

CHAPTER

53

FUSELAGE



**737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 53
FUSELAGE**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
53-EFFECTIVE PAGES			53-00-00			53-05-02 (cont)		
1 thru 7	Sep 15/2023		201	Sep 15/2021		232	Jan 15/2023	
8	BLANK		202	Sep 15/2021		233	Jan 15/2023	
53-CONTENTS			53-00-37			234	Jan 15/2023	
1	Jan 15/2023		201	Sep 15/2021		235	Jan 15/2023	
2	Jan 15/2023		202	BLANK		236	Jan 15/2023	
3	Jan 15/2023		53-05-02			237	Jan 15/2023	
4	Jan 15/2023		201	Jan 15/2023		238	Jan 15/2023	
5	Jan 15/2023		202	Jan 15/2023		239	Jan 15/2023	
6	Jan 15/2023		203	Jan 15/2023		240	Jan 15/2023	
7	Jan 15/2023		204	Jan 15/2023		241	Jan 15/2023	
8	Jan 15/2023		205	Jan 15/2023		242	Jan 15/2023	
9	Jan 15/2023		206	Jan 15/2023		243	Jan 15/2023	
10	Jan 15/2023		207	Jan 15/2023		244	Jan 15/2023	
11	Jan 15/2023		208	Jan 15/2023		245	Jan 15/2023	
12	Jan 15/2023		209	Jan 15/2023		246	Jan 15/2023	
13	Jan 15/2023		210	Jan 15/2023		247	Jan 15/2023	
14	Jan 15/2023		211	Jan 15/2023		248	Jan 15/2023	
15	Jan 15/2023		212	Jan 15/2023		249	Jan 15/2023	
16	Jan 15/2023		213	Jan 15/2023		250	Jan 15/2023	
17	Jan 15/2023		214	Jan 15/2023		251	Jan 15/2023	
18	Jan 15/2023		215	May 15/2023		252	Jan 15/2023	
19	Jan 15/2023		216	Jan 15/2023		253	Jan 15/2023	
20	Jan 15/2023		217	Jan 15/2023		254	Jan 15/2023	
21	Jan 15/2023		218	Jan 15/2023		255	Jan 15/2023	
22	Jan 15/2023		219	Jan 15/2023		256	Jan 15/2023	
23	Jan 15/2023		220	Jan 15/2023		257	Jan 15/2023	
24	May 15/2023		221	Jan 15/2023		258	Jan 15/2023	
25	Jan 15/2023		222	Jan 15/2023		259	Jan 15/2023	
26	Jan 15/2023		223	Jan 15/2023		260	Jan 15/2023	
O 27	Sep 15/2023		224	Jan 15/2023		261	Jan 15/2023	
28	Jan 15/2023		225	Jan 15/2023		262	Jan 15/2023	
O 29	Sep 15/2023		226	Jan 15/2023		263	Jan 15/2023	
O 30	Sep 15/2023		227	Jan 15/2023		264	Jan 15/2023	
31	Jan 15/2023		228	Jan 15/2023		265	Jan 15/2023	
32	BLANK		229	May 15/2023		266	Jan 15/2023	
			230	Jan 15/2023		267	Jan 15/2023	
			231	Jan 15/2023				

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

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53-05-02 (cont)			53-05-02 (cont)			53-05-03 (cont)		
268	Jan 15/2023		298.6	Jan 15/2023		235	Sep 15/2021	
269	Jan 15/2023		53-05-03			236	Sep 15/2021	
270	Jan 15/2023		201	Sep 15/2021		237	Sep 15/2021	
271	Jan 15/2023		202	Sep 15/2021		238	Sep 15/2021	
272	Jan 15/2023		R 203	Sep 15/2023		239	Sep 15/2021	
273	Jan 15/2023		204	Sep 15/2021		240	Sep 15/2021	
274	Jan 15/2023		205	Sep 15/2021		241	Sep 15/2021	
275	Jan 15/2023		206	Sep 15/2021		242	Sep 15/2021	
276	Jan 15/2023		207	Sep 15/2021		243	Sep 15/2021	
277	Jan 15/2023		208	Sep 15/2021		244	Sep 15/2021	
278	May 15/2023		209	Sep 15/2021		245	Sep 15/2021	
279	Jan 15/2023		210	Sep 15/2021		246	Sep 15/2021	
280	Jan 15/2023		211	Sep 15/2021		247	Sep 15/2021	
281	Jan 15/2023		212	Sep 15/2021		248	Sep 15/2021	
282	Jan 15/2023		213	Sep 15/2021		249	Sep 15/2021	
283	Jan 15/2023		214	Sep 15/2021		250	Sep 15/2021	
284	Jan 15/2023		215	Sep 15/2021		251	Sep 15/2021	
285	Jan 15/2023		216	Sep 15/2021		252	Sep 15/2021	
286	Jan 15/2023		217	Sep 15/2021		253	Sep 15/2021	
287	Jan 15/2023		218	Sep 15/2021		254	Sep 15/2021	
288	Jan 15/2023		219	Sep 15/2021		255	Sep 15/2021	
289	Jan 15/2023		220	Sep 15/2021		256	Sep 15/2021	
290	Jan 15/2023		221	Sep 15/2021		257	Sep 15/2021	
291	Jan 15/2023		222	Sep 15/2021		258	Sep 15/2021	
292	Jan 15/2023		223	Sep 15/2021		259	Sep 15/2021	
293	Jan 15/2023		224	Sep 15/2021		260	Sep 15/2021	
294	Jan 15/2023		225	Sep 15/2021		261	Sep 15/2021	
295	Jan 15/2023		226	Sep 15/2021		262	May 15/2023	
296	Jan 15/2023		227	Sep 15/2021		263	Sep 15/2021	
297	Jan 15/2023		228	Sep 15/2022		264	Sep 15/2021	
298	Jan 15/2023		229	Sep 15/2022		265	Sep 15/2021	
298.1	Jan 15/2023		230	Sep 15/2021		266	Sep 15/2021	
298.2	May 15/2023		231	Sep 15/2021		267	Sep 15/2021	
298.3	Jan 15/2023		232	Sep 15/2021		268	Sep 15/2021	
298.4	Jan 15/2023		233	Sep 15/2021		269	Sep 15/2021	
298.5	Jan 15/2023		234	Sep 15/2021		270	Sep 15/2021	

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53-05-03 (cont)			53-05-03 (cont)			53-05-03 (cont)		
271	Jan 15/2023		298.9	May 15/2022		298.45	May 15/2022	
272	Jan 15/2023		298.10	Jan 15/2023		298.46	May 15/2022	
273	Sep 15/2021		298.11	May 15/2022		298.47	May 15/2022	
274	Sep 15/2021		298.12	May 15/2022		298.48	Jan 15/2023	
275	Sep 15/2021		298.13	Jan 15/2023		298.49	May 15/2022	
276	Sep 15/2021		298.14	May 15/2022		298.50	May 15/2022	
277	Sep 15/2021		298.15	May 15/2022		298.51	May 15/2022	
278	Sep 15/2021		298.16	May 15/2022		298.52	May 15/2022	
279	Sep 15/2021		298.17	May 15/2022		298.53	Jan 15/2023	
280	Sep 15/2021		298.18	May 15/2022		298.54	May 15/2022	
281	Sep 15/2021		298.19	May 15/2022		298.55	May 15/2022	
282	Sep 15/2021		298.20	May 15/2022		298.56	May 15/2022	
283	Sep 15/2021		298.21	May 15/2022		298.57	Jan 15/2023	
284	Sep 15/2021		298.22	May 15/2022		298.58	May 15/2022	
285	Sep 15/2021		298.23	May 15/2022		298.59	May 15/2022	
286	May 15/2022		298.24	May 15/2022		298.60	May 15/2022	
287	May 15/2022		298.25	May 15/2022		298.61	May 15/2022	
288	May 15/2022		298.26	May 15/2022		298.62	May 15/2022	
289	May 15/2022		298.27	May 15/2022		298.63	May 15/2022	
290	May 15/2022		298.28	May 15/2022		298.64	May 15/2022	
R 291	Sep 15/2023		298.29	May 15/2022		298.65	May 15/2022	
R 292	Sep 15/2023		298.30	May 15/2022		298.66	May 15/2022	
293	May 15/2022		298.31	May 15/2022		298.67	May 15/2022	
294	May 15/2022		298.32	May 15/2022		298.68	May 15/2022	
R 295	Sep 15/2023		298.33	May 15/2022		298.69	May 15/2022	
296	May 15/2022		298.34	May 15/2022		298.70	May 15/2022	
297	May 15/2022		298.35	May 15/2022		298.71	May 15/2022	
298	May 15/2022		298.36	May 15/2022		298.72	May 15/2022	
298.1	May 15/2022		298.37	May 15/2022		298.73	May 15/2022	
298.2	May 15/2022		298.38	May 15/2022		298.74	May 15/2022	
298.3	May 15/2022		298.39	May 15/2022		298.75	May 15/2022	
298.4	May 15/2022		298.40	May 15/2022		298.76	May 15/2022	
298.5	May 15/2022		298.41	May 15/2022		298.77	May 15/2022	
298.6	May 15/2022		298.42	Jan 15/2023		298.78	May 15/2022	
298.7	May 15/2022		298.43	May 15/2022		298.79	May 15/2023	
298.8	May 15/2022		298.44	May 15/2022		298.80	May 15/2022	

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53-05-03 (cont)			53-11-00 (cont)			53-11-01 (cont)		
298.81	May 15/2023		218	Sep 15/2021		411	Jan 15/2023	
298.82	May 15/2023		219	Sep 15/2021		412	BLANK	
298.83	May 15/2023		220	Sep 15/2021		53-11-02		
298.84	May 15/2023		221	Sep 15/2021		401	Sep 15/2021	
298.85	May 15/2023		222	Sep 15/2021		402	Sep 15/2021	
298.86	May 15/2023		223	Sep 15/2021		403	Sep 15/2021	
298.87	May 15/2023		224	Sep 15/2021		404	Sep 15/2021	
298.88	May 15/2023		225	Sep 15/2021		405	Sep 15/2021	
298.89	May 15/2023		226	Sep 15/2021		406	Sep 15/2021	
298.90	May 15/2023		227	Sep 15/2021		407	Sep 15/2021	
298.91	May 15/2022		228	Sep 15/2021		408	Sep 15/2021	
298.92	May 15/2022		229	Sep 15/2021		409	Sep 15/2021	
298.93	May 15/2022		230	Sep 15/2021		410	Sep 15/2021	
298.94	May 15/2022		231	Sep 15/2021		411	Sep 15/2021	
298.95	May 15/2022		232	Sep 15/2021		412	BLANK	
298.96	May 15/2022		233	Sep 15/2021		53-14-01		
298.97	May 15/2022		234	Sep 15/2021		401	Sep 15/2021	
298.98	May 15/2022		235	Sep 15/2021		402	Sep 15/2021	
53-11-00			236	Sep 15/2021		403	Sep 15/2021	
201	Sep 15/2021		237	Sep 15/2021		404	Sep 15/2021	
202	Sep 15/2021		238	Sep 15/2021		405	Sep 15/2021	
203	Sep 15/2021		239	Sep 15/2021		406	Sep 15/2021	
204	Sep 15/2021		240	Sep 15/2021		407	Sep 15/2021	
205	Sep 15/2021		241	Sep 15/2021		408	Sep 15/2021	
206	Sep 15/2021		242	BLANK		409	Sep 15/2021	
207	Sep 15/2021		53-11-01			410	Sep 15/2021	
208	Sep 15/2021		401	Jan 15/2023		411	Sep 15/2021	
209	Sep 15/2021		402	Sep 15/2021		412	BLANK	
210	Sep 15/2021		403	Sep 15/2021		53-21-00		
211	Sep 15/2021		404	Sep 15/2021		401	Jan 15/2023	
212	Sep 15/2021		405	Sep 15/2021		402	Jan 15/2023	
213	Sep 15/2021		406	Sep 15/2021		403	Jan 15/2023	
214	Sep 15/2021		407	Sep 15/2021		R 404	Sep 15/2023	
215	Sep 15/2021		408	Jan 15/2023		405	Sep 15/2021	
216	Sep 15/2021		409	Jan 15/2023		406	Sep 15/2021	
217	Sep 15/2021		410	Jan 15/2023		407	Sep 15/2021	
						408	Sep 15/2021	

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53-21-00 (cont)			53-31-01 (cont)			53-42-11		
409	Jan 15/2023		804	BLANK		701	Sep 15/2021	
410	Jan 15/2023		53-31-02			702	Sep 15/2021	
411	Jan 15/2023		601	Sep 15/2022		53-51-00		
412	Jan 15/2023		602	Jan 15/2022		201	Sep 15/2021	
413	Jan 15/2023		603	Jan 15/2022		202	Sep 15/2021	
414	Jan 15/2023		604	Jan 15/2022		203	Sep 15/2021	
53-21-00			605	Jan 15/2022		204	BLANK	
801	Sep 15/2021		606	BLANK		53-51-02		
802	Sep 15/2021		53-31-03			801	Sep 15/2021	
803	Sep 15/2021		401	Sep 15/2022		802	Sep 15/2021	
804	Sep 15/2021		402	Sep 15/2021		803	Sep 15/2021	
805	Sep 15/2021		403	Sep 15/2022		804	BLANK	
806	Sep 15/2021		404	Sep 15/2022		53-51-11		
807	Sep 15/2021		53-31-11			401	Sep 15/2021	
808	Sep 15/2021		401	May 15/2023		402	Sep 15/2021	
809	Sep 15/2021		402	Sep 15/2021		53-51-21		
810	Sep 15/2021		403	Sep 15/2021		401	Jan 15/2023	
811	Sep 15/2021		404	Sep 15/2021		402	Jan 15/2023	
812	Sep 15/2021		405	Sep 15/2021		403	Jan 15/2023	
813	Sep 15/2021		406	BLANK		404	Sep 15/2021	
814	Sep 15/2021		53-31-31			405	Sep 15/2021	
53-21-11			R 401	Sep 15/2023		406	Sep 15/2021	
801	Sep 15/2021		O 402	Sep 15/2023		407	Sep 15/2021	
802	Sep 15/2022		O 403	Sep 15/2023		408	Sep 15/2021	
803	Sep 15/2021		O 404	Sep 15/2023		409	Sep 15/2021	
804	BLANK		O 405	Sep 15/2023		410	Sep 15/2021	
53-31-01			O 406	Sep 15/2023		411	Sep 15/2021	
601	Jan 15/2023		R 407	Sep 15/2023		R 412	Sep 15/2023	
602	Jan 15/2023		R 408	Sep 15/2023		R 413	Sep 15/2023	
603	Sep 15/2021		R 409	Sep 15/2023		414	Jan 15/2023	
604	Sep 15/2022		R 410	Sep 15/2023		415	Jan 15/2023	
605	Sep 15/2021		R 411	Sep 15/2023		416	Jan 15/2023	
606	Sep 15/2021		R 412	Sep 15/2023		417	Jan 15/2023	
53-31-01			A 413	Sep 15/2023		418	Jan 15/2023	
801	May 15/2023		A 414	BLANK		419	Jan 15/2023	
802	Sep 15/2022					420	Jan 15/2023	
803	Jan 15/2022					421	Jan 15/2023	

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53-51-21 (cont)			53-51-21 (cont)			53-52-00		
422	Sep 15/2021		458	May 15/2022		R 701	Sep 15/2023	
423	Sep 15/2021		459	May 15/2022		R 702	Sep 15/2023	
424	Sep 15/2021		460	BLANK		R 703	Sep 15/2023	
425	Sep 15/2021		53-51-21			R 704	Sep 15/2023	
R 426	Sep 15/2023		601	Sep 15/2021		R 705	Sep 15/2023	
R 427	Sep 15/2023		602	Sep 15/2022		R 706	Sep 15/2023	
O 428	Sep 15/2023		603	Sep 15/2021		R 707	Sep 15/2023	
R 429	Sep 15/2023		604	Sep 15/2021		R 708	Sep 15/2023	
430	May 15/2022		605	Sep 15/2021		R 709	Sep 15/2023	
431	Sep 15/2022		606	Sep 15/2022		R 710	Sep 15/2023	
432	Jan 15/2023		607	Sep 15/2021		R 711	Sep 15/2023	
433	Sep 15/2022		608	BLANK		R 712	Sep 15/2023	
434	May 15/2023		53-52-00			O 713	Sep 15/2023	
435	Jan 15/2023		201	Sep 15/2021		O 714	Sep 15/2023	
436	Jan 15/2023		202	Sep 15/2021		O 715	Sep 15/2023	
437	May 15/2022		203	Sep 15/2021		O 716	Sep 15/2023	
438	May 15/2022		204	Sep 15/2021		D 717	Sep 15/2023	
R 439	Sep 15/2023		205	Sep 15/2021		D 718	Sep 15/2023	
R 440	Sep 15/2023		206	Sep 15/2021		D 719	Sep 15/2023	
R 441	Sep 15/2023		53-52-00			D 720	Sep 15/2023	
442	Sep 15/2022		401	Jan 15/2023		D 721	Sep 15/2023	
443	Jan 15/2023		402	Jan 15/2023		D 722	Sep 15/2023	
444	May 15/2022		403	Sep 15/2021		53-52-03		
445	May 15/2022		404	Sep 15/2021		R 201	Sep 15/2023	
446	Sep 15/2022		405	May 15/2022		R 202	Sep 15/2023	
447	May 15/2022		406	May 15/2023		R 203	Sep 15/2023	
448	May 15/2022		407	May 15/2023		R 204	Sep 15/2023	
449	May 15/2022		408	Jan 15/2023		R 205	Sep 15/2023	
450	May 15/2022		409	Jan 15/2023		R 206	Sep 15/2023	
451	May 15/2022		410	May 15/2022		A 207	Sep 15/2023	
452	May 15/2022		53-52-00			A 208	Sep 15/2023	
R 453	Sep 15/2023		R 601	Sep 15/2023		53-52-03		
R 454	Sep 15/2023		602	May 15/2023		801	Sep 15/2022	
R 455	Sep 15/2023		603	Jan 15/2023		802	Sep 15/2021	
456	May 15/2022		R 604	Sep 15/2023		53-52-31		
457	May 15/2022					401	Sep 15/2021	
						402	Sep 15/2021	

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53-52-31 (cont)			53-54-00					
403	Sep 15/2021		601	Sep 15/2021				
404	May 15/2022		602	Sep 15/2021				
405	Sep 15/2021		603	Sep 15/2021				
406	BLANK		604	Sep 15/2021				
53-53-00			605	Sep 15/2021				
R 401	Sep 15/2023		606	BLANK				
R 402	Sep 15/2023		53-54-00					
R 403	Sep 15/2023		801	Sep 15/2021				
R 404	Sep 15/2023		802	Sep 15/2022				
O 405	Sep 15/2023		803	Sep 15/2021				
O 406	Sep 15/2023		804	Sep 15/2021				
O 407	Sep 15/2023		805	Sep 15/2021				
O 408	Sep 15/2023		806	Sep 15/2022				
O 409	Sep 15/2023		807	Sep 15/2021				
O 410	Sep 15/2023		808	Sep 15/2021				
R 411	Sep 15/2023		809	Sep 15/2022				
O 412	Sep 15/2023		810	Jan 15/2022				
R 413	Sep 15/2023		811	Jan 15/2022				
R 414	Sep 15/2023		812	BLANK				
53-54-00								
401	Sep 15/2021							
402	Sep 15/2021							
403	Sep 15/2021							
404	Sep 15/2021							
405	Sep 15/2021							
406	May 15/2023							
407	Sep 15/2021							
408	Sep 15/2021							
409	Sep 15/2021							
410	Sep 15/2021							
411	Sep 15/2021							
412	Sep 15/2021							
413	Sep 15/2021							
414	Sep 15/2021							
415	Sep 15/2021							
416	Sep 15/2021							

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<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>FUSELAGE - MAINTENANCE PRACTICES</u>	53-00-00		201	SIA ALL
Airworthiness Limitation Precautions TASK 53-00-00-912-801			201	SIA ALL
<u>FUSELAGE - CORROSION PREVENTION</u>	53-00-37		201	SIA ALL
<u>FUSELAGE FATIGUE INSPECTIONS - MAINTENANCE PRACTICES</u>	53-05-02		201	SIA ALL
INTERNAL - SPECIAL DETAILED: Wheel Well Aft Bulkhead and Pressure Web STA 727 TASK 53-05-02-250-843			201	SIA ALL
INTERNAL - SPECIAL DETAILED: Overwing Frames and Stub Beams TASK 53-05-02-270-804			201	SIA ALL
INTERNAL - SPECIAL DETAILED: Overwing Frames and Stub Beams TASK 53-05-02-270-805			202	SIA ALL
INTERNAL - SPECIAL DETAILED: Aft Pressure Bulkhead, STA 1016 TASK 53-05-02-250-915			203	SIA ALL
INTERNAL - SPECIAL DETAILED: Aft Pressure Bulkhead, STA 1016 TASK 53-05-02-250-916			203	SIA ALL
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INTERNAL - SPECIAL DETAILED: Aft Pressure Bulkhead, STA 1016 TASK 53-05-02-250-919			204	SIA ALL
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INTERNAL - DETAILED: Overwing Frames and Stub Beams TASK 53-05-02-211-870			213	SIA ALL
INTERNAL - DETAILED: Wheel Well Frame, STA 685 TASK 53-05-02-211-871			213	SIA ALL
INTERNAL - SPECIAL DETAILED: Wheel Well Frame, STA 685 TASK 53-05-02-250-937			214	SIA ALL
INTERNAL - SPECIAL DETAILED: Wheel Well Frame, STA 685 TASK 53-05-02-250-938			214	SIA ALL
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INTERNAL - SPECIAL DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure TASK 53-05-02-250-939			215	SIA ALL
EXTERNAL - SPECIAL DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure TASK 53-05-02-250-940			216	SIA ALL
INTERNAL - DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure TASK 53-05-02-211-872			216	SIA ALL
INTERNAL - SPECIAL DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure TASK 53-05-02-270-807			217	SIA ALL
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INTERNAL - SPECIAL DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure TASK 53-05-02-250-943			219	SIA ALL
INTERNAL - SPECIAL DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure TASK 53-05-02-250-944			220	SIA ALL
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INTERNAL - DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure, STA 601 to STA 616 TASK 53-05-02-211-873			221	SIA ALL
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EXTERNAL - DETAILED: Crown Skin Panel - STA 727 to 887 TASK 53-05-02-211-877			223	SIA ALL
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INTERNAL - GENERAL VISUAL: Side Skin Panel - STA 727 to 887 TASK 53-05-02-210-810			225	SIA ALL
INTERNAL - DETAILED: Side Skin Panel - STA 727 to 887 TASK 53-05-02-211-881			226	SIA ALL
INTERNAL - GENERAL VISUAL: Side Skin Panel - STA 727 to 887 TASK 53-05-02-210-811			226	SIA ALL
INTERNAL - DETAILED: Side Skin Panel - STA 727 to 887 TASK 53-05-02-211-882			226	SIA ALL
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EXTERNAL - DETAILED: Longitudinal Lap Skin Splice, STA 727 to 887 TASK 53-05-02-211-886			229	SIA ALL
EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice, STA 727 to 887 TASK 53-05-02-250-951			230	SIA ALL
EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice, STA 727 to 887 TASK 53-05-02-250-952			230	SIA ALL
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INTERNAL - SPECIAL DETAILED: Cutout - Aft Cargo Door, Backup Surround Structure TASK 53-05-02-250-960			235	SIA ALL
INTERNAL - SPECIAL DETAILED: Cutout - Aft Cargo Door, Backup Surround Structure TASK 53-05-02-250-961			236	SIA ALL
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EXTERNAL - SPECIAL DETAILED: Wheel Well Aft Bulkhead and Pressure Web, STA 727 TASK 53-05-02-250-976			248	SIA ALL
INTERNAL - SPECIAL DETAILED: Wheel Well Aft Bulkhead and Pressure Web, STA 727 TASK 53-05-02-270-812			248	SIA ALL
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INTERNAL - SPECIAL DETAILED: Main Landing Gear Support Frame, STA 716 TASK 53-05-02-250-980			250	SIA ALL
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EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice TASK 53-05-02-250-985			253	SIA ALL
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INTERNAL - SPECIAL DETAILED: Cutout - Forward Entry Door, Backup Surround Structure TASK 53-05-02-250-999			263	SIA ALL
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INTERNAL - SPECIAL DETAILED: Nose Wheel Well Side and Top Panels TASK 53-05-02-250-A03			264	SIA ALL
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INTERNAL - SPECIAL DETAILED: Crown Skin Panel - STA 360 to 540 TASK 53-05-02-250-A07			270	SIA ALL
INTERNAL - DETAILED: Crown Skin Panel - STA 360 to 540 TASK 53-05-02-211-904			270	SIA ALL
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EXTERNAL - DETAILED: Side Skin Panel - STA 360 to 540 TASK 53-05-02-211-905			271	SIA ALL
EXTERNAL - SPECIAL DETAILED: Side Skin Panel - STA 360 to 540 TASK 53-05-02-270-815			272	SIA ALL
EXTERNAL - GENERAL VISUAL: Side Skin Panel - STA 360 to 540 TASK 53-05-02-210-820			273	SIA ALL
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INTERNAL - DETAILED: Side Skin Panel - STA 360 to 540 TASK 53-05-02-211-907			274	SIA ALL
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EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice TASK 53-05-02-250-A11			277	SIA ALL
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EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice TASK 53-05-02-250-A19			280	SIA ALL
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<u>NOSE RADOME - CLEANING/PAINTING</u>	53-52-00		701	SIA ALL
Nose Radome Cleaning and Painting TASK 53-52-00-370-801			701	SIA ALL
<u>LIGHTNING DIVERTER STRIPS - MAINTENANCE PRACTICES</u>	53-52-03		201	SIA ALL
Remove the Lightning Diverter Strips TASK 53-52-03-000-801			201	SIA ALL
Install the Lightning Diverter Strip TASK 53-52-03-400-801			206	SIA ALL
Lightning Diverter Strips - Test TASK 53-52-03-820-801			207	SIA ALL
<u>LIGHTNING DIVERTER STRIPS - REPAIRS</u>	53-52-03		801	SIA ALL
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Radome Exterior Coating Repair
TASK 53-54-00-300-808

809

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FUSELAGE - MAINTENANCE PRACTICES

1. General

- A. This procedure has this task:
- (1) Airworthiness Limitation Precautions.

TASK 53-00-00-912-801

2. Airworthiness Limitation Precautions

A. General

- (1) Critical Design Configuration Control Limitations (CDCCLs)
 - (a) All occurrences of CDCCLs found in this chapter of the AMM are identified by this note after each applicable CDCCL design feature:

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).
 - (b) Design features that are CDCCLs are defined and controlled by Special Federal Aviation Regulation (SFAR) 88, and can be found in the Special Compliance Items/Airworthiness Limitations document. CDCCLs are a means of identifying certain design configuration features intended to preclude a fuel tank ignition source for the operational life of the airplane. CDCCLs are mandatory and cannot be changed or deleted without the approval of the FAA office that is responsible for the airplane model Type Certificate, or applicable regulatory agency. A critical fuel tank ignition source prevention feature may exist in the fuel system and its related installation or in systems that, if a failure condition were to develop, could interact with the fuel system in such a way that an unsafe condition would develop without this limitation. Strict adherence to configuration, methods, techniques, and practices as prescribed is required to ensure the CDCCL is complied with. Any use of parts, methods, techniques or practices not contained in the applicable CDCCL must be approved by the FAA office that is responsible for the airplane model Type Certificate, or applicable regulatory agency.
- (2) Airworthiness Limitation Instructions (ALIs)
 - (a) All occurrences of fuel tank system ALIs found in this chapter of the AMM are identified by this note after each applicable ALI inspection feature:

NOTE: ALI - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on airworthiness limitation instructions (ALIs).
 - (b) Inspection features that are ALIs are defined and controlled by Special Federal Aviation Regulation (SFAR) 88, and can be found in the Special Compliance Items/Airworthiness Limitations document. These ALIs identify inspection features related to fuel tank ignition source prevention which must be done to maintain the design level of safety for the operational life of the airplane. These inspection features are mandatory and cannot be changed or deleted without the approval of the FAA office that is responsible for the airplane model Type Certificate, or applicable regulatory agency. Strict adherence to methods, techniques and practices as prescribed is required to ensure the ALI is complied with. Any use of methods, techniques or practices not contained in these ALIs must be approved by the FAA office that is responsible for the airplane model Type Certificate, or applicable regulatory agency.

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B. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage
500	Left Wing
600	Right Wing

C. Critical Design Configuration Control Limitations (CDCCLs)

SUBTASK 53-00-00-910-001



OBEY THE MANUFACTURER'S PROCEDURES WHEN YOU DO MAINTENANCE THAT HAS AN EFFECT ON A CDCCL. IF YOU DO NOT OBEY THE PROCEDURES, IT CAN INCREASE THE RISK OF A SOURCE OF FUEL TANK IGNITION. INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT CAN OCCUR IF THERE IS A FIRE OR EXPLOSION.

- (1) Make sure you follow the procedures for items identified as CDCCLs.

D. Airworthiness Limitation Instructions (ALIs)

SUBTASK 53-00-00-910-002



OBEY THE MANUFACTURER'S PROCEDURES WHEN YOU DO MAINTENANCE THAT HAS AN EFFECT ON AN ALI. IF YOU DO NOT OBEY THE PROCEDURES, IT CAN INCREASE THE RISK OF A SOURCE OF FUEL TANK IGNITION. INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT CAN OCCUR IF THERE IS A FIRE OR EXPLOSION.

- (1) Make sure you follow the procedures for items identified as ALIs.

————— **END OF TASK** —————

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FUSELAGE - CORROSION PREVENTION

1. General

Refer to the applicable section in the Table 201 for corrosion prevention instructions for the different areas of the fuselage.

Table 201/53-00-37-993-801 Specific Corrosion Problems - Fuselage

AREA	PROBLEM	INDEX
Crown Frames, Stringers and Skin	Corrosion of frames, stringers and interior skin surfaces.	53-11-37
Lower Lobe Structure	Corrosion of frames, stringers and interior skin surfaces.	53-11-37
	Corrosion of lower lobe doublers and lower lobe skins between BS 360 to 540 and BS 727 to 1016.	
Galleys and Lavatories	Corrosion of structure under galleys and lavatories due to spillage.	53-11-37
	Corrosion of partition support on cabin floor between BS 1006 and 1030 because of soaked foam dams.	53-11-37
Main Wheel Well and Keel Beam	Corrosion on surfaces inside wheel well because of air contaminants and runway splash.	53-11-37
	Stress corrosion on inboard lug of main landing gear trunnion support beam and the BS 706 frame lug.	
	Stress corrosion cracks on horizontal integral ribs on BS 685 and 706 frames.	
	Stress corrosion cracks in keel beam lower tee chords.	
	Stress corrosion of keel beam inboard splice tees.	
Nose Gear Wheel Well	Corrosion on the surfaces inside the wheel well because of air contaminants and runway splash.	53-11-37
	Stress corrosion on lock support fittings.	
	Stress corrosion cracking of the actuator support fittings.	
	Corrosion of the exterior surfaces.	
Doorway Openings	Corrosion on the structure around door openings.	53-11-37
	Stress corrosion of aft airstair door stop fittings.	
Aft Pressure Bulkhead	Corrosion on the aft face of the bulkhead.	53-11-37
	Corrosion on the lower 10 inches of the forward face of the bulkhead because of clogged drain hole.	
Upper Lobe Frames, Stringers and Skin	Cracks from fastener holes on Stringer 17 left and right.	53-11-37
	Broken attach bolt on BS 1088 bulkhead	
	Pillow blankets that trapped moisture.	
Wing-To-Body Fairing Cavity	Corrosion on the door and door hinge.	53-51-37
	Corrosion of the under fairing skin.	

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FUSELAGE FATIGUE INSPECTIONS - MAINTENANCE PRACTICES

1. General

A. This procedure contains scheduled maintenance task data.

TASK 53-05-02-250-843

2. INTERNAL - SPECIAL DETAILED: Wheel Well Aft Bulkhead and Pressure Web STA 727

NOTE: This procedure is a scheduled maintenance task.

A. **Location Zones**

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
143	Area Below Aft Cargo Compartment - Left
144	Area Below Aft Cargo Compartment - Right

B. **Inspection**

NOTE: Remove and/or displace aft cargo forward bulkhead, ceiling, sidewall panels and insulation blankets as required. Remove any sealant from around the fasteners before performing inspection.

SUBTASK 53-05-02-250-043

- (1) Do a High Frequency Eddy Current inspection of the frame inner chord at STA 727 between stringers S-17 and S-21 on both the left and right hand side.

See Doc. D626A010, DTR check form 53-40-16-03.

————— **END OF TASK** —————

TASK 53-05-02-270-804

3. INTERNAL - SPECIAL DETAILED: Overwing Frames and Stub Beams

NOTE: This procedure is a scheduled maintenance task.

A. **Location Zones**

Zone	Area
135	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Left
136	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Right
137	Area Above M.L.G. Wheel Well, Body Station 663.75 to Body Station 727 - Left
138	Area Above M.L.G. Wheel Well, Body Station 663.75 Body Station 727 - Right

B. **Access Panels**

Number	Name/Location
S1301	Area Above Wing Box Center Section Inspection

C. **Inspection**

NOTE: Remove floor panels. Remove/displace insulation blankets as required.

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SUBTASK 53-05-02-010-086

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
S1301	Area Above Wing Box Center Section Inspection

SUBTASK 53-05-02-270-004

- (2) Do an Ultrasonic inspection of the inboard and outboard strap fastener attachments (to the stub beam and floor beam) at the overwing stub beam locations (STA 578, 601, and 616) on both the left and right hand side.

See Doc. D626A010, DTR check form 53-40-20-01.

SUBTASK 53-05-02-410-087

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
S1301	Area Above Wing Box Center Section Inspection

————— END OF TASK —————

TASK 53-05-02-270-805

4. INTERNAL - SPECIAL DETAILED: Overwing Frames and Stub Beams

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
135	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Left
136	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Right
137	Area Above M.L.G. Wheel Well, Body Station 663.75 to Body Station 727 - Left
138	Area Above M.L.G. Wheel Well, Body Station 663.75 Body Station 727 - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
S1301	Area Above Wing Box Center Section Inspection

C. Inspection

NOTE: Remove floor panels. Remove/displace insulation blankets as required.

SUBTASK 53-05-02-010-085

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
S1301	Area Above Wing Box Center Section Inspection

SUBTASK 53-05-02-270-005

- (2) Do an Ultrasonic inspection of the inboard and outboard strap fastener attachments (to the stub beam and floor beam) at the overwing stub beam location (STA 639) on the left and right hand side. (PSE 53-40-20-01A)

See Doc. D626A010, DTR check form 53-40-20-01A for alternative inspection.

SUBTASK 53-05-02-410-086

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
S1301	Area Above Wing Box Center Section Inspection

————— END OF TASK —————

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TASK 53-05-02-250-915

5. INTERNAL - SPECIAL DETAILED: Aft Pressure Bulkhead, STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin interiors as required to perform the inspection.

SUBTASK 53-05-02-250-111

- (1) Do a High Frequency Eddy Current inspection of the pressure dome webs along the aft fastener row attaching the web to the pressure chord between stiffener locations from S-5L to S-7L and from S-5R to S-9R.

See Doc. D626A010, DTR check form 53-80-01-05A.

————— **END OF TASK** —————

TASK 53-05-02-250-916

6. INTERNAL - SPECIAL DETAILED: Aft Pressure Bulkhead, STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin interiors as required to perform the inspection and removal of sealant around fasteners required prior to inspection.

SUBTASK 53-05-02-250-112

- (1) Do a High Frequency Eddy Current inspection of the pressure dome webs along the aft fastener row attaching the web to the pressure chord between stiffener locations outside of S-5L to S-7L and S-5R to S-9R.

See Doc. D626A010, DTR check form 53-80-01-05B.

————— **END OF TASK** —————

TASK 53-05-02-270-801

7. INTERNAL - SPECIAL DETAILED: Aft Pressure Bulkhead, STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin interiors as required to perform the inspection.

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SUBTASK 53-05-02-270-001

- (1) Do an Ultrasonic inspection around the fasteners common to the pressure chord splices between S-2 and S-3, and S-16 and S-17 at the aft pressure bulkhead.

See Doc. D626A010, DTR check form 53-80-01-06, for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-917

8. INTERNAL - SPECIAL DETAILED: Aft Pressure Bulkhead, STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin interiors as required to perform the inspection.

SUBTASK 53-05-02-250-113

- (1) Do a Low Frequency Eddy Current inspection of the forward side of the pressure dome in the web around fasteners common to the lap slice and the stiffeners.

See Doc D626A010, DTR check form 53-80-01-07 for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-918

9. INTERNAL - SPECIAL DETAILED: Aft Pressure Bulkhead, STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin interiors as required to perform the inspection and removal of sealant required prior to the inspection.

SUBTASK 53-05-02-250-114

- (1) Do a High Frequency Eddy Current inspection of the forward side of the pressure dome web around fasteners common to the tear straps.

See Doc D626A010, DTR check form 53-80-01-08 for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-919

10. INTERNAL - SPECIAL DETAILED: Aft Pressure Bulkhead, STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left

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(Continued)

Zone	Area
312	Area Aft of Pressure Bulkhead - Right

B. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door

C. Inspection

SUBTASK 53-05-02-010-087

- (1) Open this access panel:

Number	Name/Location
311BL	Stabilizer Trim Access Door

SUBTASK 53-05-02-250-115

- (2) Do a Low Frequency Eddy Current inspection of the aft side of the pressure dome web at the intersection of the tear straps and lap splice next to the stiffeners.

See Doc D626A010, DTR check form 53-80-01-09A.

SUBTASK 53-05-02-410-088

- (3) Close this access panel:

Number	Name/Location
311BL	Stabilizer Trim Access Door

————— END OF TASK —————

TASK 53-05-02-250-920

11. INTERNAL - SPECIAL DETAILED: Aft Pressure Bulkhead, STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin interiors as required to perform the inspection.

SUBTASK 53-05-02-250-116

- (1) Do a Low Frequency Eddy Current inspection of the fwd side of the pressure dome web at the intersection of the tear strap, lap splice, and doubler next to the stringer S-23 on both left and right hand side.

See Doc D626A010, DTR check form 53-80-01-09B.

————— END OF TASK —————

TASK 53-05-02-250-921

12. INTERNAL - SPECIAL DETAILED: Aft Pressure Bulkhead, STA 1016

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door

C. Inspection

SUBTASK 53-05-02-010-088

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

SUBTASK 53-05-02-250-117

- (2) Do a Low Frequency Eddy Current inspection of all fasteners common to the pressure dome webs at the apex location. Both the visible and hidden layers must be inspected.

See Doc. D626A010, DTR check form 53-80-01-09C.

SUBTASK 53-05-02-410-089

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

————— **END OF TASK** —————

TASK 53-05-02-250-922

13. INTERNAL - SPECIAL DETAILED: Aft Pressure Bulkhead, STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door

C. Inspection

SUBTASK 53-05-02-010-089

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

SUBTASK 53-05-02-250-118

- (2) Do a High Frequency Eddy Current inspection of all fasteners common to the pressure dome webs at the apex location. Both the visible and hidden layers must be inspected.

See Doc. D626A010, DTR check form 53-80-01-09C.

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SUBTASK 53-05-02-410-090

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

————— END OF TASK —————

TASK 53-05-02-250-923

14. INTERNAL - SPECIAL DETAILED: Aft Pressure Bulkhead, STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin interiors as required to perform the inspection.

SUBTASK 53-05-02-250-119

- (1) Do a High Frequency Eddy Current inspection of the forward side of the pressure dome webs at the junction of the radial stiffeners/lap splices and the tear straps.
See Doc D626A010, DTR check form 53-80-01-11 for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-270-802

15. INTERNAL - SPECIAL DETAILED: Aft Pressure Bulkhead, STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

C. Inspection

SUBTASK 53-05-02-010-090

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

SUBTASK 53-05-02-270-002

- (2) Do an Ultrasonic inspection of the aft side of the pressure dome web along the aft fastener row common to the web and Y-chord (between S-3L and S-3R)
See Doc D626A010, DTR check form 53-80-01-13.

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SUBTASK 53-05-02-410-091

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

————— END OF TASK —————

TASK 53-05-02-211-864

16. INTERNAL - DETAILED: Vertical Fin Front Spar Fittings, STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin interiors as required to perform the inspection. Sealant that extends beyond 0.40 inches around fastener heads or collars must be removed.

SUBTASK 53-05-02-211-064

- (1) Do a Detailed inspection of the fitting on both sides of the bulkhead at STA 1016.
See Doc D626A010, DTR check form 53-80-02-01 for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-925

17. EXTERNAL - SPECIAL DETAILED: Vertical Fin Front Spar Fittings

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
323AL	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door

C. Inspection

NOTE: Bolt removal is not required.

SUBTASK 53-05-02-010-091

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
323AL	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door

SUBTASK 53-05-02-250-121

- (2) Do a High Frequency Eddy Current inspection of the exposed forward and aft surfaces of the fitting lugs.
See Doc D626A010, DTR check form 53-80-02-03.

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SUBTASK 53-05-02-410-092

- (3) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
323AL	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door

————— END OF TASK —————

TASK 53-05-02-250-926

18. EXTERNAL - SPECIAL DETAILED: Jackscrew Fitting Lugs

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

C. Inspection

NOTE: Remove/disconnect the jackscrew from the fitting and move aside for access to the lugs.

SUBTASK 53-05-02-010-092

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

SUBTASK 53-05-02-250-122

- (2) Do a High Frequency Eddy Current inspection of both primary jackscrew fitting lugs on both sides around the bushing at the STA 1088 bulkhead.

See Doc D626A010, DTR check form 53-80-05-01 for alternative inspection.

SUBTASK 53-05-02-410-093

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

————— END OF TASK —————

TASK 53-05-02-270-803

19. INTERNAL - SPECIAL DETAILED: Vertical Fin Spar Fittings

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

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B. Access Panels

Number	Name/Location

311BL	Stabilizer Trim Access Door

C. Inspection

NOTE: Access to the fittings on the fwd and aft side of the STA 1088 bulkhead.

SUBTASK 53-05-02-010-093

(1) Open this access panel:

Number	Name/Location

311BL	Stabilizer Trim Access Door

SUBTASK 53-05-02-270-003

(2) Do an Ultrasonic inspection around the top two (2) fasteners in the outboard primary fittings (fwd and aft) common to the bulkhead. The top of the fitting are sandwiched between the splice angles and the bulkhead.

See Doc D626A010, DTR check form 53-80-06-01.

SUBTASK 53-05-02-410-094

(3) Close this access panel:

Number	Name/Location

311BL	Stabilizer Trim Access Door

————— END OF TASK —————

TASK 53-05-02-211-865

20. INTERNAL - DETAILED: Vertical Fin Rear Spar Fittings

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

B. Inspection

NOTE: Remove vertical fin including primary and failsafe bolts.

SUBTASK 53-05-02-211-065

(1) Do a Detailed inspection of all four primary lugs (fwd and aft primary fitting lugs, left and right hand side) from inside of the lug at STA 1088.

See Doc D626A010, DTR check form 53-80-06-02.

————— END OF TASK —————

TASK 53-05-02-250-927

21. INTERNAL - SPECIAL DETAILED: Bulkhead, STA 1156

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

Zone	Area
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right
317	Tail Cone Compartment - Left
318	Tail Cone Compartment - Right

B. Access Panels

Number	Name/Location
317BL	Tailcone Access Door
318BR	Tailcone Access Door

C. Inspection

SUBTASK 53-05-02-010-094

- (1) Open these access panels:

Number	Name/Location
317BL	Tailcone Access Door
318BR	Tailcone Access Door

SUBTASK 53-05-02-250-123

- (2) Do a High Frequency Eddy Current inspection of the web inboard along the failsafe strap from the top of the stabilizer attach fitting down 16 inches vertically.
See Doc D626A010, DTR check form 53-80-07-02.

SUBTASK 53-05-02-410-095

- (3) Close these access panels:

Number	Name/Location
317BL	Tailcone Access Door
318BR	Tailcone Access Door

————— END OF TASK —————

TASK 53-05-02-250-928

22. INTERNAL - SPECIAL DETAILED: Horizontal Stabilizer Pivot Fittings, STA 1156

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

B. Inspection

NOTE: Remove sliding seals for access.

SUBTASK 53-05-02-250-124

- (1) Do a High Frequency Eddy Current inspection of the hinge fitting beams around the pivot pins.
See Doc D626A010, DTR check form 53-80-08-01.

————— END OF TASK —————

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TASK 53-05-02-230-802

23. **INTERNAL - SPECIAL DETAILED: Horizontal Stabilizer Pivot Pins**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

B. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door

C. Inspection

NOTE: Removal and separation of pivot pins is required to perform the inspection.

SUBTASK 53-05-02-010-095

- (1) Open this access panel:

Number	Name/Location
311BL	Stabilizer Trim Access Door

SUBTASK 53-05-02-230-002

- (2) Do a Dye Penetrant inspection of both the inner and outer pivot pins at STA 1156 bulkhead.
To accomplish inspection see SOPM 20-20-02.
See Doc D626A010, DTR check form 53-80-08-02.

SUBTASK 53-05-02-410-096

- (3) Close this access panel:

Number	Name/Location
311BL	Stabilizer Trim Access Door

————— **END OF TASK** —————

TASK 53-05-02-211-869

24. **INTERNAL - DETAILED: Overwing Frames and Stub Beams**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

NOTE: Remove cabin interiors as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-02-211-068

- (1) Do a Detailed inspection of the frame in all overwing upper to lower frame splice joints at STA 559, 578, 601, 616 and 639, at all inner chord and web fastener locations on both the left and right hand side. The splices are located between S-8 and S-10 for STA 559, and between S-7 and S-9 for STA 578, 601, 616, and 639.

See Doc. D626A010, DTR check form 53-40-20-03, for alternative inspection.

————— **END OF TASK** —————

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TASK 53-05-02-211-870

25. **INTERNAL - DETAILED: Overwing Frames and Stub Beams**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Access Panels

Number	Name/Location
231ZF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
232SF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)

C. Inspection

NOTE: Remove floor panels. Remove/displace insulation blankets as required.

SUBTASK 53-05-02-010-139

- (1) Open these access panels:

Number	Name/Location
231ZF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
232SF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)

SUBTASK 53-05-02-211-069

- (2) Do a Detailed inspection of the stub beam from the frame attachment location to the strap attachment to the floor beam for all overwing stub beam locations (STA 559, 578, 601, 616, and 639) on the left and right hand side.
- See Doc. D626A010, DTR check form 53-40-20-04.

SUBTASK 53-05-02-410-140

- (3) Close these access panels:

Number	Name/Location
231ZF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
232SF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)

————— **END OF TASK** —————

TASK 53-05-02-211-871

26. **INTERNAL - DETAILED: Wheel Well Frame, STA 685**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove sidewalls and insulation as required.

SUBTASK 53-05-02-211-070

- (1) Do a Detailed inspection of the frame inner chord at STA 685 from stringer S-11 to S-15 on both the left and right hand side.

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See Doc. D626A010, DTR check form 53-40-21-02.

————— END OF TASK —————

TASK 53-05-02-250-937

27. INTERNAL - SPECIAL DETAILED: Wheel Well Frame, STA 685

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
137	Area Above M.L.G. Wheel Well, Body Station 663.75 to Body Station 727 - Left
138	Area Above M.L.G. Wheel Well, Body Station 663.75 Body Station 727 - Right

B. Inspection

NOTE: Remove sidewalls, insulation, and floor panels as required.

SUBTASK 53-05-02-250-134

- (1) Do a High Frequency Eddy Current inspection of the frame inner chord at STA 685 from S-15 to S-18A (5 inches below the crease beam inner chord) on the left and right hand side of the aircraft.

See Doc. D626A010, DTR check form 53-40-21-03, for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-938

28. INTERNAL - SPECIAL DETAILED: Wheel Well Frame, STA 685

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
137	Area Above M.L.G. Wheel Well, Body Station 663.75 to Body Station 727 - Left
138	Area Above M.L.G. Wheel Well, Body Station 663.75 Body Station 727 - Right

B. Access Panels

Number	Name/Location
241BF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
241CF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
242AF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
242BF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)

C. Inspection

SUBTASK 53-05-02-010-140

- (1) Open these access panels:

Number	Name/Location
241BF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
241CF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
242AF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
242BF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)

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SUBTASK 53-05-02-250-135

- (2) Do a High Frequency Eddy Current inspection of the stub beam upper chord at STA 685 from two inches inside the skin to the most inboard stiffener and around any fasteners through the upper web and chord in this area on both the left and right hand side.

See Doc. D626A010, DTR check form 53-40-21-04, for alternative inspection.

SUBTASK 53-05-02-410-141

- (3) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
241BF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
241CF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
242AF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
242BF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)

————— END OF TASK —————

TASK 53-05-02-270-806

29. INTERNAL - SPECIAL DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

NOTE: Remove sidewalls and insulation as required.

SUBTASK 53-05-02-270-006

- (1) Do an Ultrasonic inspection of the STA 578 frame outer chord common to the upper stringer fittings at S-11 and S-13, and the upper and middle door stop back-up fittings at S-13, on the left and right side of the aircraft.

See Doc. D626A010, DTR check form 53-40-22-01.

————— END OF TASK —————

TASK 53-05-02-250-939

30. INTERNAL - SPECIAL DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

NOTE: Remove sidewalls and insulation as required.

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SUBTASK 53-05-02-250-136

- (1) Do a High Frequency Eddy Current inspection around all fasteners common to the STA 578 frame outer chord from S-10 to S-13 on both the left and right hand side. This excludes locations common to the door stop back-up fittings and the stringer end fittings which are included in PSE 53-40-22-01.

See Doc. D626A010, DTR check form 53-40-22-01A.

————— END OF TASK —————

TASK 53-05-02-250-940

31. EXTERNAL - SPECIAL DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

SUBTASK 53-05-02-250-137

- (1) Do a High Frequency Eddy Current inspection of the fuselage skin around all fasteners common to the edge frame outer chord at the following locations:
 - STA 578: Between S-13 to one fastener below S-15 on both the left and right hand side.
 - STA 601: Between S-10 lap splice to one fastener below S-17 on both the left and right hand side.
 - STA 616: Between S-10 lap splice to one fastener below S-14 on both the left and right hand side.
 - STA 639: Between S-10 lap splice to one fastener below S-17 on both the left and right hand side.
- See Doc. D626A010, DTR check form 53-40-22-02.

————— END OF TASK —————

TASK 53-05-02-211-872

32. INTERNAL - DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

NOTE: Remove interior panels and insulation as required.

SUBTASK 53-05-02-211-071

- (1) Do a Detailed inspection of the edge frame inner chords and webs at STA 578, STA 601, STA 616, and STA 639, between S-9 and S-17 on both the left and right hand side.

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See Doc. D626A010, DTR check form 53-40-22-03.

— END OF TASK —

TASK 53-05-02-270-807

33. INTERNAL - SPECIAL DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

NOTE: Remove interior panels and insulation as required.

SUBTASK 53-05-02-270-007

- (1) Do an Ultrasonic inspection of the edge frame inner chord and web at the fastener locations common to the upper sill attachment at STA 578 on both the left and right hand side.

See Doc. D626A010, DTR check form 53-40-22-04.

— END OF TASK —

TASK 53-05-02-250-941

34. INTERNAL - SPECIAL DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Access Panels

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

C. Inspection

SUBTASK 53-05-02-010-100

- (1) Open these access panels:

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

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SUBTASK 53-05-02-250-138

- (2) Do a High Frequency Eddy Current of the edge of the fuselage skin, bearstrap, and cubstrap at each upper corner at STA 578, STA 601, STA 616, and STA 639 on both the left and right hand side.

See Doc. D626A010, DTR check form 53-40-22-05.

SUBTASK 53-05-02-410-101

- (3) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

————— END OF TASK —————

TASK 53-05-02-250-942

35. INTERNAL - SPECIAL DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

C. Inspection

SUBTASK 53-05-02-010-101

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

SUBTASK 53-05-02-250-139

- (2) Do a High Frequency Eddy Current inspection around fasteners common to the lower corners at STA 578, STA 601, STA 616, and STA 639 between S-14 and S-15 on both the left and right hand side.

See Doc. D626A010, DTR check form 53-40-22-06.

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SUBTASK 53-05-02-410-102

- (3) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

————— END OF TASK —————

TASK 53-05-02-250-943

36. INTERNAL - SPECIAL DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

C. Inspection

SUBTASK 53-05-02-010-102

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

SUBTASK 53-05-02-250-140

- (2) Do a High Frequency Eddy Current inspection of the edge of the skin, bearstrap, and cubstrap common to the lower corners at STA 578, STA 601, STA 616, and STA 639 between S-14 and S-15 on both the left and right hand side.

See Doc. D626A010, DTR check form 53-40-22-06.

SUBTASK 53-05-02-410-103

- (3) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

————— END OF TASK —————

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TASK 53-05-02-250-944

37. **INTERNAL - SPECIAL DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Access Panels

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

C. Inspection

NOTE: Emergency exit door must be open to perform the inspection. Remove or displace passenger cabin sidewall lining as required to perform the inspection.

SUBTASK 53-05-02-010-103

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

SUBTASK 53-05-02-250-141

- (2) Do a High Frequency Eddy Current inspection of the lower sill inner chord splice strap around the six fasteners (three forward, three aft) at STA 578, STA 601, STA 616, and STA 639 on the left and right hand side.

See Doc. D626A010, DTR check form 53-40-22-07, for alternative inspection.

SUBTASK 53-05-02-410-104

- (3) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

————— **END OF TASK** —————

TASK 53-05-02-250-945

38. **INTERNAL - SPECIAL DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure**

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Access Panels

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

C. Inspection

SUBTASK 53-05-02-010-104

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

SUBTASK 53-05-02-250-142

- (2) Do a High Frequency Eddy Current inspection of the edge frame inner chord at the three stop fitting locations common to each frame at STA 578, STA 601, STA 616, and STA 639 on the left and right hand side.

See Doc. D626A010, DTR check form 53-40-22-09.

SUBTASK 53-05-02-410-105

- (3) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

————— END OF TASK —————

TASK 53-05-02-211-873

39. INTERNAL - DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure, STA 601 to STA 616

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

NOTE: Remove interior panels and insulation materials between the overwing exit doors.

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SUBTASK 53-05-02-211-072

- (1) Do a Detailed inspection of the three door stop intercostals on both the left and right hand side, STA 601 to STA 616.

See Doc. D626A010, DTR check form 53-40-23-02.

————— END OF TASK —————

TASK 53-05-02-250-946

40. INTERNAL - SPECIAL DETAILED: Cutout - Overwing Emergency Exit Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

SUBTASK 53-05-02-250-143

- (1) Do a High Frequency Eddy Current inspection of the window frame at STA 578 at the door stop backup fitting attachment to window frame. The window frame is located forward from the forward overwing emergency exit door on both the left and right hand side.

See Doc. D626A010, DTR check form 53-40-23-03.

————— END OF TASK —————

TASK 53-05-02-211-874

41. INTERNAL - DETAILED: Pressure Deck Attachment to Rear Spar Extension

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
137	Area Above M.L.G. Wheel Well, Body Station 663.75 to Body Station 727 - Left
138	Area Above M.L.G. Wheel Well, Body Station 663.75 Body Station 727 - Right

B. Inspection

NOTE: Removal of the fillet seal is required. Remove floor panels as required.

SUBTASK 53-05-02-211-073

- (1) Do a Detailed inspection of the compression chord attachment angle between the rear spar extension and the pressure deck from the aft side, including the bend radius, at STA 663.

See Doc. D626A010, DTR check form 53-40-24-01, for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-211-875

42. EXTERNAL - DETAILED: Crown Skin Panel - STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-211-074

- (1) Do a Detailed inspection of the skin around all fastener locations from S-10L to S-10R, except at the lap splices and antenna locations. (PSE 53-60-01-01)
See Doc. D626A010, DTR check form 53-30-01-01.

————— **END OF TASK** —————

TASK 53-05-02-211-876

43. EXTERNAL - DETAILED: Crown Skin Panel - STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Applicable to airplanes with the antenna installed, or if structural provisions are installed with an external cover in lieu of the antenna.

NOTE: Remove antenna fairing, antenna and baseplate as required to expose skin.

SUBTASK 53-05-02-211-075

- (1) Do a Detailed inspection of the skin under the ADF antenna fairing at STA 727A+9.
See Doc. D626A010, DTR check form 53-60-01-04.

————— **END OF TASK** —————

TASK 53-05-02-211-877

44. EXTERNAL - DETAILED: Crown Skin Panel - STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Applicable to airplanes with the antenna installed, or if structural provisions are installed with an external cover in lieu of the antenna.

NOTE: Remove antenna fairing, antenna and baseplate as required to expose skin.

SUBTASK 53-05-02-211-076

- (1) Do a Detailed inspection of the skin under the SATCOM HGA antenna fairing at STA 747.
See Doc. D626A010, DTR check form 53-60-01-07.

————— **END OF TASK** —————

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TASK 53-05-02-211-878

45. EXTERNAL - DETAILED: Crown Skin Panel - STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Applicable to airplanes with the antenna installed, or if structural provisions are installed with an external cover in lieu of the antenna.

NOTE: Removal of the antenna fairing is required.

SUBTASK 53-05-02-211-077

- (1) Do a Detailed inspection of the skin under the ELT antenna fairing at STA 796.
See Doc. D626A010, DTR check form 53-60-01-08.

————— **END OF TASK** —————

TASK 53-05-02-211-879

46. EXTERNAL - DETAILED: Crown Skin Panel - STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Applicable to airplanes with the antenna installed or if structural provisions are installed with an external cover in lieu of the antenna

NOTE: Remove the radome, antenna, and the antenna adapter plate. Remove all applicable penetration coverplates if installed.

SUBTASK 53-05-02-211-078

- (1) Do a Detailed inspection of the fuselage skin common to the large external antenna (Ku/Ka, Ku/K/Ka, 2Ku Band) adapter plate footprint and the lugs common to the fuselage and antenna installation.

See Doc. D626A010, DTR check form 53-60-01-09.

————— **END OF TASK** —————

TASK 53-05-02-250-947

47. INTERNAL - SPECIAL DETAILED: Crown Skin Panel - STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

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B. Inspection

NOTE: Applicable to airplane with the large antenna option (Ku/Ka, Ku/K/Ka, or 2Ku Band) installed or if structural provisions are installed with an external cover in lieu of the antenna.

SUBTASK 53-05-02-250-144

- (1) Do a High Frequency Eddy Current inspection of the crown frame web along the inboard edge of the shear tie and the crown frame chord along the outboard edge of the frame doubler at STA 727D and STA 727E from S-4 to S-5 on the left and right hand side.

See Doc. D626A010, DTR check form 53-60-01-11D.

————— END OF TASK —————

TASK 53-05-02-210-809

48. EXTERNAL - GENERAL VISUAL: Side Skin Panel - STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-210-008

- (1) Do a General Visual inspection of the fuselage skin from S-14 to S-17, STA 727 to STA 887, on both the left and right hand side. (PSE 53-60-02-02)

See Doc. D626A010, DTR check form 53-30-02-02 for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-210-810

49. INTERNAL - GENERAL VISUAL: Side Skin Panel - STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove cabin interior as required. Remove/replace insulation blankets as required.

SUBTASK 53-05-02-210-009

- (1) Do a General Visual inspection of the upper and lower frames, and failsafe chord, between S-12 and S-15 on both the left hand and right hand side at the following frame locations:

737-7: STA 727A, STA 727B, STA 847 and STA 867

737-8/-8200: STA 727A to 727G and STA 847 to 867

737-9: STA 727A, STA 727B, STA 847 and STA 867

See Doc. D626A010, DTR check form 53-60-02-05.

————— END OF TASK —————

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TASK 53-05-02-211-881

50. INTERNAL - DETAILED: Side Skin Panel - STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove cabin interior as required. Remove/replace insulation blankets as required.

SUBTASK 53-05-02-211-080

- (1) Do a Detailed inspection of the upper and lower frames, and failsafe chord, between S-12 and S-15 on both the left and right hand side at the following frame locations:
- 737-7: STA 727A, STA 727B, STA 847 and STA 867
737-8/-8200: STA 727A to 727G and STA 847 to 867
737-9: STA 727A, STA 727B, STA 847 and STA 867
See Doc. D626A010, DTR check form 53-60-02-05.

————— **END OF TASK** —————

TASK 53-05-02-210-811

51. INTERNAL - GENERAL VISUAL: Side Skin Panel - STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove cabin interior as required. Remove/replace insulation blankets as required.

SUBTASK 53-05-02-210-010

- (1) Do a General Visual inspection of the side frames, inner chord, web, and failsafe chord at STA 727A and STA 867, between stringers S-18 and S-26 on both the left and right hand side. Inspect the frame splice between S-24R and S-26R. Exclude the cargo door edge frames.
See Doc. D626A010, DTR check form 53-60-02-06.

————— **END OF TASK** —————

TASK 53-05-02-211-882

52. INTERNAL - DETAILED: Side Skin Panel - STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

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B. Inspection

NOTE: Removal of side panels required to gain access.

SUBTASK 53-05-02-211-081

- (1) Do a Detailed inspection of the side frames, inner chord, web, and failsafe chord. between STA 727A and STA 867, between stringers S-18 and S-26 on both the left and right hand side. Inspect the frame splice between S-24R and S-26R. Exclude the cargo door edge frames.

See Doc. D626A010, DTR check form 53-60-02-06.

————— **END OF TASK** —————

TASK 53-05-02-210-812

53. EXTERNAL - GENERAL VISUAL: Bilge Skin Panel - STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

143	Area Below Aft Cargo Compartment - Left

144	Area Below Aft Cargo Compartment - Right

B. Inspection

SUBTASK 53-05-02-210-011

- (1) Do a General Visual inspection of the fuselage skin from S-23L to S-23R, STA 727 to STA 887 (PSE 53-60-03-01)

See Doc. D626A010, DTR check form 53-30-02-02 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-211-883

54. EXTERNAL - DETAILED: Bilge Skin Panel - STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

143	Area Below Aft Cargo Compartment - Left

144	Area Below Aft Cargo Compartment - Right

194	Lower Wing-To-Body Fairing - Aft of Wheel Well

B. Inspection

NOTE: Remove aft wing-to-body fairing as required for proper inspection.

SUBTASK 53-05-02-211-082

- (1) Do a Detailed inspection of the drain hole cutouts under the wing-to-body fairing at STA 727 to STA 887. (PSE 53-60-03-05)

See Doc. D626A010, DTR check form 53-30-02-04.

————— **END OF TASK** —————

TASK 53-05-02-211-884

55. EXTERNAL - DETAILED: Bilge Skin Panel - STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

Zone	Area
143	Area Below Aft Cargo Compartment - Left
144	Area Below Aft Cargo Compartment - Right
194	Lower Wing-To-Body Fairing - Aft of Wheel Well

B. Inspection

NOTE: Remove aft wing-to-body fairing as required for proper inspection.

SUBTASK 53-05-02-211-083

- (1) Do a Detailed inspection of the hydraulic penetration cutouts under the wing-to-body fairing, STA 727 to STA 887. (PSE 53-60-03-07)

See Doc. D626A010, DTR check form 53-30-02-04.

————— **END OF TASK** —————

TASK 53-05-02-250-948

56. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice, STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-145

- (1) Do a High Frequency Eddy Current inspection of the S-4L and S-4R lap splice upper fastener row from STA 727 to STA 887. (PSE 53-60-04-01)

See Doc. D626A010, DTR check form 53-30-04-01.

————— **END OF TASK** —————

TASK 53-05-02-250-949

57. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice, STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-146

- (1) Do a Low Frequency Eddy Current inspection of the S-4L and S-4R lap splice lower fastener row from STA 727 to STA 887. (PSE 53-60-04-01)

See Doc. D626A010, DTR check form 53-30-04-02.

————— **END OF TASK** —————

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TASK 53-05-02-250-950

58. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice, STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-147

- (1) Do a High Frequency Eddy Current inspection of the S-10L and S-10R lap splice upper fastener row from STA 727 to STA 887. (PSE 53-60-04-03)

See Doc. D626A010, DTR check form 53-30-04-03.

————— **END OF TASK** —————

TASK 53-05-02-211-885

59. INTERNAL - DETAILED: Longitudinal Lap Skin Splice, STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove interior panels as required.

SUBTASK 53-05-02-211-084

- (1) Do a Detailed inspection of the S-10L and S-10R lap splice lower fastener row from STA 727 to STA 887. (PSE 53-60-04-04)

See Doc. D626A010, DTR check form 53-30-04-04.

————— **END OF TASK** —————

TASK 53-05-02-211-886

60. EXTERNAL - DETAILED: Longitudinal Lap Skin Splice, STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-211-085

- (1) Do a Detailed inspection of the S-14L and S-14R lap splice upper fastener row from STA 727 to STA 887. (PSE 53-60-04-05)

See Doc. D626A010, DTR check form 53-30-04-05.

————— **END OF TASK** —————

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TASK 53-05-02-250-951

61. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice, STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-148

- (1) Do a Low Frequency Eddy Current inspection of the S-14L and S-14R lap splice lower fastener row from STA 727 to STA 887. (PSE 53-60-04-06)
See Doc. D626A010, DTR check form 53-30-04-06.

————— **END OF TASK** —————

TASK 53-05-02-250-952

62. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice, STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Removal of the wing-to-body fairing is required for proper inspection.

SUBTASK 53-05-02-250-149

- (1) Do a Low Frequency Eddy Current inspection of the S-23L and S-23R lap splice upper fastener row from STA 727 to STA 887. (PSE 53-60-04-07)
See Doc. D626A010, DTR check form 53-30-04-07.

————— **END OF TASK** —————

TASK 53-05-02-211-887

63. EXTERNAL - DETAILED: Longitudinal Lap Skin Splice, STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Removal of the wing-to-body fairing is required for proper inspection.

SUBTASK 53-05-02-211-086

- (1) Do a Detailed inspection of the S-23L and S-23R lap splice lower fastener row under the wing-to-body fairing from STA 727 to STA 887. (PSE 53-60-04-08)

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See Doc. D626A010, DTR check form 53-30-04-08.

————— END OF TASK —————

TASK 53-05-02-250-953

64. EXTERNAL - SPECIAL DETAILED: Window Belt, STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-150

- (1) Do a High Frequency Eddy Current inspection of the window frame detail around each passenger window from STA 727 to STA 887 on the left and right hand side.

See Doc. D626A010, DTR check form 53-60-05-02, for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-954

65. INTERNAL - SPECIAL DETAILED: Window Belt, STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Removal and/or displacement of passenger cabin sidewalls or sidewall window assemblies and insulation blankets is required.

SUBTASK 53-05-02-250-151

- (1) Do a High Frequency Eddy Current inspection of the window frame detail around each passenger window from STA 727 to STA 887 on the left and right hand side.

See Doc. D626A010, DTR check form 53-60-05-02, for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-210-813

66. EXTERNAL - GENERAL VISUAL: Window Belt, STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left

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Zone	Area
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-210-012

- (1) Do a General Visual inspection of the skin at the skin to window frame fastener around each passenger window from STA 727 to STA 887 on the left and right hand side.

See Doc. D626A010, DTR check form 53-60-05-03, for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-955

67. EXTERNAL - SPECIAL DETAILED: Window Belt, STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-152

- (1) Do a High Frequency Eddy Current inspection of the skin at the skin to window frame fastener around each passenger window from STA 727 to STA 887 on the left and right hand side.

See Doc D626A010, DTR check form 53-60-05-03, for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-956

68. EXTERNAL - SPECIAL DETAILED: Window Belt, STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-153

- (1) Do a High Frequency Eddy Current inspection of the skin at the skin to window frame fastener around each passenger window from STA 727 to STA 887 on the left and right hand side.

See Doc. D626A010, DTR check form 53-60-05-03A.

————— END OF TASK —————

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TASK 53-05-02-250-957

69. INTERNAL - SPECIAL DETAILED: Cutout - Aft Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
822	Aft Cargo Door

C. Inspection

NOTE: Perform inspection with door open. Remove or displace cargo liners as required to perform this inspection. Remove sealant at door stops as required.

SUBTASK 53-05-02-010-105

- (1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

SUBTASK 53-05-02-250-154

- (2) Do a High Frequency Eddy Current of the forward and aft edge frame inner chord between the web and failsafe strap from S-18R to S-26R.
See Doc. D626A010, DTR check form 53-60-08-01.

SUBTASK 53-05-02-410-106

- (3) Close this access panel:

Number	Name/Location
822	Aft Cargo Door

————— **END OF TASK** —————

TASK 53-05-02-250-958

70. INTERNAL - SPECIAL DETAILED: Cutout - Aft Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
822	Aft Cargo Door

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C. Inspection

NOTE: Remove cargo liners as required.

SUBTASK 53-05-02-010-106

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

SUBTASK 53-05-02-250-155

- (2) Do a High Frequency Eddy Current inspection of the forward and aft edge frame inner chord failsafe strap between S-17R and S-18R.

See Doc. D626A010, DTR check form 53-60-08-02, for alternative inspection.

SUBTASK 53-05-02-410-107

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

————— END OF TASK —————

TASK 53-05-02-250-959

71. INTERNAL - SPECIAL DETAILED: Cutout - Aft Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

C. Inspection

NOTE: Remove Cargo Liners as required.

SUBTASK 53-05-02-010-107

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

SUBTASK 53-05-02-250-156

- (2) Do a High Frequency Eddy Current inspection of the end of the edge frame inner chord at S-17R and S-18R on the forward and aft edge frames.

See Doc. D626A010, DTR check form 53-60-08-03.

SUBTASK 53-05-02-410-108

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

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————— END OF TASK —————

TASK 53-05-02-270-809

72. INTERNAL - SPECIAL DETAILED: Cutout - Aft Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
822	Aft Cargo Door

C. Inspection

NOTE: Perform inspection with cargo door open. Remove cargo liners as required.

SUBTASK 53-05-02-010-108

- (1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

SUBTASK 53-05-02-270-009

- (2) Do an Ultrasonic inspection of the outboard portion of the forward and aft edge frame web under all door stop fittings and sill clip intersection locations of aft cargo door.

See Doc. D626A010, DTR check form 53-60-08-05.

SUBTASK 53-05-02-410-109

- (3) Close this access panel:

Number	Name/Location
822	Aft Cargo Door

————— END OF TASK —————

TASK 53-05-02-250-960

73. INTERNAL - SPECIAL DETAILED: Cutout - Aft Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
822	Aft Cargo Door

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C. Inspection

SUBTASK 53-05-02-010-109

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

SUBTASK 53-05-02-250-157

- (2) Do a High Frequency Eddy Current inspection of the bearstrap for 2 inches on each side of the forward and aft skin splice at S-23R, STA 794.4 and STA 847.

See Doc. D626A010, DTR check form 53-60-08-06.

SUBTASK 53-05-02-410-110

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

————— END OF TASK —————

TASK 53-05-02-250-961

74. INTERNAL - SPECIAL DETAILED: Cutout - Aft Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

C. Inspection

SUBTASK 53-05-02-010-110

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

SUBTASK 53-05-02-250-158

- (2) Do a High Frequency Eddy Current inspection of the forward and aft frame bearstrap between the edge frames and cargo door cutout.

See Doc. D626A010, DTR check form 53-60-08-08.

SUBTASK 53-05-02-410-111

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

————— END OF TASK —————

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TASK 53-05-02-210-814

75. EXTERNAL - GENERAL VISUAL: Cutout - Aft Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
822	Aft Cargo Door

C. Inspection

NOTE: Scuff plate removal not required.

SUBTASK 53-05-02-010-111

- (1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

SUBTASK 53-05-02-210-013

- (2) Do a General Visual inspection of the skin at all four door cutout corners (upper/lower/forward/aft).

See Doc. D626A010, DTR check form 53-60-08-09 for alternative inspection.

SUBTASK 53-05-02-410-112

- (3) Close this access panel:

Number	Name/Location
822	Aft Cargo Door

————— **END OF TASK** —————

TASK 53-05-02-211-888

76. INTERNAL - DETAILED: Cutout - Aft Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
822	Aft Cargo Door

C. Inspection

NOTE: Remove corner castings.

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SUBTASK 53-05-02-010-112

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

SUBTASK 53-05-02-211-087

- (2) Do a Detailed inspection of the bearstrap, including fastener and edge, at all four door cutout corners (upper/lower/forward/aft).

See Doc. D626A010, DTR check form 53-60-08-09 for alternative inspection.

SUBTASK 53-05-02-410-113

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

————— END OF TASK —————

TASK 53-05-02-250-962

77. INTERNAL - SPECIAL DETAILED: Cutout - Aft Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Inspection

NOTE: Remove or displace aft cargo door lining as required to perform the inspection.

SUBTASK 53-05-02-250-159

- (1) Do a High Frequency Eddy Current inspection of the outer chord around fasteners common to the chord and bearstrap at the upper main sill outer chord, STA 767 to STA 867. (PSE 53-60-08-10)

See Doc. D626A010, DTR check form 53-30-08-10.

————— END OF TASK —————

TASK 53-05-02-211-889

78. INTERNAL - DETAILED: Cutout - Aft Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

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B. Access Panels

Number	Name/Location
822	Aft Cargo Door

C. Inspection

NOTE: Sealant that extends beyond 0.40 inches around fastener heads or collars must be removed.

SUBTASK 53-05-02-010-113

- (1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

SUBTASK 53-05-02-211-088

- (2) Do a Detailed inspection of the upper main sill inner chord.
See Doc. D626A010, DTR check form 53-60-08-11, for alternative inspection.

SUBTASK 53-05-02-410-114

- (3) Close this access panel:

Number	Name/Location
822	Aft Cargo Door

————— END OF TASK —————

TASK 53-05-02-250-963

79. INTERNAL - SPECIAL DETAILED: Cutout - Aft Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
822	Aft Cargo Door

C. Inspection

NOTE: Removal of the scuff plate assembly is required to perform this inspection.

SUBTASK 53-05-02-010-114

- (1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

SUBTASK 53-05-02-250-160

- (2) Do a Low Frequency Eddy Current inspection around fasteners common to the web at the lower main sill, bullnose chord. (PSE 52-60-08-12)
See Doc. D626A010, DTR check form 53-30-08-12.

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SUBTASK 53-05-02-410-115

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

————— END OF TASK —————

TASK 53-05-02-250-964

80. EXTERNAL - SPECIAL DETAILED: Cutout - Aft Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

C. Inspection

SUBTASK 53-05-02-010-115

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

SUBTASK 53-05-02-250-161

- (2) Do a High Frequency Eddy Current inspection around all fasteners common to the inboard strap between STA 760 to STA 800 at the lower main sill, inner chord. (PSE 53-60-08-13)
See Doc. D626A010, DTR check form 53-30-08-13, for alternative inspection.

SUBTASK 53-05-02-410-116

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

————— END OF TASK —————

TASK 53-05-02-250-965

81. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right

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Zone	Area
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
143	Area Below Aft Cargo Compartment - Left
144	Area Below Aft Cargo Compartment - Right

B. Inspection

NOTE: Removal of the wing-to-body fairing is required for proper inspection.

SUBTASK 53-05-02-250-162

- (1) Do a Low Frequency Eddy Current inspection of the lap splice upper fastener row of stringers S-24L and S-24R from STA 360 to STA 540.

See Doc. D626A010, DTR check form 53-30-04-07.

————— **END OF TASK** —————

TASK 53-05-02-211-891

82. EXTERNAL - DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
143	Area Below Aft Cargo Compartment - Left
144	Area Below Aft Cargo Compartment - Right
191	Lower Wing-To-Body Fairing - Forward of Wing Box

B. Inspection

NOTE: Removal of the wing-to-body fairing is required for proper inspection.

SUBTASK 53-05-02-211-090

- (1) Do a Detailed inspection of the lap splice lower fastener row under the wing-to-body fairing of stringers S-24L and S24R.

See Doc. D626A010, DTR check form 53-30-04-08.

————— **END OF TASK** —————

TASK 53-05-02-250-966

83. INTERNAL - SPECIAL DETAILED: Window Belt, STA 360 to 540

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

NOTE: Removal and/or displacement of passenger cabin sidewalls or sidewall assemblies and insulation blankets is required.

SUBTASK 53-05-02-250-163

- (1) Do a High Frequency Eddy Current inspection of the window frame around each passenger window on the left and right hand side from STA 360 to STA 540. (PSE 53-30-05-02)
See Doc. D626A010, DTR check form 53-60-05-02 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-250-967

84. EXTERNAL - SPECIAL DETAILED: Window Belt, STA 360 to 540

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

SUBTASK 53-05-02-250-164

- (1) Do a High Frequency Eddy Current inspection of the window frame around each passenger window on the left and right hand side from STA 360 to STA 540. (PSE 53-30-05-02)
See Doc. D626A010, DTR check form 53-60-05-02 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-210-815

85. INTERNAL - GENERAL VISUAL: Window Belt, STA 360 to 540

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

SUBTASK 53-05-02-210-014

- (1) Do a General Visual inspection of the skin at the skin to window frame fastener around each passenger window on the left and right hand side from STA 360 to STA 540. (PSE 53-30-05-03)
See Doc. D626A010, DTR check form 53-60-05-03 for alternative inspection.

————— **END OF TASK** —————

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TASK 53-05-02-250-968

86. INTERNAL - SPECIAL DETAILED: Window Belt, STA 360 to 540

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

SUBTASK 53-05-02-250-165

- (1) Do a High Frequency Eddy Current inspection of the skin at the skin to window frame fastener around each passenger window on the left and right hand side from STA 360 to STA 540. (PSE 53-30-05-03)

See Doc. D626A010, DTR check form 53-60-05-03 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-250-969

87. EXTERNAL - SPECIAL DETAILED: Window Belt, STA 360 to 540

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

SUBTASK 53-05-02-250-166

- (1) Do a High Frequency Eddy Current inspection of the skin at the skin to window frame fastener around each passenger window on the left and right hand side from STA 360 to STA 540. (PSE 53-30-05-03A)

See Doc. D626A010, DTR check form 53-60-05-03A.

————— **END OF TASK** —————

TASK 53-05-02-250-970

88. INTERNAL - SPECIAL DETAILED: Cutout - Forward Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

B. Access Panels

Number	Name/Location
821	Forward Cargo Door

C. Inspection

NOTE: Perform inspection with door open. Remove or displace cargo liners as required to perform this inspection. Remove sealant at door stops as required.

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SUBTASK 53-05-02-010-117

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

SUBTASK 53-05-02-250-167

- (2) Do a High Frequency Eddy Current inspection of the fwd and aft edge frame inner chord between the web and failsafe strap of the forward cargo door from S-18R to S-26R. (PSE 53-30-08-01)

See Doc. D626A010, DTR check form 53-60-08-01.

SUBTASK 53-05-02-410-118

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

————— END OF TASK —————

TASK 53-05-02-250-971

89. INTERNAL - SPECIAL DETAILED: Cutout - Forward Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

C. Inspection

NOTE: Perform inspection with door open. Remove cargo liners as required to perform this inspection.

SUBTASK 53-05-02-010-118

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

SUBTASK 53-05-02-250-168

- (2) Do a High Frequency Eddy Current inspection of the fwd and aft edge frame inner chord failsafe strap of forward cargo door between S-17R and S-18R. (PSE 53-30-08-02)

See Doc. D626A010, DTR check form 53-60-08-02 for alternative inspection.

SUBTASK 53-05-02-410-119

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

————— END OF TASK —————

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TASK 53-05-02-250-972

90. **INTERNAL - SPECIAL DETAILED: Cutout - Forward Cargo Door, Backup Surround Structure**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

B. Access Panels

Number	Name/Location
821	Forward Cargo Door

C. Inspection

NOTE: Perform inspection with door open. Remove sealant at door stops as required.

SUBTASK 53-05-02-010-119

- (1) Open this access panel:

Number	Name/Location
821	Forward Cargo Door

SUBTASK 53-05-02-250-169

- (2) Do a High Frequency Eddy Current inspection of the end of the fwd and aft edge frame inner chord of the forward cargo door at S-17R and S-18R. (PSE 53-30-08-03)

See Doc. D626A010, DTR check form 53-60-08-03.

SUBTASK 53-05-02-410-120

- (3) Close this access panel:

Number	Name/Location
821	Forward Cargo Door

————— **END OF TASK** —————

TASK 53-05-02-270-810

91. **INTERNAL - SPECIAL DETAILED: Cutout - Forward Cargo Door, Backup Surround Structure**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

B. Access Panels

Number	Name/Location
821	Forward Cargo Door

C. Inspection

NOTE: Perform inspection with door open. Remove cargo liners as required to perform this inspection.

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SUBTASK 53-05-02-010-120

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

SUBTASK 53-05-02-270-010

- (2) Do an Ultrasonic inspection of the outboard portion of the fwd and aft edge frame web under all door stop fittings and sill clip intersection locations of forward cargo door. (PSE 53-30-08-05)

See Doc. D626A010, DTR check form 53-60-08-05.

SUBTASK 53-05-02-410-121

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

————— END OF TASK —————

TASK 53-05-02-250-973

92. INTERNAL - SPECIAL DETAILED: Cutout - Forward Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

C. Inspection

SUBTASK 53-05-02-010-121

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

SUBTASK 53-05-02-250-170

- (2) Do a High Frequency Eddy Current inspection of the bearstrap for 2 inches on each side of the fwd and aft skin splice at S-24R, STA 440 and STA 492.4. (PSE 53-30-08-06)

See Doc. D626A010, DTR check form 53-60-08-06.

SUBTASK 53-05-02-410-122

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

————— END OF TASK —————

TASK 53-05-02-250-974

93. INTERNAL - SPECIAL DETAILED: Cutout - Forward Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

B. Access Panels

Number	Name/Location
821	Forward Cargo Door

C. Inspection

SUBTASK 53-05-02-010-122

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

SUBTASK 53-05-02-250-171

- (2) Do a High Frequency Eddy Current inspection of the fwd and aft frame bearstrap between the edge frames and cargo door cutout. (PSE 53-30-08-08)

See Doc. D626A010, DTR check form 53-60-08-08.

SUBTASK 53-05-02-410-123

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

————— END OF TASK —————

TASK 53-05-02-270-811

94. INTERNAL - SPECIAL DETAILED: Bulkhead and Splices, STA 663

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
132	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Right
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
137	Area Above M.L.G. Wheel Well, Body Station 663.75 to Body Station 727 - Left
138	Area Above M.L.G. Wheel Well, Body Station 663.75 Body Station 727 - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

B. Inspection

NOTE: Removal of the wing-to-body fairing is required for proper Inspection.

SUBTASK 53-05-02-270-011

- (1) Do an Ultrasonic inspection along edge of skin S-18 strap of the lower fitting failsafe strap at STA 663.75, WL 195, on both the left and right hand side.

See Doc. D626A010, DTR check form 53-40-15-06.

————— END OF TASK —————

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TASK 53-05-02-250-975

95. INTERNAL - SPECIAL DETAILED: Wheel Well Aft Bulkhead and Pressure Web, STA 727

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
143	Area Below Aft Cargo Compartment - Left
144	Area Below Aft Cargo Compartment - Right

B. Inspection

NOTE: Sealant removal around fasteners is required before inspection.

SUBTASK 53-05-02-250-172

- (1) Do a High Frequency Eddy Current inspection of the failsafe angle at frame STA 727 from stringer S-21 to S-27 on both the left and right hand side. Inspect around each fastener common to the skin and web. When fasteners are impaired by stringer clips/beam clips then inspect around the edge of each clip.

See Doc. D626A010, DTR check form 53-40-16-01A.

————— **END OF TASK** —————

TASK 53-05-02-250-976

96. EXTERNAL - SPECIAL DETAILED: Wheel Well Aft Bulkhead and Pressure Web, STA 727

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
143	Area Below Aft Cargo Compartment - Left
144	Area Below Aft Cargo Compartment - Right

B. Inspection

SUBTASK 53-05-02-250-173

- (1) Do a High Frequency Eddy Current inspection of the outer chord at frame STA 727 from stringer S-21 to S-27 on both the left and right hand side.

See Doc. D626A010, DTR check form 53-40-16-01B.

————— **END OF TASK** —————

TASK 53-05-02-270-812

97. INTERNAL - SPECIAL DETAILED: Wheel Well Aft Bulkhead and Pressure Web, STA 727

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
143	Area Below Aft Cargo Compartment - Left
144	Area Below Aft Cargo Compartment - Right

B. Inspection

NOTE: Remove and/or displace the forward bulkhead panels, sidewall ceiling panels and insulation blankets as required.

SUBTASK 53-05-02-270-012

- (1) Do an Ultrasonic inspection of the frame around the seven fasteners through the inner chord and web at WL 201.

See Doc. D626A010, DTR check form 53-40-16-02.

————— **END OF TASK** —————

TASK 53-05-02-250-977

98. INTERNAL - SPECIAL DETAILED: Wheel Well Aft Bulkhead and Pressure Web, STA 727

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove and/or displace passenger cabin ceiling panels and insulation as required to perform the inspection.

SUBTASK 53-05-02-250-174

- (1) Do a High Frequency Eddy Current inspection of the frame web that is visible outboard of the failsafe chord on the forward side of the frame web between S-9 to S-10 on both the left and right hand side.

See Doc. D626A010, DTR check form 53-40-16-06 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-250-978

99. INTERNAL - SPECIAL DETAILED: Side Strut Support Frame, STA 706

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove and/or displace passenger cabin sidewalls and insulation blankets as required to perform the inspection.

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SUBTASK 53-05-02-250-175

- (1) Do a High Frequency Eddy Current inspection of the frame inner chord, the failsafe angle around fasteners common to the failsafe angle between S-10 and S-13, the forward frame web around fasteners between S-10 and S-14, and the frame outer chord around fasteners common to the skin between S-10 to S-14. The inspection is on both the left and right hand side.

See Doc. D626A010, DTR check form 53-40-17-01 for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-211-892

100. INTERNAL - DETAILED: Side Strut Support Frame, STA 706

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove and/or displace passenger cabin sidewalls and insulation blankets as required to perform the inspection.

SUBTASK 53-05-02-211-091

- (1) Do a Detailed inspection of the upper flange of the frame following the edge of the flange, and around all web and lower flange fasteners on both the fwd and aft frames of the stub beam at STA 706, BL 46 to BL 63, on both the left and right hand side.

See Doc. D626A010, DTR check form 53-40-17-03 for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-979

101. INTERNAL - SPECIAL DETAILED: Side Strut Support Frame, STA 706

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-176

- (1) Do a Low Frequency Eddy Current inspection around all fasteners hidden by the intercostal parts at STA 706, S-14 on both the left and right hand side.

See Doc. D626A010, DTR check form 53-40-17-04.

————— END OF TASK —————

TASK 53-05-02-250-980

102. INTERNAL - SPECIAL DETAILED: Main Landing Gear Support Frame, STA 716

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

Zone	Area
137	Area Above M.L.G. Wheel Well, Body Station 663.75 to Body Station 727 - Left
138	Area Above M.L.G. Wheel Well, Body Station 663.75 Body Station 727 - Right

B. Inspection

NOTE: Remove and/or displace passenger cabin sidewall panels, sidewall air grilles, and insulation blankets as required to perform the inspection.

SUBTASK 53-05-02-250-177

- (1) Do a High Frequency Eddy Current inspection of the frame web around the fasteners common to the stringer clip at S-16 and the forward and aft flanges of the frame inner chord from 6 inches above S-16 to 6 inches below S-16, on both the left and right hand side.

See Doc. D626A010, DTR check form 53-40-19-01 for alternative inspection.

———— **END OF TASK** ————

TASK 53-05-02-211-893

103. INTERNAL - DETAILED: Overwing Frames and Stub Beams

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
135	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Left
136	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Right
137	Area Above M.L.G. Wheel Well, Body Station 663.75 to Body Station 727 - Left
138	Area Above M.L.G. Wheel Well, Body Station 663.75 Body Station 727 - Right

B. Access Panels

Number	Name/Location
231ZF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
232SF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
241CF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
241FF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
242BF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
242DF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)

C. Inspection

NOTE: Remove floor panels. Remove/displace insulation blankets as required.

SUBTASK 53-05-02-010-123

- (1) Open these access panels:

Number	Name/Location
231ZF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
232SF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
241CF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
241FF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
242BF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
242DF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)

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SUBTASK 53-05-02-211-092

- (2) Do a Detailed inspection of the overwing frames below S-17 at stub beam attachment, on both the left and right hand side. This inspection is for all overwing frames (STA 559, 578, 601, 616, and 639)

See Doc. D626A010, DTR check form 53-40-20-02 for alternative inspection.

SUBTASK 53-05-02-410-124

- (3) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
231ZF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
232SF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
241CF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
241FF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
242BF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)
242DF	PANEL ASSY - PASSENGER CABIN FLOOR ACCESS - (SEC 44)

————— **END OF TASK** —————

TASK 53-05-02-250-981

104. **EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
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 53-05-02-250-178

- (1) Do a High Frequency Eddy Current inspection of the S-4 lap splice upper row from STA 259.5 to STA 360, left and right hand side.

See Doc. D626A010, DTR check form 53-10-03-01 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-250-982

105. **EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
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 53-05-02-250-179

- (1) Do a Low Frequency Eddy Current inspection of the S-4 lap splice lower row from STA 259.5 to STA 360, left and right hand side.

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See Doc. D626A010, DTR check form 53-10-03-02 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-250-983

106. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

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 53-05-02-250-180

- (1) Do a High Frequency Eddy Current inspection of the S-14 lap upper fastener row between the following stations, left and right hand side:

S-14L from STA 259.5 to STA 294.5, and STA 350 to STA 360

S-14R from STA 259.5 to STA 277, and STA 344 to STA 360

See Doc. D626A010, DTR check form 53-10-03-03 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-250-984

107. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

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 53-05-02-250-181

- (1) Do a Low Frequency Eddy Current inspection of the S-14 lap lower fastener row between the following stations, left and right hand side:

S-14L from STA 259.5 to STA 294.5 and STA 350 to STA 360

S-14R from STA 259.5 to STA 277 and STA 344 to STA 360

See Doc. D626A010, DTR check form 53-10-03-04 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-250-985

108. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

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

B. Inspection

SUBTASK 53-05-02-250-182

- (1) Do a Low Frequency Eddy Current inspection of the S-24 lap splice upper row from STA 178 to STA 360, left and right hand side.

See Doc. D626A010, DTR check form 53-10-03-05 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-250-986

109. INTERNAL - SPECIAL DETAILED: Cutout - Crew Cabin Windows

NOTE: This procedure is a scheduled maintenance task.

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 53-05-02-250-183

- (1) Do a High Frequency Eddy Current inspection of the A-B post structure, from the inside of the aircraft, between upper and lower sills.

See Doc. D626A010, DTR check form 53-10-04-01.

————— **END OF TASK** —————

TASK 53-05-02-211-894

110. EXTERNAL - DETAILED: Cutout - Crew Cabin Windows

NOTE: This procedure is a scheduled maintenance task.

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 53-05-02-211-093

- (1) Do a Detailed inspection of the C-D post from the outside of the aircraft, along the entire post length, left and right hand side.

See Doc. D626A010, DTR check form 53-10-04-02.

————— **END OF TASK** —————

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TASK 53-05-02-210-816

111. **EXTERNAL - GENERAL VISUAL: Cutout - Crew Cabin Windows**

NOTE: This procedure is a scheduled maintenance task.

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 53-05-02-210-015

- (1) Do a General Visual inspection of the E-F post from the outside of the aircraft, along the entire post length, left and right hand side.

See Doc. D626A010, DTR check form 53-10-04-03.

————— **END OF TASK** —————

TASK 53-05-02-211-895

112. **EXTERNAL - DETAILED: Cutout - Crew Cabin Windows**

NOTE: This procedure is a scheduled maintenance task.

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 53-05-02-211-094

- (1) Do a Detailed inspection of the E-F post from the outside of the aircraft, along the entire post length, left and right hand side.

See Doc. D626A010, DTR check form 53-10-04-03.

————— **END OF TASK** —————

TASK 53-05-02-250-987

113. **EXTERNAL - SPECIAL DETAILED: Crew Cabin Windows**

NOTE: This procedure is a scheduled maintenance task.

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 53-05-02-250-184

- (1) Do a Low Frequency Eddy Current inspection of both rows of fasteners attaching the skin to the B-D sill between BL 8 and BL 26.5 on the left and right hand side.

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See Doc. D626A010, DTR check form 53-10-04-04.

————— END OF TASK —————

TASK 53-05-02-250-988

114. INTERNAL - SPECIAL DETAILED: Cutout - Crew Cabin Windows

NOTE: This procedure is a scheduled maintenance task.

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

NOTE: Remove glesheild as required to perform inspection.

SUBTASK 53-05-02-250-185

- (1) Do a High Frequency Eddy Current inspection of the flanges and web of the point "D" fitting, from the CD post inboard, around all four fasteners common to the BD sill, on both the left and right side.

See Doc. D626A010, DTR check form 53-10-04-05.

————— END OF TASK —————

TASK 53-05-02-250-989

115. INTERNAL - SPECIAL DETAILED: Cutout - Crew Cabin Windows

NOTE: This procedure is a scheduled maintenance task.

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

NOTE: Remove sealant as required.

SUBTASK 53-05-02-250-186

- (1) Do a High Frequency Eddy Current inspection of the inconel angle around the seven (7) fasteners that join the angle to the B-D sill web and point "D", left and right hand side.

NOTE: There are three (3) fasteners that join the angle, web, and fitting. There are four (4) fasteners that join the angle and the fitting.

See Doc. D626A010, DTR check form 53-10-04-06.

————— END OF TASK —————

TASK 53-05-02-250-990

116. EXTERNAL - SPECIAL DETAILED: Crown Skin Panel - Fwd of STA 259.5

NOTE: This procedure is a scheduled maintenance task.

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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 53-05-02-250-187

- (1) Do a Low Frequency Eddy Current inspection of the splice strap under the crown skin, fwd of STA 259.5, at the first row of fasteners left and right of BL 0.0.
See Doc. D626A010, DTR check form 53-10-05-01.

————— END OF TASK —————

TASK 53-05-02-211-896

117. EXTERNAL - DETAILED: Crown Skin Panel - STA 259.5 to 360

NOTE: This procedure is a scheduled maintenance task.

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 53-05-02-211-095

- (1) Do a Detailed inspection of the skin around all fastener locations from S-10L to S-10R, except at the lap splices and antenna locations. (PSE 53-10-08-01).
See Doc. D626A010, DTR check form 53-30-01-01.

————— END OF TASK —————

TASK 53-05-02-210-817

118. EXTERNAL- GENERAL VISUAL: Upper Door Skin Panel, STA 259.5 to 360.

NOTE: This procedure is a scheduled maintenance task.

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 53-05-02-210-016

- (1) Do a General Visual inspection of the upper door skin panels (entry and galley doors), from S-4 thorough S-14, left and right hand side.
See Doc. D626A010, DTR check form 53-10-09-02 for alternative inspection.

————— END OF TASK —————

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TASK 53-05-02-210-818

119. EXTERNAL - GENERAL VISUAL: Lower Door Skin Panel, STA 259.5 to 360.

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

B. Inspection

SUBTASK 53-05-02-210-017

- (1) Do a General Visual inspection of the lower door skin panels (entry and galley doors), from S-14 through S-24 (left and right hand side). (PSE 53-10-10-02).

See Doc. D626A010, DTR check form 53-10-09-02 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-270-813

120. INTERNAL - SPECIAL DETAILED: Forward Access Door Cutout Bulkhead, STA 213 Chord

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

B. Inspection

NOTE: Remove/displace insulation as required.

SUBTASK 53-05-02-270-013

- (1) Do an Ultrasonic inspection of the chord nearest to the nose wheel well cutout and the chord under the door fittings, left and right hand side. (PSE 53-10-12-02)

See Doc. D626A010, DTR check form 53-10-23-01A for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-250-991

121. INTERNAL - SPECIAL DETAILED: Forward Access Door Cutout Bulkhead, STA 213 Chord

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
112	Area Forward of Nose Landing Gear Wheel Well

B. Inspection

NOTE: Remove/displace insulation as required.

SUBTASK 53-05-02-250-188

- (1) Do a High Frequency Eddy Current inspection of the chord nearest to the nose wheel well cutout, inspect every fastener common to the chord between LBL 15.6 and RBL 15.6 and inspect the fasteners where the chord is not hidden by the fittings. (PSE 53-10-12-02)

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See Doc. D626A010, DTR check form 53-10-23-01B.

————— END OF TASK —————

TASK 53-05-02-250-992

122. EXTERNAL - SPECIAL DETAILED: Cutout - Electronic Equipment Door

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>

117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

B. Inspection

SUBTASK 53-05-02-250-189

- (1) Do a High Frequency Eddy Current inspection of the skin around the entire perimeter of the electronic equipment door cutout bounded by STA 323.7 and STA 351.2, RBL 15.47 and LBL 6.74, and the two fastener rows adjacent to the cutout edge.

See Doc. D626A010, DTR check form 53-10-13-01 for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-211-897

123. INTERNAL - SPECIAL DETAILED: Cutout - Electronic Equipment Door

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>

117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>

117A	Electronic Equipment Access Door

C. Inspection

SUBTASK 53-05-02-010-124

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>

117A	Electronic Equipment Access Door

SUBTASK 53-05-02-250-190

- (2) Do a High Frequency Eddy Current inspection of the outer chords and the fastener row adjacent to the cutout edge bounded by STA 323.7 and STA 351.2, RBL 15.47 and LBL 6.74.

See Doc. D626A010, DTR check form 53-10-13-01 for alternative inspection.

SUBTASK 53-05-02-410-125

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>

117A	Electronic Equipment Access Door

————— END OF TASK —————

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TASK 53-05-02-250-993

124. EXTERNAL- SPECIAL DETAILED: Cutout - Forward Entry Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
831	Forward Entry Door

C. Inspection

SUBTASK 53-05-02-010-125

- (1) Open this access panel:

Number	Name/Location
831	Forward Entry Door

SUBTASK 53-05-02-250-191

- (2) Do a High Frequency Eddy Current inspection of the two rows of fasteners common to the forward edge frame, STA 303.9, and skin between stringers S-7L and S-13L.

See Doc. D626A010, DTR check form 53-10-14-04 for alternative inspection.

SUBTASK 53-05-02-410-126

- (3) Close this access panel:

Number	Name/Location
831	Forward Entry Door

————— END OF TASK —————

TASK 53-05-02-211-898

125. INTERNAL - DETALIED: Cutout - Forward Entry Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

NOTE: Remove interior panels as required. Any sealant beyond 0.4 inches around the fastener collar must be removed.

SUBTASK 53-05-02-211-096

- (1) Do a Detailed inspection around fasteners in the inboard flange of the stop fittings at S-7 through S-16, forward edge frame, STA 303.9.

See Doc. D626A010, DTR check form 53-10-14-07 for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-994

126. INTERNAL - SPECIAL DETAILED: Cutout - Forward Entry Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

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

B. Inspection

NOTE: Remove interior panels as required. Remove any sealant around the fastener heads before inspecting the strap.

SUBTASK 53-05-02-250-192

- (1) Do a High Frequency Eddy Current inspection around the four fasteners common to the door stop on each strap at S-7 through S-14, forward edge frame, STA 303.9.
See Doc. D626A010, DTR check form 53-10-14-08 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-250-995

127. INTERNAL - SPECIAL DETAILED: Cutout - Forward Entry Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

NOTE: Remove interior panels as required. Remove any sealant around the fastener heads before inspecting the strap.

SUBTASK 53-05-02-250-193

- (1) Do a High Frequency Eddy Current inspection around the first two fasteners in the necked down section of the strap at S-15 and S-16, forward edge frame, STA 303.9.
See Doc. D626A010, DTR check form 53-10-14-09 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-211-899

128. INTERNAL - DETAILED: Cutout - Forward Entry Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
831	Forward Entry Door

C. Inspection

NOTE: Open forward entry door and remove interior panels as required.

SUBTASK 53-05-02-010-126

- (1) Open this access panel:
- | <u>Number</u> | <u>Name/Location</u> |
|---------------|----------------------|
| 831 | Forward Entry Door |

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SUBTASK 53-05-02-250-194

- (2) Do a Detailed inspection of the aft edge frame, STA 348.2, stop fittings inner flanges at S-7 through S-14 locations.

See Doc. D626A010, DTR check form 53-10-14-11 for alternative inspection.

SUBTASK 53-05-02-410-127

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
831	Forward Entry Door

————— END OF TASK —————

TASK 53-05-02-250-996

129. INTERNAL - SPECIAL DETAILED: Cutout - Forward Entry Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

B. Inspection

NOTE: Removal of the scuff plates is required.

SUBTASK 53-05-02-250-195

- (1) Do a High Frequency Eddy Current inspection of the skin/bearstrap around fastener holes and along the edge of the cutout, STA 303 to STA 350, hidden by the scuff plates. Also, perform inspection on the lower edges of the cutout for the forward galley service door.

See Doc. D626A010, DTR check form 53-10-14-12 for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-997

130. EXTERNAL - SPECIAL DETAILED: Cutout - Forward Entry Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

B. Inspection

NOTE: Removal of the scuff plates is required.

SUBTASK 53-05-02-250-196

- (1) Do a High Frequency Eddy Current inspection of the skin/bearstrap around fastener holes and along the edge of the cutout, STA 303 to STA 350, hidden by the scuff plates. Also, perform inspection on the lower edges of the cutout for the forward galley service door.

See Doc. D626A010, DTR check form 53-10-14-12 for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-998

131. INTERNAL - SPECIAL DETAILED: Cutout - Forward Entry Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

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

B. Inspection

SUBTASK 53-05-02-250-197

- (1) Do a High Frequency Eddy Current inspection of the chord at the forward edge frame, STA 303.9, lower main sill attachment.

See Doc. D626A010, DTR check form 53-10-14-13.

————— END OF TASK —————

TASK 53-05-02-250-999

132. INTERNAL - SPECIAL DETAILED: Cutout - Forward Entry Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

SUBTASK 53-05-02-250-198

- (1) Do a Low Frequency Eddy Current inspection of the strap at the lower auxiliary sill, STA 296, forward edge frame attachment.

See Doc. D626A010, DTR check form 53-10-14-15.

————— END OF TASK —————

TASK 53-05-02-250-A00

133. INTERNAL - SPECIAL DETAILED: Cutout - Forward Galley Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

NOTE: Remove interior panels as required.

SUBTASK 53-05-02-250-199

- (1) Do a High Frequency Eddy Current inspection of the four (4) fasteners at each door stop location, adjacent to the STA 291.5 edge frame.

See Doc. D626A010, DTR check form 53-10-15-02 for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-A01

134. EXTERNAL - SPECIAL DETAILED: Cutout - Forward Galley Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

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

B. Inspection

SUBTASK 53-05-02-250-200

- (1) Do a High Frequency Eddy Current inspection around fasteners common to the skin and chords between stringers S-8R and S-14R at the forward and aft edge frames at STA 291.5 and STA 328.5.

See Doc. D626A010, DTR check form 53-10-15-04 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-250-A02

135. INTERNAL - SPECIAL DETAILED: Bulkhead, STA 294.5

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

B. Inspection

NOTE: Access through E/E bay aft of nose wheel well.

SUBTASK 53-05-02-250-201

- (1) Do a High Frequency Eddy Current inspection of the fasteners at the WL 172 beam (also known as the nose wheel well aft bulkhead upper chord) at the intersection of the nose wheel well side panel (between BL 15 and BL 17).

See Doc. D626A010, DTR check form 53-10-18-01 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-250-A03

136. INTERNAL - SPECIAL DETAILED: Nose Wheel Well Side and Top Panels

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right

B. Inspection

NOTE: Sealant removal around the fasteners or edges is required.

SUBTASK 53-05-02-250-202

- (1) Do a High Frequency Eddy Current inspection around the fasteners along the centerline of the beam, STA 226 to STA 251.

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See Doc. D626A010, DTR check form 53-10-19-01 for alternative inspection.

END OF TASK

TASK 53-05-02-211-900

137. INTERNAL - DETAILED: Nose Wheel Well Side and Top Panels

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right

B. Access Panels

Number	Name/Location
113BW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

C. Inspection

SUBTASK 53-05-02-010-127

- (1) Open these access panels:

Number	Name/Location
113BW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

SUBTASK 53-05-02-211-097

- (2) Do a Detailed inspection of the following locations:

Side panel web from STA 259.5 to STA 294.5

STA 268 and STA 285 vertical beams

Upper sill of the aft cutout from STA 268 to STA 285

Lower sill of the aft cutout from STA 259.5 to STA 285

See Doc. D626A010, DTR check form 53-10-19-03 for alternative inspection.

SUBTASK 53-05-02-410-128

- (3) Close these access panels:

Number	Name/Location
113BW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

END OF TASK

TASK 53-05-02-211-901

138. INTERNAL - DETAILED: Nose Landing Gear Support Fittings

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
115	Nose Landing Gear Wheel Well - Left

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Zone	Area
116	Nose Landing Gear Wheel Well - Right

B. Access Panels

Number	Name/Location
113AC	Fwd Nose Wheel Well Upper Access Panel
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel
114AC	Fwd Nose Wheel Well Upper Access Panel
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

C. Inspection

SUBTASK 53-05-02-010-128

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
113AC	Fwd Nose Wheel Well Upper Access Panel
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel
114AC	Fwd Nose Wheel Well Upper Access Panel
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

SUBTASK 53-05-02-211-098

- (2) Do a Detailed inspection of the inboard and outboard fittings around the perimeter of the bushings and the webs of the fittings, STA 258.9, WL 189.3, LBL/RBL 16.

See Doc. D626A010, DTR check form 53-10-20-02.

SUBTASK 53-05-02-410-129

- (3) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
113AC	Fwd Nose Wheel Well Upper Access Panel
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel
114AC	Fwd Nose Wheel Well Upper Access Panel
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

————— **END OF TASK** —————

TASK 53-05-02-211-902

139. INTERNAL - DETAILED: Nose Landing Gear Support Fittings

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
115	Nose Landing Gear Wheel Well - Left

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Zone	Area
116	Nose Landing Gear Wheel Well - Right

B. Access Panels

Number	Name/Location
113AC	Fwd Nose Wheel Well Upper Access Panel
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel
114AC	Fwd Nose Wheel Well Upper Access Panel
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

C. Inspection

SUBTASK 53-05-02-010-129

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
113AC	Fwd Nose Wheel Well Upper Access Panel
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel
114AC	Fwd Nose Wheel Well Upper Access Panel
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

SUBTASK 53-05-02-211-099

- (2) Do a Detailed inspection of the inboard and outboard segments of the trunnion support fitting around the pin socket, STA 294.5, WL 156.1, LBL/RBL 16.

See Doc. D626A010, DTR check form 53-10-20-03.

SUBTASK 53-05-02-410-130

- (3) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
113AC	Fwd Nose Wheel Well Upper Access Panel
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel
114AC	Fwd Nose Wheel Well Upper Access Panel
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

———— **END OF TASK** ————

TASK 53-05-02-250-A04

140. INTERNAL - SPECIAL DETAILED: Cutout - Airstair Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left

B. Inspection

NOTE: For airplanes with airstairs door only.

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SUBTASK 53-05-02-250-203

- (1) Do a High Frequency Eddy Current inspection of the edge frame web along the outboard edge of the inner chord, STA 303.9 and STA 351.2.

See Doc. D626A010, DTR check form 53-10-21-03 for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-A05

141. INTERNAL - SPECIAL DETAILED: Cutout - Airstair Door, Backup Surround Structure

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

117BL	Forward Airstair Door

C. Inspection

NOTE: For airplanes with airstairs door only.

NOTE: Open airstair door.

SUBTASK 53-05-02-010-130

- (1) Open this access panel:

Number	Name/Location

117BL	Forward Airstair Door

SUBTASK 53-05-02-250-204

- (2) Do a Low Frequency Eddy Current inspection of the forward and aft edge frame webs around fasteners common to shear clips and stiffener locations where the edge frame web is hidden, STA 303.9 and STA 351.2.

See Doc. D626A010, DTR check form 53-10-21-04.

SUBTASK 53-05-02-410-131

- (3) Close this access panel:

Number	Name/Location

117BL	Forward Airstair Door

————— END OF TASK —————

TASK 53-05-02-270-814

142. INTERNAL - SPECIAL DETAILED: Cutout - Nose Wheel Well

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

112	Area Forward of Nose Landing Gear Wheel Well

113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left

114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right

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B. Inspection

NOTE: Remove/displace insulation as required.

SUBTASK 53-05-02-270-014

- (1) Do an Ultrasonic inspection of the chord nearest to the nose wheel well cutout and the chord, STA 216, LBL/RBL 7.8, under the door fittings, left and right hand side.

See Doc. D626A010, DTR check form 53-10-23-01A for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-A06

143. INTERNAL - SPECIAL DETAILED: Cutout - Nose Wheel Well

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

112	Area Forward of Nose Landing Gear Wheel Well
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right

B. Inspection

NOTE: Remove/displace insulation as required.

SUBTASK 53-05-02-250-205

- (1) Do a High Frequency Eddy Current inspection of the chord nearest to the nose wheel well cutout, inspect every fastener common to the chord, STA 216, between LBL 15.6 and RBL 15.6 and inspect the fasteners where the chord is not hidden by the fittings.

See Doc. D626A010, DTR check form 53-10-23-01B.

————— END OF TASK —————

TASK 53-05-02-211-903

144. EXTERNAL - DETAILED: Crown Skin Panel - STA 360 to 540

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-211-100

- (1) Do a Detailed inspection of the skin around all fastener locations from S-10L to S-10R except at the lap splices and antenna locations.

See Doc. D626A010, DTR check form 53-30-01-01.

————— END OF TASK —————

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TASK 53-05-02-250-A07

145. INTERNAL - SPECIAL DETAILED: Crown Skin Panel - STA 360 to 540

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

NOTE: Remove the TCAS antenna to expose the crown skin common to the cutout.

SUBTASK 53-05-02-250-206

- (1) Do a High Frequency Eddy Current inspection of the edges of the TCAS antenna cutout in the Section 43 crown skin, STA 385.

See Doc. D626A010, DTR check form 53-30-01-04.

———— **END OF TASK** ————

TASK 53-05-02-211-904

146. INTERNAL - DETAILED: Crown Skin Panel - STA 360 to 540

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

NOTE: Removal of external antenna fairings and base plates are required. Remove the antenna before inspection. Remove the antenna and adapter plate or cover plate to gain access to the skin prior to inspection. Remove all applicable penetration cover plates if installed.

SUBTASK 53-05-02-211-101

- (1) Do a Detailed inspection of the crown skin panel under the footprint of the antenna adapter plate or cover plate between STA 360 and STA 540 for the following antenna cutouts:

ATC Antenna, STA 430,RBL 5.0

Iridium SATCOM Antenna, STA 450, LBL 5.0

AWLU/TWLU Antenna, STA 463.8, RBL 5.0

AWLU/TWLU Antenna, STA 476.4, RBL 5.0

AID Antenna, STA 476.4, RBL 5.0

GPS Antenna, STA 500A+5 and STA 500A+15, RBL/LBL 5.0

737-7: EGLA/ALGA SATCOM Antenna, STA 528.5, LBL 4.735

737-8/8200: EGLA/ALGA SATCOM Antenna, STA 500H+7.0,LBL 4.735

737-9: EGLA/ALGA SATCOM Antenna, STA 500K+7.0,LBL 4.735

See Doc. D626A010, DTR check form 53-30-01-04A.

———— **END OF TASK** ————

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TASK 53-05-02-210-819

147. EXTERNAL - GENERAL VISUAL: Side Skin Panel - STA 360 to 540

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
194	Lower Wing-To-Body Fairing - Aft of Wheel Well
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-210-018

- (1) Do a General Visual inspection of the fuselage skin, STA 360 to STA 540, S-14 to S-17, left and right hand side.

See Doc. D626A010, DTR check form 53-30-02-02 for alternative inspection.

END OF TASK

TASK 53-05-02-211-905

148. EXTERNAL - DETAILED: Side Skin Panel - STA 360 to 540

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
143	Area Below Aft Cargo Compartment - Left
144	Area Below Aft Cargo Compartment - Right
191	Lower Wing-To-Body Fairing - Forward of Wing Box
194	Lower Wing-To-Body Fairing - Aft of Wheel Well
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Access Panels

Number	Name/Location
191AL	Forward Wing-To-Body Fairing Panel - Upper
191AR	Forward Wing-To-Body Fairing Panel - Upper
195AL	Wing-To-Body Fairing - Left Side

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Number	Name/Location

195AR	Wing-To-Body Fairing - Right Side

C. Inspection

NOTE: Remove or displace wing-to-body fairings as required to perform this inspection.

SUBTASK 53-05-02-010-131

(1) Open these access panels:

Number	Name/Location

191AL	Forward Wing-To-Body Fairing Panel - Upper
191AR	Forward Wing-To-Body Fairing Panel - Upper
195AL	Wing-To-Body Fairing - Left Side
195AR	Wing-To-Body Fairing - Right Side

SUBTASK 53-05-02-211-102

(2) Do a Detailed inspection of the fuselage skin panels under the wing-to-body fairing.

See Doc. D626A010, DTR check form 53-30-02-04.

SUBTASK 53-05-02-410-132

(3) Close these access panels:

Number	Name/Location

191AL	Forward Wing-To-Body Fairing Panel - Upper
191AR	Forward Wing-To-Body Fairing Panel - Upper
195AL	Wing-To-Body Fairing - Left Side
195AR	Wing-To-Body Fairing - Right Side

————— END OF TASK —————

TASK 53-05-02-270-815

149. EXTERNAL - SPECIAL DETAILED: Side Skin Panel - STA 360 to 540

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
191	Lower Wing-To-Body Fairing - Forward of Wing Box
192	Lower Wing-To-Body Fairing - Under Wing Box

B. Access Panels

Number	Name/Location

191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward

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C. Inspection

SUBTASK 53-05-02-010-132

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward

SUBTASK 53-05-02-270-015

- (2) Do an Ultrasonic inspection of the skin underneath wing-to-body drag angle, forward of STA 536, S-21 to S-22, on the left and right hand side.

See Doc. D626A010, DTR check form 53-30-02-05B.

SUBTASK 53-05-02-410-133

- (3) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward

————— END OF TASK —————

TASK 53-05-02-210-820

150. EXTERNAL - GENERAL VISUAL: Side Skin Panel - STA 360 to 540

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

SUBTASK 53-05-02-210-019

- (1) Do a General Visual inspection of the upper frames and the lower frames between S-11 and S-15 on both the left and right hand side, and inspect the inner chord, doubler and failsafe chord.

This inspection includes:

737-7: STA 500C, 500D, 500E, and 520

737-8 and 737-8200: STA 500G, 500H, 500I, and 520

737-9: STA 500J, 500K, 500L, and 520

See Doc. D626A010, DTR check form 53-30-02-06.

————— END OF TASK —————

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TASK 53-05-02-211-906

151. EXTERNAL - DETAILED: Side Skin Panel - STA 360 to 540

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

SUBTASK 53-05-02-211-103

- (1) Do a Detailed inspection of the upper frames and the lower frames between S-11 and S-15 on both the left and right hand side, and inspect the inner chord, doubler and failsafe chord.

This inspection includes:

737-7: STA 500C, 500D, 500E, and 520

737-8 and 737-8200: STA 500G, 500H, 500I, and 520

737-9: STA 500J, 500K, 500L, and 520

See Doc. D626A010, DTR check form 53-30-02-06.

————— **END OF TASK** —————

TASK 53-05-02-211-907

152. INTERNAL - DETAILED: Side Skin Panel - STA 360 to 540

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
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right

B. Inspection

NOTE: Removal of side panels required to gain access.

SUBTASK 53-05-02-211-104

- (1) Do a Detailed inspection of the side frames inner chord, web, doubler, and failsafe chords between STA 380 and STA 520, between stringers S-18 and S-26, on the left and right hand side. In addition, inspect the frame splices between S-24R and S-26R.

See Doc. D626A010, DTR check form 53-30-02-07.

NOTE: The inspection excludes the cargo door side frames.

————— **END OF TASK** —————

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TASK 53-05-02-210-821

153. EXTERNAL - GENERAL VISUAL: Side Skin Panel - STA 360 to 540

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right

B. Inspection

SUBTASK 53-05-02-210-020

- (1) Do a General Visual inspection of the fuselage skin, S-24L to S-24R. (PSE 53-30-03-02)
See Doc. D626A010, DTR check form 53-30-02-02 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-211-908

154. EXTERNAL - DETAILED: Bilge Skin Panel - STA 360 to 540

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
191	Lower Wing-To-Body Fairing - Forward of Wing Box

B. Inspection

NOTE: Remove cargo floor panels and scuff plates. Remove/Displace insulation blankets as required.

SUBTASK 53-05-02-211-105

- (1) Do a Detailed inspection of the drain mast cutout, STA 500I+16.5. (PSE 53-30-03-07).
See Doc. D626A010, DTR check form 53-30-02-04.

————— **END OF TASK** —————

TASK 53-05-02-250-A08

155. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

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B. Inspection

SUBTASK 53-05-02-250-207

- (1) Do a High Frequency Eddy Current inspection of the S-4L and S-4R lap splice upper fastener row, STA 360 to STA 540.

See Doc. D626A010, DTR check form 53-30-04-01.

————— END OF TASK —————

TASK 53-05-02-250-A09

156. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-208

- (1) Do a Low Frequency Eddy Current inspection of the S-4L and S-4R lap splice lower fastener row, STA 360 to STA 540.

See Doc. D626A010, DTR check form 53-30-04-02.

————— END OF TASK —————

TASK 53-05-02-250-A10

157. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-209

- (1) Do a High Frequency Eddy Current inspection of the S-10L and S-10R lap splice upper fastener row, STA 360 to STA 540.

See Doc. D626A010, DTR check form 53-30-04-03.

————— END OF TASK —————

TASK 53-05-02-211-909

158. INTERNAL - DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove interior panels as required.

SUBTASK 53-05-02-211-106

- (1) Do a Detailed inspection of the S-10L and S-10R lap splice lower fastener row, STA 360 to STA 540.

See Doc. D626A010, DTR check form 53-30-04-04.

————— **END OF TASK** —————

TASK 53-05-02-211-910

159. EXTERNAL - DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-211-107

- (1) Do a Detailed inspection of the S-14L and S-14R lap splice upper fastener row, STA 360 to STA 540.

See Doc. D626A010, DTR check form 53-30-04-05.

————— **END OF TASK** —————

TASK 53-05-02-250-A11

160. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-210

- (1) Do a Low Frequency Eddy Current inspection of the S-14L and S-14R lap splice lower fastener row, STA 360 to STA 540.

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See Doc. D626A010, DTR check form 53-30-04-06.

————— END OF TASK —————

TASK 53-05-02-211-912

161. EXTERNAL - DETAILED: Bilge Skin Panel - STA 887 to 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

145	Aft Cargo Compartment Equipment Bay - Left

B. Inspection

NOTE: Removal of drain mast required.

SUBTASK 53-05-02-211-109

- (1) Do a Detailed inspection of the exterior side of the fuselage skin around the drain mast cutout at STA 986.5 to STA 1006, S-24L to S-25L.

See. Doc. D626A010, DTR check form 53-70-01-04.

————— END OF TASK —————

TASK 53-05-02-211-913

162. EXTERNAL - DETAILED: Circumferential Skin and Stringer Splice, STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-211-110

- (1) Do a Detailed inspection of the skin around all fastener locations from S-10L to S-10R at STA 1016, except at the lap splices and antenna locations. (PSE 53-70-02-03)

See Doc. D626A010, DTR check form 53-30-01-01.

————— END OF TASK —————

TASK 53-05-02-250-A14

163. EXTERNAL – SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area

241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-213

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringer S-4L and S-4R from STA 887 to STA 1016.

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See Doc. D626A010, DTR check form 53-70-03-01.

————— END OF TASK —————

TASK 53-05-02-250-A15

164. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-214

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringer S-4L and S-4R from STA 887 to STA 1016.

See Doc. D626A010, DTR check form 53-70-03-02.

————— END OF TASK —————

TASK 53-05-02-250-A16

165. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-215

- (1) Do a High Frequency Eddy Current Inspection of the upper skin along the upper fastener row at stringer S-14L and S-14R from STA 887 to STA 1016.

See Doc D626A010, DTR check form 53-70-03-03 for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-A17

166. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-216

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringers S-14L and S-14R from STA 887 to STA 1016.

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See Doc. D626A010, DTR check form 53-70-03-04.

————— END OF TASK —————

TASK 53-05-02-250-A18

167. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-217

- (1) Do a Low Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-23L and S-23R from STA 887 to STA 1016.

See Doc. D626A010, DTR check form 53-70-03-05.

————— END OF TASK —————

TASK 53-05-02-250-A19

168. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-218

- (1) Do a High Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringers S-23L and S-23R from STA 887 to STA 1016.

See Doc. D626A010, DTR check form 53-70-03-06.

————— END OF TASK —————

TASK 53-05-02-211-914

169. EXTERNAL - DETAILED: Crown Skin Panel - STA 887 to 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-211-111

- (1) Do a Detailed inspection of the skin around all fastener locations from S-10L to S-10R, from STA 887 to STA 1016, except at the lap splices and antenna locations. (PSE 53-70-04-01).

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See Doc. D626A010, DTR check form 53-30-01-01.

————— END OF TASK —————

TASK 53-05-02-211-915

170. INTERNAL - SPECIAL DETAILED: Cutout - Aft Entry Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove or displace interior sidewall as required to perform inspection.

SUBTASK 53-05-02-211-112

- (1) Do a High Frequency Eddy Current inspection of the four fasteners located at each of the door stop locations. The fasteners are found at the door stop tension straps forward edge frame at STA 951.

See Doc. D626A010, DTR check form 53-70-07-03.

————— END OF TASK —————

TASK 53-05-02-211-916

171. INTERNAL - DETAILED: Cutout - Aft Entry Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove or displace interior sidewall and door lining as required to perform inspection.

SUBTASK 53-05-02-211-113

- (1) Do a Detailed inspection of door stop #1, #2, #6, and #7 intercostals along the inner chord and around fasteners common to the web and doubler at the aft edge frame STA 992.8.

See Doc. D626A010, DTR check form 53-70-07-04.

NOTE: Door stops are numbered from the bottom up.

————— END OF TASK —————

TASK 53-05-02-250-A20

172. INTERNAL - SPECIAL DETAILED: Cutout - Aft Entry Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

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B. Inspection

NOTE: Remove or displace interior sidewall and door lining as required to perform inspection.

SUBTASK 53-05-02-250-219

- (1) Do a High Frequency Eddy Current inspection of door stop #1, #2, #6, and #7 intercostals along the inner chord and around fasteners common to the web and doubler at the aft edge frame STA 992.8.

See Doc. D626A010, DTR check form 53-70-07-04.

NOTE: Door stops are numbered from the bottom up.

————— **END OF TASK** —————

TASK 53-05-02-211-917

173. INTERNAL - DETAILED: Cutout - Aft Entry Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Access Panels

Number	Name/Location
834	Aft Entry Door

C. Inspection

SUBTASK 53-05-02-010-134

- (1) Open this access panel:

Number	Name/Location
834	Aft Entry Door

SUBTASK 53-05-02-211-114

- (2) Do a Detailed inspection of the skin around the edge of the scuff plate at the aft entry door.
See Doc D626A010, DTR check form 53-70-07-06 for alternative inspection.

SUBTASK 53-05-02-410-135

- (3) Close this access panel:

Number	Name/Location
834	Aft Entry Door

————— **END OF TASK** —————

TASK 53-05-02-250-A21

174. INTERNAL - SPECIAL DETAILED: Cutout - Aft Entry Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

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B. Inspection

NOTE: Sealant removal of any cap seals from around the fasteners is required before inspection.

SUBTASK 53-05-02-250-220

- (1) Do a High Frequency Eddy Current inspection of the inboard flange of the inner chord at the locations where the inboard face of the inboard flange is hidden.

See Doc D626A010, DTR check form 53-70-07-07 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-211-918

175. INTERNAL - DETAILED: Cutout - Aft Entry Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove or displace interior sidewall and door lining as required to perform inspection.

SUBTASK 53-05-02-211-115

- (1) Do a Detailed inspection of the inner chord, web, and strap along the upper main sill from STA 951 to STA 1006.

See Doc D626A010, DTR check form 53-70-07-11 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-250-A22

176. INTERNAL - SPECIAL DETAILED: Cutout - Aft Entry Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-221

- (1) Do a High Frequency Eddy Current inspection of the first eleven (11) fasteners on the upper flange of the outer chord aft of the forward edge frames on the aft entry door lower main sill at STA 951.

See Doc. D626A010, DTR check form 53-70-07-12.

————— **END OF TASK** —————

TASK 53-05-02-250-A23

177. INTERNAL - SPECIAL DETAILED: Cutout - Aft Galley Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-222

- (1) Do a High Frequency Eddy Current inspection of the four (4) fastener locations at each door stop location at the door stop tension straps forwards edge frame at STA 951.
See Doc. D626A010, DTR check form 53-70-08-03.

————— END OF TASK —————

TASK 53-05-02-250-A24

178. INTERNAL - SPECIAL DETAILED: Cutout - Aft Galley Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-223

- (1) Do a Low Frequency Eddy Current inspection of the four (4) fastener locations at door stop #5 at the tension strap locations hidden by the bracket at STA 951.
See Doc. D626A010, DTR check form 53-70-08-03.

————— END OF TASK —————

TASK 53-05-02-211-919

179. INTERNAL - DETAILED: Cutout - Aft Galley Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove or displace interior sidewall and door lining as required to perform inspection.

SUBTASK 53-05-02-211-116

- (1) Do a Detailed inspection of door stop #1, #2, #5, and #6 intercostals along the inner chord and around fasteners common to the web and doubler located on the aft edge frame at STA 992.8.
See Doc. D626A010, DTR check form 53-70-08-04.
NOTE: Door stops are numbered from the bottom up.

————— END OF TASK —————

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TASK 53-05-02-250-A25

180. **INTERNAL - SPECIAL DETAILED: Cutout - Aft Galley Door, Backup Surround Structure**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove or displace interior sidewall and door lining as required to perform inspection.

SUBTASK 53-05-02-250-224

- (1) Do a High Frequency Eddy Current inspection of door stop #1, #2, #5, and #6 intercostals along the inner chord and around fasteners common to the web and doubler located on the aft edge frame at STA 992.8.

See Doc. D626A010, DTR check form 53-70-08-04.

NOTE: Door stops are numbered from the bottom up.

————— **END OF TASK** —————

TASK 53-05-02-211-920

181. **INTERNAL - DETAILED: Cutout - Aft Galley Door, Backup Surround Structure**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

C. Inspection

SUBTASK 53-05-02-010-135

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

SUBTASK 53-05-02-211-117

- (2) Do a Detailed inspection of the skin around the edge of the scuff plate at the aft galley door. (PSE 53-70-08-06)

See Doc D626A010, DTR check form 53-70-07-06 for alternative inspection.

SUBTASK 53-05-02-410-136

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

————— **END OF TASK** —————

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TASK 53-05-02-250-A26

182. INTERNAL - SPECIAL DETAILED: Cutout - Aft Galley Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Sealant removal of any cap seals from around the fasteners is required before inspection.

SUBTASK 53-05-02-250-225

- (1) Do a High Frequency Eddy Current inspection of the inboard flange of the inner chord at the locations where the inboard face of the inboard flange is hidden. (PSE 53-70-08-07)

See Doc D626A010, DTR check form 53-70-07-07 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-211-921

183. INTERNAL - DETAILED: Cutout - Aft Galley Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove or displace interior sidewall and door lining as required to perform inspection.

SUBTASK 53-05-02-211-118

- (1) Do a Detailed inspection of the inner chord, web, and strap along the upper main sill from STA 951 to STA 1006. (PSE 53-70-08-11)

See Doc D626A010, DTR check form 53-70-07-11 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-250-A27

184. INTERNAL - SPECIAL DETAILED: Cutout - Aft Galley Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-226

- (1) Do a High Frequency Eddy Current inspection of the first eleven (11) fasteners on the upper flange of the outer chord aft of the forward edge frames on the galley door lower main sill at STA 951. (PSE 53-70-08-12)

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See Doc. D626A010, DTR check form 53-70-07-12.

————— END OF TASK —————

TASK 53-05-02-250-A28

185. INTERNAL - SPECIAL DETAILED: Window Belt, STA 887 to 927

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-227

- (1) Do a High Frequency Eddy Current inspection of the window frame detail around each passenger window from STA 887 to STA 927 on the left and right hand side. (PSE 53-70-09-02)

See Doc. D626A010, DTR check form 53-60-05-02, for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-A29

186. INTERNAL - SPECIAL DETAILED: Window Belt, STA 887 to 927

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Removal and/or displacement of passenger cabin sidewalls or sidewall window assemblies and insulation blankets is required.

SUBTASK 53-05-02-250-228

- (1) Do a High Frequency Eddy Current inspection of the window frame detail around each passenger window from STA 887 to STA 927 on the left and right hand side. (PSE 53-70-09-02)

See Doc. D626A010, DTR check form 53-60-05-02, for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-210-822

187. INTERNAL - GENERAL VISUAL: Window Belt, STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

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B. Inspection

SUBTASK 53-05-02-210-021

- (1) Do a General Visual inspection of the skin at the skin to window frame fastener around each passenger window on both the left and right hand side from STA 727 to STA 887. (PSE 53-70-09-03)

See Doc. D626A010, DTR check form 53-60-05-03, for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-A30

188. INTERNAL - SPECIAL DETAILED: Window Belt, STA 727 to 887

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-229

- (1) Do a High Frequency Eddy Current inspection of the skin at the skin to window frame fastener around each passenger window on both the left and right hand side from STA 727 to STA 887. (PSE 53-70-09-03)

See Doc. D626A010, DTR check form 53-60-05-03, for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-A31

189. INTERNAL - SPECIAL DETAILED: Window Belt, STA 727 to 927

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-230

- (1) Do a High Frequency Eddy Current inspection of the skin at the skin to window frame fastener around each passenger window on both the left and right hand side from STA 727 to STA 927. (PSE 53-70-09-03A)

See Doc. D626A010, DTR check form 53-60-05-03A.

————— END OF TASK —————

TASK 53-05-02-211-922

190. INTERNAL - DETAILED: Aft Pressure Bulkhead, STA 1016

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door

C. Inspection

NOTE: Access the aft side of the pressure dome bulkhead.

SUBTASK 53-05-02-010-136

- (1) Open this access panel:

Number	Name/Location
311BL	Stabilizer Trim Access Door

SUBTASK 53-05-02-211-119

- (2) Do a Detailed inspection of the pressure dome webs between the stiffeners and tear straps at STA 1016.

See Doc D626A010, DTR check form 53-80-01-02 for alternative inspection.

SUBTASK 53-05-02-410-137

- (3) Close this access panel:

Number	Name/Location
311BL	Stabilizer Trim Access Door

————— **END OF TASK** —————

TASK 53-05-02-211-923

191. INTERNAL - DETAILED: Aft Pressure Bulkhead, STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door

C. Inspection

NOTE: Access the aft side of the pressure dome bulkhead.

SUBTASK 53-05-02-010-137

- (1) Open this access panel:

Number	Name/Location
311BL	Stabilizer Trim Access Door

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SUBTASK 53-05-02-211-120

- (2) Do a Detailed inspection of the pressure dome webs lap splices along the fasteners rows adjacent to the radial stiffeners. Also inspect the pressure dome webs along the fasteners rows common to all radial stiffeners.

See Doc. D626A010, DTR check form 53-80-01-03.

SUBTASK 53-05-02-410-138

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door

————— END OF TASK —————

TASK 53-05-02-250-A32

192. INTERNAL - SPECIAL DETAILED: Aft Pressure Bulkhead, STA 1016

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

B. Inspection

NOTE: Remove necessary passenger cabin and aft cargo interiors as required to perform the inspection.

SUBTASK 53-05-02-250-231

- (1) Do a Low Frequency Eddy Current inspection of the forward side of the pressure dome web along the second row of fasteners common to the stiffener and stiffener clip at each lap splice location (S-1, S-7L/R, S-15L/R, S-23L/R). At each non-lap splice stiffener location (S-3L/R, S-5L/R, S-9L/R, S-11L/R, S-13L/R, S-18L/R, S-21L/R S-25L/R, S-27.5) inspect the second row of fasteners common to the stiffener and stiffener clip. At each oil can stiffener location (S-2L/R, S-4L/R, S-6L/R) inspect the second fastener common to the stiffener.

See Doc. D626A010, DTR check form 53-80-01-04.

————— END OF TASK —————

TASK 53-05-02-210-823

193. EXTERNAL - GENERAL VISUAL: Cutout - Forward Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

B. Inspection

NOTE: Scuff plate removal not required.

SUBTASK 53-05-02-210-022

- (1) Do a General Visual inspection of the skin at all four door cutout corners (upper/lower/forward/aft). (PSE 53-30-08-09)

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See Doc. D626A010, DTR check form 53-60-08-09 for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-211-924

194. INTERNAL - DETAILED: Cutout - Forward Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

B. Inspection

NOTE: Remove corner castings.

SUBTASK 53-05-02-250-232

- (1) Do a Detailed inspection of the bearstrap, including fastener and edge, at all four door cutout corners (upper/lower/forward/aft). (PSE 53-30-08-09)

See Doc. D626A010, DTR check form 53-60-08-09 for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-250-A40

195. INTERNAL - SPECIAL DETAILED: Cutout - Forward Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Inspection

NOTE: Remove or displace forward cargo door lining as required to perform the inspection.

SUBTASK 53-05-02-250-233

- (1) Do a High Frequency Eddy Current inspection of the outer chord around fasteners common to the chord and bearstrap at the upper main sill outer chord, STA 420 to STA 500A.

See Doc. D626A010, DTR check form 53-30-08-10.

————— END OF TASK —————

TASK 53-05-02-211-925

196. INTERNAL - DETAILED: Cutout - Forward Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right

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B. Inspection

NOTE: Sealant removal around fasteners is required before inspection.

SUBTASK 53-05-02-211-121

- (1) Do a Detailed inspection of the upper main sill inner chord. (PSE 53-30-08-11)
See Doc. D626A010, DTR check form 53-60-08-11 for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-250-A33

197. INTERNAL - SPECIAL DETAILED: Cutout - Forward Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Inspection

NOTE: Removal of the scuff plate assembly is required to perform this inspection.

SUBTASK 53-05-02-250-234

- (1) Do a Low Frequency Eddy Current inspection around fasteners common to the web at lower main sill, bullnose chord.
See Doc. D626A010, DTR check form 53-30-08-12.

————— **END OF TASK** —————

TASK 53-05-02-250-A34

198. EXTERNAL - SPECIAL DETAILED: Cutout - Forward Cargo Door, Backup Surround Structure

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
122	Forward Cargo Compartment - Right
124	Forward Cargo Compartment - Right
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Inspection

SUBTASK 53-05-02-500-001

- (1) Do a High Frequency Eddy Current inspection around all fasteners common to the inboard strap between STA 420 and STA 440 and between STA 492.4 and STA 500A at the lower main sill, inner chord.
See Doc. D626A010, DTR check form 53-30-08-13 for alternative inspection.

————— **END OF TASK** —————

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TASK 53-05-02-250-A35

199. INTERNAL - SPECIAL DETAILED: Wing-to-Body Drag Angle

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
132	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Right
191	Lower Wing-To-Body Fairing - Forward of Wing Box

B. Inspection

NOTE: Removal of wing-to-body fairing is required.

SUBTASK 53-05-02-250-235

- (1) Do a High Frequency Eddy Current inspection of the upper and lower edges of each angle along the entire length of the lower drag angle assembly from STA 518 to STA 555 between S-23 and S-24 on both the left and right hand side.

See Doc. D626A010, DTR check form 53-30-11-01.

————— **END OF TASK** —————

TASK 53-05-02-250-A36

200. INTERNAL - SPECIAL DETAILED: Wing-to-Body Drag Angle

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
132	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Right
191	Lower Wing-To-Body Fairing - Forward of Wing Box

B. Inspection

NOTE: Removal of wing-to-body fairings is required.

SUBTASK 53-05-02-500-002

- (1) Do a High Frequency Eddy Current inspection of the exposed flange of the inboard angle 1.5 inches forward and aft of the fasteners common to the fuselage skin and bulkhead at STA 536 between S-21 and S-22 on both the left and right hand side.

See Doc. D626A010, DTR check form 53-30-11-03.

————— **END OF TASK** —————

TASK 53-05-02-211-926

201. EXTERNAL - DETAILED: Crown Skin Panel - STA 540 to 727

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-211-122

- (1) Do a Detailed inspection of the skin around all fastener locations from S-10L to S-10R, from STA 540 to STA 727, except at the lap splices and antenna locations. (PSE 53-40-01-01).
See D626A010, DTR check form 53-30-01-01.

————— **END OF TASK** —————

TASK 53-05-02-250-A37

202. INTERNAL - SPECIAL DETAILED: Crown Skin Panel - STA 540 to 727

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-236

- (1) Do a High Frequency Eddy Current inspection around the anti-collision light skin attachment fasteners at the anti-collision light cutout, STA 568.
See D626A010, DTR check form 53-40-01-02.

————— **END OF TASK** —————

TASK 53-05-02-211-927

203. EXTERNAL - DETAILED: Crown Skin Panel - STA 540 to 727

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove antenna fairing, antenna and baseplate as required.

SUBTASK 53-05-02-211-123

- (1) Do a Detailed inspection of the skin around all of the structure location at the VHF antenna cutout, STA 630, and ADF antenna cutout, STA 694.

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See D626A010, DTR check form 53-40-01-04.

————— END OF TASK —————

TASK 53-05-02-211-928

204. EXTERNAL - DETAILED: Crown Skin Panel - STA 540 to 727

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Removal of the antennas is not required.

SUBTASK 53-05-02-211-124

- (1) Do a Detailed inspection of the exposed skin surrounding the antenna structure for the VHF antenna, STA 630, and ADF antenna, STA 694.

See D626A010, DTR check form 53-40-01-04.

————— END OF TASK —————

TASK 53-05-02-211-929

205. INTERNAL - DETAILED: Side Skin Panel - STA 540 to 727

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Removal of cabin interior and insulation blanket is required.

SUBTASK 53-05-02-211-125

- (1) Do a Detailed inspection of the side skin panel and stringer from stringer S-9 to S-11, between STA 664 and STA 706, on both the left and right hand side.

See Doc. D626A010, DTR check form 53-40-02-02.

————— END OF TASK —————

TASK 53-05-02-250-A39

206. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left

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Zone	Area
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-237

- (1) Do a High Frequency Eddy Current inspection of the lap splice upper fastener row at S-4L and S-4R from STA 540 to STA 727.

See Doc. D626A010, DTR check form 53-40-03-01.

————— **END OF TASK** —————

TASK 53-05-02-250-A38

207. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-238

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringers S-4L and S-4R from STA 540 to STA 727.

See Doc. D626A010, DTR check form 53-40-03-02.

————— **END OF TASK** —————

TASK 53-05-02-250-A41

208. EXTERNAL - SPECIAL DETAILED: Longitudinal Lap Skin Splice

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-239

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-10L and S-10R from STA 540 to STA 727.

See Doc. D626A010, DTR check form 53-40-03-03.

————— **END OF TASK** —————

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TASK 53-05-02-211-930

209. INTERNAL - DETAILED: Longitudinal Splice, STA 540 to 727

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove interior panels as required.

SUBTASK 53-05-02-211-126

- (1) Do a Detailed inspection of the lap splice lower fastener row at S-10L and S-10R from STA 540 to STA 727. (PSE 53-40-03-04).

See Doc. D626A010, DTR check form 53-30-04-04.

————— **END OF TASK** —————

TASK 53-05-02-250-A42

210. EXTERNAL - SPECIAL DETAILED: Window Belt, STA 540 to 727

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-240

- (1) Do a High Frequency Eddy Current inspection of the window frame detail around each passenger window from STA 540 to STA 727 on both the left and right hand side. (PSE 53-40-04-02)

See Doc. D626A010, DTR check form 53-60-05-02.

————— **END OF TASK** —————

TASK 53-05-02-250-A43

211. INTERNAL - SPECIAL DETAILED: Window Belt, STA 540 to 727

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

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B. Inspection

SUBTASK 53-05-02-250-241

- (1) Do a High Frequency Eddy Current inspection of the window frame detail around each passenger window from STA 540 to STA 727 on both the left and right hand side. (PSE 53-40-04-02).

See Doc. D626A010, DTR check form 53-60-05-02.

————— **END OF TASK** —————

TASK 53-05-02-210-824

212. EXTERNAL - GENERAL VISUAL: Window Belt, STA 540 to 727

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-210-023

- (1) Do a General Visual inspection of the skin at the skin to window frame fastener around each passenger window from STA 540 to STA 727 on the left and right hand side. (PSE 53-40-04-03)

See Doc. D626A010, DTR check form 53-60-05-03, for alternative inspection.

————— **END OF TASK** —————

TASK 53-05-02-250-A44

213. EXTERNAL - SPECIAL DETAILED: Window Belt, STA 540 to 727

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-242

- (1) Do a High Frequency Eddy Current inspection of the skin at the skin to window frame fastener around each passenger window from STA 540 to STA 727 on the left and right hand side. (PSE 53-40-04-03)

See Doc D626A010, DTR check form 53-60-05-03, for alternative inspection.

————— **END OF TASK** —————

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TASK 53-05-02-250-A45

214. EXTERNAL - SPECIAL DETAILED: Window Belt, STA 540 to 727

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-250-243

- (1) Do a High Frequency Eddy Current inspection of the skin at the skin to window frame fastener around each passenger window from STA 540 to STA 727 on the left and right hand side. (PSE 53-40-04-03A)

See Doc. D626A010, DTR check form 53-60-05-03A.

————— **END OF TASK** —————

TASK 53-05-02-211-931

215. EXTERNAL - DETAILED: Circumferential Skin and Stringer Splice, STA 727

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

SUBTASK 53-05-02-211-127

- (1) Do a Detailed inspection of the skin around all fastener locations at STA 727 from S-10L to S-10R except at the lap splices and antenna locations. (PSE 53-40-06-01)

See Doc. D626A010, DTR check form 53-30-01-01.

————— **END OF TASK** —————

TASK 53-05-02-211-932

216. INTERNAL - DETAILED: Stringer Splice, STA 663.75

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove and/or displace passenger cabin sidewall panels and insulation blankets as required.

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SUBTASK 53-05-02-211-128

- (1) Do a Detailed inspection of stringers S-11 and S-13 from 10 inches forward and aft of STA 663, left and right hand side.

See Doc. D626A010, DTR check form 53-40-07-02, for alternative inspection.

————— END OF TASK —————

TASK 53-05-02-211-933

217. INTERNAL - DETAILED: Keel Beam

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
139	Keel Beam, (Part) Body Station 540.00 to Body Station 727.00

B. Access Panels

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door

C. Inspection

SUBTASK 53-05-02-010-138

- (1) Open these access panels:

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door

SUBTASK 53-05-02-211-129

- (2) Do a Detailed inspection of the outboard and inboard side of the keel beam side panel webs from STA 540 to STA 663 including the vertical stiffener at STA 637.

See Doc. D626A010, DTR check form 53-40-08-01.

SUBTASK 53-05-02-410-139

- (3) Close these access panels:

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door

————— END OF TASK —————

TASK 53-05-02-250-A46

218. INTERNAL - SPECIAL DETAILED: Stiffener Attachment to Floor Beam, STA 727

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right

B. Inspection

NOTE: Removal and/or displacement of aft cargo forward bulkhead, ceiling, sidewall panels and insulation blankets as required to perform the inspection.

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SUBTASK 53-05-02-250-244

- (1) Do a High Frequency Eddy Current inspection of the fastener row connecting the pressure bulkhead stiffener to the stiffener attachment fitting that joins the stiffener to the floor beam (at five locations) around the fastener/collar on the outboard side at LBL 45.5 and RBL 45.5 and WL 202.6.

See Doc. D626A010, DTR check form 53-40-10-01 for alternate inspection.

————— END OF TASK —————

TASK 53-05-02-250-A47

219. INTERNAL - SPECIAL DETAILED: Stringer 18A, Chords and Links

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
135	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Left
136	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Right
137	Area Above M.L.G. Wheel Well, Body Station 663.75 to Body Station 727 - Left
138	Area Above M.L.G. Wheel Well, Body Station 663.75 Body Station 727 - Right

B. Inspection

NOTE: Remove all 4 link assemblies (2 per side, 2 bolts per assembly).

SUBTASK 53-05-02-250-245

- (1) Do a High Frequency Eddy Current inspection around the bushings on each lug, three lugs per assembly, on the upper and lower surface at STA 663.

See Doc. D626A010, DTR check form 53-40-12-01.

————— END OF TASK —————

TASK 53-05-02-250-A48

220. INTERNAL - SPECIAL DETAILED: Bulkhead and Splices, STA 540

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

NOTE: Remove cabin interiors as required. Remove/displace insulation blanket as required.

SUBTASK 53-05-02-250-246

- (1) Do a High Frequency Eddy Current inspection of the frame inner chord at all fasteners common to the inner chord and to the inner splice plate at STA 540, S-9 to S-10, left and right hand side.

See Doc. D626A010, DTR check form 53-40-14-01.

————— END OF TASK —————

TASK 53-05-02-250-A49

221. INTERNAL - SPECIAL DETAILED: Bulkhead and Splices, STA 540

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

NOTE: Remove cabin interiors as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-02-250-247

- (1) Do a High Frequency Eddy Current inspection of the frame inner chord between S-12 and S-15 at STA 540, left and right hand side.

See Doc. D626A010, DTR check form 53-40-14-03, for alternate inspection.

————— **END OF TASK** —————

TASK 53-05-02-211-934

222. EXTERNAL - DETAILED: Bulkhead and Splices, STA 540

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

B. Inspection

SUBTASK 53-05-02-211-130

- (1) Do a Detailed inspection of the skin around all fastener locations from S-10L to S-10R at STA 540, except at the lap splices and antenna locations. (PSE 53-40-14-04).

See Doc. D626A010, DTR check form 53-30-01-01.

————— **END OF TASK** —————

TASK 53-05-02-211-935

223. INTERNAL - DETAILED: Bulkhead and Splices, STA 663

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove cabin interiors as required. Remove/displace insulation blanket as required.

SUBTASK 53-05-02-211-131

- (1) Do a Detailed inspection of the frame inner chord from S-9L to S-9R at STA 663.75.

See Doc. D626A010, DTR check form 53-40-15-02.

————— **END OF TASK** —————

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TASK 53-05-02-250-A50

224. **INTERNAL - SPECIAL DETAILED: Bulkhead and Splices, STA 663**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

B. Inspection

NOTE: Remove cabin interiors as required. Remove/displace insulation blanket as required.

SUBTASK 53-05-02-250-248

- (1) Do a High Frequency Eddy Current inspection of the bulkhead inner chord from S-9 to S-17 at STA 663.75, left and right hand side.

See Doc. D626A010, DTR check form 53-40-15-03.

————— **END OF TASK** —————

TASK 53-05-02-250-A51

225. **INTERNAL - SPECIAL DETAILED: Bulkhead and Splices, STA 663**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
132	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Right
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
137	Area Above M.L.G. Wheel Well, Body Station 663.75 to Body Station 727 - Left
138	Area Above M.L.G. Wheel Well, Body Station 663.75 Body Station 727 - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

B. Inspection

SUBTASK 53-05-02-250-249

- (1) Do a High Frequency Eddy Current inspection of the inner chord at STA 663.75 along the edge from WL 208 (below floor) down to WL 190 (the start of the vertical tong that attaches the frame to the rear spar web), left and right hand side.

See Doc. D626A010, DTR check form 53-40-15-04.

————— **END OF TASK** —————

TASK 53-05-02-211-936

226. **INTERNAL - DETAILED: Bulkhead and Splices, STA 663**

NOTE: This procedure is a scheduled maintenance task.

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A. Location Zones

Zone	Area
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
132	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Right
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
137	Area Above M.L.G. Wheel Well, Body Station 663.75 to Body Station 727 - Left
138	Area Above M.L.G. Wheel Well, Body Station 663.75 Body Station 727 - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

B. Inspection

SUBTASK 53-05-02-210-024

- (1) Do a Detailed inspection of the lower fitting outer chord at STA 663.75 from WL 202 down to WL 202, left and right hand side.

See Doc. D626A010, DTR check form 53-40-15-05.

———— **END OF TASK** ————

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AIRCRAFT MAINTENANCE MANUAL

FUSELAGE - STRUCTURAL INSPECTIONS - MAINTENANCE PRACTICES

TASK 53-05-03-210-801

1. EXTERNAL - GENERAL VISUAL: FUSELAGE LOWER LOBE, FORWARD ACCESS DOOR CUTOUT
(Figure 201)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	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

D. Inspection

SUBTASK 53-05-03-010-001

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
112A	Forward Access Door

NOTE: Open forward access door.

SUBTASK 53-05-03-210-001

- (2) Do a General Visual inspection of the door cutout at forward access door.

SUBTASK 53-05-03-910-001

- (3) Basic Task Description, 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 53-05-03-410-001

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
112A	Forward Access Door

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

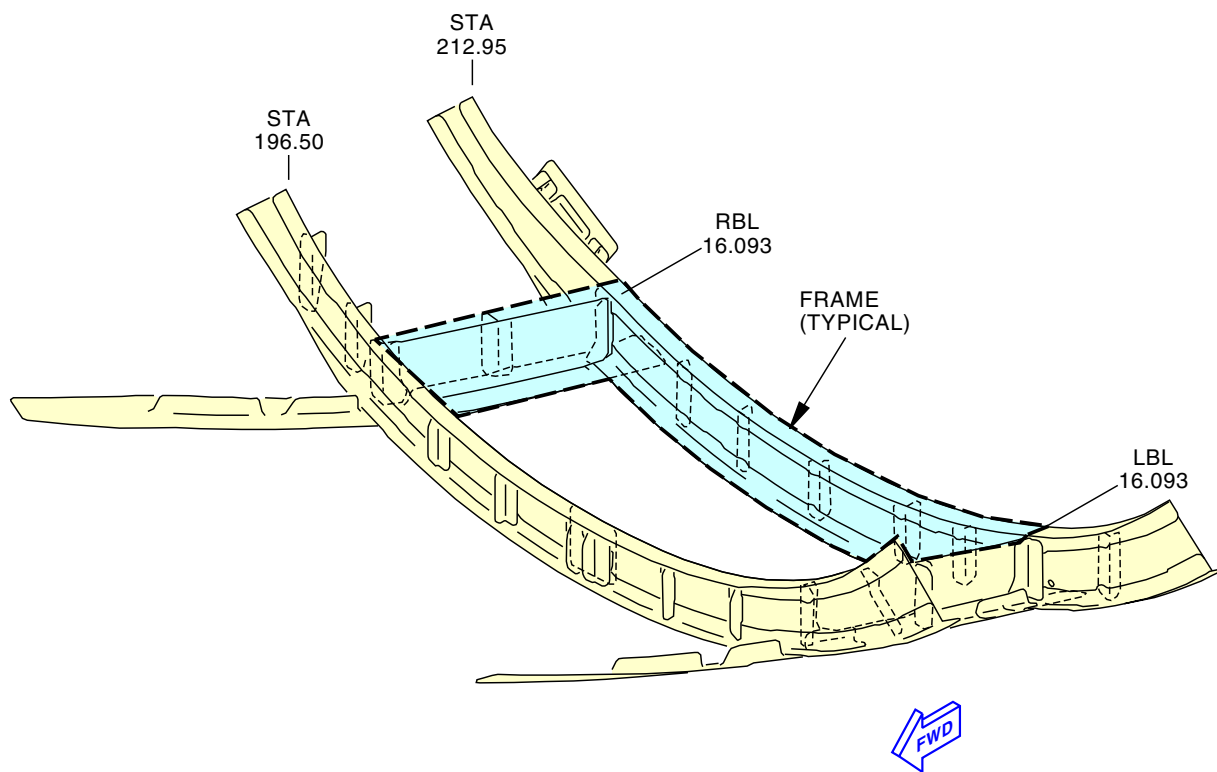
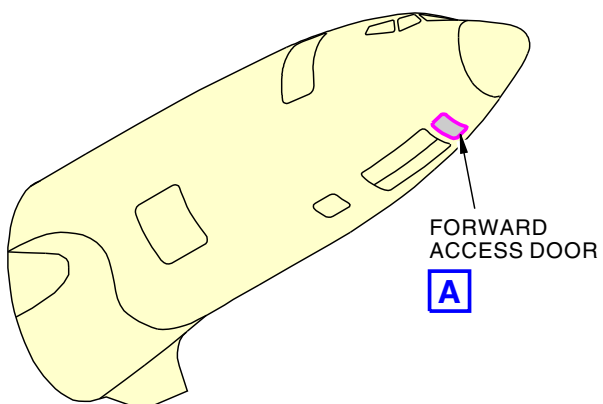
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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



FORWARD ACCESS DOOR FRAME

A

2416003 S00061539617_V3

External - Forward Access Door Cutout Frame
Figure 201/53-05-03-990-801

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-802

2. **EXTERNAL - GENERAL VISUAL: FUSELAGE LOWER LOBE, EE COMPARTMENT DOOR CUTOUT**
(Figure 202)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	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 53-05-03-010-002

- (1) Open this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

- (2) Open Electronic Equipment access door.

SUBTASK 53-05-03-210-002

- (3) Do a General Visual inspection of the door cutout at Electronic Equipment access door.

SUBTASK 53-05-03-910-002

- (4) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 53-05-03-410-002

- (5) Close this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

————— END OF TASK —————

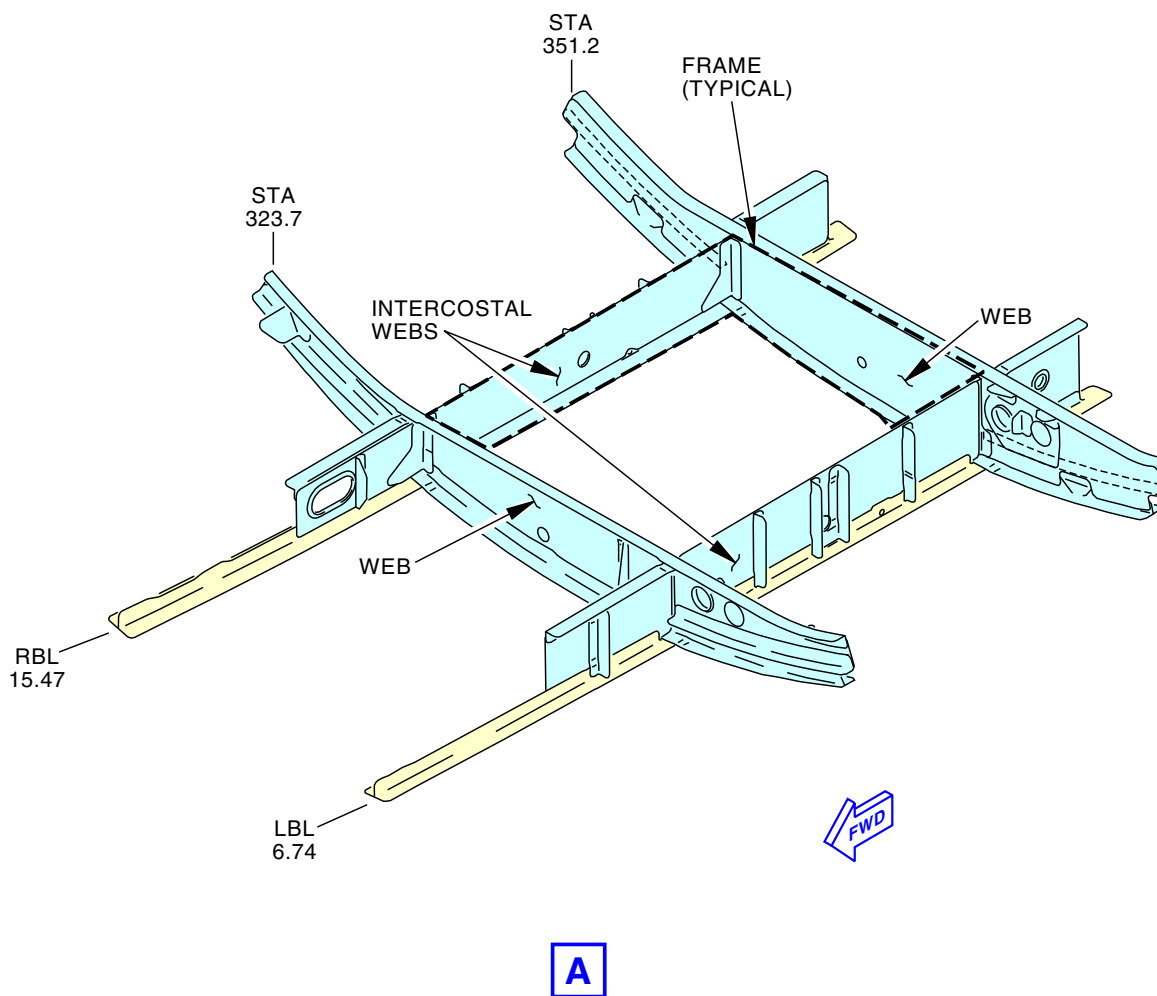
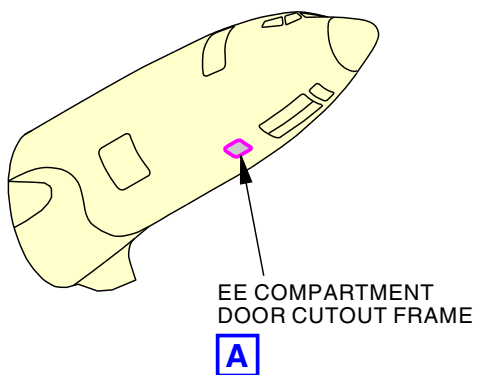
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416004 S00061539619_V1

External - EE Compartment Door Cutout Frame
Figure 202/53-05-03-990-802

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-803

3. **EXTERNAL - GENERAL VISUAL: NOSE WHEEL WELL**

(Figure 203)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right

C. Inspection

SUBTASK 53-05-03-210-003

- (1) Do a General Visual inspection of the nose landing gear wheel well, including canted bulkhead (STA 216.8 to 221.6), STA 294.5 bulkhead, side and top panels, trunnion support fitting, actuator support fitting, and drag brace fitting.

SUBTASK 53-05-03-910-003

- (2) Basic Task Description, 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

———— **END OF TASK** ————

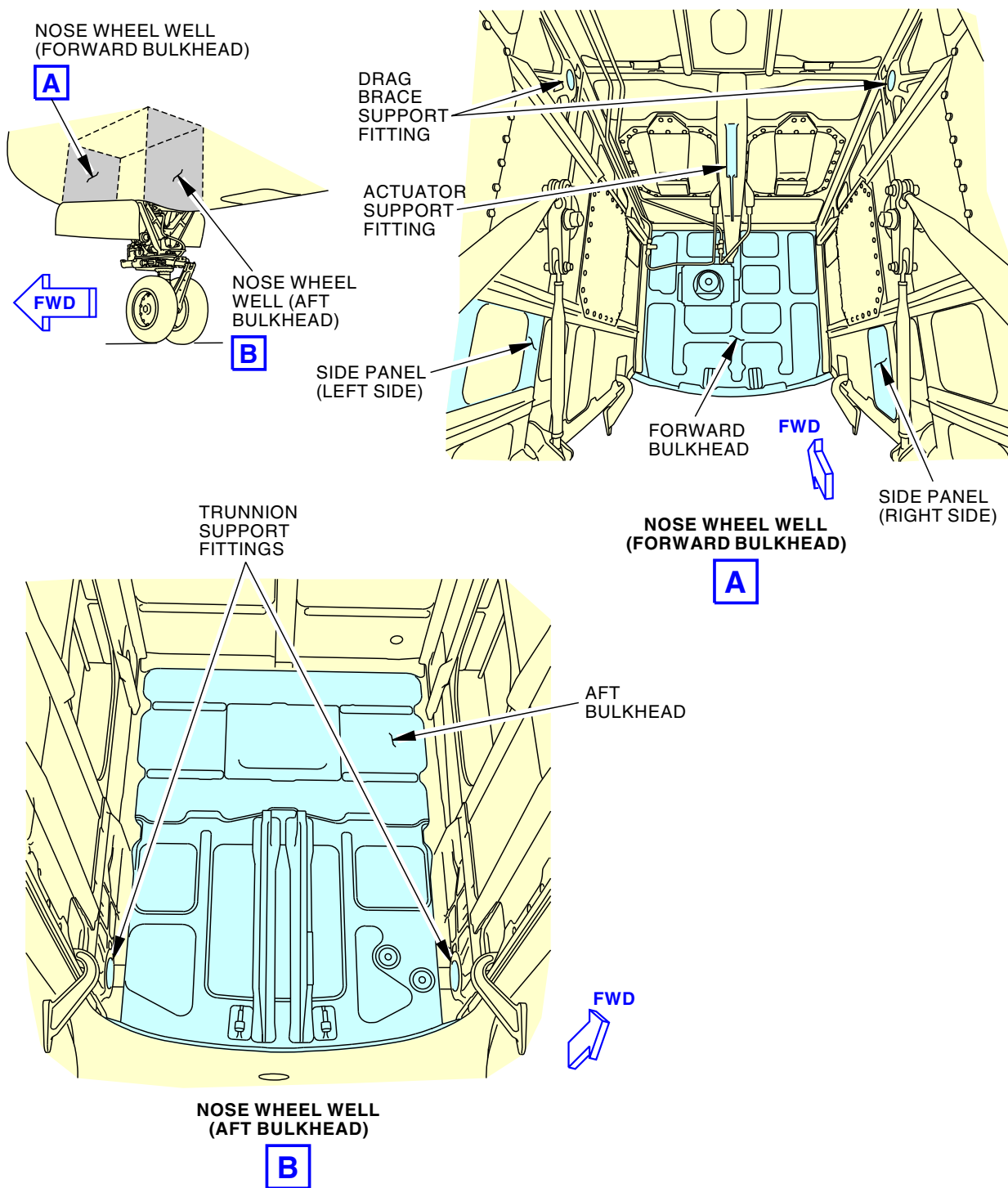
EFFECTIVITY
SIA ALL

D633AM101-SIA

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2416005 S00061539621_V1

Nose Landing Gear Wheel Well
Figure 203/53-05-03-990-803

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-801

4. **EXTERNAL - DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE, FITTINGS AND STOPS**

(Figure 204)

NOTE: This procedure is a scheduled maintenance task.

A. References

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

B. Location Zones

<u>Zone</u>	<u>Area</u>
122	Forward Cargo Compartment - Right

C. Access Panels

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

D. Inspection

SUBTASK 53-05-03-010-003

(1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

SUBTASK 53-05-03-211-001

(2) Do a Detailed inspection of the forward cargo door surround structure, fittings and stops.

SUBTASK 53-05-03-910-004

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

SUBTASK 53-05-03-410-003

(4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
821	Forward Cargo Door

————— **END OF TASK** —————

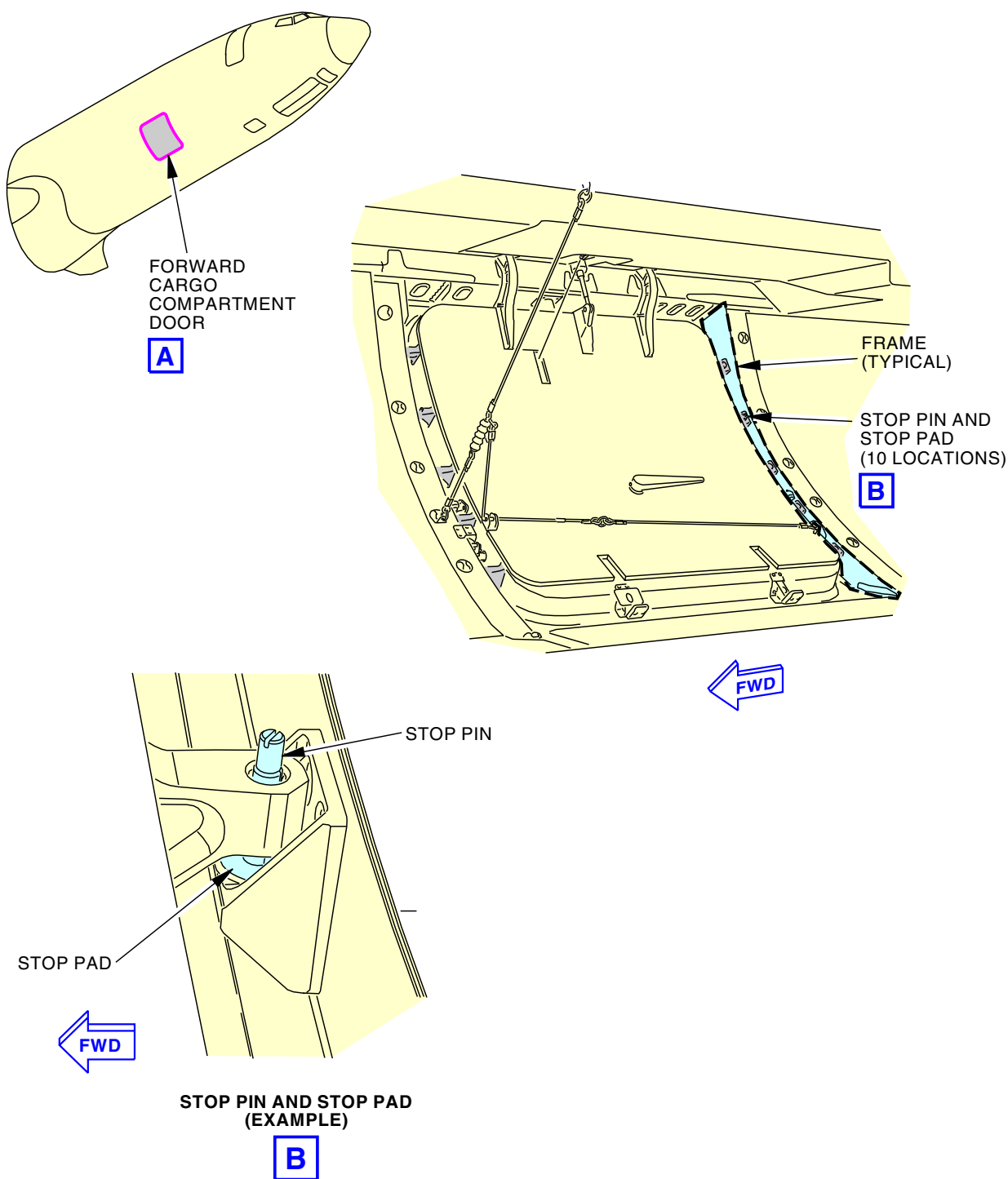
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416006 S00061539623_V1

External - Forward Cargo Door Surround Structure Fitting and Stops
Figure 204/53-05-03-990-804

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL**

TASK 53-05-03-211-802

5. EXTERNAL - DETAILED: AFT CARGO DOOR SURROUND STRUCTURE, FITTINGS AND STOPS
(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
142	Aft Cargo Compartment - Right

C. Access Panels

Number	Name/Location
822	Aft Cargo Door

D. Inspection

SUBTASK 53-05-03-010-004

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

SUBTASK 53-05-03-211-002

- (2) Do a Detailed inspection of the aft cargo door surround structure, fittings and stops.

SUBTASK 53-05-03-910-005

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

SUBTASK 53-05-03-410-004

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
822	Aft Cargo Door

———— **END OF TASK** ————

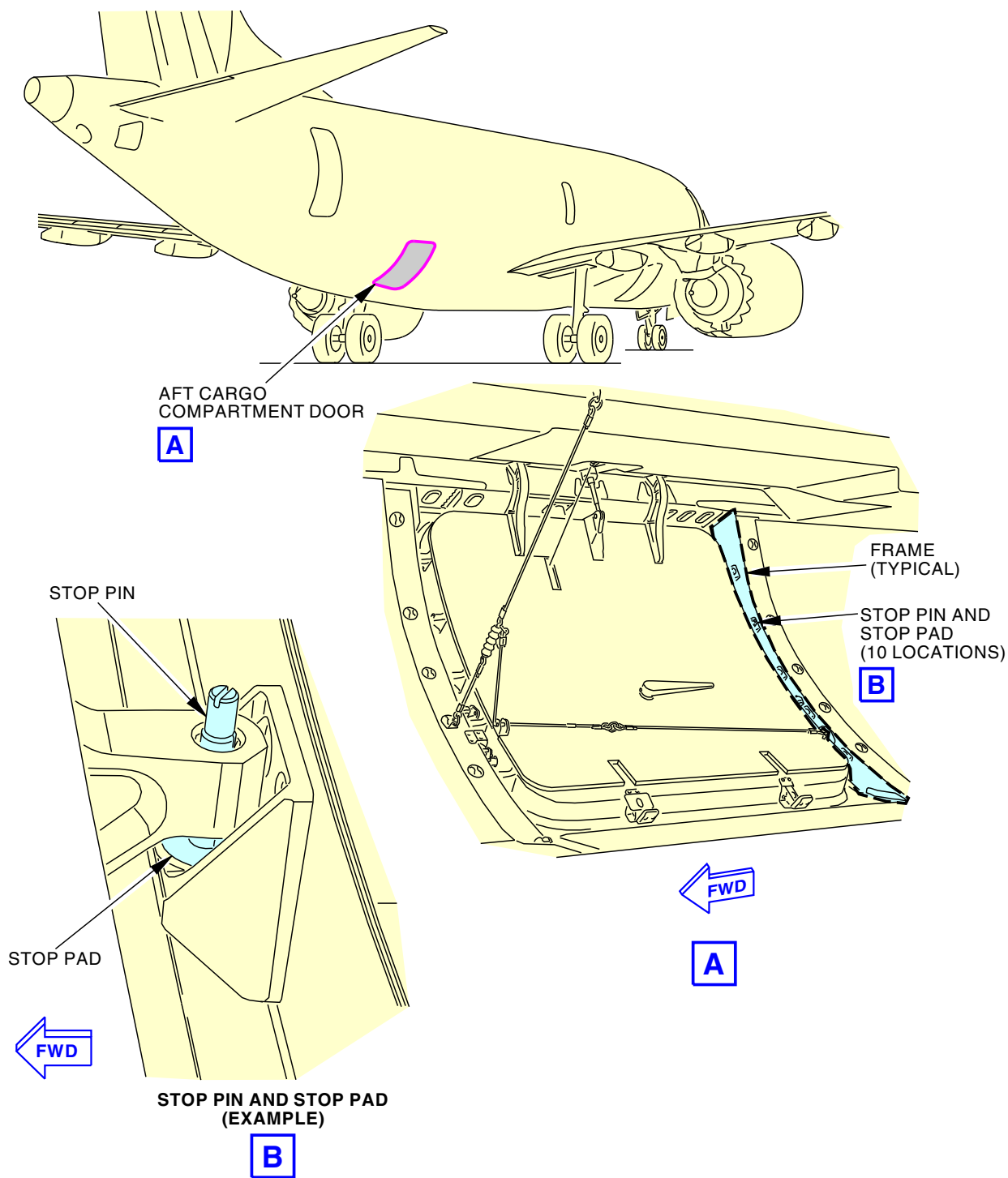
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416007 S00061539625_V1

External - Aft Cargo Door Surround Structure Fittings and Stops
Figure 205/53-05-03-990-805

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-804

6. **EXTERNAL - GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL**

(Figure 206, Figure 207, Figure 208)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
139	Keel Beam, (Part) Body Station 540.00 to Body Station 727.00
193	Lower Wing-To-Body Fairing - Wheel Well

C. Inspection

SUBTASK 53-05-03-210-004

- (1) Do a General Visual inspection of the main landing gear wheel well, including:
1. Pressure deck web and stiffeners, including attachment to wing center section rear spar at Sta 663.
 2. Bulkhead at STA 663.
 3. Bulkhead and pressure web at STA 727.
 4. Keel beam chords, webs, stiffeners and splice, keel beam/rear spar attachment angles.
 5. Stringer 18A web, chord and links.
 6. Side strut support frame at STA 706.
 7. Main landing gear support frame at STA 695 and 716.
 8. Wheel well frame at STA 685.
 9. Flap track support fittings.

