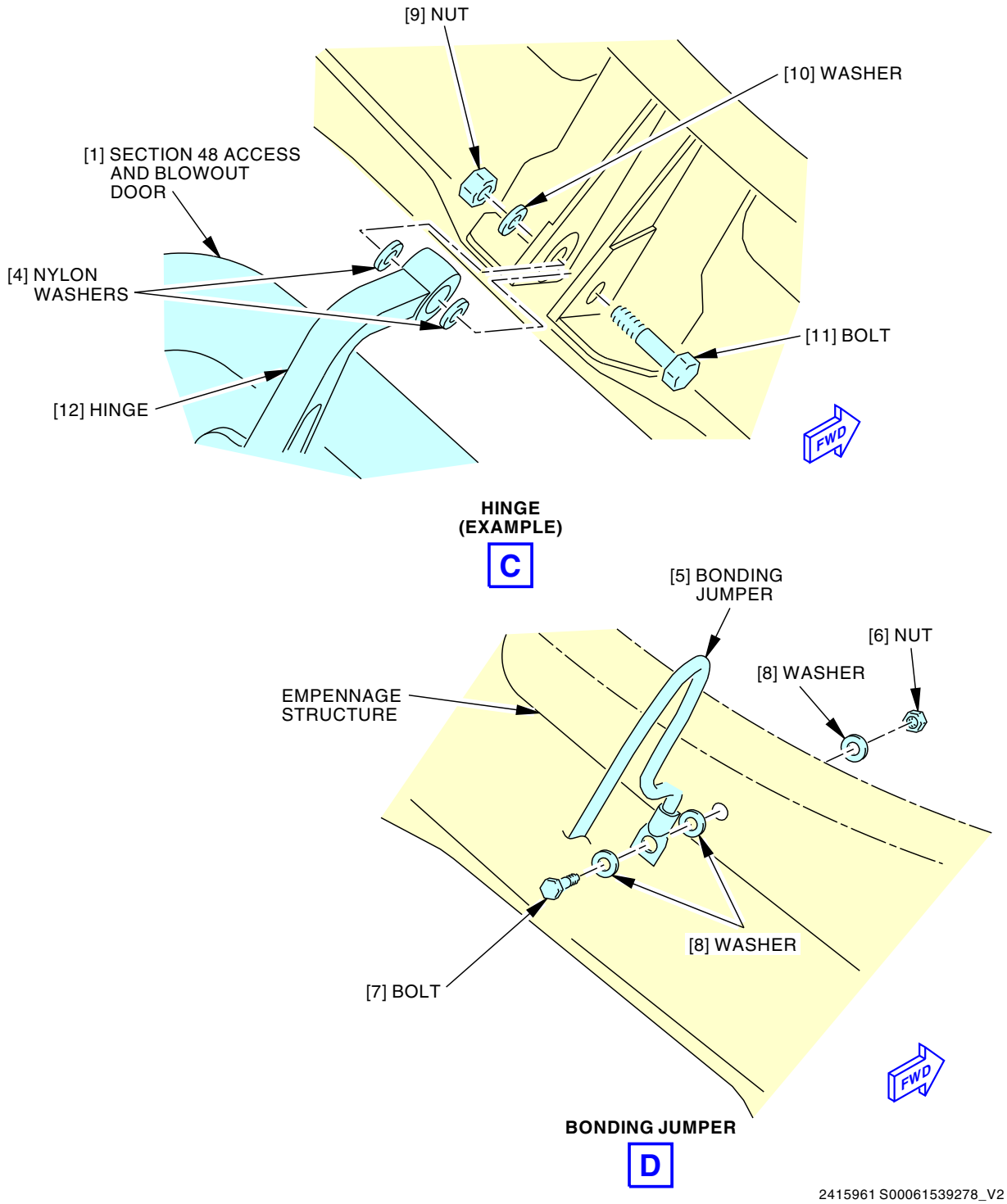
1 **CAUTION:**

THE SKIN CLEARANCE MUST BE CONSTANT AROUND PERIPHERY OF THE DOOR.

2415960 S00061539277_V2

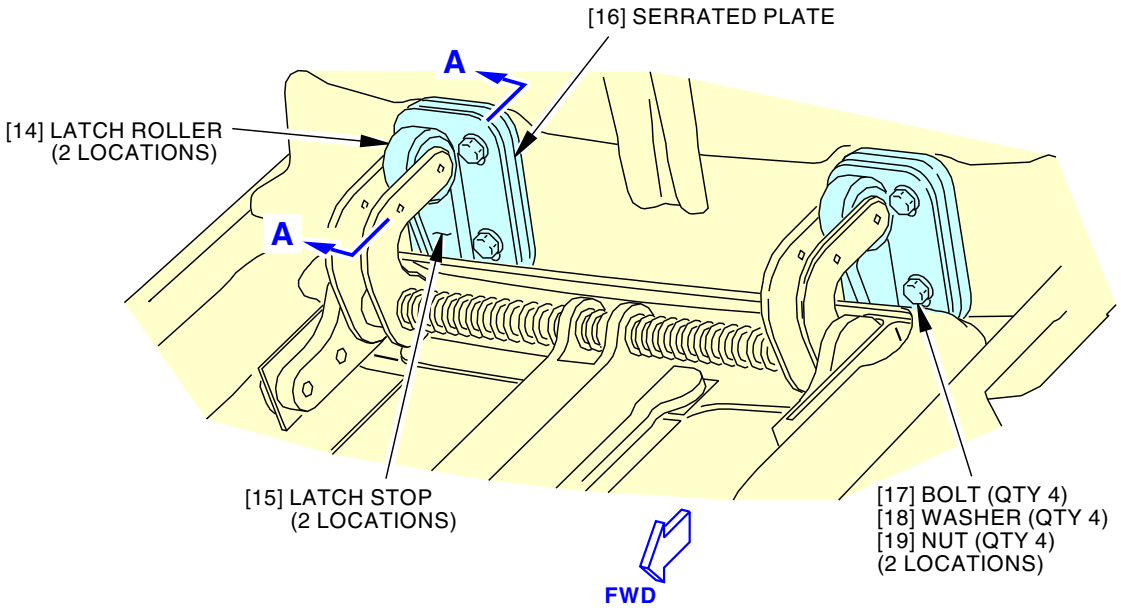
Section 48 Access and Blowout Door Installation
Figure 401/52-49-11-990-801 (Sheet 2 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



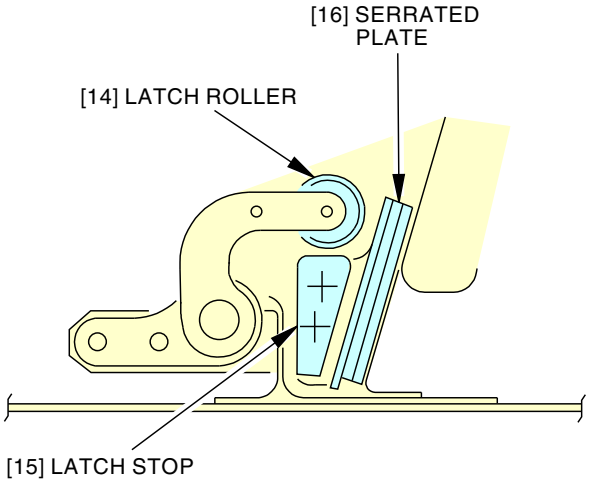
Section 48 Access and Blowout Door Installation
Figure 401/52-49-11-990-801 (Sheet 3 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



ROLLER STOPS

E



LATCH ROLLER AND STOP

A-A

2415962 S00061539279_V1

Section 48 Access and Blowout Door Installation
Figure 401/52-49-11-990-801 (Sheet 4 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SECTION 48 ACCESS AND BLOWOUT DOOR - ADJUSTMENT/TEST

1. General

A. This procedure has this task:

(1) A test of the section 48 access and blowout door.

TASK 52-49-11-720-801

2. Section 48 Access and Blowout Door Test

(Figure 501)

A. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left

B. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door

C. Prepare for the Test

SUBTASK 52-49-11-010-003

(1) Open this access panel:

Number	Name/Location
311BL	Stabilizer Trim Access Door

SUBTASK 52-49-11-010-004

WARNING STAY OFF THE DOOR. YOUR WEIGHT CAN RELEASE THE SPRING-LOADED LATCHES. IF YOU FALL THROUGH THE DOOR, INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT CAN OCCUR.

(2) Go into the compartment and close the door.

D. Procedure

SUBTASK 52-49-11-480-002

(1) Do a blowout test on the door:

(a) Apply a device that weighs between 61 lb (27.7 kg) – 80 lb (36.3 kg) on the door frame near the latch torque shaft.

(b) Make sure the latches release.

(c) If it is necessary, adjust the door latch release pressure as follows:

1) Loosen bolts [3], washers [4], and nuts [5].

2) Move the serrated plates [2] up or down to change the door opening pressure.

a) Move the inboard and outboard serrated plates [2] the same number of serrations and in the same direction.

3) Tighten the bolts [3] to 29 in-lb (3.3 N·m) — 31 in-lb (3.5 N·m).

SUBTASK 52-49-11-710-002

(2) Do a test on the usual operation of the door as follows:

(a) Open and close the door.

(b) Make sure the door opens and closes smoothly.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(c) Make sure the hinges, latches, and strut operate correctly.

E. Put the Airplane Back to Its Usual Condition.

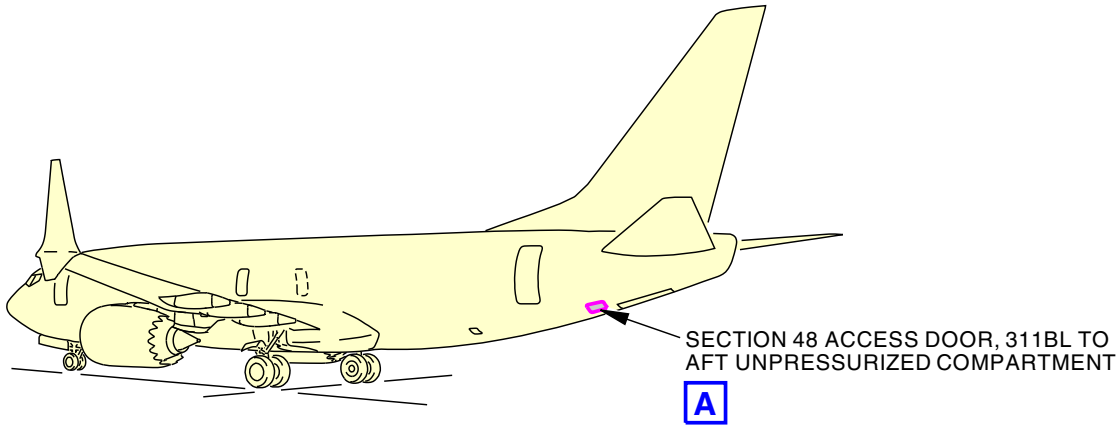
SUBTASK 52-49-11-410-001

(1) Close this access panel:

Number	Name/Location
311BL	Stabilizer Trim Access Door

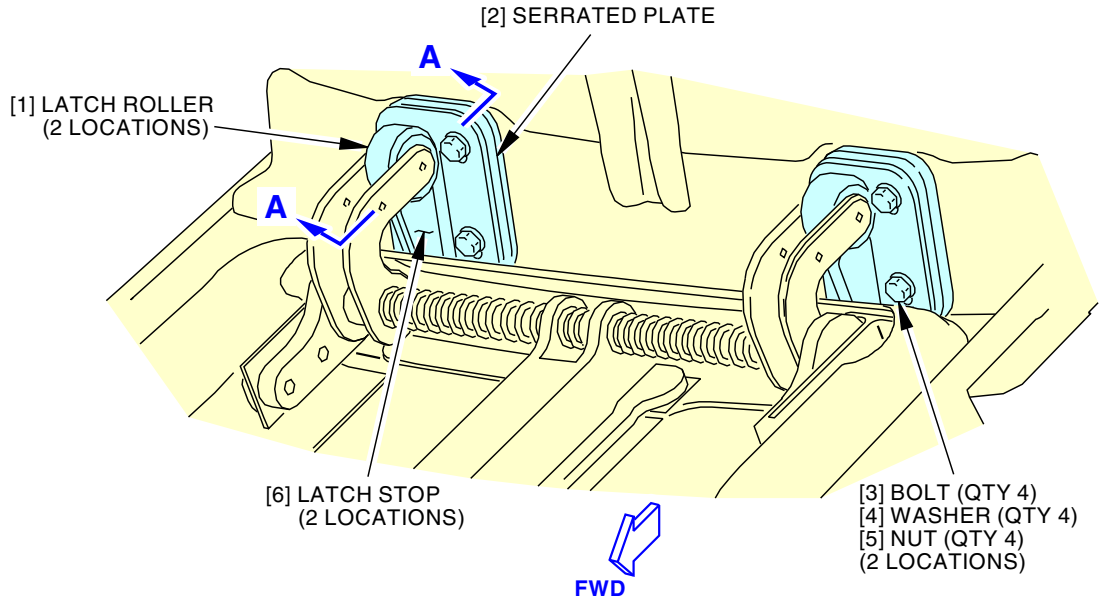
END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



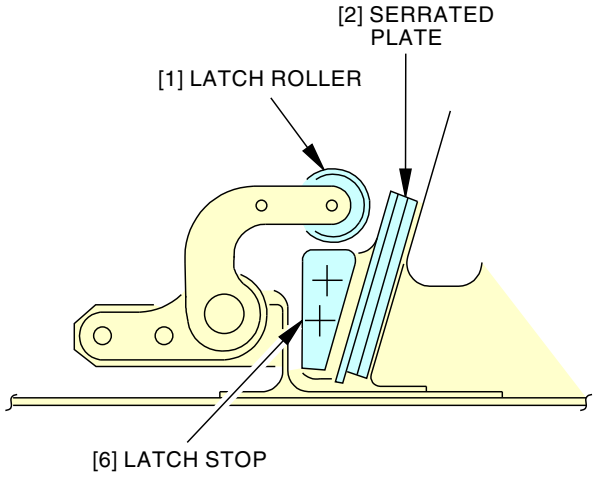
Section 48 Access and Blowout Door Test
Figure 501/52-49-11-990-802 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



ROLLER STOPS

B



LATCH ROLLER AND STOP

A-A

2415964 S00061539283_V1

Section 48 Access and Blowout Door Test
Figure 501/52-49-11-990-802 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

REFUELING STATION DOOR - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the refueling station door.

(2) An installation of the refueling station door.

TASK 52-49-21-000-801

2. Refueling Station Door Removal

(Figure 401)

A. Consumable Materials

Reference	Description	Specification
G02438	Wrap - Tie - TY24M (TY-RAP)	

B. Location Zones

Zone	Area
621	Right Wing - Leading Edge to Front Spar

C. Prepare for the Removal

SUBTASK 52-49-21-010-001

(1) Open the refueling station door [1].

D. Refueling Station Door Removal

SUBTASK 52-49-21-020-001

(1) Disconnect the hold-open strut [5] from the wing structure:

(a) Remove the cotter pin [3], pin [4], washers [6] and washers [7].

(b) Remove the hold-open strut [5] from the fitting [2] on the wing.

SUBTASK 52-49-21-020-002

(2) Disconnect the interphone service at the hinge half [11] of the refueling station door [1].

(a) Remove the nuts [9], washers [10], and bolts [8].

(b) Use TY24M (TY-RAP) tie wrap, G02438 to hold the interphone service to the airplane.

SUBTASK 52-49-21-020-003

(3) Disconnect the inboard and outboard lights from the refueling station door [1]:

(a) Remove the light hoods [21], jamnuts [20], clips [17], and washers [16].

(b) Remove the bolts [19], nuts [22], and clamps [18] from bracket [24] and bracket [25].

(c) Pull the connectors from the brackets [23].

(d) Use TY24M (TY-RAP) tie wrap, G02438 to hold the light power cable to the airplane.

SUBTASK 52-49-21-020-004

(4) Remove the forward end of the three bonding jumpers at the hinge half [11] of the refueling station door [1]:

(a) To disconnect the bonding jumpers, remove the bolts [12], washers [13], and nuts [9].

SUBTASK 52-49-21-000-001

(5) To remove the refueling station door [1] from the airplane, remove the bolts [14], nuts [9], and washers [15] at the hinge half [11].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-49-21-020-005

(6) If it is necessary, remove the latches [28]:

(a) Remove the bolts [29], washers [30] and nuts [27].

(b) Remove the latches [28].

——— END OF TASK ———

TASK 52-49-21-400-801

3. Refueling Station Door Installation

(Figure 401)

A. References

Reference	Title
SWPM 20-20-10	REPLACEMENT OF GROUND STUDS AND BONDING JUMPER INSTALLATION

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 Meter - 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 #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659

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
3	Cotter pin	52-49-21-01-055	SIA ALL

E. Location Zones

Zone	Area
621	Right Wing - Leading Edge to Front Spar

F. Refueling Station Door Installation

SUBTASK 52-49-21-400-001

(1) If the latches [28] have been removed, do these steps:

(a) Put the latches [28] on the refueling station door [1].

(b) Install the bolts [29], washers [30] and nuts [27].

SUBTASK 52-49-21-000-002

(2) To install the refueling station door [1] on the airplane, install the bolts [14], nuts [9], and washers [15] at the hinge half [11].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-49-21-020-006

(3) Install the forward end of the three bonding jumpers at hinge half [11] of the refueling station door [1] (SWPM 20-20-10):

(a) To connect the bonding jumpers, install the bolts [12], washers [13], and nuts [9].

(b) Use an intrinsically safe approved bonding meter, COM-1550 to make sure that the resistance between the bolt [12] and the refueling station door [1] is not more than 0.001 ohm.

(c) Apply a fillet seal of sealant, A00247 on the bonding jumper fasteners.

SUBTASK 52-49-21-420-001

(4) Install the inboard light and the outboard light:

(a) Make sure that the washer [16] and jamnut [20] is on the connector.

(b) Push the connectors through the hole in the brackets [23].

(c) Put the clamps [18] on the light power cables.

(d) Install the bolts [19], nuts [22], and clamps [18] in bracket [24] and bracket [25].

(e) Install the clip [17], jamnut [20], and light hood [21].

(f) Tighten the jamnuts [20].

SUBTASK 52-49-21-020-007

(5) Connect the interphone service to the hinge half [11] of the refueling station door [1].

(a) Disconnect the interphone service from where you temporarily tied it to the airplane.

(b) To connect the interphone service, install the nuts [9], washers [10], and bolts [8].

SUBTASK 52-49-21-420-002

(6) Connect the hold-open strut [5] to the wing structure:

(a) Install the pin [4], washers [6], washers [7], and new cotter pin [3] that attach the hold-open strut [5] to the wing structure.

SUBTASK 52-49-21-420-003

(7) If it is necessary, check the latches [28]:

(a) Close the refueling station door [1].

(b) Make sure that the latches [28] will lock with finger pressure.

(c) Make sure that the refueling station door [1] is satisfactorily held against the airplane structure by the closed latches.

WARNING BE CAREFUL WHEN YOU RELEASE THE REFUEL LATCHES. THE REFUEL DOOR WILL OPEN FREELY. THIS CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

(d) Make sure that finger pressure will open the latches [28].

1) If it is necessary, adjust the striker bolt [31] to get the correct latch pressure.

a) Turn the bolt offset adjustment screw [32] until the latch pressure is correct.

NOTE: Clockwise adjustment will increase the latch pressure and decrease door to skin flushness. Counter clockwise adjustment will decrease the latch pressure and increase door to skin flushness.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

G. Installation Test

SUBTASK 52-49-21-710-001

(1) Do a test on the refueling station door [1]:

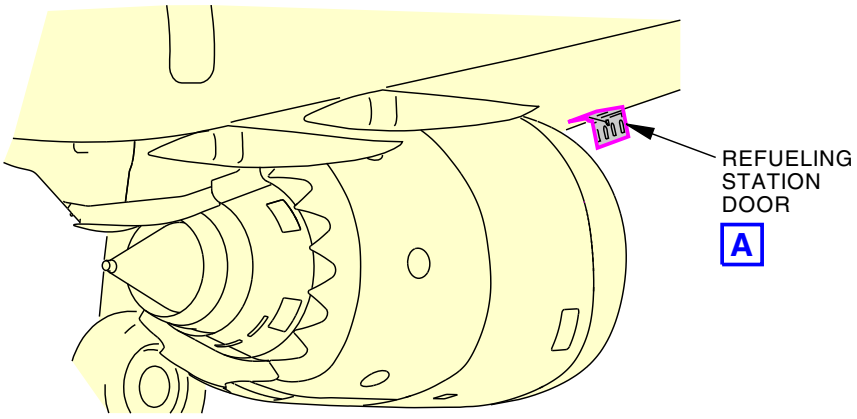
(a) Open and close the refueling station door [1].

(b) Make sure that the refueling station door [1] operates smoothly.

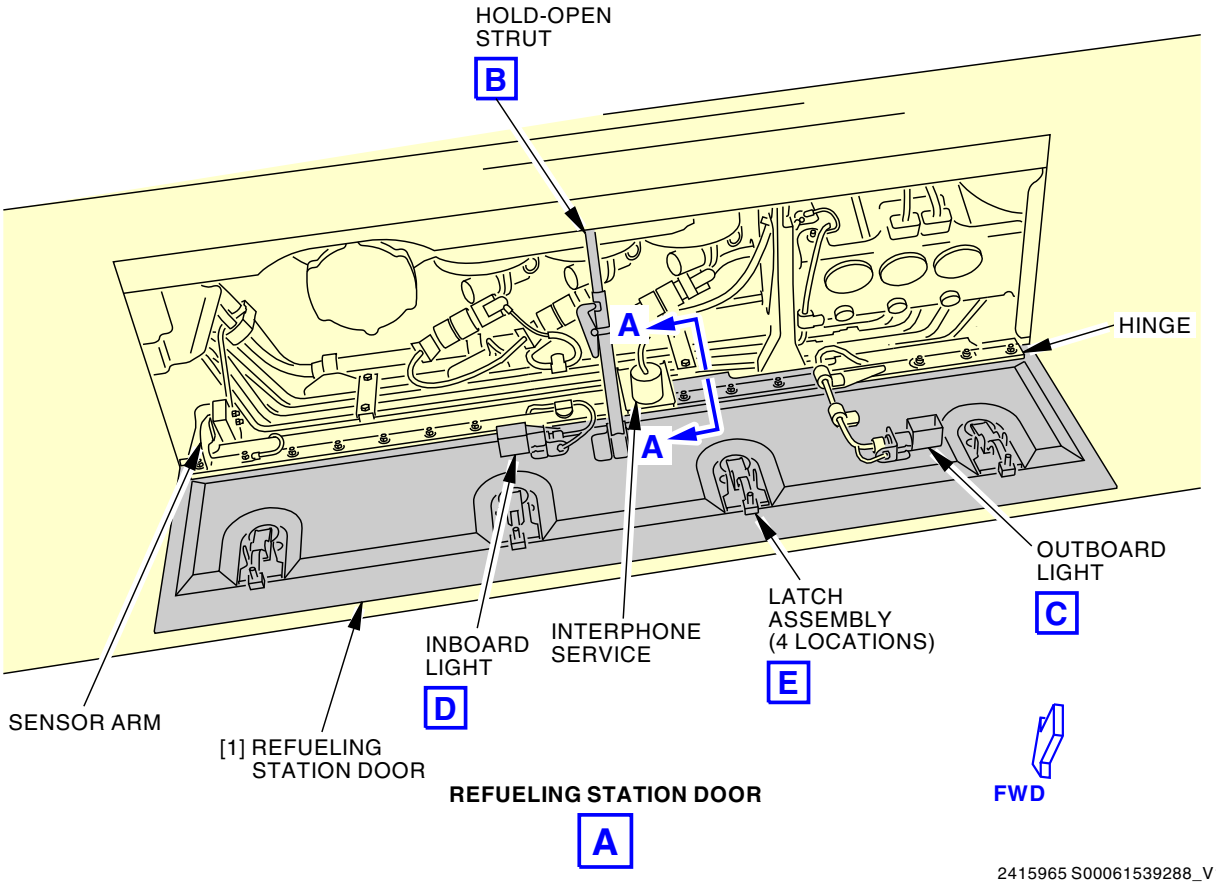
(c) Make sure that the latches [28] operate correctly.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



RIGHT WING



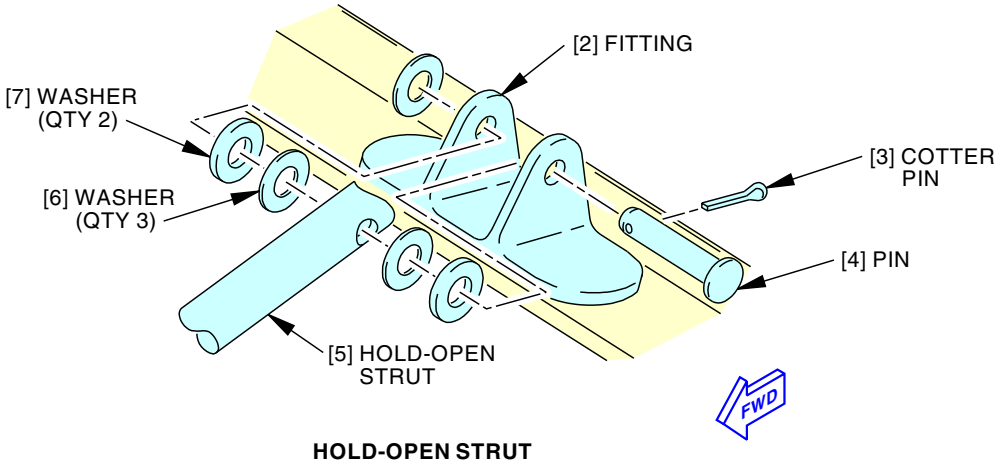
REFUELING STATION DOOR

A

2415965 S00061539288_V1

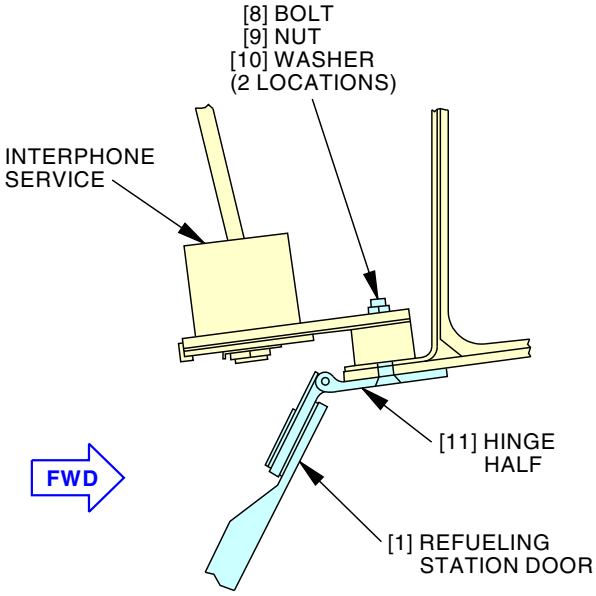
Refueling Station Door Installation
Figure 401/52-49-21-990-801 (Sheet 1 of 4)

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HOLD-OPEN STRUT

B



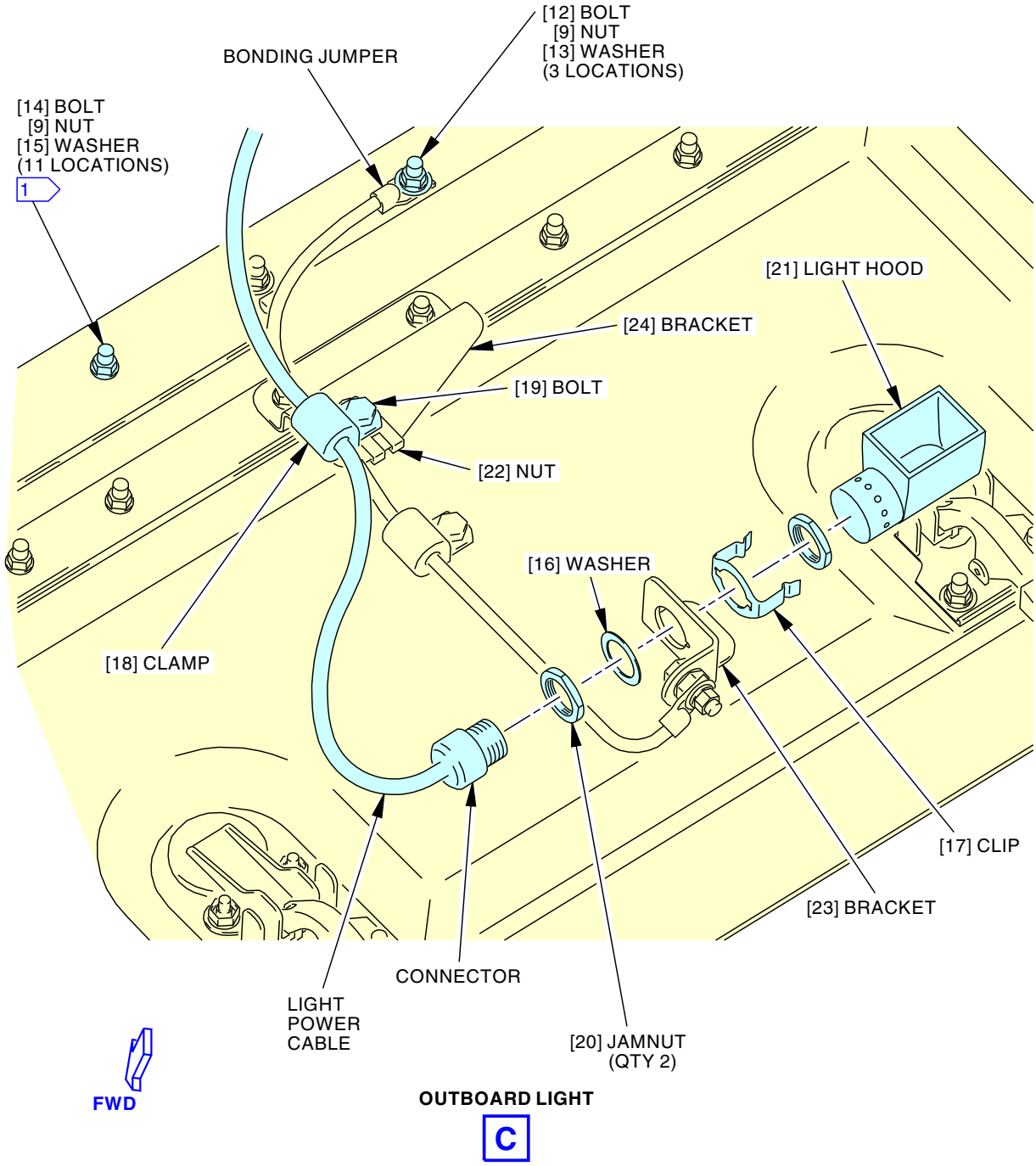
(DOOR IN THE OPEN POSITION)

A-A

2415966 S00061539289_V1

Refueling Station Door Installation
Figure 401/52-49-21-990-801 (Sheet 2 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

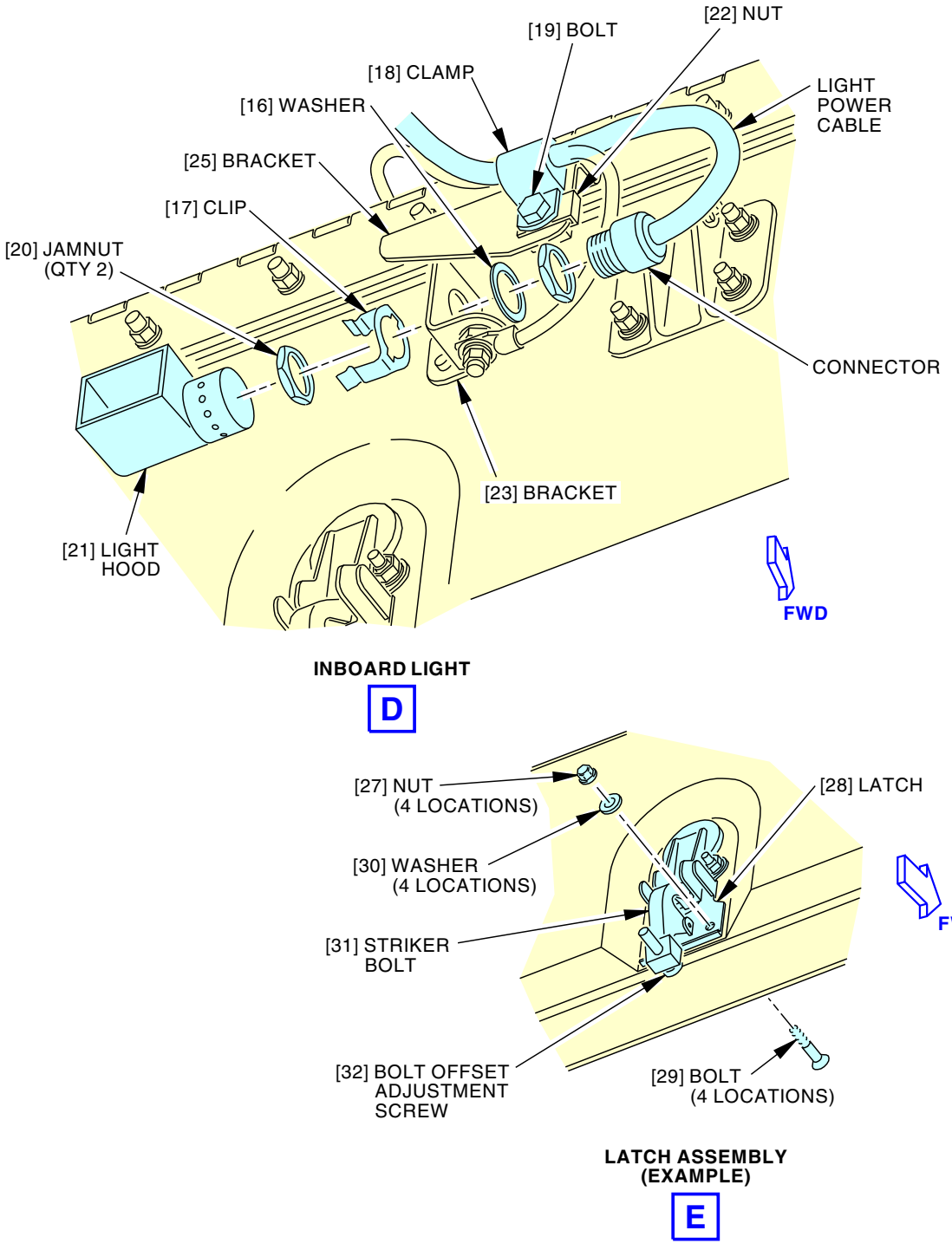


1 ONLY REMOVE OR INSTALL FASTENERS ON HINGE HALF [11]

2415967 S00061539290_V2

Refueling Station Door Installation
Figure 401/52-49-21-990-801 (Sheet 3 of 4)

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2415968 S00061539291_V2

Refueling Station Door Installation
Figure 401/52-49-21-990-801 (Sheet 4 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FLIGHT COMPARTMENT DOOR - MAINTENANCE PRACTICES

1. General

A. This procedure contains these tasks:

(1) Program the Access Code

(2) Program Time Delays and DOOR BELL Enable

B. In the program mode, if the time gap between two of the inputs, including the ENT key, is more than 30 seconds the system will:

(1) Ignore keypad inputs made before the program button was pushed.

(2) Retain the access, time delay and doorbell enable codes before the program button was pushed.

(3) Exit the program mode.

C. If the system is in the program mode for more than 3 minutes, it will exit the program mode.

D. The door is unlocked while the system is in the program mode.

TASK 52-51-00-900-801

2. Program the Access Code

(Figure 201)

A. General

(1) The access code must be 3 to 8 characters long.

(2) The amber LED on the keypad will blink continuously while the system is in the program mode.

(3) The access code is set to 12345 at the factory.

B. Location Zones

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

C. Program the Access Code

SUBTASK 52-51-00-850-001

(1) Do these procedures to program the access code:

(a) Remove the access cover from the chime module.

(b) Press and release the ACCESS switch on the chime module.

(c) Make sure that the amber light on the keypad FLASHES.

(d) Enter the new 3 to 8 digit access code on the keypad.

NOTE: Make sure the access code number is consistant with airline operational requirements.

(e) Press the ENT button on the keypad.

(f) Make sure that the amber light on the keypad is OFF.