SUBTASK 53-05-03-910-006

- (2) Basic Task Description, 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

————— **END OF TASK** —————

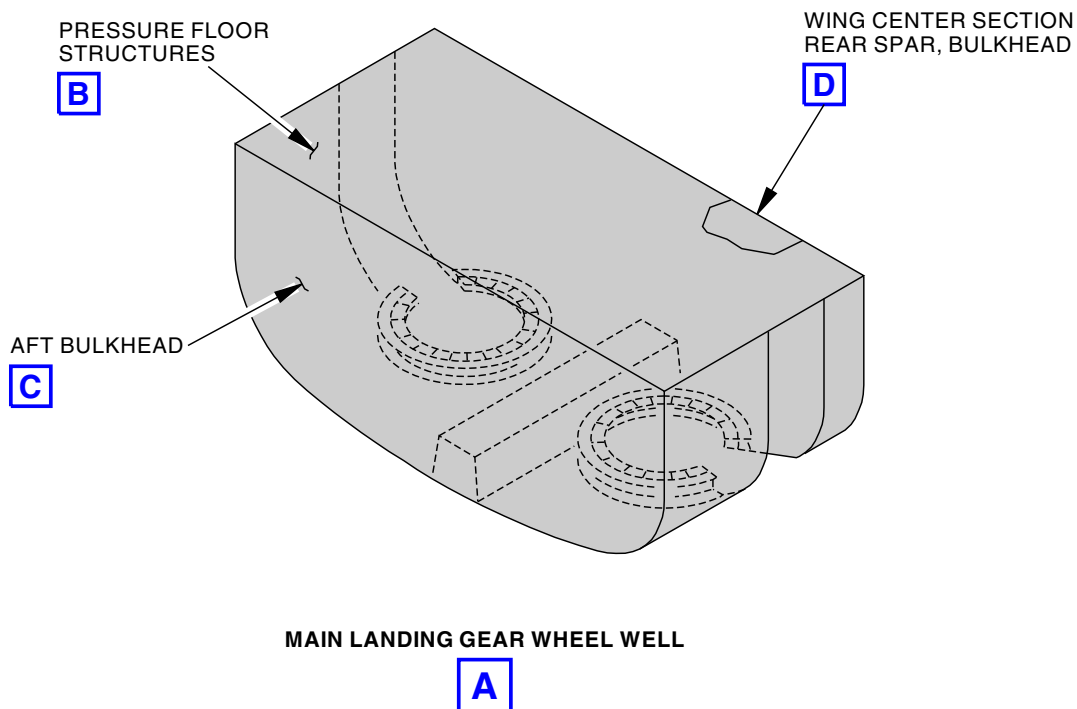
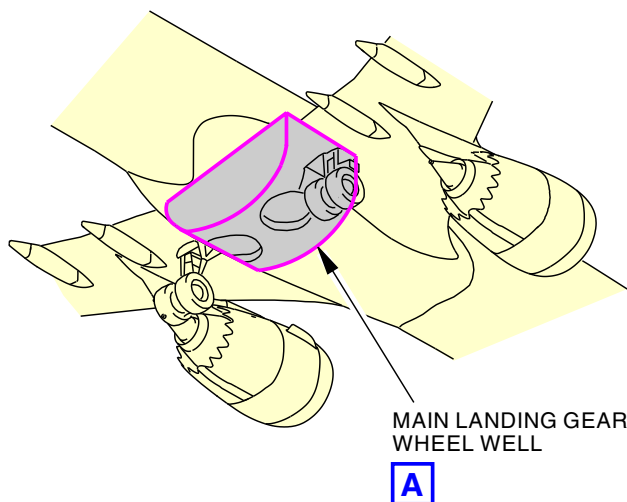
EFFECTIVITY
SIA ALL

D633AM101-SIA

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2416008 S00061539627_V1

EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL
Figure 206/53-05-03-990-806 (Sheet 1 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

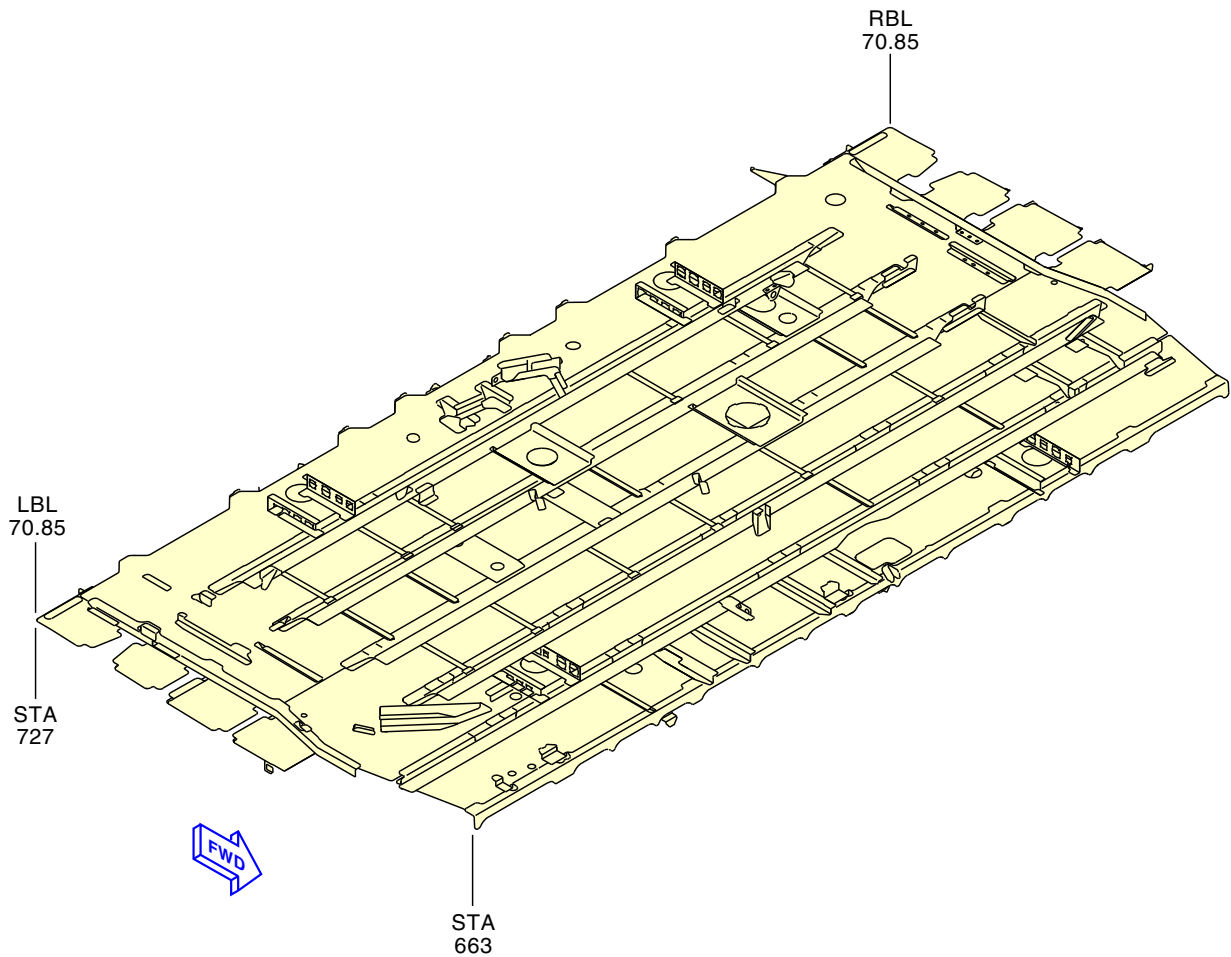
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AIRCRAFT MAINTENANCE MANUAL



PRESSURE FLOOR STRUCTURES
(BOTTOM VIEW LOOKING UP)

B

2416009 S00061539628_V1

EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL
Figure 206/53-05-03-990-806 (Sheet 2 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

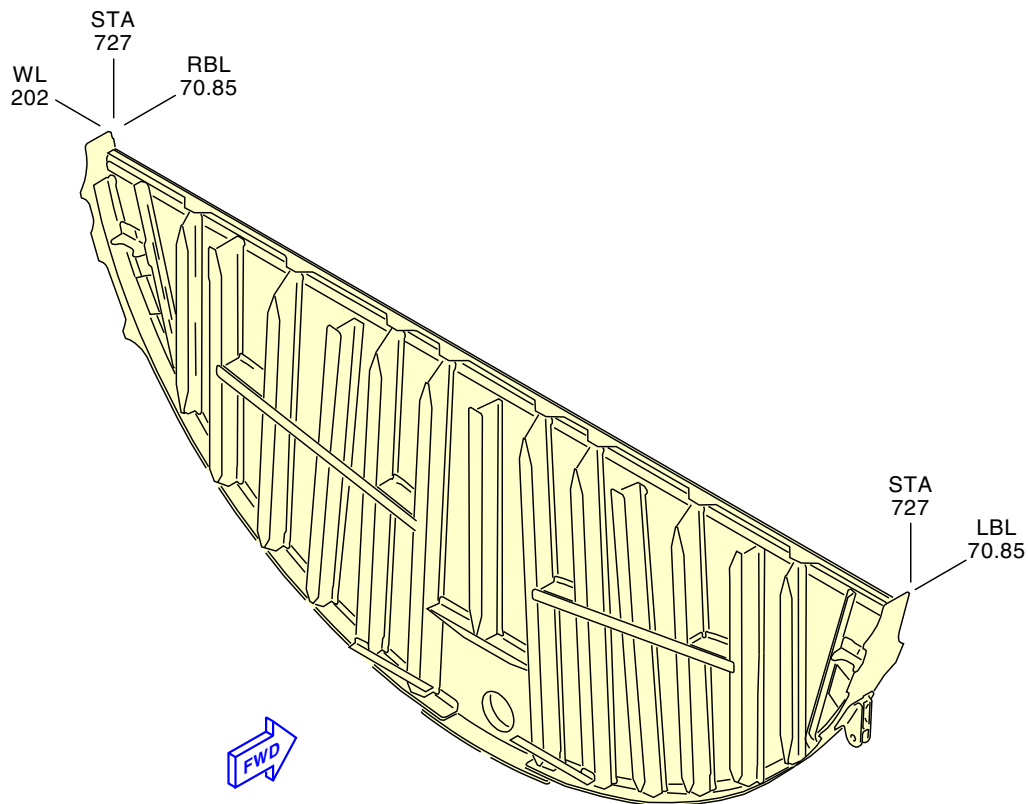
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AIRCRAFT MAINTENANCE MANUAL



AFT BULKHEAD
(STA 727)



2416010 S00061539629_V1

EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL
Figure 206/53-05-03-990-806 (Sheet 3 of 4)

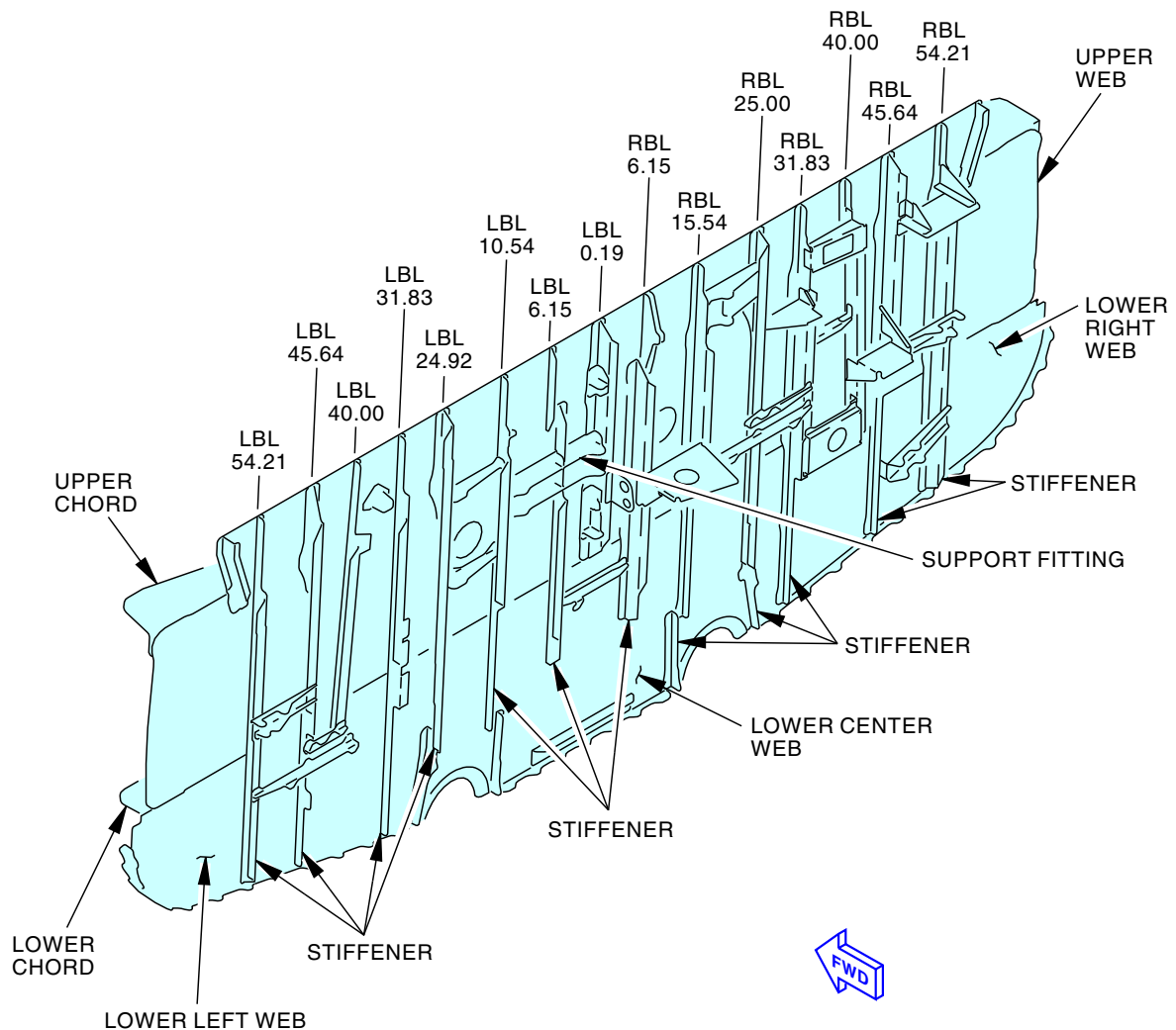
EFFECTIVITY
SIA ALL

D633AM101-SIA

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WING CENTER SECTION
REAR SPAR, BULKHEAD
(STA 663)

D

2416011 S00061539630_V1

EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL
Figure 206/53-05-03-990-806 (Sheet 4 of 4)

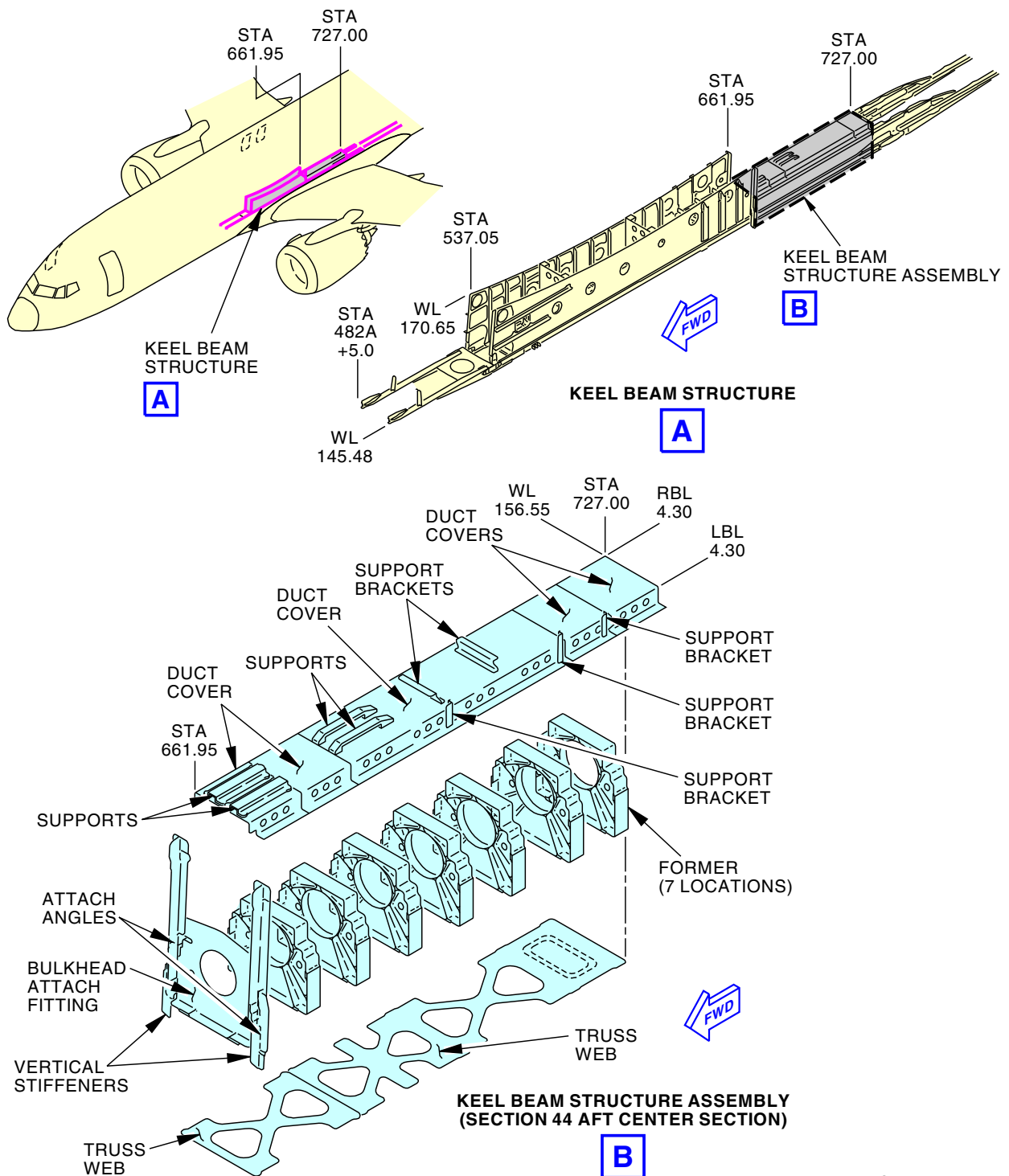
EFFECTIVITY
SIA ALL

53-05-03

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AIRCRAFT MAINTENANCE MANUAL



2416012 S00061539631_V2

EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL
Figure 207/53-05-03-990-807

EFFECTIVITY
SIA ALL

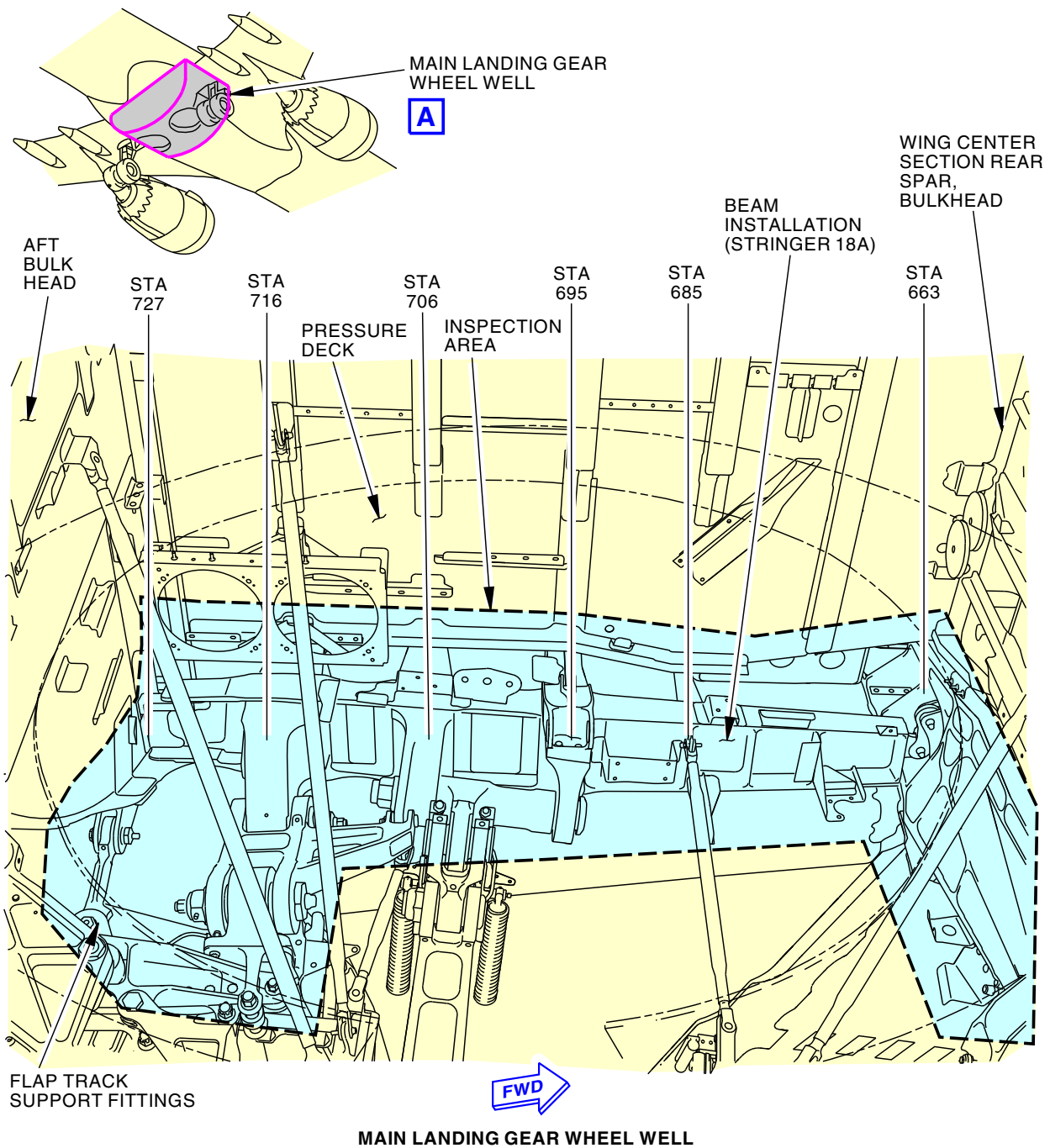
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AIRCRAFT MAINTENANCE MANUAL



NOTE:

LEFT SIDE SHOWN, RIGHT SIDE OPPOSITE,
 LESS FIREBOTTLE BRACKET

2416013 S00061539632_V1

EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL
Figure 208/53-05-03-990-808

EFFECTIVITY
 SIA ALL

D633AM101-SIA

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-805

7. INTERNAL - GENERAL VISUAL: FORWARD PRESSURE BULKHEAD

(Figure 209)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
111	Radome

C. Access Panels

Number	Name/Location
111	Radome

D. Inspection

SUBTASK 53-05-03-010-005

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
111	Radome

NOTE: Open nose radome.

SUBTASK 53-05-03-210-005

- (2) Do a General Visual inspection of the forward side of STA 178 bulkhead.

SUBTASK 53-05-03-910-007

- (3) Basic Task Description, 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 53-05-03-410-005

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
111	Radome

————— END OF TASK —————

EFFECTIVITY
SIA ALL

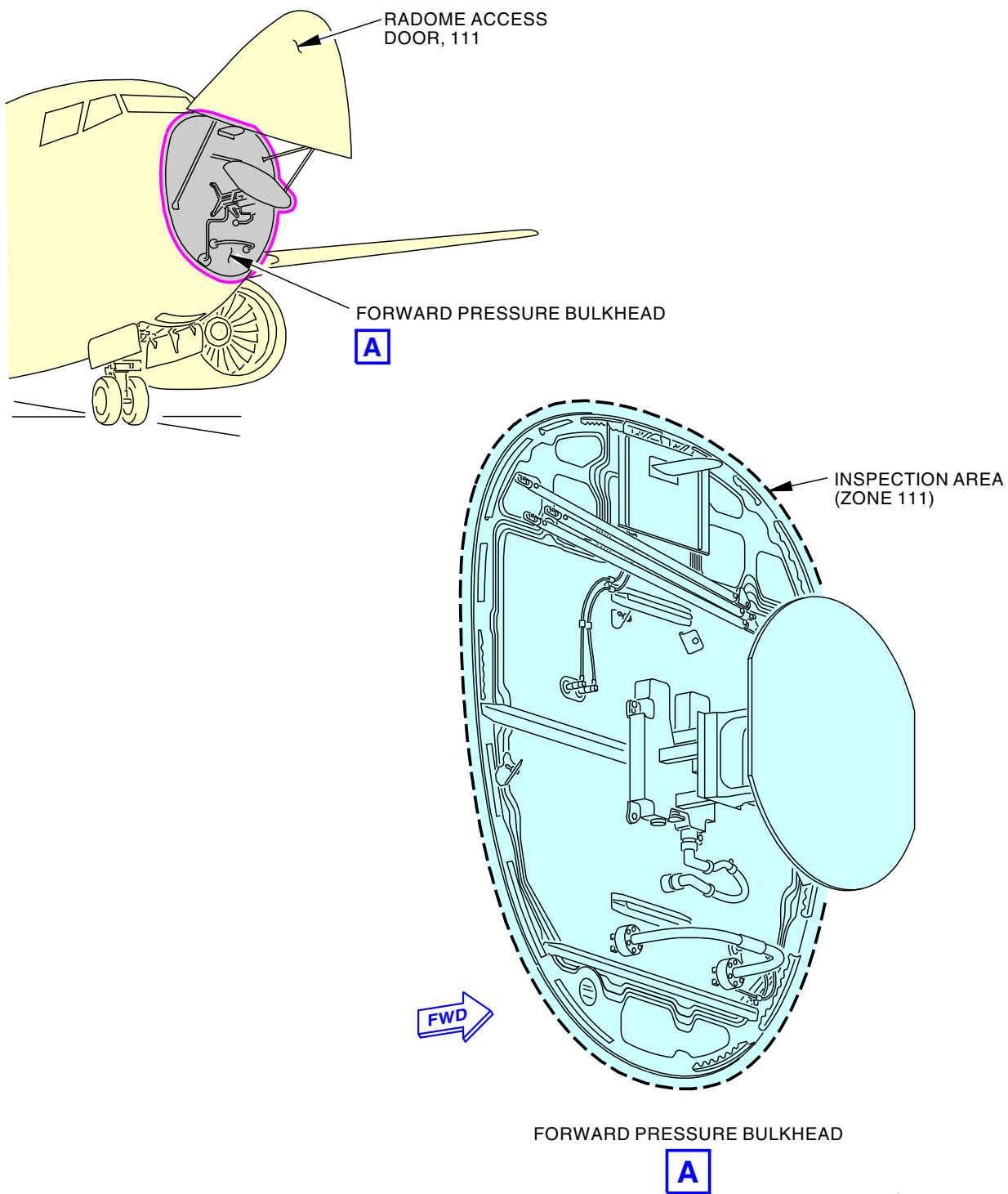
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**737-7/8/8200/9/10
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2416014 S00061539634_V1

**Forward Pressure Bulkhead, Sta. 178
Figure 209/53-05-03-990-809**

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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TASK 53-05-03-210-806

8. INTERNAL - GENERAL VISUAL: AREA FORWARD OF NOSE WHEEL WELL

(Figure 210)

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
112	Area Forward of Nose Landing Gear Wheel Well

C. Access Panels

Number	Name/Location
112A	Forward Access Door
S1122	Area Forward Of Nose Wheel Well Inspection

D. Inspection

SUBTASK 53-05-03-010-006

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
112A	Forward Access Door
S1122	Area Forward Of Nose Wheel Well Inspection

NOTE: Remove weather radar RT mount. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-006

- (2) Do a General Visual inspection of the fuselage lower lobe from STA 178 bulkhead to canted bulkhead (STA 216.8 to 221.6), including bulkheads, skin panels (skins, frames, stringers), longitudinal lap splices, forward access door cutout, and nose wheel well cutout.

SUBTASK 53-05-03-910-008

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

SUBTASK 53-05-03-410-006

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
112A	Forward Access Door
S1122	Area Forward Of Nose Wheel Well Inspection

———— **END OF TASK** ————

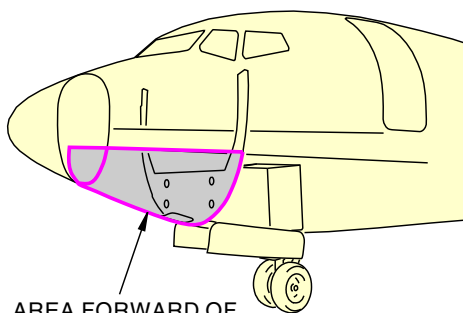
EFFECTIVITY
SIA ALL

53-05-03

D633AM101-SIA

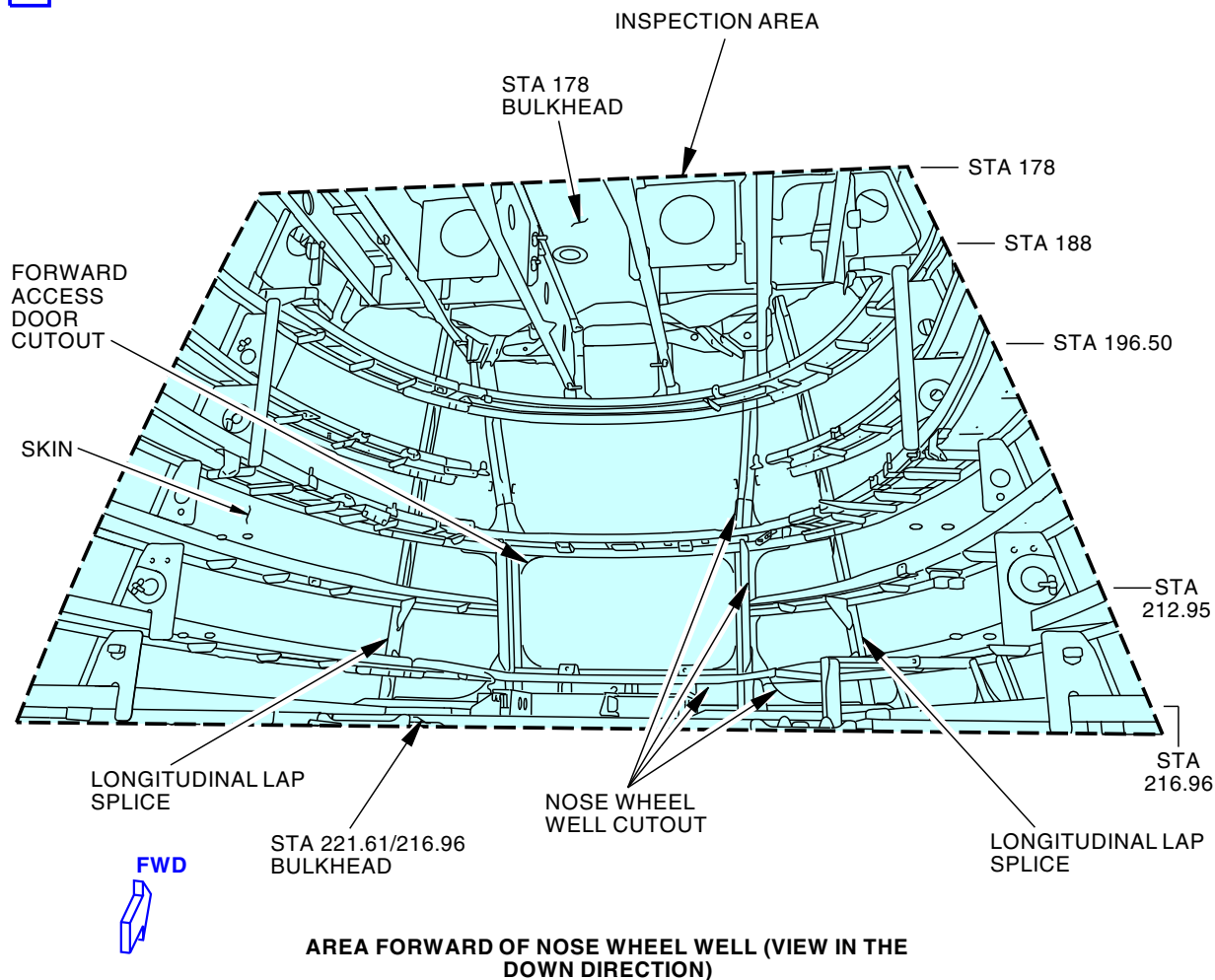
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AREA FORWARD OF
NOSE WHEEL WELL

A



A

2416015 S00061539636_V2

Forward of Nose Landing Gear Wheel Well General Visual (Internal)
Figure 210/53-05-03-990-810

EFFECTIVITY
SIA ALL

53-05-03

D633AM101-SIA

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-807

9. **INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FLOOR STRUCTURE**

(Figure 211)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	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

D. Inspection

SUBTASK 53-05-03-010-007

- (1) Open this access panel:

Number	Name/Location
112A	Forward Access Door

NOTE: Access through forward access door.

SUBTASK 53-05-03-210-007

- (2) Do a General Visual inspection of the flight compartment floor structure from lower lobe.

SUBTASK 53-05-03-910-009

- (3) Basic Task Description, 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 53-05-03-410-007

- (4) Close this access panel:

Number	Name/Location
112A	Forward Access Door

————— **END OF TASK** —————

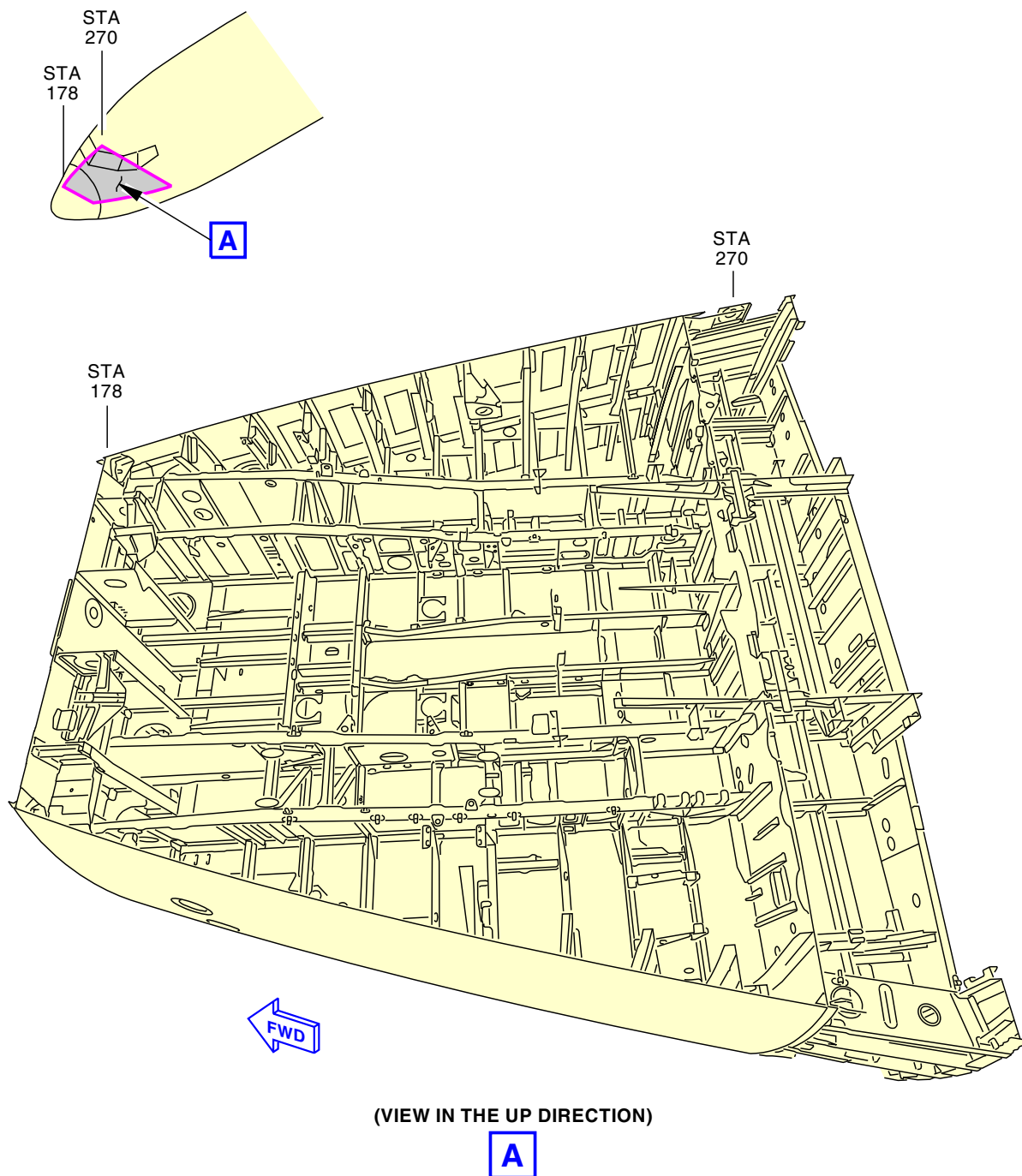
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416016 S00061539638_V1

Flight Deck Floor Structure
Figure 211/53-05-03-990-811

EFFECTIVITY
SIA ALL

53-05-03

D633AM101-SIA

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-808

10. INTERNAL - GENERAL VISUAL: AREA ABOVE AND OUTBOARD OF NOSE WHEEL WELL

(Figure 212)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
05-51-91-790-801	Cabin Pressure Leak Test (P/B 201)
51-05-01-210-808	737-7/8/8200/9 Basic Task Description (P/B 201)
53-14-01-020-801	Nose Wheel Well Access Panels Removal (P/B 401)
53-14-01-420-801	Nose Wheel Well Access Panels Installation (P/B 401)

B. Location Zones

Zone	Area
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right

C. Access Panels

Number	Name/Location
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel
S1101	Area Above And Outboard of Nose Wheel Well Inspection

D. Inspection

SUBTASK 53-05-03-010-054

- (1) Open this access panel:

Number	Name/Location
S1101	Area Above And Outboard of Nose Wheel Well Inspection

NOTE: Access through nose wheel well side and top access panels, and through access panel in crew floor. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-010-055

- (2) Open these access panels:

Number	Name/Location
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

NOTE: Access through nose wheel well side and top access panels, and through access panel in crew floor. Remove/displace insulation blankets as required.

- (a) Do this task: Nose Wheel Well Access Panels Removal, TASK 53-14-01-020-801.

SUBTASK 53-05-03-210-008

- (3) Do a General Visual inspection of the fuselage lower lobe from canted bulkhead (Sta 216.8 to 221.6) to Sta 294, including:

1. Skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices, bulkhead at Sta 259.5.

EFFECTIVITY
SIA ALL

53-05-03

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2. Nose wheel well cutout surround structure, nose wheel well side and top panels.
3. Trunnion support fitting, actuator support fitting and drag brace fitting.

SUBTASK 53-05-03-910-010

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

SUBTASK 53-05-03-410-008

- (5) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

- (a) Do this task: Nose Wheel Well Access Panels Installation, TASK 53-14-01-420-801.
- (b) Do this task: Cabin Pressure Leak Test, TASK 05-51-91-790-801.

SUBTASK 53-05-03-410-040

- (6) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
S1101	Area Above And Outboard of Nose Wheel Well Inspection

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

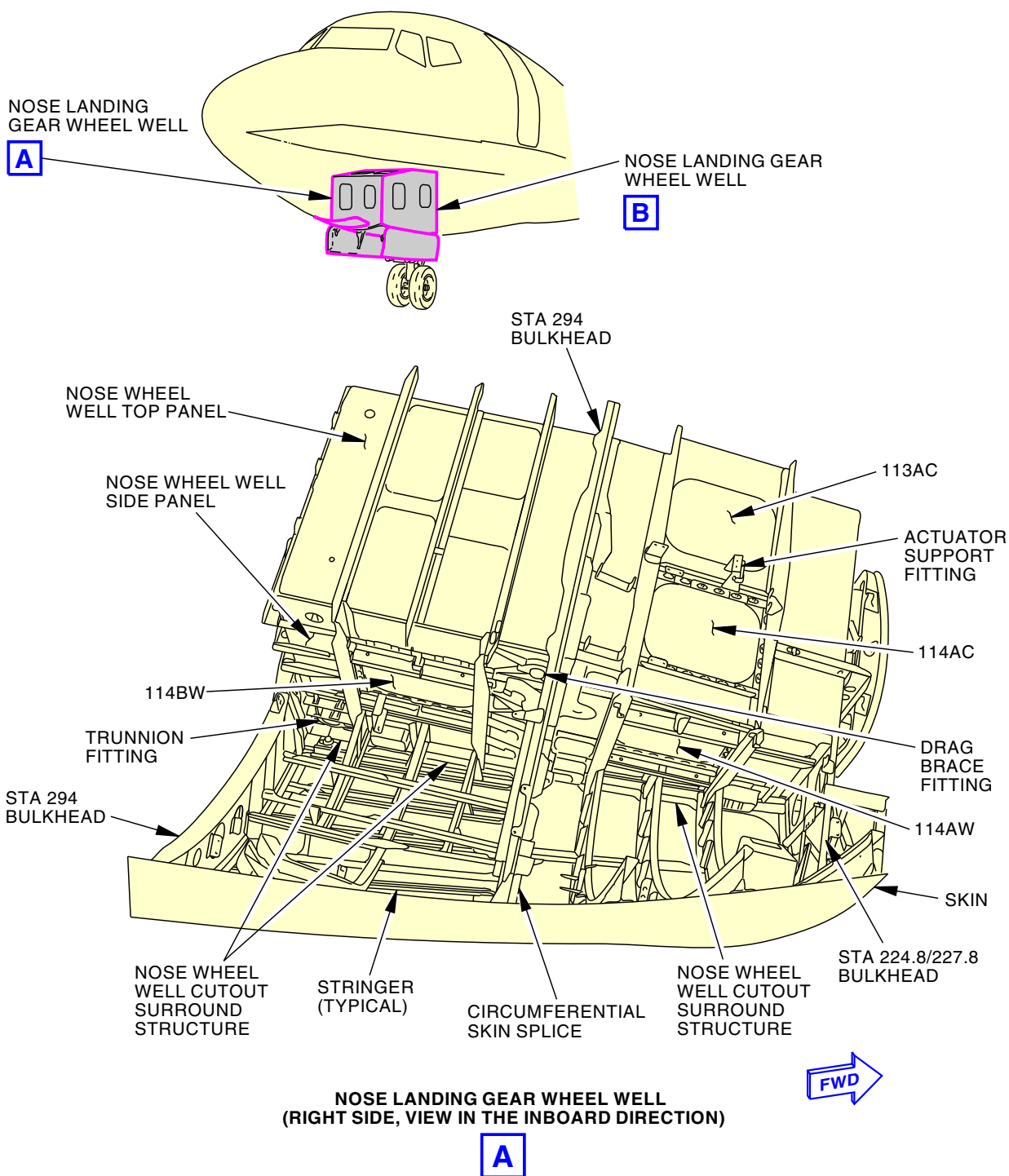
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



2416017 S00061539640_V2

Above and Outboard of the Nose Landing Gear Wheel Well General Visual (Internal)
Figure 212/53-05-03-990-812 (Sheet 1 of 2)

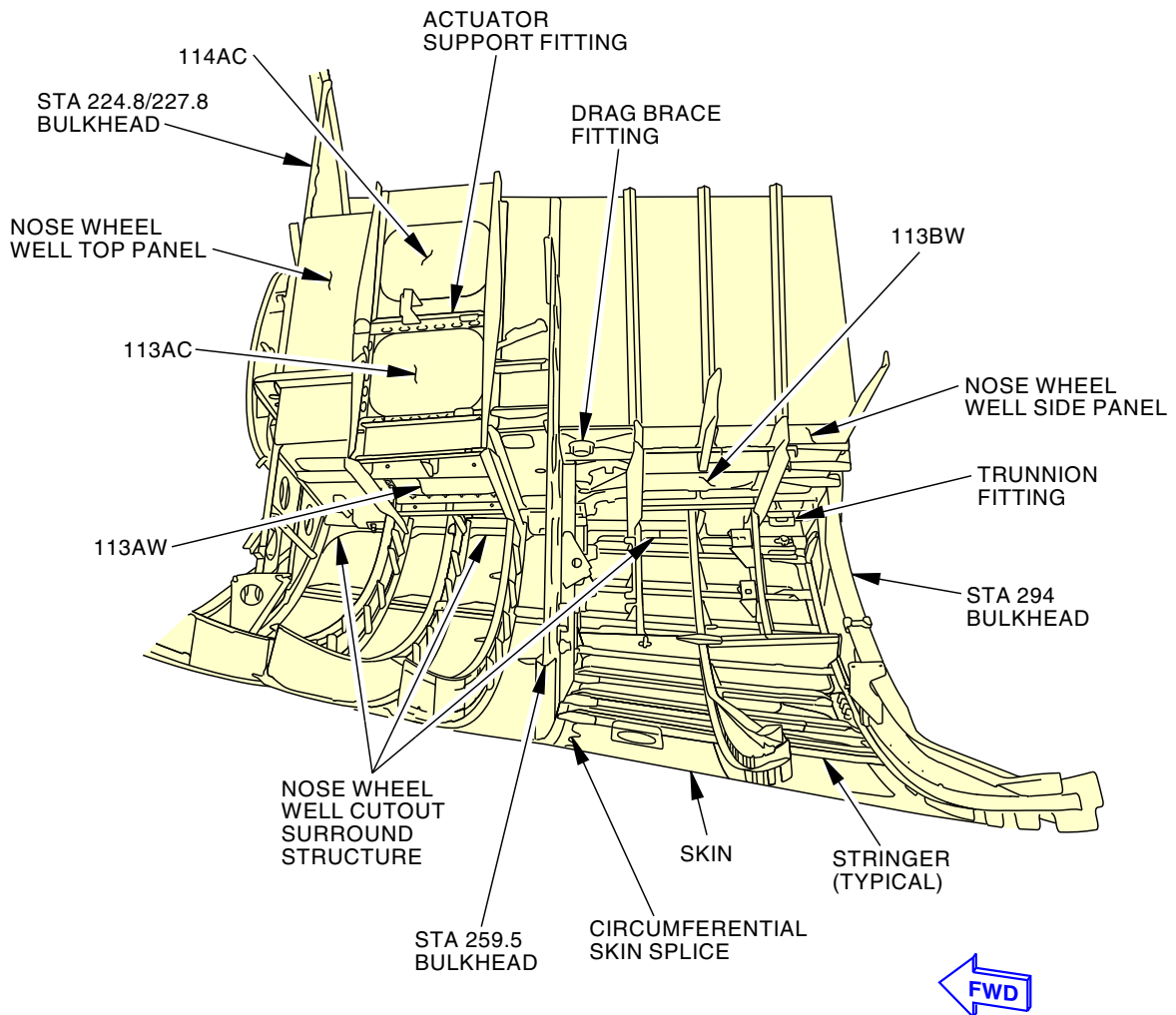
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**NOSE LANDING GEAR WHEEL WELL
(LEFT SIDE, VIEW IN THE DOWN DIRECTION)**

B

2416018 S00061539641_V2

**Above and Outboard of the Nose Landing Gear Wheel Well General Visual (Internal)
Figure 212/53-05-03-990-812 (Sheet 2 of 2)**

EFFECTIVITY
SIA ALL

53-05-03

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-809

11. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - DRY AREA
(Figure 213)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
50-10-02-000-801	Cargo Compartment Sidewall Liners Removal (P/B 401)
50-10-02-400-801	Cargo Compartment Sidewall Liners Installation (P/B 401)
50-10-03-000-801	Cargo Compartment Ceiling Liner Removal (P/B 401)
50-10-03-400-801	Cargo Compartment Ceiling Liner Installation (P/B 401)
51-05-01-210-808	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - Right

C. Access Panels

Number	Name/Location
117BL	Forward Airstair Door
S1101	Area Above And Outboard of Nose Wheel Well Inspection

D. Inspection

SUBTASK 53-05-03-010-009

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
117BL	Forward Airstair Door
S1101	Area Above And Outboard of Nose Wheel Well Inspection

NOTE: Remove or displace auxiliary fuel tank as required (business jet only). Remove forward airstairs and airstairs compartment (if installed).

SUBTASK 53-05-03-010-086

- (2) If it is necessary, do the following tasks:

- (a) Cargo Compartment Sidewall Liners Removal, TASK 50-10-02-000-801
- (b) Cargo Compartment Ceiling Liner Removal, TASK 50-10-03-000-801

NOTE: Remove ceiling and sidewall panels as required. Remove/displace insulation blankets as required.

EFFECTIVITY
SIA ALL

D633AM101-SIA

53-05-03

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**737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-05-03-210-009

- (3) Do a General Visual inspection of the passenger compartment floor structure in dry areas (away from doors, galleys and lavs) from lower lobe.

SUBTASK 53-05-03-910-011

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

SUBTASK 53-05-03-410-070

- (5) If the ceiling or sidewall panels were removed, then do the following applicable tasks:
- (a) Cargo Compartment Sidewall Liners Installation, TASK 50-10-02-400-801
 - (b) Cargo Compartment Ceiling Liner Installation, TASK 50-10-03-400-801

SUBTASK 53-05-03-410-009

- (6) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
117BL	Forward Airstair Door
S1101	Area Above And Outboard of Nose Wheel Well Inspection

————— **END OF TASK** —————

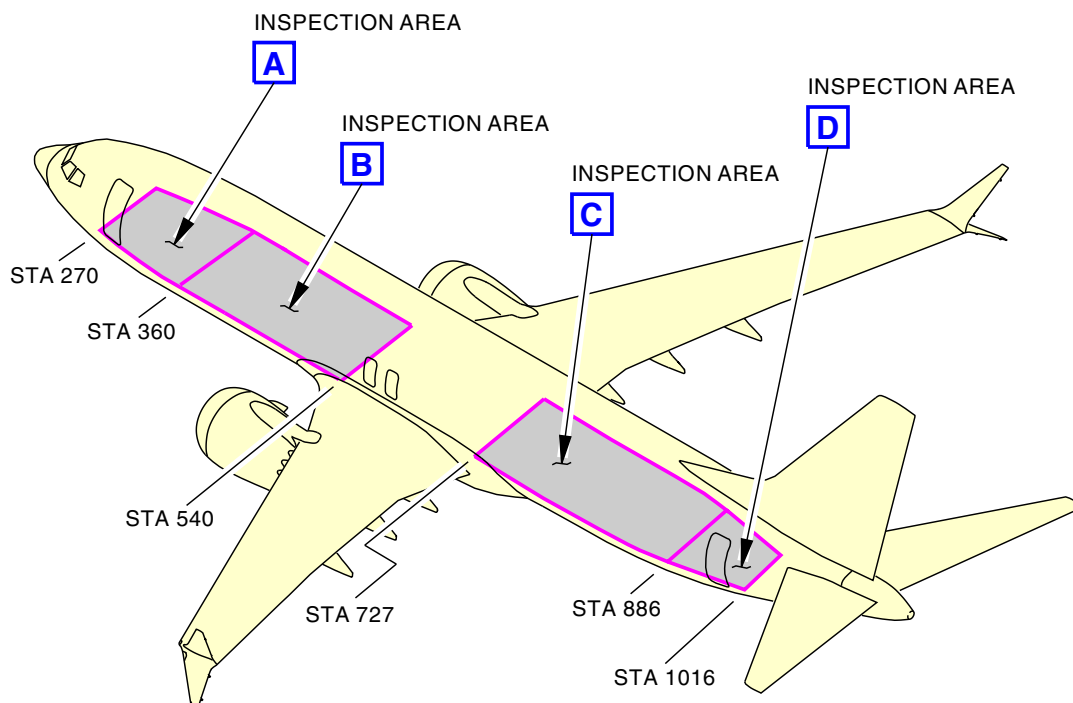
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416019 S00061539643_V1

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE
Figure 213/53-05-03-990-813 (Sheet 1 of 5)

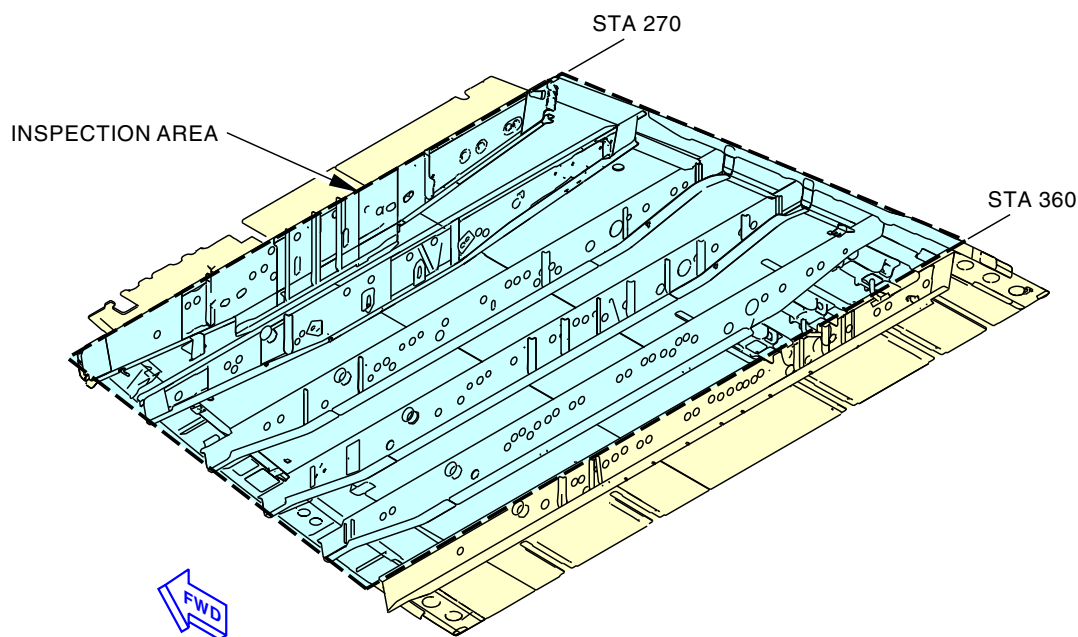
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

53-05-03

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**PASSENGER COMPARTMENT FLOOR STRUCTURE
(BOTTOM VIEW)**

A

2416020 S00061539644_V1

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE
Figure 213/53-05-03-990-813 (Sheet 2 of 5)

EFFECTIVITY
SIA ALL

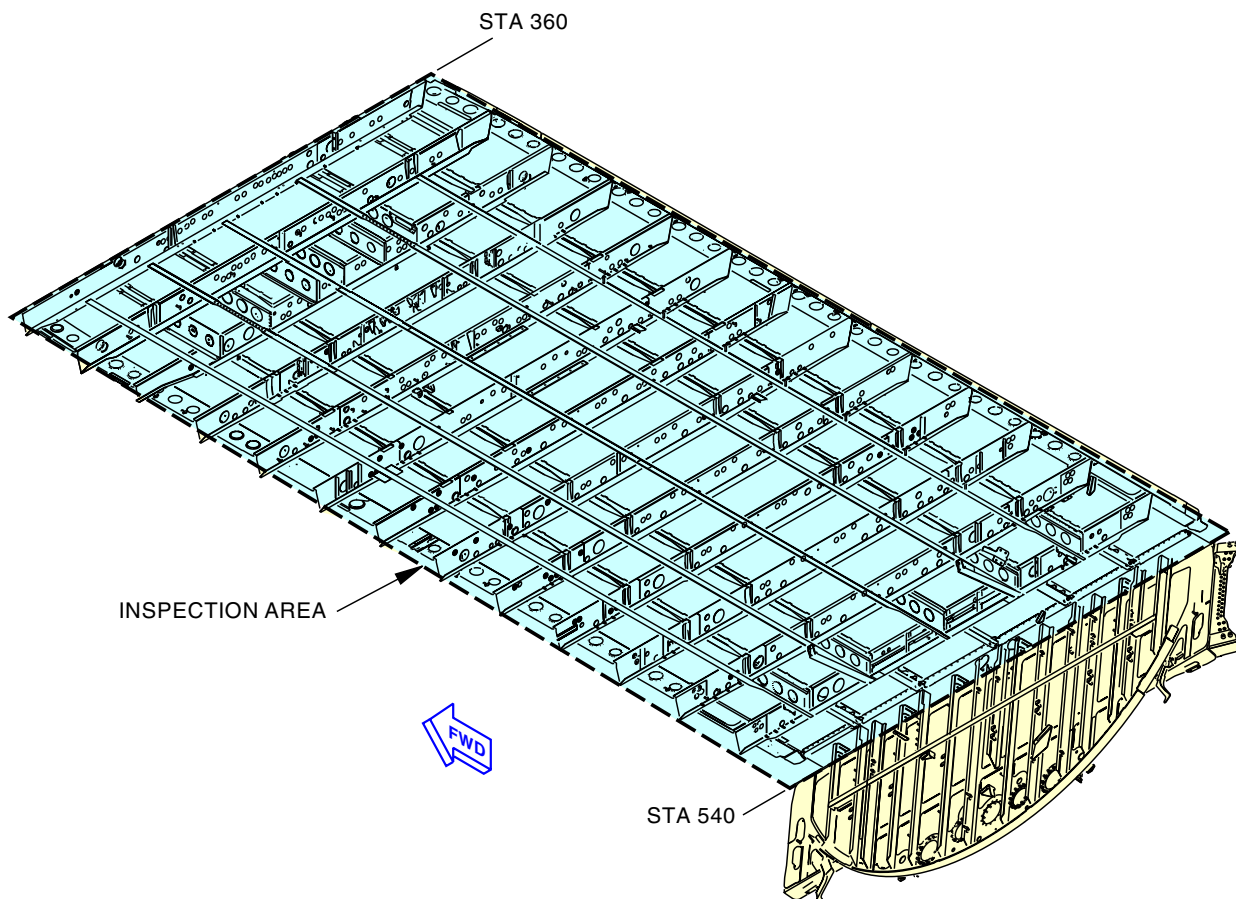
D633AM101-SIA

53-05-03

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AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT FLOOR STRUCTURE
(BOTTOM VIEW)

B

2416021 S00061539645_V1

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE
Figure 213/53-05-03-990-813 (Sheet 3 of 5)

EFFECTIVITY
SIA ALL

53-05-03

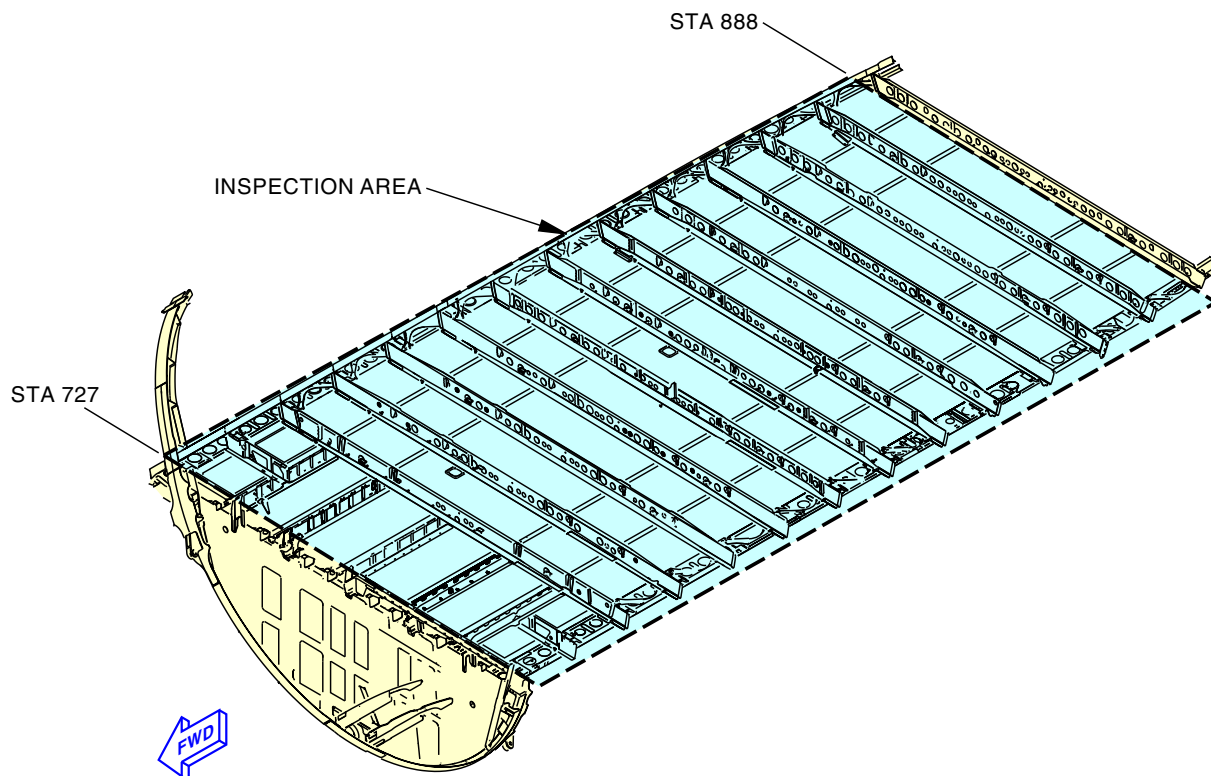
D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT FLOOR STRUCTURE
(BOTTOM VIEW)

C

MPD ITEM
53-100-00

2416022 S00061539646_V1

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE
Figure 213/53-05-03-990-813 (Sheet 4 of 5)

EFFECTIVITY
SIA ALL

53-05-03

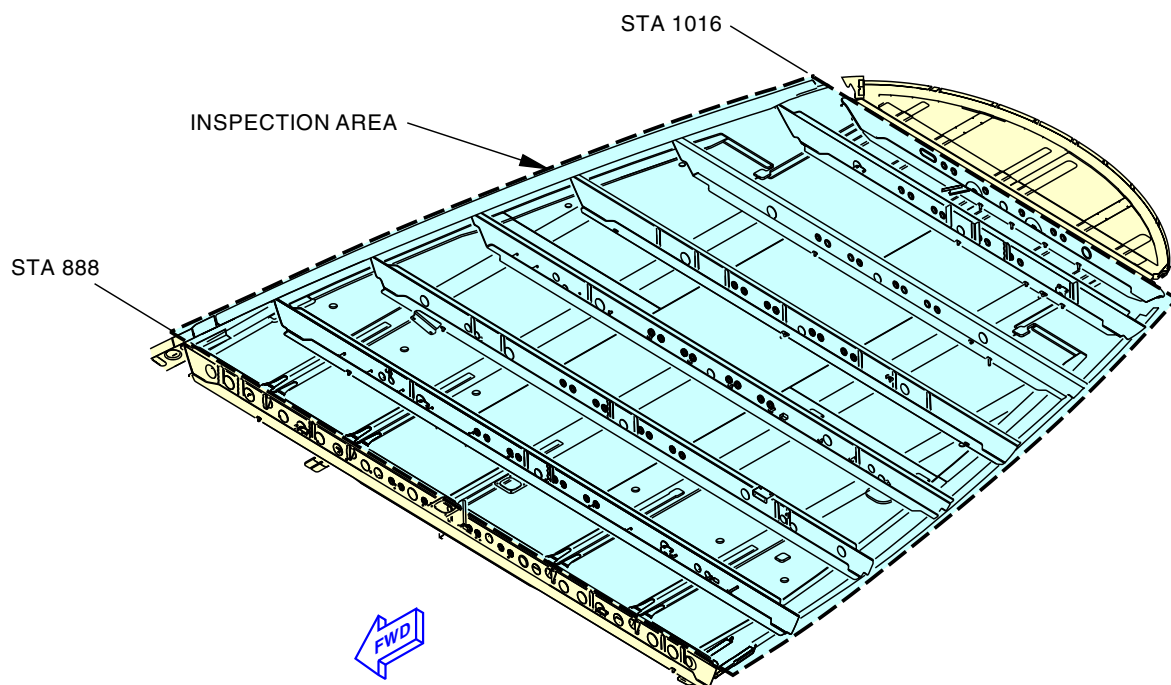
D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT FLOOR STRUCTURE
(BOTTOM VIEW)

D

2416023 S00061539647_V1

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE
Figure 213/53-05-03-990-813 (Sheet 5 of 5)

EFFECTIVITY
SIA ALL

53-05-03

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-810

12. **INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - WET AREA**
(Figure 214)

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
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - Right

C. Access Panels

Number	Name/Location
117BL	Forward Airstair Door
S1101	Area Above And Outboard of Nose Wheel Well Inspection

D. Inspection

SUBTASK 53-05-03-010-010

- (1) Open these access panels:

Number	Name/Location
117BL	Forward Airstair Door
S1101	Area Above And Outboard of Nose Wheel Well Inspection

NOTE: Remove ceiling and sidewall panels as required. Remove/displace insulation blankets as required. Remove or displace auxiliary fuel tank as required (business jet only). Remove forward airstairs and airstair compartment (if installed. 117BL).

SUBTASK 53-05-03-210-010

- (2) Do a General Visual inspection of the passenger compartment floor structure in wet areas (within approximately 20 inches from doors, galleys and lavs) from lower lobe.

SUBTASK 53-05-03-910-012

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

SUBTASK 53-05-03-410-010

- (4) Close these access panels:

Number	Name/Location
117BL	Forward Airstair Door

EFFECTIVITY
SIA ALL

D633AM101-SIA

53-05-03

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
S1101	Area Above And Outboard of Nose Wheel Well Inspection

————— END OF TASK —————

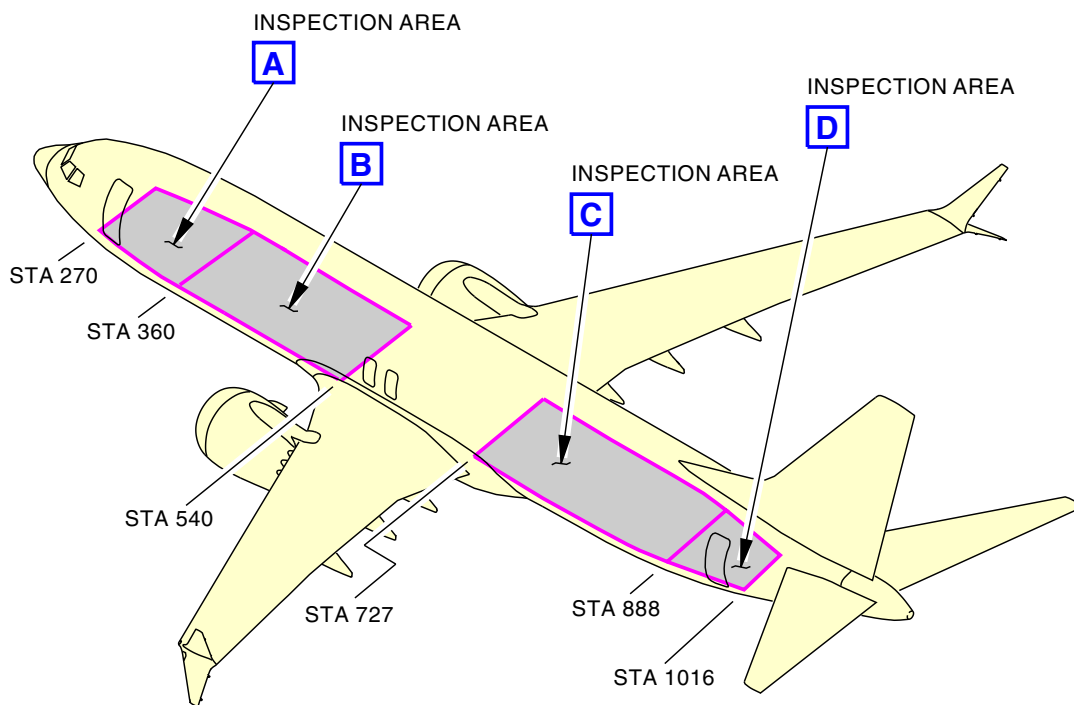
EFFECTIVITY
SIA ALL

D633AM101-SIA

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2416024 S00061539649_V1

Passenger Compartment Structure-Wet Area General Visual (Internal)
Figure 214/53-05-03-990-814 (Sheet 1 of 5)

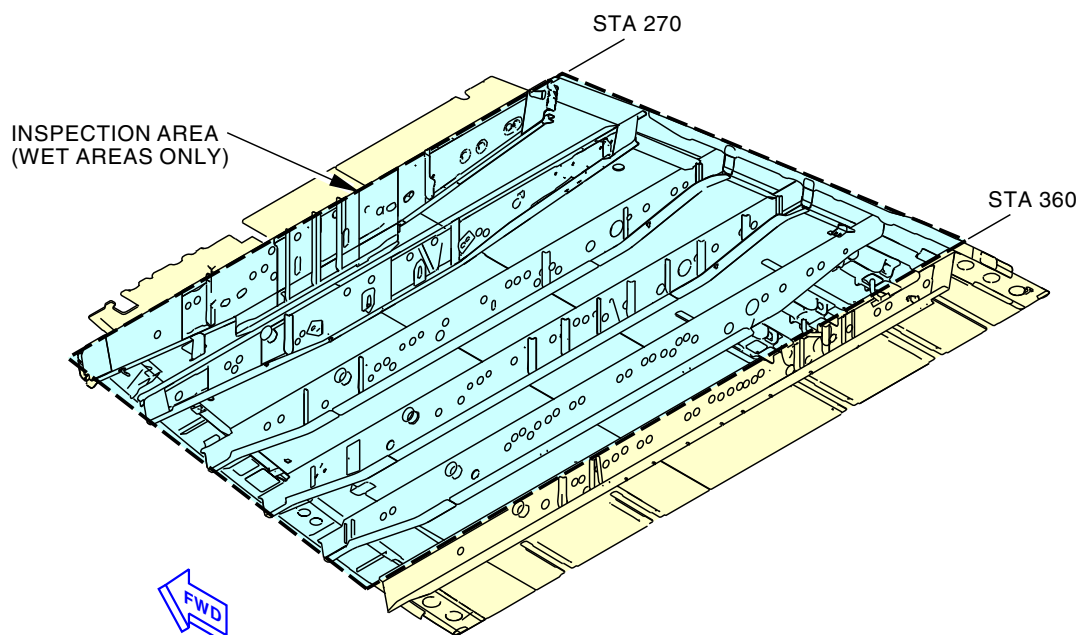
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**PASSENGER COMPARTMENT FLOOR STRUCTURE
(BOTTOM VIEW)**

A

2416025 S00061539650_V1

Passenger Compartment Structure-Wet Area General Visual (Internal)
Figure 214/53-05-03-990-814 (Sheet 2 of 5)

EFFECTIVITY
SIA ALL

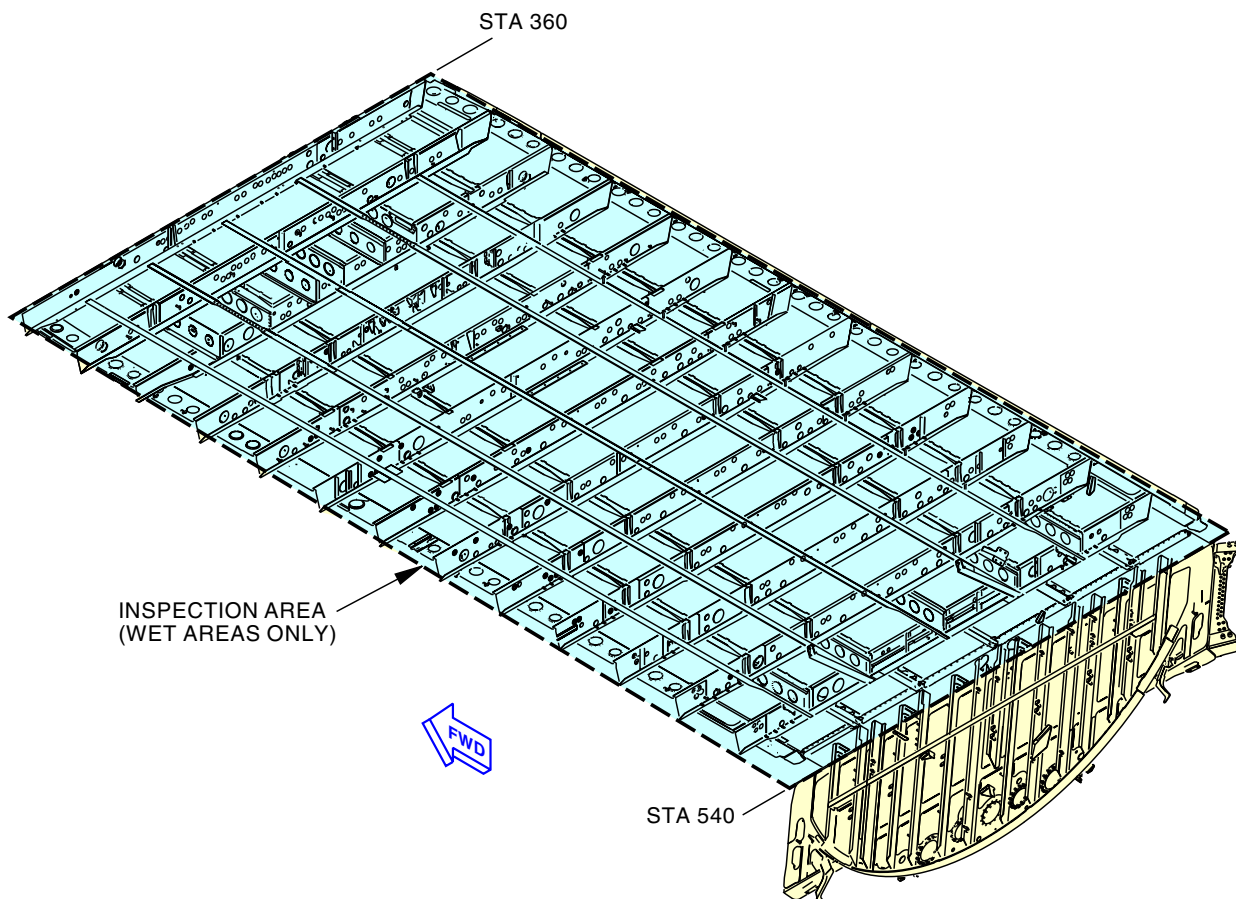
53-05-03

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AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT FLOOR STRUCTURE
(BOTTOM VIEW)

B

2416026 S00061539651_V1

Passenger Compartment Structure-Wet Area General Visual (Internal)
Figure 214/53-05-03-990-814 (Sheet 3 of 5)

EFFECTIVITY
SIA ALL

53-05-03

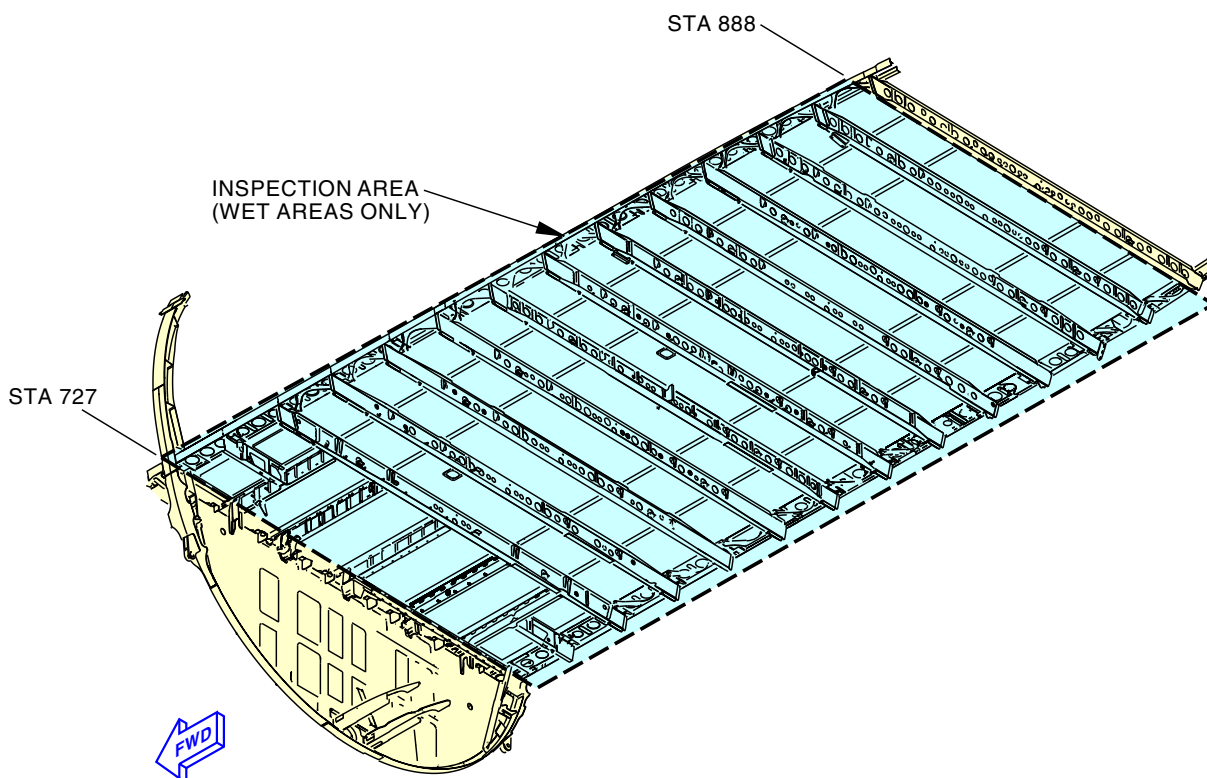
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT FLOOR STRUCTURE
(BOTTOM VIEW)

C

2416027 S00061539652_V1

Passenger Compartment Structure-Wet Area General Visual (Internal)
Figure 214/53-05-03-990-814 (Sheet 4 of 5)

EFFECTIVITY
SIA ALL

53-05-03

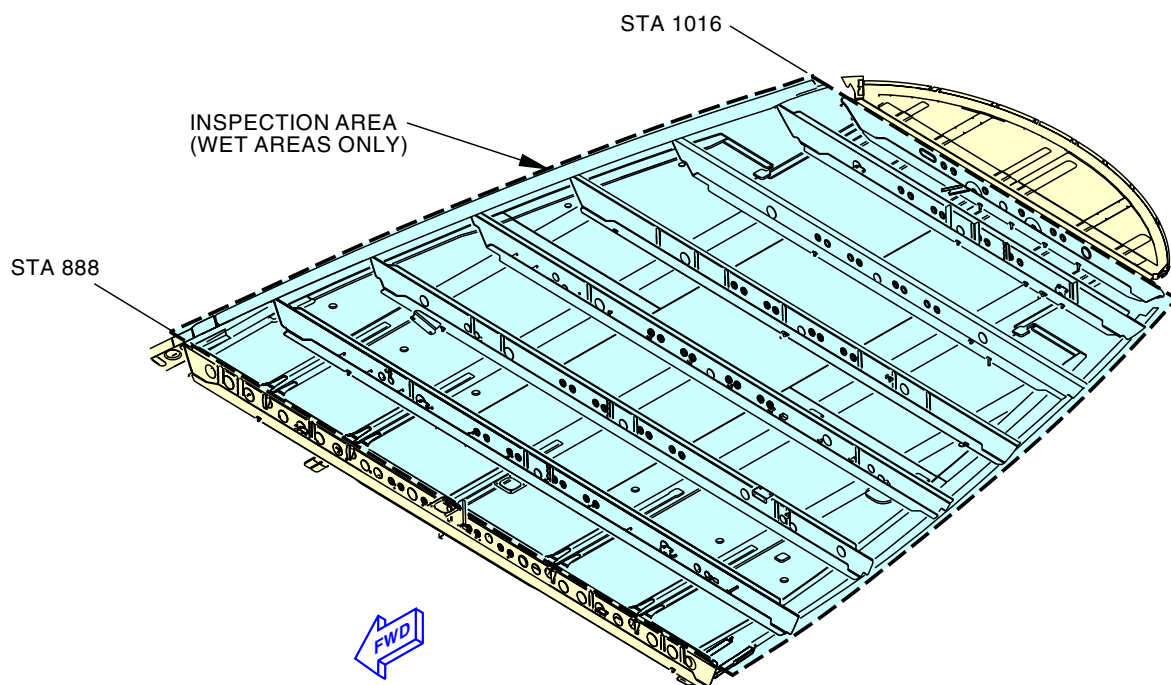
D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT FLOOR STRUCTURE
(BOTTOM VIEW)

D

2416028 S00061539653_V1

Passenger Compartment Structure-Wet Area General Visual (Internal)
Figure 214/53-05-03-990-814 (Sheet 5 of 5)

EFFECTIVITY
SIA ALL

53-05-03

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-811

13. **INTERNAL - GENERAL VISUAL: ELECTRICAL AND ELECTRONICS COMPARTMENT**

(Figure 215)

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
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

C. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door
S1102	Electrical And Electronics Compartment Inspection

D. Inspection

SUBTASK 53-05-03-010-011

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
117A	Electronic Equipment Access Door
S1102	Electrical And Electronics Compartment Inspection

NOTE: Remove LRUs and racks. Do not remove permanently installed structure.
Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-011

- (2) Do a general visual inspection of the EE compartment (STA 294.5 to STA 400), including:
- (a) Skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices, bulkhead at STA 294.5
 - (b) EE compartment door and airstairs door cutout surround structure
 - (c) Forward entry and galley door cutout surround structure (portion in lower lobe).

SUBTASK 53-05-03-910-013

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

SUBTASK 53-05-03-410-011

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
117A	Electronic Equipment Access Door
S1102	Electrical And Electronics Compartment Inspection

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

53-05-03

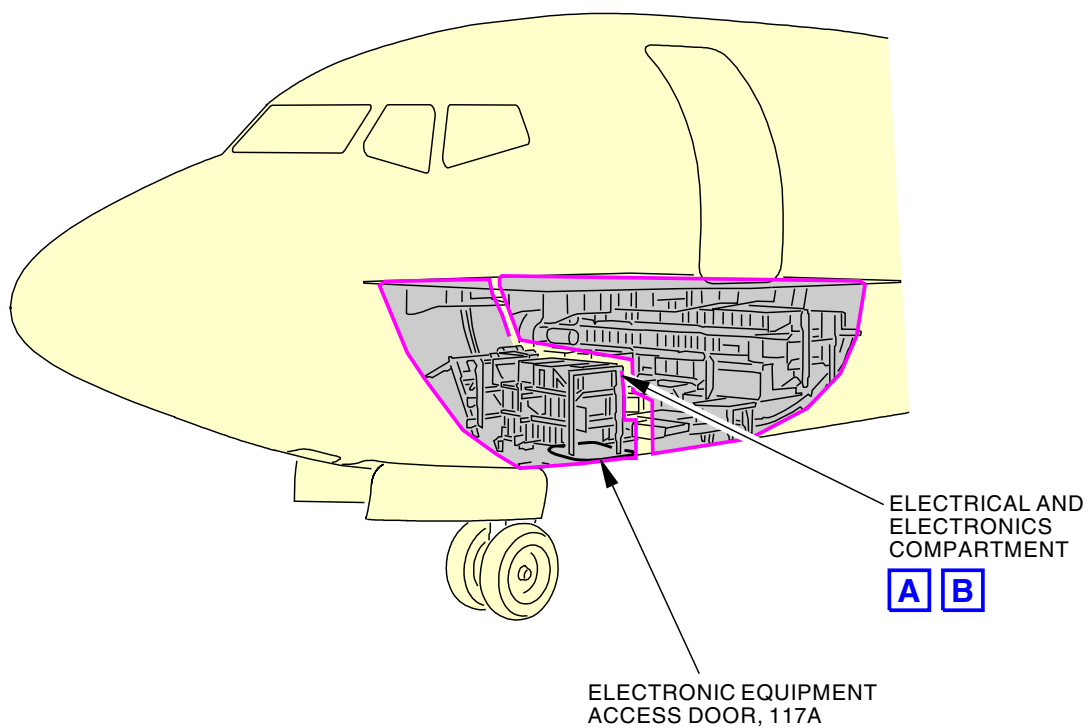
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2416029 S00061539655_V1

Electrical Equipment Access Door General Visual (Internal)
Figure 215/53-05-03-990-815 (Sheet 1 of 6)

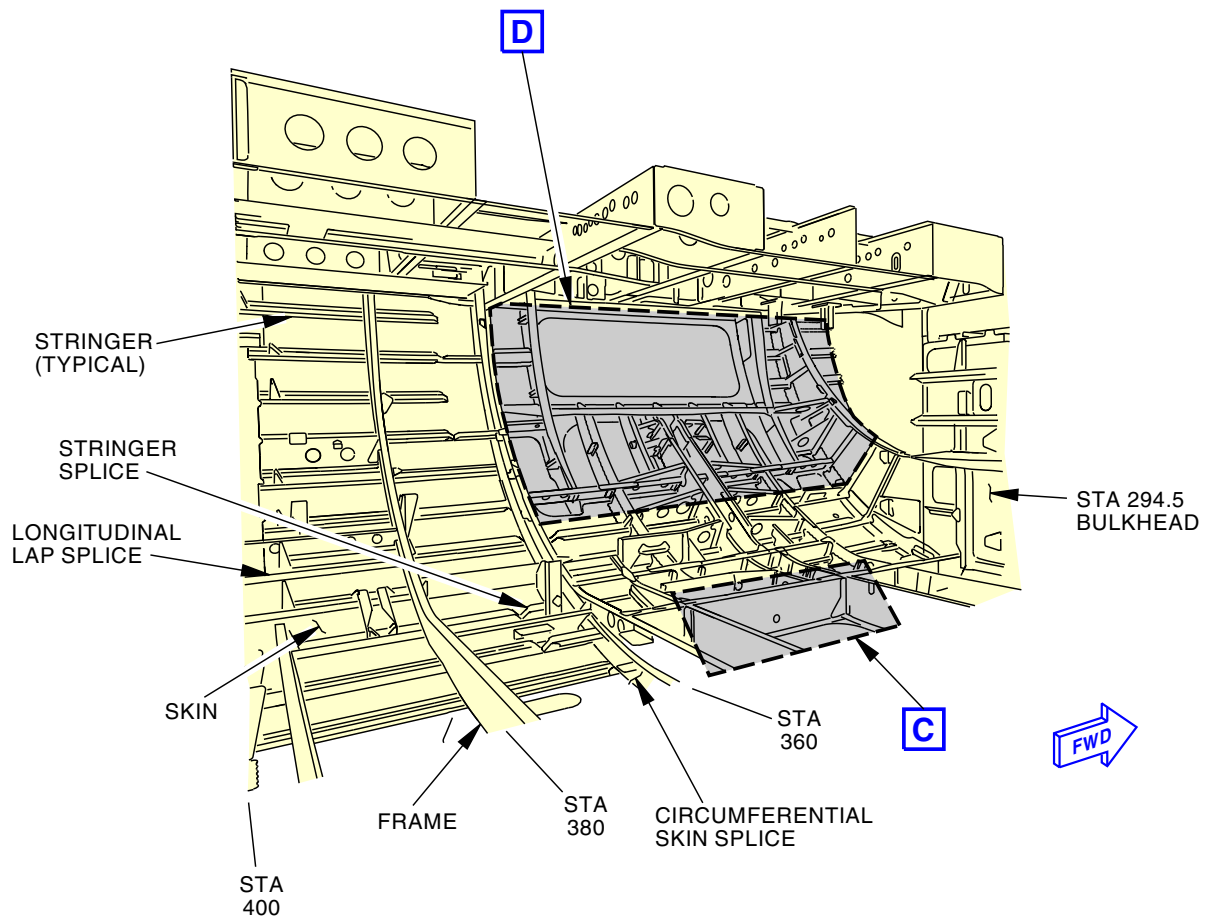
EFFECTIVITY
SIA ALL

D633AM101-SIA

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**ELECTRICAL AND ELECTRONIC COMPARTMENT
(LEFT SIDE)**

A

2416030 S00061539656_V1

Electrical Equipment Access Door General Visual (Internal)
Figure 215/53-05-03-990-815 (Sheet 2 of 6)

EFFECTIVITY
SIA ALL

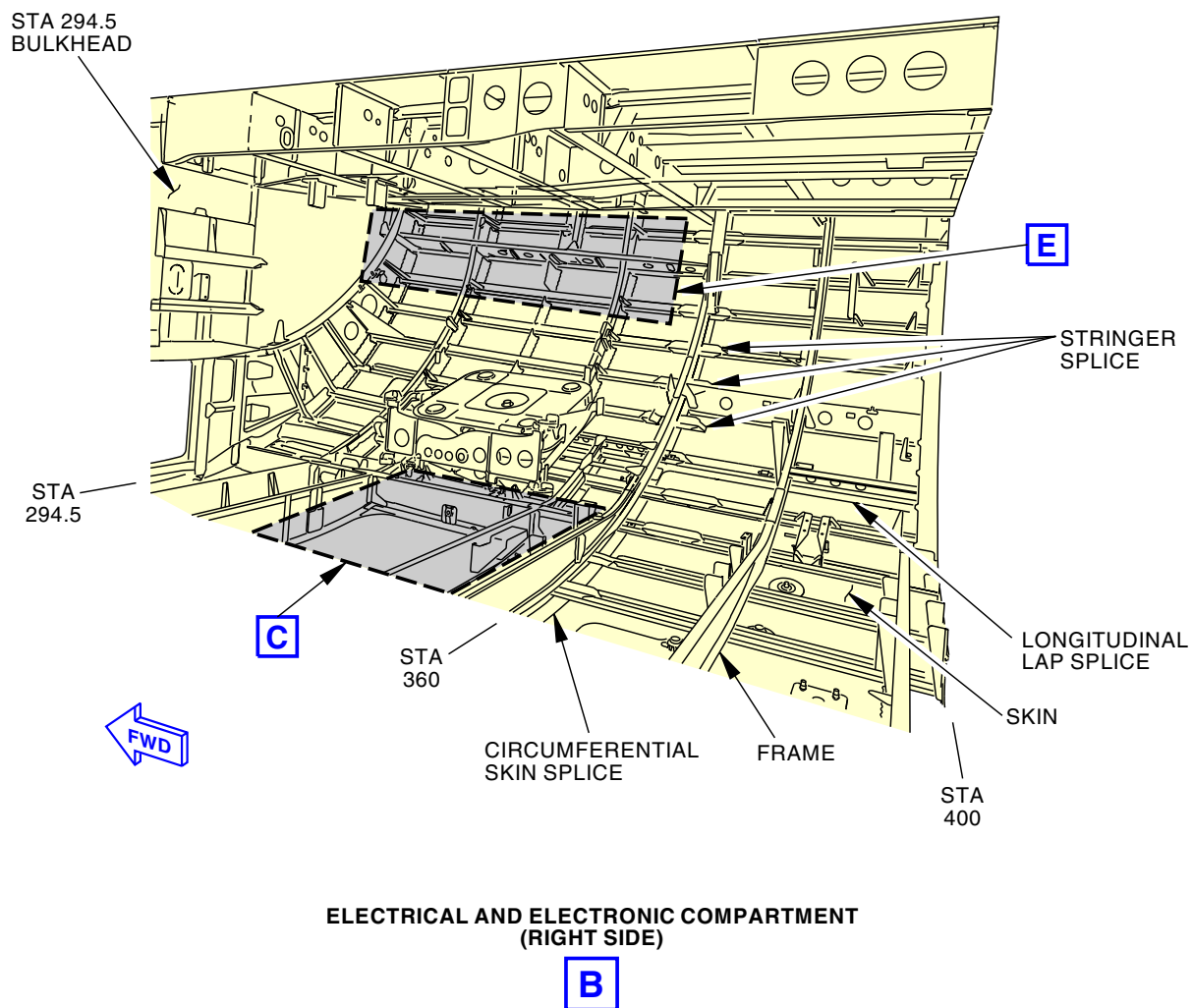
53-05-03

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



2416031 S00061539657_V1

Electrical Equipment Access Door General Visual (Internal)
Figure 215/53-05-03-990-815 (Sheet 3 of 6)

EFFECTIVITY
SIA ALL

D633AM101-SIA

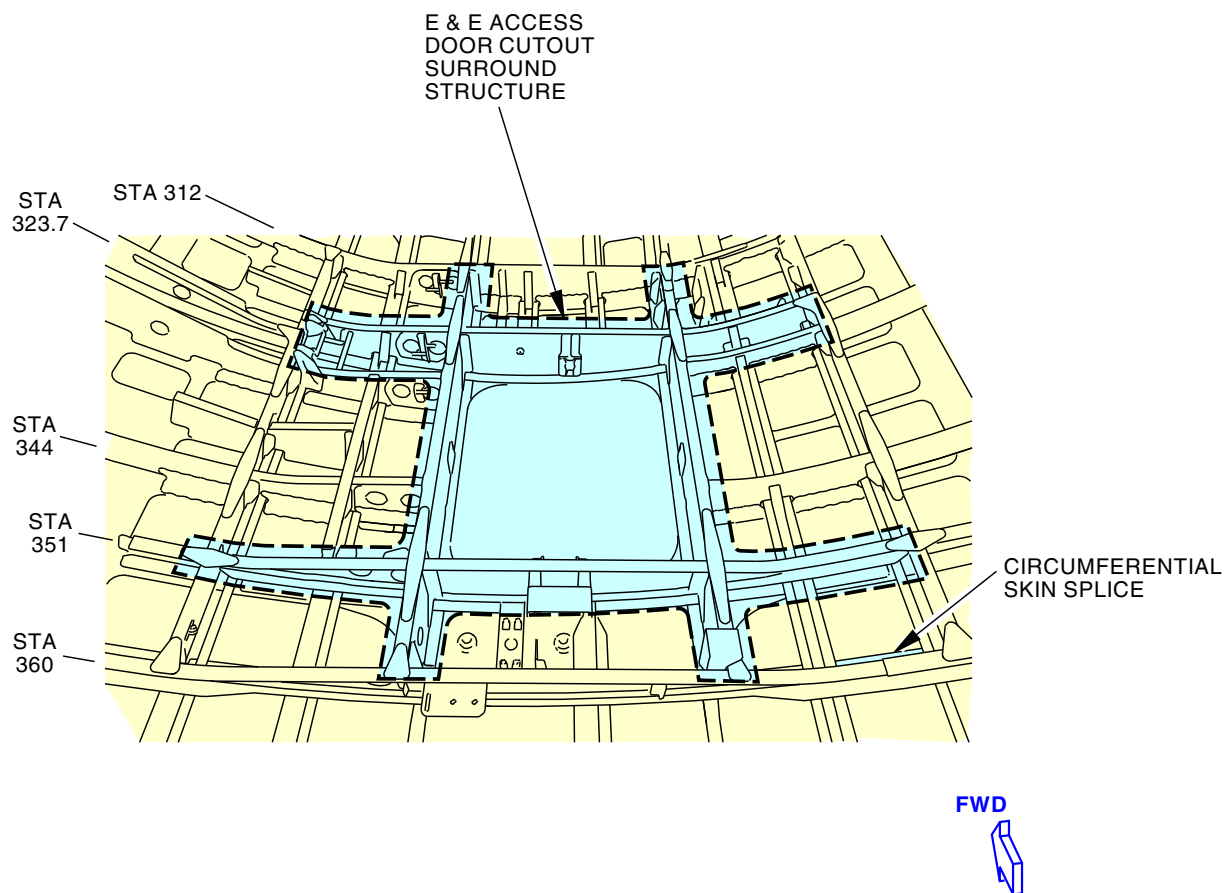
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



ELECTRICAL AND ELECTRONIC COMPARTMENT
ACCESS DOOR CUTOUT SURROUND STRUCTURE

C

2416032 S00061539658_V1

Electrical Equipment Access Door General Visual (Internal)
Figure 215/53-05-03-990-815 (Sheet 4 of 6)

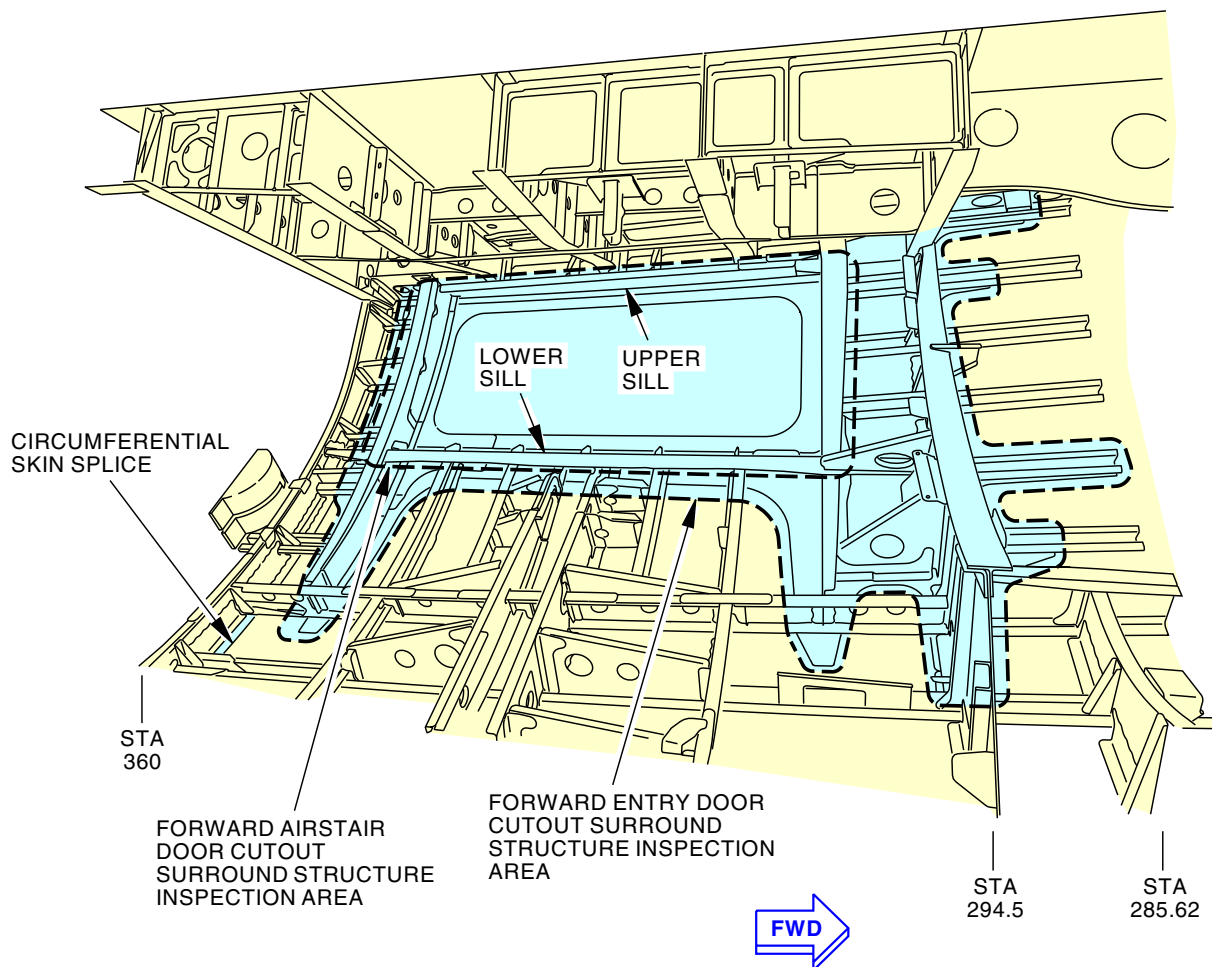
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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FORWARD AIRSTAIR DOOR AND FORWARD ENTRY DOOR CUTOUT AND SURROUND STRUCTURE

D

2416033 S00061539659_V2

Electrical Equipment Access Door General Visual (Internal)
Figure 215/53-05-03-990-815 (Sheet 5 of 6)

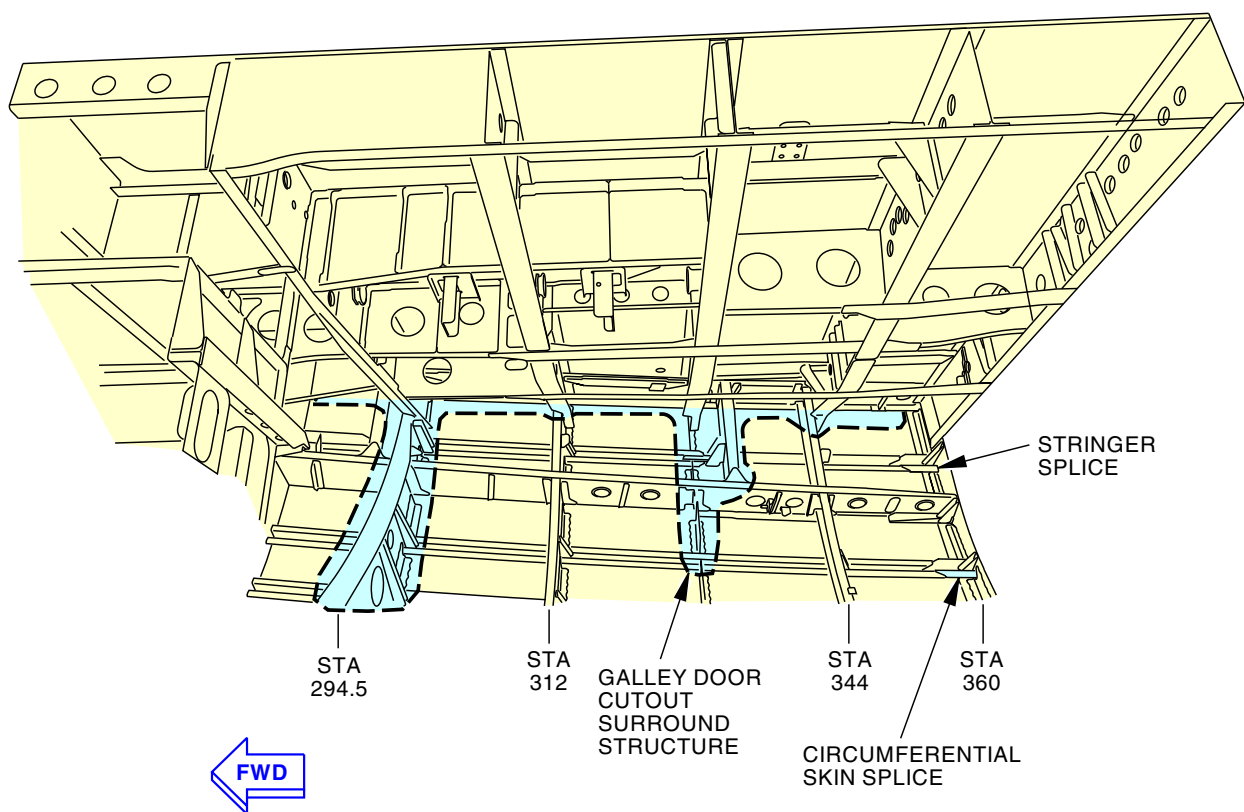
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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GALLEY DOOR CUTOUT SURROUND
STRUCTURE

E

2416034 S00061539660_V1

Electrical Equipment Access Door General Visual (Internal)
Figure 215/53-05-03-990-815 (Sheet 6 of 6)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-812

14. INTERNAL - GENERAL VISUAL: FORWARD CARGO COMPARTMENT

(Figure 216)

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
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right

C. Access Panels

Number	Name/Location
S1201	Forward Cargo Compartment Inspection

D. Inspection

SUBTASK 53-05-03-010-012

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
S1201	Forward Cargo Compartment Inspection

NOTE: Remove sidewalls and ceiling panels. Remove/displace insulation blankets as required. Remove/displace auxiliary fuel tank as required (business jet only).

SUBTASK 53-05-03-210-012

- (2) Do a General Visual inspection of the forward cargo compartment skin panels including skins, frames, and stringers (note: inspection includes the circumferential skin and stringer splice at STA 500E for the -9 models).

SUBTASK 53-05-03-910-014

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

SUBTASK 53-05-03-410-012

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
S1201	Forward Cargo Compartment Inspection

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

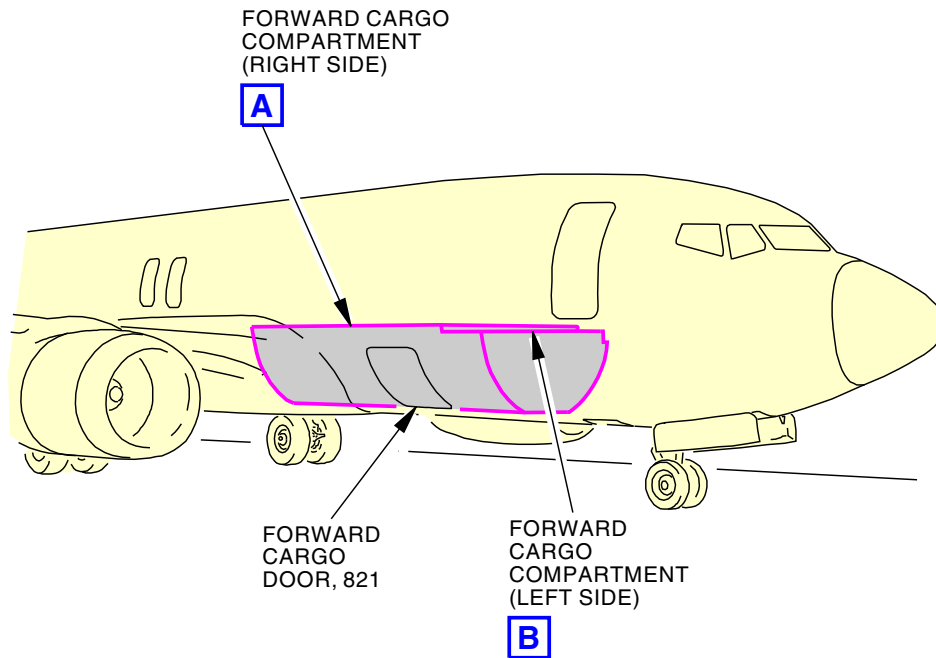
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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



2416035 S00061539662_V1

Forward Cargo Compartment General Visual (Internal) (Sidewall Liners and Insulation Removed)
Figure 216/53-05-03-990-816 (Sheet 1 of 4)

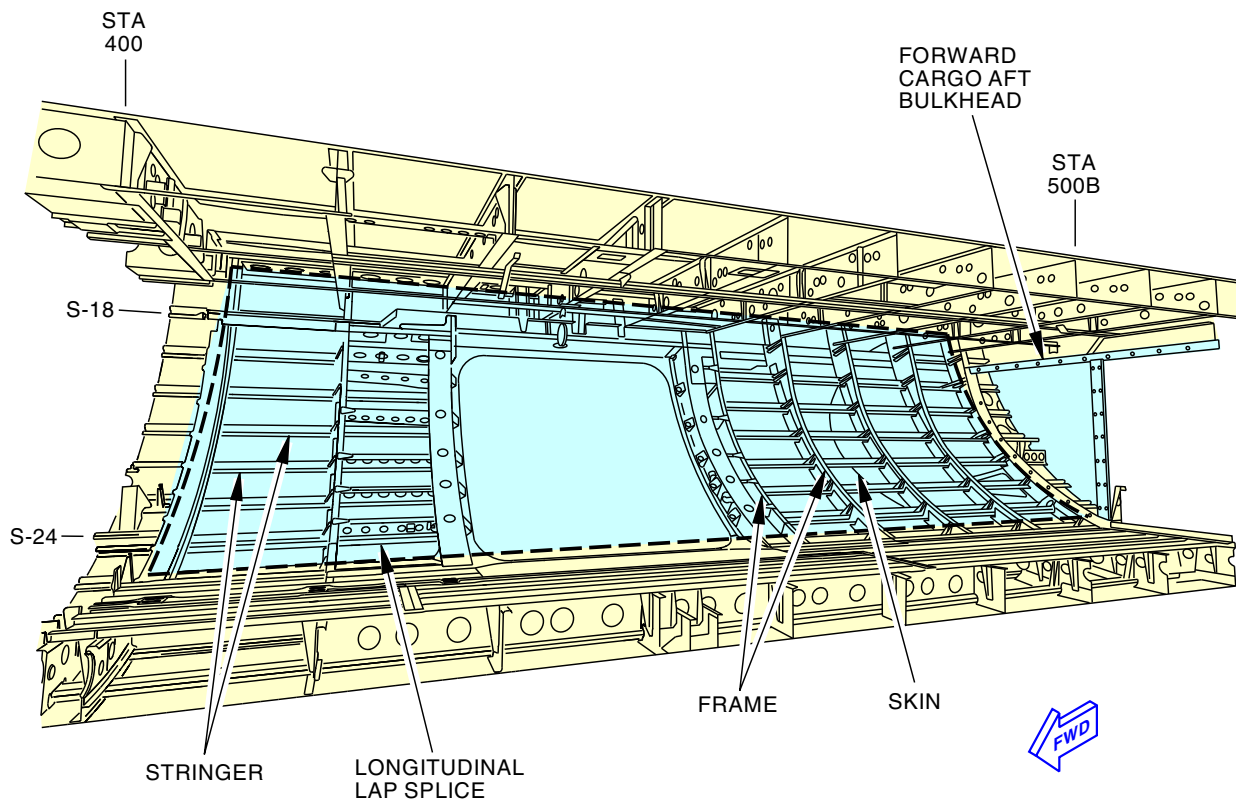
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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FORWARD CARGO COMPARTMENT (STA 400 TO AFT BULKHEAD)
(RIGHT SIDE VIEW)

A

2416036 S00061539663_V1

Forward Cargo Compartment General Visual (Internal) (Sidewall Liners and Insulation Removed)
Figure 216/53-05-03-990-816 (Sheet 2 of 4)

EFFECTIVITY
SIA ALL

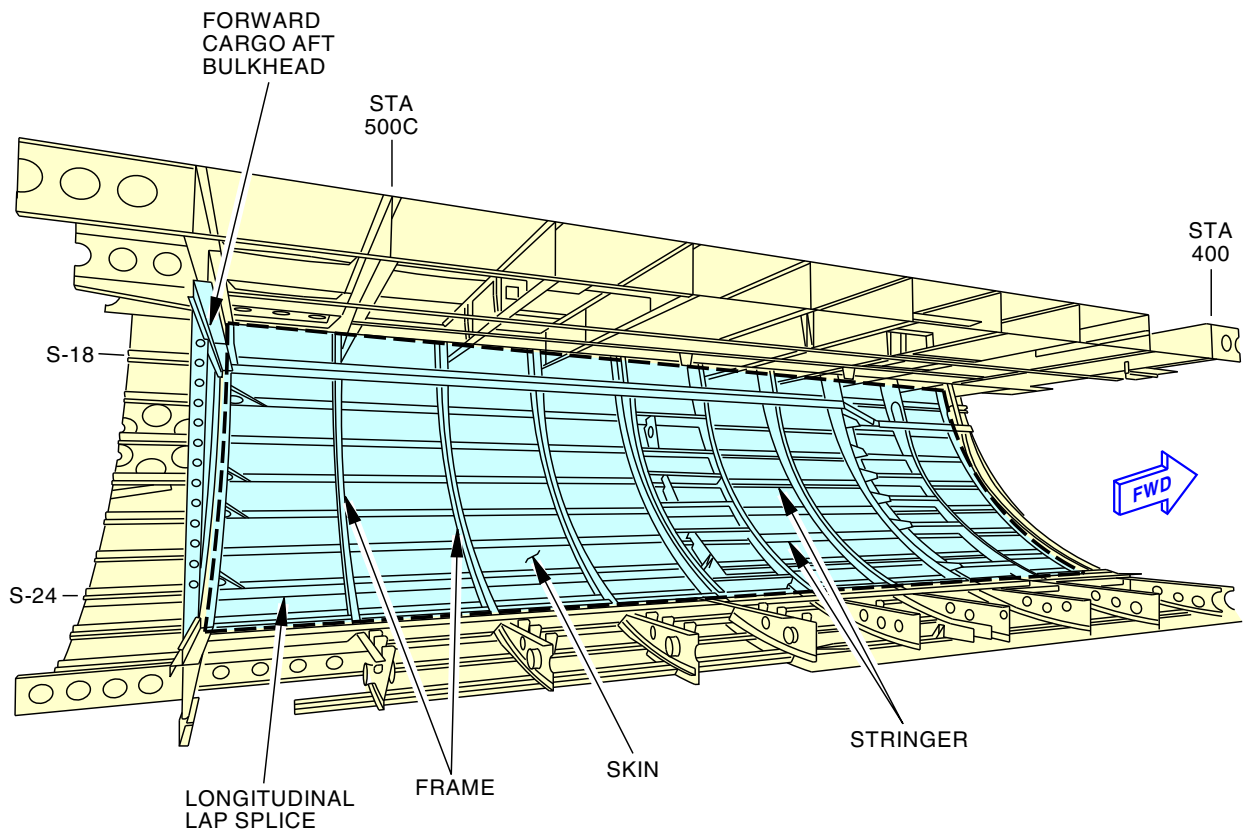
53-05-03

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AIRCRAFT MAINTENANCE MANUAL



FORWARD CARGO COMPARTMENT (STA 400 TO AFT BULKHEAD)
(LEFT SIDE VIEW)

B

2416037 S00061539664_V1

Forward Cargo Compartment General Visual (Internal) (Sidewall Liners and Insulation Removed)
Figure 216/53-05-03-990-816 (Sheet 3 of 4)

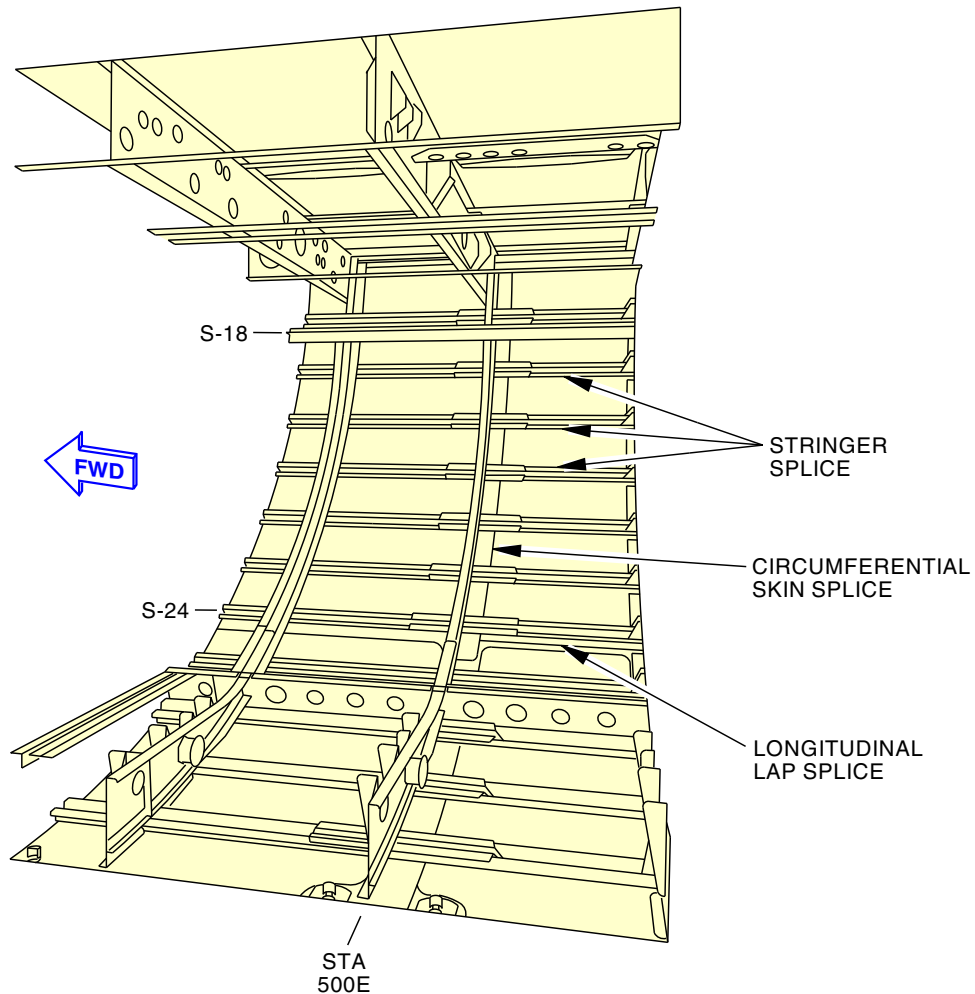
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**CIRCUMFERENTIAL SKIN AND STRINGER SPLICE -900 MODEL
(RIGHT SIDE VIEW, LEFT SIDE OPPOSITE)**

2416038 S00061539665_V1

**Forward Cargo Compartment General Visual (Internal) (Sidewall Liners and Insulation Removed)
Figure 216/53-05-03-990-816 (Sheet 4 of 4)**

EFFECTIVITY
SIA ALL

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TASK 53-05-03-210-813

15. **INTERNAL - GENERAL VISUAL: FORWARD CARGO COMPARTMENT FLOOR STRUCTURE**
(Figure 217)

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
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right

C. Access Panels

Number	Name/Location
S1003	Forward and Aft Cargo Compartment Floor Structure Inspection

D. Inspection

SUBTASK 53-05-03-010-013

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
S1003	Forward and Aft Cargo Compartment Floor Structure Inspection

NOTE: Remove cargo floor panels.

SUBTASK 53-05-03-210-013

- (2) Do a General Visual inspection of the forward cargo compartment floor structure.

SUBTASK 53-05-03-910-015

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

SUBTASK 53-05-03-410-013

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
S1003	Forward and Aft Cargo Compartment Floor Structure Inspection

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

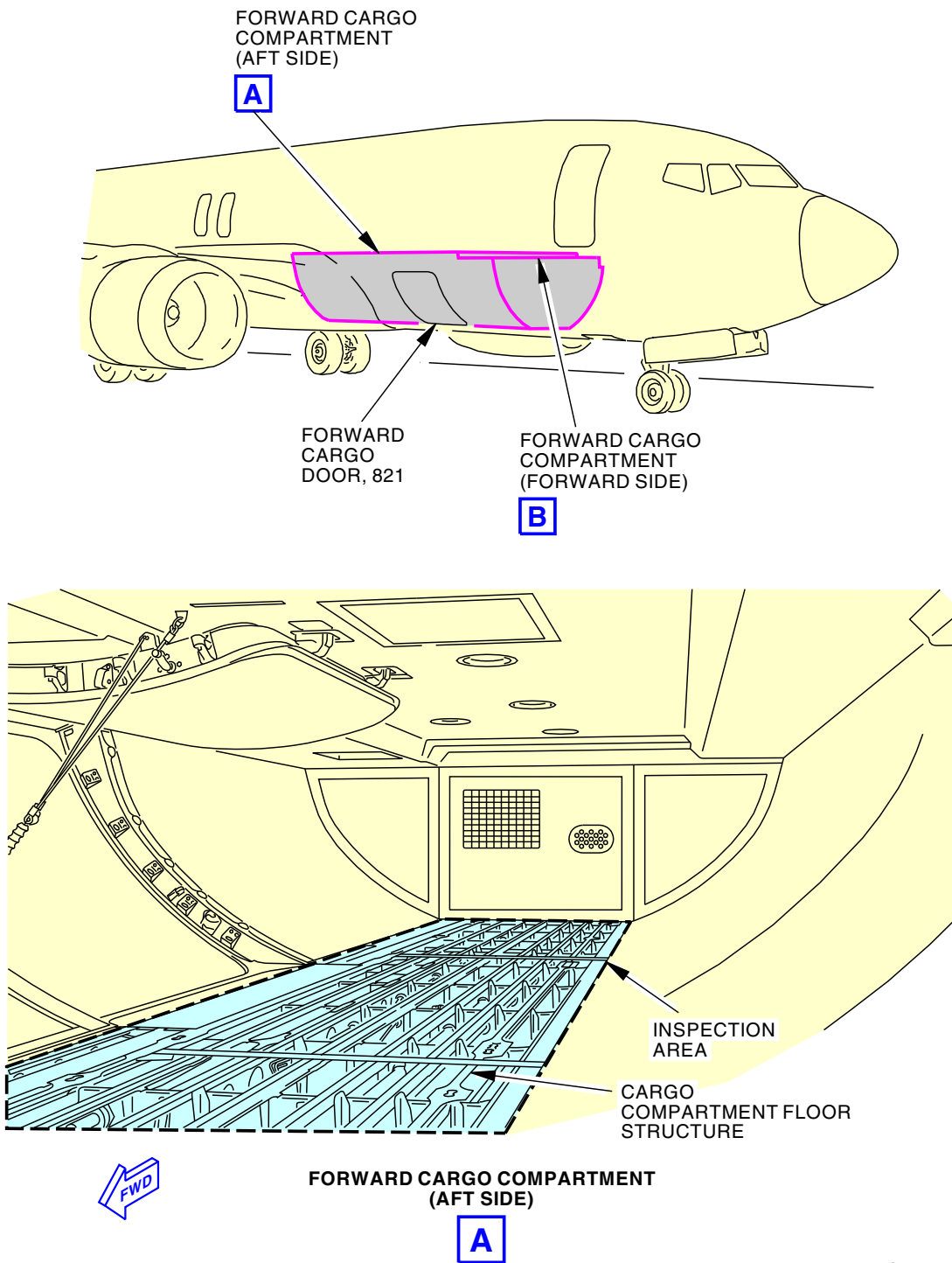
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2416039 S00061539667_V1

Forward Cargo Compartment Floor Structure General Visual (Internal)
Figure 217/53-05-03-990-817 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

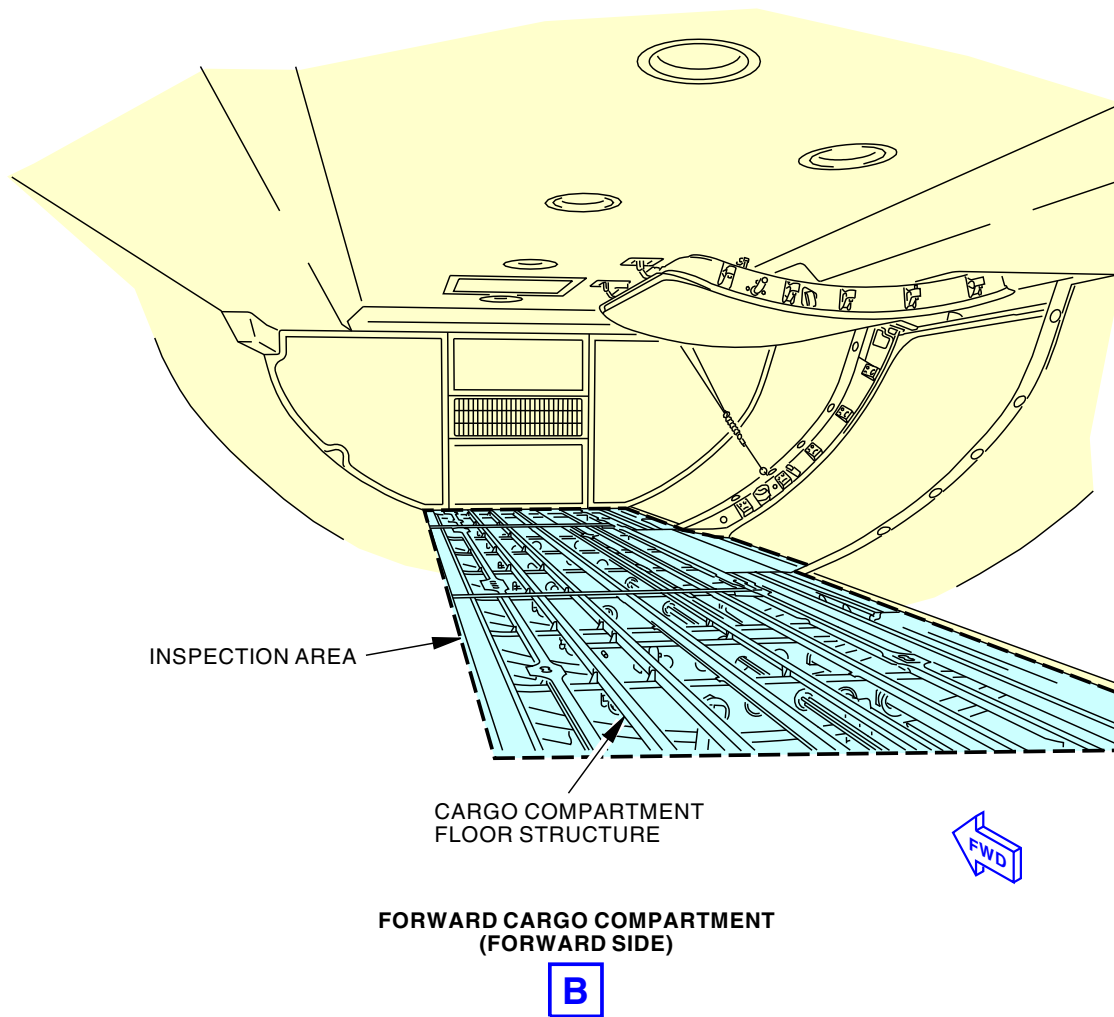
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416040 S00061539668_V1

Forward Cargo Compartment Floor Structure General Visual (Internal)
Figure 217/53-05-03-990-817 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-814

16. **INTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT FLOOR STRUCTURE**

(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
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

C. Access Panels

Number	Name/Location
S1003	Forward and Aft Cargo Compartment Floor Structure Inspection

D. Inspection

SUBTASK 53-05-03-010-014

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
S1003	Forward and Aft Cargo Compartment Floor Structure Inspection

NOTE: Remove cargo floor panels.

SUBTASK 53-05-03-210-014

- (2) Do a General Visual inspection of the aft cargo compartment floor structure.

SUBTASK 53-05-03-910-016

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

SUBTASK 53-05-03-410-014

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
S1003	Forward and Aft Cargo Compartment Floor Structure Inspection

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

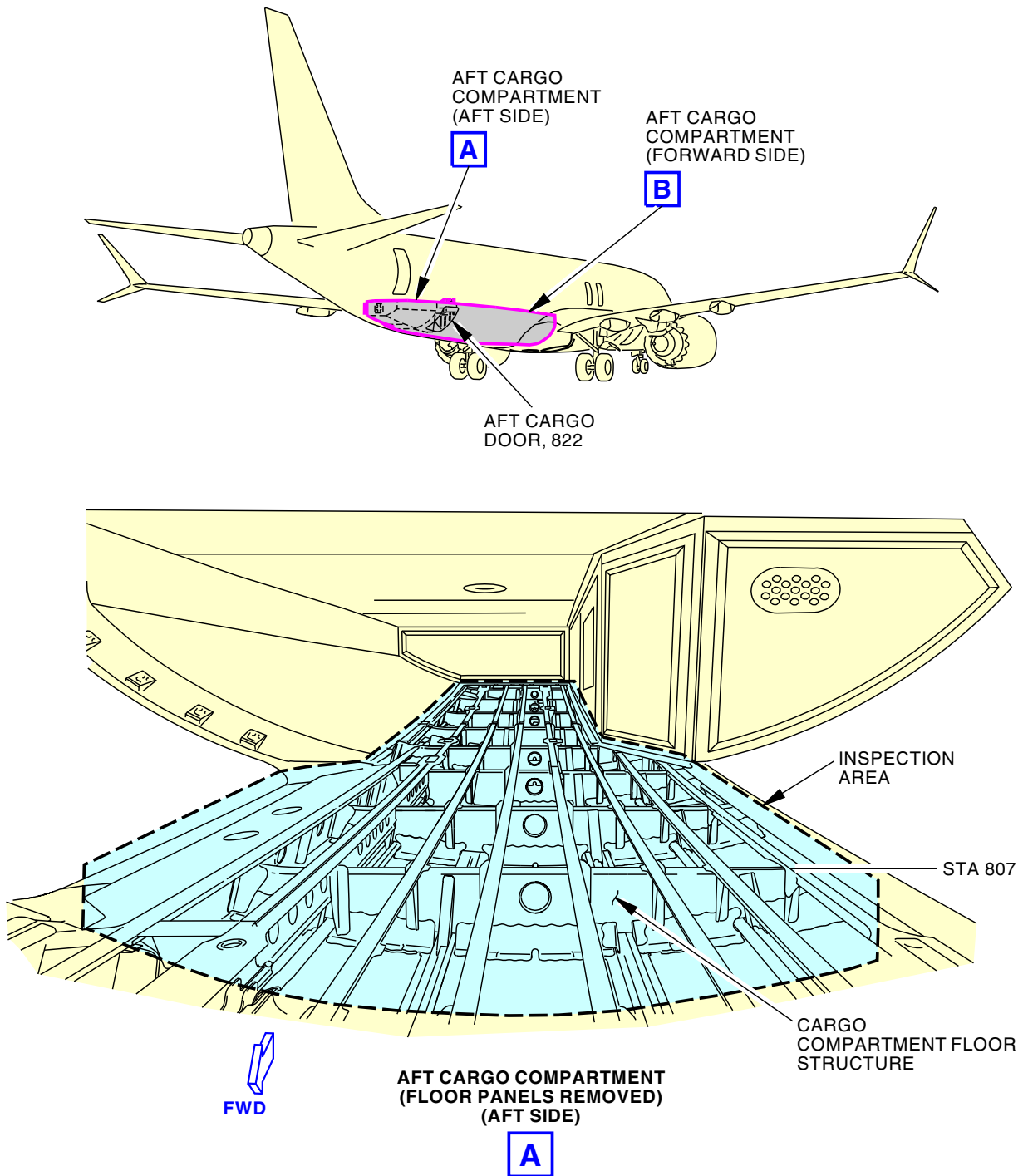
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2416041 S00061539670_V1

INTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT FLOOR STRUCTURE
Figure 218/53-05-03-990-818 (Sheet 1 of 2)

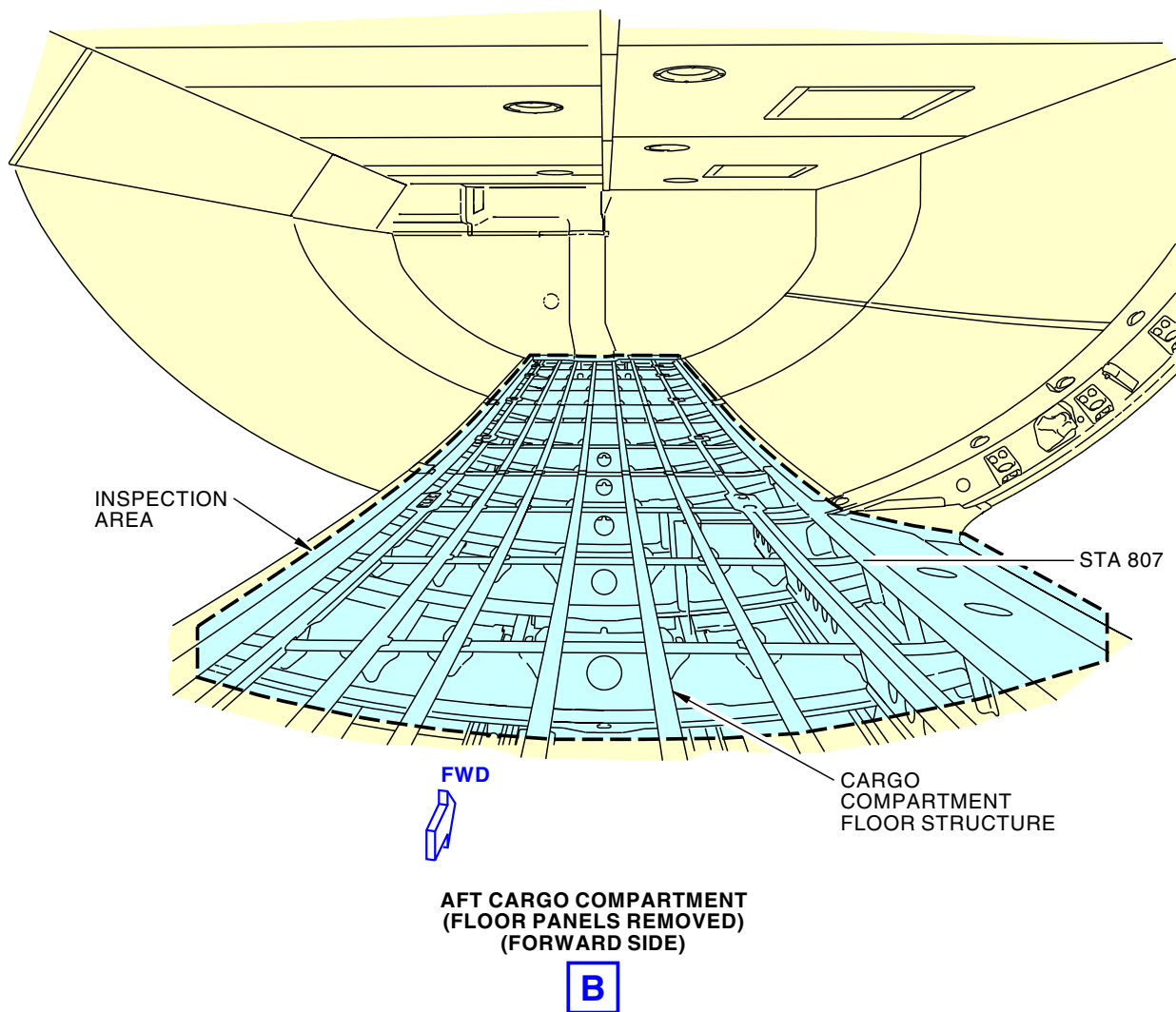
EFFECTIVITY
SIA ALL

D633AM101-SIA

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MPD ITEM
53-140-00

2416042 S00061539671_V1

INTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT FLOOR STRUCTURE
Figure 218/53-05-03-990-818 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

53-05-03

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TASK 53-05-03-211-803

17. **INTERNAL - DETAILED: FORWARD CARGO DOOR CUTOUT**

(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
122	Forward Cargo Compartment - Right

C. Access Panels

Number	Name/Location
S1221	Forward Cargo Door Cutout Inspection

D. Inspection

SUBTASK 53-05-03-010-015

- (1) Open this access panel:

Number	Name/Location
S1221	Forward Cargo Door Cutout Inspection

NOTE: Remove door reveals. Remove sidewalls as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-003

- (2) Do a Detailed inspection of the forward cargo door cutout surround structure.

SUBTASK 53-05-03-910-017

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

SUBTASK 53-05-03-410-015

- (4) Close this access panel:

Number	Name/Location
S1221	Forward Cargo Door Cutout Inspection

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

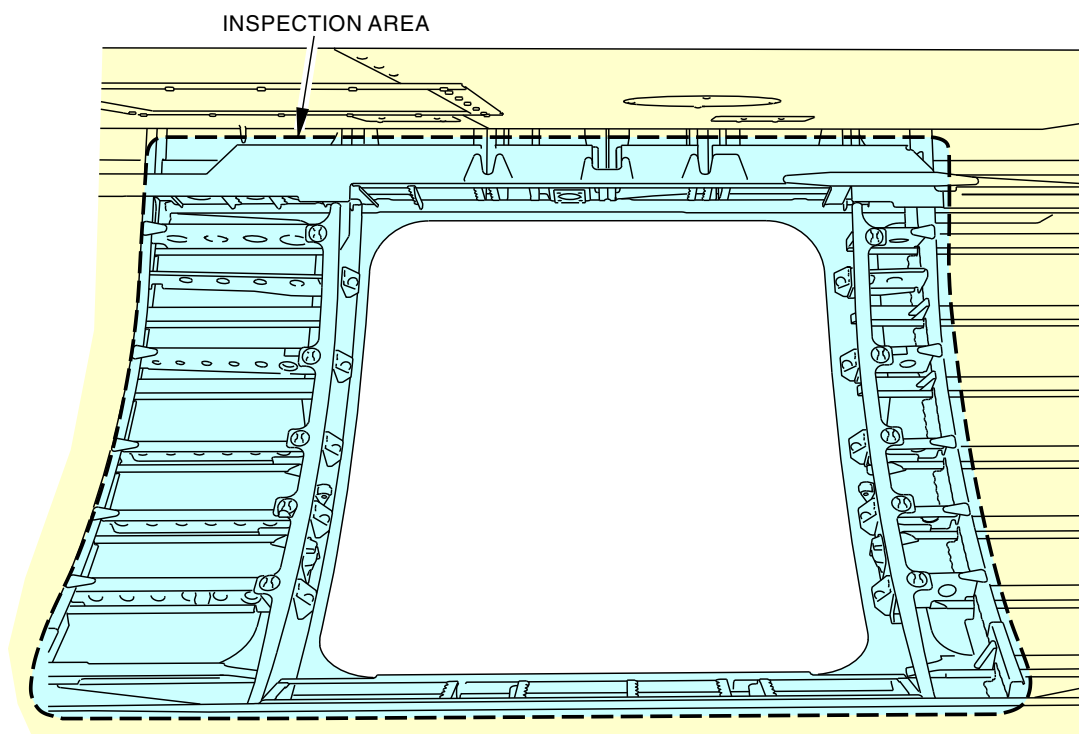
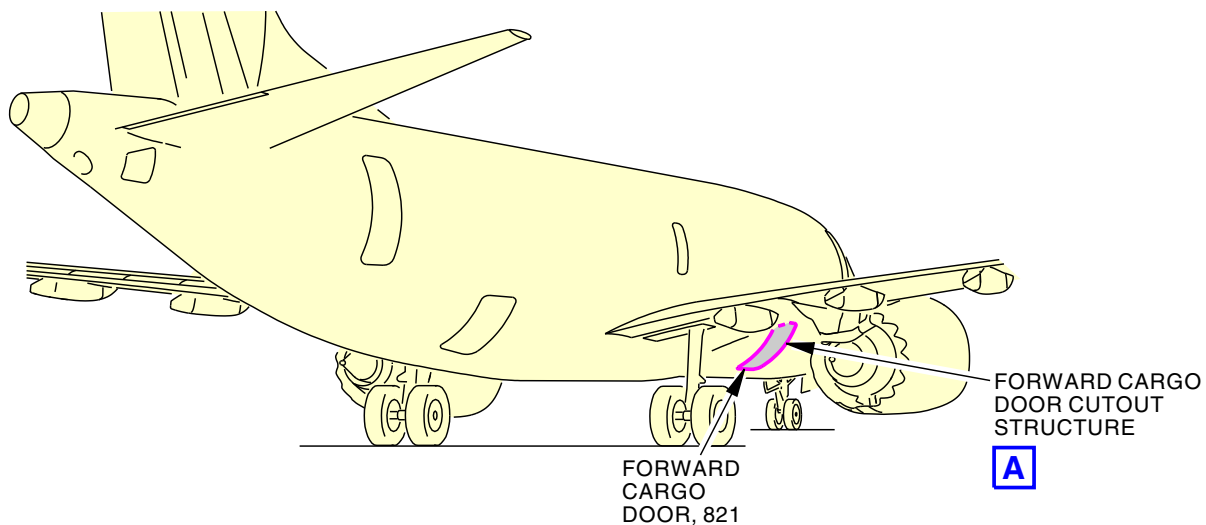
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**FORWARD CARGO DOOR CUTOUT STRUCTURE
(DOOR REVEALS AND SIDEWALL PANELS REMOVED)**



MPD ITEM
53-150-00

2416043 S00061539673_V1

Forward Cargo Door Cutout Detailed (Internal)
Figure 219/53-05-03-990-819

EFFECTIVITY
SIA ALL

53-05-03

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TASK 53-05-03-210-815

18. **INTERNAL - GENERAL VISUAL: FORWARD BILGE**

(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
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right

C. Access Panels

Number	Name/Location
S1202	Forward Bilge Inspection

D. Inspection

SUBTASK 53-05-03-010-016

(1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
S1202	Forward Bilge Inspection

- (a) Remove cargo floor panels and scuff plates.
- (b) If it is necessary, remove or displace insulation blankets.

SUBTASK 53-05-03-210-015

(2) Do a General Visual inspection of the forward bilge skin panels including skins, frames, stringers, longitudinal lap splices, and cargo door cutout surround structure in bilge (inspection includes the circumferential skin and stringer splice at STA 500E for the -9 / -10 models).

SUBTASK 53-05-03-910-018

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

SUBTASK 53-05-03-410-016

(4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
S1202	Forward Bilge Inspection

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

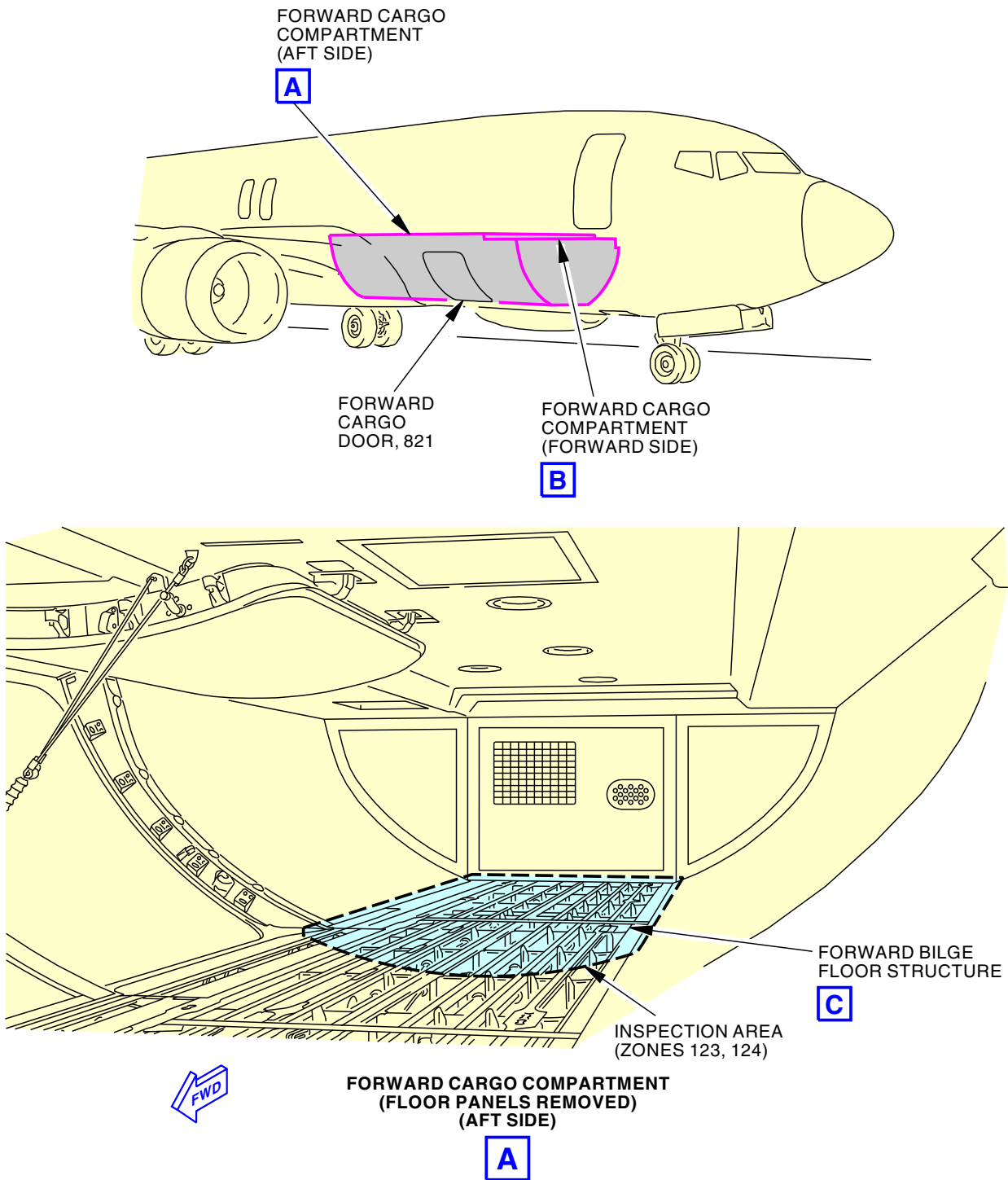
53-05-03

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2416044 S00061539675_V1

Below the Forward Cargo Comp - Forward Bilge General Visual (Int)
Figure 220/53-05-03-990-820 (Sheet 1 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

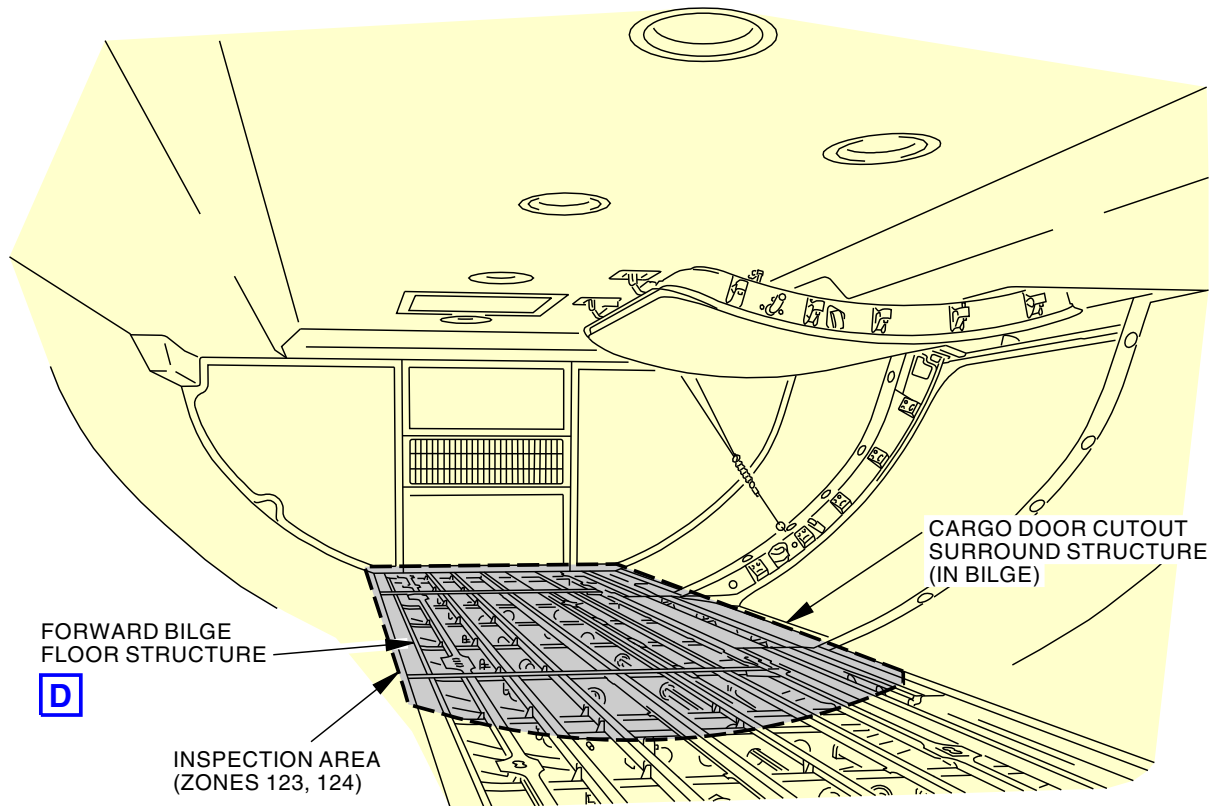
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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FORWARD CARGO COMPARTMENT
(FLOOR PANELS REMOVED)
(FORWARD SIDE)

B



2416045 S00061539676_V1

Below the Forward Cargo Comp - Forward Bilge General Visual (Int)
Figure 220/53-05-03-990-820 (Sheet 2 of 4)

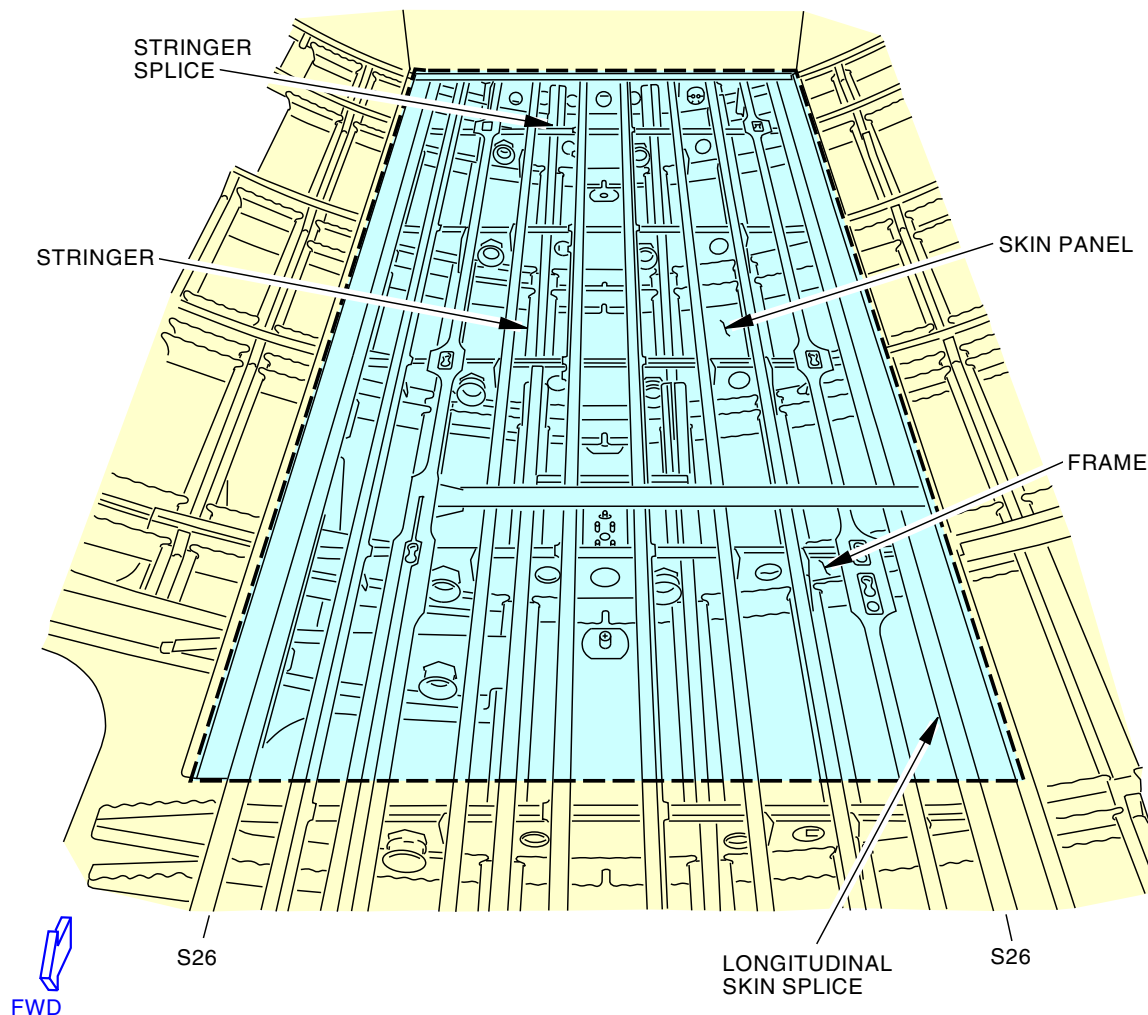
EFFECTIVITY
SIA ALL

53-05-03

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**FORWARD BILGE FLOOR STRUCTURE
(FLOOR PANELS AND INSULATION REMOVED)
(FORWARD SIDE)**

C

2416046 S00061539677_V2

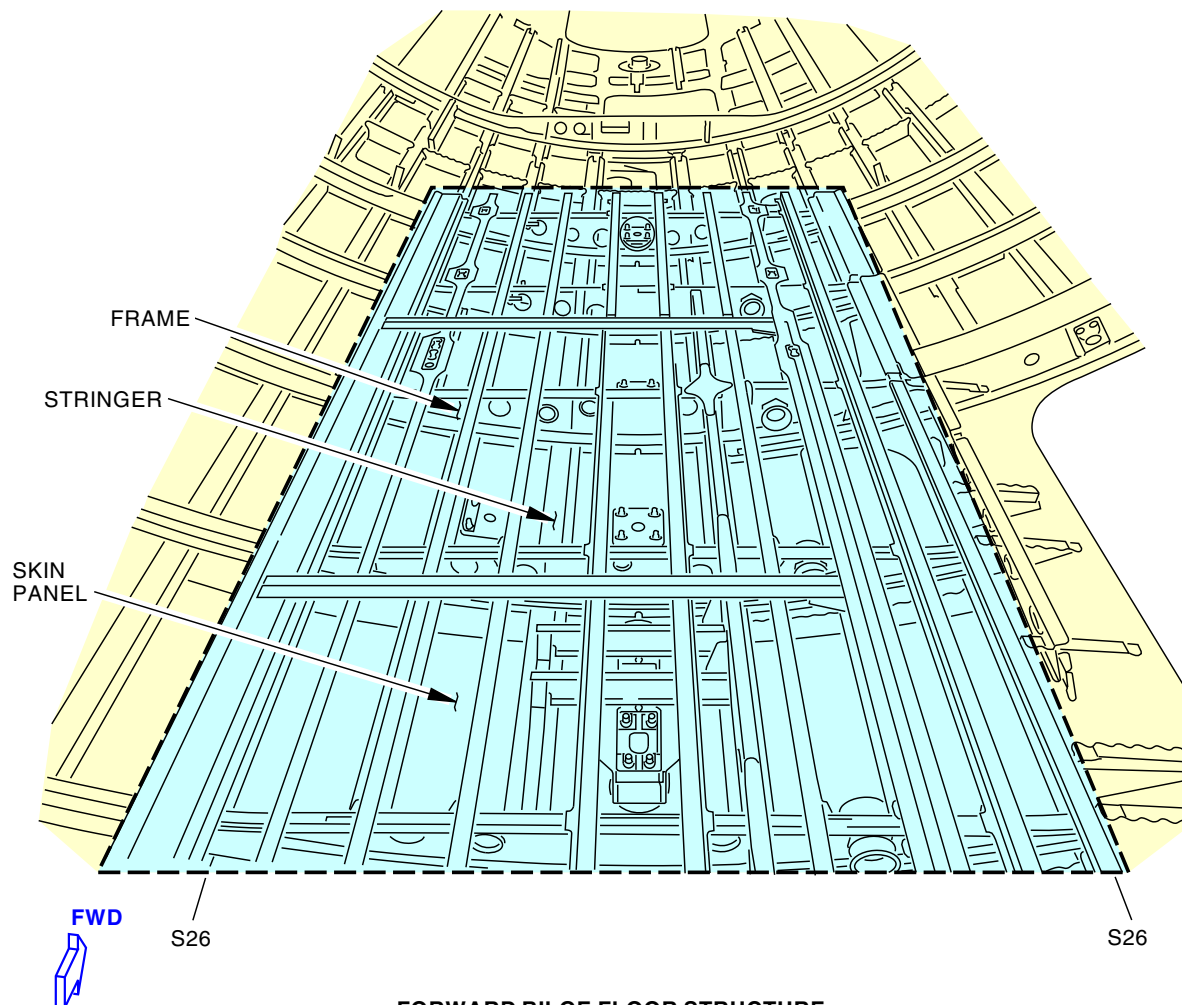
Below the Forward Cargo Comp - Forward Bilge General Visual (Int)
Figure 220/53-05-03-990-820 (Sheet 3 of 4)

EFFECTIVITY
SIA ALL

53-05-03

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**FORWARD BILGE FLOOR STRUCTURE
(FLOOR PANELS AND INSULATION REMOVED)
(FORWARD SIDE)**

D

2416047 S00061539678_V2

Below the Forward Cargo Comp - Forward Bilge General Visual (Int)
Figure 220/53-05-03-990-820 (Sheet 4 of 4)

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-816

19. INTERNAL - GENERAL VISUAL: AREA AFT OF FORWARD CARGO COMPARTMENT

(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
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right

C. Access Panels

Number	Name/Location
S1203	Area Aft Of Forward Cargo Compartment Inspection

D. Inspection

SUBTASK 53-05-03-010-017

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
S1203	Area Aft Of Forward Cargo Compartment Inspection

NOTE: Remove forward cargo compartment aft bulkhead panels. Remove/displace insulation blankets as required. Remove ducting as required.

SUBTASK 53-05-03-210-016

- (2) Do a General Visual inspection of the area aft of forward cargo compartment, including skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices, and forward side of Sta 540 bulkhead and bulkhead splices.

SUBTASK 53-05-03-910-019

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

SUBTASK 53-05-03-410-017

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
S1203	Area Aft Of Forward Cargo Compartment Inspection

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

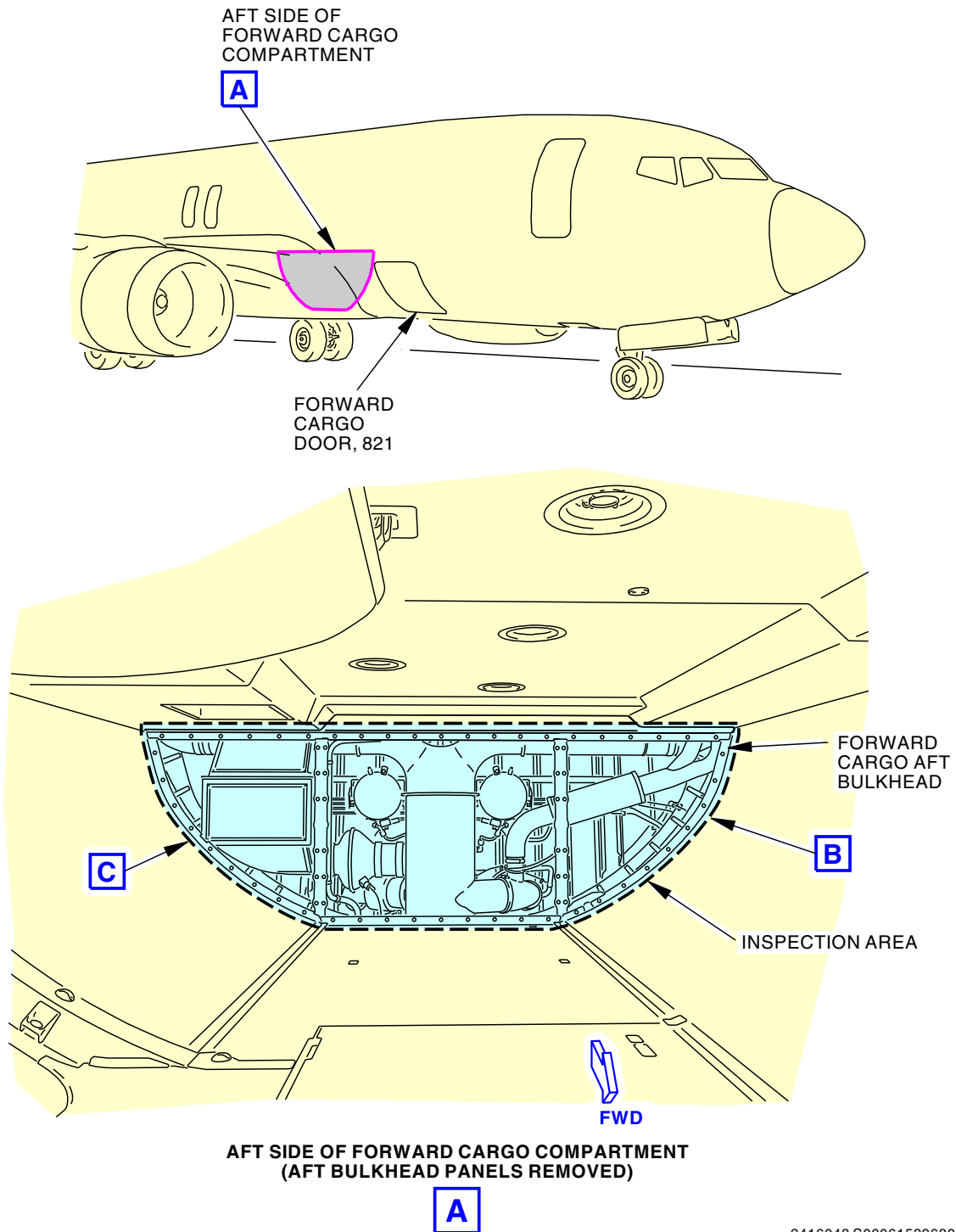
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**737-7/8/8200/9/10
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2416048 S00061539680_V1

INTERNAL-GENERAL VISUAL: AREA AFT OF FORWARD CARGO COMPARTMENT
Figure 221/53-05-03-990-821 (Sheet 1 of 3)

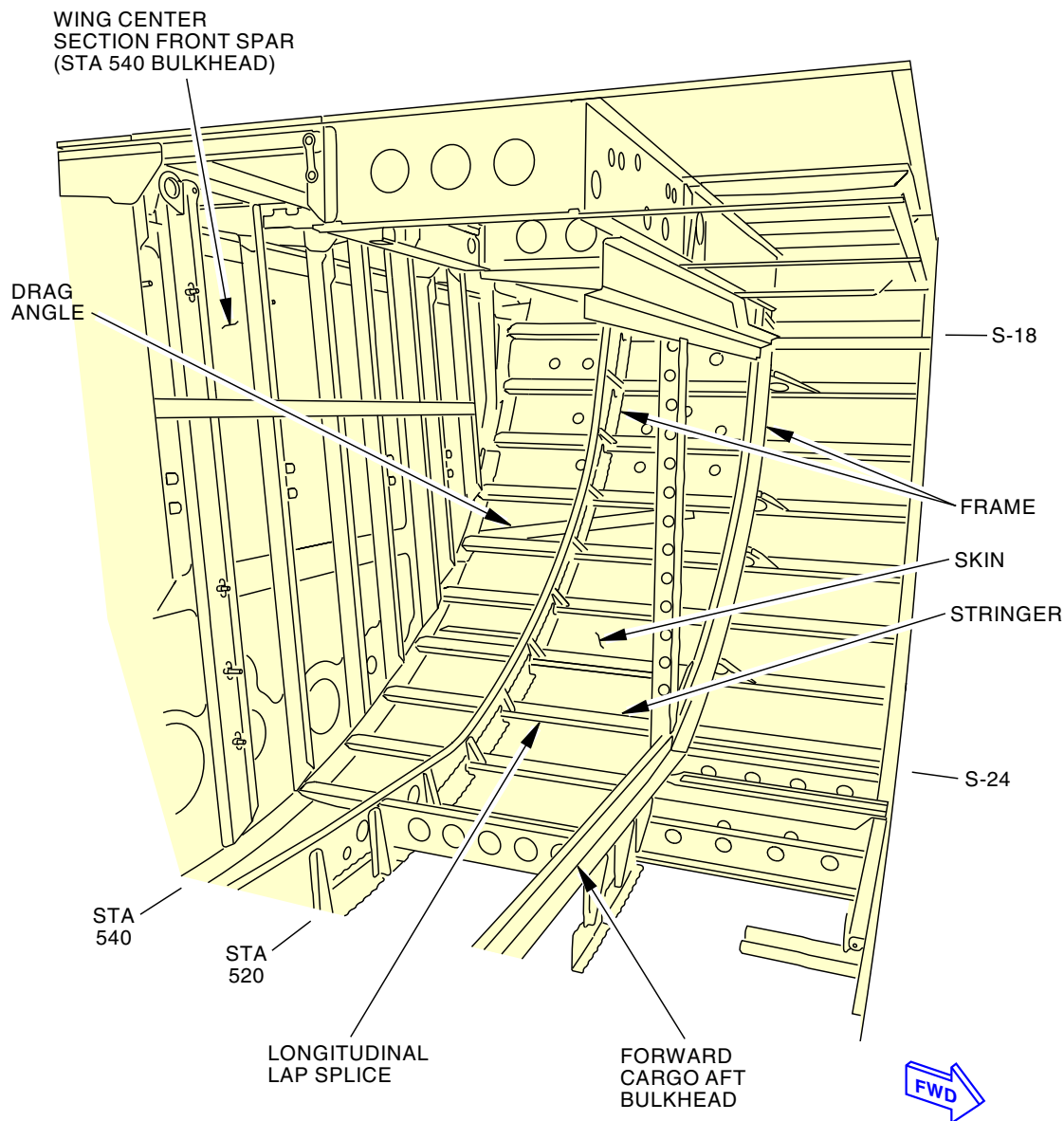
EFFECTIVITY
SIA ALL

53-05-03

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AREA AFT OF FORWARD CARGO
(LEFT SIDE VIEW)

B

2416049 S00061539681_V1

INTERNAL-GENERAL VISUAL: AREA AFT OF FORWARD CARGO COMPARTMENT
Figure 221/53-05-03-990-821 (Sheet 2 of 3)

EFFECTIVITY
SIA ALL

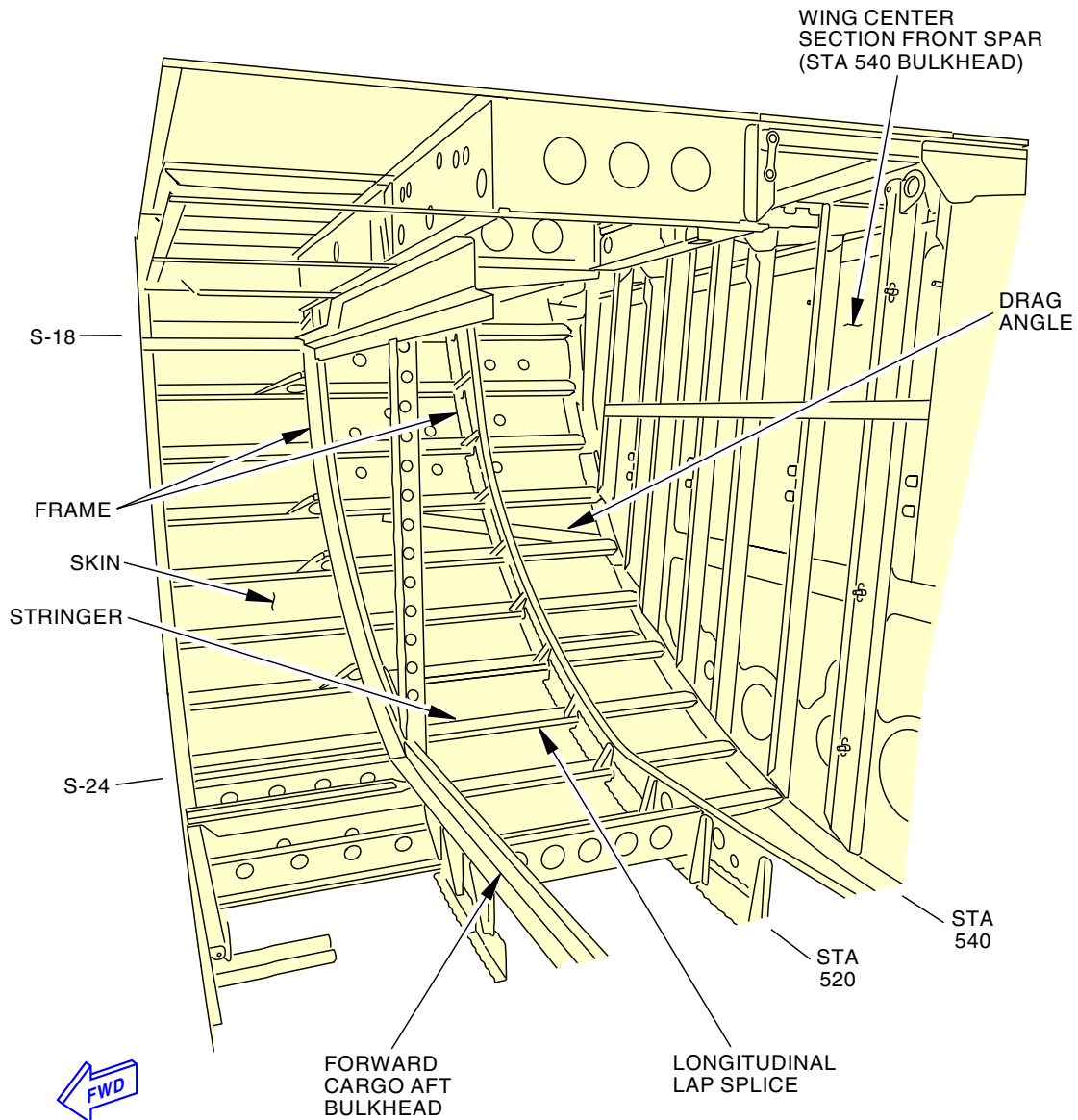
53-05-03

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AREA AFT OF FORWARD CARGO
(RIGHT SIDE VIEW)

C

2416050 S00061539682_V1

INTERNAL-GENERAL VISUAL: AREA AFT OF FORWARD CARGO COMPARTMENT
Figure 221/53-05-03-990-821 (Sheet 3 of 3)

EFFECTIVITY
SIA ALL

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TASK 53-05-03-210-817

20. **INTERNAL - GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (forward of wing box)**

(Figure 222)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
129	Keel Beam (Part) - Section 43
191	Lower Wing-To-Body Fairing - Forward of Wing Box

C. Access Panels

Number	Name/Location
191AL	Forward Wing-To-Body Fairing Panel - Upper
191AR	Forward Wing-To-Body Fairing Panel - Upper
191BL	Forward Wing-To-Body Fairing Panel, Ram Air Inlet
191BR	Forward Wing-To-Body Fairing Panel, Ram Air Inlet
191CL	Forward Wing-To-Body Fairing Panel - Middle
191CR	Forward Wing-To-Body Fairing Panel - Middle
191D	Forward Wing-To-Body Fairing Panel - Lower
191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191GL	Ram Air Actuator Panel - Forward
191GR	Ram Air Actuator Panel - Forward
191HL	Ram Air Inlet Lip Panel - Forward
191HR	Ram Air Inlet Lip Panel - Forward

D. Inspection

SUBTASK 53-05-03-010-018

(1) Open these access panels:

Number	Name/Location
191AL	Forward Wing-To-Body Fairing Panel - Upper
191AR	Forward Wing-To-Body Fairing Panel - Upper
191BL	Forward Wing-To-Body Fairing Panel, Ram Air Inlet
191BR	Forward Wing-To-Body Fairing Panel, Ram Air Inlet
191CL	Forward Wing-To-Body Fairing Panel - Middle
191CR	Forward Wing-To-Body Fairing Panel - Middle
191D	Forward Wing-To-Body Fairing Panel - Lower
191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191GL	Ram Air Actuator Panel - Forward
191GR	Ram Air Actuator Panel - Forward

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
191HL	Ram Air Inlet Lip Panel - Forward
191HR	Ram Air Inlet Lip Panel - Forward

SUBTASK 53-05-03-210-017

- (2) Do a General Visual inspection of the area under lower wing-to-body fairing (forward of wing box), including skin panels, longitudinal lap splices, keel beam extension, wing-to-body drag angles, and Sta 540 bulkhead.

SUBTASK 53-05-03-910-020

- (3) Basic Task Description, 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 53-05-03-410-018

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
191AL	Forward Wing-To-Body Fairing Panel - Upper
191AR	Forward Wing-To-Body Fairing Panel - Upper
191BL	Forward Wing-To-Body Fairing Panel, Ram Air Inlet
191BR	Forward Wing-To-Body Fairing Panel, Ram Air Inlet
191CL	Forward Wing-To-Body Fairing Panel - Middle
191CR	Forward Wing-To-Body Fairing Panel - Middle
191D	Forward Wing-To-Body Fairing Panel - Lower
191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191GL	Ram Air Actuator Panel - Forward
191GR	Ram Air Actuator Panel - Forward
191HL	Ram Air Inlet Lip Panel - Forward
191HR	Ram Air Inlet Lip Panel - Forward

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

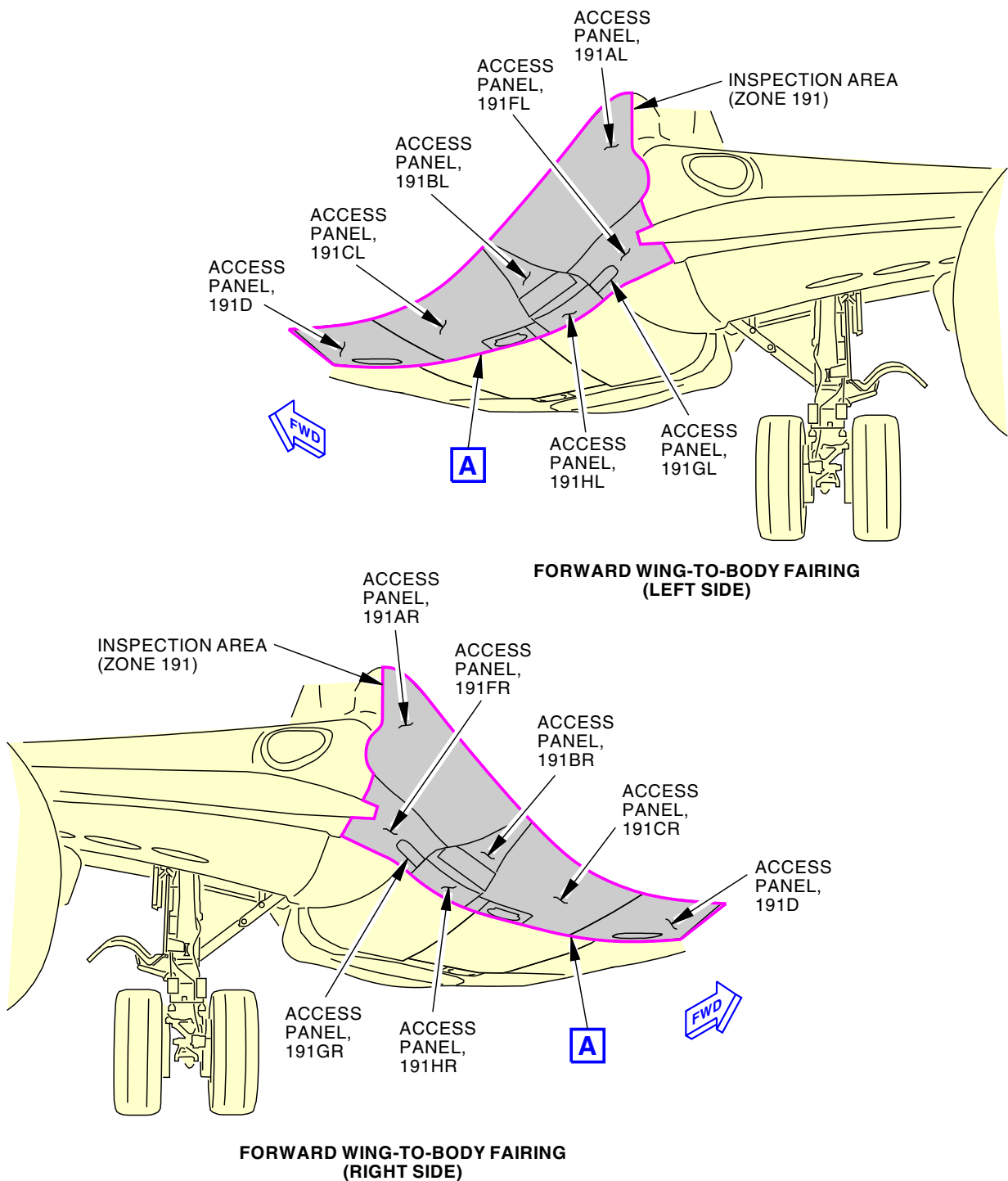
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AIRCRAFT MAINTENANCE MANUAL



2416051 S00061539684_V1

INTERNAL-GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (Forward Of Wing Box)
Figure 222/53-05-03-990-822 (Sheet 1 of 2)

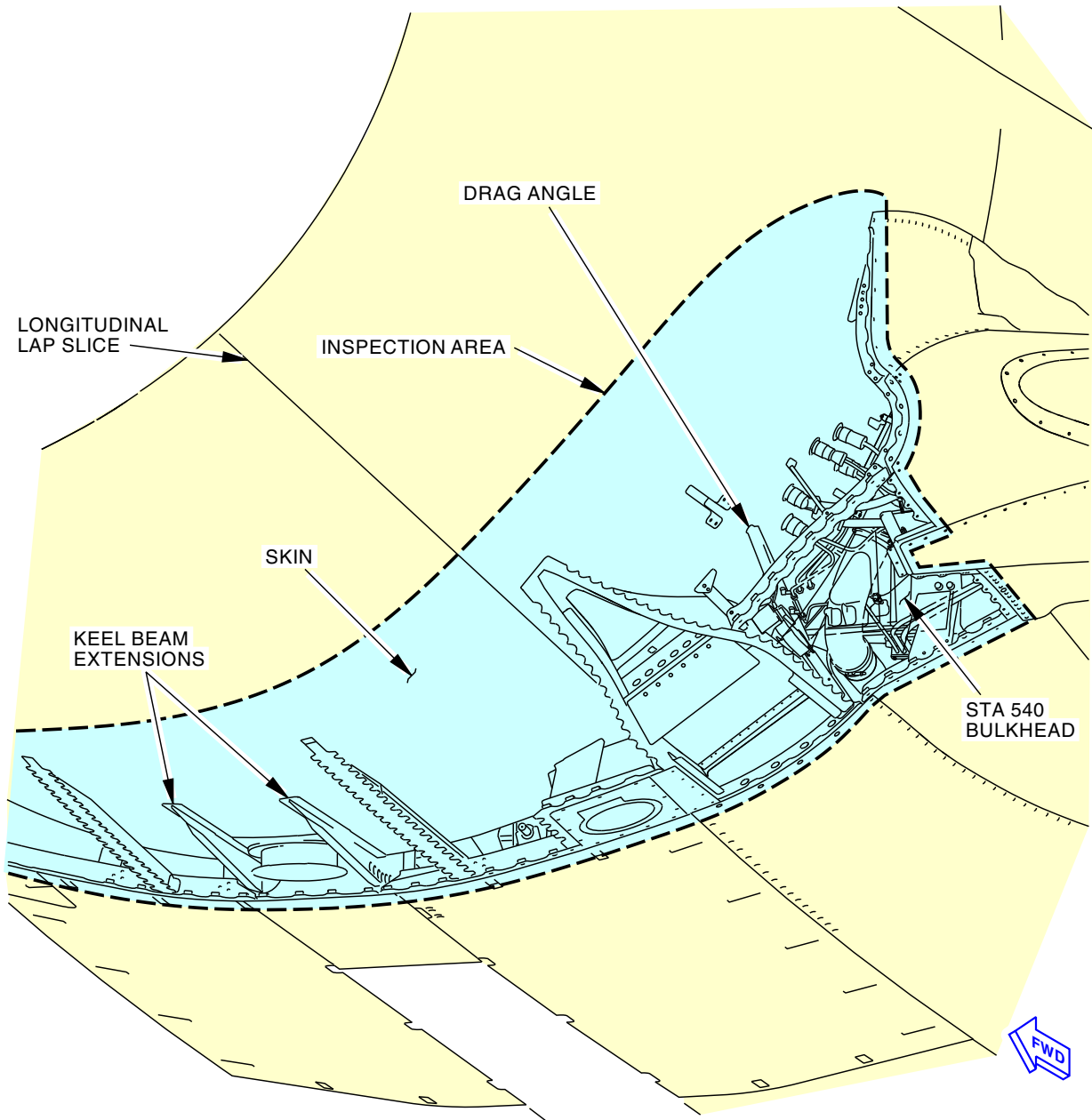
EFFECTIVITY SIA ALL

D633AM101-SIA

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(LEFT SIDE OF FUSELAGE SHOWN, RIGHT SIDE OF FUSELAGE IS EQUIVALENT)

A

2416052 S00061539685_V1

INTERNAL-GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (Forward Of Wing Box)
Figure 222/53-05-03-990-822 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

53-05-03

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-818

21. **INTERNAL - GENERAL VISUAL: AREA ABOVE WING BOX CENTER SECTION**

(Figure 223)

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
135	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Left
136	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Right

C. Access Panels

Number	Name/Location
S1301	Area Above Wing Box Center Section Inspection

D. Inspection

SUBTASK 53-05-03-010-019

(1) Special Access:

<u>Number</u>	<u>Name/Location</u>
S1301	Area Above Wing Box Center Section Inspection

NOTE: Remove floor panels. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-018

(2) Do a General Visual inspection of the fuselage lower lobe above wing box center section upper panel, including side skin panels (skins, frames and stringers), Sta 540 bulkhead, and overwing frames and stub beams.

SUBTASK 53-05-03-910-021

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

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

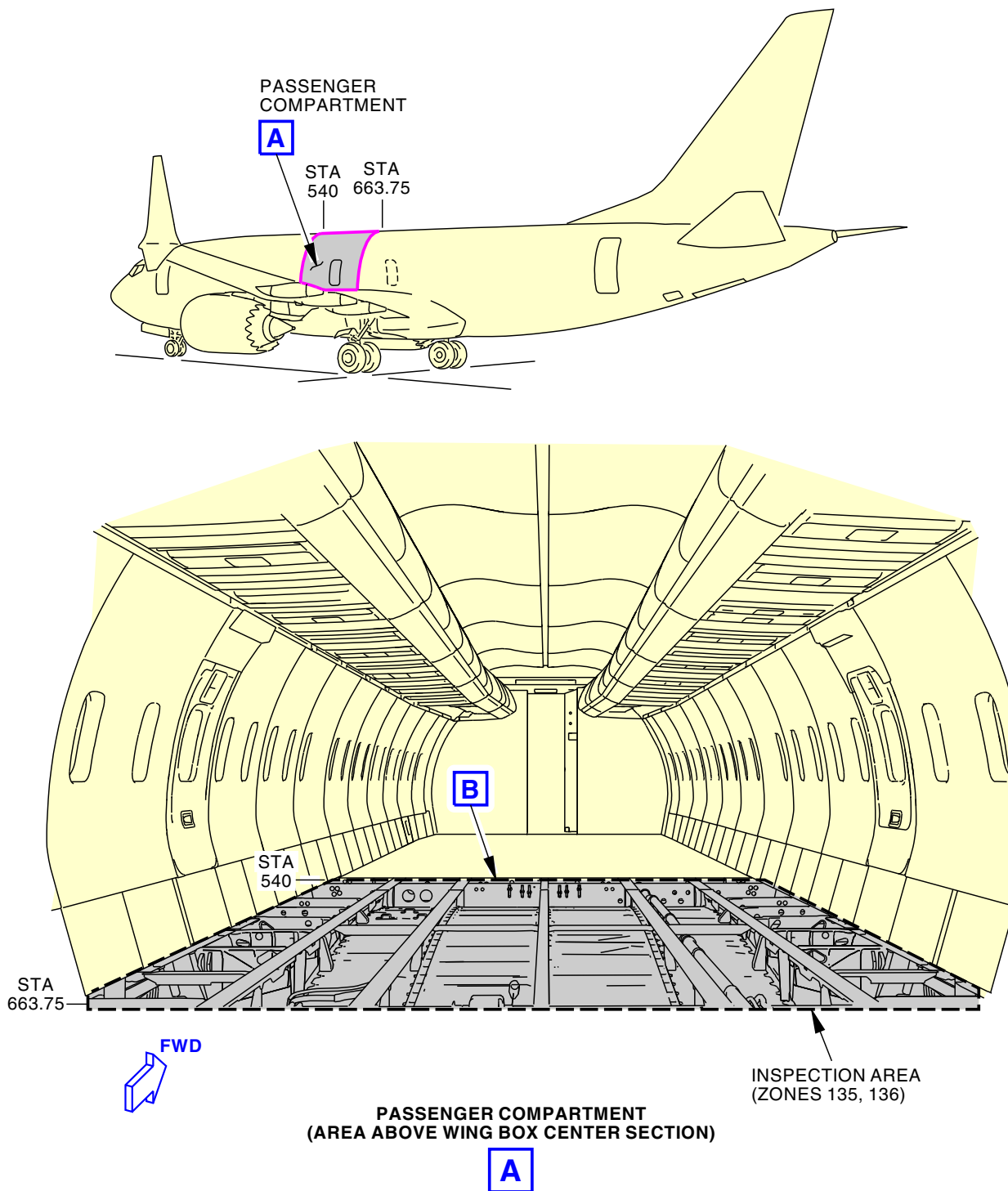
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AIRCRAFT MAINTENANCE MANUAL



2416053 S00061539687_V1

INTERNAL-GENERAL VISUAL: AREA ABOVE WING BOX CENTER SECTION
Figure 223/53-05-03-990-823 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

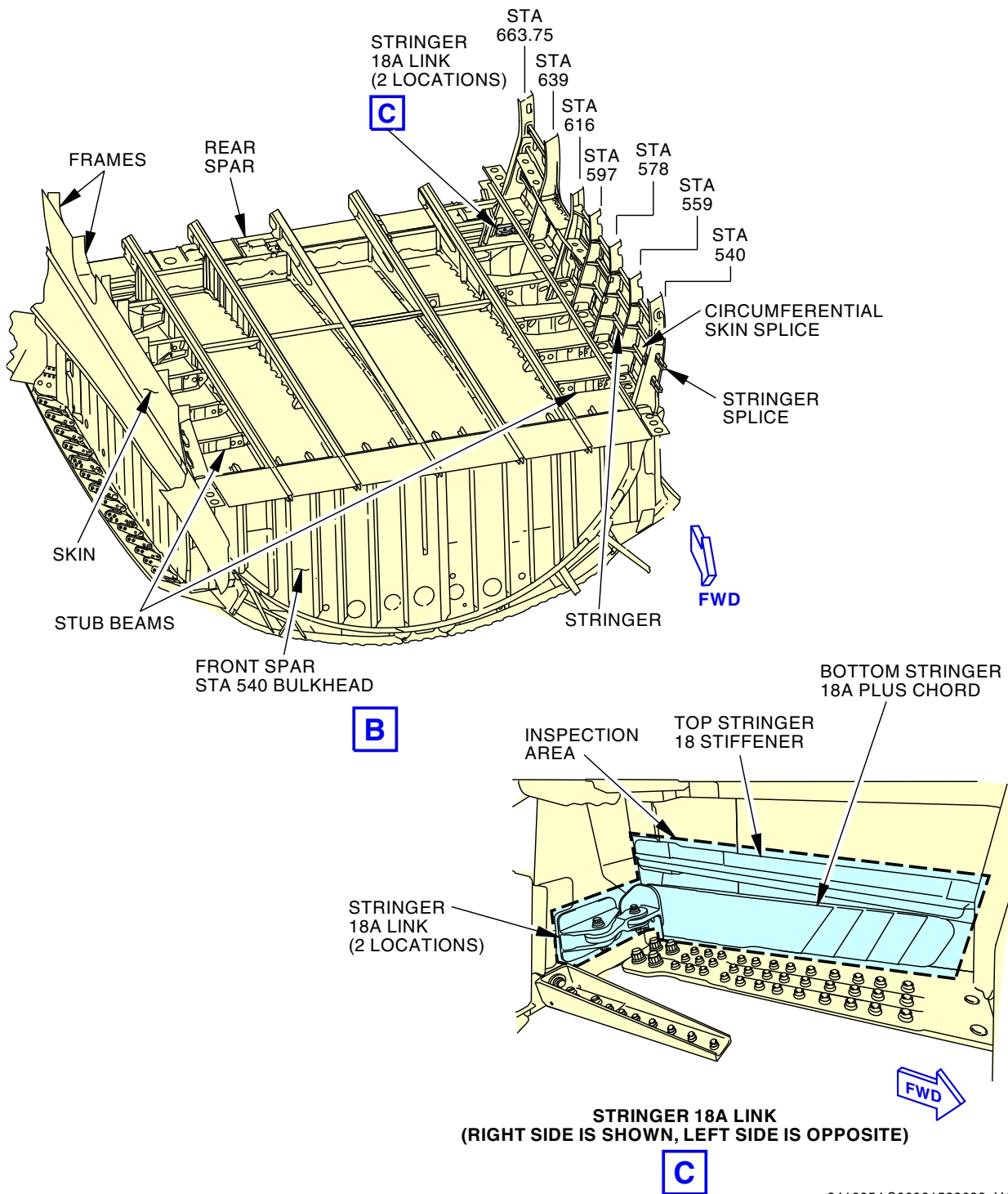
53-05-03

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**737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL**



2416054 S00061539688_V1

INTERNAL-GENERAL VISUAL: AREA ABOVE WING BOX CENTER SECTION
Figure 223/53-05-03-990-823 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-819

22. **INTERNAL - GENERAL VISUAL: AREA ABOVE MAIN LANDING GEAR WHEEL WELL**

(Figure 224)

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
137	Area Above M.L.G. Wheel Well, Body Station 663.75 to Body Station 727 - Left
138	Area Above M.L.G. Wheel Well, Body Station 663.75 Body Station 727 - Right

C. Access Panels

Number	Name/Location
S1302	Area Above Main Landing Gear Wheel Well Inspection

D. Inspection

SUBTASK 53-05-03-010-020

- (1) Open this access panel:

Number	Name/Location
S1302	Area Above Main Landing Gear Wheel Well Inspection

NOTE: Remove floor panels. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-019

- (2) Do a General Visual inspection of the fuselage lower lobe above main landing gear wheel well, including:
1. Pressure deck web to stiffeners, stiffener attachment to floor beam at STA 727.
 2. Side skin panels, circumferential skin and stringer splice.
 3. Bulkheads at STA 663 and 727.
 4. Side strut support frame at STA 706.
 5. Main landing gear support frame at STA 695 and 716.
 6. Wheel well frame at STA 685.

SUBTASK 53-05-03-910-022

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

SUBTASK 53-05-03-410-019

- (4) Close this access panel:

Number	Name/Location
S1302	Area Above Main Landing Gear Wheel Well Inspection

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

53-05-03

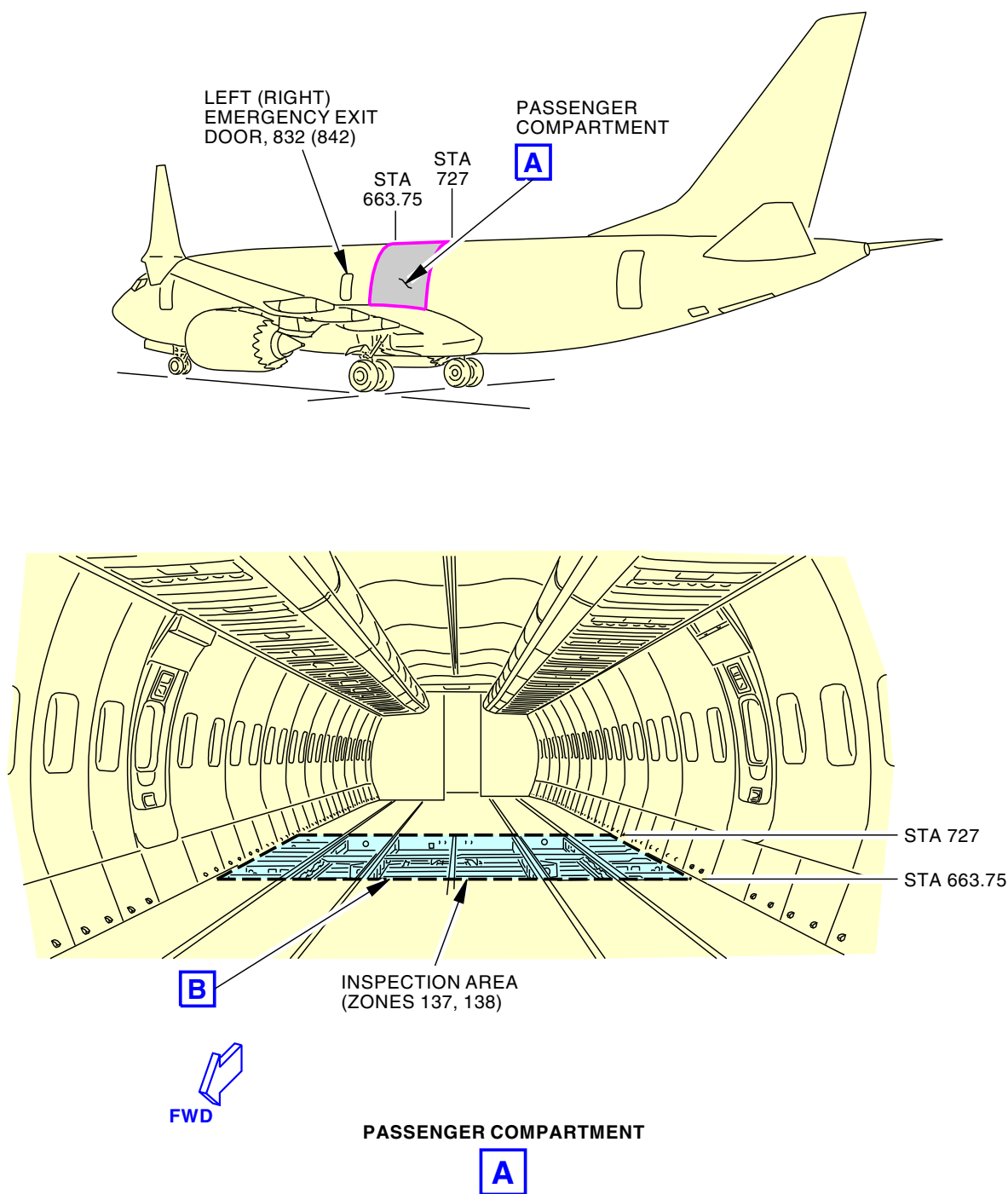
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AIRCRAFT MAINTENANCE MANUAL



2416055 S00061539690_V1

Above and Outboard of the Main Landing Gear Wheel Well General Visual (Internal)
Figure 224/53-05-03-990-824 (Sheet 1 of 2)

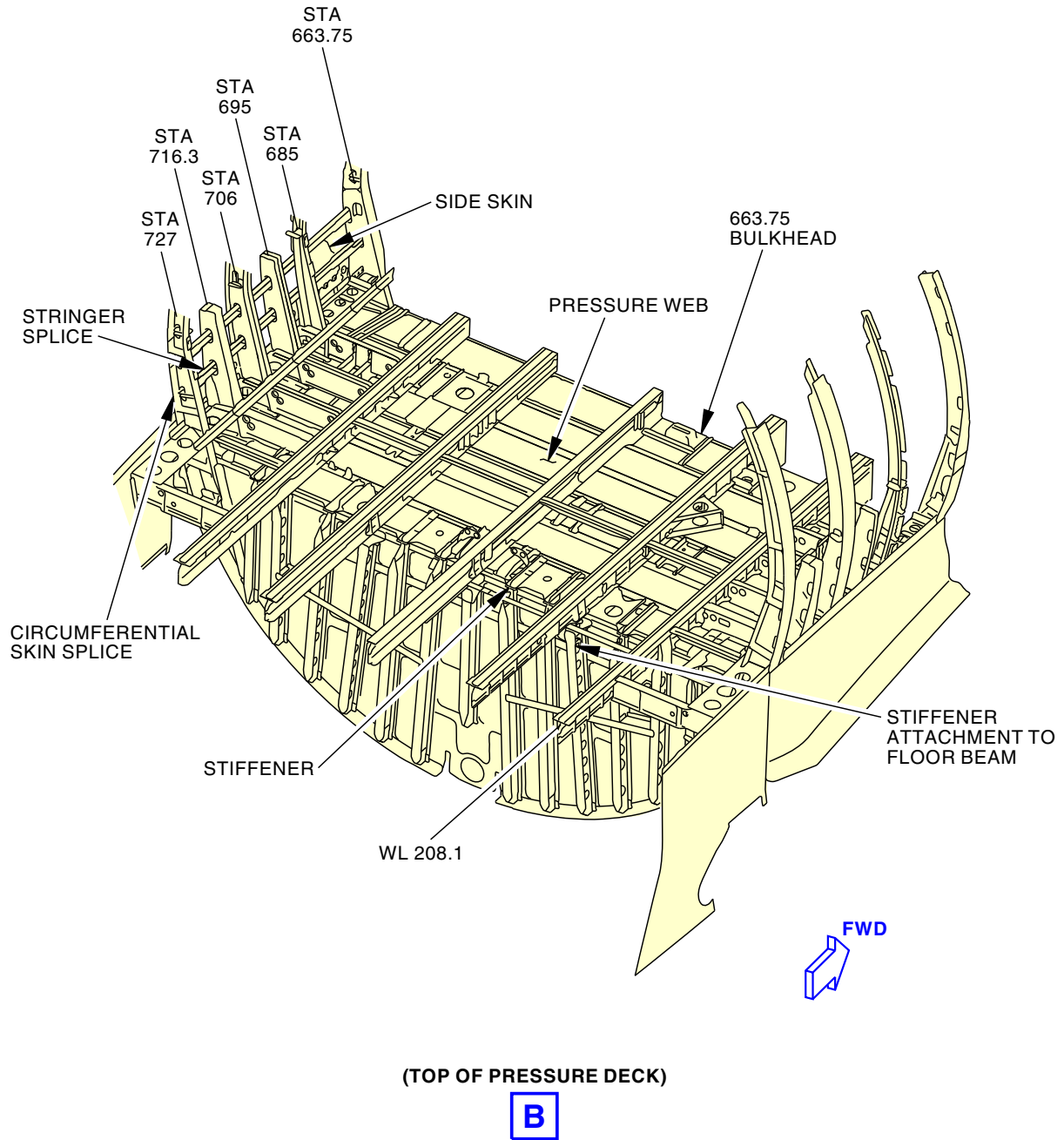
EFFECTIVITY
SIA ALL

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2416056 S00061539691_V1

Above and Outboard of the Main Landing Gear Wheel Well General Visual (Internal)
Figure 224/53-05-03-990-824 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

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TASK 53-05-03-210-820

23. **INTERNAL - GENERAL VISUAL: KEEL BEAM UNDER WING-TO-BODY FAIRING (under wing box)**
(Figure 225)

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
139	Keel Beam, (Part) Body Station 540.00 to Body Station 727.00
192	Lower Wing-To-Body Fairing - Under Wing Box

C. Access Panels

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
S1004	Keel Beam Under Wing-to-Body Fairing (Under Wing Box) Inspection

D. Inspection

SUBTASK 53-05-03-010-021

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
S1004	Keel Beam Under Wing-to-Body Fairing (Under Wing Box) Inspection

NOTE: Option 1: Remove center wing-to-body fairing (192CL, 192CR, 192E, 192F) and open AC bay access door.

Option 2: Open AC bay door and remove AC pack to gain access to access holes.

SUBTASK 53-05-03-210-020

- (2) Do a General Visual inspection of the keel beam under wing-to-body fairing (under wing box, Sta 540 to 663.75), including keel beam chords, webs, stiffeners, splice, keel beam/rear spar attachment angles.

SUBTASK 53-05-03-910-023

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

SUBTASK 53-05-03-410-020

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
192F	ECS Under Keel Panel - Middle
S1004	Keel Beam Under Wing-to-Body Fairing (Under Wing Box) Inspection

———— **END OF TASK** ————

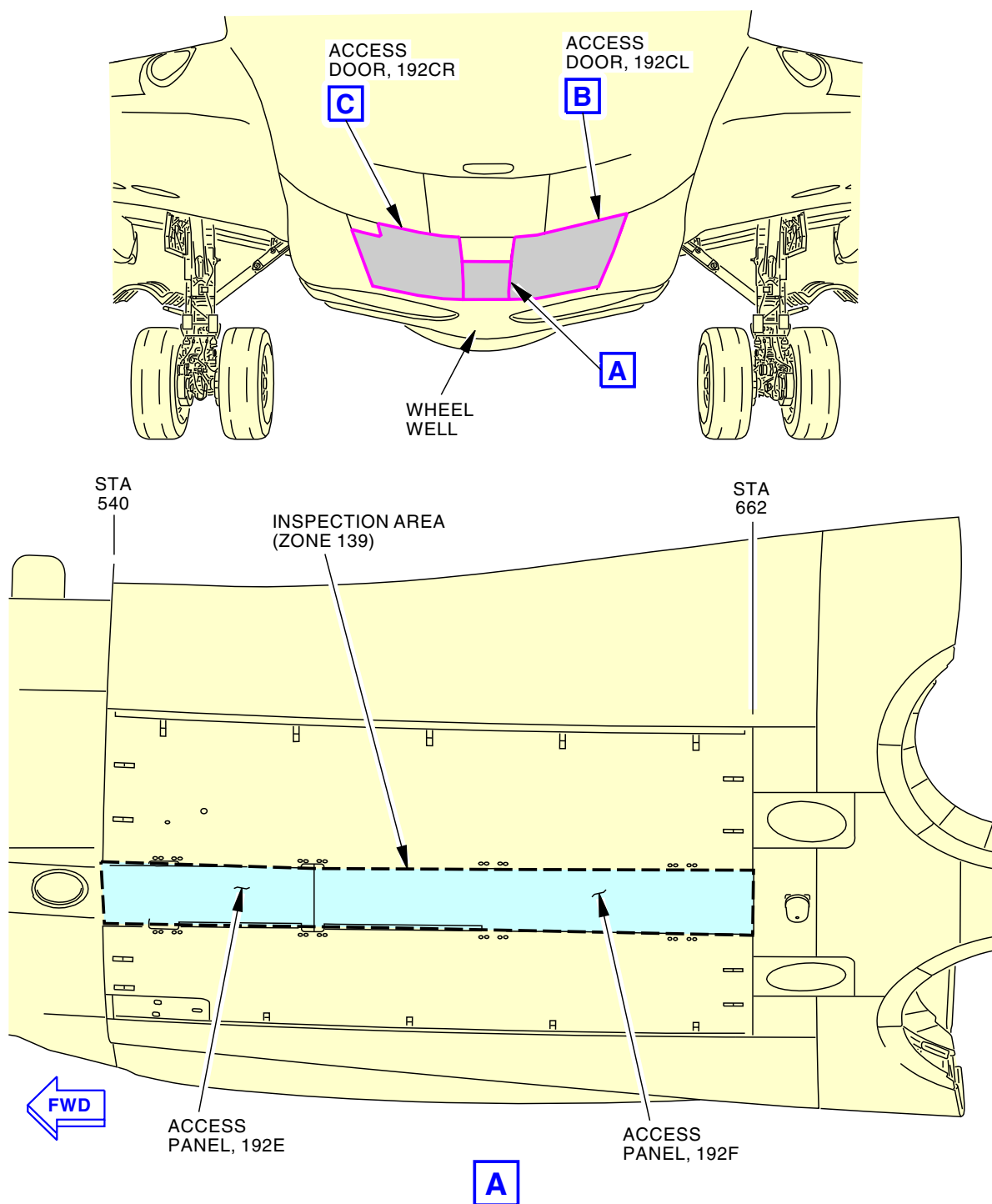
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SIA ALL

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2416057 S00061539693_V1

Keel Beam
Figure 225/53-05-03-990-825 (Sheet 1 of 3)

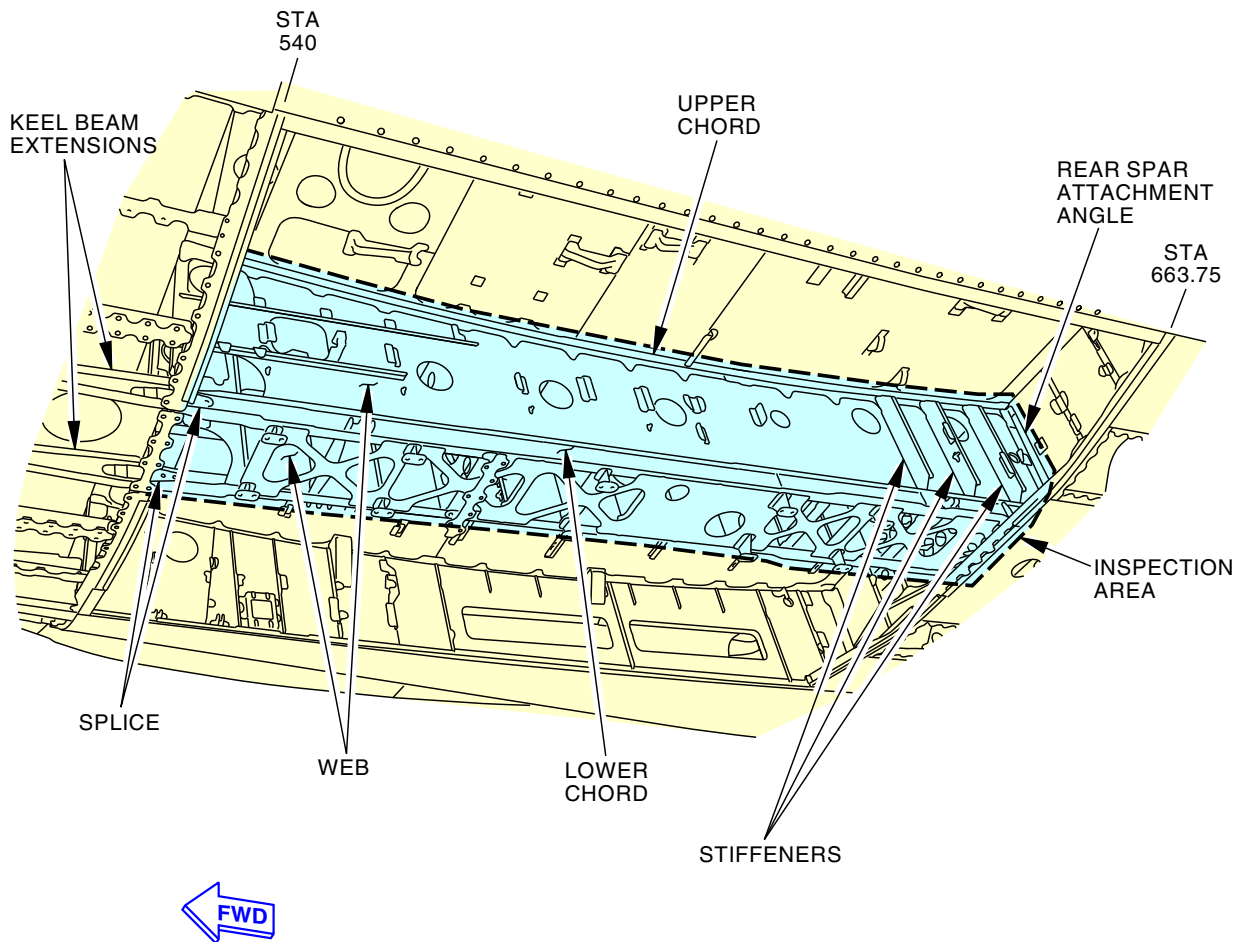
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**KEEL BEAM
(STA 540 TO STA 663.75)
(ECS DOORS REMOVED)**

B

2416058 S00061539694_V1

Keel Beam
Figure 225/53-05-03-990-825 (Sheet 2 of 3)

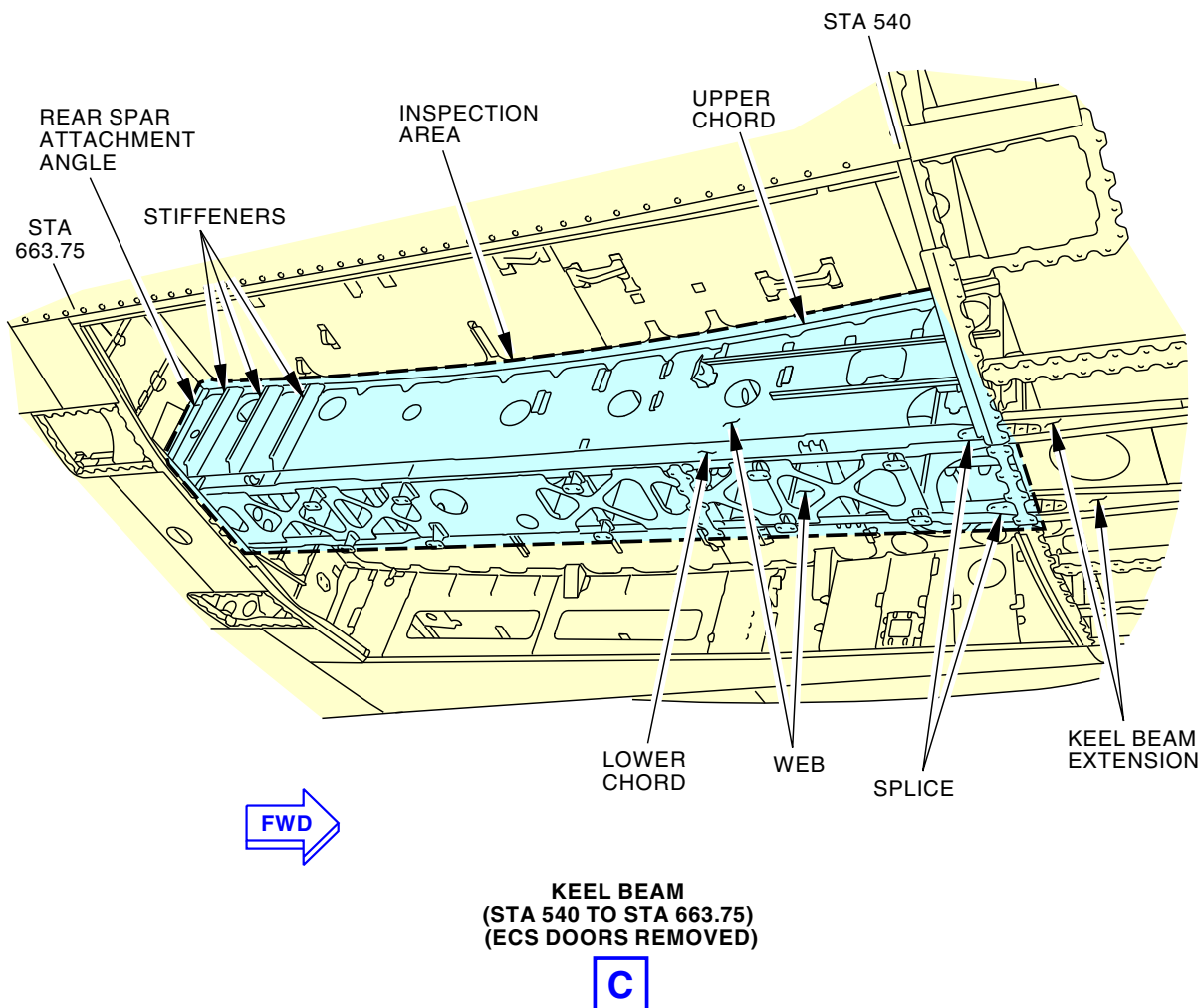
EFFECTIVITY
SIA ALL

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2416059 S00061539695_V1

Keel Beam
Figure 225/53-05-03-990-825 (Sheet 3 of 3)

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SIA ALL

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TASK 53-05-03-210-821

24. INTERNAL - GENERAL VISUAL: KEEL BEAM IN WHEEL WELL

(Figure 226)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
33-44-02-960-802	Lower Anti-Collision Light - Light Assembly Replacement (P/B 201)
33-44-02-960-807	Lower Anti-Collision Light - LED Light Assembly Replacement (P/B 201)
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)
53-51-21-000-802	Center Wing-To-Body Fairing Panel (Except 192AL, 192AR, 192HL, 192HR, 195BL, 195BR) Removal (P/B 401)
53-51-21-400-802	Center Wing-To-Body Fairing Panel (Except 192AL, 192AR, 192HL, 192HR, 195BL, 195BR) - Installation (P/B 401)

B. Location Zones

Zone	Area
139	Keel Beam, (Part) Body Station 540.00 to Body Station 727.00
193	Lower Wing-To-Body Fairing - Wheel Well

C. Access Panels

Number	Name/Location
193B	Wheel Well Panel - Forward Inboard
193D	Wheel Well Panel - Aft Inboard

D. Inspection

SIA 001-014

SUBTASK 53-05-03-020-005

- (1) For a removal of the access panel, 193B, remove the lower anti-collision light assembly (TASK 33-44-02-960-802).

SIA 015-999

SUBTASK 53-05-03-020-006

- (2) For a removal of the access panel, 193B, remove the LED lower anti-collision light assembly (TASK 33-44-02-960-807).

SIA ALL

SUBTASK 53-05-03-010-022

- (3) Open these access panels:
(TASK 53-51-21-000-802)

Number	Name/Location
193B	Wheel Well Panel - Forward Inboard
193D	Wheel Well Panel - Aft Inboard

SUBTASK 53-05-03-210-021

- (4) Do a General Visual inspection of the keel beam in wheel well (Sta 663.75 to 727), including keel beam chords, webs, stiffeners, splice, keel beam/rear spar attachment angles.

EFFECTIVITY
SIA ALL

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SUBTASK 53-05-03-910-024

(5) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 53-05-03-410-021

(6) Close these access panels:

(TASK 53-51-21-400-802)

<u>Number</u>	<u>Name/Location</u>
193B	Wheel Well Panel - Forward Inboard
193D	Wheel Well Panel - Aft Inboard

SIA 001-014

SUBTASK 53-05-03-420-005

(7) For an installation of the access panel, 193B, install the lower anti-collision light assembly (TASK 33-44-02-960-802).

SIA 015-999

SUBTASK 53-05-03-420-006

(8) For an installation of the access panel, 193B, install the LED lower anti-collision light assembly (TASK 33-44-02-960-807).

SIA ALL

————— END OF TASK —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

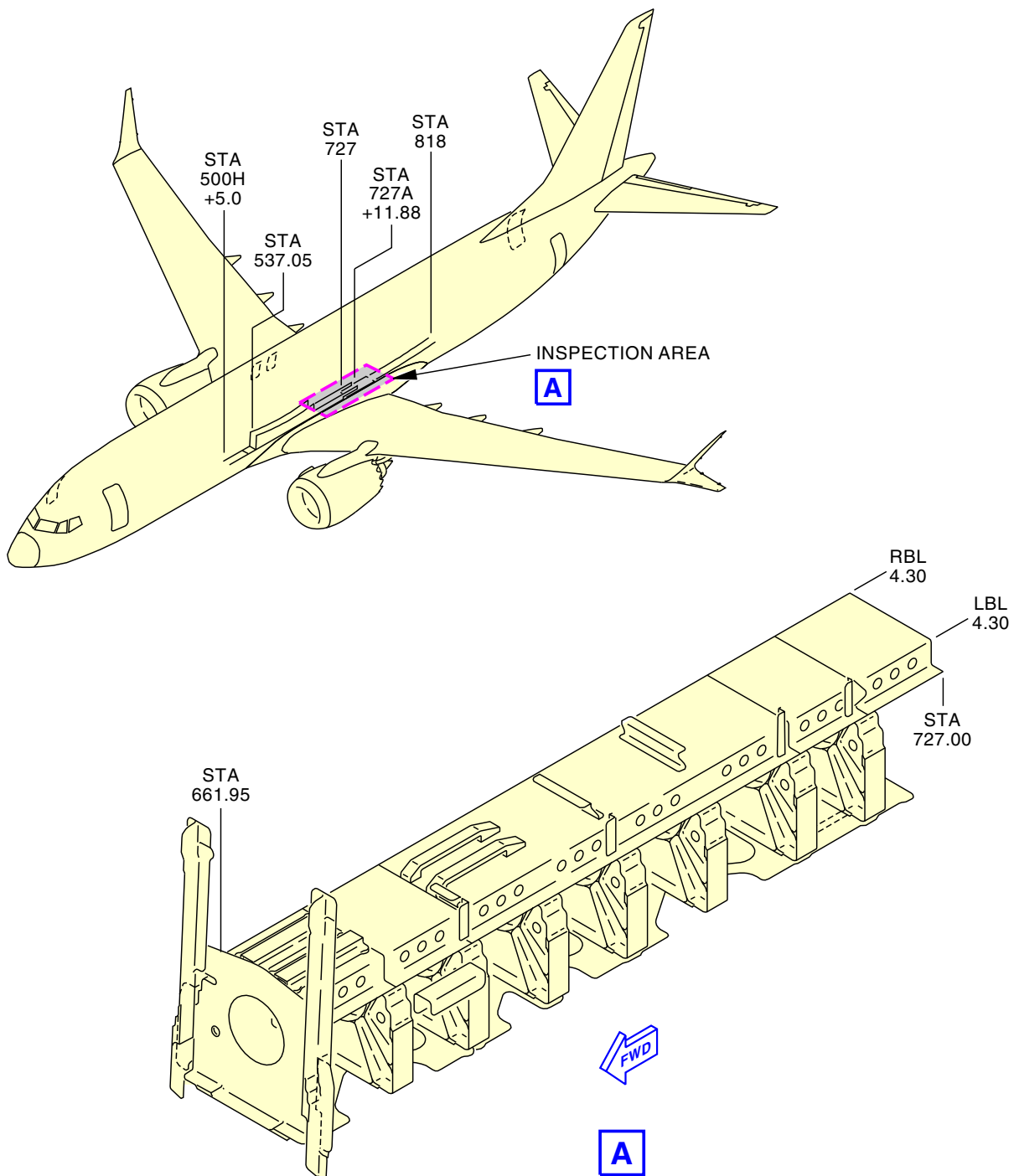
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2416060 S00061539697_V1

INTERNAL - GENERAL VISUAL: KEEL BEAM IN WHEEL WELL
Figure 226/53-05-03-990-826

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-822

25. INTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT

(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
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

C. Access Panels

Number	Name/Location
S1401	AFT Cargo Compartment Inspection

D. Inspection

SUBTASK 53-05-03-010-023

(1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
S1401	AFT Cargo Compartment Inspection

NOTE: Remove sidewall and ceiling panels, E6 LRU, access panels around vacuum lav tank. Remove/displace insulation blankets as required. Remove/displace vacuum lav components as required. Remove/displace auxiliary fuel tank as required (business jet only).

SUBTASK 53-05-03-210-022

(2) Do a General Visual inspection of the aft cargo compartment, including:

1. Side skin panels (skin, frames, stringers), circumferential skin and stringer splices, (note: located at Sta 727I for -900 and 727L for -900ER models).
2. Stringer 18 strap at side of body.
3. Stringer 18A web, chord and links.
4. Aft side of STA 727 bulkhead and pressure web.

SUBTASK 53-05-03-910-025

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

SUBTASK 53-05-03-410-022

(4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
S1401	AFT Cargo Compartment Inspection

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

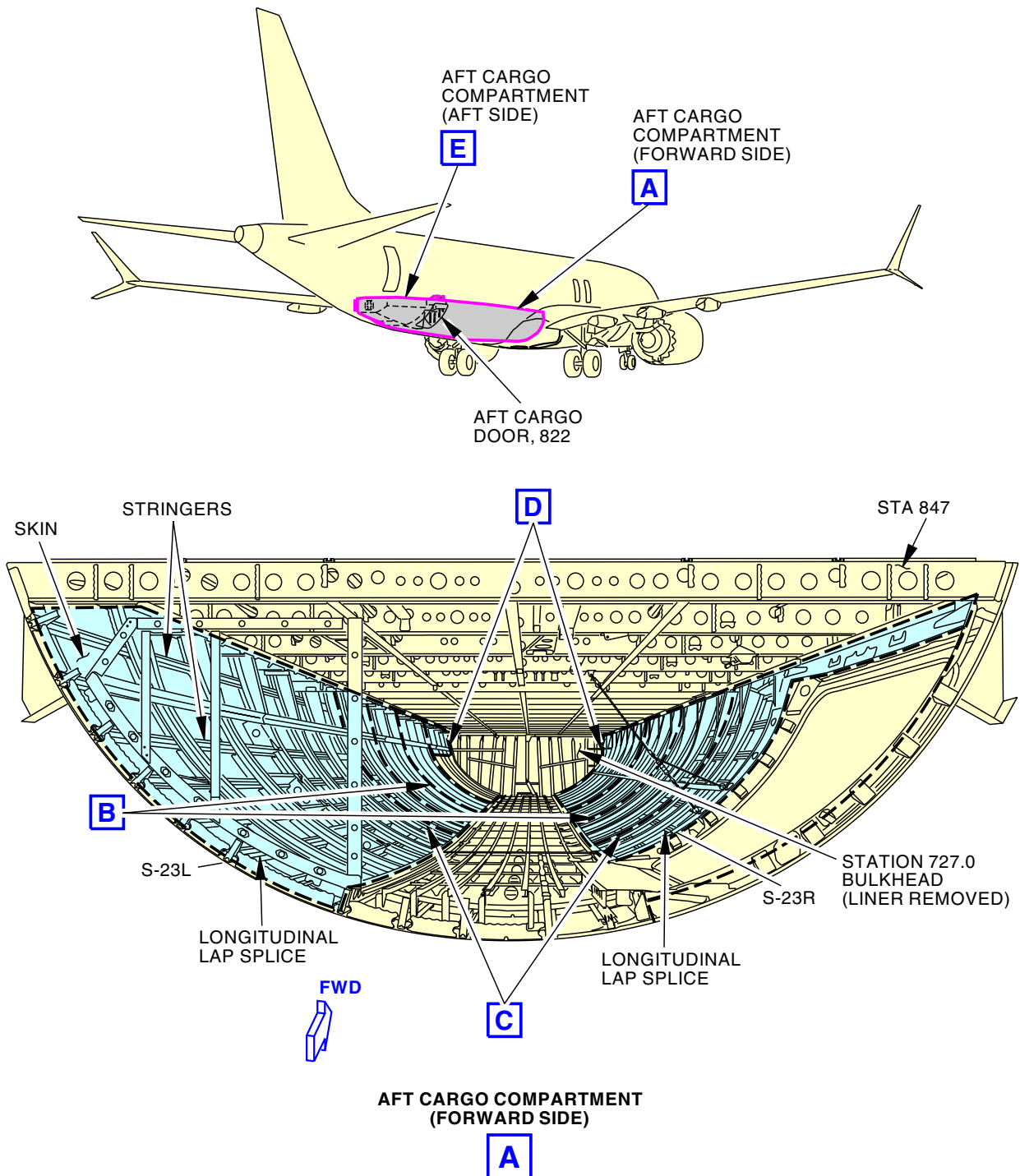
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2416061 S00061539699_V1

INTERNAL-GENERAL VISUAL: AFT CARGO COMPARTMENT
Figure 227/53-05-03-990-827 (Sheet 1 of 3)

EFFECTIVITY
SIA ALL

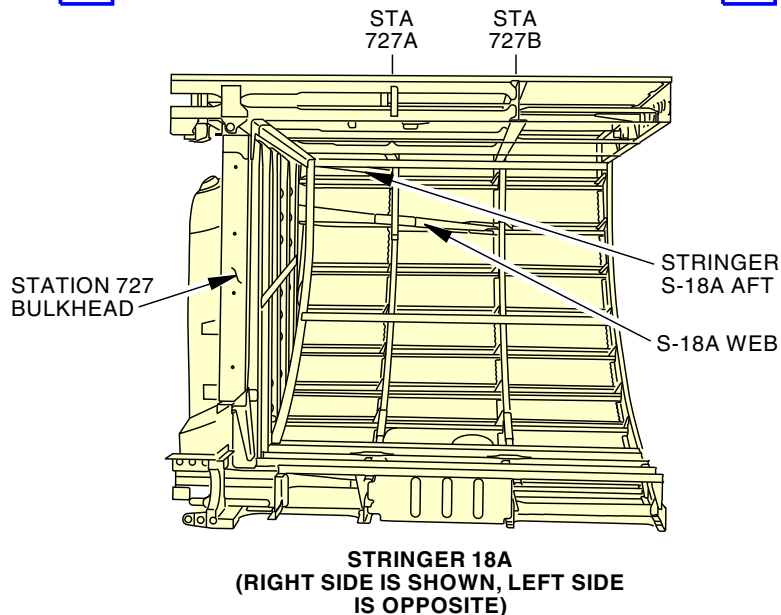
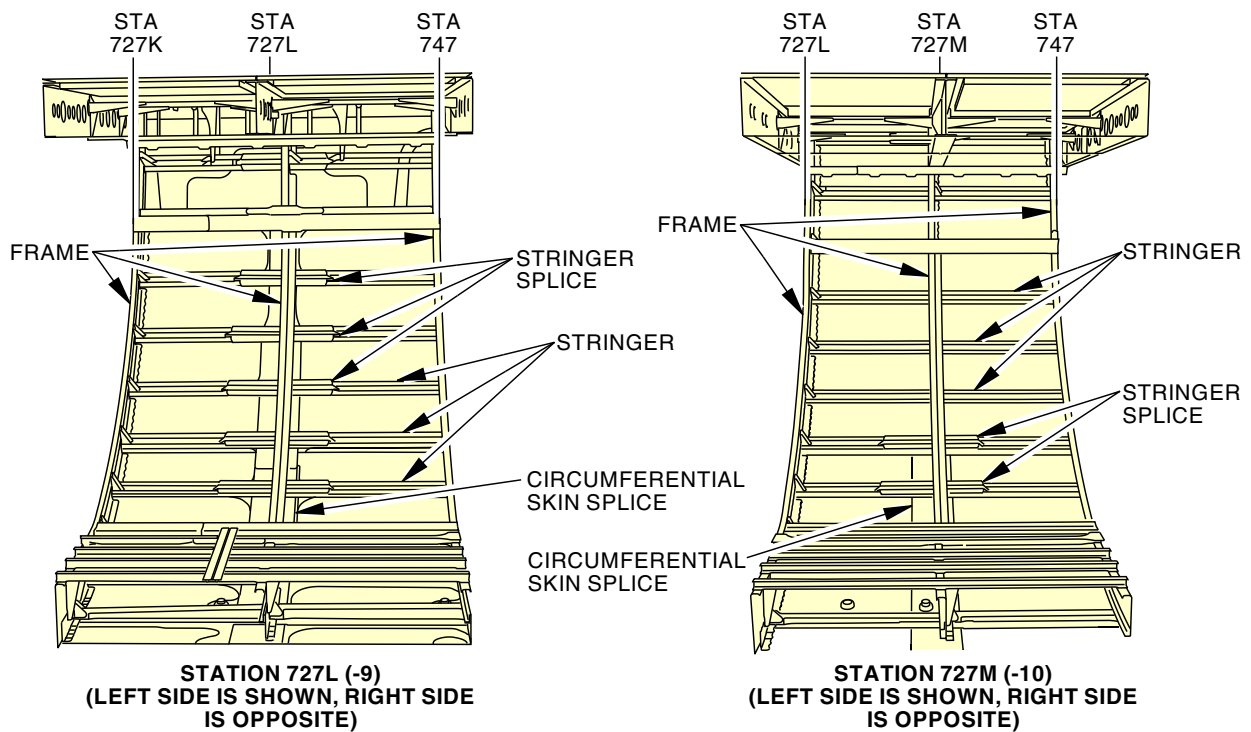
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**737-7/8/8200/9/10
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2416062 S00061539700_V2

INTERNAL-GENERAL VISUAL: AFT CARGO COMPARTMENT
Figure 227/53-05-03-990-827 (Sheet 2 of 3)

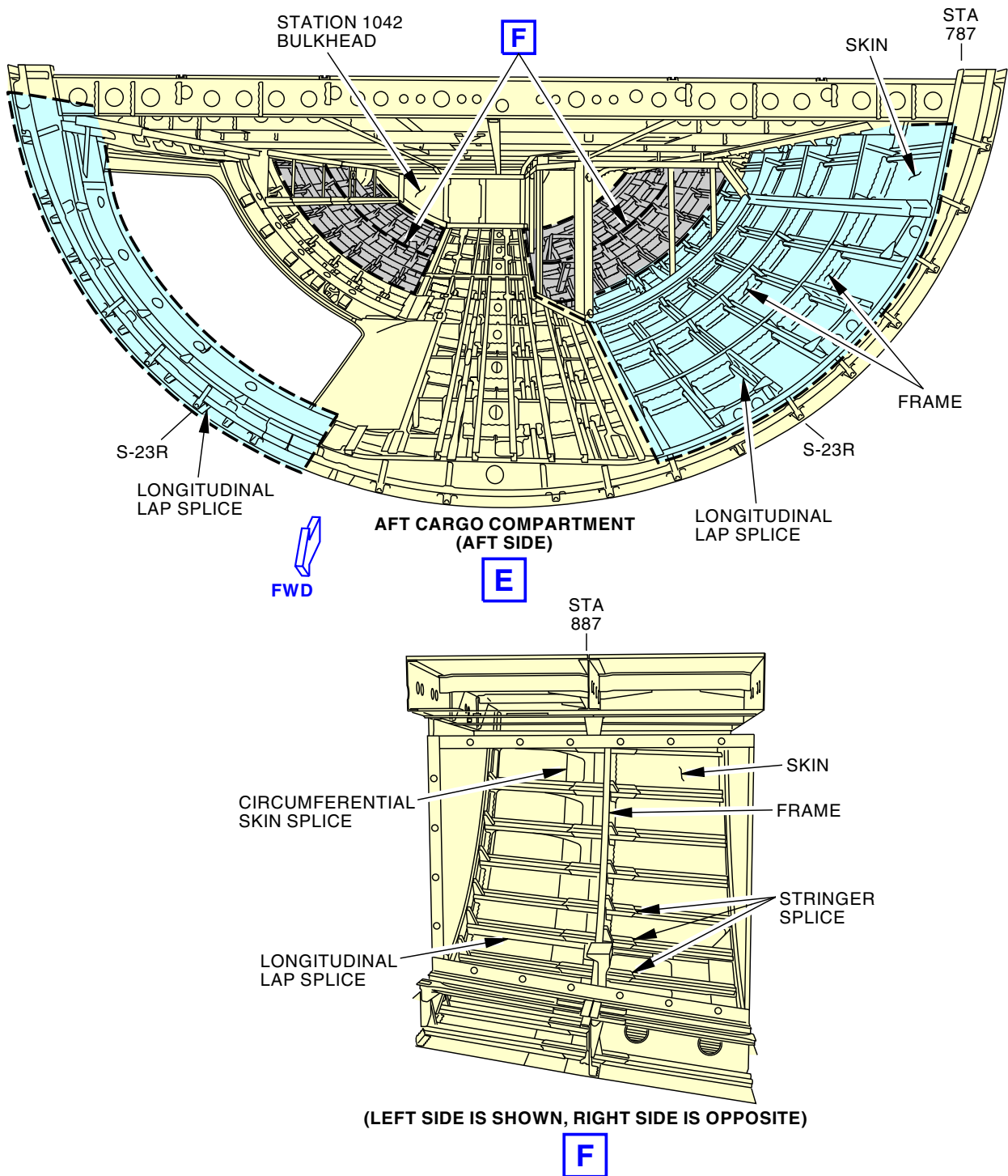
EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL



2416063 S00061539701_V2

INTERNAL-GENERAL VISUAL: AFT CARGO COMPARTMENT
Figure 227/53-05-03-990-827 (Sheet 3 of 3)

EFFECTIVITY
SIA ALL

53-05-03

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-804

26. **INTERNAL - DETAILED: AFT CARGO DOOR CUTOUT**

(Figure 228)

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
142	Aft Cargo Compartment - Right

C. Access Panels

Number	Name/Location
S1421	Aft Cargo Door Cutout Inspection

D. Inspection

SUBTASK 53-05-03-010-024

- (1) Special Access:

Number	Name/Location
S1421	Aft Cargo Door Cutout Inspection

NOTE: Remove door reveals. Remove sidewalls as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-004

- (2) Do a Detailed inspection of the aft cargo door cutout surround structure.

SUBTASK 53-05-03-910-026

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

SUBTASK 53-05-03-410-023

- (4) Close this access panel:

Number	Name/Location
S1421	Aft Cargo Door Cutout Inspection

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

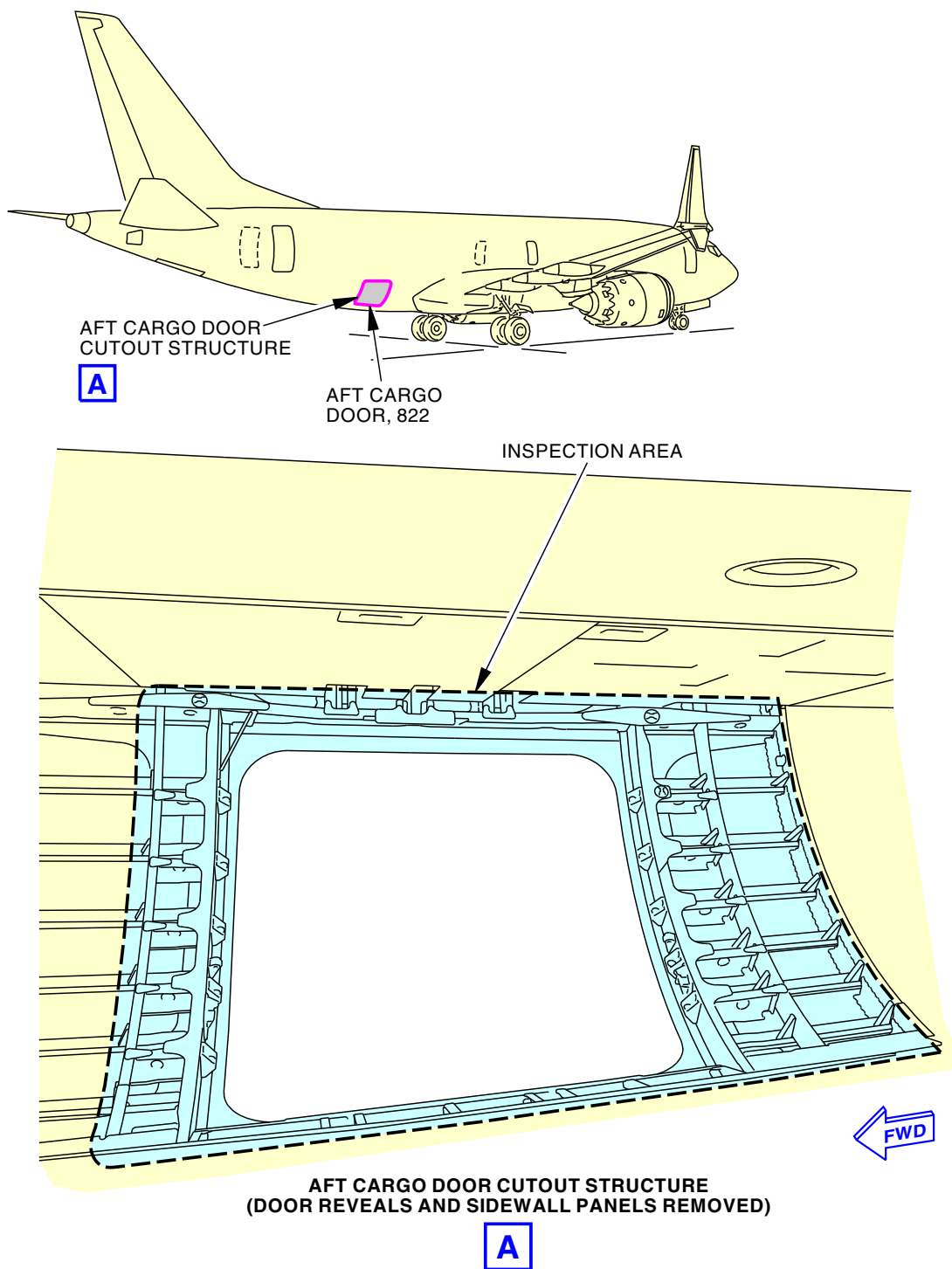
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2416064 S00061539703_V1

Aft Cargo Door Cutout Detailed (Internal)
Figure 228/53-05-03-990-828

EFFECTIVITY
SIA ALL

D633AM101-SIA

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TASK 53-05-03-210-823

27. **INTERNAL - GENERAL VISUAL: AFT BILGE**

(Figure 229, Figure 230)

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
143	Area Below Aft Cargo Compartment - Left
144	Area Below Aft Cargo Compartment - Right

C. Access Panels

Number	Name/Location
S1402	Aft Bilge Inspection

D. Inspection

SUBTASK 53-05-03-010-025

(1) Special Access:

Number	Name/Location
S1402	Aft Bilge Inspection

NOTE: Remove cargo floor panels and scuff plates. Remove/Displace insulation blankets as required.

SUBTASK 53-05-03-210-023

(2) Do a General Visual inspection of the aft bilge skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices, (note: located at STA 727L for -9 models and 727M for -10 models); Sta 727 bulkhead and pressure web, and cargo door cutout surround structure in bilge.

SUBTASK 53-05-03-910-027

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

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

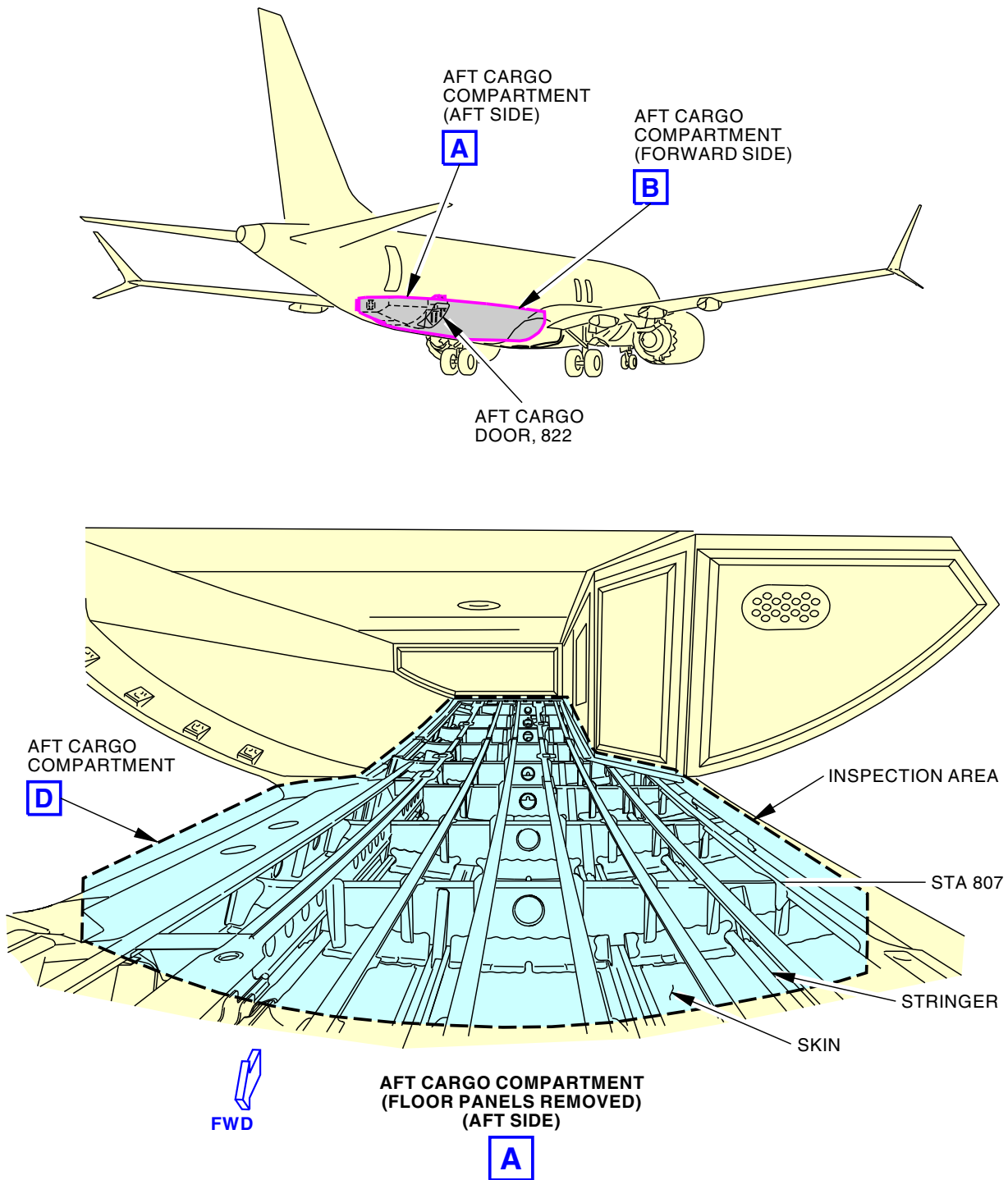
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2416065 S00061539705_V1

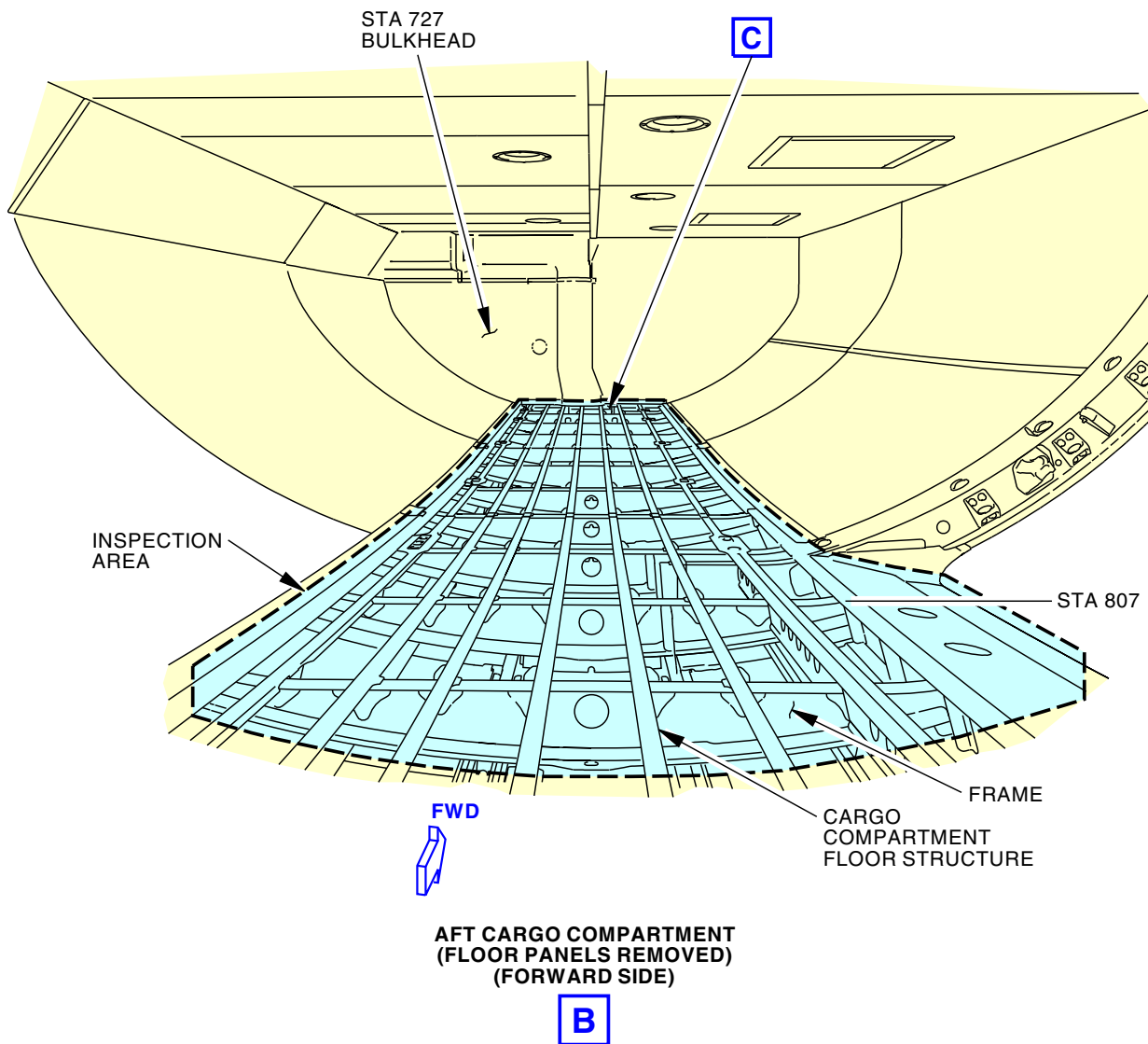
Below the Aft Cargo Comp. - Aft Bilge General Visual (Int)
Figure 229/53-05-03-990-829 (Sheet 1 of 3)

EFFECTIVITY
SIA ALL

53-05-03

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2416066 S00061539706_V1

Below the Aft Cargo Comp. - Aft Bilge General Visual (Int)
Figure 229/53-05-03-990-829 (Sheet 2 of 3)

EFFECTIVITY
SIA ALL

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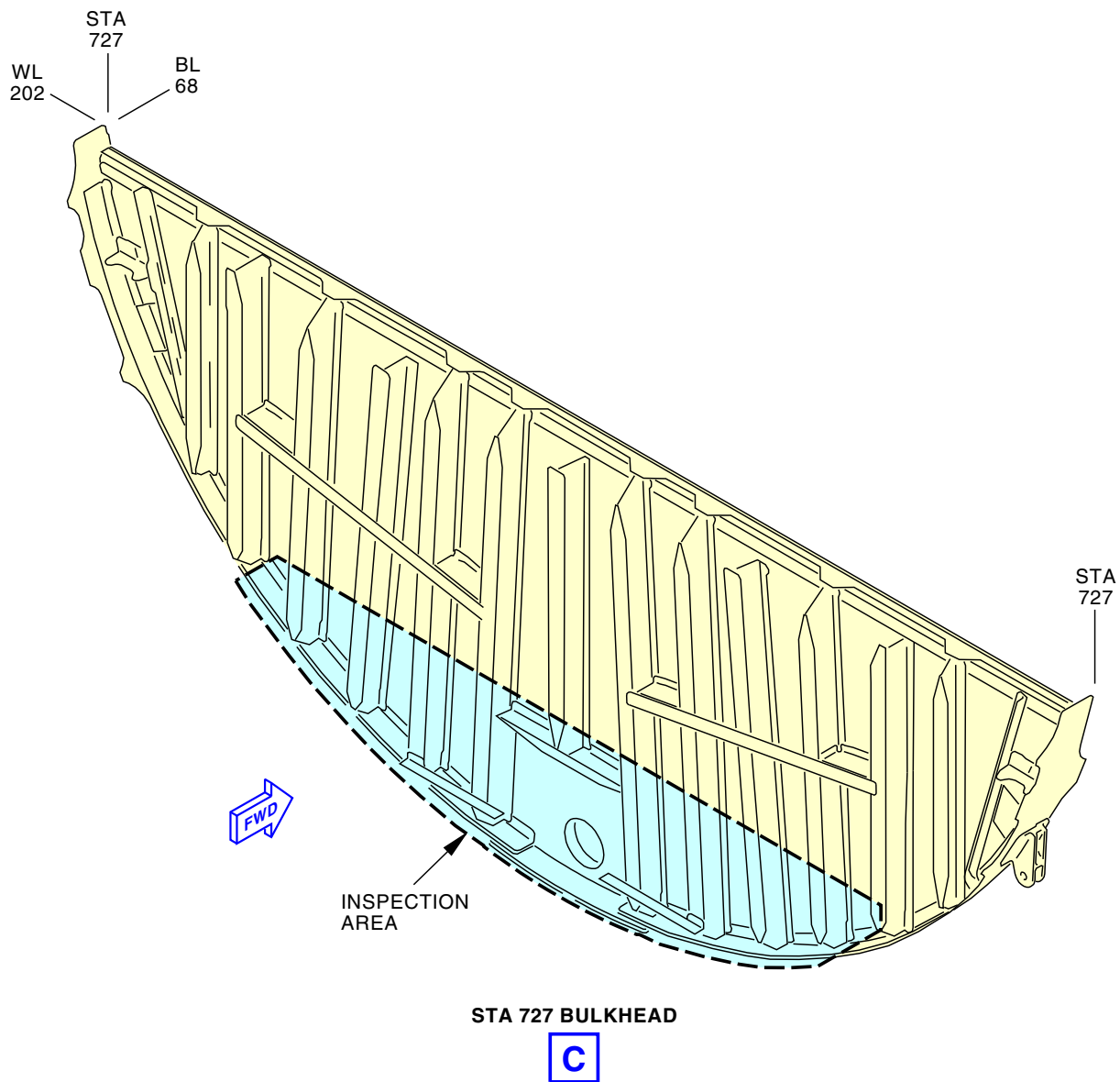
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2416067 S00061539707_V1

Below the Aft Cargo Comp. - Aft Bilge General Visual (Int)
Figure 229/53-05-03-990-829 (Sheet 3 of 3)

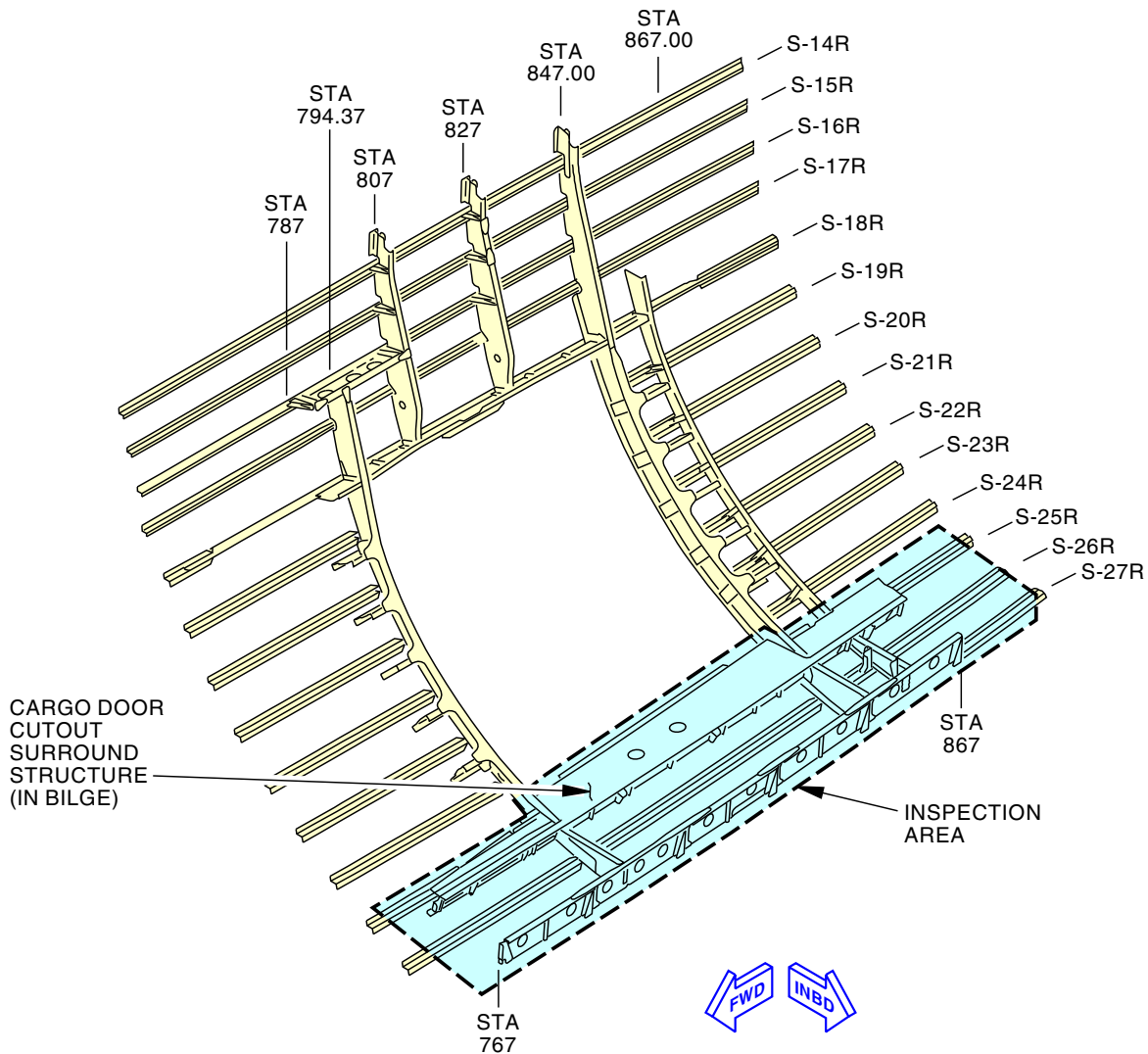
EFFECTIVITY
SIA ALL

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AFT CARGO COMPARTMENT
(DOOR REVEALS AND SIDEWALL PANELS REMOVED)

D

2416068 S00061539708_V1

Section 46 Aft Cargo Door Surround Structure Locations - General Visual (Internal)
Figure 230/53-05-03-990-830

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-824

28. **INTERNAL - GENERAL VISUAL: AREA AFT OF CARGO COMPARTMENT**

(Figure 231)

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
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - Right

C. Access Panels

Number	Name/Location
S1403	Area Aft of Cargo Compartment Inspection

D. Inspection

SUBTASK 53-05-03-010-026

(1) Special Access:

Number	Name/Location
S1403	Area Aft of Cargo Compartment Inspection

NOTE: Remove aft cargo compartment aft bulkhead panel and potable water tank.
Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-024

- (2) Do a General Visual inspection of the area aft of cargo compartment, including:
1. Skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices.
 2. Aft entry and galley door cutout surround structure in lower lobe.
 3. STA 1016 bulkhead, including chords, pressure web, stiffeners, chord/web attachments.
 4. Stringer splice fittings and tension bolts at STA 1016.

SUBTASK 53-05-03-910-028

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

————— **END OF TASK** —————

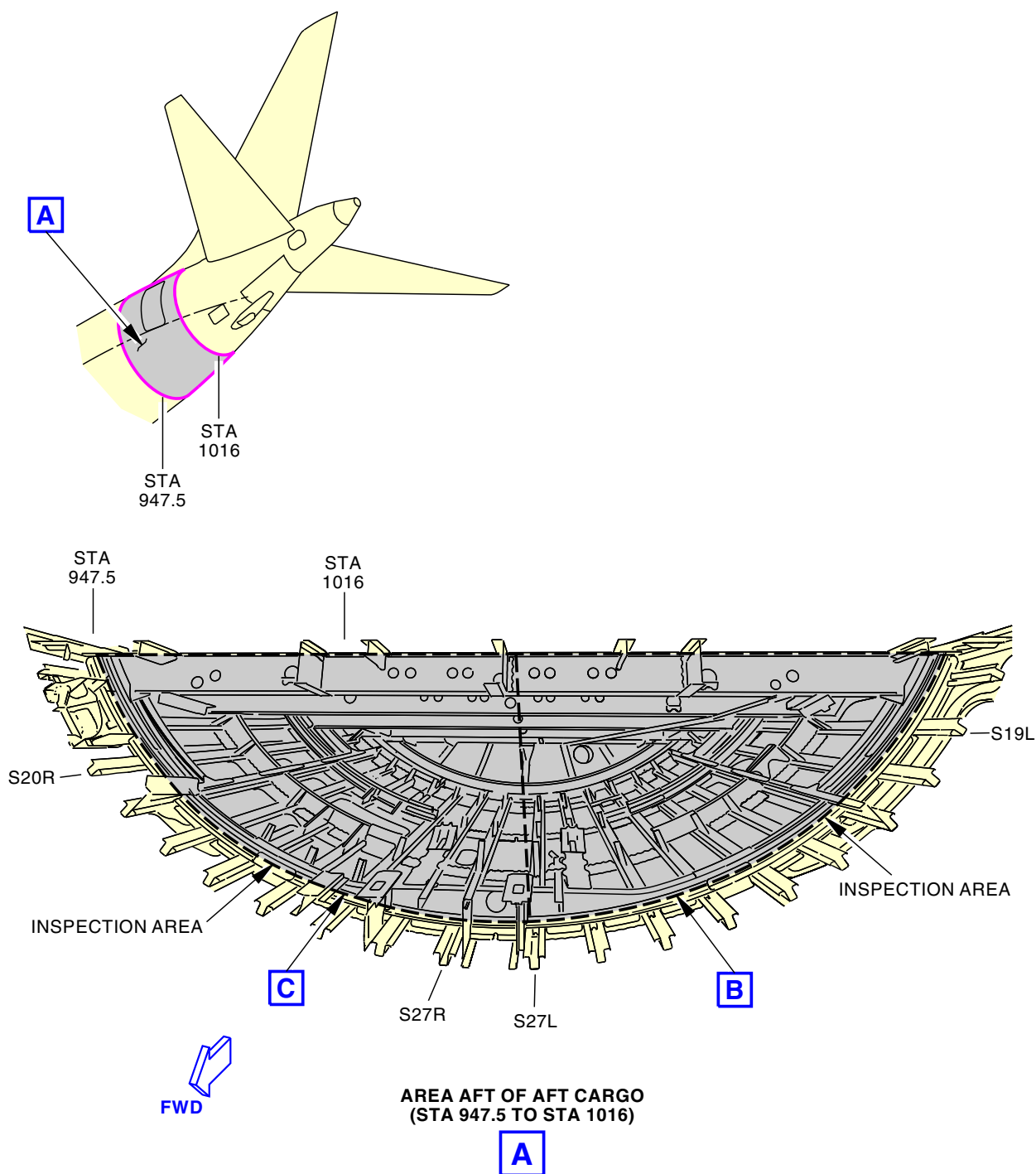
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416069 S00061539710_V1

Internal-General Visual: Internal-Area Aft Of Cargo Compartment
Figure 231/53-05-03-990-831 (Sheet 1 of 3)

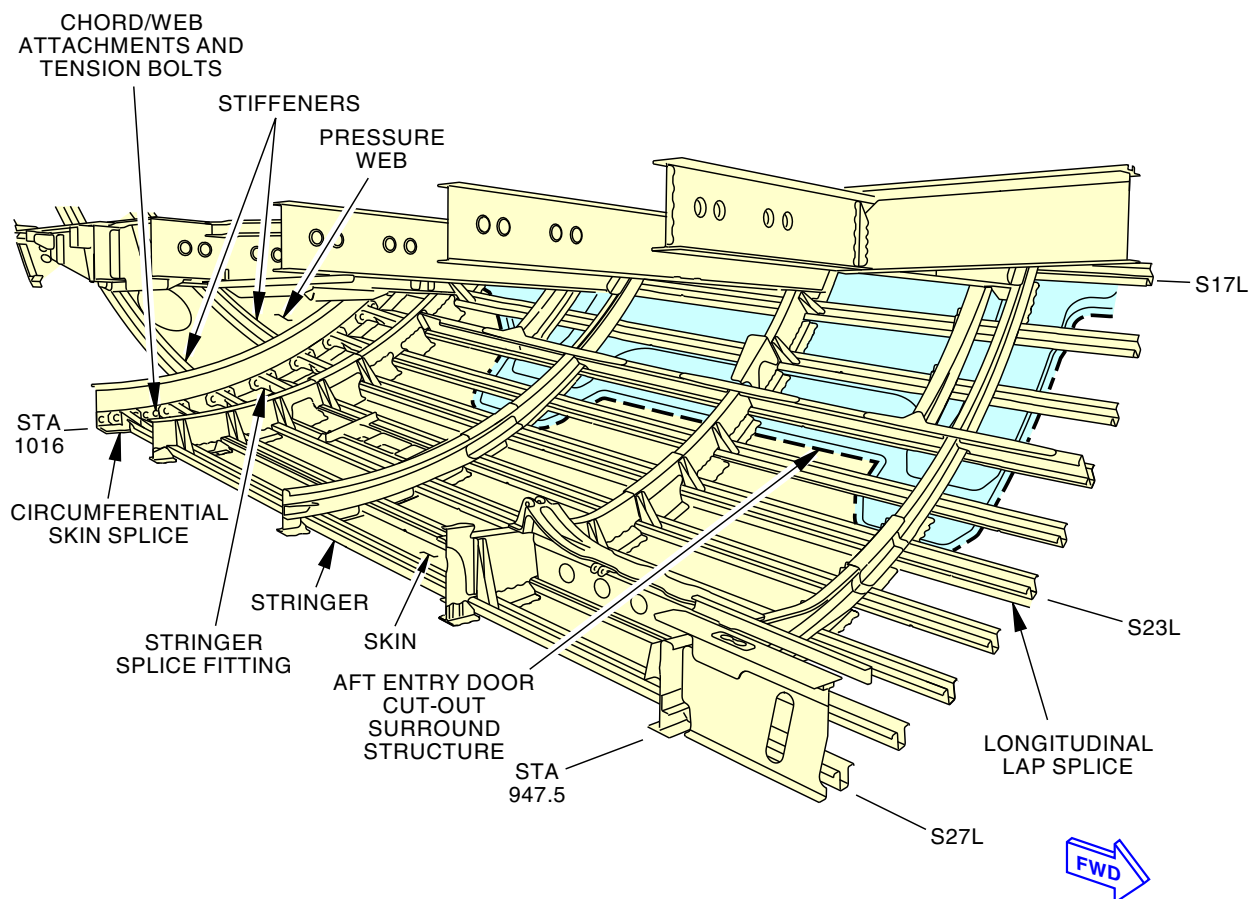
EFFECTIVITY
SIA ALL

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AREA AFT OF AFT CARGO
(STA 947.5 TO STA 1016)
(LEFT SIDE)

B

2416070 S00061539711_V1

Internal-General Visual: Internal-Area Aft Of Cargo Compartment
Figure 231/53-05-03-990-831 (Sheet 2 of 3)

EFFECTIVITY
SIA ALL

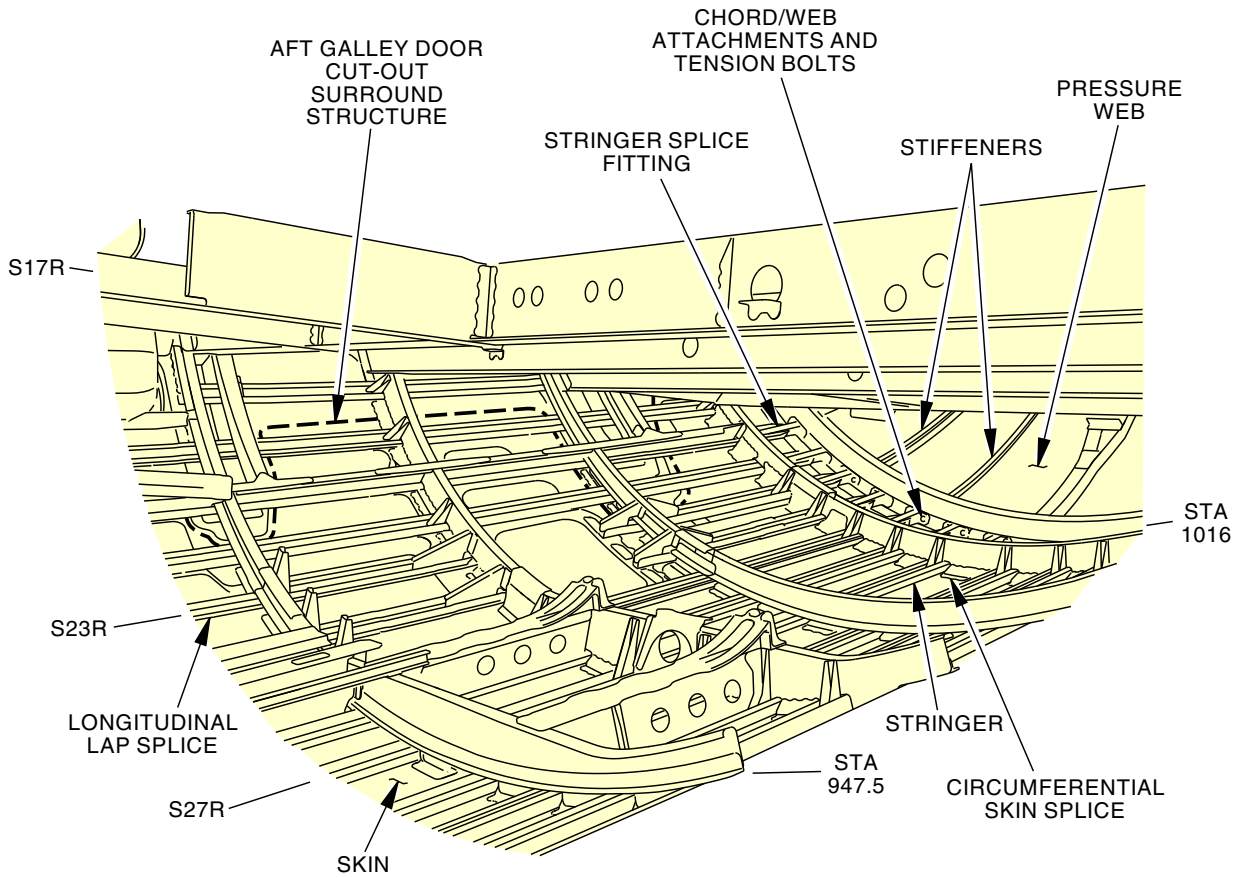
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AIRCRAFT MAINTENANCE MANUAL



AREA AFT OF AFT CARGO
(STA 947.5 TO STA 1016)
(RIGHT SIDE)



2416071 S00061539712_V1

Internal-General Visual: Internal-Area Aft Of Cargo Compartment
Figure 231/53-05-03-990-831 (Sheet 3 of 3)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-825

29. INTERNAL - GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (aft of wheel well)
(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
149	Keel Beam (Part) Body Station 727.00 to Body Station 743.95
194	Lower Wing-To-Body Fairing - Aft of Wheel Well

C. Access Panels

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft
194CL	Aft Wing To Body Fairing Panel
194CR	Aft Wing To Body Fairing Panel
194DL	Aft Wing To Body Fairing Panel
194DR	Aft Wing To Body Fairing Panel
194E	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel
194HL	Aft Wing To Body Fairing Panel
194HR	Aft Wing To Body Fairing Panel

D. Inspection

SUBTASK 53-05-03-010-027

(1) Open these access panels:

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft
194CL	Aft Wing To Body Fairing Panel
194CR	Aft Wing To Body Fairing Panel
194DL	Aft Wing To Body Fairing Panel
194DR	Aft Wing To Body Fairing Panel
194E	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
194GR	Aft Wing To Body Fairing Panel
194HL	Aft Wing To Body Fairing Panel
194HR	Aft Wing To Body Fairing Panel

SUBTASK 53-05-03-210-025

- (2) Do a General Visual inspection of the area under lower wing-to-body fairing (aft of wheel well), including skin panels, longitudinal lap splices, circumferential skin splice, stringer 18 strap at side of body, stringer 18A (web, chords and links), and keel beam extension.

SUBTASK 53-05-03-910-029

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

SUBTASK 53-05-03-410-024

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft
194CL	Aft Wing To Body Fairing Panel
194CR	Aft Wing To Body Fairing Panel
194DL	Aft Wing To Body Fairing Panel
194DR	Aft Wing To Body Fairing Panel
194E	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel
194HL	Aft Wing To Body Fairing Panel
194HR	Aft Wing To Body Fairing Panel

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

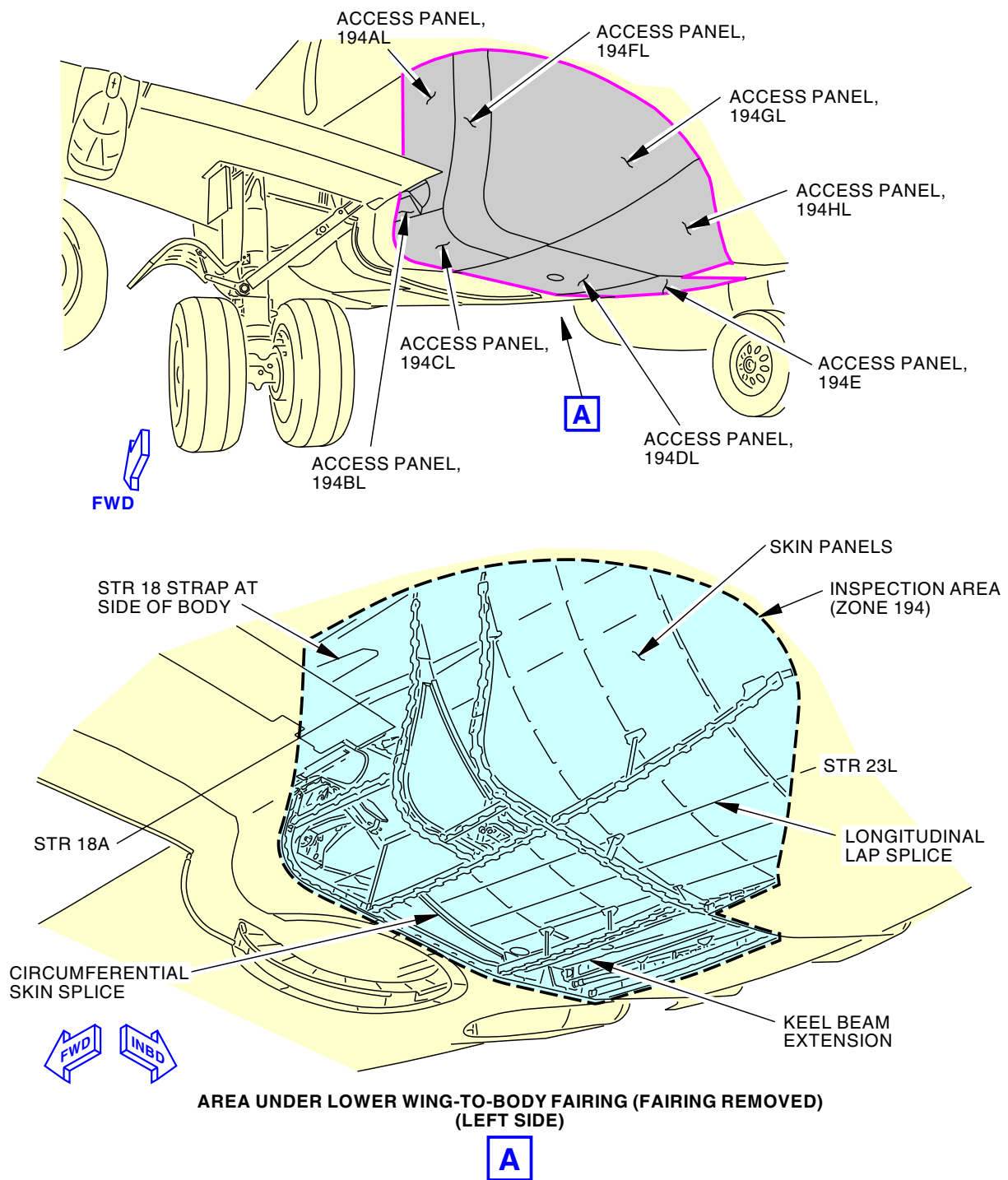
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**737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL**



2416072 S00061539714_V1

INTERNAL-GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (aft of wheel well)
Figure 232/53-05-03-990-832 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

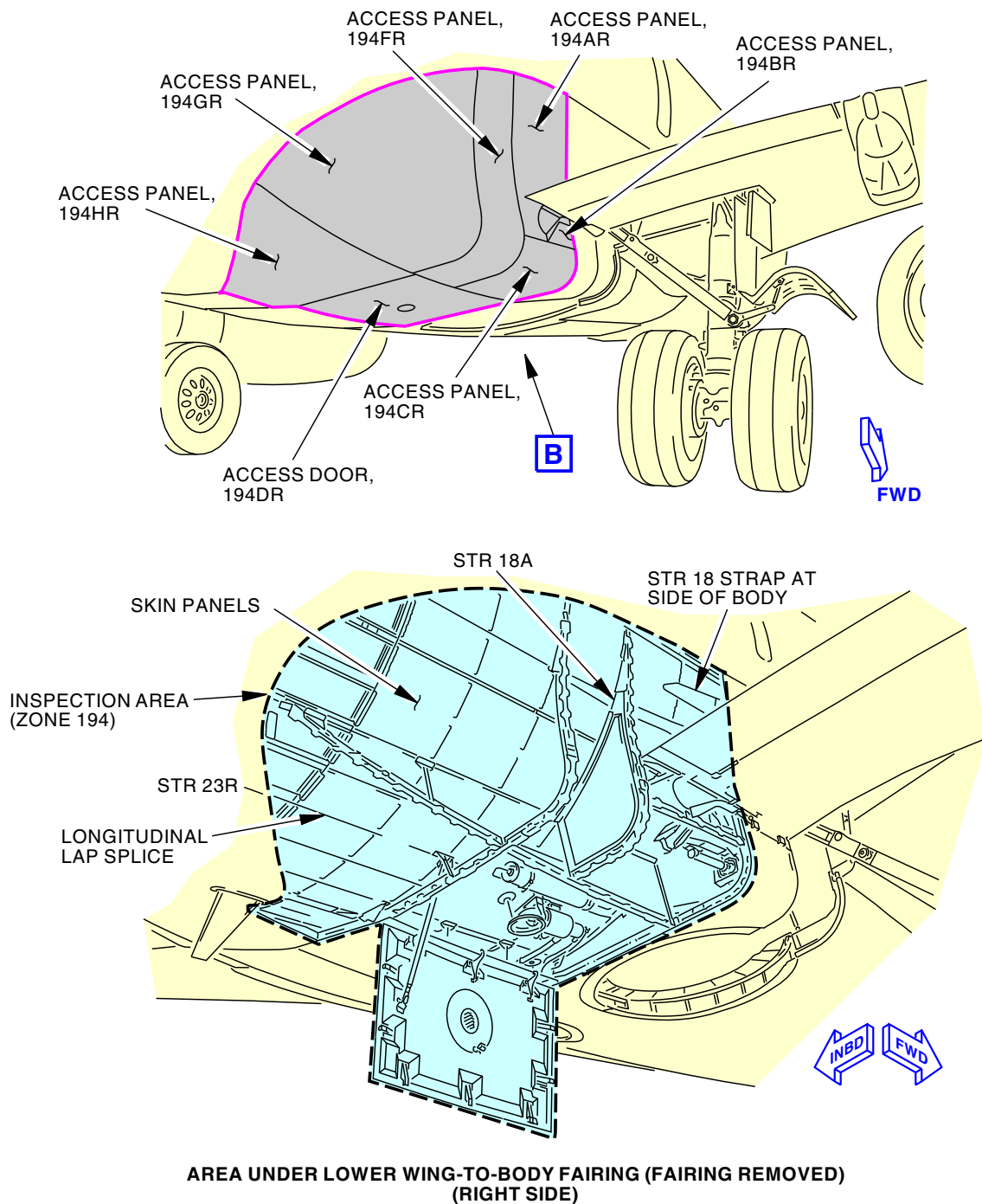
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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



AREA UNDER LOWER WING-TO-BODY FAIRING (FAIRING REMOVED)
(RIGHT SIDE)

B

2416073 S00061539715_V1

INTERNAL-GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (aft of wheel well)
Figure 232/53-05-03-990-832 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

53-05-03

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-826

30. INTERNAL - GENERAL VISUAL: AREA UNDER WING-TO-BODY FAIRING (above wing)
(Figure 233, Figure 234)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

C. Access Panels

Number	Name/Location
195AL	Wing-To-Body Fairing - Left Side
195AR	Wing-To-Body Fairing - Right Side
195BL	Wing-To-Body Fairing - Left Side
195BR	Wing-To-Body Fairing - Right Side
195CL	Wing-To-Body Fairing - Left Side
195CR	Wing-To-Body Fairing - Right Side

D. Inspection

SUBTASK 53-05-03-010-028

- (1) Open these access panels:

Number	Name/Location
195AL	Wing-To-Body Fairing - Left Side
195AR	Wing-To-Body Fairing - Right Side
195BL	Wing-To-Body Fairing - Left Side
195BR	Wing-To-Body Fairing - Right Side
195CL	Wing-To-Body Fairing - Left Side
195CR	Wing-To-Body Fairing - Right Side

SUBTASK 53-05-03-210-026

- (2) Do a General Visual inspection of the area under above-wing wing-to-body fairing, including skin panels, circumferential skin splices, and stringer 18 strap at side of body.

SUBTASK 53-05-03-910-030

- (3) Basic Task Description, 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 53-05-03-410-025

- (4) Close these access panels:

Number	Name/Location
195AL	Wing-To-Body Fairing - Left Side
195AR	Wing-To-Body Fairing - Right Side
195BL	Wing-To-Body Fairing - Left Side
195BR	Wing-To-Body Fairing - Right Side
195CL	Wing-To-Body Fairing - Left Side
195CR	Wing-To-Body Fairing - Right Side

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

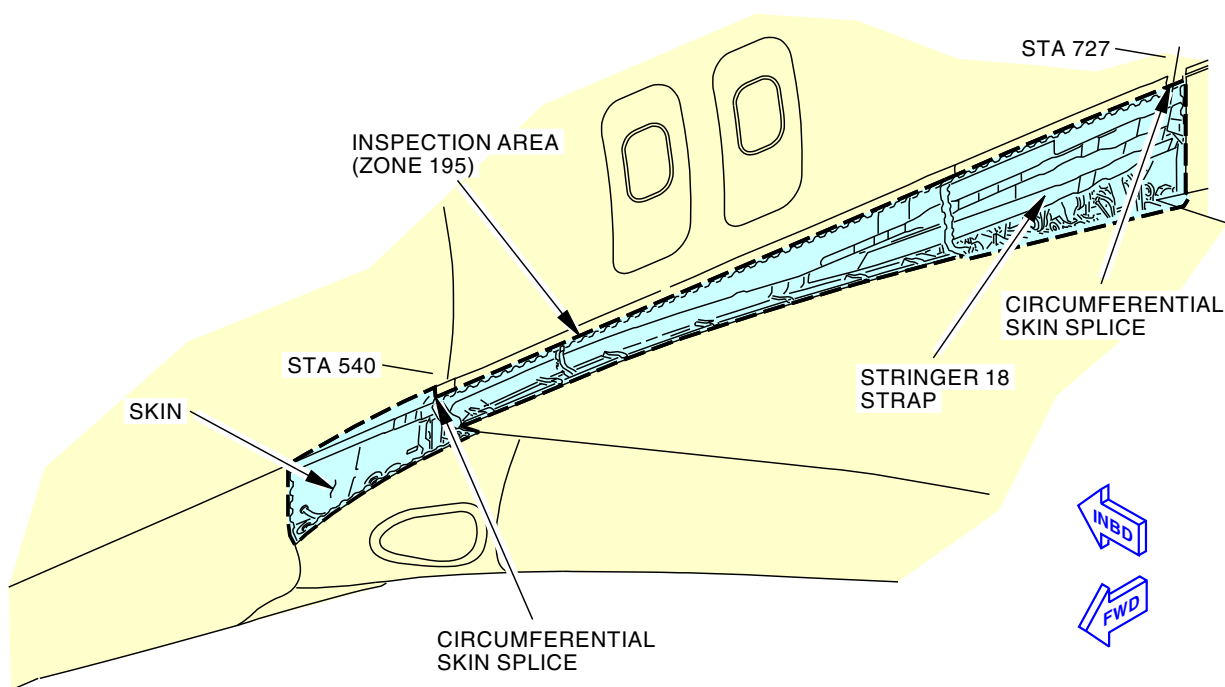
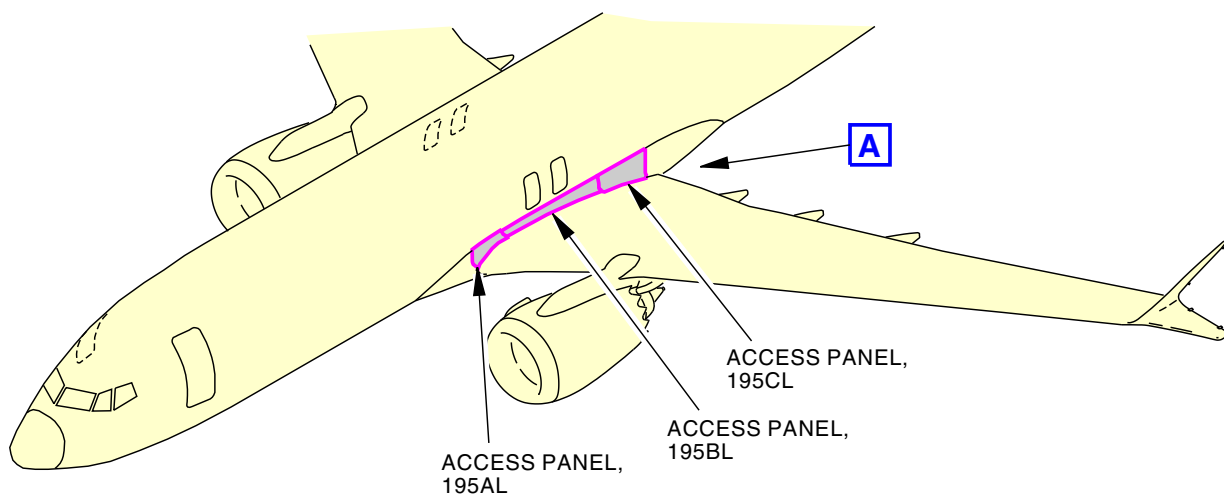
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AIRCRAFT MAINTENANCE MANUAL



2416074 S00061539717_V1

Internal - General Visual: Area Under Left Wing-to-Body Fairing
Figure 233/53-05-03-990-833

EFFECTIVITY
SIA ALL

D633AM101-SIA

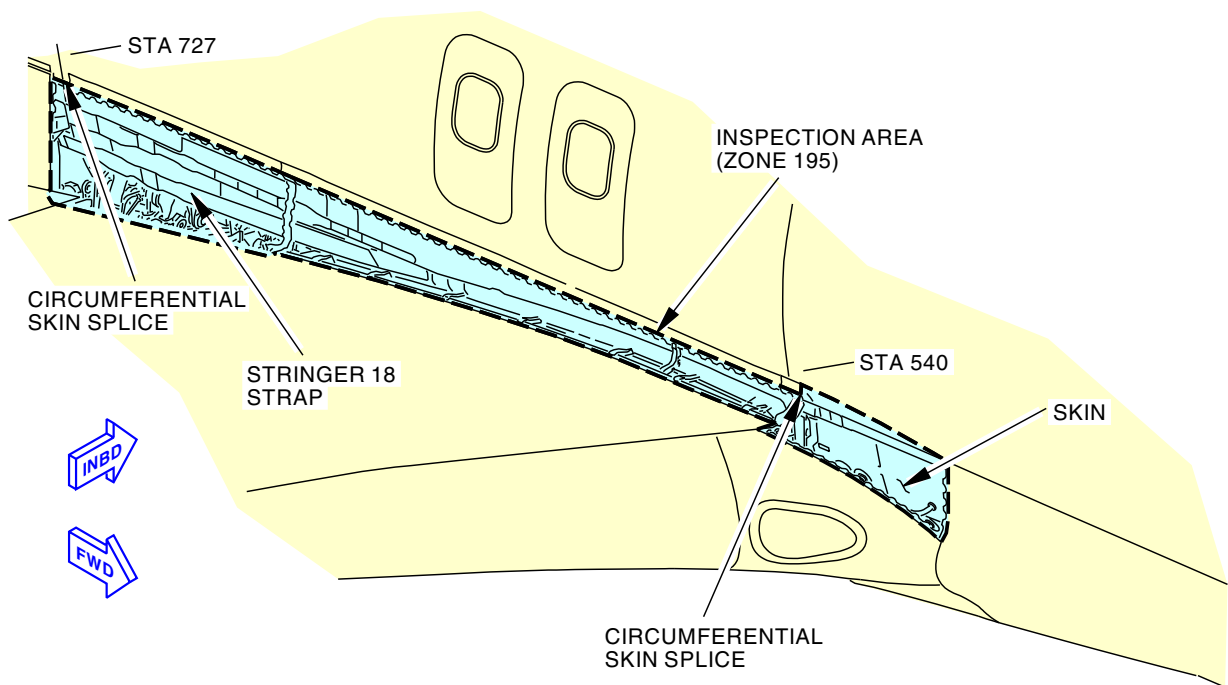
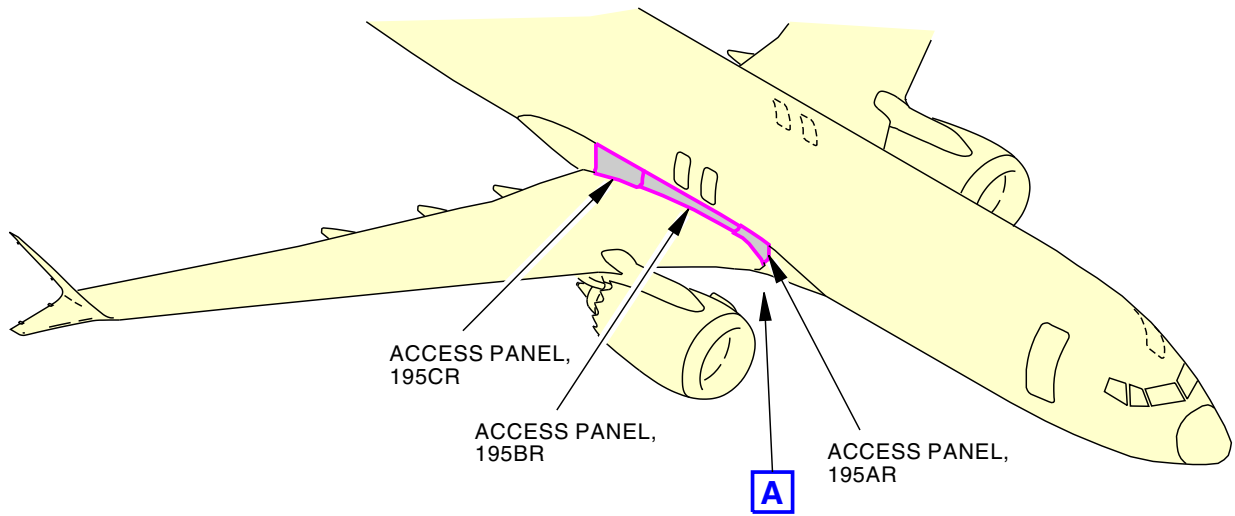
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



A

2416075 S00061539718_V1

Internal - General Visual: Area Under Right Wing-to-Body Fairing
Figure 234/53-05-03-990-834

EFFECTIVITY
SIA ALL

D633AM101-SIA

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-827

31. **EXTERNAL - GENERAL VISUAL: OVERWING EMERGENCY EXIT CUTOUT**

(Figure 235, Figure 236)

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
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

C. Access Panels

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

D. Inspection

SUBTASK 53-05-03-010-029

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

NOTE: Open automatic overwing exits.

SUBTASK 53-05-03-210-027

- (2) Do a General Visual inspection of the automatic overwing exit cutout structure, fittings and stops.

SUBTASK 53-05-03-910-031

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

SUBTASK 53-05-03-410-026

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
832	Emergency Exit Door (AOE)
833	Emergency Exit Door (AOE)
842	Emergency Exit Door (AOE)
843	Emergency Exit Door (AOE)

————— **END OF TASK** —————

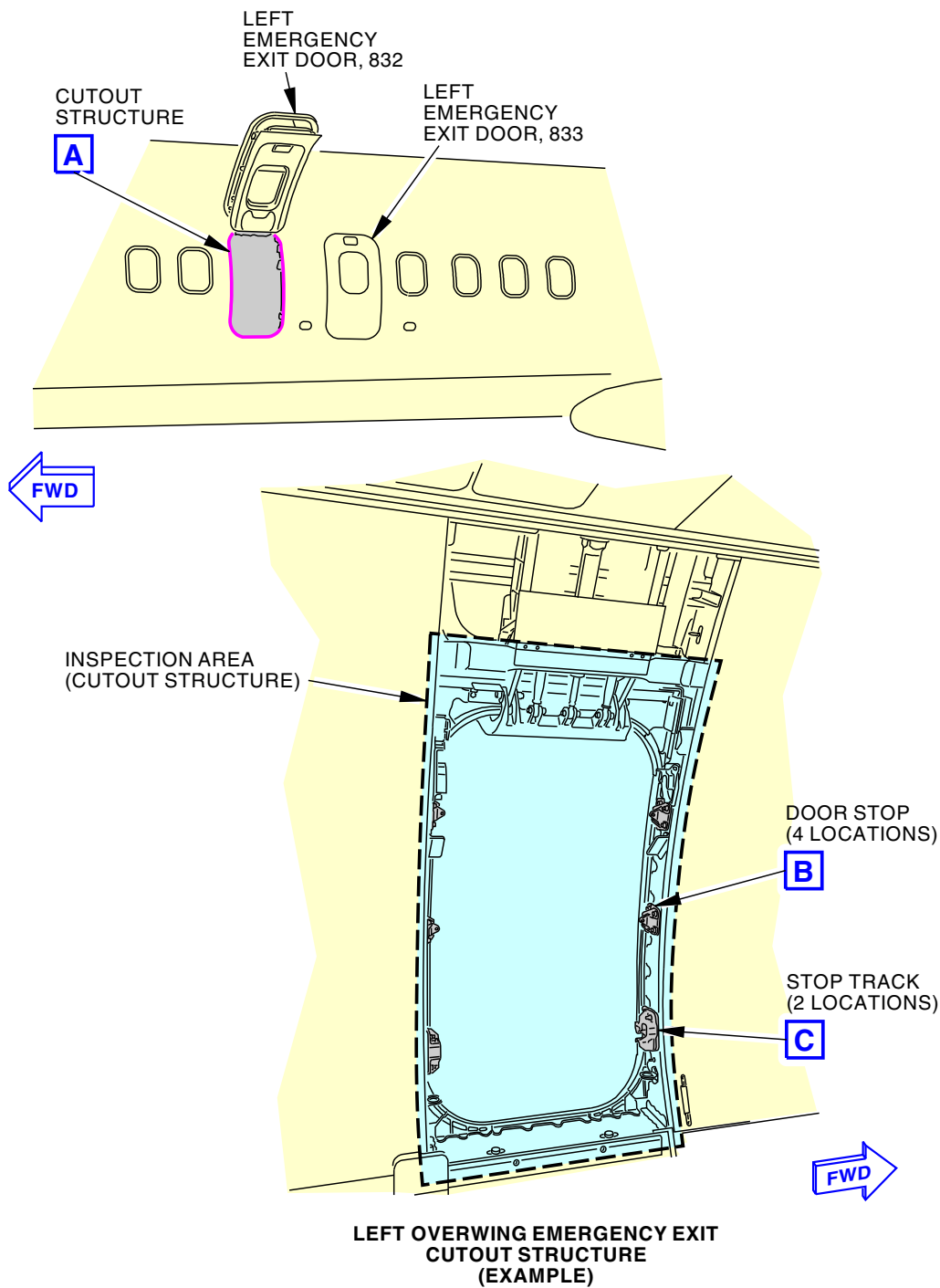
EFFECTIVITY
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416076 S00061539720_V1

Left Overwing Emergency Exit Cutout
Figure 235/53-05-03-990-835 (Sheet 1 of 2)

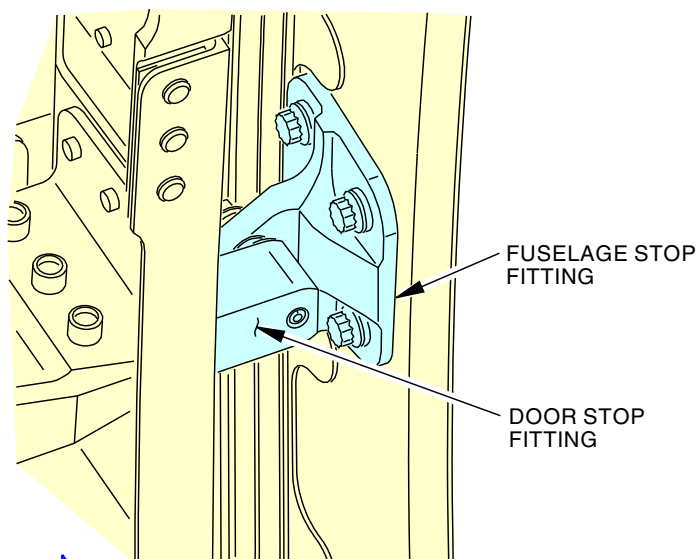
EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

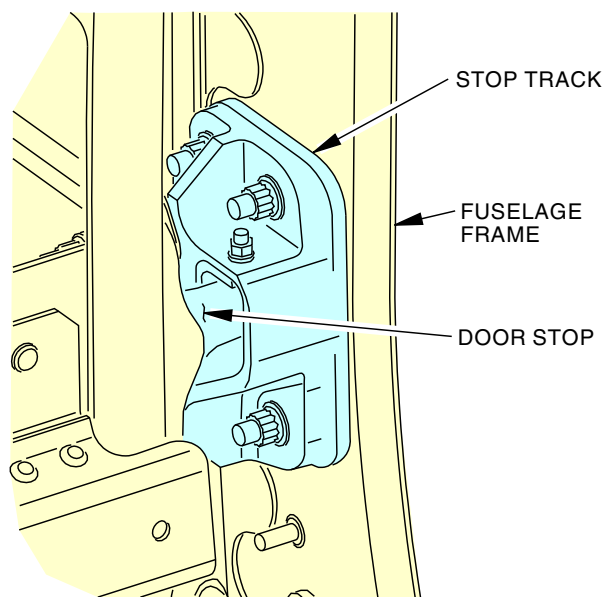
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DOOR STOP
(EXAMPLE)

B



STOP TRACK
(EXAMPLE)

C



2416077 S00061539721_V1

Left Overwing Emergency Exit Cutout
Figure 235/53-05-03-990-835 (Sheet 2 of 2)

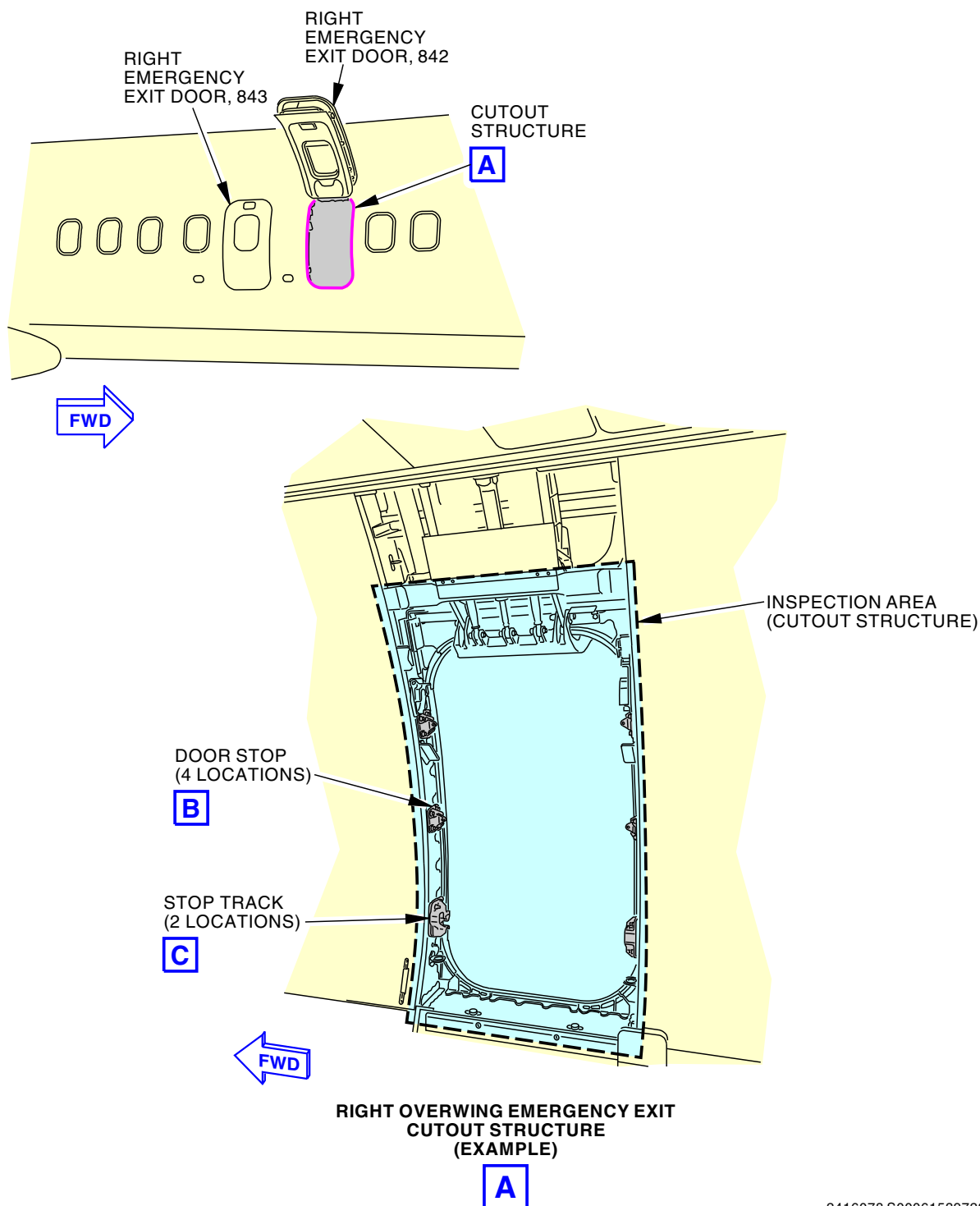
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416078 S00061539722_V1

Right Overwing Emergency Exit Cutout
Figure 236/53-05-03-990-836 (Sheet 1 of 2)

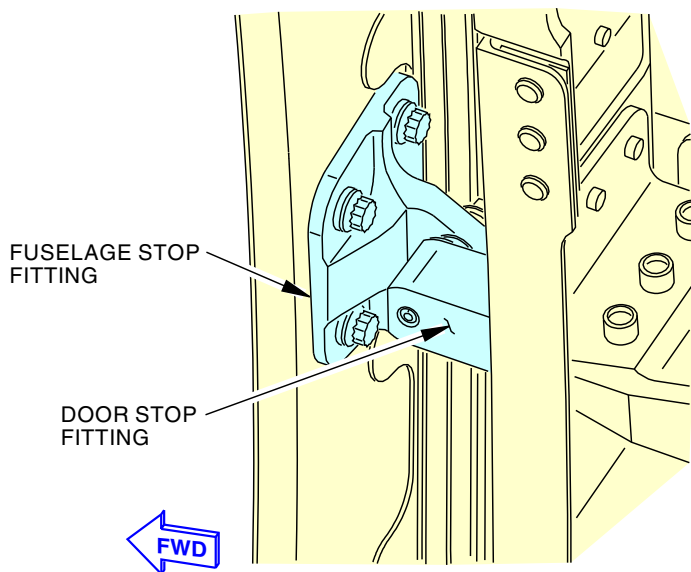
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

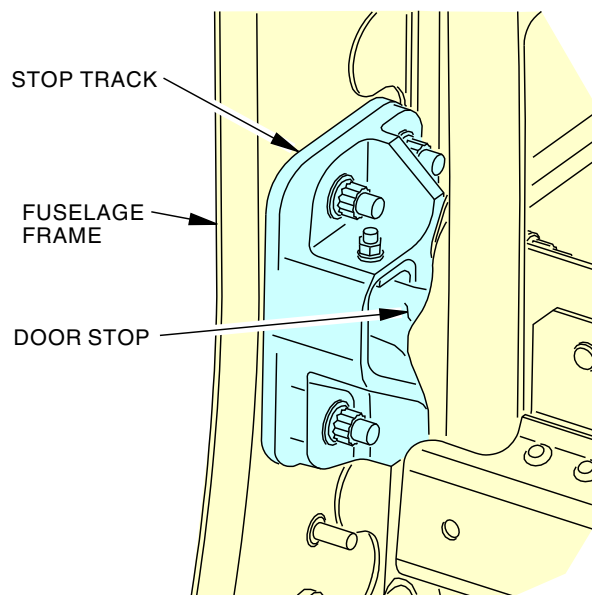
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**DOOR STOP
(EXAMPLE)**

B



**STOP TRACK
(EXAMPLE)**

C

2416079 S00061539723_V1

**Right Overwing Emergency Exit Cutout
Figure 236/53-05-03-990-836 (Sheet 2 of 2)**

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-805

32. **EXTERNAL - DETAILED: FORWARD ENTRY DOOR FRAME, STOPS, LATCHES AND HINGES**
(Figure 237)

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
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

C. Access Panels

Number	Name/Location
831	Forward Entry Door

D. Inspection

SUBTASK 53-05-03-010-030

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
831	Forward Entry Door

NOTE: Open forward entry door.

SUBTASK 53-05-03-211-005

- (2) Do a Detailed inspection of the door frames, stops, latches and hinges on the forward door cutout surround structure.

SUBTASK 53-05-03-910-032

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

SUBTASK 53-05-03-410-027

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
831	Forward Entry Door

————— **END OF TASK** —————

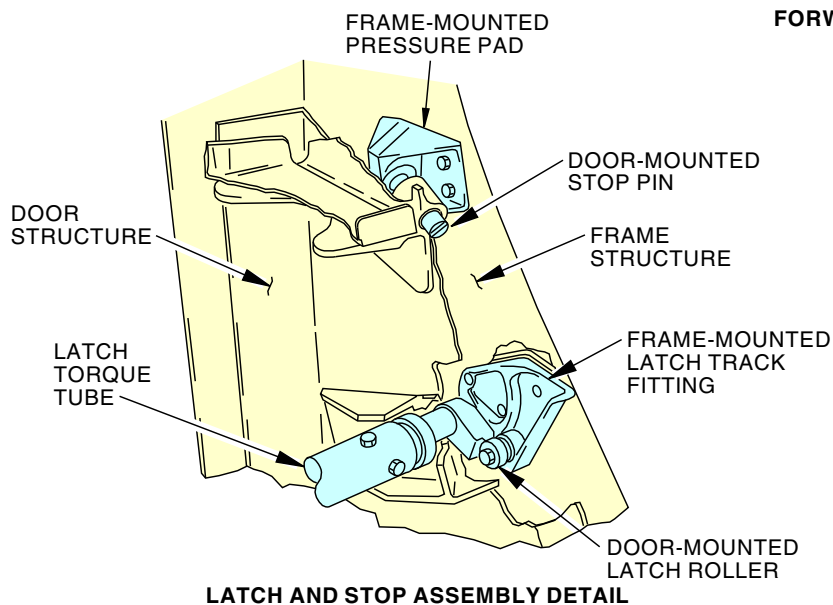
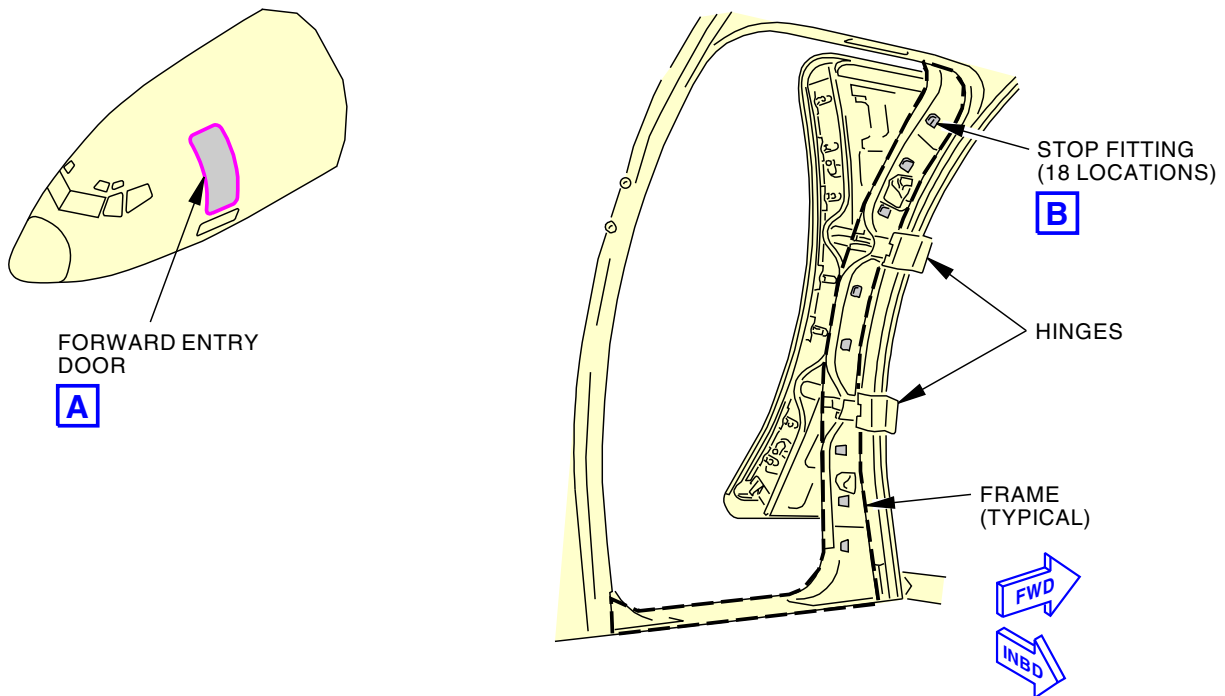
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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LATCH AND STOP ASSEMBLY DETAIL

2415751 S00061538817_V1

External - Forward Entry Door Frame, Stop, Latches and Hinges
Figure 237/53-05-03-990-837

EFFECTIVITY
SIA ALL

D633AM101-SIA

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-806

33. **EXTERNAL - DETAILED: FORWARD GALLEY SERVICE DOOR FRAME, STOPS, LATCHES AND HINGES**

(Figure 238)

NOTE: This procedure is a scheduled maintenance task.

A. References

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

B. Location Zones

<u>Zone</u>	<u>Area</u>
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

C. Access Panels

<u>Number</u>	<u>Name/Location</u>
841	Forward Galley Service Door

D. Inspection

SUBTASK 53-05-03-010-031

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
841	Forward Galley Service Door

NOTE: Open forward galley service door.

SUBTASK 53-05-03-211-006

- (2) Do a Detailed inspection of the door frames, stops, latches and hinges on forward galley door cutout surround structure.

SUBTASK 53-05-03-910-033

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

SUBTASK 53-05-03-410-028

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
841	Forward Galley Service Door

————— **END OF TASK** —————

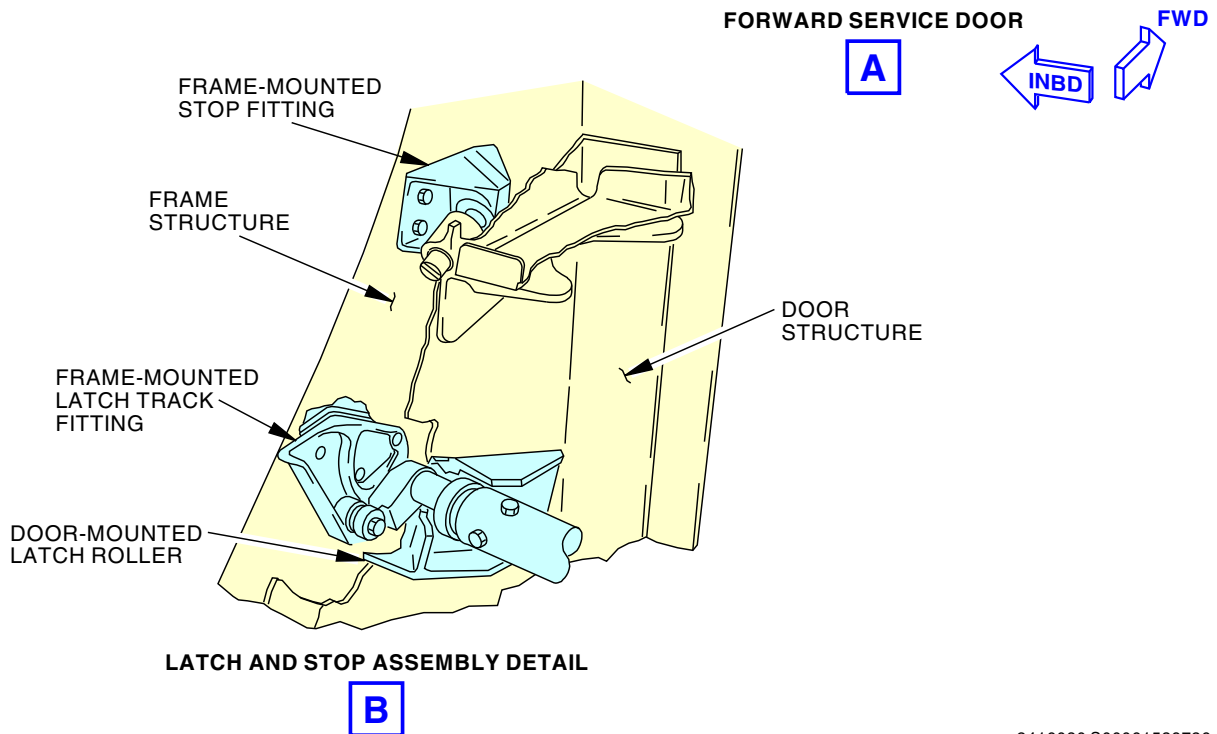
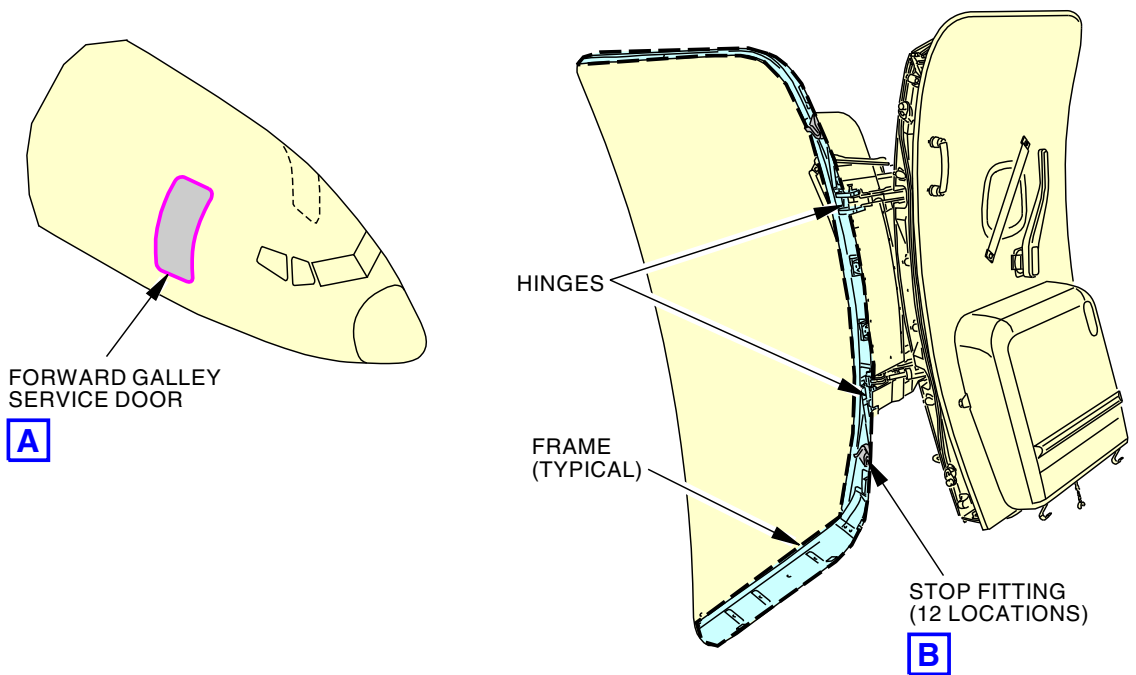
EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416080 S00061539726_V1

External - Forward Galley Service Door Frame, Stops, Latches and Hinges
Figure 238/53-05-03-990-838

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-807

34. **EXTERNAL - DETAILED: AFT ENTRY DOOR FRAME, STOPS, LATCHES AND HINGES**
(Figure 239)

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
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

C. Access Panels

Number	Name/Location
834	Aft Entry Door

D. Inspection

SUBTASK 53-05-03-010-032

- (1) Open this access panel:

Number	Name/Location
834	Aft Entry Door

NOTE: Open aft entry door.

SUBTASK 53-05-03-211-007

- (2) Do a Detailed inspection of the door frames, stops, latches and hinges on aft entry cutout surround structure.

SUBTASK 53-05-03-910-034

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

SUBTASK 53-05-03-410-029

- (4) Close this access panel:

Number	Name/Location
834	Aft Entry Door

————— **END OF TASK** —————

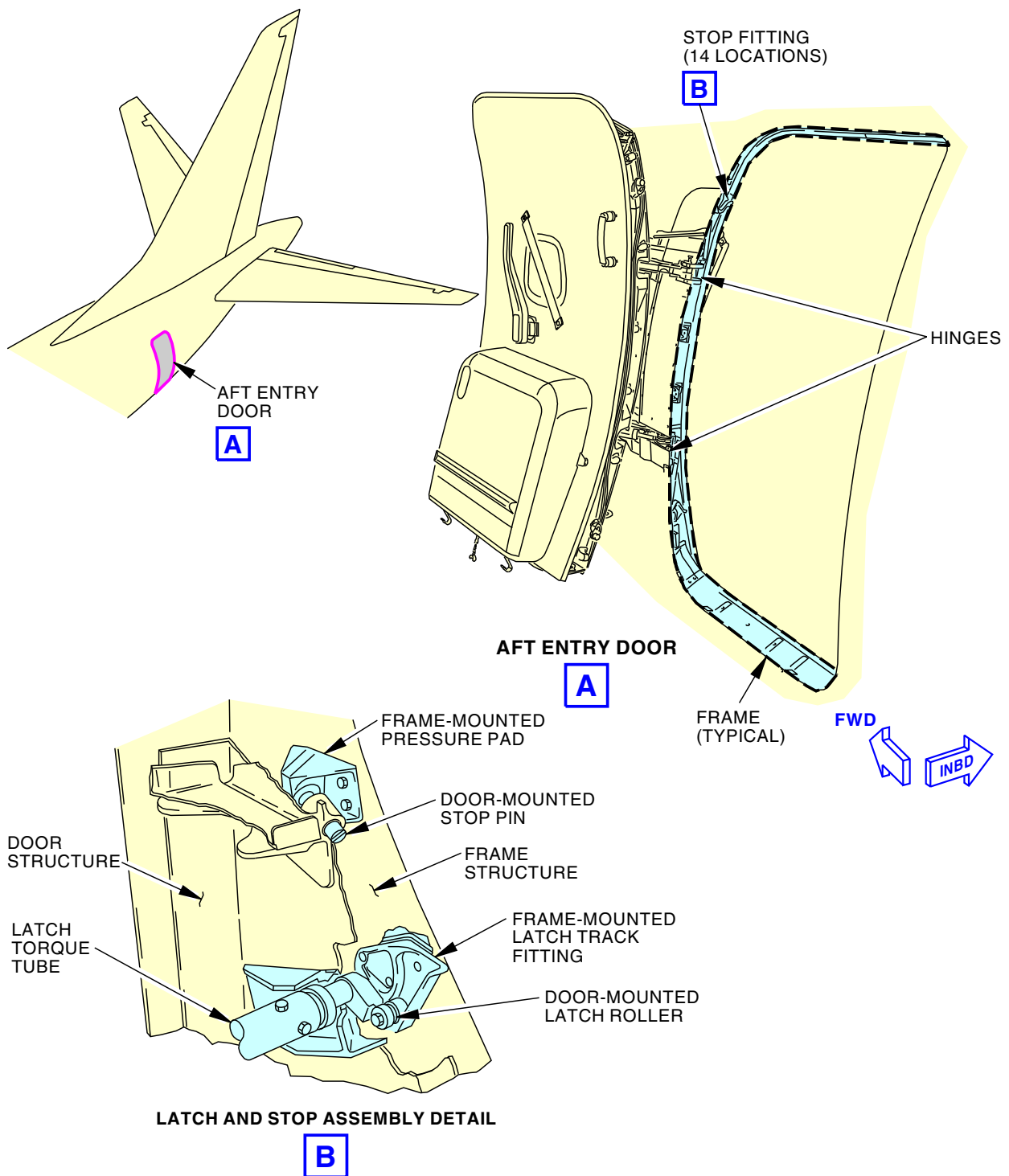
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416081 S00061539728_V1

AFT Entry Door Frame, Stops, Latches and Hinges
Figure 239/53-05-03-990-839

EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-808

35. **EXTERNAL - DETAILED: AFT GALLEY SERVICE DOOR FRAME, STOPS, LATCHES AND HINGES**
(Figure 240)

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
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

C. Access Panels

Number	Name/Location
844	Aft Galley Service Door

D. Inspection

SUBTASK 53-05-03-010-033

- (1) Open this access panel:

Number	Name/Location
844	Aft Galley Service Door

NOTE: Open aft galley door.

SUBTASK 53-05-03-211-008

- (2) Do a Detailed inspection of the door frames, stops, latches and hinges on aft galley door cutout surround structure.

SUBTASK 53-05-03-910-035

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

SUBTASK 53-05-03-410-030

- (4) Close this access panel:

Number	Name/Location
844	Aft Galley Service Door

————— **END OF TASK** —————

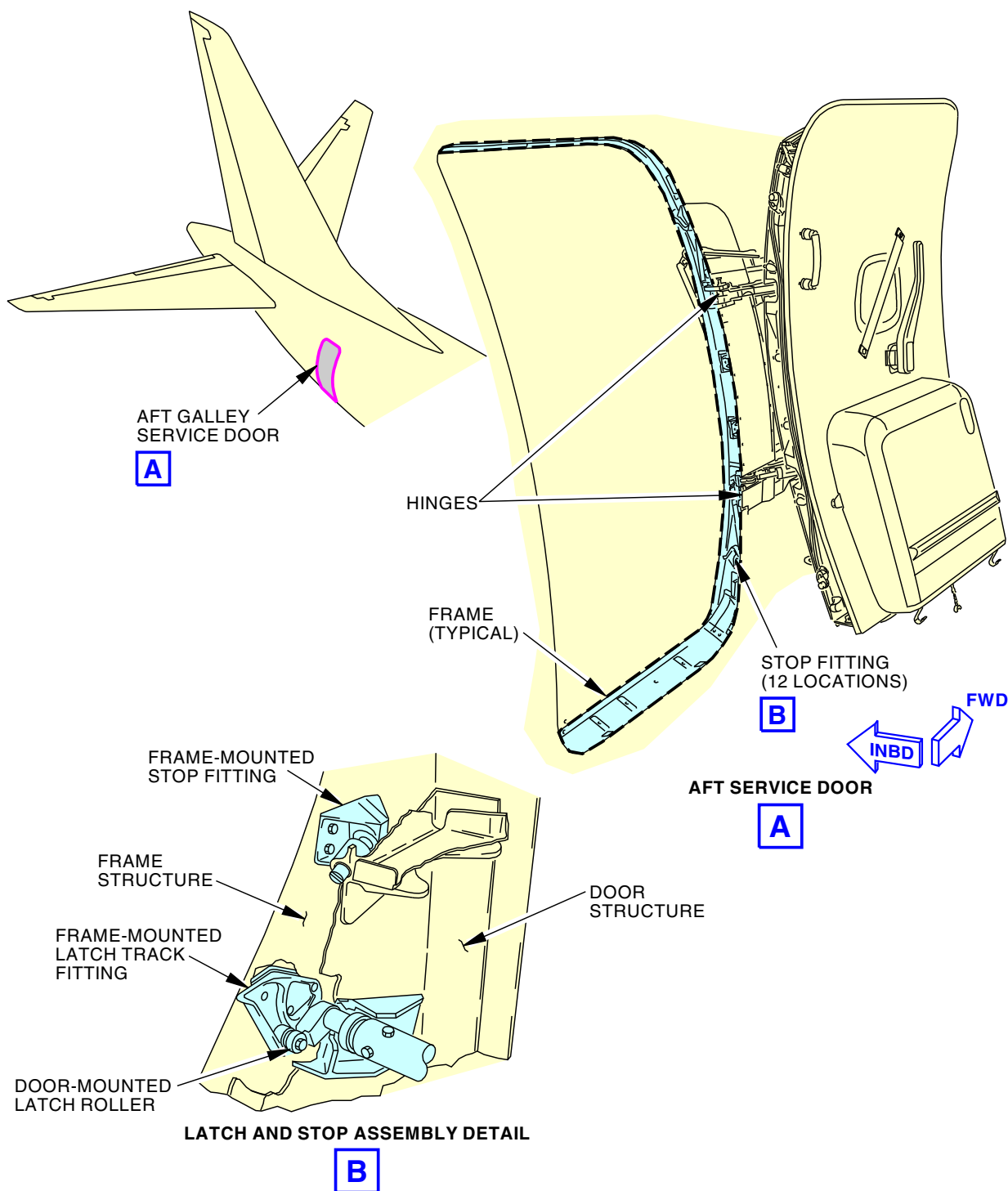
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416082 S00061539730_V1

Aft Galley Door Frame, Stop, Latches and Hinges
Figure 240/53-05-03-990-840

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-828

36. INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FROM STA 178 TO 270

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
211	Flight Compartment - Left
212	Flight Compartment - Right
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. Access Panels

Number	Name/Location
S2101	Flight Compartment Inspection

D. Inspection

SUBTASK 53-05-03-010-034

(1) Special Access:

Number	Name/Location
S2101	Flight Compartment Inspection

NOTE: Remove glare shield, liners, overhead units and panels as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-028

(2) Do a General Visual inspection of the flight compartment from Sta 178 to 270, including skin panels (skins, frames, stringers), circumferential skin and stringer splice, crew cabin window cutout structure, and structure adjacent to ground block behind rudder pedal. Inspection area does not include: Forward side of frame at STA 259.5 and structure 3 inches forward of STA 259.5; BL 0 + 4 inches (Left and Right); Forward and aft side of Frame 259.5 and structure from STA 249 to STA 263 between floor and S-5L (excluding window and window frame structure); Forward side of Frame 259.5 and structure 3 inches forward of STA 259.5 between floor and S-3R; Structure forward of STA 203.8 to STA 178 and from floor up to window frame (except structure adjacent to ground block behind rudder pedal); skin, frames and stringers above P5 panel.

SUBTASK 53-05-03-910-036

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

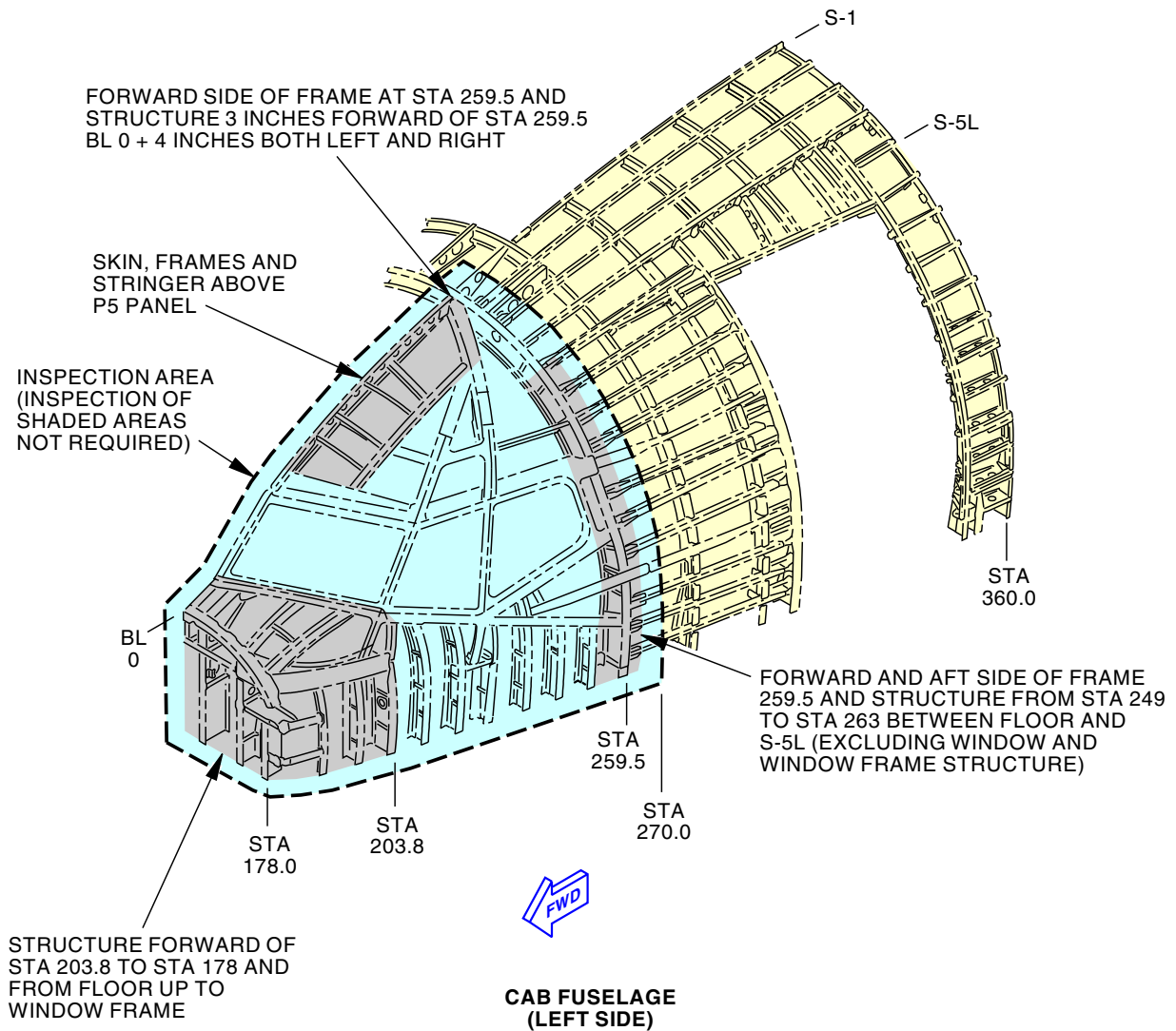
————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

53-05-03

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2416083 S00061539732_V1

FLIGHT COMPARTMENT FROM STA 178 TO 270
Figure 241/53-05-03-990-841 (Sheet 1 of 2)

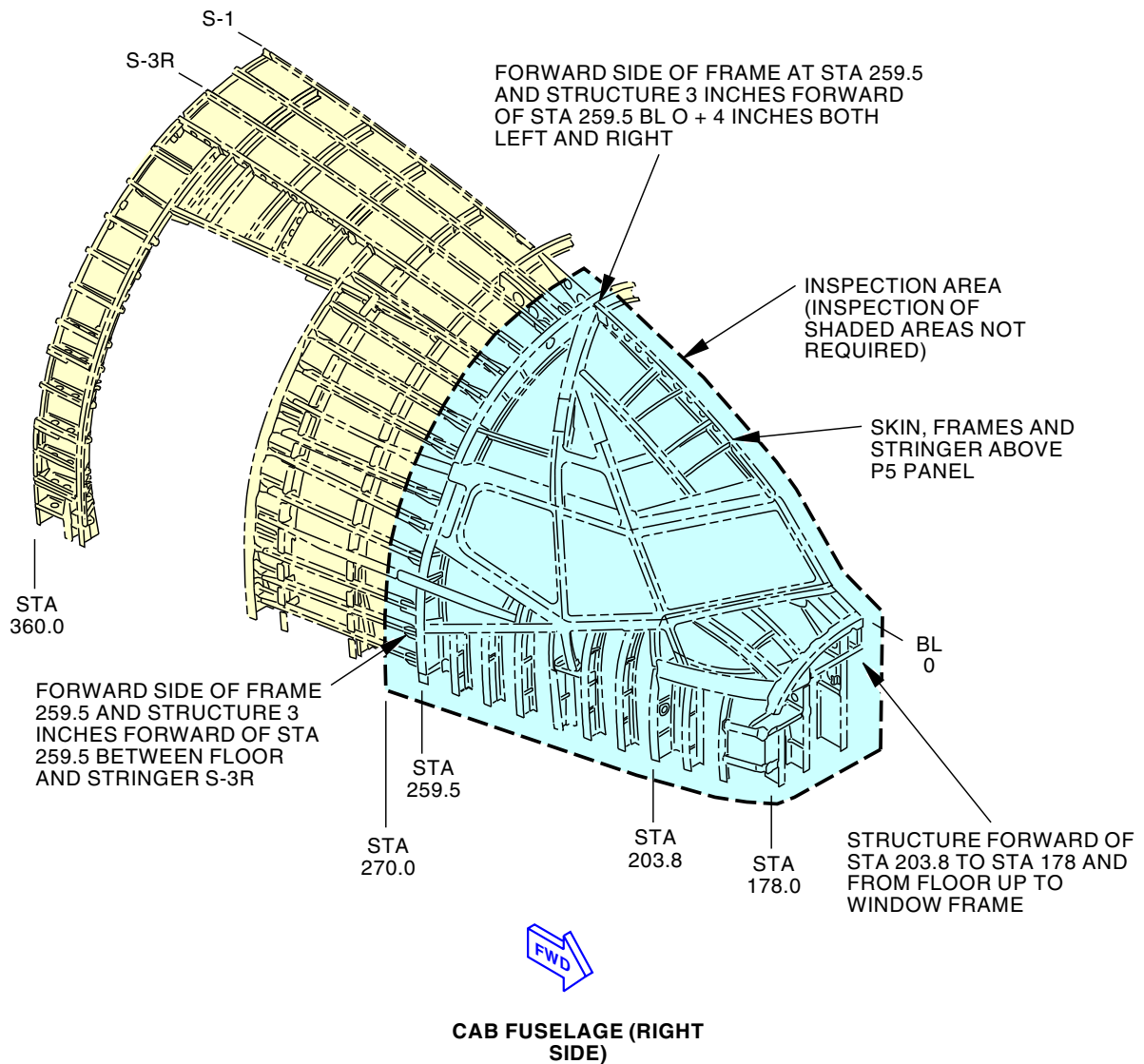
EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL



2416084 S00061539733_V2

FLIGHT COMPARTMENT FROM STA 178 TO 270
Figure 241/53-05-03-990-841 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-829

37. **INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FLOOR STRUCTURE**

(Figure 242)

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
211	Flight Compartment - Left
212	Flight Compartment - Right

C. Access Panels

Number	Name/Location
S1202	Forward Bilge Inspection

D. Inspection

SUBTASK 53-05-03-010-035

(1) Special Access:

<u>Number</u>	<u>Name/Location</u>
S1202	Forward Bilge Inspection

NOTE: Remove sidewalls and floor panels as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-029

(2) Do a General Visual inspection of the flight compartment floor structure.

SUBTASK 53-05-03-910-037

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

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

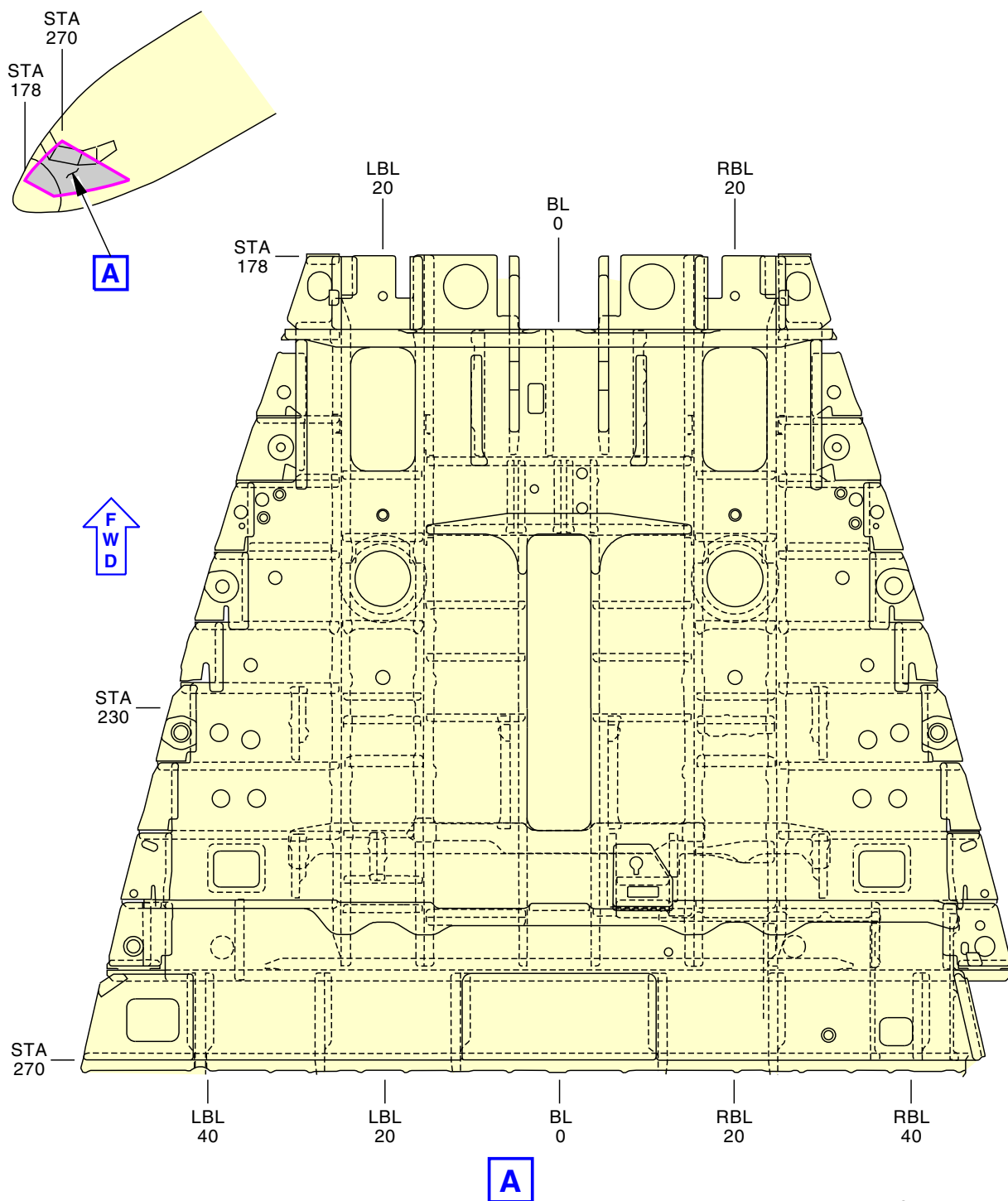
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2416085 S00061539735_V1

Flight Deck Floor Structure
Figure 242/53-05-03-990-842

EFFECTIVITY
SIA ALL

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TASK 53-05-03-210-830

38. **INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FROM STA 270 to 360**

(Figure 243)

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
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. Access Panels

Number	Name/Location
S2201	Passenger Compartment From STA 259.5 to 360

D. Inspection

SUBTASK 53-05-03-010-036

(1) Special Access:

Number	Name/Location
S2201	Passenger Compartment From STA 259.5 to 360

NOTE: Remove galleys/lavs. Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-030

(2) Do a General Visual inspection of the passenger compartment from Sta 270 to 360 (except areas around door cutouts), including skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices.

SUBTASK 53-05-03-910-038

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

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

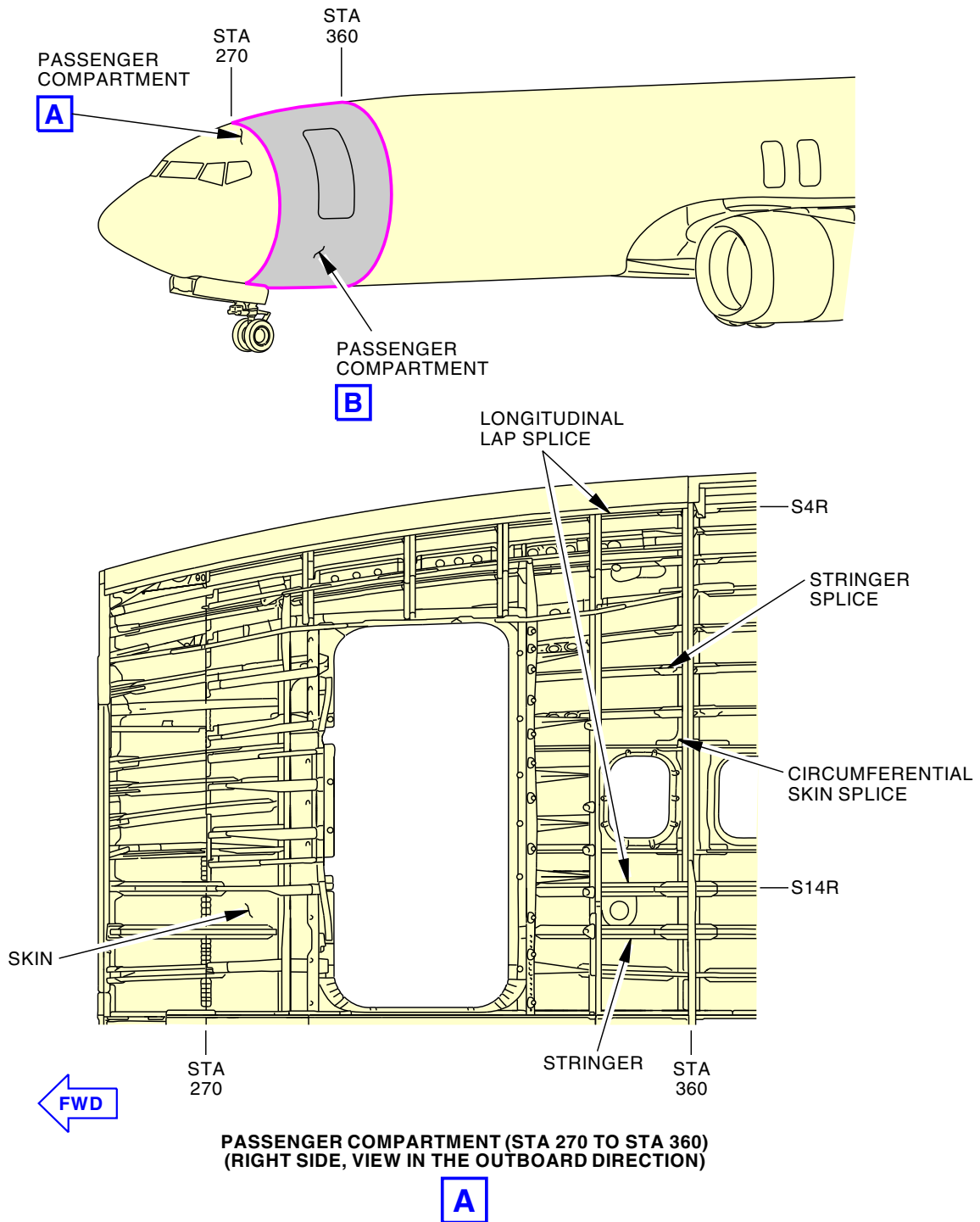
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AIRCRAFT MAINTENANCE MANUAL



2416087 S00061539738_V1

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FROM STA 270 TO STA 360
Figure 243/53-05-03-990-843 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

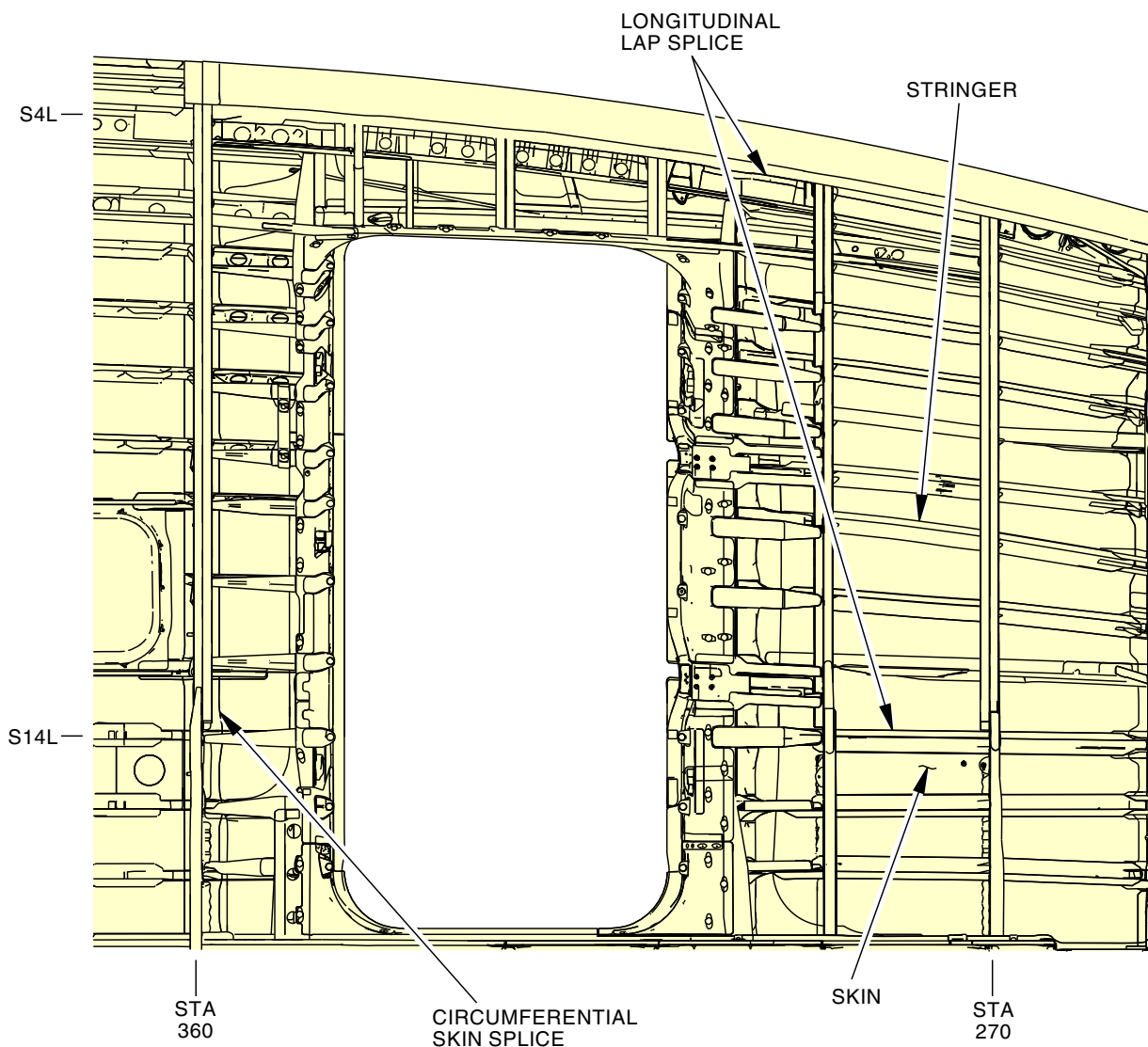
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AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT (STA 270 TO STA 360) (LEFT SIDE, VIEW IN THE OUTBOARD DIRECTION)



B

2416088 S00061539739_V1

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FROM STA 270 TO STA 360
Figure 243/53-05-03-990-843 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-809

39. INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS

(Figure 244)

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
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

C. Access Panels

Number	Name/Location
S2001	Passenger Compartment Door Cutouts Inspection

D. Inspection

SUBTASK 53-05-03-010-037

(1) Special Access:

Number	Name/Location
S2001	Passenger Compartment Door Cutouts Inspection

NOTE: Remove galleys/lavs. Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-009

(2) Do a Detailed inspection of the forward entry door cutout surround structure (the door cutout to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-039

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

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

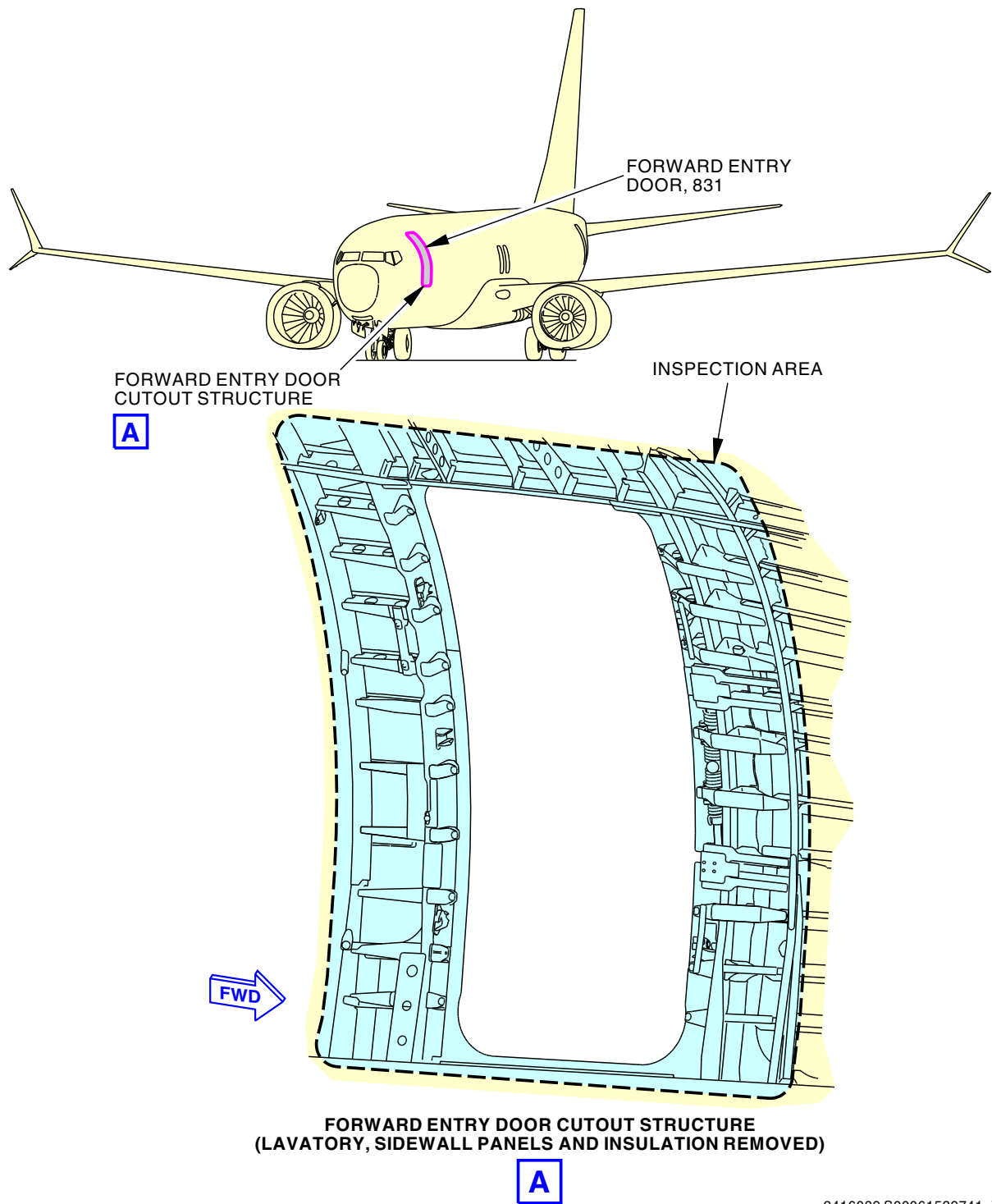
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AIRCRAFT MAINTENANCE MANUAL



2416089 S00061539741_V1

Forward Entry Door Cutout Surround Structure (Lavatory, Sidewall Panels And Insulation Removed)
Figure 244/53-05-03-990-844

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-810

40. **INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS**

Figure 245

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
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

C. Access Panels

Number	Name/Location
222AR	Forward Galley Service Door Hinge and Torque Tube Access Panel
S2001	Passenger Compartment Door Cutouts Inspection

D. Inspection

SUBTASK 53-05-03-010-038

- (1) Open this access panel:

Number	Name/Location
222AR	Forward Galley Service Door Hinge and Torque Tube Access Panel

Special Access:

Number	Name/Location
S2001	Passenger Compartment Door Cutouts Inspection

NOTE: Remove galleys/lavs. Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-010

- (2) Do a Detailed inspection of the forward galley door cutout surround structure (the door cutout to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-040

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

SUBTASK 53-05-03-410-031

- (4) Close this access panel:

Number	Name/Location
222AR	Forward Galley Service Door Hinge and Torque Tube Access Panel

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

53-05-03

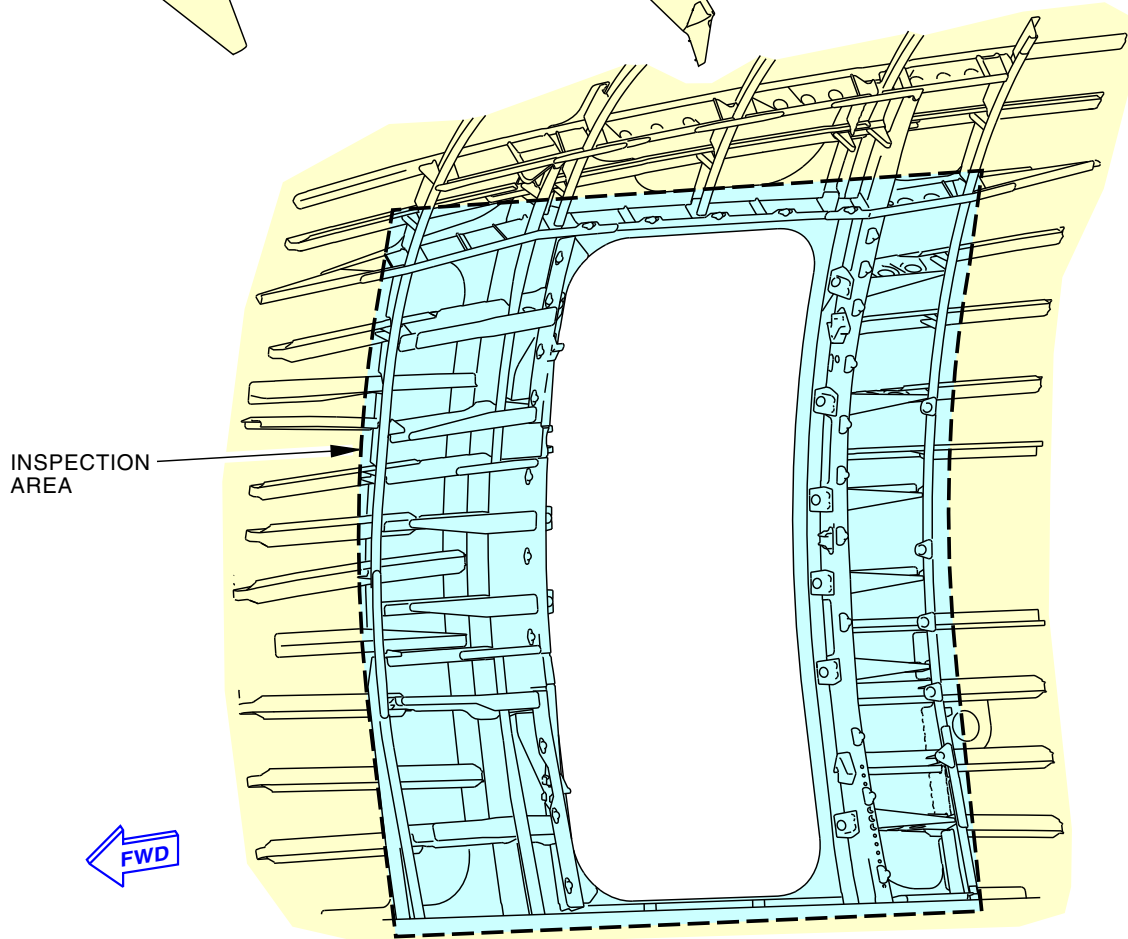
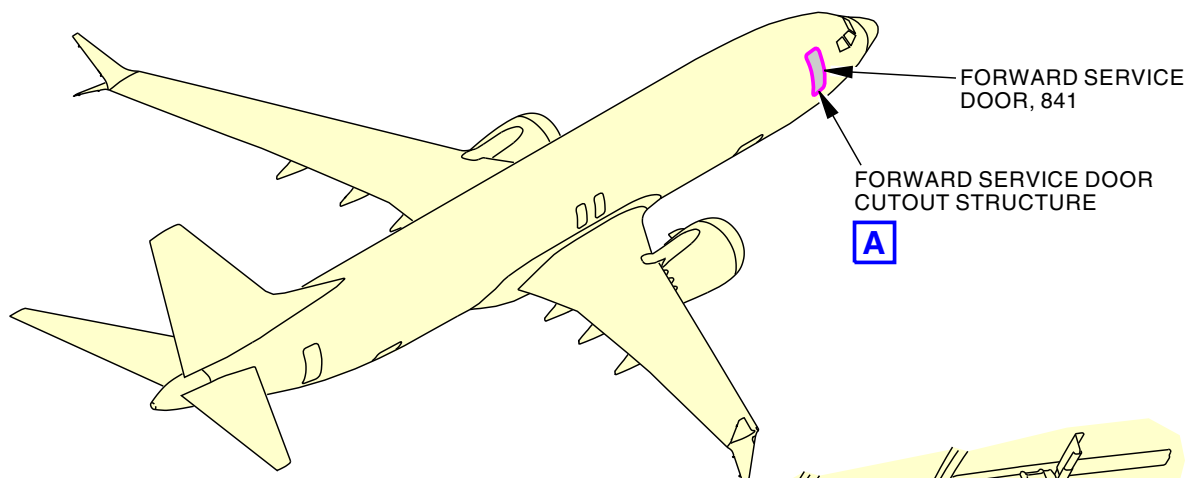
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AIRCRAFT MAINTENANCE MANUAL



FORWARD SERVICE DOOR CUTOUT STRUCTURE
(GALLEY, SIDEWALL PANELS AND INSULATION REMOVED)

A

2416090 S00061539743_V1

Forward Galley Service Door Cutout Surround Structure (Galley, Sidewall Panels and Insulation Removed)

Figure 245/53-05-03-990-845

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-811

41. INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS

(Figure 246)

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
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

C. Access Panels

Number	Name/Location
S2001	Passenger Compartment Door Cutouts Inspection

D. Inspection

SUBTASK 53-05-03-010-039

(1) Special Access:

Number	Name/Location
S2001	Passenger Compartment Door Cutouts Inspection

NOTE: Remove galleys/lavs. Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-011

(2) Do a Detailed inspection of the aft entry door cutout surround structure (the door cutout to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-041

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

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

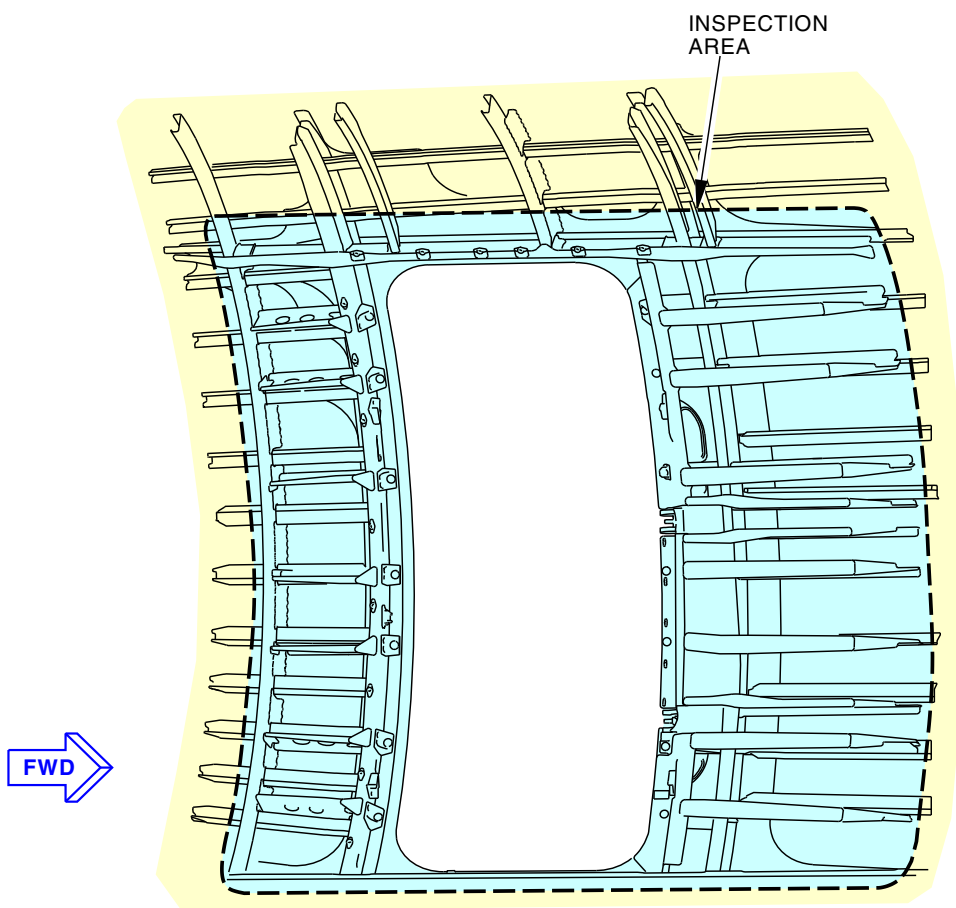
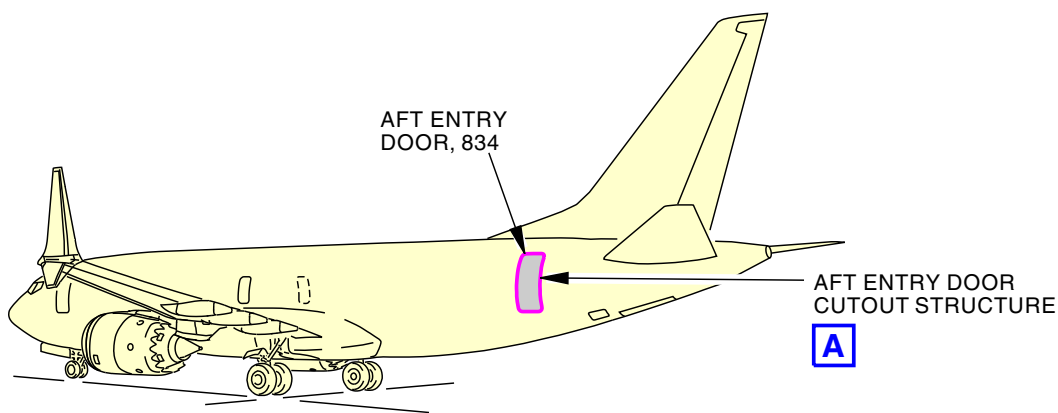
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AIRCRAFT MAINTENANCE MANUAL



AFT ENTRY DOOR CUTOUT STRUCTURE
(LAVATORY, SIDEWALL PANELS AND INSULATION REMOVED)

A

2416091 S00061539745_V1

Passenger Compartment Door Cutouts
Figure 246/53-05-03-990-846

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-211-812

42. INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS

(Figure 247)

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
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

C. Access Panels

Number	Name/Location
S2001	Passenger Compartment Door Cutouts Inspection

D. Inspection

SUBTASK 53-05-03-010-040

- (1) Special Access:

Number	Name/Location
S2001	Passenger Compartment Door Cutouts Inspection

NOTE: Remove galleys/lavs. Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-012

- (2) Do a Detailed inspection of the aft galley door cutout surround structure (the door cutout to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-042

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

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

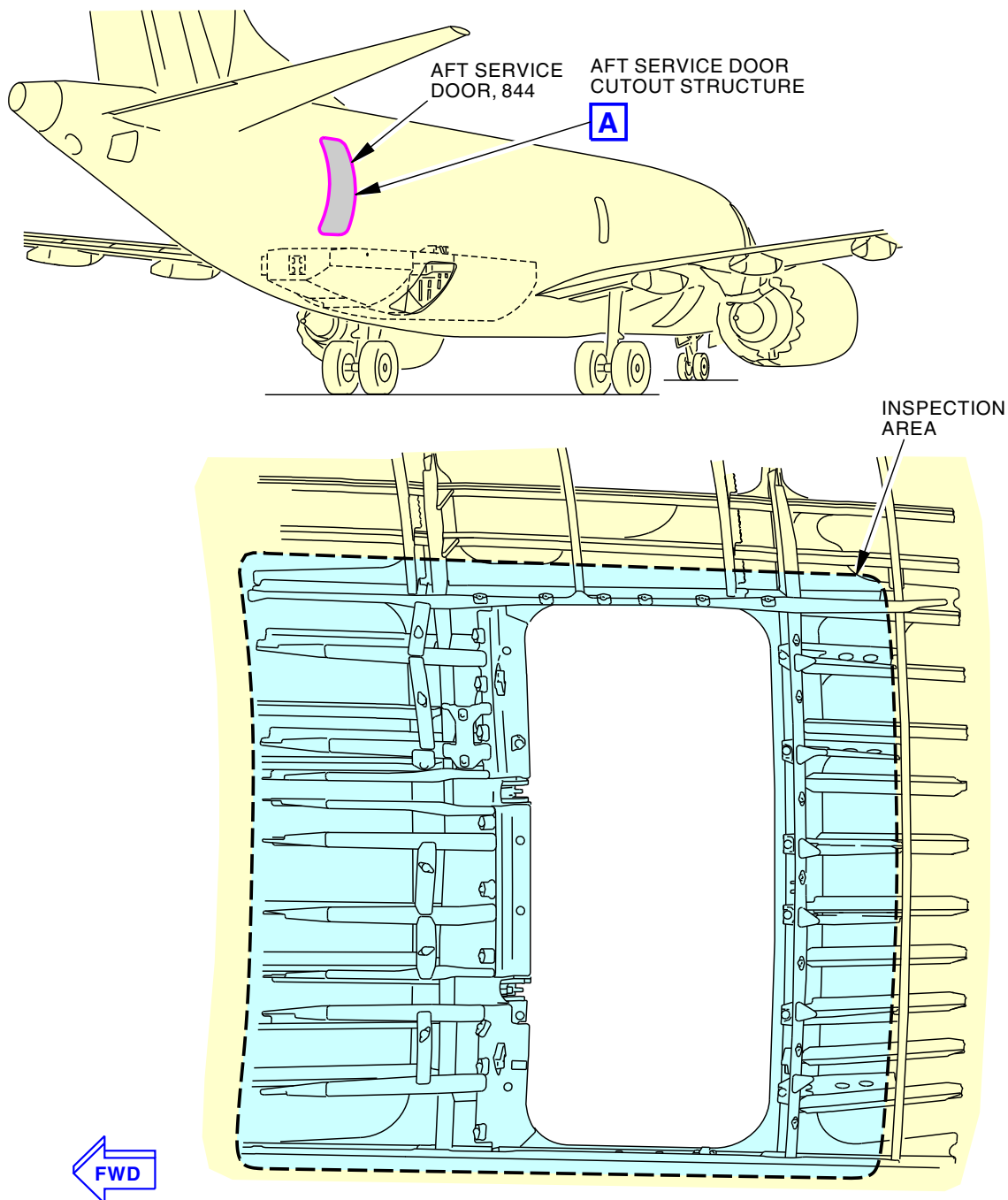
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53-05-03

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AIRCRAFT MAINTENANCE MANUAL



AFT SERVICE DOOR CUTOUT STRUCTURE
(GALLEY, SIDEWALL PANELS AND INSULATION REMOVED)

A

2416092 S00061539747_V1

Passenger Compartment Door Cutouts
Figure 247/53-05-03-990-847

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-831

43. **INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - DRY AREA**
(Figure 248)

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
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

C. Access Panels

Number	Name/Location
S2002	Passenger Compartment Floor Structure - Dry Area Inspection

D. Inspection

SUBTASK 53-05-03-010-041

(1) Special Access:

Number	Name/Location
S2002	Passenger Compartment Floor Structure - Dry Area Inspection

NOTE: Remove floor panels and sidewalls as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-031

(2) Do a General Visual inspection of the passenger compartment floor structure in dry area (away from doors, galleys and lavs). Exclude floor structure from Sta 540 to 727.