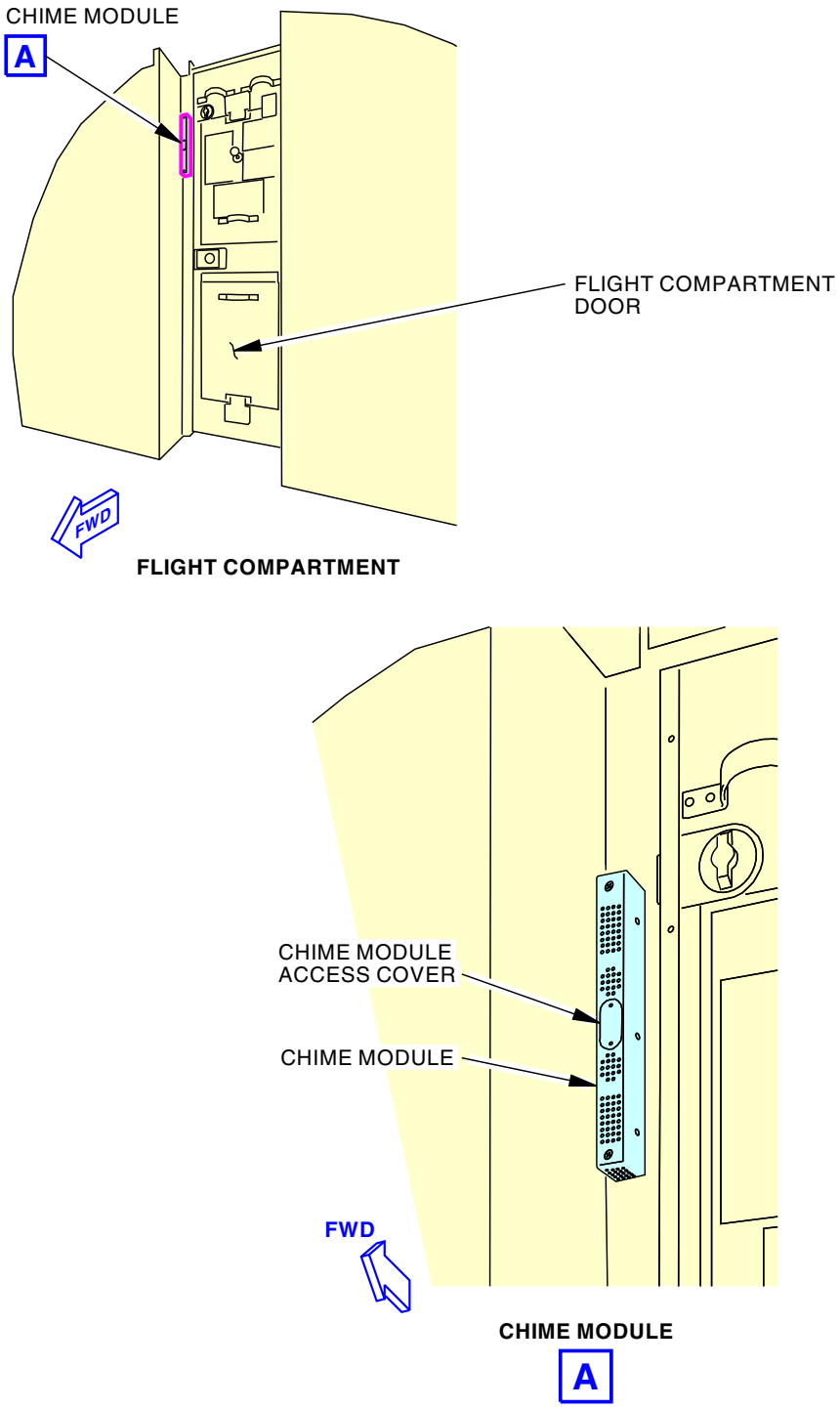
(g) Make sure that the red light on the keypad is ON.

(h) Use the new access code to make sure the door will unlock.

(i) Install the access cover on the chime module.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Chime Module
Figure 201/52-51-00-990-805

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-51-00-900-802

3. Program Time Delays and Door Bell Enable

(Figure 201)

A. General

(1) Programming steps for the DENY and AUTO UNLOCK time delays are all the same.

(2) The green Light Emitting Diode (LED) on the keypad will blink continuously while the system is in the program mode.

(3) The DOOR BELL ENABLE code will toggle the door bell enable.

(4) To program more than one time delay or door bell enable, the program mode must be re-entered each time.

(5) The keypad code to sound the door bell is 1, ENT.

(6) The access time delay is set to 30 seconds at the factory.

(7) The deny time delay set to 5 minutes at the factory.

(8) The door bell function is set to DISABLE at the factory.

B. Location Zones

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

C. Program Time Delays and Door Bell Enable

SUBTASK 52-51-00-850-002

(1) Do these steps to program the time delays and door bell enable:

(a) Remove the access cover from the chime module.

(b) Press and release the TIMERS switch on the chime module.

(c) Enter the 3 digit time delay or doorbell enable code on the keypad (Table 201).

NOTE: The Access Time Delay must only be set to 30, 45, or 60 seconds. If the door bell mode is enabled then the Continuous Chime Time Delay must be set to 0 seconds (code 311).

(d) Press the ENT button on the keypad.

(e) Enter the 3 digit time delay or doorbell enable code a second time on the keypad (Table 201).

(f) Press the ENT button on the keypad.

NOTE: The green LED will come on for five seconds when the new code has been accepted by the chime module. The green LED will then go off and the red LED will come on. If the two codes that you entered do not match the chime module will exit the programming mode.

(g) Use the access code to unlock the door in the AUTO mode.

(h) Make sure that the time delays for the CONTINUOUS CHIME, AUTO UNLOCK or DENY are correct.

(i) Enter 1 and ENT on the keypad to make sure that the DOOR BELL ENABLE mode operates, if the DOOR BELL mode has been enabled.

(j) Install the access cover on the chime module.

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Table 201/52-51-00-993-801 TIME DELAY AND DOOR BELL ENABLE CODES

CODE	TIME	NOMENCLATURE
112	30 Seconds	Access Time Delay *[1]
113	45 Seconds	Access Time Delay *[2]
114	60 Seconds	Access Time Delay *[2]
211	5 Minutes	Deny Access Time Delay
212	10 Minutes	Deny Access Time Delay
213	15 Minutes	Deny Access Time Delay
214	20 Minutes	Deny Access Time Delay
215	25 Minutes	Deny Access Time Delay
221	30 Minutes	Deny Access Time Delay
311	0 Seconds	Continuous Chime Time Delay
312	5 Seconds	Continuous Chime Time Delay
313	10 Seconds	Continuous Chime Time Delay
314	15 Seconds	Continuous Chime Time Delay
315	20 Seconds	Continuous Chime Time Delay
321	25 Seconds	Continuous Chime Time Delay *[2]
322	30 Seconds	Continuous Chime Time Delay *[2]
323	35 Seconds	Continuous Chime Time Delay *[2]
324	40 Seconds	Continuous Chime Time Delay *[2]
325	45 Seconds	Continuous Chime Time Delay *[2]
331	50 seconds	Continuous Chime Time Delay *[2]
555	N/A	Toggles Door Bell Mode ON or OFF *[3]

*[1] 30 second Access Time Delay is required for airplanes that are registered in a JAA Member country.
*[2] Not a valid code for airplanes that are registered in a JAA member country.
*[3] If Door Bell Mode is enabled then the Continuous Chime Time Delay must be set to 0 seconds (Code 311).

——— END OF TASK ———

TASK 52-51-00-710-801

4. Decompression Panel Hinge Operation

(Figure 202)

NOTE: This procedure is a scheduled maintenance task.

A. General

(1) This procedure contains task to do a check of the decompression panel hinge operation to make sure that the decompression panel hinges operate smoothly without binding or interference.

B. Location Zones

Zone	Area
211	Flight Compartment - Left

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Zone	Area
212	Flight Compartment - Right

C. Decompression Panel Hinge Operation

SUBTASK 52-51-00-010-001

(1) Gain access to the forward side of the flight deck door.

SUBTASK 52-51-00-010-002

(2) Do these steps to do a check of the decompression panel:

(a) Do these steps to remove the decompression panel:

1) Disconnect the strap that attaches the upper decompression panel to the flight compartment door by pulling up on the strap at the door connection.

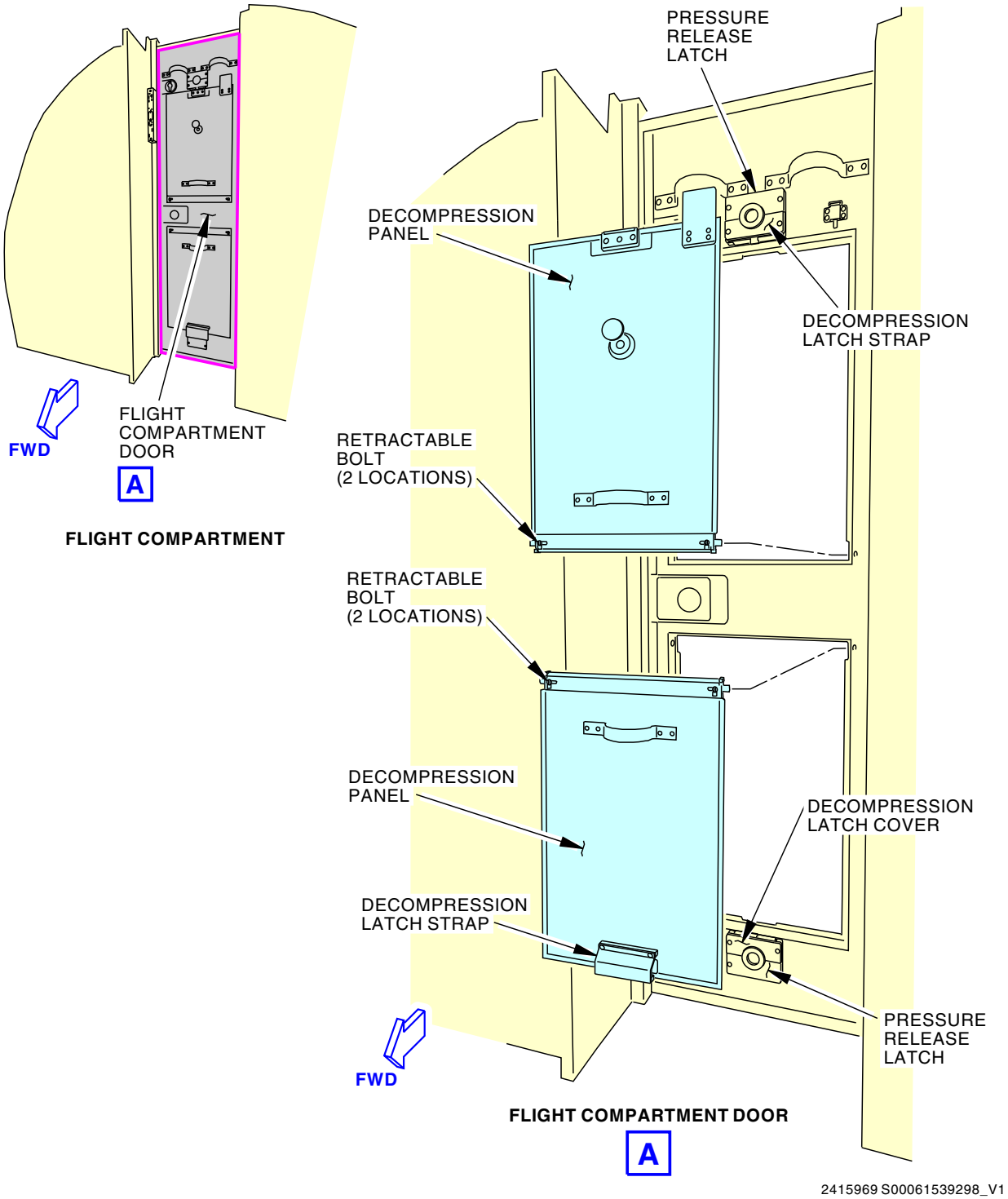
2) Push in on the two retractable bolts on the hinge assembly at the top or bottom of the decompression panel to remove it.

(b) Make sure that the bolts retract smoothly and completely clear the panel doorframe.

(c) Install the decompression panel.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Decompression Panel Hinge Operation
Figure 202/52-51-00-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FLIGHT COMPARTMENT DOOR - ADJUSTMENT/TEST

1. General

A. This procedure has these tasks:

(1) Operational Check of the Flight Compartment Access System

(2) Flight Compartment Security Door Access System Test

(3) Functional Check of the DENY Function of the Flight Compartment Security Access System (Scheduled Maintenance Task)

(4) Pressure Release Latch Functional Test.

TASK 52-51-00-710-802

2. Operational Check of the Flight Compartment Access System

(Figure 501)

A. General

(1) This task does a test of the chime module speaker to make sure you can hear the chime and that other parts of the access system operate.

B. Location Zones

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

C. Prepare for the Test

SUBTASK 52-51-00-860-001

(1) Obtain the access code for the flight deck door.

NOTE: The access code is programmable. You need to obtain the access code currently in use by the flight crew.

SUBTASK 52-51-00-860-003

(2) Make sure that this circuit breaker is closed:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

SUBTASK 52-51-00-860-004

(3) Make sure the Flight Deck Access System switch on the Chime Module is in the NORM position (guard closed).

SUBTASK 52-51-00-860-005

(4) Make sure the flight compartment door is open.

D. Flight Compartment Access System Operational Test

SUBTASK 52-51-00-710-001

(1) Do these steps to make sure the chime module speaker operates:

(a) Make sure the FLT DK DOOR switch is in the AUTO position.

(b) Enter the access code in the keypad and press the ENT key.

(c) Make sure the chime module sounds.

(d) Make sure the AUTO UNLK light comes on.

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(e) Put the FLT DK DOOR switch to the DENY position.

(f) Make sure the AUTO UNLK light goes off.

(g) Put the FLT DK DOOR switch to the UNLKD position.

(h) Put the Flight Deck Access System switch on the chime module to the OFF position.

(i) Make sure the LOCK FAIL Light comes on.

(j) Put the Flight Deck Access System switch to the NORM position.

——— END OF TASK ———

TASK 52-51-00-700-801

3. Flight Compartment Security Door Access System Test

(Figure 501)

A. General

(1) This task is performed with the door in the open position. With the door in the open position, one mechanic can turn the FLT DK DOOR rotary switch, enter keypad numbers and see the position of the strike at the same time. This allows the test to be performed with one mechanic.

(2) This task does a test of the following functions of the flight compartment security door access system:

(a) AUTO Mode

(b) UNLOCK Mode

(c) DENY Mode

(d) Power on Solenoid Deactivation

(e) Doorbell Function

B. Location Zones

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

C. Prepare for the Test

SUBTASK 52-51-00-750-001

(1) Obtain the following information:

NOTE: These items are programmable. You need to obtain the access code and times currently in use by the flight crew.

(a) Access Code

(b) Access Time Delay

(c) Deny Time Delay

(d) Time of Continuous Chime

SUBTASK 52-51-00-860-008

(2) Make sure that this circuit breaker is closed:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 52-51-00-860-009

(3) Make sure the Flight Deck Access System switch on the Chime Module is in the NORM position (guard closed).

SUBTASK 52-51-00-860-010

(4) Make sure the flight compartment door is open.

D. AUTO Mode Test

SUBTASK 52-51-00-710-002

(1) Do these steps to make sure the AUTO Mode operates:

(a) Make sure the FLT DK DOOR rotary switch on the Cockpit Control panel Switch/Light Module is in the AUTO position.

(b) Make sure the red LED on the keypad is on.

(c) Make sure the electric strike is in the locked position.

NOTE: The solenoid pin in the electric strike is extended up and the strike can not be turned.

(d) Enter the access code in the keypad..

NOTE: You must keep track of the time elapsed from when you press the ENT key.

(e) Press the ENT key.

(f) Do these steps immediately after the correct access code is entered:

1) Make sure that the amber LED on the keypad comes on and the red LED goes off.

2) Make sure the chime module sounds two one-half second tones.

NOTE: If the Continuous Chime Time Delay is set to 0 (zero) seconds (Code 311), then a continuous chime will occur and not the half second tones.

3) Make sure the AUTO UNLK light comes on.

(g) Do this step when one third of the Access Time Delay has elapsed:

NOTE: If the Time of Continuous Chime is programmed to occur at one third or less of the Access Time Delay, then the two half second tones in the step below will not sound.

1) Make sure the chime sounds two half second tones again.

(h) Do these steps when the Time of Continuous Chime has elapsed:

NOTE: If the Time of Continuous Chime is set to occur 5 seconds or less before the Access Time Delay, the Time of Continuous Chime will occur 10 seconds before the Access Time Delay.

1) Make sure the AUTO UNLK light flashes.

2) Make sure the chime module sounds continuously.

(i) Do these steps when the Access Time Delay has expired:

1) Make sure the electric strike is in the unlocked position.

NOTE: The solenoid pin in the electric strike retracts down and the strike can be turned.

2) Make sure the green LED on the keypad comes on and the amber LED goes off.

3) Make sure the chime module does not sound.

4) Make sure the AUTO UNLK light goes off.

(j) Do these steps five seconds after the electric strike goes to the unlocked position:

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1) Make sure the electric strike is in the locked position.
2) Make sure the green LED goes off and the red LED comes on.

E. UNLOCK Mode Test

SUBTASK 52-51-00-710-003

(1) Do these steps to make sure the UNLOCK Mode operates:
   (a) Make sure the FLT DK DOOR rotary switch on the Cockpit Control Panel Switch/Light module is in the AUTO position.
   (b) Make sure the red LED on the keypad is on.
   (c) Make sure the electric strike is in the locked position.
      NOTE: The solenoid pin in the electric strike extends up and the strike can not be turned.
   (d) Enter the access code in the keypad and press the ENT key.
      1) Make sure that the amber LED on the keypad comes on and the red LED goes off.
      2) Make sure that the chime module sounds two one-half second tones.
         NOTE: If the continuous chime time delay is set to 0 seconds (code 311), then a continuous chime occurs and not the half second tones.
      3) Make sure the AUTO UNLK light on the cockpit control panel comes on.
   (e) Put and hold the FLT DK DOOR switch to the UNLKD position.
      1) Make sure that the green LED on the keypad comes on and the amber LED goes off.
      2) Make sure the electric strike is in the unlocked position.
         NOTE: The solenoid pin in the electric strike retracts down and the strike can be turned.
   (f) Put the FLT DK DOOR switch back to the AUTO position.

F. DENY Mode Test

SUBTASK 52-51-00-710-004

(1) Do these steps to make sure the DENY Mode operates:
   (a) Make sure the FLT DK DOOR rotary switch on the Cockpit Control Panel Switch/Light module is in the AUTO position.
   (b) Make sure the red LED on the keypad is on.
   (c) Make sure the electric strike is in the locked position.
      NOTE: The solenoid pin in the electric strike extends up and the strike can not be turned.
   (d) Enter the access code in the keypad and press the ENT key.
      1) Make sure that the amber LED on the keypad comes on and the red LED goes off.
      2) Make sure that the chime module sounds two one-half second tones.
         NOTE: If the continuous chime time delay is set to 0 seconds (code 311), then a continuous chime occurs and not the half second tones.
      3) Make sure the AUTO UNLK light on the cockpit control panel comes on.
   (e) Put and momentarily hold the FLT DK DOOR switch in the DENY position.
      NOTE: You must keep track of the time elapsed from when you put the switch in the DENY position.

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1) Make sure that the electric strike is in the locked position.

NOTE: The solenoid pin in the electric strike extends up and the strike can not be turned.

2) Make sure that the amber LED on the keypad goes off and the red LED comes on.

3) Make sure that the AUTO UNLK light on the cockpit control panel goes off.

(f) Do these steps before the DENY Time Delay has expired:

1) Enter the access code in the keypad and press the ENT key.

a) Make sure that the red LED on the keypad stays on.

b) Make sure that the chime module does not sound.

c) Make sure the AUTO UNLK light on the cockpit control panel stays off.

(g) Do these steps after the Deny Time Delay has expired:

1) Enter the access code on the keypad and press the ENT key.

a) Make sure that the amber LED on the keypad comes on and the red LED goes off.

b) Make sure the chime module sounds two one-half second tones.

NOTE: When the continuous chime time delay is set to 0 seconds (code 311), a continuous chime occurs and not the half second tones.

c) Make sure the AUTO UNLK light on the cockpit control panel comes on.

(h) Put and hold the FLT DK DOOR switch to the UNLKD position.

1) Make sure that the green LED on the keypad comes on and the amber LED goes off.

2) Make sure the electric strike is in the unlocked position.

NOTE: The solenoid pin in the electric strike retracts down and the strike can be turned.

(i) Put the FLT DK DOOR switch back to the AUTO position.

1) Make sure the red LED on the keypad comes on and the green LED goes off.

2) Make sure the electric strike is in the locked position.

NOTE: The solenoid pin in the electric strike extends up and the strike can not be turned.

G. Power On Solenoid Deactivation Test

SUBTASK 52-51-00-710-005

(1) Do these steps to make sure the Flight Deck Access System switch operates:

(a) Open the switch guard on the bottom of the chime module and put the toggle switch to the OFF position.

(b) Make sure the electric strike is in the unlocked position.

NOTE: The Solenoid pin in the electric strike will retract down such that you can rotate the strike.

(c) Make sure the LOCK FAIL light on the cockpit control module comes ON.

(d) Put the toggle switch back to the NORM position and close the guard.

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(e) Make sure the electric strike is in the locked position.

NOTE: The Solenoid pin in the electric strike will extend such that you can not rotate the strike.

(f) Make sure the LOCK FAIL light goes off.

H. Doorbell Function Test

SUBTASK 52-51-00-710-006

(1) Do these steps to make sure the Doorbell Function operates:

NOTE: The Doorbell function must be enabled.

(a) Enter 1 in the keypad and then ENT.

(b) Make sure the chime module sounds two tones.

(c) Make sure the red LED stays on.

——— END OF TASK ———

TASK 52-51-00-700-802

4. Functional Check of the DENY Function of the Flight Deck Access System

(Figure 501)

NOTE: This procedure is a scheduled maintenance task.

A. General

(1) This task does a test of the Deny function of the flight compartment security door access system.

B. Location Zones

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

C. DENY Function of the Flight Deck Access System Functional Check

SUBTASK 52-51-00-750-002

(1) Obtain the following information:

NOTE: These items are programable. You need to obtain the access code and times currently in use by the flight crew.

(a) Access Code

(b) Deny Time Delay

SUBTASK 52-51-00-860-012

(2) Make sure that this circuit breaker is closed:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

SUBTASK 52-51-00-860-013

(3) Make sure the Flight Deck Access System switch on the Chime Module is in the NORM position (guard closed).

SUBTASK 52-51-00-860-014

(4) Make sure the flight compartment door is open.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

D. DENY Mode Test

SUBTASK 52-51-00-710-007

(1) Do these steps to make sure the DENY Mode operates:

(a) Make sure the red LED on the keypad is on.

(b) Make sure the electric strike is in the locked position.

NOTE: The solenoid pin in the electric strike will be extended up and the strike can not be turned.

(c) Enter the access code in the keypad and press the ENT key.

1) Make sure that the amber LED on the keypad comes on and the red LED goes off.

2) Make sure that the chime module sounds two one-half second tones.

NOTE: When the continuous chime time delay is set to 0 seconds (code 311), a continuous chime occurs and not the half second tones.

3) Make sure that the AUTO UNLK light on the cockpit control panel comes on.

(d) Put and momentarily hold the FLT DK DOOR switch in the DENY position.

NOTE: You must keep track of the time elapsed from when you put the switch in the DENY position.

1) Make sure that the electric strike is in the locked position.

NOTE: The solenoid pin in the electric strike is extended up and the strike can not be turned.

2) Make sure that the amber LED on the keypad goes off and the red LED comes on.

3) Make sure that the AUTO UNLK light on the cockpit control panel goes off.

4) Make sure that the chime module does not sound.

(e) Do these steps before the DENY Time Delay has expired:

1) Enter the access code in the keypad and press the ENT key.

a) Make sure that the red LED on the keypad stays on.

b) Make sure that the chime module does not sound.

c) Make sure that the AUTO UNLK light on the cockpit control panel goes off.

(f) Do these steps after the Deny Time Delay has expired:

1) Enter the access code on the keypad and press the ENT key.

a) Make sure that the amber LED on the keypad comes on and the red LED goes off.

b) Make sure that the chime module sounds two one-half second tones.

NOTE: If the continuous chime time delay is set to 0 seconds (code 311), then a continuous chime occurs and not the half second tones.

c) Make sure that the AUTO UNLK light on the cockpit control panel comes on.

(g) Put and hold the FLT DK DOOR switch to the UNLKD position.

1) Make sure that the green LED on the keypad comes on and the amber LED goes off.

2) Make sure the electric strike is in the unlocked position.

NOTE: The solenoid pin in the electric strike retracts down and the strike can be turned.

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(h) Put the FLT DK DOOR switch back to the AUTO position.

1) Make sure the red LED on the keypad comes on and the green LED goes off.

2) Make sure the electric strike is in the locked position.

NOTE: The solenoid pin in the electric strike will be extended up and the strike can not be turned.

END OF TASK

52-CMR-01

TASK 52-51-00-710-803

5. Pressure Release Latch Functional Test

(Figure 502)

NOTE: This procedure is a scheduled maintenance task.

A. General

(1) This task does a functional test of the pressure release latches.

(2) The tests for the upper and lower pressure release latches is the same.

B. References

Reference	Title
52-51-08-000-801	Decompression Panel and Pressure Release Latch Removal (P/B 401)
52-51-08-400-801	Decompression Panel and Pressure Release Latch 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-4400	Test Kit - Flight Deck Door (includes HSK6263-11, -13, -15) Part #: HSK6263-1 Supplier: 4U783

D. Location Zones

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

E. Prepare for the Test

SUBTASK 52-51-00-010-003

(1) Do the applicable steps to remove the latch strap and the decompression latch cover to get access to the latches (TASK 52-51-08-000-801).

SUBTASK 52-51-00-840-001

(2) Prepare the test kit, SPL-4400 as follows:

(a) Make sure that the vent on the vacuum generator manometer does not have unwanted material or blockage.

(b) Make sure that the hose is securely connected between the fitting on the squeeze bulb and the manometer.

(c) Push the power control switch to turn on the display.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(d) Turn the display selection control to the necessary unit value.

F. Procedure

SUBTASK 52-51-00-710-008

(1) Use the vacuum generator to make sure that the pressure release latch operates correctly.

(a) Put the vacuum cup over the air cylinder filter on the front of the pressure release latch.

(b) Make sure that the vacuum cup is in full contact with the air cylinder filter and covers the air cylinder filter fully.

NOTE: Hold the vacuum cup in full contact with the face of the pressure relief latch at the air cylinder filter during the entire test.

(c) Operate the squeeze bulb until the pressure decreases to 0.5 psi (3.4 kPa) at the air cylinder filter.

NOTE: The pressure drop will show on the display of the manometer.

(d) Insert the bolt rotation tool in the pressure relief latch hole in the bolt.

(e) Make sure that you can turn the bolt 90 degrees from the closed position to the open position.

NOTE: The air cylinder will open when the latch release load is 99 lb (45 kg) ±5 lb (2 kg).

(f) Remove the vacuum cup from the air cylinder filter.

(g) Rotate the bolt back to the closed position.

NOTE: Make sure you rotate the bolt until you can feel a hard stop.

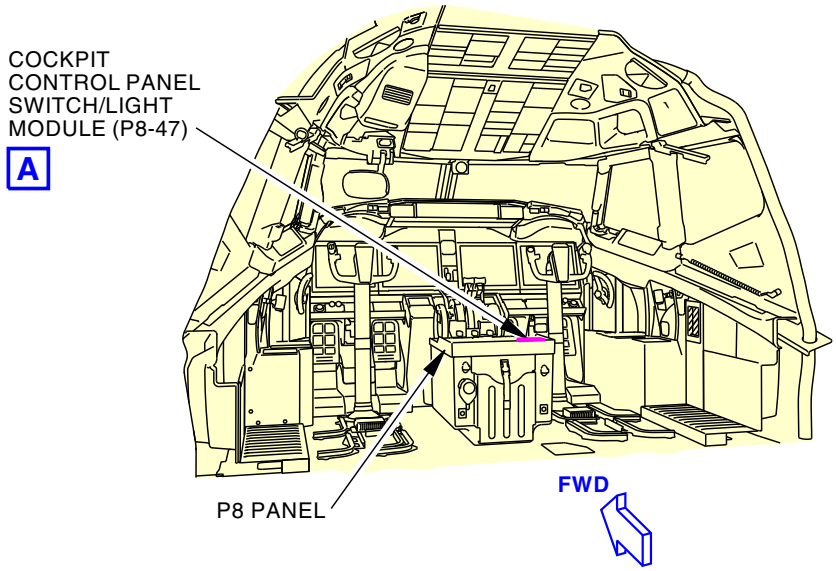
G. Put the Airplane Back to its Usual Condition

SUBTASK 52-51-00-410-001

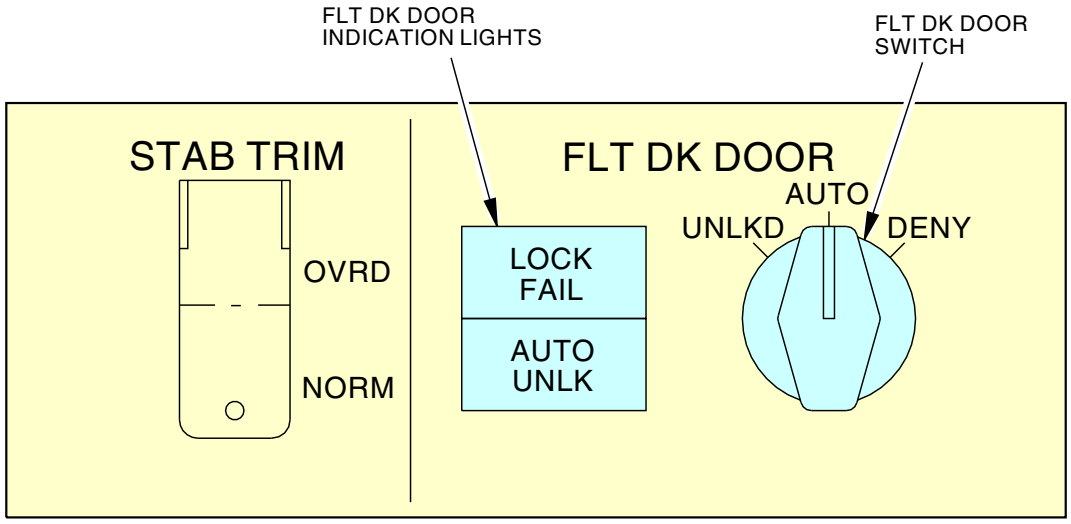
(1) Install the latch strap and the decompression latch cover (Decompression Panel and Pressure Release Latch Installation, TASK 52-51-08-400-801).

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



FLIGHT COMPARTMENT



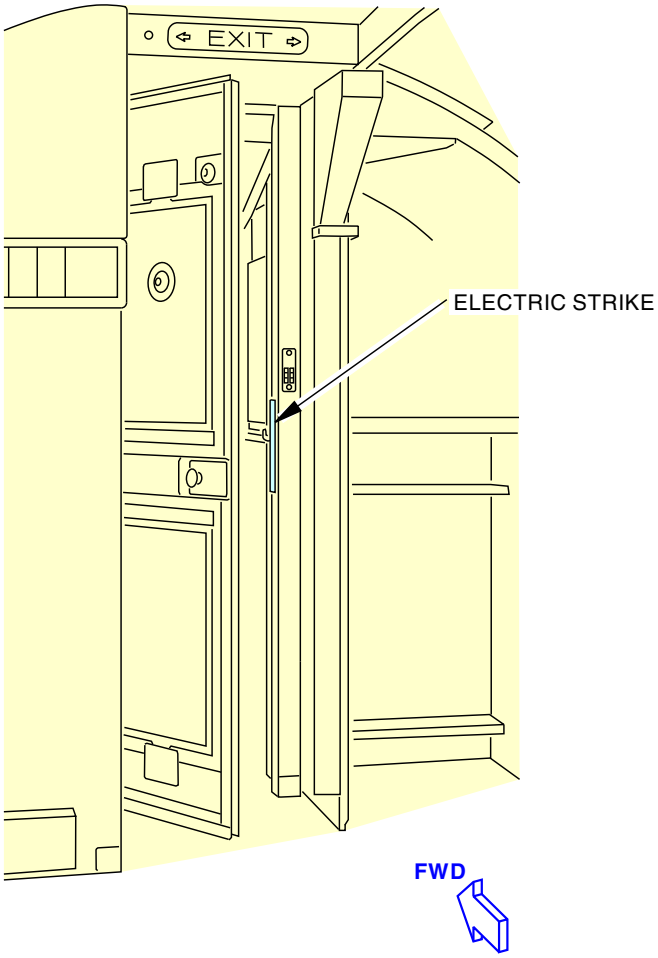
COCKPIT CONTROL PANEL SWITCH/LIGHT MODULE

A

2415970 S00061539304_V2

Flight Compartment Door - Adjustment/Test
Figure 501/52-51-00-990-802 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

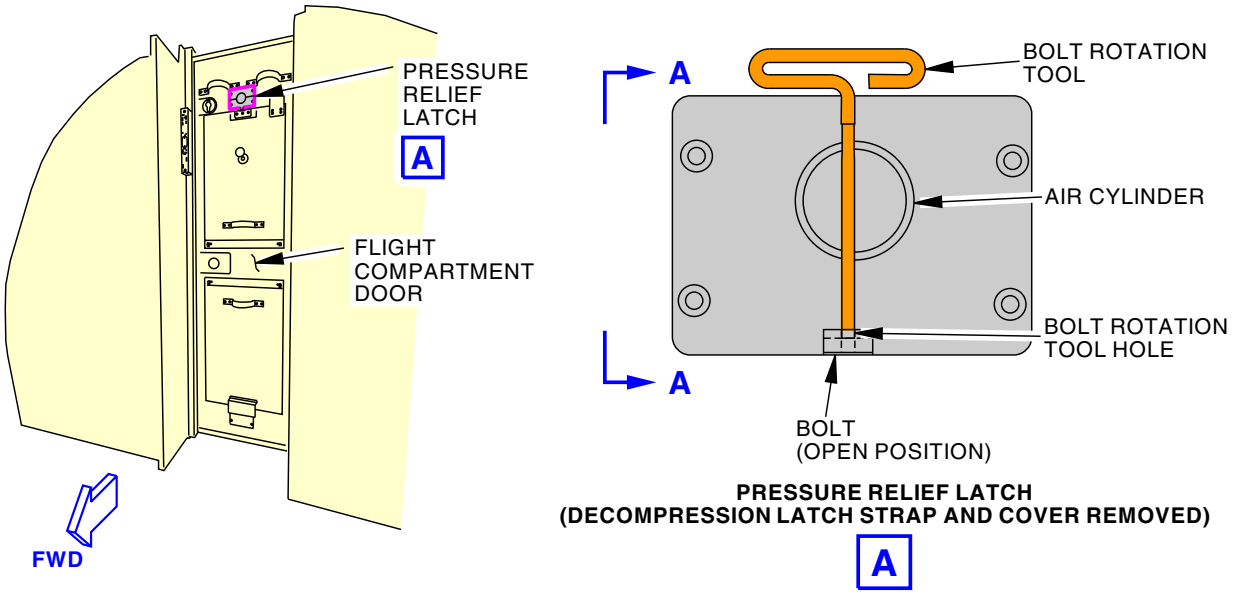


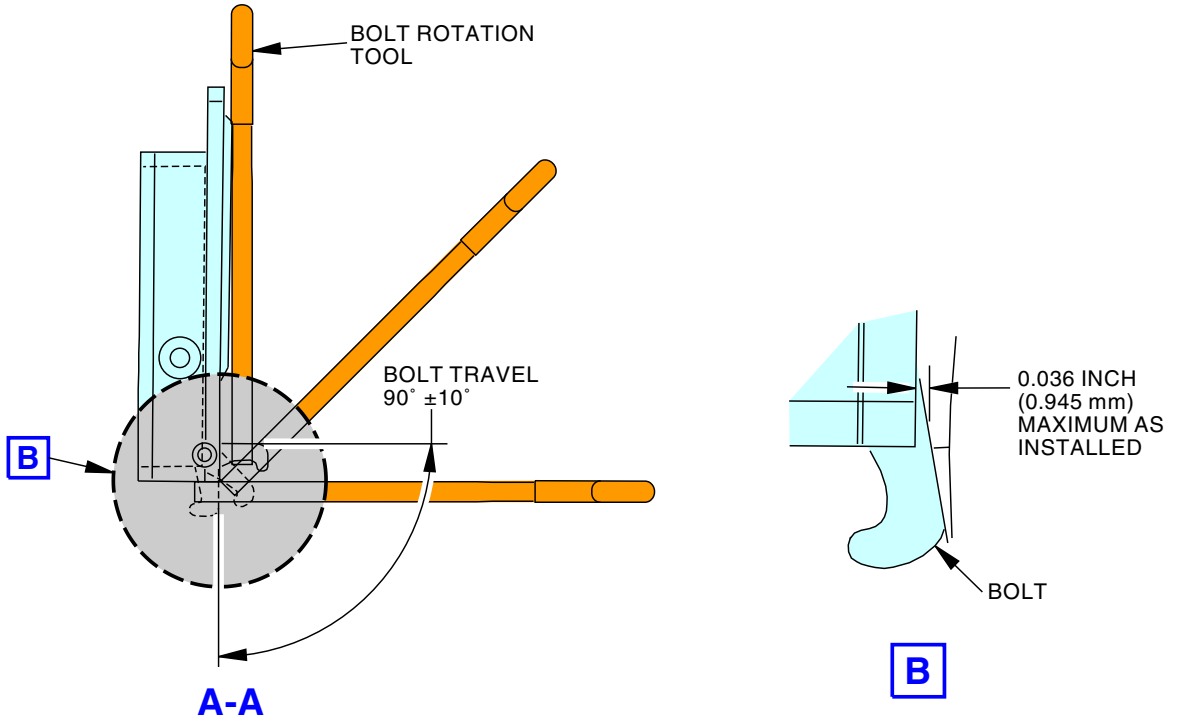
FLIGHT COMPARTMENT DOOR

2415971 S00061539305_V1

Flight Compartment Door - Adjustment/Test
Figure 501/52-51-00-990-802 (Sheet 2 of 2)

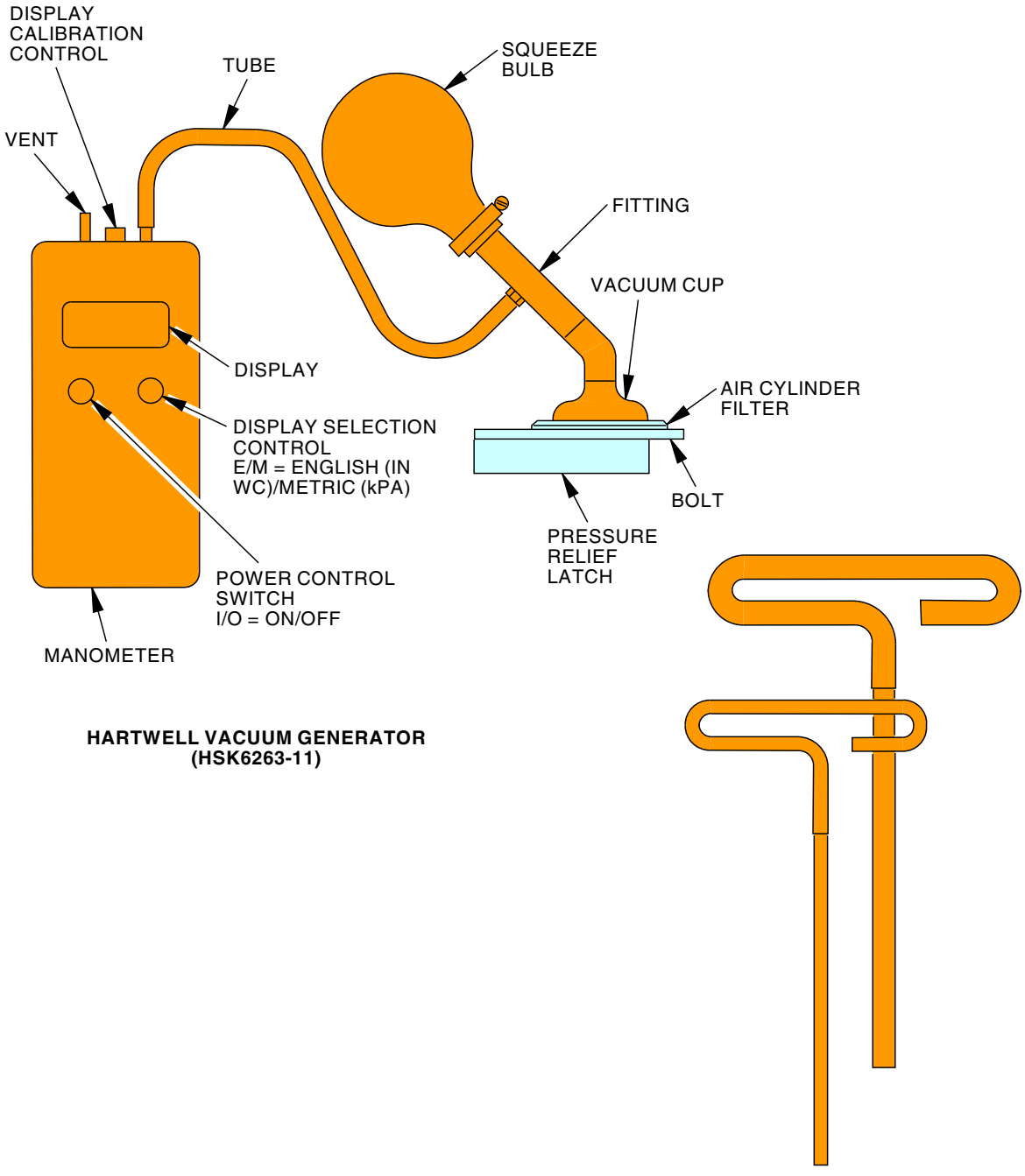
ECCN 9E991 BOEING PROPRIETARY - See title page for details





Pressure Release Latch Test
Figure 502/52-51-00-990-803 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Pressure Release Latch Test
Figure 502/52-51-00-990-803 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FLIGHT COMPARTMENT DOOR - INSPECTION/CHECK

1. General

A. This procedure contains these tasks:

(1) An inspection of the decompression panel hinges

(2) An inspection of the decompression panel seals

(3) There are two decompression panels in the door. The removal and installation steps are almost the same for both panels.