SUBTASK 53-05-03-910-043

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

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

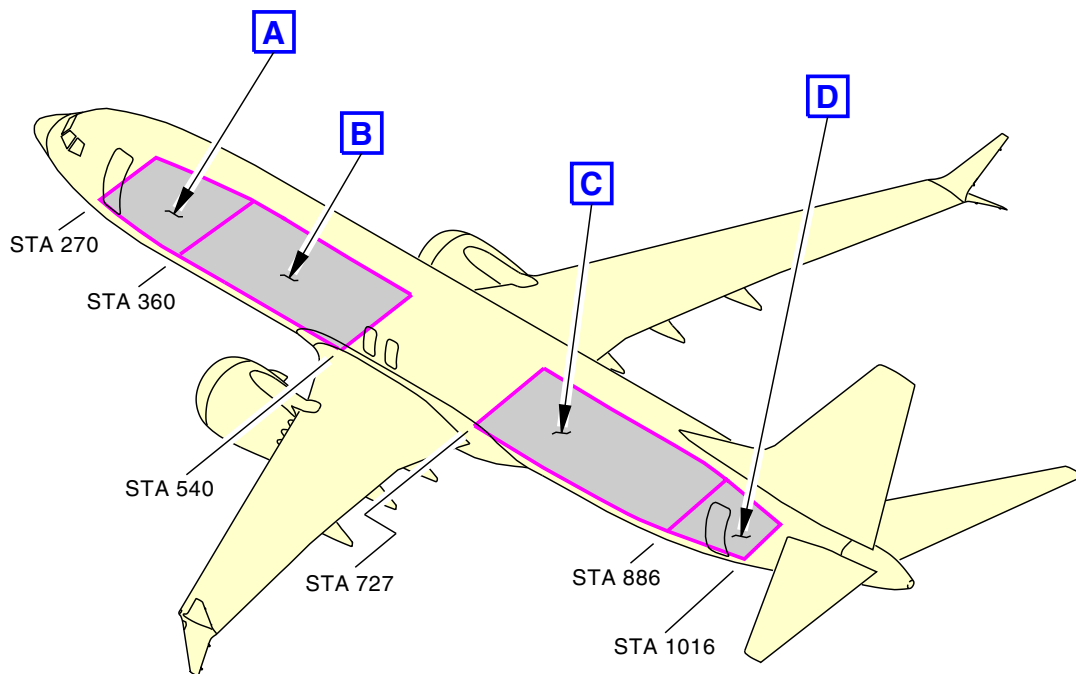
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AIRCRAFT MAINTENANCE MANUAL



2416093 S00061539749_V1

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE-DRY AREA
Figure 248/53-05-03-990-848 (Sheet 1 of 5)

EFFECTIVITY
SIA ALL

D633AM101-SIA

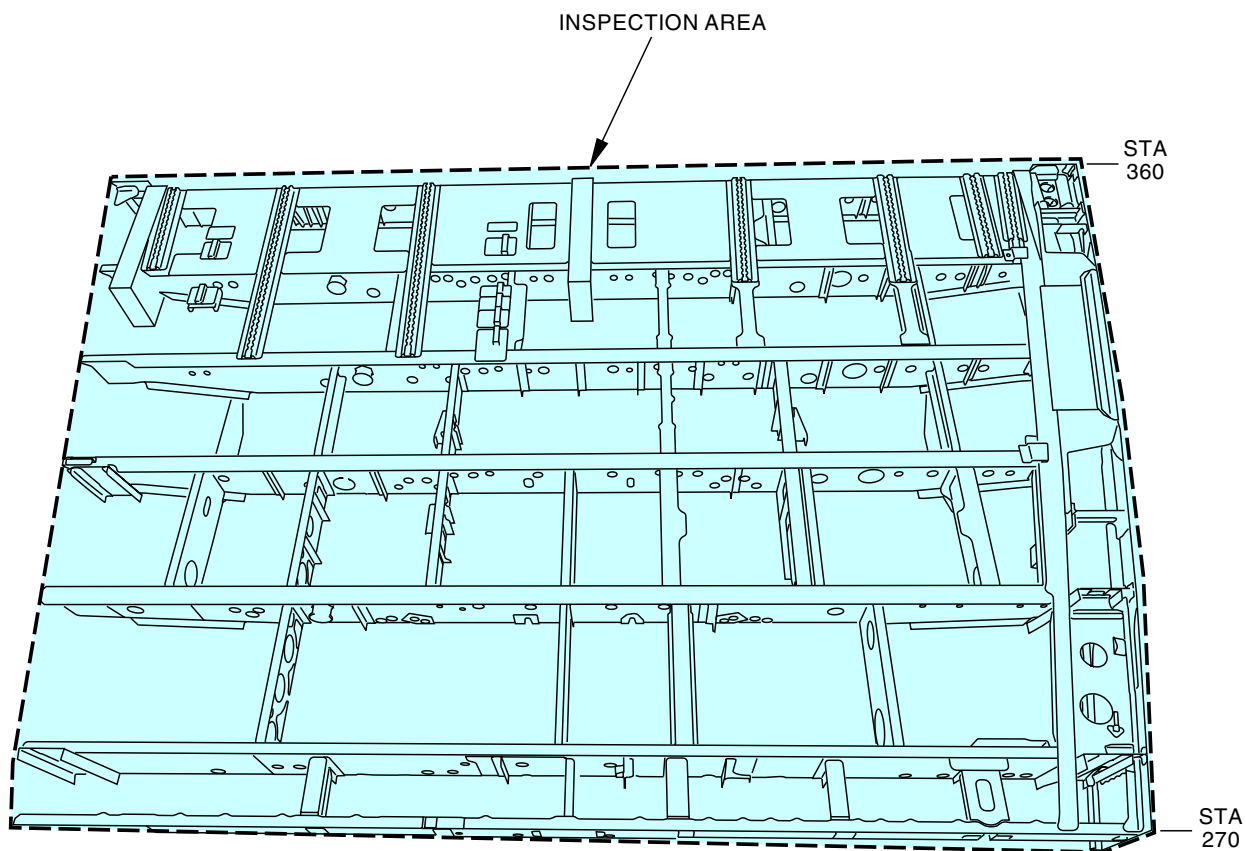
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AIRCRAFT MAINTENANCE MANUAL



A

2416094 S00061539750_V1

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE-DRY AREA
Figure 248/53-05-03-990-848 (Sheet 2 of 5)

EFFECTIVITY
SIA ALL

D633AM101-SIA

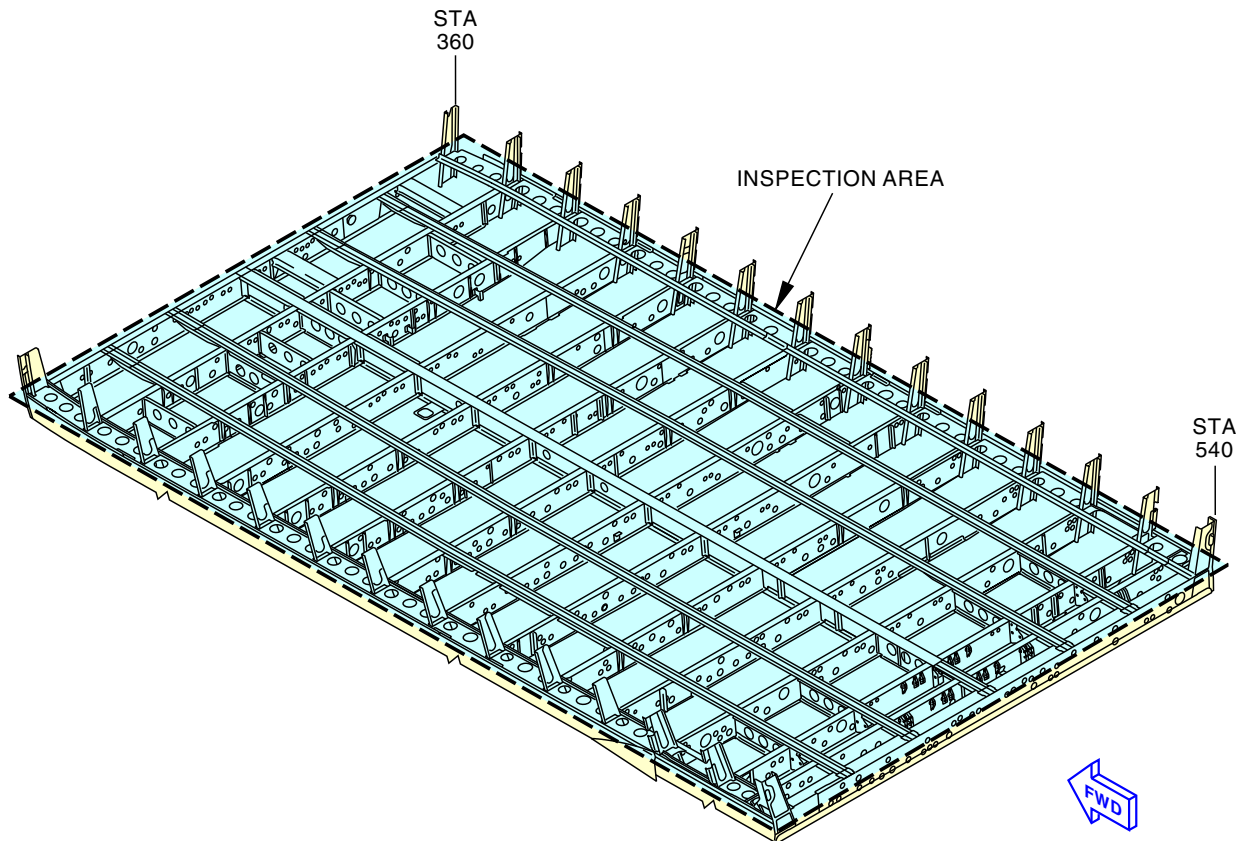
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AIRCRAFT MAINTENANCE MANUAL



B

MPD ITEM
53-370-00

2416095 S00061539751_V1

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE-DRY AREA
Figure 248/53-05-03-990-848 (Sheet 3 of 5)

EFFECTIVITY
SIA ALL

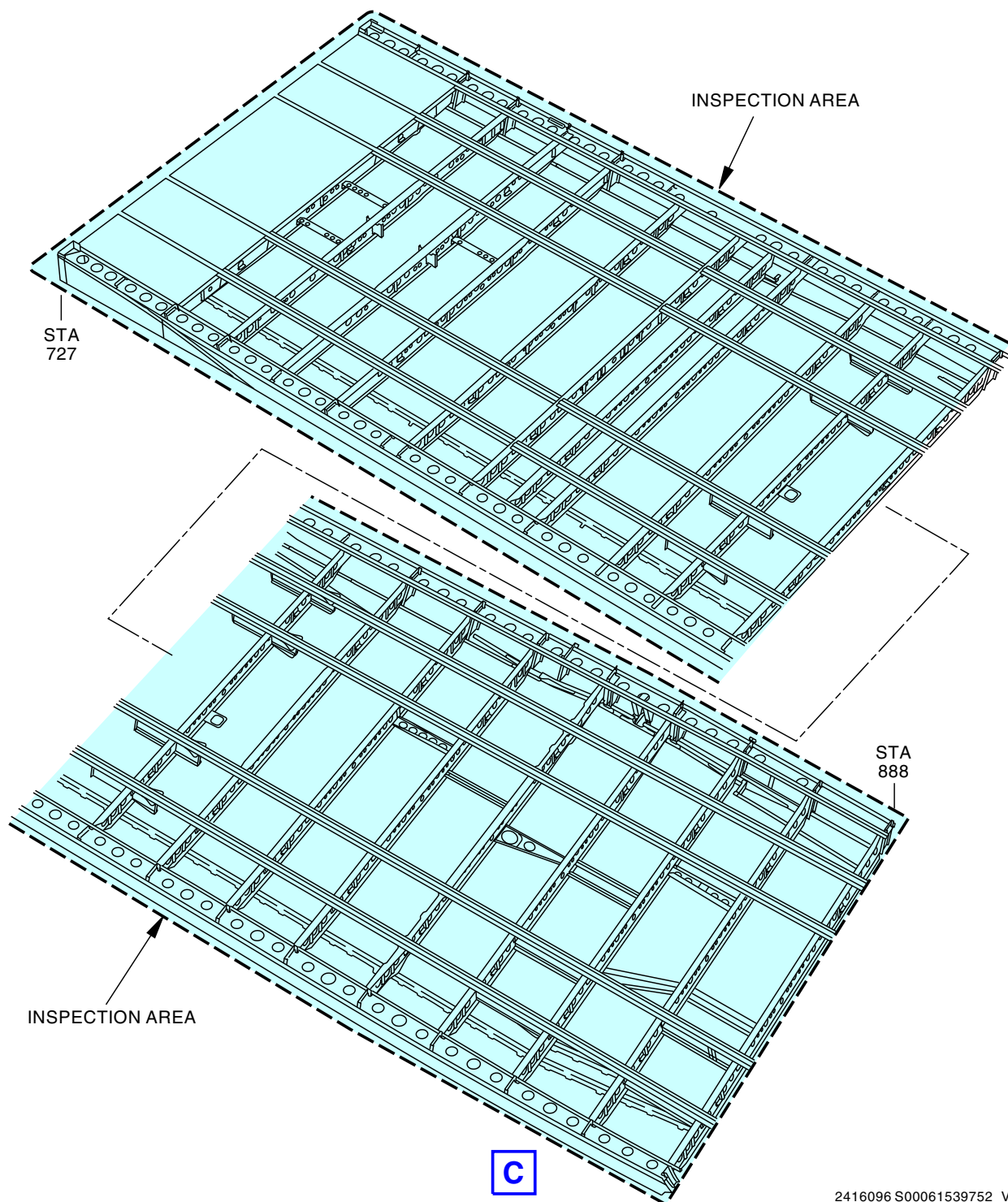
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AIRCRAFT MAINTENANCE MANUAL



2416096 S00061539752_V1

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE-DRY AREA
Figure 248/53-05-03-990-848 (Sheet 4 of 5)

EFFECTIVITY
SIA ALL

D633AM101-SIA

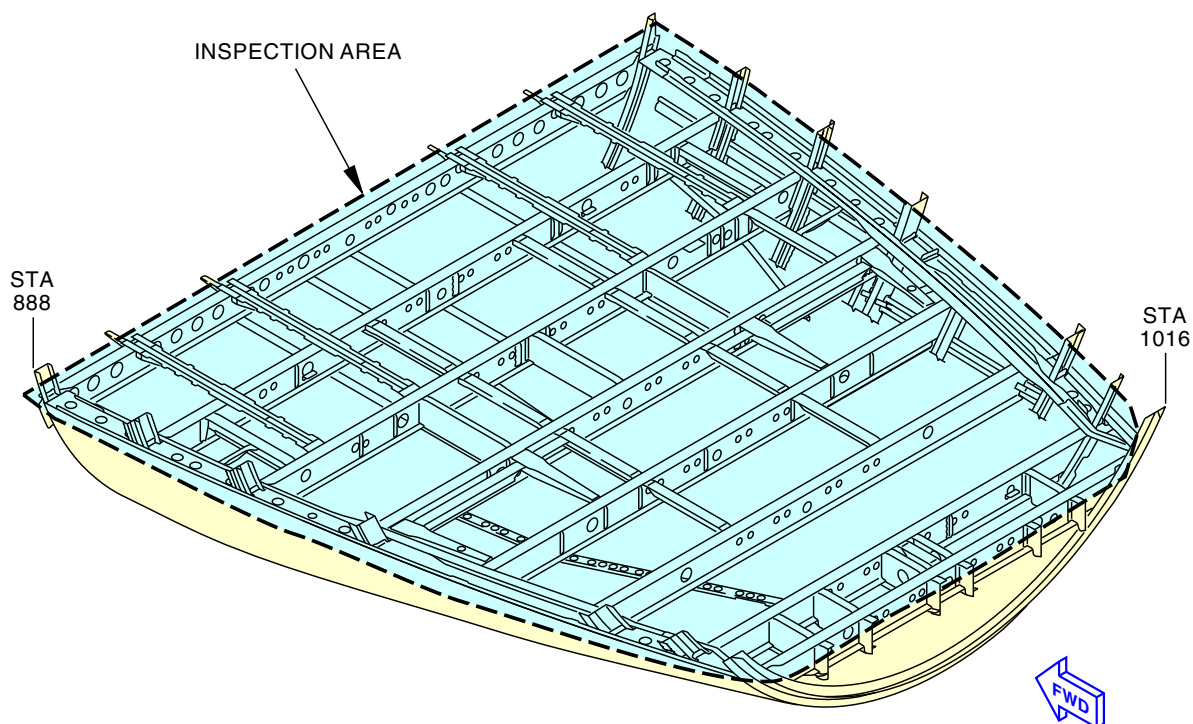
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D

2416097 S00061539753_V1

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE-DRY AREA
Figure 248/53-05-03-990-848 (Sheet 5 of 5)

EFFECTIVITY
SIA ALL

D633AM101-SIA

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-832

44. **INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - WET AREA**
(Figure 249, Figure 250)

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
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

C. Access Panels

Number	Name/Location
S2003	Passenger Compartment Floor Structure - Wet Area Inspection

D. Inspection

SUBTASK 53-05-03-010-042

(1) Special Access:

Number	Name/Location
S2003	Passenger Compartment Floor Structure - Wet Area Inspection

NOTE: Remove galleys and lavs. Remove floor panels and sidewalls as required.
Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-032

- (2) Do a General Visual inspection of the passenger compartment floor structure in wet area (within approximately 20 inches from doors, galleys and lavs, and the floor structure below the door to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-044

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

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

53-05-03

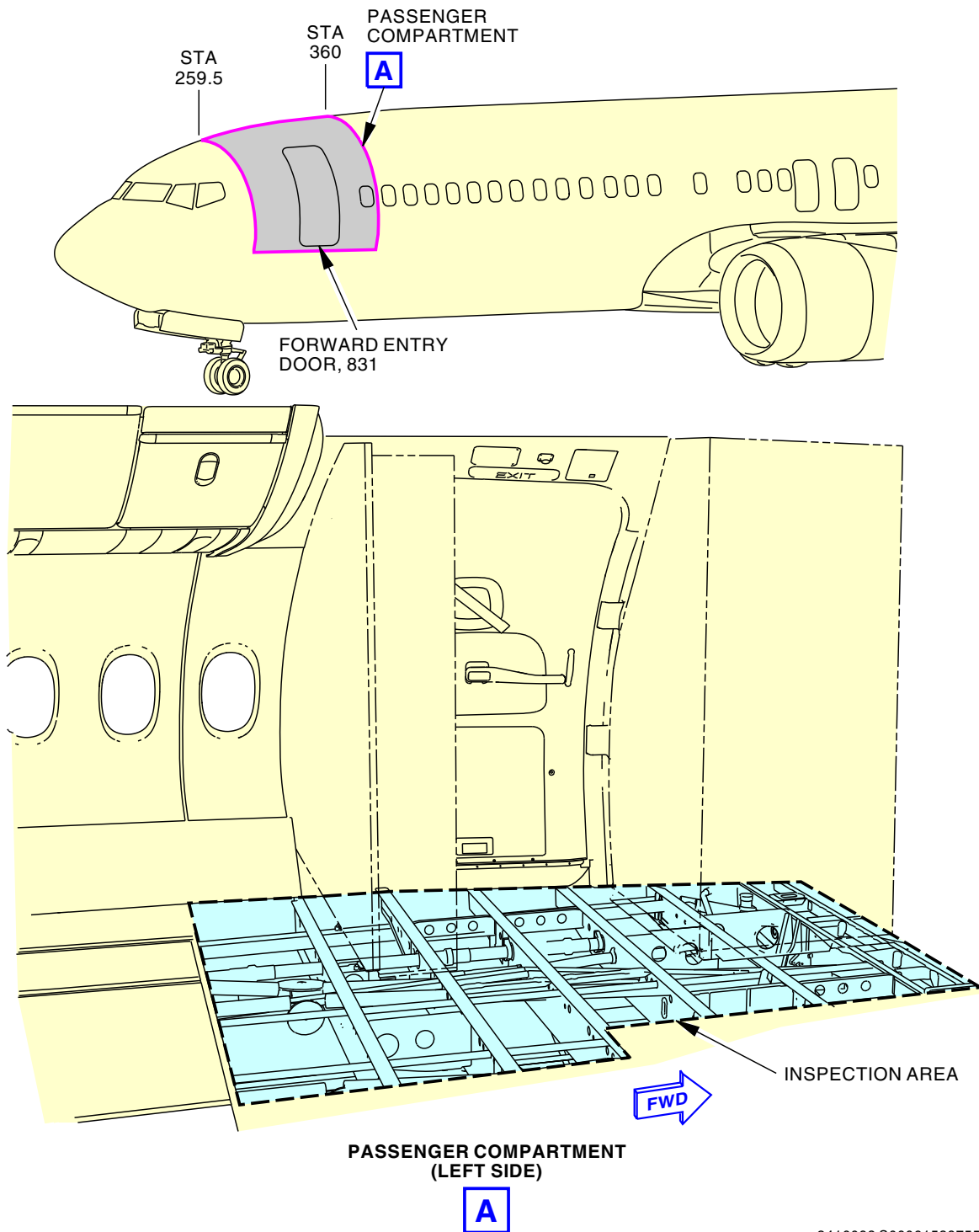
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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



2416098 S00061539755_V2

Passenger Compartment Structure - Wet Area General Visual (Internal)
Figure 249/53-05-03-990-849 (Sheet 1 of 2)

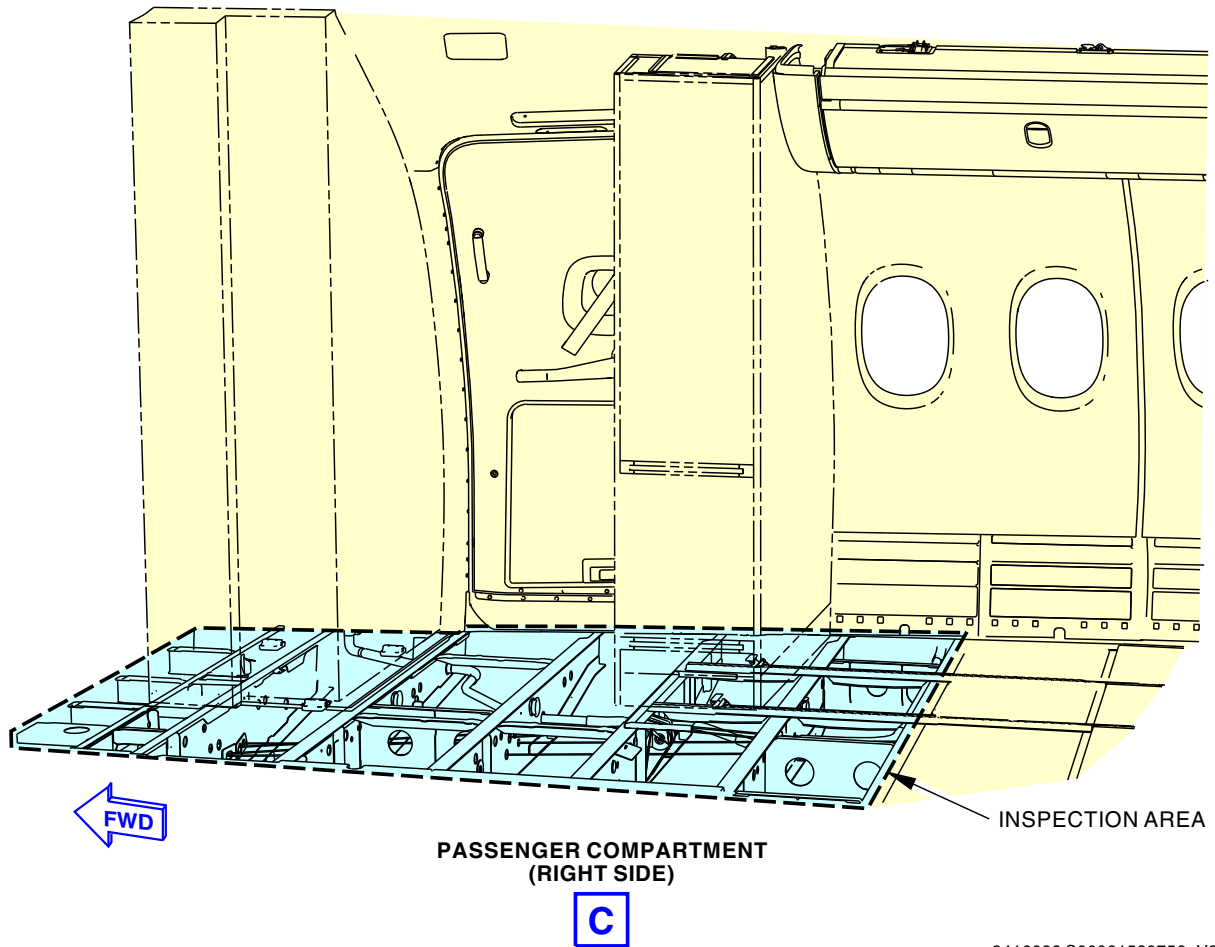
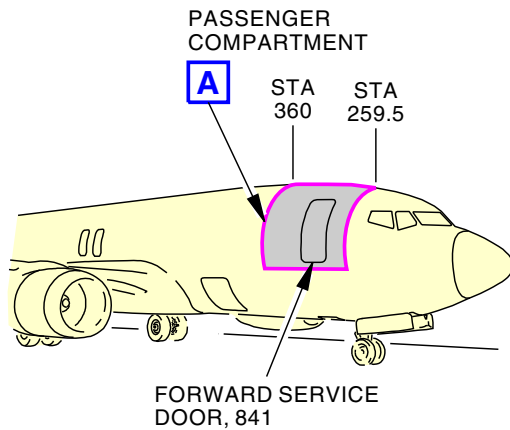
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416099 S00061539756_V2

Passenger Compartment Structure - Wet Area General Visual (Internal)
Figure 249/53-05-03-990-849 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

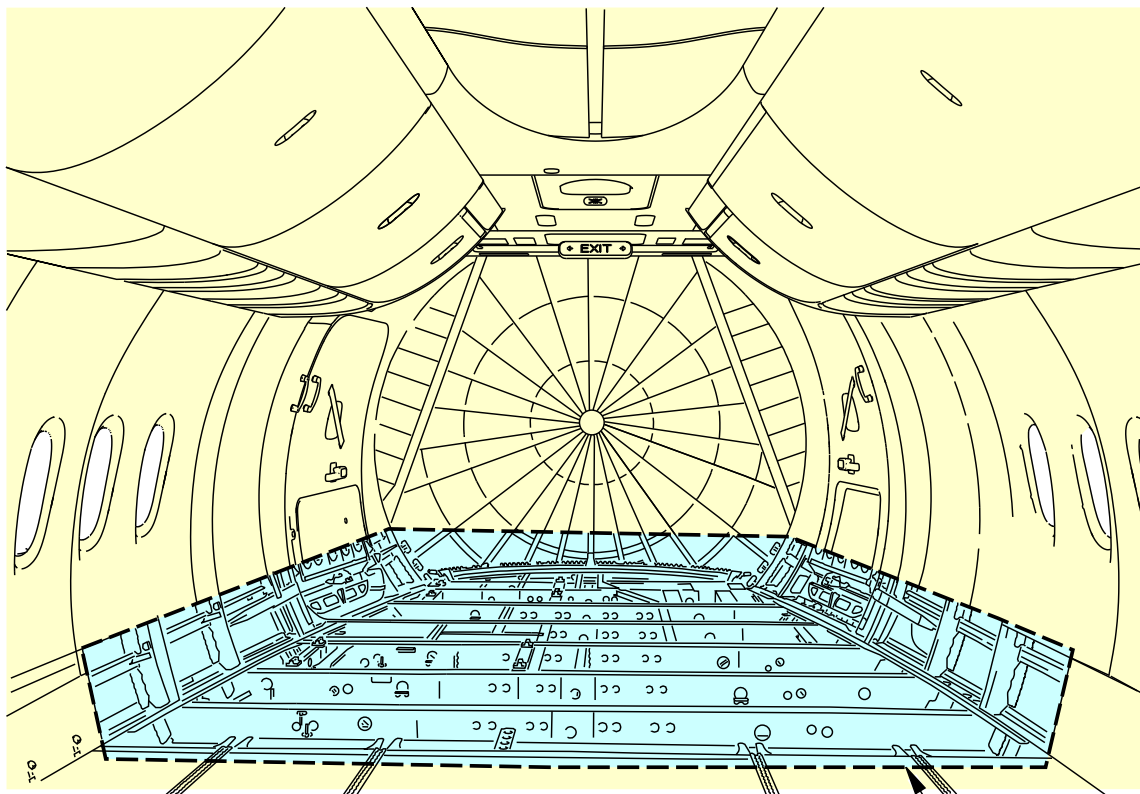
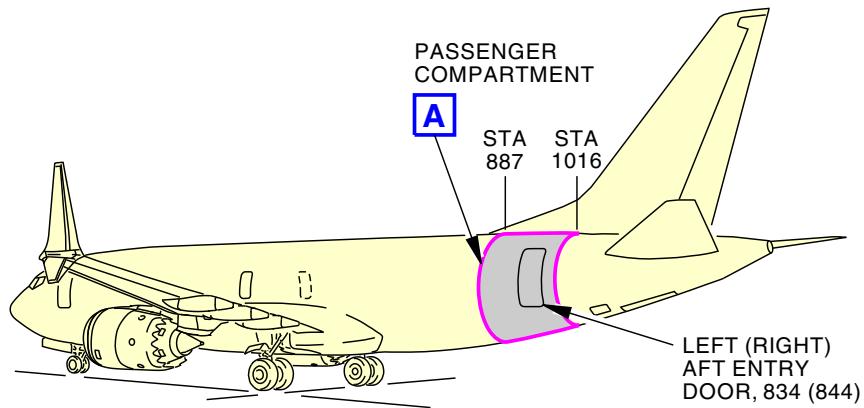
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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT
(STA 887 to STA 1016)

INSPECTION AREA
(WET AREAS ONLY)



2416100 S00061539757_V2

Passenger Compartment Structure - Wet Area General Visual (Internal)
Figure 250/53-05-03-990-850 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

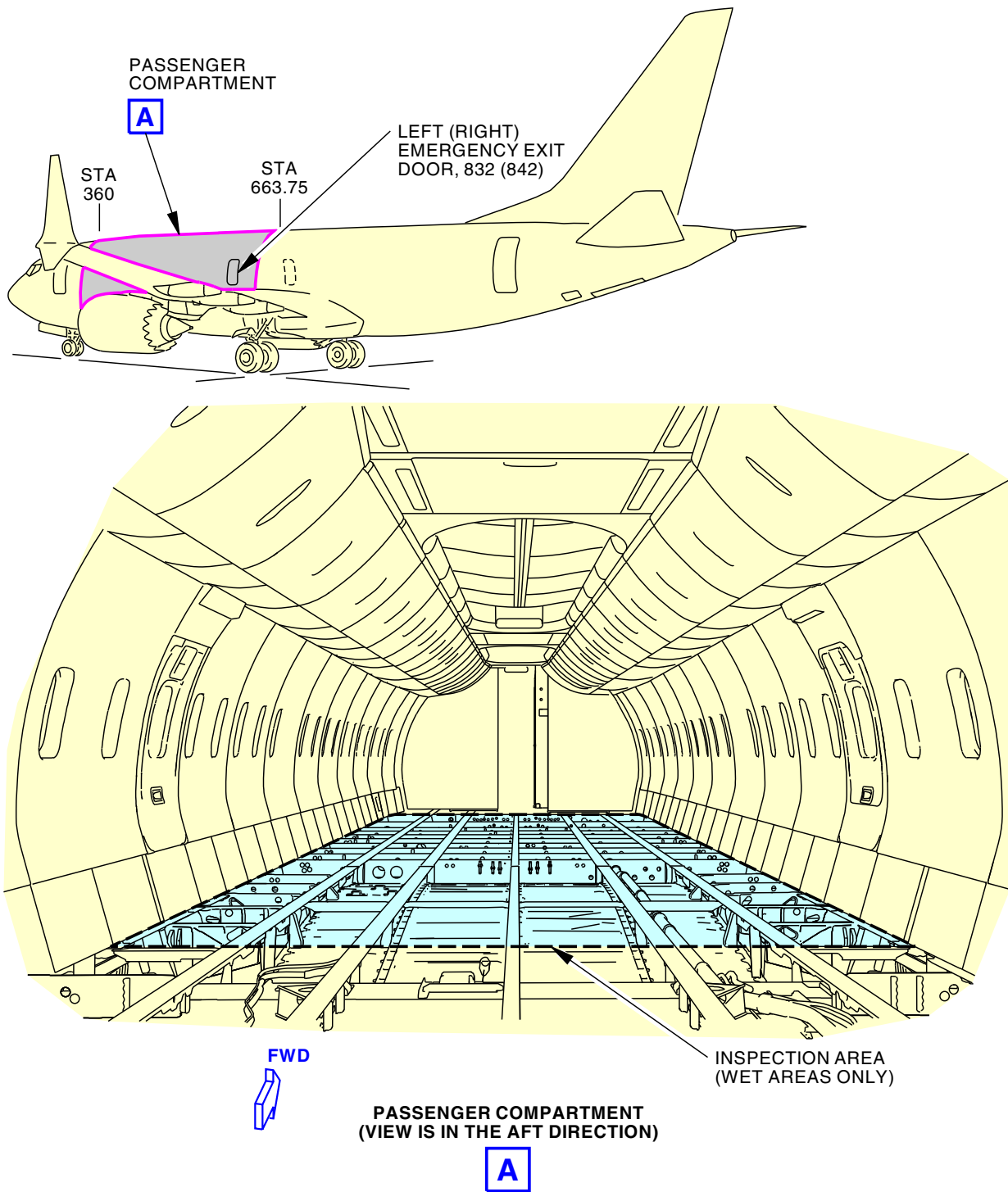
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2416101 S00061539758_V2

Passenger Compartment Structure - Wet Area General Visual (Internal)
Figure 250/53-05-03-990-850 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

53-05-03

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-833

45. **INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - WET AREA**
(Figure 251)

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
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

C. Access Panels

Number	Name/Location
S2004	Passenger Compartment Floor Structure - Wet Area Inspection

D. Inspection

SUBTASK 53-05-03-010-043

(1) Special Access:

Number **Name/Location**

S2004 Passenger Compartment Floor Structure - Wet Area Inspection

NOTE: Galleys and lavs removal is not required. Remove galley kick-plates and any other easily removable panels that may help inspect areas under galleys and lavs.

SUBTASK 53-05-03-210-033

- (2) Do a General Visual inspection of the galley and lav attach fittings and any other easily visible portions of the floor structure in wet area (within approximately 20 inches from galleys and lavs, and the floor structure below the door to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-045

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

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

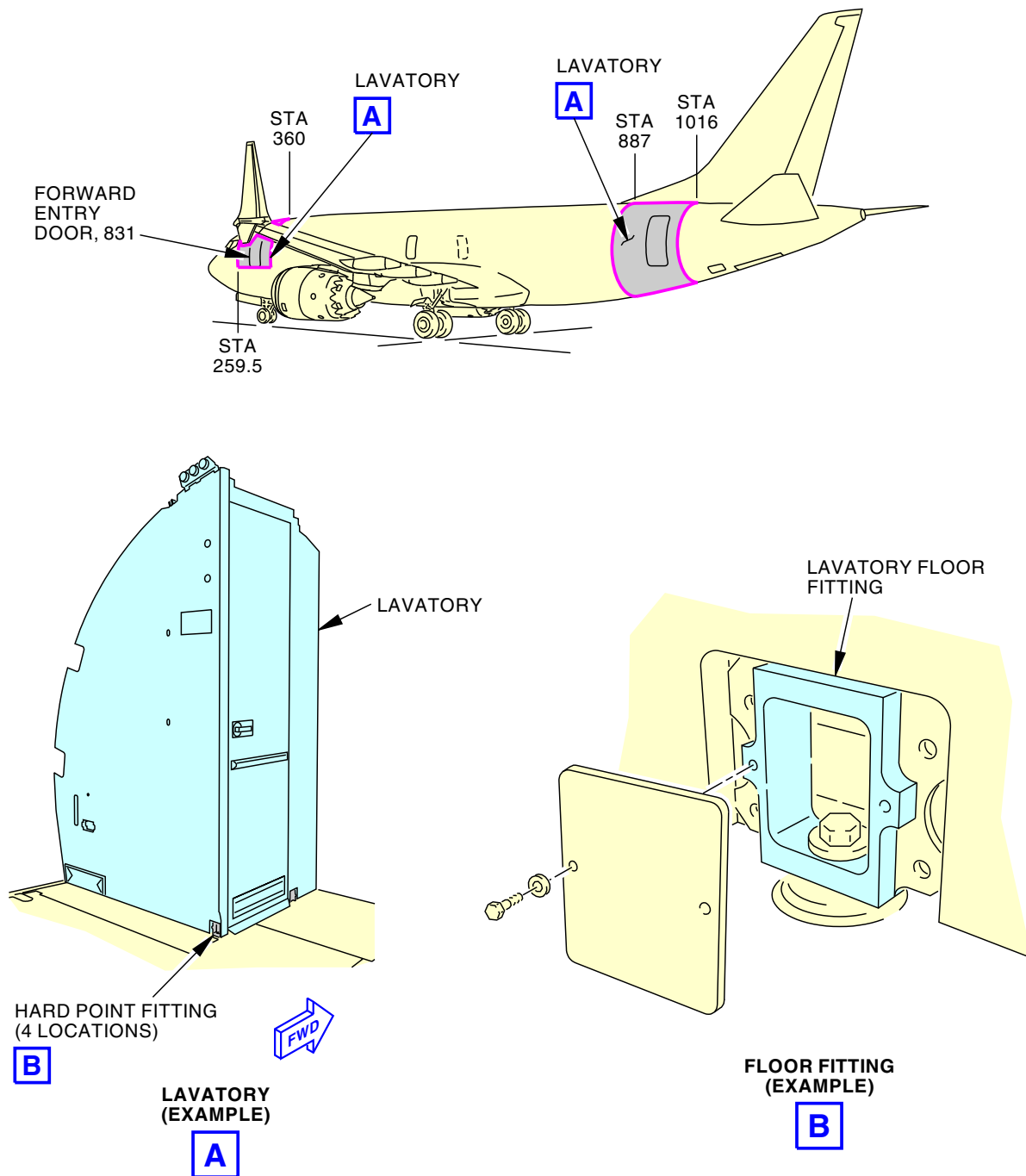
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416102 S00061539760_V1

Passenger Compartment Floor Structure - Wet Area
Figure 251/53-05-03-990-851 (Sheet 1 of 3)

EFFECTIVITY
SIA ALL

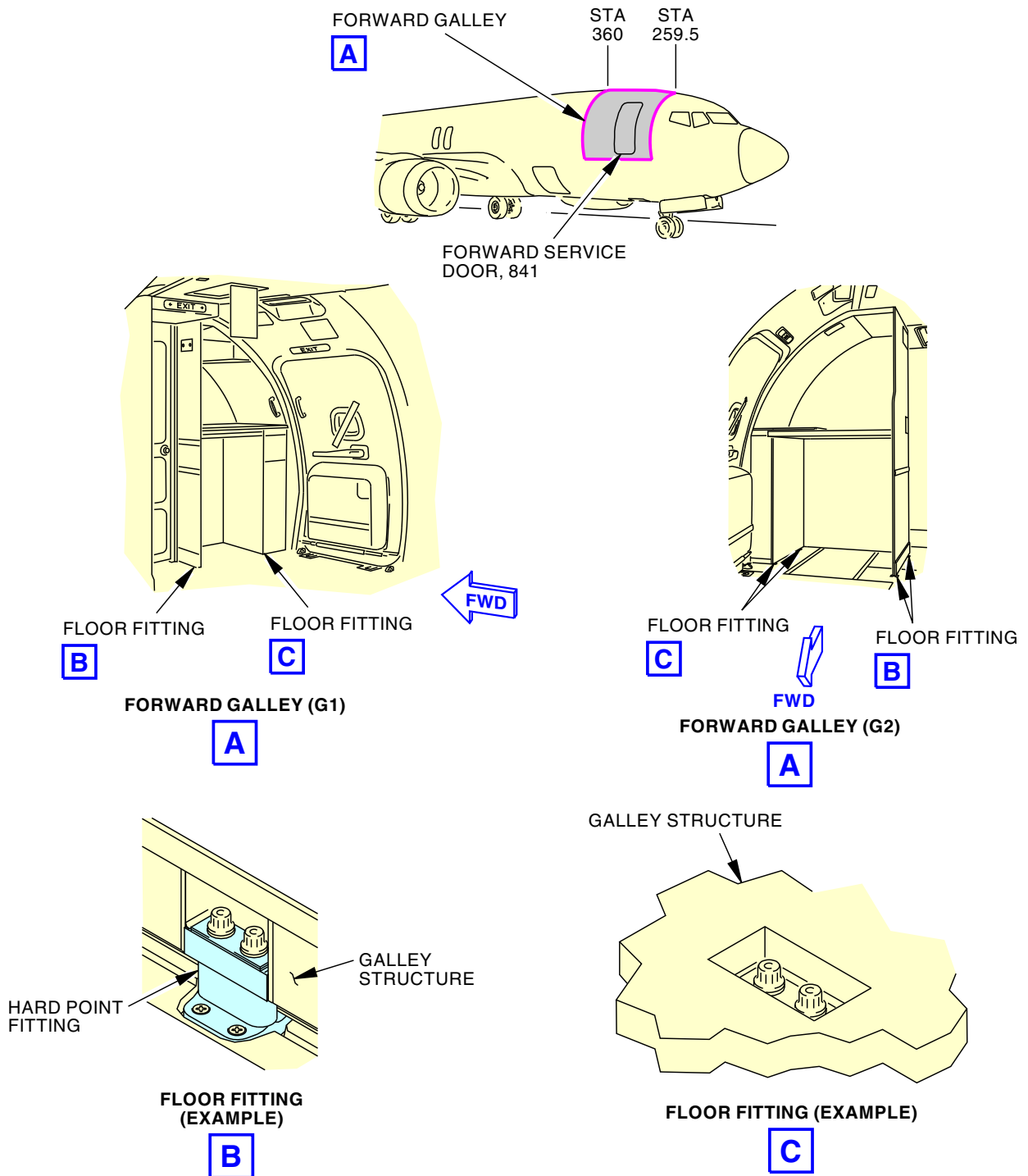
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



2416103 S00061539761_V1

Passenger Compartment Floor Structure - Wet Area
Figure 251/53-05-03-990-851 (Sheet 2 of 3)

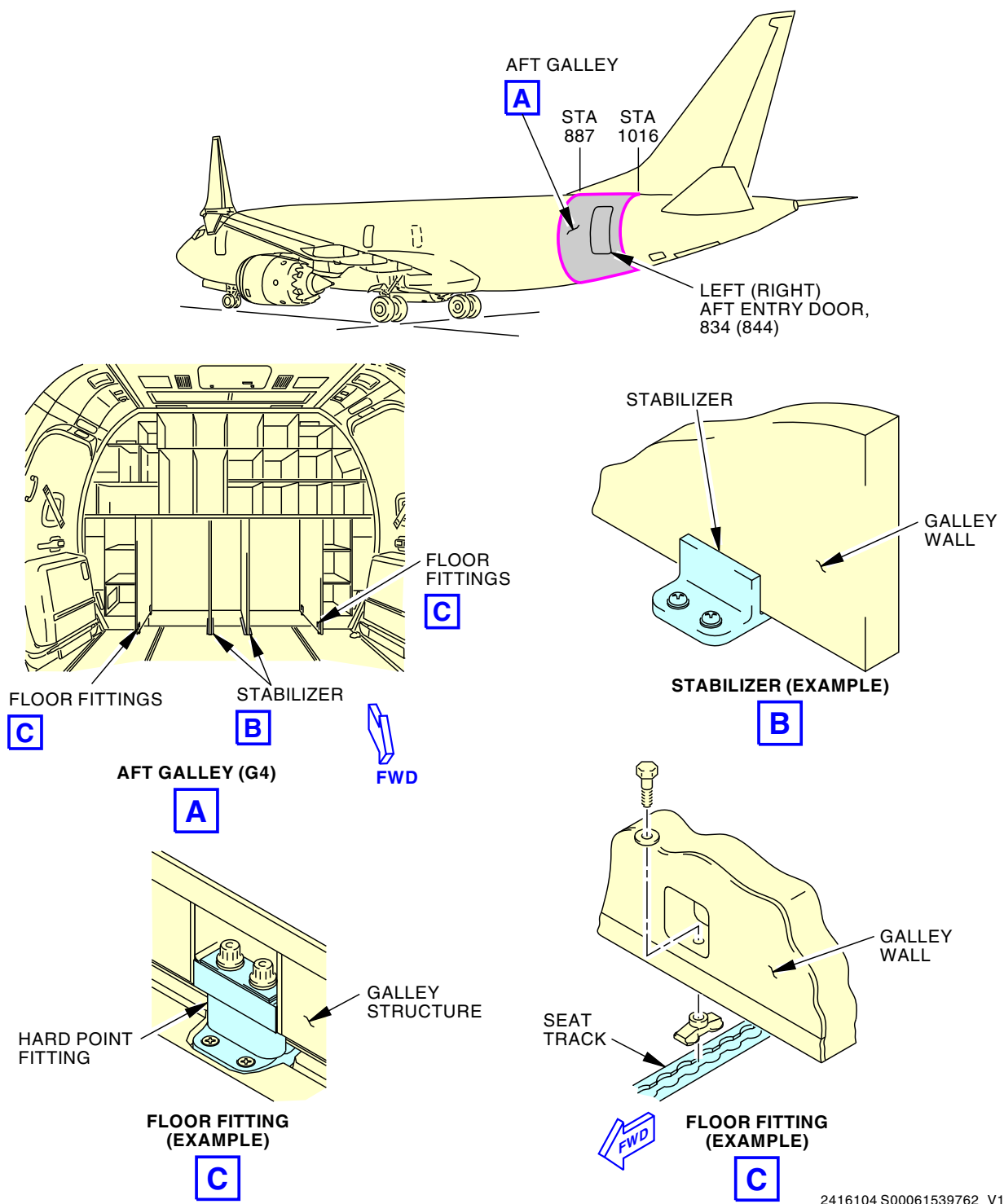
EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416104 S00061539762_V1

Passenger Compartment Floor Structure - Wet Area
Figure 251/53-05-03-990-851 (Sheet 3 of 3)

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-834

46. **INTERNAL - GENERAL VISUAL: FORWARD PASSENGER COMPARTMENT, STA 360 to 663.75**
(Figure 252)

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
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

C. Access Panels

Number	Name/Location
833	Emergency Exit Door (AOE)
834	Aft Entry Door
S2301	Forward Passenger Compartment STA 360 to 663.75

D. Inspection

SUBTASK 53-05-03-010-044

- (1) Open these access panels:

Number	Name/Location
833	Emergency Exit Door (AOE)
834	Aft Entry Door

Special Access:

Number	Name/Location
S2301	Forward Passenger Compartment STA 360 to 663.75

NOTE: Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-034

- (2) Do a General Visual inspection of the passenger compartment from STA 360 to 663.75, including:
1. Skin panels (skins, frames and stringers), longitudinal lap splices, circumferential skin and stringer splices.
 2. Window belt structure.
 3. Overwing emergency exit cutout structure.
 4. Forward cargo door cutout surround structure (portion in upper lobe).
 5. STA 540 and 663 bulkheads and splices.
 6. Overwing frames and stub beams.

SUBTASK 53-05-03-910-046

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

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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SUBTASK 53-05-03-410-032

(4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
833	Emergency Exit Door (AOE)
834	Aft Entry Door

————— END OF TASK —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

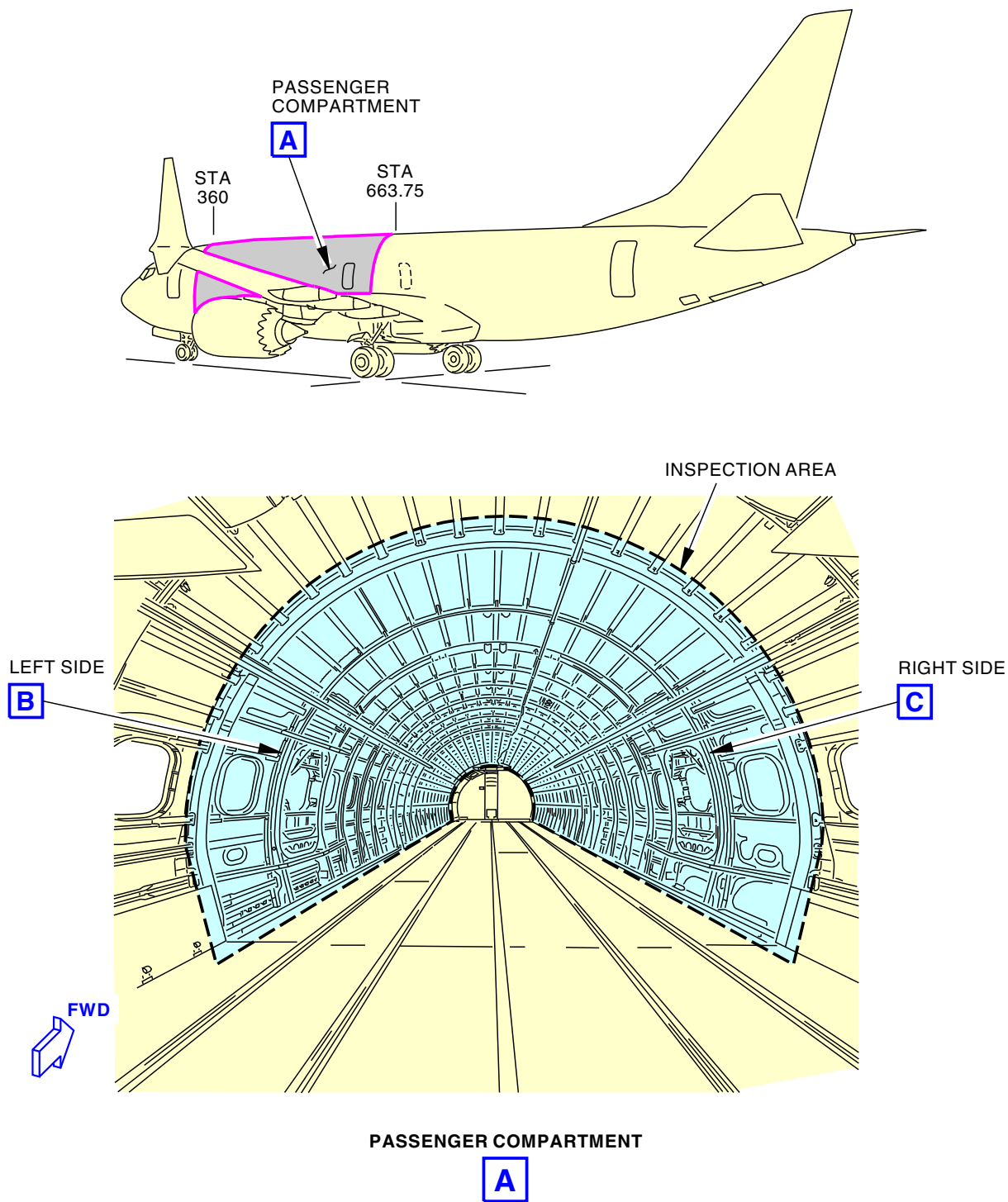
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AIRCRAFT MAINTENANCE MANUAL



2416105 S00061539764_V1

INTERNAL-GENERAL VISUAL: FORWARD PASSENGER COMPARTMENT, STA 360 TO STA 663.75
Figure 252/53-05-03-990-852 (Sheet 1 of 3)

EFFECTIVITY
SIA ALL

D633AM101-SIA

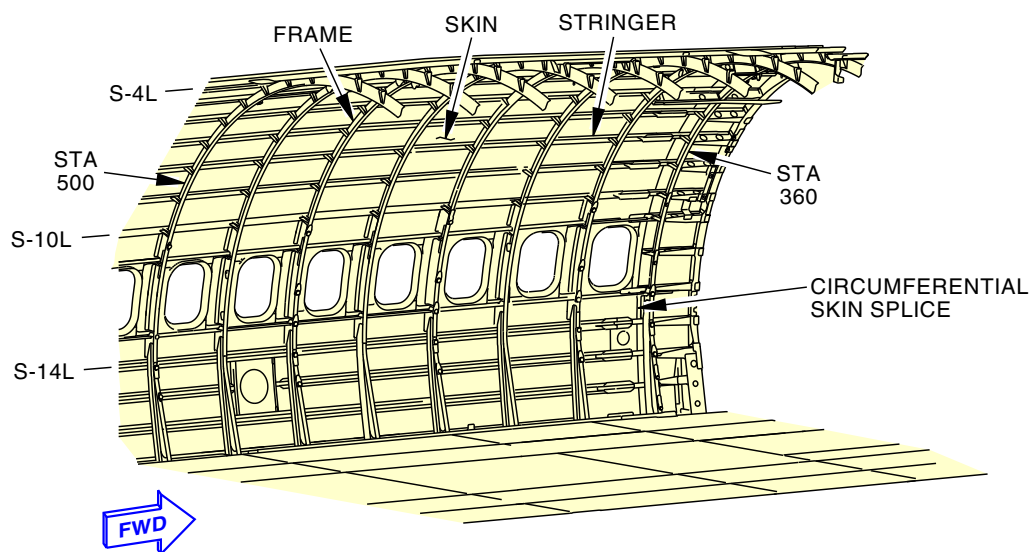
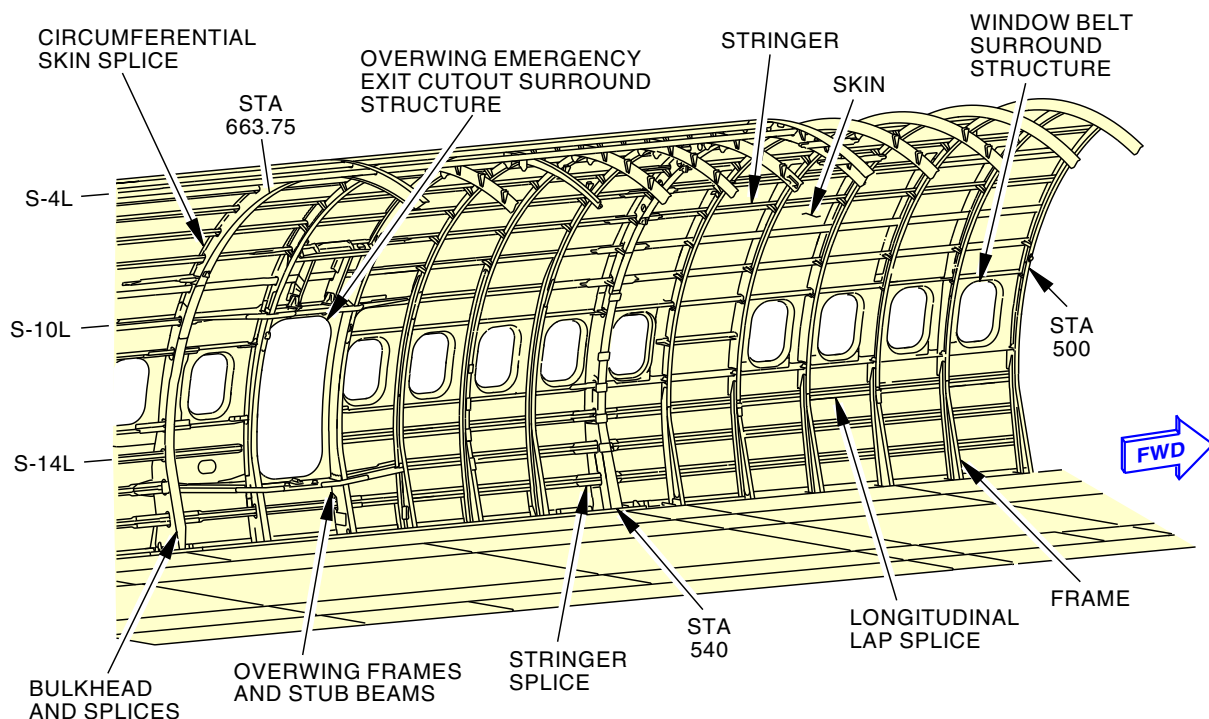
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



LEFT SIDE - PASSENGER COMPARTMENT

B

2416106 S00061539765_V1

INTERNAL-GENERAL VISUAL: FORWARD PASSENGER COMPARTMENT, STA 360 TO STA 663.75
Figure 252/53-05-03-990-852 (Sheet 2 of 3)

EFFECTIVITY
SIA ALL

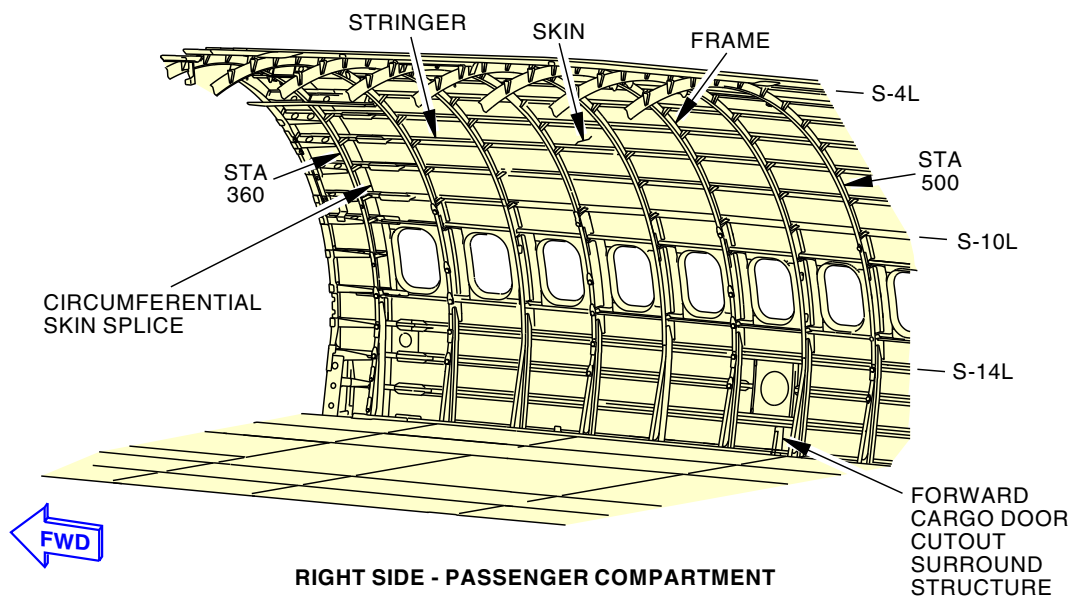
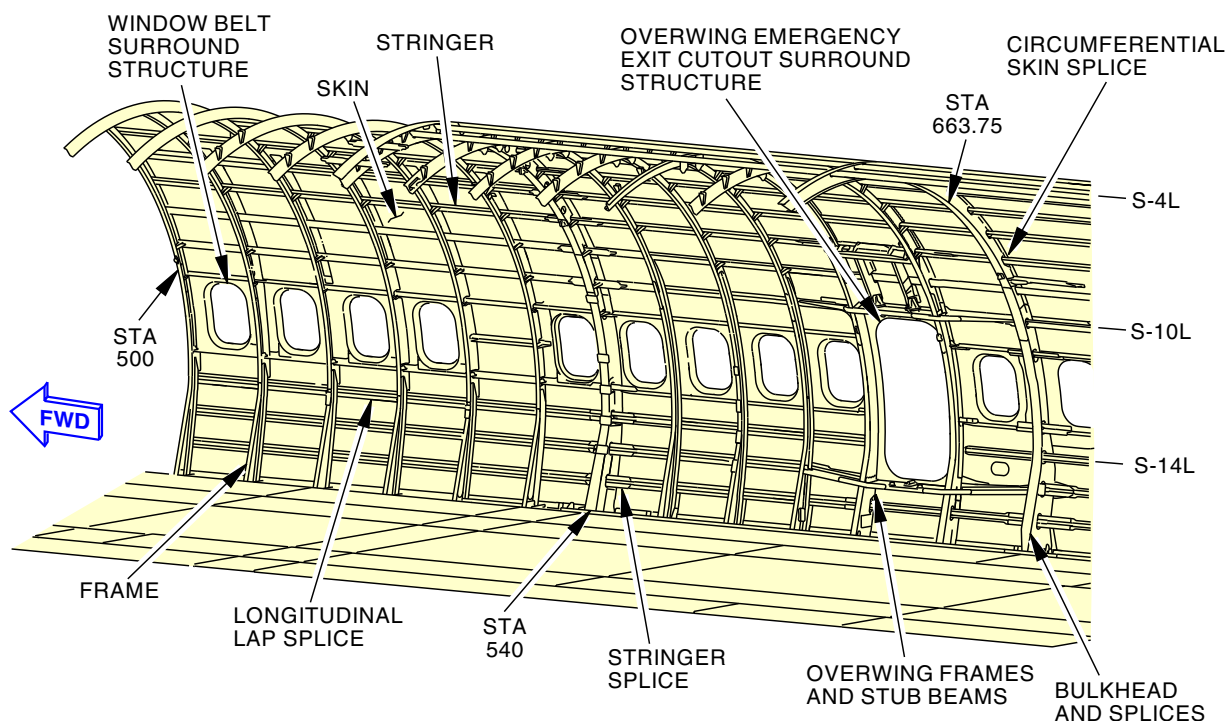
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**737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL**



RIGHT SIDE - PASSENGER COMPARTMENT

C

2416107 S00061539766_V1

INTERNAL-GENERAL VISUAL: FORWARD PASSENGER COMPARTMENT, STA 360 TO STA 663.75
Figure 252/53-05-03-990-852 (Sheet 3 of 3)

EFFECTIVITY
SIA ALL

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-835

47. INTERNAL - GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 to 1016

(Figure 253)

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
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

C. Access Panels

Number	Name/Location
S2401	AFT Passenger Compartment STA 663.75 to 1016

D. Inspection

SUBTASK 53-05-03-010-045

(1) Special Access:

Number	Name/Location
S2401	AFT Passenger Compartment STA 663.75 to 1016

NOTE: Remove galleys/lavs. Remove cabin interior as required. Remove/replace insulation blankets as required.

SUBTASK 53-05-03-210-035

(2) Do a General Visual inspection of the passenger compartment from STA 663.75 to 1016 (except areas around door cutouts), including:

1. Skin panels (skins, frames and stringers), longitudinal lap splices, circumferential skin and stringer splices (note: inspection includes the circumferential skin and stringer splice at Sta 727I for the -900 models).
2. Window belt structure.
3. STA 663 bulkhead and splices.
4. STA 727 bulkhead.
5. Side strut support frame at STA 706.
6. Main landing gear support frames at STA 695 and 716.
7. Wheel well frame at STA 685.
8. Aft cargo door cutout surround structure (portion in upper lobe).
9. Forward side of STA 1016 bulkhead (chords, pressure web, stiffeners, chord/web attachments), including vertical fin front spar fittings.
10. Stringer splice fittings and tension bolts at STA 1016.

SUBTASK 53-05-03-910-047

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

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

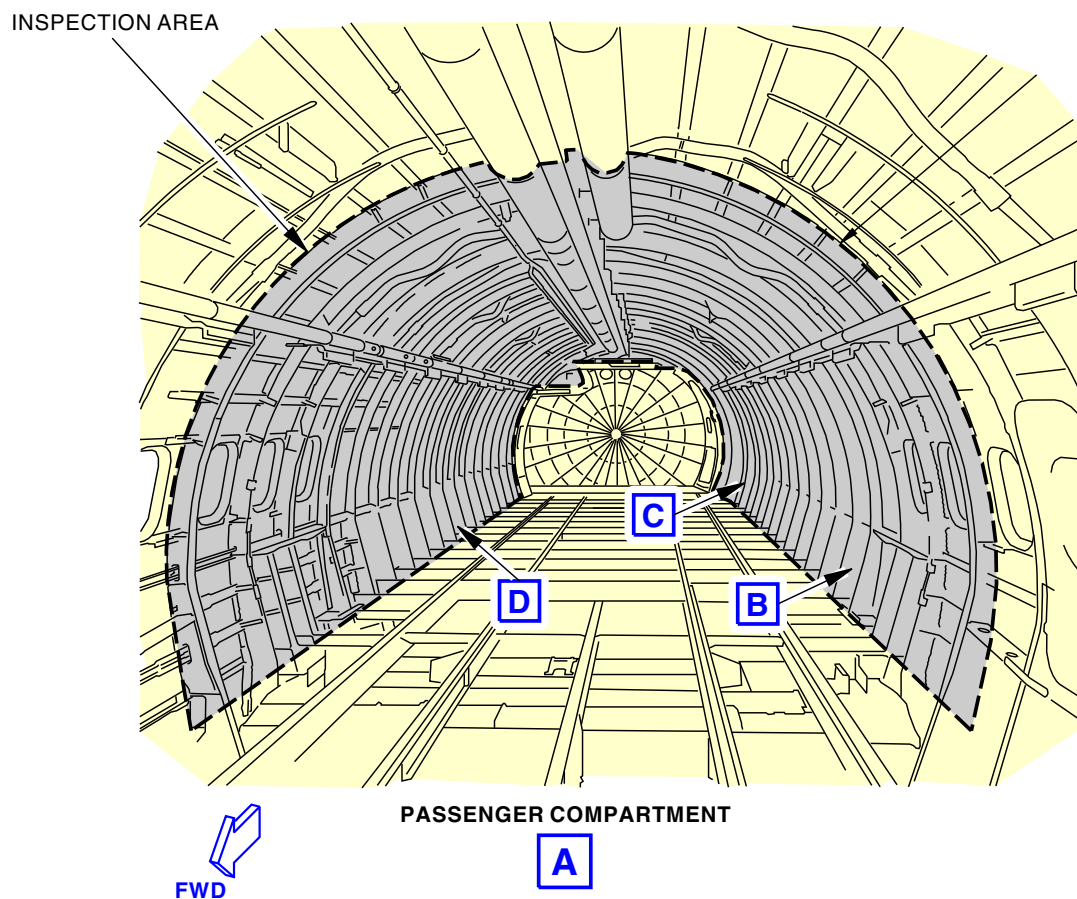
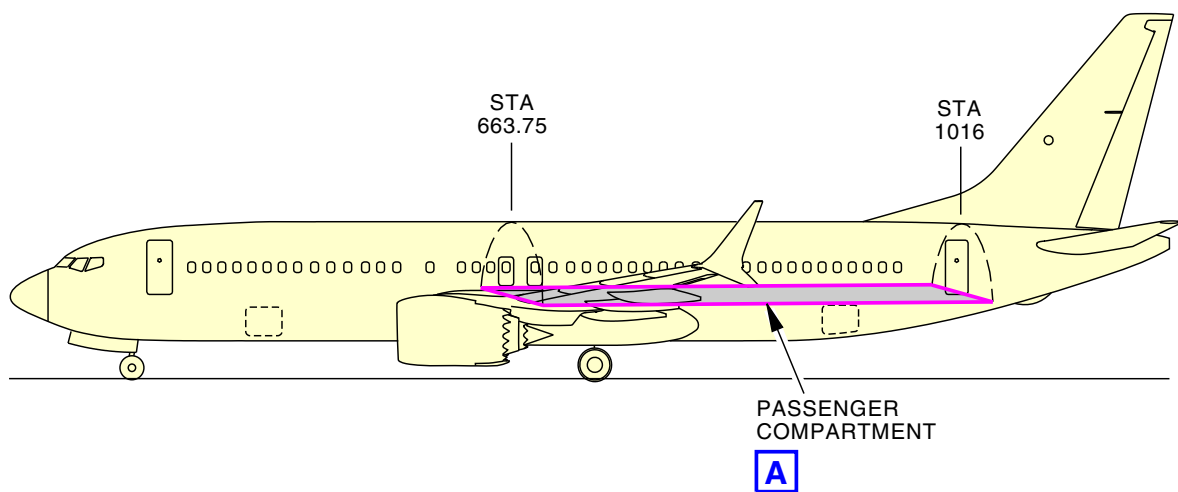
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AIRCRAFT MAINTENANCE MANUAL



2416108 S00061539768_V1

INTERNAL-GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 TO STA 1016
Figure 253/53-05-03-990-853 (Sheet 1 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

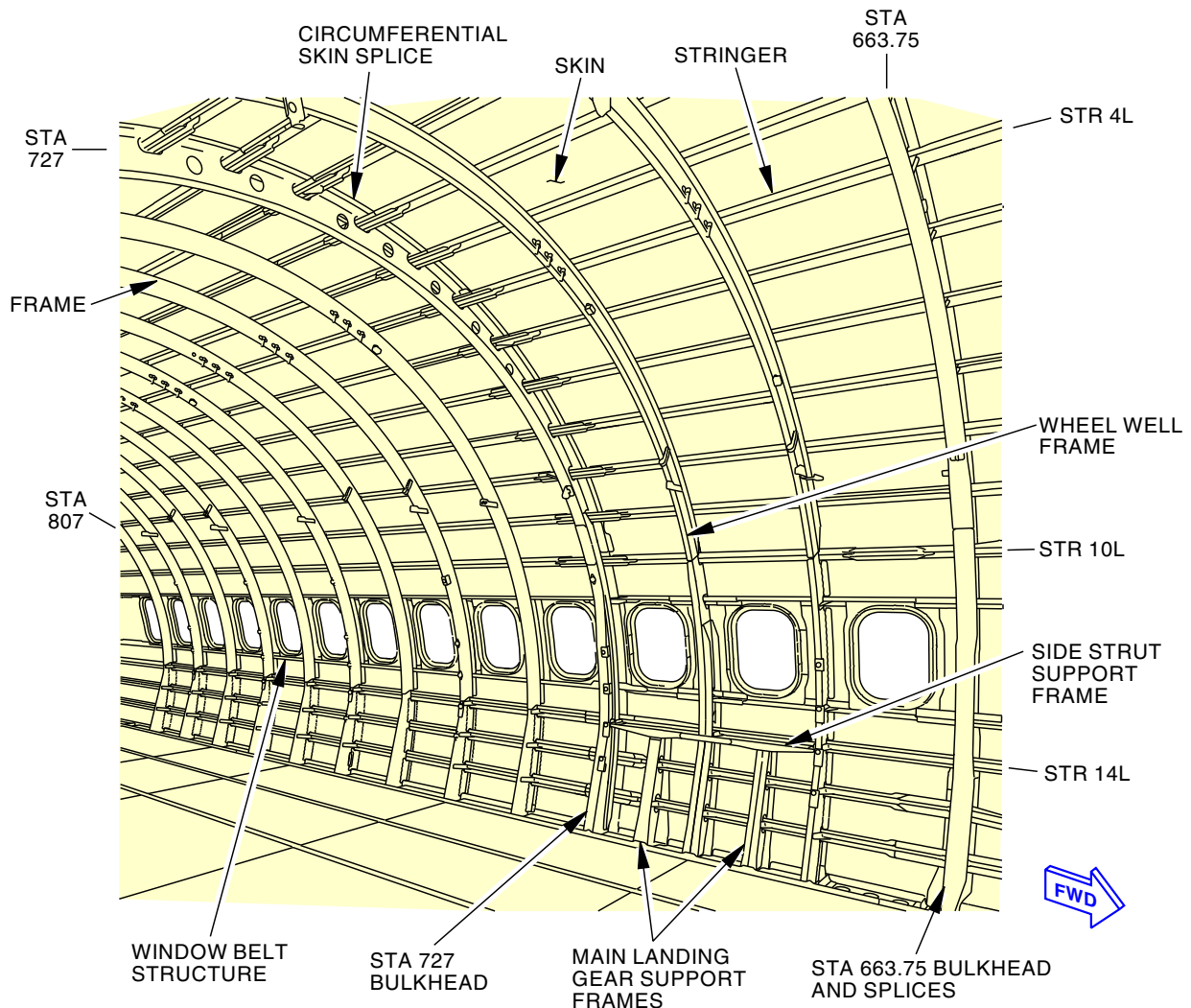
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AIRCRAFT MAINTENANCE MANUAL



AFT PASSENGER COMPARTMENT
(STA 663.75 TO 807)
(LEFT SIDE IS SHOWN, RIGHT SIDE IS ALMOST THE SAME)

B

2416109 S00061539769_V1

INTERNAL-GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 TO STA 1016
Figure 253/53-05-03-990-853 (Sheet 2 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

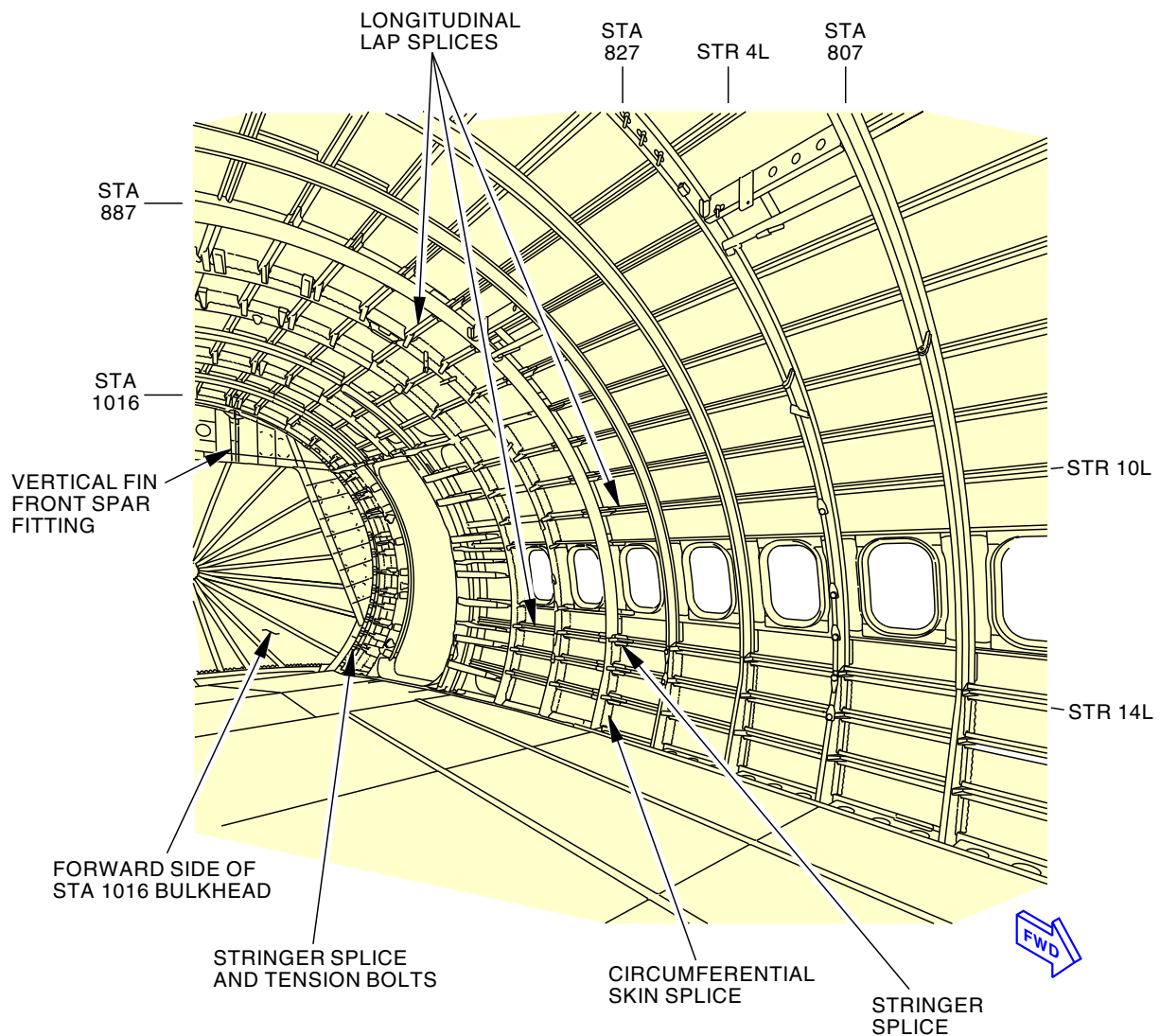
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



AFT PASSENGER COMPARTMENT
(STA 807 TO 1016)
(LEFT SIDE IS SHOWN, RIGHT SIDE IS ALMOST THE SAME)



2416110 S00061539770_V1

INTERNAL-GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 TO STA 1016
Figure 253/53-05-03-990-853 (Sheet 3 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

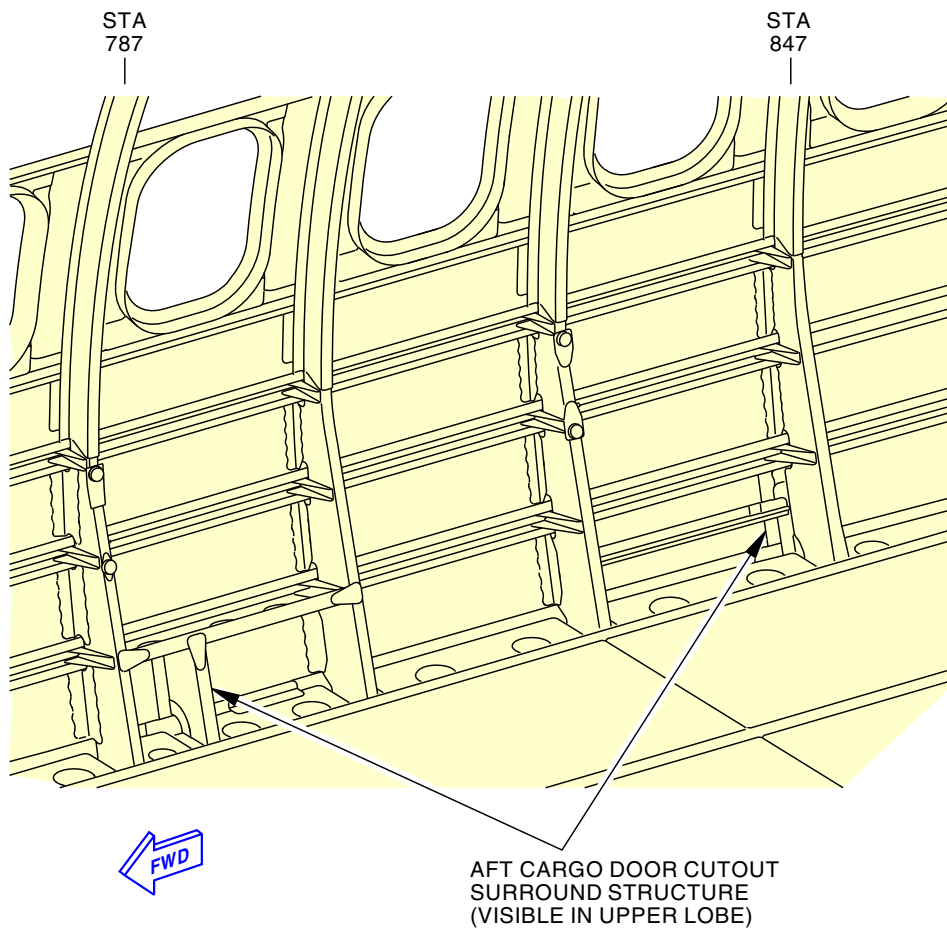
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AIRCRAFT MAINTENANCE MANUAL



2416111 S00061539771_V1

INTERNAL-GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 TO STA 1016
Figure 253/53-05-03-990-853 (Sheet 4 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-836

48. **INTERNAL - GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD**

(Figure 254)

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

C. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door

D. Inspection

SUBTASK 53-05-03-010-046

- (1) Open this access panel:

Number	Name/Location
311BL	Stabilizer Trim Access Door

SUBTASK 53-05-03-210-036

- (2) Do a General Visual inspection of the area aft of STA 1016 pressure bulkhead to STA 1088, including:
1. Skin panels (skins, frames and stringers), longitudinal lap splices, circumferential skin and stringer splices.
 2. Aft side of STA 1016 bulkhead (chords, pressure web, stiffeners, chord/web attachments).
 3. Stringer splice fittings and tension bolts at STA 1016.
 4. STA 1088 bulkhead, including vertical fin rear spar fittings and horizontal stabilizer center section jackscrew fitting lugs and bolts.

SUBTASK 53-05-03-910-048

- (3) Basic Task Description, 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 53-05-03-410-033

- (4) Close this access panel:

Number	Name/Location
311BL	Stabilizer Trim Access Door

————— **END OF TASK** —————

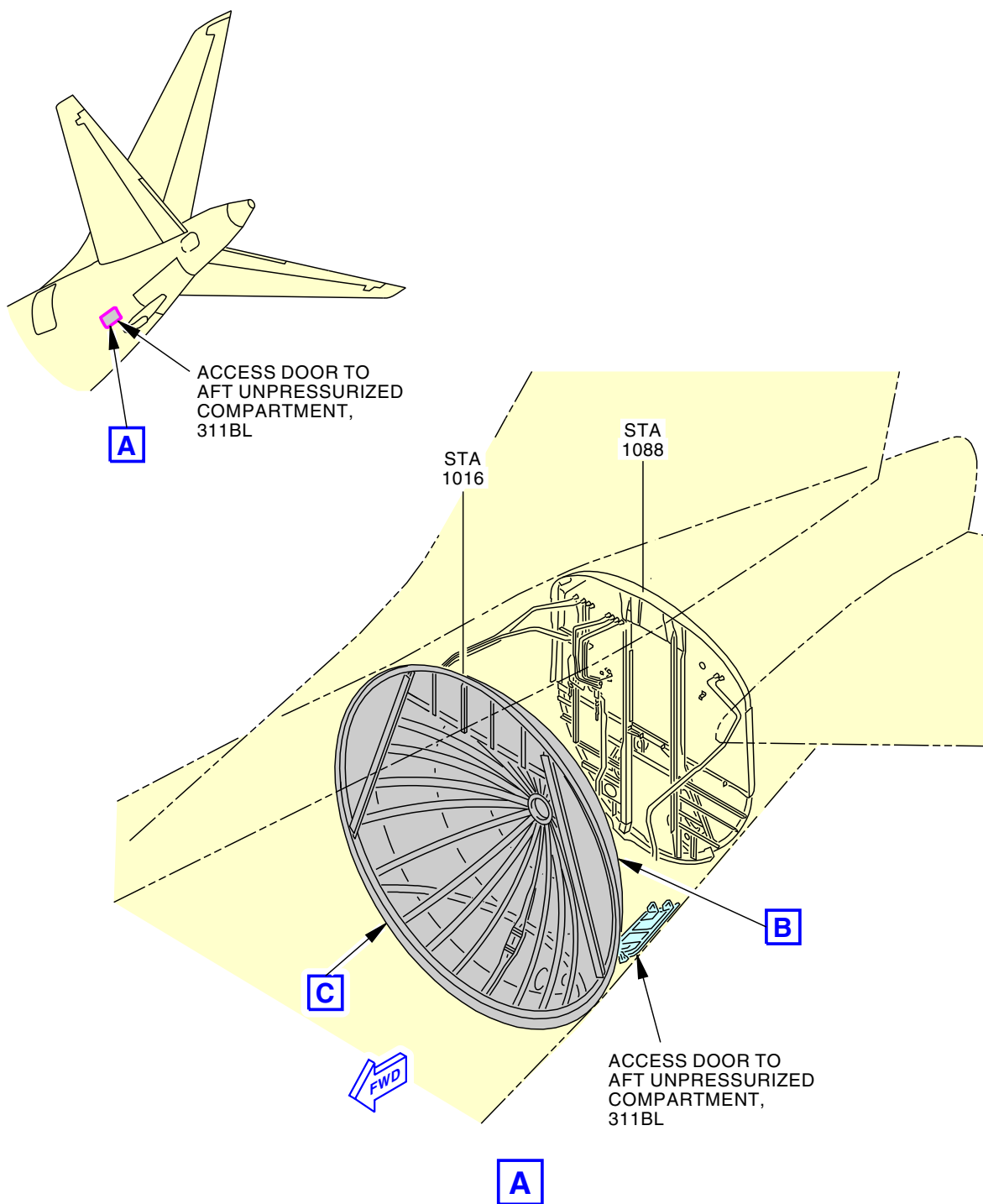
EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416112 S00061539773_V1

INTERNAL-GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD
Figure 254/53-05-03-990-854 (Sheet 1 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

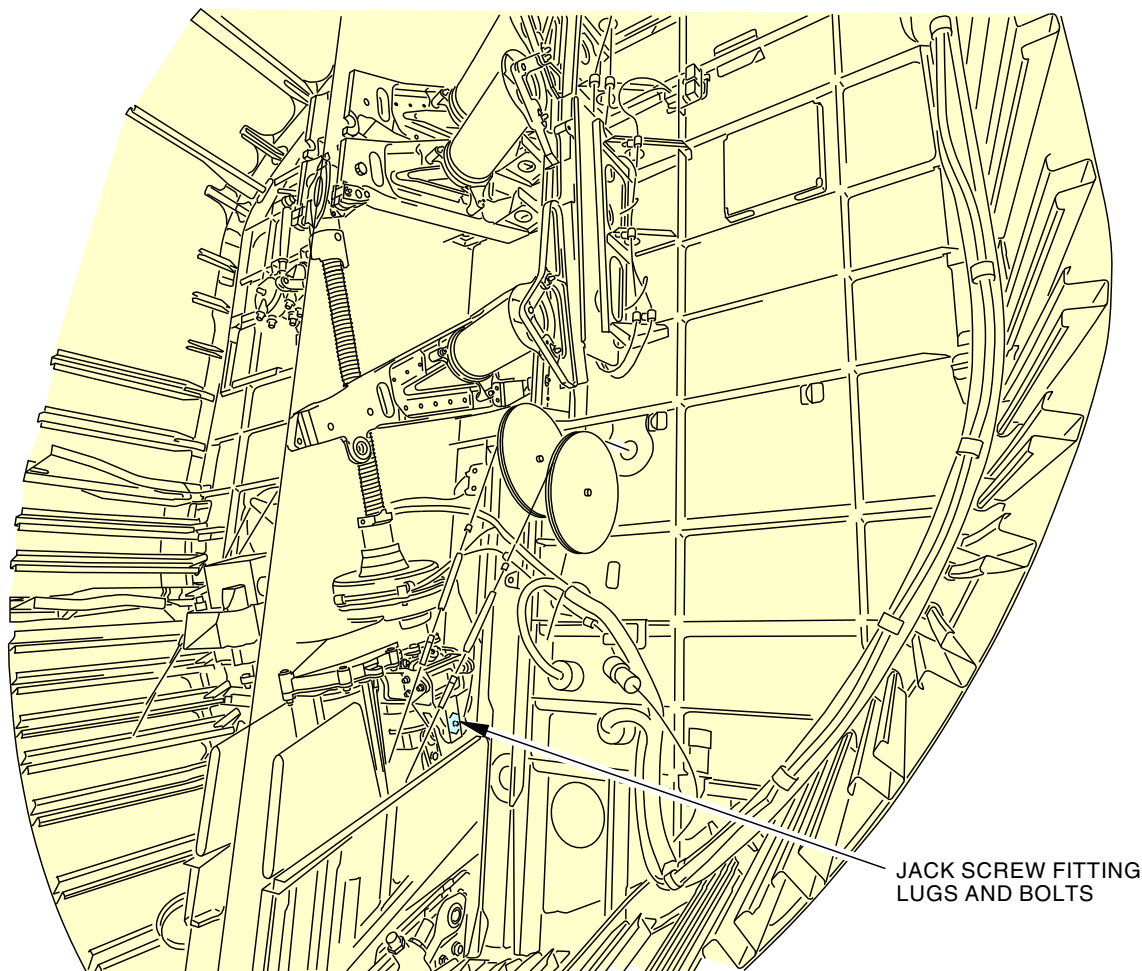
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JACK SCREW FITTING
LUGS AND BOLTS



VIEW FROM BACK



2416113 S00061539774_V1

INTERNAL-GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD
Figure 254/53-05-03-990-854 (Sheet 2 of 4)

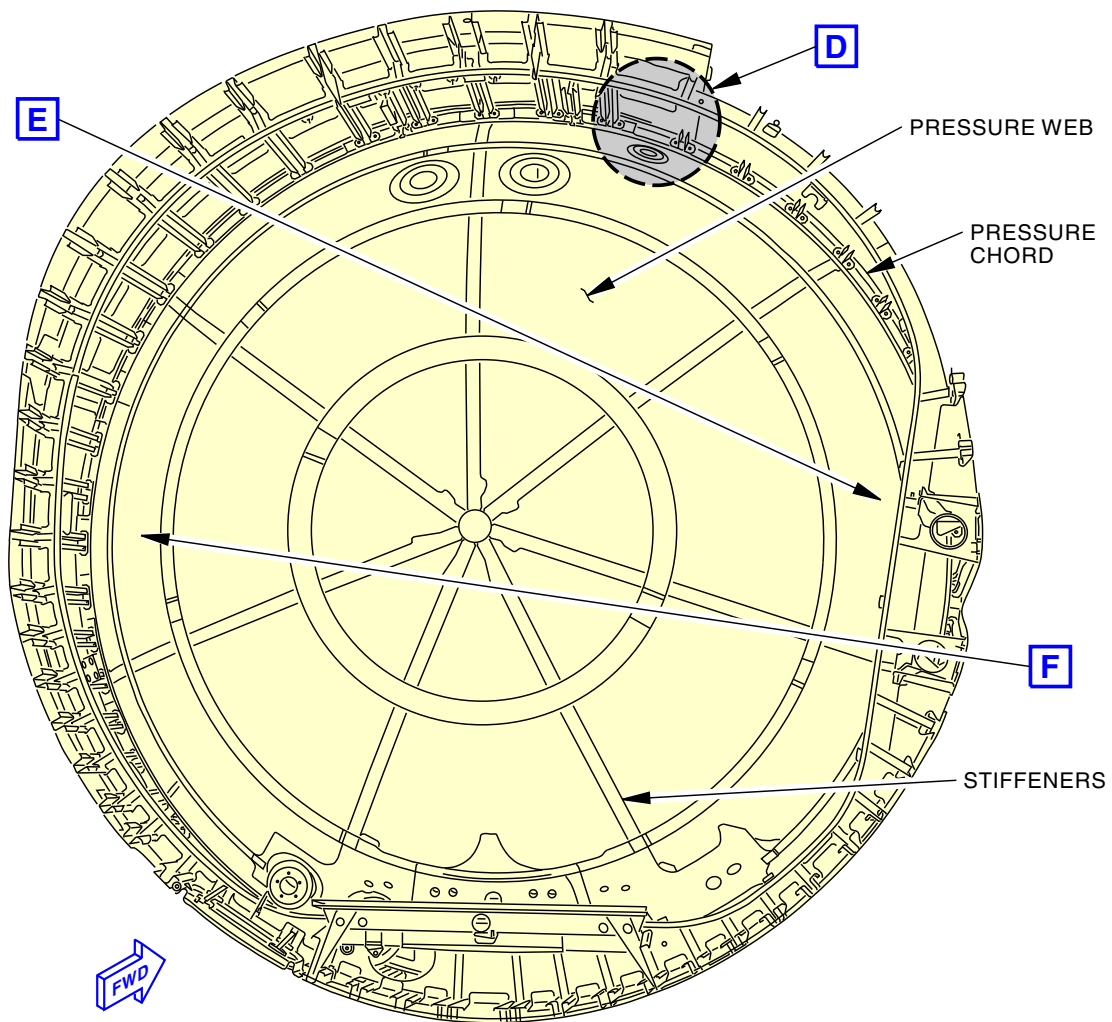
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

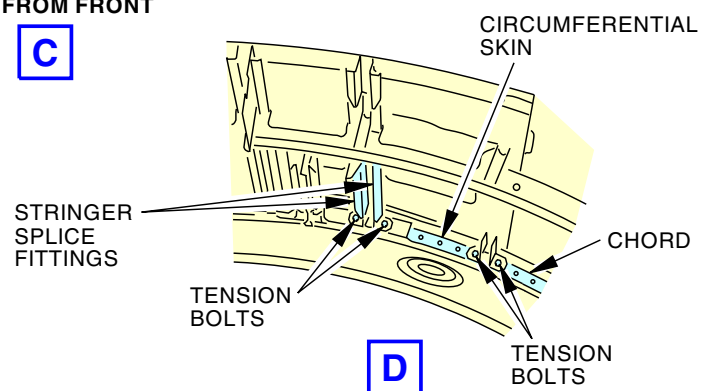
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VIEW FROM FRONT

C



2416114 S00061539775_V1

INTERNAL-GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD
Figure 254/53-05-03-990-854 (Sheet 3 of 4)

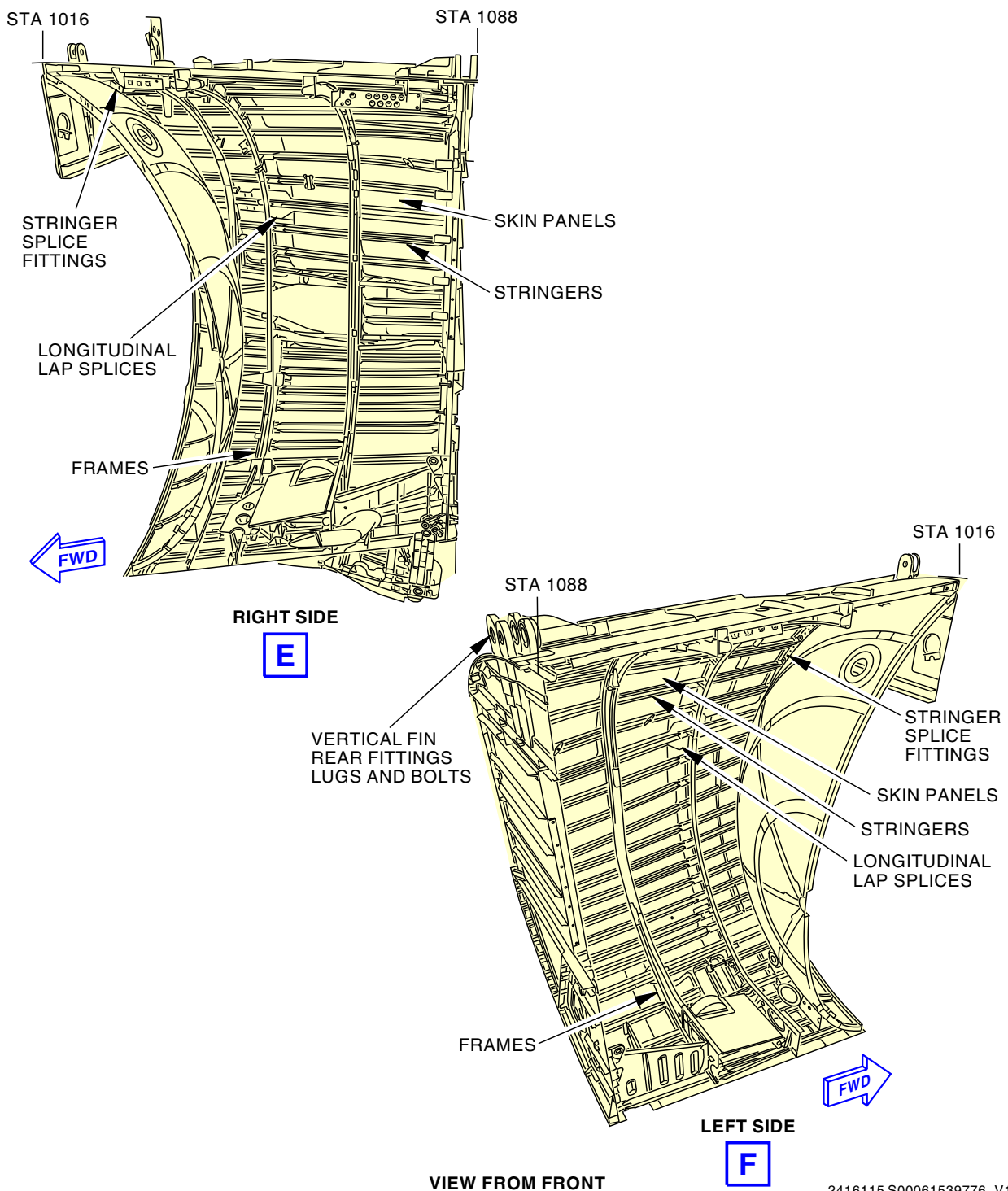
EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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INTERNAL-GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD
Figure 254/53-05-03-990-854 (Sheet 4 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-837

49. **INTERNAL - GENERAL VISUAL: STABILIZER TORSION BOX COMPARTMENT AND APU COMPARTMENT**

(Figure 255)

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
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right
315	APU Compartment - Left
316	APU Compartment - Right

C. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door
315A	APU Cowl Door
331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342AT	Gap Cover, Horizontal Stabilizer
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
S3101	Stabilizer Torsion Box Compartment and APU Compartment Inspection

D. Inspection

SUBTASK 53-05-03-010-047

(1) Open these access panels:

Number	Name/Location
311BL	Stabilizer Trim Access Door
315A	APU Cowl Door
331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342AT	Gap Cover, Horizontal Stabilizer
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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Special Access:

<u>Number</u>	<u>Name/Location</u>
S3101	Stabilizer Torsion Box Compartment and APU Compartment Inspection

NOTE: For area below stringer 12, remove APU and firewalls; remove APU plenum as required. For area above stringer 12, adjust stabilizer trim as required. For access to Sta 1156 horizontal stabilizer hinge fitting lugs and bolts, remove gap seal and horizontal stabilizer rear spar sliding seal as required.

SUBTASK 53-05-03-210-037

- (2) Do a General Visual inspection of the stabilizer torsion box compartment and APU compartment, including:
1. Skin panels (skins, frames and stringers), longitudinal lap splices.
 2. STA 1088 bulkhead, including vertical fin rear spar fittings.
 3. Forward side of STA 1156 bulkhead, including horizontal stabilizer hinge fittings and bolts.
 4. Upper horizontal deck (at stringer 6) and lower horizontal deck (at stringer 12).

SUBTASK 53-05-03-910-049

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

SUBTASK 53-05-03-410-034

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door
315A	APU Cowl Door
331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342AT	Gap Cover, Horizontal Stabilizer
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

———— **END OF TASK** ————

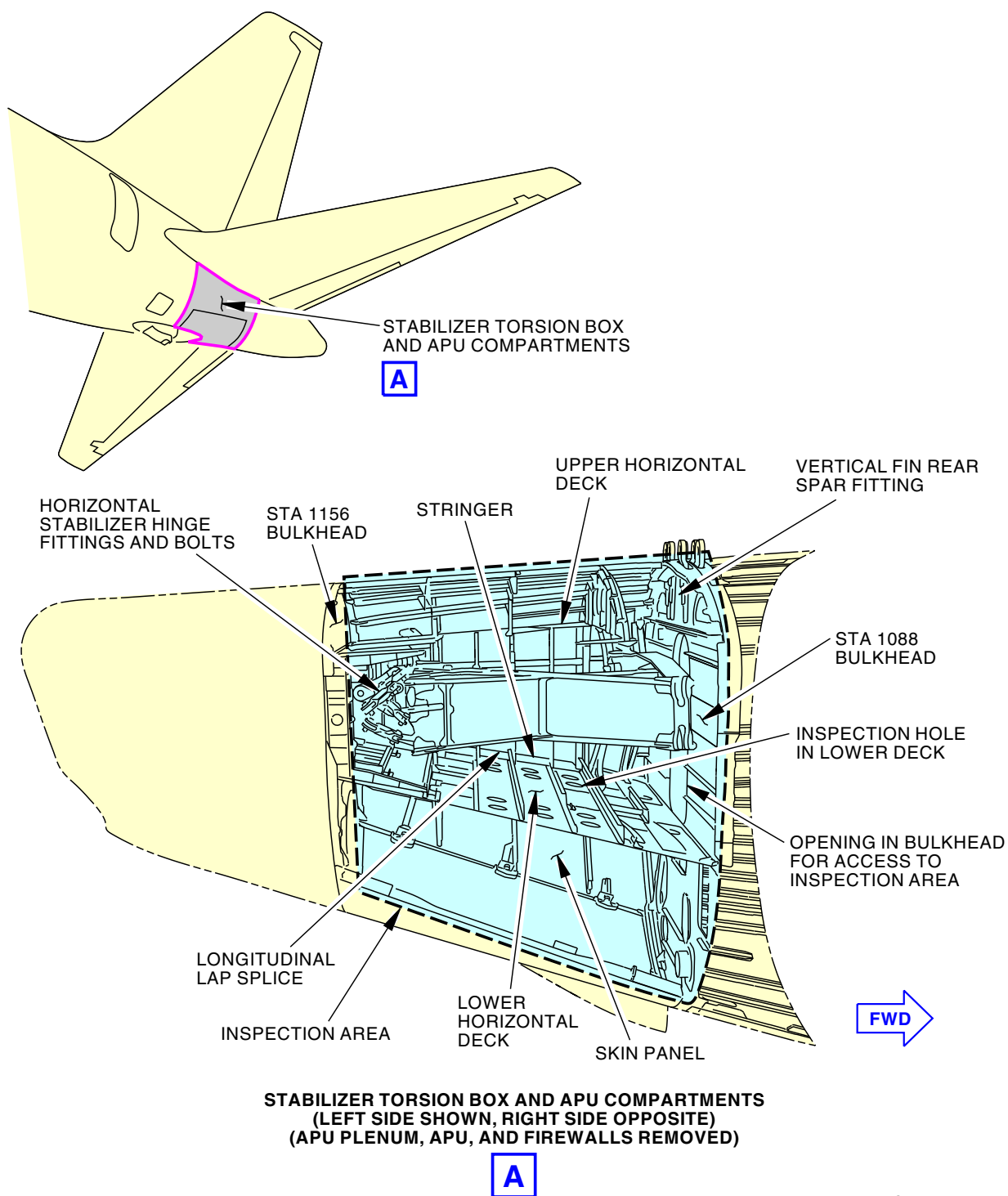
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416116 S00061539778_V1

INTERNAL-GENERAL VISUAL: STABILIZER TORSION BOX COMPARTMENT AND APU COMPARTMENT
Figure 255/53-05-03-990-855

EFFECTIVITY SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-838

50. **INTERNAL - GENERAL VISUAL: STA 1156 BULKHEAD**

(Figure 256)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
317	Tail Cone Compartment - Left
318	Tail Cone Compartment - Right

C. Access Panels

Number	Name/Location
318BR	Tailcone Access Door

D. Inspection

SUBTASK 53-05-03-010-048

(1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
318BR	Tailcone Access Door

SUBTASK 53-05-03-210-038

(2) Do a General Visual inspection of the aft side of STA 1156 bulkhead.

SUBTASK 53-05-03-910-050

(3) Basic Task Description, 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 53-05-03-410-035

(4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
318BR	Tailcone Access Door

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

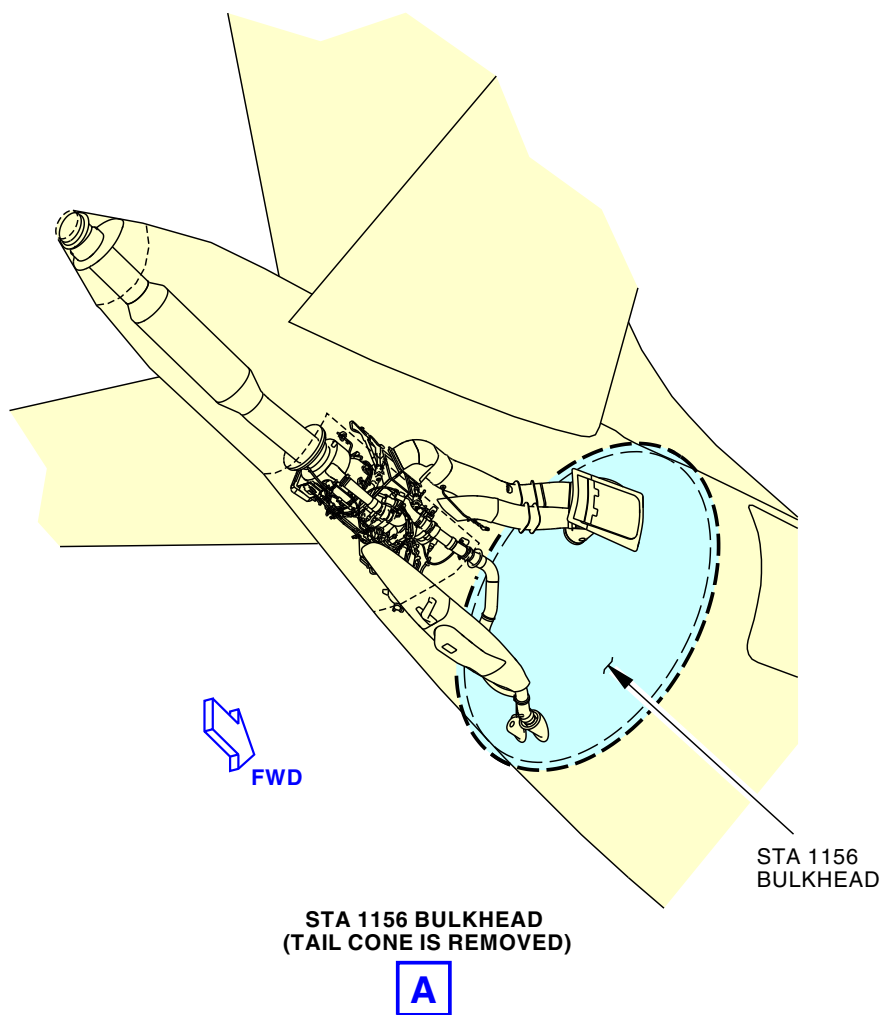
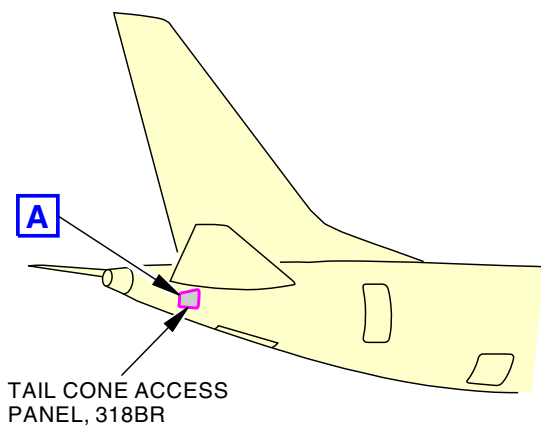
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



2416117 S00061539780_V2

INTERNAL-GENERAL VISUAL: STA 1156 BULKHEAD
Figure 256/53-05-03-990-856

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-839

51. **INTERNAL - GENERAL VISUAL: FUSELAGE SKIN UNDER DORSAL FIN**

(Figure 257)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
321	Vertical Fin - Dorsal Fin

C. Access Panels

Number	Name/Location
321A	Vertical Fin, Dorsal Fin

D. Inspection

SUBTASK 53-05-03-010-049

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
321A	Vertical Fin, Dorsal Fin

SUBTASK 53-05-03-210-039

- (2) Do a General Visual inspection of the fuselage skin under dorsal fin and aft to Sta 1016, including circumferential splice.

SUBTASK 53-05-03-910-051

- (3) Basic Task Description, 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 53-05-03-410-036

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
321A	Vertical Fin, Dorsal Fin

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

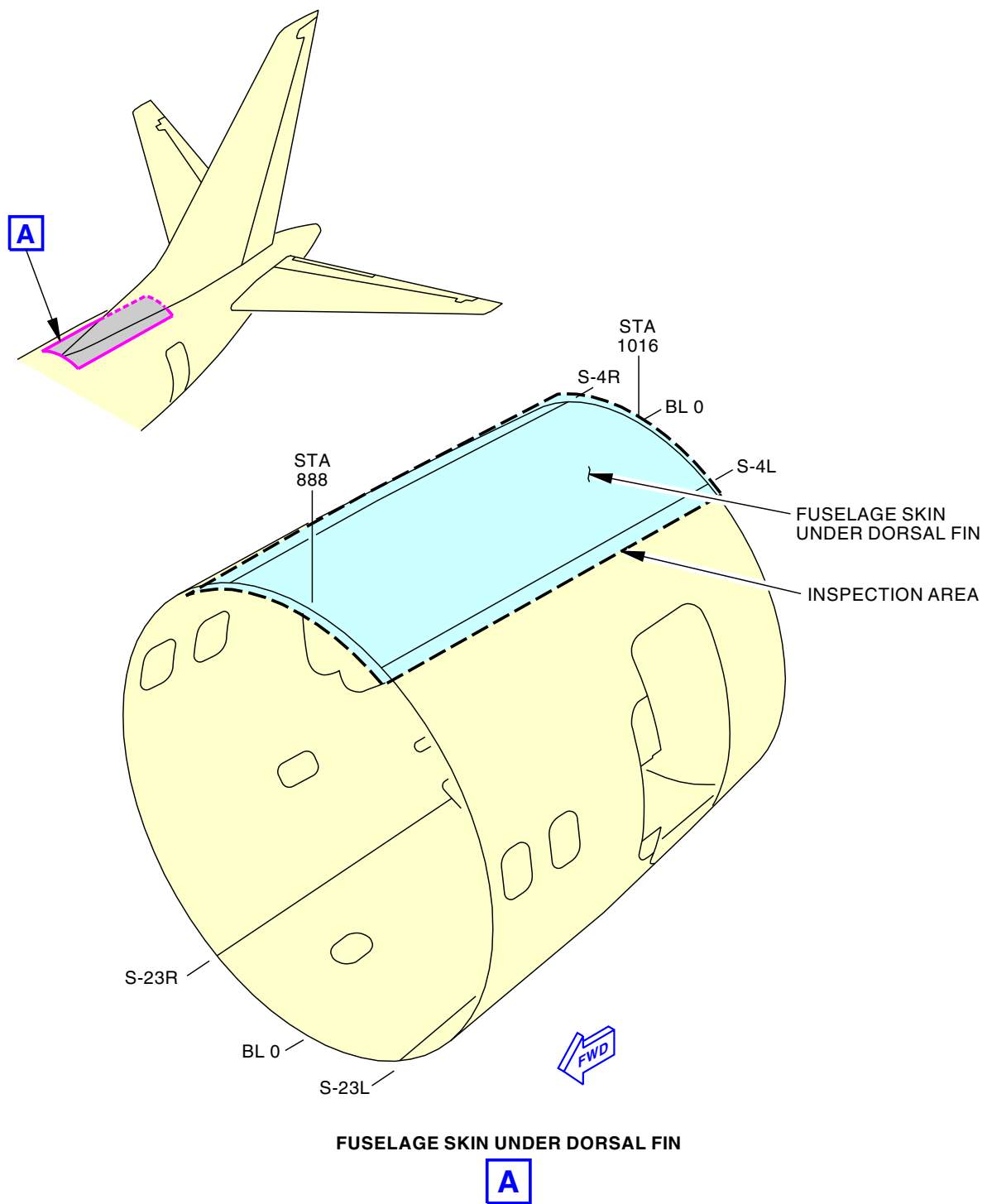
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



2416118 S00061539782_V1

Internal-General Visual: Fuselage Skin Under Dorsal Fin
Figure 257/53-05-03-990-857

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-840

52. **INTERNAL - GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING**

(Figure 258)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Tools/Equipment

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

Reference	Description
SPL-2032	Sling Equipment - Vertical Fin Part #: C55010-33 Supplier: 81205 Opt Part #: C55010-1 Supplier: 81205

C. Location Zones

Zone	Area
322	Vertical Fin - Removable Fin Leading Edge

D. Access Panels

Number	Name/Location
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door

E. Inspection

SUBTASK 53-05-03-480-001

(1) Install the sling equipment, SPL-2032.

SUBTASK 53-05-03-010-050

(2) Open these access panels:

Number	Name/Location
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door

NOTE: Bolt removal is not required.

SUBTASK 53-05-03-210-040

(3) Do a General Visual inspection of the vertical fin front spar fitting lugs and bolts (STA (Station) 1016).

SUBTASK 53-05-03-910-052

(4) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-05-03-410-037

(5) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door

SUBTASK 53-05-03-080-001

(6) Remove the sling equipment, SPL-2032.

———— **END OF TASK** ————

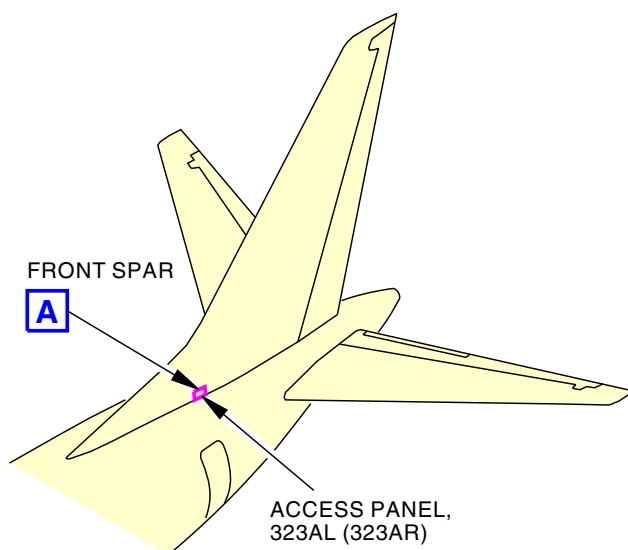
EFFECTIVITY
SIA ALL

D633AM101-SIA

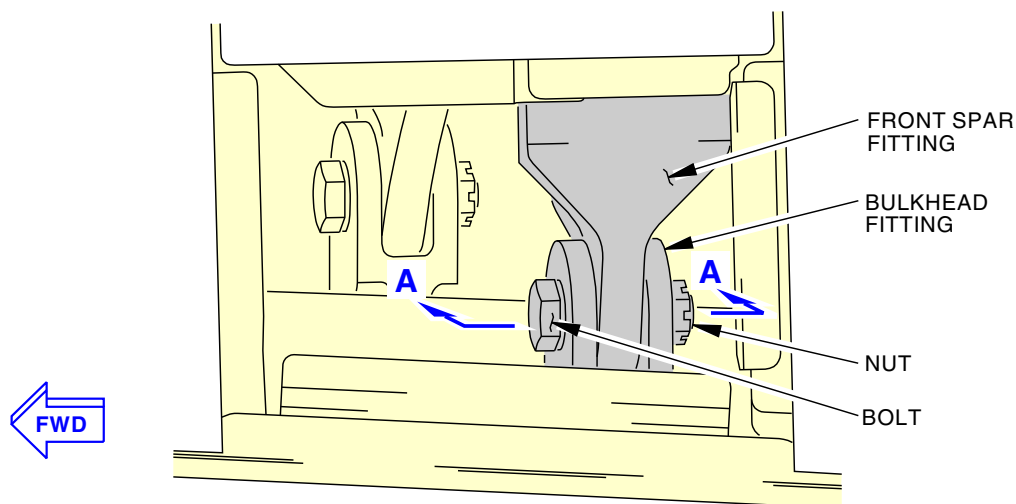
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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VERTICAL FIN
(LEFT SIDE IS SHOWN,
RIGHT SIDE IS EQUIVALENT)



FRONT SPAR
(ACCESS PANEL REMOVED)

A

2416123 S00061539789_V2

Vertical Fin Front Spar Fitting General Visual Inspection (Internal)
Figure 258/53-05-03-990-877 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

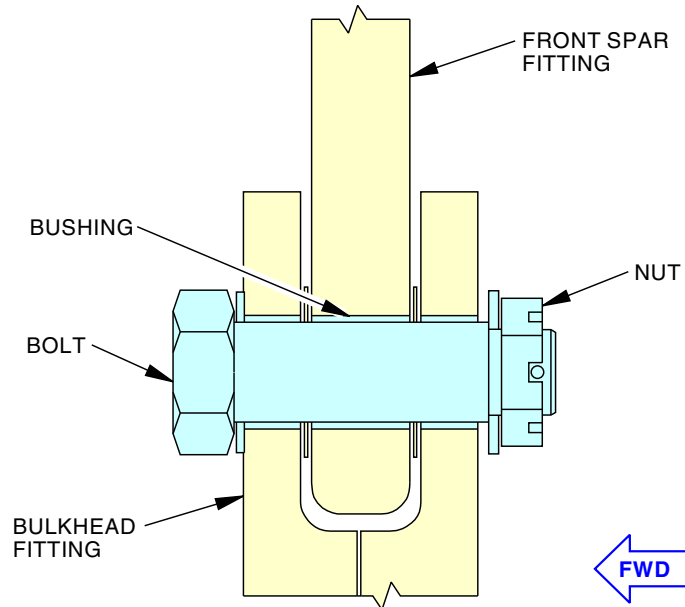
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



FRONT SPAR FITTING
A-A

2416124 S00061539790_V2

Vertical Fin Front Spar Fitting General Visual Inspection (Internal)
Figure 258/53-05-03-990-877 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-841

53. **INTERNAL - GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING**

(Figure 259)

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. 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-2032	Sling Equipment - Vertical Fin Part #: C55010-33 Supplier: 81205 Opt Part #: C55010-1 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
D00633	Grease - Aircraft General Purpose	BMS3-33
D50004	Compound - Antiseize	BMS3-28

D. Location Zones

Zone	Area
322	Vertical Fin - Removable Fin Leading Edge

E. Access Panels

Number	Name/Location
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door

F. Inspection

SUBTASK 53-05-03-480-003

(1) Install the sling equipment, SPL-2032.

SUBTASK 53-05-03-010-051

(2) Open these access panels:

Number	Name/Location
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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SUBTASK 53-05-03-020-007

- (3) Remove the cotter pins [5], nuts [4], washers [3], washers [2], and bolts [1] from the front spar attach fittings.

NOTE: There is a bolt on the left side and the right side. You must remove one bolt at a time to keep the fin aligned.

SUBTASK 53-05-03-210-041

- (4) Do a General Visual inspection of the vertical fin front spar fitting lugs and bolts [1] (STA (Station) 1016).

SUBTASK 53-05-03-910-053

- (5) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 53-05-03-110-001

- (6) Clean the bolts [1] and bolt hole with solvent, B00083.

SUBTASK 53-05-03-420-007

- (7) Install the fasteners of the front spar fitting:
- (a) Apply a layer of grease, D00633 on the shank of the bolts [1].
NOTE: Apply grease, D00633 only to the shank of the bolts [1].
 - (b) Apply anti-seize compound, D50004 to the bolt [1] threads and the nut [4] threads.
 - (c) Install the bolts [1], washers [2], washers [3], washers [6] and nuts [4].
 - 1) Torque the nuts [4] to 50 in-lb (5.6 N·m) - 1500 in-lb (169.5 N·m)
NOTE: Maintain the required gaps shown in view A-A.
NOTE: Align the nut [4] with the cotter pin hole in the bolt [1].
 - 2) Install new cotter pins [5] in to the nuts [4].

SUBTASK 53-05-03-410-038

- (8) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door

SUBTASK 53-05-03-080-003

- (9) Remove the sling equipment, SPL-2032.

————— **END OF TASK** —————

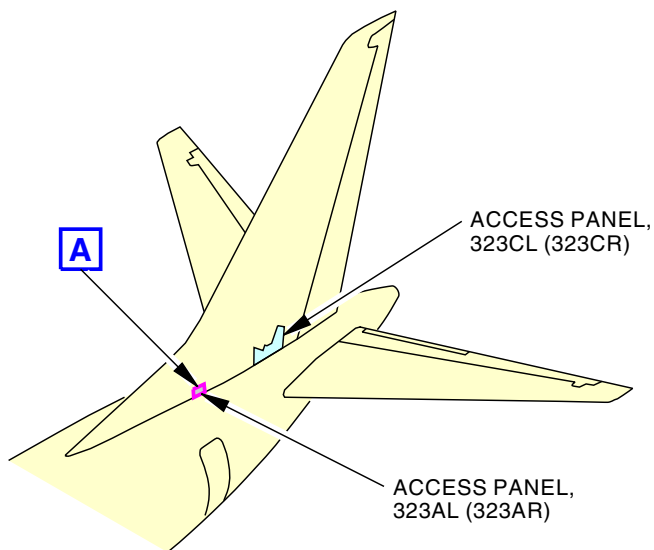
EFFECTIVITY
SIA ALL

D633AM101-SIA

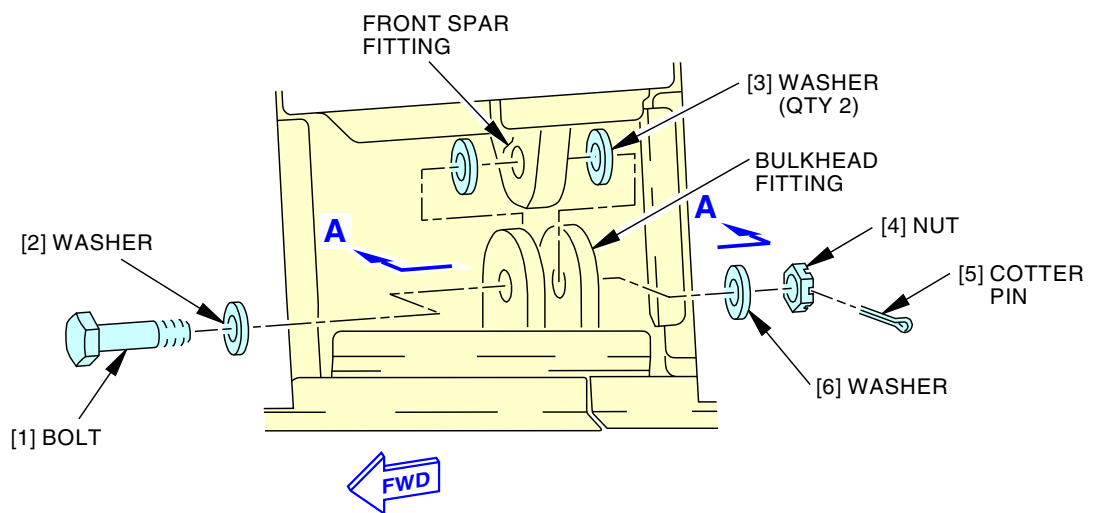
ECCN 9E991 BOEING PROPRIETARY - See title page for details

53-05-03

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VERTICAL FIN
(LEFT SIDE IS SHOWN,
RIGHT SIDE IS EQUIVALENT)



FRONT SPAR INSTALLATION
(ACCESS PANEL REMOVED)

A

2416119 S00061539784_V1

INTERNAL-GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING
Figure 259/53-05-03-990-876 (Sheet 1 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

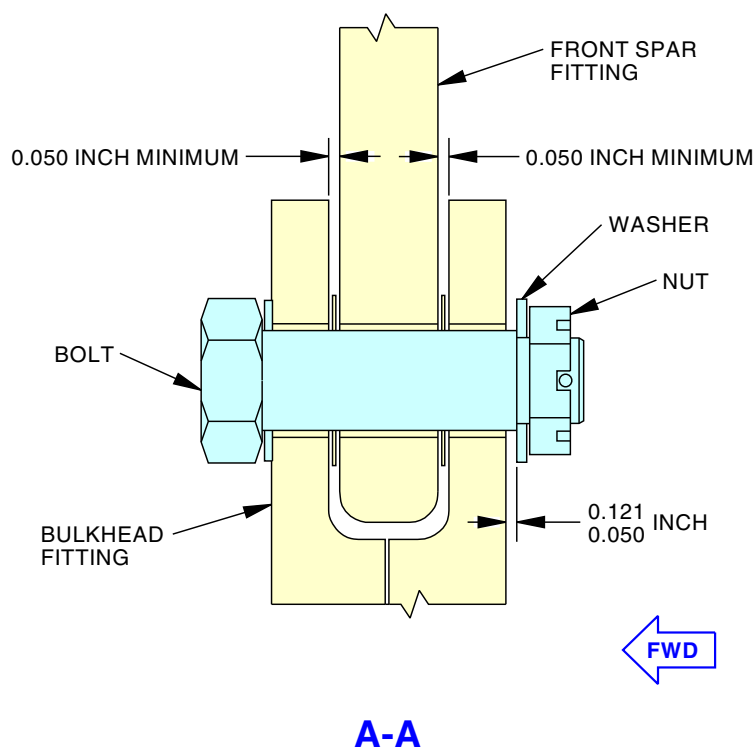
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



2416120 S00061539785_V1

INTERNAL-GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING
Figure 259/53-05-03-990-876 (Sheet 2 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

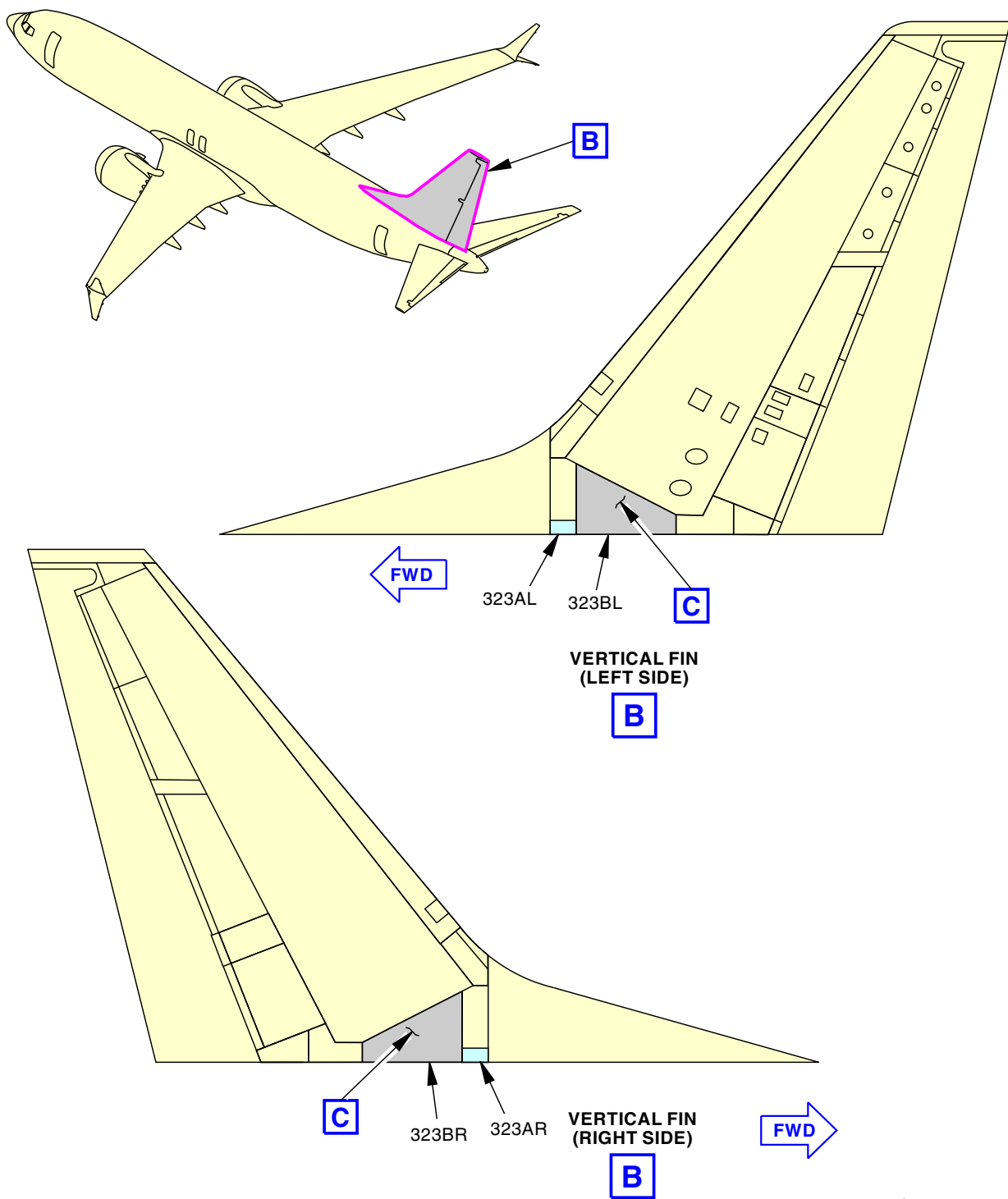
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AIRCRAFT MAINTENANCE MANUAL



2416121 S00061539786_V1

INTERNAL-GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING
Figure 259/53-05-03-990-876 (Sheet 3 of 4)

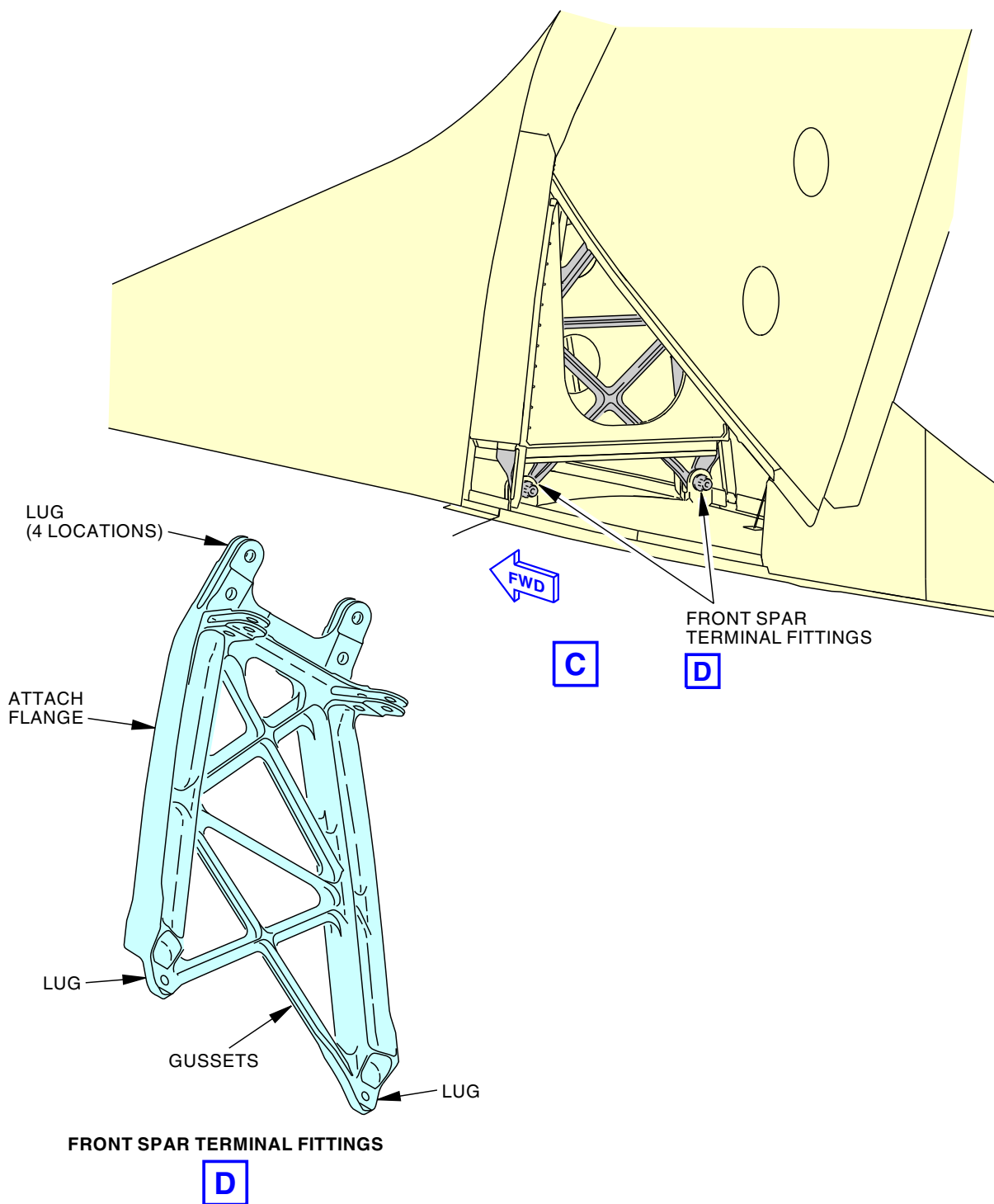
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416122 S00061539787_V1

INTERNAL-GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING
Figure 259/53-05-03-990-876 (Sheet 4 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-842

54. **INTERNAL - GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING**

(Figure 260)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Tools/Equipment

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

Reference	Description
SPL-2032	Sling Equipment - Vertical Fin Part #: C55010-33 Supplier: 81205 Opt Part #: C55010-1 Supplier: 81205

C. Location Zones

Zone	Area
323	Vertical Fin - Front Spar To Rear Spar

D. Access Panels

Number	Name/Location
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

E. Inspection

SUBTASK 53-05-03-480-002

- (1) Install the sling equipment, SPL-2032.

SUBTASK 53-05-03-010-052

- (2) Open these access panels:

Number	Name/Location
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

NOTE: Bolt removal is not required.

SUBTASK 53-05-03-210-042

- (3) Do a General Visual inspection of the vertical fin rear spar fitting lugs and bolts at Sta 1088. Inspect fuselage skin under vertical fin from Sta 1016 to 1088.

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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SUBTASK 53-05-03-910-054

(4) Basic Task Description, 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 53-05-03-410-039

(5) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

SUBTASK 53-05-03-080-002

(6) Remove the sling equipment, SPL-2032.

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

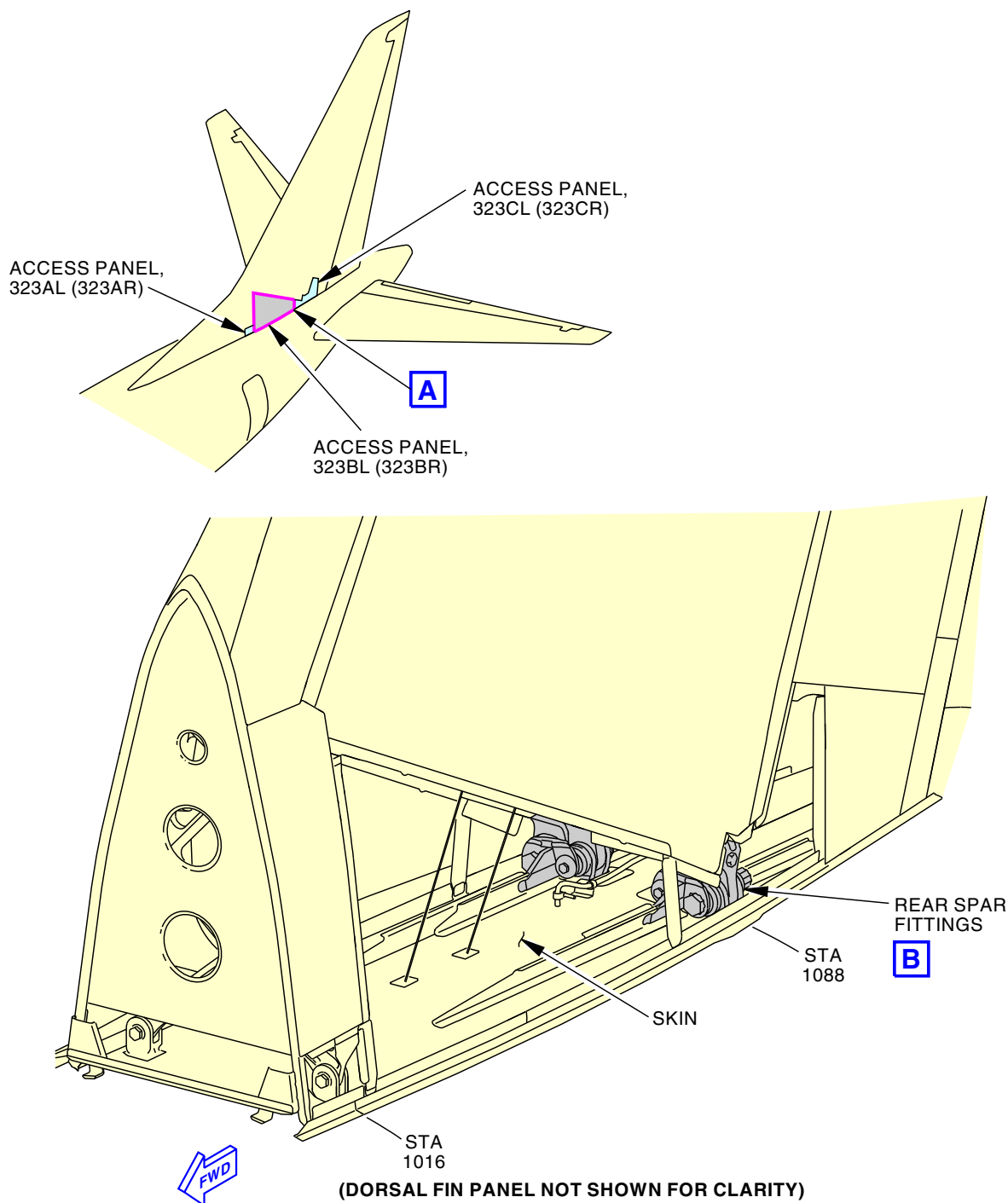
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



2416125 S00061539792_V1

INTERNAL-GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING
Figure 260/53-05-03-990-860 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

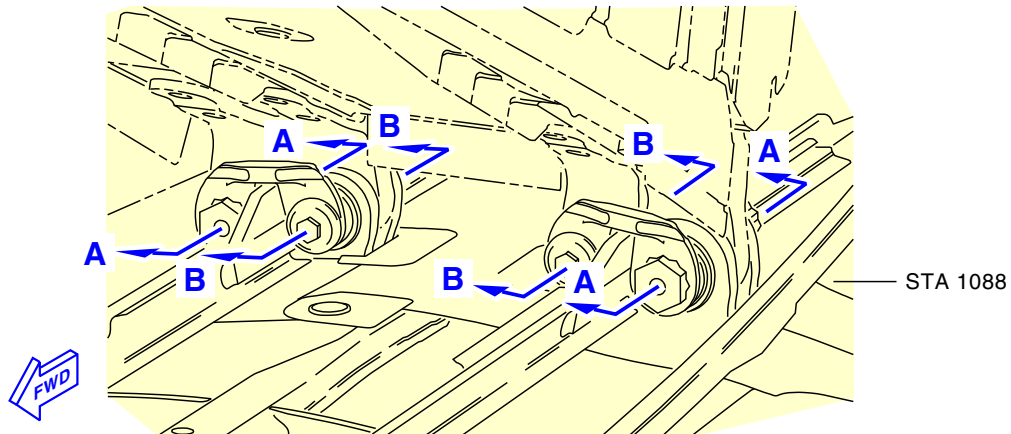
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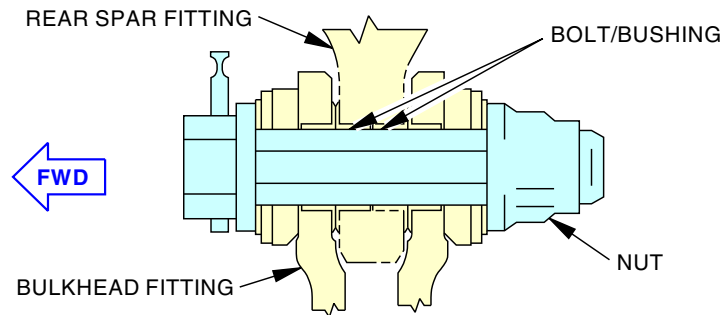


737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



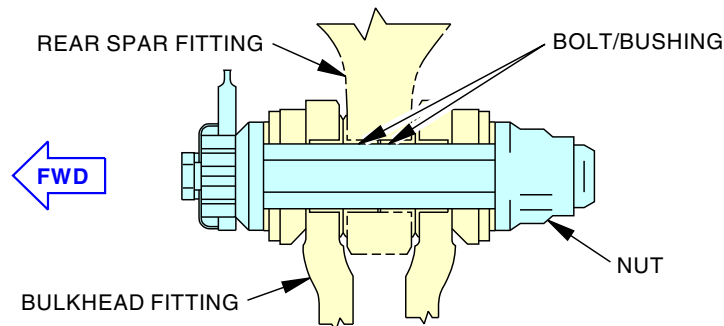
REAR SPAR FITTINGS

B



OUTBOARD SPAR FITTING

A-A



INBOARD SPAR FITTING

B-B

2416126 S00061539793_V1

INTERNAL-GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING
Figure 260/53-05-03-990-860 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-03-210-843

55. **INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FROM STA 178 TO 270**

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
211	Flight Compartment - Left
212	Flight Compartment - Right
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. Access Panels

Number	Name/Location
S2101	Flight Compartment Inspection

D. Inspection

SUBTASK 53-05-03-010-053

(1) Special Access:

Number	Name/Location
S2101	Flight Compartment Inspection

(2) Remove glare shield, liners, overhead units and panels. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-043

(3) Do a General Visual inspection of the flight compartment, including skin panels (skins, frames, stringers), circumferential skin and stringer splice, crew cabin window cutout structure, and forward pressure bulkhead within the following areas: Forward side of frame at STA 259.5 and structure 3 inches forward of STA 259.5; BL 0 + 4 inches (Left and Right); Forward and aft side of Frame 259.5 and structure from STA 249 to STA 263 between floor and S-5L (excluding window and window frame structure); Forward side of Frame 259.5 and structure 3 inches forward of STA 259.5 between floor and S-3R; Structure forward of STA 203.8 to STA 178 and from floor up to window frame; and skin, frames and stringers above P5 panel.

SUBTASK 53-05-03-910-055

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

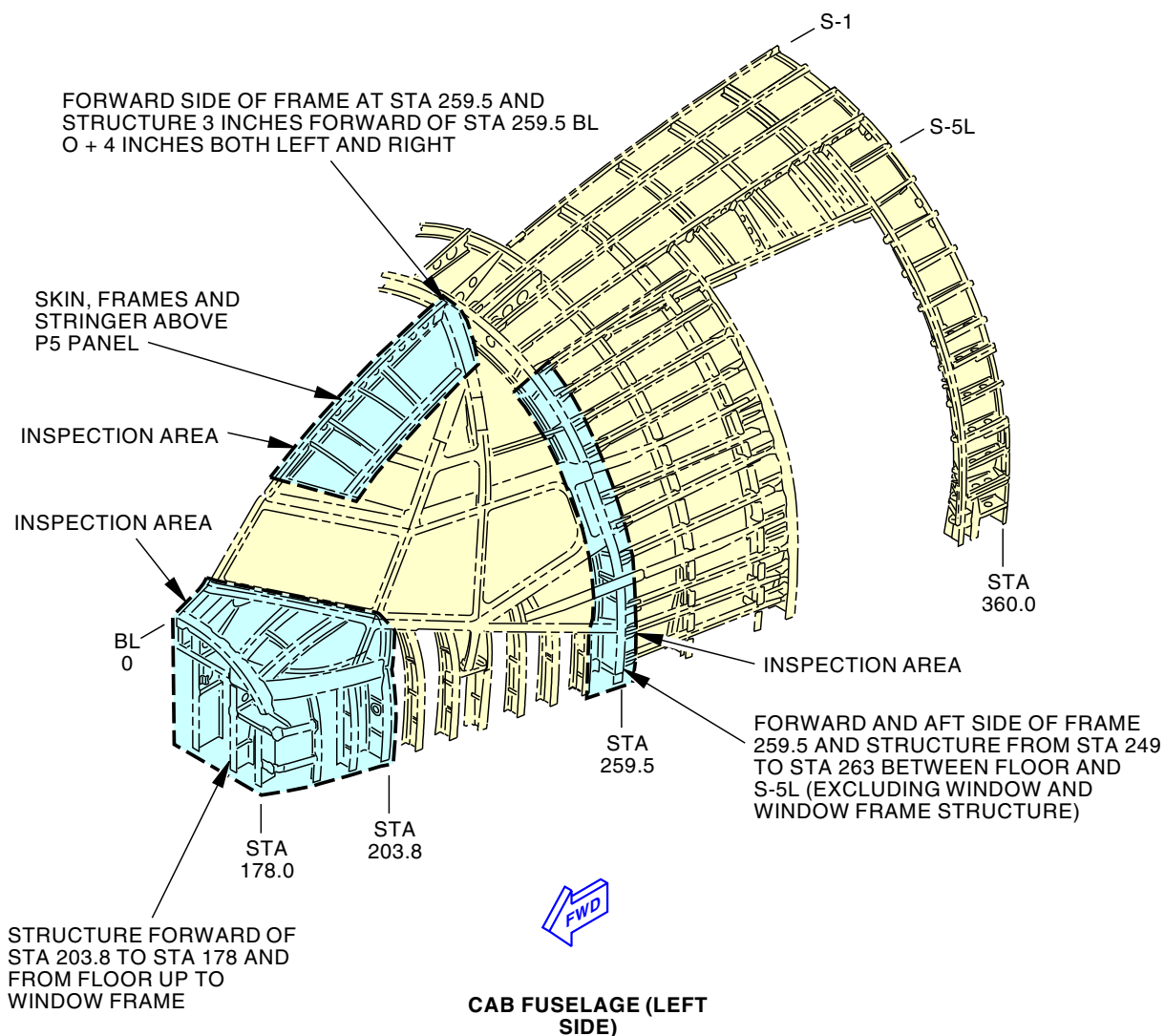
————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

53-05-03

D633AM101-SIA

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2416127 S00061539795_V1

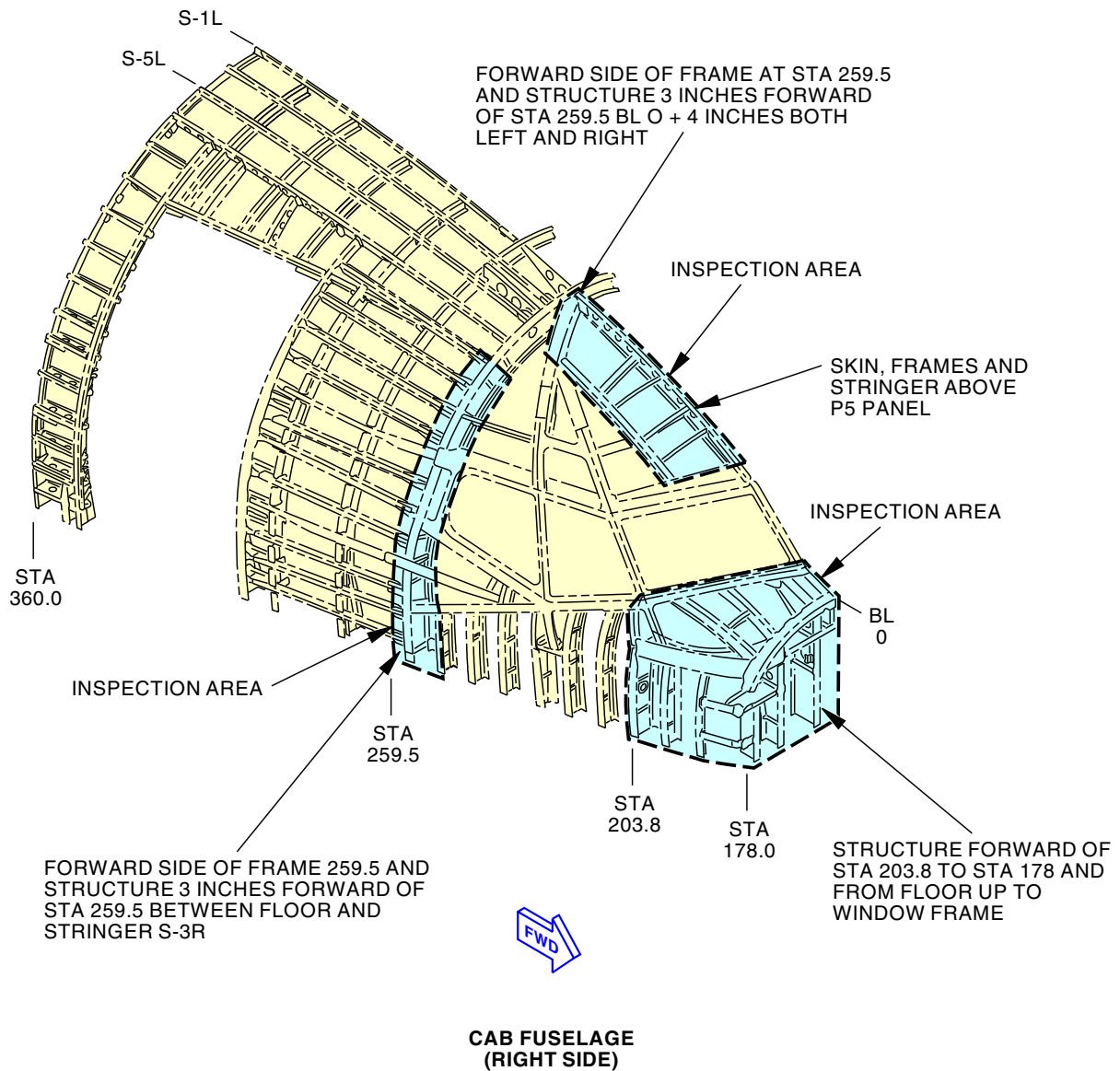
FLIGHT COMPARTMENT FROM STA 178 TO 270
Figure 261/53-05-03-990-861 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

53-05-03

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D633AM101-SIA



2416128 S00061539796_V1

FLIGHT COMPARTMENT FROM STA 178 TO 270
Figure 261/53-05-03-990-861 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

SIA 015-999

TASK 53-05-03-210-844

56. INTERNAL - GENERAL VISUAL: CROWN SKIN PANEL

(Figure 262)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This task has instructions to do a general visual inspection of the crown skin panel.

B. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)
53-54-00-000-801	Broadband Radome Removal (P/B 401)
53-54-00-000-802	Adapter Plate Assembly Removal (P/B 401)
53-54-00-400-801	Broadband Radome Installation (P/B 401)
53-54-00-400-802	Adapter Plate Assembly Installation (P/B 401)

C. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

D. Crown Skin Panel Inspection

SUBTASK 53-05-03-020-001

- (1) Remove the broadband radome (TASK 53-54-00-000-801).

SUBTASK 53-05-03-020-002

- (2) Remove the adapter plate (TASK 53-54-00-000-802).

SUBTASK 53-05-03-210-044

- (3) Do a general visual inspection of the crown skin and lugs under the adapter plate.

SUBTASK 53-05-03-910-056

- (4) Basic task description, TASK 51-05-01-210-806.

SUBTASK 53-05-03-420-001

- (5) Install the adapter plate (TASK 53-54-00-400-802).

SUBTASK 53-05-03-420-002

- (6) Install the broadband radome (TASK 53-54-00-400-801).

SUBTASK 53-05-03-710-001

- (7) Do the operation check of the satellite antenna system.

———— **END OF TASK** ————

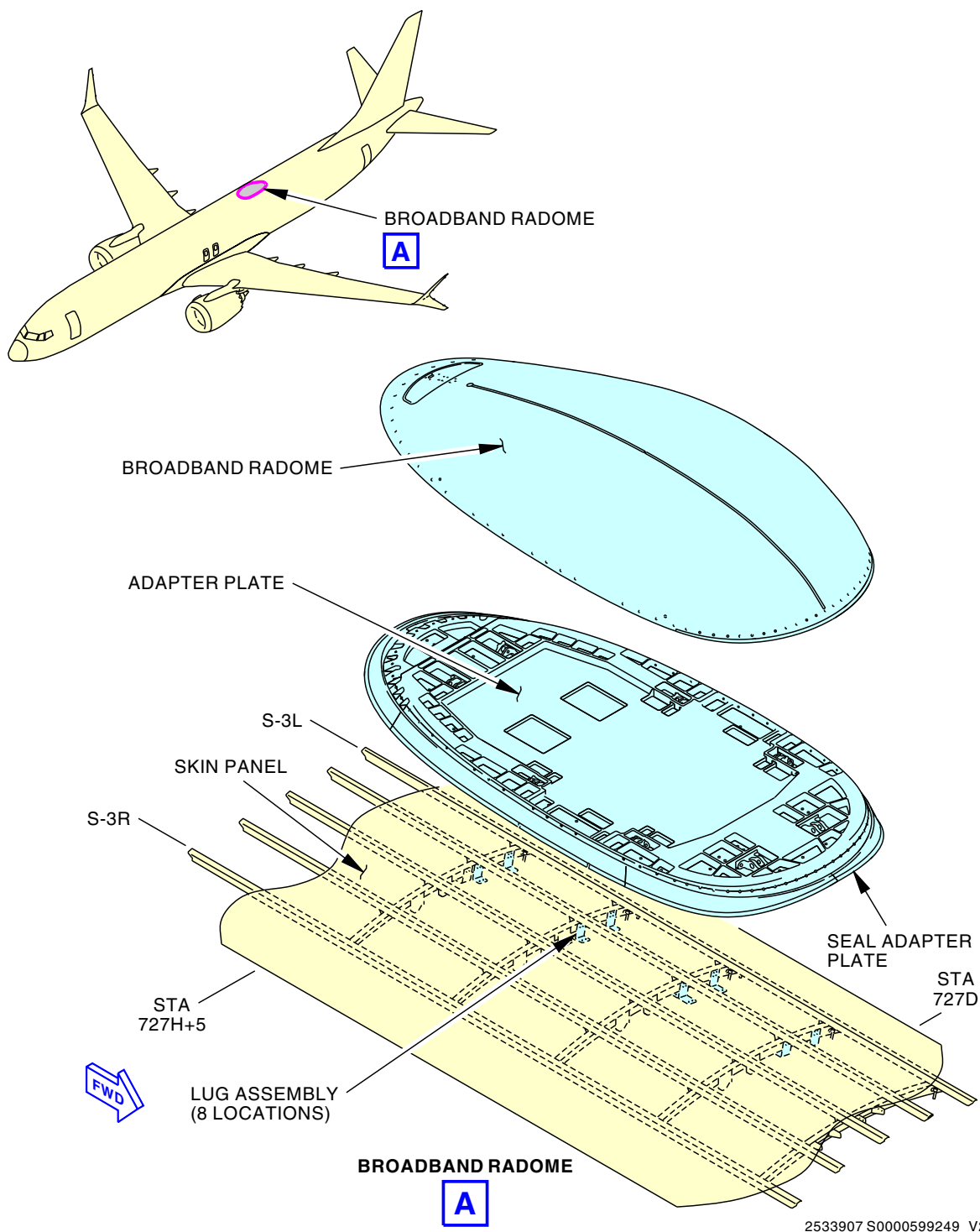
EFFECTIVITY
SIA ALL

53-05-03

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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Broadband Radome
Figure 262/53-05-03-990-862

EFFECTIVITY
SIA 015-999

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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SIA ALL

TASK 53-05-03-210-853

57. INTERNAL - GENERAL VISUAL INSPECTION OF THE AREA AFT OF STA 1016 BULKHEAD

NOTE: This procedure is a scheduled maintenance task.

A. Access Panels

<u>Number</u>	<u>Name/Location</u>

311BL	Stabilizer Trim Access Door

B. Prepare for the Procedure

SUBTASK 53-05-03-010-065

(1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>

311BL	Stabilizer Trim Access Door

C. Procedure

SUBTASK 53-05-03-210-052

(1) Do an internal general visual inspection of the area aft of STA 1016 pressure bulkhead to STA 1088, including:

(a) Skin panels (skins, frames and stringers), longitudinal lap splices, circumferential skin and stringer splices.

(b) Aft side of STA 1016 bulkhead (chords, pressure web, stiffeners, chord/web attachments).

(c) Stringer splice fittings and tension bolts at STA 1016.

(d) STA 1088 bulkhead, including vertical fin rear spar fittings and horizontal stabilizer center section jackscrew fitting lugs and bolts.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 53-05-03-410-050

(1) Close this access panel:

<u>Number</u>	<u>Name/Location</u>

311BL	Stabilizer Trim Access Door

————— **END OF TASK** —————

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FRAMES AND BULKHEADS - MAINTENANCE PRACTICES

1. General

A. This procedure contains 7 tasks:

- (1) Corrosion Prevention of the Crown Frames, Stringers and Skin.
- (2) Corrosion Prevention of the Lower Lobe Structure.
- (3) Corrosion Prevention of the Galley and Lavatory Areas.
- (4) Corrosion Prevention of the Main Gear Wheel Well and Keel Beam.
- (5) Corrosion Prevention of the Nose Gear Wheel Well.
- (6) Corrosion Prevention of the Door Openings.
- (7) Corrosion Prevention of the Upper Lobe Frames, Stringers and Skin.

TASK 53-11-00-600-801

2. Crown Frames, Stringers and Skin - Corrosion Prevention

Figure 201

A. General

- (1) The fuselage is of semimonocoque construction utilizing aluminum skins, circumferential frames and longitudinal hat section stringers. The fuselage skin is installed with circumferential butt joints and longitudinal lap joints that are usually flush riveted. Skins should be treated concurrently with fuselage structure.
- (2) The stringers, frames and skins have been found susceptible to corrosion due to moisture entrapment between the skin and insulation blankets. Added to this moisture spillage, condensation or moisture through open doors running along frames or stringers collecting at some dammed location contribute to corrosion. Corrosion can readily start where protective finishes have been broken or deteriorated.
- (3) Treatment of the interior structure should be accomplished at the same time as longitudinal lap splices are treated or whenever access is gained to expose the frame/stringer/skin structure. For lap splices, refer to CORROSION INSPECTION AND DETECTION, SUBJECT 51-00-51.
- (4) Insulation blankets are provided on cabin interiors for passenger comfort and to minimize the condensation of warm cabin air on cold skins and stringers. Corrosion has been experienced in areas where the blankets are not installed taut and wrap around stringers or lay on the skins. Reports of water soaked blankets have been common in these instances.
- (5) Delamination of the waffle doublers on the crown and side skin panels has been reported. If left untreated, delaminated doublers may promote corrosion and cracking of the skin interior and doublers.
- (6) Stress corrosion has been attributed to reported three cracks in the right side BS540 bulkhead forging refer to Figure 201 (Sheet 1).
- (7) Refer to STANDARD PRACTICES AND STRUCTURES, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

B. References

Reference	Title
51-00	STANDARD PRACTICES AND STRUCTURES
51-00-51	CORROSION INSPECTION AND DETECTION

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Reference	Title
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
SRM 737-MAX	D000534530

C. 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
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. Location Zones

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

E. Corrosion Prevention

SUBTASK 53-11-00-610-001

- (1) Make the periodic inspection described in CORROSION INSPECTION AND DETECTION, SUBJECT 51-00-51 to preclude or detect the early stages of corrosion. Missing fasteners, white powdery or any discolored deposits are evidences of the existence of corrosion which should alert operators that some corrective action is required. A corrosion prevention program should be initiated to prevent the accumulation of corrosive products in order to minimize the occurrence of corrosion.

SUBTASK 53-11-00-610-002

- (2) Corrosion Inspection/Removal
- (a) Following cleaning of suspected areas, a visual inspection utilizing bright lighting and mirror is effective for identifying the existence of corrosion. In specific localized areas where inspection by visual means is impossible or where extent of corrosion has to be determined after visual detection, CORROSION INSPECTION AND DETECTION, SUBJECT 51-00-51 for applicable method.
 - (b) Where corrosion exists (noticeable bulges of the skin or white deposits of corrosion products at fastener heads or joint edges), refer to SRM 737-MAX for details of corrosion removal.
 - (c) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by an application of a corrosion inhibiting compound into the affected area to retard the corrosion process. The finish system should be restored at the next maintenance opportunity (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59).

SUBTASK 53-11-00-610-003

- (3) Application of Corrosion Inhibitors
- (a) For details of application of water displacing corrosion inhibiting compound, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-11-00-610-004

- (4) Prevention Treatment
- (a) Maintenance Prevention

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- 1) At first opportunity when scheduled maintenance work allows access to the structure, corrosion prevention treatment should be accomplished.
 - 2) Remove insulation blankets to expose frame, stringer and skin. Dry blankets thoroughly if found wet.
 - 3) Open plugged drains.
 - 4) Replace broken or damaged finishes. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems.
 - 5) In all areas, except where indicated, apply a coat of epoxy primer, C00259 primer to inboard flanges of stringers and allow to dry thoroughly.
 - 6) Allow solvent to evaporate before reinstalling insulation blankets.
 - 7) Reinstall blankets so they are taut and so that the outboard surfaces of the upper blanket overlap the lower blanket.
- (b) Improved Corrosion Protection
- 1) Apply corrosion inhibiting compound, G00009 to all exposed structure. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for methods of application of corrosion inhibiting compound, G00009.
 - 2) Some airplane have had the tightly sealed covers replaced with unsealed covers to permit water to enter the blanket and drain. The blankets serve as drain paths into the lower lobe drain masts. Water repellent blanket filler is used.
 - 3) The sealant, A00247 class F, is applied by spray, brush or roller coating to the inner flanges of stringers and edges of frames where contacted by the insulation blankets above the window belt, between stations 259.5 and 1015. Airplane stringers may have sealant, A00247 or an additional coat of yellow primer, C00259.

SUBTASK 53-11-00-610-005

(5) Frequency of Application

- (a) Periodic inspection is required to areas identified susceptible to corrosion and should be consistent to the schedules identified in the Maintenance Planning Document. Operators must be aware of reported problems and areas of occurrences.
- (b) Periodic application of corrosion inhibiting compound, G00009 compounds is necessary to areas identified and should be consistent to the schedule specified in the Maintenance Planning Document.

————— **END OF TASK** —————

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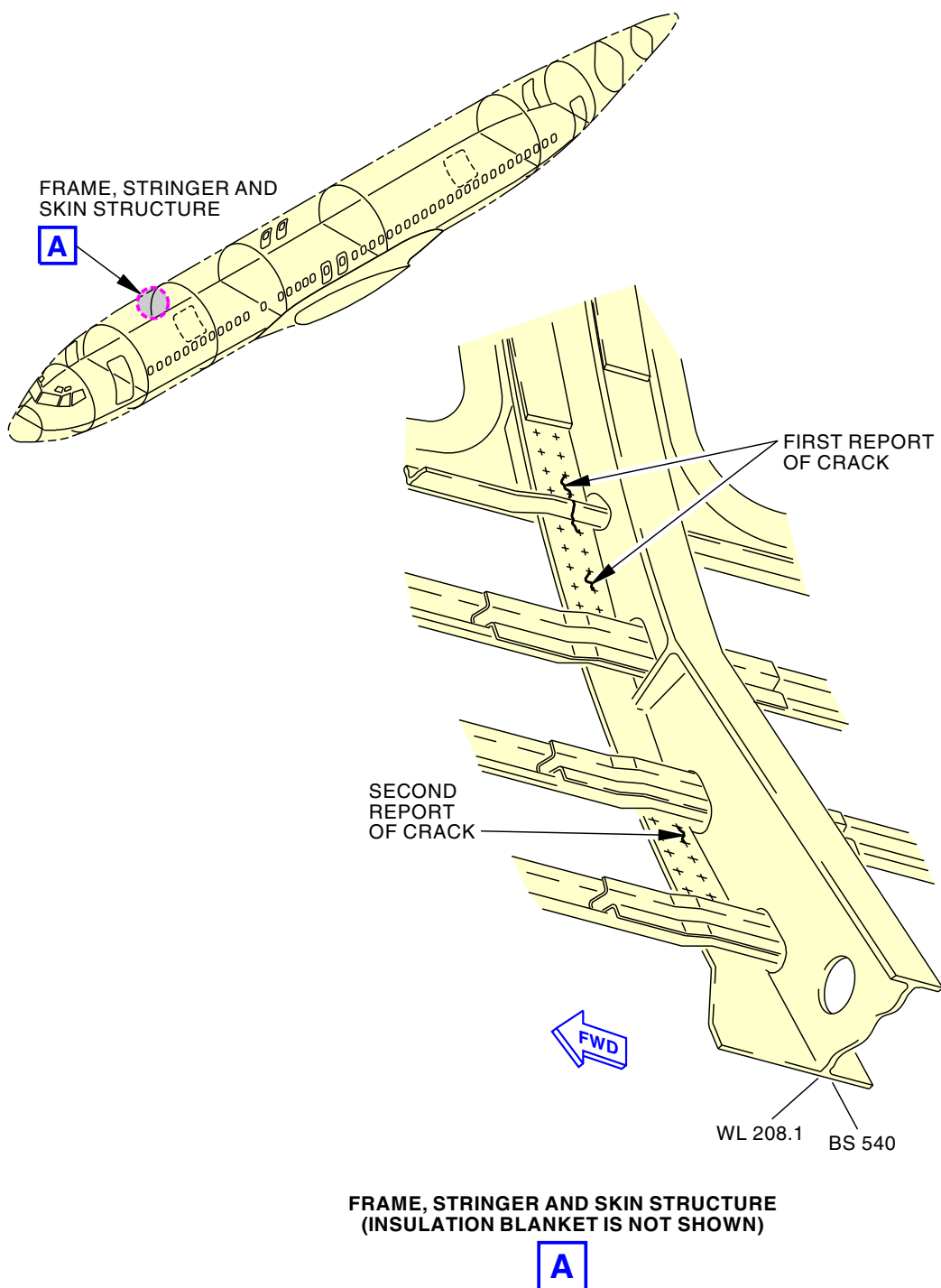
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Crown Frames, Stringers and Skin
Figure 201/53-11-00-990-801 (Sheet 1 of 2)

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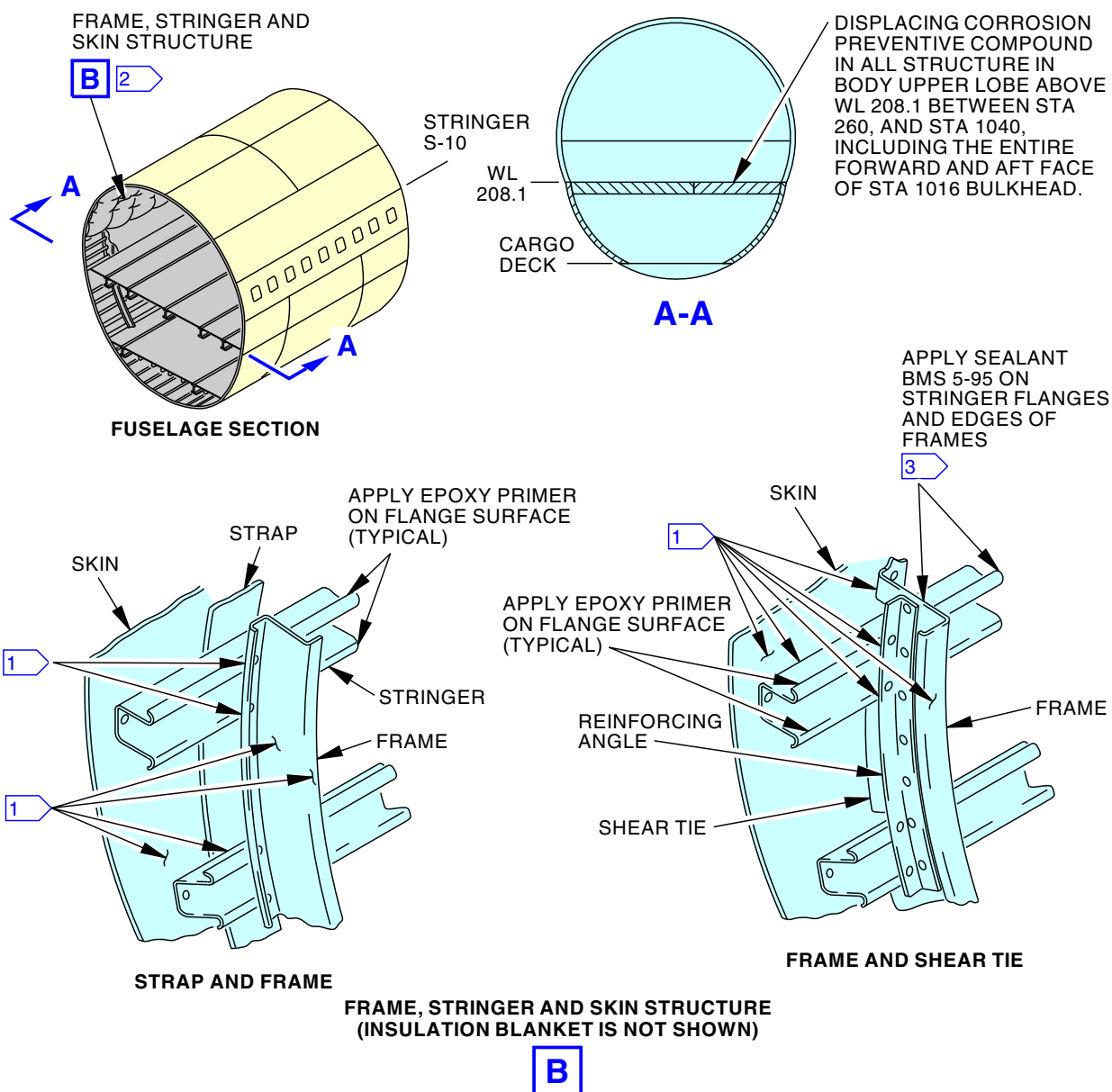
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- 1 APPLY BMS 3-23 TO ALL EXPOSED STRUCTURE.
- 2 WHEN INSULATION BLANKETS ARE REINSTALLED, ENSURE THAT OUTBOARD SURFACE OF UPPER BLANKET OVERLAPS LOWER BLANKET.
- 3 IN AREAS ABOVE THE WINDOW BELT BETWEEN STA 259.5 AND STA 1015 WHERE BLANKETS CONTACT STRINGER FLANGES AND EDGES OF FRAMES. BETWEEN BODY STATIONS 540 AND 1016 WHERE STRINGER SOUND DAMPING CAPS ARE USED, SEALANT IS NOT REQUIRED.

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Crown Frames, Stringers and Skin
Figure 201/53-11-00-990-801 (Sheet 2 of 2)

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TASK 53-11-00-600-802

3. Lower Lobe Structure - Corrosion Prevention

Figure 202

A. General

- (1) The fuselage is of semimonocoque construction utilizing aluminum skins, circumferential frames and longitudinal stringers. The fuselage skin is installed with circumferential butt joints and longitudinal lap joints. The floor beams act as tension ties across the frames. In the lower lobe area, shear ties from the skin to the frame are used between stringers with an inner angle on the frame.
- (2) The lower lobe structure including stringers, frames, shear ties, faying surfaces at doublers and straps, etc., are susceptible to corrosion due to moisture accumulation, moisture laden insulation blankets, cargo spillage, toilet effluent leakage and environmental contaminants. The lower lobe areas described herein include the cargo compartments, bilge areas and the electronic compartment.
- (3) To help clean out contamination in the lower lobe, dam divide the bilge into compartments for optional hose out operations (Figure 202 (Sheet 3))
- (4) At the nose wheel well, the three hinge bracket supports for the wheel well doors on the left and right side have pockets that can catch moisture.
- (5) Insulation blankets are provided on cabin interiors for passenger comfort and to minimize the condensation of warm cabin air on cold skins and stringers. Corrosion has been experienced in areas where the blankets are not installed taut and wrap around stringers or lay on the skins. Reports of water soaked blankets have been common in these instances.
- (6) Treatment of the areas under galleys and lavatories is described in Figure 203.
- (7) Areas where corrosion is of particular concern is from BS 260 to BS 360, stringers S-19 left to S-19 right.
- (8) Refer to STANDARD PRACTICES AND STRUCTURES, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

B. References

Reference	Title
51-00	STANDARD PRACTICES AND STRUCTURES
51-00-51	CORROSION INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
SRM 737-MAX	D000534530

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C00032	Coating - Protective Enamel, General Use	BMS10-60 Type I
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00260	Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel	BMS10-11 Type II
D00633	Grease - Aircraft General Purpose	BMS3-33

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(Continued)

Reference	Description	Specification
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. Location Zones

Zone	Area
100	Lower Half of Fuselage

E. Corrosion Prevention

SUBTASK 53-11-00-610-006

- (1) Make the regular inspections of CORROSION INSPECTION AND DETECTION, SUBJECT 51-00-51 to stop of find the start of corrosion. Inspect the areas beneath the forward and aft cargo floors. Skin bulges, missing fasteners, or white powdery deposits are signs of corrosion.

SUBTASK 53-11-00-610-007



DO NOT APPLY THE CORROSION-INHIBITING COMPOUNDS IN THE AREAS THAT HAVE OXYGEN SYSTEM COMPONENTS. THE MIXTURE OF CORROSION-INHIBITING COMPOUNDS, AND OXYGEN CAN CAUSE AN EXPLOSION. AN EXPLOSION CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.



DO NOT INSTALL THE INSULATION BLANKETS THAT ARE SOAKED WITH CORROSION INHIBITING COMPOUNDS. INSULATION BLANKETS INADVERTENTLY SPATTERED WITH THE CORROSION INHIBITING COMPOUNDS SHOULD BE ALLOWED TO DRY BEFORE INSTALLATION. SOAKED INSULATION BLANKETS ARE POTENTIAL FIRE HAZARDS. THEY CAN CAUSE DAMAGE TO THE AIRPLANE.

- (2) If you find corrosion (skin bulges, missing fasteners or large amounts of white deposits at the fastener heads or faying surfaces), refer to SRM 737-MAX for details of corrosion removal.

SUBTASK 53-11-00-610-008

- (3) For details of application of water displacing corrosion inhibiting compound, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-11-00-610-009

- (4) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by an application of a corrosion inhibiting compound into the affected area to retard the corrosion process. The finish system should be restored at the first opportunity consistent with the maintenance schedule.

NOTE: The treatment of internal structure described above should be made at first opportunity the area is exposed. Location of the area should be noted and monitored from the outside every 3 months for visual indication of corrosion progression. Any noticeable skin bulges would require scheduling corrosion removal outlined in SRM 737-MAX.

SUBTASK 53-11-00-610-010

- (5) The corrosion inhibiting compound, G00009 should not be used in the vicinity of oxygen system components. The suggested protection system for areas near oxygen system components is as follows:
 - (a) Clean corrosion and repair affected area per the SRM 737-MAX.
 - (b) Chemical treat bare aluminum surfaces.

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- (c) Apply one coat of green primer, C00259 Type 1.
- (d) Apply one coat of yellow primer, C00259 type 1.
- (e) Apply coating, C00260, type 2 epoxy or coating, C00032 polyurethane enamel top coat.

SUBTASK 53-11-00-610-011

(6) Prevention Treatment

- (a) At first opportunity when scheduled maintenance work allows access to the structure, corrosion prevention treatment should be accomplished.
- (b) Remove sidewall lining and insulation blankets in the cargo compartment and beneath the upper lobe entry and cargo doors to expose frame, stringer, doublers and skin.
- (c) Remove floor panels to gain access to bilge areas, if required.
- (d) Remove ceiling lining for access to main deck floor beams and intercostals.
- (e) Open plugged drains.
- (f) Make sure that all drain paths are clear at the frames and stringers in the airframe lower lobe and stringer ends at station bulkhead.
- (g) Replace broken or damaged finishes. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems.
- (h) Apply a coat of primer, C00259 primer to the inboard flange surfaces of stringers and allow to dry thoroughly.
- (i) Replace or repair broken or damaged leveling compounds used for drainage.
- (j) The chromate-loaded sealant, A00247, class F, is applied to the inboard flanges and to portions of the frames that come in contact with insulation blankets. Allow to cure for 48 hours. Note condition of the sealant and reapply as necessary.
- (k) Apply corrosion inhibiting compound to all exposed structure under the cargo floor and to the sidewalls beneath the upper lobe entry and cargo doors. The use of spray equipment with nozzle directed into faying surfaces is recommended. Do not apply excessively.

NOTE: To reduce the possibility of moisture entrapment between insulation blankets and airplane skins in the bilge area, supports for the insulation blankets were provided. These supports consist of nylon twine and brackets. Earlier installations utilizing silicone rubber loops may deteriorate because of exposure to hydrocarbons such as corrosion inhibitors and should be replaced with the nylon twine.

- (l) Allow solvent to evaporate before reinstalling insulation blankets.
- (m) Install blankets so they are taut and so that the outboard surfaces of the upper blanket overlap the lower blanket.
- (n) Install liners and floor panels. Install the floor panel fasteners with grease, D00633.

SUBTASK 53-11-00-610-012

(7) Frequency of Application

- (a) Periodic inspection is required to areas identified susceptible to corrosion and should be consistent to the schedules identified in the Maintenance Planning Document. Operators must be aware of reported problems and areas of occurrences.
- (b) Periodic application of corrosion inhibiting compound, G00009 compounds is necessary to areas identified and should be consistent to the schedule specified in the Maintenance Planning Document.

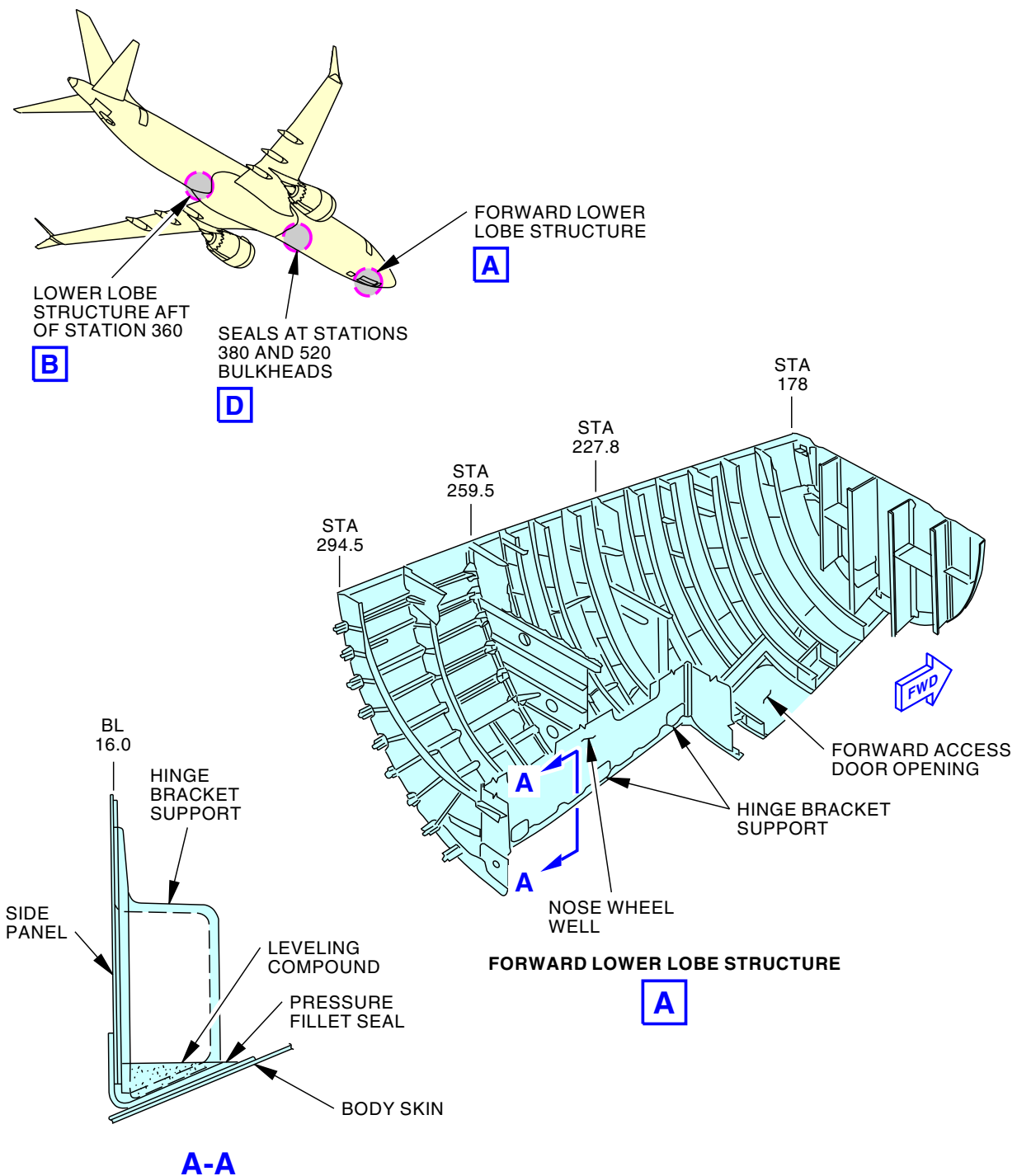
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Lower Lobe Structure
Figure 202/53-11-00-990-802 (Sheet 1 of 4)

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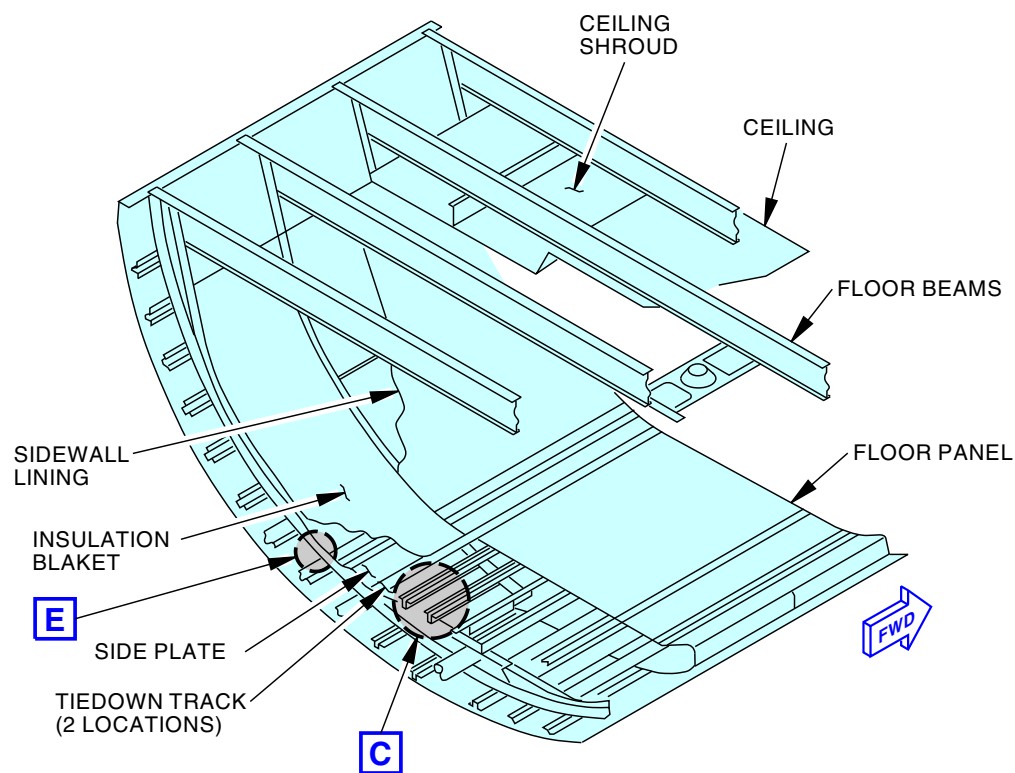
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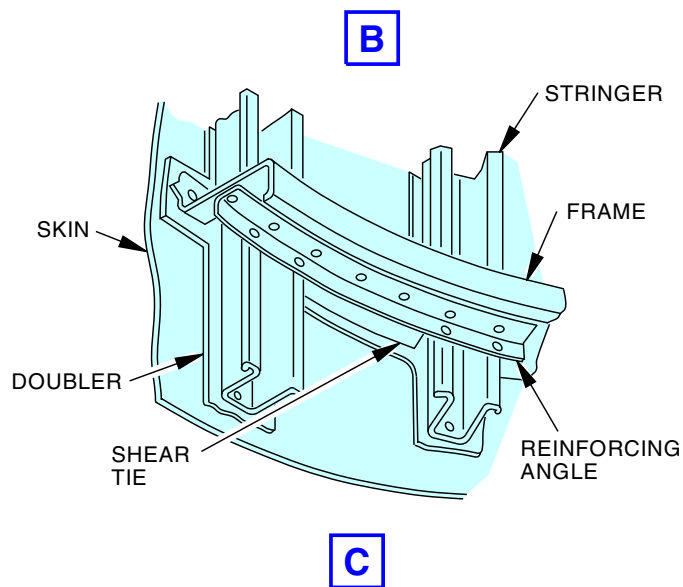
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LOWER LOBE STRUCTURE AFT



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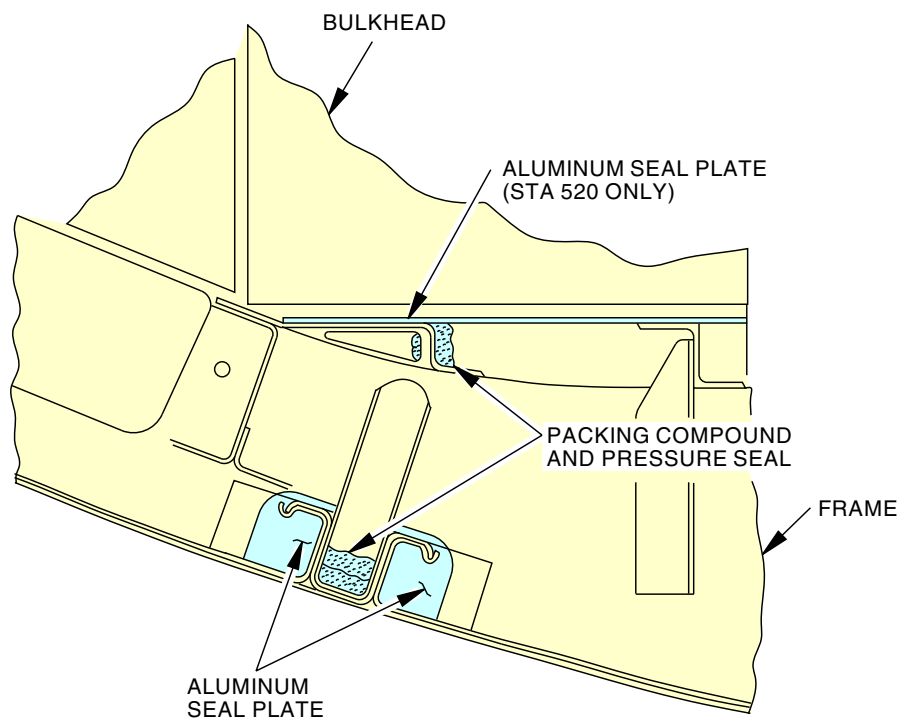
Lower Lobe Structure
Figure 202/53-11-00-990-802 (Sheet 2 of 4)

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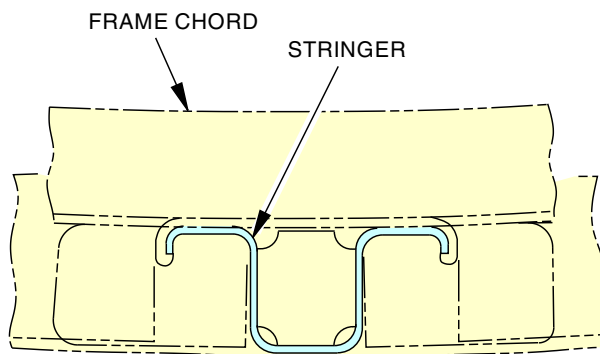
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SEALS AT STATIONS 380 AND 520 BULKHEADS

D



DAMS FOR HOSE-OUT OPTION

E

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Lower Lobe Structure
Figure 202/53-11-00-990-802 (Sheet 3 of 4)

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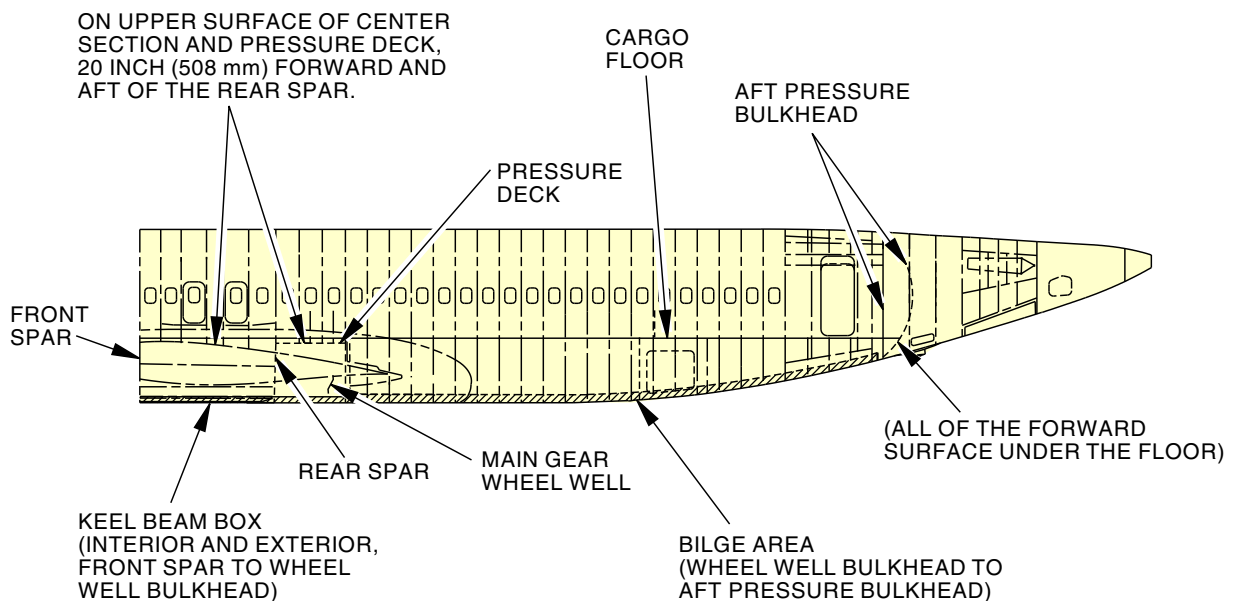
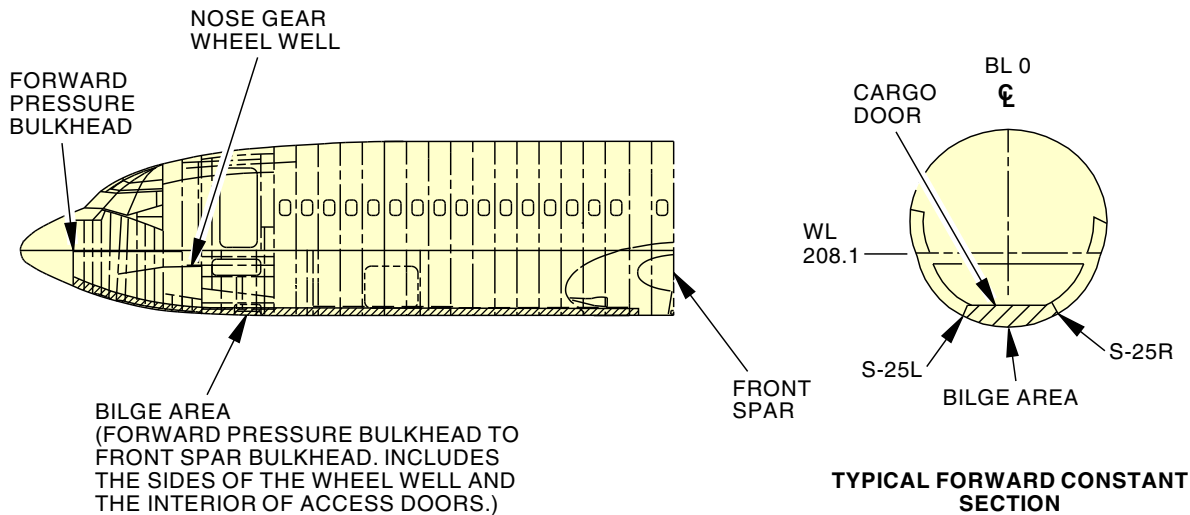
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Lower Lobe Structure
Figure 202/53-11-00-990-802 (Sheet 4 of 4)

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TASK 53-11-00-600-803

4. Galley and Lavatory Areas - Corrosion Prevention

Figure 203

A. General

- (1) Areas under galleys and lavatories are susceptible to corrosion because of spillage of fluids or food. Leakage from plumbing lines also contributes to corrosion. Seat tracks in galley or lavatory areas are particularly susceptible because of exposure to traffic debris and spillage which collect inside the track. Corrosion has also been reported on the forward lavatory bulkhead-to-floor area and door post, aft of the lavatory door.
- (2) Insulation blankets are provided on cabin interiors for passenger comfort and to minimize the condensation of warm cabin air on cold skins and stringers. Corrosion has been experienced in areas where the blankets are not installed taut and wrap around stringers or lie on the skins. Reports of water soaked blankets have been common in these instances.
- (3) Unsealed covers permit water to enter the blanket and drain. The blankets serve as drain paths into the lower lobe drain masts. Water repellent blanket filler is used.
- (4) A water dam and seal has been added to the outboard side of the forward lavatory floor, and between the aft lavatories. Floor drains have been added to the aft lavatories and a drain installation to the forward lavatory.
- (5) Corrosion of the bulkhead web can result in severe cracks and rapid cabin depressurization. The corrosion, can be contributed to fluids from galleys and lavatories. A plugged drain hole in the station 1016 frame chord assembly can trap these fluids and thereby accelerate the corrosion process. See Figure 203 for aft pressure bulkhead.
- (6) Apply corrosion inhibiting compound corrosion inhibiting compound, G00009 to wet areas (doorways, galleys and lavatories) of the main cabin Ref. (Figure 203).
- (7) Refer to STANDARD PRACTICES AND STRUCTURES, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

B. References

Reference	Title
51-00	STANDARD PRACTICES AND STRUCTURES
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
SRM 737-MAX	D000534530

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
D00633	Grease - Aircraft General Purpose	BMS3-33
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. Location Zones

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

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E. Corrosion Prevention

SUBTASK 53-11-00-610-013

- (1) Periodically examine galley and lavatory areas to detect early stages of corrosion. Skin bulges, missing fasteners or white powdery deposits are evidences of the existence of corrosion which should alert operators that some corrective action is required. A corrosion prevention program should be initiated to prevent the accumulation of moisture in order to minimize the occurrence of corrosion.

SUBTASK 53-11-00-610-014

- (2) Where extensive corrosion exists (noticeable skin bulges, missing fasteners, or large amounts of white deposits) refer to SRM 737-MAX for details of corrosion removal.

SUBTASK 53-11-00-610-015



DO NOT APPLY THE CORROSION-INHIBITING COMPOUNDS IN THE AREAS THAT HAVE OXYGEN SYSTEM COMPONENTS. THE MIXTURE OF CORROSION-INHIBITING COMPOUNDS, AND OXYGEN CAN CAUSE AN EXPLOSION. AN EXPLOSION CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.



DO NOT INSTALL THE INSULATION BLANKETS THAT ARE SOAKED WITH CORROSION INHIBITING COMPOUNDS. INSULATION BLANKETS INADVERTENTLY SPATTERED WITH THE CORROSION INHIBITING COMPOUNDS SHOULD BE ALLOWED TO DRY BEFORE INSTALLATION. SOAKED INSULATION BLANKETS ARE POTENTIAL FIRE HAZARDS. THEY CAN CAUSE DAMAGE TO THE AIRPLANE.

- (3) For details of application of corrosion inhibiting compound, G00009, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-11-00-610-016

- (4) For minor corrosion to minimize the down time of the airplane, the corrosion products should be cleared off, followed by an application of a corrosion inhibiting compound into the affected area to retard the corrosion process. The finish system should be restored at the next maintenance opportunity (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59).

NOTE: The treatment of the internal structure described above should be made at the first opportunity the area is exposed. Location of the area should be noted and monitored from the outside every 3 months for visual indication of corrosion progression. Any noticeable skin bulges would require scheduling corrosion removal outlined in Structural Repair Manual.

SUBTASK 53-11-00-610-017

- (5) The treatment of seat tracks in the galleys and lavatories should be accomplished per Figure 203.

SUBTASK 53-11-00-610-018

- (6) Prevention Treatment

- (a) At the next maintenance opportunity and work allows access to the structure, corrosion prevention treatment should be accomplished.

NOTE: Preferred access to the floor structure is from the lower lobe.

- (b) Remove sidewall lining and insulation blankets to expose frames, stringers, doublers and skin.

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- (c) Remove floor panels to gain access to bilge areas.
- (d) Remove insulation blankets and liners (if any) from bulkheads in the immediate area below galleys or lavatories.
- (e) Remove ceiling lining for access to main deck floor beams and intercostals.
- (f) Open plugged drains, if any.
- (g) Clear all drain paths.
- (h) Refinish broken or damaged finishes. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems. Use interior finish system with polyurethane enamel topcoat.
- (i) Replace or repair broken or damaged leveling compounds used for drainage.
- (j) Apply sealant, A00247, class F, chromate-loaded sealant to the inboard flanges and to portions of the frames that come in contact with insulation blankets. Allow to cure for 48 hours. Note condition of the sealant and reapply as necessary.
- (k) Apply corrosion inhibiting compound, G00009 water displacing corrosion inhibiting compound to all structures under galleys and lavatories. Exposed structure of bulkheads should also be included. Special efforts should be made to apply the corrosion inhibitor to the top of the floor support structure where moisture may be trapped between the floor panel and floor support. The use of spray equipment with nozzle directed into faying surfaces is recommended. Do not apply excessively.

NOTE: To reduce the possibility of moisture entrapment between insulation blankets and airplane skins in the bilge area, supports for the insulation blankets were provided. These supports consist of nylon twine and brackets. Silicone rubber used on earlier installations may deteriorate due to exposure to hydrocarbons present in corrosion inhibiting compound and should be replaced with nylon twine.

- (l) Allow solvent in the corrosion inhibitor to evaporate before reinstalling insulation blankets.
- (m) Install blankets so they are taut and so that the outboard surfaces of lower blanket overlap the lower blanket.
- (n) Install liners and floor panels. Install the floor panel fasteners with grease, D00633.

SUBTASK 53-11-00-610-019

(7) Frequency of Application

- (a) It is recommended that corrosion inhibiting compound, G00009 water displacing corrosion inhibiting compound be applied to the lower lobe structure whenever the area is made accessible, at intervals not to exceed the "D" check.

————— **END OF TASK** —————

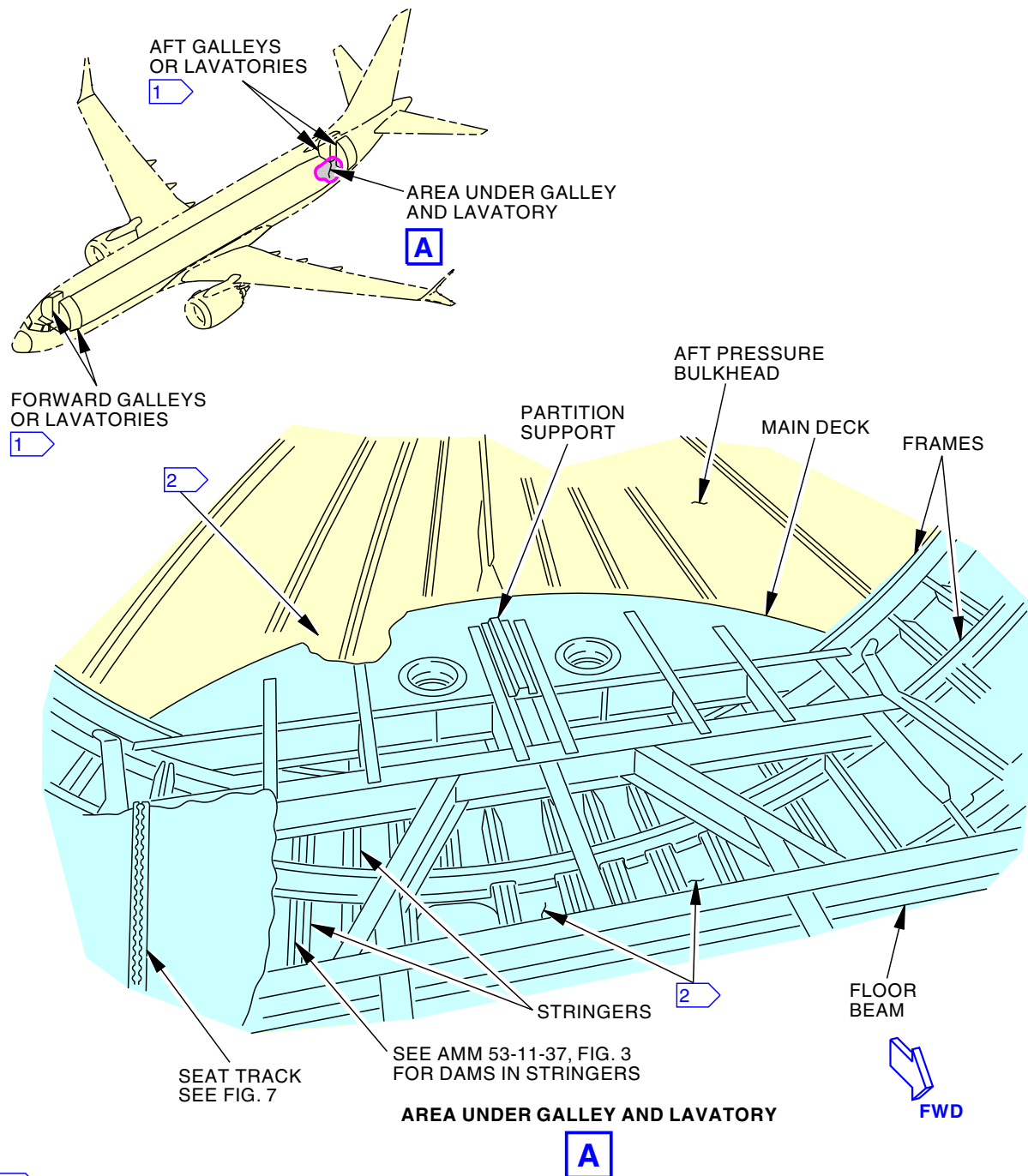
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- 1** LOCATION OF GALLEY AND LAVATORY VARIES
- 2** APPLY BMS 3-23 ON ALL EXPOSED STRUCTURE

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Galley and Lavatory Areas
Figure 203/53-11-00-990-803 (Sheet 1 of 3)

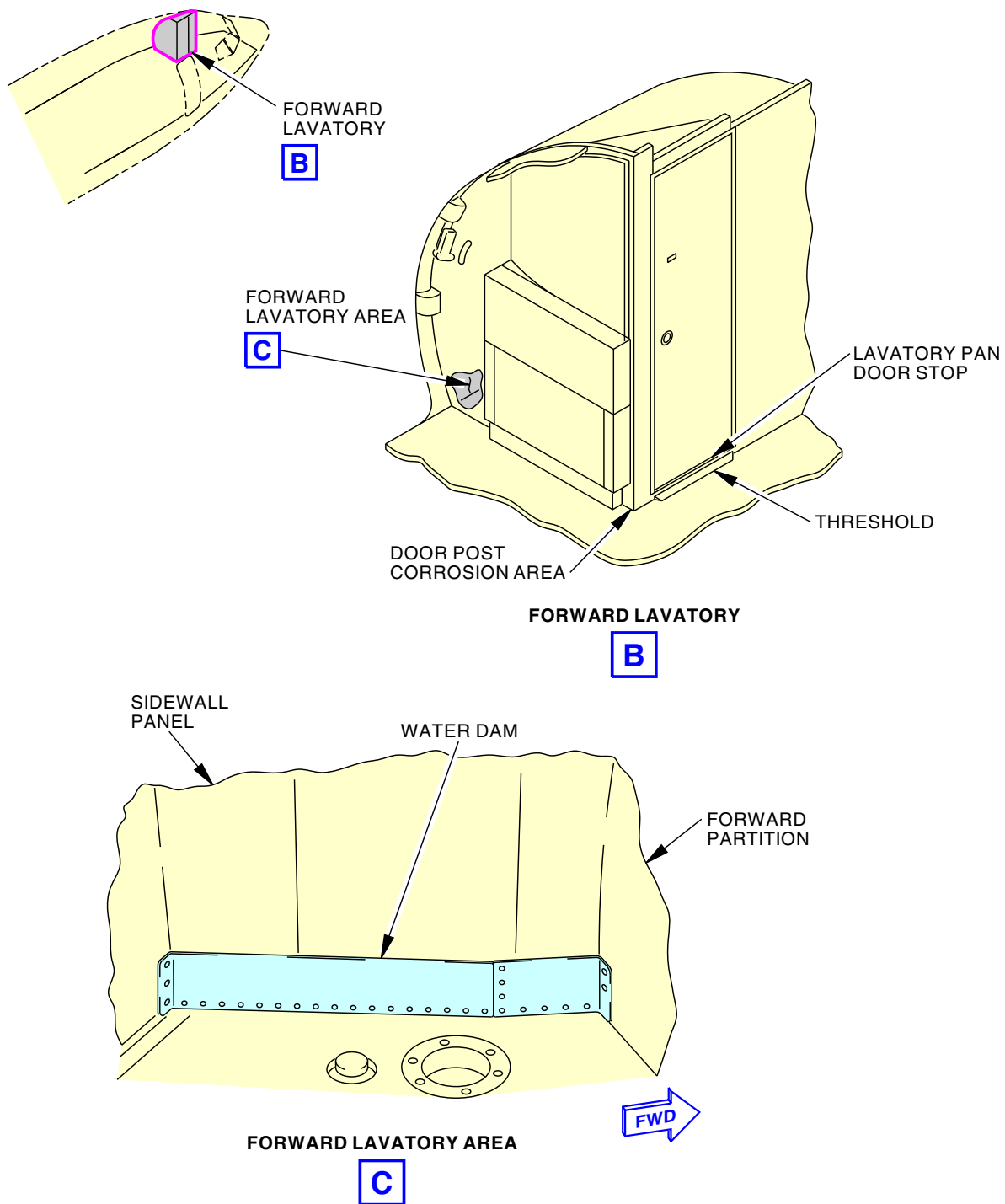
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Galley and Lavatory Areas
Figure 203/53-11-00-990-803 (Sheet 2 of 3)

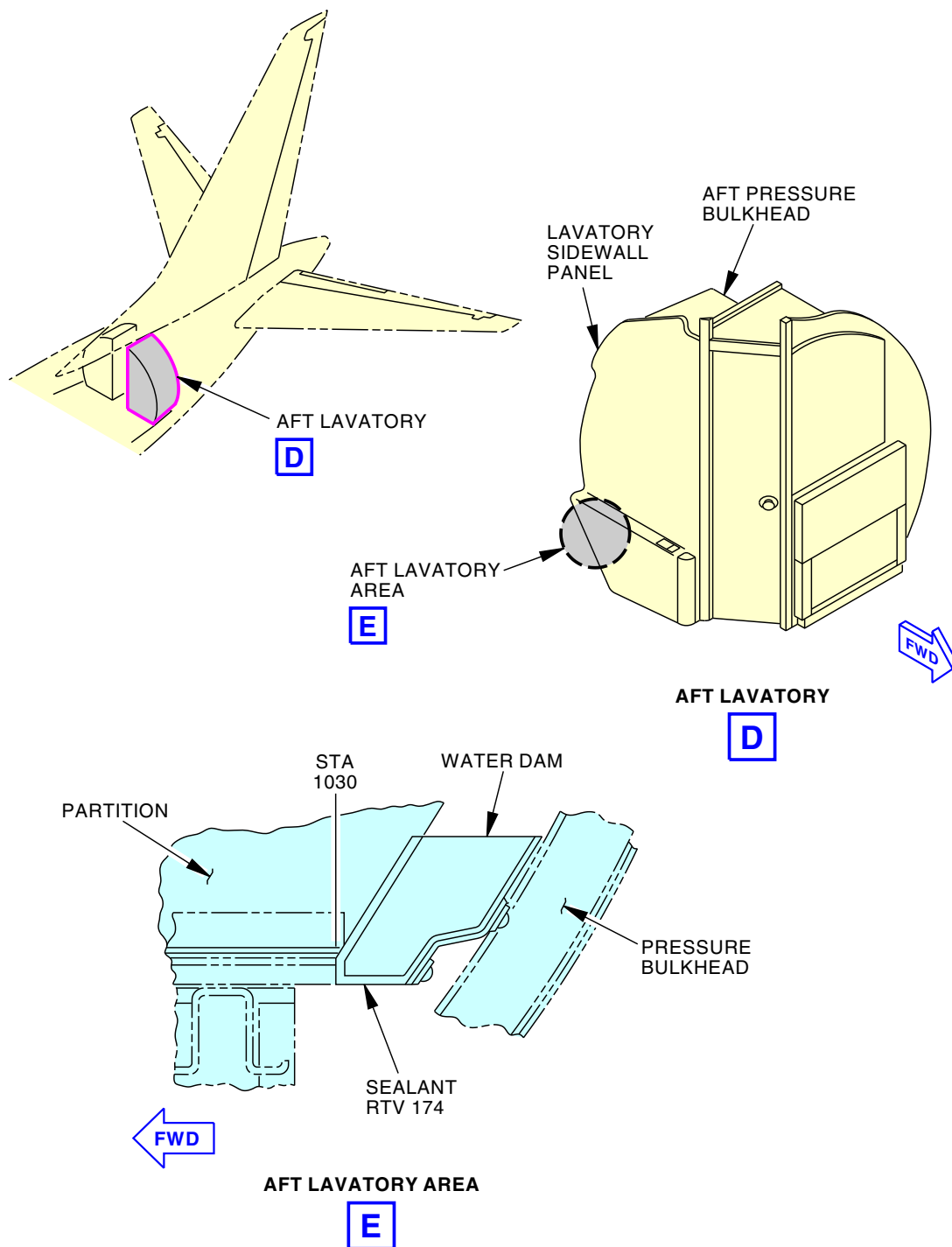
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Galley and Lavatory Areas
Figure 203/53-11-00-990-803 (Sheet 3 of 3)

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TASK 53-11-00-600-804

5. Main Gear Wheel Well and Kell Beam - Corrosion Prevention

Figure 204

A. General

- (1) The main gear wheel well is in the fuselage section aft of the bulkhead at the rear spar of the wing center section. The floor is formed by the wing to body fairing with an opening provided to fit the tire, with the outboard tire providing the closure for the cavity. A keel beam carries the longitudinal stress loads across the cavity. The wheel well in the fuselage extends into the inboard end of the wing trailing edge structure. The wing wheel well houses the greater portion of the landing gear components.
- (2) The surfaces inside the fuselage are exposed to air contaminants and runway splash and are subject to corrosion.
- (3) The wing wheel well should be treated at the same time as the trunnion attach fittings, the landing gear support beam and forward trunnion support structure.
- (4) Stress corrosion cracking can occur in the horizontal integral ribs of the BS 685 and 706 frames. Cracks have occurred at WL192, 202 and 208 on Sta 685 frames and at WL202 on STA 706 frames on both sides of airplanes. Cracks originated at, or passed through holes for fasteners used to attach shear webs to frame ribs. Cracks occurred in frames made from 7079 material.
- (5) Stress corrosion cracks can occur in the keel beam left and right lower tee chord. They initiated under the splice near the ends of the 7178-T6511 aluminum chords at Sta 743. Corrosion has also occurred between the tee chord and skin.
- (6) Corrosion can occur on the keel beam lower chord surfaces between STA 520 and STA 540 and aft of STA 727. Stress corrosion cracks on the keel beam lower chord at STA 590 and between STA 530 and STA 536.
- (7) Stress corrosion cracking can occur in the horizontal flange of the forward and aft frame fitting at STA 695. The cracks run along the line of fasteners common to the stringer S-18A shear beam Figure 204 (Sheet 2).
- (8) Stress corrosion cracks can occur in both left and right inboard splice tees of the keel beam at the main wheel well aft bulkhead Figure 204 (Sheet 3).
- (9) Refer to STANDARD PRACTICES AND STRUCTURES, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

B. References

Reference	Title
29	HYDRAULIC POWER
51-00	STANDARD PRACTICES AND STRUCTURES
51-00-51	CORROSION INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES

C. Consumable Materials

Reference	Description	Specification
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

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D. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right

E. Corrosion Prevention

SUBTASK 53-11-00-610-020

(1) General Philosophy

- (a) The basic corrosion prevention philosophy is to make the periodic inspection described in CORROSION INSPECTION AND DETECTION, SUBJECT 51-00-51 to preclude or detect the early stages of corrosion. Missing fasteners, white powdery or discolored deposits are evidences of the existence of corrosion which should alert operators that some corrective action is required. A corrosion prevention program should be initiated to prevent the accumulation of moisture or corrosive products in order to minimize the occurrence of corrosion.

SUBTASK 53-11-00-610-021

(2) Corrosion Inspection/Removal

- (a) Following cleaning of suspected areas, a visual inspection utilizing bright lighting and mirror is effective for identifying the existence of corrosion. In specific localized areas where inspection by visual means is impossible or where extent of corrosion has to be determined after visual detection, CORROSION INSPECTION AND DETECTION, SUBJECT 51-00-51 for applicable method.
- (b) Where corrosion exists (noticeable bulges of the skin or white deposits of corrosion products at fastener heads of joint edges), refer to Structural Repair Manual for details of corrosion removal.
- (c) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by the application of a corrosion inhibiting compound into the affected area to retard the corrosion process (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59). The finish system should be restored at the next maintenance opportunity.

SUBTASK 53-11-00-610-022

(3) Application of Corrosion Inhibitors

- (a) For details of application of water displacing corrosion inhibiting compound, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.
- (b) Hydraulic tubing, tubing supports and fittings are to be treated per HYDRAULIC POWER, CHAPTER 29.

SUBTASK 53-11-00-610-023

(4) Prevention Treatment

(a) Maintenance Prevention

- 1) At the next maintenance opportunity, corrosion prevention treatment should be accomplished in the wheel well and on the aft keel beam.
- 2) Treatment of the wheel well at the same time as the main gear is recommended.
- 3) Remove runway debris and generally clean the entire wheel well area.
- 4) Replace damaged or broken finishes if at all possible. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems.

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- 5) Apply corrosion inhibiting compound to all exposed wheel well structure. Special effort should be made to apply corrosion inhibitor along doubler edges, along faying surfaces and on fastener heads. The use of spray equipment with nozzle directed into faying surface is recommended.
- 6) Apply water displacing corrosion inhibiting compound to the frames at BS 685 and 706, WL 193 to 208.
- 7) Regrease all grease fittings in the treatment area.
- 8) In cases where the wheel well is cleaned with steam or high pressure water and detergent, reapplication of corrosion inhibiting compound is recommended.

SUBTASK 53-11-00-610-024

(5) Frequency of Application

- (a) Periodic inspection is required to areas identified as susceptible to corrosion and should be consistent to the schedules specified in the Maintenance Planning Document. Operators must be aware of reported problems and areas of occurrences.
- (b) Periodic application of corrosion inhibiting compound, G00009 is necessary to areas identified and should be consistent to the schedule specified in the Maintenance Planning Document.

————— **END OF TASK** —————

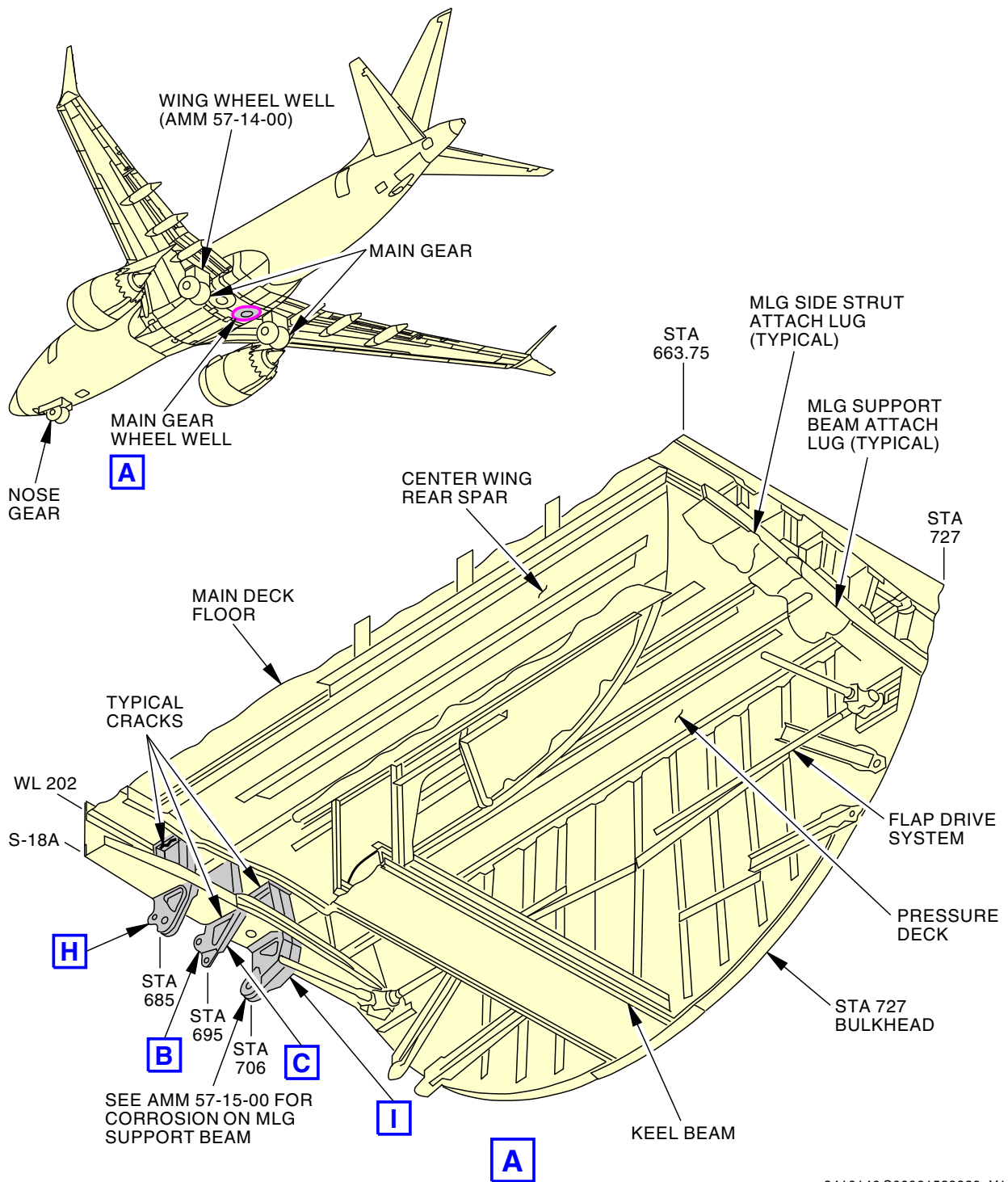
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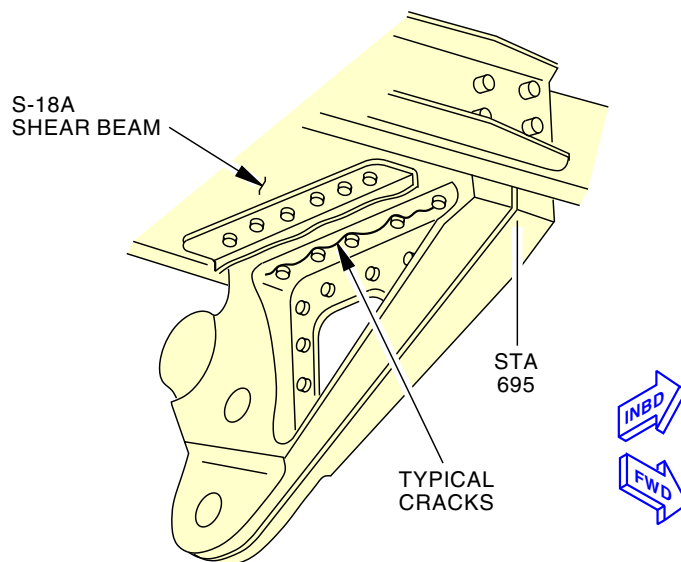
Main Gear Wheel and Keel Beam
Figure 204/53-11-00-990-804 (Sheet 1 of 5)

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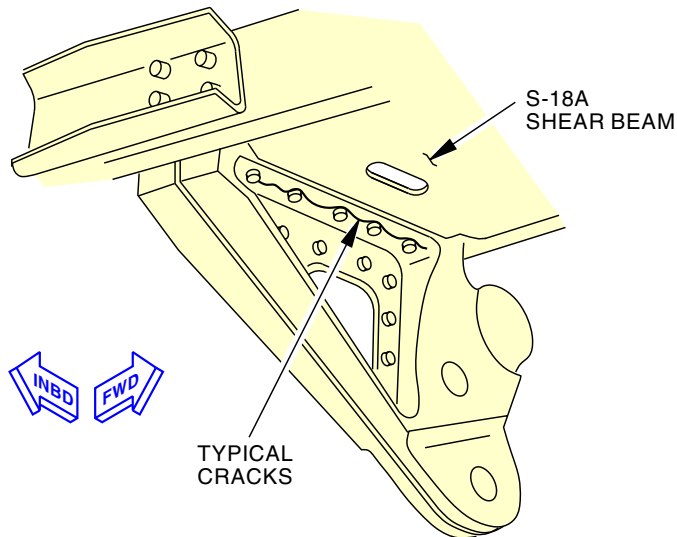
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B



C

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Main Gear Wheel and Keel Beam
Figure 204/53-11-00-990-804 (Sheet 2 of 5)

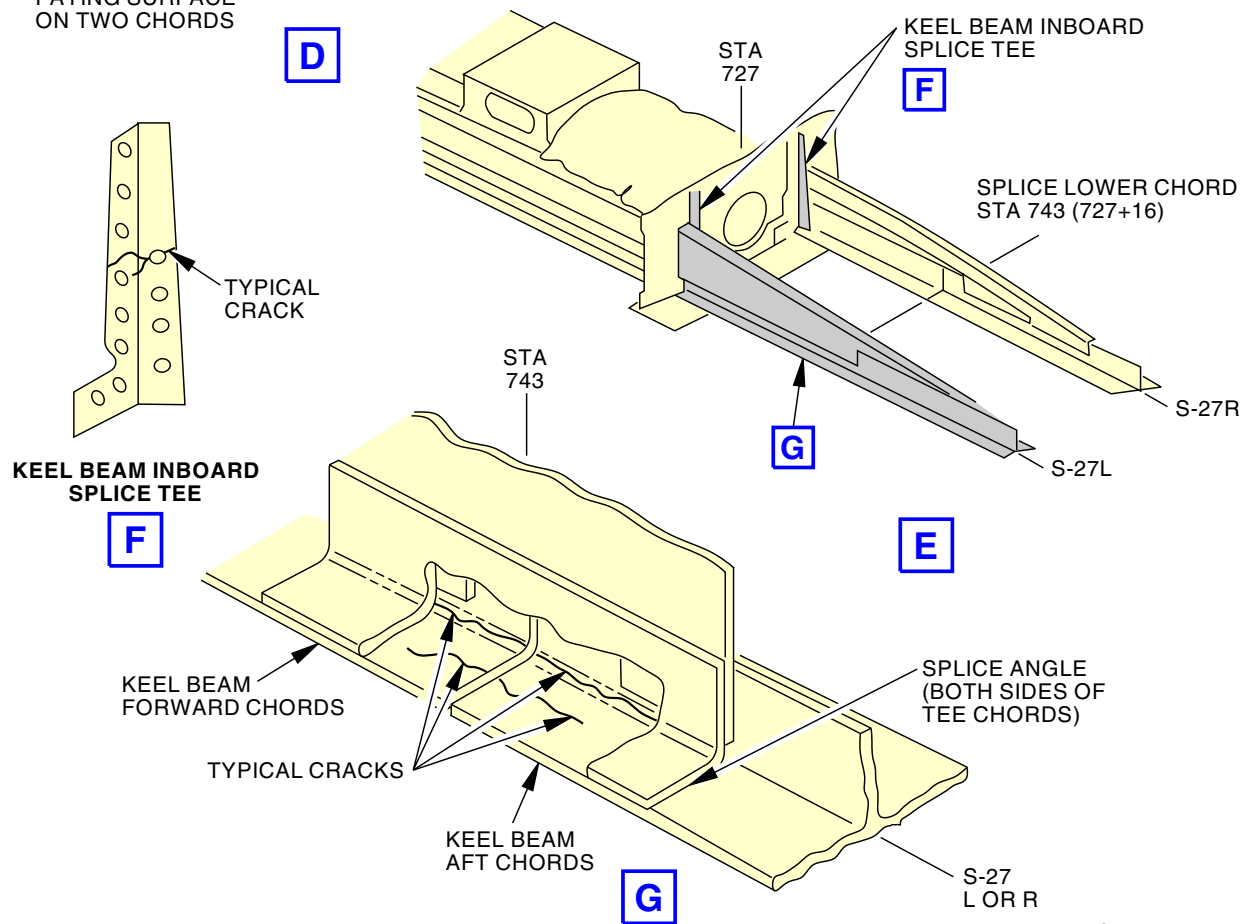
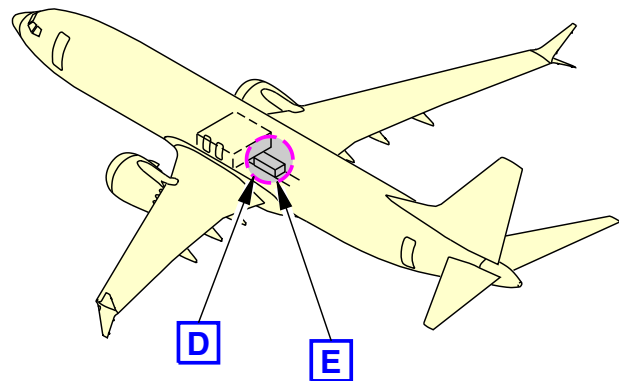
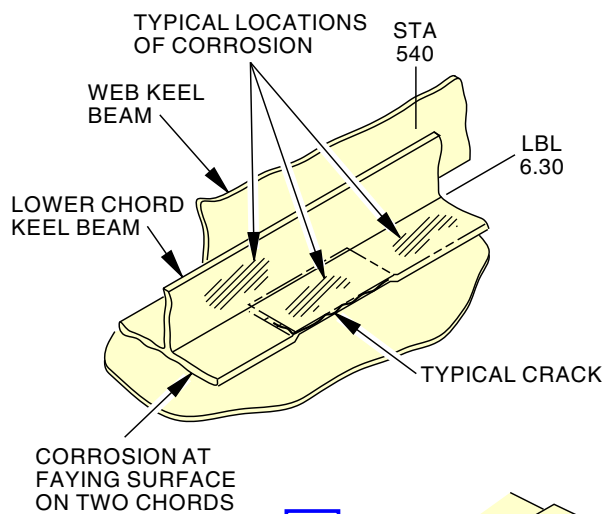
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Main Gear Wheel and Keel Beam
Figure 204/53-11-00-990-804 (Sheet 3 of 5)

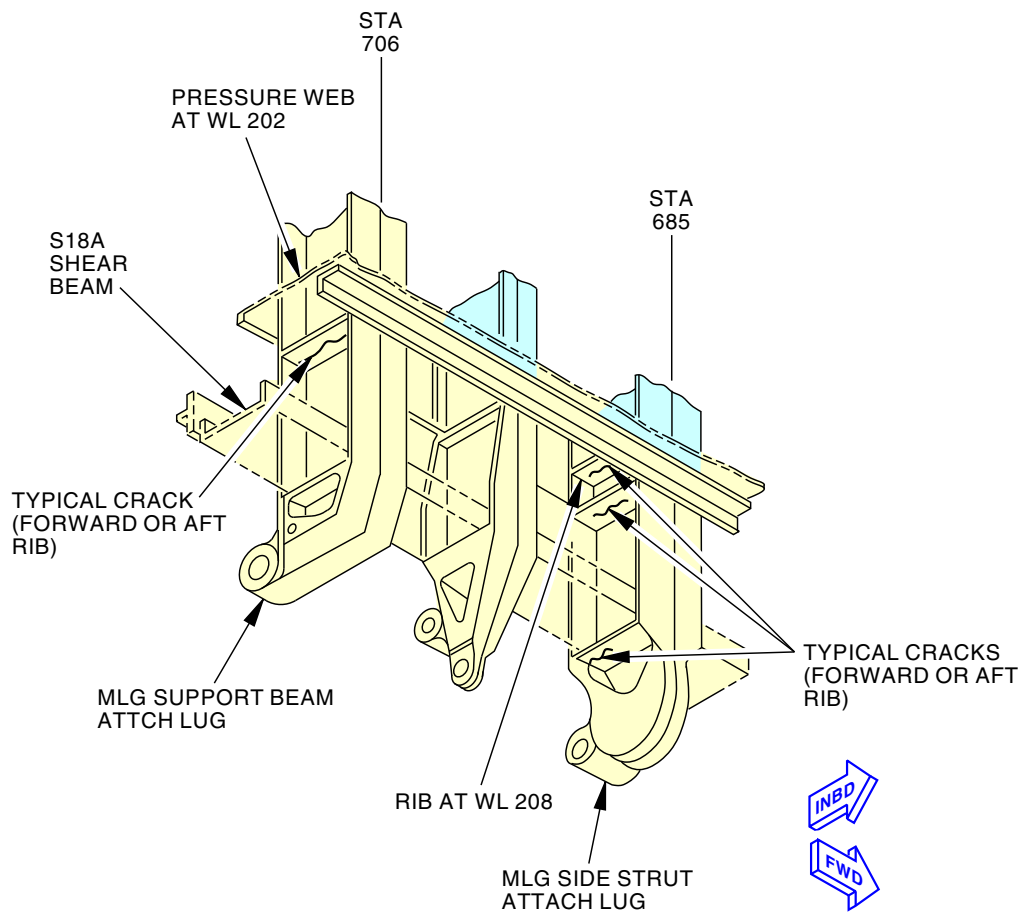
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(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)



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Main Gear Wheel and Keel Beam
Figure 204/53-11-00-990-804 (Sheet 4 of 5)

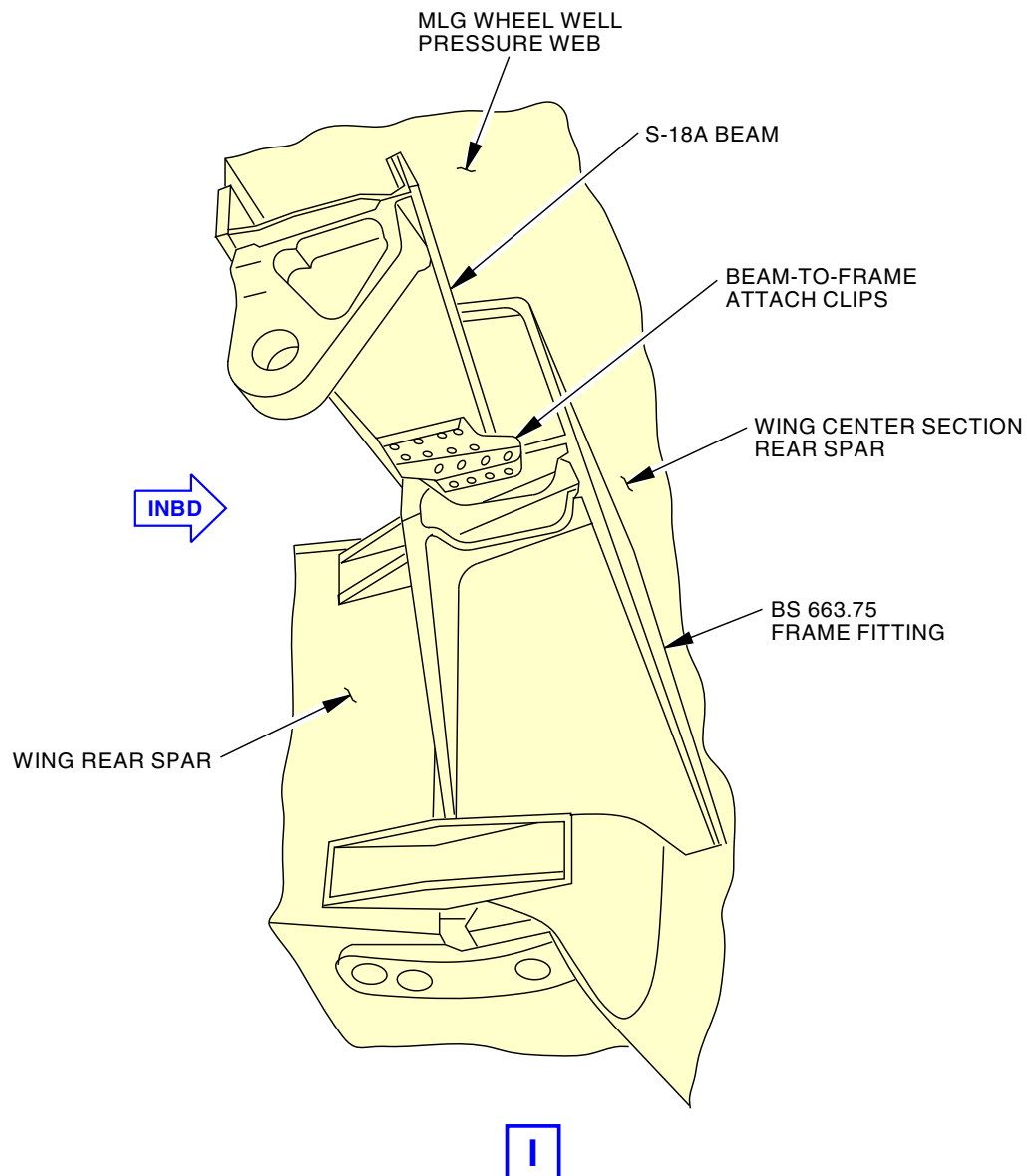
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Main Gear Wheel and Keel Beam
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TASK 53-11-00-600-805

6. Nose Gear Wheel Well - Corrosion Prevention

Figure 205

A. General

- (1) The nose gear wheel well is a rigid box structure consisting of a ceiling, two sidewalls, a forward and an aft wall and is located in the forward fuselage. The nose gear attachment fittings are located in the wheel well.
- (2) The surfaces inside the box structure are exposed to air contaminants and runway splash and are subject to corrosion. The nose gear attachment fittings are also found to be susceptible to corrosion.
- (3) Stress corrosion cracking can occur in the aluminum alloy actuator support fitting. Cracks can occur in the vertical leg midway between the rows of fastener holes.
- (4) Stress corrosion cracks have been reported on the LH and RH lock support fitting to which the strap is riveted. One of the cracks was between the two attach rivet holes and the other extended into the upper flange radius. It was determined that the strap induced clamp-up stresses in the fitting during strap installation. The strap was removed as a crack preventive measure.
- (5) Refer to STANDARD PRACTICES AND STRUCTURES, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

B. References

Reference	Title
51-00	STANDARD PRACTICES AND STRUCTURES
51-00-51	CORROSION INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES

C. Consumable Materials

Reference	Description	Specification
C00755	Compound - Organic Corrosion Inhibiting, Heavy Duty	BMS3-26
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. Location Zones

Zone	Area
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right

E. Corrosion Prevention

SUBTASK 53-11-00-610-025

- (1) Make the periodic inspection described in CORROSION INSPECTION AND DETECTION, SUBJECT 51-00-51 to preclude or detect the early stages of corrosion. Missing fasteners, white powdery or any discolored deposits are evidences of the existence of corrosion which should alert operators that some corrective action is required. A corrosion prevention program should be initiated to prevent the accumulation of corrosive products in order to minimize the occurrence of corrosion.

SUBTASK 53-11-00-610-026

- (2) Corrosion Inspection/Removal

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- (a) Following cleaning of suspected areas, a visual inspection utilizing bright lighting and mirror is effective for identifying the existence of corrosion. In specific localized areas where inspection by visual means is impossible or where extent of corrosion has to be determined after visual detection, CORROSION INSPECTION AND DETECTION, SUBJECT 51-00-51 for applicable method.
- (b) Where corrosion exists (noticeable bulges of the skin or white deposits of corrosion products at fastener heads or joint edges), refer to Structural Repair Manual for details of corrosion removal.
- (c) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by the application of a corrosion inhibiting compound into the affected area to retard the corrosion process (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59). The finish system should be restored at the next maintenance opportunity.

SUBTASK 53-11-00-610-027

(3) Application of Corrosion Inhibitors

- (a) For details of application of water displacing corrosion inhibiting compound, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-11-00-610-028

(4) Prevention Treatment

- (a) At the next maintenance opportunity, corrosion prevention treatment should be accomplished in the wheel well.
- (b) Treatment of the wheel well at the same time as the nose gear is recommended.
- (c) Remove runway debris and generally clean the entire wheel well. Make sure that all drain paths are clear in structural areas at the nose gear wheel well.
- (d) Replace damaged or broken finishes if at all possible. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems.
- (e) Apply water displacing corrosion inhibiting compound to all exposed wheel well structure. Special effort should be made to apply the corrosion inhibitor along doubler edges, along faying surfaces and on fastener heads. The use of spray equipment with nozzle directed into faying surfaces is recommended.
- (f) Apply water displacing corrosion inhibiting compound to nose gear actuator attachment fitting, nose gear trunnion support fittings and miscellaneous other fittings. Ensure that all lugs and lug faces are treated.
- (g) Regrease all grease fittings in the treatment area.
- (h) In cases where the wheel well is cleaned with steam or high pressure water and detergent, reapplication of corrosion inhibiting compound is recommended.

SUBTASK 53-11-00-610-029

(5) Frequency of Application

- (a) Periodic inspection is required to areas identified as susceptible to corrosion and should be consistent to the schedules specified in the Maintenance Planning Document. Operators must be aware of reported problems and areas of occurrences.
- (b) Periodic application of corrosion inhibiting compound, G00009 is necessary to areas identified and should be consistent to the schedule specified in the Maintenance Planning Document.

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SUBTASK 53-11-00-610-030

(6) Improved Corrosion Protection

- (a) A layer of corrosion preventive compound, C00755 was added on the corrosion inhibiting compound, G00009 in some areas.

————— **END OF TASK** —————

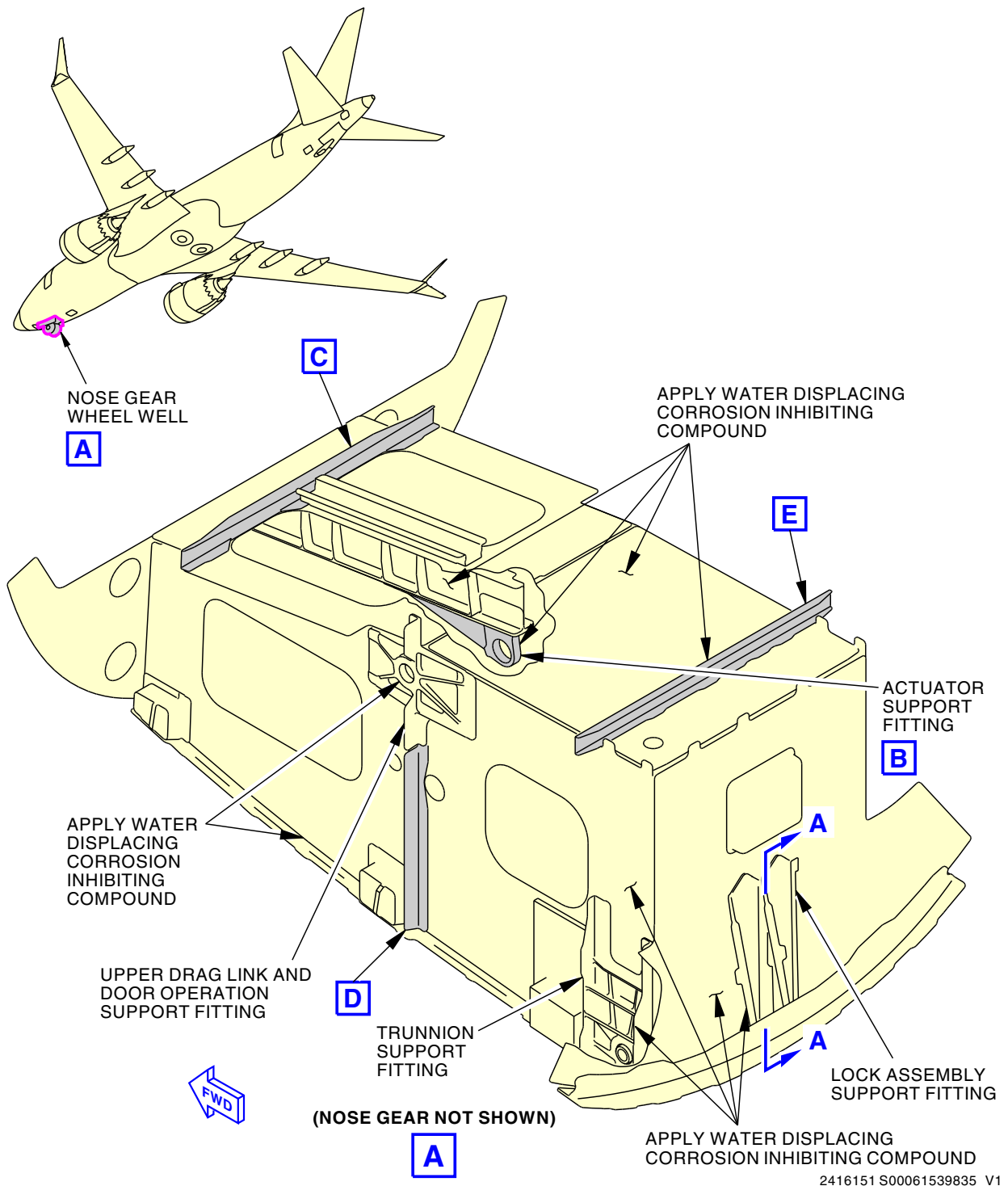
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Nose Gear Wheel Well
Figure 205/53-11-00-990-805 (Sheet 1 of 2)

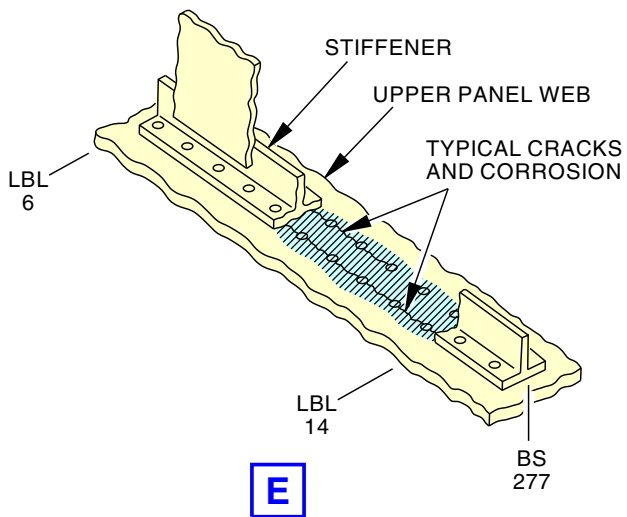
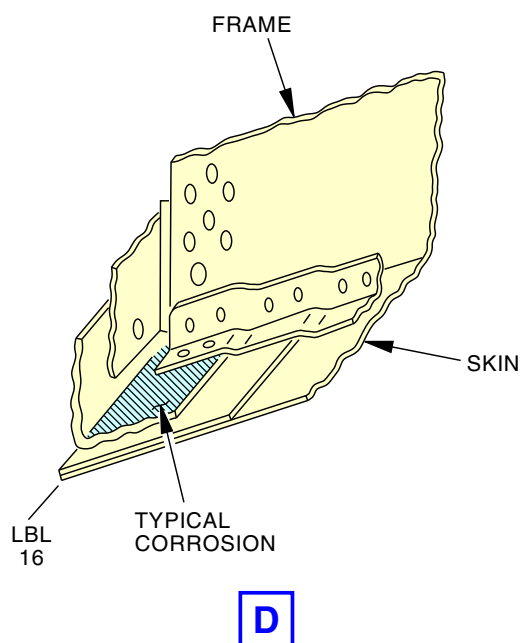
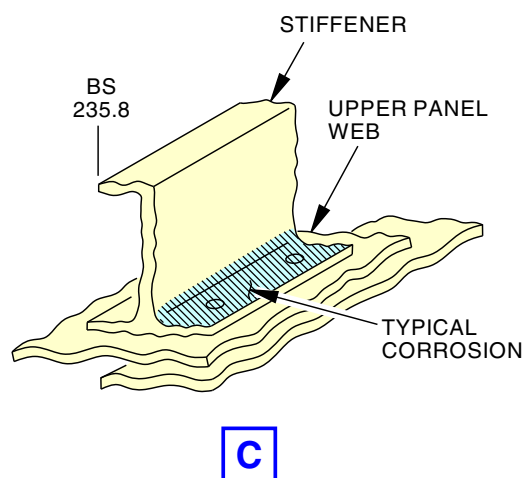
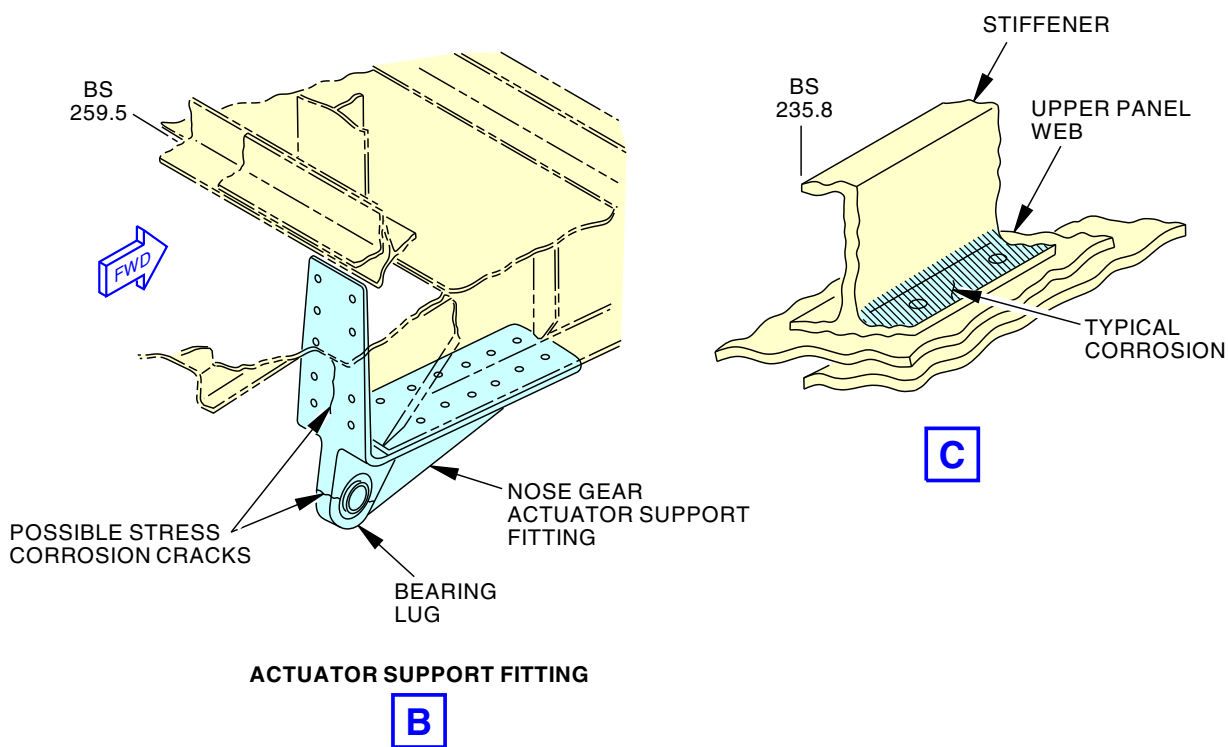
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Nose Gear Wheel Well
Figure 205/53-11-00-990-805 (Sheet 2 of 2)

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TASK 53-11-00-600-806

7. Door Openings - Corrosion Prevention

Figure 206

A. General

- (1) The door openings and surrounding structure in the fuselage section are made up of frames, doublers, fittings, stiffeners and intercostals. In addition, the passenger and/or crew entry doors have reveals and scuff plates.
- (2) The primary corrosion area is under the door sill, floor panels and floor beams. Contaminants are tracked in by passenger, crew members, cargo and service personnel or by driven rain/snow when door is opened. Specific problems have been reported under the corrosion resistant steel plates at the cargo doors.
- (3) Insulation blankets are provided on cabin interiors for passenger comfort and to minimize the condensation of warm cabin air on cold skins and stringers. Corrosion has been experienced in areas where the blankets are not installed taut and wrap around stringers or lay on the skins. Reports of water soaked blankets have been common in these instances.
- (4) Stress corrosion can cause cracks in the frame at Station 360.
- (5) Refer to the STANDARD PRACTICES AND STRUCTURES, SECTION 51-00 for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

B. References

Reference	Title
51-00	STANDARD PRACTICES AND STRUCTURES
51-00-51	CORROSION INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES

C. 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
D00633	Grease - Aircraft General Purpose	BMS3-33
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. Location Zones

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

E. Corrosion Prevention

SUBTASK 53-11-00-610-031

- (1) Make the regular inspection of CORROSION INSPECTION AND DETECTION, SUBJECT 51-00-51 to stop or find the start of corrosion. Missing fasteners, white powdery or any discolored deposits are signs of corrosion.

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SUBTASK 53-11-00-610-032

- (2) If you find corrosion (web bulges, missing fasteners or large amounts of discolored deposits at fastener heads or faying surfaces), refer to Structural Repair Manual for details of corrosion removal.

SUBTASK 53-11-00-610-033

- (3) For small amounts of corrosion, to decrease the downtime of the airplane, clean off the corrosion products. Apply a corrosion inhibiting compound into the affected area to stop the corrosion process (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59). The finish system should be restored at the first maintenance opportunity.

SUBTASK 53-11-00-610-034

(4) Prevention Treatment

- (a) At next maintenance opportunity, corrosion prevention treatment should be accomplished in the door opening area.
- (b) Treatment of the door at the same time as the door opening is recommended.
- (c) Remove traffic debris and generally clean the entire door opening area. Remove reveal and scuff plate where applicable.
- (d) Remove sidewall lining and insulation blankets to expose frames, stringers, doublers and skin.
- (e) Remove door reveal, scuff plates and thresholds.
- (f) Remove floor panels to gain access to floor beams and intercostals near the door opening.
- (g) Open plugged drains.
- (h) Make sure that all drain paths are clear at the equipment access doorway, fwd and aft galley and entry doorways and cargo doorway.
- (i) Replace damaged or broken finishes. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish system.
- (j) Apply a coat of epoxy primer, C00259 to the inboard flange surfaces of stringers and allow to dry thoroughly.
- (k) Apply sealant, A00247, class F, chromate-loaded sealant to the inboard flanges and to portions of the frames that come in contact with insulation blankets. Allow to cure for 48 hours. Note condition of the sealant and reapply as necessary.
- (l) Apply corrosion inhibiting compound to all immediate structure. Special efforts should be made to apply the corrosion inhibitor along doubler edges, along faying surfaces and on fastener heads. The use of spray equipment with nozzle directed into faying surfaces is recommended. Special attention should be given to flanges of floor beams, doorsills and floor beam to fuselage frame splices.
- (m) Replace or repair broken or damaged leveling compounds used for drainage.
- (n) Allow solvent in corrosion inhibiting compound to evaporate before reinstalling insulation blankets.
- (o) Install blankets so they are tight and so that the outboard surfaces of the upper blanket overlap the lower blanket.
- (p) Relubricate all lube points per standard servicing procedures.
- (q) Install liners and floor panels. Install the floor panel fasteners with grease, D00633.

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SUBTASK 53-11-00-610-035

(5) Frequency of Application

- (a) Regular inspection is required in areas that can get corrosion and should agree with the schedules in the Maintenance Planning Document. Operators must know of problems and areas.
- (b) Regular application of corrosion inhibiting compound, G00009 compound is necessary on areas identified and should agree with the schedule in the Maintenance Planning Document.

————— **END OF TASK** —————

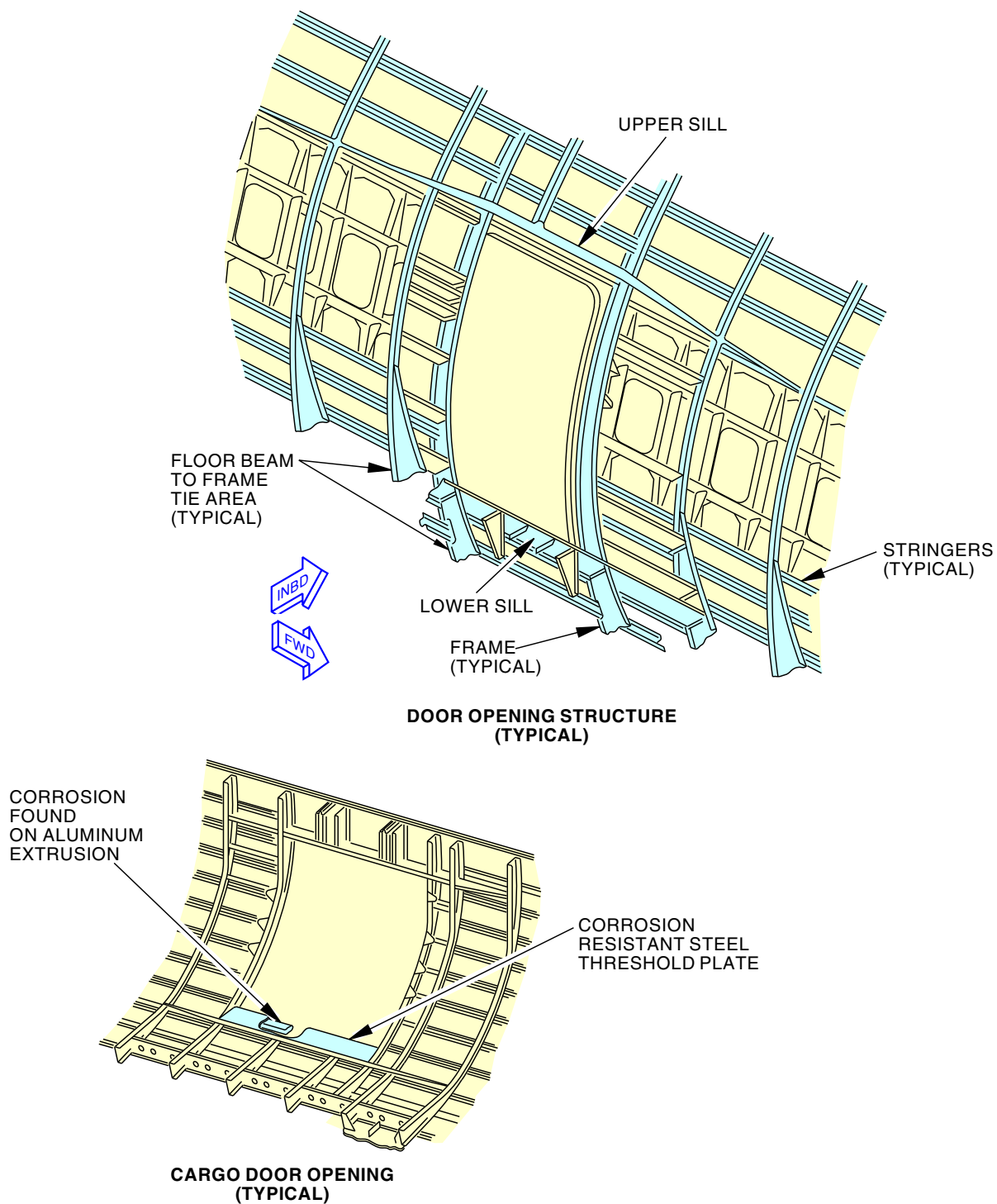
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Door Openings
Figure 206/53-11-00-990-806 (Sheet 1 of 3)

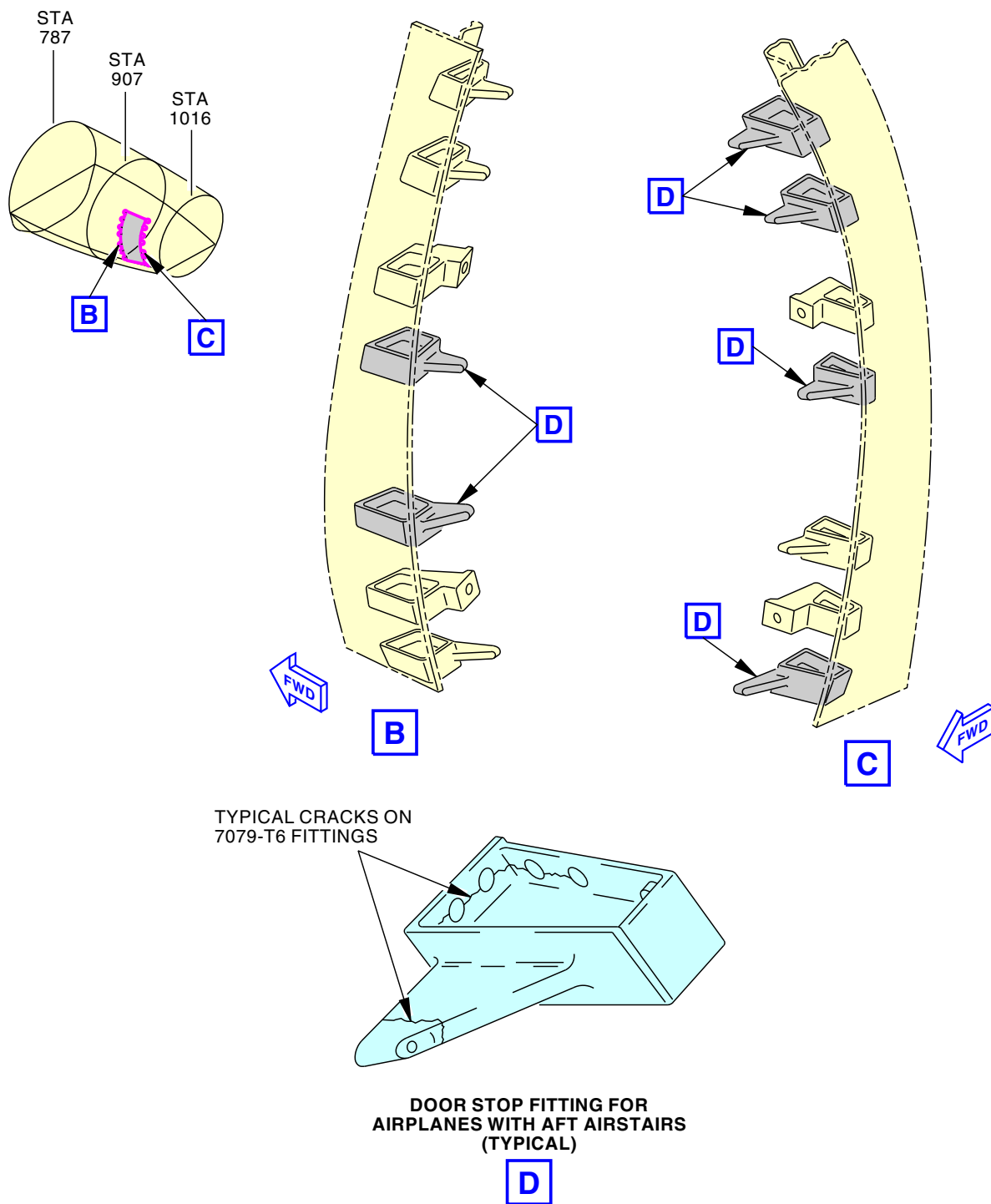
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2416156 S00061539841_V1

Door Openings
Figure 206/53-11-00-990-806 (Sheet 2 of 3)

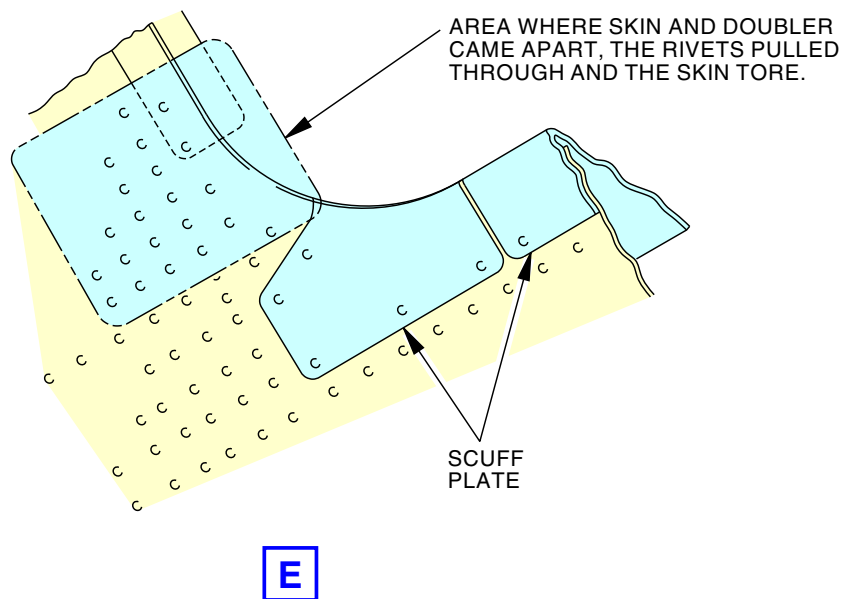
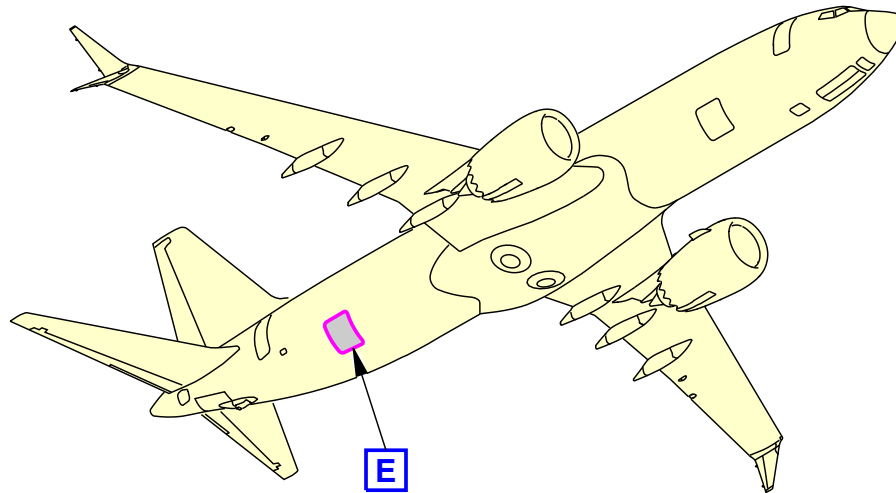
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Door Openings
Figure 206/53-11-00-990-806 (Sheet 3 of 3)

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TASK 53-11-00-600-807

8. Upper Lobe Frames, Stringers and Skin - Corrosion Prevention

Figure 207

A. General

- (1) The fuselage is of semimonocoque construction which uses aluminum skins, circumferential frames and longitudinal hat section stringers. The fuselage skin is installed with circumferential butt joints and longitudinal lap joints that are usually flush riveted. Skins should be treated at the same time with the fuselage structure.
- (2) Cracks can happen in the areas where the skin and doubler come apart. Cracks come from the fastener holes in the double rivet row in Stringer 17L and 17R between BS 422 to 500A, and BS 727A to BS 747.
- (3) The main compartment sidewall insulation have pillow blankets installed just inboard of the airplane skin and insulation blankets installed inboard of the pillow blankets. It was found that the pillow catches the moisture against the airplane skin which can add to possible corrosion of the adjacent structure.
- (4) Refer to STANDARD PRACTICES AND STRUCTURES, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

B. References

Reference	Title
51-00	STANDARD PRACTICES AND STRUCTURES
51-00-51	CORROSION INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES

C. Consumable Materials

Reference	Description	Specification
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Corrosion Prevention

SUBTASK 53-11-00-610-036

- (1) The basic corrosion prevention philosophy is to make the periodic inspection described in CORROSION INSPECTION AND DETECTION, SUBJECT 51-00-51 to preclude or detect the early stages of corrosion. Skin bulges, missing fasteners or white powdery deposits are evidences of the existence of corrosion which should alert operators that some corrective action is required. A corrosion prevention program should be initiated to prevent the accumulation of moisture or corrosive compounds in order to minimize the occurrence of corrosion.

SUBTASK 53-11-00-610-037

- (2) Where extensive corrosion exists (very noticeable skin bulges, missing fasteners, or large amounts of white deposits at the fastener heads or faying surfaces), refer to Structural Repair Manual for details of corrosion removal.

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SUBTASK 53-11-00-610-038



DO NOT APPLY THE CORROSION-INHIBITING COMPOUNDS IN THE AREAS THAT HAVE OXYGEN SYSTEM COMPONENTS. THE MIXTURE OF CORROSION-INHIBITING COMPOUNDS, AND OXYGEN CAN CAUSE AN EXPLOSION. AN EXPLOSION CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.



DO NOT INSTALL THE INSULATION BLANKETS THAT ARE SOAKED WITH CORROSION INHIBITING COMPOUNDS. INSULATION BLANKETS INADVERTENTLY SPATTERED WITH THE CORROSION INHIBITING COMPOUNDS SHOULD BE ALLOWED TO DRY BEFORE INSTALLATION. SOAKED INSULATION BLANKETS ARE POTENTIAL FIRE HAZARDS. THEY CAN CAUSE DAMAGE TO THE AIRPLANE.

- (3) For details of application of water displacing corrosion inhibiting compound, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-11-00-610-039

- (4) For minor corrosion detected during the periodic inspections and to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by an application of a corrosion inhibiting compound into the affected area to retard the corrosion process.

SUBTASK 53-11-00-610-040

(5) Prevention Treatment

- (a) At the next maintenance opportunity, corrosion prevention treatment should be accomplished.
- (b) Remove insulation blankets to expose frame, stringer and skin. Dry blankets thoroughly if found wet.
- (c) Replace broken or damaged finishes. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems.
- (d) Apply a coat of epoxy primer, C00259 to the inboard flange surfaces of stringer and allow to dry thoroughly.
- (e) Apply water displacing corrosion inhibiting compound to all exposed structure. The use of spray equipment with nozzle directed into faying surfaces is recommended.
- (f) Allow solvent to evaporate before reinstalling insulation blankets.
- (g) Reinstall blankets so they are taut and so that the outboard surface of the upper blanket overlaps the lower blanket.
- (h) Reinstall liner and restore airplane to normal.

SUBTASK 53-11-00-610-041

(6) Improved Corrosion Protection

- (a) A production change replaced the H-11 attach bolts used in the vertical-fin-aft-spar-terminal support fitting at BS 1088 bulkhead with Inconel 718 bolts. The Inconel 718 bolt is less susceptible to cracks caused by stress corrosion.

————— END OF TASK —————

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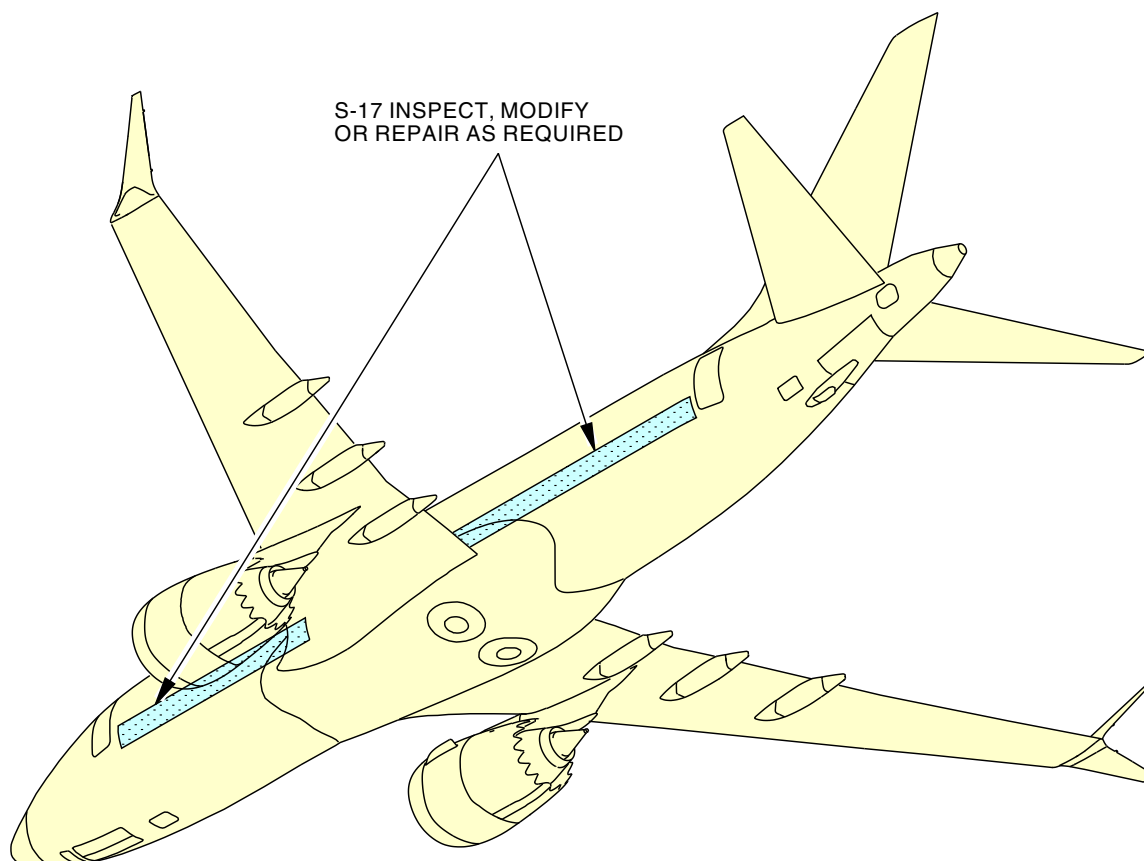
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LEFT SIDE IS SHOWN
(RIGHT SIDE IS OPPOSITE)

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Upper Lobe Frames, Stringers and Skin
Figure 207/53-11-00-990-807 (Sheet 1 of 2)

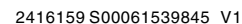
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Upper Lobe Frames, Stringers and Skin
Figure 207/53-11-00-990-807 (Sheet 2 of 2)

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PASSENGER ENTRY DOOR SCUFF PLATE - REMOVAL/INSTALLATION

1. **General**

- A. This procedure has these tasks:
- (1) Passenger entry door scuff plate removal
 - (2) Passenger entry door scuff plate installation.

TASK 53-11-01-000-801

2. **Passenger Entry Door Scuff Plate Removal**

(Figure 401 or Figure 402 or Figure 403 or Figure 404)

A. **General**

- (1) This task gives the instructions to remove the passenger entry door scuff plate.

B. **Tools/Equipment**

Reference	Description
STD-1064	Scraper - Phenolic, Hard Resin

C. **Consumable Materials**

Reference	Description	Specification
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740

D. **Location Zones**

Zone	Area
830	Subzone - Passenger Compartment Doors, Left
840	Subzone - Passenger Compartment Doors, Right

E. **Passenger Entry Door Scuff Plate Removal**

SUBTASK 53-11-01-020-001

- (1) Remove the scuff plate [1]:
 - (a) Remove the fasteners that attach the scuff plate [1] to structure.
 - (b) Use a hard resin phenolic scraper, STD-1064, to release the scuff plate [1] from structure.
 - (c) Remove the scuff plate [1].

NOTE: The door lining [2] attached to the scuff plate [1] is installed with a parting agent on the scuff plate [1] for separation and removal of the scuff plate [1]. It is possible to remove the door lining attached to the scuff plate with the scuff plate [1].



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.

- (d) Remove sealant and parting agent from faying surfaces with solvent, B00148, and a hard resin phenolic scraper, STD-1064.
- (e) Do a visual inspection of the nut plates to find if they are in acceptable condition.
 - 1) If it is necessary, replace the scuff plate [1].

———— **END OF TASK** ————

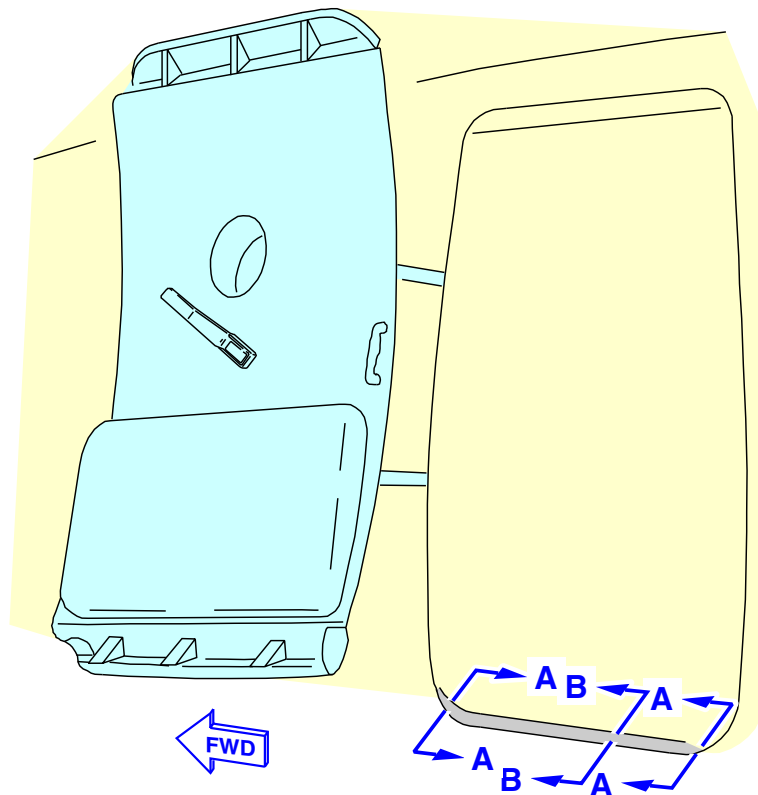
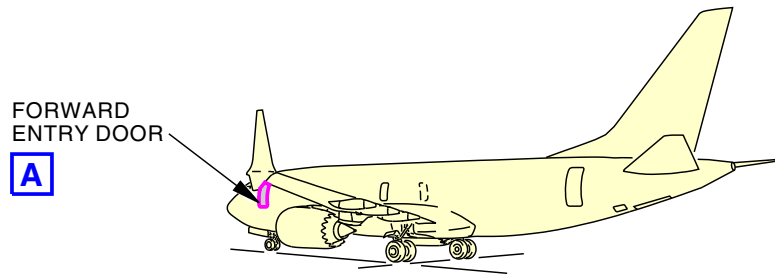
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FORWARD ENTRY DOOR

A

2416129 S00061539802_V1

Forward Entry Door Scuff Plate Installation
Figure 401/53-11-01-990-804 (Sheet 1 of 2)

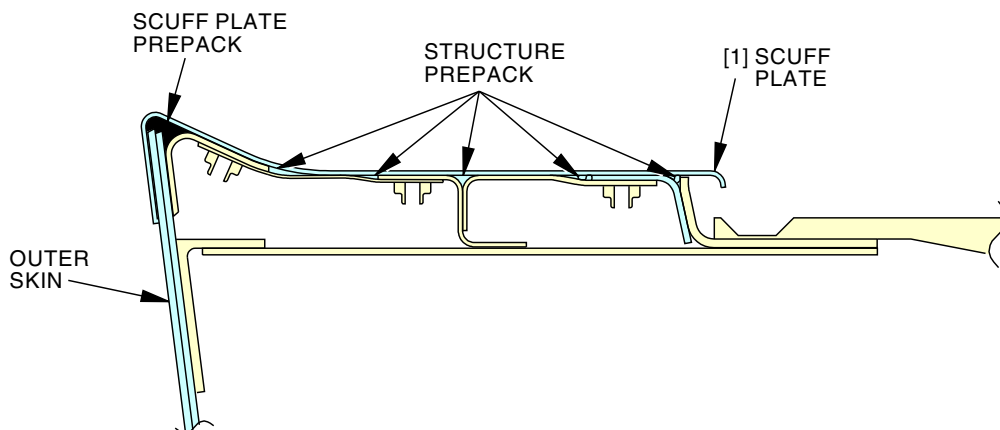
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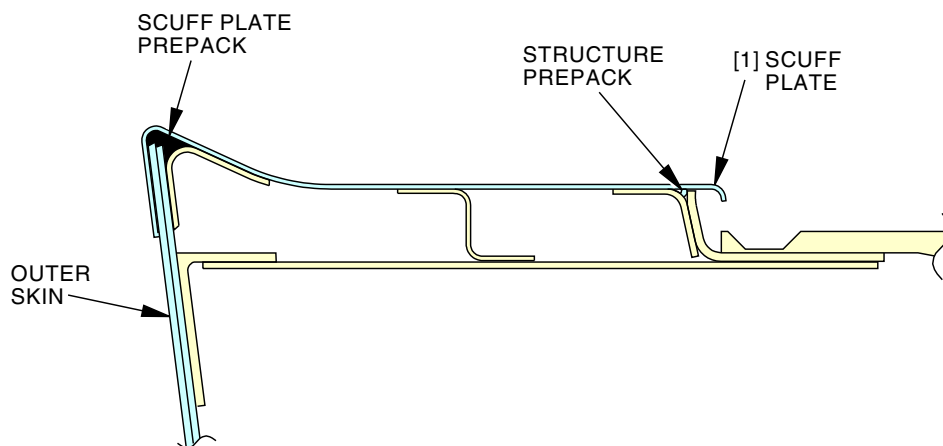
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A-A



B-B

2416130 S00061539803_V2

Forward Entry Door Scuff Plate Installation
Figure 401/53-11-01-990-804 (Sheet 2 of 2)

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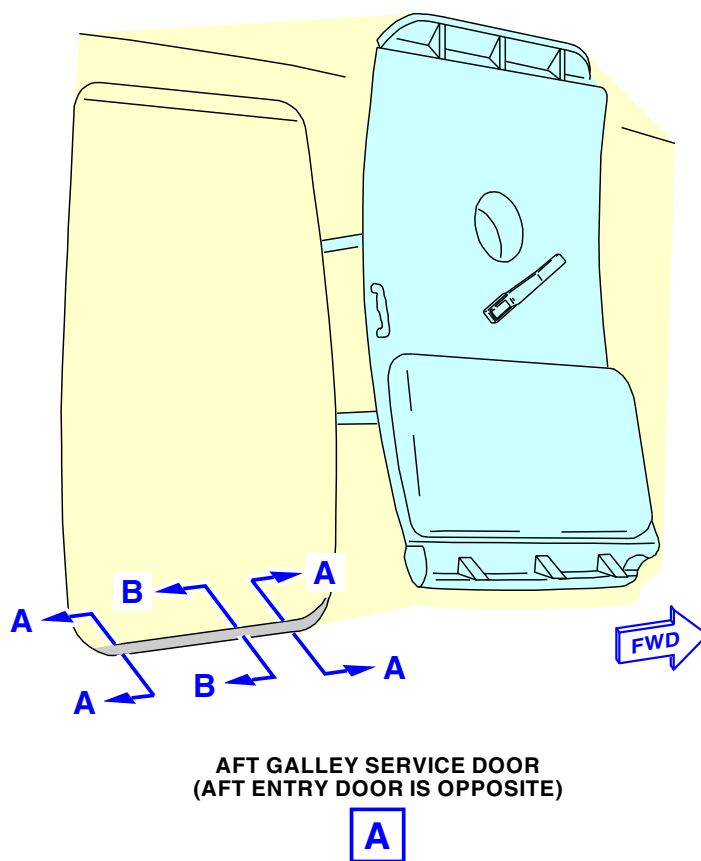
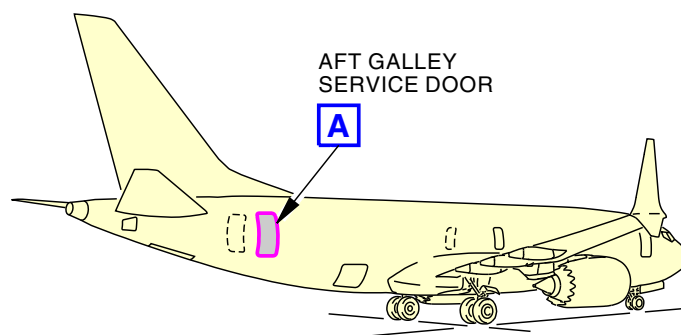
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Aft Galley Service Door and Aft Entry Door Scuff Plate Installation
Figure 402/53-11-01-990-805 (Sheet 1 of 2)

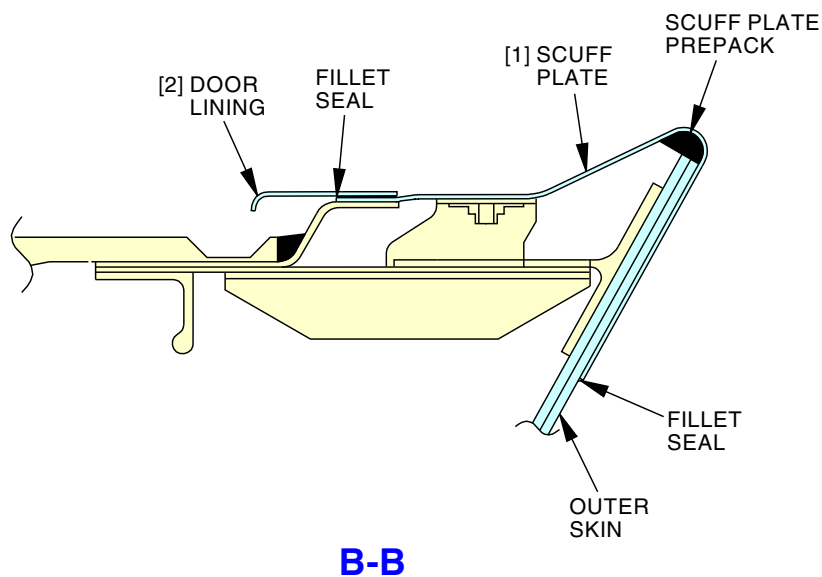
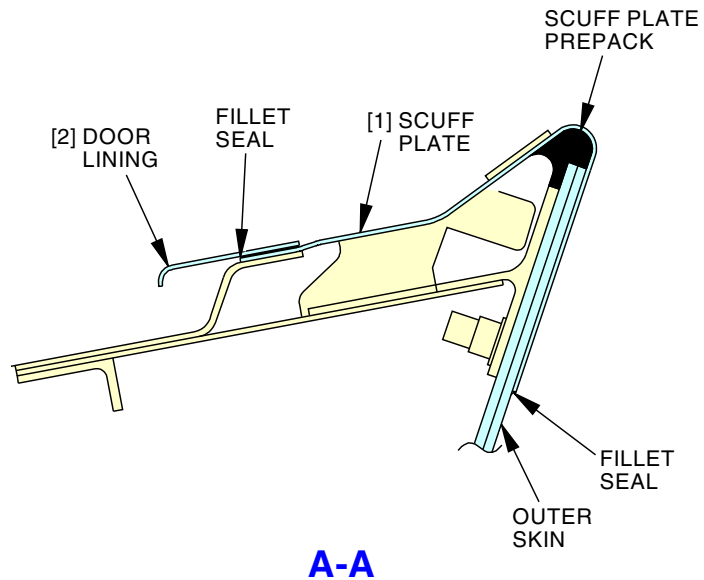
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Aft Galley Service Door and Aft Entry Door Scuff Plate Installation
Figure 402/53-11-01-990-805 (Sheet 2 of 2)

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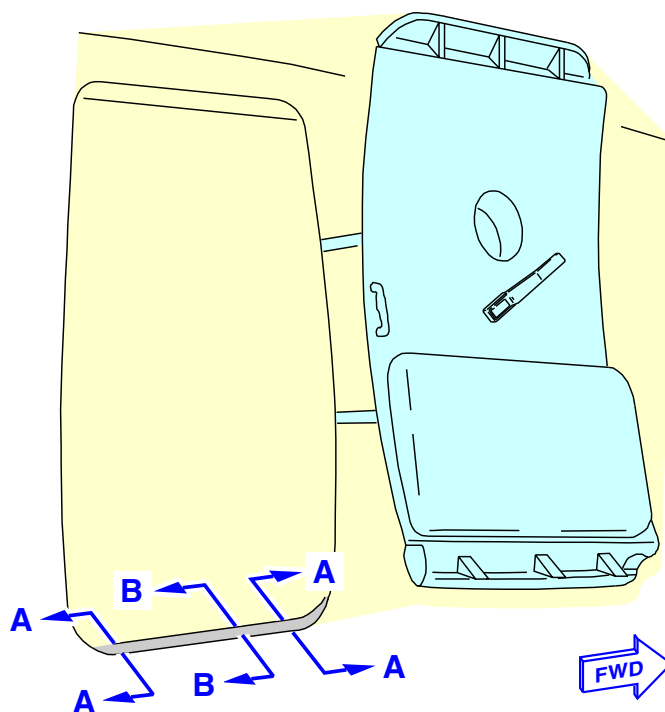
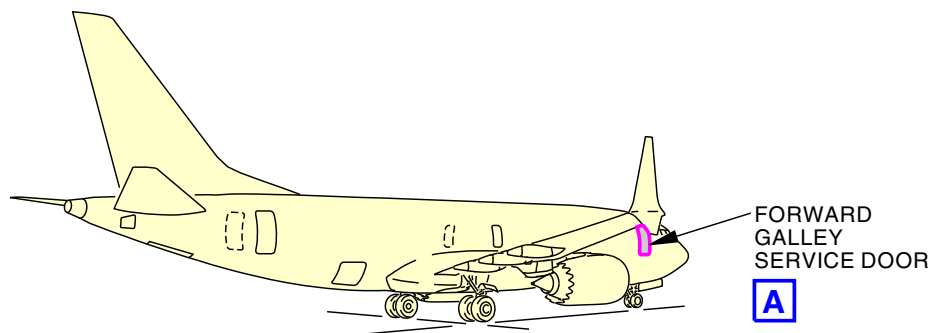
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FORWARD GALLEY SERVICE DOOR

A

2416133 S00061539806_V1

Forward Galley Service Door Scuff Plate Installation
Figure 403/53-11-01-990-806 (Sheet 1 of 2)

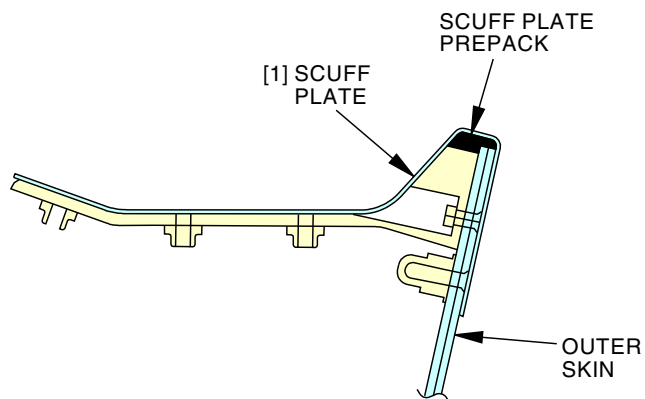
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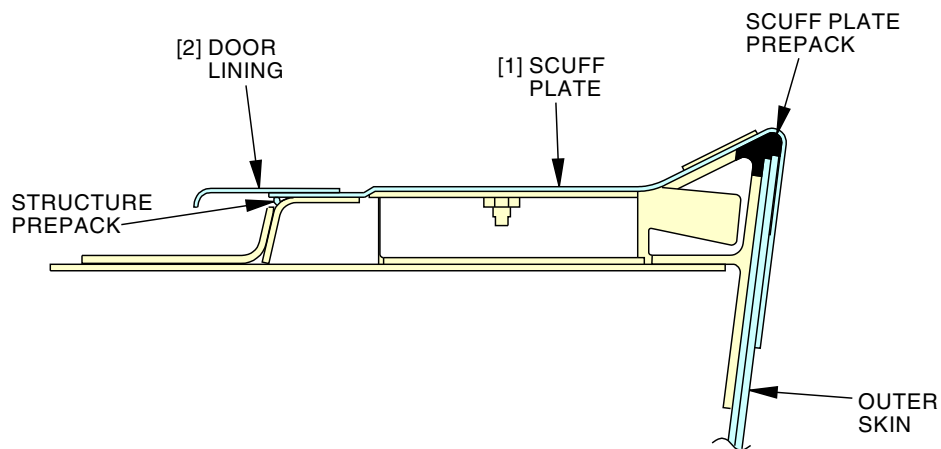
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A-A



B-B

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Forward Galley Service Door Scuff Plate Installation
Figure 403/53-11-01-990-806 (Sheet 2 of 2)

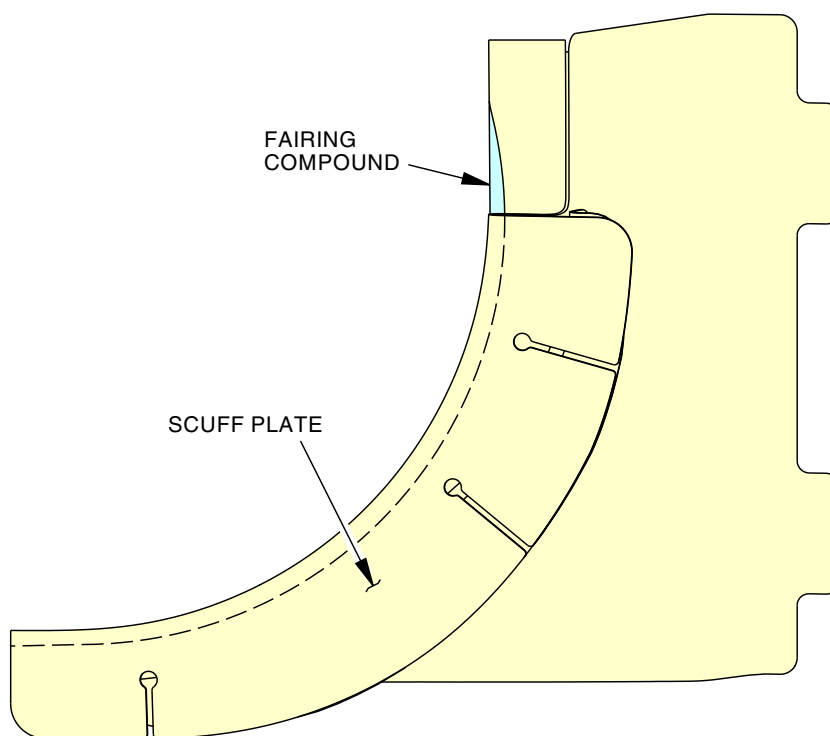
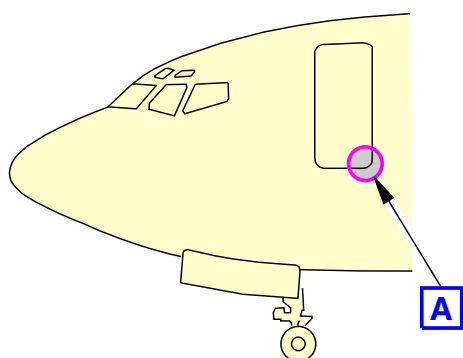
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(EXAMPLE)



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Entry Door Scuff Plate Installation - Fairing Compound
Figure 404/53-11-01-990-807

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TASK 53-11-01-420-801

3. Passenger Entry Door Scuff Plate Installation

(Figure 401 or Figure 402 or Figure 403 or Figure 404)

A. General

(1) This task gives the instructions to install the passenger entry door scuff plate.

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A01024	Compound - Fairing - 3M EC-3587B	BAC5530
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
C50033	Coating - Chemical Conversion - Bonderite M-CR 1200S Aero (Formerly Alodine 1200)	BAC5719 Class A, C or D, MIL-DTL-81706 Type I Class 1A or 3
G02185	Agent - Peelable Parting (Valspar - 4A-183 Green Strippable Coating)Manufacturing discontinued, use stock until depleted	
G02497	Agent - Non-Peelable Parting (Henkel Loctite - Frekote 700-NC Mold Release)	BAC5000
G50313	Agent - Non-Peelable Parting (Henkel Loctite - Frekote 710-NC Mold Release)	BAC5000
G50365	Agent - Peelable Parting (AC Products - AC962-73C) Production discontinued, use stock until depleted.	BAC5000
G50366	Agent - Parting, Peelable, AZ 534-2B (0A3C8 - Aztec Chemical, Inc., El Monte, CA)	BAC5000, PSD 6-187
G50367	Agent - Peelable Parting (Aztec Chemical AZ 634-2)	MIL-PRF-6799, BAC5000
G50368	Agent - Peelable Parting (Rexco Chemical Company - Partall Coverall Film)	BAC5000
G50369	Coating - Alkaline Removable, Water Resistant	BMS15-12 Type I Class 1

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Scuff plate	53-11-01-13-602	SIA ALL
		53-11-01-38-075	SIA ALL
		53-11-01-38-086	SIA ALL
		53-11-01-38-106	SIA 001-005
		53-11-01-38-125	SIA 006-999

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D. Location Zones

Zone	Area
830	Subzone - Passenger Compartment Doors, Left
840	Subzone - Passenger Compartment Doors, Right

E. Passenger Entry Door Scuff Plate Installation

SUBTASK 53-11-01-110-001

- (1) Install the scuff plate [1]:



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.

- (a) If it is necessary, clean all faying surfaces with a solvent, B00148 (MEK).
- (b) Apply MIL-C-81706, class 1A, form II Bonderite M-CR 1200S Aero coating, C50033, and two coats of primer, C00259, to the exposed metal surfaces of the outer skin that will be under the scuff plate [1].
- (c) Apply a coat of parting agent to the bottom side of the scuff plate [1] and the outer skin.
 - 1) Recommended: peelable AC962-73C peelable parting agent, G50365
 - 2) Alternate: Valspar 4A-183 green strippable coating, G02185
 - 3) Alternate: peelable parting agent, G50366
 - 4) Alternate: AZ 634-2 peelable parting agent, G50367
 - 5) Alternate: Rexco Partall Coverall Film peelable parting agent, G50368
 - 6) Alternate: temporary coating, G50369
 - 7) Alternate: Frekote 710-NC non-peelable parting agent, G50313.
- (d) Prepack the scuff plate [1] in the area shown with sealant, A00247, a minimum 0.35 in. (8.9 mm) thick.
- (e) Prepack the structure in the areas shown with sealant, A00247.
- (f) Apply sealant, A00247, to the structure surface that will touch the scuff plate [1].
- (g) Install the scuff plate [1].
- (h) If a new door lining [2] will be installed on the scuff plate [1], do these steps:
 - 1) Apply sealant, A00247, to the area of the door lining [2] that will touch the scuff plate [1].
 - 2) Apply Frekote 700-NC non-peelable parting agent, G02497, to the area of the scuff plate [1] that will touch the door lining [2].
 - 3) Install the door lining [2] on the scuff plate [1].
- (i) Apply primer, C00259, to the fastener holes.
- (j) Make sure the primer, C00259, is dry before the fasteners are installed.
- (k) Install the fasteners wet with compound, C00528.
- (l) Remove excess sealant from the edges of the scuff plate [1].
- (m) FOR FORWARD ENTRY DOOR;

Fill gaps and fastener recesses with sealant, A00247, and fair flush with adjacent surfaces.

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- (n) FOR AFT ENTRY DOOR AND GALLEY SERVICE DOORS;
Fill gaps and fastener recesses with 3M EC-3587B compound, A01024, and fair flush with the adjacent surfaces.
- (o) FOR FORWARD ENTRY DOOR AND FORWARD GALLEY SERVICE DOOR;
Fill forward and aft edges of the scuff plate [1] with 3M EC-3587B compound, A01024, and fair flush with adjacent surfaces.
NOTE: This will give a smooth surface for the door seal.
- (p) FOR AFT ENTRY DOOR AND AFT GALLEY SERVICE DOOR;
Fill forward and aft edges of the scuff plate [1] with sealant, A00247, and fair flush with adjacent surfaces.
NOTE: This will give a smooth surface for the door seal.
- (q) FOR FORWARD GALLEY SERVICE DOOR;
Apply sealant, A00247 (aero-smoother), around scuff plate [1] at a 6 to 1 taper ratio.
- (r) FOR AFT ENTRY AND AFT GALLEY SERVICE DOORS;
Apply a sealant, A02315, fillet seal around the scuff plate [1].
- (s) FOR AFT ENTRY AND AFT GALLEY SERVICE DOORS;
Fill slots at forward area of the scuff plate [1] with sealant, A00247, and fair flush with adjacent surfaces.

———— **END OF TASK** ————

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CARGO DOOR SCUFF PLATE - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the cargo door scuff plate
 - (2) An installation of the cargo door scuff plate.
- B. The installation of all the scuff plates are almost the same.
- C. The clearances between the scuff plates and airplane structure are sealed for aerodynamic smoothness.

TASK 53-11-02-020-801

2. Cargo Door Scuff Plate Removal

(Figure 401)

A. **General**

- (1) This task gives the instructions to remove the cargo door scuff plate.

B. **References**

Reference	Title
51-22-00 P/B 201	SEALS AND SEALING - MAINTENANCE PRACTICES

C. **Tools/Equipment**

Reference	Description
STD-1064	Scraper - Phenolic, Hard Resin

D. **Consumable Materials**

Reference	Description	Specification
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740

E. **Location Zones**

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

F. **Cargo Door Scuff Plate Removal**

SUBTASK 53-11-02-020-001

- (1) Remove the filler scuff plate [1].



CAUTION

DO NOT USE METAL TOOLS TO REMOVE THE SEALANT. AN APPROVED TOOL WILL PREVENT DAMAGE TO THE SKIN OF THE AIRCRAFT.

- (a) Use a hard resin phenolic scraper, STD-1064, to release the filler scuff plate [1] from the structure.
- (b) Remove the filler scuff plate [1] from the airplane.

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SUBTASK 53-11-02-020-002



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

- (2) Remove the scuff plate [4].
 - (a) Remove the screws [5] that attach the scuff plate [4] to the structure.



DO NOT USE METAL TOOLS TO REMOVE THE SEALANT. AN APPROVED TOOL WILL PREVENT DAMAGE TO THE SKIN OF THE AIRCRAFT.

- (b) Use a hard resin phenolic scraper, STD-1064, to release the scuff plate [4] from the structure.
 - (c) Remove the scuff plate [4] from the airplane.
 - (d) Remove the filler scuff plate [6] from the structure.
 - 1) Use a hard resin phenolic scraper, STD-1064, to release the filler scuff plate [6] from the structure.
 - (e) Remove the gasket [9] from the structure.



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



BE CAREFUL WHEN YOU REMOVE THE SEAL WITH THE SEALANT REMOVAL TOOL. DAMAGE TO THE AIRPLANE SKIN CAN OCCUR.

- (3) Remove the sealant and parting agent from mating surfaces with solvent, B00148, and a hard resin phenolic scraper, STD-1064 (PAGEBLOCK 51-22-00/201).
- (4) Do a visual inspection of the nut plates [11] to find if they are in a satisfactory condition.
 - (a) If it is necessary, replace the nut plates [11].

SUBTASK 53-11-02-020-003

- (5) Remove the forward and aft scuff plates [2].
 - (a) Remove the screws [3] that attach the scuff plate [2] to the structure.

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CAUTION

DO NOT USE METAL TOOLS TO REMOVE THE SEALANT. AN APPROVED TOOL WILL PREVENT DAMAGE TO THE SKIN OF THE AIRCRAFT.

- (b) Use a hard resin phenolic scraper, STD-1064, to release the scuff plate [2] from the structure.
- (c) Remove the scuff plate [2] from the airplane.

SUBTASK 53-11-02-020-004

- (6) Remove the scuff plate [7].

- (a) Remove the screws [8] that attach the scuff plate [7] to the structure.



CAUTION

DO NOT USE METAL TOOLS TO REMOVE THE SEALANT. AN APPROVED TOOL WILL PREVENT DAMAGE TO THE SKIN OF THE AIRCRAFT.

- (b) Use a hard resin phenolic scraper, STD-1064, to release the scuff plate [7] from the structure.
- (c) Remove the scuff plate [7] from the structure.
- (d) Remove the gasket [12] from the structure.

———— **END OF TASK** ————

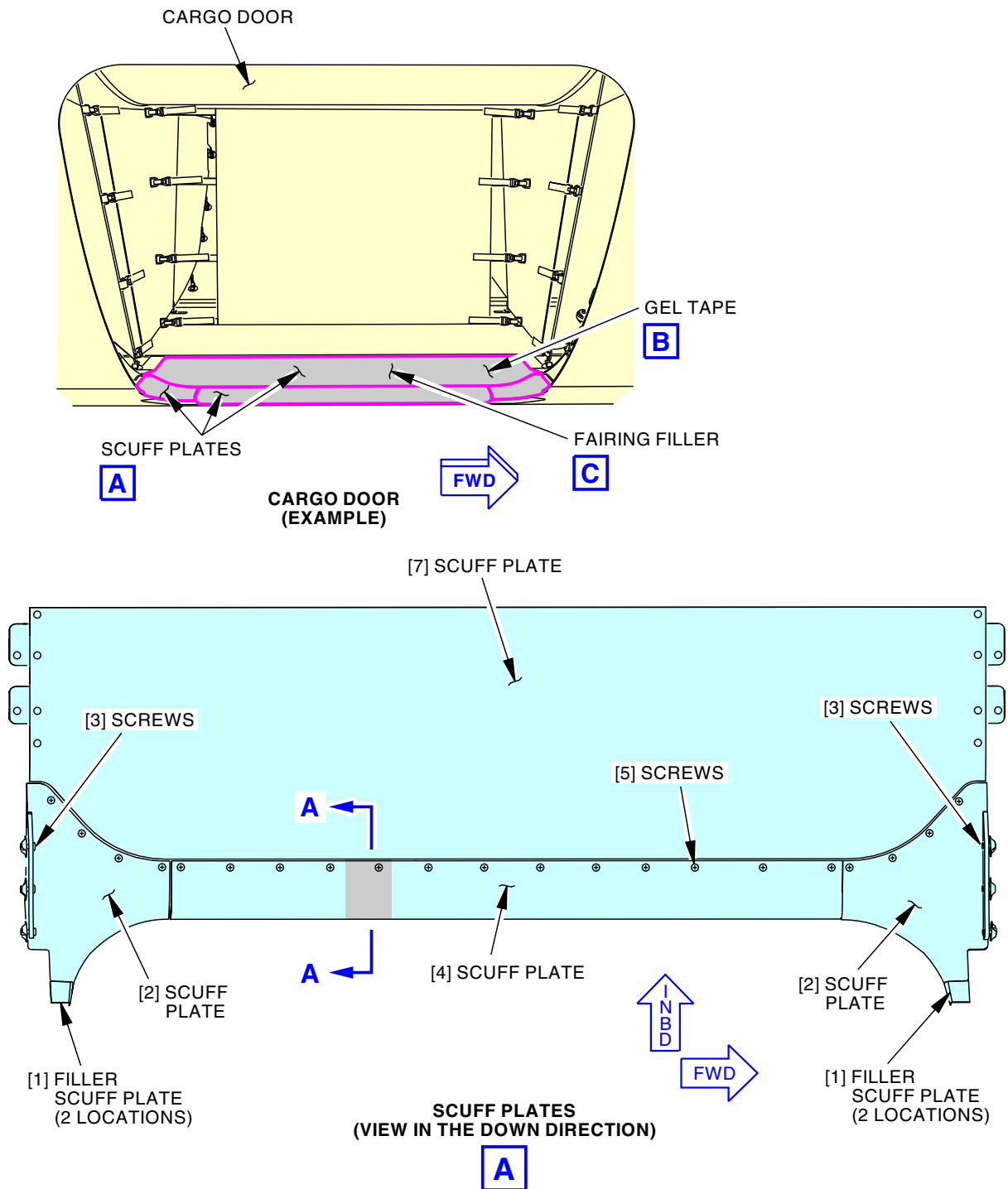
EFFECTIVITY
SIA ALL

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2416135 S00061539812_V2

Cargo Door Scuff Plate Installation
Figure 401/53-11-02-990-802 (Sheet 1 of 3)

EFFECTIVITY
SIA ALL

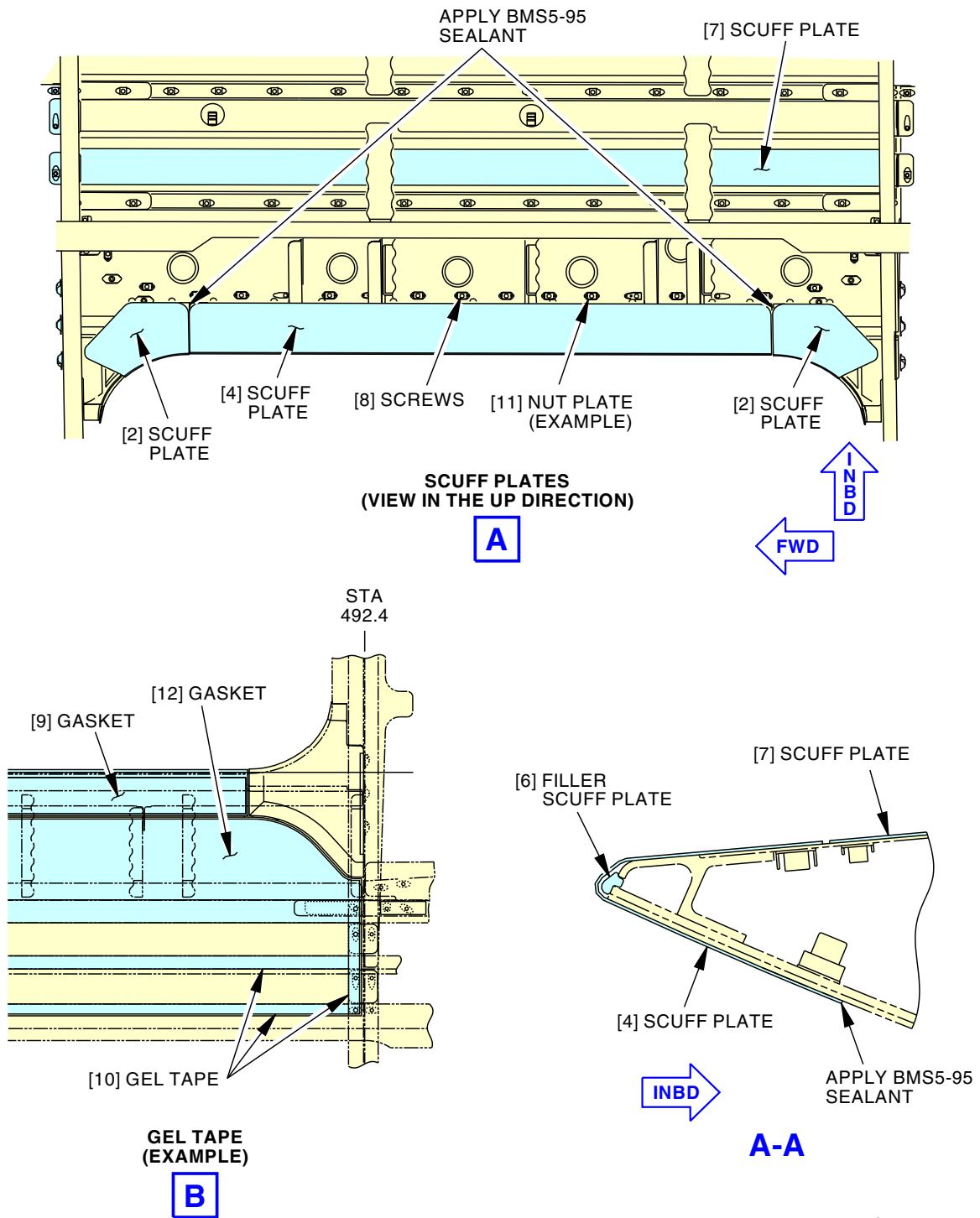
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2416136 S00061539813_V3

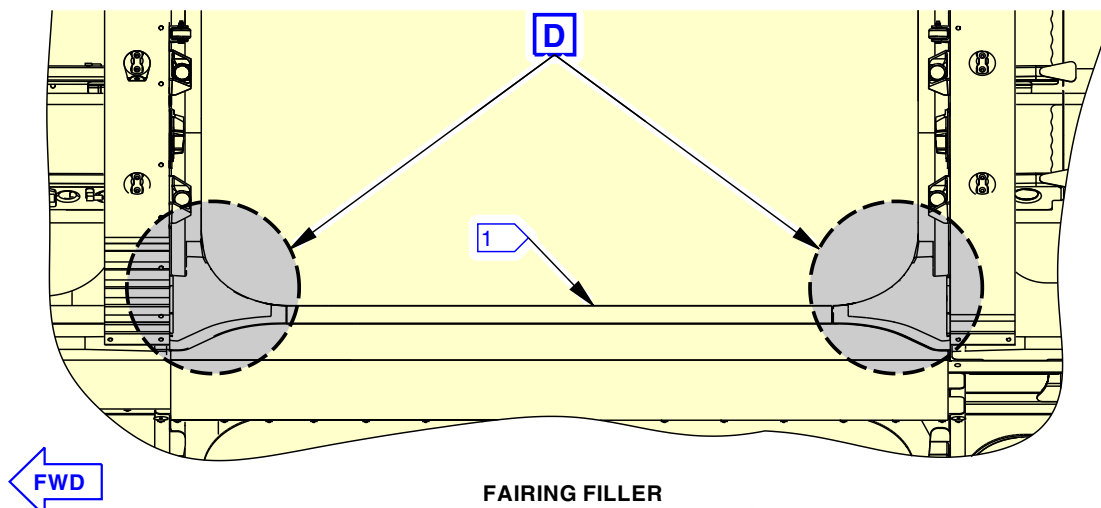
Cargo Door Scuff Plate Installation
Figure 401/53-11-02-990-802 (Sheet 2 of 3)

EFFECTIVITY
SIA ALL

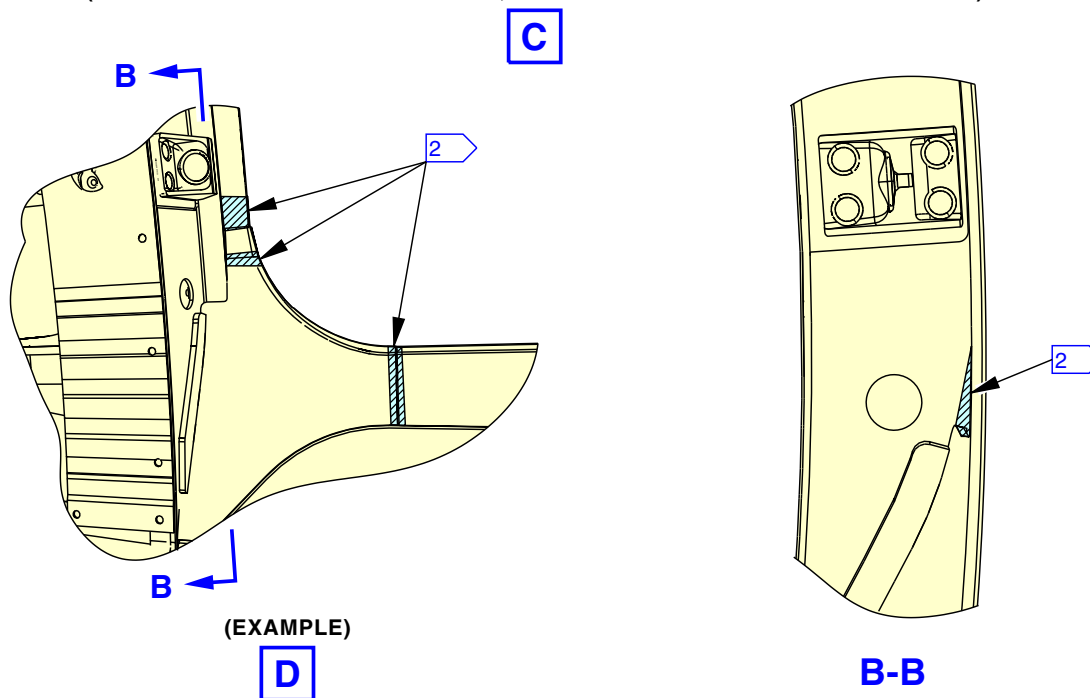
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FAIRING FILLER
(VIEW IN THE OUTBOARD DIRECTION)
(FORWARD CARGO DOOR IS SHOWN, AFT CARGO DOOR IS ALMOST THE SAME)



 FAIRING COMPOUND

 1 FILL FLUSH FASTENER RECESS FOR OUTBOARD FASTENER ROW COMMON TO THE DOOR SEAL PLANE/INTERFACE.

 2 FILL THE GAPS AND MISMATCHES.

2969212 S0000748418_V1

Cargo Door Scuff Plate Installation
Figure 401/53-11-02-990-802 (Sheet 3 of 3)

EFFECTIVITY
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TASK 53-11-02-420-801

3. Cargo Door Scuff Plate Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the cargo door scuff plate.

B. References

Reference	Title
51-22-00 P/B 201	SEALS AND SEALING - MAINTENANCE PRACTICES

C. Consumable Materials

Reference	Description	Specification
A01024	Compound - Fairing - 3M EC-3587B	BAC5530
A50250	Sealant - P/S 870 Class B-1/2 Corrosion Inhibitive Sealant	BMS5-95 Class B-1/2
A50343	Sealant - PPG Aerospace PR-1772 Class B Low Weight Fuselage Sealant	BMS5-142 Type II Class B
A50419	Sealant - Pressure And Environmental-Chromate, Type I, Class B-2	BMS5-95 Type I Class B-2
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
B00666	Solvent - Methyl Propyl Ketone	BMS11-9
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23
G02185	Agent - Peelable Parting (Valspar - 4A-183 Green Strippable Coating)Manufacturing discontinued, use stock until depleted	
G50313	Agent - Non-Peelable Parting (Henkel Loctite - Frekote 710-NC Mold Release)	BAC5000
G50365	Agent - Peelable Parting (AC Products - AC962-73C) Production discontinued, use stock until depleted.	BAC5000
G50366	Agent - Parting, Peelable, AZ 534-2B (0A3C8 - Aztec Chemical, Inc., El Monte, CA)	BAC5000, PSD 6-187
G50367	Agent - Peelable Parting (Aztec Chemical AZ 634-2)	MIL-PRF-6799, BAC5000
G50368	Agent - Peelable Parting (Rexco Chemical Company - Partall Coverall Film)	BAC5000
G50369	Coating - Alkaline Removable, Water Resistant	BMS15-12 Type I Class 1
G50734	Tape - Flame Retardant Hi-Tak (Av-DEC - HI-TAK HT3935-7FR-XXX)	

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
2	Scuff plate	53-11-02-01-080	SIA ALL
		53-11-02-01-085	SIA ALL
		53-11-02-02-080	SIA ALL
		53-11-02-02-095	SIA ALL

EFFECTIVITY
SIA ALL

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(Continued)

AMM Item	Description	AIPC Reference	AIPC Effectivity
4	Scuff plate	53-11-02-01-090	SIA ALL
		53-11-02-02-110	SIA ALL
7	Scuff plate	53-11-02-01-095	SIA ALL
		53-11-02-02-115	SIA ALL
9	Gasket	53-11-02-01-220	SIA ALL
		53-11-02-02-120	SIA ALL
12	Gasket	53-11-02-01-225	SIA ALL
		53-11-02-02-125	SIA ALL

E. Location Zones

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

F. Cargo Door Scuff Plate Installation

SUBTASK 53-11-02-420-001

- (1) Install the scuff plate [7].



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- (a) Clean all mating surfaces with solvent, B00184, or solvent, B00666.
- (b) Apply one layer of corrosion inhibiting compound, G00009, to the surface of the structure.
- (c) Install the new gasket [12].

NOTE: For the gasket (143A8335-2) use one piece of the HI-TAK Tape, G50734, 8 in. (20 cm) x 52 in. (132 cm).

NOTE: For the gasket (146A8335-2) use one piece of the HI-TAK Tape, G50734, 8 in. (20 cm) x 52.5 in. (133 cm).

- 1) Install the gasket [12] until its outboard edge aligns with the outboard edge of the holes on the scuff plate [7].
 - (d) Install the gel tape [10] (HI-TAK Tape, G50734).
 - 1) Install the forward edge gel tape [10] (HI-TAK Tape, G50734) to align with the forward edge holes on the scuff plate [7].
 - 2) Install the inboard edge gel tape [10] (HI-TAK Tape, G50734) to align with the inboard edge holes of the scuff plate [7].
 - 3) Install the aft edge gel tape [10] (HI-TAK Tape, G50734) to align with the aft edge holes on the scuff plate [7].
 - 4) Install the middle strip gel tape [10] (HI-TAK Tape, G50734) on the center of the rail.
- NOTE: The gel tape (HI-TAK Tape, G50734) can hang along the center of the scuff plate [7].

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- (e) Install the scuff plate [7] in its position.
- (f) Install the screws [8] that attach the scuff plate [7] to the structure.
 - 1) Apply P/S 870 Class B-1/2 sealant, A50250, or sealant, A50419, to the screws [8].
 - 2) Tighten the screws [8] to 18 in-lb (2.0 N·m) - 22 in-lb (2.5 N·m).

SUBTASK 53-11-02-420-002

- (2) Install the forward and aft scuff plates [2].



WARNING

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- (a) Clean all mating surfaces with solvent, B00148, or solvent, B00666.
- (b) Apply one layer of corrosion inhibiting compound, G00009, Type II to the structure and skin area.
- (c) Apply two layers of parting agent to the scuff plates in all areas of a mating surface (PAGEBLOCK 51-22-00/201).
 - 1) Use AC962-73C peelable parting agent, G50365 (recommended), or one of these parting agents:
 - a) Optional Valspar 4A-183 green strippable coating, G02185
 - b) Optional AZ-534-2B peelable parting agent, G50366
 - c) Optional AZ 634-2 peelable parting agent, G50367
 - d) Optional Rexco Partall Coverall Film peelable parting agent, G50368
 - e) Optional temporary coating, G50369
 - f) Optional Frekote 710-NC non-peelable parting agent, G50313.
- (d) Apply a fay surface seal between the skin and the forward and aft scuff plates [2] with P/S 870 Class B-1/2 sealant, A50250, or sealant, A50419.
- (e) Install the forward and aft scuff plates [2] in their positions.
- (f) Install the screws [3] that attach the scuff plates [2] to the structure.
 - 1) Apply P/S 870 Class B-1/2 sealant, A50250, or sealant, A50419, to the screws [3].
 - 2) Tighten the screws [3] to 18 in-lb (2.0 N·m) - 22 in-lb (2.5 N·m).
- (g) Install the filler scuff plates [1].



WARNING

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- (h) Clean all mating surfaces with solvent, B00148, or solvent, B00666.

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- (i) Bond the filler scuff plate [1] to the structure with P/S 870 Class B-1/2 sealant, A50250, or sealant, A50419.

SUBTASK 53-11-02-420-003

- (3) Install the scuff plate [4].



WARNING

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- (a) Clean all mating surfaces with solvent, B00148, or solvent, B00666.
- (b) Apply one layer of corrosion inhibiting compound, G00009, Type II to the structure and skin area.
- (c) Install the inboard edge of the new gasket [9] to align with the inboard edge holes on the scuff plate [4].
NOTE: For the gasket (143A8335-1) use one piece of the HI-TAK Tape, G50734, 3 in. (8 cm) x 36.5 in. (93 cm).
NOTE: For the gasket (146A8335-1) use one piece of the HI-TAK Tape, G50734, 3 in. (8 cm) x 36 in. (91 cm).
- (d) Install the filler scuff plate [6].
 - 1) Bond the filler scuff plate [6] to the structure with P/S 870 Class B-1/2 sealant, A50250, or sealant, A50419.
- (e) Apply two layers of parting agent to the scuff plates in all areas of a mating surface (PAGEBLOCK 51-22-00/201).
 - 1) Use AC962-73C peelable parting agent, G50365 (recommended), or one of these parting agents:
 - a) Optional Valspar 4A-183 green strippable coating, G02185
 - b) Optional AZ 534-2B peelable parting agent, G50366
 - c) Optional AZ 634-2 peelable parting agent, G50367
 - d) Optional Rexco Partall Coverall Film peelable parting agent, G50368
 - e) Optional temporary coating, G50369
 - f) Optional Frekote 710-NC non-peelable parting agent, G50313.
- (f) Apply P/S 870 Class B-1/2 sealant, A50250, or sealant, A50419, to the scuff plate [4] around the filler scuff plate [6].
- (g) Apply a fay surface seal between the skin and scuff plate [4] with P/S 870 Class B-1/2 sealant, A50250, or sealant, A50419.
- (h) Install the scuff plate [4] in its position.
- (i) Install the screws [5] that attach the scuff plate [4] to the structure.
 - 1) Apply P/S 870 Class B-1/2 sealant, A50250, or sealant, A50419, to the screws [5].
 - 2) Tighten the screws [5] to 18 in-lb (2.0 N·m) - 22 in-lb (2.5 N·m).

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SUBTASK 53-11-02-390-003

- (4) Fill the gaps flush with P/S 870 Class B-1/2 sealant, A50250, or sealant, A50419, around the scuff plate [4], scuff plate [7], forward and aft scuff plates [2] and bull nose.

SUBTASK 53-11-02-390-001

- (5) Remove excess sealant from the gap and edge after squeeze-out has stopped.

SUBTASK 53-11-02-390-002

- (6) Apply 3M EC-3587B compound, A01024 (fairing) or PR-1772 Class B Sealant, A50343 (as alternative), to the gaps and fastener recesses common to the door seal.
- (a) Clean areas to be filled with solvent, B00148, or solvent, B00666.
 - (b) Fill flush fastener recesses for outboard fastener row that are common to the door seal plane/interface only (View C, Figure 401).
 - (c) Sand smooth to a visually equivalent RHR 125 finish that is flush with adjacent surfaces.
 - (d) Fill the gaps and mismatches (View D, Figure 401).
 - (e) To obtain a smooth continual surface around the corner of the body opening, smooth and blend phenolic filler (if it is necessary) and fairing compound in indicated areas .
 - 1) Make a smooth fair ramp at a minimum ratio of 10 to 1.
 - (f) Sand smooth with no abrupt transition to a visually equivalent RHR 125 finish.

———— **END OF TASK** ————

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NOSE WHEEL WELL ACCESS PANELS - REMOVAL/INSTALLATION

1. **General**

- A. This procedure has these tasks:
- (1) Nose wheel well access panels removal
 - (2) Nose wheel well access panels installation.

TASK 53-14-01-020-801

2. **Nose Wheel Well Access Panels Removal**

(Figure 401)

A. **General**

- (1) This task gives the instructions to remove the nose wheel well access panels.
- (2) The nose wheel well access panel is referred to as the access panel in this task.

B. **References**

Reference	Title
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)

C. **Location Zones**

Zone	Area
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right

D. **Prepare for the Removal**

SUBTASK 53-14-01-480-001



MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED ON ALL THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT. THIS CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.

- (1) Make sure that the downlock pins are installed on the nose and main landing gear (TASK 32-00-01-480-801).

E. **Forward Side Access Panel Removal**

SUBTASK 53-14-01-020-001

- (1) Remove the 36 hex bolts [15], flat washers [16], and O-ring seal washers [17] from the applicable forward side access panel [18].
 - (a) Discard the 36 O-ring seal washers [17].

SUBTASK 53-14-01-020-002

- (2) Remove the forward side access panel [18].

F. **Aft Side Access Panel Removal**

SUBTASK 53-14-01-020-004

- (1) Remove the 28 hex bolts [12], flat washers [11], and O-ring seal washers [10] from the applicable aft side access panel [13].
 - (a) Discard the 28 O-ring seal washers [10].

SUBTASK 53-14-01-020-005

- (2) Remove the aft side access panel [13].

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G. Top Access Panels Removal

SUBTASK 53-14-01-020-007

- (1) Remove the two hex bolts [5], flat washers [6], and O-ring seal washers [7] from the spin brake spring assembly.
 - (a) Discard the two O-ring seal washers [7].

SUBTASK 53-14-01-020-008

- (2) Remove the applicable top access panel [8].
 - (a) Remove the 27 hex bolts [4], flat washers [3], and O-ring seal washers [2].
 - (b) Remove the top access panel [8].
 - (c) Discard the 27 O-ring seal washers [2].

———— **END OF TASK** ————

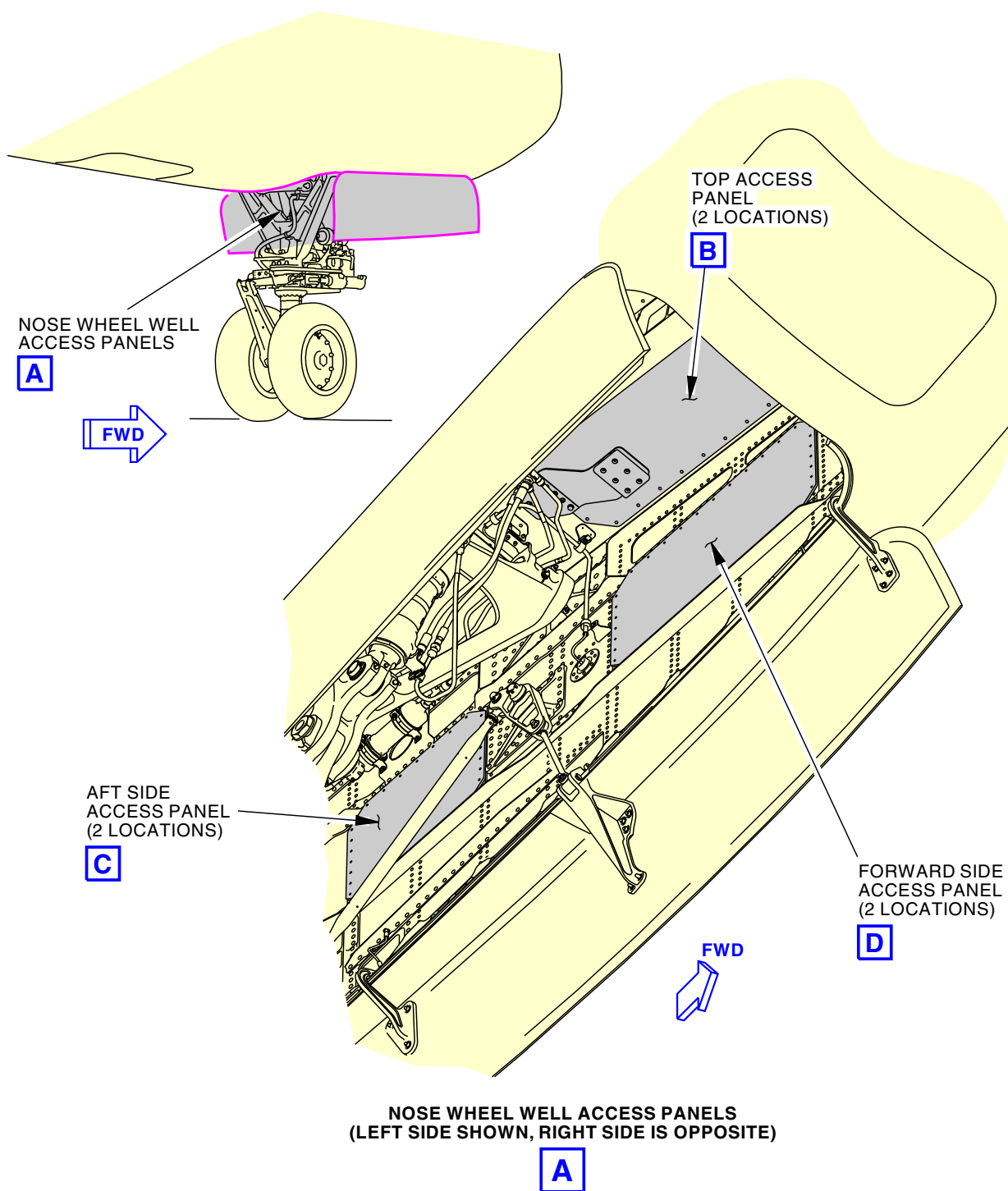
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Nose Wheel Well Access Panels Installation
Figure 401/53-14-01-990-801 (Sheet 1 of 4)

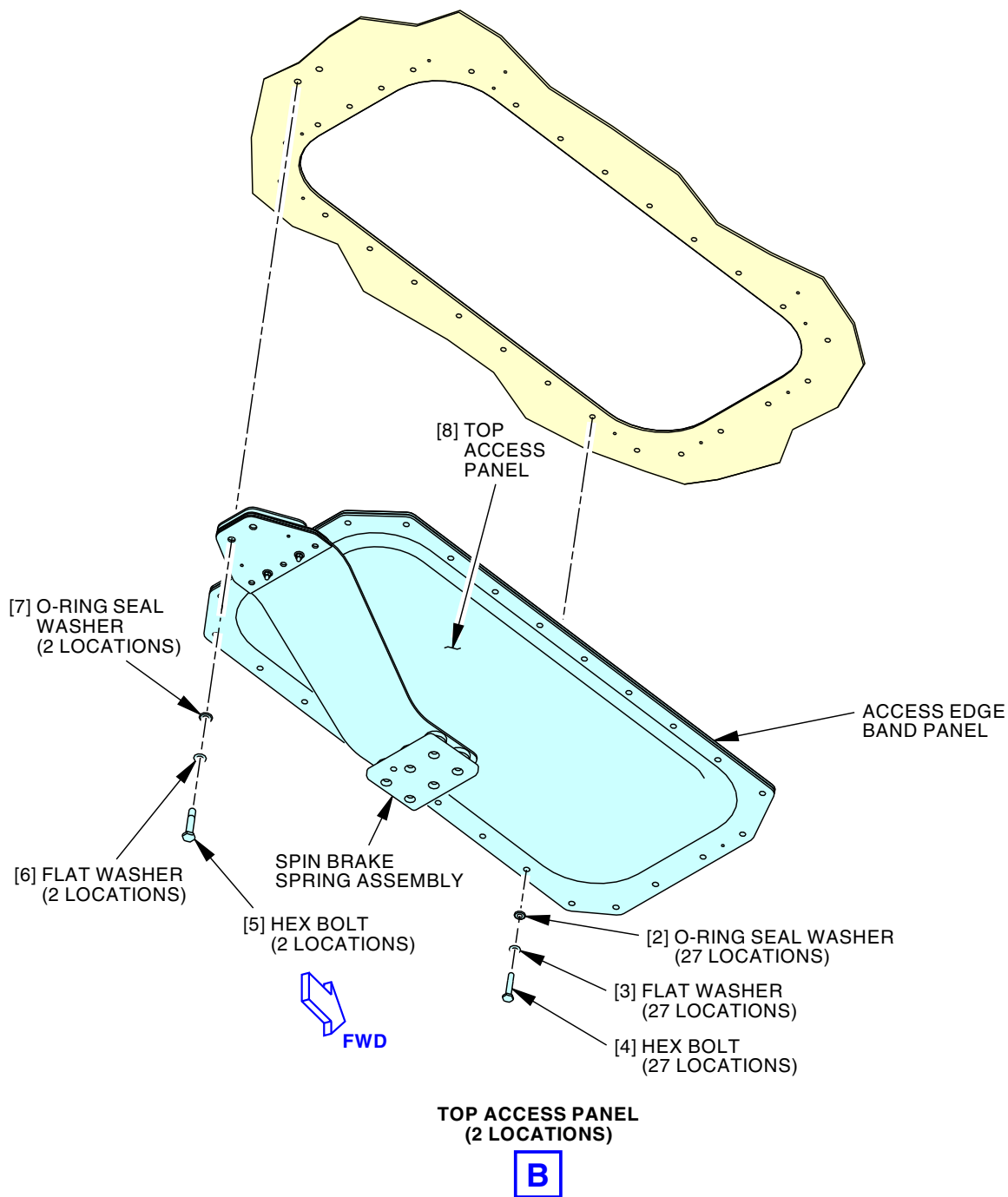
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Nose Wheel Well Access Panels Installation
Figure 401/53-14-01-990-801 (Sheet 2 of 4)

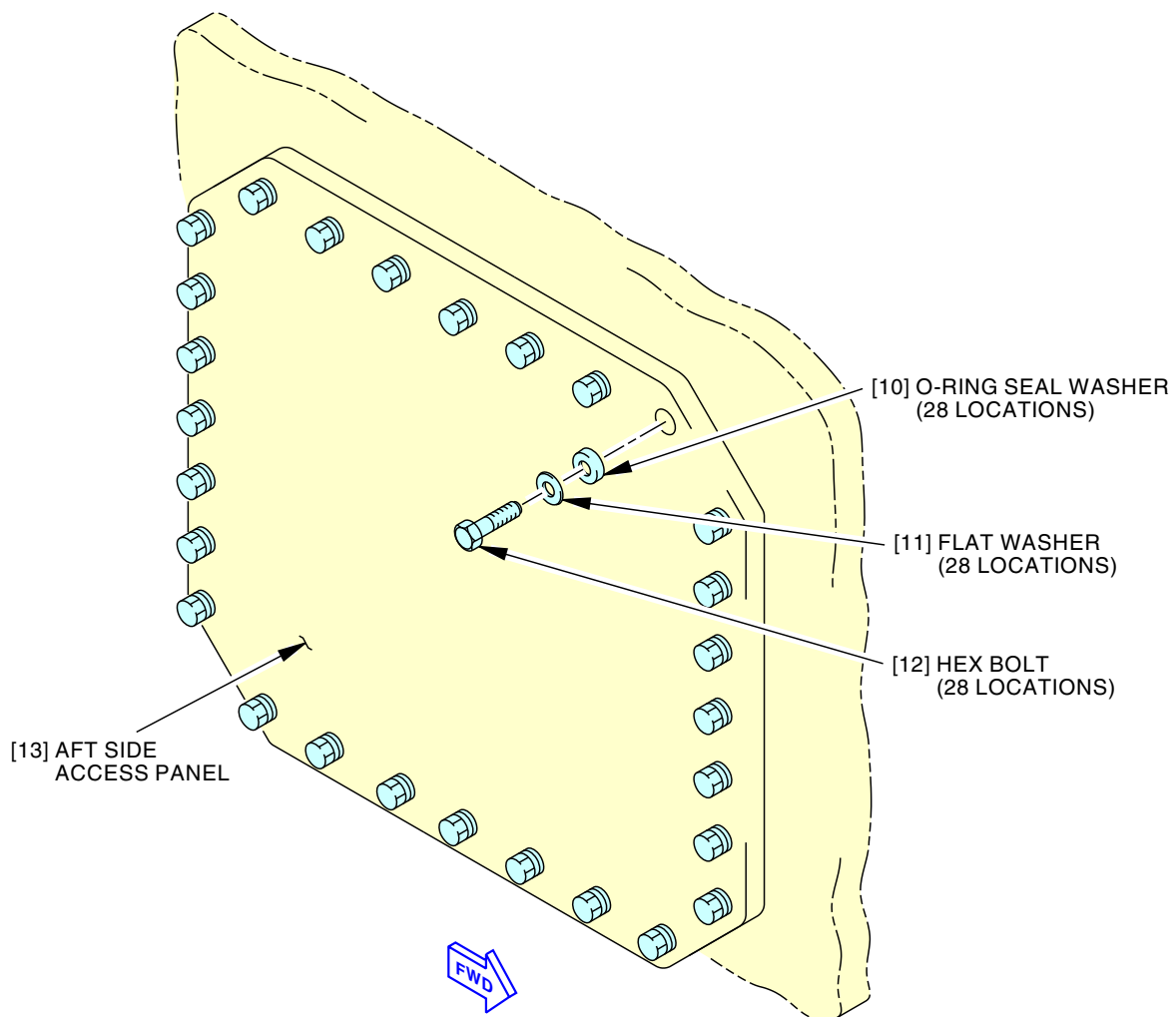
EFFECTIVITY
SIA ALL

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AFT SIDE
ACCESS PANEL
(TYPICAL)

C

2416164 S00061539859_V4

Nose Wheel Well Access Panels Installation
Figure 401/53-14-01-990-801 (Sheet 3 of 4)

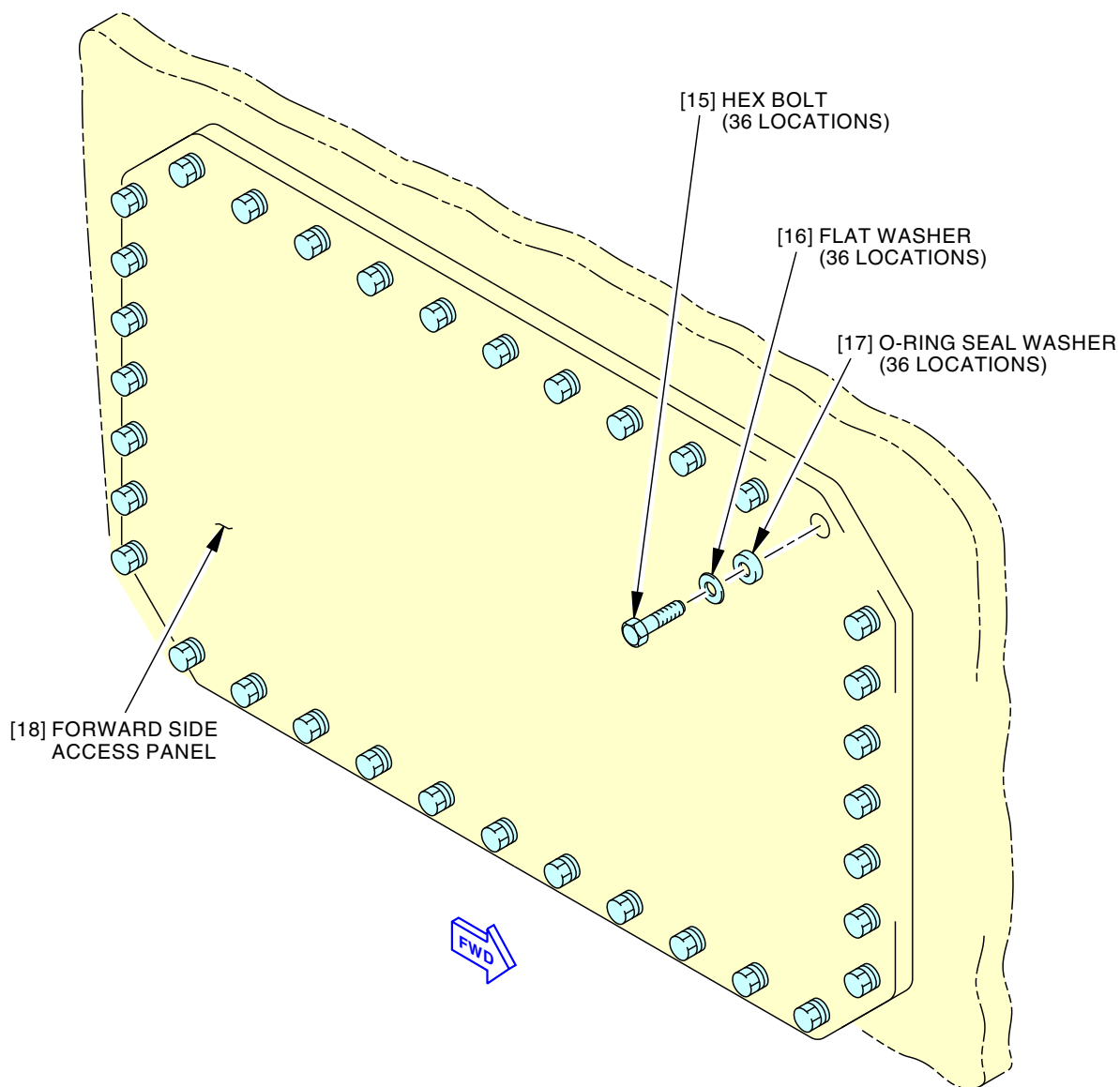
EFFECTIVITY
SIA ALL

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FORWARD SIDE
ACCESS PANEL
(TYPICAL)

D

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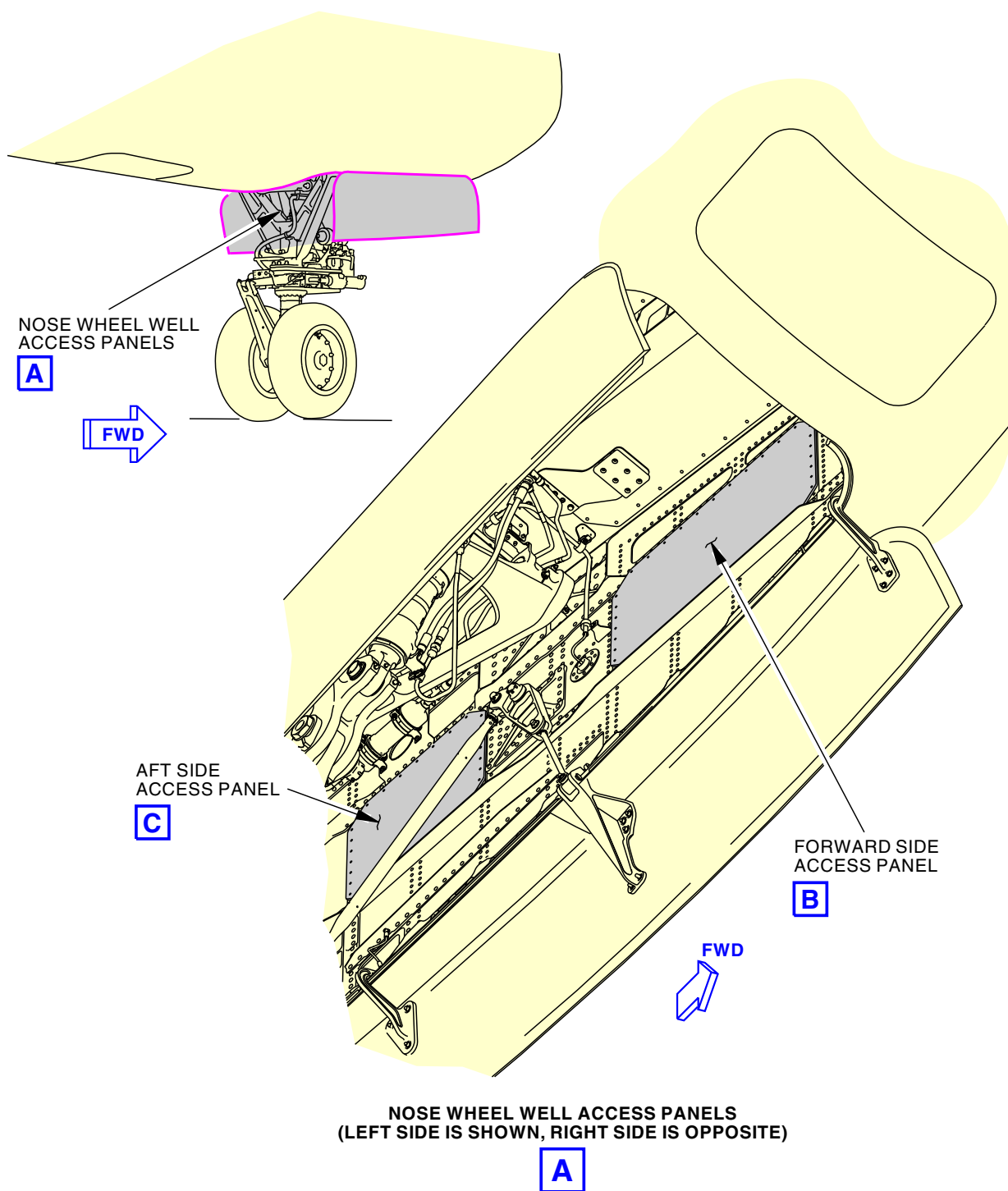
Nose Wheel Well Access Panels Installation
Figure 401/53-14-01-990-801 (Sheet 4 of 4)

EFFECTIVITY
SIA ALL

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2978108 S0000756284_V1

Nose Wheel Well Access Panel Sealant Inspection
Figure 402/53-14-01-990-802 (Sheet 1 of 3)

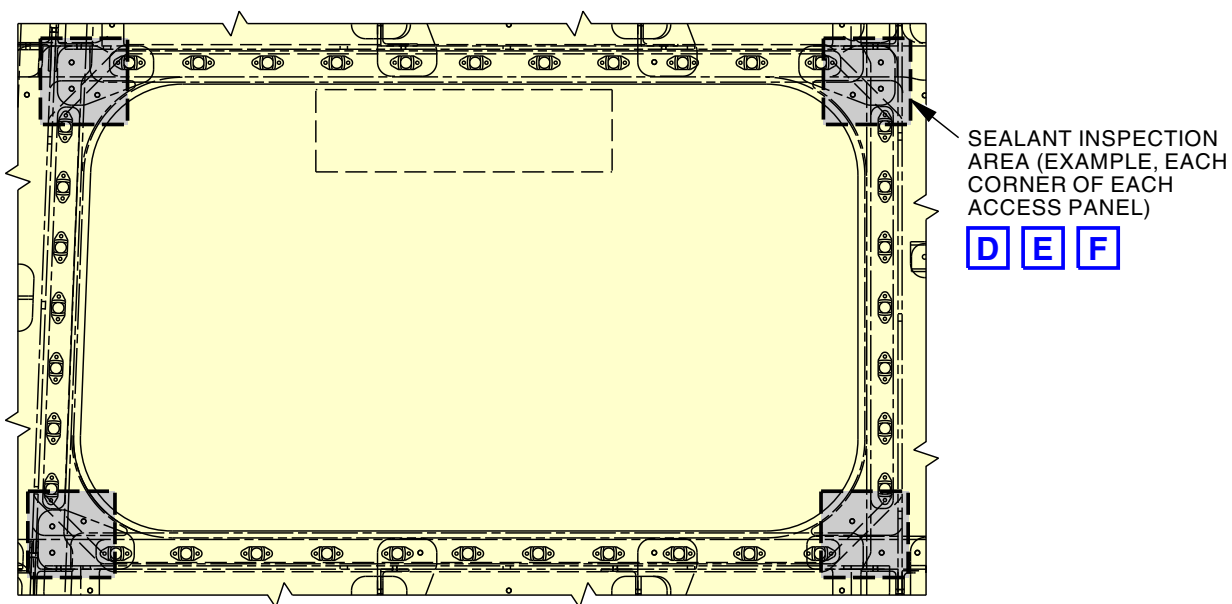
EFFECTIVITY
SIA ALL

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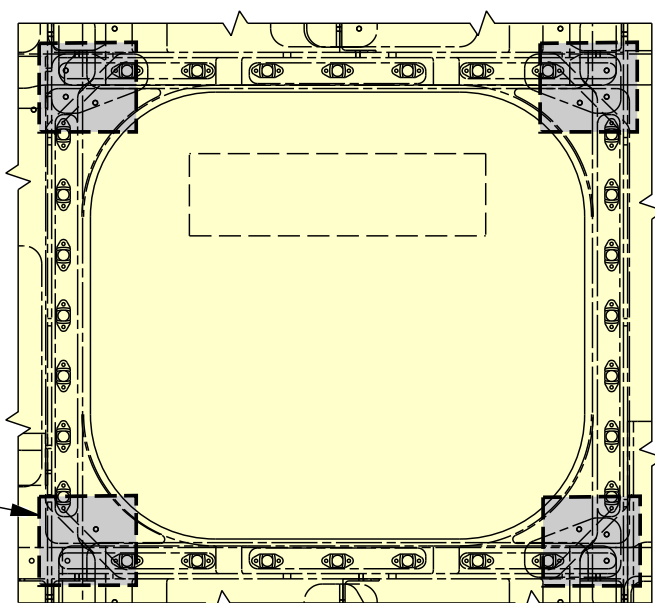


FORWARD SIDE ACCESS PANEL
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

B

SEALANT INSPECTION AREA
(EXAMPLE, EACH CORNER OF
EACH ACCESS PANEL)

D E F



AFT SIDE ACCESS PANEL
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

C

2978128 S0000756287_V1

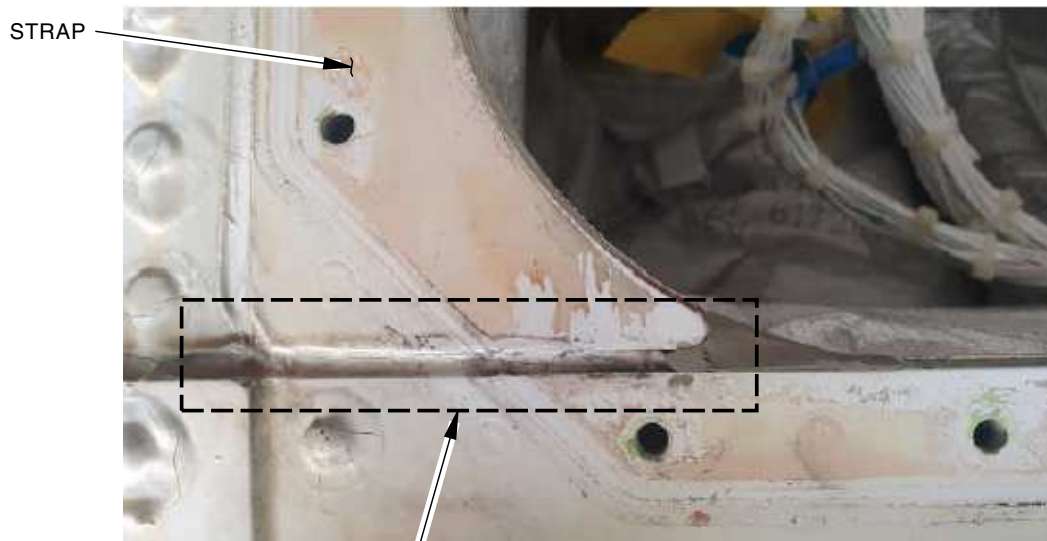
Nose Wheel Well Access Panel Sealant Inspection
Figure 402/53-14-01-990-802 (Sheet 2 of 3)

EFFECTIVITY
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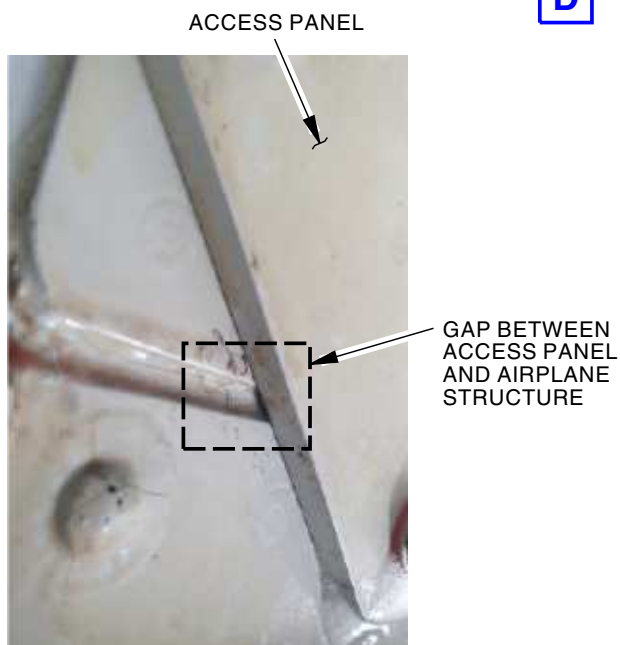


MISSING SEALANT OR SEALANT DOES NOT FORM A
PRESSURE SEAL BETWEEN STRUCTURE AND ACCESS PANEL

**SEALANT INSPECTION AREA
(ACCESS PANEL IS REMOVED)**

D

MISSING SEALANT OR SEALANT
DOES NOT FORM A PRESSURE
SEAL BETWEEN STRUCTURE
AND ACCESS PANEL



SEALANT INSPECTION AREA

E



**SEALANT INSPECTION AREA
(ACCESS PANEL IS REMOVED)**

F

2978134 S0000756347_V1

Nose Wheel Well Access Panel Sealant Inspection
Figure 402/53-14-01-990-802 (Sheet 3 of 3)

EFFECTIVITY
SIA ALL

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TASK 53-14-01-420-801

3. **Nose Wheel Well Access Panels Installation**

(Figure 401 and Figure 402)

A. General

- (1) This task gives the instructions to install the nose wheel well access panels.
- (2) The nose wheel well access panel is referred to as the access panel in this task.