TASK 52-51-00-210-801

2. Decompression Panel Hinge - Inspection

(Figure 601)

NOTE: This procedure is a scheduled maintenance task.

A. General

(1) This procedure is a scheduled maintenance task.

B. Location Zones

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

C. Decompression Panel Hinge Inspection

SUBTASK 52-51-00-010-004

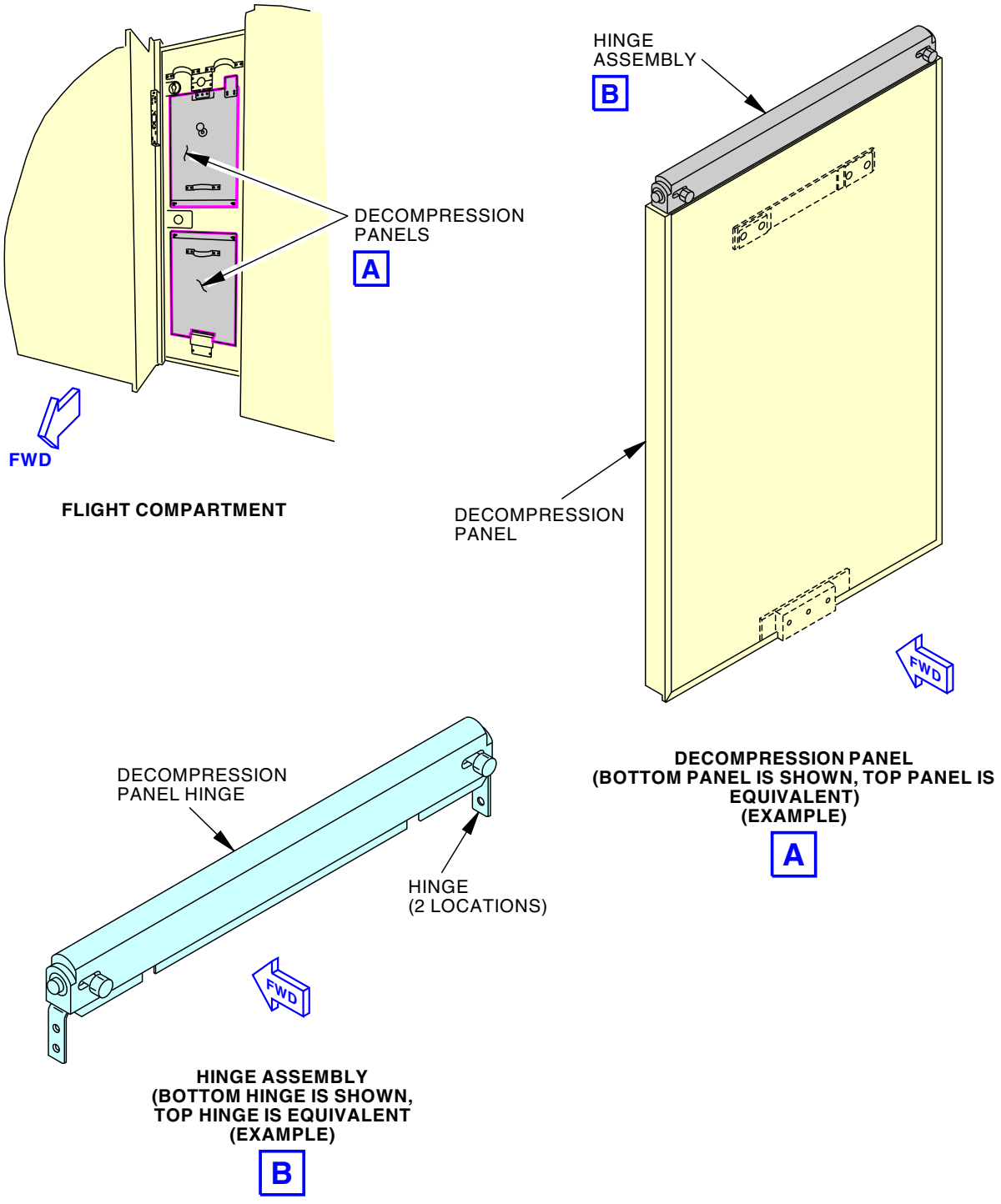
(1) Gain access to the forward side of the flight deck door.

SUBTASK 52-51-00-210-001

(2) Examine the condition of the top and bottom decompression panel hinges for damage or corrosion.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415974 S00061539310_V1

Decompression Panel Hinges - Inspection
Figure 601/52-51-00-990-804

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-51-00-210-802

3. Decompression Panel Seal - Inspection

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Decompression Panel Seal Inspection

SUBTASK 52-51-00-010-005

(1) Gain access to the forward side of the flight deck door.

SUBTASK 52-51-00-010-006

(2) Do these steps to remove the decompression panel:

(a) Disconnect the strap that attaches the upper decompression panel to the flight compartment door by pulling up on the strap at the door connection.

(b) Push in the two retractable bolts at the top or bottom of the decompression panel.

(c) Remove the decompression panel.

SUBTASK 52-51-00-210-002

(3) Check the door seals on the top, bottom, and sides of the panel frame for these abnormal conditions:

(a) Cracks

(b) Notches

(c) Unusual wear

(d) Tears

(e) Splits

(f) Dents.

SUBTASK 52-51-00-410-002

(4) Install the decompression panel.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FLIGHT COMPARTMENT DOOR - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the flight compartment door.

(2) An installation of the flight compartment door.

B. The flight compartment door is installed on the outer wall of Lavatory A.

TASK 52-51-01-000-801

2. Flight Compartment Door Removal

(Figure 401)

A. Location Zones

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

B. Flight Compartment Door Removal

SUBTASK 52-51-01-020-001

(1) Do these steps to remove the flight compartment door [1]:

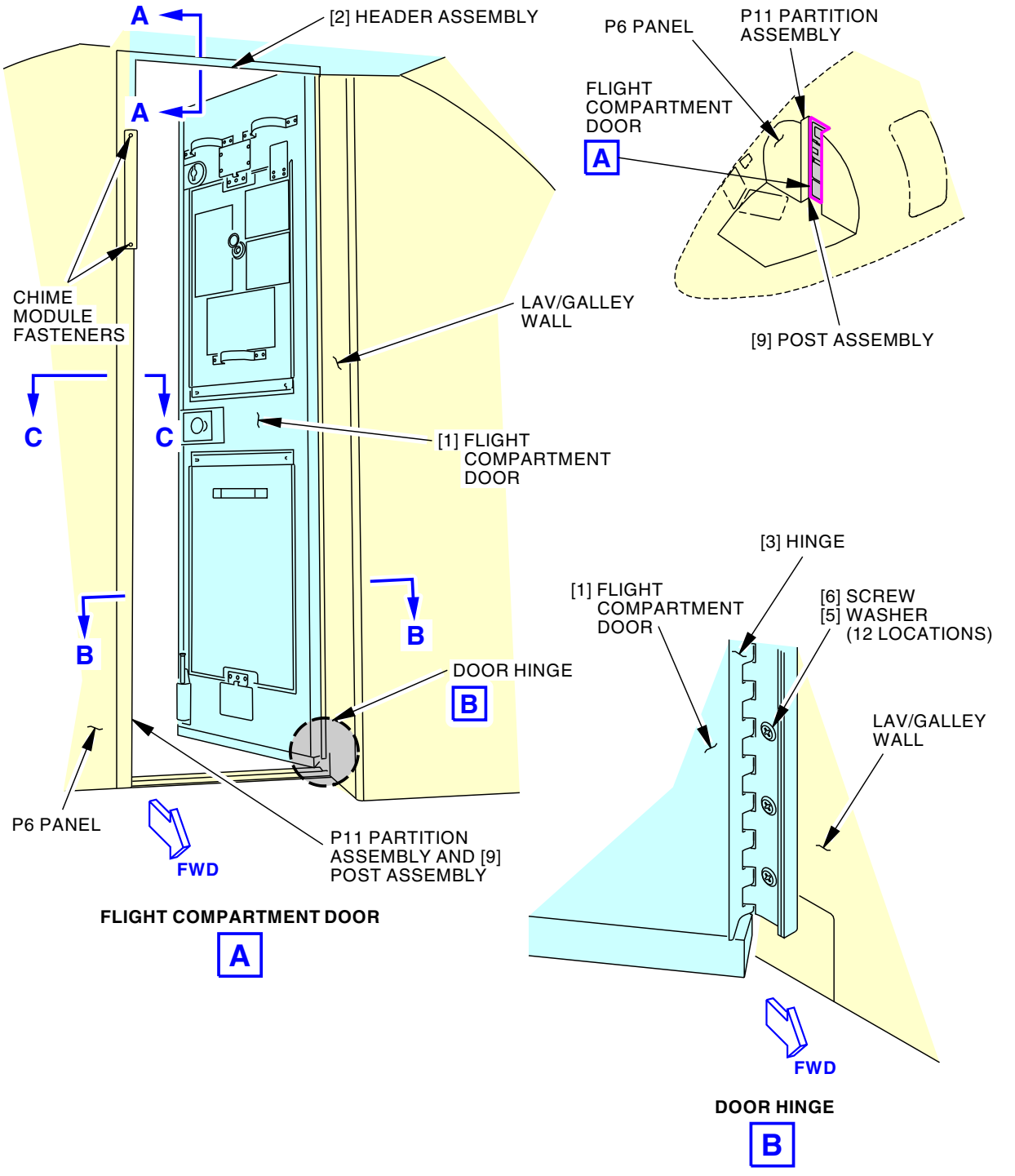
(a) Open the flight compartment door [1].

(b) Remove the screws [6] and washers [5] that attach the hinge [3] to the Lavatory A wall.

(c) Remove the flight compartment door [1].

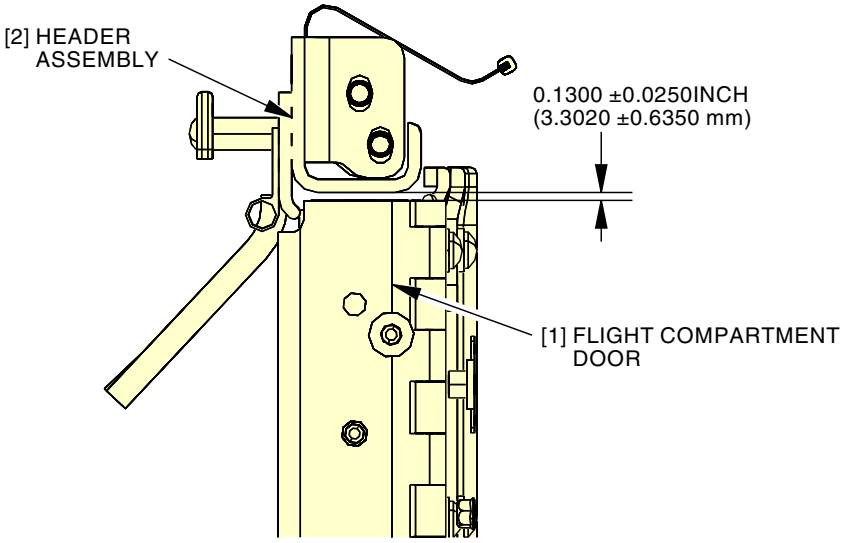
END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



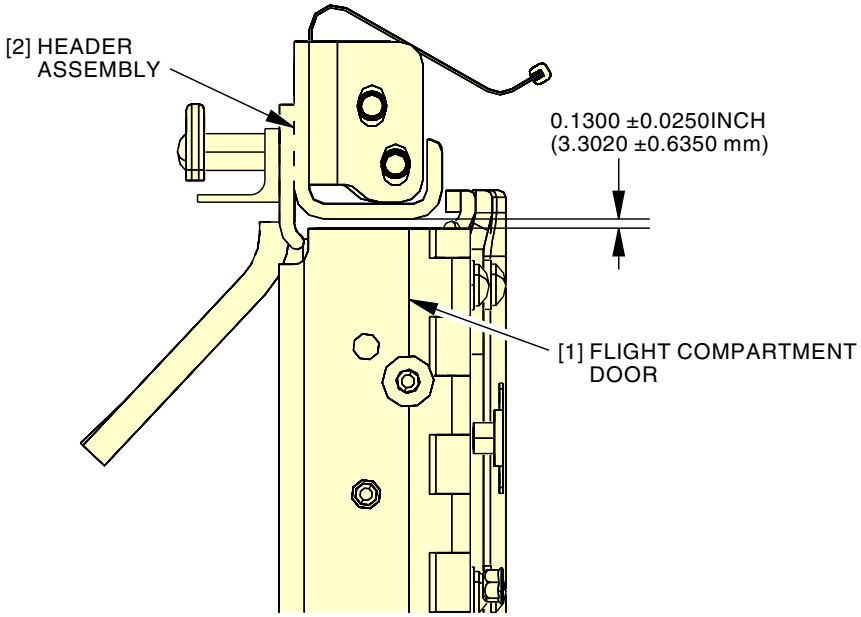
Flight Compartment Door Installation
Figure 401/52-51-01-990-803 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



CREW DOOR AND HEADER CLEARANCE (DOOR IN CLOSED POSITION)

A-A 1



CREW DOOR AND HEADER CLEARANCE (DOOR IN CLOSED POSITION)

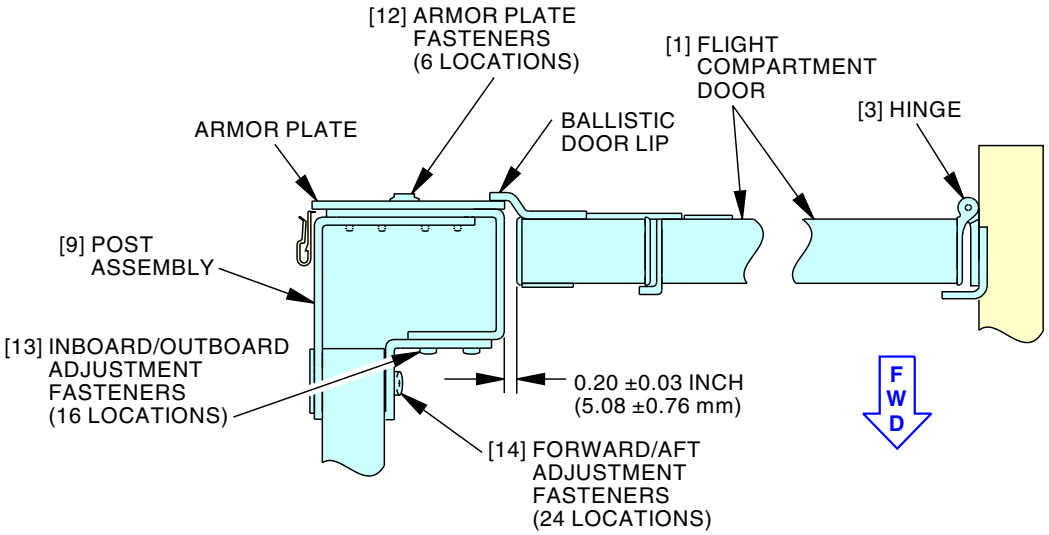
A-A 2

1 AIRPLANES WITH BULB SEAL
2 AIRPLANE WITH L SEAL

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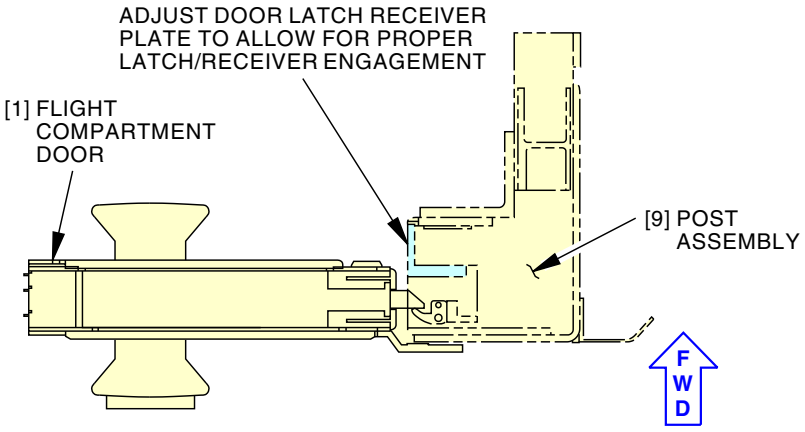
Flight Compartment Door Installation
Figure 401/52-51-01-990-803 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



CREW DOOR AND POST ASSEMBLY CLEARANCE (DOOR IN CLOSED POSITION)

B-B



CREW DOOR LATCH/RECEIVER PLATE ENGAGEMENT (DOOR IN CLOSED POSITION)

C-C

2415975 S00061539316_V4

Flight Compartment Door Installation
Figure 401/52-51-01-990-803 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-51-01-400-801

3. Flight Compartment Door Installation

(Figure 401)

A. References

Reference	Title
52-51-03 P/B 401	ELECTRIC STRIKE - REMOVAL/INSTALLATION
52-51-06-000-801	Chime Module Removal (P/B 401)
52-51-06-400-801	Chime Module Installation (P/B 401)

B. Tools/Equipment

Reference	Description
STD-1100	Gauge - Push/Pull, Dial, 0-50 Lb Capacity

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Flight compartment door	52-51-01-01-020	SIA ALL

D. Location Zones

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

E. Flight Compartment Door Installation

SUBTASK 52-51-01-420-001

(1) Do these steps to install the flight compartment door [1]:

(a) Put the flight compartment door [1] in its position.

(b) Install the screws [6] and washers [5] that attach the hinge [3] to the Lavatory A wall.

SUBTASK 52-51-01-820-001

(2) Do these steps to adjust the flight compartment door [1]:

(a) Measure the clearance between the post assembly [9] and the flight compartment door [1].

(b) Make sure that the clearance is 0.2000 in. (5.0800 mm).

NOTE: The dimension is to be constant from top to the bottom of the door jam.

(c) If the clearance is not correct, adjust the post assembly [9] inboard or outboard:

1) Loosen the armor plate fasteners [12].

2) Do this task: Chime Module Removal, TASK 52-51-06-000-801.

NOTE: The chime module must be removed to allow post assembly movement.

a) Do not remove the chime module from the wire bundle.

3) Loosen the inboad/outboard adjustment fasteners [13].

4) Move the post assembly [9] as required.

a) If necessary, move the deadbolt strike plate on the post assembly [9] to allow for proper engagement of the locking bolt.

5) Tighten the inboard/outboard adjustment fasteners [13] to 30 ±5 in-lb (3 ±1 N·m).

6) Do this task: Chime Module Installation, TASK 52-51-06-400-801.

7) Tighten the armor plate fasteners [12].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

a) Tighten the armor plate fasteners [12] to 30 ±5 in-lb (3 ±1 N·m).

(d) Make sure that the ballistic door lip of the flight compartment door [1] is flush with the post assembly [9].

(e) If the ballistic door lip of the flight compartment door [1] is not flush with the post assembly [9], adjust the post assembly [9] forward or aft:

NOTE: Open clearance of 0.1250 in. (3.1750 mm) is permitted.

1) Do this task: Chime Module Removal, TASK 52-51-06-000-801.

NOTE: The chime module must be removed to allow post assembly movement.

a) Do not remove the chime module from the wire bundle.

2) Loosen the forward/aft adjustment fasteners [14].

3) Move the post assembly [9] as required.

4) Tighten the forward/aft adjustment fasteners [14] to 30 ±5 in-lb (3 ±1 N·m).

5) Do this task: Chime Module Installation, TASK 52-51-06-400-801.

(f) If necessary, adjust the header assembly [2] to keep a clearance of 0.1300 ±0.0250 in. (3.3020 ±0.6350 mm).

SUBTASK 52-51-01-710-001

(3) Open this circuit breaker and install safety tag:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

(4) Use the push/pull gauge (0-50 lbs), STD-1100, on the handle of the flight compartment door [1] to make sure that the flight compartment door [1] will open from the passenger cabin with a force of 30 lbf (133 N) or less:

(a) If the flight compartment door [1] will not open with a force of 30 lbf (133 N) or less, do these steps:

1) Do the steps to adjust the flight compartment door [1] again.

2) Use the push/pull gauge (0-50 lbs), STD-1100, on the handle of the flight compartment door [1] to make sure that the flight compartment door [1] will open from the passenger cabin with a force of 30 lbf (133 N) or less.

a) If the flight compartment door [1] still does not open with a force of 30 lbf (133 N) or less, replace or adjust the electric strike assembly (ELECTRIC STRIKE - REMOVAL/INSTALLATION, PAGEBLOCK 52-51-03/401).

(5) Remove the safety tag and close this circuit breaker:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FLIGHT COMPARTMENT DOOR - INSPECTION/CHECK

1. General

A. This procedure has this task:

(1) Flight Compartment Door Seal Inspection.

TASK 52-51-01-200-801

2. Flight Compartment Door Seal - Inspection

(Figure 601)

NOTE: This procedure is a scheduled maintenance task.

A. General

(1) This procedure is a visual inspection of the condition and security of the flight compartment door hinge seal.

B. Tools/Equipment

Reference	Description
STD-1315	Spatula - Plastic, Stiff

C. Consumable Materials

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

D. Location Zones

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

E. Flight Compartment Door Seal Inspection

SUBTASK 52-51-01-210-001

(1) Do these steps to do an inspection of the door hinge seal:

(a) Open the flight compartment door [1].

(b) Examine the hinge seal [2] on the door frame for these incorrect conditions:

1) Cracks
2) Notches
3) Unusual wear
4) Tears
5) Splits
6) Dents

SUBTASK 52-51-01-960-001

(2) Do these steps to replace the hinge seal [2] if you find an incorrect condition:

(a) Carefully use a stiff plastic spatula, STD-1315, to remove the damaged hinge seal [2].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) Clean the applicable edge surface of the flight compartment door [1] with a clean cotton wiper, G00034, that is moist with solvent, B00083.

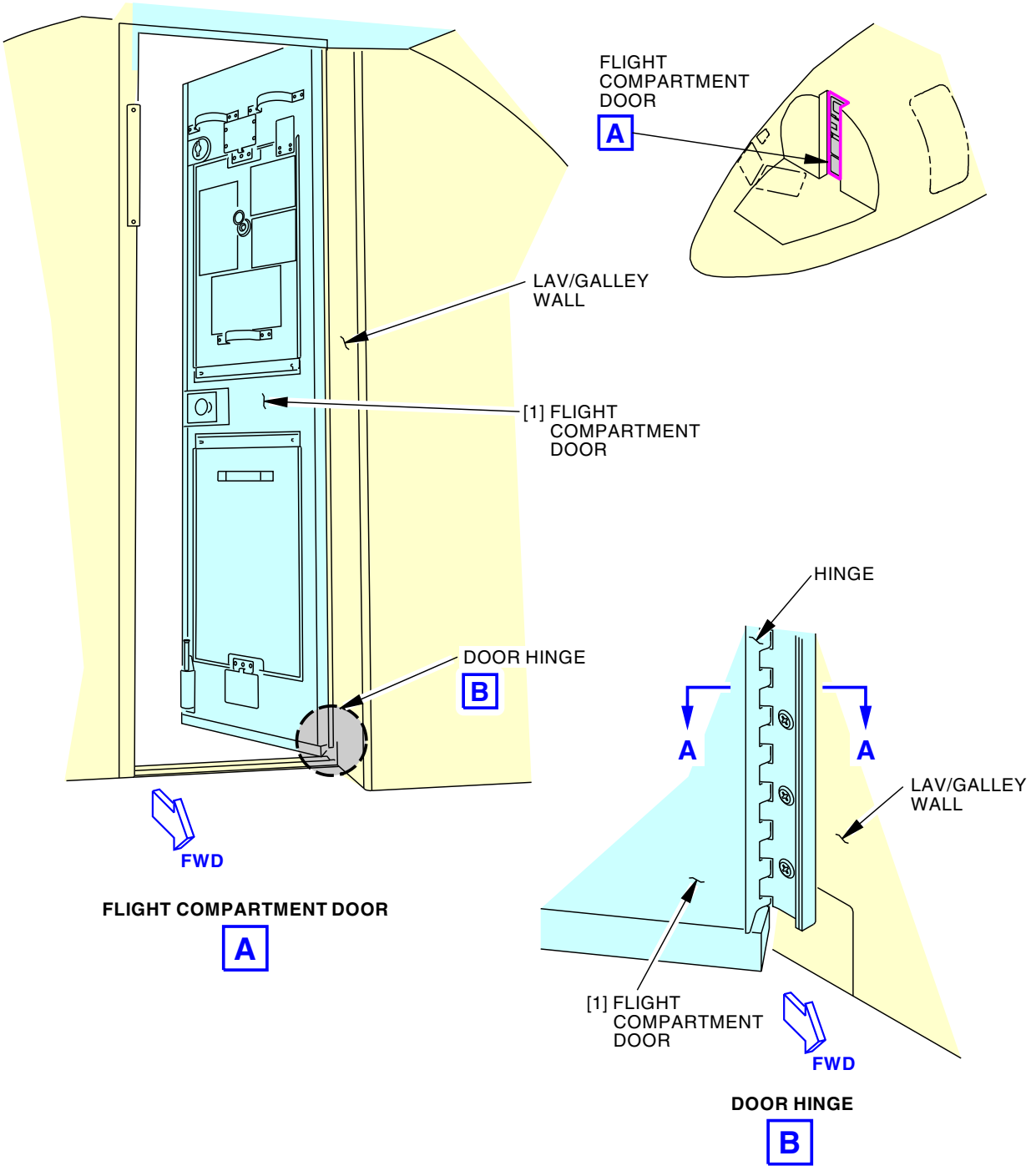
(c) Dry the surface with a clean and dry cotton wiper, G00034.

(d) Apply the new hinge seal [2] to the flight compartment door [1].

NOTE: The seal is self-adhesive.

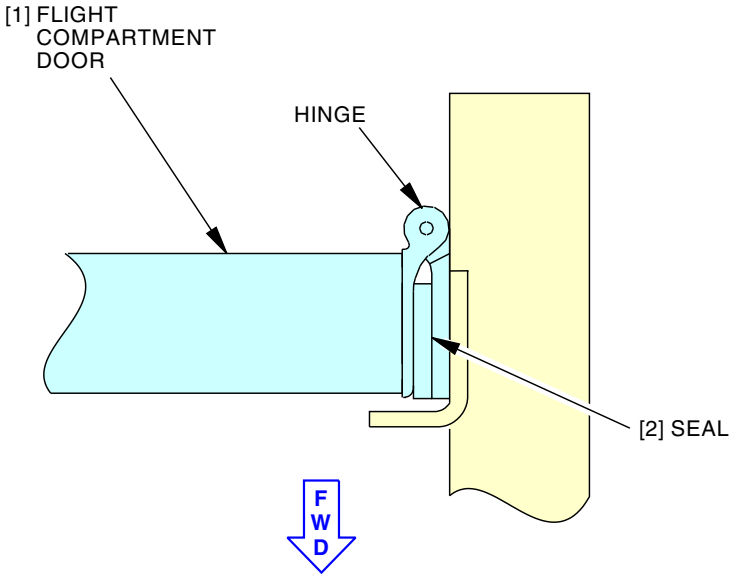
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Flight Compartment Door Seal Inspection
Figure 601/52-51-01-990-802 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



**CREW DOOR HINGE AND SEAL
(DOOR IN THE CLOSED POSITION)**

A-A

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**Flight Compartment Door Seal Inspection
Figure 601/52-51-01-990-802 (Sheet 2 of 2)**

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FLIGHT COMPARTMENT DOOR LATCH - REMOVAL/INSTALLATION

1. General

A. This Procedure has these tasks:

(1) A removal of the flight compartment door latch.

(2) An installation of the flight compartment door latch.

TASK 52-51-02-000-801

2. Flight Compartment Door Latch Removal

(Figure 401)

A. Location Zones

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

B. Flight Compartment Door Latch Removal

SUBTASK 52-51-02-020-001

(1) Do these steps to remove the door latch assembly [5]:

(a) Remove the screws [2] that attach the cover [3] to the cover [7].

(b) Remove the cover [3].

(c) Remove the plate [4].

(d) Remove the cover [7].

(e) Remove the plate [6].

(f) Remove the screws [1] that attach the door latch assembly [5] to the flight compartment door.

(g) Remove the door latch assembly [5] from the flight compartment door.

END OF TASK

TASK 52-51-02-400-801

3. Flight Compartment Door Latch Installation

(Figure 401)

A. References

Reference	Title
52-51-01-400-801	Flight Compartment Door Installation (P/B 401)
52-51-03-400-801	Electric Strike Installation (P/B 401)

B. Tools/Equipment

Reference	Description
STD-1100	Gauge - Push/Pull, Dial, 0-50 Lb Capacity

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
5	Door latch assembly	52-51-01-01B-050	SIA ALL

ECCN 9E991 BOEING PROPRIETARY - See title page for details

D. Location Zones

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

E. Flight Compartment Door Latch Installation

SUBTASK 52-51-02-420-001

(1) Do these steps to install the door latch assembly [5]:

(a) Put the door latch assembly [5] in its position in the flight compartment door.

(b) Install the screws [1].

(c) Put the plate [6] and plate [4] in their positions.

(d) Install the cover [7] and the cover [3].

(e) Install the screws [2] that attach the cover [3] to the cover [7].

F. Do a Post Installation Test of the Flight Compartment Door Latch

SUBTASK 52-51-02-710-001

(1) Do these steps to do a test of the door latch:

(a) Make sure that the deadbolt is not engaged.

(b) Turn the door knob clockwise and make sure the latch tongue retracts.

(c) Close the door.

(d) Make sure that the latch tongue engages the strike plate and you can not open the door.

(e) Turn the door knob clockwise and make sure that you can open the door.

SUBTASK 52-51-02-860-001

(2) Open this circuit breaker and install safety tag:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

SUBTASK 52-51-02-710-002

(3) Use the push/pull gauge (0-50 lbs), STD-1100, on the handle of the flight compartment door to make sure that the flight compartment door will open from the passenger cabin with a force of 30 lbf (133 N) or less.

(a) If the flight compartment door will not open with a force of 30 lbf (133 N) or less, do these steps:

1) Adjust the gap between the flight compartment door and door post (TASK 52-51-01-400-801).

2) Adjust the gap between the flight compartment door and electric strike assembly (TASK 52-51-03-400-801).

SUBTASK 52-51-02-860-002

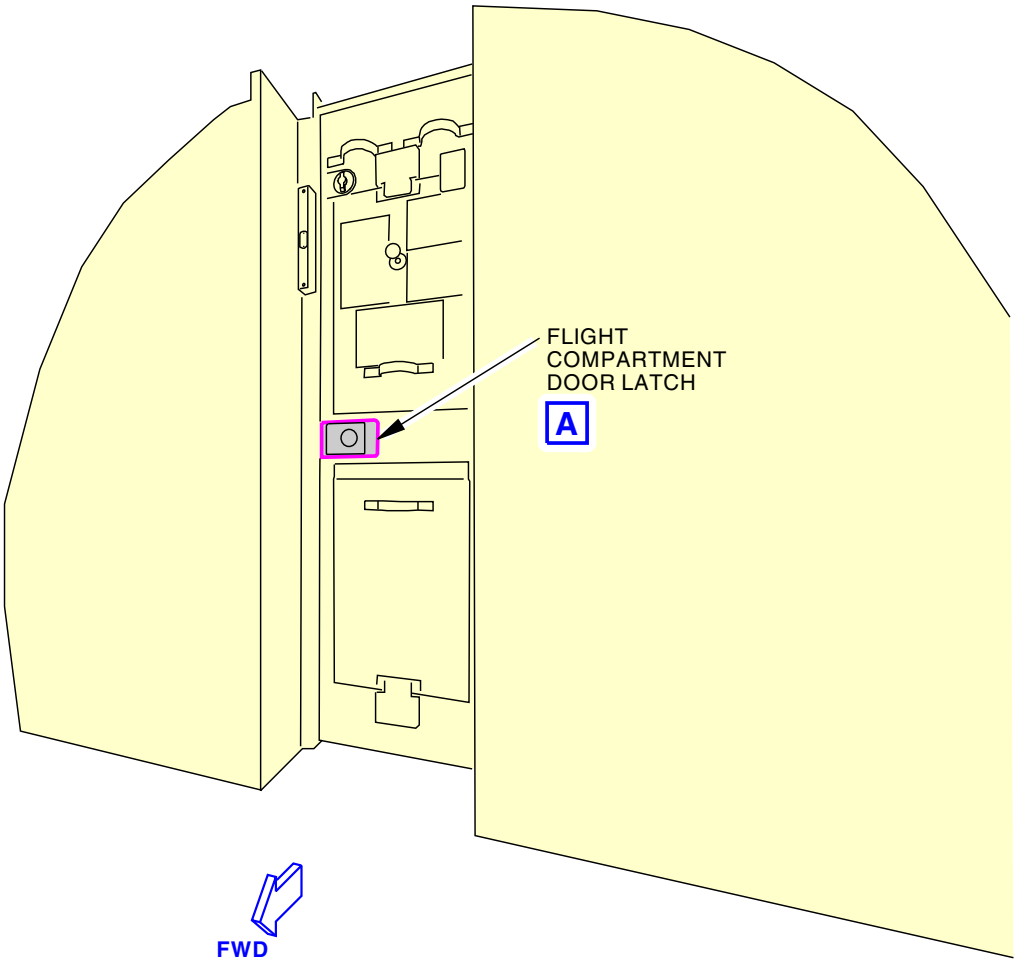
(4) Remove the safety tag and close this circuit breaker:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

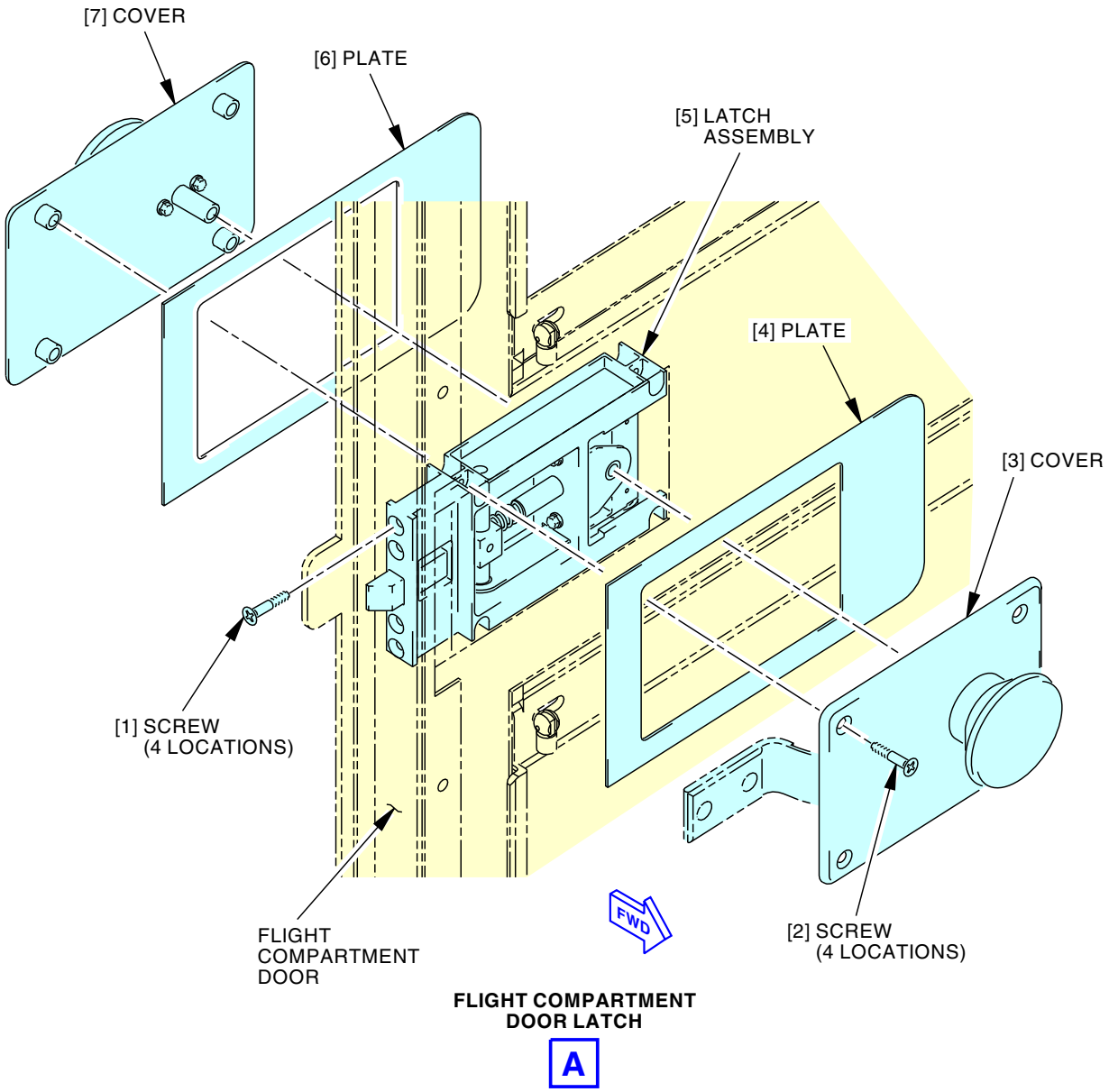


FLIGHT COMPARTMENT DOOR

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Flight Compartment Door Latch Installation
Figure 401/52-51-02-990-801 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Flight Compartment Door Latch Installation
Figure 401/52-51-02-990-801 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

ELECTRIC STRIKE - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Electric Strike Removal

(2) Electric Strike Installation.

TASK 52-51-03-000-801

2. Electric Strike Removal

(Figure 401)

A. Location Zones

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

B. Prepare for the Removal

SUBTASK 52-51-03-860-001

(1) Open this circuit breaker and install safety tag:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

SUBTASK 52-51-03-010-001

(2) Open the flight compartment door.

C. Electric Strike Removal

SUBTASK 52-51-03-020-001

(1) Remove the screws [2] that attach the electric strike assembly [1] to the door post.

SUBTASK 52-51-03-020-002

(2) Carefully pull the electric strike assembly [1] out of the door post.

SUBTASK 52-51-03-020-003

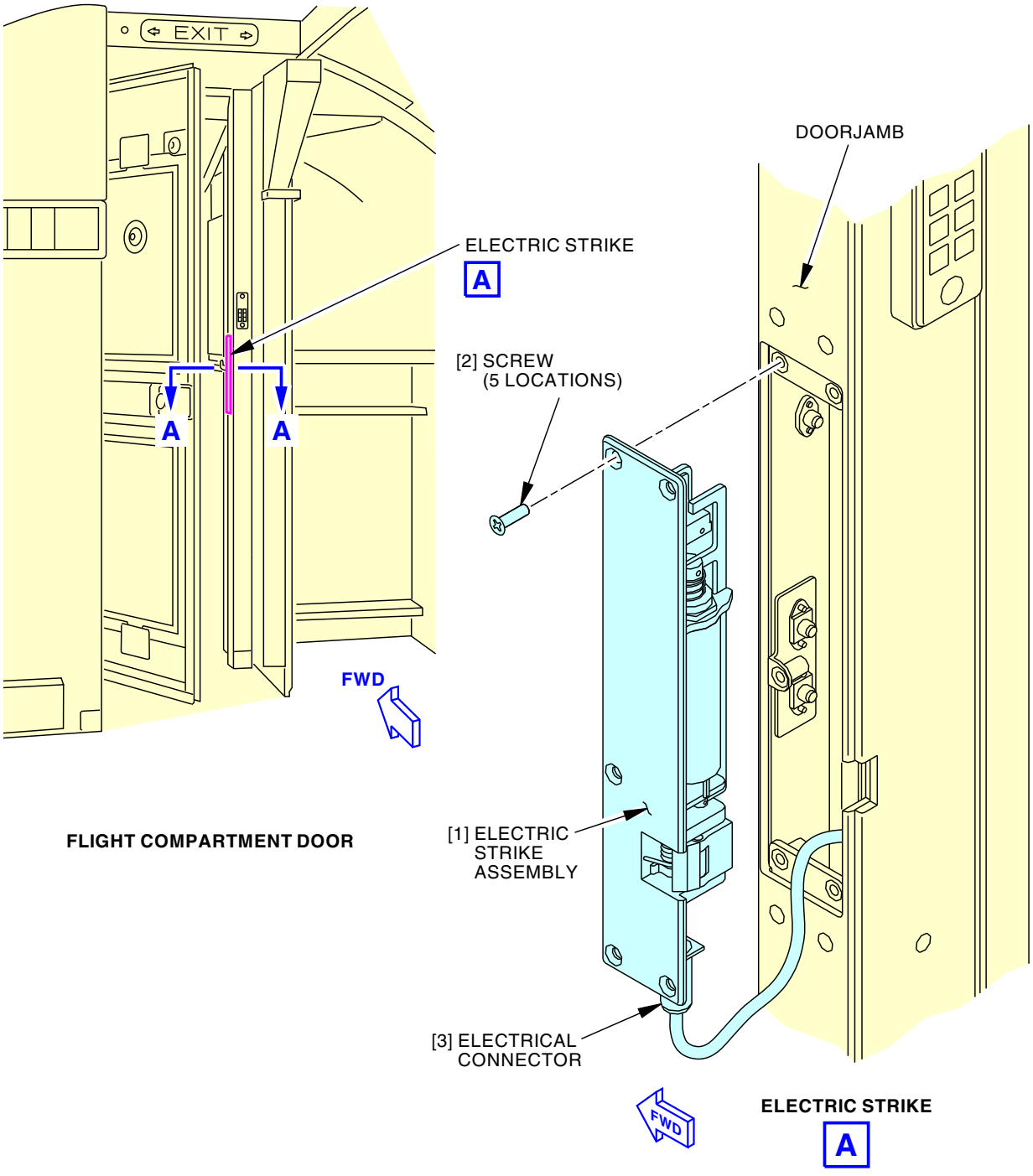
(3) Disconnect the electrical connector [3] from the electric strike assembly [1].

SUBTASK 52-51-03-020-004

(4) Remove the electric strike assembly [1].

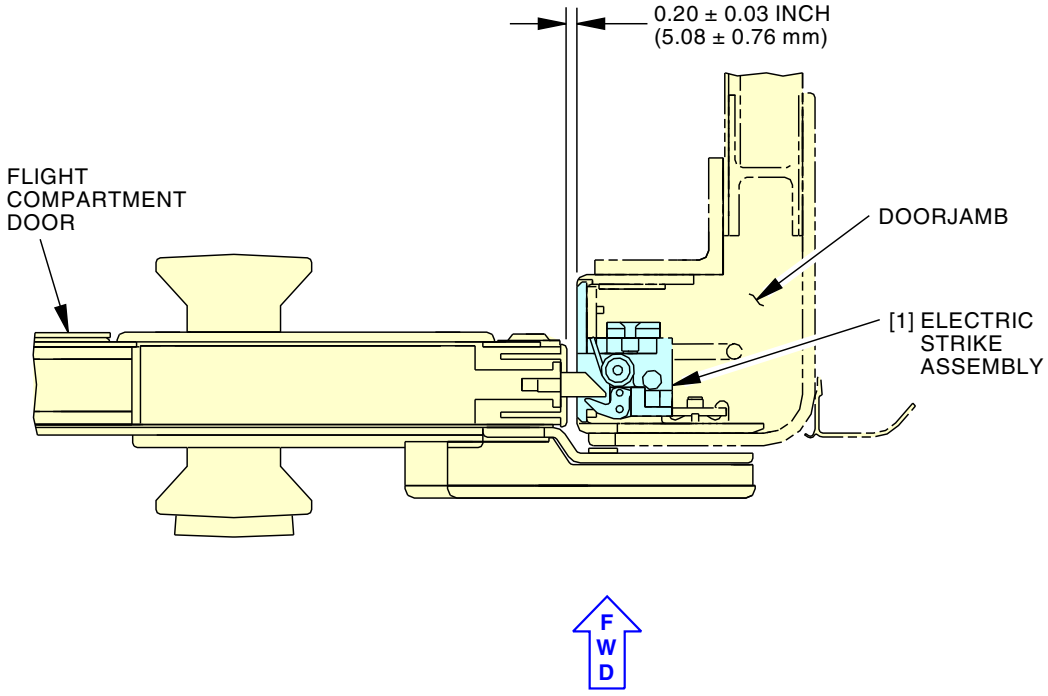
END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Electric Strike Installation
Figure 401/52-51-03-990-802 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



FLIGHT COMPARTMENT DOOR/ELECTRICAL STRIKE ASSEMBLY ADJUSTMENT (DOOR IN CLOSED POSITION)

A-A

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Electric Strike Installation
Figure 401/52-51-03-990-802 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-51-03-400-801

3. Electric Strike Installation

(Figure 401)

A. References

Reference	Title
52-51-01-400-801	Flight Compartment Door Installation (P/B 401)

B. Tools/Equipment

Reference	Description
STD-1100	Gauge - Push/Pull, Dial, 0-50 Lb Capacity

C. Consumable Materials

Reference	Description	Specification
D50390	Lubricant - Spray Powder, Dry Film, Moly Lube	

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Electric strike assembly	52-51-01-02-025	SIA 001-005
		52-51-01-02-255	SIA 006-999

E. Location Zones

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

F. Electric Strike Installation

SUBTASK 52-51-03-420-001

(1) Connect the electrical connector [3] to the electric strike assembly [1].

SUBTASK 52-51-03-420-002

(2) Carefully insert the electric strike assembly [1] into the door post opening and put it in its position.

SUBTASK 52-51-03-420-003

(3) Install the screws [2] that attach the electric strike assembly [1] to the door post.

SUBTASK 52-51-03-820-001

(4) Make sure that the gap between the electric strike assembly [1] and flight compartment door is within 0.20 ±0.03 in. (5.08 ±0.76 mm) (View A-A, Figure 401).

(a) If the gap is not within the limit, do these steps:

1) Loosen the screws [2] that attach the electric strike assembly [1] to the doorjamb.

2) Adjust the position of the electric strike assembly [1] to match the clearance.

3) Tighten the screws [2].

SUBTASK 52-51-03-640-001

(5) If it is necessary, spray a light layer of dry film spray, D50390, on the moving parts of the latch assembly.

G. Do a Post Installation Test of the Electric Strike

SUBTASK 52-51-03-710-001

(1) Make sure that the electric strike assembly [1] solenoid is in the de-energized position.

NOTE: The solenoid is de-energized when the pin is retracted such that the strike can rotate.

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SUBTASK 52-51-03-710-002

(2) Close the door.

SUBTASK 52-51-03-710-003

(3) Use the push/pull gauge (0-50 lbs), STD-1100, on the handle of the flight compartment door to make sure that the flight compartment door will open from the passenger cabin with a force of 30 lbf (133 N) or less.

(a) If the flight compartment door will not open with a force of 30 lbf (133 N) or less, adjust the gap between the flight compartment door and the door post. Refer to Flight Compartment Door Installation, TASK 52-51-01-400-801.

SUBTASK 52-51-03-710-004

(4) Remove the safety tag and close this circuit breaker:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

SUBTASK 52-51-03-710-005

(5) Make sure the FLT DK DOOR three position switch on the P8-47 Control Panel Switch/Light module is in the AUTO position.

SUBTASK 52-51-03-710-006

(6) Make sure that the electric strike solenoid energizes.

NOTE: The pin will extend preventing the strike from rotating.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FLIGHT COMPARTMENT DOOR DEADBOLT - REMOVAL/INSTALLATION

1. General

A. This Procedure has these tasks:

(1) A removal of the flight compartment door deadbolt.

(2) An installation of the flight compartment door deadbolt.

(3) An installation test of the flight compartment door deadbolt.

TASK 52-51-04-000-801

2. Flight Compartment Door Deadbolt Removal

(Figure 401)

A. Location Zones

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

B. Flight Compartment Door Deadbolt Removal

SUBTASK 52-51-04-020-001

(1) Do these steps to remove the deadbolt lock assembly:

(a) Extend the bolt assembly [4].

(b) Remove the screws [3] that hold the cover assembly [2] to the housing assembly [1].

(c) Retract the bolt assembly [4].

(d) Remove the cover assembly [2].

(e) Remove the two retaining screws [5].

(f) Remove the bolt assembly [4] from the housing assembly [1].

(g) Remove the housing assembly [1] from the door.

——— END OF TASK ———

TASK 52-51-04-400-801

3. Flight Compartment Door Deadbolt Installation

(Figure 401)

A. Consumable Materials

Reference	Description	Specification
A50011	Sealant - Silicone, Aluminum Color - RTV109	

B. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Housing assembly	52-51-01-01A-050	SIA ALL
		52-51-01-01A-095	SIA ALL

C. Location Zones

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

D. Flight Compartment Door Deadbolt Installation

SUBTASK 52-51-04-420-001

(1) Do these steps to install the deadbolt lock assembly:

(a) Install the housing assembly [1] to the cabin side of the door.

(b) Put the bolt assembly [4] into the housing assembly [1].

1) Make sure that the bolt assembly [4] is in full contact with the housing assembly [1].

2) Make sure that the bolt assembly [4] engages the lock cylinder in the housing assembly [1].

(c) Install the retaining screws [5].

1) Make sure that the retaining screws [5] extend 0.125 in. (3.175 mm) above the housing assembly [1] surface.

(d) Move the bolt assembly [4] to the full retract position.

(e) Install the cover assembly [2] to the housing assembly [1].

(f) Turn the handle on the cover assembly [2] to extend the bolt assembly [4].

(g) Install the screws [3] in the cover assembly [2].

E. Flight Compartment Door Deadbolt Installation Test

SUBTASK 52-51-04-710-001

(1) Do these steps to do an installation test of the deadbolt:

NOTE: When the deadbolt is fully retracted red dots can be seen on the cover plate. When the deadbolt is fully extended green dots can be seen on the cover plate.

(a) Extend the deadbolt and make sure that it engages in the lock position.

(b) Retract the deadbolt and make sure that it engages in the unlock position.

(c) Make sure that the handle on the cover assembly is secure.

(d) Close the flight compartment door.

(e) Turn the handle and make sure that the deadbolt fully locks in the latch receptical.

1) Make sure that you can fully see the GREEN DOTS on the cover assembly.

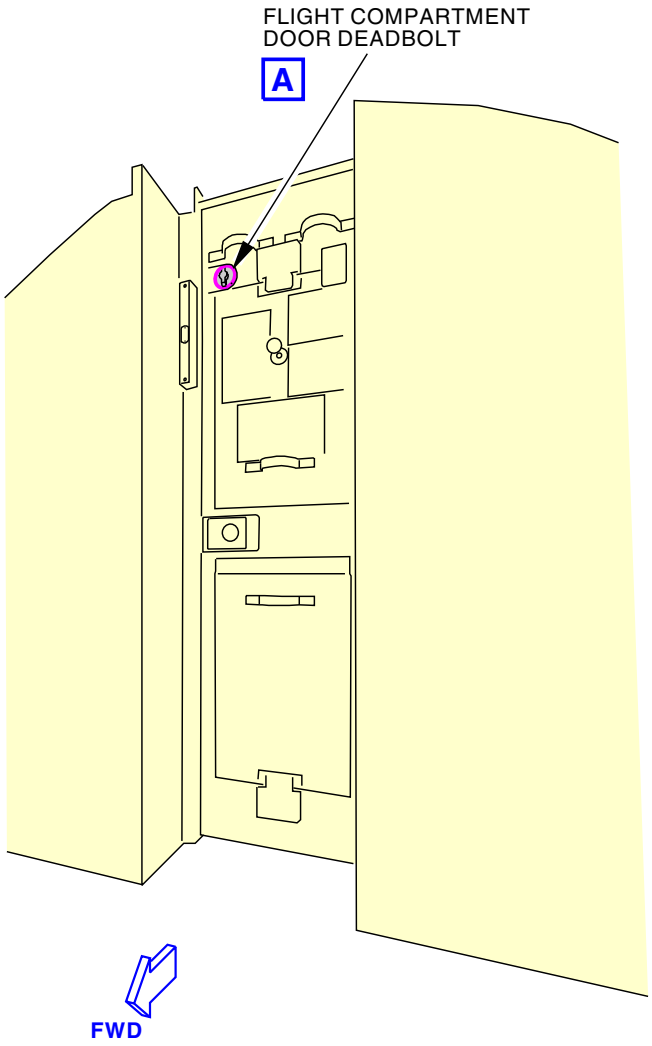
(f) Make sure that the deadbolt extends and retracts with the keylock.

(g) If necessary turn the center adjustment screw on the cover assembly to adjust the keylock.

(h) Put RTV109 sealant, A50011 or equivalent on the center screw head and make flush with the handle.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

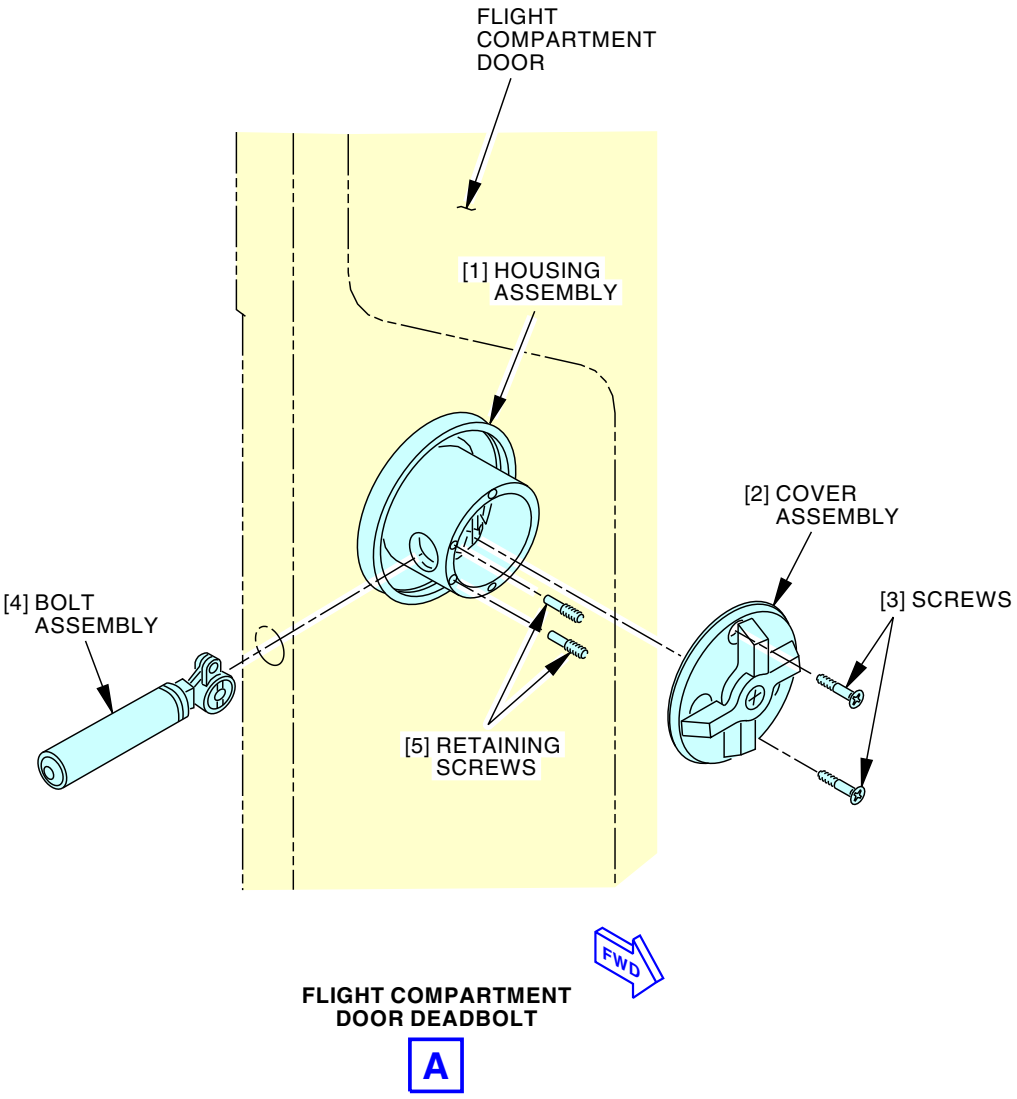


FLIGHT COMPARTMENT DOOR

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Flight Compartment Door Deadbolt - Installation
Figure 401/52-51-04-990-801 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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Flight Compartment Door Deadbolt - Installation
Figure 401/52-51-04-990-801 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

KEYPAD - REMOVAL/INSTALLATION

1. General

A. This Procedure has these tasks:

(1) A removal of the keypad.

(2) An installation of the keypad.

TASK 52-51-05-000-801

2. Keypad Removal

(Figure 401)

A. Location Zones

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

B. Prepare for the Removal

SUBTASK 52-51-05-860-001

(1) Open this circuit breaker and install safety tag:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

C. Keypad Removal

SUBTASK 52-51-05-020-001

(1) Remove the screw covers [3] on the top and the bottom of the keypad [1].

SUBTASK 52-51-05-020-002

(2) Remove the screws [2] that attach the keypad [1] to the door post.

SUBTASK 52-51-05-020-003

(3) Disconnect the electrical connector.

SUBTASK 52-51-05-020-004

(4) Remove the keypad [1].

——— END OF TASK ———

TASK 52-51-05-400-801

3. Keypad Installation

(Figure 401)

A. References

Reference	Title
52-51-00-700-801	Flight Compartment Security Door Access System Test (P/B 501)

B. Location Zones

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Keypad Installation

SUBTASK 52-51-05-420-001

(1) Put the keypad [1] in its position.

SUBTASK 52-51-05-420-002

(2) Install the electrical connector.

SUBTASK 52-51-05-420-003

(3) Install the screws [2].

SUBTASK 52-51-05-420-004

(4) Install the screw covers [3].

SUBTASK 52-51-05-860-002

(5) Remove the safety tag and close this circuit breaker:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

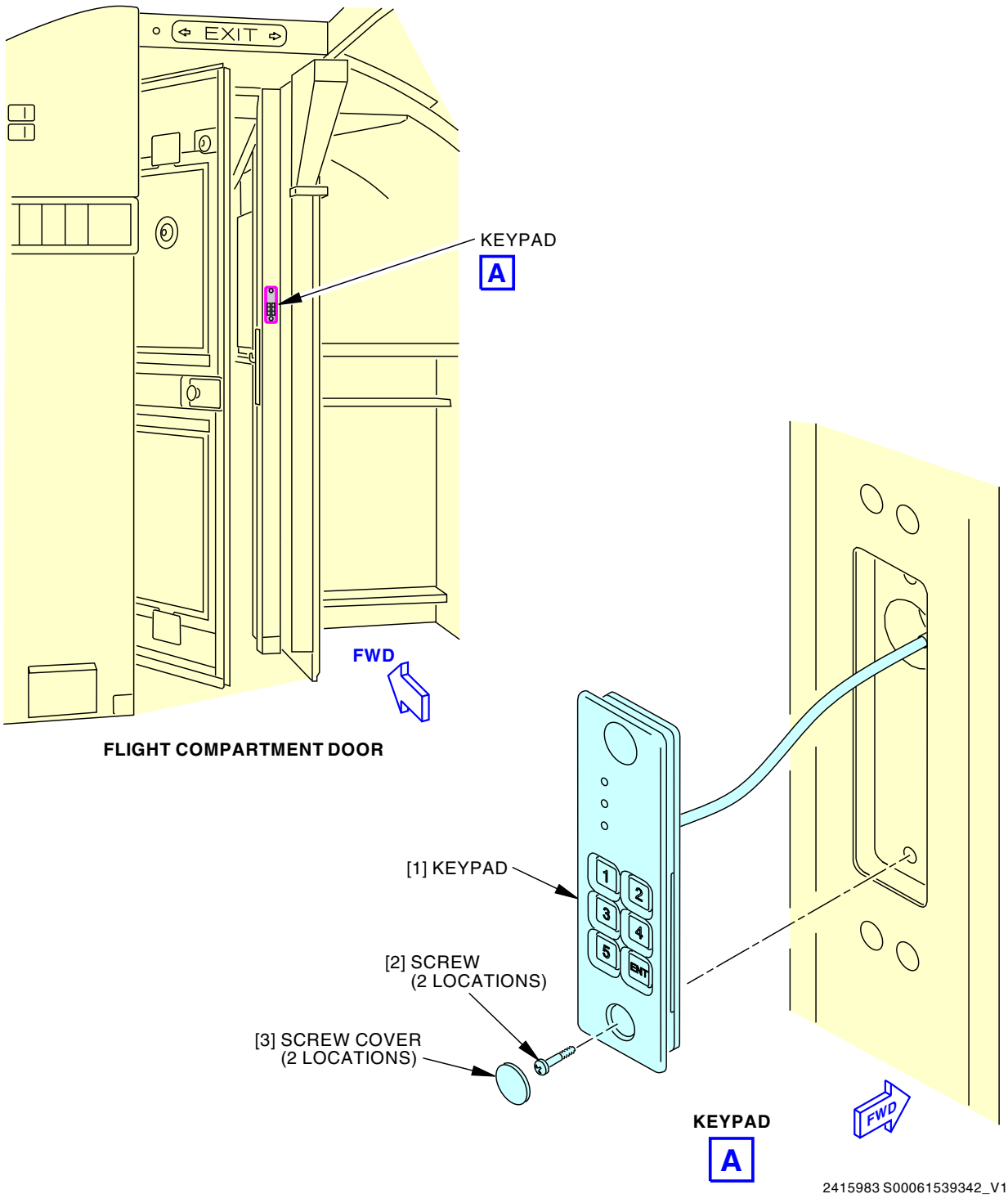
D. Do a Post Installation Test of the Keypad

SUBTASK 52-51-05-730-001

(1) Do the system test of the flight compartment security door access system. To do a test of the flight compartment security door access system, do this task: Flight Compartment Security Door Access System Test, TASK 52-51-00-700-801

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Keypad Installation
Figure 401/52-51-05-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CHIME MODULE - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the chime module

(2) An installation of the chime module.

TASK 52-51-06-000-801

2. Chime Module Removal

(Figure 401)

A. Location Zones

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

B. Prepare for the Removal

SUBTASK 52-51-06-860-001

(1) Open this circuit breaker and install safety tag:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

C. Chime Module Removal

SUBTASK 52-51-06-020-001

(1) Remove the screws [2] that attach the chime module [1] to the door post.

SUBTASK 52-51-06-020-002

(2) Disconnect the electrical connectors.

SUBTASK 52-51-06-020-003

(3) Remove the chime module [1].

END OF TASK

TASK 52-51-06-400-801

3. Chime Module Installation

(Figure 401)

A. References

Reference	Title
52-51-00-700-801	Flight Compartment Security Door Access System Test (P/B 501)
52-51-00-900-801	Program the Access Code (P/B 201)
52-51-00-900-802	Program Time Delays and Door Bell Enable (P/B 201)

B. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Chime module	52-51-01-02-175	SIA 001-005
		52-51-01-02-390	SIA 006-999

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Location Zones

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

D. Chime Module Installation

SUBTASK 52-51-06-420-001

(1) Put the chime module [1] in it's position.

SUBTASK 52-51-06-420-002

(2) Install the electrical connectors.

SUBTASK 52-51-06-420-003

(3) Install the screws [2].

SUBTASK 52-51-06-860-002

(4) Remove the safety tag and close this circuit breaker:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

SUBTASK 52-51-06-860-004

(5) Program the chime module access code, do this task: Program the Access Code, TASK 52-51-00-900-801.

SUBTASK 52-51-06-860-003

(6) Program the chime module time delays and chime, do this task: Program Time Delays and Door Bell Enable, TASK 52-51-00-900-802.

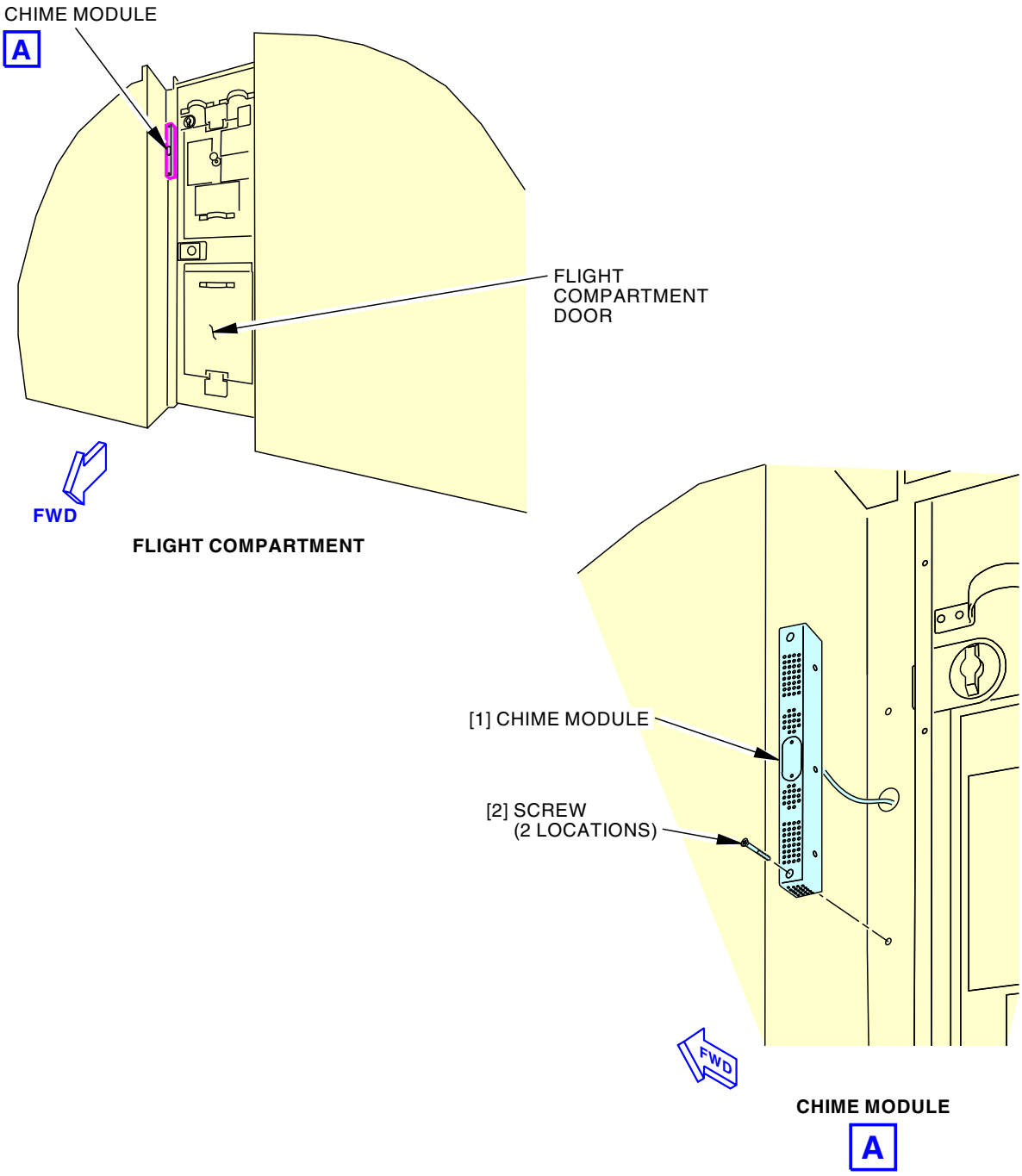
E. Post Installation Test of the Chime Module

SUBTASK 52-51-06-730-001

(1) To do the system test of the flight compartment security door access system, do this task: Flight Compartment Security Door Access System Test, TASK 52-51-00-700-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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Chime Module Installation
Figure 401/52-51-06-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CHIME MODULE - CLEANING

1. General

A. This Procedure has a task to clean the chime module.

TASK 52-51-06-000-802

2. Chime Module Cleaning

A. Consumable Materials

Reference	Description	Specification
B00068	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002, MIL-E-51454 Type II
B00130	Alcohol - Isopropyl	TT-I-735

B. Location Zones

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

C. Chime Module Cleaning

SUBTASK 52-51-06-160-001

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 OR CAUSE DAMAGE TO THE ENVIRONMENT. REFER TO THE MATERIAL SAFETY DATA SHEETS (MSDS) AND THE LOCAL SAFETY PRECAUTIONS.

CAUTION MAKE SURE YOU DO NOT SPRAY THE CHIME MODULE DIRECTLY WITH THE CLEANING SOLUTION. IF YOU SPRAY THE CHIME MODULE DIRECTLY WITH THE CLEANING SOLUTION, DAMAGE TO THE CHIME MODULE CAN OCCUR.

(1) Do these steps to clean the chime module:

(a) Moisten the cloth with the solvent, alcohol, B00068 or alcohol, B00130

(b) Use the cloth to clean the exterior surface of the chime module.

(c) Dry the chime module with a clean cloth.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

COCKPIT CONTROL PANEL SWITCH/LIGHT (P8-47) - REMOVAL/INSTALLATION

1. General

A. This Procedure has these tasks:

(1) A removal of the cockpit control panel switch/light.

(2) An installation of the cockpit control panel switch/light.

(3) The cockpit control panel switch/light will be called control panel in this procedure.

TASK 52-51-07-020-801

2. Cockpit Control Panel Switch/Light (P8-47) Removal

(Figure 401)

A. Location Zones

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

B. Cockpit Control Panel Switch/Light (P8-47) Removal

SUBTASK 52-51-07-020-001

(1) Do these steps to remove the cockpit control panel switch/light module (P8-47) [1] from the aft electronic panel:

(a) Open these circuit breakers and install safety tags:

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
B	10	C00207	FLIGHT CONTROL STAB TRIM CONT

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

(b) Turn the quarter-turn fasteners [2] which hold the cockpit control panel switch/light module (P8-47) [1] to the aft electronic panel.

NOTE: The typical location of the cockpit control panel switch/light module (P8-47) [1] is in the right aft corner of the P8 panel.

(c) Carefully remove the cockpit control panel switch/light module (P8-47) [1] out of the aft electronic panel.

(d) Disconnect the electrical conectors [3].

(e) Remove the cockpit control panel switch/light module (P8-47) [1].

END OF TASK

TASK 52-51-07-420-801

3. Cockpit Control Panel Switch/Light (P8-47) Installation

(Figure 401)

A. References

Reference	Title
24-22-00-860-802	Remove Electrical Power (P/B 201)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Reference	Title
27-41-00-700-807	Column Actuated Stabilizer Trim Cutout Switch Override Test (P/B 501)
52-51-00-700-801	Flight Compartment Security Door Access System Test (P/B 501)

B. Location Zones

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

C. Cockpit Control Panel Switch/Light (P8-47) Installation

SUBTASK 52-51-07-420-001

(1) Do these steps to install the cockpit control panel switch/light module (P8-47) [1] into the aft electronic panel:

(a) Reconnect the electrical conectors [3].

(b) Carefully put the cockpit control panel switch/light module (P8-47) [1] into the aft electronic panel.

(c) Turn the quarter-turn fasteners [2].

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

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
B	10	C00207	FLIGHT CONTROL STAB TRIM CONT

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
E	1	C00137	DOOR LOCK

SUBTASK 52-51-07-710-001

(2) Do this task: Flight Compartment Security Door Access System Test, TASK 52-51-00-700-801.

(3) Do this task: Column Actuated Stabilizer Trim Cutout Switch Override Test, TASK 27-41-00-700-807.