B. References

Reference	Title
05-51-91-790-801	Cabin Pressure Leak Test (P/B 201)
51-22-00-390-805	Hole and Slot Seal Application (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
2	O-ring seal washer	32-22-11-02-040	SIA ALL
7	O-ring seal washer	32-22-11-02-045	SIA ALL
8	Top access panel	32-22-11-02-105	SIA ALL
		32-22-11-02-110	SIA ALL
		32-22-11-02-145	SIA ALL
		32-22-11-02-150	SIA ALL
10	O-ring seal washer	32-22-11-02-050	SIA ALL
13	Aft side access panel	32-22-11-02-210	SIA ALL
17	O-ring seal washer	32-22-11-02-050	SIA ALL
18	Forward side access panel	32-22-11-02-185	SIA ALL
		32-22-11-02-190	SIA ALL

E. Location Zones

Zone	Area
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right

F. Prepare for the Installation

SUBTASK 53-14-01-210-001

- (1) Examine the sealant areas for the forward and aft side access panels 113AW, 113BW, 114AW, and 114BW as shown in Figure 402.
 - (a) Make sure that the sealant is not damaged.
 - (b) Make sure that the sealant is not missing.
 - (c) Make sure that there are no gaps between the access panels and the airplane structure.
 - (d) Make sure that there are no signs of cabin pressure leak.
 - (e) If there are signs of damage or missing sealant, remove the access panels.
 - 1) Apply sealant, A00247 per Hole and Slot Seal Application, TASK 51-22-00-390-805.

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- 2) Install the access panels.

G. Forward Side Access Panels Installation

SUBTASK 53-14-01-420-001

- (1) Install the applicable forward side access panel [18].
 - (a) Do an inspection of the gasket flushed on the forward side access panel [18] for damage.
 - 1) If you find damage, install a new forward side access panel [18].
 - (b) Align the forward side access panel [18] against the structure.
 - (c) Install the 36 hex bolts [15], flat washers [16], and new O-ring seal washers [17].

SUBTASK 53-14-01-420-002

- (2) Tighten the 36 hex bolts [15] to 30 ± 5 in-lb (3.4 ± 0.6 N·m).

SUBTASK 53-14-01-790-001

- (3) Make sure that there are no air leaks, do this task: Cabin Pressure Leak Test, TASK 05-51-91-790-801.

H. Aft Side Access Panels Installation

SUBTASK 53-14-01-420-003

- (1) Install the applicable aft side access panel [13].
 - (a) Do an inspection of the gasket flushed on the aft side access panel [13] for damage.
 - 1) If you find damage, install a new aft side access panel [13].
 - (b) Align the aft side access panel [13] against the structure.
 - (c) Install the 28 hex bolts [12], flat washers [11], and new O-ring seal washers [10].

SUBTASK 53-14-01-420-004

- (2) Tighten the 28 hex bolts [12] to 30 ± 5 in-lb (3.4 ± 0.6 N·m).

SUBTASK 53-14-01-790-002

- (3) Make sure that there are no air leaks, do this task: Cabin Pressure Leak Test, TASK 05-51-91-790-801.

I. Top Access Panels Installation

SUBTASK 53-14-01-420-008

- (1) Install the top access panel [8].
 - (a) Do an inspection of the gasket flushed on the top access panel [8] for damage.
 - 1) If you find damage, install a new top access panel [8].
 - (b) Align the top access panel [8] with the structure.
 - (c) Install the two hex bolts [5], flat washers [6], and new O-ring seal washers [7] to secure the spring assembly to the structure.
 - (d) Install the 27 hex bolts [4], flat washers [3], and new O-ring seal washers [2] to secure the top access panel [8] to the structure.

SUBTASK 53-14-01-420-009

- (2) Tighten the two hex bolts [5] and 27 hex bolts [4] to 60 ± 10 in-lb (6.8 ± 1.2 N·m).

SUBTASK 53-14-01-790-003

- (3) Make sure that there are no air leaks, do this task: Cabin Pressure Leak Test, TASK 05-51-91-790-801.

————— END OF TASK —————

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PASSENGER CABIN FLOORS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Passenger cabin floor panel removal
 - (2) Passenger cabin floor panel installation.

TASK 53-21-00-000-801

2. Passenger Cabin Floor Panel Removal

(Figure 401 or Figure 402)

A. **General**

- (1) This task has one or more steps which are a means to satisfy Critical Design Configuration Control Limitation (CDCCL) requirements. A CDCCL note will follow the step to which it applies. Any step or sub-step that precedes or follows a CDCCL identified step is not subject to the CDCCL requirement.
 - (a) For important information on CDCCL requirements, refer to this task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801.

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.
 - (b) This task gives the instructions to remove the passenger cabin floor panel.

B. **References**

Reference	Title
25-27-21-000-801	Entry and Service Area Floor Covering - Removal (P/B 401)
28-11-00-211-801	External Wires Near the Center Fuel Tank Inspection (P/B 601)
53-00-00-912-801	Airworthiness Limitation Precautions (P/B 201)
53-21-11-300-801	Vinyl Water Barrier Repair (P/B 801)

C. **Tools/Equipment**

Reference	Description
STD-1064	Scraper - Phenolic, Hard Resin

D. **Passenger Cabin Floor Panel Removal**

SUBTASK 53-21-00-010-001

- (1) Break the panel seals.
 - (a) If the water barrier is installed, get access to the panel fasteners (TASK 53-21-11-300-801).
 - (b) If the entry and service area floor covering is installed, get access to the panel fasteners (TASK 25-27-21-000-801).
 - (c) If the nylon cord is installed in the sealant, pull the nylon cord to break the seal.
 - (d) Break the seals without a nylon cord installed with a hard resin phenolic scraper, STD-1064, or a sealant removal tool.

SUBTASK 53-21-00-020-001

- (2) Remove the fasteners.

SUBTASK 53-21-00-020-002

- (3) Remove the panel.

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SUBTASK 53-21-00-010-002

 28-AWL-02: CDCCL

- (4) If you removed the panels over the center fuel tank and do maintenance, preventative maintenance, or alteration in any area within 12 in. (305 mm) from the fuel tank, do these steps:

NOTE: CDCCL- Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important Information on CDCCL.

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

 28-AWL-02: CDCCL

- (a) Make sure that you do not change the routing and clamping of the wires over the center fuel tank.

NOTE: CDCCL- Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important Information on CDCCL.

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

 28-AWL-02: CDCCL

- (b) Before you install the panels over the center tank, do this task only for the areas over the center tank where you removed the panels: External Wires Near the Center Fuel Tank Inspection, TASK 28-11-00-211-801.

NOTE: CDCCL- Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important Information on CDCCL.

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

———— **END OF TASK** ————

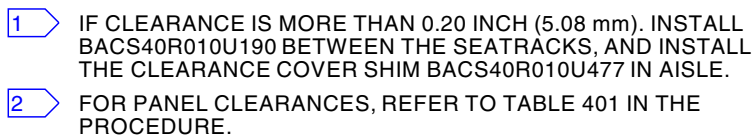
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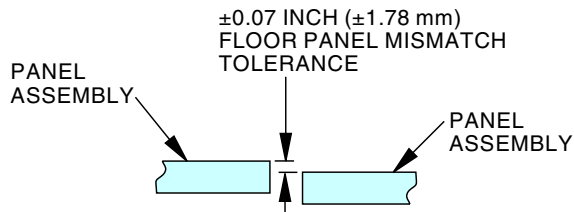
Floor Panel Installation and Sealing
Figure 401/53-21-00-990-803 (Sheet 1 of 2)

53-21-00

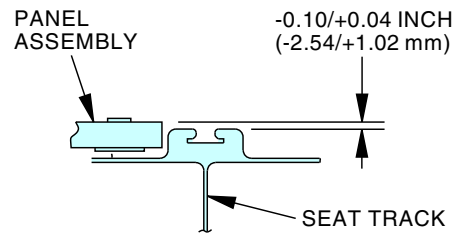
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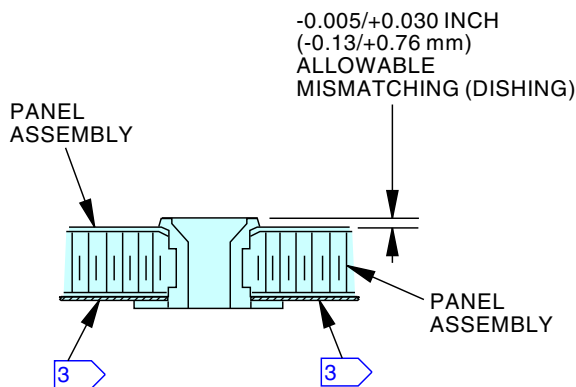
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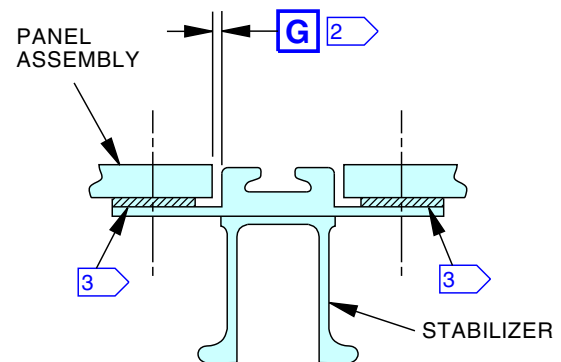
TYPICAL MISMATCH DIMENSION FOR FLOOR
PANEL INSTALLATION



TYPICAL MISMATCH DIMENSION FOR FLOOR
PANEL INSTALLATION

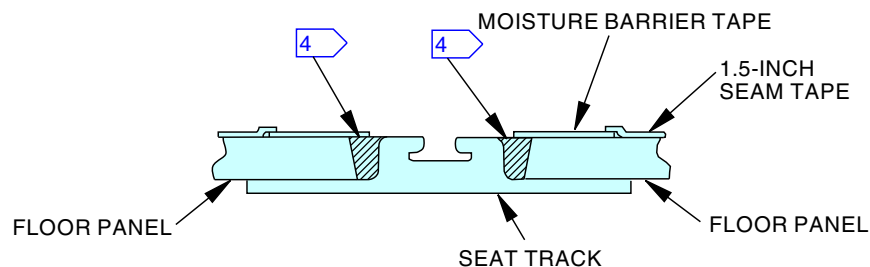


TYPICAL MISMATCH DIMENSION FOR FLOOR
PANEL INSTALLATION



TYPICAL MISMATCH DIMENSION FOR FLOOR
PANEL INSTALLATION

D-D



TYPICAL FLOOR PANEL SEALING AT
SEAT TRACKS

2 FOR PANEL CLEARANCES, REFER TO TABLE 401
IN THE PROCEDURE.

3 HI-TAK TAPE

4 SEALANT

2416165 S00061539865_V3

Floor Panel Installation and Sealing
Figure 401/53-21-00-990-803 (Sheet 2 of 2)

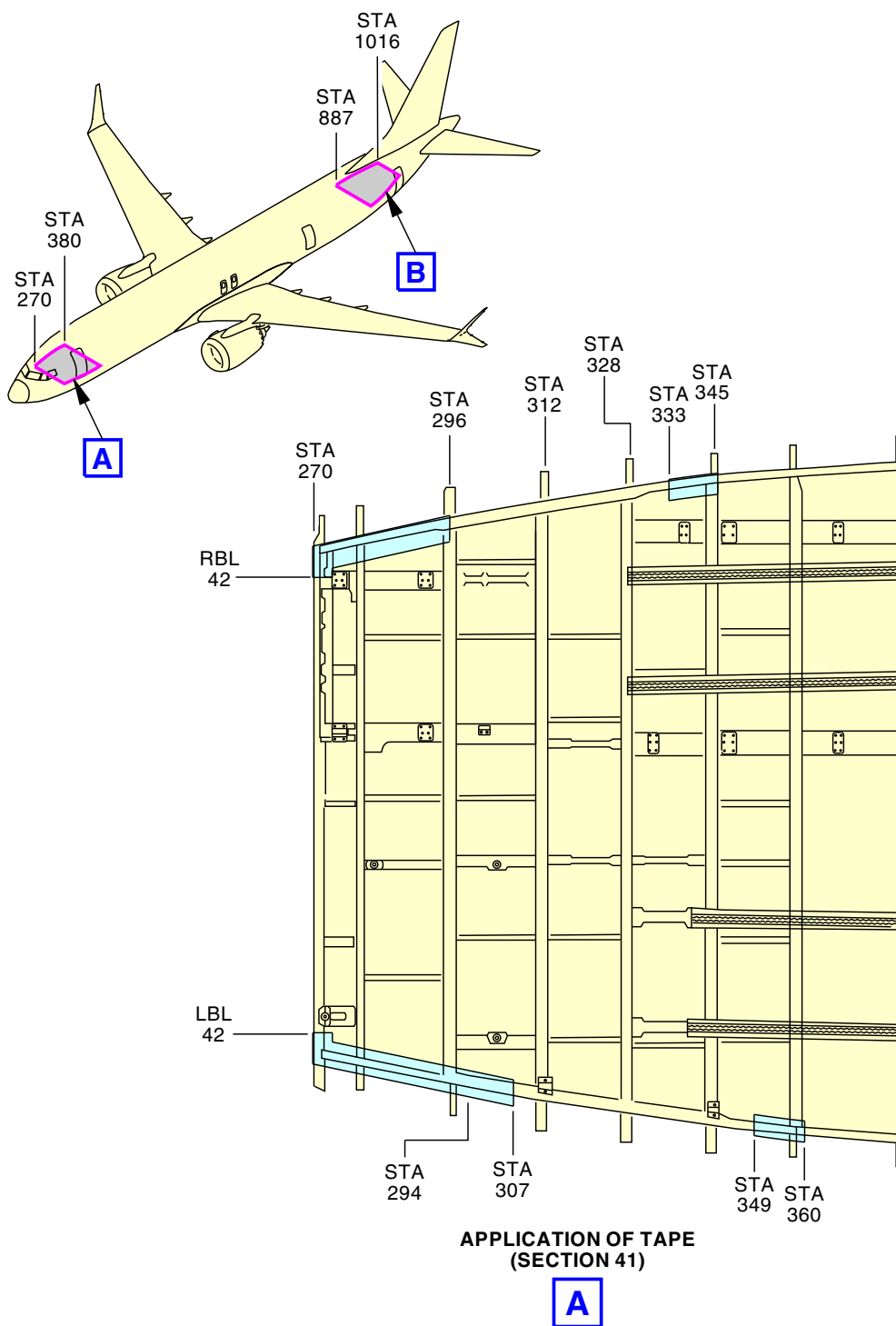
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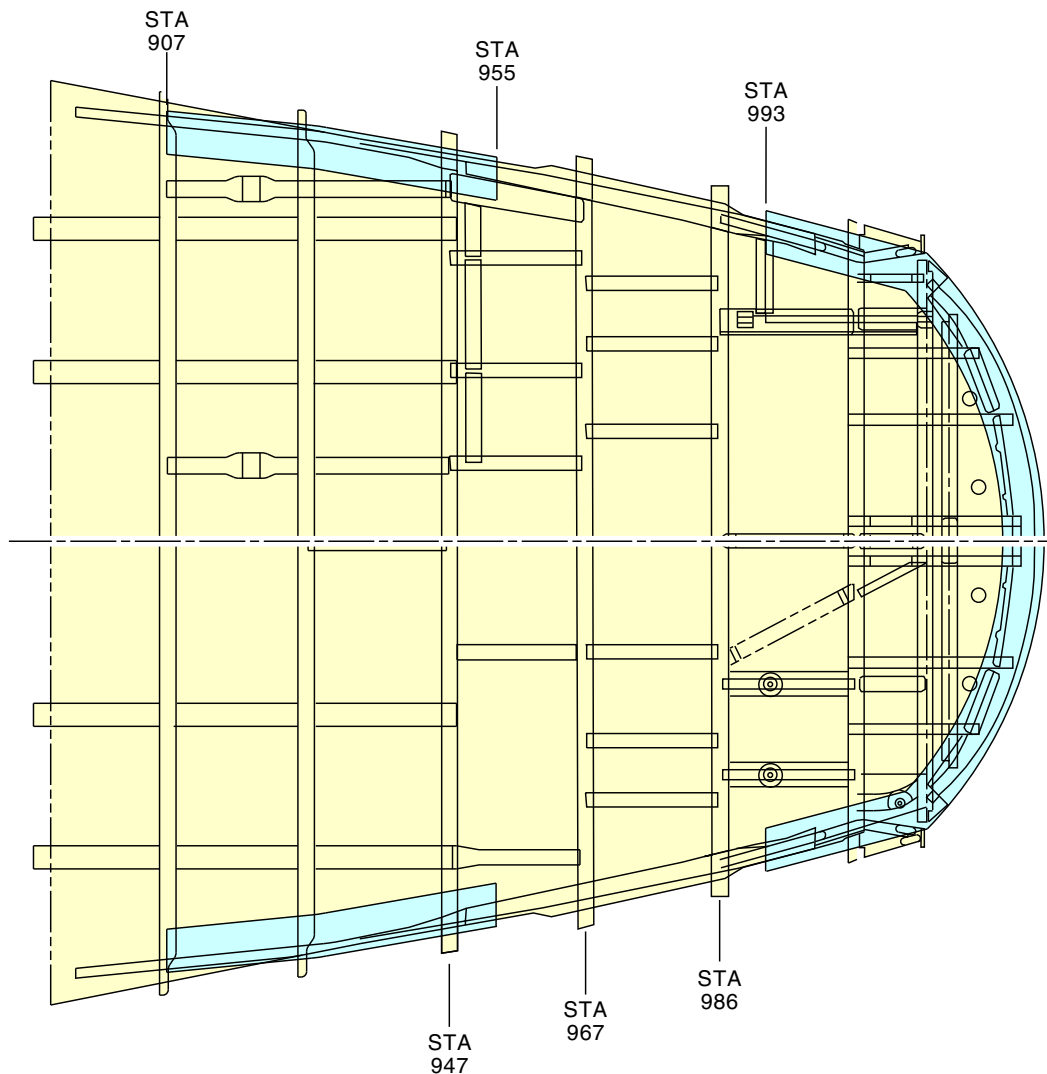
Floor Panel Sealing
Figure 402/53-21-00-990-804 (Sheet 1 of 4)

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APPLICATION OF TAPE
(SECTION 47)

B

2880900 S0000682333_V2

Floor Panel Sealing
Figure 402/53-21-00-990-804 (Sheet 2 of 4)

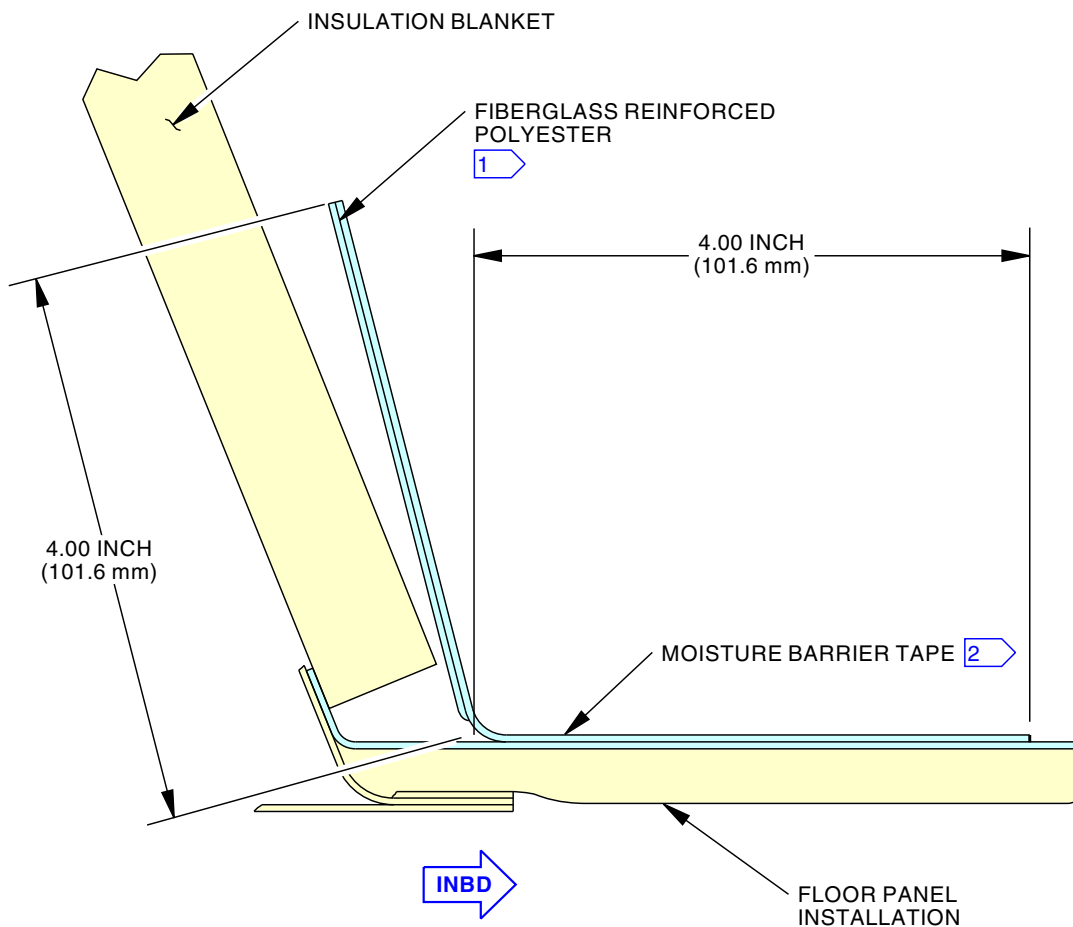
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- 1 PER BMS 8-2 CLASS 1 GRADE A TYPE 13
- 2 PER BMS 8-346 CLASS 4 GRADE A TYPE II

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Floor Panel Sealing
Figure 402/53-21-00-990-804 (Sheet 3 of 4)

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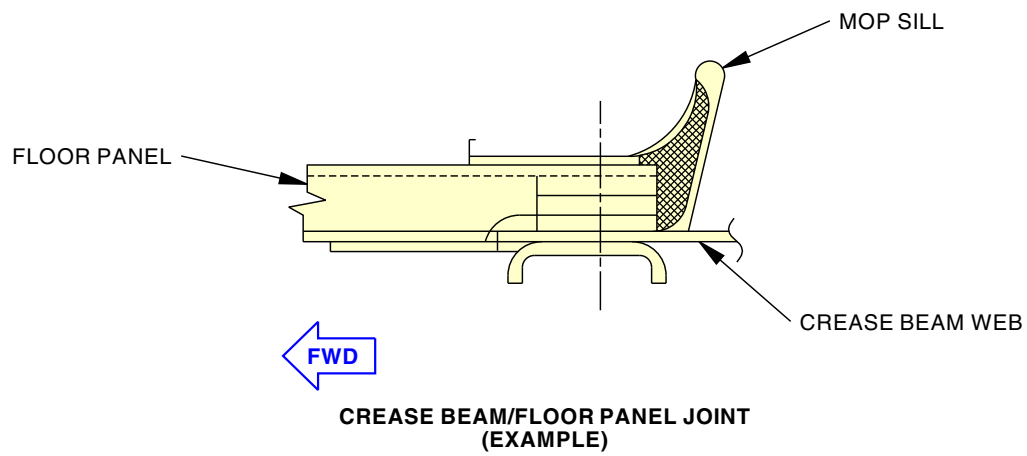
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2880902 S0000682335_V1

Floor Panel Sealing
Figure 402/53-21-00-990-804 (Sheet 4 of 4)

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TASK 53-21-00-400-801

3. Passenger Cabin Floor Panel Installation

(Figure 401 or Figure 402)

A. General

(1) This task has one or more steps which are a means to satisfy Critical Design Configuration Control Limitation (CDCCL) requirements. A CDCCL note will follow the step to which it applies. Any step or sub-step that precedes or follows a CDCCL identified step is not subject to the CDCCL requirement.

(a) For important information on CDCCL requirements, refer to this task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801.

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

(b) This task gives the instructions to install the passenger cabin floor panel.

B. References

Reference	Title
25-27-21-400-801	Entry and Service Area Floor Covering - Installation (P/B 401)
28-11-00-211-801	External Wires Near the Center Fuel Tank Inspection (P/B 601)
53-00-00-912-801	Airworthiness Limitation Precautions (P/B 201)
53-21-00-300-801	Polyurethane Waterseal Repair (P/B 801)

C. Tools/Equipment

Reference	Description
STD-449	Gun - Sealant
STD-745	Roller - Hard Rubber
STD-810	Spatula - Fillet Smoothing, Hardwood or Plastic

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A00306	Resin - Urethane - Flexane-80	
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
B00666	Solvent - Methyl Propyl Ketone	BMS11-9
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
C00953	Primer - Devcon Flexane FL-20	
C50033	Coating - Chemical Conversion - Bonderite M-CR 1200S Aero (Formerly Alodine 1200)	BAC5719 Class A, C or D, MIL-DTL-81706 Type I Class 1A or 3
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G02092	Tape - Flexible Foam Sound Damping And Sealing Tape	BMS8-283

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(Continued)

Reference	Description	Specification
G02424	Tape - Skyflex Noise Reduction - GUA1057-1, GUA1059-1, GUA1057-144	
G50019	Tape - Flexible Foam Sound Damping And Sealing Tape	BMS8-283 Type I
G50029	Sleeving - Expandable, Braided (Polyester, Tight Weave)	BMS13-52 Type V
G50738	Tape - Flame Retardant Hi-Tak TufSeal, (Av-DEC - HI-TAK HT3000FR-XXX)	
G51339	Fabric, General Purpose, Rigid, Fire Retarded, Glass Fabric Reinforced Plastic Sheetting	BMS8-2 Type 13, Class 1, Grade A
G51340	Tape - Moisture Barrier, Adhesive One-side	BMS8-346 Type II Class 4
G51561	Tape - Vinyl Foam, 1 Inch (25.40 mm) Wide - 3M 4508	

E. Passenger Cabin Floor Panel Installation

SUBTASK 53-21-00-210-001

 28-AWL-02: CDCCL

- (1) If you removed the panels over the center fuel tank and do maintenance in the area above the center fuel tank, do these steps:

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important Information on CDCCL.

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

 28-AWL-02: CDCCL

- (a) Make sure that you do not change the routing and clamping of the wires over the center fuel tank.

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important Information on CDCCL.

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

 28-AWL-02: CDCCL

- (b) Before you install the panels over the center tank, do this task only for the areas over the center tank where you removed the panels: External Wires Near the Center Fuel Tank Inspection, TASK 28-11-00-211-801.

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important Information on CDCCL.

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

SUBTASK 53-21-00-390-001

- (2) Prepare the fastener holes for the floor panel in the wet areas of the structure as follows:
- (a) Clean and apply Bonderite M-CR 1200S Aero coating, C50033, to the bare aluminum surface on the floor support structure.
 - (b) Apply one layer of primer, C00259, to the floor support structure.
 - (c) Apply compound, C00528, to the holes.
 - (d) If the clipnuts were removed, install the new clipnuts:

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- 1) Apply compound, C00528, to the floor support structure at the clipnut locations.
- 2) Install new composite torlon clipnuts everywhere on the floor structure at the floor panel attachment locations (recommended BACN11AL, optional BACN10YDG) to improve corrosion resistance.

NOTE: Be careful when you install the clipnuts to prevent scratches on the floor support structure.

- 3) Turn the clipnuts in the clockwise direction against the floor support structure.

SUBTASK 53-21-00-390-002

- (3) Before you install the floor panels in the wet area, examine the condition of Hi-Tak TufSeal Tape, G50738, on the floor structure and GUA1057-1, GUA1059-1, GUA1057-144 tape, G02424, on the floor panels.

NOTE: The wet area is between STA 270 and STA 380 and between STA 887 and STA 1016.

- (a) Do these steps to replace damaged tape:
 - 1) Remove the damaged tape from the panel or the floor support structure if it is necessary.



BE CAREFUL WHEN REMOVING ADHESIVES FROM PRIMARY STRUCTURE. HARSH SCRAPPING OR USE OF IMPROPER TOOLS MAY CAUSE SCRIBE DAMAGE TO THE AIRCRAFT, WHICH CAN RESULT IN FATIGUE CRACKING. CONTACT ENGINEERING IF NICKS, SCRATCHES, OR SCRIBE MARKS ARE EVIDENT ON PRIMARY STRUCTURE.

- 2) Clean scuff plates, floor panels and floor panel support structure with an approved plastic scraper and solvent, B00184, or solvent, B00666.
- 3) Apply corrosion inhibiting compound, G00009, to the floor panel support structure if it is necessary.
- 4) Apply Hi-Tak TufSeal Tape, G50738, on the floor support structure and crease beams if it is necessary.
- 5) Apply GUA1057-1, GUA1059-1, GUA1057-144 tape, G02424, to the floor panels if it is necessary.

SUBTASK 53-21-00-400-001

- (4) Before you install floor panels in the dry area, examine tape, G50019, tape, G02092, or 3M 4508 tape, G51561.

NOTE: The dry area is between section 41 and section 47, and more than 20 in. (51 cm) from a galley, lavatory or entry/service door.

NOTE: For the three section 44 aisle panels (STA 537 to STA 727B) 3M 4508 tape, G51561, may be used instead of tape, G50019, or tape, G02092.

- (a) Remove the damaged tape from the panel or the floor support structure if it is necessary.



BE CAREFUL WHEN YOU REMOVE ADHESIVE FROM THE FLOOR PANEL SURFACES. DAMAGE TO THE FLOOR PANEL CAN OCCUR.

- (b) Clean the floor panels with an approved plastic scraper and solvent, B00184, or solvent, B00666.

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- (c) Apply tape, G50019, tape, G02092, or 3M 4508 tape, G51561, on the floor panel.

NOTE: Additional layers of tape, G50019, tape, G02092, or 3M 4508 tape, G51561, can be applied under low panels, to meet panel mismatch tolerances. The total thickness of compressed tape, G50019, or tape, G02092, must be 0.07 in. (1.78 mm) or less.

NOTE: Do not apply other tapes over 3M 4508 tape, G51561.

- (d) Use a hard rubber roller, STD-745, or hand to apply pressure on the tape to make sure that the tape is firmly installed.

SUBTASK 53-21-00-350-001

- (5) If a replacement floor panel is to be installed, make sure that the new floor panel has the same contour and dimensions as the removed floor panel.

SUBTASK 53-21-00-420-001

- (6) Align the floor panel with the holes in the floor support structure.

SUBTASK 53-21-00-420-002

- (7) Install the screws with wet compound, C00528, until they are smooth with the floor panel.

NOTE: Do not tighten the screws.

SUBTASK 53-21-00-820-001

- (8) Do these steps to tighten the floor panel screws:

- (a) Torque the screws on the panels with the two-piece insert to 22.5 $\pm$ 2.5 in-lb (2.5 $\pm$ 0.3 N·m).

NOTE: Do a check of the torque before the installation of the floor covering.

- (b) Torque the screws on the panels with the one-piece insert to 32.5 $\pm$ 2.5 in-lb (3.7 $\pm$ 0.3 N·m).

NOTE: Let the panel dish at the fastener -0.005 in. (-0.127 mm) to 0.030 in. (0.762 mm).

SUBTASK 53-21-00-220-001

- (9) Examine the floor panel clearances (Table 401).

Table 401/53-21-00-993-801 Floor Panel Installation Clearances

CLEARANCE	SECTION	PANEL CLEARANCE
D	A-A	0.100 $\pm$ 0.040 in. (2.540 $\pm$ 1.016 mm)
E	B-B	0.100 $\pm$ 0.040 in. (2.540 $\pm$ 1.016 mm)
F	C-C	0.180 +0.020 / -0.050 in. (4.572 +0.508 / -1.270 mm)
G	D-D	0.100 +0.050 / -0.070 in. (2.540 +1.270 / -1.778 mm)

SUBTASK 53-21-00-390-003

- (10) Apply one layer of Scotch Flatback Masking Tape 250, G00270, to the edge of the joints that are adjacent to and along the full length of the clearance at the edges of the panels.

SUBTASK 53-21-00-420-003

- (11) If you apply sealant, A00247, or sealant, A02315 (recommended), do these steps:
- (a) Apply sealant in the clearance between the floor panel and the crease beam in the area that follows:
- 1) From STA 344 to STA 380.

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- (b) Apply sealant, A00247, or sealant, A02315, to the remaining wet area to prevent corrosion:
- 1) The remaining openings between the floor panels
 - 2) The seat tracks
 - 3) The bulkheads
 - 4) The mounting hard points
 - 5) The door drain gutter
 - 6) The mop sill.

SUBTASK 53-21-00-390-004



DO NOT CAUSE A BLOCKAGE WHEN YOU APPLY SEALANT NEAR OR AROUND THE FUSELAGE DRAIN HOLES, TUBES, OR PATHS. THE FUNCTION OF THE DRAIN HOLES IS TO DRAIN CONDENSATION AND FLUIDS OVERBOARD. IF YOU CAUSE A BLOCKAGE, FLUIDS WILL COLLECT IN THE AIRPLANE. THE FLUIDS CAN CAUSE DAMAGE TO THE STRUCTURE OR A FIRE IF THE FLUIDS ARE FLAMMABLE.

- (12) If you apply Flexane-80 resin, A00306, do these steps:
- (a) Install sleeve, G50029, around the edges of the panel.
 - (b) Apply Devcon Flexane FL-20 primer, C00953.
 - (c) Apply Flexane-80 resin, A00306 (alternate), with a sealant gun, STD-449, or hardwood or plastic fillet smoothing spatula, STD-810.
 - (d) Make sure that there are no air bubbles when you apply the sealant.
 - (e) Use a hardwood or plastic fillet smoothing spatula, STD-810, to make the seal smooth with the Scotch Flatback Masking Tape 250, G00270.

SUBTASK 53-21-00-390-005

- (13) Make the edges of the seal smooth.
- (a) Remove all of the unwanted compound with the hardwood or plastic fillet smoothing spatula, STD-810.
 - (b) Remove Scotch Flatback Masking Tape 250, G00270, after the seal is smooth or let Scotch Flatback Masking Tape 250, G00270, stay during the curing time.
 - (c) Install the moisture barrier if it is applicable (TASK 53-21-00-300-801).

SUBTASK 53-21-00-400-002

- (14) If the entry and service area floor covering are installed, do this task: Entry and Service Area Floor Covering - Installation, TASK 25-27-21-400-801.

SUBTASK 53-21-00-390-006

- (15) Apply moisture barrier tape, G51340, and fabric, G51339, to cover the entire top surface of the mop sills and crease beams (Figure 401 or Figure 402).

- (a) Make sure that the protective backing on the panel side of the moisture barrier tape, G51340 is removed before installation.

NOTE: Use moisture barrier tape, G51340 widths that will give 1/16 in. (1.6 mm) - 1/8 in. (3.2 mm) of excess on each side of the mop sills and crease beams. Excesses more than 1/8 in. (3.2 mm) are permitted.

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- (b) Make sure that the moisture barrier tape, G51340 is trimmed as required to fit around the gutter, seat tracks, galley chiller cutouts, and monument fittings.

NOTE: Slit, notch, or cut moisture barrier tape, G51340 as required to fit airframe structure contours.

- (c) Make sure that the moisture barrier tape, G51340 does not adhere to insulation blankets.
- (d) Make sure that the fiberglass reinforced polyester is trimmed to fit around monument plumbing lines and fittings.

NOTE: Crease, fold, bend, or score fiberglass reinforced polyester to fit airframe structure contours.

- (e) If the clipnuts were removed, install the new clipnuts as follows:

- 1) Apply compound, C00528, to the floor support structure at the clipnut locations.
- 2) Install new composite torlon clipnuts everywhere on the floor structure at the floor panel attachment locations (preferred BACN11AL, optional BACN10YDG) to improve corrosion resistance.

NOTE: Be careful when you install the clipnuts to prevent scratches on the floor support structure.

- 3) Turn the clipnuts clockwise against the floor support structure.

———— **END OF TASK** ————

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PASSENGER CABIN FLOORS - REPAIRS

1. General

- A. This procedure contains the task to repair polyurethane waterseal on passenger floors in wet areas of the aircraft, which are defined as that part of the floor that is local to doorways, galleys and lavatories.
- B. The waterseal installation is intended to reduce corrosion of floor structure by preventing liquids spilled in wet areas from traveling below floor level.

TASK 53-21-00-300-801

2. Polyurethane Waterseal Repair

(Figure 801)

A. **Consumable Materials**

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
G02423	Tape - Moisture Barrier - 3 Feet Wide - 3M 8663	
G02500	Tape - Moisture Barrier - 4 inch Wide - 3M 8663DL	
G50179	Tape - Moisture Barrier, Adhesive One-side, Clear Polyurethane	BMS8-346 Type I

B. **Location Zones**

Zone	Area
200	Upper Half of Fuselage

C. **Polyurethane Waterseal Repair**

SUBTASK 53-21-00-420-004

- (1) If the tape shows deterioration or damage because of the floor panel removal, install the new polyurethane tape.

SUBTASK 53-21-00-420-005

- (2) Do these steps to install the moisture barrier:

- (a) Make sure the floor panels and the seat tracks are clean according to BAC5750 before you install the moisture barrier.
- (b) Install the polyurethane moisture barrier in the wet areas of the floor structure:

NOTE: The moisture barrier must be, as much as possible, one continuous piece. Do not try to fit the moisture barrier below lavatories or galleys where removal of these fixtures is necessary.

The maximum permitted overlap between two pieces of the moisture barrier is 4 in. (102 mm).

- 1) Center the moisture barrier tape, G50179, on the floor panel joint to cover the sealant and fasteners/inserts.

NOTE: The moisture barrier tape, G50179, is applied only to joints between two floor panels and not to other structure including seat track, gutters, lavatory and galley mounts, crease beams and partition walls.

- a) Apply the tape against the floor while you remove the backing.

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- b) If air bubbles are trapped under the tape, do these steps to re-apply it:
 - <1> Pull the tape back off the floor panel.
 - <2> Smooth the tape down.
 - c) Make sure the tape overlaps by a minimum of 0.5 in. (12.7 mm) where you have a splice.
 - d) Cut the tape approximately 1.5 in. (38.1 mm) from the edge of seat tracks, entryway gutters, and lavatory/gallery mounts.
- 2) Put a section of the 3M 8663 tape, G02423, with backing still in applied, on the all of the wet area, laying the tape in forward/aft direction.
- a) Mark the tape approximately 1.5 in. (38.1 mm) from the edge of seat tracks, entryway gutters, and lavatory/gallery mounts.



CAUTION

DO NOT CUT THE WATER SEAL TAPE AGAINST THE FLOOR PANEL, OR OTHER STRUCTURE. DAMAGE TO THE STRUCTURE, OR FINISHES ON THE STRUCTURE WILL OCCUR.

- b) Trim the tape at marked locations.
 - c) Remove the backing from the adhesive side and put the tape on the floor.
NOTE: Be careful not to stretch the tape while you smooth it down.
 - <1> Cover all flush lavatory/galley mounts or girt bar attach fittings.
 - d) If air bubbles are trapped under the tape, do these steps to re-apply it:
 - <1> Pull the tape back off the floor panel.
 - <2> Smooth the tape down.
 - e) Remove the backing from the non adhesive side of the tape.
- 3) Install the adjacent sections of 3M 8663 tape, G02423.
- a) Overlap onto the existing water seal tape by 1 in. (25 mm) to 3 in. (76 mm).
NOTE: An overlap of 2 in. (51 mm) will cause the edge of the waterseal tape splice and the edge of the seam tape to align. This may show through the galley/entryway mat.
- 4) If a section of 3M 8663 tape, G02423, must be spliced longitudinally for some reason, do these steps:
- a) Put down the first section of tape.
 - b) Apply a bead of sealant, A00247, per BAC5000 to the edge of the waterseal tape that will be covered by the second section.
NOTE: This fillet will prevent water from being able to travel under the tape through the small gap left at the edge of the underlying section of waterseal tape.
 - c) Apply the second section of 3M 8663 tape, G02423.
NOTE: Too many splices or splices located in the wrong location may cause excessive tape build up that will show through floor coverings
 - <1> Overlap the first by 1 in. (25 mm) to 3 in. (76 mm).
- 5) Apply 3M 8663DL tape, G02500, to all of the 3M 8663 tape, G02423, splices.

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- a) Make sure the tape is centered on the overlapping edge of the waterseal tape and is continuous (not spliced at any point).
- (3) Do these steps to seal the seat tracks (open track, no filler):
 - (a) Apply a sealant, A00247, to all waterseal edges where it cut back from the seat track.
 - (b) Put a strip of 3M 8663DL tape, G02500, down on each side of the seat track with one edge overlapped onto the existing waterseal and one edge on the sealant between the seat track and floor panel.
 - 1) Extend the tape a minimum of 2 in. (51 mm) past the end of the seat track cutout.
 - 2) Push the tape down firmly to smooth out the sealant bead.
 - 3) Make sure the seam tape strips is continuous with no splices.
 - 4) Apply sealant, A00247, to the edge of the previous applied seam tape.
 - (c) Put a small strip of 3M 8663DL tape, G02500, at the end of the seat track with one edge overlapped onto the existing waterseal and one edge on the sealant between the seat track and floor panel.
 - 1) Extend the seam tape to overlap onto previous applied seam tape a minimum of 1 in. (25 mm).
 - 2) Push the tape down firmly to smooth out the sealant bead.
- (4) Do these steps to seal seat tracks with no filler (open track) (Alternative methods):
 - (a) Method 1
 - 1) Cut a patch of 3M 8663 tape, G02423, or 3M 8663DL tape, G02500, to fit over the seat track and overlap onto the existing waterseal tape a minimum of 1 in. (25 mm).
 - 2) Make sure the edge of the patch at the end of the seat track extends a minimum of 2 in. (51 mm) past the end of the seat track cutout.
 - 3) Apply sealant, A00247, to all waterseal edges where it has been cut back from the seat track.
 - 4) Remove the backing from the adhesive side of the tape and push the tape down firmly to smooth out the sealant bead.
 - 5) Remove the backing from the nonadhesive side of the tape.
 - (b) Method 2
 - 1) Install the 3M 8663 tape, G02423, to the floor panel, except the seat track.
 - 2) Apply a bead of sealant, A00247, to the edge of the waterseal around the perimeter of the seat track.
 - (c) Method 3
 - 1) Put a strip of 3M 8663DL tape, G02500, down each side of the seat track with one edge along the edge of the seat track crown.
 - a) Make sure the edge of the patch at the end of the seat track extends a minimum of 2 in. (51 mm) past the end of the seat track cutout.
 - b) Make sure the seam tape strips is continuous with no splices.
 - c) Apply a bead of sealant, A00247, to the perimeter of the seam tape except at the edge next to the seat track.
 - 2) Install the 3M 8663 tape, G02423.
 - a) Overlap the seam tape.
 - b) Push the tape down firmly to smooth out the sealant bead.

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- (5) Do these steps to seal seat tracks with filler:
- (a) Apply sealant, A00247, to all waterseal edges where it has been cut back from the seat track.
 - (b) Put a strip of 3M 8663DL tape, G02500, down on each side of the seat track with one edge overlapped onto the existing waterseal and one edge on the sealant between the seat track and floor panel.
 - 1) Extend the tape a minimum of 2 in. (51 mm) past the end of the seat track cutout.
 - 2) Push the tape down firmly to smooth out the sealant bead.
 - 3) Make sure the seam tape strips is continuous with no splices.
 - (c) Center a strip of 3M 8663DL tape, G02500, over the seat track and filler.
 - 1) Overlap the previous applied seam tape.
 - 2) Extend the tape a minimum of 2 in. (51 mm) past the end of the seat track cutout.
 - 3) Make sure the seam tape strips is continuous with no splices.
- (6) Do these steps to seal seat tracks with filler (Alternative methods):
- (a) Method 1
 - 1) Cut a patch of 3M 8663 tape, G02423, or 3M 8663DL tape, G02500, to fit over the seat track and overlap onto the existing waterseal tape a minimum of 1 in. (25 mm).
 - 2) Make sure the edge of the patch at the end of the seat track extends a minimum of 2 in. (51 mm) past the end of the seat track cutout.
 - 3) Apply sealant, A00247, to all waterseal edges where it has been cut back from the seat track.
 - 4) Remove the backing from the adhesive side of the tape and push the tape down firmly to smooth out the sealant bead.
 - 5) Remove the backing from the nonadhesive side of the tape.
 - (b) Method 2
 - 1) Install the 3M 8663 tape, G02423, directly over the seat track without trimming it back around the perimeter.
 - 2) Apply a bead of sealant, A00247, to the edge of the waterseal around the perimeter of the seat track.

NOTE: Do not splice the waterseal tape over the seat track.
 - (c) Method 3
 - 1) Put a strip of 3M 8663DL tape, G02500, down each side of the seat track with one edge along the edge of the seat track crown.
 - a) Make sure the edge of the patch at the end of the seat track extends a minimum of 2 in. (51 mm) past the end of the seat track cutout.
 - b) Make sure the seam tape strips is continuous with no splices.
 - c) Apply a bead of sealant, A00247, to the perimeter of the seam tape, except on the edge next to the seat track.
 - 2) Install the 3M 8663 tape, G02423:
 - a) Overlap the seam tape.
 - b) Push the tape down firmly to smooth out the sealant bead.
 - c) Trim the waterseal tape to the edge of the seat track crown.



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- 3) Center a strip of 3M 8663DL tape, G02500, on the seat track and filler, overlap the previous applied waterseal tape.
 - a) Extend the tape a minimum of 2 in. (51 mm) past the end of the seat track cutout.
 - b) Make sure the seam tape strips is continuous with no splices.
- (7) Do these steps to seal lavatory and galley mounts:
 - (a) Cut a patch of 3M 8663 tape, G02423, or 3M 8663DL tape, G02500, to either cover the flush mounts or to extend into the radius of protruding mounts.
 - (b) Extend the tape to overlap onto the existing waterseal tape a minimum of 1 in. (25 mm).
 - (c) Apply sealant, A00247, to all tape edges where it is cut back from the edges of the mounts.
 - (d) Apply sealant, A00247, to the edges of all protruding mounts.
 - (e) Remove the backing from the adhesive side of the tape and push the tape down firmly to smooth out the sealant bead.
 - (f) Remove the backing from the non-adhesive side of the tape.
- (8) Do these steps to seal lavatory and galley mounts (Alternative methods):
 - (a) Method 1
 - 1) Apply sealant, A00247, to the edges of all protruding mounts.
 - 2) Apply the 3M 8663 tape, G02423, to either cover the flush mounts or to the radius of protruding mounts.
 - 3) Remove the backing from the non-adhesive side of the tape.
 - 4) Cut a patch of 3M 8663 tape, G02423, or 3M 8663DL tape, G02500, to either cover the flush mounts or to extend into the radius of protruding mounts.
 - 5) Extend the tape a minimum of 1 in. (25 mm) beyond the edge of the mount.
 - 6) Remove the backing from the non-adhesive side of the tape.
 - 7) Apply sealant, A00247, to the edges of all protruding mounts.
 - (b) Method 2
 - 1) Cut a patch of 3M 8663 tape, G02423, or 3M 8663DL tape, G02500, to either cover the flush mounts or to extend into the radius of protruding mounts.
 - a) Extend the tape a minimum of 1 in. (25 mm) beyond the edge of the mount.
 - b) Remove the backing from the non-adhesive side of the tape.
 - c) Apply sealant to the outer edges of the patch.
 - 2) Apply the 3M 8663 tape, G02423, to overlap the patch.
 - a) Remove the backing from the non-adhesive side of the tape.
 - b) Apply sealant, A00247, to the inner edges of the tape.
 - 3) Cut a patch of 3M 8663 tape, G02423, or 3M 8663DL tape, G02500, to either cover the flush mounts or to extend into the radius of protruding mounts.
 - a) Extend the tape to overlap the previous installed tape by a minimum of 1 in. (25 mm).
 - b) Remove the backing from the non-adhesive side of the tape.
 - c) Apply sealant, A00247, to the edges of all protruding mounts.
- (9) Do these steps to seal the door gutters:

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- (a) Cut a patch of 3M 8663 tape, G02423, or 3M 8663DL tape, G02500, to fit over the gutter and girt bar fitting for the forward entry door.
- (b) Extend the tape a minimum of 1 in. (25 mm) onto the existing waterseal tape.
- (c) Trim the tape at the edge of the gutter.
- (d) Make sure the forward and aft ends of the patch extend a minimum of 2 in. (51 mm) past the door edge frames.
- (e) Apply sealant, A00247, to all waterseal tape edges where it is cut back from the edge of the gutter.
- (f) Apply a bead of sealant, A00247, to the existing sealant at the edge of the gutter and along the side of body crease beam chord.
- (g) Remove the backing from the adhesive side of the tape and push the tape down firmly to smooth out the sealant bead.
- (h) Remove the backing from the non-adhesive side of the tape.
- (10) Do these steps to seal the floor panel edges at side of body crease beam:
 - (a) Trim the 3M 8663 tape, G02423, to the edge of the floor panels at the side of body.
 - 1) Apply a bead of sealant, A00247, to the existing sealant at the side of body crease beam and fair it smooth.
 - 2) Apply sealant, A00247, to the edge of door gutter patch.
 - (b) Apply the 3M 8663DL tape, G02500, on the sealant at the side of body to extend a minimum of 1 in. (25 mm) onto the existing waterseal tape and above the top edge of the side of body crease beam chord.
 - 1) Extend the tape to overlap onto the door gutter patch a minimum of 1 in. (25 mm).
 - 2) Push the seam tape until it touch and stick to the faired sealant.
 - 3) Trim the seam tape to the top edge of the side of body crease beam chord.
- (11) Do these steps to seal the floor panel edges at side of body crease beam (Alternative method):
 - (a) Apply a bead of sealant, A00247, to the existing sealant at the side of body crease beam and fair it smooth.
 - (b) Apply 3M 8663 tape, G02423, on the sealant at the side of body to extend above the top edge of the side of body crease beam chord.
 - (c) Push the waterseal tape until it touch and stick to the faired sealant.
 - (d) Trim the waterseal tape to the top edge of the side of body crease beam chord.
- (12) Do these steps to seal the floor panel edges adjacent to bulkheads:
 - (a) Trim the 3M 8663 tape, G02423, to the edge of the floor panels or the bulkhead base at the flight deck partition.
 - 1) Apply a bead of sealant, A00247, to the existing sealant or bulkhead base at the flight deck partition and fair it smooth.
 - (b) Apply 3M 8663DL tape, G02500, on the sealant at the flight deck partition to extend a minimum of 1 in. (25 mm) onto the existing waterseal tape and wrap up the flight deck partition a minimum of 2 in. (51 mm).
 - 1) Push the seam tape until it touch and stick to the faired sealant.
- (13) Do these steps to seal the floor panel edges adjacent to flight deck transition:
 - (a) Trim the 3M 8663 tape, G02423, to the edge of the floor panels adjacent to the flight deck.

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- (b) Apply 3M 8663DL tape, G02500, on the edge of the waterseal tape extending over the lip and onto the vertical surface adjacent to the flight deck.

SUBTASK 53-21-00-300-001

- (14) Do these steps to repair cuts or air bubbles trapped under moisture barrier tape:

NOTE: All air bubble must be less than 0.5 in. (12.7 mm) square inches in total area. In the walkway area, bubble must be less than 0.05 in. (1.27 mm) in height and less than 0.1 in. (2.5 mm) in height elsewhere.

NOTE: Air bubbles more than 0.1 in. (2.5 mm) square inches in area must be limited in number to 10 or less in any 1 ft (305 mm) diameter area.

- (a) To repair the air bubble, use a sharp blade to cut the tape over the bubble and squeeze the air out.
- 1) Be careful not to damage the underlying floor panel or structure.
- (b) Apply a small bead of sealant, A00247, on the cut.
- (c) Apply new tape and push down firmly to smooth out the sealant bead.
- (d) Make sure the repair tape overlap the cut by a minimum of 2 in. (51 mm).

———— **END OF TASK** ————

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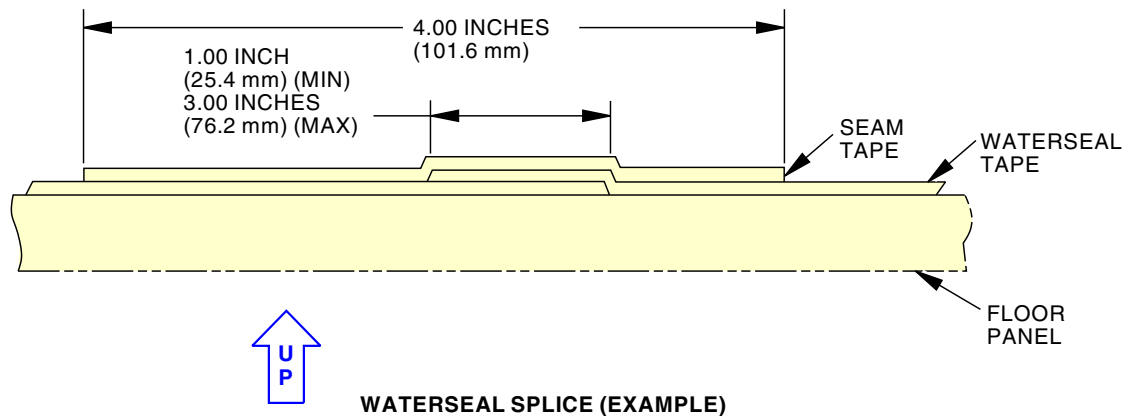
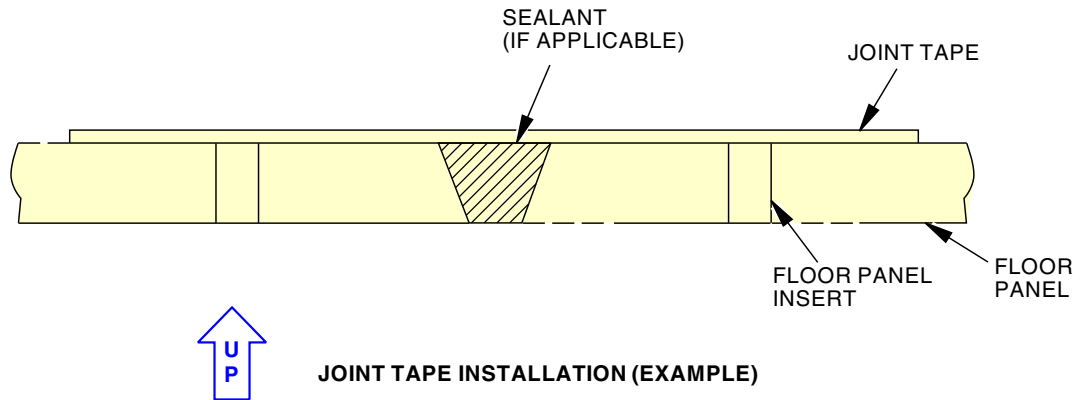
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Water Seal Tape Application
Figure 801/53-21-00-990-802 (Sheet 1 of 7)

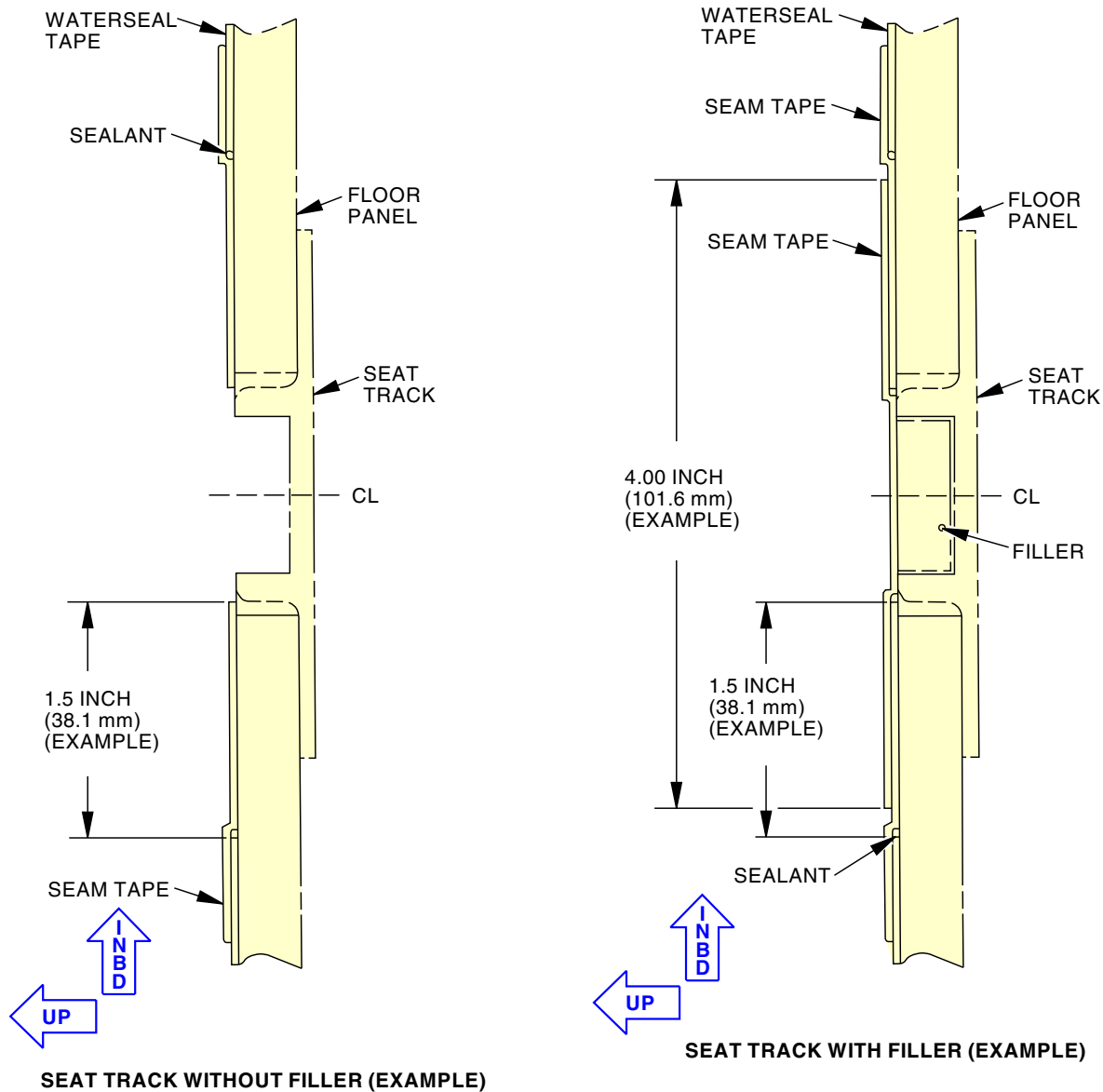
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Water Seal Tape Application
Figure 801/53-21-00-990-802 (Sheet 2 of 7)

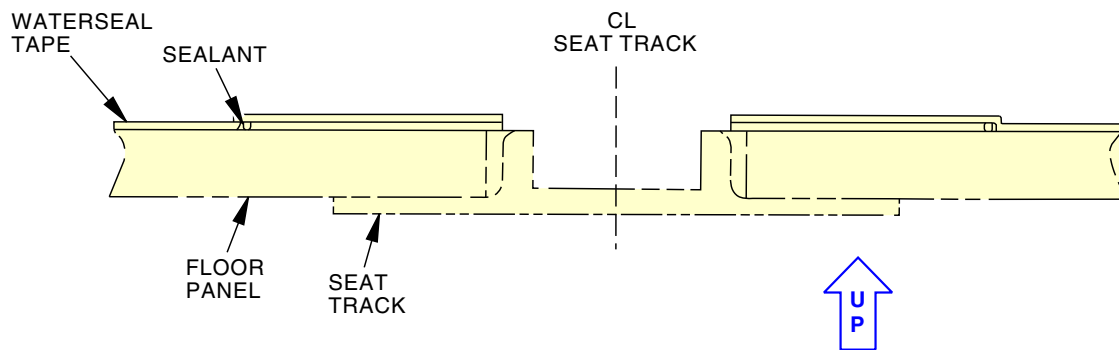
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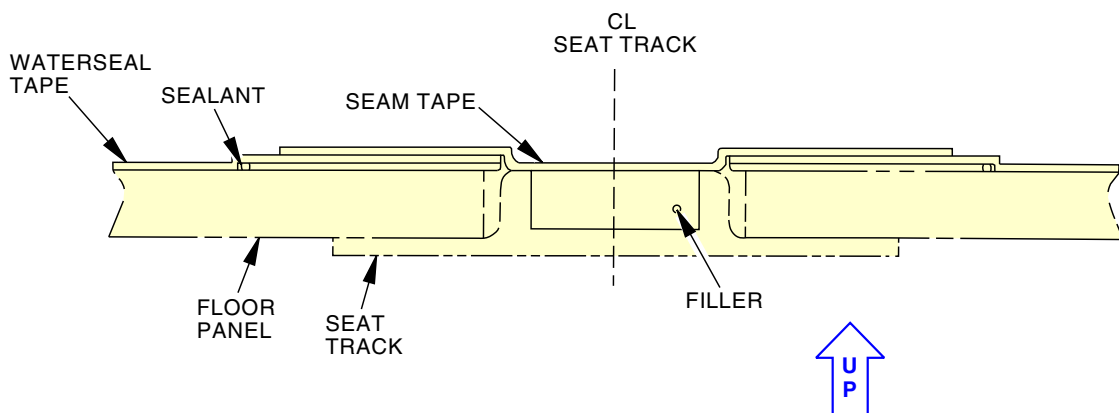
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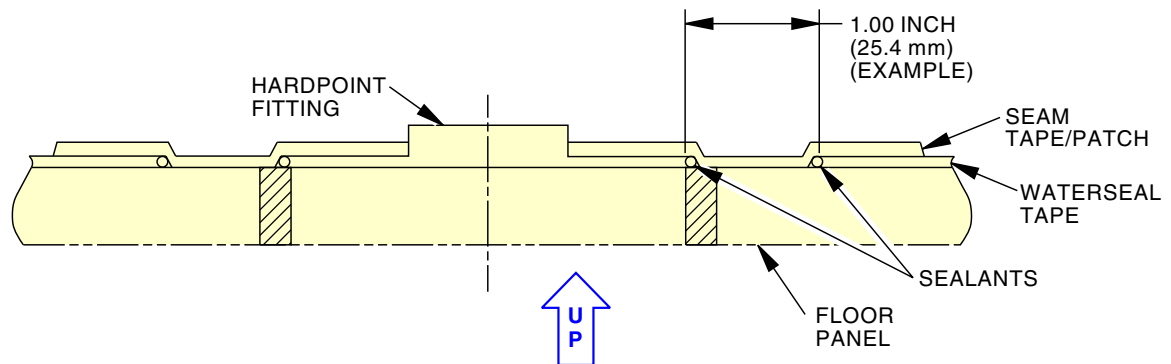
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SEAT TRACK WITHOUT FILLER
(OPTIONAL METHOD 3)



SEAT TRACK WITH FILLER
(OPTIONAL METHOD 3)



LAVATORY AND GALLEY HARDPOINT FITTINGS
(EXAMPLE)

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Water Seal Tape Application
Figure 801/53-21-00-990-802 (Sheet 3 of 7)

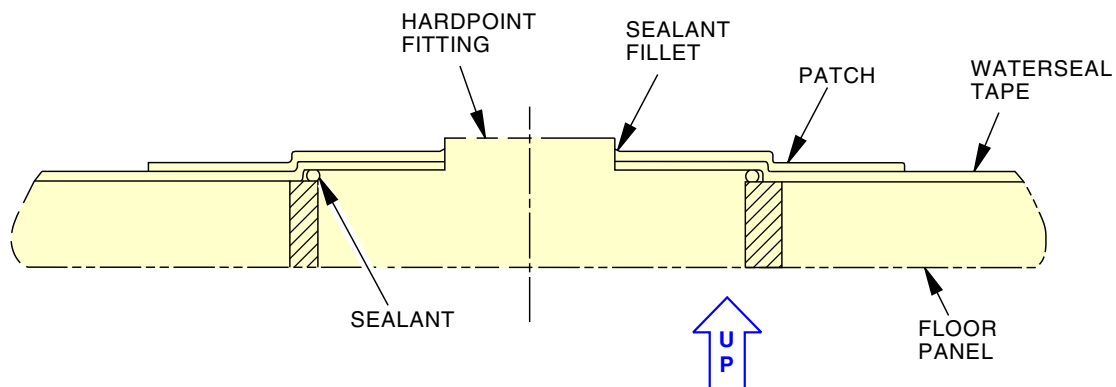
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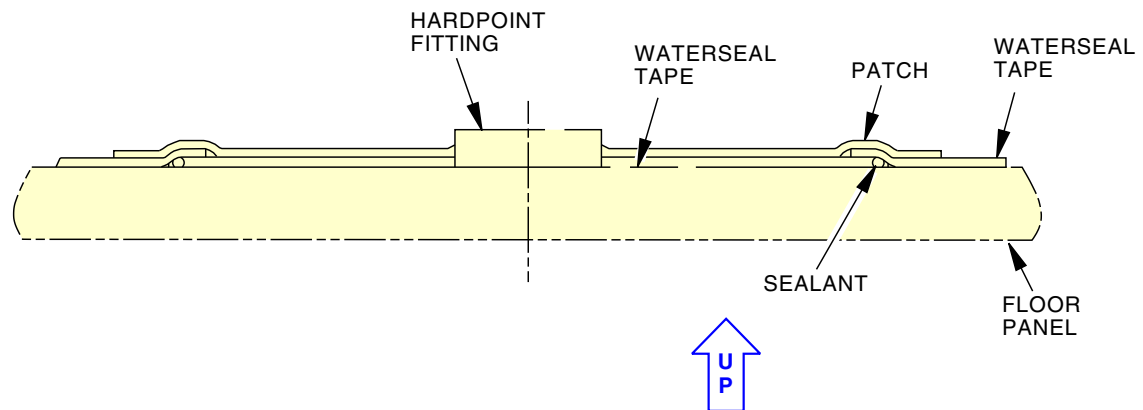
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LAVATORY AND GALLEY HARDPOINT FITTINGS
(OPTIONAL METHOD 1)



LAVATORY AND GALLEY HARDPOINT FITTINGS
(OPTIONAL METHOD 2)

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Water Seal Tape Application
Figure 801/53-21-00-990-802 (Sheet 4 of 7)

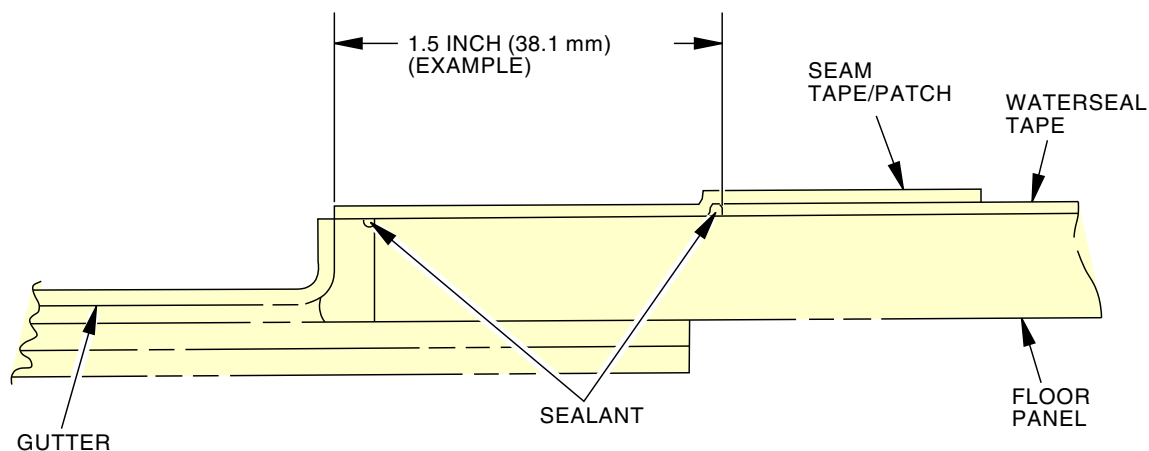
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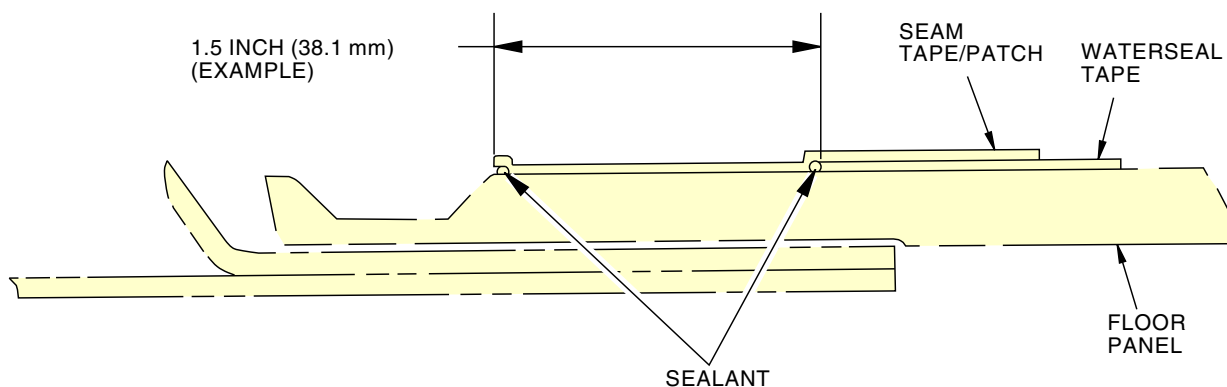
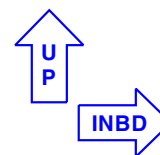
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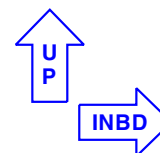
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DOORWAY GUTTER
(EXAMPLE)



INTEGRAL GUTTER FLOOR PANEL
(EXAMPLE)



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Water Seal Tape Application
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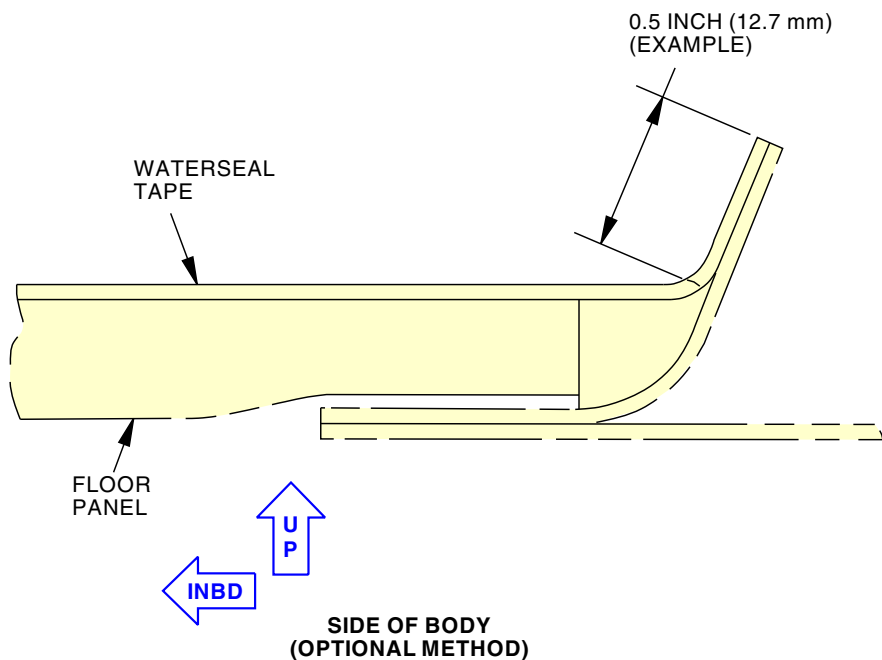
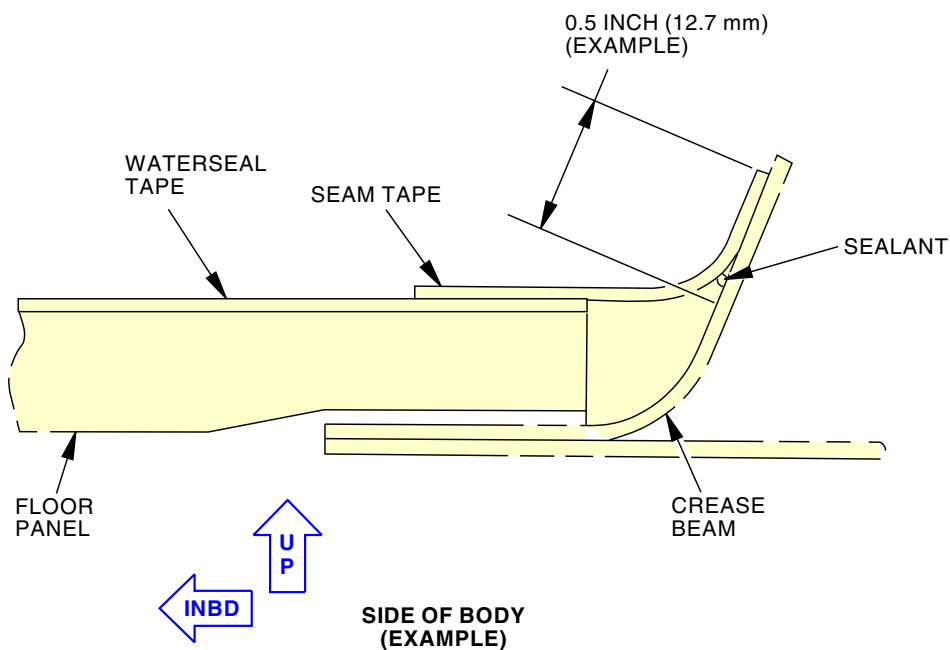
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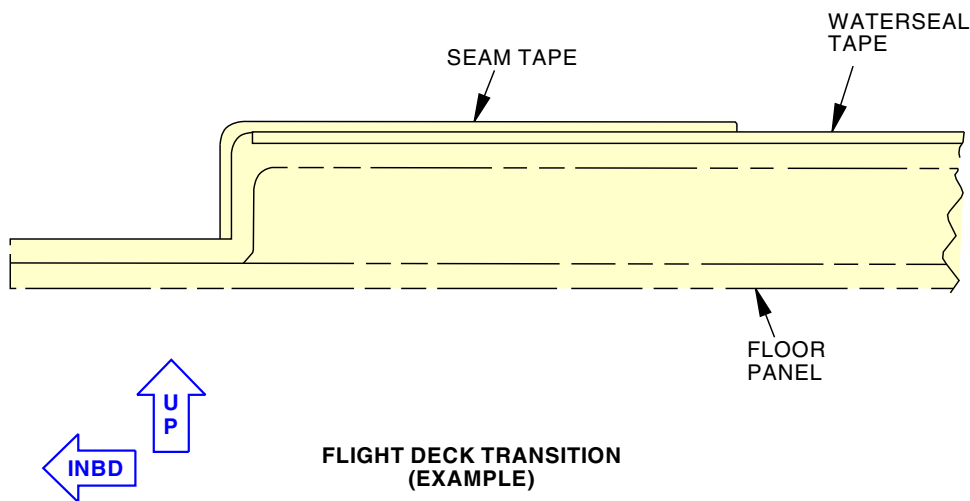
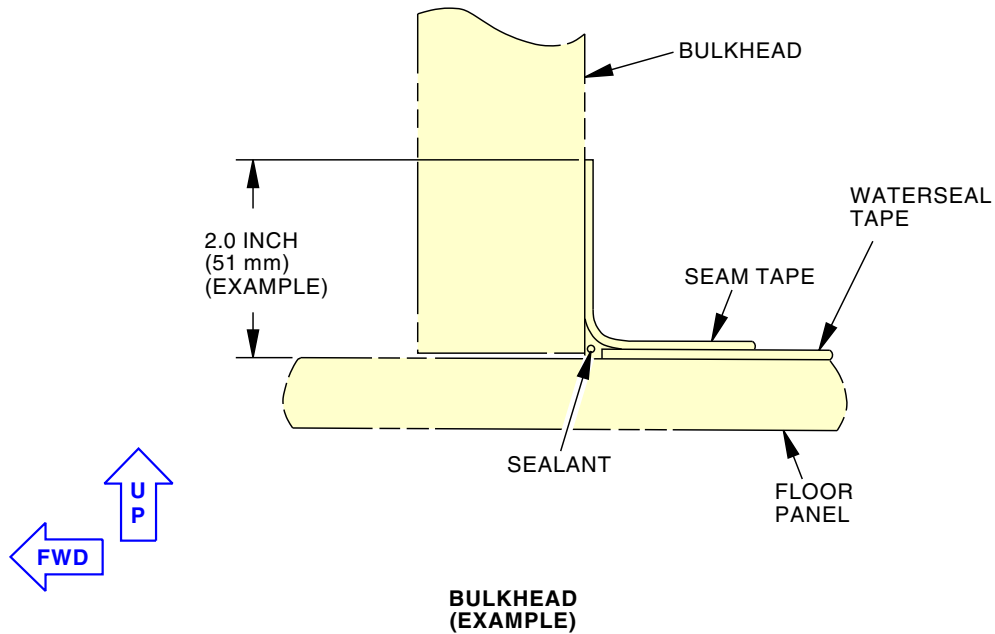
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Water Seal Tape Application
Figure 801/53-21-00-990-802 (Sheet 7 of 7)

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WATER BARRIER - REPAIRS

1. General

- A. This procedure contains two tasks. The first task is the repair of the vinyl part of the water barrier. The second task is the repair of the mylar part of the water barrier.
- B. The water barrier has mylar sheets (transparent), vinyl sheets (nontransparent) or 18 in. (457 mm) wide strips of tape bonded to the floor panels. This procedure gives instructions on how to cut the water barrier for the removal of a floor panel. It also gives instructions on how to repair the water barrier with the floor panel installed.
- C. The vinyl tape at right angles to the seat tracks with a 1.00 in. (25.40 mm) overlap is the recommended replacement of the water barrier.
- D. Cut through the water barrier around the edges of the floor panel to remove the floor panel. Pull back the vinyl to get to the fasteners for the floor panels. If mylar is on the floor panel fasteners, cut a circular patch for each fastener.

TASK 53-21-11-300-801

2. Vinyl Water Barrier Repair

A. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
G00157	Tape - Nitto P-306L (use until stock depleted)	

B. Location Zones

Zone	Area
200	Upper Half of Fuselage

C. Vinyl Water Barrier Repair

SUBTASK 53-21-11-350-001

- (1) Apply the Nitto P-306L tape, G00157 (vinyl tape), at right angles to the seat tracks with a minimum of a 1.00 in. (25.40 mm) overlap.

SUBTASK 53-21-11-390-001

- (2) Apply sealant, A00247, to the vinyl tape overlap.

NOTE: You can use 3.00 in. (76.20 mm) wide vinyl tape on the edge of the overlap as an alternative to the sealant.

————— END OF TASK —————

TASK 53-21-11-300-802

3. Mylar Water Barrier Repair

A. References

Reference	Title
53-21-00-400-801	Passenger Cabin Floor Panel Installation (P/B 401)

B. Tools/Equipment

Reference	Description
STD-809	Spatula

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C. Consumable Materials

Reference	Description	Specification
A00156	Adhesive - For Bonding Mylar And Nylon, 2 Part, RT Cure	BMS5-31
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)
G00111	Sheet - Mylar	

D. Location Zones

Zone	Area
200	Upper Half of Fuselage

E. Prepare for the Repair

SUBTASK 53-21-11-410-001

- (1) Do this task: Passenger Cabin Floor Panel Installation, TASK 53-21-00-400-801.

SUBTASK 53-21-11-350-002

- (2) Cut strips of mylar sheet, G00111, to make a splice with the edges of the floor panel.
- (a) Make sure the splice makes a 0.75 in. (19 mm) overlap with the fastener line and with the adjacent floor panel.

SUBTASK 53-21-11-140-001

- (3) Clean the mating surfaces with solvent, B00083.

SUBTASK 53-21-11-350-003

- (4) Mix 100 parts by weight of the adhesive, A00156 (Pro-Seal 501), with 30 parts by weight of the Pro-Seal 501-A accelerator.
- (a) If you mix the adhesive, A00156, in the original can, cut off the rim of the can to make it easier.
- (b) Mix for approximately 5 minutes with a spatula, STD-809, or an equivalent tool.
- (c) Apply the adhesive, A00156, as soon as it is possible.

NOTE: The heat of the material in a container decreases the work life. The work life is 20 minutes at 77°F (25°C).

- 1) Use 0.11 ±0.01 lb (50 ±5 g) for each 1 ft² (929 cm²)s of the surface that you cover.

F. Mylar Water Barrier Repair

SUBTASK 53-21-11-390-002

- (1) Apply a layer of the adhesive, A00156, to the mating surface of the splice.

SUBTASK 53-21-11-390-003

- (2) Bond the splice to the water barrier.

SUBTASK 53-21-11-140-002

- (3) Remove the unwanted adhesive, A00156, with a clean cotton wiper, G00034, moist with solvent, B00083.

SUBTASK 53-21-11-350-004

- (4) Put a weight or tape on the edges that show signs of delamination until the adhesive, A00156, dries.

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SUBTASK 53-21-11-860-001

- (5) Let the adhesive, A00156, dry for a minimum of 2 hours.

NOTE: A minimum of 12 hours is necessary for the adhesive, A00156, to fully dry.

———— **END OF TASK** ————

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EXTERNAL DRAINAGE - INSPECTION/CHECK

1. General

- A. This procedure contains the following tasks:
- (1) External drainage inspection/check.
 - (2) Ball drain valve inspection/check.
- B. Examine the external drains regularly to prevent possible fire or corrosion.

TASK 53-31-01-200-801

2. External Drainage Inspection/Check

(Figure 601)

A. References

Reference	Title
53-31-03-000-801	Fuselage Drain Valve Assembly Removal (P/B 401)
53-31-03-400-801	Fuselage Drain Valve Assembly Installation (P/B 401)
53-51-21-000-801	Forward Wing-To-Body Fairing Panel Removal (P/B 401)
53-51-21-000-803	Aft Wing-To-Body Fairing Panel Removal (P/B 401)
53-51-21-400-801	Forward Wing-To-Body Fairing Panel - Installation (P/B 401)
53-51-21-400-803	Aft Wing-To-Body Fairing Panel - Installation (P/B 401)

B. Tools/Equipment

Reference	Description
STD-7395	Brush - Rigid Bristled

C. Consumable Materials

Reference	Description	Specification
B00003	Cleaner - Emulsion Alkaline - GMC 528B (use until stock depleted)	
B00005	Cleaner - Alkaline - Cee Bee 280	
B00008	Cleaner - Alkaline - Oakite 204	
B00015	Cleaner - Heavy Duty, Multipurpose - Calla 301A	BAC5744, AMS 1526-A, AMS 1550-A
B00402	Cleaner - Aerospace Equipment	MIL-PRF-87937
G01043	Cloth - Lint-free	

D. Access Panels

Number	Name/Location
191D	Forward Wing-To-Body Fairing Panel - Lower
194E	Aft Wing To Body Fairing Panel

E. Prepare for the Inspection

SUBTASK 53-31-01-010-001

- (1) Open these access panels:
- (TASK 53-51-21-000-801 and TASK 53-51-21-000-803)

<u>Number</u>	<u>Name/Location</u>
191D	Forward Wing-To-Body Fairing Panel - Lower
194E	Aft Wing To Body Fairing Panel

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F. Removable Drain Valve Inspection

SUBTASK 53-31-01-210-001

- (1) Examine the removable drain valve.
 - (a) Examine the drain holes (with valves or with no valves) in the areas of body, wing, empennage, nacelle and control surfaces.
 - (b) Make sure that the drains are free of unwanted materials.
 - (c) Clean the drains, if it is necessary.

G. Removable Drain Valves Cleaning

SUBTASK 53-31-01-020-001

- (1) Do this task: Fuselage Drain Valve Assembly Removal, TASK 53-31-03-000-801.

SUBTASK 53-31-01-110-001

- (2) Clean the valve with a lint-free cloth, G01043, that is moist with GMC 528B cleaner, B00003, or cleaner, B00402.

NOTE: The following cleaners are optional to GMC 528B cleaner, B00003, and cleaner, B00402: Cee Bee 280 cleaner, B00005, Oakite 204 cleaner, B00008, and Calla 301A cleaner, B00015.

SUBTASK 53-31-01-140-001

- (3) Use a rigid bristled brush, STD-7395, to clean the valve.

SUBTASK 53-31-01-170-001

- (4) Flush the valve with clear water.

SUBTASK 53-31-01-160-001

- (5) Remove unwanted materials from the drain paths in the valve retainer if the drain paths are not clear.

SUBTASK 53-31-01-210-002

- (6) Make sure that the drain paths in the valve are clear.

SUBTASK 53-31-01-210-003

- (7) Make sure that the plunger and the spring stay installed in the valve.

SUBTASK 53-31-01-400-001

- (8) Do this task: Fuselage Drain Valve Assembly Installation, TASK 53-31-03-400-801.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 53-31-01-410-001

- (1) Close these access panels:
(TASK 53-51-21-400-801 and TASK 53-51-21-400-803)

<u>Number</u>	<u>Name/Location</u>
191D	Forward Wing-To-Body Fairing Panel - Lower
194E	Aft Wing To Body Fairing Panel

————— **END OF TASK** —————

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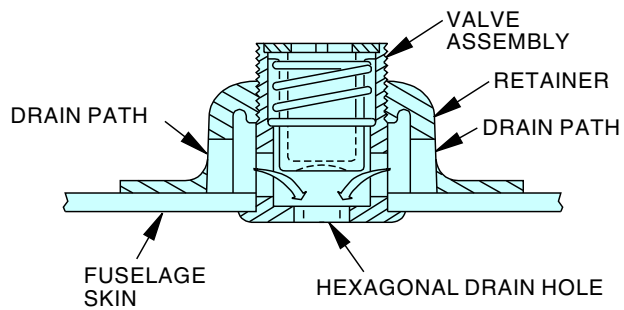
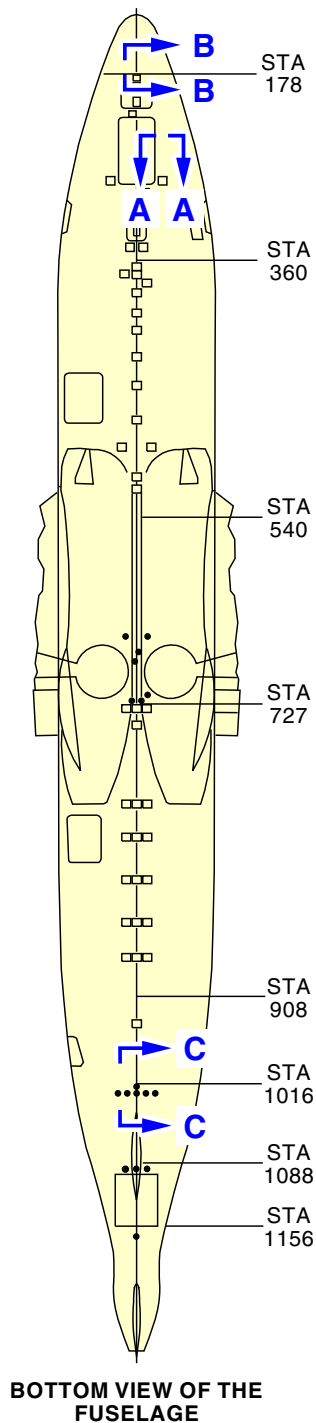
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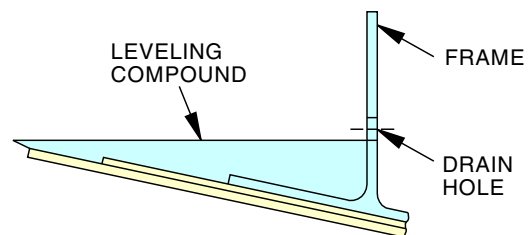
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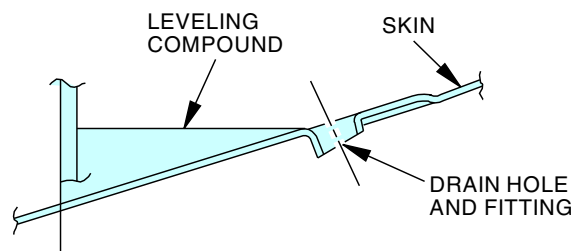


- REMOVABLE DRAIN VALVE
 (-7 34 INSTALLED)
 (-8 38 INSTALLED)
 (-8200 36 INSTALLED)
 (-9 50 INSTALLED)
 (-10 50 INSTALLED)

(EXAMPLE)
A-A



(EXAMPLE)
B-B



(EXAMPLE)
C-C

NOTE:

- SPECIAL TYPE DRAIN HOLE AS SHOWN
 ●-OPEN DRAIN HOLE

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Airframe Drainage - Fuselage
Figure 601/53-31-01-990-803

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TASK 53-31-01-200-802

3. Ball Drain Valve Inspection/Check

(Figure 602)

A. Consumable Materials

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
B00130	Alcohol - Isopropyl	TT-I-735
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

B. Examine the Ball Drain Valves

SUBTASK 53-31-01-210-005

- (1) Examine the ball drain valves.
 - (a) Examine the ball drain valves in the wing center section rear spar.
 - (b) Make sure that the ball drain valves are clean.
 - (c) Make sure that the ball drain valves operate correctly.
 - (d) Clean the ball drain valves, if it is necessary.

C. Clean the Ball Drain Valves

SUBTASK 53-31-01-110-002

- (1) Clean the ball drain valves with a cloth cotton wiper, G00034 moist with solvent, B00083 or alcohol, B00130.
 - (a) Remove unwanted materials from ball drain valve housing.

————— **END OF TASK** —————

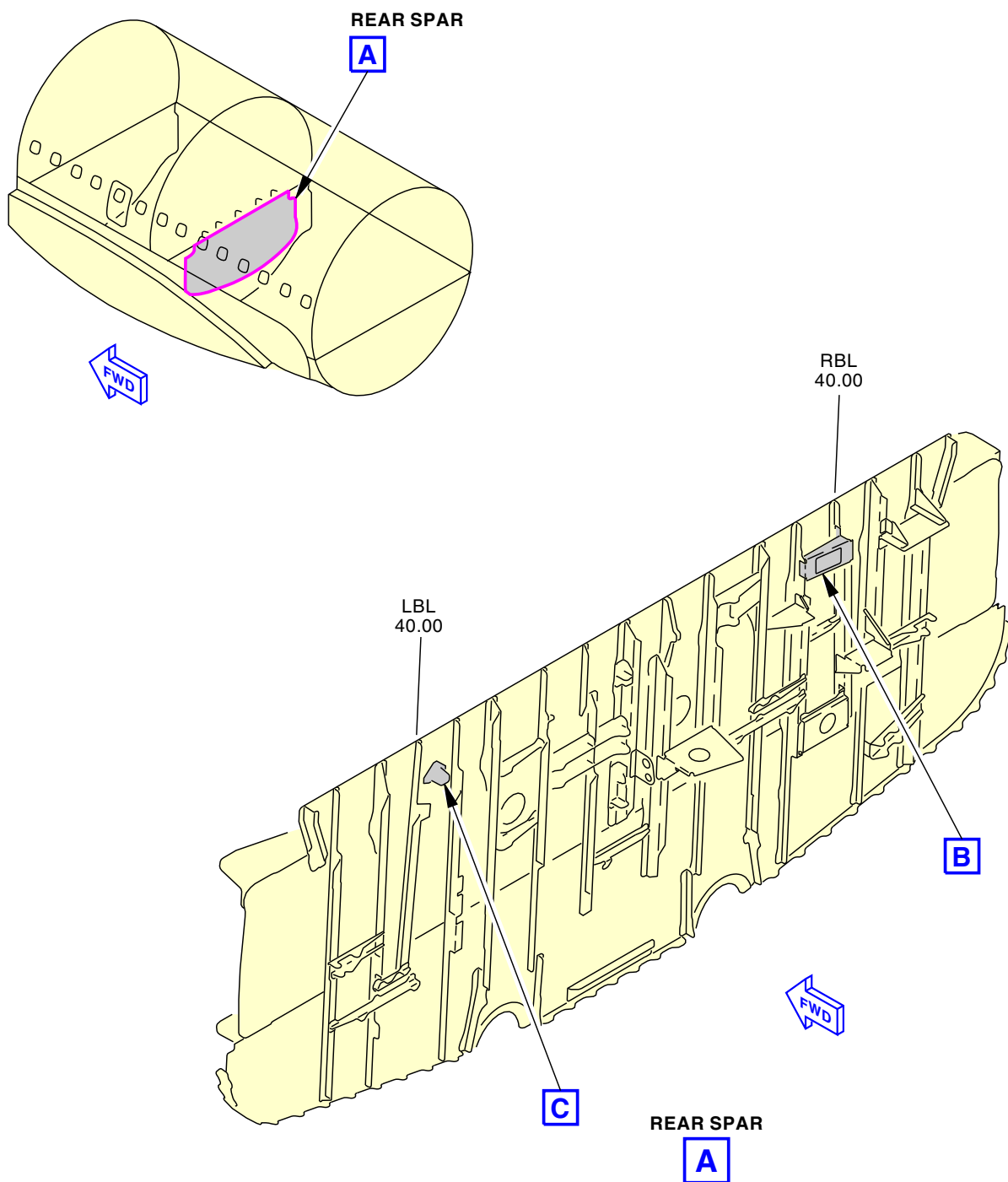
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Wing Center Section Rear Spar Ball Drain Valves
Figure 602/53-31-01-990-802 (Sheet 1 of 2)

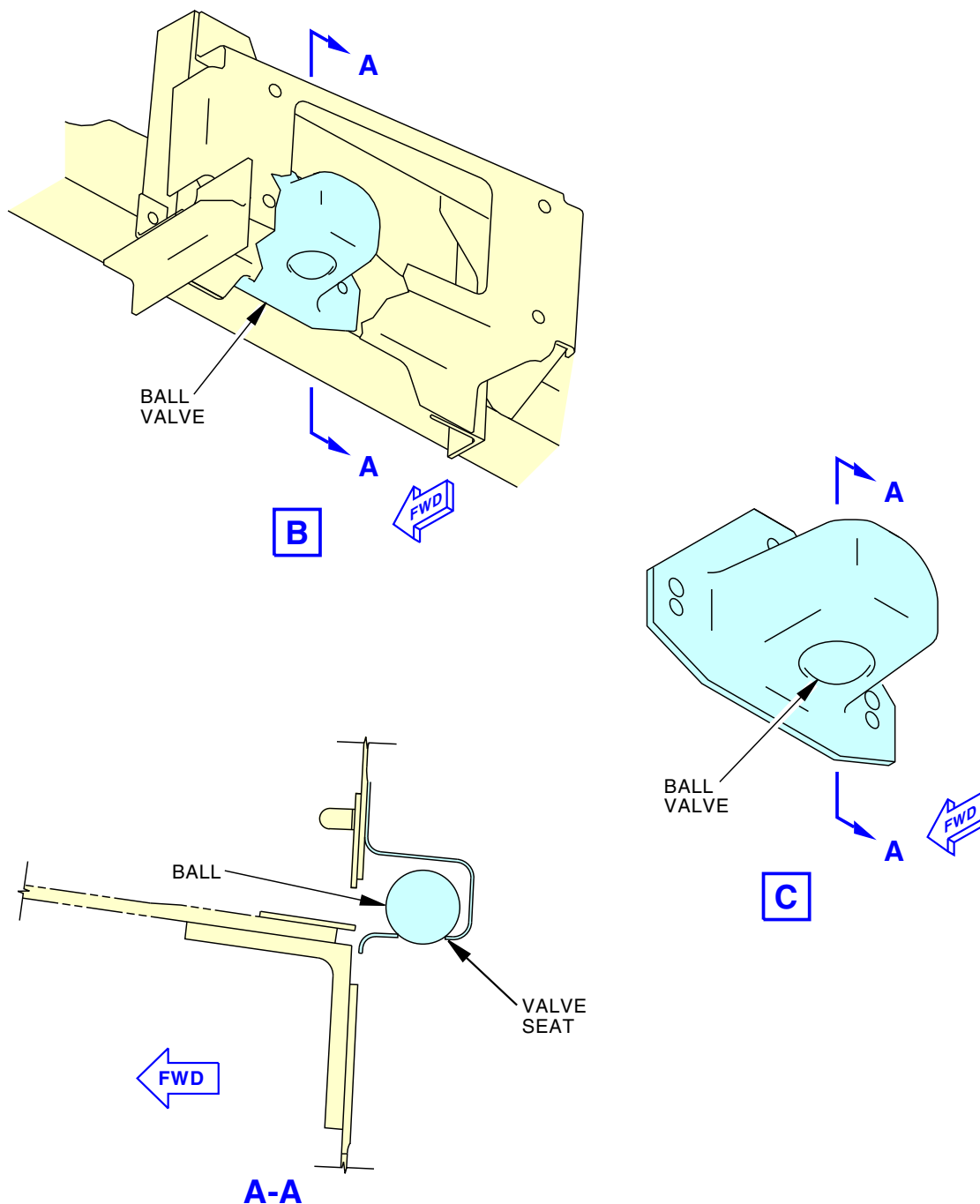
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Wing Center Section Rear Spar Ball Drain Valves
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EXTERNAL DRAINAGE - REPAIRS

1. General

- A. This procedure contains one task. The task is to repair the compound used to level the area around the aircraft drains.

TASK 53-31-01-350-801

2. Repair the Compound Used to Level the Area Around the Aircraft Drains

A. References

Reference	Title
08-20-02-580-801	Level the Airplane With a Plumb Bob and Inclinometers (P/B 201)
08-20-03-580-801	Level the Airplane With a Attitude Gage (P/B 201)
51-21-95-300-801	Alodine Treatment Application (P/B 701)

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-2481	Sealant Removal Tool (meets BSS7384 requirements) Part #: 1-6390-A Supplier: 63318 Part #: 10810 Supplier: \$0855 Part #: 10811 Supplier: \$0855 Part #: 10812 Supplier: \$0855 Part #: 234350 Supplier: 5HCF1 Part #: 235072 Supplier: 5HCF1 Part #: 235073 Supplier: 5HCF1 Part #: 235074 Supplier: 5HCF1 Part #: 235075 Supplier: 5HCF1 Part #: 235076 Supplier: 5HCF1 Part #: 311/03 Supplier: F6892 Part #: 311/14 Supplier: F6892 Part #: 311/25 Supplier: F6892 Part #: 311/37 Supplier: F6892 Part #: AS1 Supplier: \$1351 Part #: AS2 Supplier: \$1351 Part #: AS3 Supplier: \$1351 Part #: DAD5013 Supplier: 7RKH2 Part #: DFD5019 Supplier: 7RKH2 Part #: JNT411B60 Supplier: 3DN12 Part #: JNT411B90 Supplier: 3DN12 Part #: SCD5019 Supplier: 7RKH2 Part #: ST982LF-9 Supplier: 81205 Part #: TS1275-4 Supplier: 22975

C. Consumable Materials

Reference	Description	Specification
A50428	Compound - Self-Leveling, For Fluid Drainage, Flexible, Fire-Retarded	BMS5-125 Type IV
B00068	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002, MIL-E-51454 Type II

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(Continued)

Reference	Description	Specification
B00130	Alcohol - Isopropyl	TT-I-735
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 CLA)
G50222	Brush - Tampico Fiber, Non-Metallic	

D. Location Zones

Zone	Area
100	Lower Half of Fuselage

E. Procedure

SUBTASK 53-31-01-340-006

- (1) When you pour the compound, the airplane must be in a level position (TASK 08-20-02-580-801 or TASK 08-20-03-580-801).

SUBTASK 53-31-01-340-001

- (2) Use a sealant removal tool, COM-2481, or a rigid-bristle tampico fiber brush, G50222 to remove compound that is loose or damaged.

SUBTASK 53-31-01-110-003



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.

- (3) Use a cotton wiper, G00034, that is moist with alcohol, B00068 or alcohol, B00130 to clean the structure and any compound that remains on the surface.

SUBTASK 53-31-01-370-001

- (4) For an aluminum surface that does not have a protective layer, do these steps.
 - (a) Apply a layer of coating, C00064 (TASK 51-21-95-300-801).
 - (b) Apply one layer of primer, C00259, to the surface of the aluminum.

SUBTASK 53-31-01-340-002

- (5) Mix the compound, A50428.

SUBTASK 53-31-01-340-003

- (6) Pour the compound, A50428, around the drain.

SUBTASK 53-31-01-340-004

- (7) For airplanes without removable drain valves, the compound, A50428, must be level with the bottom of the drain hole.
 - (a) As an option, the compound, A50428, can be within 0.06 in. (1.52 mm) of spring drain valve contact area.

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- (b) Make sure the compound does not go into the drain valve.

SUBTASK 53-31-01-340-005

- (8) For airplanes with removable drain valves, make sure the compound, A50428, is level with the bottom of the drain hole or the bottom of the drain valve.
 - (a) Make sure the compound does not go into the drain valve.
 - (b) Do not move the airplane before the compound is hard (approximately 6 hours at 72 ±5°F (22 ±3°C)).

NOTE: The full cure time is 7 days.

———— **END OF TASK** ————

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INTERNAL DRAINAGE - INSPECTION/CHECK

1. General

- A. This procedure contains one task:
- (1) Examine internal drains.
- B. You must examine the internal drains with a regular schedule to make sure the drainage operates correctly, and to help prevent a fire or corrosion.

TASK 53-31-02-200-801

2. Examine Internal Drains

(Figure 601, Figure 602)

A. References

Reference	Title
53-21-00-000-801	Passenger Cabin Floor Panel Removal (P/B 401)

B. Consumable Materials

Reference	Description	Specification
B00005	Cleaner - Alkaline - Cee Bee 280	
B00008	Cleaner - Alkaline - Oakite 204	
B00015	Cleaner - Heavy Duty, Multipurpose - Calla 301A	BAC5744, AMS 1526-A, AMS 1550-A
B00402	Cleaner - Aerospace Equipment	MIL-PRF-87937
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CLA)

C. Location Zones

Zone	Area
100	Lower Half of Fuselage

D. Procedure

SUBTASK 53-31-02-010-001

- (1) Remove the floor panels to get access to the upper surface of the wing center section (TASK 53-21-00-000-801).

SUBTASK 53-31-02-210-001

- (2) Examine the drain openings through the aft lower corner of the ribs at the pressure deck beam.

SUBTASK 53-31-02-210-002

- (3) Examine the internal drains frequently.
- (a) Make sure that they are clear from blockage.

SUBTASK 53-31-02-140-001

- (4) To clean the internal drains, do these steps:
- (a) Use a cotton wiper, G00034 that is moist with cleaner, B00402 solution to remove all the soil and unwanted materials from the drains.

NOTE: The cleaners that follow are optional to cleaner, B00402: Cee Bee 280 cleaner, B00005, Oakite 204 cleaner, B00008 and Calla 301A cleaner, B00015.

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- (b) Examine and clean the horizontal drain hole.

———— **END OF TASK** ————

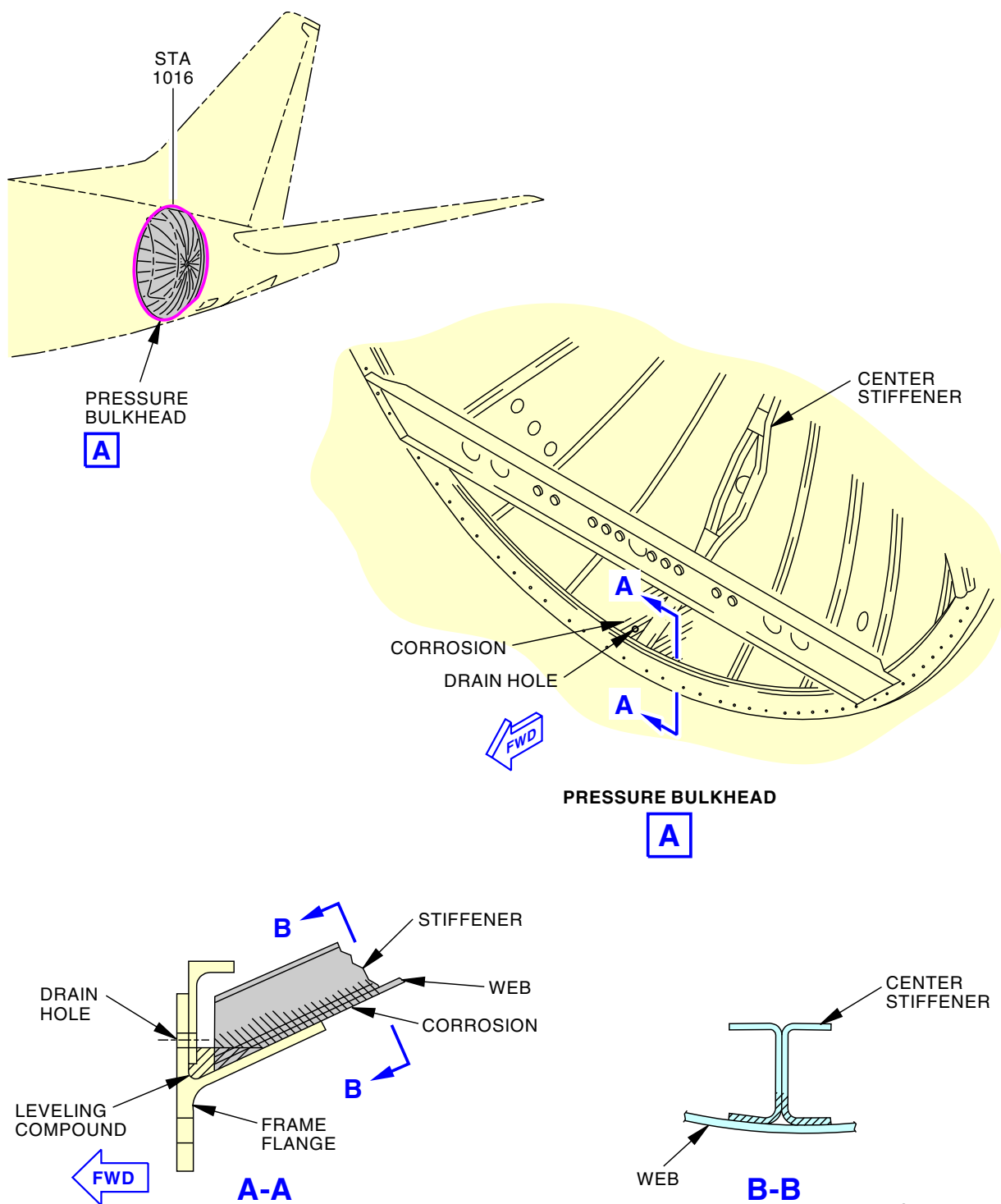
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Internal Drainage
Figure 601/53-31-02-990-801

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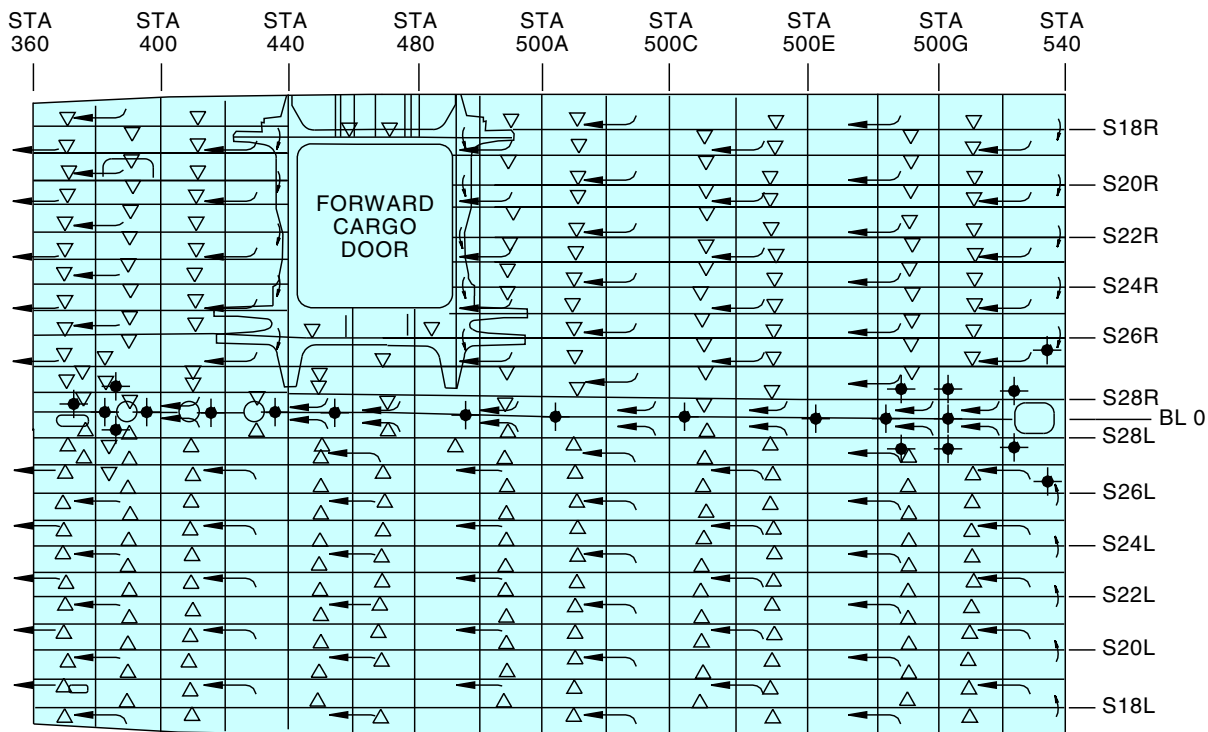
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SECTION 43

- LEGEND
- △ STRINGER AND FRAME DRAIN HOLE LOCATION AND FLOW DIRECTION
 - DRAIN VALVE
 - ← FLOW DIRECTION

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Internal Drain Paths
Figure 602/53-31-02-990-802 (Sheet 1 of 2)

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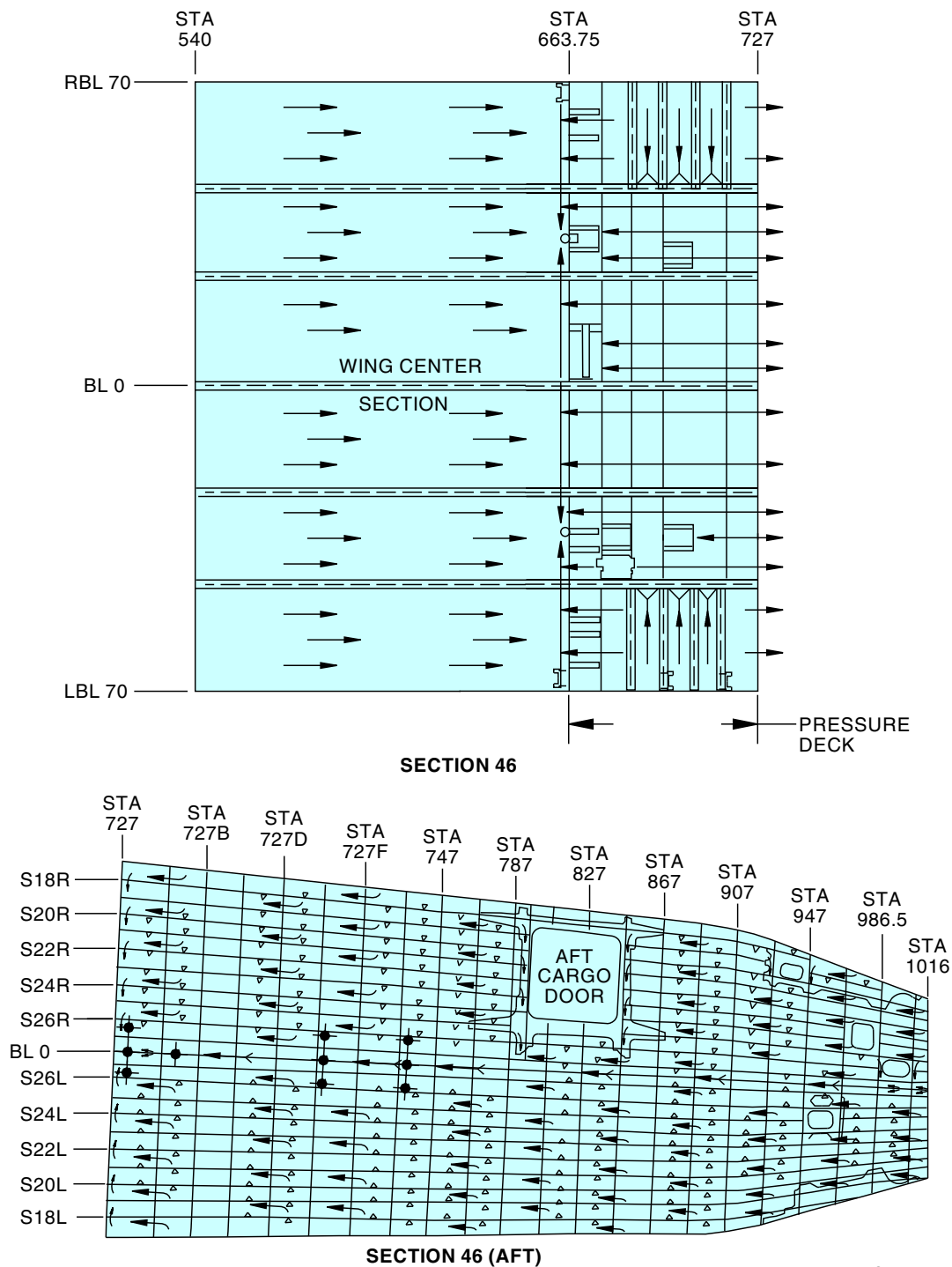
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Internal Drain Paths
Figure 602/53-31-02-990-802 (Sheet 2 of 2)

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FUSELAGE DRAIN VALVE - REMOVAL/INSTALLATION

1. **General**

A. This procedure has these tasks:

- (1) A removal of the fuselage drain valve assembly
- (2) An installation of the fuselage drain valve assembly.

B. You can get access to the fuselage drain valve assembly from the outer surface of the fuselage.

TASK 53-31-03-000-801

2. **Fuselage Drain Valve Assembly Removal**

(Figure 401)

A. **Tools/Equipment**

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

Reference	Description
SPL-1975	Adapter, Fuselage Drain Valve Part #: 2024 Supplier: 91ZW0

B. **Location Zones**

Zone	Area
100	Lower Half of Fuselage

C. **Fuselage Drain Valve Assembly Removal**

SUBTASK 53-31-03-020-001



CAUTION

DO NOT USE A STEEL WRENCH. A STEEL WRENCH CAN CAUSE DAMAGE TO THE DRAIN VALVE.

- (1) Put the drain valve adapter, SPL-1975, in the fuselage drain valve assembly [1].

SUBTASK 53-31-03-020-002

- (2) Turn the drain valve adapter, SPL-1975, to remove the fuselage drain valve assembly [1] from the retainer [2].

———— **END OF TASK** ————

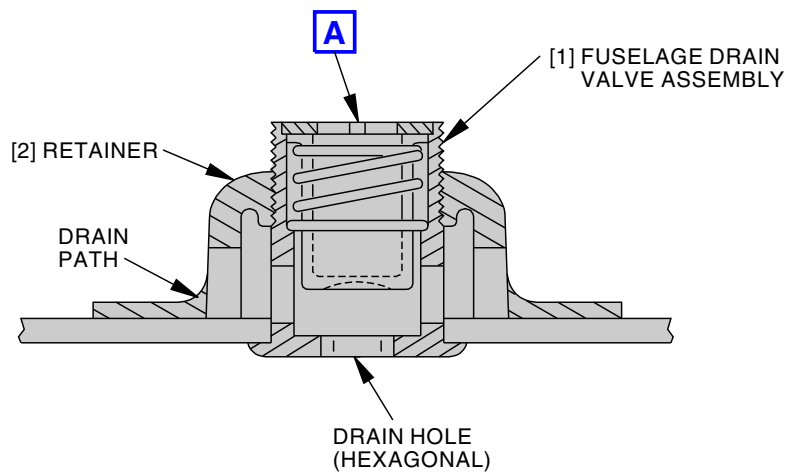
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SIA ALL

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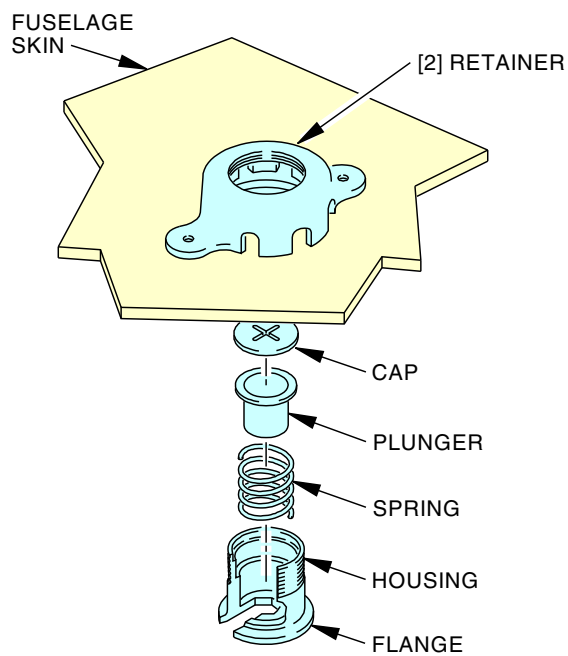
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FUSELAGE DRAIN VALVE ASSEMBLY



FUSELAGE DRAIN VALVE ASSEMBLY

A

2415651 S00061538579_V2

Fuselage Drain Valve Assembly Installation
Figure 401/53-31-03-990-802

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TASK 53-31-03-400-801

3. Fuselage Drain Valve Assembly Installation

(Figure 401)

A. Tools/Equipment

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

Reference	Description
SPL-1975	Adapter, Fuselage Drain Valve Part #: 2024 Supplier: 91ZW0

B. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Fuselage drain valve assembly	53-31-03-01-005	SIA ALL
		53-31-03-01-055	SIA ALL
		53-31-03-01-105	SIA ALL
		53-31-03-01-155	SIA ALL
2	Retainer	53-31-03-05-055	SIA ALL
		53-31-03-05-105	SIA ALL
		53-31-03-05-155	SIA ALL
		53-31-03-05-205	SIA ALL

C. Location Zones

Zone	Area
100	Lower Half of Fuselage

D. Prepare for the Installation

SUBTASK 53-31-03-100-001



WARNING ALKALINE CLEANING MATERIALS USUALLY REACT WITH MUCH FORCE WHEN MIXED WITH WATER. CONCENTRATED SOLUTIONS CAN BADLY BURN SKIN AND EYES. WEAR FACE SHIELDS AND PROTECTIVE CLOTHING WHEN YOU USE THESE MATERIALS. OBEY ALL SAFETY PRECAUTIONS.

(1) Clean the fuselage drain valve assembly [1] with a water-based cleaner solution (Table 401).

Table 401/53-31-03-993-801 Spray Cleaners, Light Duty

Cleaner	Vendor	Solution Control		Metal to be Cleaned						Remarks
		Conc. Oz/gal	Temp °F	Fe	Al	Ti	Mg	*[1]	*[2]	
ALK-660	*[3]	5-10 Vol%	60-120	x	x	x		x	x	*[4]
Chem Clean 1004	V23373	2.0-8.0 (1.4-5.5 Vol%)	90-150	x	x	x				
Daraclean 211	V04552	0.01-0.10	Room							*[5]

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Table 401/53-31-03-993-801 Spray Cleaners, Light Duty (Continued)

Fleetline JC5	V44389	0.01-0.10	Room							*[5]
Isoprep 39	V89138, V99442	1-4	140-170		x					
KC 270	V2R358	2.0-3.8	90-150	x	x	x				
Oakite 161	V44389	0.75-2.5	170-190	x	x	x		x	x	
Spray Altrex	V83339	0.75-2.5	170-190	x	x	x		x	x	
Super Bee 300LF	V5K793	8-25 (Vol %)	105-175	x	x	x	x	x	x	*[3]
Super Bee 300 LFG	V5K793	8-25 (Vol %)	105-175	x	x	x	x	x	x	*[3]
Terj	V72008	0.75-2.5	170-190	x	x	x		x	x	
Turco 4215	V61102	0.75-2.55	145-180	x	x	x		x	x	*[6]
Turco 4215 NCLT	V61102	1-4	120-140	x	x	x		x	x	*[6]
Turco 4215 S	V61102	0.75-2.25	145-180	x	x	x		x	x	*[6]

*[1] Be-Cu, Cd, Cu, Pb, Ag, Sn, Zn, and solder

*[2] Cr, Co, Au, Mo, Ni, and stainless steel

*[3] Refer to BAC5749.

*[4] Carbon-fiber reinforced bismaleimide (BMI) parts and assemblies.

*[5] Composites BMS 8-212, BMS 8-256, BMS 8-276, but not honeycomb parts.

*[6] Silicate-free

SUBTASK 53-31-03-110-001

(2) Make sure that the spring-loaded plunger moves freely.

(a) If the plunger does not move freely, replace the fuselage drain valve assembly [1].

E. Fuselage Drain Valve Assembly Installation

SUBTASK 53-31-03-420-001

(1) Put the fuselage drain valve assembly [1] into the fuselage hole.

SUBTASK 53-31-03-420-002

(2) Engage the threads of the fuselage drain valve assembly [1] in the retainer [2].

(a) Tighten the fuselage drain valve assembly [1] with the drain valve adapter, SPL-1975, to 6 in-lb (0.7 N·m) - 10 in-lb (1.1 N·m).

———— **END OF TASK** ————

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NOSE VORTEX GENERATORS - REMOVAL/INSTALLATION

1. General

- A. This procedure contains these tasks:
- (1) Nose Vortex Generators Removal
 - (2) Nose Vortex Generators Installation

TASK 53-31-11-000-801

2. Nose Vortex Generators Removal

(Figure 401)

A. Tools/Equipment

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

Reference	Description
COM-2481	Sealant Removal Tool (meets BSS7384 requirements)
	Part #: 1-6390-A Supplier: 63318
	Part #: 10810 Supplier: \$0855
	Part #: 10811 Supplier: \$0855
	Part #: 10812 Supplier: \$0855
	Part #: 234350 Supplier: 5HCF1
	Part #: 235072 Supplier: 5HCF1
	Part #: 235073 Supplier: 5HCF1
	Part #: 235074 Supplier: 5HCF1
	Part #: 235075 Supplier: 5HCF1
	Part #: 235076 Supplier: 5HCF1
	Part #: 311/03 Supplier: F6892
	Part #: 311/14 Supplier: F6892
	Part #: 311/25 Supplier: F6892
	Part #: 311/37 Supplier: F6892
	Part #: AS1 Supplier: \$1351
	Part #: AS2 Supplier: \$1351
	Part #: AS3 Supplier: \$1351
	Part #: DAD5013 Supplier: 7RKH2
	Part #: DFD5019 Supplier: 7RKH2
	Part #: JNT411B60 Supplier: 3DN12
	Part #: JNT411B90 Supplier: 3DN12
	Part #: SCD5019 Supplier: 7RKH2
	Part #: ST982LF-9 Supplier: 81205
	Part #: TS1275-4 Supplier: 22975

B. Location Zones

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

C. Procedure - Remove the Nose Vortex Generators

SUBTASK 53-31-11-020-001

- (1) Remove the loose vortex generators [1] with sealant removal tool, COM-2481.

————— **END OF TASK** —————

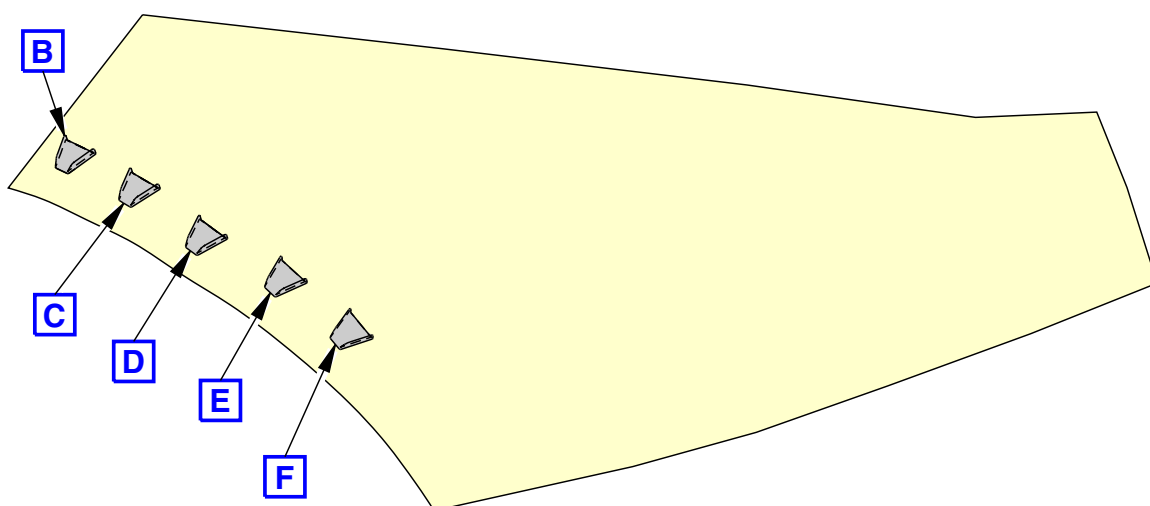
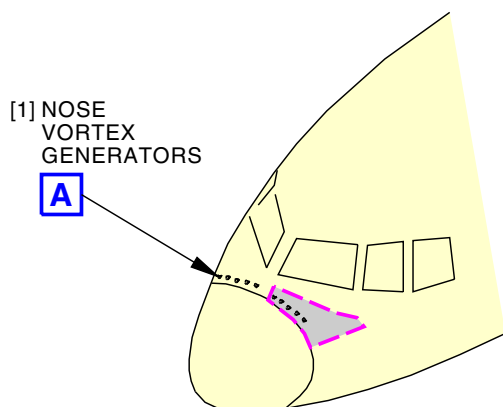
EFFECTIVITY
SIA ALL

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NOSE VORTEX GENERATORS

A

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Nose Vortex Generators
Figure 401/53-31-11-990-801 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

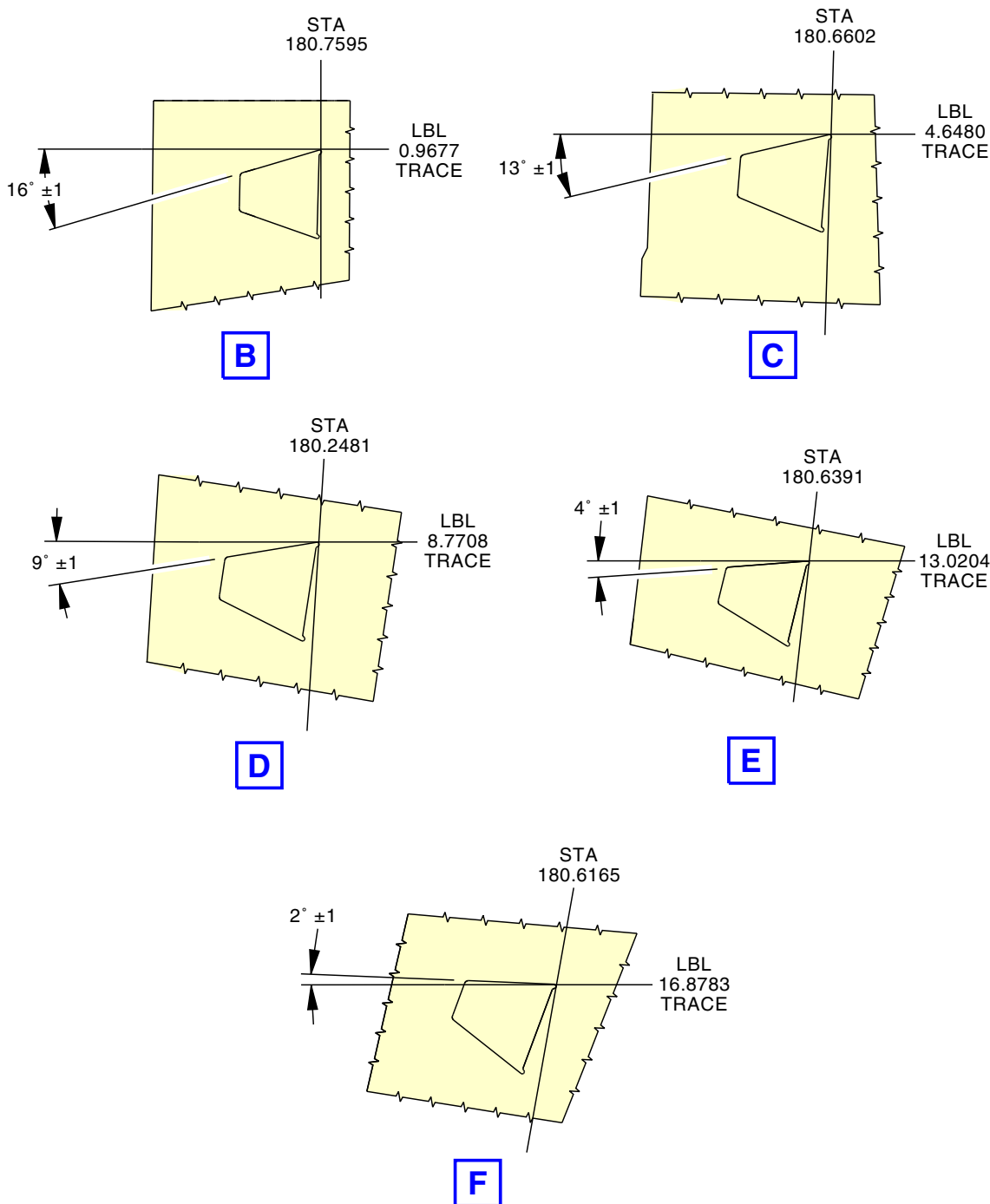
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AIRCRAFT MAINTENANCE MANUAL



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Nose Vortex Generators
Figure 401/53-31-11-990-801 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

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TASK 53-31-11-400-801

3. Nose Vortex Generators Installation

(Figure 401)

A. References

Reference	Title
51-22-00-160-801	Prepare For Sealing (P/B 201)

B. Consumable Materials

Reference	Description	Specification
A00436	Sealant - Fuel Tank	BMS5-45 (Supersedes BMS5-26)
A00551	Sealant - Fuel Tank	BAC5010 Type 44 (BMS5-44, BMS5-45)

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Vortex generator	53-31-21-02-305	SIA ALL

D. Location Zones

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

E. Procedure - Install the Nose Vortex Generator

SUBTASK 53-31-11-150-001

(1) Clean the mating surface (TASK 51-22-00-160-801).

SUBTASK 53-31-11-410-001

(2) Put the vortex generators [1] in the correct positions.

SUBTASK 53-31-11-410-002

(3) Do the steps that follow to bond the vortex generators [1] to the fuselage skin surface:



WARNING

DO NOT GET THE SEALANT ON YOUR SKIN OR IN YOUR EYES. PUT ON PROTECTIVE CLOTHING, GOGGLES AND A FACE MASK. USE IN A WELL VENTILATED AREA. DO NOT BREATHE THE GAS. IF YOU GET THE SEALANT ON YOUR SKIN OR IN YOUR EYES, WIPE IT AWAY. GET MEDICAL AID IF YOUR SKIN OR EYES BECOME IRRITATED.

(a) Mix the base compound for the sealant, A00551 with the activator.

NOTE: Refer to the manufacturer's instructions for the details.

1) Do not thin the sealant.

(b) Apply a thin, constant layer of the adhesive mixture to each mating surface.

(c) Put the vortex generators [1] on the nose section surface immediately, with sufficient pressure.

(d) Make sure that the surfaces are sealed together fully and that a continuous bead of extruded adhesive is around the edge of the vortex generators [1].

NOTE: This seals the surfaces together and shows a correct seal.

(e) Remove the unwanted adhesive around the edges of the vortex generators [1].

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SUBTASK 53-31-11-410-003

(4) Fillet seal around the vortex generators [1].

(a) Make the fillet seal to 0.03 in. (0.76 mm) by 0.03 in. (0.76 mm).

NOTE: If more sealant is necessary for the fillet seal, use sealant, A00436 Class B.

SUBTASK 53-31-11-410-004

(5) After the adhesive dries, (Table 401), apply paint to the nose section surface if it is necessary.

Table 401/53-31-11-993-801 Cure Time For BMS 5-44 (Class B) and BMS 5-45 (Class B)

Adhesive	Cure Time
BMS 5-44 Class B-1/2	24 hours at standard conditions
BMS 5-44 Class B-2	48 hours at standard conditions
BMS 5-45 Class B-1/2	12 hours at standard conditions
BMS 5-45 Class B-2	24 hours at standard conditions

————— **END OF TASK** —————

EFFECTIVITY
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STABILIZER TO BODY FRONT SPAR SLIDING SEAL - REMOVAL/INSTALLATION

1. General

- A. This procedure contains four tasks:
- (1) The removal of the stabilizer-to-body upper front spar sliding seal.
 - (2) The installation of the stabilizer-to-body upper front spar sliding seal (referred to as the sliding seal).
 - (3) The removal of the stabilizer-to-body lower front spar sliding seal.
 - (4) The installation of the stabilizer-to-body lower front spar sliding seal (referred to as the sliding seal).
- B. The sliding seal closes the opening where the attach fitting of the forward stabilizer moves. The approved repair of the seal can be done when the seal plates has been removed and this task has been done: Apply The Abrasion-Resistant Teflon Finish, BMS 10-86 Type I, TASK 51-21-81-370-801.

TASK 53-31-31-000-801

2. Stabilizer-to-Body Upper Front Spar Sliding Seal Removal

(Figure 401)

A. **Location Zones**

Zone	Area
300	Empennage

B. **Removal Procedure**

NOTE: The use of safety lockwire is optional to secure the two links together.

SUBTASK 53-31-31-020-001

- (1) Remove the center track strips [3].

SUBTASK 53-31-31-020-002

- (2) Move the stabilizer to 4.0 degrees leading edge down.

SIA ALL; AIRPLANES WITH FIXED UPPER LINK ASSEMBLY

SUBTASK 53-31-31-020-003

- (3) Remove the pins [4] that connect the fixed upper link assemblies [5] to the pedestal [6].
 - (a) If the pin [4] heads point to the lugs, the pedestal [6] can be removed to get access for the removal of the pins.
 - (b) Keep the pedestal [6] for the installation.

SIA ALL; AIRPLANES WITH ADJUSTABLE UPPER LINK ASSEMBLY

SUBTASK 53-31-31-020-016

- (4) Remove the pins [4] that connect the adjustable upper link assemblies [9] to the pedestal [6].
 - (a) If the pin [4] heads point to the lugs, the pedestal [6] can be removed to get access for the removal of the pins.
 - (b) Keep the pedestal [6] for the installation.

SIA ALL

SUBTASK 53-31-31-020-004

- (5) Pull out the upper seal plate [1].

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-31-31-020-005

- (6) Remove all the hardware from the upper seal plate [1].

NOTE: Keep the link assembly and the corner plates for installation.

———— **END OF TASK** ————

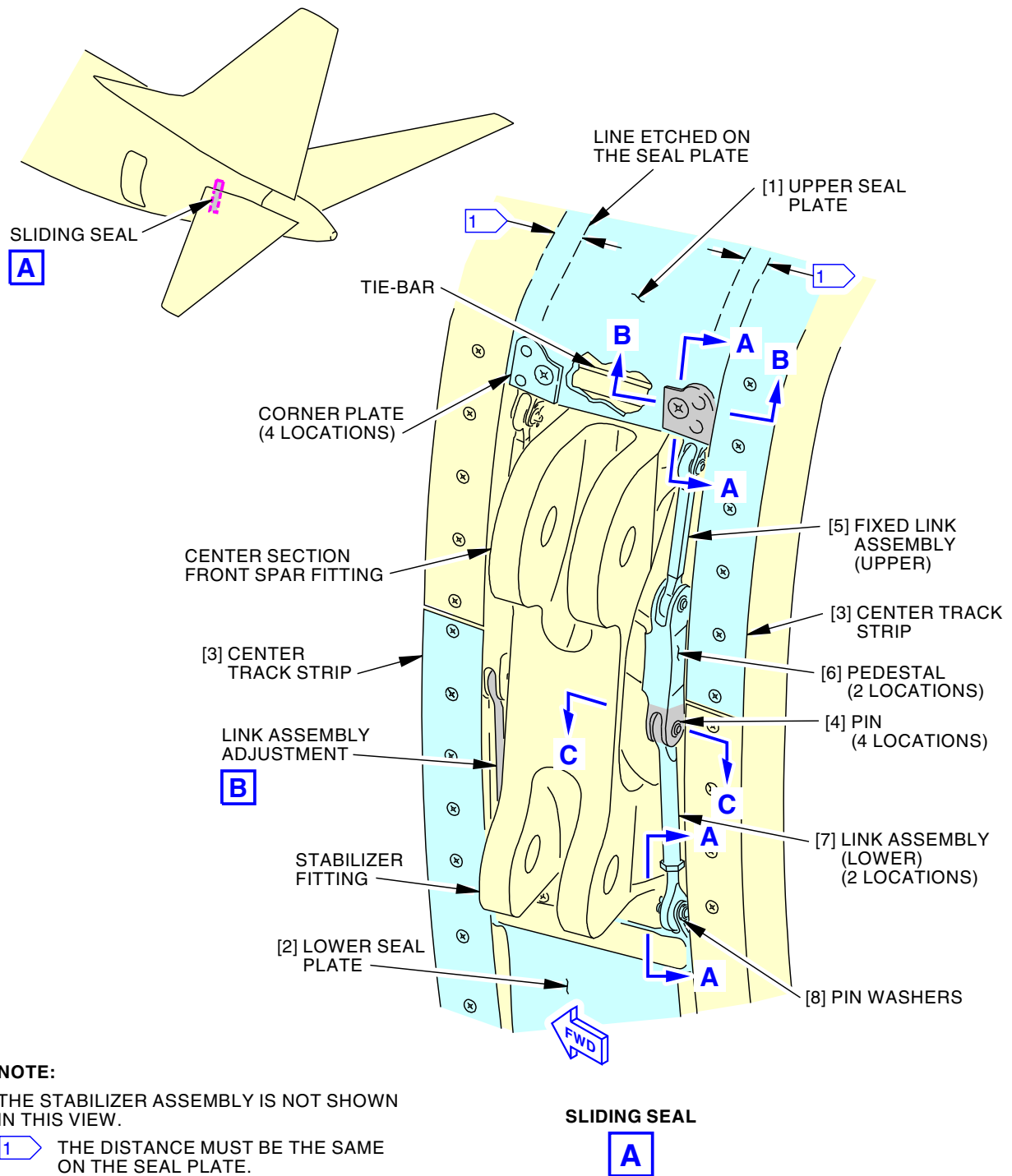
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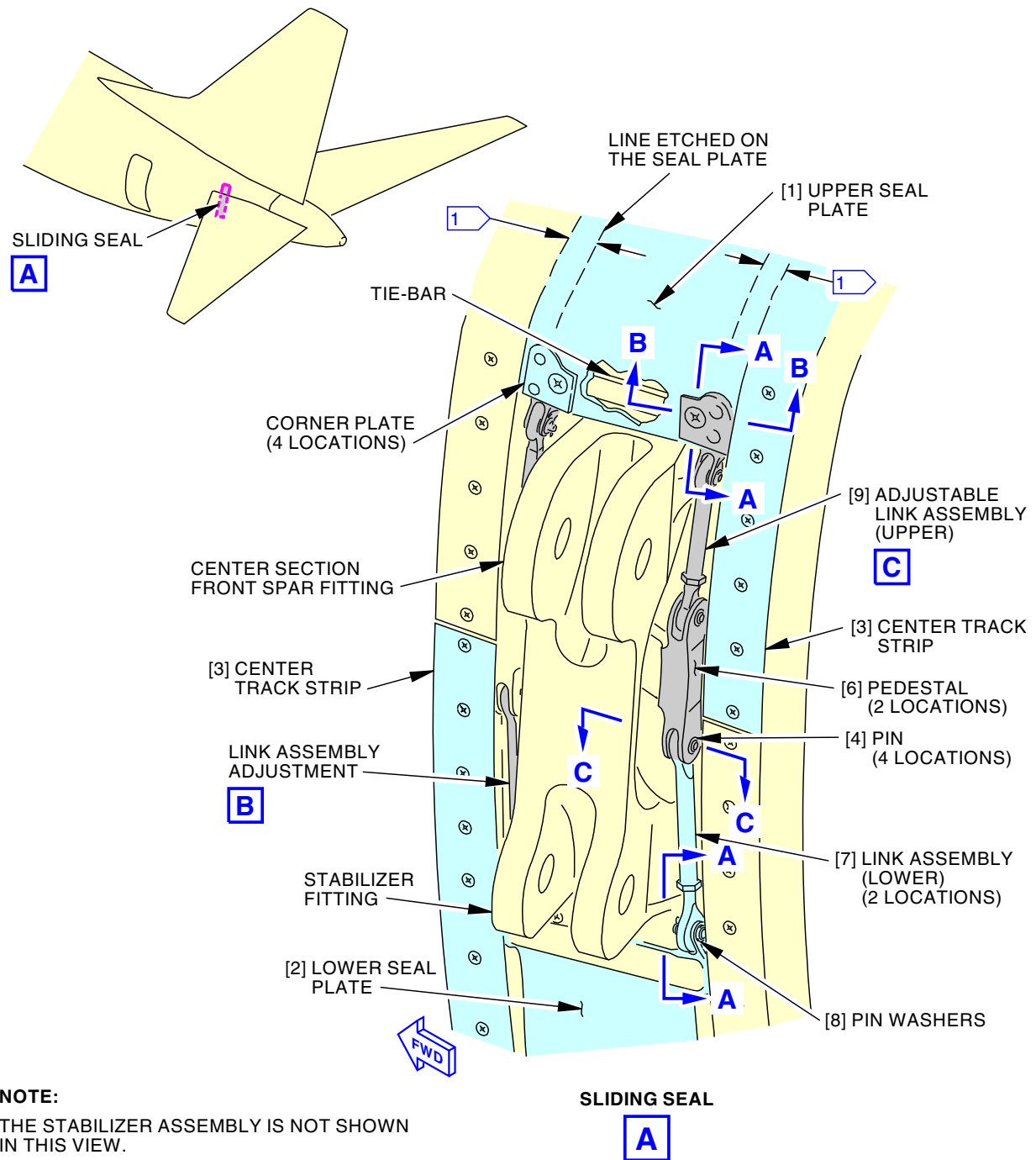
Front Spar Sliding Seal Installation
Figure 401/53-31-31-990-802 (Sheet 1 of 4)

EFFECTIVITY
SIA ALL; AIRPLANES WITH FIXED UPPER LINK
ASSEMBLY

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NOTE:

THE STABILIZER ASSEMBLY IS NOT SHOWN IN THIS VIEW.

1 THE DISTANCE MUST BE THE SAME ON THE SEAL PLATE.

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Front Spar Sliding Seal Installation
Figure 401/53-31-31-990-802 (Sheet 2 of 4)

EFFECTIVITY
SIA ALL; AIRPLANES WITH ADJUSTABLE UPPER
LINK ASSEMBLY

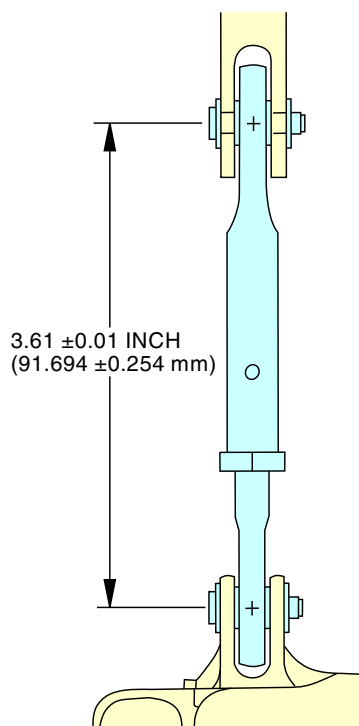
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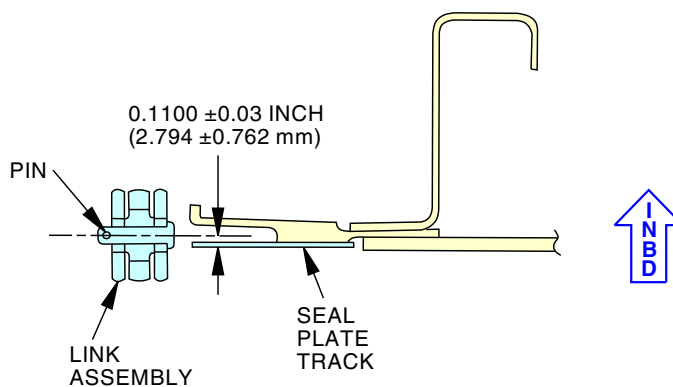


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LINK ASSEMBLY (LOWER) ADJUSTMENT

B



C-C

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Front Spar Sliding Seal Installation
Figure 401/53-31-31-990-802 (Sheet 3 of 4)

EFFECTIVITY
SIA ALL

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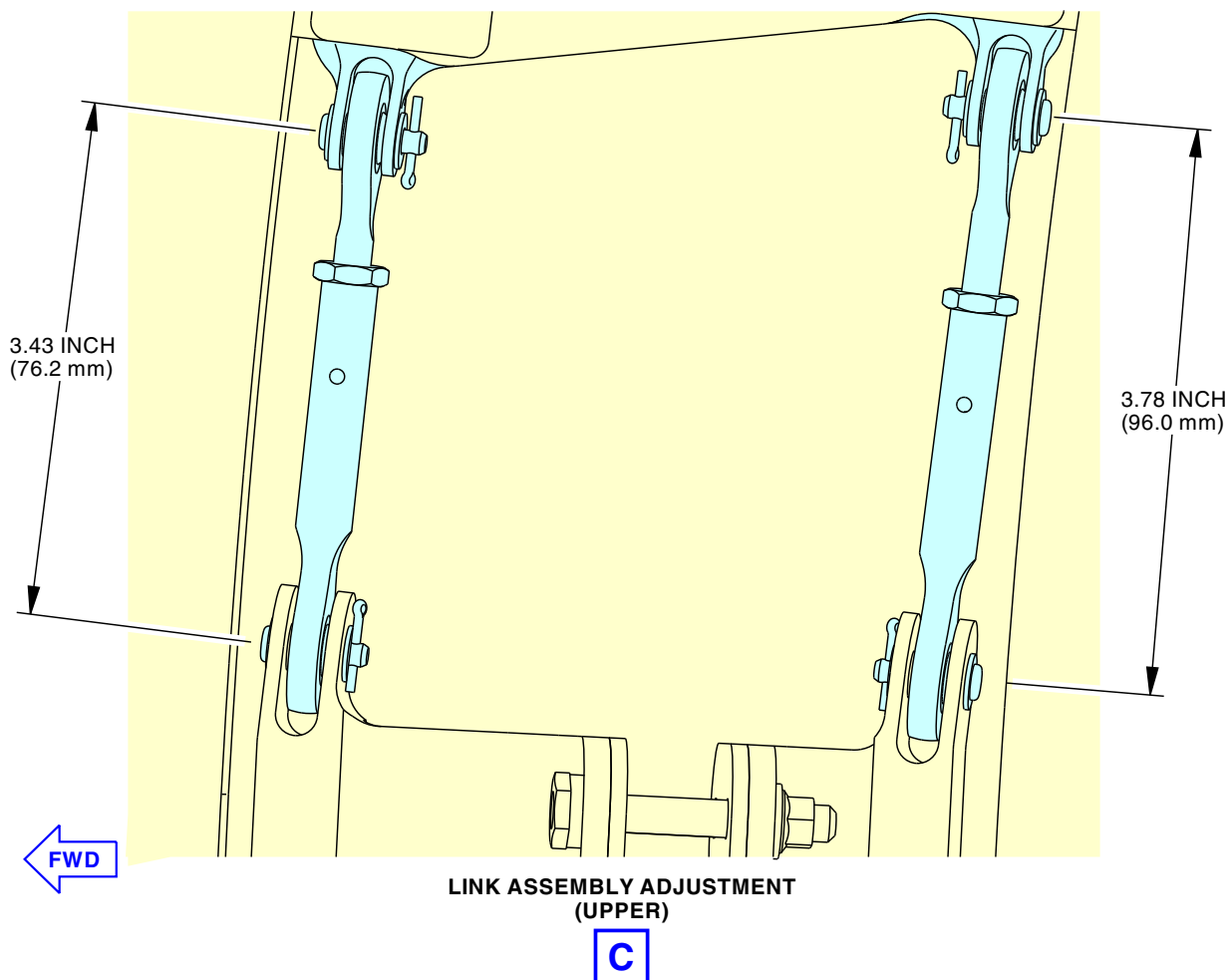
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Front Spar Sliding Seal Installation
Figure 401/53-31-31-990-802 (Sheet 4 of 4)

EFFECTIVITY
SIA ALL; AIRPLANES WITH ADJUSTABLE UPPER
LINK ASSEMBLY

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AIRCRAFT MAINTENANCE MANUAL

TASK 53-31-31-400-801

3. **Stabilizer-to-Body Upper Front Spar Sliding Seal Installation**

(Figure 401)

A. **Consumable Materials**

Reference	Description	Specification
G02480	Tape - Mylar, Clear, 3.5 mils, Maximum 16.5" Width - Permacel P-255	
G51458	Tape - Polyester, Adhesive - Nitto No. 315	

B. **Expendables/Parts**

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Upper seal plate	53-31-31-02-095	SIA ALL
		53-31-31-02-100	SIA ALL
4	Pin	53-31-31-03-010	SIA ALL

C. **Location Zones**

Zone	Area
300	Empennage

D. **Stabilizer-to-Body Upper Front Spar Sliding Seal Installation**

SUBTASK 53-31-31-860-001

- (1) Make sure that the stabilizer position is at 4.0 degrees leading edge down.

SUBTASK 53-31-31-420-001

SIA ALL; AIRPLANES WITH FIXED UPPER LINK ASSEMBLY

- (2) Position the fixed upper link assembly [5] on the center of the replacement upper seal plate [1].

SIA ALL; AIRPLANES WITH ADJUSTABLE UPPER LINK ASSEMBLY

SUBTASK 53-31-31-420-028

- (3) Position the adjustable upper link assembly [9] on the center of the replacement upper seal plate [1].

SIA ALL

SUBTASK 53-31-31-210-001

- (4) Make sure that the tie-bar lugs are clear of the upper seal plate [1] edges.
(a) Make sure that the edge distance will be satisfactory.

SUBTASK 53-31-31-210-002

- (5) Make a mark of the location of the tie-bar on the upper seal plate [1] with a pencil for reference.

SUBTASK 53-31-31-160-001

- (6) Remove any contamination or unwanted materials from the tracks area.

SUBTASK 53-31-31-410-002

- (7) If it is necessary, install the pedestal [6].

SIA ALL; AIRPLANES WITH FIXED UPPER LINK ASSEMBLY

SUBTASK 53-31-31-420-002

- (8) Temporarily attach the fixed upper link assembly [5] to the pedestal [6].

NOTE: Do not install the cotter pins.

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SIA ALL

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SIA ALL; AIRPLANES WITH ADJUSTABLE UPPER LINK ASSEMBLY

SUBTASK 53-31-31-420-029

- (9) Temporarily attach the adjustable upper link assembly [9] to the pedestal [6].

NOTE: Do not install the cotter pins.

SIA ALL

SUBTASK 53-31-31-420-003



APPLY TAPE AROUND THE END OF THE TRACK STRIP. IF YOU DO NOT OBEY, DAMAGE TO THE SEAL PLATE DURING THE INSTALLATION CAN OCCUR.

- (10) Apply protective Permacel P-255 tape, G02480 (recommended), or Nitto No. 315 tape, G51458 (alternative), around the end of the track strip (Figure 401).

SUBTASK 53-31-31-420-004

- (11) Put the upper seal plate [1] into the tracks.

NOTE: The plate must be bent in the opposite direction during installation to remove the stabilizer.

SUBTASK 53-31-31-420-005

- (12) Use the index mark to align the upper seal plate [1] on the fixed upper link assembly [5].

SUBTASK 53-31-31-420-006

- (13) Lightly attach the upper seal plate [1] to the tie-bar with a clamp.

SUBTASK 53-31-31-420-007

- (14) If it is necessary, move the upper seal plate [1] in a longitudinal direction to get equal dimensions.

NOTE: The dimensions are between the etched line on the seal plate and edges of the track strip along the full length of the visible track.

SUBTASK 53-31-31-950-001



DO THIS STEP CAREFULLY. IF THE PARTICLES GO INTO THE TRACKS, IT CAN CAUSE DAMAGE TO THE TEFLON COATING ON THE SEAL.

- (15) Apply Permacel P-255 tape, G02480 (recommended), or Nitto No. 315 tape, G51458 (alternative), to all the track openings to prevent that the drilled chips go into the track.

SUBTASK 53-31-31-420-008

- (16) Tighten the clamps.

SUBTASK 53-31-31-420-009

- (17) Back drill a minimum of two locations through the holes in the tie-bar into the upper seal plate [1].

SUBTASK 53-31-31-420-010

- (18) Install the temporary cleco fasteners in the holes.

SIA ALL; AIRPLANES WITH FIXED UPPER LINK ASSEMBLY

SUBTASK 53-31-31-020-006

- (19) Remove the pins [4] that attach the fixed upper link assembly [5] to the pedestal [6].

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SIA ALL

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737-7/8/8200/9/10 AIRCRAFT MAINTENANCE MANUAL

SIA ALL; AIRPLANES WITH ADJUSTABLE UPPER LINK ASSEMBLY

SUBTASK 53-31-31-020-017

- (20) Remove the pins [4] that attach the adjustable upper link assembly [9] to the pedestal [6].

SIA ALL; AIRPLANES WITH FIXED UPPER LINK ASSEMBLY

SUBTASK 53-31-31-020-007

- (21) Remove the upper seal plate [1] with the attached fixed upper link assembly [5].

SIA ALL; AIRPLANES WITH ADJUSTABLE UPPER LINK ASSEMBLY

SUBTASK 53-31-31-020-018

- (22) Remove the upper seal plate [1] with the attached adjustable upper link assembly [9].

SIA ALL; AIRPLANES WITH FIXED UPPER LINK ASSEMBLY

SUBTASK 53-31-31-420-011

- (23) At the bench, assemble the upper seal plate [1], fixed upper link assembly [5], and corner plates.

NOTE: Use the holes that are in the tie-bar for the locations to drill.

SIA ALL; AIRPLANES WITH ADJUSTABLE UPPER LINK ASSEMBLY

SUBTASK 53-31-31-420-030

- (24) At the bench, assemble the upper seal plate [1], adjustable upper link assembly [9], and corner plates.

NOTE: Use the holes that are in the tie-bar for the locations to drill.

SIA ALL

SUBTASK 53-31-31-210-003



MAKE SURE THAT TAPE STAYS AROUND THE END OF THE STRIP. IF YOU DO NOT OBEY, DAMAGE TO THE SEAL PLATE DURING THE INSTALLATION CAN OCCUR.

- (25) Make sure that protective Permacel P-255 tape, G02480 (recommended), or Nitto No. 315 tape, G51458 (alternative), stays around the end of the strip.

SUBTASK 53-31-31-420-012

- (26) Put the seal assembly into the tracks.

NOTE: The plate must be bent in the opposite direction during installation to remove the stabilizer.

SUBTASK 53-31-31-420-013

- (27) Move the upper seal plate [1] up and down.

NOTE: The force to move the upper seal plate must be less than 20 lb (9 kg) and upper seal plate must move freely.

SUBTASK 53-31-31-220-003

- (28) Make sure that the distance between the center line of each pin [4] and inside of the outer track strip is 0.11 ± 0.03 in. (2.79 ± 0.76 mm).

(a) If it is necessary, adjust as follows:

- 1) Loosen the four bolts on the pedestal [6].
- 2) Move the pedestal assembly along the serrations on the serrated plate inbound or outbound.

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- 3) Tighten the bolts and nuts.

SIA ALL; AIRPLANES WITH FIXED UPPER LINK ASSEMBLY

SUBTASK 53-31-31-420-014

- (29) Attach the fixed upper link assembly [5] to the pedestal [6] with the pins [4].

SIA ALL; AIRPLANES WITH ADJUSTABLE UPPER LINK ASSEMBLY

SUBTASK 53-31-31-420-031

- (30) Attach the adjustable upper link assembly [9] to the pedestal [6] with the pins [4].

SUBTASK 53-31-31-420-032

- (31) Adjust the upper link assembly [9] length (View C, Figure 401).

- (a) Tighten the nuts of the adjustable upper link assembly [9] to 20 in-lb (2.26 N·m) - 30 in-lb (3.39 N·m).

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SUBTASK 53-31-31-420-015

- (32) Install the cotter pins.

SUBTASK 53-31-31-420-016

- (33) Install the rub guide.

SUBTASK 53-31-31-420-017

- (34) Adjust and trim the ends of the rub guide.

- (a) Keep a clearance distance of 0.03 ±0.01 in. (0.76 ±0.26 mm) between each end of the rub guide and track.

SUBTASK 53-31-31-420-018

- (35) Manually put the leading edge of the stabilizer to the full up position.

SUBTASK 53-31-31-210-004

- (36) Make sure that the double flush rivet at the uppermost corner of the upper seal plate [1] is not out more than 0.003 in. (0.076 mm).

- (a) If the rivet touches the body structure, cut the driven head until it does not touch the body structure.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 53-31-31-020-009

- (1) Remove all the protective tapes and covers.

SUBTASK 53-31-31-160-002

- (2) Clean the area.

SUBTASK 53-31-31-420-019

- (3) Install the center track strips [3].

— END OF TASK —

TASK 53-31-31-000-802

4. Stabilizer-to-Body Lower Front Spar Sliding Seal Removal

(Figure 401)

A. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
2	Lower seal plate	53-31-31-03-055	SIA ALL

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(Continued)

AMM Item	Description	AIPC Reference	AIPC Effectivity
2 (cont.)		53-31-31-03-060	SIA ALL

B. Location Zones

Zone	Area
300	Empennage

C. Removal Procedure

NOTE: The use of safety lockwire is optional to secure the two links together.

SUBTASK 53-31-31-020-010

- (1) Remove the center track strips [3].

SUBTASK 53-31-31-020-011

- (2) Move the stabilizer to the full up position.

SUBTASK 53-31-31-020-012

- (3) Remove the pins [4] that connect the lower link assemblies [7] to the pedestal [6].

SUBTASK 53-31-31-020-013

- (4) Pull out the lower seal plate [2].

SUBTASK 53-31-31-020-014

- (5) Remove the lower link assembly [7] and attaching hardware.

- (a) Keep the link assembly and attaching hardware for installation.

————— **END OF TASK** —————

TASK 53-31-31-400-802

5. Stabilizer-to-Body Lower Front Spar Sliding Seal Installation

(Figure 401)

A. Consumable Materials

Reference	Description	Specification
G02480	Tape - Mylar, Clear, 3.5 mils, Maximum 16.5" Width - Permacel P-255	
G51458	Tape - Polyester, Adhesive - Nitto No. 315	

B. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
2	Lower seal plate	53-31-31-03-055 53-31-31-03-060	SIA ALL SIA ALL
4	Pin	53-31-31-03-010	SIA ALL

C. Location Zones

Zone	Area
300	Empennage

D. Stabilizer-to-Body Lower Front Spar Sliding Seal Installation

SUBTASK 53-31-31-860-002

- (1) Make sure that the stabilizer is in the full up position.

SUBTASK 53-31-31-160-003

- (2) Remove any contamination or unwanted material from the track area.

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SUBTASK 53-31-31-420-020



APPLY TAPE AROUND THE END OF THE TRACK STRIP. IF YOU DO NOT OBEY, DAMAGE TO THE SEAL PLATE DURING THE INSTALLATION CAN OCCUR.

- (3) Apply protective Permacel P-255 tape, G02480 (recommended), or Nitto No. 315 tape, G51458 (alternative), around the end of the track strip (Figure 401).

SUBTASK 53-31-31-420-021

- (4) Put the lower seal plate [2] into the tracks.

NOTE: The plate must be bent in the opposite direction during installation to remove the stabilizer.

SUBTASK 53-31-31-420-022

- (5) Move the lower seal plate [2] up and down.

NOTE: The force to move the lower seal plate must be less than 20 lb (9 kg) and lower seal plate must move freely.

SUBTASK 53-31-31-220-001

- (6) Make sure that the distance between the center line of each pin [4] and inside of the outer track strip is 0.11 ± 0.03 in. (2.79 ± 0.76 mm).
 - (a) If it is necessary, adjust as follows:
 - 1) Loosen the bolts on the pedestal [6].
 - 2) Move the pedestal assembly along the serrations on the serrated plate inbound or outbound.
 - 3) Tighten the bolts and nuts.

SUBTASK 53-31-31-420-023

- (7) Attach the lower link assembly [7] to the pedestal [6] with the pins [4].

SUBTASK 53-31-31-420-024

- (8) Install the cotter pins.

SUBTASK 53-31-31-420-025

- (9) Attach the lower seal plate [2] to the lower link assembly [7] with the pin washers [8].

SUBTASK 53-31-31-220-002

- (10) Adjust the forward link assembly length to 3.61 ± 0.01 in. (9.17 ± 0.03 cm) (View B, Figure 401).
 - (a) Tighten the nuts of the lower link assembly [7] to 20 in-lb ($2.26 \text{ N}\cdot\text{m}$) - 30 in-lb ($3.39 \text{ N}\cdot\text{m}$).
 - (b) Install the cotter pins.

SUBTASK 53-31-31-210-006

- (11) Adjust the aft link assembly length in half turn increments to achieve an equal gap between the rub guide and seal tracks.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 53-31-31-020-015

- (1) Remove all the protective tapes and covers.

SUBTASK 53-31-31-160-004

- (2) Clean the area.

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SUBTASK 53-31-31-420-027

(3) Install the center track strips [3].

————— **END OF TASK** —————

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PASSENGER CABIN AND CARGO COMPARTMENT TRACKS - CLEANING/PAINTING

1. **General**

- A. This procedure contains one task. The task is to clean the passenger cabin and cargo compartment tracks.
- B. A minimum quantity of maintenance is necessary for the passenger cabin and cargo compartment tracks if you keep them clean and free of moisture. Use the task that follows when you find corrosion.

TASK 53-42-11-100-801

2. **Clean the Passenger Cabin and Cargo Compartment Track**

A. References

Reference	Title
SRM 51-20-01	PROTECTIVE TREATMENT OF METALLIC AND COMPOSITE MATERIALS

B. Tools/Equipment

Reference	Description
STD-123	Brush - Soft Bristle

C. Consumable Materials

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
B00102	Abrasive - Aluminum Oxide Coated Cloth	BAC5719 Type II Class A (MIL-DTL-5541 Class 1A)
C00064	Coating - Aluminum Chemical Conversion	
C00755	Compound - Organic Corrosion Inhibiting, Heavy Duty	BMS3-26

D. Location Zones

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

E. Procedure

SUBTASK 53-42-11-140-001

- (1) Manually clean the track with solvent, B00083.

SUBTASK 53-42-11-210-001

- (2) Make sure you remove oil or grease.

SUBTASK 53-42-11-140-002

- (3) Rub the track with abrasive cloth, B00102 paper to remove the corrosion.

SUBTASK 53-42-11-140-003

- (4) Remove the residue with a soft bristle brush, STD-123.

SUBTASK 53-42-11-140-004

- (5) Clean the surface again with solvent, B00083.

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SUBTASK 53-42-11-110-001



WARNING

DO NOT TOUCH YOUR SKIN WITH THE CHEMICAL CONVERSION COATING. IT CONTAINS CHROMIC ACID AND CAN CAUSE INJURY TO PERSONS.



CAUTION

PUT A COVER ON THE CARPETS WHILE YOU APPLY THE CHEMICAL CONVERSION COATING. IT CAN CAUSE A STAIN ON SOME FABRICS.

(6) Apply a layer of the chemical conversion coating, C00064 to the surface.

SUBTASK 53-42-11-370-001

(7) Apply a finish if it is necessary.

SUBTASK 53-42-11-390-001

(8) Below the galleys, apply a corrosion preventive compound, C00755 in the seat tracks (SRM SUBJECT 51-20-01).

———— **END OF TASK** ————

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WING-TO-BODY FAIRING - MAINTENANCE PRACTICES

1. General

- A. This procedure contains 1 task:
- (1) Corrosion Prevention of the Wing to Body Fairing Cavity.

TASK 53-51-00-600-801

2. Wing to Body Fairing Cavity - Corrosion Prevention

Figure 201

A. **General**

- (1) The upper wing-to-body fairing is attached to the upper wing surface and fuselage skin along the wing to fuselage joints. The lower lobe fairing houses the ambient air inlets to the ram air system during pack cooling fan operation. The lower lobe fuselage skin under the fairing extends to the bulkhead below the front spar of the center wing section. The cavity formed by the lower lobe fairing and fuselage skin is the area of concern and is the subject of this figure. Aft of this area the fairing covers the center wing section.
- (2) Service experience has shown the revised finish system has been effective in controlling the corrosion problem. Corrosion damage is due to the accumulation of moisture from the ambient air as it enters the cavity during pack cooling fan operation.
- (3) Corrosion was reported on the fuselage skin and the external doubler on the wing upper surface under the wing to body fairing. The body surfaces under the fairing is treated with a water displacing corrosion inhibiting compound in production.
- (4) Refer to STANDARD PRACTICES AND STRUCTURES, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

B. **References**

Reference	Title
51-00	STANDARD PRACTICES AND STRUCTURES
51-00-51	CORROSION INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
SRM 737-MAX	D000534530

C. **Consumable Materials**

Reference	Description	Specification
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. **Location Zones**

Zone	Area
100	Lower Half of Fuselage

E. **Corrosion Prevention**

SUBTASK 53-51-00-610-001

- (1) Make the periodic inspection described in CORROSION INSPECTION AND DETECTION, SUBJECT 51-00-51 to ensure that the protective finishes provided at manufacture remain intact. Access for inspections can be made through service doors and access panels in the fairing. A corrosion prevention program should be initiated to prevent the accumulation of corrosive products in order to minimize the occurrence of corrosion.

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SUBTASK 53-51-00-610-002



DO NOT APPLY THE CORROSION-INHIBITING COMPOUND TO SILICONE RUBBER, RUBBER SEALS, OR RUBBER CUSHIONS. THE CORROSION-INHIBITING COMPOUND CAN CAUSE SEALS, AND CUSHIONS TO BECOME LARGER, AND CAN CAUSE THE DETERIORATION OF THEM.

- (2) Use corrosion inhibiting compound, G00009 where extensive corrosion exists (noticeable skin bulges, missing fasteners or large amounts of discolored deposits of fastener heads or faying surfaces), refer to SRM 737-MAX for details of corrosion removal.

SUBTASK 53-51-00-610-003

- (3) Where corrosion is not evident, apply corrosion inhibiting compound in all metallic areas of the cavity.

NOTE: For details of water displacing corrosion inhibiting compound, corrosion inhibiting compound, G00009, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-51-00-610-004

- (4) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by an application of corrosion inhibiting compound on the affected area to retard the corrosion process and into the entire cavity area noted in part C. The finish system should be restored at the next maintenance opportunity (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 and SRM 737-MAX).

SUBTASK 53-51-00-610-005

- (5) Frequency of Application
- (a) Inspect the area at regular maintenance intervals and reapply corrosion inhibitor as necessary.