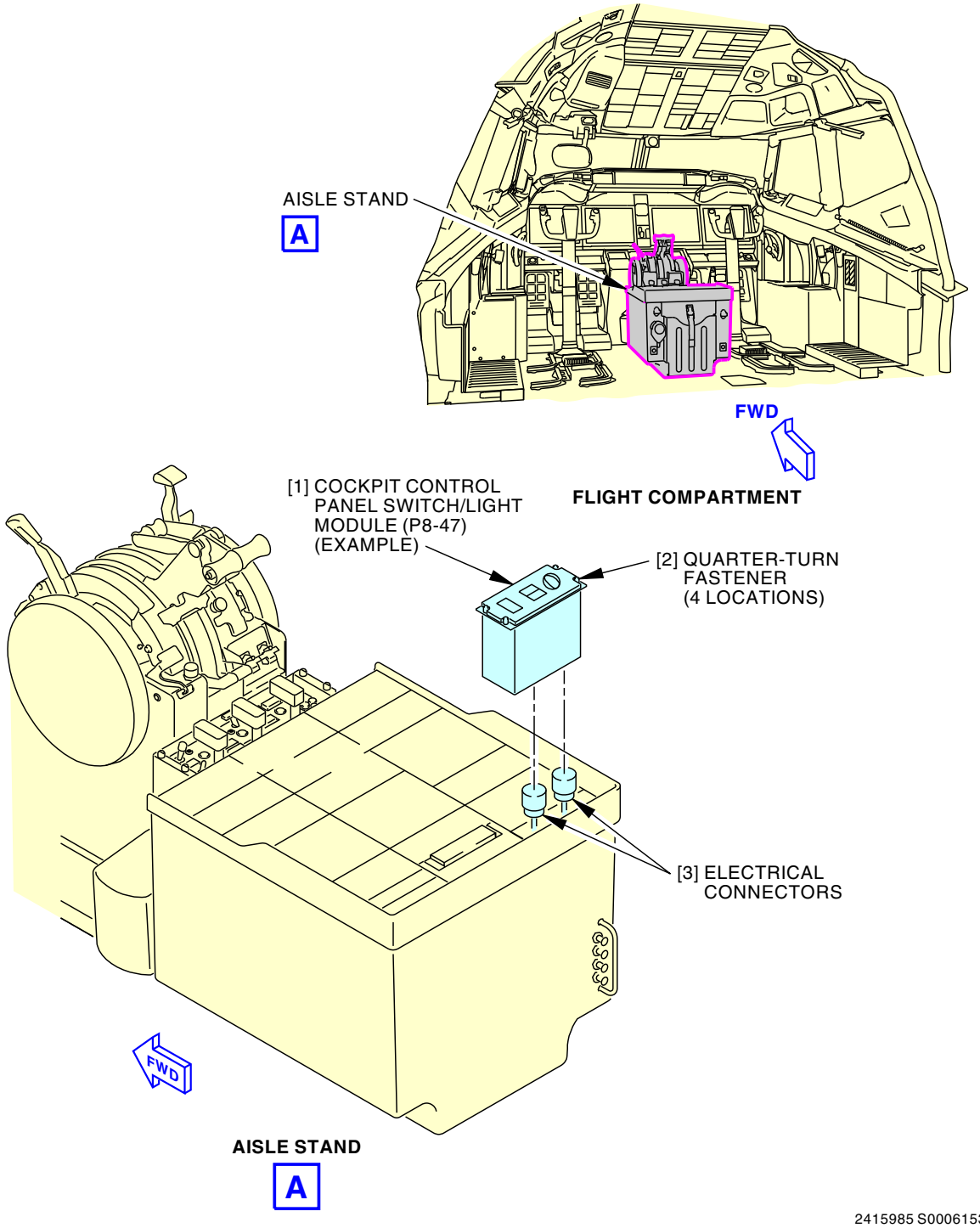
D. Put the Airplane Back to Its Usual Condition.

SUBTASK 52-51-07-860-001

(1) Remove the electrical power if it is not necessary, do this task: TASK 24-22-00-860-802.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Control Panel Switch/Light Installation
Figure 401/52-51-07-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

DECOMPRESSION PANEL AND PRESSURE RELEASE LATCH - REMOVAL/INSTALLAION

1. General

A. This Procedure has these tasks:

(1) A removal of the decompression panels and pressure release latches.

(2) An installation of the decompression panels and pressure release latches.

(3) There are two decompression panels and pressure release latches in the door. The removal and installation steps are almost the same for both panels and latches.

TASK 52-51-08-000-801

2. Decompression Panel and Pressure Release Latch Removal

(Figure 401)

A. Location Zones

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

B. Decompression Panel and Pressure Release Latch Removal

SUBTASK 52-51-08-020-001

(1) Do these steps to remove the pressure release latch [2]:

(a) Remove the screws [8] and washers [7] that attach the decompression latch cover [9] to the lower decompression panel [1].

(b) Remove the decompression latch cover [9].

(c) Remove the screws [5] and washers [4] that attach the decompression latch strap [6] to the pressure release latch [2].

(d) Remove the decompression latch strap [6].

(e) Remove the screws [3] that attach the pressure release latch [2] to the flight compartment door.

(f) Remove the pressure release latch [2].

SUBTASK 52-51-08-020-002

(2) Do these steps to remove the decompression panel [1]:

(a) Disconnect the strap that attaches the lower or upper decompression panel [1] to the flight compartment door by pulling down or up on the strap at the door connection.

(b) Push in on the two retractable bolts at the top or bottom of the decompression panel [1].

(c) Remove the decompression panel [1].

END OF TASK

TASK 52-51-08-400-801

3. Decompression Panel and Pressure Release Latch Installation

(Figure 401)

A. References

Reference	Title
52-51-00-710-803	Pressure Release Latch Functional Test (P/B 501)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Decompression panel	52-51-01-01-312	SIA ALL
		52-51-01-01-314	SIA ALL
		52-51-01-01C-110	SIA ALL
		52-51-01-01D-120	SIA ALL

C. Location Zones

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

D. Decompression Panel and Pressure Release Latch Installation

SUBTASK 52-51-08-420-001

(1) Do these steps to install the decompression panel [1]:

(a) Push in on the two retractable bolts on the decompression panel [1].

(b) Put the decompression panel [1] in its position.

(c) Release the retractable bolts.

(d) Connect the strap on the flight compartment door for the lower or upper decompression panel [1].

(e) Make sure that the decompression panel [1] can swing freely.

SUBTASK 52-51-08-420-002

(2) Do these steps to install the pressure release latch [2]:

(a) Put the pressure release latch [2] in its position with the decompression panel [1] in the closed position.

(b) Install the screws [3] that attach the pressure release latch [2] to the flight compartment door.

(c) Put the decompression latch strap [6] in its position on the pressure release latch [2].

(d) Install the screws [5] and washers [4].

(e) Put the decompression latch cover [9] in its position on the lower decompression panel [1].

(f) Install the screws [8] and washers [7].

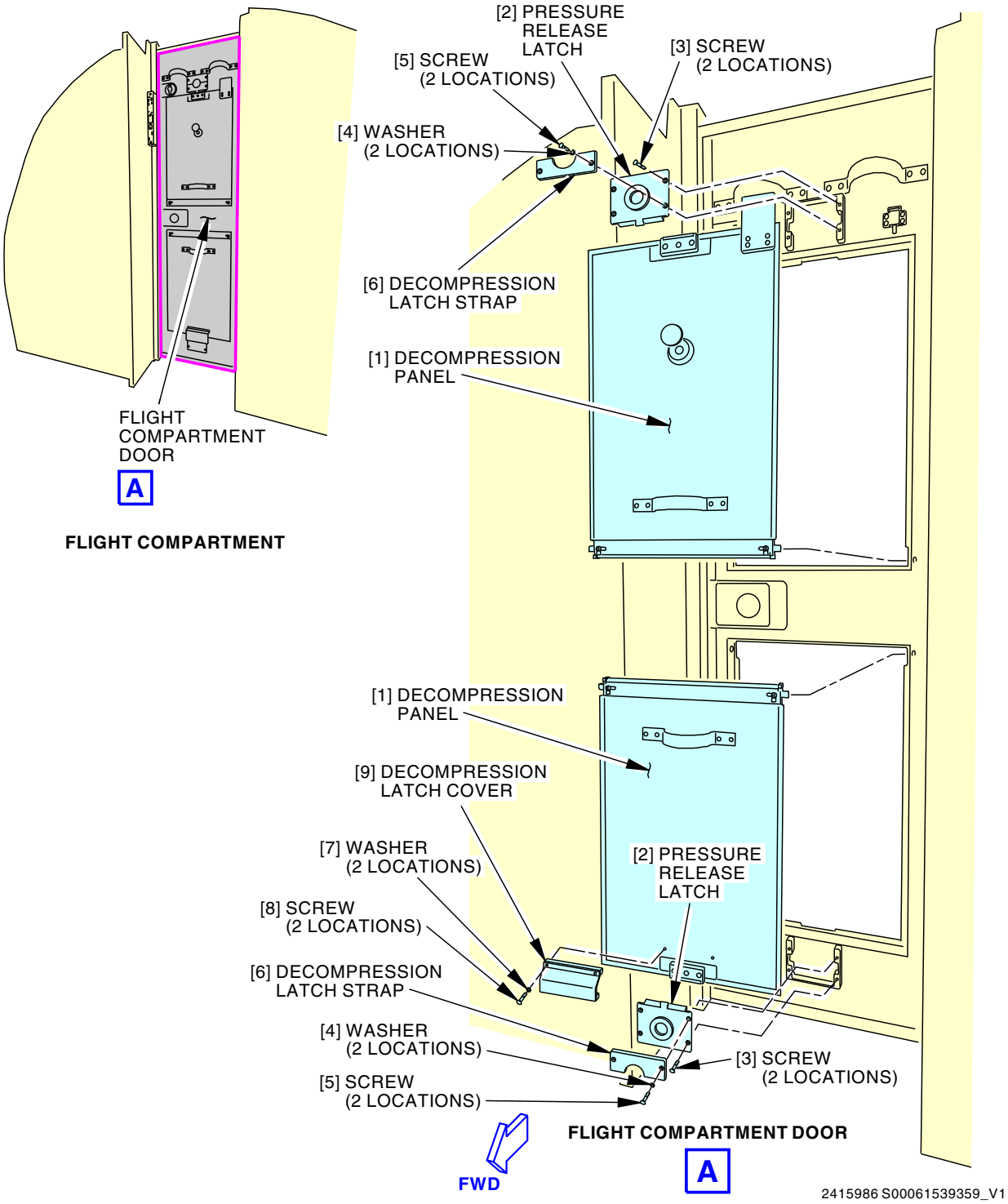
SUBTASK 52-51-08-720-001

(3) Do a functional check of the latch.

(a) Do this task: Pressure Release Latch Functional Test, TASK 52-51-00-710-803.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Decompression Panel and Pressure Release Latch Installation
Figure 401/52-51-08-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

DOOR WARNING SYSTEM - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks:

(1) Door warning annunciator panel removal

(2) Door warning annunciator panel installation.

TASK 52-71-00-000-801

2. Door Warning Annunciator Panel Removal

(Figure 201)

A. General

(1) This task gives the instructions to remove the door warning annunciator panel.

B. References

Reference	Title
24-22-00-860-802	Remove Electrical Power (P/B 201)

C. Location Zones

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

D. Door Warning Annunciator Panel Removal

SUBTASK 52-71-00-862-001

(1) Do this task: Remove Electrical Power, TASK 24-22-00-860-802.

SUBTASK 52-71-00-865-001

(2) Open these circuit breakers and install safety tags:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
B	13	C00131	MASTER CAUTION ANNUNCIATOR BAT
C	12	C01276	MASTER CAUTION ANNUNCIATOR CONT 2
F	14	C01180	INDICATOR MASTER DIM SECT 8

SUBTASK 52-71-00-030-001

(3) Loosen the quarter-turn fasteners [2] that hold the door warning annunciator panel [1] to the forward overhead panel, P5.

SUBTASK 52-71-00-020-001

(4) Pull out the door warning annunciator panel [1].

SUBTASK 52-71-00-030-002

(5) Disconnect the electrical connectors [3] from the door warning annunciator panel [1].

SUBTASK 52-71-00-020-002

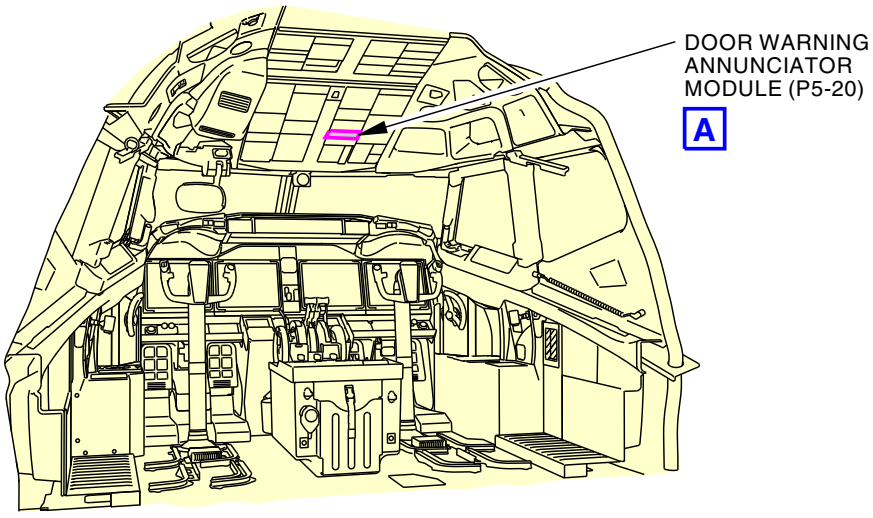
(6) Remove the door warning annunciator panel [1].

SUBTASK 52-71-00-420-002

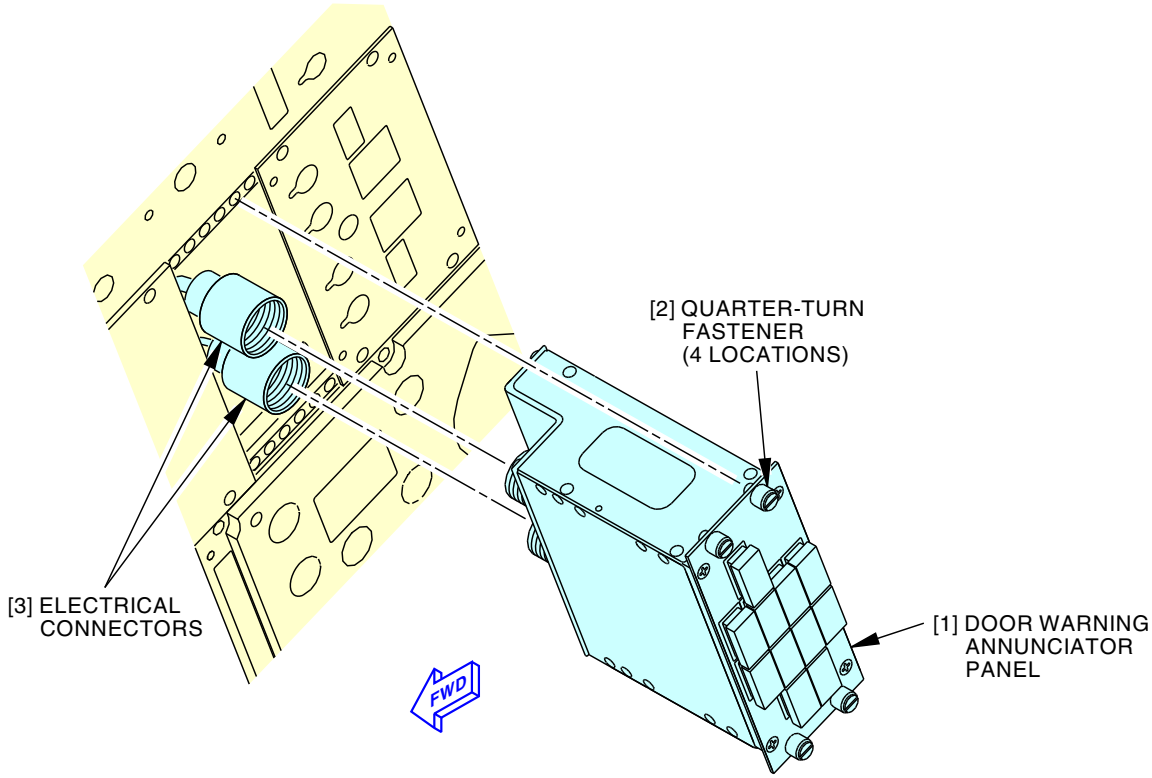
(7) Install the protective covers on the electrical connectors [3] and the electrical receptacles on the door warning annunciator panel [1].

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



FLIGHT COMPARTMENT



DOOR WARNING ANNUNCIATOR MODULE (P5-20)

A

2737741 S0000627818_V1

Door Warning Annunciator Panel Installation
Figure 201/52-71-00-990-802

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-71-00-400-801

3. Door Warning Annunciator Panel Installation

(Figure 201)

A. General

(1) This task gives the instructions to install the door warning annunciator panel.

B. References

Reference	Title
24-22-00-860-801	Supply Electrical Power (P/B 201)
24-22-00-860-802	Remove Electrical Power (P/B 201)
52-71-00-730-801	Door Warning System Test (P/B 501)

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Door warning annunciator panel	52-71-00-01-050	SIA ALL

D. Location Zones

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

E. Door Warning Annunciator Panel Installation

SUBTASK 52-71-00-862-002

(1) Make sure that the electrical power is off: Remove Electrical Power, TASK 24-22-00-860-802.

SUBTASK 52-71-00-865-002

(2) Open these circuit breakers and install safety tags:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
B	12	C00132	MASTER CAUTION ANNUNCIATOR BUS 1
B	13	C00131	MASTER CAUTION ANNUNCIATOR BAT
C	12	C01276	MASTER CAUTION ANNUNCIATOR CONT 2
F	14	C01180	INDICATOR MASTER DIM SECT 8

SUBTASK 52-71-00-020-003

(3) Remove the protective covers from the electrical connectors [3] and the electrical receptacles on the door warning annunciator panel [1].

SUBTASK 52-71-00-430-001

(4) Connect the electrical connectors [3] to the back of the door warning annunciator panel [1].

SUBTASK 52-71-00-420-001

(5) Put the door warning annunciator panel [1] into the forward overhead panel, P5.

SUBTASK 52-71-00-430-002

(6) Tighten the quarter-turn fasteners [2].

SUBTASK 52-71-00-865-003

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

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
B	12	C00132	MASTER CAUTION ANNUNCIATOR BUS 1

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
B	13	C00131	MASTER CAUTION ANNUNCIATOR BAT
C	12	C01276	MASTER CAUTION ANNUNCIATOR CONT 2
F	14	C01180	INDICATOR MASTER DIM SECT 8

SUBTASK 52-71-00-861-001

(8) Do this task: Supply Electrical Power, TASK 24-22-00-860-801.

SUBTASK 52-71-00-730-001

(9) Do this task: Door Warning System Test, TASK 52-71-00-730-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

DOOR WARNING SYSTEM - ADJUSTMENT/TEST

1. General

A. This procedure has this task:

(1) Test of the door warning system.

TASK 52-71-00-730-801

2. Door Warning System Test

(Figure 501)

A. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right
821	Forward Cargo Door
822	Aft Cargo Door
830	Subzone - Passenger Compartment Doors, Left
840	Subzone - Passenger Compartment Doors, Right

B. Door Warning System Test

SUBTASK 52-71-00-860-003

(1) Make sure the door to be tested is fully closed, latched, and locked.

SUBTASK 52-71-00-860-004

WARNING

MAKE SURE THAT THE GIRT BAR IS NOT ENGAGED IN THE BRACKETS OF THE FLOOR-MOUNTED ESCAPE SLIDE. IF THE GIRT BAR IS ENGAGED IN THE BRACKETS, THE ESCAPE SYSTEM CAN OPERATE WHEN YOU OPEN THE DOOR. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

(2) For the entry and galley service doors, make sure the escape slide girt bars are not engaged in the floor fittings.

SUBTASK 52-71-00-210-001

(3) Make sure that the applicable door warning light on the Forward Overhead Panel, P5, is off.

(a) Make sure that the two MASTER CAUTION lights in the master caution annunciators on the Glareshield Panel, P7, are off.

1) If the two MASTER CAUTION lights are on, push the MASTER CAUTION reset.

(b) Make sure that the DOORS lamp in the master caution annunciator on the right hand side of the Glareshield Panel, P7, is off.

1) If the DOORS lamp is on, push the MASTER CAUTION reset.

SUBTASK 52-71-00-730-002

(4) Do a test on each door in the system (Figure 501):

(a) Open the door.

(b) Make sure the two MASTER CAUTION lights in the master caution annunciators on the Glareshield Panel, P7, come on.

(c) Make sure the DOORS lamp in the master caution annunciator on the right hand side of the Glareshield Panel, P7, comes on.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(d) Make sure the applicable door warning light on the Forward Overhead Panel, P5, comes on.

(e) Close the door.

(f) Make sure the applicable door warning light on the Forward Overhead Panel, P5, goes off (Figure 501).

(g) Push the MASTER CAUTION reset.

(h) Make sure the two MASTER CAUTION lights in the master caution annunciators on the Glareshield Panel, P7, go off.

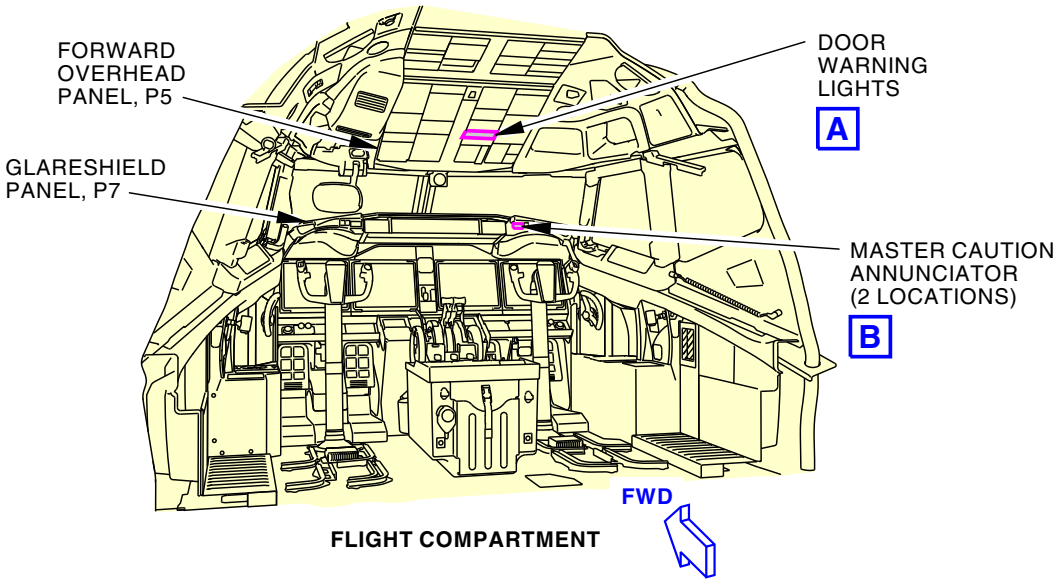
(i) Make sure the DOORS lamp in the master caution annunciator on the right hand side of the Glareshield Panel, P7, goes off.

NOTE: Make sure that no other doors in the system are opened or closed during the test.

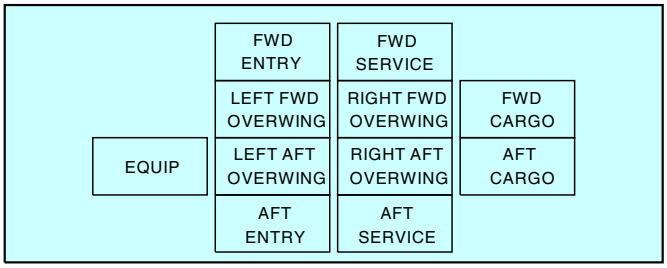
(j) Do these steps again for each door in the system.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

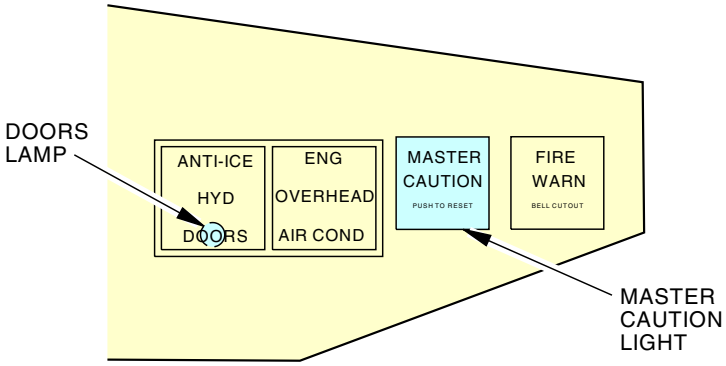


FLIGHT COMPARTMENT



DOOR WARNING LIGHTS

A



MASTER CAUTION ANNUNCIATOR (EXAMPLE)

B

2415987 S00061539367_V1

Door Warning System Test
Figure 501/52-71-00-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

ENTRY AND GALLEY SERVICE DOOR WARNING SYSTEM - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks:

(1) Entry and galley service door indication sensor removal (S194, S195, S199, or S200)

(2) Entry and galley service door indication sensor installation (S194, S195, S199, or S200)

(3) Entry and galley service door indication sensor adjustment (S194, S195,S199, or S200)

(4) Entry and galley service door indication sensor test (S194, S195, S199, or S200)

(5) Forward entry door indication sensor plunger adjustment (S199)

(6) Forward entry door indication switch removal (S1147)

(7) Forward entry door indication switch installation (S1147)

(8) Forward entry door indication switch adjustment (S1147)

(9) Forward entry door indication switch test (S1147).

B. This procedure is applicable for the indication sensor (S194, S195, S199, or S200) on the entry or galley service doors.

C. This procedure is applicable for the indication switch (S1147) on the forward entry door.

D. For the forward entry door;

(1) The indication sensor (S199) is found on the forward side of the fuselage frame on the top latch receiver.

(2) The indication switch (S1147) is found on the aft side of the fuselage frame on the top latch receiver.

E. For the aft entry door;

(1) The indication sensor (S200) is found on the aft side of the fuselage frame on the latch receiver.

F. For the galley service doors;

(1) The indication sensors (S194, forward galley or S195, aft galley) are found on the aft side of the fuselage frame on the latch receiver.

G. When the latch roller on the door goes into the latch receiver on the fuselage frame, it pushes an actuator to operate the indication sensor or switch.

H. The indication sensor and switch detects that the door is fully closed, latched and locked.

TASK 52-71-11-000-801

2. Entry and Galley Service Door Indication Sensor Removal (S194, S195, S199, or S200)

(Figure 202)

A. General

(1) This task gives the instructions to remove the indication sensor (S194, S195, S199, or S200) on the entry or galley service doors.

(2) For the S1147 indication switch on the forward entry door, do this task: Forward Entry Door Switch Removal (S1147), TASK 52-71-11-000-802.

B. References

Reference	Title
32-09-00-840-801	Prepare to Put the Airplane in the Air Mode (P/B 201)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

D. Access Panels

Number	Name/Location
831	Forward Entry Door
834	Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Prepare for the Removal

SUBTASK 52-71-11-010-001

(1) Open the applicable access doors for access to the sensor assemblies [1]:

Number	Name/Location
831	Forward Entry Door
834	Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

SUBTASK 52-71-11-860-007

(2) Do this task: Prepare to Put the Airplane in the Air Mode, TASK 32-09-00-840-801.

SUBTASK 52-71-11-860-001

(3) Open these circuit breakers and install safety tags:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
D	1	C01399	PSEU PRI
D	2	C01400	PSEU ALTN

F. Entry and Galley Service Door Indication Sensor Removal (S194, S195, S199, or S200)

SUBTASK 52-71-11-020-001

(1) Remove the proximity sensor [11]:

(a) Remove the bolts [23] that attach the cover [6] from the sensor assembly [1].

(b) Remove the bolts [3] and washers [2] that attach the sensor assembly [1] to the latch receiver [7].

(c) For the aft entry or galley service door, remove the bolt [8] and washer [9] that attach the sensor assembly [1] to the fuselage frame.

(d) Remove the sensor assembly [1] from the latch receiver [7].

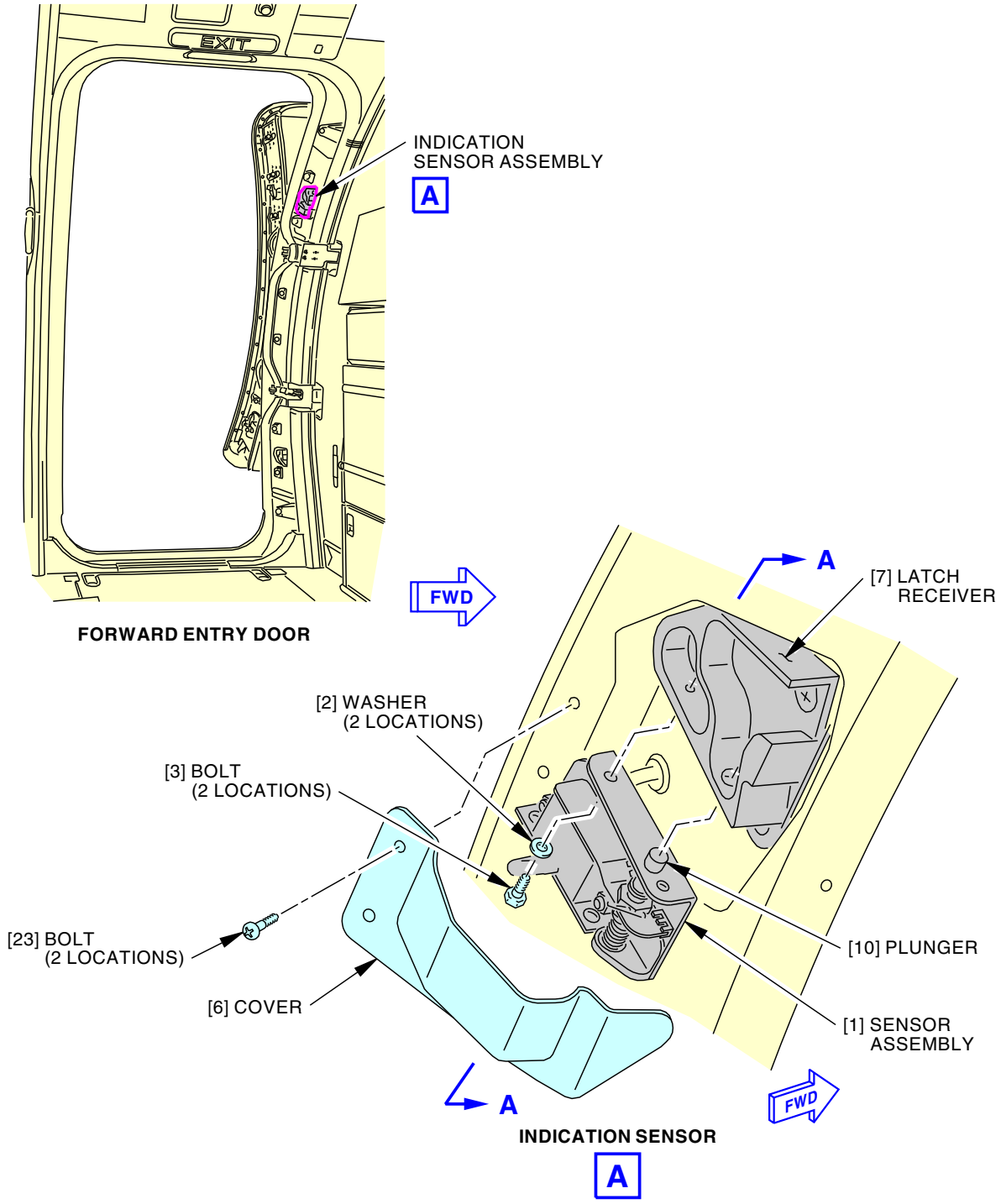
(e) Remove the screws [12], washers [13], and nuts [14] from the proximity sensor [11] and sensor assembly [1].

(f) Cut the wires that attach the proximity sensor [11] to the airplane wiring as near as possible to the proximity sensor [11].

(g) Remove the proximity sensor [11].

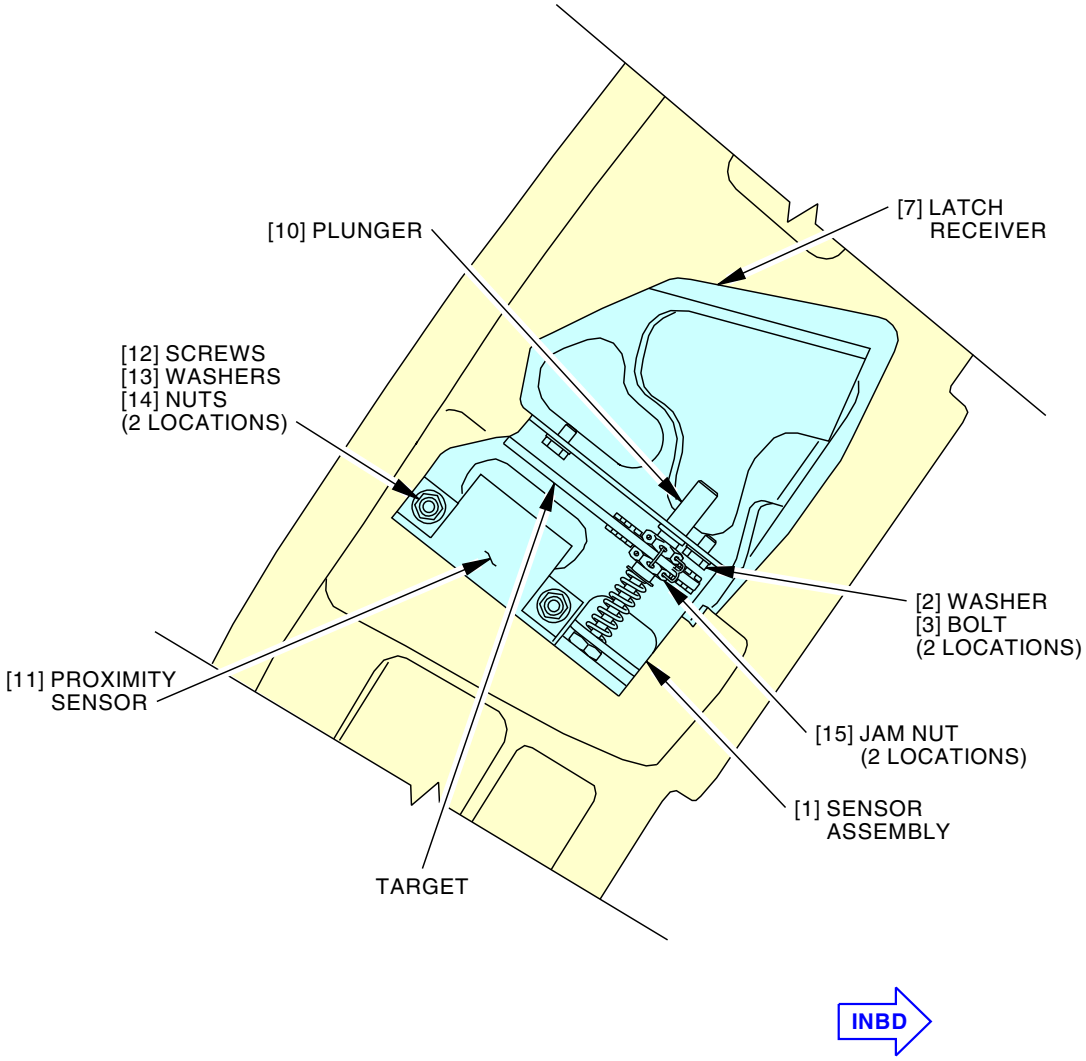
END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Forward Entry Door Warning System
Figure 201/52-71-11-990-806 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

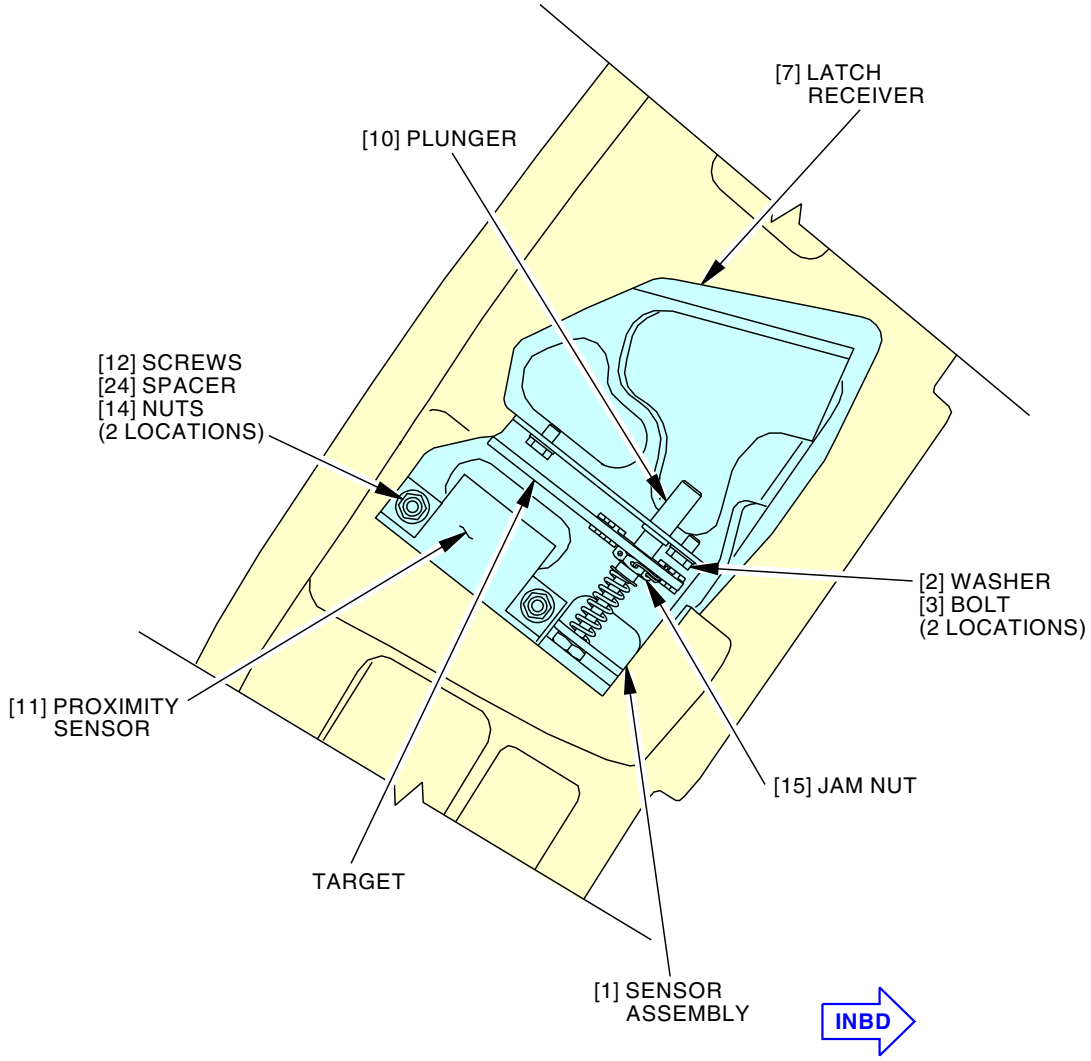


1 AIRPLANES WITH SENSOR ASSEMBLY 284A1322-6, -7, -8

2415990 S00061539376_V3

Forward Entry Door Warning System
Figure 201/52-71-11-990-806 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



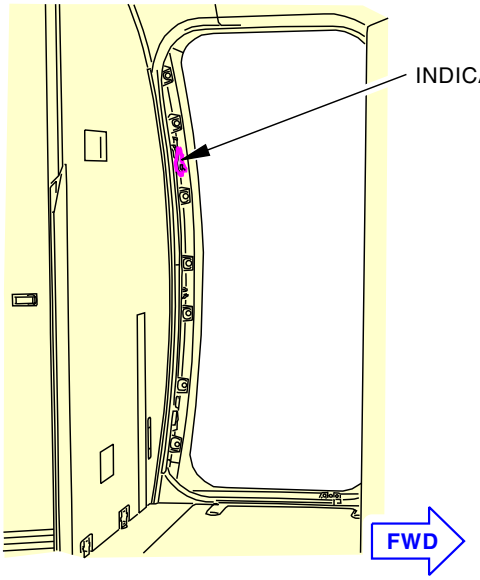
A-A 2

2 AIRPLANES WITH SENSOR ASSEMBLY 284A1322-9.

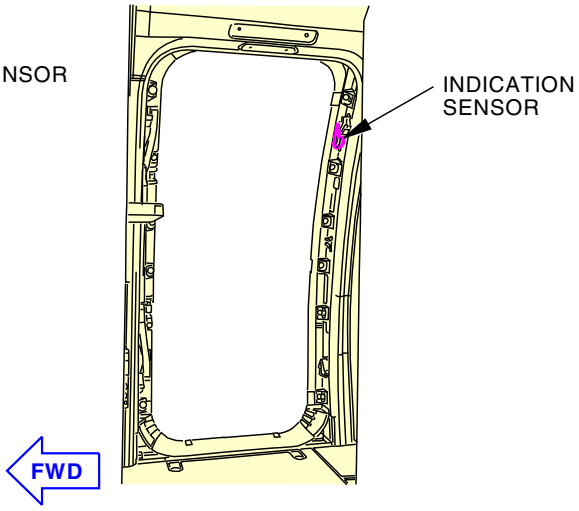
2821444 S0000652640_V1

Forward Entry Door Warning System
Figure 201/52-71-11-990-806 (Sheet 3 of 3)

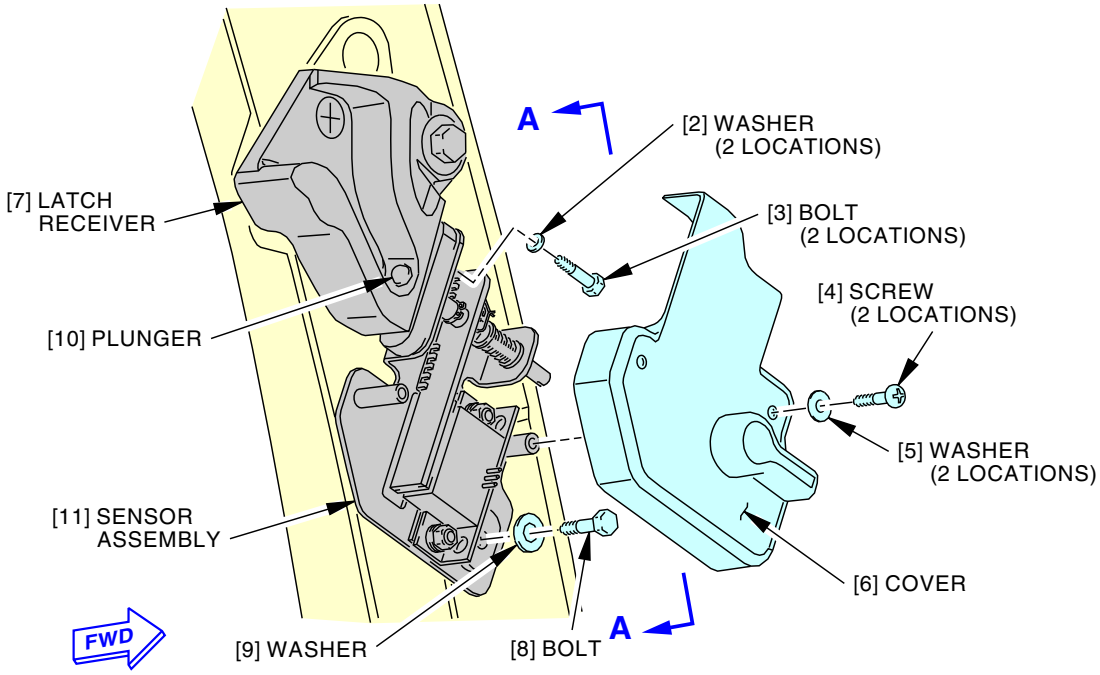
ECCN 9E991 BOEING PROPRIETARY - See title page for details



AFT ENTRY DOOR



FORWARD GALLEY SERVICE DOOR
(AFT GALLEY SERVICE DOOR
IS EQUIVALENT)



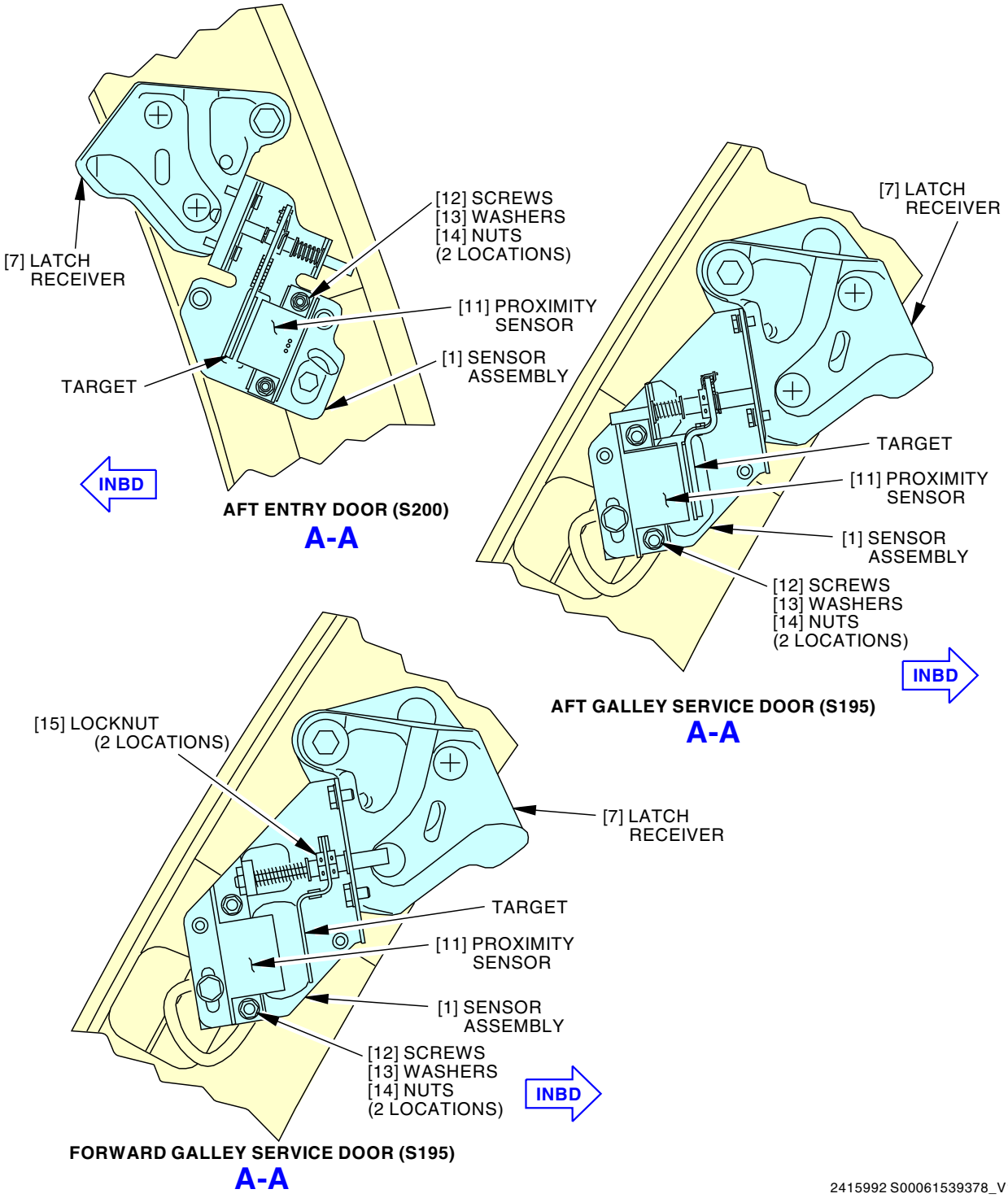
AFT ENTRY DOOR INDICATION SENSOR
(FORWARD AND AFT GALLEY SERVICE DOOR SENSORS ARE OPPOSITE)

A

2415991 S00061539377_V1

Aft Entry Door and Galley Service Doors Warning System
Figure 202/52-71-11-990-807 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Aft Entry Door and Galley Service Doors Warning System
Figure 202/52-71-11-990-807 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-71-11-400-801

3. Entry and Galley Service Door Indication Sensor Installation (S194, S195, S199, or S200)

(Figure 201, Figure 202)

A. General

(1) This task gives the instructions to install the indication sensor (S194, S195, S199, or S200) on the entry or galley service doors.

(2) For the S1147 indication switch on the forward entry door, do this task: Forward Entry Door Switch Installation (S1147), TASK 52-71-11-400-802.

B. References

Reference	Title
32-09-00-840-802	Return the Airplane Systems Back to Their Normal on Ground Condition (P/B 201)
WDM 52-71-11	D000534529

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Sensor assembly	52-71-11-01-005	SIA ALL
		52-71-11-02A-050	SIA ALL
		52-71-11-03A-050	SIA ALL
		52-71-11-04-064	SIA ALL

D. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Access Panels

Number	Name/Location
831	Forward Entry Door
834	Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

F. Entry and Galley Service Door Indication Sensor Installation (S194, S195, S199, or S200)

SUBTASK 52-71-11-420-001

(1) Install the new sensor assembly [1]:

(a) Identify the correct connections between the sensor wiring and airplane wiring (WDM 52-71-11).

NOTE: Make sure that the sensor wires are connected to the correct airplane wires. If the wires are not correctly connected the sensor will not operate.

(b) Connect the airplane wiring to the sensor wiring of the proximity sensor [11].

(c) Install the proximity sensor [11] sensor to the sensor assembly [1] with the screws [12], washers [13], and nuts [14].

(d) Put the sensor assembly [1] on the latch receiver [7].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(e) For the aft entry or galley service door, install the bolt [8] and washer [9] to attach the sensor assembly [1] to the fuselage frame.

(f) Install the bolts [3] and washers [2] that the sensor assembly [1] to the latch receiver [7].

SUBTASK 52-71-11-860-008

(2) Do this task: Return the Airplane Systems Back to Their Normal on Ground Condition, TASK 32-09-00-840-802.

SUBTASK 52-71-11-860-002

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

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
D	1	C01399	PSEU PRI
D	2	C01400	PSEU ALTN

SUBTASK 52-71-11-820-001

(4) Do this task: Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200), TASK 52-71-11-820-801.

SUBTASK 52-71-11-420-002

(5) Install the cover [6] on the sensor assembly [1]:

(a) Put the cover [6] on the sensor assembly [1].

(b) Install the bolts [23] that attach the cover [6] to the sensor assembly [1].

SUBTASK 52-71-11-710-001

(6) Do this task: Entry and Galley Service Door Indication Sensor Test (S194, S195, S199, or S200), TASK 52-71-11-710-801.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 52-71-11-410-001

(1) Close the applicable access doors:

Number	Name/Location
831	Forward Entry Door
834	Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

——— END OF TASK ———

TASK 52-71-11-820-801

4. Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200)

(Figure 201, Figure 202, Figure 203)

A. General

(1) This task gives the instructions to adjust the indication sensor (S194, S195, S199, or S200) on the entry or galley service doors.

(2) For the indication switch S1147, on the forward entry door, do this task: TASK 52-71-11-820-803.

B. References

Reference	Title
20-10-44-400-801	Lockwire, Cotter Pins, and Lockrings - Installation (P/B 401)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Reference	Title
31-65-00-970-801	System Maintenance Data Pages Function (P/B 201)

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
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

E. Access Panels

Number	Name/Location
831	Forward Entry Door
834	Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

F. Prepare for the Adjustment

SUBTASK 52-71-11-010-002

(1) Close and lock the applicable access doors:

Number	Name/Location
831	Forward Entry Door
834	Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

G. Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200)

SUBTASK 52-71-11-820-002

(1) Adjust the sensor, as follows:

(a) On the MAX Display System (MDS), go to the 32 PSEU display in the MAINT DATA PGS as shown in Figure 203 (TASK 31-65-00-970-801).

1) Make sure that with the doors closed that the DOOR clearance values for the sensors that follow are within tolerance of the optimum gap (Table 201).

a) AFT ENTRY

b) AFT SERVICE

c) FWD ENTRY

d) FWD SERVICE.

2) If the sensor clearance is too small or too large, the values for the STATE will show ”MARG” (or “FAR” if the sensor clearance is much too large).

a) Door light will come on.

3) If the sensor clearance is outside the tolerance range but is less than FAR, the values for the STATE will show "MARG".

ECCN 9E991 BOEING PROPRIETARY - See title page for details

a) Door light will not come on.

(b) If the sensor clearance is not within tolerance (MARG or FAR is shown), adjust clearance as follows:

NOTE: Get the sensor clearance as close as possible to the optimum clearance when adjusting. The clearance can be different after the PSEU Sensor Rigging test is completed.

1) Open the applicable door.

2) If the cover [6] is installed on the proximity sensor [11], remove the cover [6]:

a) Remove the screws [4] and washers [5] that attach the cover [6] to the sensor assembly [1].

b) Remove the cover [6] from the proximity sensor [11].

3) If the clearance is out of tolerance for the forward entry door or forward service door, do these steps:

a) Remove the MS20995C32 lockwire, G01048, from the jam nuts [15].

b) Loosen the jam nuts [15].

c) Turn the jam nuts [15] on the plunger [10] to move the target until the clearance is within the tolerance of the optimum gap (Table 201).

NOTE: The clearance is applicable to the entire face of the proximity sensor.

Table 201/52-71-11-993-801 Sensor Gap Clearance

Sensor #	Door	Optimum Gap	Acceptable Gap
SIA 001-006 PRE SB 737-32-1555			
S199	Fwd Entry	0.100 in. (2.54 mm)	0.047 in. (1.19 mm) - 0.153 in. (3.89 mm)
SIA 007-999; SIA 001-006 POST SB 737-32-1555			
S199	Fwd Entry	0.140 in. (3.56 mm)	0.047 in. (1.19 mm) - 0.190 in. (4.83 mm)
SIA 001-006 PRE SB 737-32-1555			
S200	Aft Entry	0.100 in. (2.54 mm)	0.058 in. (1.47 mm) - 0.142 in. (3.61 mm)
SIA 007-999; SIA 001-006 POST SB 737-32-1555			
S200	Aft Entry	0.140 in. (3.56 mm)	0.058 in. (1.47 mm) - 0.190 in. (4.83 mm)
SIA ALL			
S194	Fwd Service	0.160 in. (4.06 mm)	0.090 in. (2.29 mm) - 0.230 in. (5.84 mm)
SIA 001-006 PRE SB 737-32-1555			
S195	Aft Service	0.100 in. (2.54 mm)	0.058 in. (1.47 mm) - 0.142 in. (3.61 mm)
SIA 007-999; SIA 001-006 POST SB 737-32-1555			
S195	Aft Service	0.140 in. (3.56 mm)	0.058 in. (1.47 mm) - 0.190 in. (4.83 mm)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SIA 007-999; SIA 001-006 POST SB 737-32-1555 (Continued)

Table 201/52-71-11-993-801 Sensor Gap Clearance (Continued)

Sensor #	Door	Optimum Gap	Acceptable Gap
SIA ALL			

<1> Make sure that the target is parallel to the proximity sensor [11].

<2> If it is necessary, adjust the target so that it is parallel to the proximity sensor [11].

d) Tighten the jam nuts [15].

e) Close and lock the door.

f) Do a check of the clearance value on the Proximity Switch Electronic Unit (PSEU).

g) Repeat the steps to adjust the target and then do a check of the clearance until it is within the tolerance of the optimum gap (Table 201).

h) Install the MS20995C32 lockwire, G01048, on the jam nuts [15].

<1> Use the double-twist method to install the lockwire (TASK 20-10-44-400-801).

<2> Make sure that you keep the lockwire in tension during the installation.

<3> Make sure that you twist the strands until the end of the twisted section is within 0.125 in. (3.175 mm) of the jam nuts [15].

4) If the clearance is out of tolerance for the aft entry or aft galley service door, do this step:

a) Turn the slotted end of the plunger [10] until the clearance is within the tolerance of the optimum gap (Table 201).

NOTE: The clearance is applicable to the entire face of the proximity sensor.

<1> Make sure that the target is parallel to the proximity sensor [11].

<2> If it is necessary, adjust the target so that it is parallel to the proximity sensor [11].

<3> Close the applicable door.

<4> Do a check of the clearance value on the PSEU maintenance page.

b) Repeat the steps to adjust the target and then do a check of the clearance until it is within the tolerance of the optimum gap (Table 201).

(c) Do this task: Entry and Galley Service Door Indication Sensor Test (S194, S195, S199, or S200), TASK 52-71-11-710-801.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 52-71-11-710-002

(1) If you removed for adjustment, install the cover [6]:

(a) Put the cover [6] on the sensor assembly [1].

(b) Install the screws [4] and washers [5] that attach the cover [6] to the sensor assembly [1].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

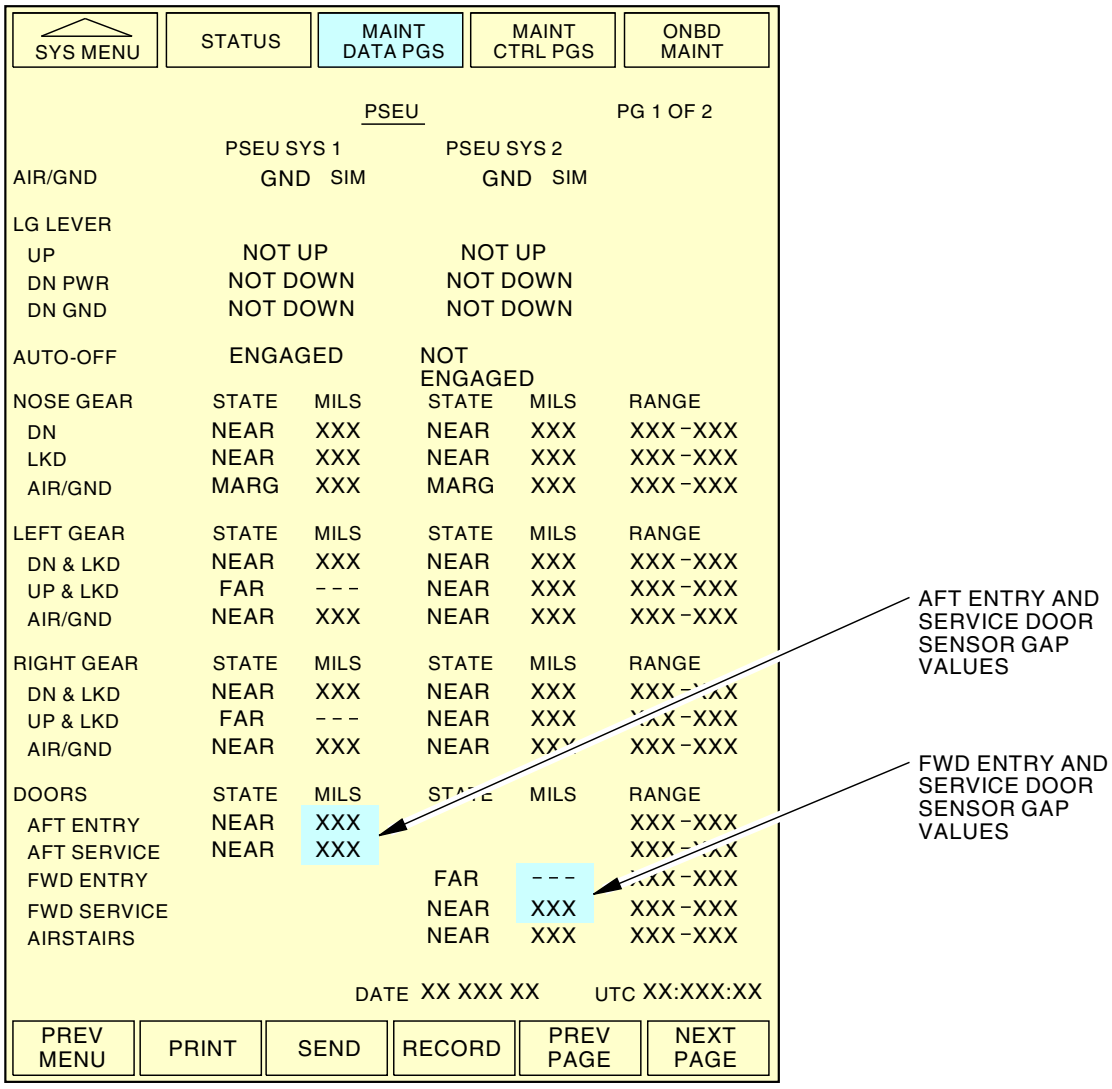
SUBTASK 52-71-11-410-002

(2) If open for adjustment, close the applicable access doors:

Number	Name/Location
831	Forward Entry Door
834	Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2458863 S0000571821_V2

PSEU Sensor Rigging Display
Figure 203/52-71-11-990-808

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-71-11-710-801

5. Entry and Galley Service Door Indication Sensor Test (S194, S195, S199, or S200)

(Figure 201, Figure 202, Figure 203)

NOTE: This procedure is a scheduled maintenance task.

A. General

(1) This task gives the instructions to test the indication sensor (S194, S195, S199, or S200) on the entry or galley service doors.

(2) For the S1147 indication switch on the forward entry door, do this task: Forward Entry Door Switch Test (S1147), TASK 52-71-11-710-802.

B. Location Zones

Zone	Area
831	Forward Entry Door
834	Left Aft Entry Door
841	Forward Galley Service Door
844	Aft Galley Service Door

C. Entry and Galley Service Door Indication Sensor Test (S194, S195, S199, or S200)

SUBTASK 52-71-11-710-003

(1) Do a test on the entry or galley service door proximity sensor [11]:

(a) Make sure that the entry and galley service doors are fully closed, latched and locked.

(b) Make sure that the FWD ENTRY, AFT ENTRY, FWD SERVICE, and AFT SERVICE lights do not show on the forward overhead panel, P5, in the flight compartment.

(c) Open the applicable door.

(d) Make sure that the FWD ENTRY, AFT ENTRY, FWD SERVICE, or AFT SERVICE light shows on the forward overhead panel, P5, for the applicable door.

(e) Close the door.

(f) Make sure that the FWD ENTRY, AFT ENTRY, FWD SERVICE, or AFT SERVICE light goes off.

——— END OF TASK ———

TASK 52-71-11-820-802

6. Forward Entry Door Indication Sensor Plunger Adjustment (S199)

(Figure 201)

A. General

(1) This task gives the instructions to adjust the indication sensor (S199) plunger on the forward entry door.

B. Location Zones

Zone	Area
831	Forward Entry Door

C. Access Panels

Number	Name/Location
831	Forward Entry Door

ECCN 9E991 BOEING PROPRIETARY - See title page for details

D. Prepare for the Adjustment

SUBTASK 52-71-11-860-004

(1) Make sure that this access panel is open:

Number	Name/Location
831	Forward Entry Door

(2) If the cover [6] is installed on the sensor assembly [1], remove the cover [6]:

(a) Remove the bolts [23] that attach the cover [6] to the sensor assembly [1].

(b) Remove the cover [6] from the sensor assembly [1].

E. Forward Entry Door Indication Sensor Plunger Adjustment (S199)

SUBTASK 52-71-11-820-003

(1) Do an adjustment of the forward entry door indication sensor plunger [10]:

(a) Examine the plunger [10].

1) Make sure that the plunger [10] moves freely when you push it with your finger.

2) If the plunger [10] does not move freely, adjust it as follows:

a) Look for burrs on the proximity sensor [11], which can stop the free movement of the plunger [10].

b) Make sure that the plunger [10] does not touch the bolt [3].

<1> If the plunger [10] touches the bolt [3], turn the bolt head slightly.

c) If the plunger [10] still does not move freely, move the plunger [10] in and out with your finger several times until it moves freely.

(2) Install the cover [6], if it was removed:

(a) Put the cover [6] on the sensor assembly [1].

(b) Install the bolts [23] that attach the cover [6] to the sensor assembly [1].

(3) Do this task: Entry and Galley Service Door Indication Sensor Test (S194, S195, S199, or S200), TASK 52-71-11-710-801.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 52-71-11-410-003

(1) Close this access panel:

Number	Name/Location
831	Forward Entry Door

END OF TASK

TASK 52-71-11-000-802

7. Forward Entry Door Switch Removal (S1147)

(Figure 204)

A. General

(1) This task gives the instructions to remove the indication switch (S1147) on the forward entry.

(2) For the indication sensor (S194, S195, S199, or S200), do this task: Entry and Galley Service Door Indication Sensor Removal (S194, S195, S199, or S200), TASK 52-71-11-000-801.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B. Consumable Materials

Reference	Description	Specification
G02421	Lockwire	NASM20995C40

C. Location Zones

Zone	Area
831	Forward Entry Door

D. Access Panels

Number	Name/Location
831	Forward Entry Door

E. Prepare for the Removal

SUBTASK 52-71-11-840-001

(1) Open this access panel:

Number	Name/Location
831	Forward Entry Door

F. Forward Entry Door Switch Removal (S1147)

SUBTASK 52-71-11-020-002

(1) Remove the lockwire, G02421, that holds the jam nuts [15].

SUBTASK 52-71-11-020-003

(2) Remove the jam nut [15].

SUBTASK 52-71-11-020-004

(3) Move the indication switch [22] out of the bracket on the latch receiver [7].

(a) Carefully move the indication switch [22] away from the aft door frame.

SUBTASK 52-71-11-020-005

(4) Disconnect the wires from the indication switch [22].

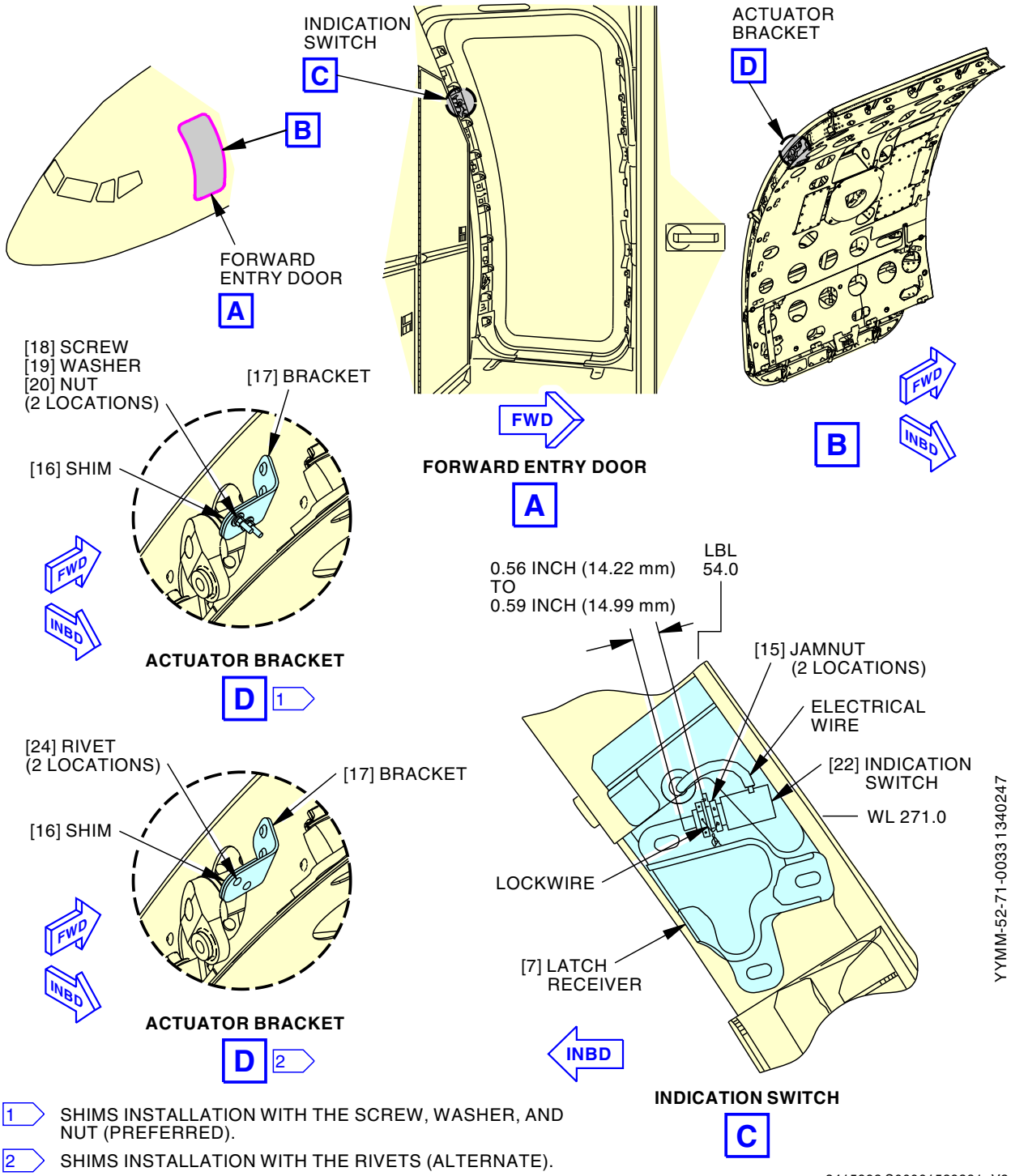
(a) Make sure that you have sufficient airplane wires for the subsequent installation.

SUBTASK 52-71-11-020-006

(5) Remove the indication switch [22].

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Indication Switch Installation
Figure 204/52-71-11-990-803

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-71-11-400-802

8. Forward Entry Door Switch Installation (S1147)

(Figure 204)

A. General

(1) This task gives the instructions to install the indication switch (S1147) on the forward entry.

(2) For the indication sensor (S194, S195, S199, or S200), do this task: Entry and Galley Service Door Indication Sensor Installation (S194, S195, S199, or S200), TASK 52-71-11-400-801.

B. References

Reference	Title
20-10-44-400-801	Lockwire, Cotter Pins, and Lockrings - Installation (P/B 401)
20-50-11 P/B 201	STANDARD TORQUE VALUES - MAINTENANCE PRACTICES
SWPM 20-30-12	ASSEMBLY OF SPLICES
WDM 52-71-11	D000534529

C. Consumable Materials

Reference	Description	Specification
G02421	Lockwire	NASM20995C40

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
22	Indication switch	52-71-11-05-010	SIA ALL

E. Location Zones

Zone	Area
831	Forward Entry Door

F. Access Panels

Number	Name/Location
831	Forward Entry Door

G. Forward Entry Door Switch Installation (S1147)

SUBTASK 52-71-11-860-005

(1) Make sure that this access panel is open:

Number	Name/Location
831	Forward Entry Door

SUBTASK 52-71-11-420-003

(2) Install the indication switch [22]:

(a) Connect the indication switch [22] to the airplanes wires:

1) For identification of the correct connections between the sensor wires and airplane wires: WDM 52-71-11.

2) Connect the airplane wires to the sensor wires (SWPM 20-30-12).

(b) Make sure that one of the jam nuts [15] is on the shaft of the indication switch [22].

(c) Put the indication switch [22] in its correct position on the aft latch receiver [7].

(d) Use the second jam nut [15] to connect the indication switch [22] to the latch receiver [7].

(e) Do this task: Forward Entry Door Switch Adjustment (S1147), TASK 52-71-11-820-803.

(f) Make sure that the jam nuts [15] are correctly torqued (PAGEBLOCK 20-50-11/201).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1) Make sure that the lockwire, G02421, is on the jam nuts [15] (TASK 20-10-44-400-801).

SUBTASK 52-71-11-720-001

(3) Do this task: Forward Entry Door Switch Test (S1147), TASK 52-71-11-710-802.

SUBTASK 52-71-11-860-006

(4) If it is not necessary, close the forward entry door.

——— END OF TASK ———

TASK 52-71-11-820-803

9. Forward Entry Door Switch Adjustment (S1147)

(Figure 204)

A. General

(1) This task gives the instructions to adjust the S1147 indication switch on the forward entry door.

(2) For the indication sensors (S194, S195, S199, or S200) on the entry or galley service doors, do this task: Entry and Galley Service Door Indication Sensor Adjustment (S194, S195, S199, or S200), TASK 52-71-11-820-801.

B. Consumable Materials

Reference	Description	Specification
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C50005	Coating - Chemical Conversion - Bonderite M-CR 1200S Aero (Formerly Alodine 1200S)	BAC5719 Class A, C or D, MIL-DTL-81706 Type I Class 1A or 3
C50069	Coating - Chemical And Solvent Resistant Finish - (BAC 702 White Color, Gloss)	BMS10-11 Type II
G02421	Lockwire	NASM20995C40

C. Location Zones

Zone	Area
831	Forward Entry Door

D. Forward Entry Door Switch Adjustment (S1147)

SUBTASK 52-71-11-820-004

(1) Measure the distance between the inboard face of the bracket that holds the indication switch [22] and the end of the switch plunger.

(a) Make sure that the measurement is between 0.56 in. (14.22 mm) to 0.59 in. (14.99 mm).

1) If it is necessary, adjust the jam nuts [15] until it is in the limits.

(b) Tighten the jam nuts [15].

NOTE: Each one-half turn of the hexnut adjusts the switch by 0.015 in. (0.381 mm).

1) Make sure that the indication switch [22] stays in the limits while you tighten the jam nuts [15].

SUBTASK 52-71-11-820-006

(2) Do this task: Forward Entry Door Switch Test (S1147), TASK 52-71-11-710-802.

(a) If the indication switch [22] does not actuate, do the steps that follow to adjust the indication switch [22] and actuator bracket [17].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1) Measure the distance between the end of the indication switch [22] plunger and the outboard face of the bracket [17].
   a) Use a 0.50 in. (12.70 mm) block of clay on the outboard face of the actuator bracket [17].
   b) Open and close the door to compress the clay.
   c) Measure the clay that is left between the compression caused by the indication switch [22] plunger and the face of the bracket [17].
2) To identify the number of shims [16] necessary for adjustment, add 0.10 in. (2.54 mm) to the measurement.

   NOTE: This is the distance the switch plunger must be pushed.

   NOTE: The total distance is the necessary shim thickness, with a tolerance of ± 0.010 in. (0.25 mm).
3) Prepare the number of shims [16] necessary for adjustment (maximum four).

   NOTE: Each shim [16] has 0.032 in. (0.813 mm) solid thickness plus ten peelable shims of 0.003 in. (0.076 mm) each, for 0.062 in. (1.575 mm) total thickness. 1 Shim - for adjustment to 0.062 in. (1.575 mm), 2 Shims - for adjustment 0.062 in. (1.575 mm) - 0.124 in. (3.150 mm), 3 Shims - for adjustment 0.124 in. (3.150 mm) - 0.186 in. (4.724 mm) and 4 Shims - for adjustment 0.186 in. (4.724 mm) - 0.248 in. (6.299 mm).
4) Drill 0.140 in. (3.556 mm) screw holes and 0.270 in. (6.858 mm), 100 degree countersunk through shim and bracket (preferred) or drill out the rivets [24] and discard them (alternate).

   NOTE: If the shim [16] was attached with the screws [18], spring washers [19] and nuts [20] to the bracket [17], then the alternate method is not applicable.
   a) Align to the existing hole in the bracket.
5) Install the shim [16] with the solid part touching the switch plunger.
6) Install the screws [18], spring washers [19] and nuts [20] (preferred) or new rivets [24] (alternate) to attach the shims [16] to the actuator bracket [17].
7) Apply Bonderite M-CR 1200S Aero coating, C50005, to the bare aluminum surfaces.
8) Apply primer, C00259, to surfaces with conversion coating, including exposed laminations of the peelable shim, after shim thickness adjustment.
9) Apply coating, C50069, on visible surfaces.

(b) If the indication switch [22] does actuate, do the steps that follow to adjust the indication switch [22] and actuator bracket [17].
1) Measure the distance the indication switch plunger travels or is depressed by the bracket [17].
   a) Apply clay to the entire plunger surface of the switch and surrounding threaded area of the switch housing until it is contacting the face of the switch mounting bracket.
   b) Open and close the door to compress the clay.
   c) Measure the protrusion of the plunger from depressed clay.
2) If the distance the plunger travels or is depressed is 0.100 ±0.010 in. (2.540 ±0.254 mm) no further adjustment is necessary.

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3) If the measured dimension is greater than or less than 0.100 ±0.010 in. (2.540 ±0.254 mm), adjust the hexnuts one half turn at a time or add shims as needed, or a combination of both in order to obtain 0.100 ±0.010 in. (2.540 ±0.254 mm) plunger travel.

a) Prepare the number of shims [16] necessary for adjustment.