————— END OF TASK —————

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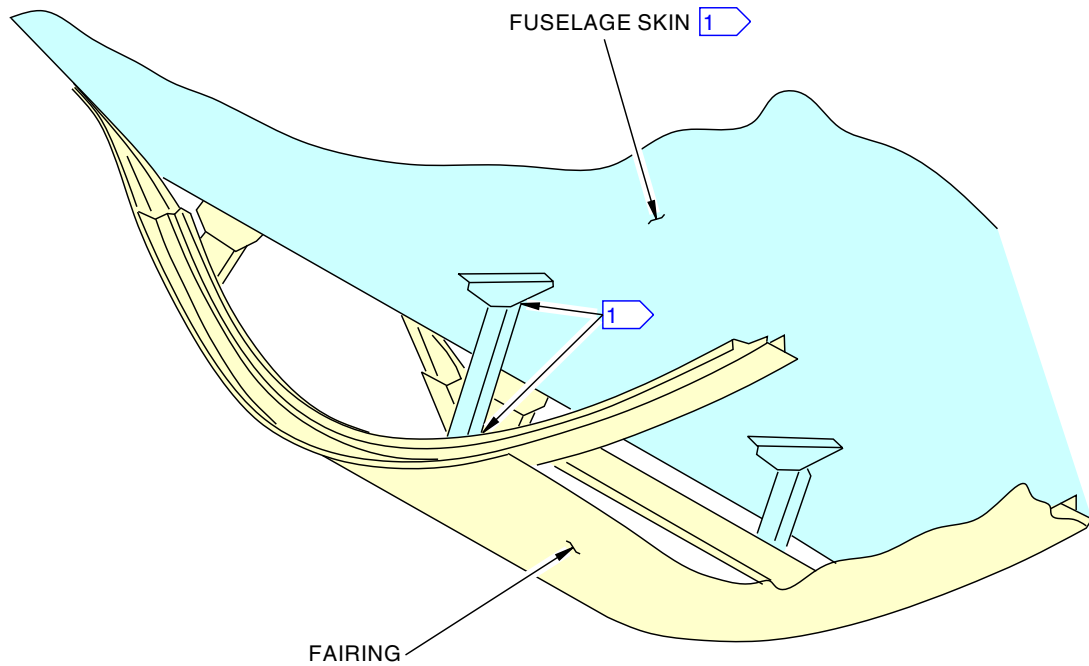
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TYPICAL FAIRING CAVITY STRUCTURE

NOTE:

 APPLY BMS 3-23 CORROSION INHIBITOR

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**Wing to Body Fairing Cavity
Figure 201/53-51-00-990-801**

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FRONT SPAR TO REAR SPAR UNDERWING PANEL - INSPECTION/REPAIR

1. General

- A. This procedure contains two tasks. The first task is to examine the countersunk of the fastener holes of the front spar to rear spar underwing panel. The second task is the repair the holes if cracks are found.

TASK 53-51-02-200-801

2. Front Spar to Rear Spar Underwing Panel Inspection

Figure 801

A. **Location Zones**

Zone	Area
100	Lower Half of Fuselage

B. **Procedure**

SUBTASK 53-51-02-010-001

- (1) Remove the sixteen 0.25 in. (6.35 mm) attach fasteners from the outboard edge of the aft and forward panels on the left and right sides (Figure 801).

SUBTASK 53-51-02-210-001

- (2) Do a visual inspection with a 10X magnifying glass of the countersunk and adjacent area of the hole.

SUBTASK 53-51-02-300-001

- (3) If you find cracks in or adjacent to the countersunk area, do this task: Front Spar to Rear Spar Underwing Panel Repair, TASK 53-51-02-300-801.

SUBTASK 53-51-02-420-001

- (4) If you do not find cracks, or you have made repairs to cracks, install the bolts and washers:
- (a) Measure and record the nutplate for the self-locking torque. The torque should be 3.5 in-lb (0.4 N·m) to 30 in-lb (3 N·m).
 - (b) Add the self-locking torque (5 in-lb (1 N·m) to 10 in-lb (1 N·m)) to calculate the installation torque.
 - (c) Tighten the bolts to the midrange of this torque range.

————— **END OF TASK** —————

TASK 53-51-02-300-801

3. Front Spar to Rear Spar Underwing Panel Repair

A. **References**

Reference	Title
SRM 51-70-04	REPAIR PROCEDURES FOR WET LAYUP MATERIALS
SRM 51-70-05	REPAIR PROCEDURES FOR PREIMPREGNATED MATERIALS

B. **Consumable Materials**

Reference	Description	Specification
G50400	Resin - Fiberglass Layup, Short Worklife, Non-Brominated	BMS8-201 Type IV (Supersedes BMS8-201 Type II)

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C. Location Zones

Zone	Area
100	Lower Half of Fuselage

D. Procedure

SUBTASK 53-51-02-340-001

(1) If you find cracks only in the countersunk area:

(a) Fill the crack with resin, G50400.

SUBTASK 53-51-02-340-002

(2) If you find cracks that extend more than the countersunk area, do one of the repair procedures that follow:

(a) SRM SUBJECT 51-70-04, Repair 6

(b) SRM SUBJECT 51-70-05, Repair 6.

————— END OF TASK —————

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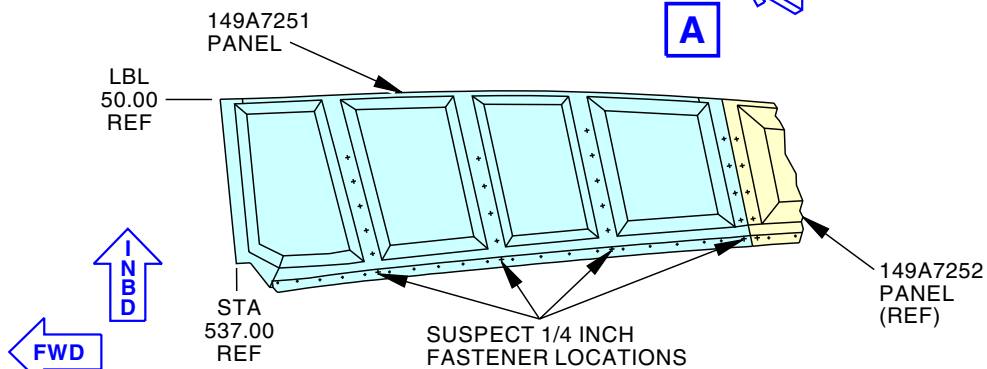
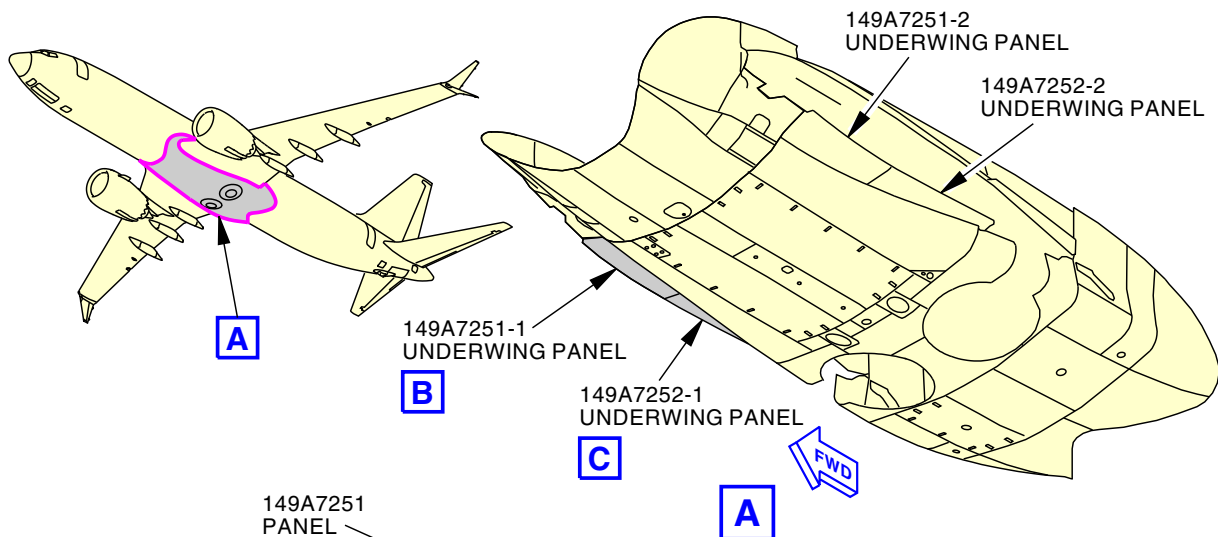
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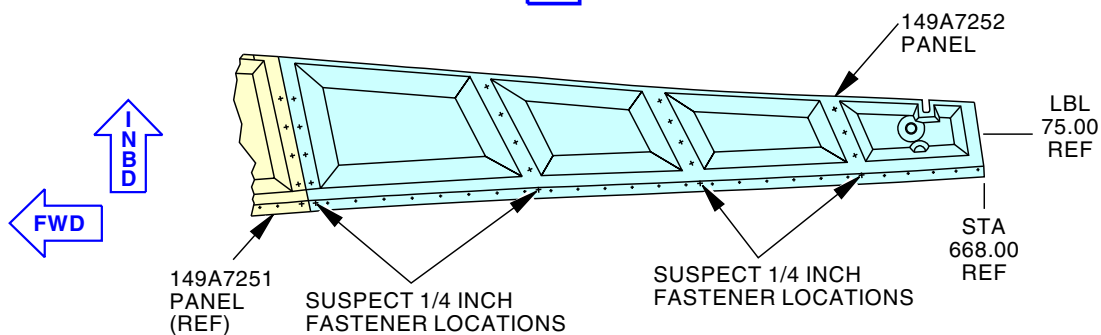
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**FORWARD UNDERWING PANEL, 149A7251, FASTENER LOCATIONS
(LEFT PANEL IS SHOWN, RIGHT PANEL IS OPPOSITE)**



**AFT UNDERWING PANEL, 149A7252, FASTENER LOCATIONS
(LEFT PANEL IS SHOWN, RIGHT PANEL IS OPPOSITE)**

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**Front Spar to Rear Spar Underwing Panel Attachment Fasteners
Figure 801/53-51-02-990-801**

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WING-TO-BODY FAIRING BLOWOUT PANEL - REMOVAL/INSTALLATION

1. **General**

- A. This procedure has these tasks:
- (1) Wing-to-Body fairing blowout panel removal
 - (2) Wing-to-Body fairing blowout panel installation.
- B. Each blowout panel has a hinge on one side. The opposite side has clips, which are held by rivets. These clips keep the blowout panels closed.

TASK 53-51-11-000-801

2. **Wing-to-Body Fairing Blowout Panel Removal**

A. **Location Zones**

Zone	Area
200	Upper Half of Fuselage

B. **Wing-to-Body Fairing Blowout Panel Removal**

SUBTASK 53-51-11-010-001

- (1) If the panel blows out, open the applicable underwing fairing and remove the rivets.

————— **END OF TASK** —————

TASK 53-51-11-400-801

3. **Wing-to-Body Fairing Blowout Panel Installation**

A. **References**

Reference	Title
51-21-81 P/B 701	ABRASION-RESISTANT TEFLON FINISH - CLEANING/PAINTING
51-22-00-390-801	Non-Removable Faying (Mated) Surface Seal Application (P/B 201)

B. **Tools/Equipment**

Reference	Description
STD-810	Spatula - Fillet Smoothing, Hardwood or Plastic

C. **Location Zones**

Zone	Area
200	Upper Half of Fuselage

D. **Wing-to-Body Fairing Blowout Panel Installation**

SUBTASK 53-51-11-210-001

- (1) Examine the attach clips for damage.

SUBTASK 53-51-11-140-001

- (2) Use a hardwood or plastic fillet smoothing spatula, STD-810 to clean the sealant from the mating surfaces.

SUBTASK 53-51-11-120-001

- (3) Apply an abrasion resistant finish and parting agent to the outer face of the fairing lip (ABRASION-RESISTANT TEFLON FINISH - CLEANING/PAINTING, PAGEBLOCK 51-21-81/701).

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SUBTASK 53-51-11-140-002

- (4) Remove the sealant from the clearance between the blowout panel and panel cutout.

SUBTASK 53-51-11-390-001



BE CAREFUL WHEN YOU APPLY HAND PRESSURE TO PUT THE BLOWOUT PANEL IN THE CORRECT POSITION. TOO MUCH PRESSURE CAN CAUSE DISTORTION OF THE BLOWOUT PANEL.

- (5) Apply a bead of sealant to the inner face of the panel lip (TASK 51-22-00-390-801).

SUBTASK 53-51-11-420-001

- (6) Install the blowout panels with one rivet, 3/32 in. (2.4 mm) diameter, in the aft outboard location and one rivet, 1/8 in. (3.2 mm) diameter, in the forward outboard location.

SUBTASK 53-51-11-860-001

- (7) After the sealant dries, open and close the blowout panel to make sure that it did not bond to the structure.

SUBTASK 53-51-11-860-002

- (8) Close and latch the blowout panel.

————— **END OF TASK** —————

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WING-TO-BODY FAIRING PANELS - REMOVAL/INSTALLATION

1. **General**

A. This procedure has these tasks:

- (1) Forward Wing-To-Body fairing panel removal
- (2) Forward Wing-To-Body fairing panel installation
- (3) Center Wing-To-Body fairing panel (Except 192AL, 192AR, 192HL, 192HR, 195BL, 195BR) removal
 - (a) This includes the Wing-To-Body fairing panels above the wings.
- (4) Center Wing-To-Body fairing panel (Except 192AL, 192AR, 192HL, 192HR, 195BL, 195BR) installation
 - (a) This includes the Wing-To-Body fairing panels above the wings.
- (5) Center Wing-To-Body fairing panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) removal
 - (a) This includes the Wing-To-Body fairing panels above the wings.
- (6) Center Wing-To-Body fairing panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) installation
 - (a) This includes the Wing-To-Body fairing panels above the wings.
- (7) Aft Wing-To-Body fairing panel removal
- (8) Aft Wing-To-Body fairing panel installation.

TASK 53-51-21-000-801

2. **Forward Wing-To-Body Fairing Panel Removal**

(Figure 401)

A. **General**

- (1) This task gives the instructions to remove the forward Wing-to-Body fairing panel.

B. **References**

Reference	Title
21-51	PACK FLOW CONTROL AND PACK COOLING SYSTEM
51-22-00-160-801	Prepare For Sealing (P/B 201)
53-51-21-211-801	Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection (P/B 601)

C. **Location Zones**

Zone	Area
191	Lower Wing-To-Body Fairing - Forward of Wing Box

D. **Access Panels**

Number	Name/Location
191AL	Forward Wing-To-Body Fairing Panel - Upper
191AR	Forward Wing-To-Body Fairing Panel - Upper
191BL	Forward Wing-To-Body Fairing Panel, Ram Air Inlet
191BR	Forward Wing-To-Body Fairing Panel, Ram Air Inlet
191CL	Forward Wing-To-Body Fairing Panel - Middle
191CR	Forward Wing-To-Body Fairing Panel - Middle
191D	Forward Wing-To-Body Fairing Panel - Lower
191E	Low Pressure ECS Panel - Forward

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(Continued)

Number	Name/Location
191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191GL	Ram Air Actuator Panel - Forward
191GR	Ram Air Actuator Panel - Forward
191HL	Ram Air Inlet Lip Panel - Forward
191HR	Ram Air Inlet Lip Panel - Forward

E. Prepare for the Removal

SUBTASK 53-51-21-020-001

- (1) Remove the equipment that is attached to the fairing.
 - (a) Ram Air Inlet (SECTION 21-51).

F. Forward Wing-To-Body Fairing Panel Removal

SUBTASK 53-51-21-160-001

- (1) Remove sealant from the edge of the applicable panel.

NOTE: You can remove a section of the fillet seal (TASK 51-22-00-160-801).

SUBTASK 53-51-21-020-002

- (2) Do these steps to remove the applicable fairing panels:
 - (a) Make sure that you hold the fairing panel until all the fasteners are removed.
 - (b) Make sure that you identify the bolts [15], bonding bolts [16] and dimpled washers [17] to install them in the same location.
 - 1) Make sure that you identify the bonding bolts [16] and dimpled washers [17] for electrical bonding (TASK 53-51-21-211-801).
 - (c) Zone 191:
 - 1) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 191AL [7].
 - a) Open this access panel:

Number	Name/Location
191AL	Forward Wing-To-Body Fairing Panel - Upper
 - 2) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 191AR [1].
 - a) Open this access panel:

Number	Name/Location
191AR	Forward Wing-To-Body Fairing Panel - Upper
 - 3) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 191BL [6].
 - a) Open this access panel:

Number	Name/Location
191BL	Forward Wing-To-Body Fairing Panel, Ram Air Inlet
 - 4) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 191BR [2].

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- a) Open this access panel:
- | <u>Number</u> | <u>Name/Location</u> |
|---------------|---|
| 191BR | Forward Wing-To-Body Fairing Panel, Ram Air Inlet |
- 5) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 191CL [5].
- a) Open this access panel:
- | <u>Number</u> | <u>Name/Location</u> |
|---------------|---|
| 191CL | Forward Wing-To-Body Fairing Panel - Middle |
- 6) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 191CR [3].
- a) Open this access panel:
- | <u>Number</u> | <u>Name/Location</u> |
|---------------|---|
| 191CR | Forward Wing-To-Body Fairing Panel - Middle |
- 7) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 191D [4].
- a) Open this access panel:
- | <u>Number</u> | <u>Name/Location</u> |
|---------------|--|
| 191D | Forward Wing-To-Body Fairing Panel - Lower |
- 8) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 191E [11].
- a) Open this access panel:
- | <u>Number</u> | <u>Name/Location</u> |
|---------------|----------------------------------|
| 191E | Low Pressure ECS Panel - Forward |
- 9) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 191FL [9].
- a) Open this access panel:
- | <u>Number</u> | <u>Name/Location</u> |
|---------------|---|
| 191FL | Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet |
- 10) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 191FR [13].
- a) Open this access panel:
- | <u>Number</u> | <u>Name/Location</u> |
|---------------|---|
| 191FR | Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet |
- 11) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 191GL [8].
- a) Open this access panel:
- | <u>Number</u> | <u>Name/Location</u> |
|---------------|----------------------------------|
| 191GL | Ram Air Actuator Panel - Forward |
- 12) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 191GR [14].

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- a) Open this access panel:

<u>Number</u>	<u>Name/Location</u>

191GR	Ram Air Actuator Panel - Forward

- 13) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 191HL [10].

- a) Open this access panel:

<u>Number</u>	<u>Name/Location</u>

191HL	Ram Air Inlet Lip Panel - Forward

- 14) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 191HR [12].

- a) Open this access panel:

<u>Number</u>	<u>Name/Location</u>

191HR	Ram Air Inlet Lip Panel - Forward

- (d) Remove the fairing panel from the airplane.

———— **END OF TASK** ————

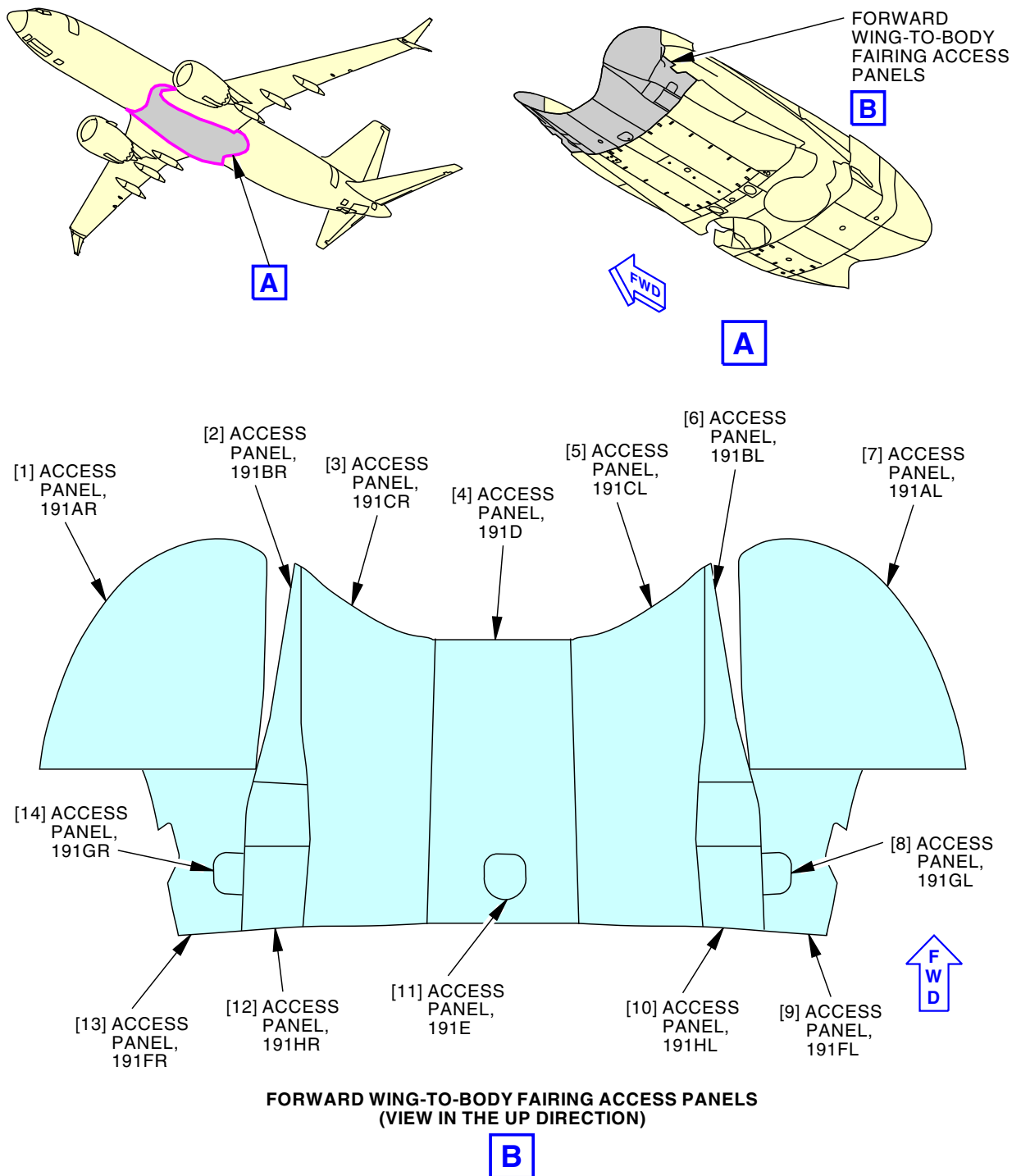
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2416183 S00061539924_V1

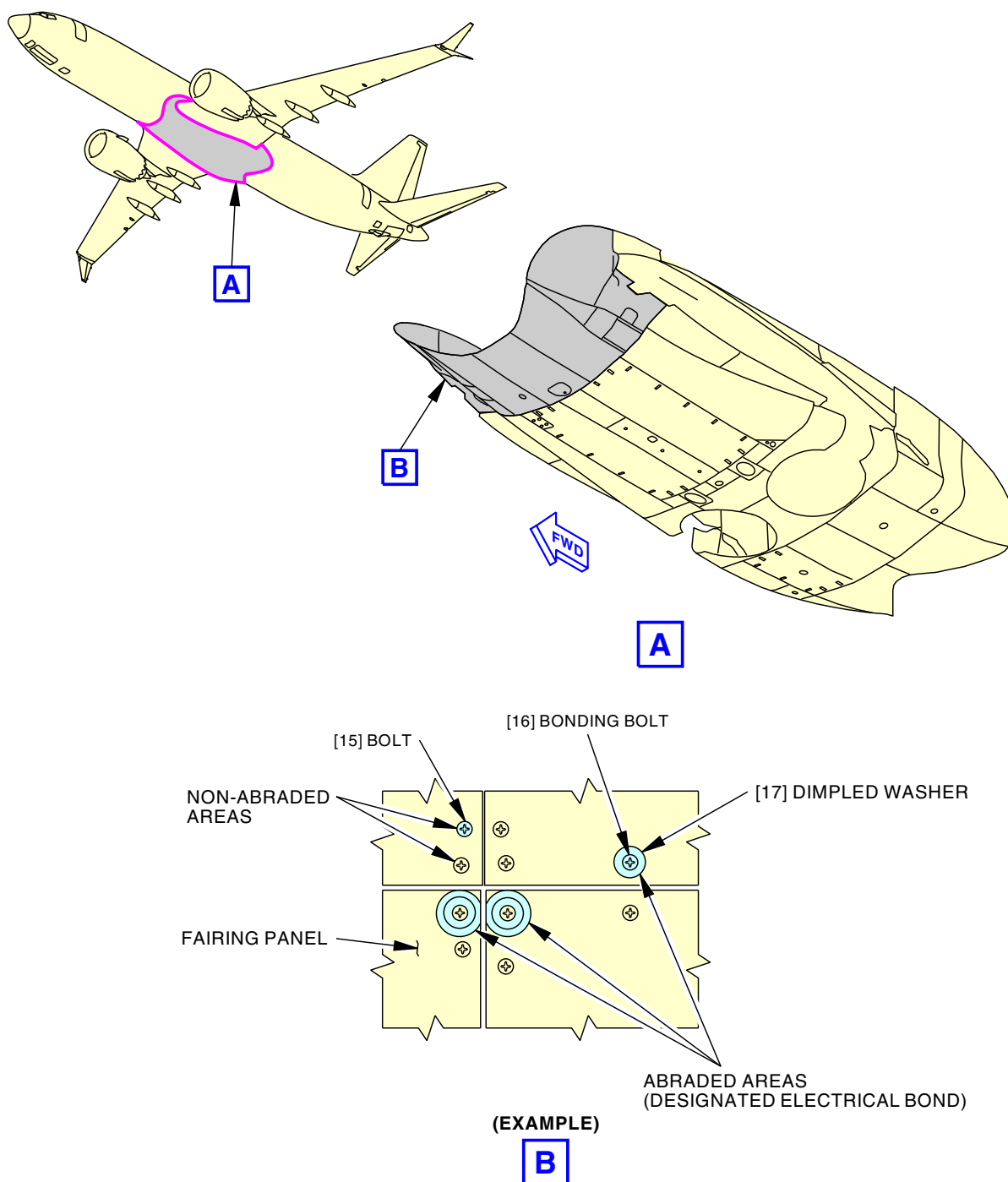
Forward Wing-to-Body Fairing Access Panels Installation
Figure 401/53-51-21-990-801

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2532165 S0000598550_V1

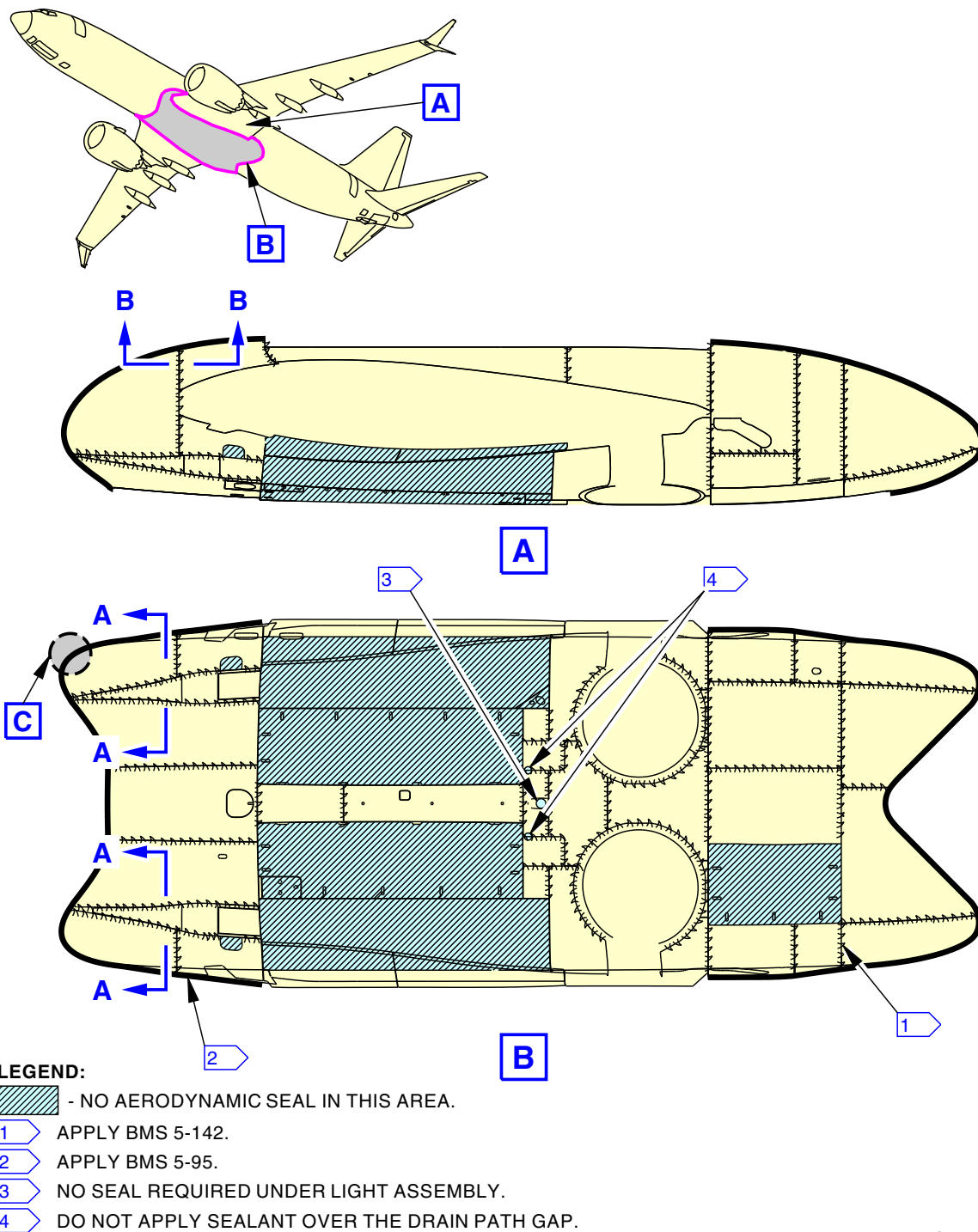
Wing-to-Body Fastener Example
Figure 402/53-51-21-990-802

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2532171 S0000597575_V3

Wing-to-Body Fairing Seal Requirements
Figure 403/53-51-21-990-803 (Sheet 1 of 4)

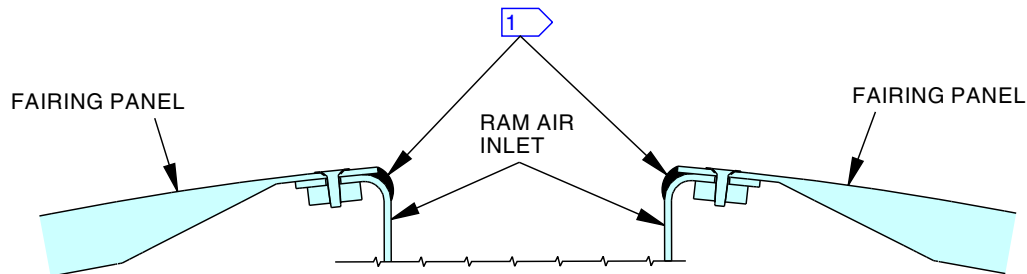
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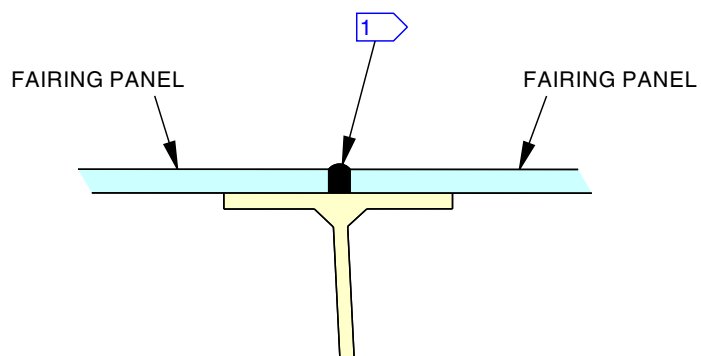
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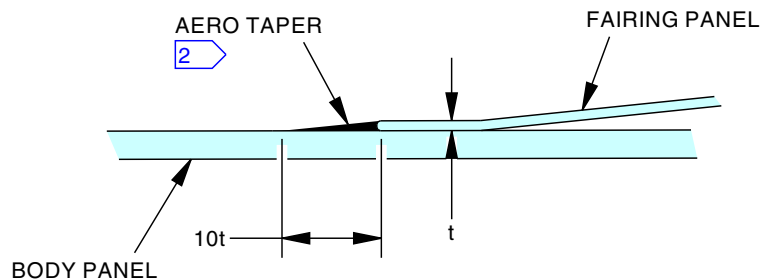


A-A



(EXAMPLE)

B-B



(EXAMPLE)

C

2532178 S0000598645_V3

Wing-to-Body Fairing Seal Requirements
Figure 403/53-51-21-990-803 (Sheet 2 of 4)

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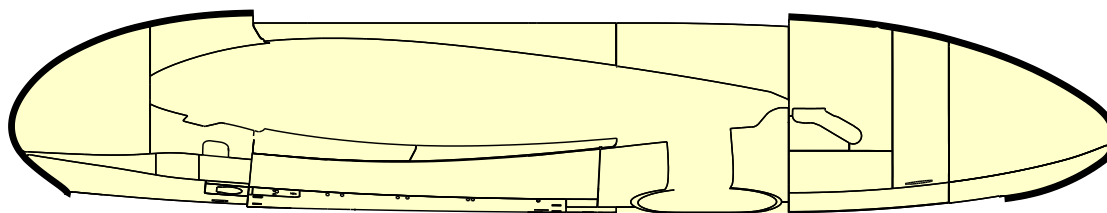
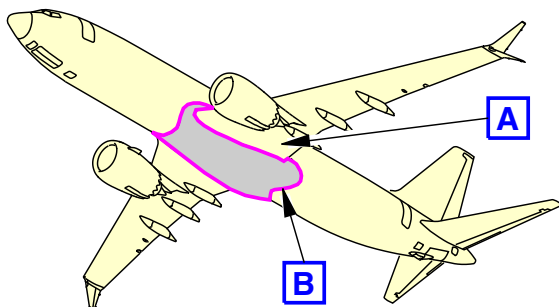
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A

2852081 S0000668643_V1

Wing-to-Body Fairing Seal Requirements
Figure 403/53-51-21-990-803 (Sheet 3 of 4)

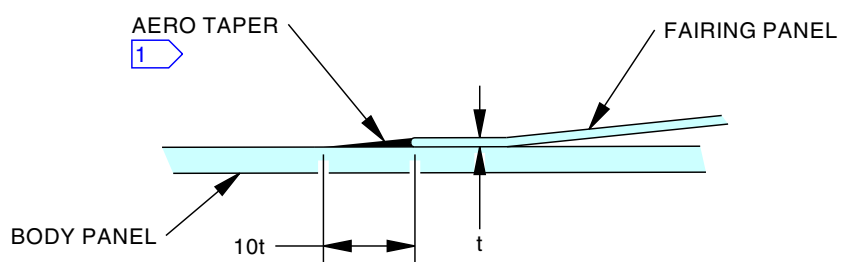
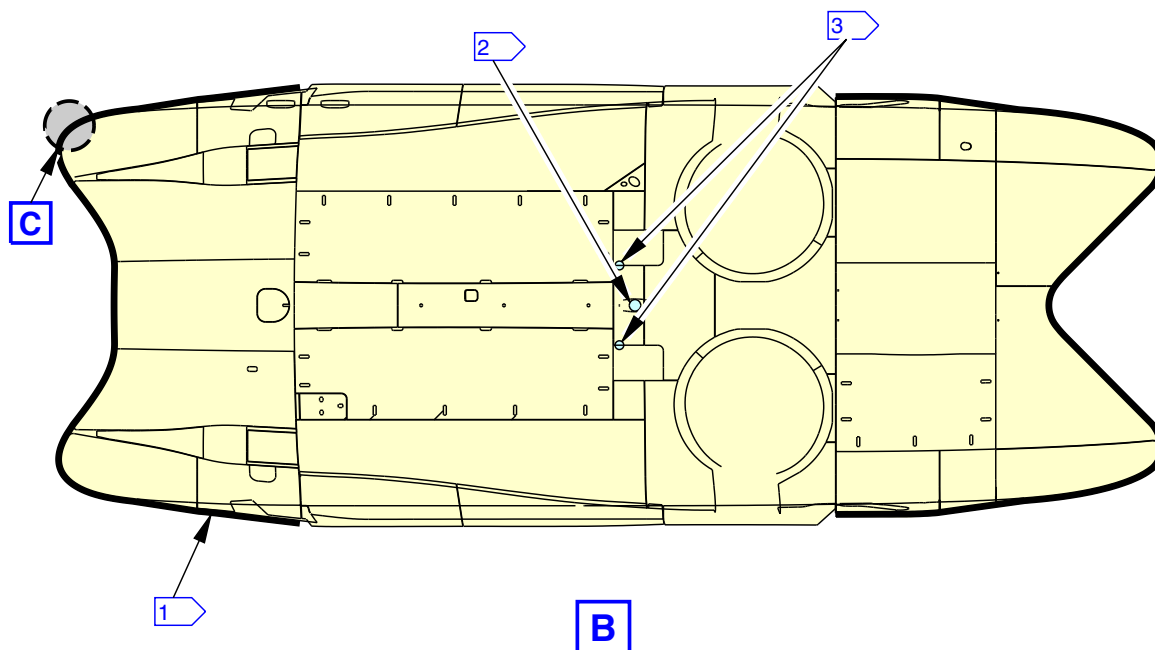
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(EXAMPLE)

C

NOTE:

- 1** APPLY BMS 5-95.
- 2** NO SEAL REQUIRED UNDER LIGHT ASSEMBLY.
- 3** DO NOT APPLY SEALANT OVER THE DRAIN PATH GAP.

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Wing-to-Body Fairing Seal Requirements
Figure 403/53-51-21-990-803 (Sheet 4 of 4)

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TASK 53-51-21-400-801

3. **Forward Wing-To-Body Fairing Panel - Installation**

(Figure 401)

A. General

(1) This task gives the instructions to install the forward wing-to-body fairing panel.

B. References

Reference	Title
21-51	PACK FLOW CONTROL AND PACK COOLING SYSTEM
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
51-21-81 P/B 701	ABRASION-RESISTANT TEFLON FINISH - CLEANING/PAINTING
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
53-51-21-211-801	Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection (P/B 601)
53-51-21-760-801	Wing-To-Body Fairing Panel Maximum Electrical Resistance Check (P/B 601)
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
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

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Reference	Description	Specification
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00304	Coating - Teflon Filled, Non Decorative, Sprayable Material	BMS10-86 Type I
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
C50149	Coating - Teflon Filled, Non Decorative, Brushable or Sprayable Material	BMS10-86 Type II
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Access panel, 191AR	53-51-00-14-035	SIA ALL
2	Access panel, 191BR	53-51-51-04-035	SIA ALL
3	Access panel, 191CR	53-51-51-04-185	SIA ALL
4	Access panel, 191D	53-51-51-04-260	SIA ALL
5	Access panel, 191CL	53-51-51-04-130	SIA ALL
6	Access panel, 191BL	53-51-51-04-030	SIA ALL
7	Access panel, 191AL	53-51-00-14-030	SIA ALL
8	Access panel, 191GL	53-51-00-14-121	SIA ALL
9	Access panel, 191FL	53-51-00-14-130	SIA ALL
10	Access panel, 191HL	53-51-51-04-085	SIA ALL
11	Access panel, 191E	53-51-51-04-250	SIA ALL
12	Access panel, 191HR	53-51-51-04-090	SIA ALL
13	Access panel, 191FR	53-51-00-14-135	SIA ALL
14	Access panel, 191GR	53-51-00-14-126	SIA ALL

F. Location Zones

Zone	Area
191	Lower Wing-To-Body Fairing - Forward of Wing Box

G. Access Panels

Number	Name/Location
191AL	Forward Wing-To-Body Fairing Panel - Upper
191AR	Forward Wing-To-Body Fairing Panel - Upper
191BL	Forward Wing-To-Body Fairing Panel, Ram Air Inlet
191BR	Forward Wing-To-Body Fairing Panel, Ram Air Inlet
191CL	Forward Wing-To-Body Fairing Panel - Middle
191CR	Forward Wing-To-Body Fairing Panel - Middle
191D	Forward Wing-To-Body Fairing Panel - Lower
191E	Low Pressure ECS Panel - Forward
191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191GL	Ram Air Actuator Panel - Forward
191GR	Ram Air Actuator Panel - Forward

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(Continued)

Number	Name/Location

191HL	Ram Air Inlet Lip Panel - Forward

191HR	Ram Air Inlet Lip Panel - Forward

H. Prepare for the Installation

SUBTASK 53-51-21-160-002

- (1) Make sure that the mating surfaces between the panel and structure are free from contamination.

NOTE: The mating structure surface has Teflon and does not cause contamination. It is not necessary to remove the Teflon.

SUBTASK 53-51-21-210-001

- (2) Make sure that the Teflon mating structure surface is in a good condition.
 - (a) If it is necessary, repair the Teflon coating on the structure surface.
 - 1) Apply coating, C00304 or coating, C50149 (PAGEBLOCK 51-21-81/701).
 - 2) Do not get Teflon in nutplate threads.

SUBTASK 53-51-21-210-002

- (3) Make sure that you identify the designated electrical bonds on the panel (TASK 53-51-21-211-801).

SUBTASK 53-51-21-350-001



DO NOT APPLY CORROSION-PREVENTATIVE COMPOUND TO THE BOND-BOLTS AND THEIR HOLES. THE COMPOUND PREVENTS CORRECT INSTALLATION OF THE BONDING BOLT. IF YOU DO NOT INSTALL THE BONDING BOLT CORRECTLY, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (4) Apply the corrosion preventive compound, C00308, to the flanges on the fairing that touches the structure.

NOTE: Do not apply the compound to the fastener holes for bonding bolts.

SUBTASK 53-51-21-350-003

- (5) Apply the corrosion inhibiting compound, G00009, to the area on the structure and body skin which touches the fairing.
 - (a) If it is necessary, refer to the STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

I. Forward Wing-To-Body Fairing Panel Installation

SUBTASK 53-51-21-420-001

- (1) Install the bolts [15] that do not have a designated electrical bond on the applicable fairing panel.
 - (a) If it is necessary, apply primer, C00259, to the fastener holes in the structure.

NOTE: Do not apply primer on fastener holes with designated electrical bonding.
 - (b) Let the primer dry.
 - (c) Put the panel in its position.
 - 1) Install the bolts [15] that do not have a designated electrical bond for access panel, 191AL [7].

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Close this access panel:

<u>Number</u>	<u>Name/Location</u>

191AL	Forward Wing-To-Body Fairing Panel - Upper

- 2) Install the bolts [15] that do not have a designated electrical bond for access panel, 191AR [1].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

191AR	Forward Wing-To-Body Fairing Panel - Upper

- 3) Install the bolts [15] that do not have a designated electrical bond for access panel, 191BL [6].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

191BL	Forward Wing-To-Body Fairing Panel, Ram Air Inlet

- 4) Install the bolts [15] that do not have a designated electrical bond for access panel, 191BR [2].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

191BR	Forward Wing-To-Body Fairing Panel, Ram Air Inlet

- 5) Install the bolts [15] that do not have a designated electrical bond for access panel, 191CL [5].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

191CL	Forward Wing-To-Body Fairing Panel - Middle

- 6) Install the bolts [15] that do not have a designated electrical bond for access panel, 191CR [3].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

191CR	Forward Wing-To-Body Fairing Panel - Middle

- 7) Install the bolts [15] that do not have a designated electrical bond for access panel, 191D [4].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

191D	Forward Wing-To-Body Fairing Panel - Lower

- 8) Install the bolts [15] that do not have a designated electrical bond for access panel, 191E [11].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

191E	Low Pressure ECS Panel - Forward

- 9) Install the bolts [15] that do not have a designated electrical bond for access panel, 191FL [9].

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Close this access panel:

<u>Number</u>	<u>Name/Location</u>

191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

- 10) Install the bolts [15] that do not have a designated electrical bond for access panel, 191FR [13].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

- 11) Install the bolts [15] that do not have a designated electrical bond for access panel, 191GL [8].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

191GL	Ram Air Actuator Panel - Forward

- 12) Install the bolts [15] that do not have a designated electrical bond for access panel, 191GR [14].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

191GR	Ram Air Actuator Panel - Forward

- 13) Install the bolts [15] that do not have a designated electrical bond for access panel, 191HL [10].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

191HL	Ram Air Inlet Lip Panel - Forward

- 14) Install the bolts [15] that do not have a designated electrical bond for access panel, 191HR [12].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

191HR	Ram Air Inlet Lip Panel - Forward

SUBTASK 53-51-21-420-002



INSTALL THE BONDING BOLTS IN THE SAME FASTENER HOLES THAT YOU REMOVED THEM FROM. BONDING BOLTS CAN HELP TO PREVENT LIGHTNING DAMAGE. LIGHTNING CAN CAUSE DAMAGE TO THE AIRPLANE.

- (2) Install the bonding bolts [16] and dimpled washers [17] in the designated bonding fastener holes.

SUBTASK 53-51-21-760-001

- (3) Measure the electrical bonding resistance between each bonding bolt [16] and fairing panel with a digital/analog multimeter, COM-1793 (TASK 53-51-21-760-801, SWPM 20-20-00).
- (a) Make sure that the resistance for each bonding bolt [16] is not more than 300,000 ohms for these access panels:

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- In Zone 191: 191HL, 191BL, 191HR, 191BR, 191AL, 191AR, 191FL, 191FR, 191GL, 191GR, 191HL, 191HR.
- (b) Make sure that the resistance for each bonding bolt [16] is not more than 10 ohms for these access panels:
 - In Zone 191: 191D, 191CR, 191CL
- (c) Make sure that the resistance for each bonding jumper is not more than 0.5 ohms for this access panel:
 - In Zone 191: 191E

SUBTASK 53-51-21-210-003

- (4) Make sure that the distance between panels is in tolerance.
- (a) Measure the misfair between the fairing panels.
- 1) If you install access panels 191BL or 191BR, make sure that there is no misfair between the panels and adjacent panels.
NOTE: These panels make a recess for the Ram Air inlet.
 - 2) If you install access panels 191AL or 191AR, make sure that the misfair for the trailing edge is between 0.07 in. (1.78 mm) and -0.03 in. (-0.76 mm).
NOTE: The trailing edge will be against panel 195AL or 195AR.
 - 3) For all other access panels, make sure that the misfair is less than or equal to 0.04 in. (1.02 mm).
- (b) Measure the clearance between the fairing panels.
- 1) Make sure that the clearance between the panels is 0.1400 $\pm$ 0.0600 in. (3.556 $\pm$ 1.524 mm).
NOTE: For these fairing panels: 191CL, 191CR, 191D, 191HL, 191HR.
 - 2) If you install access panels 191AL or 191AR, make sure that the clearance for the trailing edge is 0.1000 $\pm$ 0.0600 in. (2.5400 $\pm$ 1.5240 mm).
NOTE: The trailing edge will be against panel 195AL or 195AR.

SUBTASK 53-51-21-210-018

- (5) Measure the clearance between the fairing panel and airplane skin.
- (a) Make sure that the clearance between access panel, 191FR [13] (access panel, 191FL [9]), and airplane skin is 0.1000 $\pm$ 0.0600 in. (2.5400 $\pm$ 1.5240 mm).

SUBTASK 53-51-21-210-020

- (6) Measure the clearance between the fairing panel and leading edge flap.
- (a) Make sure that the clearance between the access panel, 191FR [13] (access panel, 191FL [9]), and leading edge of the leading edge flap is 0.5100 $\pm$ 0.0600 in. (12.9540 $\pm$ 1.5240 mm).
- (b) Make sure that the clearance between the access panel, 191FR [13] (access panel, 191FL [9]), and other edges of the leading edge flap is 0.0900 $\pm$ 0.0600 in. (2.2860 $\pm$ 1.5240 mm).

SUBTASK 53-51-21-210-004

- (7) Measure the flushness between the bolts and fairing panel.
- (a) Make sure that the distance between the bolts and fairing panel is between 0.000 $\pm$ 0.005 in. (0.000 $\pm$ 0.127 mm).

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SUBTASK 53-51-21-390-010

- (8) Apply sealant, A50359, to make an aerodynamic seal as shown in the Figure 403 (TASK 51-22-00-390-809).

NOTE: This makes an aerodynamic and weather seal.

- (a) Do not apply sealant on the access doors.

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SUBTASK 53-51-21-390-003

- (9) Apply sealant, A50231, or sealant, A00247, to make an aerodynamic seal where the panels touch the airplane skin (Figure 403).

J. Put the Airplane Back to Its Usual Condition

SUBTASK 53-51-21-410-001

- (1) Connect or install the equipment to the fairing.

SUBTASK 53-51-21-710-001

- (2) Do an operational test for the disconnected or removed equipment:
(a) Ram air intake (SECTION 21-51).

————— **END OF TASK** —————

TASK 53-51-21-000-802

4. Center Wing-To-Body Fairing Panel (Except 192AL, 192AR, 192HL, 192HR, 195BL, 195BR)

Removal

(Figure 404 and Figure 405)

A. General

- (1) This task gives the instructions to remove the center Wing-To-Body fairing panel.
- (2) This task is only applicable for these access panels:
- In Zone 192: 192BL, 192BR, 192CL, 192CR, 192E, 192F, 192G, 192JL, 192JR, 192K
 - In Zone 193: 193AL, 193AR, 193B, 193CL, 193CR, 193D, 193EL, 193ER
 - In Zone 195: 195AL, 195CL
 - In Zone 196: 195AR, 195CR.

B. References

Reference	Title
33-44-02 P/B 201	LOWER ANTI-COLLISION LIGHT - MAINTENANCE PRACTICES
33-44-02-960-802	Lower Anti-Collision Light - Light Assembly Replacement (P/B 201)
33-44-02-960-807	Lower Anti-Collision Light - LED Light Assembly Replacement (P/B 201)
34-32-11 P/B 401	MARKER BEACON ANTENNA - REMOVAL/INSTALLATION
34-55-11 P/B 401	DME ANTENNA - REMOVAL/INSTALLATION
51-22-00-160-801	Prepare For Sealing (P/B 201)
52-48-42-000-801	Environmental Control Systems (ECS) Access Door Removal (P/B 401)

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Reference	Title
53-51-21-211-801	Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection (P/B 601)
SRM 51-40-02	FASTENER INSTALLATION AND REMOVAL

C. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box
193	Lower Wing-To-Body Fairing - Wheel Well
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

D. Access Panels

Number	Name/Location
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
192G	Sump Drain Access Door
192JL	Air Conditioning Panel - Aft
192JR	Air Conditioning Panel - Aft
192K	Air Conditioning Under Keel Panel - Aft
193AL	Wheel Well Panel - Forward Outboard
193AR	Wheel Well Panel - Forward Outboard
193B	Wheel Well Panel - Forward Inboard
193CL	Wheel Well Panel - Aft Outboard
193CR	Wheel Well Panel - Aft Outboard
193D	Wheel Well Panel - Aft Inboard
193EL	Access Panel - Aft Wheel Well
193ER	Access Panel - Aft Wheel Well
195AL	Wing-To-Body Fairing - Left Side
195AR	Wing-To-Body Fairing - Right Side
195CL	Wing-To-Body Fairing - Left Side
195CR	Wing-To-Body Fairing - Right Side

E. Prepare for the Removal

SUBTASK 53-51-21-010-001

- (1) If it is necessary, remove or disconnect the applicable equipment that is attached to the fairing:
 - (a) DME Antennas (PAGEBLOCK 34-55-11/401).
 - (b) Marker Beacon Antenna (PAGEBLOCK 34-32-11/401).
 - (c) Anti-Collision Light (PAGEBLOCK 33-44-02/201).

F. Center Wing-To-Body Fairing Panel Removal

SUBTASK 53-51-21-160-003

- (1) Remove sealant from the edge of the applicable panel.

NOTE: You can remove a section of the fillet seal (TASK 51-22-00-160-801).

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SUBTASK 53-51-21-020-003

- (2) To remove the ECS Access Doors (192CL or 192CR) or the ECS High Pressure Access Door (192DR), do this task: Environmental Control Systems (ECS) Access Door Removal, TASK 52-48-42-000-801.

SUBTASK 53-51-21-020-009

- (3) To remove the access panel, 193B [34], or access panel, 192K [36], remove the lower anti-collision light assembly (TASK 33-44-02-960-807 or TASK 33-44-02-960-802).

SUBTASK 53-51-21-020-004

- (4) Do these steps to remove the applicable fairing panels:
- (a) Make sure that you hold the fairing panel until all the fasteners have been removed.
 - (b) Make sure that you identify the bolts [15], bonding bolts [16] and dimpled washers [17] to install them in the same locations.
 - 1) Make sure that you identify the bonding bolts [16] and dimpled washers [17] for electrical bonding (TASK 53-51-21-211-801).
 - (c) Zone 192:
 - 1) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 192BL [30].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
 - 2) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 192BR [42].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
 - 3) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 192E [43].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
192E	ECS Under Keel Panel - Forward
 - 4) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 192F [28].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
192F	ECS Under Keel Panel - Middle
 - 5) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 192G [26].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
192G	Sump Drain Access Door
 - 6) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 192JL [33]

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Open this access panel:

<u>Number</u>	<u>Name/Location</u>
192JL	Air Conditioning Panel - Aft

- 7) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 192JR [39].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
192JR	Air Conditioning Panel - Aft

- 8) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 192K [36].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
192K	Air Conditioning Under Keel Panel - Aft

(d) Zone 193:

- 1) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 193AL [31].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
193AL	Wheel Well Panel - Forward Outboard

- 2) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 193AR [38].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
193AR	Wheel Well Panel - Forward Outboard

- 3) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 193B [34].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
193B	Wheel Well Panel - Forward Inboard

- 4) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 193CL [32].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
193CL	Wheel Well Panel - Aft Outboard

- 5) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 193CR [37].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
193CR	Wheel Well Panel - Aft Outboard

- 6) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 193D [35].

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Open this access panel:

<u>Number</u>	<u>Name/Location</u>
193D	Wheel Well Panel - Aft Inboard

- 7) To open access panel, 193EL [65], do these steps (View A-A, Figure 404):
- Remove the rivets [67] (SRM SUBJECT 51-40-02).
 - Remove the bolts [68], washers [69], bonding bolts [70], bolts [71], washers [72], and nuts [73].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
193EL	Access Panel - Aft Wheel Well

- 8) To open access panel, 193ER [66], do these steps (View A-A, Figure 404):
- Remove the rivets [67] (SRM SUBJECT 51-40-02).
 - Remove the bolts [68], washers [69], bonding bolts [70], bolts [71], washers [72], and nuts [73].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
193ER	Access Panel - Aft Wheel Well

(e) Zone 195:

- 1) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 195AL [20].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
195AL	Wing-To-Body Fairing - Left Side

- 2) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 195CL [24].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
195CL	Wing-To-Body Fairing - Left Side

(f) Zone 196:

- 1) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 195AR [21].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
195AR	Wing-To-Body Fairing - Right Side

- 2) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 195CR [23].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
195CR	Wing-To-Body Fairing - Right Side

(g) Remove the fairing panel from the airplane.

———— **END OF TASK** ————

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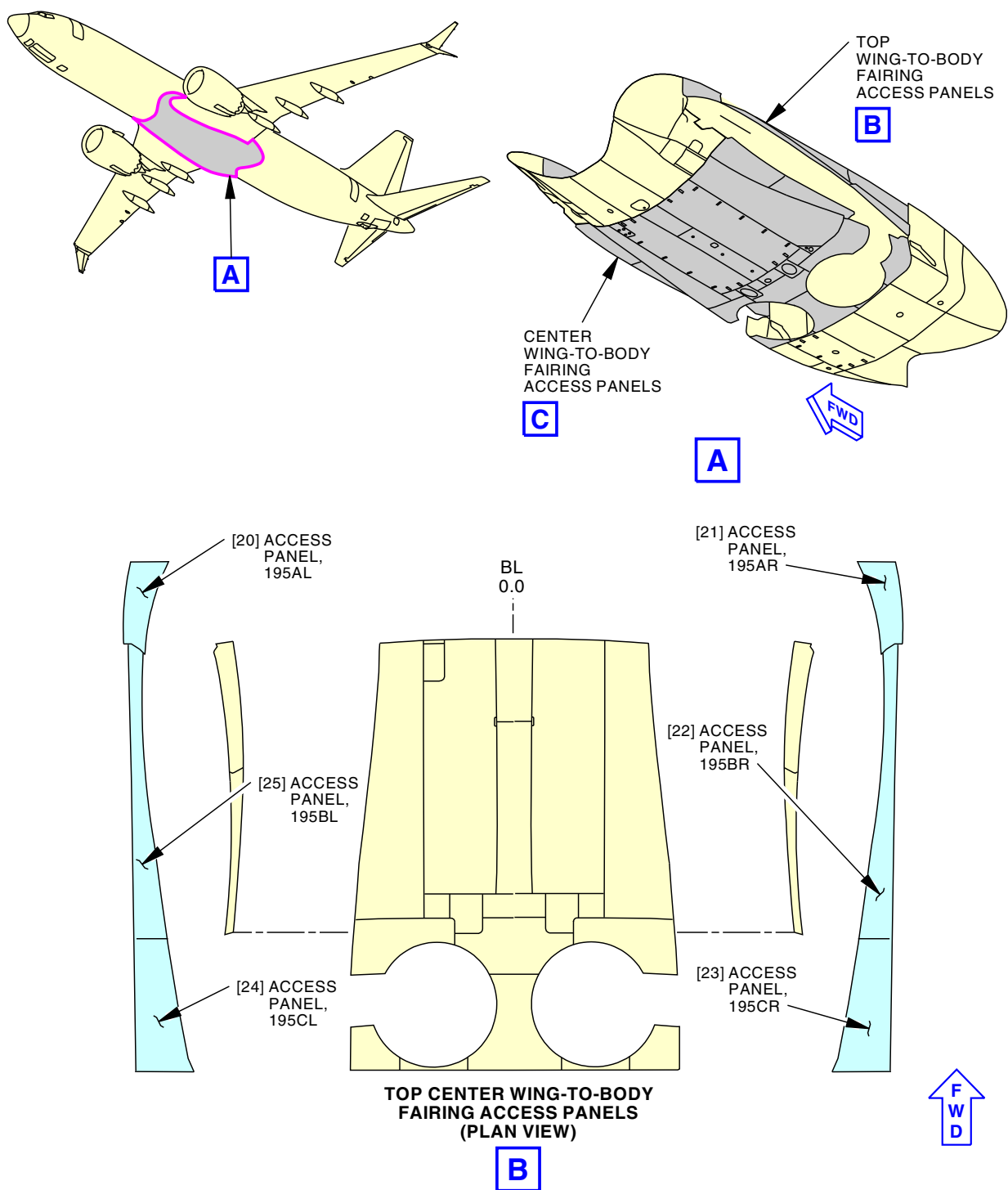
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2416184 S00061539927_V3

Center Wing-To-Body Fairing Panels
Figure 404/53-51-21-990-804 (Sheet 1 of 3)

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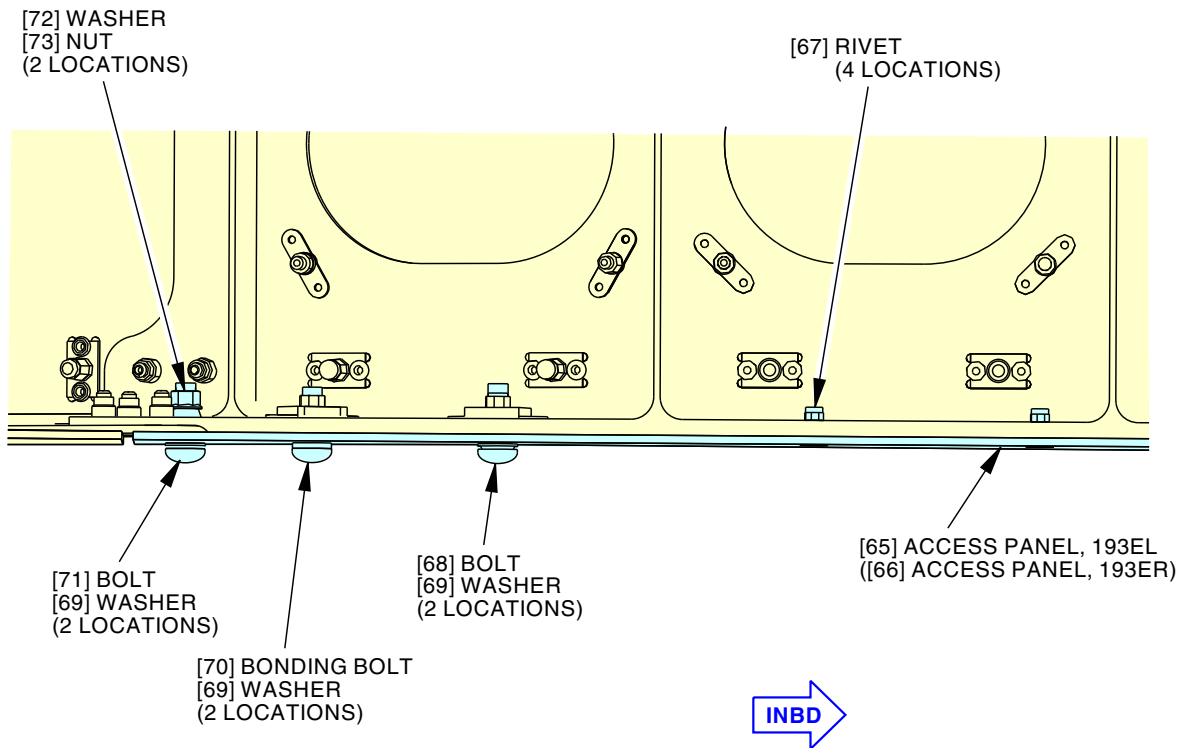


2416185 S00061539928_V3

Center Wing-To-Body Fairing Panels
Figure 404/53-51-21-990-804 (Sheet 2 of 3)

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A-A

2978198 S0000756270_V1

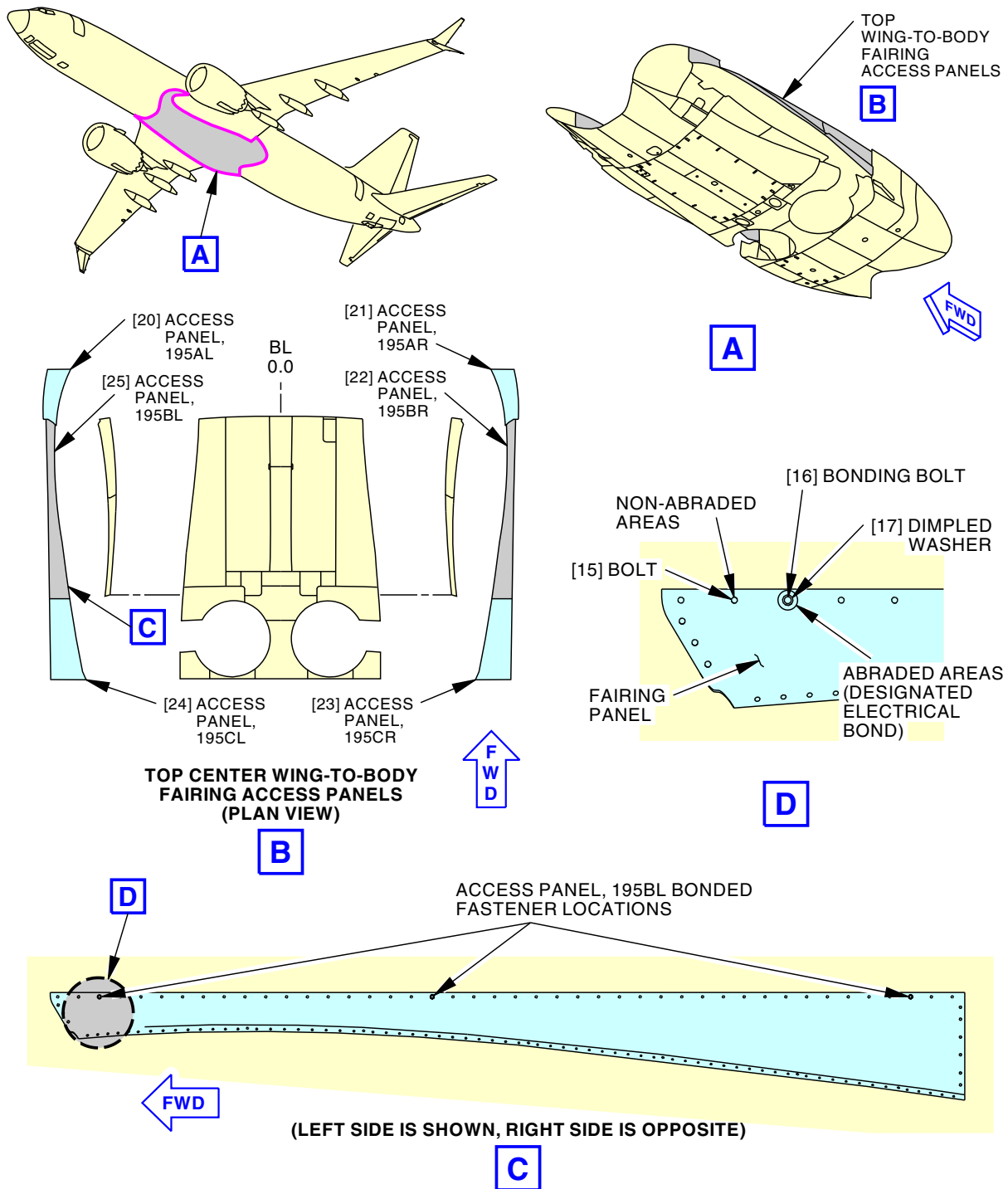
Center Wing-To-Body Fairing Panels
Figure 404/53-51-21-990-804 (Sheet 3 of 3)

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2547206 S0000605850_V5

Upper Wing-to-Body Fairing Panels - Bonding Fasteners
Figure 405/53-51-21-990-809

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TASK 53-51-21-400-802

5. **Center Wing-To-Body Fairing Panel (Except 192AL, 192AR, 192HL, 192HR, 195BL, 195BR) - Installation**

(Figure 403, Figure 404, and Figure 405)

A. General

- (1) This task gives the instructions to install the center Wing-To-Body fairing panel.
- (2) This task is only applicable for these access panels:
 - In Zone 192: 192BL, 192BR, 192CL, 192CR, 192E, 192F, 192G, 192JL, 192JR, 192K
 - In Zone 193: 193AL, 193AR, 193B, 193CL, 193CR, 193D, 193EL, 193ER
 - In Zone 195: 195AL, 195CL
 - In Zone 196: 195AR, 195CR.

B. References

Reference	Title
33-44-02 P/B 201	LOWER ANTI-COLLISION LIGHT - MAINTENANCE PRACTICES
33-44-02-960-802	Lower Anti-Collision Light - Light Assembly Replacement (P/B 201)
33-44-02-960-807	Lower Anti-Collision Light - LED Light Assembly Replacement (P/B 201)
34-32-11 P/B 401	MARKER BEACON ANTENNA - REMOVAL/INSTALLATION
34-55-11 P/B 401	DME ANTENNA - REMOVAL/INSTALLATION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
51-21-81 P/B 701	ABRASION-RESISTANT TEFLON FINISH - CLEANING/PAINTING
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
52-48-42-400-801	Environmental Control Systems (ECS) Access Door Installation (P/B 401)
53-51-21-211-801	Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection (P/B 601)
53-51-21-760-801	Wing-To-Body Fairing Panel Maximum Electrical Resistance Check (P/B 601)
SRM 51-40-02	FASTENER INSTALLATION AND REMOVAL

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
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
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
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00304	Coating - Teflon Filled, Non Decorative, Sprayable Material	BMS10-86 Type I
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
C00767	Coating - Anti-Static Coating	BMS10-21 Type III
C50149	Coating - Teflon Filled, Non Decorative, Brushable or Sprayable Material	BMS10-86 Type II
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
20	Access panel, 195AL	53-51-51-10-105	SIA ALL
21	Access panel, 195AR	53-51-51-10-110	SIA ALL
23	Access panel, 195CR	53-51-51-10-280	SIA ALL
24	Access panel, 195CL	53-51-51-10-275	SIA ALL
26	Access panel, 192G	53-12-11-01-190	SIA ALL
28	Access panel, 192F	53-12-11-01-195	SIA ALL
30	Access panel, 192BL	53-51-02-01-250	SIA ALL
31	Access panel, 193AL	53-51-51-02-230	SIA ALL

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AMM Item	Description	AIPC Reference	AIPC Effectivity
32	Access panel, 193CL	53-51-51-02-290	SIA ALL
33	Access panel, 192JL	53-51-21-01-045	SIA ALL
34	Access panel, 193B	53-51-51-02-325	SIA ALL
35	Access panel, 193D	53-51-51-02-345	SIA ALL
36	Access panel, 192K	53-12-11-01-240	SIA ALL
37	Access panel, 193CR	53-51-51-02-295	SIA ALL
38	Access panel, 193AR	53-51-51-02-135	SIA ALL
39	Access panel, 192JR	53-51-21-01-125	SIA ALL
42	Access panel, 192BR	53-51-02-02-175	SIA ALL
43	Access panel, 192E	53-12-11-01-005	SIA ALL
65	Access panel, 193EL	53-51-51-02-235	SIA ALL
66	Access panel, 193ER	53-51-51-02-240	SIA ALL

F. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box
193	Lower Wing-To-Body Fairing - Wheel Well
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

G. Access Panels

Number	Name/Location
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
192G	Sump Drain Access Door
192JL	Air Conditioning Panel - Aft
192JR	Air Conditioning Panel - Aft
192K	Air Conditioning Under Keel Panel - Aft
193AL	Wheel Well Panel - Forward Outboard
193AR	Wheel Well Panel - Forward Outboard
193B	Wheel Well Panel - Forward Inboard
193CL	Wheel Well Panel - Aft Outboard
193CR	Wheel Well Panel - Aft Outboard
193D	Wheel Well Panel - Aft Inboard
193EL	Access Panel - Aft Wheel Well
193ER	Access Panel - Aft Wheel Well
195AL	Wing-To-Body Fairing - Left Side
195AR	Wing-To-Body Fairing - Right Side
195CL	Wing-To-Body Fairing - Left Side
195CR	Wing-To-Body Fairing - Right Side

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H. Prepare for the Installation

SUBTASK 53-51-21-160-004

- (1) Make sure that the mating surfaces between the panel and structure are free from contamination.

NOTE: The mating structure surface has Teflon and does not cause contamination. It is not necessary to remove the Teflon.

SUBTASK 53-51-21-210-005

- (2) Make sure that the Teflon mating structure surface is in a good condition.
 - (a) If it is necessary, repair the Teflon coating on the structure surface.
 - 1) Apply coating, C00304 or coating, C50149 (PAGEBLOCK 51-21-81/701).
 - 2) Do not get Teflon in nutplate threads.

SUBTASK 53-51-21-210-006

- (3) Make sure that the designated electrical bonds are identified on the panel (TASK 53-51-21-211-801).

SUBTASK 53-51-21-350-004



DO NOT APPLY CORROSION-PREVENTATIVE COMPOUND TO THE BOND-BOLTS AND THEIR HOLES. THE COMPOUND PREVENTS CORRECT INSTALLATION OF THE BONDING BOLT. IF YOU DO NOT INSTALL THE BONDING BOLT CORRECTLY, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (4) Apply corrosion preventive compound, C00308, to the flanges on the fairing that touches the structure.

NOTE: Do not apply the compound to the fastener holes for bonding bolts.

SUBTASK 53-51-21-350-006

- (5) Apply corrosion inhibiting compound, G00009, to the area on the structure and body skin that touches the fairing.
 - (a) If it is necessary, refer to the STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

I. Center Wing-To-Body Fairing Panels Installation

SUBTASK 53-51-21-420-003

- (1) To install the ECS Access Doors (192CL or 192CR) or ECS High Pressure Access Door (192DR), do this task: Environmental Control Systems (ECS) Access Door Installation, TASK 52-48-42-400-801.

SUBTASK 53-51-21-420-004

- (2) Install the bolts that do not have a designated electrical bond on the applicable panel.
 - (a) If it is necessary, apply primer, C00259, to the fastener hole areas in the structure.

NOTE: Do not apply primer on fastener holes with designated electrical bonding.
 - (b) Let the primer dry.
 - (c) Apply corrosion inhibiting material, G50136, to all areas of the holes and immediately install the bolts.
 - (d) Put the panel into its position.
 - 1) Zone 192:
 - a) Install the bolts [15] that do not have a designated electrical bond for access panel, 192BL [30].

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Close this access panel:

<u>Number</u>	<u>Name/Location</u>

192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward

- b) Install the bolts [15] that do not have a designated electrical bond for access panel, 192BR [42].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward

- c) Install the bolts [15] that do not have a designated electrical bond for access panel, 192E [43].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

192E	ECS Under Keel Panel - Forward

- d) Install the bolts [15] that do not have a designated electrical bond for access panel, 192F [28].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

192F	ECS Under Keel Panel - Middle

- e) Install the bolts [15] that do not have a designated electrical bond for access panel, 192G [26].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

192G	Sump Drain Access Door

- f) Install the bolts [15] that do not have a designated electrical bond for access panel, 192JL [33].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

192JL	Air Conditioning Panel - Aft

- g) Install the bolts [15] that do not have a designated electrical bond for access panel, 192JR [39].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

192JR	Air Conditioning Panel - Aft

- h) Install the bolts [15] that do not have a designated electrical bond for access panel, 192K [36].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

192K	Air Conditioning Under Keel Panel - Aft

2) Zone 193:

- a) Install the bolts [15] that do not have a designated electrical bond for access panel, 193AL [31].

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Close this access panel:

<u>Number</u>	<u>Name/Location</u>

193AL	Wheel Well Panel - Forward Outboard

- b) Install the bolts [15] that do not have a designated electrical bond for access panel, 193AR [38].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

193AR	Wheel Well Panel - Forward Outboard

- c) Install the bolts [15] that do not have a designated electrical bond for access panel, 193B [34].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

193B	Wheel Well Panel - Forward Inboard

- d) Install the bolts [15] that do not have a designated electrical bond for access panel, 193CL [32].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

193CL	Wheel Well Panel - Aft Outboard

- e) Install the bolts [15] that do not have a designated electrical bond for access panel, 193CR [37].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

193CR	Wheel Well Panel - Aft Outboard

- f) Install the bolts [15] that do not have a designated electrical bond for access panel, 193D [35].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

193D	Wheel Well Panel - Aft Inboard

- g) To close the access panel, 193EL [65], do these steps (View A-A, Figure 404):

<1> Install the bolts [68], washers [69], bolts [71], washers [72], and nuts [73].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

193EL	Access Panel - Aft Wheel Well

- h) To close the access panel, 193ER [66], do these steps (View A-A, Figure 404):

<1> Install the bolts [68], washers [69], bolts [71], washers [72], and nuts [73].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

193ER	Access Panel - Aft Wheel Well

- 3) Zone 195:

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- a) Install the bolts [15] that do not have a designated electrical bond for access panel, 195AL [20].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
195AL	Wing-To-Body Fairing - Left Side

- b) Install the bolts [15] that do not have a designated electrical bond for access panel, 195CL [24].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
195CL	Wing-To-Body Fairing - Left Side

4) Zone 196:

- a) Install the bolts [15] that do not have a designated electrical bond for access panel, 195AR [21].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
195AR	Wing-To-Body Fairing - Right Side

- b) Install the bolts [15] that do not have a designated electrical bond for access panel, 195CR [23].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
195CR	Wing-To-Body Fairing - Right Side

SUBTASK 53-51-21-420-010



INSTALL THE BONDING BOLTS IN THE SAME FASTENER HOLES THAT YOU REMOVED THEM FROM. BONDING BOLTS CAN HELP TO PREVENT LIGHTNING DAMAGE. LIGHTNING CAN CAUSE DAMAGE TO THE AIRPLANE.

- (3) Install the bonding bolts to the designated bonding fastener holes.
- (a) Apply anti-static coating, C00767, in the designated bonding fastener holes.
 - (b) For panels 192BL, 192BR, 193AR, 193B, 193CL, 193CR, 193D, 195AL, 195CL, 195AR, 195CR:
 - 1) Install the bonding bolts [16] and dimpled washers [17].
 - (c) For panels 193EL, 193ER:
 - 1) Install the bonding bolts [70] and washers [69].

SUBTASK 53-51-21-760-004

- (4) Measure the electrical bonding resistance for each bonding bolt [16] and dimpled washer [17] at the next hole locating on the fairing panel (TASK 53-51-21-760-801).
- (a) Use a digital/analog multimeter, COM-1793.
 - (b) Make sure that the bonding resistance for each bonding bolt [16] is 300,000 ohms or less for these access panels:
 - In Zone 192: 192BL, 192BR
 - In Zone 193: 193AR, 193B, 193CL, 193CR, 193D
 - In Zone 195: 195AL, 195CL

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- In Zone 196: 195AR, 195CR.
- (c) Make sure that the bonding resistance for each bonding jumper is 100 ohms or less for these access panels:
 - In Zone 192: 192CL, 192CR.
- (d) Make sure that the bonding resistance for each bonding bolt [16] is 10 ohms or less for these access panels:
 - In Zone 193: 193AL.
- (e) Make sure that the bonding resistance for each bonding bolt [16] is 0.5 ohm (500 milliohms) or less for these access panels:
 - In Zone 192: 192E, 192F, 192JL, 192JR, 192K.
- (f) Make sure that the bonding resistance for each bonding bolt [16] is 0.001 ohm (1 milliohm) or less for this access panel:
 - In Zone 192: 192G.

SUBTASK 53-51-21-760-005

- (5) Measure the electrical bonding resistance for each bonding bolt [70] and washer [69] at the next hole locating on the fairing panel with (TASK 53-51-21-760-801).
 - (a) Use a digital/analog multimeter, COM-1793.
 - (b) Make sure that the bonding resistance for each bonding bolt [70] is 300,000 ohms or less for these access panels:
 - In Zone 193: 193EL, 193ER.

SUBTASK 53-51-21-420-016

- (6) Install the rivets [67] for the access panel, 193EL [65] and access panel, 193ER [66] (SRM SUBJECT 51-40-02).

SUBTASK 53-51-21-210-007

- (7) Make sure that the distance between panels is in tolerance.
 - (a) Measure the misfair between the fairing panels.
 - 1) If the access panels 192CL or 192CR is installed, make sure that the misfair is less than 0.010 in. (0.254 mm).
 - 2) If the access panel 192DR is installed, make sure that the misfair is 0.00 ±0.06 in. (0.000 ±1.524 mm).
 - 3) If the access panel, 193AL [31] (access panel, 193AR [38]) or access panel, 192BL [30] (access panel, 192BR [42]) is installed, make sure that the misfair between these panels is 0.0505 +0.0400 / -0.0900 in. (1.283 +1.016 / -2.286 mm).
 - 4) If the access panel, 193AL [31] (access panel, 193AR [38]) or access panel, 192JL [33] (access panel, 192JR [39]) is installed, make sure that the misfair between these panels is 0.000 ±0.060 in. (0.00 ±1.52 mm).
 - 5) If the access panel, 195AL [20] or access panel, 195AR [21] is installed, make sure that the misfair for the leading edge is between 0.00 +0.07 / -0.03 in. (0.00 +1.78 / -0.76 mm).

NOTE: The leading edge will be against panel 191AL or 191AR.

 - 6) For all other access panels, make sure that the misfair is less than or equal to 0.04 in. (1.02 mm).
 - (b) Measure the clearance between the fairing panels.

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- 1) Make sure that the clearance between the panels is 0.1400 $\pm$ 0.0600 in. (3.5560 $\pm$ 1.5240 mm).
- 2) If the 192CL or 192CR is installed, make sure that the clearance between the two sides of each hinge is less than 0.088 in. (2.235 mm).
- 3) If the 192DR is installed, make sure that the clearance is less than 0.10 in. (2.54 mm).
- 4) If the access panel, 195AL [20] or access panel, 195AR [21] is installed, make sure that the clearance for the leading edge is 0.1000 $\pm$ 0.0600 in. (2.5400 $\pm$ 1.5240 mm).

NOTE: The leading edge will be against panel 191AL or 191AR.

SUBTASK 53-51-21-210-019

- (8) Measure the clearance between the fairing panel and airplane skin.
 - (a) Make sure that the clearance between the trailing edge of access panel, 195AR [21] (access panel, 195AL [20]) and airplane skin is 0.1050 +0.0925 / -0.0250 in. (2.6670 +2.3495 / -0.6350 mm).

SUBTASK 53-51-21-210-008

- (9) Measure the flushness between the fasteners and fairing panel.
 - (a) Make sure that the distance between the fasteners and panels is between 0.000 +0.005 / -0.010 in. (0.000 +0.127 / -0.254 mm).

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SUBTASK 53-51-21-390-011

- (10) Apply sealant, A50359, to make an aerodynamic seal (Figure 403, TASK 51-22-00-390-809).

NOTE: This makes an aerodynamic and weather seal.

- (a) Do not apply sealant on the access doors.

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SUBTASK 53-51-21-390-005

- (11) Apply sealant, A50231, or sealant, A00247, to make an aerodynamic seal where the panels touch the airplane skin (Figure 403).

J. Put the Airplane Back to Its Usual Condition

SUBTASK 53-51-21-420-017

- (1) If it is removed, install the lower anti-collision light (TASK 33-44-02-960-807 or TASK 33-44-02-960-802).

SUBTASK 53-51-21-420-006

- (2) Connect or install the equipment to the fairing.

SUBTASK 53-51-21-710-002

- (3) Do an operational test for the disconnected or removed equipment.
 - (a) DME Antennas (PAGEBLOCK 34-55-11/401).
 - (b) Marker Beacon Antenna (PAGEBLOCK 34-32-11/401).
 - (c) Anti-Collision Light (PAGEBLOCK 33-44-02/201).

———— **END OF TASK** ————

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TASK 53-51-21-000-804

6. **Center Wing-To-Body Fairing Panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) Removal**
(Figure 404, Figure 405, and Figure 406)

A. General

- (1) This task gives the instructions to remove the center Wing-To-Body fairing panel.
- (2) This task is only applicable for these access panels:
 - (a) 192AL, 192AR, 192HL, 192HR, 195BL, and 195BR.

B. References

Reference	Title
51-22-00-160-801	Prepare For Sealing (P/B 201)

C. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

D. Access Panels

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
192AR	Underwing Bolt Cover - Forward
192HL	Underwing Bolt Cover - Aft
192HR	Underwing Bolt Cover - Aft
195BL	Wing-To-Body Fairing - Left Side
195BR	Wing-To-Body Fairing - Right Side

E. Center Wing-To-Body Fairing Panel Removal

SUBTASK 53-51-21-160-007

- (1) Remove the sealant from the edge of the applicable panel.
NOTE: You can remove a section of the fillet seal (TASK 51-22-00-160-801).

SUBTASK 53-51-21-010-002

- (2) Do these steps to remove the applicable fairing panels:
 - (a) Make sure that you hold the fairing panel until all the fasteners have been removed.
 - (b) Make sure that you identify the bolts [15], bonding bolts [16] and dimpled washers [17] to install them in the same locations.
 - (c) Zone 192:
 - 1) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 192AL [27].
Open this access panel:

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
 - 2) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 192AR [41].

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Open this access panel:

<u>Number</u>	<u>Name/Location</u>
192AR	Underwing Bolt Cover - Forward

- 3) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 192HL [29].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
192HL	Underwing Bolt Cover - Aft

- 4) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 192HR [40].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
192HR	Underwing Bolt Cover - Aft

- (d) Zone 195:

- 1) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 195BL [25].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
195BL	Wing-To-Body Fairing - Left Side

- (e) Zone 196:

- 1) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 195BR [22].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
195BR	Wing-To-Body Fairing - Right Side

- (f) Remove the fairing panel from the airplane.

———— **END OF TASK** ————

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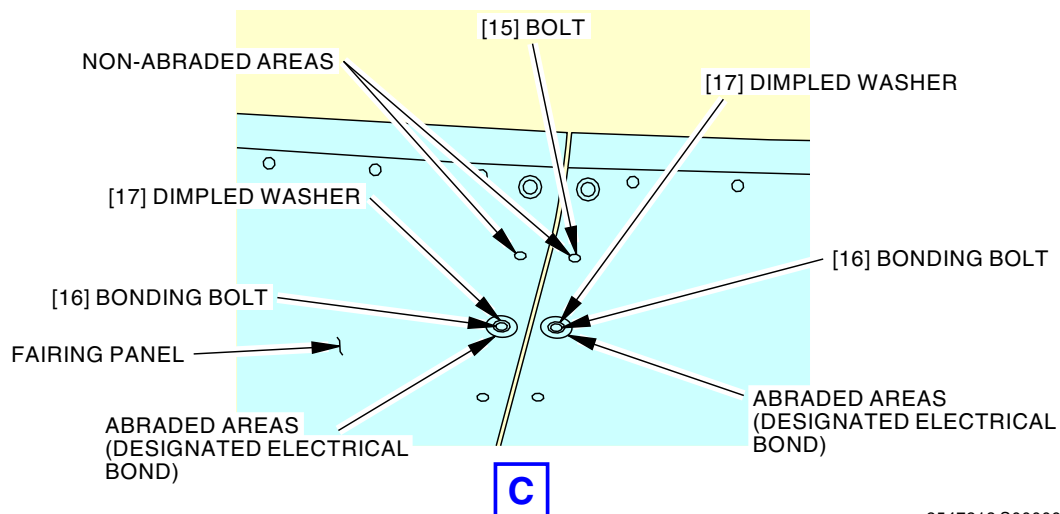
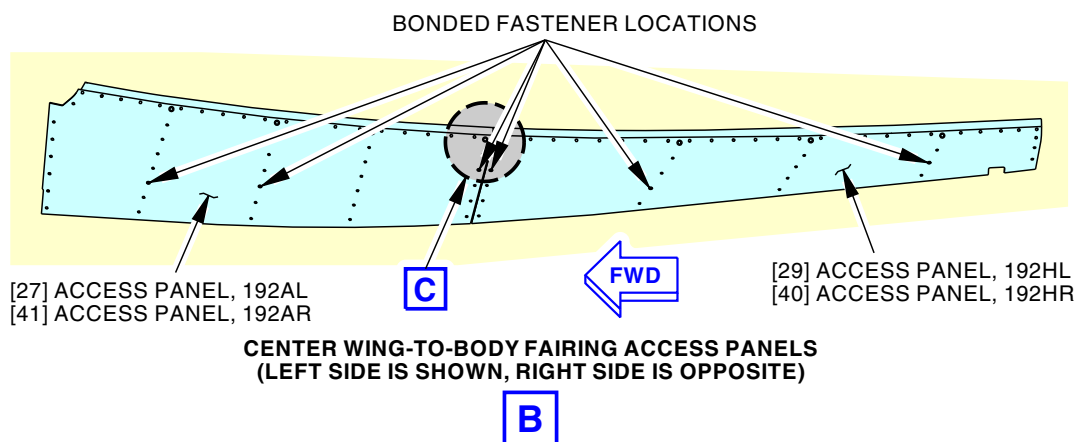
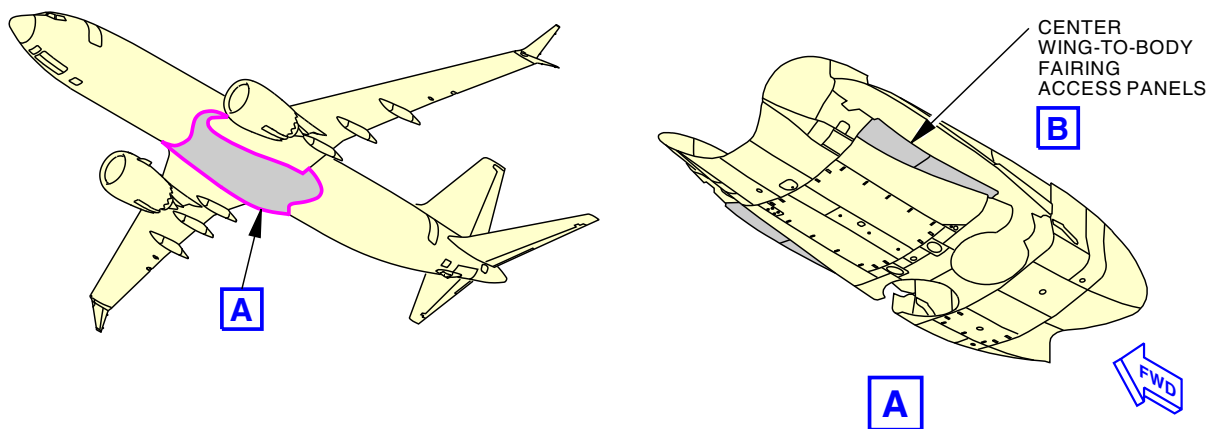
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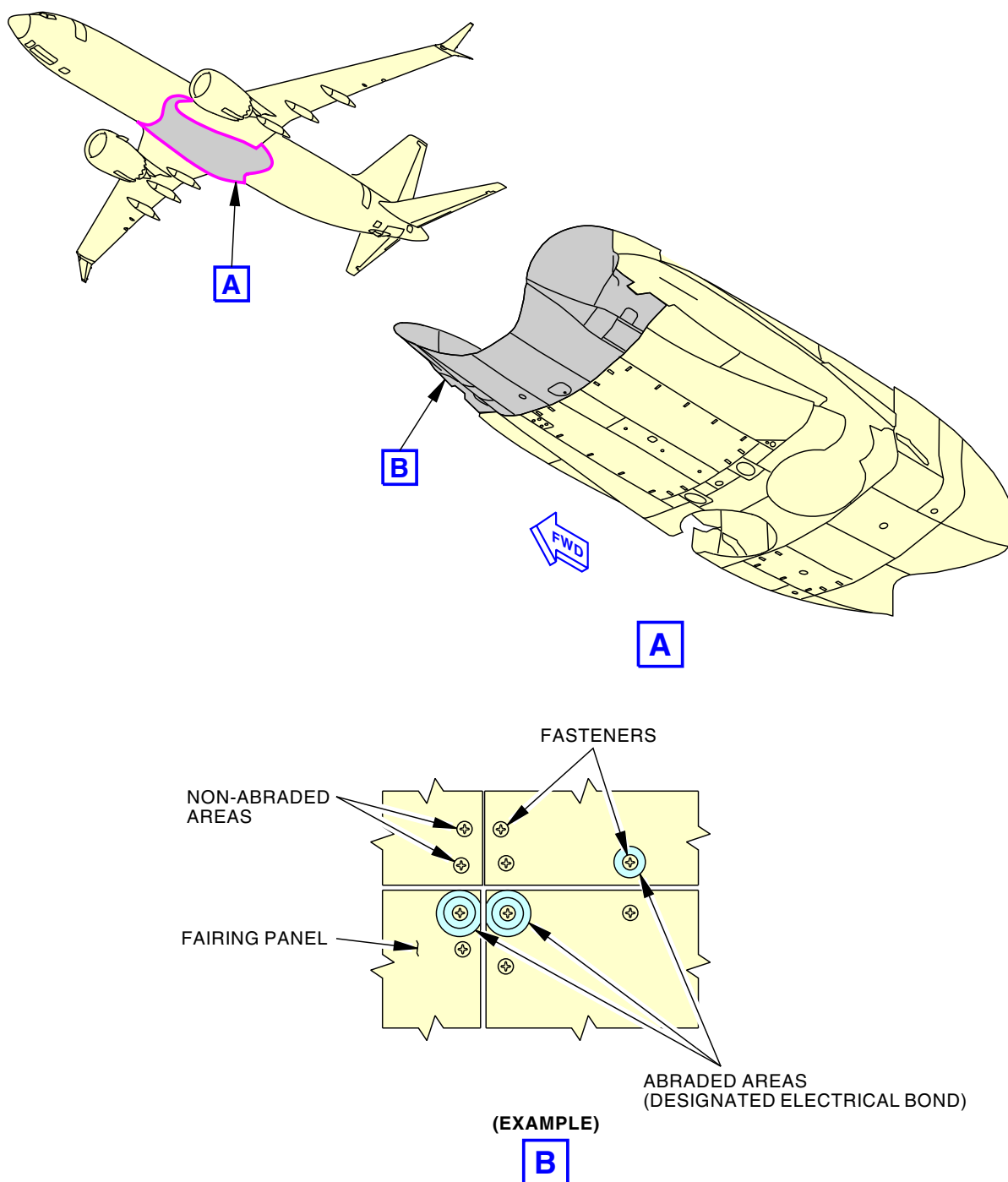
**Center Wing-to-Body Fairing Panels - Bonding Fasteners
Figure 406/53-51-21-990-807**

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Wing-To-Body Fairing Inspection
Figure 407/53-51-21-990-808

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TASK 53-51-21-400-804

7. **Center Wing-To-Body Fairing Panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) - Installation**
(Figure 403, Figure 404, Figure 405, Figure 406, and Figure 407)

A. General

- (1) This task gives the instructions to install the center Wing-To-Body fairing panel.
- (2) This task is only applicable for these access panels:
 - (a) 192AL, 192AR, 192HL, 192HR, 195BL, and 195BR.
- (3) This task has one or more steps that are a means to satisfy Critical Design Configuration Control Limitation (CDCCL) requirements. A CDCCL note will follow the step to that it applies. Any step or sub-step that precedes or follows a CDCCL identified step is not subject to the CDCCL requirement.
 - (a) For important information on CDCCL requirements, refer to this task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801.

NOTE: This is applicable to Airworthiness Limitation 53-AWL-01.

B. References

Reference	Title
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
51-21-81 P/B 701	ABRASION-RESISTANT TEFLON FINISH - CLEANING/PAINTING
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
53-00-00-912-801	Airworthiness Limitation Precautions (P/B 201)
53-51-21-760-801	Wing-To-Body Fairing Panel Maximum Electrical Resistance Check (P/B 601)
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

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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
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00304	Coating - Teflon Filled, Non Decorative, Sprayable Material	BMS10-86 Type I
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
C00767	Coating - Anti-Static Coating	BMS10-21 Type III
C00862	Coating - Chemical Conversion - Bonderite M-CR 600 Aero (Formerly Alodine 600)	BAC5719 Class A, C or D, MIL-DTL-81706 Type I Class 1A or 3
C50149	Coating - Teflon Filled, Non Decorative, Brushable or Sprayable Material	BMS10-86 Type II
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
22	Access panel, 195BR	53-51-51-10-220	SIA ALL
25	Access panel, 195BL	53-51-51-10-215	SIA ALL
27	Access panel, 192AL	53-51-02-01-075	SIA ALL
29	Access panel, 192HL	53-51-02-01-115	SIA ALL
40	Access panel, 192HR	53-51-02-02-110	SIA ALL
41	Access panel, 192AR	53-51-02-02-070	SIA ALL

F. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

G. Access Panels

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
192AR	Underwing Bolt Cover - Forward
192HL	Underwing Bolt Cover - Aft
192HR	Underwing Bolt Cover - Aft
195BL	Wing-To-Body Fairing - Left Side
195BR	Wing-To-Body Fairing - Right Side

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H. Prepare for the Installation

SUBTASK 53-51-21-160-008

- (1) Make sure that the mating surfaces between the panel and the structure are free from contamination.

NOTE: The mating structure surface has Teflon and does not cause contamination. It is not necessary to remove the Teflon.

SUBTASK 53-51-21-210-013

- (2) Make sure that the Teflon mating structure surface is in a good condition.
 - (a) If it is necessary, repair the Teflon coating on the structure surface.
 - 1) Apply coating, C00304 or coating, C50149 (PAGEBLOCK 51-21-81/701).
 - 2) Do not get Teflon in nutplate threads.

SUBTASK 53-51-21-210-014

- (3) Identify the fastener locations on each panel that have a designated electrical bond.

NOTE: There are three fasteners for each panel with a designated electrical bond.

- (a) Examine the area around each fastener hole to identify the electrical bond locations.

- 1) Locations that have an electrical bond have an abraded area in the panel around the fastener hole (Figure 407).

NOTE: It is recommended to examine the panel at the corners first. Usually, the locations are at or near the panel corners, but panel repairs can change the locations of the designated electrical bonds.

- 2) Examine all the fastener holes to identify locations with an electrical bond.

SUBTASK 53-51-21-210-015

- (4) Do these steps if the electrical bond locations are not identified after the visual inspection:

- (a) Examine the area around the fastener hole:

- 1) Locations that have an electrical bond have an abraded area in the panel around the fastener hole (Figure 407).

NOTE: It is recommended to examine the panel at the corners first. Usually, the locations are at or near the panel corners, but panel repairs can change the locations of the designated electrical bonds.

- (b) Examine the countersunk area of the fastener hole:

NOTE: The countersunk area of the panel will be below the dimpled washer.

- 1) The countersunk area for each electrically bonded fastener hole will have coating, C00767, or Bonderite M-CR 600 Aero coating, C00862.

NOTE: Non-electrical bonding locations do not have coatings in the countersunk hole.

- (c) Examine the countersunk mating surface between the dimpled washer and the panel (Figure 407).

- 1) Make sure that the surfaces without a designated electrical bond between the dimpled washer and the panel are free from contamination.

- 2) Make sure that the surfaces with a designated electrical bond between the dimpled washer and the panel are free from contamination, primer, or paint.

- (d) Do the steps again to find all the designated bond locations.

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SUBTASK 53-51-21-350-010



DO NOT APPLY CORROSION-PREVENTATIVE COMPOUND TO THE BOND-BOLTS AND THEIR HOLES. THE COMPOUND PREVENTS CORRECT INSTALLATION OF THE BONDING BOLT. IF YOU DO NOT INSTALL THE BONDING BOLT CORRECTLY, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (5) Apply corrosion preventive compound, C00308, to the flanges on the fairing that touches the structure.

NOTE: Do not apply the compound to the fastener holes for bonding bolts.

SUBTASK 53-51-21-350-012

- (6) Apply corrosion inhibiting compound, G00009, to the area on the structure and body skin that touches the fairing.
- (a) If it is necessary, refer to the STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

I. Center Wing-To-Body Fairing Panels Installation

SUBTASK 53-51-21-420-012

- (1) Install the bolts [15] that do not have a designated electrical bond on the applicable panel.

- (a) Apply primer, C00259, to the hole areas of fasteners in the structure, if it is necessary.

NOTE: Do not apply primer on fastener holes with designated electrical bonding.

- (b) Let the primer dry.
- (c) Put the panel into its position.

1) Zone 192:

- a) Install the bolts [15] that do not have a designated electrical bond for access panel, 192AL [27].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

192AL	Underwing Bolt Cover - Forward

- b) Install the bolts [15] that do not have a designated electrical bond for access panel, 192AR [41].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

192AR	Underwing Bolt Cover - Forward

- c) Install the bolts [15] that do not have a designated electrical bond for access panel, 192HL [29].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

192HL	Underwing Bolt Cover - Aft

- d) Install the bolts [15] that do not have a designated electrical bond for access panel, 192HR [40].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>

192HR	Underwing Bolt Cover - Aft

2) Zone 195:

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- a) Install the bolts [15] that do not have a designated electrical bond for access panel, 195BL [25].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
195BL	Wing-To-Body Fairing - Left Side

- 3) Zone 196:

- a) Install the bolts [15] that do not have a designated electrical bond for access panel, 195BR [22].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
195BR	Wing-To-Body Fairing - Right Side

SUBTASK 53-51-21-420-013

 53-AWL-01: CDCCL

- (2) Install the first bonding bolt [16] and dimpled washer [17], as follows:

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 53-AWL-01.

 53-AWL-01: CDCCL



CAUTION

INSTALL THE BONDING BOLTS IN THE SAME FASTENER HOLES THAT YOU REMOVED THEM FROM. BONDING BOLTS CAN HELP TO PREVENT LIGHTNING DAMAGE. LIGHTNING CAN CAUSE DAMAGE TO THE AIRPLANE.

- (a) Install a bonding bolt [16] and dimpled washer [17] in the designated bonding fastener hole.

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 53-AWL-01.

 53-AWL-01: CDCCL

- (b) Visually, make sure that the dimpled washer [17] has surface contact with the EAF, and that the bonding bolt [16] has surface contact with the dimpled washer [17].

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 53-AWL-01.

- 1) Make sure that the bonding bolt [16] is fully seated in the panel's countersink.

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 53-AWL-01: CDCCL

- (c) Measure the electrical bonding resistance between the first installed bonding bolt [16] and a dimpled washer [17] at the next designated bonding fastener hole location (with no fastener installed) on the same fairing panel (TASK 53-51-21-760-801, SWPM 20-20-00).

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 53-AWL-01.

- 1) Use a digital/analog multimeter, COM-1793.

 53-AWL-01: CDCCL

- 2) Make sure that the electrical bonding resistance is 0.500 ohm (500 milliohms) or less.

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 53-AWL-01.

SUBTASK 53-51-21-420-015

 53-AWL-01: CDCCL

- (3) Install the second bonding bolt [16] and dimpled washer [17], as follows:

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 53-AWL-01.

 53-AWL-01: CDCCL



CAUTION

INSTALL THE BONDING BOLTS IN THE SAME FASTENER HOLES THAT YOU REMOVED THEM FROM. BONDING BOLTS CAN HELP TO PREVENT LIGHTNING DAMAGE. LIGHTNING CAN CAUSE DAMAGE TO THE AIRPLANE.

- (a) Install a bonding bolt [16] and dimpled washer [17] in the designated bonding fastener hole.

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 53-AWL-01.

 53-AWL-01: CDCCL

- (b) Visually, make sure that the dimpled washer [17] has surface contact with the EAF, and that the bonding bolt [16] has surface contact with the dimpled washer [17].

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 53-AWL-01.

- 1) Make sure that the bonding bolt [16] is fully seated in the panel's countersink.

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 53-AWL-01: CDCCL

- (c) Measure the electrical bonding resistance between the second installed bonding bolt [16] and a dimpled washer [17] in the last designated bond location (with no fastener installed) on the same fairing panel (TASK 53-51-21-760-801, SWPM 20-20-00).

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 53-AWL-01.

- 1) Use a digital/analog multimeter, COM-1793.

 53-AWL-01: CDCCL

- 2) Make sure that the electrical bonding resistance is 0.500 ohm (500 milliohms) or less.

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 53-AWL-01.

SUBTASK 53-51-21-420-014

 53-AWL-01: CDCCL

- (4) Install the third bonding bolt [16] and dimpled washer [17], as follows:

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 53-AWL-01.

 53-AWL-01: CDCCL



CAUTION

INSTALL THE BONDING BOLTS IN THE SAME FASTENER HOLES THAT YOU REMOVED THEM FROM. BONDING BOLTS CAN HELP TO PREVENT LIGHTNING DAMAGE. LIGHTNING CAN CAUSE DAMAGE TO THE AIRPLANE.

- (a) Install the bonding bolt [16] and dimpled washer [17] in the third designated bonding fastener hole.

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 53-AWL-01.

 53-AWL-01: CDCCL

- (b) Visually, make sure that the dimpled washer [17] has surface contact with the EAF, and that the bonding bolt [16] has surface contact with the dimpled washer [17].

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 53-AWL-01.

- 1) Make sure that the bonding bolt [16] is fully seated in the panel's countersink.

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SUBTASK 53-51-21-210-016

- (5) Make sure that the distance between panels is in tolerance.
 - (a) Measure the misfair between the fairing panels.
 - 1) Make sure that the misfair is less than or equal to 0.04 in. (1.02 mm).
 - (b) Measure the clearance between the fairing panels.
 - 1) Make sure that the clearance between the panels is 0.1400 $\pm$ 0.0600 in. (3.5560 $\pm$ 1.5240 mm).

SUBTASK 53-51-21-210-017

- (6) Measure the flushness between the fasteners and the fairing panel.
 - (a) Make sure that the distance between the fasteners and panels is between 0.000 +0.005 / -0.010 in. (0.000 +0.127 / -0.254 mm).

SIA 001-005

SUBTASK 53-51-21-390-012

- (7) For access panels 195BL or 195BR, apply sealant, A50359, to make an aerodynamic seal (Figure 403, TASK 51-22-00-390-809).

NOTE: This makes an aerodynamic and weather seal.

- (a) Do not apply sealant on the access doors.

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SUBTASK 53-51-21-390-009

- (8) For access panels 195BL or 195BR, apply sealant, A50231, or sealant, A00247, to make an aerodynamic seal where the panels touch the airplane skin (Figure 403).

END OF TASK

TASK 53-51-21-000-803

8. Aft Wing-To-Body Fairing Panel Removal

(Figure 408)

A. General

- (1) This task gives the instructions to remove the aft Wing-To-Body fairing panel.

B. References

Reference	Title
27-51-00-860-803	Extend the Trailing Edge Flaps (P/B 201)
27-51-00-860-804	Retract the Trailing Edge Flaps (P/B 201)
28-25-07-020-801	APU Fuel Feed Line Shroud Drain Mast Removal (P/B 401)
34-32-11-000-801	Marker Beacon Antenna Removal (P/B 401)
51-22-00-160-801	Prepare For Sealing (P/B 201)
53-51-21-211-801	Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection (P/B 601)

C. Location Zones

Zone	Area
194	Lower Wing-To-Body Fairing - Aft of Wheel Well

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D. Access Panels

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft
194CL	Aft Wing To Body Fairing Panel
194CR	Aft Wing To Body Fairing Panel
194DL	Aft Wing To Body Fairing Panel
194DR	Aft Wing To Body Fairing Panel
194E	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel
194HL	Aft Wing To Body Fairing Panel
194HR	Aft Wing To Body Fairing Panel

E. Prepare for the Removal

SUBTASK 53-51-21-020-005

- (1) If necessary, remove or disconnect the equipment that is attached to the fairing:
 - (a) For the marker beacon antenna, do this task: Marker Beacon Antenna Removal, TASK 34-32-11-000-801.
 - (b) For the Auxiliary Power Unit (APU) drain mast, do this task: APU Fuel Feed Line Shroud Drain Mast Removal, TASK 28-25-07-020-801.

F. Aft Wing-To-Body Fairing Panel Removal

SUBTASK 53-51-21-160-005

- (1) Remove sealant from the edge of the applicable panel.
NOTE: You can remove a section of the fillet seal (TASK 51-22-00-160-801).

SUBTASK 53-51-21-020-006

- (2) Do these steps to remove the applicable fairing panels:
 - (a) Make sure that you hold the fairing panel until all the fasteners are removed.
 - (b) Make sure that you identify the bolts [15], bonding bolts [16] and dimpled washers [17] to install them in the same location.
 - 1) Make sure that you identify the bonding bolts [16] and dimpled washers [17] for electrical bonding (TASK 53-51-21-211-801).
 - (c) Zone 194:
 - 1) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194AL [57].
Open this access panel:

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
 - 2) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194AR [50].

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Open this access panel:

<u>Number</u>	<u>Name/Location</u>
194AR	Aft Wing To Body Fairing Panel

- 3) Do these steps to remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194BL [56].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
194BL	Flap Track Lubrication Panel - Aft

- a) Do this task: Extend the Trailing Edge Flaps, TASK 27-51-00-860-803.
 - b) Remove the visible bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194BL [56] which are blocked by the Trailing Edge (TE) flaps when they are retracted.
 - c) Do this task: Retract the Trailing Edge Flaps, TASK 27-51-00-860-804.
 - d) Remove the remaining bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194BL [56].
- 4) Do these steps to remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194BR [51].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
194BR	Flap Track Lubrication Panel - Aft

- a) Do this task: Extend the Trailing Edge Flaps, TASK 27-51-00-860-803.
 - b) Remove the visible bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194BR [51] which are blocked by the TE flaps when they are retracted.
 - c) Do this task: Retract the Trailing Edge Flaps, TASK 27-51-00-860-804.
 - d) Remove the remaining bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194BR [51].
- 5) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194CL [64].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
194CL	Aft Wing To Body Fairing Panel

- 6) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194CR [52].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
194CR	Aft Wing To Body Fairing Panel

- 7) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194DL [55].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
194DL	Aft Wing To Body Fairing Panel

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- 8) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194DR [53].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
194DR	Aft Wing To Body Fairing Panel

- 9) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194E [54].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
194E	Aft Wing To Body Fairing Panel

- 10) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194FL [58].

Open this access panel:

(TASK 28-25-07-020-801)

<u>Number</u>	<u>Name/Location</u>
194FL	Aft Wing To Body Fairing Panel

- 11) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194FR [62].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
194FR	Aft Wing To Body Fairing Panel

- 12) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194GL [59].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
194GL	Aft Wing To Body Fairing Panel

- 13) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194GR [63].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
194GR	Aft Wing To Body Fairing Panel

- 14) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194HL [60].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
194HL	Aft Wing To Body Fairing Panel

- 15) Remove the bolts [15], bonding bolts [16] and dimpled washers [17] for access panel, 194HR [61].

Open this access panel:

<u>Number</u>	<u>Name/Location</u>
194HR	Aft Wing To Body Fairing Panel

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- (d) Remove the fairing panel from the airplane.

———— **END OF TASK** ————

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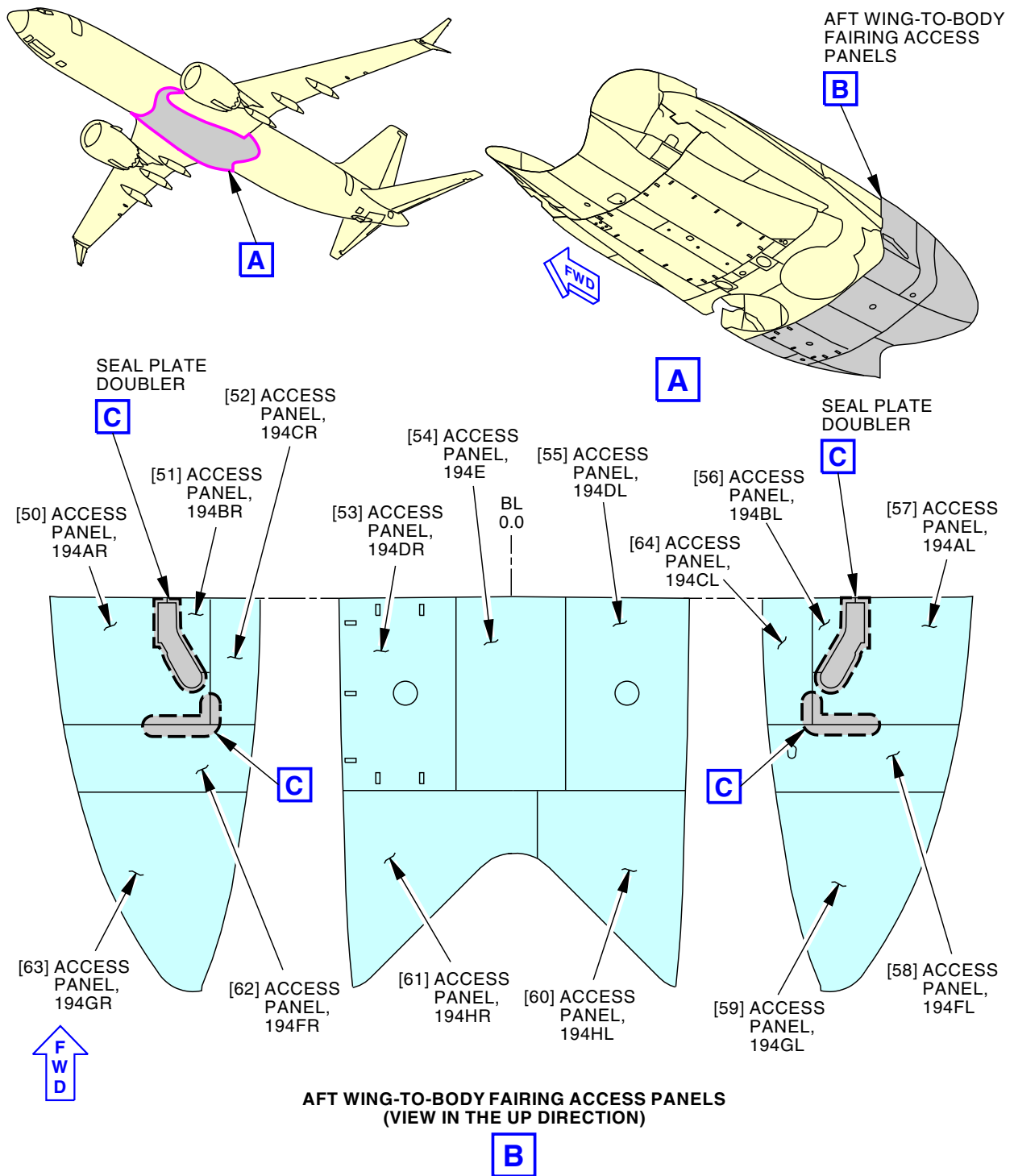
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2416186 S00061539931_V3

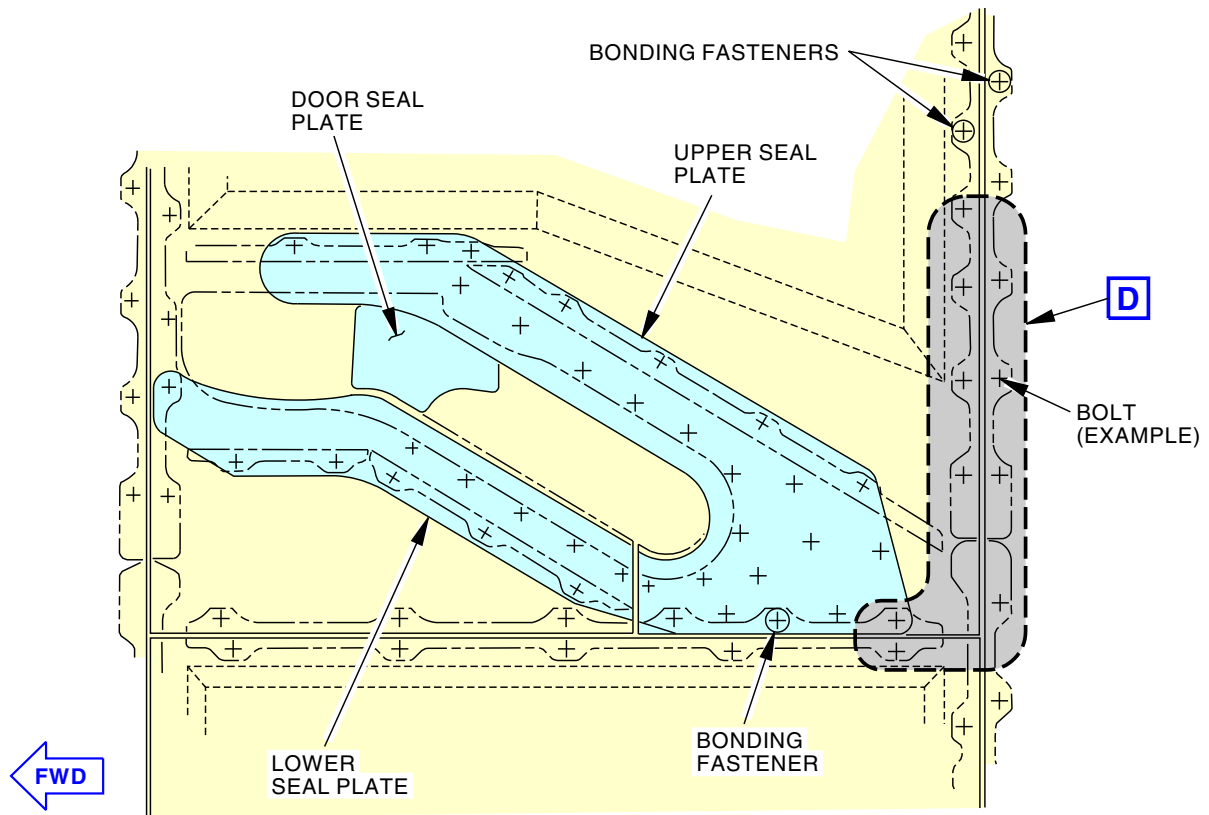
Aft Wing-To-Body Fairing Access Panels Installation
Figure 408/53-51-21-990-805 (Sheet 1 of 2)

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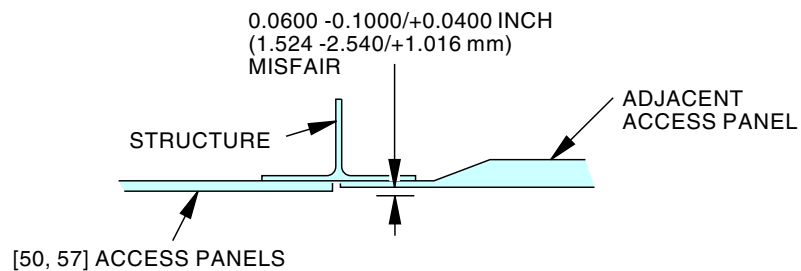
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SEAL PLATE DOUBLER

C



0.0600 -0.1000/+0.0400 INCH
(1.524 -2.540/+1.016 mm)
MISFAIR

[50, 57] ACCESS PANELS

ADJACENT
ACCESS PANEL

D

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Aft Wing-To-Body Fairing Access Panels Installation
Figure 408/53-51-21-990-805 (Sheet 2 of 2)

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TASK 53-51-21-400-803

9. **Aft Wing-To-Body Fairing Panel - Installation**

(Figure 408)

A. General

(1) This task gives the instructions to install the aft Wing-To-Body fairing panel.

B. References

Reference	Title
27-51-00-820-801	Trailing Edge Flap Control System Adjustment and Test (P/B 501)
27-51-00-860-803	Extend the Trailing Edge Flaps (P/B 201)
27-51-00-860-804	Retract the Trailing Edge Flaps (P/B 201)
28-25-07-420-801	APU Fuel Feed Line Shroud Drain Mast Installation (P/B 401)
34-32-11-400-801	Marker Beacon Antenna Installation (P/B 401)
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
51-21-81 P/B 701	ABRASION-RESISTANT TEFLON FINISH - CLEANING/PAINTING
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
53-51-21-211-801	Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection (P/B 601)
53-51-21-760-801	Wing-To-Body Fairing Panel Maximum Electrical Resistance Check (P/B 601)

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
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

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Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
A50231	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class B
A50359	Sealant - Low Density, Non-Chromate Type	BMS5-142 Type II Class B
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00304	Coating - Teflon Filled, Non Decorative, Sprayable Material	BMS10-86 Type I
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
C50149	Coating - Teflon Filled, Non Decorative, Brushable or Sprayable Material	BMS10-86 Type II
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
50	Access panel, 194AR	53-51-00-13-098	SIA ALL
51	Access panel, 194BR	53-51-00-13-025	SIA ALL
52	Access panel, 194CR	53-51-00-13-205	SIA ALL
53	Access panel, 194DR	52-49-51-02-255	SIA ALL
54	Access panel, 194E	53-51-00-15-092	SIA ALL
55	Access panel, 194DL	53-51-00-15-100	SIA ALL
56	Access panel, 194BL	53-51-00-13-024	SIA ALL
57	Access panel, 194AL	53-51-00-13-096	SIA ALL
58	Access panel, 194FL	53-51-00-13-210	SIA ALL
59	Access panel, 194GL	53-51-00-05-010	SIA ALL
60	Access panel, 194HL	53-51-00-15-095	SIA ALL
61	Access panel, 194HR	53-51-00-15-085	SIA ALL
62	Access panel, 194FR	53-51-00-13-215	SIA ALL
63	Access panel, 194GR	53-51-00-05-015	SIA ALL
64	Access panel, 194CL	53-51-00-13-200	SIA ALL

F. Location Zones

Zone	Area
194	Lower Wing-To-Body Fairing - Aft of Wheel Well

G. Access Panels

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft
194CL	Aft Wing To Body Fairing Panel

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(Continued)

Number	Name/Location

194CR	Aft Wing To Body Fairing Panel
194DL	Aft Wing To Body Fairing Panel
194DR	Aft Wing To Body Fairing Panel
194E	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel
194HL	Aft Wing To Body Fairing Panel
194HR	Aft Wing To Body Fairing Panel

H. Prepare for the Installation

SUBTASK 53-51-21-160-006

- (1) Make sure that the mating surfaces between the panel and structure are free from contamination.

NOTE: The mating structure surface has Teflon and does not cause contamination. It is not necessary to remove the Teflon.

SUBTASK 53-51-21-210-009

- (2) Make sure that the Teflon mating structure surface is in a good condition.
 - (a) If it is necessary, repair the Teflon coating on the structure surface.
 - 1) Apply coating, C00304 or coating, C50149 (PAGEBLOCK 51-21-81/701).
 - 2) Do not get Teflon in nutplate threads.

SUBTASK 53-51-21-210-010

- (3) Make sure that you identify the designated electrical bonds on the panel (TASK 53-51-21-211-801).

SUBTASK 53-51-21-350-007



DO NOT APPLY CORROSION-PREVENTATIVE COMPOUND TO THE BOND-BOLTS AND THEIR HOLES. THE COMPOUND PREVENTS CORRECT INSTALLATION OF THE BONDING BOLT. IF YOU DO NOT INSTALL THE BONDING BOLT CORRECTLY, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (4) Apply corrosion preventive compound, C00308, to the flanges on the fairing that touches the structure.

SUBTASK 53-51-21-350-009

- (5) Apply corrosion inhibiting compound, G00009, to the area on the structure and body skin that touches the fairing.
 - (a) If it is necessary, refer to the STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

I. Aft Wing-To-Body Fairing Panel Installation

SUBTASK 53-51-21-420-007

- (1) Install the bolts [15] that do not have a designated electrical bond on the applicable panel.

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DO NOT APPLY CORROSION-PREVENTATIVE COMPOUND TO THE BOND-BOLTS AND THEIR HOLES. THE COMPOUND PREVENTS CORRECT INSTALLATION OF THE BONDING BOLT. IF YOU DO NOT INSTALL THE BONDING BOLT CORRECTLY, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (a) If it is necessary, apply primer, C00259, to the fastener hole areas in the structure.
- (b) Let the primer to dry.
- (c) Put the panel into its position.

- 1) Install the bolts [15] that do not have a designated electrical bond for access panel, 194AL [57].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
194AL	Aft Wing To Body Fairing Panel

- 2) Install the bolts [15] that do not have a designated electrical bond for access panel, 194AR [50].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
194AR	Aft Wing To Body Fairing Panel

- 3) Do these steps to install the bolts [15] that do not have a designated electrical bond for access panel, 194BL [56].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
194BL	Flap Track Lubrication Panel - Aft

- a) Install all bolts [15] that you have access to that do not have a designated electrical bond for access panel, 194BL [56].
 - b) Do this task: Extend the Trailing Edge Flaps, TASK 27-51-00-860-803.
 - c) Install the remaining bolts [15] that do not have a designated electrical bond for access panel, 194BL [56] which are blocked by the Trailing Edge (TE) flaps when they are retracted.
 - d) Do this task: Retract the Trailing Edge Flaps, TASK 27-51-00-860-804.
- 4) Do these steps to install the bolts [15] that do not have a designated electrical bond for access panel, 194BR [51].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
194BR	Flap Track Lubrication Panel - Aft

- a) Install all bolts [15] that you have access to that do not have a designated electrical bond for access panel, 194BR [51].
- b) Do this task: Extend the Trailing Edge Flaps, TASK 27-51-00-860-803.
- c) Install the remaining bolts [15] that do not have a designated electrical bond for access panel, 194BR [51] which are blocked by the TE flaps when they are retracted.
- d) Do this task: Retract the Trailing Edge Flaps, TASK 27-51-00-860-804.

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- 5) Install the bolts [15] that do not have a designated electrical bond for access panel, 194CL [64].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
194CL	Aft Wing To Body Fairing Panel

- 6) Install the bolts [15] that do not have a designated electrical bond for access panel, 194CR [52].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
194CR	Aft Wing To Body Fairing Panel

- 7) Install the bolts [15] that do not have a designated electrical bond for access panel, 194DL [55].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
194DL	Aft Wing To Body Fairing Panel

- 8) Install the bolts [15] that do not have a designated electrical bond for access panel, 194DR [53].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
194DR	Aft Wing To Body Fairing Panel

- 9) Install the bolts [15] that do not have a designated electrical bond for access panel, 194E [54].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
194E	Aft Wing To Body Fairing Panel

- 10) Install the bolts [15] that do not have a designated electrical bond for access panel, 194FL [58].

Close this access panel:

(TASK 28-25-07-420-801)

<u>Number</u>	<u>Name/Location</u>
194FL	Aft Wing To Body Fairing Panel

- 11) Install the bolts [15] that do not have a designated electrical bond for access panel, 194FR [62].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
194FR	Aft Wing To Body Fairing Panel

- 12) Install the bolts [15] that do not have a designated electrical bond for access panel, 194GL [59].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
194GL	Aft Wing To Body Fairing Panel

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- 13) Install the bolts [15] that do not have a designated electrical bond for access panel, 194GR [63].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
194GR	Aft Wing To Body Fairing Panel

- 14) Install the bolts [15] that do not have a designated electrical bond for access panel, 194HL [60].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
194HL	Aft Wing To Body Fairing Panel

- 15) Install the bolts [15] that do not have a designated electrical bond for access panel, 194HR [61].

Close this access panel:

<u>Number</u>	<u>Name/Location</u>
194HR	Aft Wing To Body Fairing Panel



CAUTION

IF YOU REPLACE A PANEL THAT HAS A DOUBLER (194AL, 194BL, 194AR, 194BR), YOU MUST INSTALL A NEW PANEL WITH A NEW DOUBLER. MAKE SURE THAT YOU INSTALL IT CORRECTLY. IF YOU INSTALL THE DOUBLERS INCORRECTLY, DAMAGE TO THE EQUIPMENT CAN OCCUR.

- (d) If access panel, 194AL [57], access panel, 194AR [50], access panel, 194BL [56], or access panel, 194BR [51] are replaced and have a doubler, do the following:

NOTE: The same thickness doubler and nylon liner should be used and edges sealed with sealant. This makes an aerodynamic and a weather seal.

- 1) Install a new doubler and nylon at STA 727.
- 2) Fay seal doubler to fairing panel.
- 3) Make sure that the seal compression is within limits of operation and trailing edge flaps are within limits (TASK 27-51-00-820-801).
- 4) Apply sealant, A02315, to make a fillet seal around edge of doubler.

SUBTASK 53-51-21-420-008



CAUTION

INSTALL THE BONDING BOLTS IN THE SAME FASTENER HOLES THAT YOU REMOVED THEM FROM. BONDING BOLTS CAN HELP TO PREVENT LIGHTNING DAMAGE. LIGHTNING CAN CAUSE DAMAGE TO THE AIRPLANE.

- (2) Install the designated bonding bolts [16] and dimpled washers [17] for the applicable panel.

SUBTASK 53-51-21-760-003

- (3) Measure the maximum electrical resistance for each bonding bolt [16] and fairing panel with a digital/analog multimeter, COM-1793 (TASK 53-51-21-760-801).

- (a) Make sure that the resistance for each bonding bolt [16] is not more than 300,000 ohms for these access panels:

- In Zone 194: 194AL, 194AR, 194BL, 194BR, 194CL, 194CR, 194DL, 194FL, 194FR, 194GL, 194GR.

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- (b) Make sure that the resistance for each bonding bolt [16] is not more than 10 ohms for these access panels:
- In Zone 194: 194DR, 194E, 194HL, 194HR.

SUBTASK 53-51-21-210-011

- (4) Make sure that the distance between panels is in tolerance.
- (a) Measure the misfair between the panels.
- 1) If you install access panel, 194AL [57], access panel, 194AR [50], access panel, 194CL [64], access panel, 194CR [52], access panel, 194FL [58], or access panel, 194FR [62], make sure that the joint misfair is within the range of 0.060 +0.040 / -0.100 in. (1.524 +1.016 / -2.540 mm).
 - 2) For all other access panel joints, make sure that the joint misfair is less than or equal to 0.040 in. (1.016 mm).
- (b) Measure the clearance between the fairing panels.
- 1) Make sure that the clearance between the access panels is 0.140 ±0.060 in. (3.556 ±1.524 mm) .

SUBTASK 53-51-21-210-012

- (5) Measure the flushness between the fasteners and fairing panels.
- (a) Make sure that the fasteners are flush to the fairing panel between 0.005 in. (0.127 mm) and -0.010 in. (-0.254 mm).

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SUBTASK 53-51-21-390-013

- (6) Apply sealant, A50359, to make an aerodynamic seal (Figure 403, TASK 51-22-00-390-809).
- NOTE: This makes an aerodynamic and weather seal.
- (a) Do not apply sealant on the access doors.

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SUBTASK 53-51-21-390-007

- (7) Apply sealant, A50231, or sealant, A00247, to make an aerodynamic seal where the panels touch the airplane skin (Figure 403).

J. Put the Airplane Back to Its Usual Condition

SUBTASK 53-51-21-420-009

- (1) Connect or install the equipment to the fairing and do an operational test if the equipment was disconnected or removed:
- (a) For the marker beacon antenna, do this task: Marker Beacon Antenna Installation, TASK 34-32-11-400-801.
- (b) For the Auxiliary Power Unit (APU) drain mast, do this task: APU Fuel Feed Line Shroud Drain Mast Installation, TASK 28-25-07-420-801.

————— **END OF TASK** —————

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WING-TO-BODY FAIRING PANELS - INSPECTION/CHECK

1. **General**

A. This procedure has these tasks:

- (1) Wing-To-Body Fairing Panel maximum electrical resistance check.
- (2) Wing-To-Body Fairing Panel designated electrical bond visual inspection.

B. This task is not specified to a zone or panel. It applies to all panels in the Forward, Center, and Aft sections of the fillet fairings.

TASK 53-51-21-760-801

2. **Wing-To-Body Fairing Panel Maximum Electrical Resistance Check**

(Figure 601)

A. General

- (1) This task covers the maximum electrical resistance checks for all designated bonds for panels located in the Wing-To-Body Fairing section.

B. References

Reference	Title
53-51-21 P/B 401	WING-TO-BODY FAIRING PANELS - REMOVAL/INSTALLATION
53-51-21-400-801	Forward Wing-To-Body Fairing Panel - Installation (P/B 401)
53-51-21-400-802	Center Wing-To-Body Fairing Panel (Except 192AL, 192AR, 192HL, 192HR, 195BL, 195BR) - Installation (P/B 401)
53-51-21-400-803	Aft Wing-To-Body Fairing Panel - Installation (P/B 401)
53-51-21-400-804	Center Wing-To-Body Fairing Panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) - 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

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D. Consumable Materials

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79 Type III
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
C00767	Coating - Anti-Static Coating	BMS10-21 Type III
C00862	Coating - Chemical Conversion - Bonderite M-CR 600 Aero (Formerly Alodine 600)	BAC5719 Class A, C or D, MIL-DTL-81706 Type I Class 1A or 3

E. Location Zones

Zone	Area
190	Subzone - Wing-to-Body Fairing
191	Lower Wing-To-Body Fairing - Forward of Wing Box
192	Lower Wing-To-Body Fairing - Under Wing Box
193	Lower Wing-To-Body Fairing - Wheel Well
194	Lower Wing-To-Body Fairing - Aft of Wheel Well
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

F. Prepare for the Resistance Check

SUBTASK 53-51-21-211-001

- (1) Make sure that the fastener locations for the designated bonds are identified (TASK 53-51-21-211-801).

G. Check the Maximum Electrical Resistance of the Designated Bonds

SUBTASK 53-51-21-910-001

- (1) Make sure that one fastener and one dimpled washer is installed in a designated bond location in the panel.
 - (a) Refer to SWPM 20-20-00, Electrical Bonding of Fasteners To Conductive Finishes on Composites.
 - (b) Make sure that the flushness for the fastener and the panel is 0.000 ± 0.003 in. (0.0000 ± 0.0762 mm).

SUBTASK 53-51-21-800-001

- (2) Put a dimpled washer in an adjacent designated bonded fastener location.
 - (a) Do not install the fastener at the adjacent designated bonded fastener location.

SUBTASK 53-51-21-200-001

- (3) Connect the digital/analog multimeter, COM-1793 to examine the electrical resistance:
 - (a) Put one probe of a digital/analog multimeter, COM-1793 on the installed designated bonded fastener head.
 - (b) Put the second probe on a dimpled washer in the adjacent designated bonded fastener location.

NOTE: The dimpled washer completes an electrical bond between the panel conductive surface and the probe. There must not be a fastener at this location.

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SUBTASK 53-51-21-200-002

- (4) Make sure that the resistance is not more than in the Table 601.

Table 601/53-51-21-993-801 Panel Conductive Surface Maximum Resistance

Conductive Surface Type	Maximum Resistance (Ohm) ^{*[1]}
Anti-Static Coating	300,000
Expanded Aluminum Foil ^{*[2]}	10
Aluminum Alloy	0.5
Flamespray	0.5

*[1] Some panels will be installed with bonding jumpers. The dimension of the bonding jumper can change the maximum resistance. Refer to the installation procedure for the maximum resistance of panels with bonding jumpers (TASK 53-51-21-400-801, TASK 53-51-21-400-802 or TASK 53-51-21-400-804, TASK 53-51-21-400-803).

*[2] Some panels with the expanded aluminum foil surface can have different maximum resistances. Refer to the installation procedure for panels with different maximum resistances than in this table (TASK 53-51-21-400-801, TASK 53-51-21-400-802 or TASK 53-51-21-400-804, TASK 53-51-21-400-803).

NOTE: The maximum resistance data for each panel can be found in the installation procedures (PAGEBLOCK 53-51-21/401).

- (a) If the designated electrical bond is not in the limits, then do these steps:

- 1) Apply a layer of coating on the countersunk area of the panel.

- a) Use coating, C00767 on panels with an anti-static coating conductive surface type.
b) Use Bonderite M-CR 600 Aero coating, C00862 on panels with an aluminum conductive surface type.

- 2) Measure the maximum resistance again.

SUBTASK 53-51-21-400-001

- (5) If the maximum resistance is in the limits, then make sure that the dimpled washer does not move:

- (a) Remove the probe.

- (b) Install the fastener.

- 1) Refer to SWPM 20-20-00, Electrical Bonding of Fasteners To Conductive Finishes on Composites.

H. Repeat the Electrical Resistance of the Designated Bonds Check

SUBTASK 53-51-21-200-003

- (1) Do the "Check of the Electrical Resistance of the Designated Bonds" steps again until all designated bonds are examined.

- (a) Do the check with each subsequently installed designated bond fastener as the start point until all fasteners are installed.

NOTE: It is not necessary to remove or do the resistance check again for the first fastener installed.

- 1) If the designated electrical bond is not in the limits, then do these steps:

- a) Apply a layer of coating on the countersunk area of the panel.

<1> Use coating, C00767 on panels with an anti-static coating conductive surface type.

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<2> Use Bonderite M-CR 600 Aero coating, C00862 on panels with an aluminum conductive surface type.

b) Measure the maximum resistance for the fastener again.

I. Restore the Fairing Panel to Its Usual Condition

SUBTASK 53-51-21-390-001

- (1) Apply finish to the fairing panel after all the fasteners have been examined and installed.
 - (a) Apply one layer of primer, C00175 as necessary to the bonding fasteners only.
 - (b) Apply compound, C00528 to all the fasteners for non-designated bonds and their holes.
 - (c) Apply primer, C00259 to all the fasteners for non-designated bonds and their holes.

———— **END OF TASK** ————

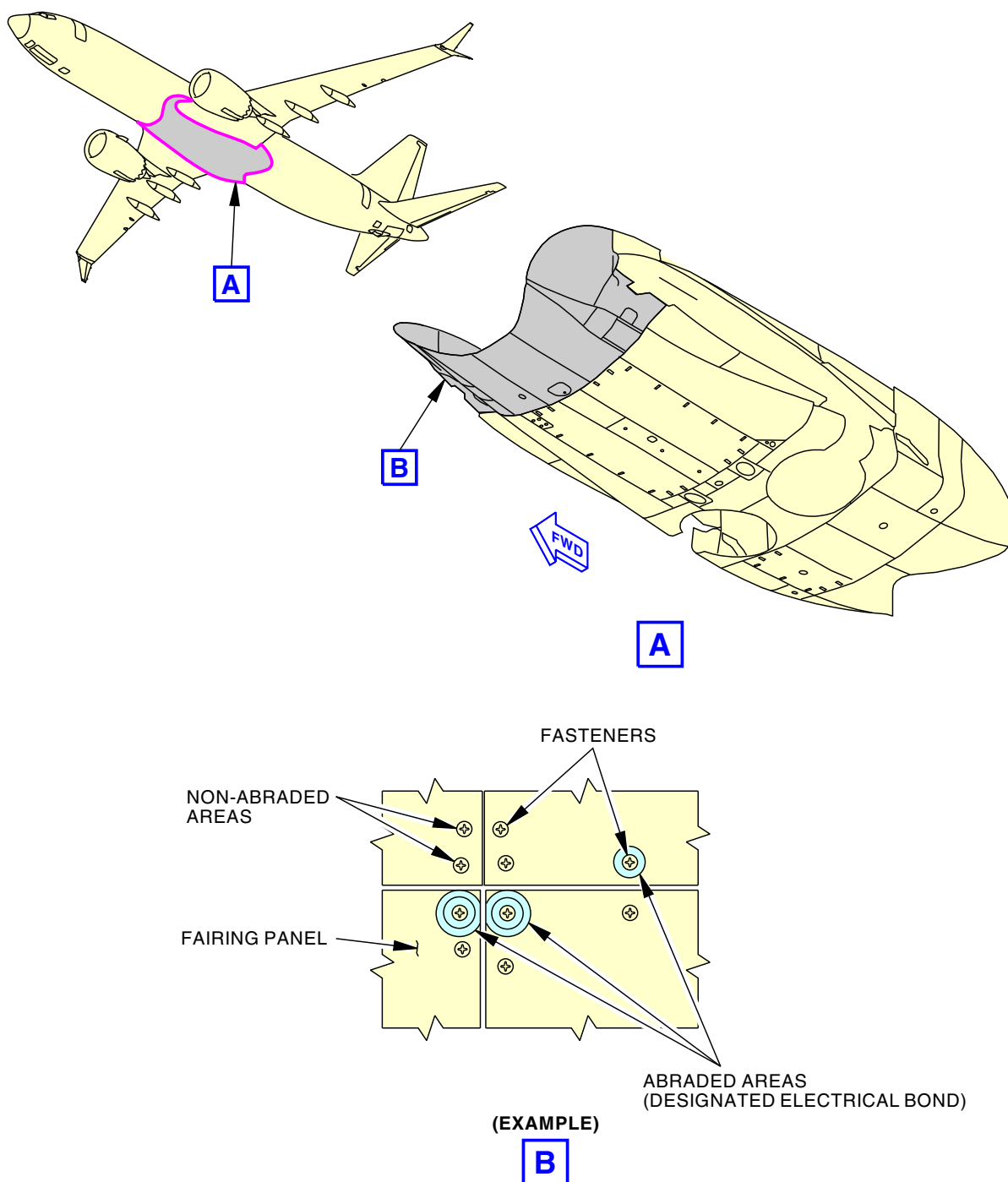
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Wing-to-Body Fairing Inspection
Figure 601/53-51-21-990-806

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TASK 53-51-21-211-801

3. **Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection**

(Figure 601)

A. General

- (1) This task covers the visual inspection of the designated electrical bonds for the panels located in the Wing-To-Body Fairing section.

B. Consumable Materials

Reference	Description	Specification
C00767	Coating - Anti-Static Coating	BMS10-21 Type III
C00862	Coating - Chemical Conversion - Bonderite M-CR 600 Aero (Formerly Alodine 600)	BAC5719 Class A, C or D, MIL-DTL-81706 Type I Class 1A or 3

C. Location Zones

Zone	Area
190	Subzone - Wing-to-Body Fairing
191	Lower Wing-To-Body Fairing - Forward of Wing Box
192	Lower Wing-To-Body Fairing - Under Wing Box
193	Lower Wing-To-Body Fairing - Wheel Well
194	Lower Wing-To-Body Fairing - Aft of Wheel Well
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

D. Visually Examine the Designated Electrical Bonds on the Wing-To-Body Fairing Panels

SUBTASK 53-51-21-211-002

- (1) Identify the fastener locations on each panel that an electrical bond is necessary to identify fastener locations for electrical bonds:

NOTE: There are usually four fasteners per panel with electrical bonds.

- (a) Examine the area around each fastener hole to identify electrical bond locations.
 - 1) Locations that have an electrical bond have an abraded area in the panel around the fastener hole (Figure 601).
 - 2) It is recommended to examine the panel at the corners first. Usually, the locations are at or near the panel corners, but panel repairs can change the locations of the electrical bonds.
 - 3) It is necessary to examine all the fastener holes to identify locations with an electrical bond.

SUBTASK 53-51-21-300-001

- (2) Do these steps if the electrical bond locations are not identified after the visual inspection:

- (a) Remove one fastener and one dimpled washer, if installed, from the panel.

NOTE: There are usually four fasteners per panel with dimpled washers.

- (b) Examine the area around the fastener hole:
 - 1) Locations that have an electrical bond have an abraded area in the panel around the fastener hole (Figure 601).
 - 2) It is recommended to examine the panel at the corners first. Usually, the locations are at or near the panel corners, but panel repairs can change the locations of the electrical bonds.

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- 3) It is necessary to examine all the fastener holes to identify locations with an electrical bond.
- (c) Examine the countersunk area of the fastener hole:
NOTE: The countersunk area of the panel will be below the dimpled washer, if installed.
- 1) The countersunk area for each electrically bonded fastener hole will have a coating, C00767 or an Bonderite M-CR 600 Aero coating, C00862.
NOTE: Non-electrical bonding locations do not have coatings in the countersunk hole.
- (d) Examine the countersunk mating surface between the dimpled washer (if installed) and the panel (Figure 601).
- 1) Make sure that the surfaces without an electrical bond between the dimpled washer and the panel are free from contamination.
- 2) Make sure that the surfaces with an electrical bond between the dimpled washer and the panel are free from contamination, primer, or paint.
- (e) If necessary, install the fastener if the location is not a designated electrical bond.
NOTE: It is not necessary to do this step if the removal and installation procedure is being done until it is necessary in the installation procedure.
- 1) Do not install the dimpled washer if the location is not a designated electrical bond.
- (f) Do the steps again to find all the designated bond locations.
NOTE: The only fasteners not installed will be fasteners for a designated electrical bond.

———— **END OF TASK** ————

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NOSE RADOME - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) Nose radome open
 - (2) Nose radome close.

TASK 53-52-00-010-801

2. Nose Radome Open

(Figure 201)

A. **General**

- (1) This task gives the instructions to open the nose radome.

B. **Location Zones**

Zone	Area
111	Radome

C. **Prepare for the Open**

SUBTASK 53-52-00-040-001

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

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
C	7	C01678	WEATHER RADAR RT RIGHT

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

D. **Nose Radome Open**

SUBTASK 53-52-00-010-001



USE CAUTION WHEN YOU OPEN THE NOSE RADOME COMPARTMENT. IF THERE IS A BATTERY FAILURE, A DANGEROUS GAS CAN EMIT. DO THE CORRECT EMERGENCY PROCEDURES IF YOU SMELL AN UNUSUAL ODOR AT THE RADOME AREA.

- (1) Remove the screws that attach the aft edge of the radome to the clips on the fuselage bulkhead.

SUBTASK 53-52-00-010-002



DO NOT OPEN THE NOSE RADOME IF THE WIND IS MORE THAN 15 KNOTS. IF YOU OPEN THE NOSE RADOME IN A WIND, THE RADOME CAN MOVE QUICKLY. THIS CAN CAUSE INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.

- (2) Open the radome.
 - (a) Hold the radome in the open position.

SUBTASK 53-52-00-020-001

- (3) Remove the radome support rods [1] from the stowed position.

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SUBTASK 53-52-00-420-001

- (4) Install the radome support rods [1] on the studs [3] to hold the radome in the open position.

———— **END OF TASK** ————

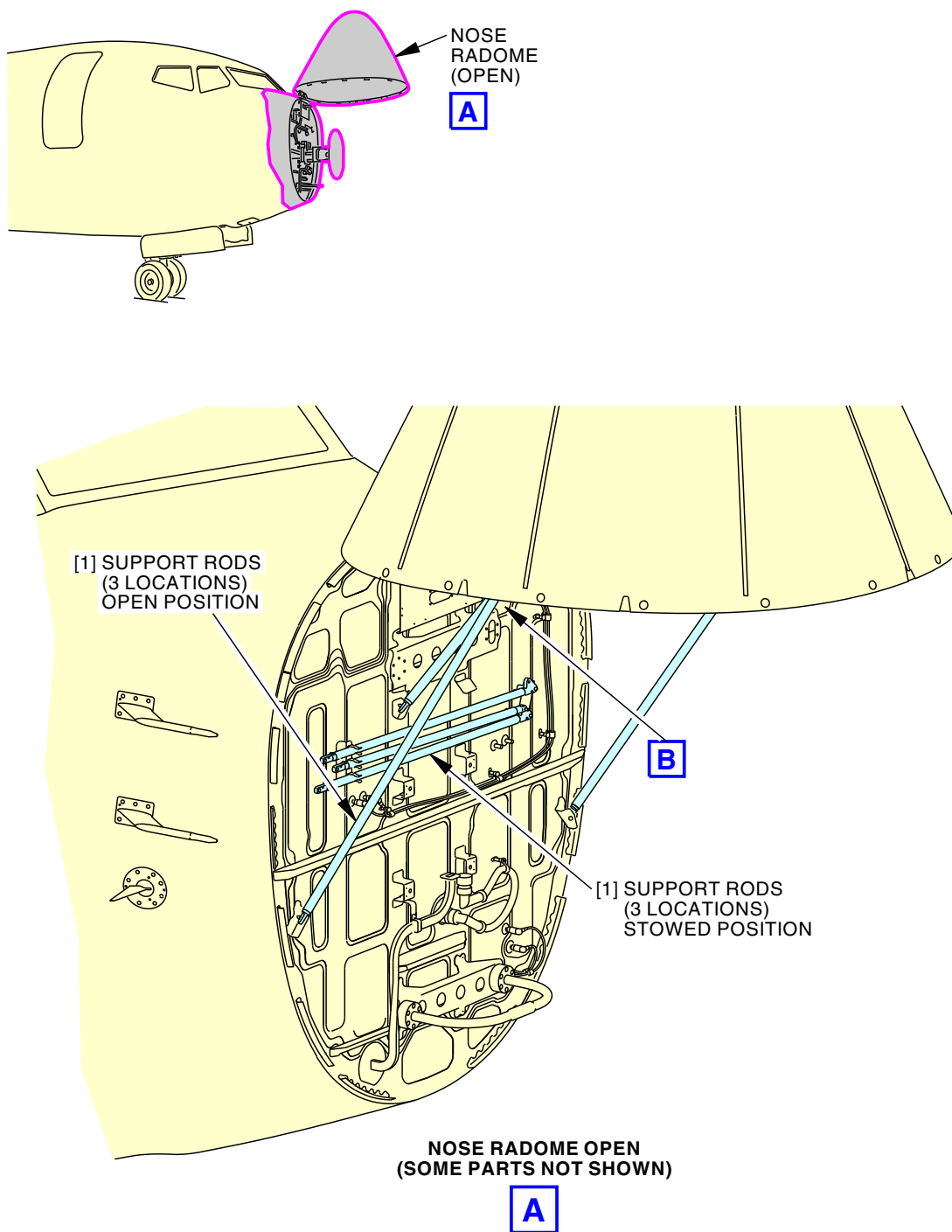
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Nose Radome Close
Figure 201/53-52-00-990-801 (Sheet 1 of 2)

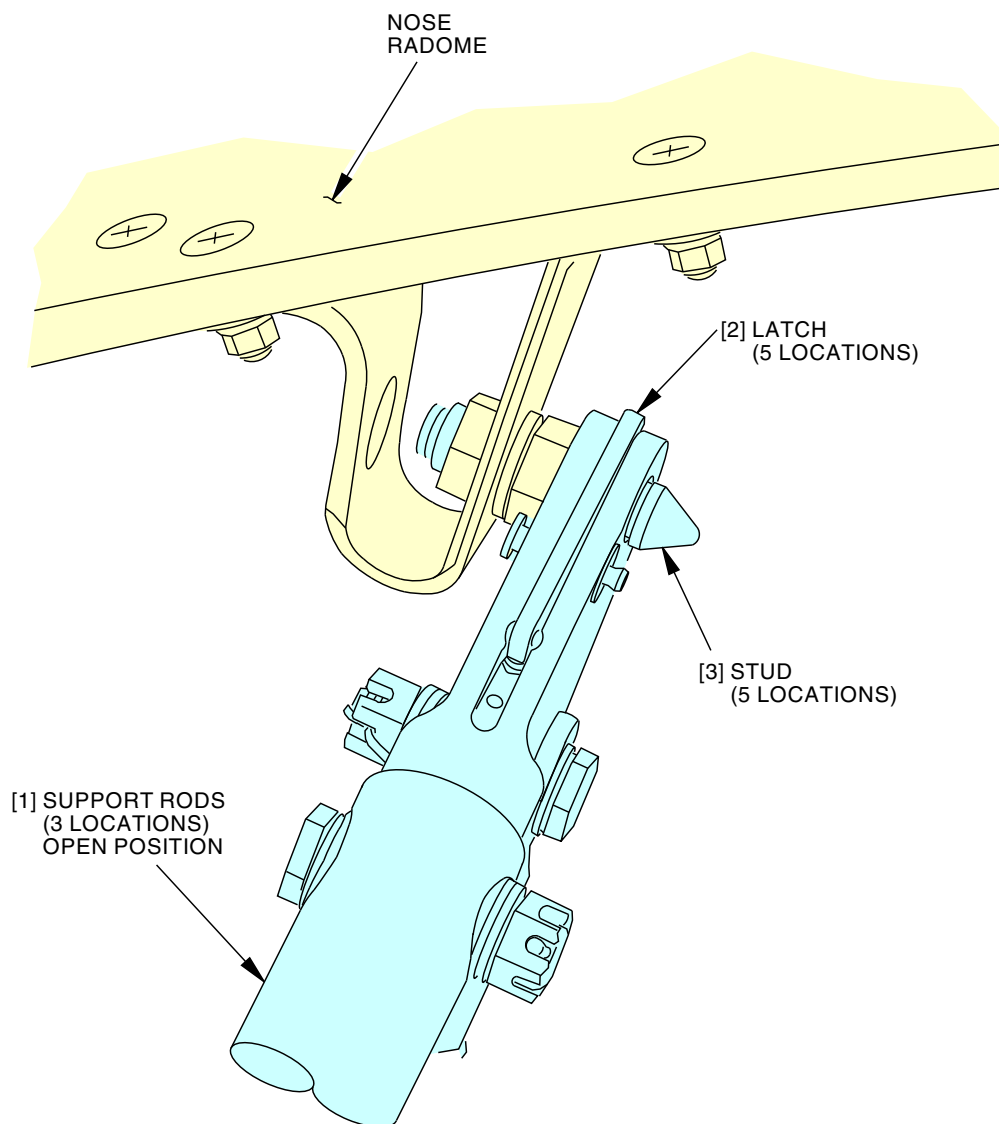
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Nose Radome Close
Figure 201/53-52-00-990-801 (Sheet 2 of 2)

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TASK 53-52-00-410-801

3. **Nose Radome Close**

(Figure 201)

A. General

- (1) This task gives the instructions to close the nose radome.

B. Consumable Materials

Reference	Description	Specification
D50004	Compound - Antiseize	BMS3-28

C. Location Zones

Zone	Area
111	Radome

D. Prepare for the Close

SUBTASK 53-52-00-040-002

- (1) Make sure that these circuit breakers are open and have safety tags:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
C	7	C01678	WEATHER RADAR RT RIGHT

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

E. Nose Radome Close

SUBTASK 53-52-00-410-001

- (1) Hold the radome while you remove the support rods [1].

SUBTASK 53-52-00-410-002

- (2) Remove the radome support rod [1].
(a) Lift the latches [2] to remove the support rods [1] from the studs [3].

SUBTASK 53-52-00-410-003

- (3) Install the radome support rods [1] in the stowed position.

SUBTASK 53-52-00-410-004

- (4) Lower the radome.

SUBTASK 53-52-00-410-005

- (5) Install the screws with compound, D50004 in the aft edge of the radome.
(a) Torque screws to 120 in-lb (13.6 N·m) - 150 in-lb (16.9 N·m).

SUBTASK 53-52-00-210-001

- (6) Make sure that the seal engages correctly.

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F. Put the Airplane Back to Its Usual Condition

SUBTASK 53-52-00-440-001

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

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	7	C01678	WEATHER RADAR RT RIGHT

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	13	C00120	WEATHER RADAR RT

————— **END OF TASK** —————

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NOSE RADOME - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Nose radome removal
 - (2) Nose radome installation.

TASK 53-52-00-000-802

2. Nose Radome Removal

(Figure 401)

A. **General**

- (1) This task is for the removal of the nose radome.
- (2) A minimum of two persons are necessary to do this task.

B. **Location Zones**

Zone	Area
111	Radome

C. **Prepare for the Removal**

SUBTASK 53-52-00-860-001

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

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	7	C01678	WEATHER RADAR RT RIGHT

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	13	C00120	WEATHER RADAR RT

D. **Nose Radome Removal**

SUBTASK 53-52-00-020-002

- (1) Remove the screws [14] that attach the aft edge of the nose radome [1] to the clips [15] on the fuselage bulkhead.

SUBTASK 53-52-00-010-003



DO NOT OPEN THE NOSE RADOME IF THE WIND IS MORE THAN 15 KNOTS. IF YOU OPEN THE NOSE RADOME IN A WIND, THE RADOME CAN MOVE QUICKLY. THIS CAN CAUSE INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.

- (2) Open the nose radome [1] and hold it in the open position.
 - (a) If it is necessary, use the support rods to support the nose radome [1].

SUBTASK 53-52-00-020-003

- (3) Disconnect one of the two ends of the bonding jumper [2] at the nose radome [1] hinge.

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SUBTASK 53-52-00-020-004



WARNING

GET SUFFICIENT AID FROM OTHER PERSONNEL AND EQUIPMENT TO HOLD THE COMPONENT DURING THE REMOVAL, AND INSTALLATION. THE COMPONENT IS HEAVY. THIS WILL PREVENT INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (4) With a minimum of two persons, remove the radome as follows:
- (a) Remove the bolts [11], washers [13], and nuts [10], from the hinge arms [4] and hinge brackets [5].
 - 1) When you remove the bolts [11], prepare to catch the shims [12] that are installed between the hinge arms [4] and the hinge brackets [5].
 - a) Make a note of the installed positions of the shims [12].
 - NOTE: This will help the installation if you install the same nose radome.
 - (b) Remove the nose radome [1] from the fuselage.

———— **END OF TASK** ————

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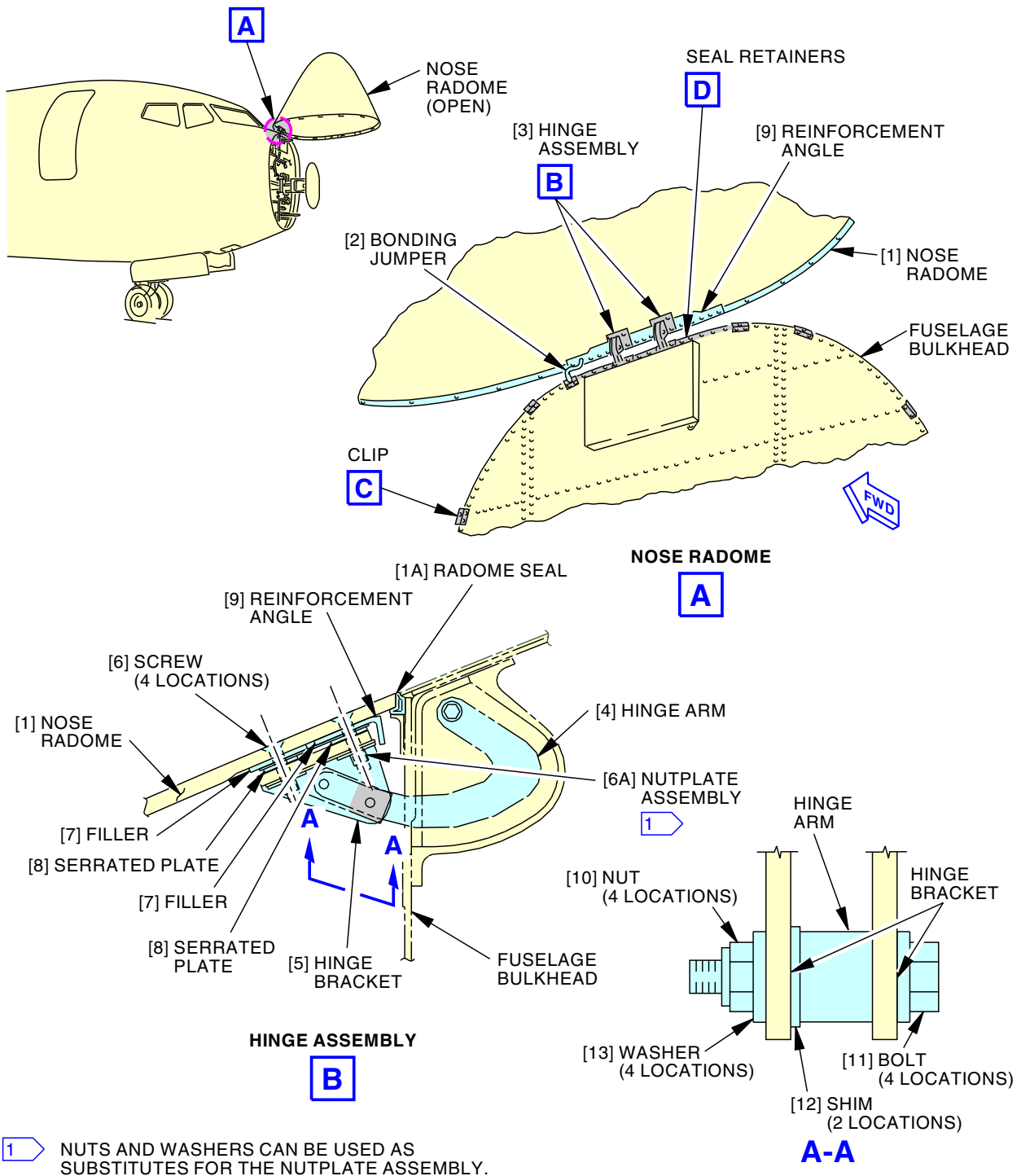
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2416192 S00061539953_V3

Nose Radome Installation
Figure 401/53-52-00-990-810 (Sheet 1 of 3)

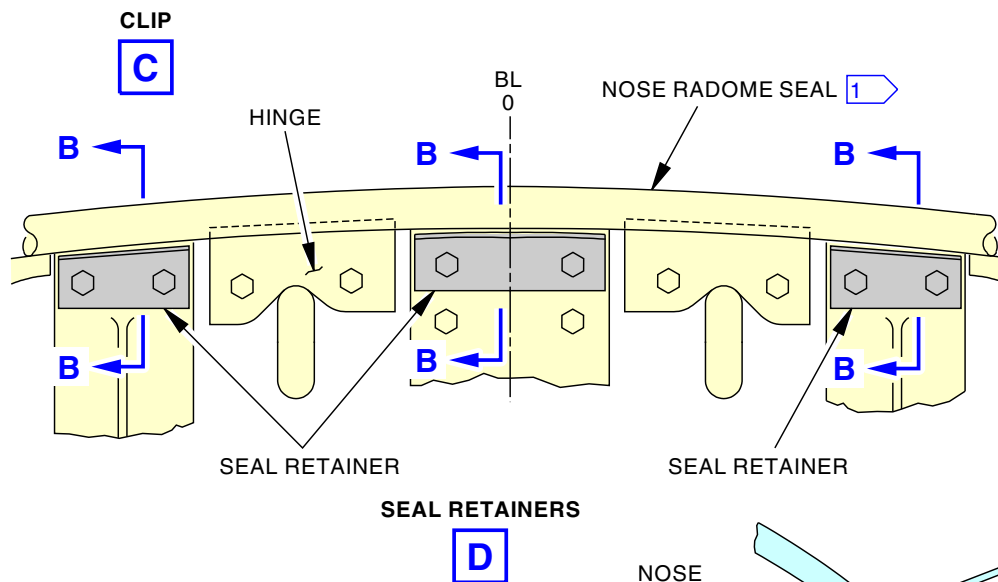
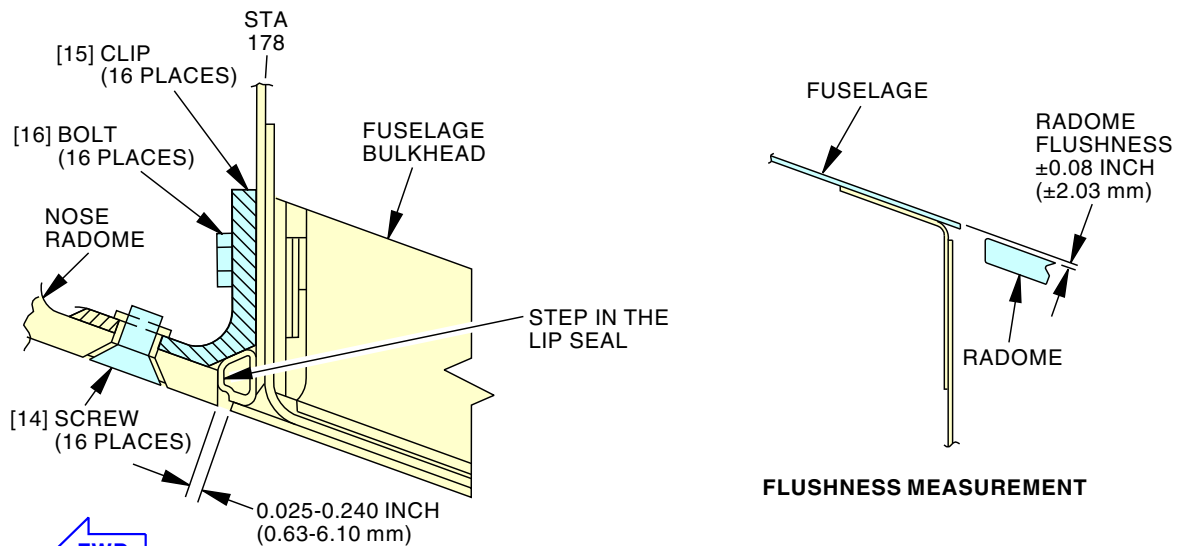
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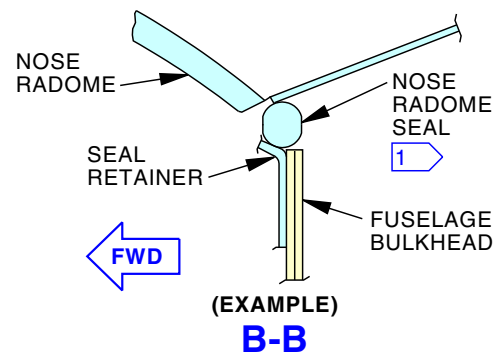
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- 1 MAKE SURE THAT THE NOSE RADOME SEAL COMPRESSES PROPERLY AROUND THE FULL PERIPHERY OF THE NOSE RADOME.
- 2 IN SERVICE LIMIT.



2416193 S00061539954_V1

Nose Radome Installation
Figure 401/53-52-00-990-810 (Sheet 2 of 3)

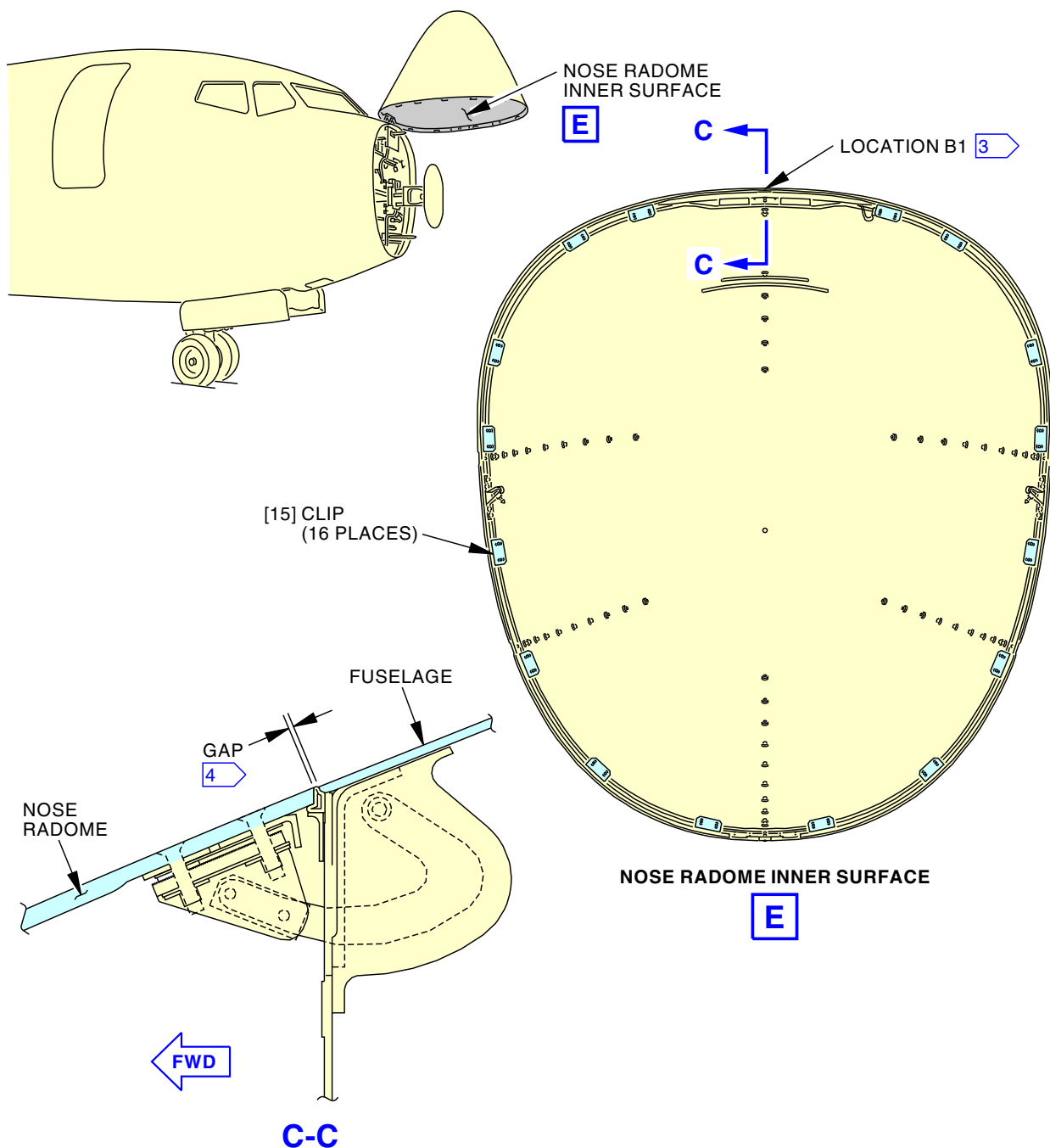
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- [3] GAP AT LOCATION B1 IS 0.046 TO 0.216 INCH (1.17 TO 5.49 mm)
- [4] ONLY MEASURE THE GAP WHEN NOSE RADOME IS FULLY CLOSED.

2416194 S00061539955_V3

Nose Radome Installation
Figure 401/53-52-00-990-810 (Sheet 3 of 3)

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TASK 53-52-00-400-802

3. **Nose Radome Installation**

(Figure 401)

A. General

- (1) This task is for the installation of the nose radome.
- (2) A minimum of two persons are necessary to do this task.

B. References

Reference	Title
51-22-00-160-801	Prepare For Sealing (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-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

D. Consumable Materials

Reference	Description	Specification
A00281	Adhesive - Dow Corning 3145 RTV	MIL-A-46146 (BAC5010 Type 79)
B00068	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002, MIL-E-51454 Type II
B00130	Alcohol - Isopropyl	TT-I-735
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
D50004	Compound - Antiseize	BMS3-28

E. Location Zones

Zone	Area
111	Radome

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F. Nose Radome Installation

SUBTASK 53-52-00-110-001

- (1) If you install a new radome, do these steps:
- (a) Install the erosion protection and the lightning diverter strips where it is necessary.
 - (b) Install the hinge brackets [5], serrated plates [8], reinforcement angles [9], and the fillers [7] on the nose radome [1] with the screws [6].
- NOTE:** The brackets can push on the flange of the reinforcement angle.
- (c) Tighten the screws [6] to 60 in-lb (7 N·m) - 75 in-lb (8 N·m).

SUBTASK 53-52-00-860-002



GET SUFFICIENT AID FROM OTHER PERSONNEL AND EQUIPMENT TO HOLD THE COMPONENT DURING THE REMOVAL, AND INSTALLATION. THE COMPONENT IS HEAVY. THIS WILL PREVENT INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (2) With a minimum of two persons, do these steps:
- (a) Hold the nose radome [1] adjacent to the fuselage bulkhead until you can engage the hinge brackets [5] with the hinge arms [4] on the bulkhead.
 - (b) Install the shims [12] where it is necessary between the hinge brackets [5] and the hinge arms [4].
 - (c) Install the bolts [11], washers [13], reinforcement angles [9], and nuts [10] to the hinge brackets [5].

SUBTASK 53-52-00-410-006

- (3) If the support rods are on the nose radome [1], do these steps:
- (a) Remove the support rods from the nose radome [1].
 - (b) Install the support rods in their storage clips on the forward pressure bulkhead.



YOU MUST BE CAREFUL WHEN YOU LOWER THE RADOME TO THE CLOSED POSITION AFTER THE INSTALLATION OF THE HINGE. IF YOU ARE NOT CAREFUL WHEN YOU LOWER THE RADOME, THE TOP AFT EDGE OF THE RADOME CAN HIT THE FUSELAGE SKIN AND CAUSE DAMAGE.

- (c) Lower the nose radome [1] carefully to the closed position.

SUBTASK 53-52-00-210-016

- (4) Make sure that the radome seal [1A] compression is sufficient with the nose radome [1] in the closed position.

SUBTASK 53-52-00-210-003

- (5) Make sure that the top aft edge does not hit the fuselage skin as follows:
- (a) Measure the gap in location B1 between the top aft edge of the radome and the fuselage.
 - (b) Make sure that the gap is 0.046 in. (1.17 mm) to 0.216 in. (5.49 mm).

SUBTASK 53-52-00-020-005

- (6) If the top edge touches the fuselage skin, do these steps:

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MAKE SURE THAT THE SEAL ENDS DO NOT TOUCH AT THE BOTTOM OF THE BULKHEAD. THERE MUST BE AN OPENING OF 8.3 INCH (21.1 CM) AT THE BOTTOM OF THE BULKHEAD TO LET THE RADOME DRAIN. IF YOU DO NOT OBEY THESE INSTRUCTIONS, DAMAGE TO EQUIPMENT CAN OCCUR.

- (a) Make sure that the seal ends do not touch at the bottom of the bulkhead.
 - 1) Make sure that there is an opening of 8.3 in. (21.1 cm) to 8.7 in. (22.1 cm) at the bottom of the bulkhead to let the radome drain.
- (b) Lift and hold the nose radome [1] in an open position.
- (c) Loosen the screws [6] of the hinge bracket [5].
- (d) Move the nose radome [1] forward to adjust the opening.
- (e) Tighten the screws [6] to 60 in-lb (7 N·m) - 75 in-lb (8 N·m).

SUBTASK 53-52-00-210-004

- (7) Examine the radome seal [1A] for rough and damaged areas.

SUBTASK 53-52-00-210-005

- (8) Make sure that the radome seal [1A] is bonded to the bulkhead along its entire length.

SUBTASK 53-52-00-020-006

- (9) If it is necessary to replace the radome seal [1A], do these steps:



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.

- (a) Clean the mating surfaces on the bulkhead with solvent, B00148, alcohol, B00068, or alcohol, B00130.
- (b) Fill the 1 in. (25 mm) to 1.25 in. (32 mm) ends of the radome seal [1A] with Dow Corning 3145 RTV adhesive, A00281.
- (c) Bond the radome seal [1A] to the bulkhead with Dow Corning 3145 RTV adhesive, A00281, along the entire length of the seal.
 - 1) Make sure that there is no seal at the bottom of bulkhead from RBL 5 in. (127 mm) to LBL 5 in. (127 mm).

NOTE: This is necessary for drainage.

- (d) Let the Dow Corning 3145 RTV adhesive, A00281, dry for 24 hours.

SUBTASK 53-52-00-210-006

- (10) Examine the clips [15] on the fuselage bulkhead as follows:
 - (a) Close the nose radome [1].
 - (b) Carefully examine the areas adjacent to the hinges for binding on the nose radome [1], when you move it to the closed position.

SUBTASK 53-52-00-020-007

- (11) If an adjustment is necessary, do these steps:
 - (a) Remove the screws [14] from the nose radome [1].
 - (b) Raise the nose radome [1] to the up position.

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- (c) Loosen the bolts [16] on the applicable clips [15] sufficient to allow them to move.
- (d) Move the clips [15] inboard.
- (e) Lower the nose radome [1] to the closed position.
- (f) Apply compound, D50004, to the threads of the screws [14].
- (g) Install the screws [14] on the nose radome [1].
- (h) Tighten the screws [14] sufficiently to put the clips into contact with the inner face of the nose radome [1].
- (i) Remove the screws [14].

SUBTASK 53-52-00-860-003

- (12) Open the nose radome [1] carefully to prevent movement of the adjusted clips [15].
 - (a) If the pressure sealant is removed from the bolts [16] that attach the clips [15], apply the sealant to make a sufficient seal (TASK 51-22-00-160-801).

SUBTASK 53-52-00-420-005

- (13) Tighten the bolts [16] that attach the clips [15] to 100 in-lb (11.3 N·m) - 125 in-lb (14.1 N·m).

SUBTASK 53-52-00-760-001

- (14) Use an intrinsically safe approved bonding meter, COM-1550, and measure the bond resistance between the clip [15] and the airplane structure (SWPM 20-20-00).
 - (a) Make sure that the bond resistance is 0.01 ohm (10 milliohms) or less.

SUBTASK 53-52-00-210-007

- (15) Make sure that the mating surfaces are clean and bright.

SUBTASK 53-52-00-420-009

- (16) Connect the bonding jumper [2].

SUBTASK 53-52-00-760-002

- (17) Use an intrinsically safe approved bonding meter, COM-1550, or non-intrinsically safe bonding meter, COM-614, to measure the resistance between the bonding jumper and the radome (SWPM 20-20-00).
 - (a) Make sure that the bond resistance is 0.001 ohm (1 milliohm) or less.

SUBTASK 53-52-00-210-008

- (18) With the nose radome [1] in a closed position, make sure that the screw holes of the nose radome [1] attachment are aligned with the holes in the attachment clips [15].

SUBTASK 53-52-00-420-006



DO NOT USE TOO MUCH FORCE TO ALIGN THE HOLES. YOU CAN CAUSE DAMAGE TO THE CLIPS AND THE RADOME.

- (19) If the adjustment is necessary, use manual force to adjust the nose radome [1] position to align the screw holes.