NOTE: Each shim has 0.032 in. (0.813 mm) solid thickness plus ten peelable shims of 0.003 in. (0.076 mm) each, for 0.062 in. (1.575 mm) total thickness. 1 Shim - for adjustment to 0.062 in. (1.575 mm), 2 Shims - for adjustment 0.062 in. (1.575 mm) - 0.124 in. (3.150 mm), 3 Shims - for adjustment 0.124 in. (3.150 mm) - 0.186 in. (4.724 mm) and 4 Shims - for adjustment 0.186 in. (4.724 mm) - 0.248 in. (6.299 mm).

b) Drill 0.140 in. (3.556 mm) screw holes and 0.270 in. (6.858 mm), 100 degree countersunk through shim and bracket (preferred) or drill out the rivets and discard them (alternate).

NOTE: If the shim [16] was attached with the screws [18], spring washers [19] and nuts [20] to the bracket [17], then the alternate method is not applicable.

<1> Align to existing hole in bracket.

c) Install the shim [16] with the solid part touching the switch plunger.

d) Install the screws [18], spring washers [19] and nuts [20] (preferred) or new rivets [24] (alternate) to attach the shims [16] to the actuator bracket [17].

e) Apply the Bonderite M-CR 1200S Aero coating, C50005, to the bare aluminium surfaces.

f) Apply the primer, C00259, to surfaces with conversion coating, including exposed laminations of the peelable shim, after shim thickness adjustment.

g) Apply the coating, C50069, on visible surfaces.

SUBTASK 52-71-11-820-005

(3) Install lockwire, G02421, between the two jam nuts [15].

——— END OF TASK ———

TASK 52-71-11-710-802

10. Forward Entry Door Switch Test (S1147)

(Figure 205)

A. General

(1) This task gives the instructions to test the S1147 indication switch on the forward entry door.

(2) Two mechanics can be necessary to complete this procedure. One mechanic to manually operate the switches and the second mechanic to operate the lights in the flight compartment.

(3) For the indication sensors (S194, S195, S199, or S200) on the entry or galley service doors, do this task: Entry and Galley Service Door Indication Sensor Test (S194, S195, S199, or S200), TASK 52-71-11-710-801.

B. References

Reference	Title
52-11-00-860-803	Open the Door with the Interior Handle (P/B 201)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Prepare for the Test

SUBTASK 52-71-11-840-002

(1) Make sure that all of the doors that show on the door warning panel on the forward overhead panel, P5, are closed and latched.

D. Forward Entry Door Switch Test (S1147)

SUBTASK 52-71-11-720-003

(1) Push the MASTER CAUTION light on the glareshield panel, P7.

(a) Make sure that the MASTER CAUTION light and the DOORS light go OFF.

SUBTASK 52-71-11-720-004

(2) Open the main entry door (TASK 52-11-00-860-803).

(a) Make sure that the MASTER CAUTION light and DOORS light on the glareshield panel, P7, come ON.

(b) Make sure that the FWD ENTRY light on the forward overhead panel, P5, comes ON.

SUBTASK 52-71-11-720-005

(3) Use your finger to push and hold the plunger on switch S1147 and switch S199.

NOTE: You will find S1147 on the aft latch receiver.

NOTE: You will find S199 on the forward latch receiver.

SUBTASK 52-71-11-210-001

(4) Make sure that the FWD ENTRY light on the forward overhead panel, P5, goes OFF.

SUBTASK 52-71-11-720-006

(5) While you hold S1147 and S199, push and release the MASTER CAUTION light on the glareshield panel, P7.

(a) Make sure that the MASTER CAUTION light and DOORS light on the glareshield panel, P7, go OFF.

SUBTASK 52-71-11-720-007

(6) Release the S1147 switch.

(a) Make sure that the MASTER CAUTION light and DOORS light on the glareshield panel, P7, come ON.

(b) Make sure that the FWD ENTRY light on the forward overhead panel, P5, comes ON.

SUBTASK 52-71-11-720-008

(7) Close and latch the forward entry door.

(a) Make sure that the FWD ENTRY light on the forward overhead panel, P5, goes OFF.

(b) Push and release the MASTER CAUTION light on the glareshield panel, P7.

1) Make sure that the MASTER CAUTION light and DOORS light on the glareshield panel, P7, go OFF.

SUBTASK 52-71-11-720-009

(8) If the test is not in the limits, then do these steps:

(a) Make sure the indication switch [22] is in the limits of the adjustment procedure.

1) Adjust the switch to the specified dimensions (TASK 52-71-11-820-803).

2) Close the door.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

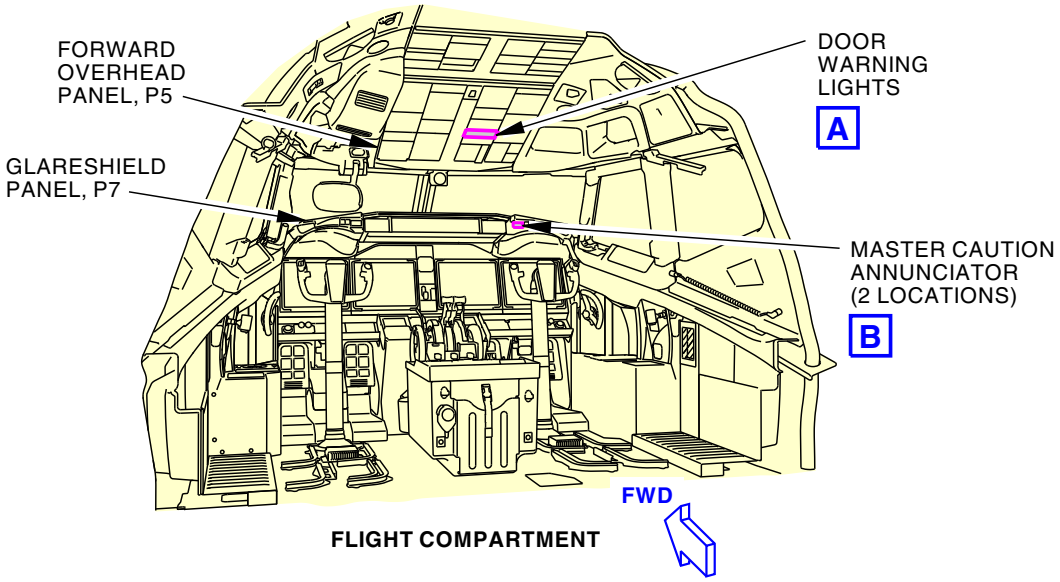
3) If the forward entry light does not go off when the door is latched and closed, then adjust the target bracket with shims (TASK 52-71-11-820-803).

   NOTE: You will find the bracket that actuates the switch on the frame of the door.

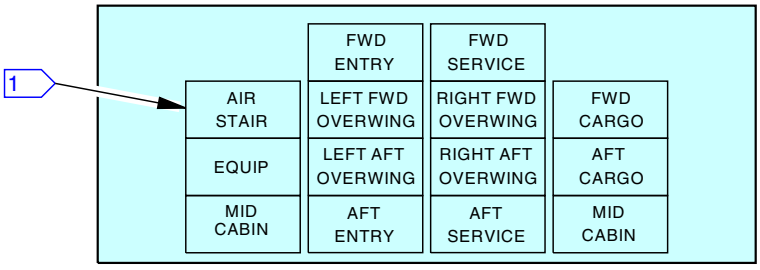
4) If the forward entry light goes off when the door is latched and closed, make sure the switch is adjusted to the specified dimensions (TASK 52-71-11-820-803).

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

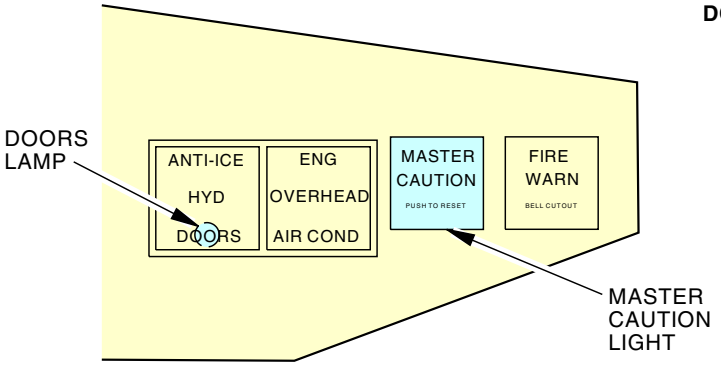


FLIGHT COMPARTMENT



DOOR WARNING LIGHTS

A



MASTER CAUTION ANNUNCIATOR
(EXAMPLE)

B

1 AIRPLANES WITH FORWARD AIRSTAIR

2415994 S00061539385_V1

Forward Entry Door Warning System Test
Figure 205/52-71-11-990-804

ECCN 9E991 BOEING PROPRIETARY - See title page for details

EMERGENCY EXIT DOOR INDICATION SWITCH - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks:

(1) Emergency exit door indication switch removal

(2) Emergency exit door indication switch installation

(3) Emergency exit door indication switch test.

B. The emergency exit door indication switch is referred to as the indication switch in this procedure.

C. There are two indication switches for each emergency exit door, they are found on the door forward and aft lock receivers. This procedure is the same for the two indication switches.

D. When the lock roller on the door goes into the lock receiver on the fuselage frame, it pushes an actuator to operate the indication switch.

E. The indication switch detects that the door is fully closed, latched and locked.

TASK 52-71-22-000-801

2. Emergency Exit Door Indication Switch Removal

(Figure 201)

A. General

(1) This task gives the instructions to remove the emergency exit door indication switch.

B. References

Reference	Title
32-09-00-840-801	Prepare to Put the Airplane in the Air Mode (P/B 201)

C. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

D. Prepare for the Removal

SUBTASK 52-71-22-010-001

WARNING MAKE SURE THAT THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING-LOADED TO OPEN AUTOMATICALLY AND CAN CAUSE INJURY TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(1) Pull down on the release handle to open the door.

SUBTASK 52-71-22-840-002

(2) Do this task: Prepare to Put the Airplane in the Air Mode, TASK 32-09-00-840-801.

SUBTASK 52-71-22-860-001

(3) Open these circuit breakers and install safety tags:

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
D	1	C01399	PSEU PRI

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(Continued)

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
D	2	C01400	PSEU ALTN

E. Emergency Exit Door Indication Switch Removal

SUBTASK 52-71-22-020-001

(1) Remove the indication switch [2]:

(a) Remove the screws [10] and washers [1] that attach the cover [9] to the indication switch [2].

(b) Remove the cover [9] from the indication switch [2].

(c) Remove the bolts [4] and washers [5] that attach the indication switch [2] to the lock receiver [6].

(d) Pull the wiring [3] attached to the indication switch [2] through the fuselage frame to get access to the wiring splices.

(e) Cut the wires that attach the indication switch [2] to the airplane wiring as near as possible to the indication switch [2].

(f) Remove the indication switch [2].

——— END OF TASK ———

TASK 52-71-22-420-801

3. Emergency Exit Door Indication Switch Installation

(Figure 201)

A. General

(1) This task gives the instructions to install the emergency exit door indication switch.

B. References

Reference	Title
32-09-00-840-802	Return the Airplane Systems Back to Their Normal on Ground Condition (P/B 201)

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
2	Indication switch	52-71-22-02-095	SIA ALL
		52-71-22-02-100	SIA ALL

D. Location Zones

Zone	Area
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

E. Emergency Exit Door Indication Switch Installation

SUBTASK 52-71-22-420-001

(1) Install the indication switch [2]:

(a) Connect the wiring [3] to the indication switch [2].

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(b) Put the indication switch [2] in its correct position on the lock receiver [6].

(c) Make sure that the actuator [7] extends through the lock receiver [6].

(d) Install the bolts [4] and washers [5] to attach the indication switch [2] to the lock receiver [6].

(e) Install the screws [10] and washers [1] that attach the cover [9] to the indication switch [2].

1) Tighten the screws [10] to 13.5 in-lb (1.53 N·m) - 16.5 in-lb (1.86 N·m).

(f) Make sure that the actuator moves freely.

SUBTASK 52-71-22-840-001

(2) Do this task: Return the Airplane Systems Back to Their Normal on Ground Condition, TASK 32-09-00-840-802.

SUBTASK 52-71-22-860-004

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

F/O Electrical System Panel, P6-3

Row	Col	Number	Name
D	1	C01399	PSEU PRI
D	2	C01400	PSEU ALTN

F. Emergency Exit Door Indication Switch Installation Test

SUBTASK 52-71-22-710-001

(1) Do this task: Emergency Exit Door Indication Switch Test, TASK 52-71-22-710-801.

——— END OF TASK ———

TASK 52-71-22-710-801

4. Emergency Exit Door Indication Switch Test

(Figure 201 and Figure 202)

NOTE: This procedure is a scheduled maintenance task.

A. General

(1) This task gives the instructions to test the emergency exit door indication switch.

B. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right
832	Left Forward Emergency Exit
833	Left Emergency Exit (STA 627.5)
842	Right Forward Emergency Exit
843	Right Emergency Exit (STA 627.5)

C. Emergency Exit Door Indication Switch Test

SUBTASK 52-71-22-730-001

(1) Do a test on the applicable indication switch [2] as follows:

(a) Make sure that all emergency exit doors are fully closed, latched and locked.

(b) Make sure that the OVERWING EXIT light does not show on the Forward Overhead Panel, P5, in the flight compartment.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(c) Select the MAINT DATA PGS tab from the Multi-Function Display (MFD).

(d) Select PSEU from the MFD.

(e) Select NEXT PAGE until IO MATRIX is shown.

WARNING MAKE SURE THAT THE DOOR OPENING PATH IS CLEAR BEFORE YOU RELEASE THE DOOR HANDLE. THE DOOR IS SPRING-LOADED TO OPEN AUTOMATICALLY AND CAN CAUSE INJURY TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(f) Open the applicable emergency exit door.

(g) Make sure that the switch signals change state from “1” = door closed to “0” = door open on the IO MATRIX for the applicable door switch (Figure 202, Table 201).

(h) Make sure that the OVERWING EXIT light comes on the Forward Overhead Panel, P5.

(i) Close the emergency exit door.

(j) Make sure that the OVERWING EXIT light goes off on the Forward Overhead Panel, P5.

(k) Make sure that the switch signals change state from “0” = door open to “1” = door closed on the IO MATRIX for the applicable door switch (Figure 202, Table 201).

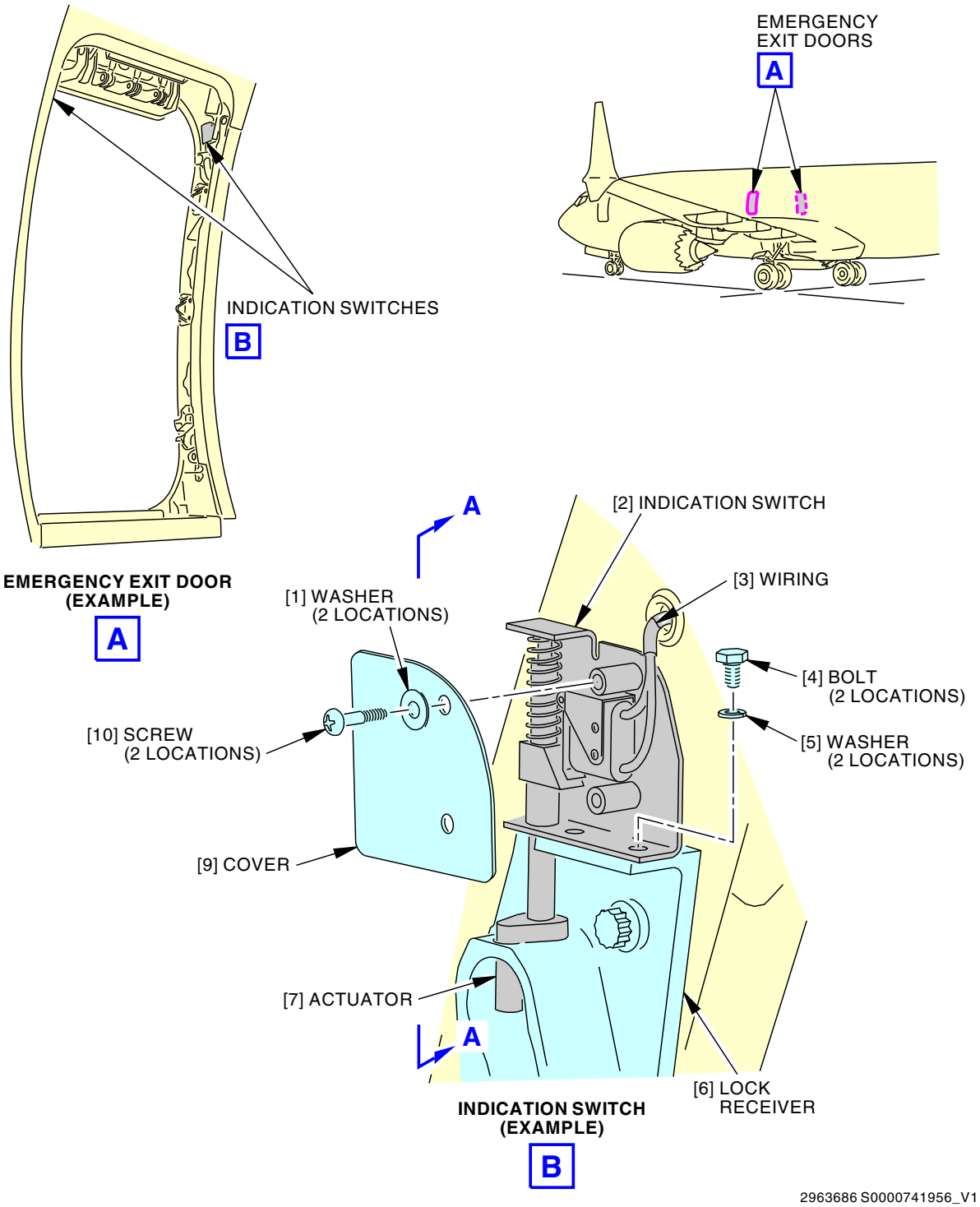
(l) If necessary, adjust the actuator.

Table 201/52-71-22-993-801 EMERGENCY EXIT DOOR INDICATION SWITCH TEST

DOOR INDICATION SWITCH	CONNECTOR	PIN
L FWD OW A	D10986	52
L FWD OW B	D10988	35
L AFT OW A	D10986	8
L AFT OW B	D10988	21
R FWD OW A	D10986	15
R FWD OW B	D10988	30
R AFT OW A	D10986	61
R AFT OW B	D10988	1

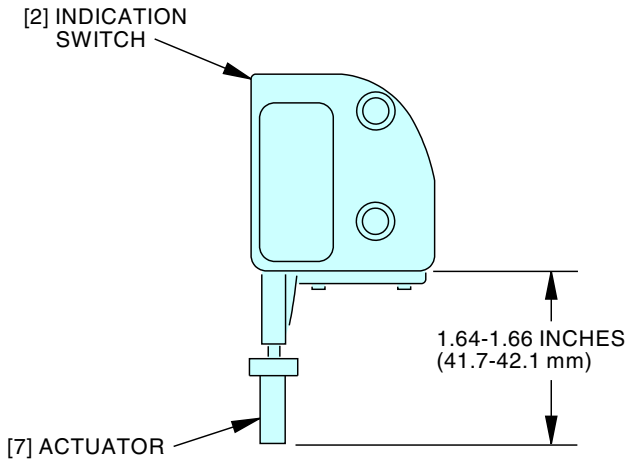
END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details



Emergency Exit Door Warning System
Figure 201/52-71-22-990-803 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

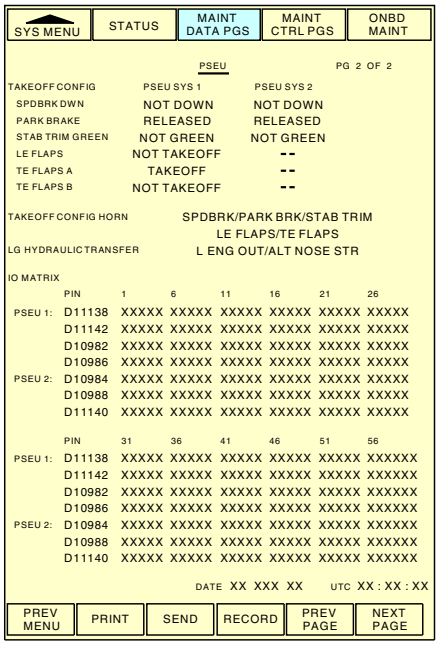


A-A

2963687 S0000741957_V1

Emergency Exit Door Warning System
Figure 201/52-71-22-990-803 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



SYS MENU | STATUS | MAINT DATA PGS | MAINT CTRL PGS | ONBD MAINT

PSEU PG 2 OF 2

	PSEU SYS 1	PSEU SYS 2
TAKEOFF CONFIG		
SPDBRK DWN	NOT DOWN	NOT DOWN
PARK BRAKE	RELEASED	RELEASED
STAB TRIM GREEN	NOT GREEN	NOT GREEN
LE FLAPS	NOT TAKEOFF	--
TE FLAPS A	TAKEOFF	--
TE FLAPS B	NOT TAKEOFF	--

TAKEOFF CONFIG HORN: SPDBRK/PARK BRK/STAB TRIM, LE FLAPS/TE FLAPS

LG HYDRAULIC TRANSFER: L ENG OUT/ALT NOSE STR

IO MATRIX

	PIN	1	6	11	16	21	26
PSEU 1:	D11138	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX
	D11142	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX
	D10982	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX
	D10986	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX
PSEU 2:	D10984	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX
	D10988	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX
	D11140	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX

	PIN	31	36	41	46	51	56
PSEU 1:	D11138	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX	XXXXXX
	D11142	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX	XXXXXX
	D10982	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX	XXXXXX
	D10986	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX	XXXXXX
PSEU 2:	D10984	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX	XXXXXX
	D10988	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX	XXXXXX
	D11140	XXXXX	XXXXX	XXXXX	XXXXX	XXXXX	XXXXXX

DATE XX XXX XX UTC XX : XX : XX

PREV MENU | PRINT | SEND | RECORD | PREV PAGE | NEXT PAGE

PSEU MAINTENANCE PAGE
(EXAMPLE)

2568420 S0000615367_V1

Emergency Exit Door Indication Switch Test
Figure 202/52-71-22-990-802

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CARGO DOOR WARNING SYSTEM - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks:

(1) Forward Cargo door indication switch removal

(2) Forward Cargo door indication switch installation

(3) Aft Cargo door indication switch removal

(4) Aft Cargo door indication switch installation

(5) Cargo door indication switch adjustment

(6) Cargo door indication switch test.

B. The indication switch is found on the forward side of the fuselage frame on the latch receiver. When the latch roller on the door goes into the latch receiver on the fuselage frame, it pushes a plunger to operate the switch.

C. The indication switch detects that the door is fully closed, latched and locked.

TASK 52-71-31-000-801

2. Forward Cargo Door Indication Switch - Removal

(Figure 201)

A. General

(1) This task gives the instructions to remove the forward cargo door indication switch.

B. Location Zones

Zone	Area
821	Forward Cargo Door

C. Prepare for the Removal

SUBTASK 52-71-31-010-001

(1) Open the forward cargo door, attach the strap to the lower stop to hold the forward cargo door open.

D. Forward Cargo Door Indication Switch Removal

SUBTASK 52-71-31-020-001

(1) Remove the forward indication switch [1] as follows:

(a) Remove the bolts [3], washers [4], and screws [7] that attach the cover [5] to the fuselage frame.

(b) Remove the cover [5].

(c) Remove the screws [8] and washers [9] that attach the wiring [6] and wiring [12] to the forward indication switch [1].

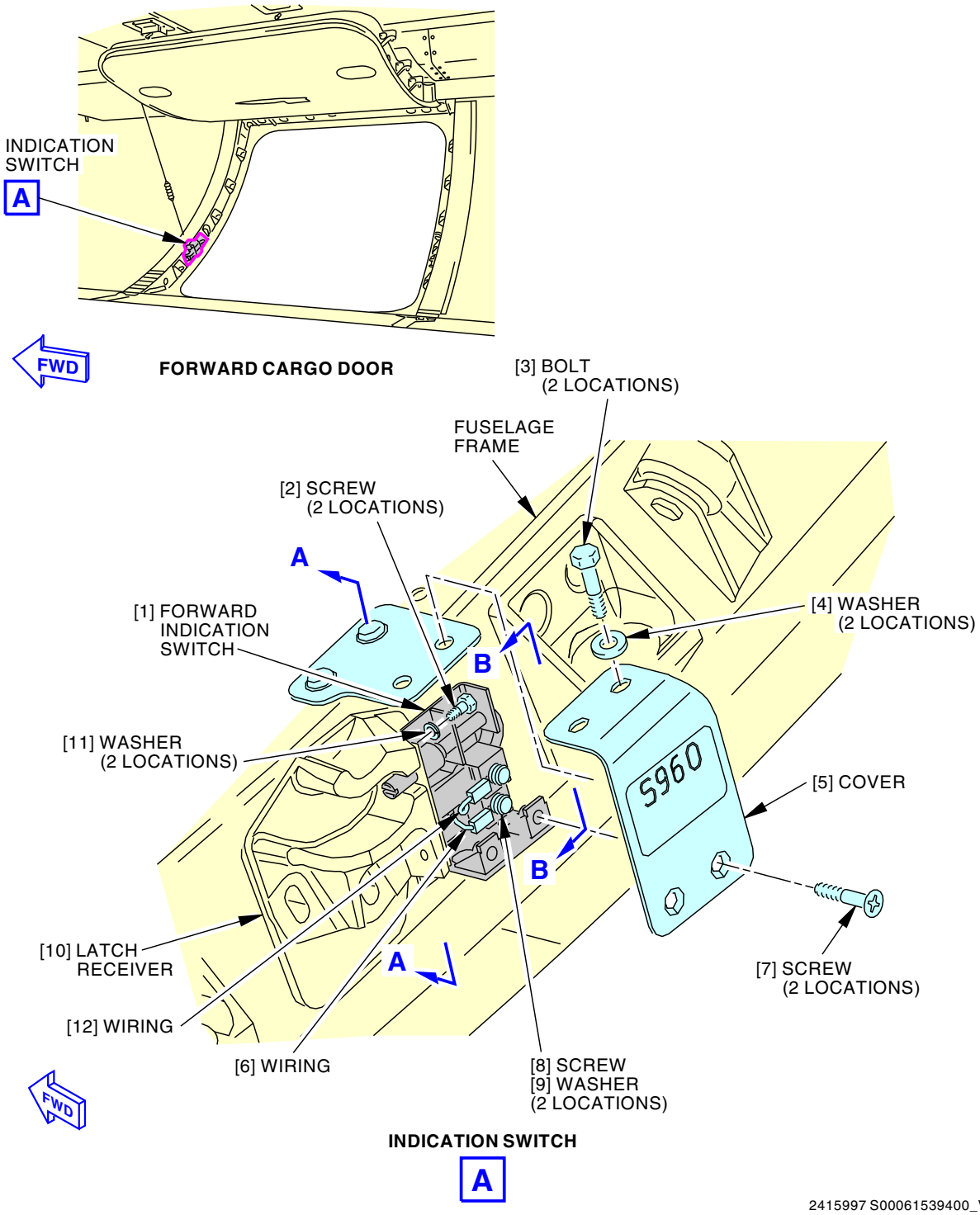
1) Install identification tags on the wiring [6] and wiring [12] to identify them for installation.

(d) Remove the screws [2] and washers [11] that attach the forward indication switch [1] to the latch receiver [10].

(e) Remove the forward indication switch [1].

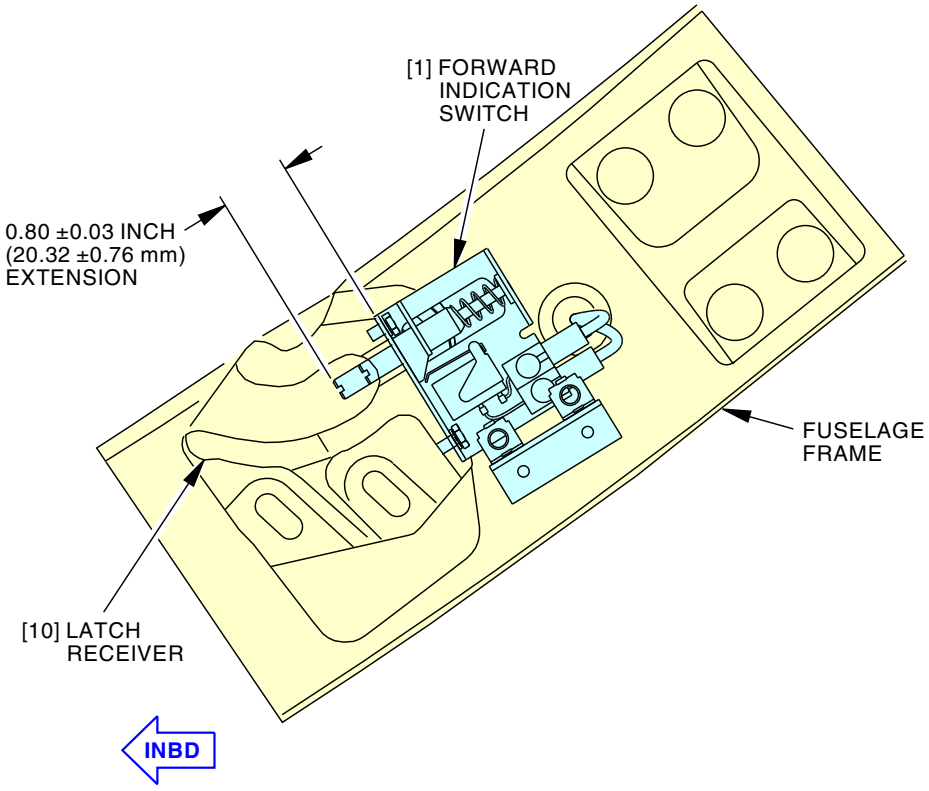
END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

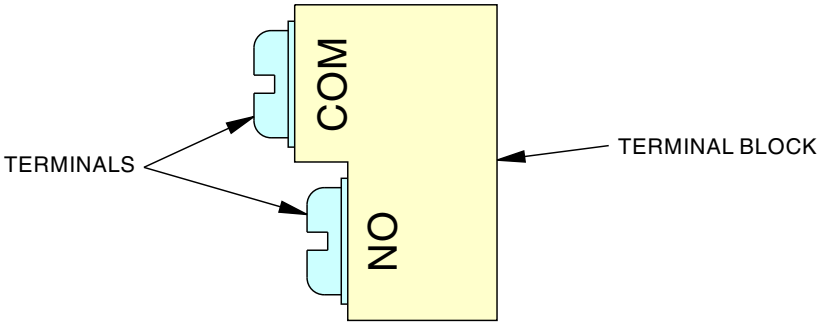


Forward Cargo Door Warning System
Figure 201/52-71-31-990-802 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



A-A

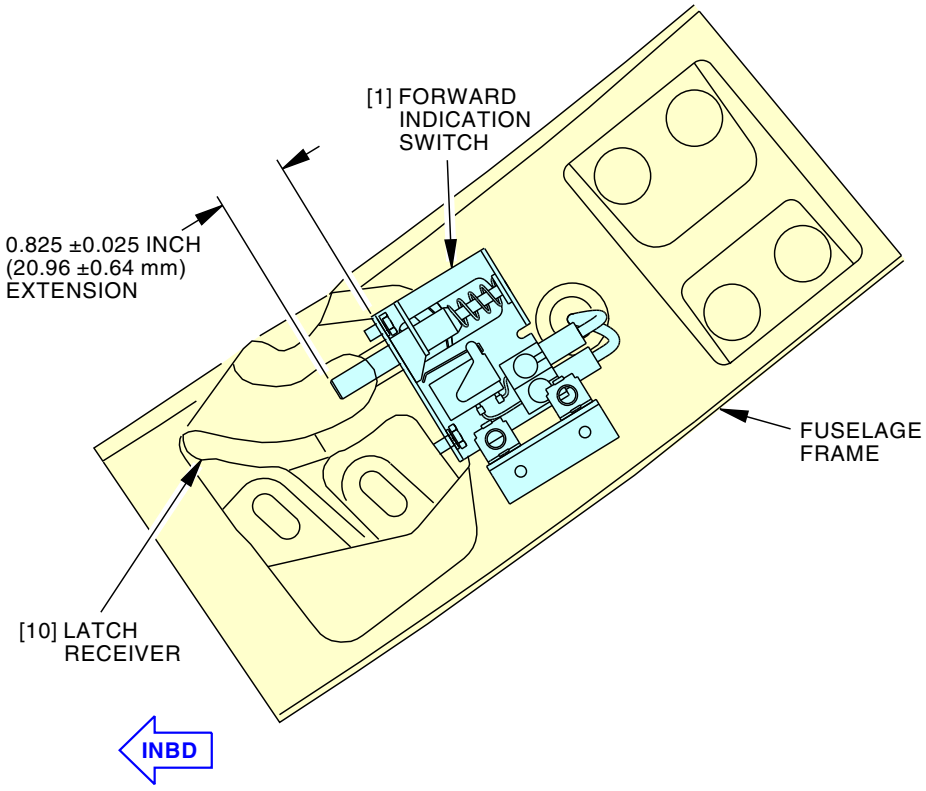


B-B

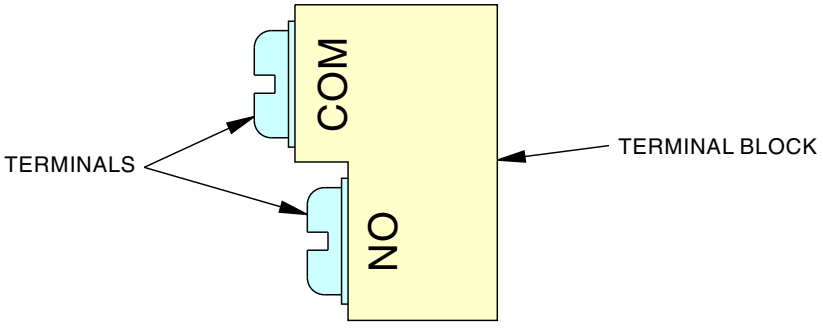
2415998 S00061539401_V3

Forward Cargo Door Warning System
Figure 201/52-71-31-990-802 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



A-A



B-B

2896631 S0000690974_V3

Forward Cargo Door Warning System
Figure 201/52-71-31-990-802 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-71-31-400-801

3. Forward Cargo Door Indication Switch - Installation

(Figure 201)

A. General

(1) This task gives the instructions to install the forward cargo door indication switch.

B. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Forward indication switch	52-71-31-01-060	SIA ALL

C. Location Zones

Zone	Area
821	Forward Cargo Door

D. Forward Cargo Door Indication Switch Installation

SUBTASK 52-71-31-420-001

(1) Install the forward indication switch [1] as follows:

(a) Put the forward indication switch [1] in its correct position through the latch receiver [10].

(b) Install the screws [2] and washers [11] that attach the forward indication switch [1] to the latch receiver [10].

(c) Install the screws [8] and washers [9] that attach the wiring [6] and wiring [12] to the forward indication switch [1].

1) Tighten the screws [8] to 4.5 in-lb (0.51 N·m) - 5 in-lb (0.56 N·m).

2) Remove identification tags from the wiring [6] and wiring [12].

(d) Put the cover [5] in its correct position over the forward indication switch [1].

(e) Install the bolts [3], washers [4], and screws [7] that attach the cover [5] to the fuselage frame.

SUBTASK 52-71-31-820-001

(2) Do this task: Cargo Door Indication Switch - Adjustment, TASK 52-71-31-820-801.

SUBTASK 52-71-31-840-001

(3) Close the forward cargo door.

SUBTASK 52-71-31-730-001

(4) Do this task: Cargo Door Indication Switch - Test, TASK 52-71-31-710-801.

——— END OF TASK ———

TASK 52-71-31-000-802

4. Aft Cargo Door Indication Switch - Removal

(Figure 202)

A. General

(1) This task gives the instructions to remove the aft cargo door indication switch.

B. Location Zones

Zone	Area
822	Aft Cargo Door

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Prepare for the Removal

SUBTASK 52-71-31-010-003

(1) Open the aft cargo door, attach the strap to the lower stop to hold the aft cargo door open.

D. Aft Cargo Door Indication Switch Removal

SUBTASK 52-71-31-020-002

(1) Remove the aft indication switch [1] as follows:

(a) Remove the bolts [3], washers [4], and screws [7] that attach the cover [5] to the fuselage frame.

(b) Remove the cover [5].

(c) Remove the screws [8] and washers [9] that attach the wiring [6] and wiring [12] to the aft indication switch [1].

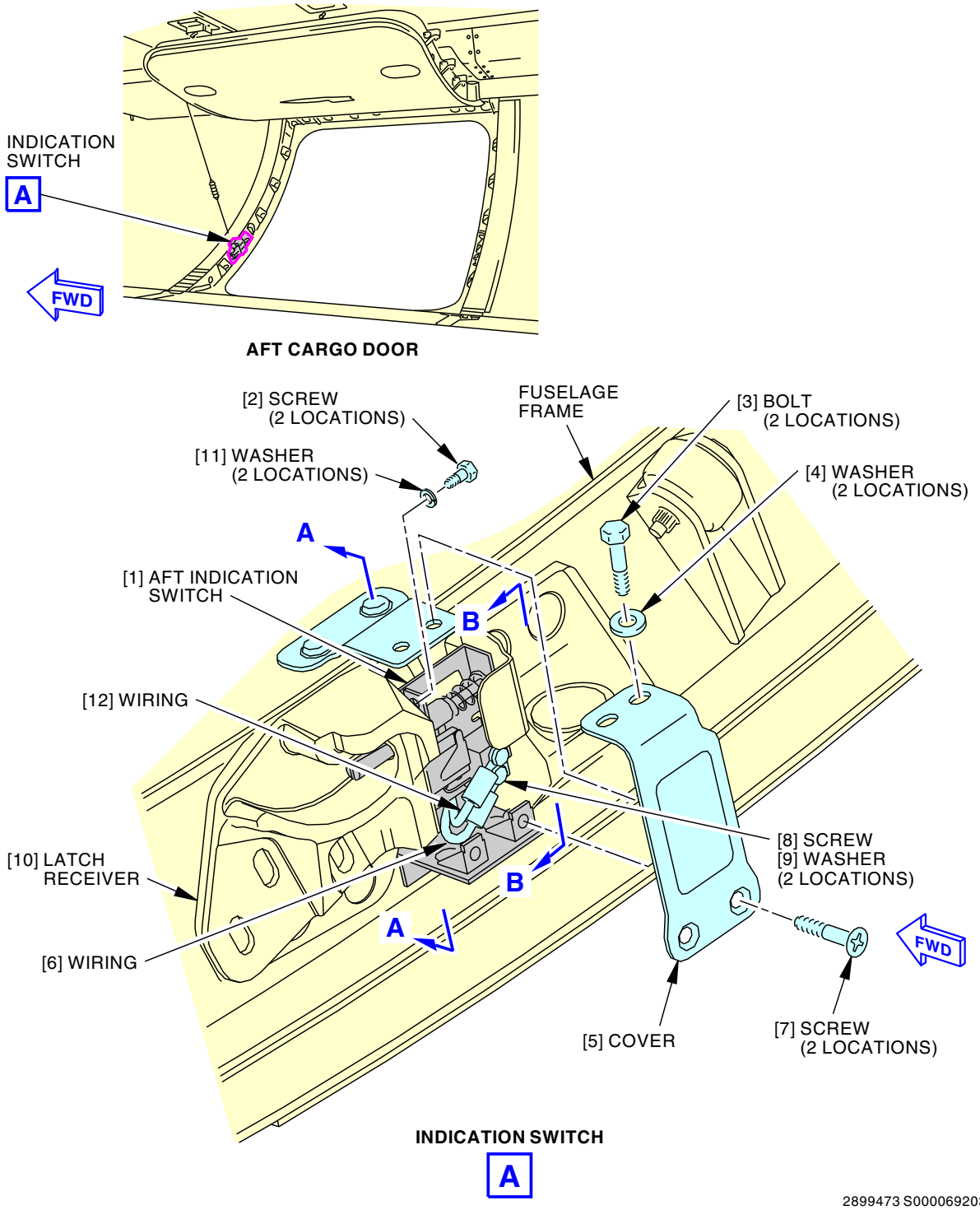
1) Install identification tags on the wiring [6] and wiring [12] to identify them for installation.

(d) Remove the screws [2] and washers [11] that attach the aft indication switch [1] to the latch receiver [10].

(e) Remove the aft indication switch [1].

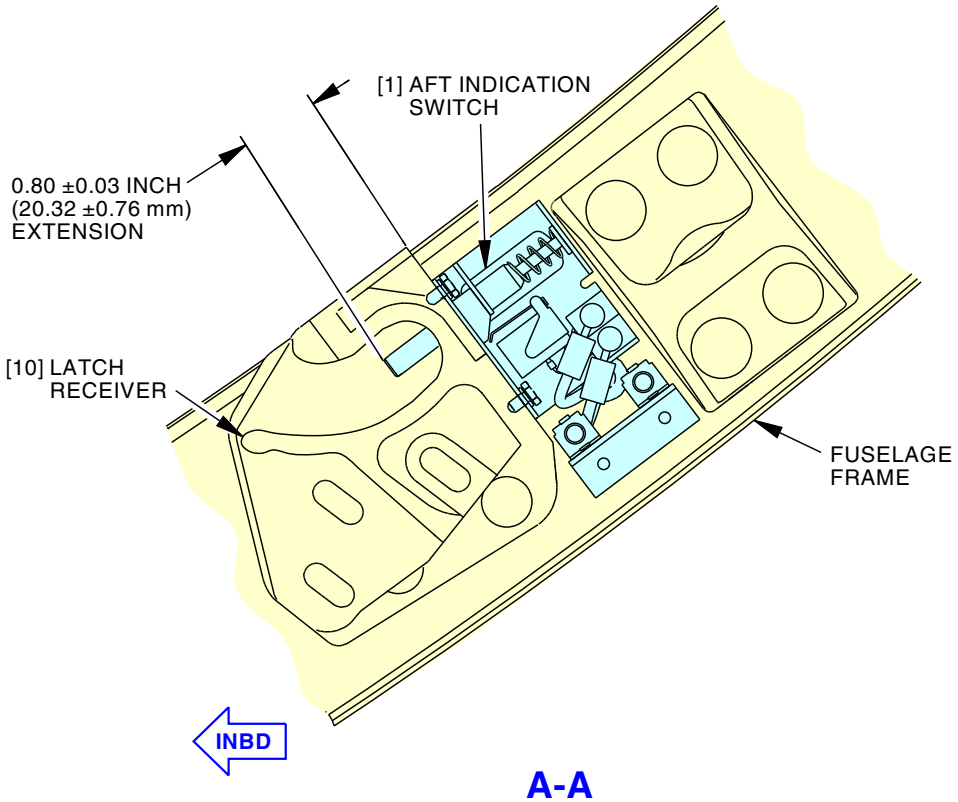
——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

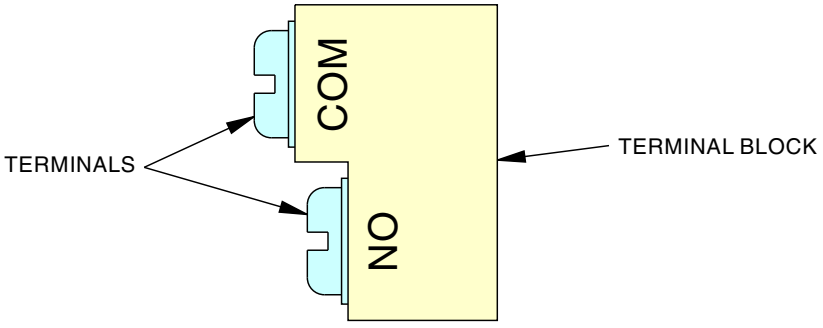


Aft Cargo Door Warning System
Figure 202/52-71-31-990-803 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



A-A

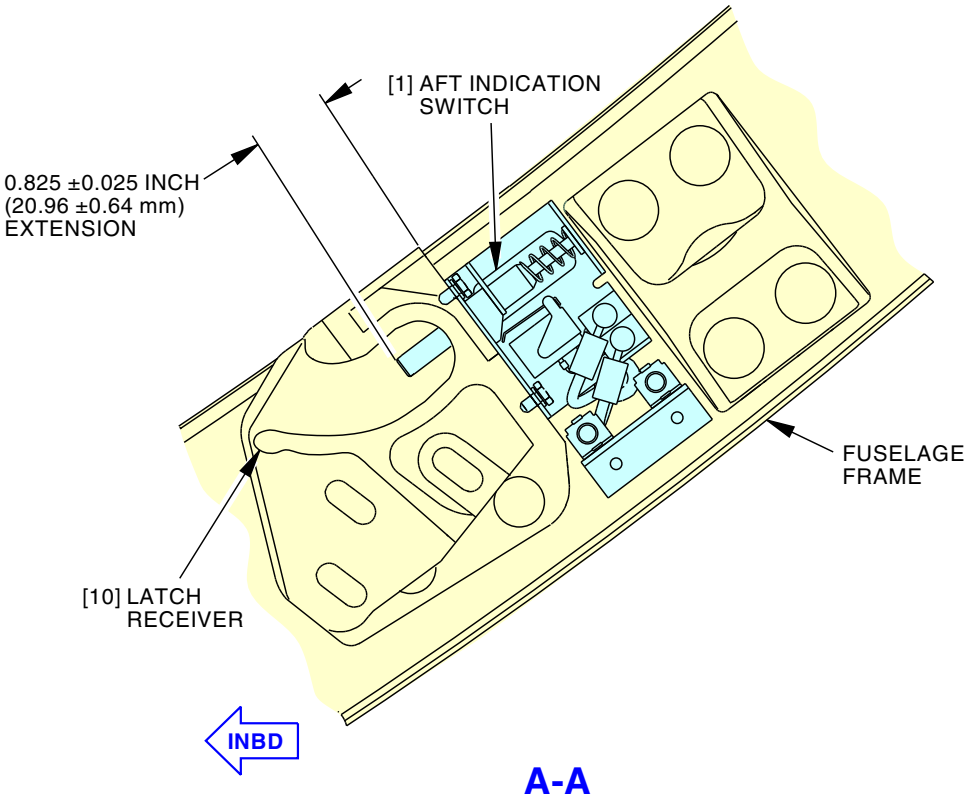


B-B

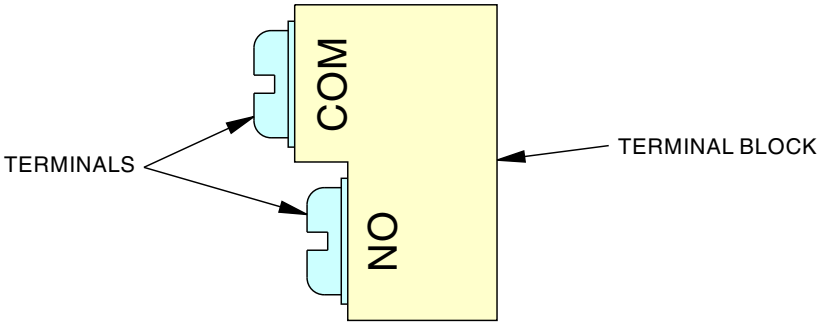
2899474 S0000692032_V2

Aft Cargo Door Warning System
Figure 202/52-71-31-990-803 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



A-A



B-B

2899475 S0000692033_V2

Aft Cargo Door Warning System
Figure 202/52-71-31-990-803 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-71-31-400-802

5. Aft Cargo Door Indication Switch - Installation

(Figure 202)

A. General

(1) This task gives the instructions to install the aft cargo door indication switch.

B. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Aft indication switch	52-71-31-02A-067	SIA ALL

C. Location Zones

Zone	Area
822	Aft Cargo Door

D. Aft Cargo Door Indication Switch Installation

SUBTASK 52-71-31-420-002

(1) Install the aft indication switch [1] as follows:

(a) Put the aft indication switch [1] in its correct position through the latch receiver [10].

(b) Install the screws [2] and washers [11] that attach the aft indication switch [1] to the latch receiver [10].

(c) Install the screws [8] and washers [9] that attach the wiring [6] and wiring [12] to the aft indication switch [1].

1) Tighten the screws [8] to 4.5 in-lb (0.51 N·m) - 5 in-lb (0.56 N·m).

2) Remove identification tags from the wiring [6] and wiring [12].

(d) Put the cover [5] in its correct position over the aft indication switch [1].

(e) Install the bolts [3], washers [4], and screws [7] that attach the cover [5] to the fuselage frame.

SUBTASK 52-71-31-820-005

(2) Do this task: Cargo Door Indication Switch - Adjustment, TASK 52-71-31-820-801.

SUBTASK 52-71-31-840-002

(3) Close the aft cargo door.

SUBTASK 52-71-31-730-003

(4) Do this task: Cargo Door Indication Switch - Test, TASK 52-71-31-710-801.

——— END OF TASK ———

TASK 52-71-31-820-801

6. Cargo Door Indication Switch - Adjustment

(Figure 201, Figure 202)

A. General

(1) This task gives the instructions to adjust the each cargo door indication switch.

B. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Prepare for the Adjustment

SUBTASK 52-71-31-010-002

(1) If it is necessary, open the cargo door and attach the strap to the lower stop to hold the door open.

D. Cargo Door Indication Switch Adjustment

SIA 001-005

SUBTASK 52-71-31-820-002

(1) Make sure that the extension of the forward indication switch [1] or aft indication switch [1] through the latch receiver [10] is 0.80 ±0.03 in. (20.32 ±0.76 mm).

SIA 006-999

SUBTASK 52-71-31-820-004

(2) Make sure that the extension of the forward indication switch [1] or aft indication switch [1] through the latch receiver [10] is 0.825 ±0.025 in. (20.96 ±0.64 mm).

SIA ALL

SUBTASK 52-71-31-820-003

(3) If necessary, adjust the forward indication switch [1] or aft indication switch [1] as follows:

(a) Put a screwdriver in the slot of the forward indication switch [1] or aft indication switch [1].

(b) Turn until the extension is correct.

SUBTASK 52-71-31-410-001

(4) If it is open, close the cargo door.

(a) Remove the strap from the lower stop.

——— END OF TASK ———

TASK 52-71-31-710-801

7. Cargo Door Indication Switch - Test

(Figure 201, Figure 202)

NOTE: This procedure is a scheduled maintenance task.

A. General

(1) This task gives the instructions to test the each cargo door indication switch.

B. Location Zones

Zone	Area
211	Flight Compartment - Left
212	Flight Compartment - Right
821	Forward Cargo Door
822	Aft Cargo Door

C. Cargo Door Indication Switch Test

SUBTASK 52-71-31-730-002

(1) Do a test of the forward indication switch [1] or aft indication switch [1] as follows:

(a) Make sure that the applicable cargo door is fully closed, latched and locked.

(b) Make sure that the FWD CARGO or AFT CARGO light does not show on the Forward Overhead Panel, P5, in the flight compartment.

(c) Open the applicable cargo door.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(d) Make sure that the FWD CARGO or AFT CARGO light on the Forward Overhead Panel, P5, comes on for the forward or aft cargo door.

(e) Close the applicable cargo door.

(f) Make sure that the FWD CARGO or AFT CARGO light goes off.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FORWARD ACCESS DOOR WARNING SYSTEM - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks:

(1) Forward access door indication switch removal

(2) Forward access door indication switch installation

(3) Forward access door indication switch test.

B. The forward access door indication switch, S196, is referred to as the indication switch in this procedure.

C. The indication switch is found on the fuselage frame forward of the left side latch fitting. The latch pin on the door pushes a latch pin flap which pushes a plunger to operate the indication switch.

D. The indication switch detects that the door is fully closed, latched and locked.

TASK 52-71-41-000-801

2. Forward Access Door Indication Switch Removal

(Figure 201)

A. General

(1) This task gives the instructions to remove the forward access door indication switch.

B. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

C. Access Panels

Number	Name/Location
112A	Forward Access Door

D. Prepare for the Removal

SUBTASK 52-71-41-010-001

(1) Open this access panel and engage the hold-open lock:

Number	Name/Location
112A	Forward Access Door

E. Forward Access Door Indication Switch Removal

SUBTASK 52-71-41-020-001

(1) Remove the indication switch [1].

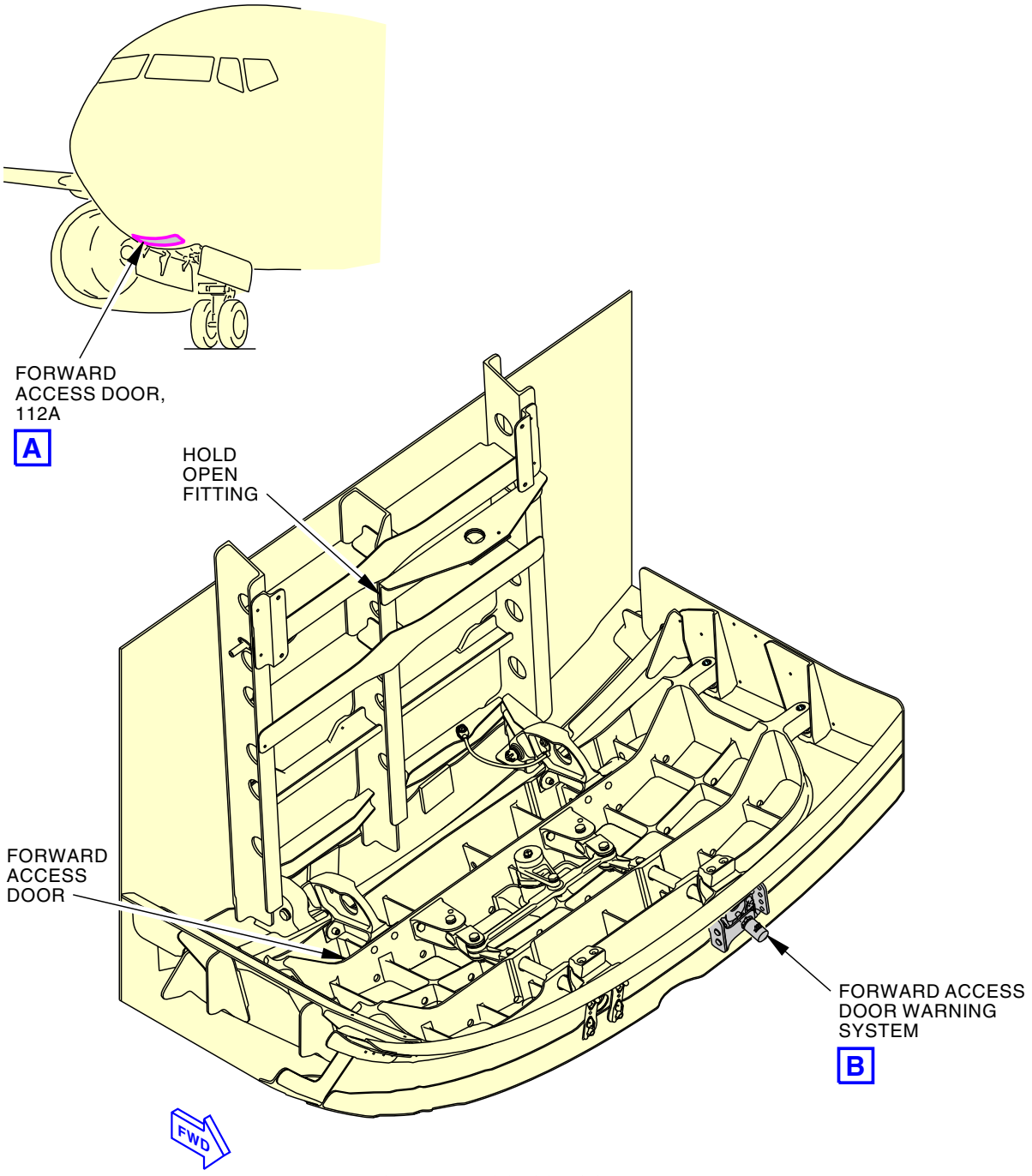
(a) Disconnect/cut the switch wires [10].

(b) Remove the locknut [2], keying washer [3], lock washer [4] from the forward end of the switch plunger.

(c) Remove the indication switch [1] from the bracket [5].

——— END OF TASK ———

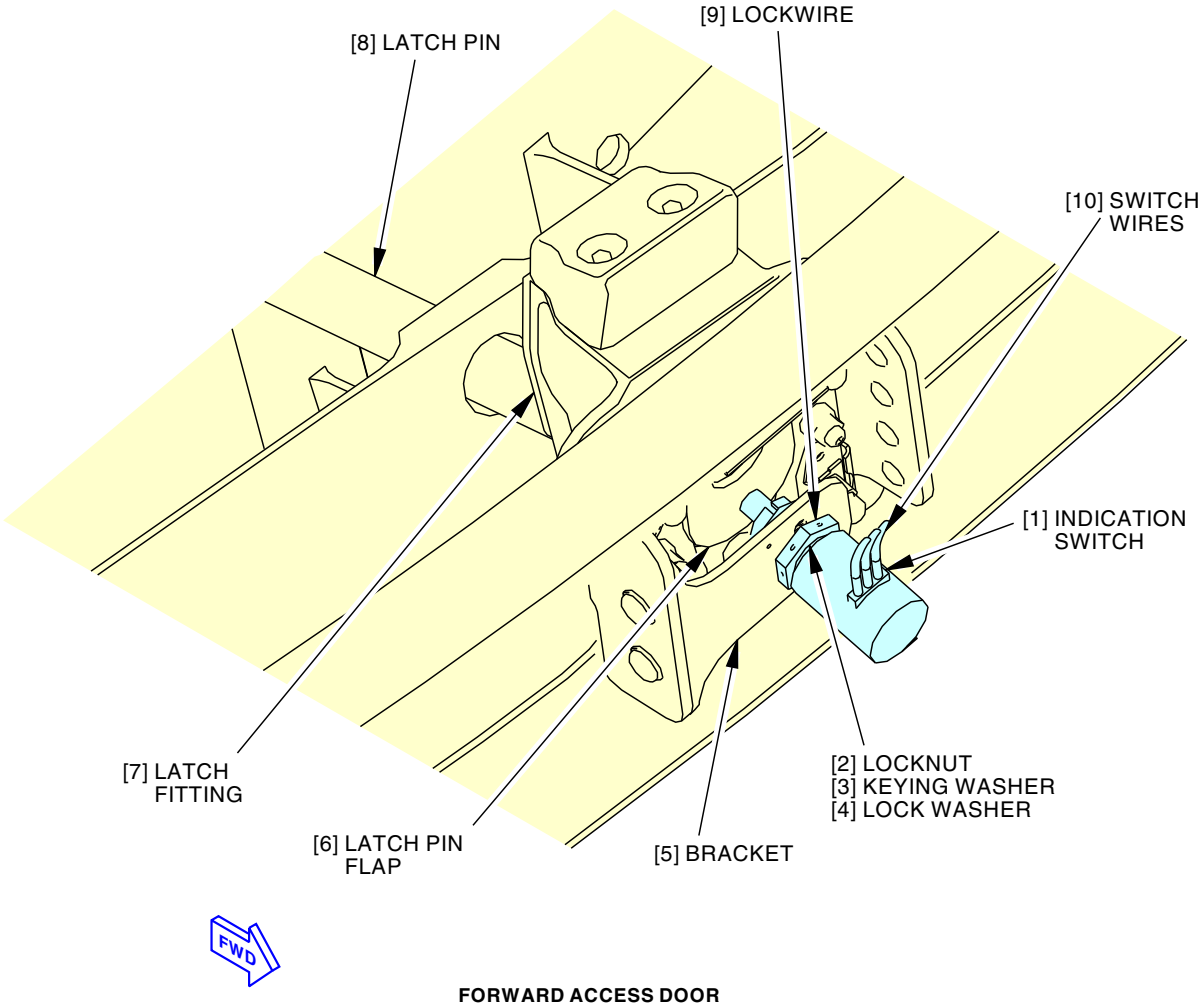
ECCN 9E991 BOEING PROPRIETARY - See title page for details



2415999 S00061539407_V2

Forward Access Door Warning System
Figure 201/52-71-41-990-802 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2416000 S00061539408_V1

Forward Access Door Warning System
Figure 201/52-71-41-990-802 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 52-71-41-400-801

3. Forward Access Door Indication Switch Installation

(Figure 201)

A. General

(1) This task gives the instructions to remove the forward access door indication switch.

B. References

Reference	Title
SWPM 20-30-00	ELECTRICAL CONNECTION OF EQUIPMENT AND INSTALLATION OF TERMINAL LUGS
WDM 52-71	Wiring Diagram Manual

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Indication switch	52-71-41-02-010	SIA ALL

D. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

E. Access Panels

Number	Name/Location
112A	Forward Access Door

F. Forward Access Door Indication Switch Installation

SUBTASK 52-71-41-420-001

(1) Install the indication switch [1].

(a) Install one locknut [2] on the forward end of the indication switch [1] plunger threads.

(b) Put the indication switch [1] plunger through the support bracket [5].

(c) Install the keying washer [3], lock washer [4] and locknut [2] on the forward end of the indication switch [1].

(d) Tighten the locknut [2] to 30 in-lb (3 N·m).

(e) Install the lockwire [9].

(f) Connect the switch wires [10] with the aircraft wiring (WDM 52-71, SWPM 20-30-00).

SUBTASK 52-71-41-860-001

(2) Close this access panel:

Number	Name/Location
112A	Forward Access Door

SUBTASK 52-71-41-730-001

(3) Do this task: Forward Access Door Indication Switch Test, TASK 52-71-41-710-801.

——— END OF TASK ———

TASK 52-71-41-710-801

4. Forward Access Door Indication Switch Test

(Figure 201)

NOTE: This procedure is a scheduled maintenance task.

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A. General

(1) This task gives the instructions to test the forward access door indication switch.

B. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

C. Forward Access Door Indication Switch Test

SUBTASK 52-71-41-730-002

(1) Do a test on the indication switch [1].

(a) Make sure that the forward access door and the electronic equipment access door are fully closed, latched and locked.

(b) Make sure that the EQUIP light does not show on the Forward Overhead Panel, P5, in the flight compartment.

(c) Open the forward access door.

(d) Make sure that the EQUIP light on the Forward Overhead Panel, P5, comes on for the forward access door.

NOTE: If either the forward access door or the electronic equipment access door is not closed, latched and locked the EQUIP light will show.

(e) Close the forward access door.

(f) Make sure that the EQUIP light does not show.

END OF TASK

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ELECTRONIC EQUIPMENT ACCESS DOOR WARNING SYSTEM - MAINTENANCE PRACTICES

1. General

A. This procedure has these tasks:

(1) Electronic equipment access door indication switch removal

(2) Electronic equipment access door indication switch installation

(3) Electronic equipment access door indication switch test.

B. The electronic equipment access door indication switch is referred to as the indication switch in this procedure.

C. The indication switch, S197, is found on the fuselage frame near the latch pin receptacle. The latch pin on the door pushes a hinged striker plate, and the striker plate pushes an actuator to operate the indication switch.

D. The indication switch detects that the door is fully closed, latched and locked.

TASK 52-71-42-000-801

2. Electronic Equipment Access Door Indication Switch Removal

(Figure 201)

A. General

(1) This task gives the instructions to remove the electronic equipment access door indication switch.

B. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

C. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door

D. Prepare for the Removal

SUBTASK 52-71-42-010-001

(1) Fully open this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

SUBTASK 52-71-42-010-002

(2) Remove the panel [2] to get access to the indication switch [12]:

(a) Remove the screws [1] that attach the panel [2] to structure.

(b) Remove the panel [2].

E. Electronic Equipment Access Door Indication Switch Removal

SUBTASK 52-71-42-020-001

(1) Remove the indication switch [12]:

(a) Remove the bolts [15] and washers [16] to disconnect the wiring [11] from the indication switch [12].

(b) Remove the self-locking nuts [13], screws [8] and spacers [10] that attach the indication switch [12] and the actuator [9] to the support bracket [14].

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(c) Remove the indication switch [12] from the actuator [9].

SUBTASK 52-71-42-020-002

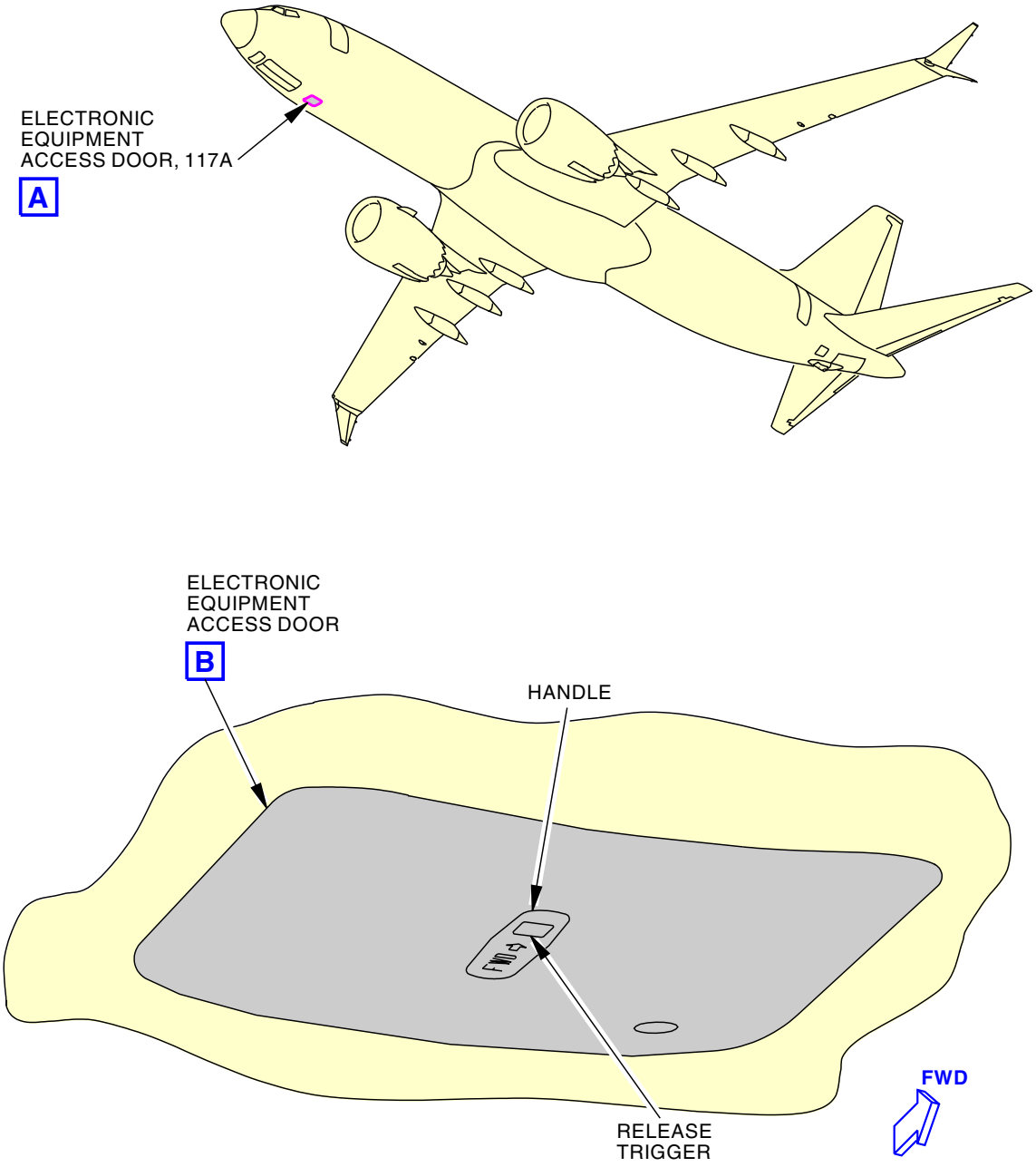
(2) Remove the actuator [9]:

(a) Remove the locknuts [6] and nuts [7] from the actuator [9].

(b) Pull the actuator [9] through the hole in the striker plate bracket [5] to remove it.

——— END OF TASK ———

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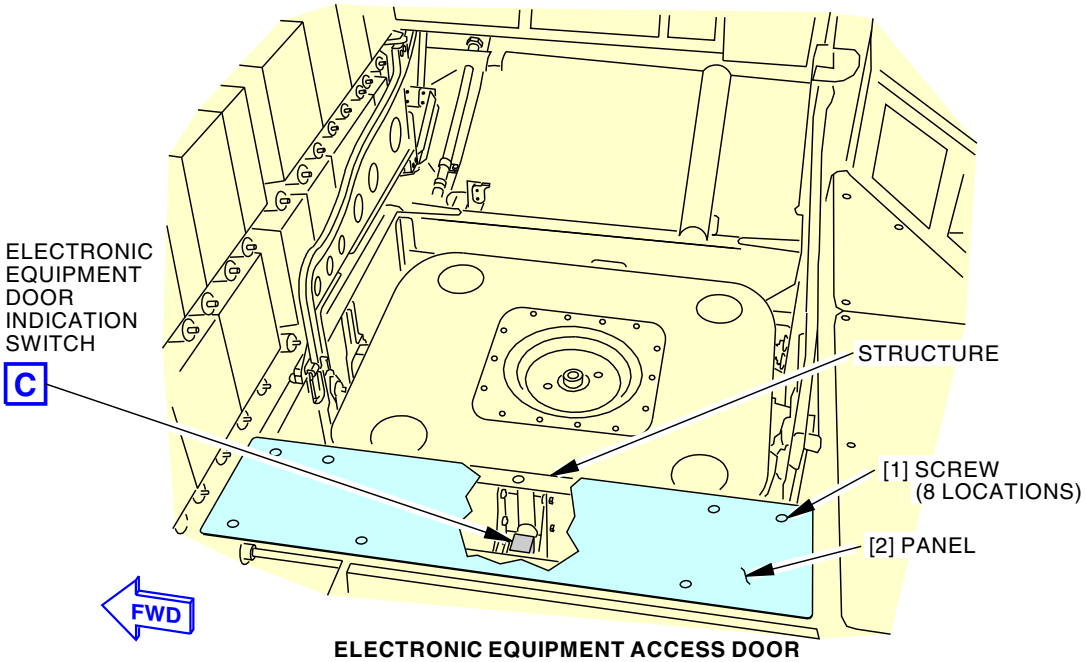
ELECTRONIC EQUIPMENT ACCESS DOOR, 117A

A

2416001 S00061539414_V1

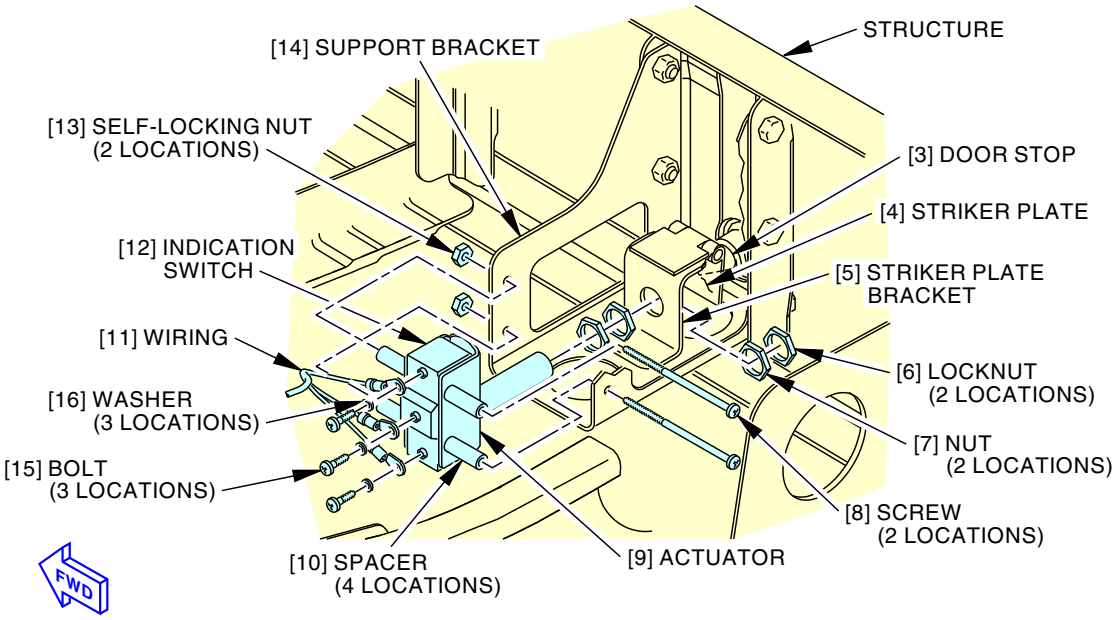
Electronic Equipment Access Door Warning System
Figure 201/52-71-42-990-802 (Sheet 1 of 2)

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ELECTRONIC EQUIPMENT ACCESS DOOR (INTERNAL VIEW, DOOR CLOSED POSITION)

B



ELECTRONIC EQUIPMENT DOOR INDICATION SWITCH

C

2416002 S00061539415_V1

Electronic Equipment Access Door Warning System
Figure 201/52-71-42-990-802 (Sheet 2 of 2)

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TASK 52-71-42-400-801

3. Electronic Equipment Access Door Indication Switch Installation

(Figure 201)

A. General

(1) This task gives the instructions to install the electronic equipment access door indication switch.

B. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
12	Indication switch	52-71-42-01A-040	SIA ALL

C. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

D. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door

E. Electronic Equipment Access Door Indication Switch Installation

SUBTASK 52-71-42-420-001

(1) Install the actuator [9]:

(a) Install the locknuts [6] and nuts [7] on the actuator [9].

(b) Put the actuator [9] through the hole in the striker plate bracket [5].

(c) Loosely install the locknuts [6] and nuts [7] on the actuator [9] closest to the electronic equipment access door.

SUBTASK 52-71-42-420-002

(2) Install the indication switch [12]:

(a) Put the indication switch [12] into the actuator [9].

(b) Install the self-locking nuts [13], screws [8] and spacers [10] that attach the indication switch [12] and the actuator [9] to the support bracket [14].

(c) Install the bolts [15] and washers [16] to connect the wiring [11] from the indication switch [12].

(d) Tighten the nuts [7] and the locknuts [6] on the striker plate bracket [5].

SUBTASK 52-71-42-710-001

(3) Do this task: Electronic Equipment Access Door Indication Switch Test, TASK 52-71-42-710-801.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 52-71-42-410-001

(1) Install the panel [2]:

(a) Put the panel [2] on the structure over the indication switch [12].

(b) Install the screws [1] that attach the panel [2] to the structure.

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SUBTASK 52-71-42-410-002

(2) Close this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

——— END OF TASK ———

TASK 52-71-42-710-801

4. Electronic Equipment Access Door Indication Switch Test

(Figure 201)

NOTE: This procedure is a scheduled maintenance task.

A. General

(1) This task gives the instructions to test the equipment access door indication switch.

B. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

C. Electronic Equipment Access Door Indication Switch Test

SUBTASK 52-71-42-860-002

(1) Make sure that the forward access door and the electronic equipment access door are fully closed, latched and locked.

SUBTASK 52-71-42-210-001

(2) Make sure that the EQUIP light does not show on the Forward Overhead Panel, P5, in the flight compartment.

SUBTASK 52-71-42-710-002

(3) Do a test on the indication switch [12]:

(a) Open the electronic equipment access door.

(b) Make sure that the EQUIP light shows on the Forward Overhead Panel, P5.

NOTE: If the forward access door or electronic equipment access door is not closed, latched and locked, the EQUIP light will show.

(c) Close the electronic equipment access door.

(d) Make sure that the EQUIP light on the Forward Overhead Panel, P5, does not show.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details