SUBTASK 53-52-00-420-007

- (20) Install the screws [14] with compound, D50004, in the aft edge of the nose radome [1].
 - (a) Tighten the screws [14] to 120 in-lb (13.6 N·m) - 150 in-lb (16.9 N·m).

SUBTASK 53-52-00-210-009

- (21) Make sure that the seal engages correctly and the nose radome [1] clearances are correct.

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G. Put the Airplane Back to Its Usual Condition

SUBTASK 53-52-00-860-004

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

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	7	C01678	WEATHER RADAR RT RIGHT

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	13	C00120	WEATHER RADAR RT

————— **END OF TASK** —————

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NOSE RADOME - INSPECTION/CHECK

1. General

- A. This procedure contains one task. This task is the check of the nose radome.

TASK 53-52-00-200-801

2. Nose Radome - Inspection

A. General

- (1) This task is for the inspection of the nose radome.

B. References

Reference	Title
05-51-19-210-802	Phase I Inspection (P/B 201)
05-51-19-210-803	Phase II Inspection (P/B 201)
53-52-00-000-802	Nose Radome Removal (P/B 401)
53-52-00-010-801	Nose Radome Open (P/B 201)
53-52-00-400-802	Nose Radome Installation (P/B 401)
53-52-00-410-801	Nose Radome Close (P/B 201)
53-52-03-000-801	Remove the Lightning Diverter Strips (P/B 201)
53-52-03-300-801	Lightning Diverter Strip Temporary Repair (P/B 801)
53-52-03-400-801	Install the Lightning Diverter Strip (P/B 201)
53-52-31-000-801	Glide Slope Director Bar Removal (P/B 401)
53-52-31-400-801	Glide Slope Director Bar Installation (P/B 401)
SRM 51-00-01	AIRPLANE REFERENCE
SRM 53-10-72	FUSELAGE NOSE RADOME - SECTION 41
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-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
COM-2010	Equipment - Moisture Indicator/Register, RADOME Part #: MRC005574 Supplier: 0CT97 Part #: MRC006507 Supplier: 0CT97

D. Location Zones

Zone	Area
111	Radome

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E. Nose Radome Inspection

SUBTASK 53-52-00-210-010

- (1) Do this task: Phase I Inspection, TASK 05-51-19-210-802 or Phase II Inspection, TASK 05-51-19-210-803.

SUBTASK 53-52-00-210-011

- (2) Do a check for damage such as holes, scuffs, cracks, blisters, and delamination.

NOTE: You can locate the delamination if you lightly hit the radome skin with a small metal object such as a short socket extension and listen for changes in the sound.

- (a) If there is damage, replace the radome (TASK 53-52-00-000-802 and TASK 53-52-00-400-802).

SUBTASK 53-52-00-280-001

- (3) Do a check for moisture as follows:

NOTE: Moisture that enters the honeycomb cells of a radome can cause the radar transmission to decrease. Periodic radome inspection is necessary to make sure that there is sufficient radar transmission.

NOTE: There are three radome moisture inspection methods. The recommended method 1 is the moisture meter inspection method. Two alternative methods are electronic thermography inspection method and liquid crystal sheets method, NDT 951-00-01 and SRM SUBJECT 51-00-01.

- (4) Method 1 - Use the moisture indicator/register RADOME equipment, COM-2010, to do a check for moisture as follows:

NOTE: The moisture indicator/register RADOME equipment, COM-2010, indicates pockets in aircraft radomes by measuring the radio frequency dielectric power loss of the material in contact with the moisture indicator/register RADOME equipment, COM-2010, gun. The radio frequency depth of penetration is approximately 2.5 in. (6.4 cm). Conductive materials such as water, aluminum, or metallic fasteners within 3 in. (7.6 cm) from the gun will cause the meter to read high. It is important that you remove all metallic parts from the area on the radome that is being tested for moisture content.

- (a) Hold the gun part of the moisture indicator/register RADOME equipment, COM-2010, a minimum of 3 in. (7.6 cm) from each part.
- (b) Push the ON-OFF switch, on the case, to the ON position.
- (c) Put the sensor head on the inner surface of the radome.
 - 1) Make sure that all the electrodes contact the radome surface.
 - 2) If it is necessary, apply light force to make sure that the sensor head contacts the radome surface.
- (d) Move the sensor head over all of the inner surface of the radome and do these steps:

NOTE: The sensor head must touch the full inner surface of the radome. To perform an adequate inspection, the sensor must be indexed at an interval of 1 in. (25 mm) or less.

 - 1) In areas that cause a meter reading of 20 or greater, put the sensor head away from the center of the indication.
 - 2) In an adjacent area with a reading of less than 20, monitor the meter reading when you move the sensor head to the center of the area.
- (e) To identify the area of entrapped water, make marks on the radome at the position of the electrodes closest to the entrapped water when the meter reading increases to 20.

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- (f) You must dry and then seal all of the areas where you find moisture.

NOTE: Do this step until the boundary of the entrapped water is marked.

- (g) If there is moisture, dry the radome and refer to SRM SUBJECT 53-10-72 to remove the moisture and seal it.

Table 601/53-52-00-993-801 RADOME CONDITION NUMERICAL SCALE

RADOME CONDITION	COLOR	NUMERICAL SCALE	ALLOWABLE SURFACE AREA of WATER
Good	Green	0 to 5	4 in. (102 mm) diameter or equivalent area
Fair	Yellow	5 to 10	
Poor	Orange	10 to 20	
NOTE: Unlimited 1-inch (25.4 mm) diameter areas of water are allowed if they are spaced more than 10 inches (254.0 mm) apart.			

- (5) Electronic Thermography (alternative) Inspection Method.

- (a) Refer to the NDT 951-00-01 for equipment, calibration and inspection instructions.

NOTE: The inspection can be performed from either side of the radome.

- (b) Examine the entire surface of the radome.

NOTE: Areas that contain entrapped water will appear cold.

- (c) Monitor the surface of the radome with the infrared camera while you use a marker to put a mark at the boundary of the entrapped water.

- (d) If the area that you marked is greater than the allowable area shown in Table 2, remove the moisture in the marked area and seal it (SRM SUBJECT 53-10-72).

- (6) Liquid Crystal (alternative) Inspection Method

- (a) Refer to the NDT 951-00-01 for equipment, calibration and inspection instructions.

NOTE: The inspection can be performed from either side of the radome.

- (b) Examine the entire surface of the radome.

NOTE: Areas that contain entrapped water will appear cold.

- (c) Monitor the surface of the radome with the liquid crystal sheets and do this step:

- 1) Use a marker to put a mark at the boundary layer of the entrapped water on the transparent template.

- (d) If the area that you marked is greater than the allowable area shown in Table 602, remove the moisture in the marked area and seal it (SRM SUBJECT 53-10-72).

Table 602/53-52-00-993-802 Table 2. RADAR CONDITION MOISTURE ACCEPTANCE CRITERIA

TABLE 2	
Moisture Meter Reject Level	Allowable Surface Area of Water
20	(4 in. (102 mm) diameter or equivalent area
<u>NOTE:</u> Unlimited 1-inch (25.4 mm) diameter areas of water are allowed if they are spaced more than 10 inches (254.0 mm) apart.	

SUBTASK 53-52-00-210-012

- (7) Examine the conductor strips for tears, loose areas, burned areas, and general deterioration.

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- (a) If there is damage, replace the radome (TASK 53-52-00-000-802 and TASK 53-52-00-400-802).

SUBTASK 53-52-00-210-017

- (8) Examine the aluminum diverter strips for loose fasteners, burned areas, and corrosion.

- (a) If there is damage, repair or replace the diverter strips:
- Lightning Diverter Strip Temporary Repair, TASK 53-52-03-300-801
 - Remove the Lightning Diverter Strips, TASK 53-52-03-000-801
 - Install the Lightning Diverter Strip, TASK 53-52-03-400-801.

SUBTASK 53-52-00-010-004

- (9) Open the nose radome (TASK 53-52-00-010-801).

SUBTASK 53-52-00-280-002

- (10) Measure the electrical bonding resistance between the ends of the diverter strips (SWPM 20-20-00).

- (a) Use an intrinsically safe approved bonding meter, COM-1550.
NOTE: Use a test probe with a sharp point to go through the paint or epoxy on the strip.
- (b) Make sure that the electrical bonding resistance is 0.01 ohms or less.

SUBTASK 53-52-00-760-003

- (11) Measure the electrical resistance between the points in Reference Not Currently Available.

- (a) Use an intrinsically safe approved bonding meter, COM-1550.
- (b) Make sure that the electrical bonding resistance is 0.01 ohms or less.

SUBTASK 53-52-00-410-007

- (12) Close the nose radome (TASK 53-52-00-410-801).

SUBTASK 53-52-00-760-004

- (13) Measure the electrical bonding resistance between the diverter strips on the radome and body structure skin.

- (a) Use an intrinsically safe approved bonding meter, COM-1550.
- (b) Make sure that the resistance is 0.01 ohms or less.

SUBTASK 53-52-00-760-005

- (14) Measure the electrical resistance between the diverter strip and airframe.

- (a) Use an intrinsically safe approved bonding meter, COM-1550.
- (b) Make sure that the resistance is less than 0.03 ohms.

SUBTASK 53-52-00-210-014

- (15) Do a check for damage of the director bar for the glide slope antenna.

NOTE: The antenna director bar is a 13 in. (33 cm) continuous strip of aluminum foil tape. The strip is installed horizontally across the centerline on the inner surface of the nose radome.

SUBTASK 53-52-00-210-015

- (16) Make sure that the attachment of the director bar is satisfactory.

SUBTASK 53-52-00-960-001

- (17) If you find damage or an unsatisfactory bond of the director bar for the glide slope antenna, replace the director bar (TASK 53-52-31-000-801 and TASK 53-52-31-400-801).

————— **END OF TASK** —————

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NOSE RADOME - CLEANING/PAINTING

1. General

- A. This procedure contains these tasks:
(1) Nose Radome Cleaning/Painting

TASK 53-52-00-370-801

2. Nose Radome Cleaning and Painting

A. General

- (1) This task is for the cleaning and painting of the nose radome.

B. References

Reference	Title
51-21-11 P/B 701	PAINT STRIPPING - CLEANING/PAINTING
51-21-21-100-802	Cleaning and Preparation of Internal and External Plastic Surfaces (P/B 701)
51-21-71-370-801	Apply BMS 10-21 Type II Conductive Coating To Specified External Surfaces (P/B 701)
51-21-71-370-803	Apply BMS 10-21 Type IV Conductive Coating To Specified External Surfaces (P/B 701)
51-21-72-370-802	BMS10-103, Type 1, Primer - Application (P/B 701)
51-21-73-370-802	BMS10-60 Topcoat Application (P/B 701)
51-21-99-300-801	Decorative Exterior Paint System Application (P/B 701)
53-52-03-000-801	Remove the Lightning Diverter Strips (P/B 201)
53-52-03-400-801	Install the Lightning Diverter Strip (P/B 201)
SRM 53-10-72-2R-0	Nose Radome Data

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

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Reference	Description
SPL-7885	Probe - Surface Resistivity Measurement Part #: ST895A-3-1 Supplier: 81205
SPL-10361	Probe - Film Resistance Measure Part #: F70328-1 Supplier: 81205 Opt Part #: ST895A-1 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
B50073	Alcohol - Isopropyl	ASTM D 770
C00766	Primer - Nonchromated Primer For Composites	BMS10-103 Type I
C00841	Coating - Anti-Static Coating	BMS10-21 Type II
C00921	Coating - Exterior Decorative Paint	BMS10-72
C50075	Coating - Protective Enamel (BAC 707 Gray Color)	BMS10-60 Type II
C50219	Coating - Anti-Static Coating	BMS10-21 Type IV
C50316	Coating - Exterior Decorative Paint	AMS3095
G02219	Tape - Yellow Vinyl Adhesive, Scotch Brand No.471, 1.5 Inches (38.1 mm) Wide	
G50123	Rag - Epoxy Coated Tack Rag - C-60	
G50220	Pad - Abrasive, Scotch- Brite 7447	
G50509	Tape - Masking (3M Scotch Fine Line Tape 218)	AMS-T-21595
G50630	Tape - Copper Foil With Conductive Adhesive (3M 1181 Tape)	

E. Location Zones

Zone	Area
111	Radome

F. Prepare to Paint the Nose Radome

SUBTASK 53-52-00-000-005

- (1) Remove the lightning diverter strips from the radome (TASK 53-52-03-000-801).

NOTE: Identify the lightning diverter strips for re-installation.

SUBTASK 53-52-00-370-001

- (2) Use Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, to mask-off the conductor straps and holes from the removed lightning diverter strips on the radome.

- (a) Make sure that coating, C00841, or coating, C50219, does not enter the conductor straps and holes from the removed lightning diverter strips on the radome.

SUBTASK 53-52-00-150-001

- (3) Remove the existing paint (PAGEBLOCK 51-21-11/701).

NOTE: This step is to make sure that the paint thicknesses are minimized.

SUBTASK 53-52-00-100-003

- (4) Clean and prepare the surface of the nose radome (TASK 51-21-21-100-802).

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G. Paint the Nose Radome

SUBTASK 53-52-00-370-002

NOTE: Thicknesses of paint which are more than 0.01 in. (0.254 mm) can decrease the necessary radome electrical transmission efficiency. A radome wall that has been repainted should be put back to its initial thickness, including paint thickness. If this is not done, radome transmission efficiency will be decreased (SRM PROCEDURE 53-10-72-2R-0).

- (1) Apply coating, C00841, or coating, C50219, to the entire nose radome surface (Figure 702 and Figure 703).
 - (a) To apply coating, C00841, do this task: Apply BMS 10-21 Type II Conductive Coating To Specified External Surfaces, TASK 51-21-71-370-801.
 - (b) To apply coating, C50219, do this task: Apply BMS 10-21 Type IV Conductive Coating To Specified External Surfaces, TASK 51-21-71-370-803.
 - (c) If the anti-static coating is not overcoated within 24 hours do the steps that follow prior to painting the next layer:
 - 1) Solvent clean using alcohol, B50073.
 - 2) Lightly abrade with very fine abrasive pad, Scotch-Brite 7447 pad, G50220.
 - 3) Solvent clean using alcohol, B50073.
 - 4) If it is necessary, use a tack rag, G50123, to remove particulate contamination.
 - 5) Visually inspect anti-static coating surface and verify that the coating is continuous (free from bare areas).

SUBTASK 53-52-00-370-003

- (2) Determine the surface resistivity of the coating, C00841, or coating, C50219, using one of the methods that follow:
 - (a) To determine the surface resistivity using the square method, do the steps that follow:
 - 1) Cut two pieces of flexible bare 3M 1181 copper foil tape, G50630, with conductive adhesive each of length "L" (Figure 704).
 - 2) Place the two pieces of tape at a distance of "0.1L ± 5 percent" and parallel to each other (Figure 704).
 - 3) Press the two pieces of tape firmly against the anti-static coating.
 - 4) Connect the Ohmmeter probes to the tape (Figure 704).
 - 5) Read the number for resistance.
 - 6) Multiply the number for resistance by 10.

NOTE: The result is the resistivity of the anti-static coating.
 - 7) Make sure that the resistivity is between 1 and 100 megohms per square (square of any dimension).
 - a) If the surface resistivity of the coating, C00841, or coating, C50219, is less than 1 megohm per square, do the steps that follow (refer to the relevant section within this task):
 - <1> Remove the coating, C00841, or coating, C50219.
 - <2> Clean and prepare the surface.
 - <3> Re-apply the coating, C00841, or coating, C50219.
 - <4> Determine the resistivity again.

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<5> Repeat once if necessary.

NOTE: Contact Liaison engineering if resistivity requirements are not met after second processing.

b) If the surface resistivity of the coating, C00841, or coating, C50219, is more than 100 megohms per square, do the steps that follow:

<1> Cure at 140°F (60°C) to 160°F (71°C) for 60 to 70 minutes.

<2> Determine the resistivity again.

<3> If the resistivity is not between 1 and 100 megohms repeat the resolution steps.

8) Remove copper tape after completion of the measurement.

(b) To determine the surface resistivity of the coating, C00841, or coating, C50219, using a surface resistivity measurement probe, SPL-7885, do the steps that follow:

1) Connect the digital/analog multimeter, COM-1793, to the surface resistivity measurement probe, SPL-7885 (Figure 705).

2) Place surface resistivity measurement probe, SPL-7885, on the conductive coating.

3) Read the number for the resistance.

4) Multiply the number for resistance by 10.

NOTE: The result is the resistivity of the anti-static coating.

5) Make sure that the resistivity is between 1 and 100 megohms per square.

a) If the surface resistivity of the coating, C00841, or coating, C50219, is less than 1 megohm per square, do the steps that follow (refer to the relevant section within this task):

<1> Remove the coating, C00841, or coating, C50219.

<2> Clean and prepare the surface.

<3> Re-apply the coating, C00841, or coating, C50219.

<4> Determine the resistivity again.

<5> Repeat once if it is necessary.

NOTE: Contact Liaison engineering if resistivity requirements are not met after second processing.

b) If the surface resistivity of the coating, C00841, or coating, C50219, is more than 100 megohms, do the steps that follow:

<1> Cure at 140°F (60°C) to 160°F (71°C) for 60 to 70 minutes.

<2> Determine the resistivity again.

<3> If the resistivity is not between 1 and 100 megohms repeat the resolution steps.

(c) To determine the surface resistivity of the coating, C00841, or coating, C50219, using the Fastener-to-Conductive Surface Test Method, do the steps that follow:

NOTE: The resistivity of the conductive coating after it is cured must be between 1 and 100 megohms per square.

NOTE: Let the conductive coat cure for the specified time before you measure the conductivity (Figure 706).

1) If the bonding surface and the head of the fastener are covered with a finish, do the steps as follows (Figure 707):

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- a) Remove a sufficient quantity of the outer coating or paint to let the probes touch the conductive finish.

NOTE: If it is necessary, the probes can be pushed through the outer coating.

- b) Put the digital/analog multimeter, COM-1793, with the film resistance measure probe, SPL-10361, in direct contact with the bonding fastener and the conductive finish.

<1> Put the film resistance measure probe, SPL-10361, 1.00 ±0.25 in. (25.40 ±6.35 mm) apart (Figure 707).

- c) Record the value of the resistivity shown on the multimeter.

<1> The minimum allowable resistivity is 1 megohm per square.

<2> The maximum allowable resistivity is 100 megohm per square.

- d) To determine the surface resistivity of the coating, C00841, or coating, C50219, using the Fastener-to-Fastener Test Method, do the steps that follow:

NOTE: The resistivity of the conductive coating after it is cured must be between 1 and 100 megohms per square.

- 1) Make sure the conductive coating shows in the fastener location.
- 2) Clean the area with alcohol, B50073.
- 3) Install one temporary fastener at each fastener location to be measured (Figure 707).

NOTE: This procedure can be used for measuring electrical resistivity of panels with covered (painted) conductive coatings when the ground fastener locations show.

- 4) Connect the digital/analog multimeter, COM-1793, probes at the two fastener locations (Figure 707).
- 5) Record the value of the resistivity with the digital/analog multimeter, COM-1793.
 - a) The minimum allowable resistivity is 1 megohm per square.
 - b) The maximum allowable resistivity is 100 megohm per square.
- 6) Remove the temporary fasteners from the surface.

SUBTASK 53-52-00-840-001

- (3) Install the lightning diverter strips (TASK 53-52-03-400-801).

SUBTASK 53-52-00-950-001

- (4) Use Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, to mask-off the exterior surface of the radome, except for a 5 in. (12.7 cm) vertical band from STA. 138.6 to STA. 143.6 (Figure 701).

SUBTASK 53-52-00-370-004

- (5) Apply a second coat of coating, C00841, or coating, C50219, to the exposed vertical band area (Figure 703).
 - (a) To apply coating, C00841, do this task: Apply BMS 10-21 Type II Conductive Coating To Specified External Surfaces, TASK 51-21-71-370-801.
 - (b) To apply coating, C50219, do this task: Apply BMS 10-21 Type IV Conductive Coating To Specified External Surfaces, TASK 51-21-71-370-803.
 - (c) If the anti-static coating is not overcoated within 24 hours do the following prior to painting the next layer:

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- 1) Solvent clean using alcohol, B50073.
- 2) Lightly abrade with very fine abrasive pad, Scotch-Brite 7447 pad, G50220.
- 3) Solvent clean using alcohol, B50073.
- 4) If necessary, use a tack rag, G50123, to remove particulate contamination.
- 5) Visually inspect anti-static coating surface and verify that the coating is continuous (free from bare areas).

SUBTASK 53-52-00-860-005

- (6) Determine the surface resistivity of the coating, C00841, or coating, C50219, using one of the following methods:
 - (a) To determine the surface resistivity using the square method, do the steps that follow:
 - 1) Cut two pieces of flexible bare 3M 1181 copper foil tape, G50630, with conductive adhesive each of length "L" (Figure 704).
 - 2) Place the two pieces of tape at a distance of "0.1L ± 5 percent" and parallel to each other (Figure 704).
 - 3) Press the two pieces of tape firmly against the anti-static coating.
 - 4) Connect the Ohmmeter probes to the tape (Figure 704).
 - 5) Read the number for resistance.
 - 6) Multiply the number for resistance by 10. The result is the resistivity of the anti-static coating.
 - 7) Make sure that the resistivity is between 1 and 100 megohms.
 - a) If the surface resistivity of the coating, C00841, or coating, C50219, is less than 1 megohm per square (square of any dimension), do the steps that follow (refer to the relevant section within this task):
 - <1> Remove the coating, C00841, or coating, C50219.
 - <2> Clean and prepare the surface.
 - <3> Re-apply the coating, C00841, or coating, C50219.
 - <4> Determine the resistivity again.
 - <5> Repeat once if necessary. Contact Liaison engineering if resistivity requirements are not met after second processing.
 - b) If the surface resistivity of the coating, C00841, or coating, C50219, is more than 100 megohms, do the steps that follow:
 - <1> Cure at 140°F (60°C) to 160°F (71°C) for 60 to 70 minutes.
 - <2> Determine the resistivity again.
 - <3> If the resistivity is not between 1 and 100 megohms repeat the resolution steps.
 - 8) Remove copper tape after completion of the measurement.
 - (b) To determine the surface resistivity of the coating, C00841, or coating, C50219, using a surface resistivity measurement probe, SPL-7885, do the steps that follow:
 - 1) Connect the digital/analog multimeter, COM-1793, to the surface resistivity measurement probe, SPL-7885 (Figure 705).
 - 2) Place surface resistivity measurement probe, SPL-7885, on the conductive coating.
 - 3) Read the number for the resistance.

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- 4) Multiply the number for resistance by 10. The result is the resistivity of the anti-static coating.
- 5) Make sure that the resistivity is between 1 and 100 megohms.
 - a) If the surface resistivity of the coating, C00841, or coating, C50219, is less than 1 megohm per square (square of any dimension), do the steps that follow (refer to the relevant section within this task):
 - <1> Remove the coating, C00841, or coating, C50219.
 - <2> Clean and prepare the surface.
 - <3> Re-apply the coating, C00841, or coating, C50219.
 - <4> Determine the resistivity again.
 - <5> Repeat once if necessary. Contact Liaison engineering if resistivity requirements are not met after second processing.
 - b) If the surface resistivity of the coating, C00841, or coating, C50219, is more than 100 megohms, do the steps that follow:
 - <1> Cure at 140°F (60°C) to 160°F (71°C) for 60 to 70 minutes.
 - <2> Determine the resistivity again.
 - <3> If the resistivity is not between 1 and 100 megohms repeat the resolution steps.
- (c) To determine the surface resistivity of the coating, C00841, or coating, C50219, using the Fastener-to-Conductive Surface Test Method, do the steps that follow:

NOTE: The resistivity of the conductive coating after it is cured must be between 1 and 100 megohms per square.

NOTE: Let the conductive coat cure for the specified time before you measure the conductivity (Figure 706).

 - 1) If the bonding surface and the head of the fastener are covered with a finish, do the steps as follows (Figure 707):
 - a) Remove a sufficient quantity of the outer coating or paint to let the probes touch the conductive finish.

NOTE: If it is necessary, the probes can be pushed through the outer coating.
 - b) Put the digital/analog multimeter, COM-1793, with the film resistance measure probe, SPL-10361, in direct contact with the bonding fastener and the conductive finish.
 - <1> Put the film resistance measure probe, SPL-10361, 1.00 ±0.25 in. (25.40 ±6.35 mm) apart (Figure 707).
 - c) Record the value of the resistivity shown on the multimeter.
 - <1> The minimum allowable resistivity is 1 megohm per square.
 - <2> The maximum allowable resistivity is 100 megohm per square.
- (d) To determine the surface resistivity of the coating, C00841, or coating, C50219, using the Fastener-to-Fastener Test Method, do the steps that follow:

NOTE: The resistivity of the conductive coating after it is cured must be between 1 and 100 megohms per square.

 - 1) Make sure the conductive coating shows in the fastener location.
 - 2) Clean the area with alcohol, B50073.

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- 3) Install one temporary fastener at each fastener location to be measured (Figure 707).

NOTE: This procedure can be used for measuring electrical resistivity of panels with covered (painted) conductive coatings when the ground fastener locations show.

- 4) Connect the digital/analog multimeter, COM-1793, probes at the two fastener locations (Figure 707).
- 5) Record the value of the resistivity with the digital/analog multimeter, COM-1793.
 - a) The minimum allowable resistivity is 1 megohm per square.
 - b) The maximum allowable resistivity is 100 megohm per square.
- 6) Remove the temporary fasteners from the surface.

SUBTASK 53-52-00-370-005

- (7) Remove the Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219.

SUBTASK 53-52-00-950-002

- (8) Use Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, to mask-off a 5 in. (12.7 cm) vertical band from STA. 138.6 to STA. 143.6 (Figure 701).

SUBTASK 53-52-00-370-006

- (9) Apply 0.3 mil (0.0076 mm) - 0.8 mil (0.0203 mm) of primer, C00766, from the radome tip to STA 138.6 and from STA 143.6 to the aft edge of the radome (Figure 702).

- (a) To apply the primer, C00766, do this task: BMS10-103, Type 1, Primer - Application, TASK 51-21-72-370-802.

SUBTASK 53-52-00-370-007

NOTE: If coating, C00921, or coating, C50316, is applied to the nose radome, either coating can be applied in lieu of coating, C50075, in an effort to minimize total paint thickness on the nose radome.

- (10) Use Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, to mask-off the radome tip to STA 138.6 (Figure 701).
- (11) Apply 1.4 mils (0.0356 mm) - 2.4 mils (0.0610 mm) of coating, C50075, from STA 143.6 to the aft edge of the radome (Figure 702).
 - (a) To apply the coating, C50075, do this task: BMS10-60 Topcoat Application, TASK 51-21-73-370-802.
- (12) Remove the Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, from the radome tip to STA 138.6.

NOTE: Do not remove Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, from STA 138.6 to STA 143.6.

SUBTASK 53-52-00-950-003

- (13) Use Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, to mask-off the area from STA 143.6 to the aft edge of the radome (Figure 701).

SUBTASK 53-52-00-370-008

- (14) Apply 8 mils (0.2032 mm) - 10 mils (0.2540 mm) of coating, C50075, from the radome tip to STA 138.6 (Figure 702).

NOTE: If coating, C00921, or coating, C50316, is applied to the nose radome, either coating can be applied in lieu of coating, C50075, in an effort to minimize total paint thickness on the nose radome.

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- (a) To apply the coating, C50075, do this task: BMS10-60 Topcoat Application, TASK 51-21-73-370-802.

SUBTASK 53-52-00-950-004

- (15) Remove the Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, from the 5 in. (127 mm) vertical band from STA 138.6 to STA 143.6.
- (16) Use Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, to mask-off the radome tip to STA 138.6 (Figure 701).

SUBTASK 53-52-00-370-009

- (17) Apply decorative primer on 5 in. (13 cm) vertical band from STA 138.6 to STA 143.6, do this task: Decorative Exterior Paint System Application, TASK 51-21-99-300-801.
- (18) Remove all the Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219.

SUBTASK 53-52-00-370-010

- (19) Apply decorative paint to the entire surface of the radome, do this task: Decorative Exterior Paint System Application, TASK 51-21-99-300-801.

NOTE: Refer to your livery drawing requirements.

———— **END OF TASK** ————

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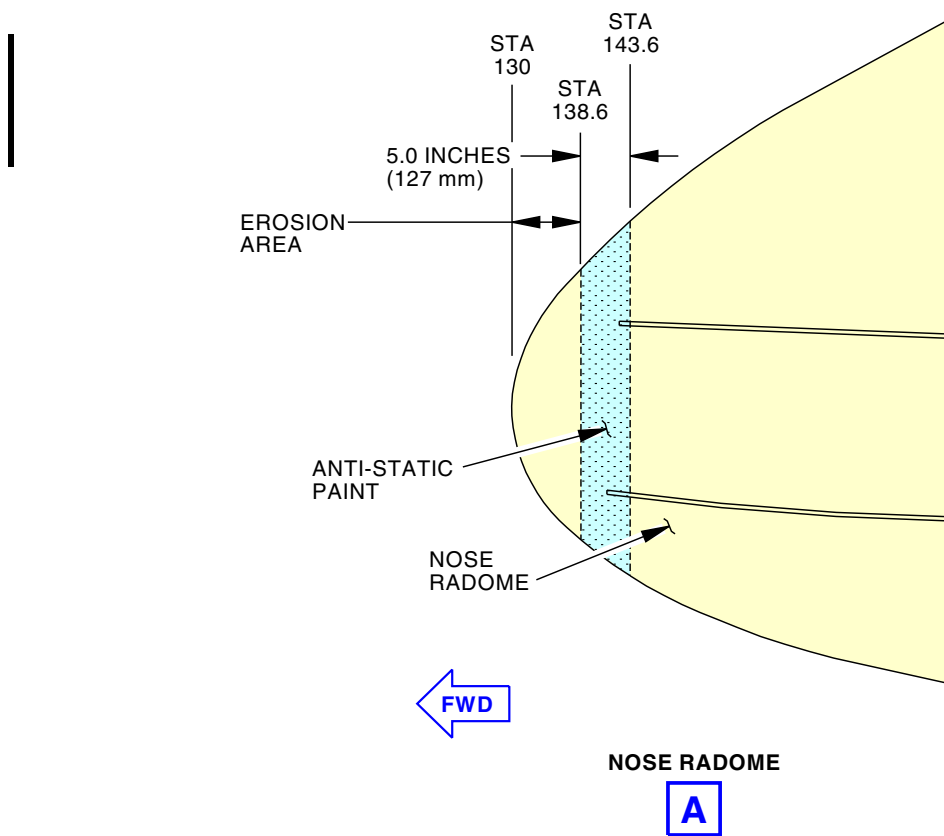
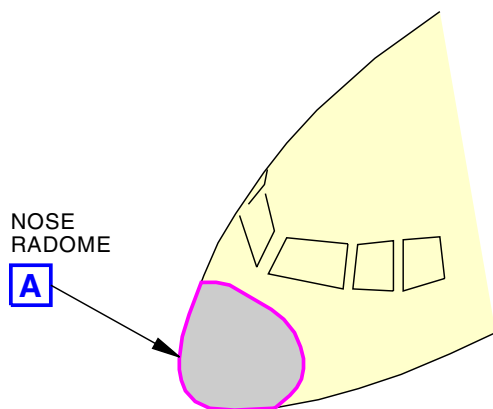
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Nose Radome anti-static band
Figure 701/53-52-00-990-804

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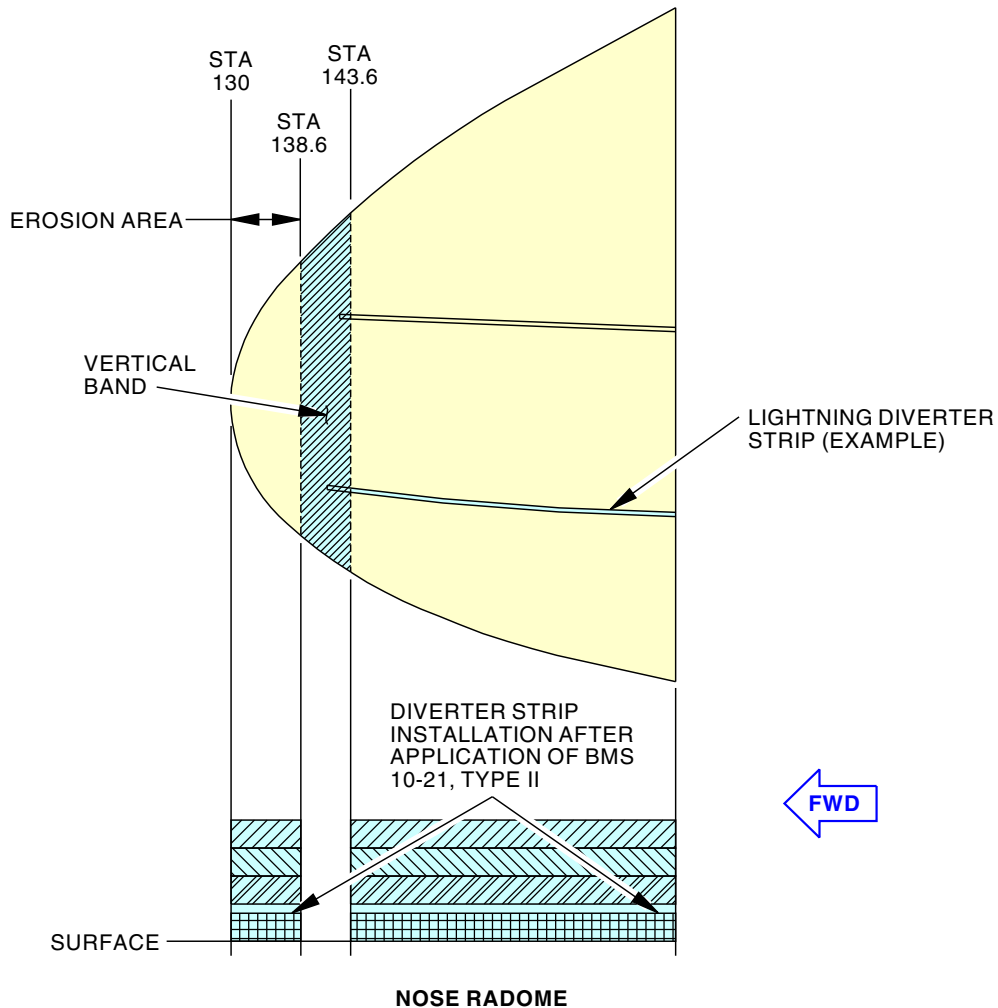
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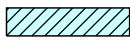
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LEGEND:

-  BMS 10-72 DECORATIVE COATING (TOPCOAT) OR AMS3095 EXTERIOR GLOSS PAINT
-  BMS 10-60 TYPE II ENAMEL COATING
-  BMS 10-103 TYPE I PRIMER (PREFERRED) OR BMS 10-79, TYPE II PRIMER (ALTERNATE)
-  BMS 10-21, TYPE II ANTI-STATIC COATING

2416196 S00061539961_V2

Nose Radome Painting - Nose Tip to STA 138.6 and STA 143.6 to Aft Edge
Figure 702/53-52-00-990-805

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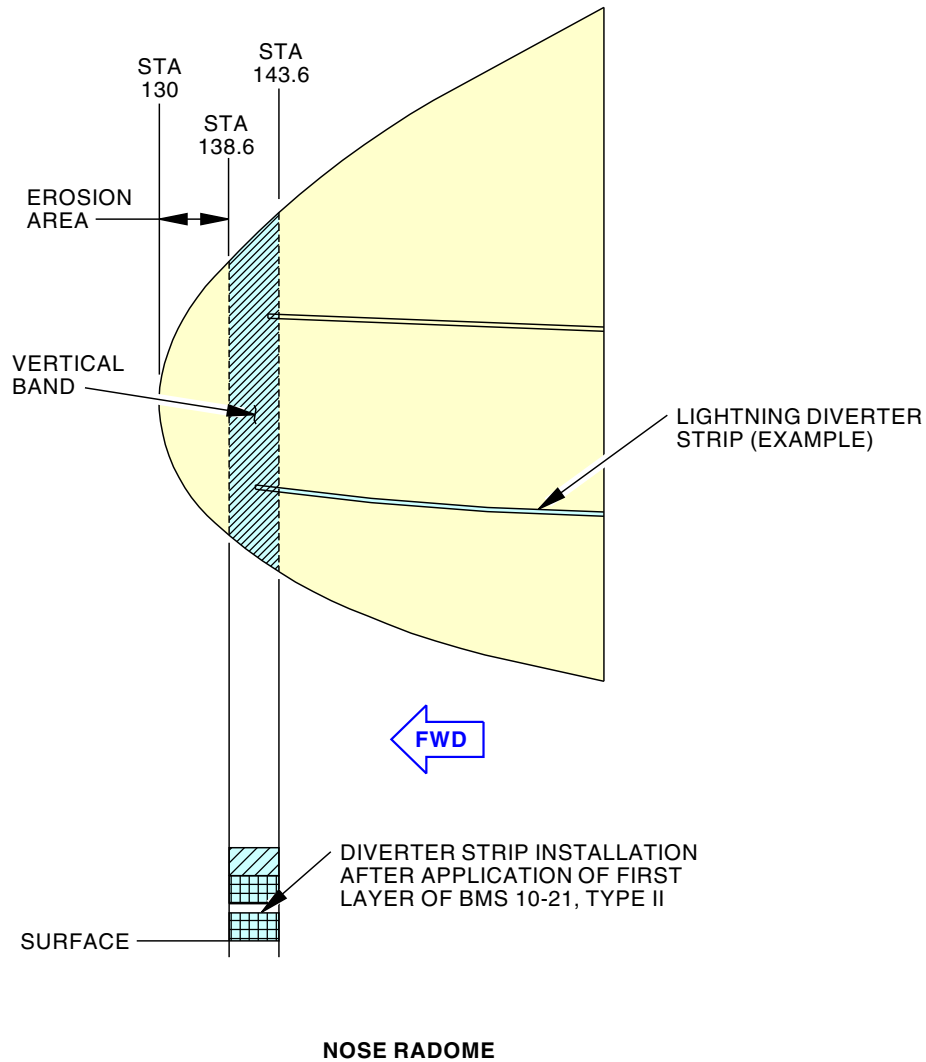
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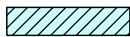
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LEGEND:

-  BMS 10-72 DECORATIVE COATING (TOPCOAT) OR AMS3095 EXTERIOR GLOSS PAINT
-  BMS 10-21, TYPE II ANTI-STATIC COATING

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Nose Radome Painting - STA 138.6 to STA 143.6
Figure 703/53-52-00-990-806

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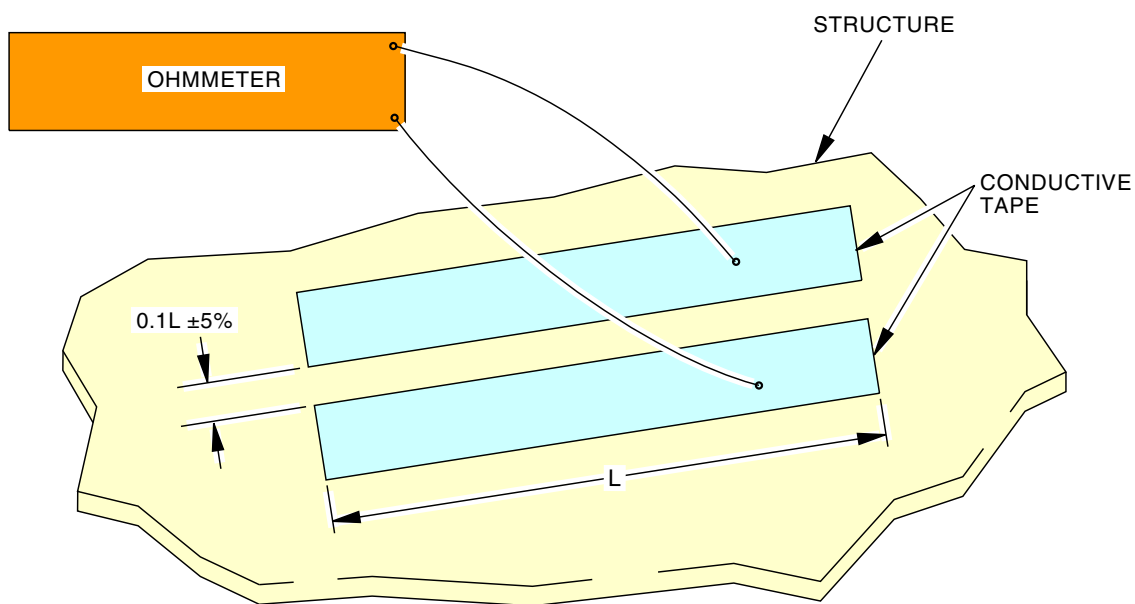
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Resistance Measurement Using Square Method
Figure 704/53-52-00-990-807

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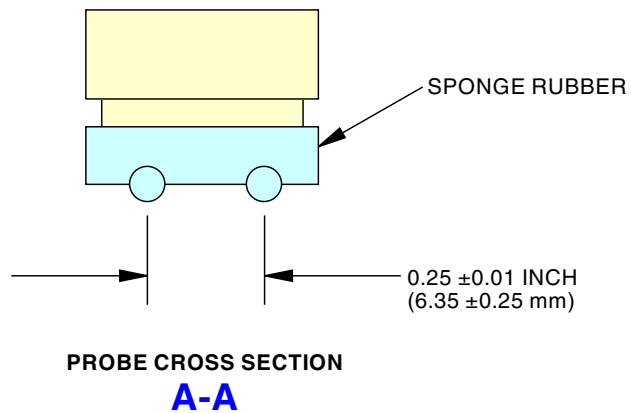
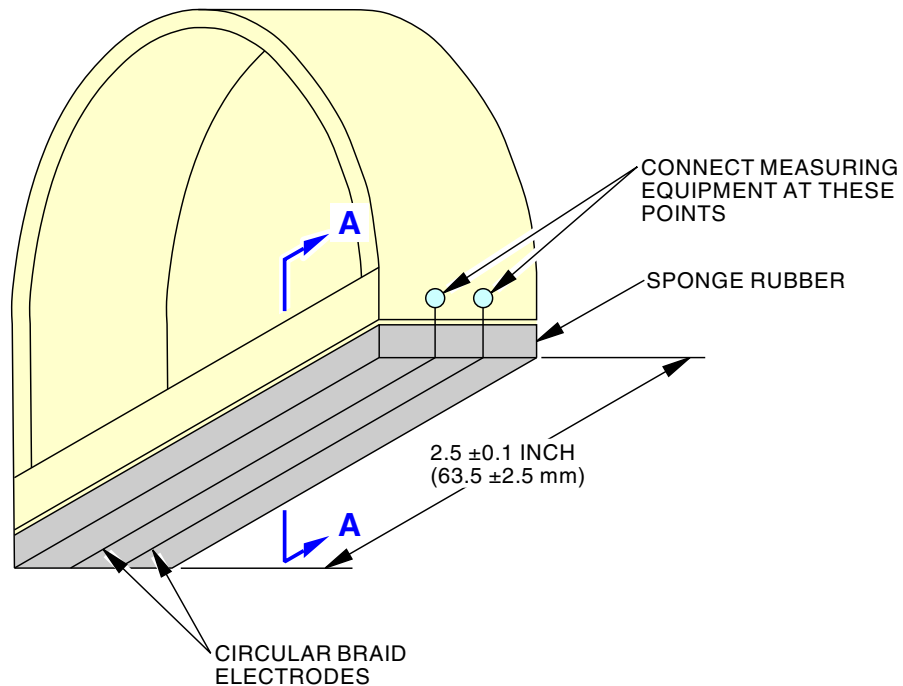
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2416199 S00061539964_V1

ST895A-3 Resistivity Probe
Figure 705/53-52-00-990-808

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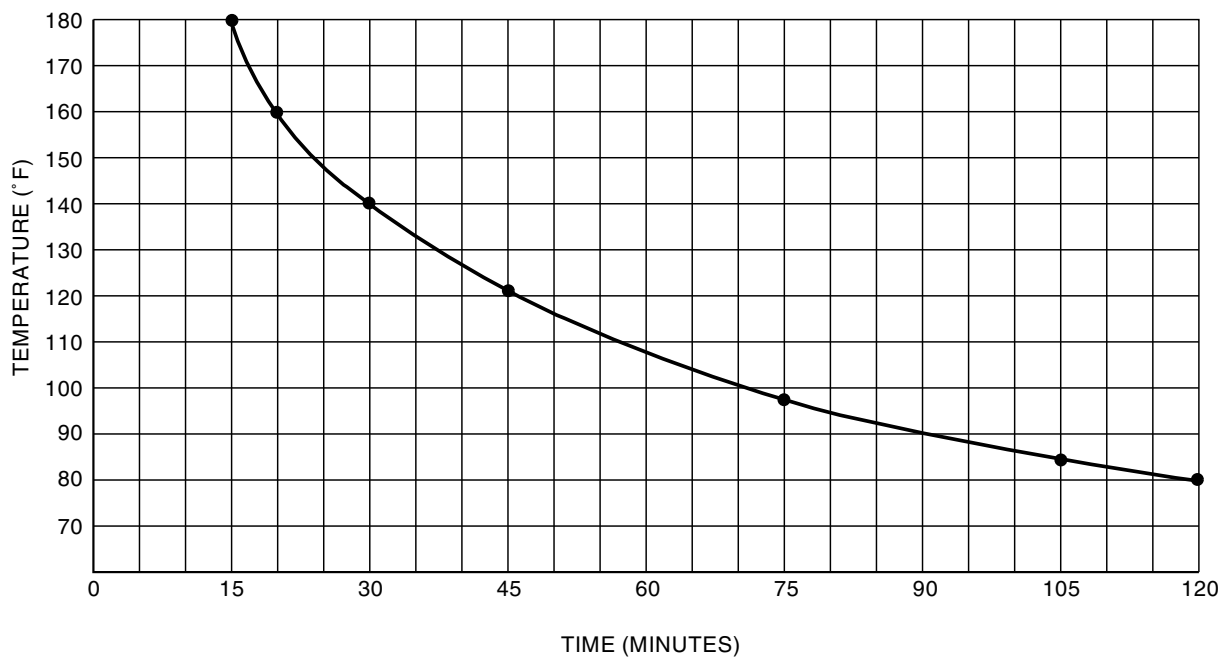
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2545539 S0000604821_V1

Conductive Coating Increased Cure Times
Figure 706/53-52-00-990-811

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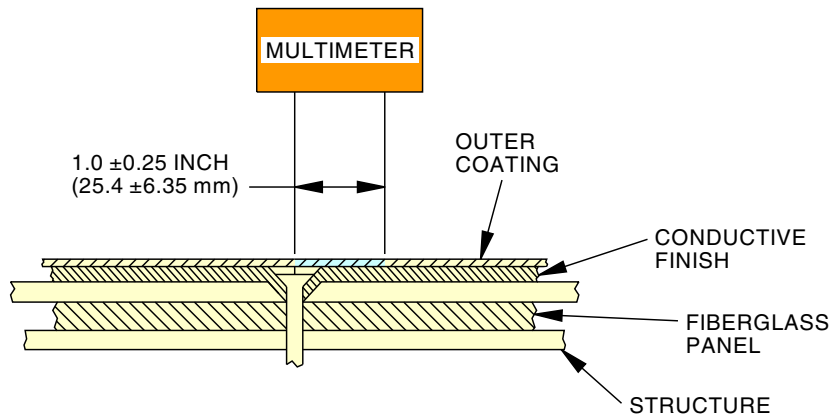
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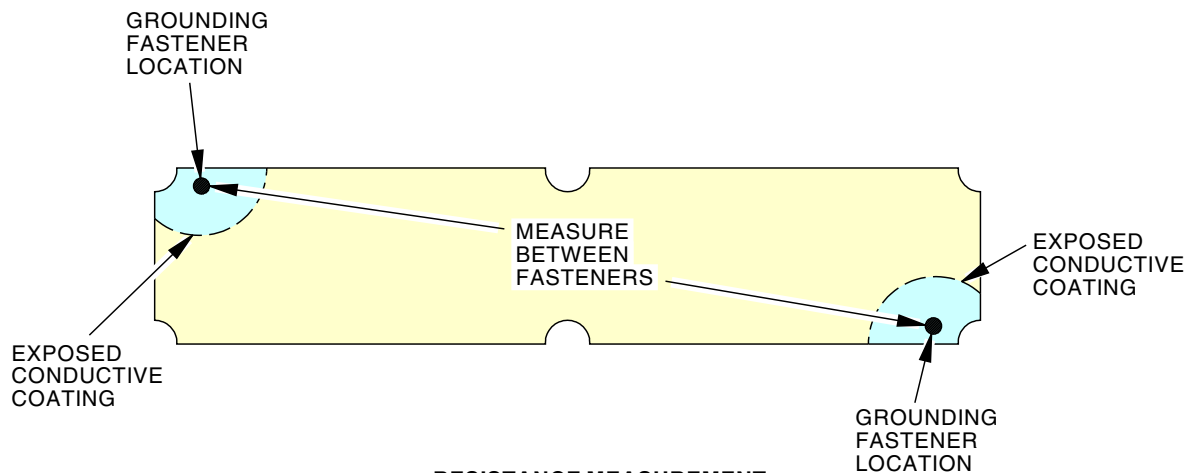
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RESISTANCE MEASUREMENT
OF CONDUCTIVE FINISH



RESISTANCE MEASUREMENT
OF CONDUCTIVE FINISH WITH
EXPOSED FASTENERS

2545542 S0000604822_V1

Resistance Measurement of Conductive Finish
Figure 707/53-52-00-990-812

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LIGHTNING DIVERTER STRIPS - MAINTENANCE PRACTICES

1. General

- A. This procedure contains the following tasks:
- (1) A removal of the lightning diverter strips
 - (2) An installation of the lightning diverter strips
 - (3) An adjustment/test of the lightning diverter strips.
- B. Repair the damaged radome surface before installation of the new lightning diverter strips.

TASK 53-52-03-000-801

2. Remove the Lightning Diverter Strips

(Figure 201)

A. **References**

Reference	Title
53-52-00-000-802	Nose Radome Removal (P/B 401)
53-52-00-010-801	Nose Radome Open (P/B 201)

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 CLA)

C. **Location Zones**

Zone	Area
111	Radome

D. **Lightning Diverter Strips Removal**

SUBTASK 53-52-03-010-001

- (1) Remove or open the nose radome [1] and keep it in the open position (TASK 53-52-00-000-802 or TASK 53-52-00-010-801).

SUBTASK 53-52-03-020-001

- (2) Remove the screws that attach the diverter strips [3] to the nose radome [1] (Figure 201).

SUBTASK 53-52-03-020-002

- (3) Remove the diverter strip [3] from the nose radome [1].

SUBTASK 53-52-03-100-001

- (4) Remove all unwanted material from the nose radome [1] surface.

SUBTASK 53-52-03-100-002

- (5) Clean the nose radome [1] surface with a cotton wiper, G00034, that is moist with solvent, B00083.

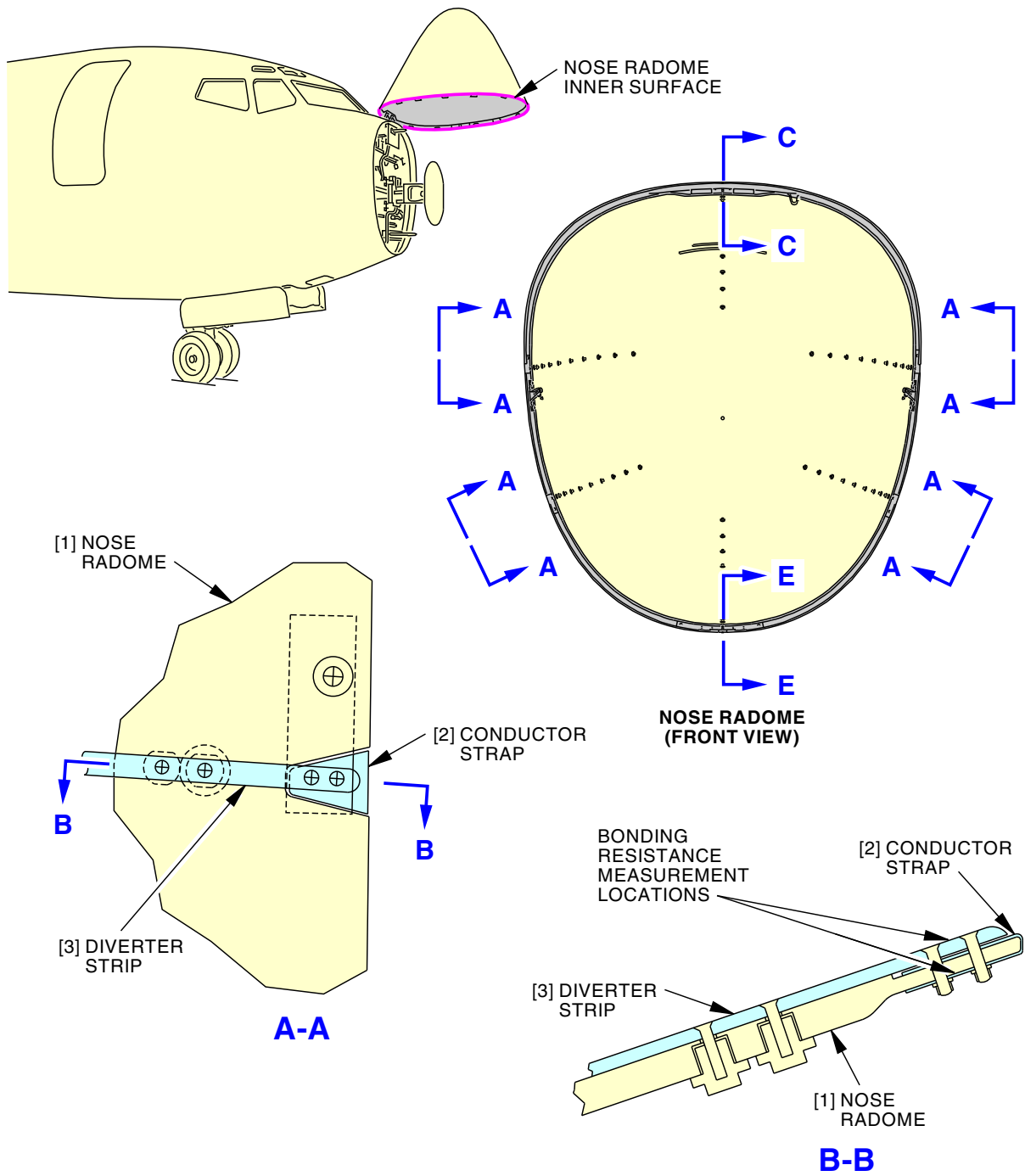
————— **END OF TASK** —————

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2416200 S00061539970_V2

Lightning Diverter Strip
Figure 201/53-52-03-990-803 (Sheet 1 of 3)

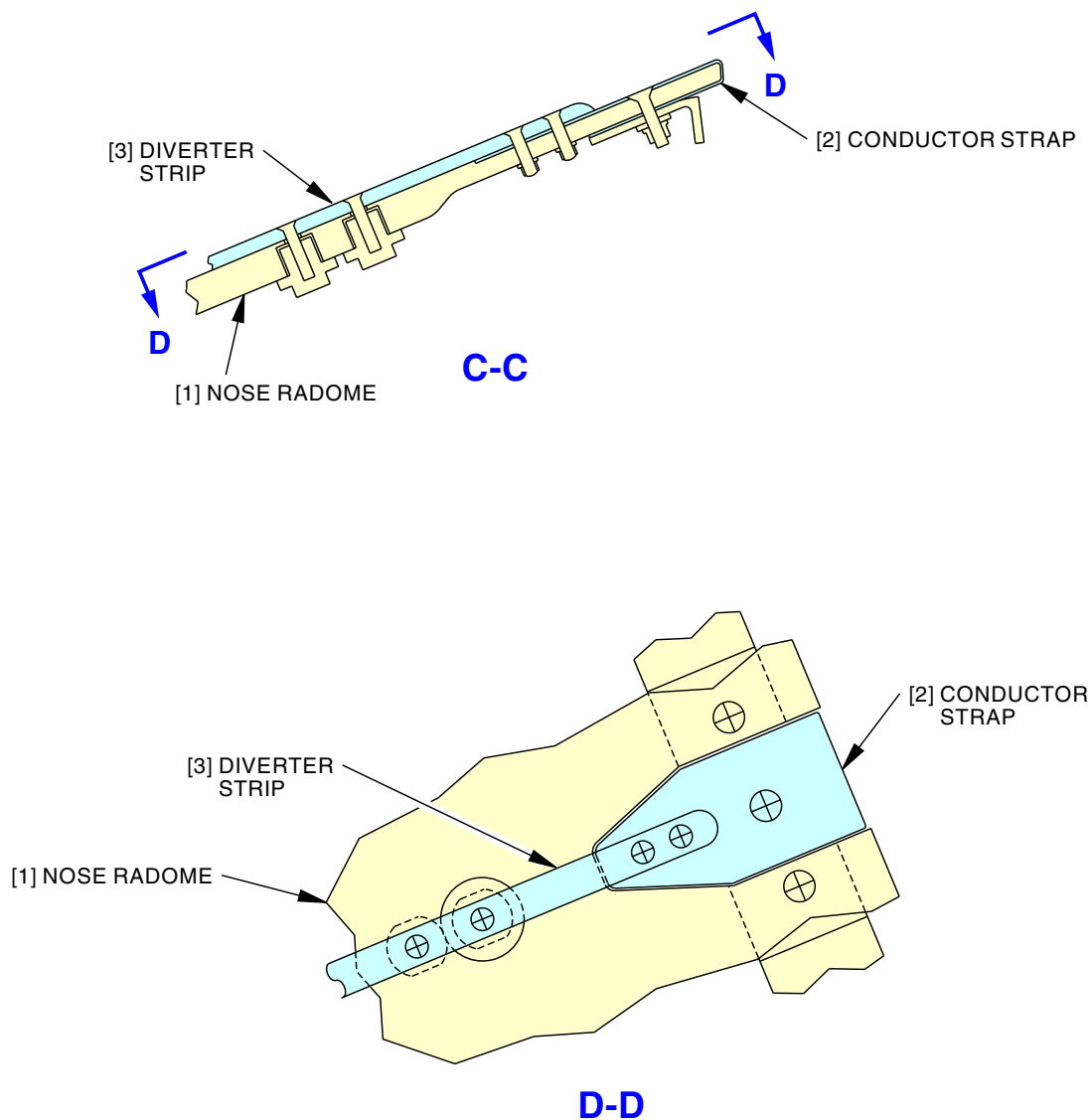
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3043663 S0000810672_V1

Lightning Diverter Strip
Figure 201/53-52-03-990-803 (Sheet 2 of 3)

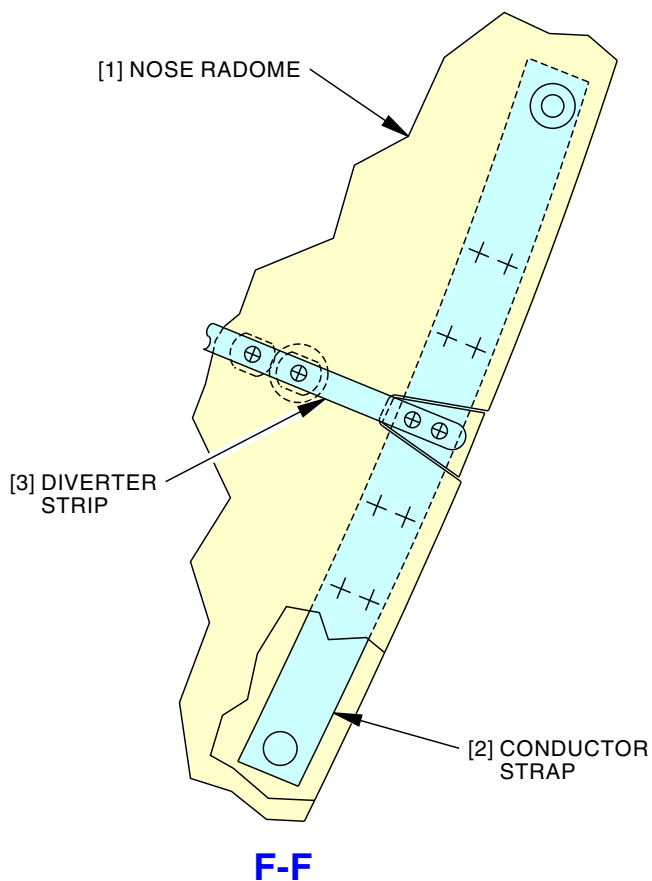
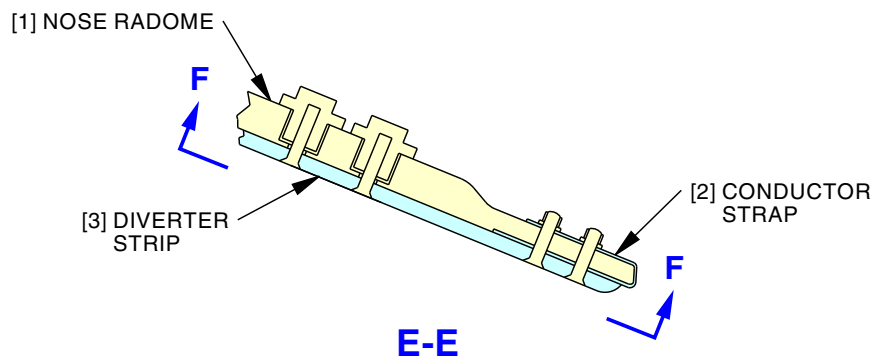
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3043664 S0000810674_V1

Lightning Diverter Strip
Figure 201/53-52-03-990-803 (Sheet 3 of 3)

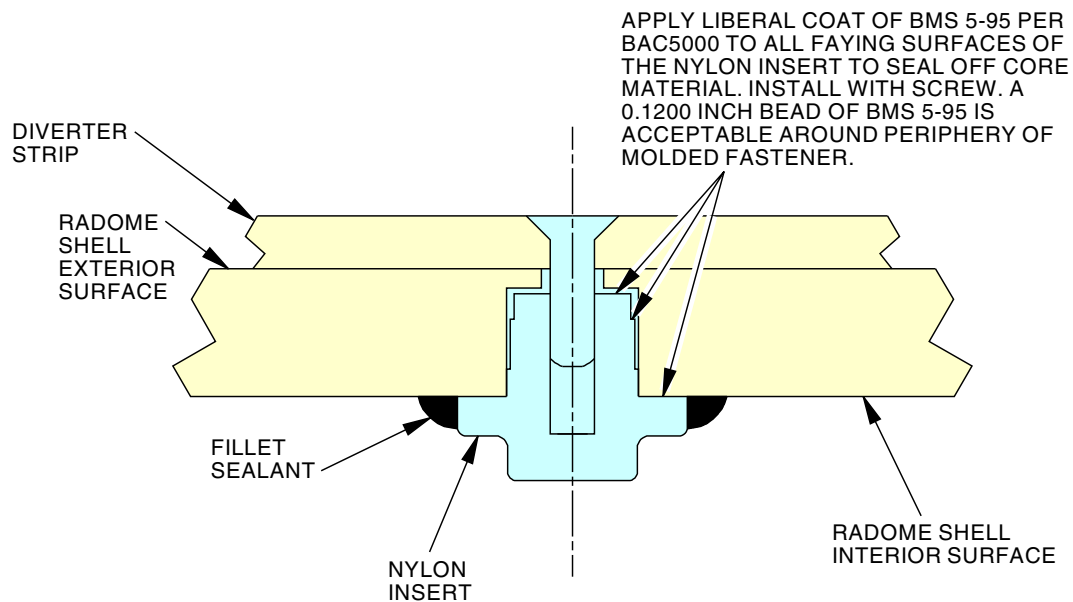
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2416201 S00061539971_V1

Insert/Sealant Installation
Figure 202/53-52-03-990-804

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TASK 53-52-03-400-801

3. Install the Lightning Diverter Strip

(Figure 201, Figure 202)

A. References

Reference	Title
51-21-99-300-802	Decorative Exterior Paint System Repair (P/B 701)
53-52-00-400-802	Nose Radome Installation (P/B 401)
53-52-00-410-801	Nose Radome Close (P/B 201)
SWPM 20-20-00 Paragraph 14.D	Category 2 Fay Sealed Fay Surface Bonds
SWPM 20-20-00 Paragraph 14.E	Category 6 Fillet Sealed Fay Surface Bond
SWPM 20-20-00, Paragraph 2	CLEANING OF FAY SURFACES

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A50250	Sealant - P/S 870 Class B-1/2 Corrosion Inhibitive Sealant	BMS5-95 Class B-1/2
A50479	Sealant - P/S 870 Class B-2 Corrosion Inhibitive Sealant	BMS5-95 Class B-2
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
G01043	Cloth - Lint-free	

C. Location Zones

Zone	Area
111	Radome

D. Lightning Diverter Strip Installation

SUBTASK 53-52-03-370-001

- (1) Repair the nose radome [1] surface if the protective finish is damaged, do this task: Decorative Exterior Paint System Repair, TASK 51-21-99-300-802.

SUBTASK 53-52-03-100-003

- (2) Clean the mating surfaces of the diverter plate and the diverter strip [3] for a satisfactory electrical bond (SWPM 20-20-00, Paragraph 2).

SUBTASK 53-52-03-390-001

- (3) Seal the diverter strip [3] attach inserts.
 - (a) Clean insert surface with a rag moistened with solvent, B00083, and let dry.
 - (b) Clean the nose radome [1] surface around insert hole with a rag moistened with solvent, B00083, and let dry.
 - (c) Apply sealant, A00247, on and around the insert hole in the nose radome [1] and the mating surface of the insert.
 - 1) Completely coat the honeycomb core cells with sealant, A00247 (Figure 202) (SWPM 20-20-00 Paragraph 14.D).
 - (d) Install the insert immediately before the sealant has a chance to set-up.

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- (e) Make sure that there is squeeze out of the sealant all round the insert on both surfaces of the nose radome [1].

- 1) The sealant squeeze out on the aerodynamic surface of the nose radome [1] needs to be flush with the surface.

NOTE: This is to accommodate the fit-up of the diverted strips.

- (f) Apply a 0.12 in. (3.05 mm) fillet seal of sealant, A00247, around the flange of the diverter strip [3] insert that is exposed to the interior side of the nose radome [1] (SWPM 20-20-00 Paragraph 14.E).

- 1) Make sure that the diverter strip [3] attach inserts are completely sealed to prevent moisture from entering the nose radome [1] honeycomb core.

SUBTASK 53-52-03-420-001

- (4) Install the diverter strip [3], do these steps:

- (a) Apply a bead of P/S 870 Class B-1/2 sealant, A50250, or P/S 870 Class B-2 sealant, A50479, on the nose radome [1] outer surface where the diverter strip [3] will be installed.
- (b) Push the diverter strip [3] tightly against the nose radome [1].
- (c) Align the diverter strip [3] holes with the correct nose radome [1] fastener holes.
- (d) Install the screws, except the diverter strip [3] grounding or terminating fasteners, with sealant, A00247.

NOTE: Grounding or terminating fasteners are not to be installed wet with sealant.

- (e) Remove excess sealant, A00247.

- 1) If used, do not let alcohol or acetone dry on the nose radome [1] surface.
- 2) Wipe the solvents from the surface using a dry, clean lint-free cloth, G01043.

- (f) At the grounding or terminating fasteners, over coat the fastener tail side and nut with sealant, A00247.

- (g) Install a bead of sealant, A00247, over the heads of each of the diverter strip [3] fasteners to prevent moisture ingress.

SUBTASK 53-52-03-410-001

- (5) Close or install the nose radome [1] if it was removed (TASK 53-52-00-410-801 or TASK 53-52-00-400-802).

SUBTASK 53-52-03-210-001

- (6) Make sure that there are no clearances between the diverter strip [3] and the nose radome [1].

SUBTASK 53-52-03-860-001

- (7) Do this task: Lightning Diverter Strips - Test, TASK 53-52-03-820-801.

———— **END OF TASK** ————

TASK 53-52-03-820-801

4. Lightning Diverter Strips - Test

(Figure 201, Figure 202)

A. General

- (1) This procedure gives the instructions to do a dc continuity test for all parts that are related to the lightning diverter strips [3]. You must do this test after you install the new diverter strips [3] or when the inspection shows deterioration. The deterioration of the lightning diverter strips [3] can cause radio noise interference.

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B. References

Reference	Title
53-52-00-010-801	Nose Radome Open (P/B 201)
53-52-00-410-801	Nose Radome Close (P/B 201)
SWPM 20-20-00 Paragraph 21	MAXIMUM PERMITTED RESISTANCE OF ELECTRICAL BONDS

C. Tools/Equipment

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

Reference	Description
COM-1550	Bonding 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

D. Location Zones

Zone	Area
111	Radome

E. Lightning Diverter Strips Test

SUBTASK 53-52-03-010-002

- (1) Do this task: Nose Radome Open, TASK 53-52-00-010-801.

SUBTASK 53-52-03-210-002

- (2) Measure the electrical resistance between the points shown in (Figure 201) with an intrinsically safe approved bonding meter, COM-1550 (SWPM 20-20-00 Paragraph 21).
- (a) Make sure that the resistance does not exceed 0.01 ohms (10 milliohms) for the diverter strips [3] that have been in service.
- (b) Maximum resistance for new diverter strips [3] is 0.001 ohms (1 milliohm).

SUBTASK 53-52-03-410-003

- (3) Do this task: Nose Radome Close, TASK 53-52-00-410-801.

SUBTASK 53-52-03-210-003

- (4) Measure the electrical resistance between the diverter strips [3] and the airframe with an intrinsically safe approved bonding meter, COM-1550 (SWPM 20-20-00 Paragraph 21).
- (a) Make sure that the resistance is less than 0.03 ohms (30 milliohms).

————— **END OF TASK** —————

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LIGHTNING DIVERTER STRIPS - REPAIRS

1. General

A. This procedure has one task:

- (1) A temporary repair of the lightning diverter strips.



DO NOT OPERATE THE AIRPLANE FOR LONG PERIODS OF TIME WITH MISSING, OR DAMAGED DIVERTER STRIPS. REPAIR THE DIVERTER STRIPS QUICKLY. THE RISK OF DAMAGE TO THE RADOME, AND OTHER EQUIPMENT FROM LIGHTNING STRIKES INCREASES WHILE THERE ARE MISSING, OR DAMAGED STRIPS.

- B. A temporary repair should be replaced by a permanent repair before reaching 400 flight hours.
- C. Because of the possible effects on the ILS antenna pattern, the number of missing or damaged strips must be at a minimum and missing/removed in a symmetrical pattern. It is possible to remove strips on BL 0 independently.
- D. The number of diverter strips missing/damaged must not be more than 40% of the total number of diverter strips. (For example, on radomes with 6 diverter strips, there must be no more than 2 diverter strips in symmetrical pairs missing or damaged at one time. Radomes with 10 diverter strips there must be no more than 4 diverter strips in symmetrical pairs missing or damaged.)
- E. Sections of diverter strips not connected to the grounding plate can cause interference with communications equipment.

TASK 53-52-03-300-801

2. Lightning Diverter Strip Temporary Repair

A. References

Reference	Title
53-52-03-000-801	Remove the Lightning Diverter Strips (P/B 201)

B. Consumable Materials

Reference	Description	Specification
G50012 [P05-278]	Tape - Protective Polyurethane - 3M 8672	
G50361	Tape - Mylar, Permacel P-280	
G50362	Tape - 3M Polyester Tape 853 (Formerly Scotch No. 853 Tape)	

C. Location Zones

Zone	Area
111	Radome

D. Lightning Diverter Strip Temporary Repair

SUBTASK 53-52-03-350-001

- (1) For damaged diverter strips:
- (a) Remove all loose pieces of the lightning diverter strip (Remove the Lightning Diverter Strips, TASK 53-52-03-000-801).
- (b) Make sure that the remaining section of the damaged strip is safely held.
- (c) Make sure that the ground plate is not damaged.
- (d) Make sure that there is a continuous connection with the remaining section of the damaged strip and the ground plate.

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SUBTASK 53-52-03-350-002

- (2) For missing or removed diverter strips:
- (a) Seal openings from missing bolts with non-metallic tape (3M 853 tape, G50362, Permacel P-280 tape, G50361, 3M 8672 tape, G50012 [P05-278], or equivalent).
 - (b) Make sure that all tape edges are flush with the surface of the radome.

———— **END OF TASK** ————

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GLIDE SLOPE ANTENNA DIRECTOR BAR - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Glide slope director bar removal
 - (2) Glide slope director bar installation.

TASK 53-52-31-000-801

2. Glide Slope Director Bar Removal

(Figure 401)

A. **General**

- (1) This task gives the instructions to remove the glide slope director bar.

B. **Location Zones**

<u>Zone</u>	<u>Area</u>
111	Radome

C. **Glide Slope Director Bar Removal**

SUBTASK 53-52-31-860-001

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

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	7	C01678	WEATHER RADAR RT RIGHT

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	13	C00120	WEATHER RADAR RT

SUBTASK 53-52-31-010-001

- (2) Open the nose radome.
 - (a) Remove the screws that attach the radome to the clips on the fuselage.



CAUTION

DO NOT OPEN THE RADOME IF THE WIND SPEED IS MORE THAN 15 KNOTS. THIS CAN CAUSE DAMAGE TO THE RADOME.

- (b) Open the radome.
 - (c) Install the support rod to hold the radome open.

SUBTASK 53-52-31-020-001

- (3) Remove the director bar [1].

————— **END OF TASK** —————

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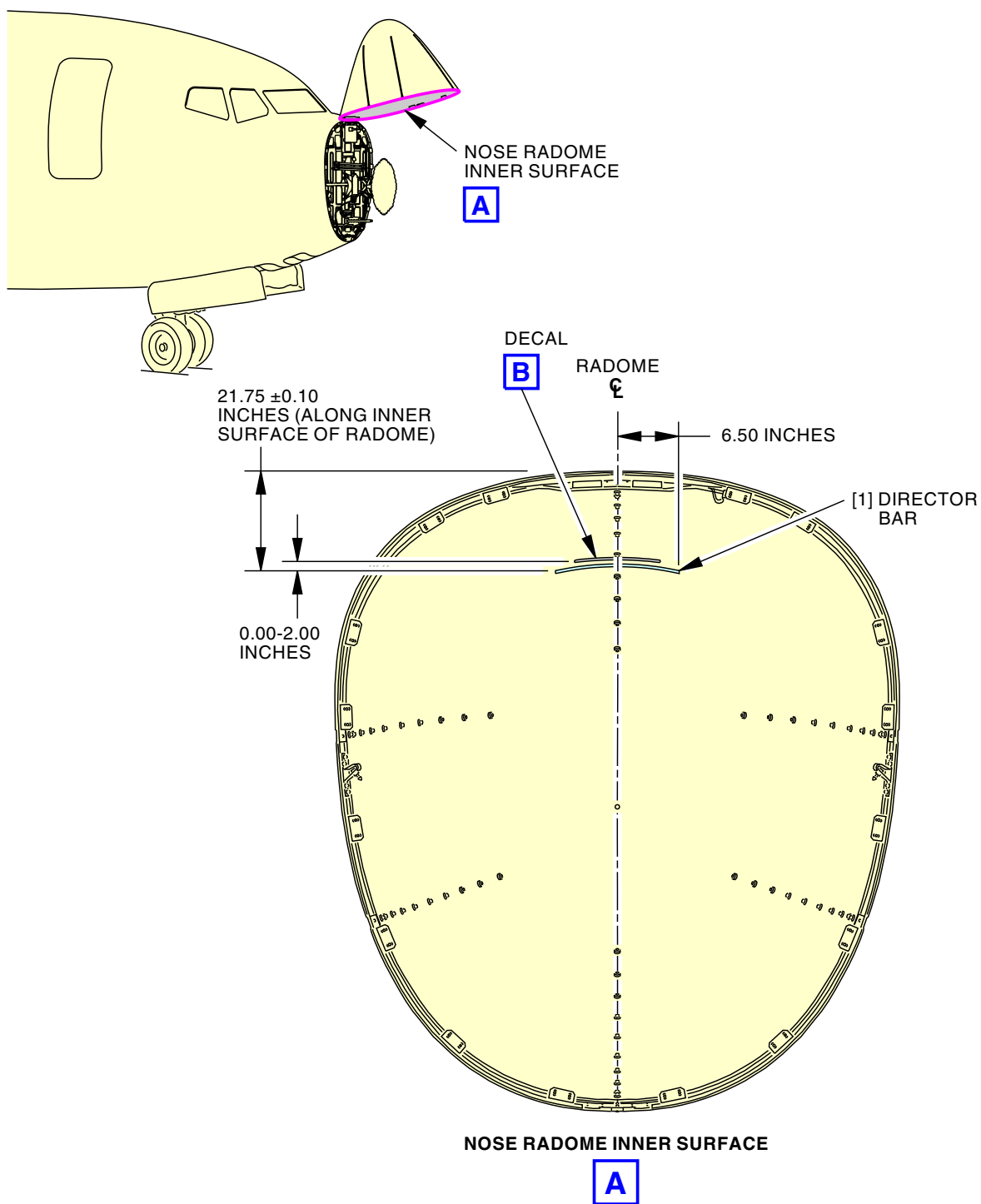
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2416202 S00061539978_V1

Director Bar - Glide Slope Antenna Installation
Figure 401/53-52-31-990-801 (Sheet 1 of 2)

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GLIDESLOPE ANTENNA DIRECTOR BAR -M1458



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Director Bar - Glide Slope Antenna Installation
Figure 401/53-52-31-990-801 (Sheet 2 of 2)

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TASK 53-52-31-400-801

3. Glide Slope Director Bar Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the glide slope director bar.

B. References

Reference	Title
53-52-00-400-802	Nose Radome Installation (P/B 401)

C. Consumable Materials

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
G00291	Tape - Aluminum Foil, 3M 425	AMS-T-23397 / L-T-80

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Director bar	53-52-31-03A-115	SIA ALL
		53-52-31-03B-015	SIA ALL

E. Location Zones

Zone	Area
111	Radome

F. Glide Slope Director Bar Installation

SUBTASK 53-52-31-110-001

(1) Clean the nose radome surface where you will install the director bar [1] with solvent, B00083.

SUBTASK 53-52-31-370-001

(2) Apply one layer of the primer, C00259 to the surface where you will install the director bar [1].

SUBTASK 53-52-31-110-002

(3) Clean the surface with the solvent, B00083.

SUBTASK 53-52-31-420-001

(4) Do these steps to make and install the director bar [1].

(a) Cut a 13 in. (33 cm) long strip of the 3M 425 Aluminum Foil Tape, G00291.

(b) Install the tape.

(c) Push the 3M 425 Aluminum Foil Tape, G00291 correctly into its location.

SUBTASK 53-52-31-420-002

(5) Install the M1458 decal on the radome if not installed.

SUBTASK 53-52-31-410-001

(6) Do this task: Nose Radome Installation, TASK 53-52-00-400-802.

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SUBTASK 53-52-31-860-002

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

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	7	C01678	WEATHER RADAR RT RIGHT

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	13	C00120	WEATHER RADAR RT

————— **END OF TASK** —————

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TAILCONE - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) Tailcone removal
- (2) Tailcone installation.

TASK 53-53-00-000-801

2. Tailcone Removal

(Figure 401)

A. General

- (1) This task gives the instructions to remove the tailcone [1].

B. References

Reference	Title
27-21-17-000-801	Rudder Index Plate Removal (P/B 401)
27-31-81-000-801	Elevator Index Plate Removal (P/B 401)
27-41-00-800-801	Horizontal Stabilizer Trim Control System - Deactivation (P/B 201)
27-41-00-800-802	Horizontal Stabilizer Trim Control System - Activation (P/B 201)
49-81-11-000-801	Exhaust Duct Muffler Removal (P/B 401)
70-00-01-910-803-G00	Electrical Connector Disconnection and Connection (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-1561	Jack - Hydraulic Part #: 930002 Supplier: FA2A9 Part #: J20009-110 Supplier: 81205 Opt Part #: J20009-108 Supplier: 81205 Opt Part #: J20009-109 Supplier: 81205
SPL-1584	Adapter Assembly - Telescoping Hydraulic Part #: J20009-136 Supplier: 81205 Opt Part #: J20009-68 Supplier: 81205
SPL-14635	Removal and Installation Equipment - Tail Cone Part #: C53002-1 Supplier: 81205
STD-10684	Plastic Sheet - Protective
STD-15046	Screwdriver - 90 Degree

D. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
317	Tail Cone Compartment - Left
318	Tail Cone Compartment - Right

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E. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door
317BL	Tailcone Access Door
318BR	Tailcone Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

F. Prepare for the Removal

SUBTASK 53-53-00-040-001



WARNING

MAKE SURE THAT ALL PERSONNEL, AND EQUIPMENT ARE AWAY FROM THE HORIZONTAL STABILIZER. THE MOVEMENT OF THE HORIZONTAL STABILIZER DURING MAINTENANCE CAN CAUSE INJURY TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (1) Deactivate the horizontal stabilizer (TASK 27-41-00-800-801).

SUBTASK 53-53-00-930-001

- (2) Use a non-permanent marker to make alignment marks on the tailcone [1] and fuselage.

SUBTASK 53-53-00-760-001

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

CAPT Electrical System Panel, P18-2

Row	Col	Number	Name
C	8	C00544	FLIGHT RECORDER POSITION SENSOR

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	13	C04051	EXTERIOR LIGHTING POSITION LEFT
C	12	C04053	ANTI COLLISION LIGHT-TAIL CONE- WHITE

F/O Electrical System Panel, P6-2

Row	Col	Number	Name
B	10	C00207	FLIGHT CONTROL STAB TRIM CONT
D	10	C00840	FLIGHT CONTROL STAB TRIM ACTUATOR

SUBTASK 53-53-00-010-004

- (4) To get access to the P91 panel, open this access panel:

Number	Name/Location
117A	Electronic Equipment Access Door

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SUBTASK 53-53-00-860-004



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.



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.

- (5) Open this circuit breaker and install safety tag:

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	5	C00389	ACCESS COMPT LT

SUBTASK 53-53-00-010-001

- (6) Do this task: Exhaust Duct Muffler Removal, TASK 49-81-11-000-801.

SUBTASK 53-53-00-010-002

- (7) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
317BL	Tailcone Access Door
318BR	Tailcone Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

SUBTASK 53-53-00-020-001

- (8) Disconnect the electrical connector [3], D44584P, and jumper [2] (STA 1164) to disconnect the tailcone wire harness from the structure connector (Figure 401, View B) (TASK 70-00-01-910-803-G00).

SUBTASK 53-53-00-020-002

- (9) Disconnect the electrical connector [15], D44592P, (STA 1159) to disconnect the tailcone wire harness from the structure connector (Figure 401, View A) (TASK 70-00-01-910-803-G00).

SUBTASK 53-53-00-020-003

- (10) Install the protective plastic sheet, STD-10684, on the tailcone [1] to prevent damage.

NOTE: When you remove the tailcone [1], it will touch the horizontal stabilizer.

SUBTASK 53-53-00-020-007

- (11) Remove the fasteners on the left and right sides of the tailcone [1] (Figure 401, View C).
- Remove the bolts [11] and track plate [4].
 - Remove the 10 bolts [5].

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- (c) Remove the bolts [6], washers [7] that attach the aft sliding gap cover [9].

NOTE: There will be access to the remaining bolts [6] and washers [7] when you move the horizontal stabilizer.

- (d) Remove the six bolts [10].
(e) Remove the bolts [11] and track plate [12].
(f) Remove the two bolts [6] and two washers [7] from the forward sliding gap cover.
1) Do not remove the forward sliding gap cover.

SUBTASK 53-53-00-440-001



MAKE SURE THAT ALL PERSONNEL, AND EQUIPMENT ARE AWAY FROM THE HORIZONTAL STABILIZER. THE MOVEMENT OF THE HORIZONTAL STABILIZER DURING MAINTENANCE CAN CAUSE INJURY TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (12) Activate the horizontal stabilizer (TASK 27-41-00-800-802).

SUBTASK 53-53-00-440-002

- (13) Set the flight control surfaces:
(a) Move the horizontal stabilizer trailing edge to the fully up position.
(b) Move the rudder trailing edge fully left or right.
(c) Move the elevator trailing edge to the fully up position.

SUBTASK 53-53-00-040-002



MAKE SURE THAT ALL PERSONNEL, AND EQUIPMENT ARE AWAY FROM THE HORIZONTAL STABILIZER. THE MOVEMENT OF THE HORIZONTAL STABILIZER DURING MAINTENANCE CAN CAUSE INJURY TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (14) Deactivate the horizontal stabilizer (TASK 27-41-00-800-801).

SUBTASK 53-53-00-400-008

- (15) Attach the equipment, SPL-14635, to the tailcone [1]:
(a) Attach the equipment, SPL-14635, to the telescoping hydraulic adapter assembly, SPL-1584, on the hydraulic jack, SPL-1561.
(b) Put the hydraulic jack, SPL-1561, on an appropriate maintenance stand.
1) Make sure that the maintenance stand is centered under the tailcone [1].
(c) If necessary, lift the maintenance stand to the tailcone [1].
(d) Put the equipment, SPL-14635, below the tailcone [1].
(e) Strap the tailcone [1] to the equipment, SPL-14635.
(f) Make sure that the equipment, SPL-14635, holds the weight of the tailcone [1].

G. Tailcone Removal

SUBTASK 53-53-00-020-008

- (1) Remove the remaining bolts [6], washers [7] and sliding gap cover [9].
(a) Use a Screw Driver, 90 Degree, STD-15046, to remove the hidden bolt [8] that is behind the sliding gap cover [9].

SUBTASK 53-53-00-020-006

- (2) Remove the bolts [13] and dimpled washers [14] from the tailcone [1] (Figure 401, View D).

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SUBTASK 53-53-00-000-001



CAUTION

DO NOT APPLY TOO MUCH FORCE WHEN YOU MOVE THE TAILCONE, IT CAN TOUCH THE EQUIPMENT INSTALLED ON THE AFT BULKHEAD. THIS CAN CAUSE DAMAGE TO THE EQUIPMENT.

- (3) Slowly move the tailcone [1] away from the bulkhead.

SUBTASK 53-53-00-000-002

- (4) Turn and lower the tailcone [1] away from the aft bulkhead.

NOTE: The bottom forward edge of the tailcone [1] will be forward of the aft bulkhead for a short time during this step.

SUBTASK 53-53-00-000-003

- (5) If a new tailcone [1] or a tailcone [1] from a different airplane will be installed, do these tasks:
- (a) Elevator Index Plate Removal, TASK 27-31-81-000-801.
 - (b) Rudder Index Plate Removal, TASK 27-21-17-000-801.

———— **END OF TASK** ————

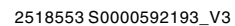
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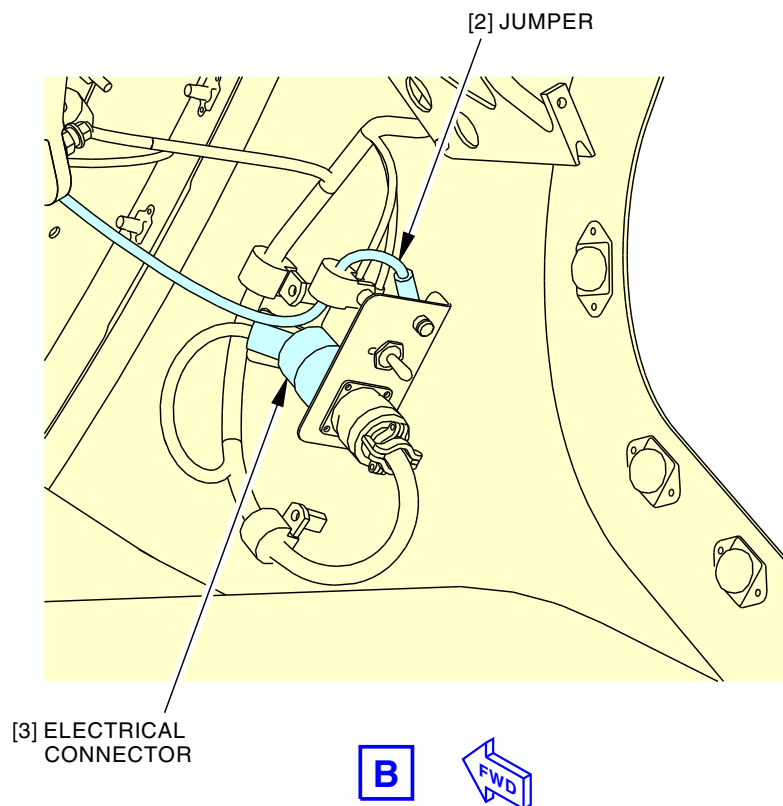
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Tailcone Installation
Figure 401/53-53-00-990-802 (Sheet 1 of 4)



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2416205 S00061539986_V2

Tailcone Installation
Figure 401/53-53-00-990-802 (Sheet 2 of 4)

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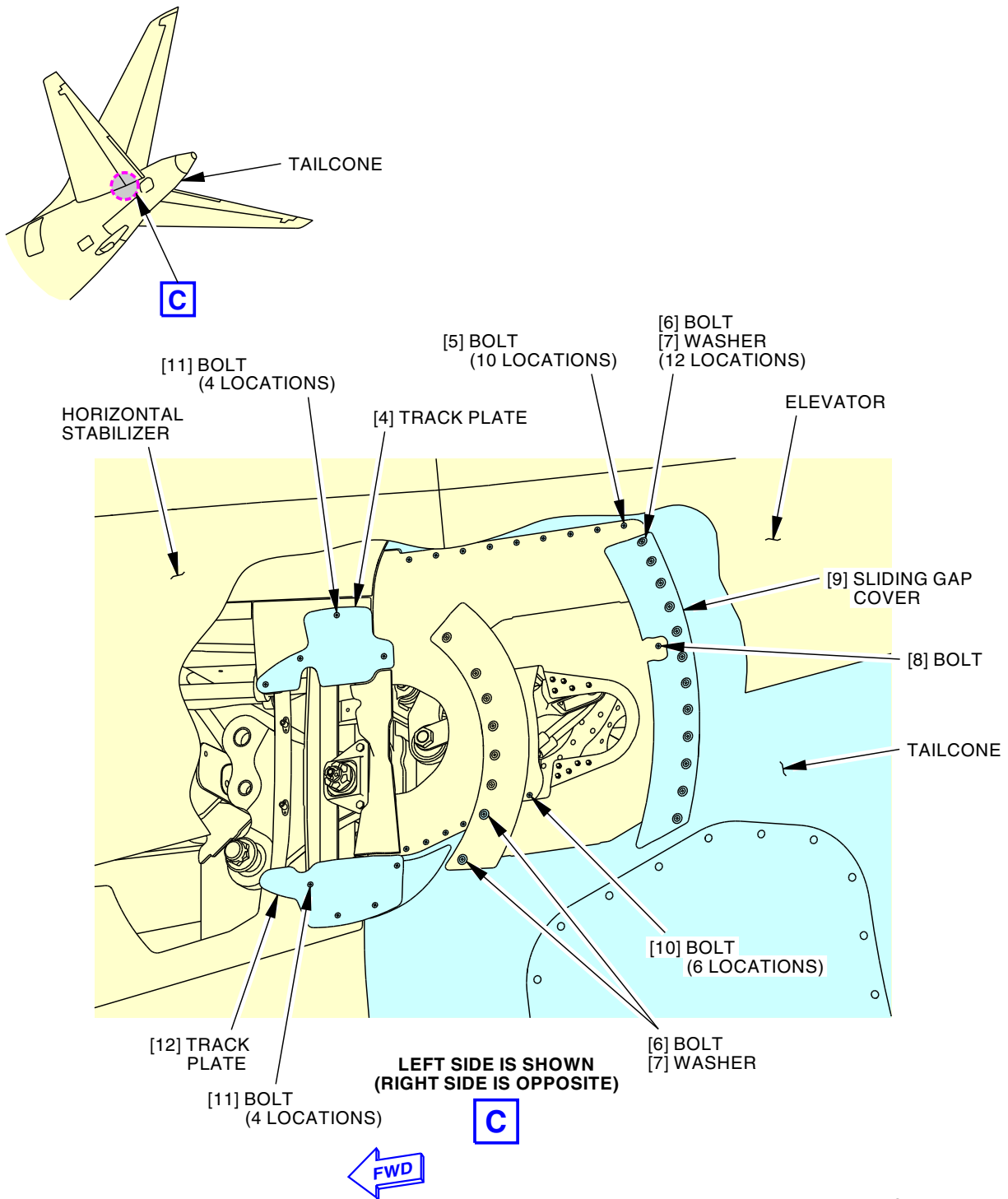
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2416204 S00061539985_V3

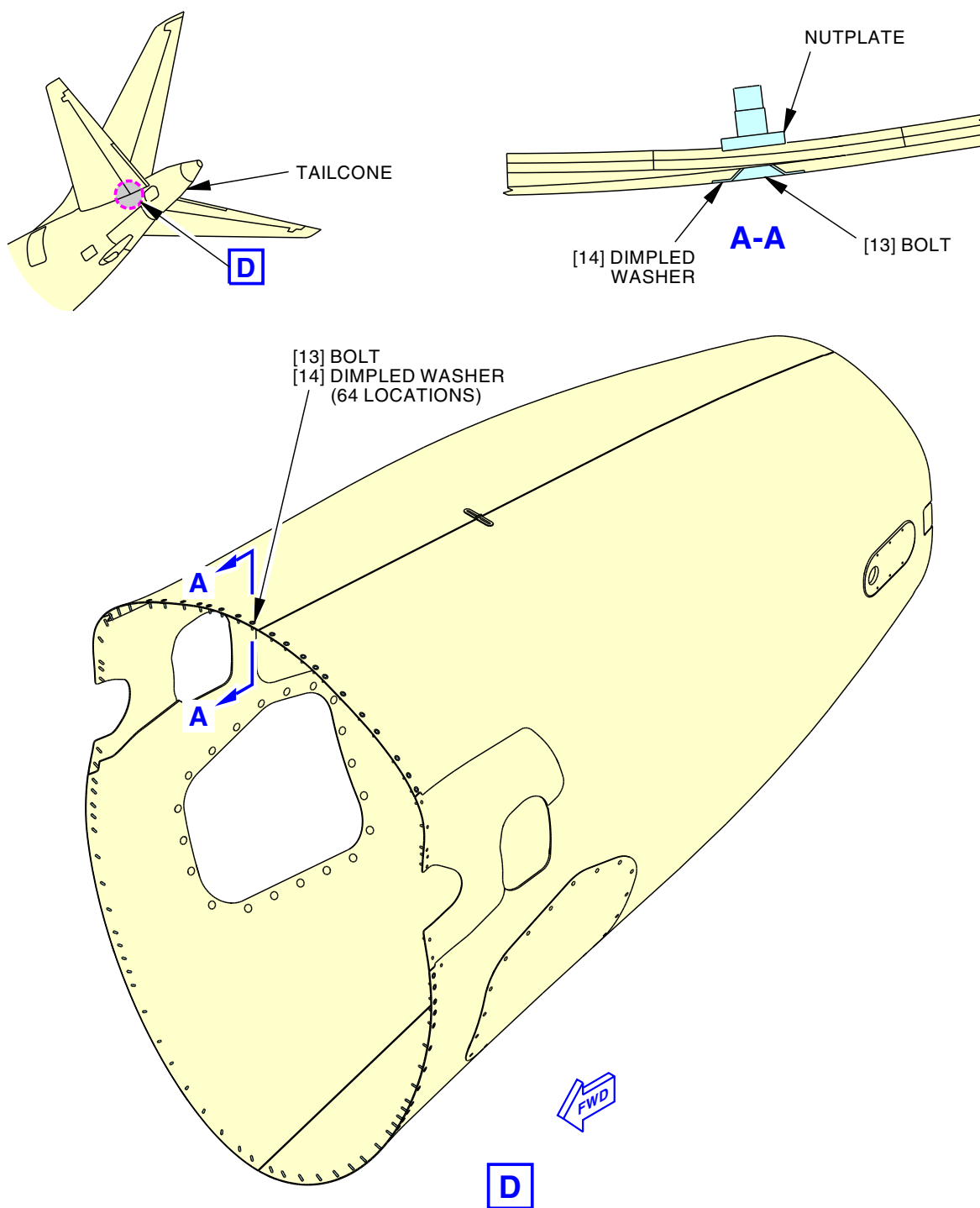
Tailcone Installation
Figure 401/53-53-00-990-802 (Sheet 3 of 4)

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2539541 S0000602634_V1

Tailcone Installation
Figure 401/53-53-00-990-802 (Sheet 4 of 4)

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TASK 53-53-00-400-801

3. Tailcone Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the tailcone.

B. References

Reference	Title
27-21-00-700-807	Rudder Trim System Test (P/B 501)
27-21-17-400-801	Rudder Index Plate Installation (P/B 401)
27-31-00-710-801	Elevator and Elevator Trim Control System - Operational Test (P/B 501)
27-31-81-400-801	Elevator Index Plate Installation (P/B 401)
27-41-00-800-801	Horizontal Stabilizer Trim Control System - Deactivation (P/B 201)
27-41-11-400-801	Horizontal Stabilizer Installation (P/B 401)
49-81-11-400-801	Exhaust Duct Muffler Installation (P/B 401)
51-22-00-160-801	Prepare For Sealing (P/B 201)
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
70-00-01-910-803-G00	Electrical Connector Disconnection and Connection (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-1561	Jack - Hydraulic Part #: 930002 Supplier: FA2A9 Part #: J20009-110 Supplier: 81205 Opt Part #: J20009-108 Supplier: 81205 Opt Part #: J20009-109 Supplier: 81205
SPL-1584	Adapter Assembly - Telescoping Hydraulic Part #: J20009-136 Supplier: 81205 Opt Part #: J20009-68 Supplier: 81205
SPL-14635	Removal and Installation Equipment - Tail Cone Part #: C53002-1 Supplier: 81205
STD-10684	Plastic Sheet - Protective
STD-15046	Screwdriver - 90 Degree

D. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Tailcone	53-53-00-01-240	SIA ALL

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F. Location Zones

Zone	Area
117	Electrical and Electronics Compartment - Left
317	Tail Cone Compartment - Left
318	Tail Cone Compartment - Right

G. Access Panels

Number	Name/Location
117A	Electronic Equipment Access Door
317BL	Tailcone Access Door
318BR	Tailcone Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

H. Prepare for the Installation

SUBTASK 53-53-00-100-001

- (1) Clean the aft bulkhead perimeter, where the tailcone [1] attaches to the bulkhead (TASK 51-22-00-160-801).

SUBTASK 53-53-00-950-001

- (2) Install a protective plastic sheet, STD-10684, on the surface of the tailcone [1] to prevent damage.
 - (a) Keep the fastener holes uncovered.

I. Tailcone Installation

SUBTASK 53-53-00-860-002



MAKE SURE THAT ALL PERSONNEL, AND EQUIPMENT ARE AWAY FROM THE HORIZONTAL STABILIZER. THE MOVEMENT OF THE HORIZONTAL STABILIZER DURING MAINTENANCE CAN CAUSE INJURY TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (1) Make sure that the horizontal stabilizer will not move (TASK 27-41-00-800-801).

SUBTASK 53-53-00-820-002

- (2) Attach the equipment, SPL-14635, to the tailcone [1]:
 - (a) Attach the equipment, SPL-14635, to the telescoping hydraulic adapter assembly, SPL-1584, on the hydraulic jack, SPL-1561.
 - (b) Put the hydraulic jack, SPL-1561, on an appropriate maintenance stand.
 - 1) Make sure that the maintenance stand is centered under the aft bulkhead.
 - (c) Strap the tailcone [1] to the equipment, SPL-14635.

SUBTASK 53-53-00-820-001

- (3) Raise the tailcone [1] on the maintenance stand into its position on the aft bulkhead.
 - (a) Make sure that the alignment marks are aligned.

NOTE: The bottom forward edge of the tailcone [1] will be forward of the aft bulkhead at the beginning of this step.

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SUBTASK 53-53-00-400-002



CAUTION

DO NOT APPLY TOO MUCH FORCE WHEN YOU MOVE THE TAILCONE, IT CAN TOUCH THE EQUIPMENT INSTALLED ON THE AFT BULKHEAD. THIS CAN CAUSE DAMAGE TO THE EQUIPMENT.

- (4) Install the tailcone [1] (View D):
 - (a) Install the 64 dimpled washers [14] and 64 bolts [13] loosely on the tailcone [1].
 - (b) Snug up opposite fasteners all around, then tighten opposite fasteners all around to the necessary torque.
 - (c) Remove the protective plastic sheet, STD-10684.

SUBTASK 53-53-00-080-001

- (5) Remove the support equipment, SPL-14635, from the tailcone [1].

SUBTASK 53-53-00-420-009

- (6) Install the aft sliding gap cover [9] on the left and right sides of the tailcone [1] (Figure 401, View C).
 - (a) Use a Screw Driver, 90 Degree, STD-15046, to install the hidden bolt [8] behind the sliding gap cover [9].
 - (b) Install the aft sliding gap cover [9], washers [7], and bolts [6] to the tailcone [1].

NOTE: You can get access to install the remaining bolts [6] and washers [7] when you move the horizontal stabilizer up and down.

SUBTASK 53-53-00-420-010

- (7) Install the fasteners on the left and right sides of the tailcone [1] (Figure 401, View C).
 - (a) Install the two bolts [6] and two washers [7] to the forward sliding gap cover.
 - (b) Install the bolts [11] and track plate [12].
 - (c) Install the six bolts [10].
 - (d) Install the remaining bolts [6], washers [7] that attach the aft sliding gap cover [9].
 - (e) Install the 10 bolts [5].
 - (f) Install the bolts [11] and track plate [4].

SUBTASK 53-53-00-420-002

- (8) If you installed a different tailcone [1], do these tasks:
 - (a) Rudder Index Plate Installation, TASK 27-21-17-400-801.
 - (b) Elevator Index Plate Installation, TASK 27-31-81-400-801.

SUBTASK 53-53-00-420-006

- (9) Connect the electrical connector [3], D44584P, and jumper [2] (STA 1164), that attaches the tailcone wire harness to the structure connector (Figure 401, View B) (TASK 70-00-01-910-803-G00).

SUBTASK 53-53-00-420-007

- (10) Connect the electrical connector [15], D44592P, (STA 1159), that attaches the tailcone wire harness to the structure connector (Figure 401, View A) (TASK 70-00-01-910-803-G00).

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SUBTASK 53-53-00-410-003

- (11) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
317BL	Tailcone Access Door
318BR	Tailcone Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

SUBTASK 53-53-00-410-002

- (12) Do this task: Exhaust Duct Muffler Installation, TASK 49-81-11-400-801.

SUBTASK 53-53-00-860-005



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.



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.

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

Power Distribution Panel Number 1, P91

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	5	C00389	ACCESS COMPT LT

SUBTASK 53-53-00-410-004

- (14) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
117A	Electronic Equipment Access Door

SUBTASK 53-53-00-860-003

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

CAPT Electrical System Panel, P18-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	8	C00544	FLIGHT RECORDER POSITION SENSOR

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	13	C04051	EXTERIOR LIGHTING POSITION LEFT
C	12	C04053	ANTI COLLISION LIGHT-TAIL CONE- WHITE

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F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	10	C00207	FLIGHT CONTROL STAB TRIM CONT
D	10	C00840	FLIGHT CONTROL STAB TRIM ACTUATOR

J. Tailcone Installation Test

SUBTASK 53-53-00-400-005

- (1) Adjust the stabilizer-to-body seals (TASK 27-41-11-400-801).

SUBTASK 53-53-00-400-006

- (2) Remove the alignment marks.

SUBTASK 53-53-00-420-008

- (3) Apply sealant, A02315, between the splice strap and the flange of the aft bulkhead (TASK 51-22-00-390-809).

SUBTASK 53-53-00-390-001

- (4) Apply sealant, A02315, between the tailcone and fuselage skin (TASK 51-22-00-390-809).

SUBTASK 53-53-00-710-001

- (5) Do this task: Elevator and Elevator Trim Control System - Operational Test, TASK 27-31-00-710-801.

SUBTASK 53-53-00-730-001

- (6) Do this task: Rudder Trim System Test, TASK 27-21-00-700-807.

————— END OF TASK —————

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BROADBAND RADOME - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Broadband Radome Removal
 - (2) Broadband Radome Installation
 - (3) Adapter Plate Assembly Removal
 - (4) Adapter Plate Assembly Installation.
- B. There is one broadband radome. The radome is installed on the antenna adapter plate, which is located on top of the airplane fuselage. The adapter plate and radome are mounted on the airplane center line, between stations 727D and 727J.

TASK 53-54-00-000-801

2. Broadband Radome Removal

(Figure 401)

A. General

- (1) This task has instructions to remove the broadband radome.
- NOTE: The broadband radome weighs approximately 42 lb (19 kg).

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-15116	Removal/Installation Equipment - Broadband Radome Lift Assy C44001-49 (included in C44001-55 Kit) / C44001-59 (included in C44001-58 Kit) Part #: C44001-58 Supplier: 81205 Opt Part #: C44001-55 Supplier: 81205
STD-13571	Screwdriver - Flat Tip

C. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

D. Prepare for the Removal

SUBTASK 53-54-00-040-001

- (1) Deactivate the satellite communication power.
- (a) Open these circuit breakers and install safety tags:

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
A	8	C04073	BROADBAND 1
A	9	C04074	BROADBAND 2

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SUBTASK 53-54-00-480-001



WARNING

BE CAREFUL WHEN YOU MOVE THE COMPONENT. THE COMPONENT IS HEAVY. INJURIES TO PERSONS CAN OCCUR.

- (2) Attach the broadband radome removal/installation equipment, C44001-49 or -59, SPL-15116 to the broadband radome [1].

NOTE: Use two persons and a hoist to lift the broadband radome from the antenna adapter plate.

- (a) Remove the hoist fasteners from the broadband radome [1].

NOTE: Re-install these hoist fasteners after installation of the broadband radome.

- (b) Attach the four hoist fittings [42] and four hoist pins [41] to the broadband radome [1].

- 1) Make sure to remove the hoist fasteners.

- (c) Remove the slack from the broadband radome removal/installation equipment, C44001-49 or -59, SPL-15116.

- 1) Make sure that the broadband radome removal/installation equipment, C44001-49 or -59, SPL-15116 is centered over the broadband radome [1].

- (d) Tighten the four hoist pins [41] to 30 in-lb (3 N·m).

E. Broadband Radome Removal

SUBTASK 53-54-00-010-001

- (1) Get access to the broadband radome blow-out door [6].
 - (a) Put a Flat Tip Screwdriver, STD-13571 in the slot on the blow-out door latch.
 - (b) Pull the latch in the aft direction.
 - (c) Lift the blow-out door in the forward direction.

SUBTASK 53-54-00-020-001

- (2) Remove the screws [11] and washers [12] that attach the bonding jumpers [8] to the support structure.

SUBTASK 53-54-00-020-002

- (3) Remove the 67 bolts [3] and 67 washers [4] that attach the broadband radome [1] to the adapter plate assembly [13].

NOTE: Remove the bolts and washers on the left and right side of the broadband radome.

SUBTASK 53-54-00-020-003

- (4) Remove the bolt [5] from the broadband radome [1].

SUBTASK 53-54-00-020-004

- (5) Carefully lift the broadband radome [1] from the airplane.

————— END OF TASK —————

EFFECTIVITY
SIA 015-999

D633AM101-SIA

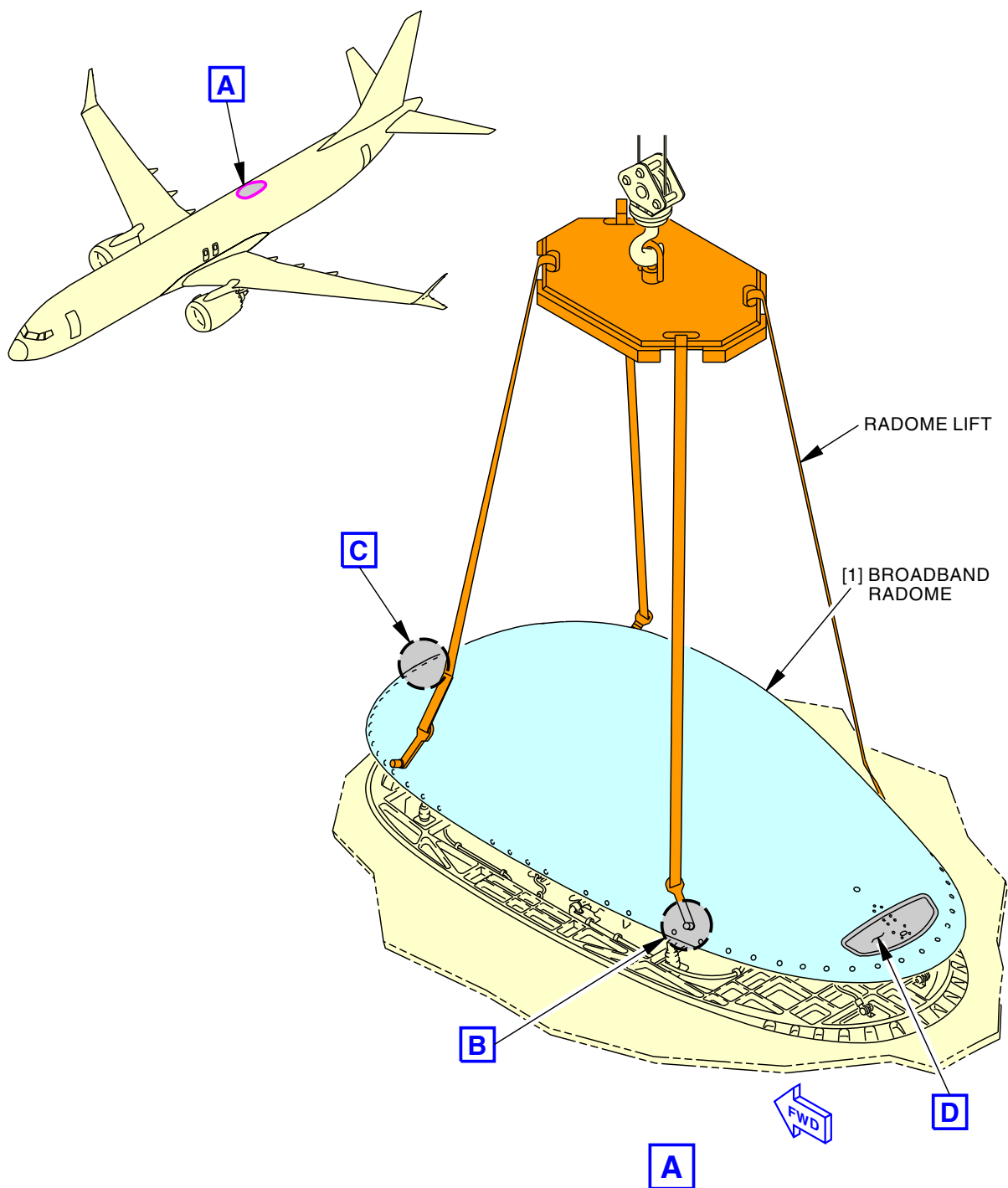
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2538830 S0000601340_V2

Broadband Radome Installation
Figure 401/53-54-00-990-801 (Sheet 1 of 3)

EFFECTIVITY
SIA 015-999

D633AM101-SIA

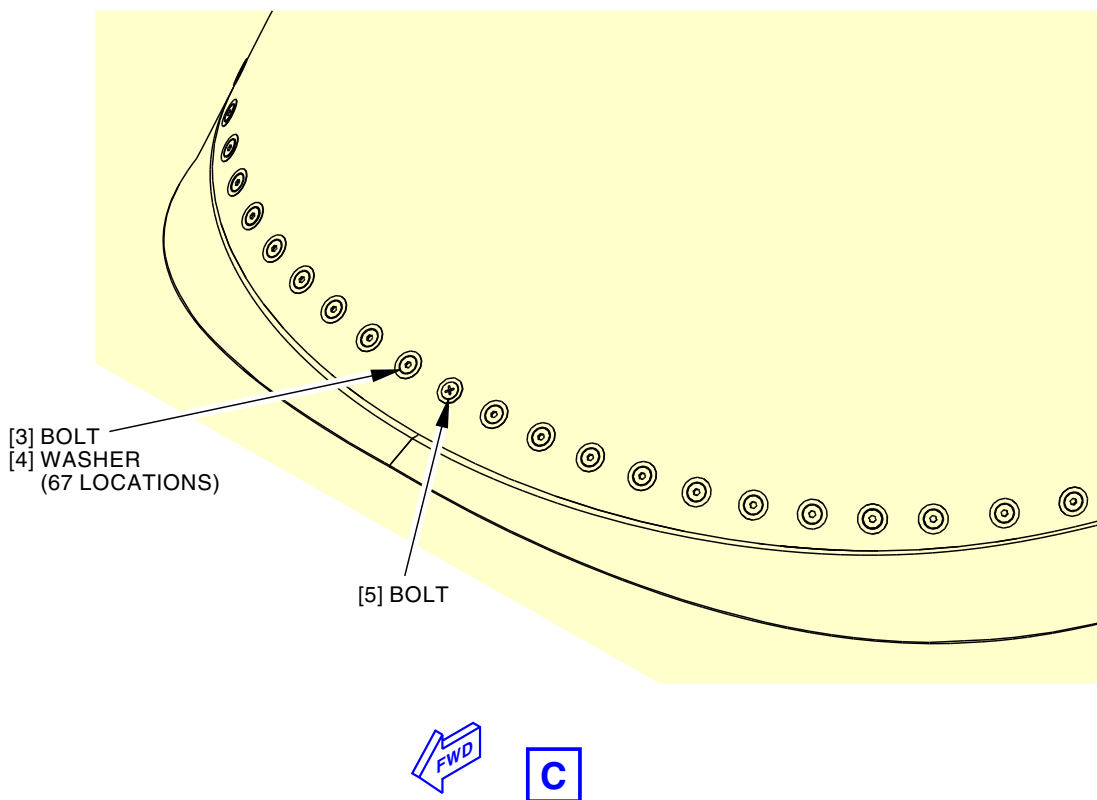
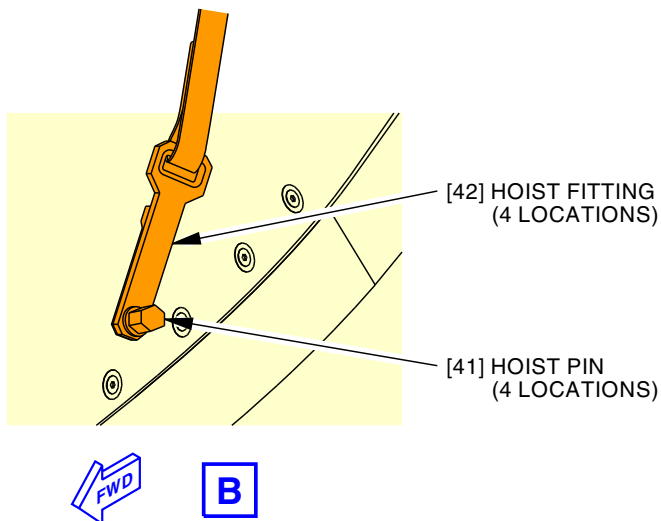
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AIRCRAFT MAINTENANCE MANUAL



2538836 S0000602106_V2

Broadband Radome Installation
Figure 401/53-54-00-990-801 (Sheet 2 of 3)

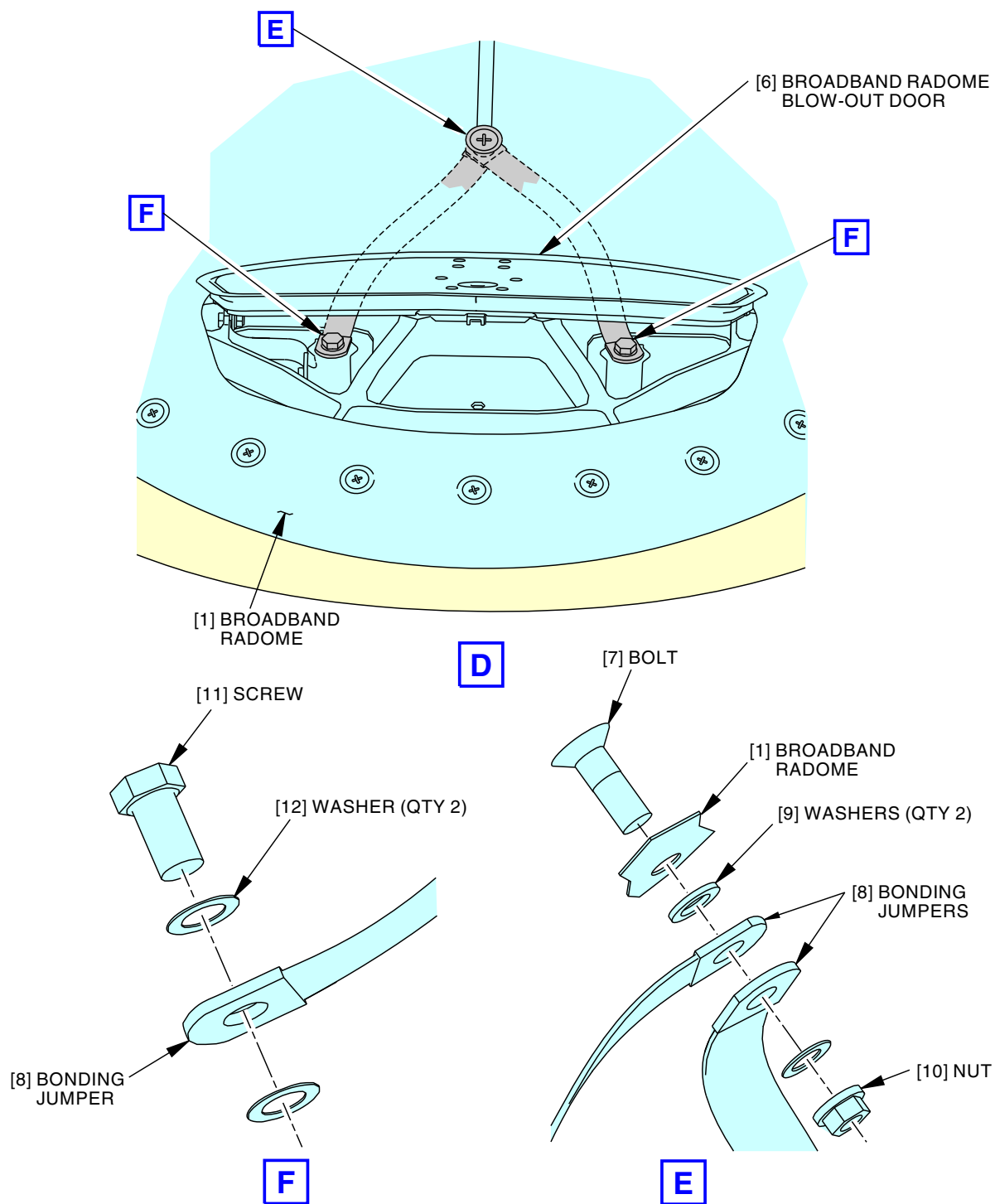
EFFECTIVITY
SIA 015-999

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2538928 S0000601885_V1

Broadband Radome Installation
Figure 401/53-54-00-990-801 (Sheet 3 of 3)

EFFECTIVITY
SIA 015-999

D633AM101-SIA

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TASK 53-54-00-400-801

3. **Broadband Radome Installation**

(Figure 401)

A. General

(1) This task has instructions to install the broadband radome.

NOTE: The broadband radome weighs approximately 42 lb (19 kg).

B. References

Reference	Title
44-35-10-400-802	Single Panel Antenna Installation (P/B 401)
44-35-29-400-801	Antenna Pointing System 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-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
SPL-15116	Removal/Installation Equipment - Broadband Radome Lift Assy C44001-49 (included in C44001-55 Kit) / C44001-59 (included in C44001-58 Kit) Part #: C44001-58 Supplier: 81205 Opt Part #: C44001-55 Supplier: 81205
STD-13571	Screwdriver - Flat Tip

D. Consumable Materials

Reference	Description	Specification
A01076	Adhesive - Synthetic Rubber	BAC5010 Type 93 (BMS5-95 Class B)
B00130	Alcohol - Isopropyl	TT-I-735

E. Location Zones

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

F. Prepare for the Installation

SUBTASK 53-54-00-420-001

(1) Install the adapter plate assembly (TASK 53-54-00-400-802).



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SUBTASK 53-54-00-420-002



WARNING

BE CAREFUL WHEN YOU INSTALL THE ANTENNA. THE ANTENNA IS HEAVY. DAMAGE TO THE ANTENNA, AND INJURIES TO PERSONNEL, CAN OCCUR.

- (2) If necessary, do this task: Single Panel Antenna Installation, TASK 44-35-10-400-802 or Antenna Pointing System Installation, TASK 44-35-29-400-801.

SUBTASK 53-54-00-420-003

- (3) Attach the two bonding jumpers [8] to the broadband radome [1]:
- (a) Clean the broadband radome [1] and washer [9] with alcohol, B00130.
 - (b) Install the bolt [7], bonding jumpers [8], washer [9] into the hole above the broadband radome blow-out door [6].
NOTE: The bolt, bonding jumpers, and washer should be installed prior to installation on the aircraft.
 - (c) Fay seal both sides of the washer [9] and two bonding jumpers [8] with adhesive, A01076.
 - (d) Put the washer [9] on the bolt [7].
 - (e) Put the two bonding jumpers [8] on the bolt [7].
 - (f) Put the remaining washer [9] and the nut [10] on the bolt [7].
 - (g) Position the unconnected end of the two bonding jumpers [8] 90 degrees to each other.
 - (h) Make sure that the two bonding jumpers [8] are aligned on the radome centerline.
 - (i) Tighten the bolt [7] to 200 ± 20 in-lb (23 ± 3 N·m).
 - (j) Apply a fillet seal of the bolt [7] and the washer [9] with adhesive, A01076.
 - (k) Measure the resistance between the ground strap and the dimpled washer with a intrinsically safe approved bonding meter, COM-1550 (SWPM 20-20-00, paragraph 21).
 - 1) Make sure that the resistance is 1.75 milliohms or less.

SUBTASK 53-54-00-480-002



WARNING

BE CAREFUL WHEN YOU MOVE THE COMPONENT. THE COMPONENT IS HEAVY. INJURIES TO PERSONS CAN OCCUR.



CAUTION

DO A VISUAL INSPECTION FOR CORROSION OR DAMAGE OF THE LIFTING LUG/ADAPTOR BEFORE YOU LIFT THE ANTENNA. IF THE LIFTING LUG/ADAPTOR HAS CORROSION OR IS DAMAGED, IT CAN FAIL AND CAUSE DAMAGE TO THE AIRPLANE OR EQUIPMENT.

- (4) Attach the broadband radome removal/installation equipment, C44001-49 or -59, SPL-15116 to the broadband radome [1].

NOTE: Use two persons and a hoist to lift the radome on to the antenna adapter plate.

- (a) Remove the hoist fasteners from the broadband radome [1].

NOTE: Re-install these hoist fasteners after installation of the broadband radome.

- (b) Attach the four hoist fittings [42] and four hoist pins [41] to the broadband radome [1].

- 1) Make sure to remove the hoist fasteners.

EFFECTIVITY
SIA 015-999

D633AM101-SIA

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- (c) Remove the slack from the broadband radome removal/installation equipment, C44001-49 or -59, SPL-15116.
 - 1) Make sure that the broadband radome removal/installation equipment, C44001-49 or -59, SPL-15116 is centered over the broadband radome [1].
- (d) Tighten the four hoist pins [41] to 30 in-lb (3 N·m).

G. Broadband Radome Installation

SUBTASK 53-54-00-420-004

- (1) Carefully lift the broadband radome [1] to the top of the airplane.

SUBTASK 53-54-00-420-005

- (2) Align the broadband radome [1] to the adapter plate assembly [13].

SUBTASK 53-54-00-410-001

- (3) Access the broadband radome blow-out door [6].
 - (a) Insert a Flat Tip Screwdriver, STD-13571 into the slot on the blow-out door latch and pull aft.
 - (b) Pull the latch in the aft direction.
 - (c) Lift the blow-out door in the forward direction.

SUBTASK 53-54-00-110-001

- (4) Clean the screw [11] and bonding jumpers [8] with alcohol, B00130.

SUBTASK 53-54-00-120-001

- (5) Fay surface seal both sides of the washer [12] and the underside of the bonding jumpers [8] with adhesive, A01076.

SUBTASK 53-54-00-420-006

- (6) Attach the bonding jumpers [8], washer [12] and screw [11] to the support structure.

SUBTASK 53-54-00-390-001

- (7) Apply a fillet seal over the screw [11] and washer [12] with adhesive, A01076.

SUBTASK 53-54-00-760-001

- (8) Measure the bonding resistance between bolt [7] and the support structure with a intrinsically safe approved bonding meter, COM-1550 (SWPM 20-20-00, paragraph 21).
 - (a) Make sure that the resistance is 0.5 milliohms or less.

SUBTASK 53-54-00-110-002

- (9) Clean the 67 washers [4] and the broadband radome [1] with alcohol, B00130.

SUBTASK 53-54-00-420-007

- (10) Install the bolt [5] that attach the broadband radome [1] to the adapter plate assembly [13].

SUBTASK 53-54-00-760-002

- (11) Measure the bonding resistance between the bolt [5] and the airplane structure with a intrinsically safe approved bonding meter, COM-1550 (SWPM 20-20-00, paragraph 21).
 - (a) Make sure that the resistance is 0.7 milliohms or less.

SUBTASK 53-54-00-420-008

- (12) Install the 67 bolts [3] and 67 washers [4] that attach the broadband radome [1] to the adapter plate assembly [13].
 - (a) Tighten the 67 bolts [3] to 150 ±20 in-lb (17 ±2 N·m).

NOTE: Start installation of the bolts and washers on the left and right side of the broadband radome.



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SUBTASK 53-54-00-390-002

- (13) Apply the adhesive, A01076 to 67 bolts [3] on the broadband radome [1].

H. Put the Airplane Back to Its Usual Condition

SUBTASK 53-54-00-080-001

- (1) Disconnect the broadband radome removal/installation equipment, C44001-49 or -59, SPL-15116 from the broadband radome [1].
- (a) Remove the four hoist pins [41] and four hoist fittings [42] from the broadband radome [1].

SUBTASK 53-54-00-420-009

- (2) Install the hoist fasteners on the broadband radome [1].
- (a) Tighten each hoist fastener to 29 in-lb (3 N·m) - 31 in-lb (4 N·m).

SUBTASK 53-54-00-440-001

- (3) Activate the satellite communication power.
- (a) Remove the safety tags and close these circuit breakers:

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
A	8	C04073	BROADBAND 1
A	9	C04074	BROADBAND 2

————— END OF TASK —————

TASK 53-54-00-000-802

4. Adapter Plate Assembly Removal

(Figure 402)

A. General

- (1) This task has instructions to remove the adapter plate assembly with a seal adapter plate installed.

B. References

Reference	Title
44-35-10-000-802	Single Panel Antenna Removal (P/B 401)
44-35-29-000-801	Antenna Pointing System 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-15115	Removal/Installation Equipment - Adapter Plate Lift Assy, C44001-50 (included in C44001-55 Kit) / C44001-60 (included in C44001-58 Kit) Part #: C44001-58 Supplier: 81205 Opt Part #: C44001-55 Supplier: 81205

D. Prepare for the Removal

SUBTASK 53-54-00-020-005

- (1) Remove the broadband radome (TASK 53-54-00-000-801).

EFFECTIVITY
SIA 015-999

D633AM101-SIA

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SUBTASK 53-54-00-020-006



WARNING

REMOVE THE ANTENNA BEFORE THE REMOVAL OF THE ADAPTER PLATE ASSEMBLY. DAMAGE TO THE ANTENNA, ADAPTER PLATE ASSEMBLY, AND INJURIES TO PERSONNEL CAN OCCUR.

- (2) Do this task: Single Panel Antenna Removal, TASK 44-35-10-000-802 or Antenna Pointing System Removal, TASK 44-35-29-000-801.

SUBTASK 53-54-00-480-003

- (3) Attach the adapter plate lift assy, C44001-50 or -60, SPL-15115, to the adapter plate assembly [13].

NOTE: Use two persons and a hoist to lift the adapter plate assembly from the airplane.

- (a) Install the four hoist fittings [44] and four hoist pins [43] to the adapter plate assembly [13].
- (b) Remove the slack from the adapter plate lift assy, C44001-50 or -60, SPL-15115.
 - 1) Make sure that the adapter plate lift assy, C44001-50 or -60, SPL-15115, is centered over the adapter plate assembly [13].
- (c) Tighten the four hoist pins [43] to 40 in-lb (5 N·m).

E. Adapter Plate Assembly Removal

SUBTASK 53-54-00-020-007



CAUTION

DO A VISUAL INSPECTION FOR CORROSION OR DAMAGE OF THE LIFTING LUG/ADAPTOR BEFORE YOU LIFT THE ANTENNA. IF THE LIFTING LUG/ADAPTOR HAS CORROSION OR IS DAMAGED, IT CAN FAIL AND CAUSE DAMAGE TO THE AIRPLANE OR EQUIPMENT.

- (1) Remove the adapter plate assembly [13]:
- (a) Remove the bolt [36], washer [37], washers [45], nut [39] and cotter pin [40] from the four lug assemblies [38].
 - (b) Remove the bolt [31], washer [32], washers [45], nut [34] and cotter pin [35] from the lug assembly [33].
 - (c) Remove the bolt [27], washer [28], washer [46], bushing [47] and nut [30] from the lug assembly [29].
 - (d) Remove the bolt [22], washer [23], washers [45], nut [25] and cotter pin [26] from the lug assembly [24].
 - (e) Remove the bolt [17], washer [18], washer [45], nut [20] and cotter pin [21] from the lug assembly [19].
 - (f) Remove the two screws [14] and four washers [15] to disconnect two bonding jumpers [16] from the airplane support structure.
 - 1) Do not remove the bonding jumpers [16] from the adapter plate assembly [13].
 - (g) Remove the adapter plate assembly [13] from the lug assembly [19], lug assembly [24], lug assembly [29], lug assembly [33], and four lug assemblies [38] that attached to the airplane.
 - (h) Carefully lift the adapter plate assembly [13] from the airplane.

————— END OF TASK —————

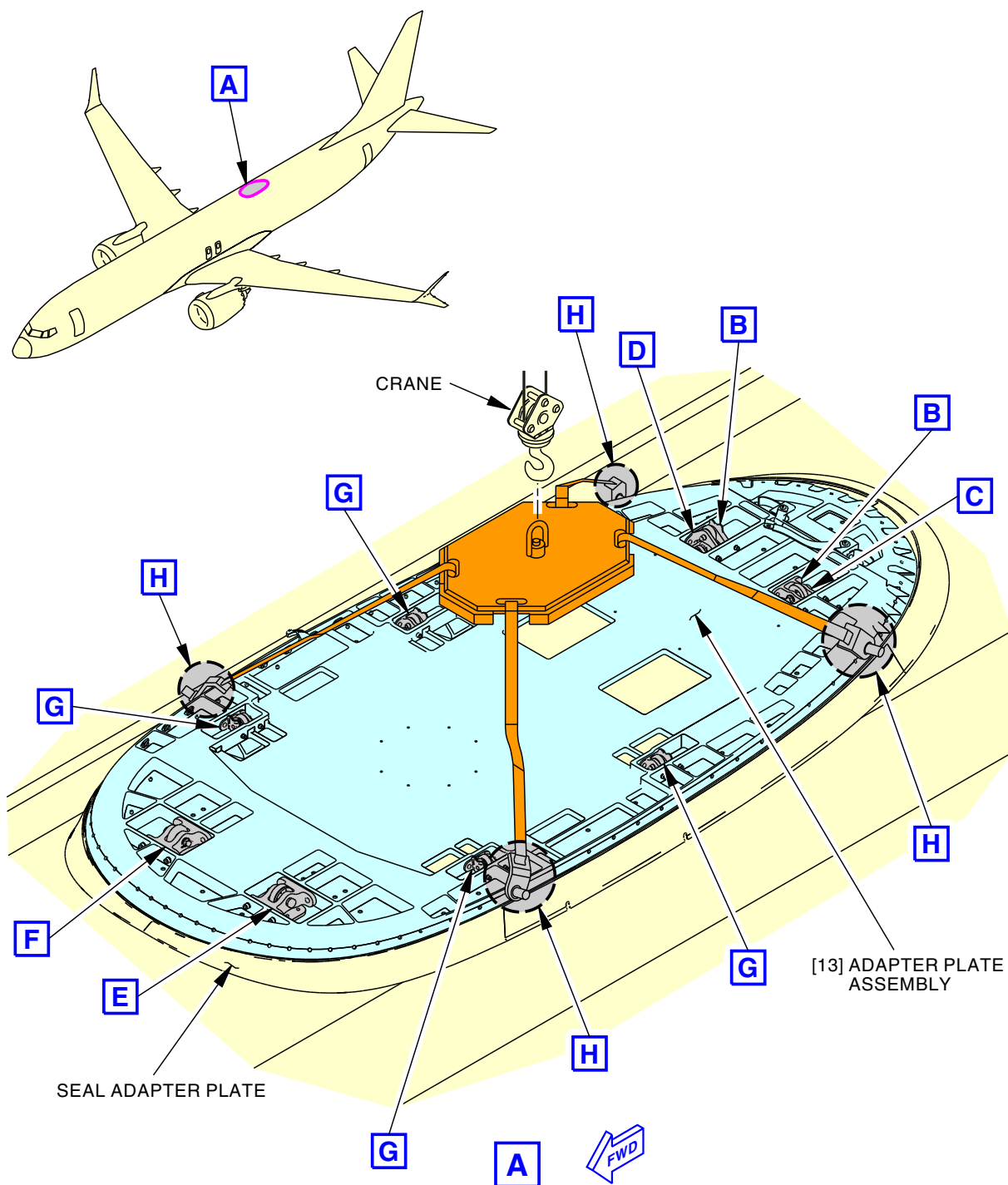
EFFECTIVITY
SIA 015-999

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2538977 S0000601699_V2

Adapter Plate Assembly Installation
Figure 402/53-54-00-990-802 (Sheet 1 of 4)

EFFECTIVITY
SIA 015-999

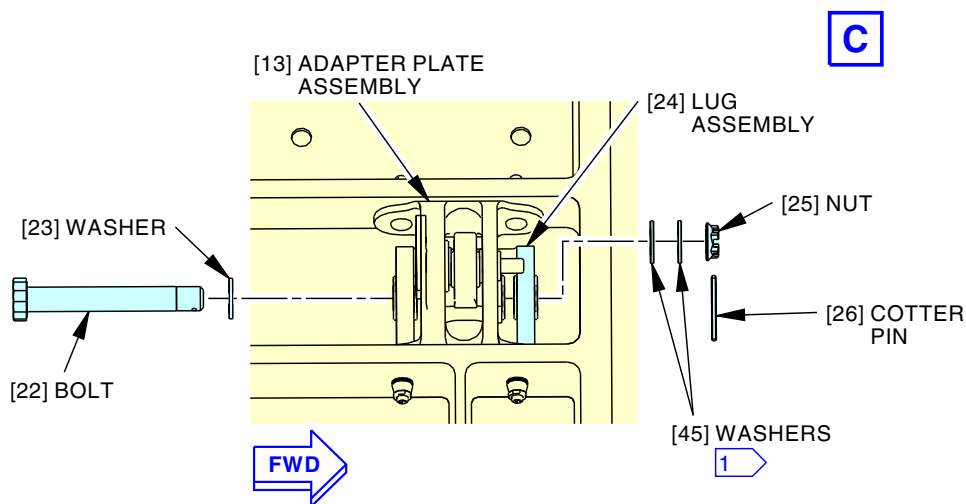
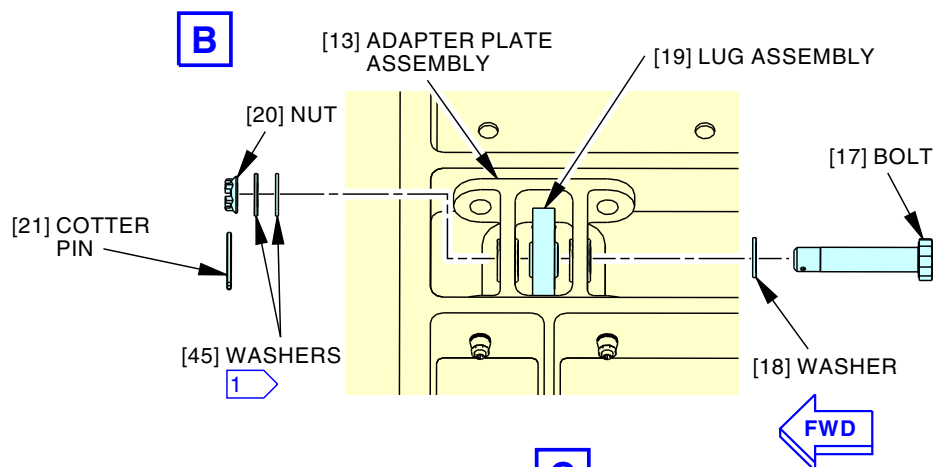
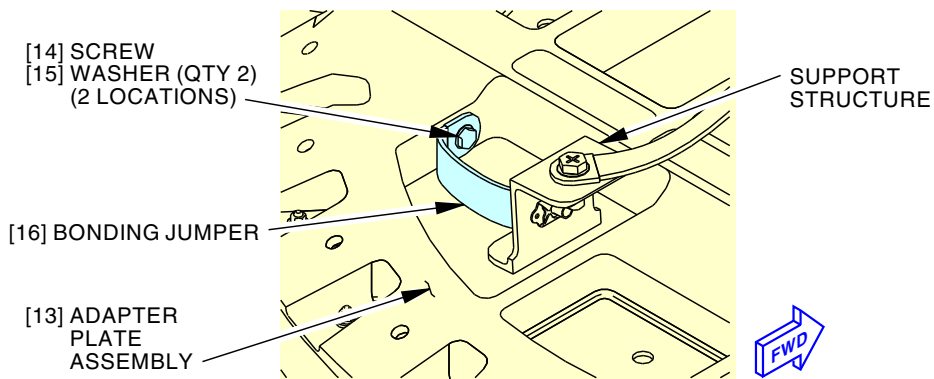
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D

2539021 S0000601892_V2

**Adapter Plate Assembly Installation
Figure 402/53-54-00-990-802 (Sheet 2 of 4)**

EFFECTIVITY
SIA 015-999

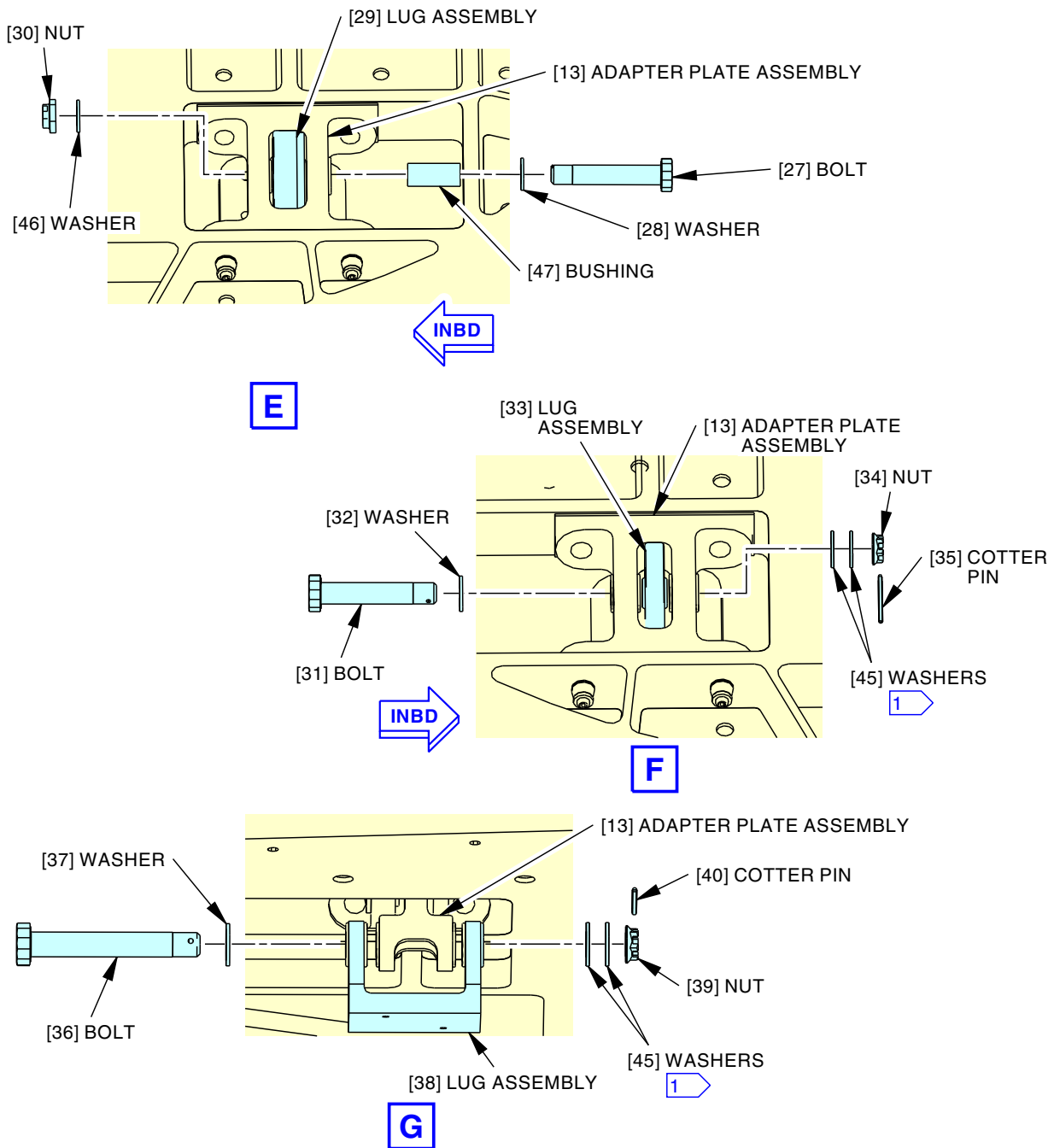
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2539061 S0000602110_V2

**Adapter Plate Assembly Installation
Figure 402/53-54-00-990-802 (Sheet 3 of 4)**

EFFECTIVITY
SIA 015-999

D633AM101-SIA

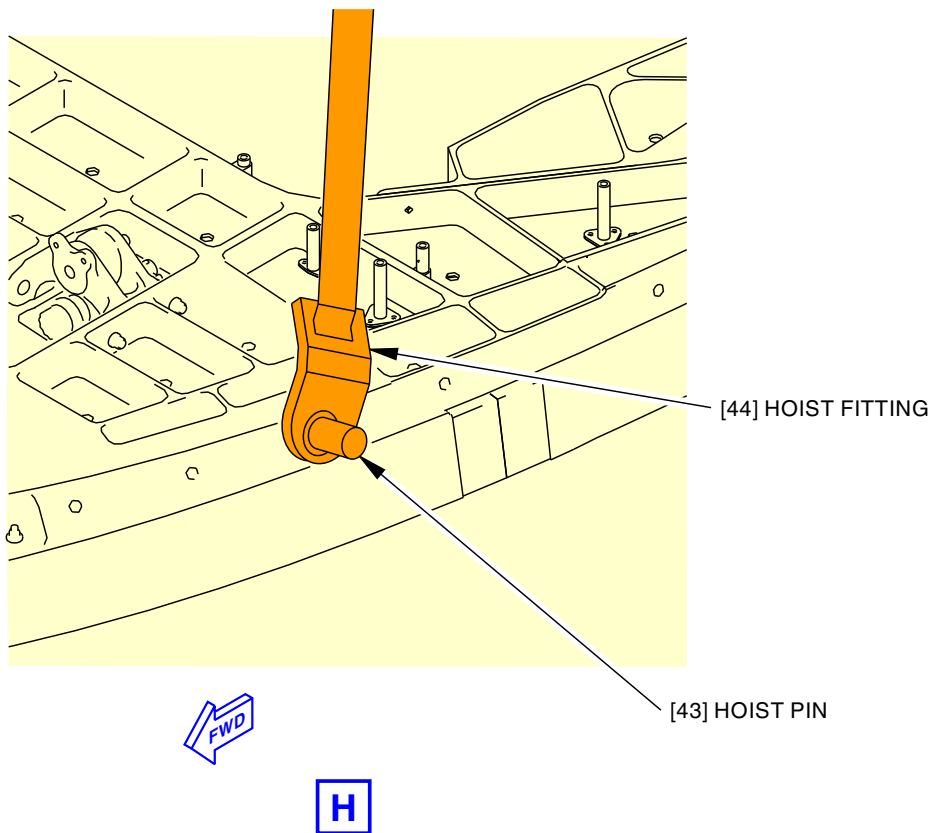
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2564425 S0000612259_V2

Adapter Plate Assembly Installation
Figure 402/53-54-00-990-802 (Sheet 4 of 4)

EFFECTIVITY
SIA 015-999

D633AM101-SIA

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TASK 53-54-00-400-802

5. **Adapter Plate Assembly Installation**

(Figure 402)

A. General

- (1) This task has instructions to install the adapter plate assembly with a seal adapter plate installed.

B. References

Reference	Title
44-35-10-400-802	Single Panel Antenna Installation (P/B 401)
44-35-29-400-801	Antenna Pointing System 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-15115	Removal/Installation Equipment - Adapter Plate Lift Assy, C44001-50 (included in C44001-55 Kit) / C44001-60 (included in C44001-58 Kit) Part #: C44001-58 Supplier: 81205 Opt Part #: C44001-55 Supplier: 81205

D. Prepare for the Installation

SUBTASK 53-54-00-480-004

- (1) Attach the adapter plate lift assy, C44001-50 or -60, SPL-15115, to the adapter plate assembly [13].

NOTE: Use two persons to hoist and lift the adapter plate assembly on the airplane.

- (a) Attach four hoist fittings [44] and four hoist pins [43] to the adapter plate assembly [13].
- (b) Remove the slack from the adapter plate lift assy, C44001-50 or -60, SPL-15115.
- 1) Make sure that the adapter plate lift assy, C44001-50 or -60, SPL-15115, is centered over the adapter plate assembly [13].
- (c) Tighten the four hoist pins [43] to 40 in-lb (5 N·m).

E. Adapter Plate Assembly Installation

SUBTASK 53-54-00-420-010

 CAUTION	DO A VISUAL INSPECTION FOR CORROSION OR DAMAGE OF THE LIFTING LUG/ADAPTOR BEFORE YOU LIFT THE ANTENNA. IF THE LIFTING LUG/ADAPTOR HAS CORROSION OR IS DAMAGED, IT CAN FAIL AND CAUSE DAMAGE TO THE AIRPLANE OR EQUIPMENT.

- (1) Carefully lift the adapter plate assembly [13] to the top of the airplane.
- (a) Make sure that the adapter plate assembly [13] aligns with the lug assembly [19], lug assembly [24], lug assembly [29], lug assembly [33], and the four lug assemblies [38].
- (b) Install the two screws [14] and four washers [15] to connect the two bonding jumpers [16] of the adapter plate assembly [13] to the airplane support structure.
- 1) Tighten the two screws [14] to 80 ±2 in-lb (9.0 ±0.2 N·m).
- (c) To connect the adapter plate assembly [13] to the lug assembly [19], do these steps:



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- 1) Install the bolt [17], washer [18], washer [45] and nut [20].
 - a) If necessary, install additional washers [45] to ensure the gap of 0.01 in. (0.25 mm) - 0.04 in. (1.02 mm) after nut [20] is locked with cotter pin [21].
 - 2) Make sure to back off the nearest castellation for the nut [20].
 - 3) Install a new cotter pin [21].
- (d) To connect the adapter plate assembly [13] to the lug assembly [24], do these steps:
- 1) Install the bolt [22], washer [23], washer [45] and nut [25].
 - a) If necessary, install additional washers [45] to ensure the gap of 0.01 in. (0.25 mm) - 0.04 in. (1.02 mm) after nut [25] is locked with cotter pin [26].
 - 2) Make sure to back off the nearest castellation for nut [25].
 - 3) Install a new cotter pin [26].
- (e) To connect the adapter plate assembly [13] to the lug assembly [29], do these steps:
- 1) Install the bolt [27], washer [28], bushing [47], washer [46] and nut [30].
 - 2) Tighten the nut [30] to 300 ±9 in-lb (34 ±1 N·m).
- (f) To connect the adapter plate assembly [13] to the lug assembly [33], do these steps:
- 1) Install the bolt [31], washer [32], washer [45] and nut [34].
 - a) If necessary, install additional washers [45] to ensure the gap of 0.01 in. (0.25 mm) - 0.04 in. (1.02 mm) after nut [34] is locked with cotter pin [35].
 - 2) Make sure to back off the nearest castellation for nut [34].
 - 3) Install a new cotter pin [35].
- (g) To connect the adapter plate assembly [13] to the lug assembly [38], do these steps:
- 1) Install the bolt [36], washer [37], washer [45] and nut [39].
 - a) If necessary, install additional washers [45] to ensure the gap of 0.01 in. (0.25 mm) - 0.04 in. (1.02 mm) after nut [39] is locked with cotter pin [40].
 - 2) Make sure to back off the nearest castellation for the nut [39].
 - 3) Install a new cotter pin [40].

F. Put the Airplane Back to Its Usual Condition

SUBTASK 53-54-00-080-002

- (1) Disconnect the adapter plate lift assy, C44001-50 or -60, SPL-15115, from the adapter plate assembly [13].
 - (a) Remove the four hoist pins [43] and four hoist fittings [44] from the adapter plate assembly [13].

SUBTASK 53-54-00-420-017

 WARNING	BE CAREFUL WHEN YOU INSTALL THE ANTENNA. THE ANTENNA IS HEAVY. DAMAGE TO THE ANTENNA, AND INJURIES TO PERSONNEL, CAN OCCUR.

- (2) If necessary, do this task: Single Panel Antenna Installation, TASK 44-35-10-400-802 or Antenna Pointing System Installation, TASK 44-35-29-400-801.

SUBTASK 53-54-00-420-018

- (3) Install the broadband radome (TASK 53-54-00-400-801).

————— **END OF TASK** —————

EFFECTIVITY
SIA 015-999

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BROADBAND RADOME - INSPECTION/CHECK

1. General

- A. This procedure has this task:
- (1) Broadband Radome Inspection

TASK 53-54-00-211-801

2. Broadband Radome Inspection

(Figure 601)

A. General

- (1) This task has instructions to inspect the Broadband Radome for damage.
 - (a) Exterior Coating Damage
 - (b) Blow-out Door Laminate Damage
 - (c) Lightning Diverter Strip Damage
 - (d) Hoist Point Hardware Damage
 - (e) Blow-out Door Edge Protector Damage
 - (f) Leading Edge Protector Damage.
 - (g) Blow-out Door Hinge Damage
 - (h) Blow-out Door Latch Damage
 - (i) Blow-out Door Seal Damage.

B. References

Reference	Title
53-54-00-000-801	Broadband Radome Removal (P/B 401)
53-54-00-300-801	Blow-out Door Hinge Repair (P/B 801)
53-54-00-300-802	Blow-out Door Latch Repair (P/B 801)
53-54-00-300-803	Blow-out Door Opening Edge Protector Repair (P/B 801)
53-54-00-300-804	Blow-out Seal Door Repair (P/B 801)
53-54-00-300-808	Radome Exterior Coating Repair (P/B 801)
53-54-00-400-801	Broadband Radome Installation (P/B 401)

C. Broadband Radome Inspection

SUBTASK 53-54-00-211-001

- (1) Inspect the Broadband Radome Exterior Coating Damage:
 - (a) Visually inspect the radome and radome blow-out door assembly exterior for scuffs, cuts, scratches or discolored areas that do not penetrate the coating.
 - (b) Visually inspect the radome and radome blow-out door assembly exterior for scuffs, cuts, scratches or discolored areas that penetrate the coating, but do not expose underlying coating primer or laminate.
 - (c) Visually inspect the radome and door assembly exterior for scuffs, cuts or scratches that penetrate the coating, and expose underlying coating primer and/or laminate.
 - (d) Visually inspect the antistatic topcoat for loss of adhesion to the elastomeric base coat. The indications are loose, bubbled or lost coating.
 - 1) Do the inspection as required.
 - 2) If the damage does not penetrate the coating, no repair is required.

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- 3) If the coating is penetrated but the primer or laminate is not exposed, no repair is required.
- (e) If the coating is penetrated and the primer or laminate is exposed, evaluate the damage against the criteria that follows:
 - 1) In the forward-exposed region of the radome, immediately repair individual damaged areas of coating primer or laminate larger than 0.25 square inches.
 - 2) In the forward-exposed region of the radome, no more than five areas of non-repaired damage smaller than 0.25 square inch are allowed.
 - 3) Make sure at least 1 inch of undamaged coating separates the damaged areas from each other.
 - 4) In the non-forward exposed region of the radome, if a damaged area is smaller than 1 square inch, no repair is required.
 - 5) In the non-forward exposed region of the radome, no more than five areas of non-repaired damage smaller than 1 square inch are allowed.
 - 6) Make sure at least 1 inch of undamaged coating separates the damaged areas from each other.
- (f) If the antistatic topcoat exhibits loss of adhesion to the elastomeric base coat, evaluate the damage against the criteria that follows:
 - 1) In the forward-exposed region of the radome, no damage area greater than 4 square inches is allowed.
- (g) If coating repair is required, do this task: Radome Exterior Coating Repair, TASK 53-54-00-300-808.

SUBTASK 53-54-00-211-002

- (2) Inspect the Broadband Radome Blow-out Door Laminate Damage:
 - (a) Inspect the radome shell and radome blow-out door for lamination damage.
 - (b) Do the inspection as required.
 - (c) In the forward-exposed region of the radome (Figure 601), no damage of any size is allowed. If lamination damage exists, replace the broadband radome, do these tasks:
 - 1) Broadband Radome Removal, TASK 53-54-00-000-801
 - 2) Broadband Radome Installation, TASK 53-54-00-400-801
 - (d) In the aft attachment region (Figure 601), evaluate the damage against the criteria that follows:
 - 1) Dents that do not cause damage to the quartz fibers are permitted if they are:
 - a) A maximum of 0.50 inches in diameter or across the longest dimension.
 - b) A maximum of 0.008 inches in depth.
 - c) Located above the row of attachment fasteners (as defined by a line connecting fastener centerlines).
 - d) Located a minimum of 1 inch away from any fastener center.
 - e) Located at least 2 times the dent diameter away from any other damage location.
 - (e) In all other areas of the radome (Figure 601), evaluate the damage against the criteria that follows:
 - 1) Dents that do not cause damage to the quartz fibers are permitted if they are:



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- a) A maximum of 0.50 inches in diameter or across the longest dimension.
 - b) A maximum of 0.008 inches in depth.
 - c) Located a minimum of 1 inch away from the blow-out door.
 - d) Located at least 2 times the dent diameter away from any other damage location.
- (f) If the damage exceeds the criteria above, replace the broadband radome, do these tasks:
- 1) Broadband Radome Removal, TASK 53-54-00-000-801
 - 2) Broadband Radome Installation, TASK 53-54-00-400-801

SUBTASK 53-54-00-211-003

- (3) Inspect the Broadband Radome Lightning Diverter Strip Damage:
- (a) Visually inspect the lightning diverter strip for missing lightning diverter strip segments or "buttons".
 - (b) Visually inspect the lightning diverter strip for an unbonded or damaged lightning diverter strip.
 - 1) Do the inspection as required.
 - (c) If either condition exists, replace the broadband radome, do these tasks:
 - 1) Broadband Radome Removal, TASK 53-54-00-000-801
 - 2) Broadband Radome Installation, TASK 53-54-00-400-801

SUBTASK 53-54-00-211-004

- (4) Inspect the Broadband Radome Hoist Point Hardware Damage:
- (a) Visually inspect for damage (damaged threads or bent nutplate base) of hoist point hardware (nutplate), that prevents normal removal and installation of hoist point screw.
 - 1) Do the inspection as required.
 - (b) If damage exists, replace the broadband radome, do these tasks:
 - 1) Broadband Radome Removal, TASK 53-54-00-000-801
 - 2) Broadband Radome Installation, TASK 53-54-00-400-801

SUBTASK 53-54-00-211-005

- (5) Inspect the Broadband Radome Blow-out Door Edge Protector Damage:
- (a) Visually inspect for damage, including bending and/or disbonding of edge protector, that prevents normal opening and closing of door.
 - 1) Do the inspection as required.
 - (b) If the blow-out door edge protector damage does not prevent blow-out door normal operation, repair the blow-out door edge protector, do this task: (Blow-out Door Opening Edge Protector Repair, TASK 53-54-00-300-803).
 - (c) If blow-out door edge protector damage exists that prevents blow-out door normal operation, replace the broadband radome, do these tasks:
 - 1) Broadband Radome Removal, TASK 53-54-00-000-801
 - 2) Broadband Radome Installation, TASK 53-54-00-400-801

SUBTASK 53-54-00-211-006

- (6) Inspect the Broadband Radome Leading Edge Protector Damage:
- (a) Visually inspect for damage, including bending and/or disbonding of edge protector, that interferes with installation of radome on aircraft.



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- 1) Do the inspection as required.
- (b) If damage exists, replace the broadband radome, do these tasks:
 - 1) Broadband Radome Removal, TASK 53-54-00-000-801
 - 2) Broadband Radome Installation, TASK 53-54-00-400-801

SUBTASK 53-54-00-211-007

- (7) Inspect the Broadband Radome Blow-out Door Hinge Damage:
- (a) Visually inspect for damage, including bending of hinge arm or brackets, that interferes with normal opening and closing of blow-out door.
 - 1) Do the inspection as required.
 - (b) If the blow-out door hinge damage does not prevent blow-out door normal operation, repair the blow-out door hinge, do this task: Blow-out Door Hinge Repair, TASK 53-54-00-300-801.
 - (c) If blow-out door hinge damage exists that prevents blow-out door normal operation, replace the broadband radome, do these tasks:
 - 1) Broadband Radome Removal, TASK 53-54-00-000-801
 - 2) Broadband Radome Installation, TASK 53-54-00-400-801

SUBTASK 53-54-00-211-008

- (8) Inspect the Broadband Radome Blow-out Door Latch Damage:
- (a) Visually inspect for damage, including jamming of latch mechanism, that interferes with normal opening and closing of latch of blow-out door.
 - 1) Do the inspection as required.
 - (b) If the blow-out door latch damage does not prevent blow-out door normal operation, repair the blow-out door latch, do this task: Blow-out Door Latch Repair, TASK 53-54-00-300-802.
 - (c) If blow-out door latch damage exists that prevents blow-out door normal operation, replace the broadband radome, do these tasks:
 - 1) Broadband Radome Removal, TASK 53-54-00-000-801
 - 2) Broadband Radome Installation, TASK 53-54-00-400-801

SUBTASK 53-54-00-211-009

- (9) Inspect the Broadband Radome Blow-out Door Seal Damage:
- (a) Visually examine the blow-out door for damage (disbonding, seal tearing) that prevents normal operation of the blow-out door.
 - 1) Do the inspection as required.
 - (b) Visually inspect for a torn or missing seal, or section of seal.
 - (c) If the blow-out door seal damage does not prevent blow-out door normal operation, repair the blow-out door seal, do this task: Blow-out Seal Door Repair, TASK 53-54-00-300-804.
 - (d) If blow-out door seal damage exists that prevents blow-out door normal operation, replace the broadband radome, do these tasks:
 - 1) Broadband Radome Removal, TASK 53-54-00-000-801
 - 2) Broadband Radome Installation, TASK 53-54-00-400-801

————— **END OF TASK** —————

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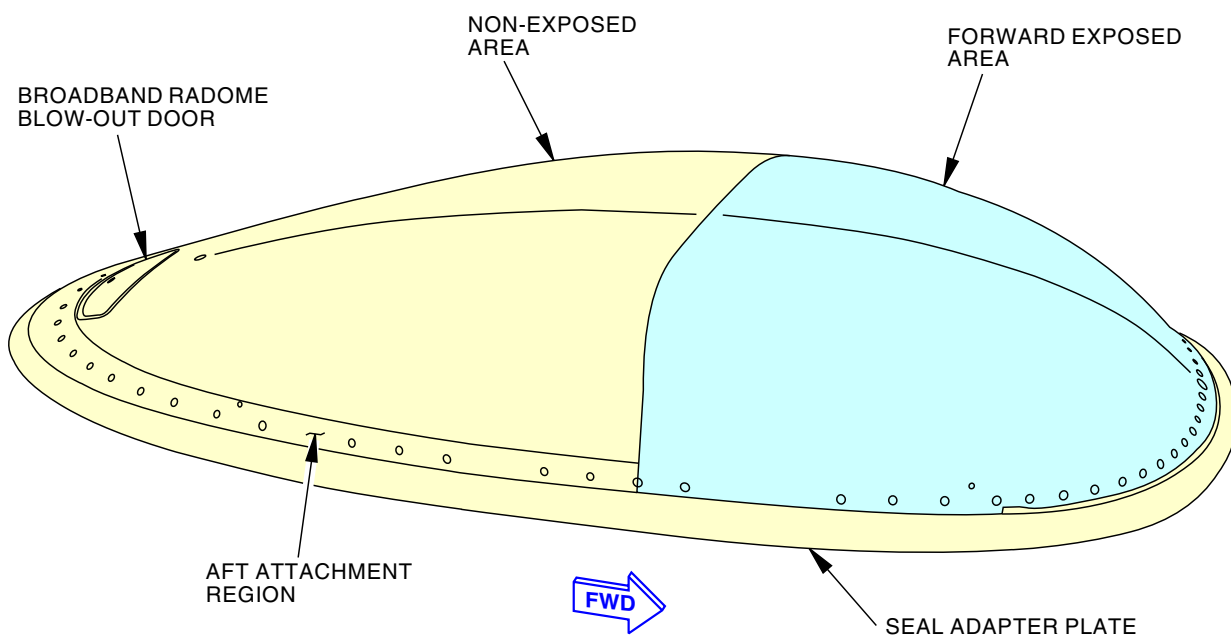
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Broadband Radome Inspection
Figure 601/53-54-00-990-803

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BROADBAND RADOME - REPAIRS

1. General

A. This procedure has these tasks:

- (1) Blow-out Door Hinge Repair
- (2) Blow-out Door Latch Repair
- (3) Blow-out Door Opening Edge Protector Repair
- (4) Blow-out Door Seal Repair
- (5) Hoist Point Nutplate Repair
- (6) Leading Edge Protector Repair
- (7) Lighting Diverter Strip Repair
- (8) Radome Exterior Coating Repair

TASK 53-54-00-300-801

2. Blow-out Door Hinge Repair

A. General

- (1) The blow-out door hinge repair consists of replacing the damaged hinge with a new hinge.

B. Blow-out Door Hinge Repair

SUBTASK 53-54-00-320-001

- (1) To replace a damaged blow-out door hinge, do these steps:
 - (a) Remove all of the fasteners that attach the hinge to the radome and blow-out door:
 - 1) Hold the fasteners using a 5/64" hex wrench.
 - 2) Turn the collar (nut) with grip-type pliers.
 - (b) Remove the damaged hinge.
 - (c) Attach the new hinge to the radome:
 - 1) Use a 5/64" hex wrench to hold the hinge bolts.
 - 2) Turn the collar / nut with a common 5/16" wrench.
 - (d) Attach the hinge to the blow-out door:
 - 1) Use a 5/64" hex wrench to hold the hinge bolts.
 - 2) Turn the collar / nut with a common 5/16" wrench.

SUBTASK 53-54-00-320-034

- (2) Touch-up the coating on the radome exterior, if required, do this task: Radome Exterior Coating Repair, TASK 53-54-00-300-808.

————— **END OF TASK** —————

TASK 53-54-00-300-802

3. Blow-out Door Latch Repair

A. General

- (1) The blow-out door latch repair consists of replacing the damaged latch with a new latch.

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B. Blow-out Door Latch Repair

SUBTASK 53-54-00-320-002

- (1) To replace a damaged blow-out door latch, do these steps:
 - (a) Remove all of the fasteners that attach the latch to the radome and blow-out door:
 - 1) Hold the fasteners using a 5/64" hex wrench.
 - 2) Turn the collar (nut) with grip-type pliers.
 - (b) Remove the damaged latch.
 - (c) Put the new latch in position on the blow-out door.
 - (d) Attach the new latch to the blow-out door:
 - 1) Use a 5/64" hex wrench to hold the hinge bolts.
 - 2) Turn the collar (nut) with a common 5/16" wrench.

SUBTASK 53-54-00-320-035

- (2) Touch-up the coating on the radome exterior, do this task: Radome Exterior Coating Repair, TASK 53-54-00-300-808.

————— **END OF TASK** —————

TASK 53-54-00-300-803

4. Blow-out Door Opening Edge Protector Repair

A. General

- (1) The blow-out door opening edge protector repair consists of replacing the damaged edge protector with a new edge protector.
- (2) This repair procedure cannot be done while the radome is installed on the airplane.

B. References

Reference	Title
53-54-00-000-801	Broadband Radome Removal (P/B 401)

C. Tools/Equipment

Reference	Description
STD-549	Knife - Putty, Broad Blade

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A01076	Adhesive - Synthetic Rubber	BAC5010 Type 93 (BMS5-95 Class B)
B00062	Solvent - Acetone (99.5% Grade)	ASTM D 329 (Supersedes O-A-51)
B00130	Alcohol - Isopropyl	TT-I-735
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	

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E. Blow-out Door Opening Edge Protector Repair

SUBTASK 53-54-00-020-015

- (1) If the damaged radome is still on the airplane, do this task: Broadband Radome Removal, TASK 53-54-00-000-801.

SUBTASK 53-54-00-320-003

- (2) To repair the blow-out door opening edge protector, do these steps:
- (a) Open the blow-out door.
 - (b) Mask the coated radome surface surrounding blow-out door edge protector.
 - (c) Use a broad blade putty knife, STD-549 to carefully disbond and remove door opening edge protector.
 - (d) Use sandpaper, G50260 to scuff sand the door opening edge protector bond region.
 - (e) Use a cotton wiper, G00034 moistened with alcohol, B00130 to remove loose particles left by the sanding.
 - (f) Wipe the new edge protector with another cotton wiper, G00034 moistened with alcohol, B00130.
 - (g) Apply adhesive, A01076 or sealant, A00247 to the bond surface of the door opening edge protector.
 - (h) Apply adhesive, A01076 or sealant, A00247 to the door opening edge protector bond surface of the radome.
 - (i) Put the door opening edge protector in the radome door opening and press into position.
 - (j) Use a cotton wiper, G00034 that is moist with solvent, B00062 to remove excess adhesive.
- NOTE:** Use only the amount of solvent required to remove excess adhesive.
- (k) Close the radome blow-out door assembly and latch the door in the closed position. This allows the door and door seal to press against door opening edge protector to hold the edge protector in position while the adhesive cures.
 - (l) Let the adhesive cure for 24 hours at 80 ±10°F (27 ±6°C).

————— **END OF TASK** —————

TASK 53-54-00-300-804

5. Blow-out Seal Door Repair

A. General

- (1) The blow-out door seal repair consists of replacing the damaged seal with a new seal.

B. Tools/Equipment

Reference	Description
STD-549	Knife - Putty, Broad Blade
STD-761	Scissors

C. Consumable Materials

Reference	Description	Specification
A00562	Adhesive - High Strength Silicone Rubber, One-Part - RTV157	
G50260	Sandpaper - Aluminum Oxide, 220 Grit	

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D. Blow-out Door Seal Repair

SUBTASK 53-54-00-390-003

- (1) To replace a damaged blow-out door seal, do these steps:
 - (a) Open the blow-out door.
 - (b) Use a broad blade putty knife, STD-549 to remove the damaged blow-out door seal.
 - (c) Use sandpaper, G50260 to scuff sand the outer door flange surface to remove remaining seal adhesive.
 - (d) Use sandpaper, G50260 to scuff sand the inner door flange surface to remove remaining seal adhesive.
 - (e) Use sandpaper, G50260 to scuff sand the edge of door flange surface to remove remaining seal adhesive.
 - (f) Use scissors, STD-761 to cut the seal at the seal centerline on the latch side of the seal.
 - (g) Use scissors, STD-761 to cut the seal on the hinge side of the seal, 2" to 3" to either the left or right side of the centerline.
 - (h) "Dry fit" the seal to the blow-out door. Trim excess seal length to permit butt joint of seal ends with no gap permitted.
 - (i) Apply RTV157 adhesive, A00562 to the bond surface of the door seal halves
 - (j) Apply RTV157 adhesive, A00562 to the outer and inner surfaces of the blow-out door flange.
 - (k) Install one half (either half) of the door seal onto the blow-out door flange.
NOTE: The door seal is molded to fit over the flange of the blow-out door flange.
 - (l) Install the other half of door seal onto the blow-out door flange.
 - (m) Carefully close and latch the door in the closed position to permit seal to be tightly held into position while the door seal adhesive cures.
 - (n) Apply RTV157 adhesive, A00562 along the door-to-seal joint line, especially in areas where unfilled gaps between door and seal bulb are visually apparent.

————— **END OF TASK** —————

TASK 53-54-00-300-805

6. Hoist Point Nutplate Repair

A. General

- (1) The radome hoist point nutplate repair consists of replacing the damaged nutplate with a new nutplate.
- (2) This repair procedure cannot be done while the radome is installed on the airplane.

B. References

Reference	Title
53-54-00-000-801	Broadband Radome Removal (P/B 401)

C. Radome Hoist Point Nutplate Repair

SUBTASK 53-54-00-020-016

- (1) If the damaged radome is still on the airplane, remove it, do this task: Broadband Radome Removal, TASK 53-54-00-000-801.

SUBTASK 53-54-00-320-004

- (2) To replace the radome hoist point nutplate, do these steps:

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- (a) Use a small diameter (1" to 2") disc sander to remove the rivet tail, which attaches the defective hoist point nutplate to the radome.
- (b) Use a small hammer and a small-diameter (0.070" to 0.090") punch to remove the rivets that attach the hoist point nutplate to the radome.
- (c) Install new rivets (NAS1200M3-7) into the hoist point nutplate rivet holes from the outer surface of the radome.
- (d) Put the new hoist point nutplate (BACN11G3A1CD) onto the rivets protruding through radome shell.
- (e) Position a pneumatic rivet squeezer over the hoist point nutplate rivets.
- (f) Squeeze the rivets to attach the hoist point nutplate to the radome.

SUBTASK 53-54-00-320-033

- (3) Touch-up the coating on the radome exterior, if required. To touch up the coating, do this task: Radome Exterior Coating Repair, TASK 53-54-00-300-808.

END OF TASK

TASK 53-54-00-300-806

7. Leading Edge Protector Repair

A. General

- (1) The radome leading edge protector repair consists of replacing the damaged leading edge protector with a new leading edge protector.
- (2) This repair procedure cannot be done while the radome is installed on the airplane.

B. References

Reference	Title
53-54-00-000-801	Broadband Radome Removal (P/B 401)

C. Tools/Equipment

Reference	Description
STD-549	Knife - Putty, Broad Blade
STD-3729	Fastener - Spring Loaded, Sheet Metal, 3/16 Cleco

D. Consumable Materials

Reference	Description	Specification
A01076	Adhesive - Synthetic Rubber	BAC5010 Type 93 (BMS5-95 Class B)

E. Radome Leading Edge Protector Repair

SUBTASK 53-54-00-020-017

- (1) If the damaged radome is still on the airplane, do this task: Broadband Radome Removal, TASK 53-54-00-000-801.

SUBTASK 53-54-00-320-005

- (2) To replace the radome leading edge protector, do these steps:
 - (a) Mask the coated radome surface surrounding the leading edge protector.
 - (b) Use a small drill motor and #40 (0.098" diameter) drill bit to remove the countersink heads of the rivets that attach the leading edge protector to the radome.
 - (c) Use a small hammer and small (0.070" to 0.090") diameter punch to remove the rivets.

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- (d) Use a broad blade putty knife, STD-549 to carefully disbond and remove the leading edge protector.
- (e) Use a small drill motor and a #40 (0.098" diameter) drill bit to enlarge the pilot hole nearest each end of the new leading edge protector to size #40 (0.098").
- (f) "Dry fit" the new leading edge protector on the radome.
- (g) Use a spring loaded fastener, STD-3729 to hold the leading edge protector in place.
- (h) Use a small drill motor and #40 (0.098") drill bit to "back drill" through the existing rivet hole in the radome and through the remaining ("unopened") leading edge protector rivet hole.
- (i) Repeat steps (g) and (h) on the holes on the other end of the leading edge protector.
- (j) Use a drill motor and a small microstop with a 100-degree cutter and #40 (0.098" diameter) pilot to countersink the outer surface of the leading edge protector at the edge protector rivet hole locations to accept NAS1200M3-6.5 rivet.
- (k) Remove the spring loaded fastener, STD-3729 and the leading edge protector from the radome.
- (l) Apply adhesive, A01076 to the lower (radome trim) edge of the radome and to the outer surface of the radome in the leading edge protector area.
- (m) Apply adhesive, A01076 to the bond surface of the leading edge protector.
- (n) Put the new leading edge protector in place on the radome.
- (o) Secure each end of the leading edge protector with a spring loaded fastener, STD-3729 while the adhesive cures.
- (p) After the adhesive has cured, install a rivet in the open hole in each end of the leading edge protector.
- (q) Remove the spring loaded fastener, STD-3729 and install a rivet in the other open hole in each end of the leading edge protector.
- (r) Put a pneumatic rivet squeezer into position to squeeze the rivets.
- (s) Squeeze the rivets.

————— **END OF TASK** —————

TASK 53-54-00-300-807

8. Lightning Diverter Strip Repair

A. General

- (1) The radome lightning diverter strip repair consists of replacing the damaged lightning diverter strip with a new lightning diverter strip.

B. References

Reference	Title
53-54-00-000-801	Broadband Radome Removal (P/B 401)

C. Consumable Materials

Reference	Description	Specification
B00130	Alcohol - Isopropyl	TT-I-735
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

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(Continued)

Reference	Description	Specification
G50073	Promoter - Tape Adhesion - Adhesion Promoter 86A	
G50260	Sandpaper - Aluminum Oxide, 220 Grit	

D. Radome Lightning Diverter Strip Repair

SUBTASK 53-54-00-020-018

- (1) If the damaged radome is still on the airplane, do this task: Broadband Radome Removal, TASK 53-54-00-000-801.

SUBTASK 53-54-00-320-006

- (2) Apply masking tape and paper along the edge of the lightning diverter strips.

NOTE: The lightning diverter strips are 0.40" wide, and the edge of the lightning diverter strips appears as a "step" in the radome exterior coating in the vicinity of the lightning diverter strips.

SUBTASK 53-54-00-320-007

- (3) Use a standard putty knife to carefully pry the dimpled washers from the radome surface at the forward and aft terminations of the lightning diverter strips.

SUBTASK 53-54-00-320-008

- (4) Use a utility or other narrow-blade sharp knife to very carefully cut through the radome coating at the edge of the lightning diverter strips.

SUBTASK 53-54-00-320-009

- (5) Use a standard putty knife to carefully disbond the lightning diverter strip from the radome outer surface.

SUBTASK 53-54-00-320-010

- (6) If necessary due to damage, replace the masking materials (tape and paper) in the area surrounding the lightning diverter strip bond region.

SUBTASK 53-54-00-320-011

- (7) Use sandpaper, G50260 to scuff sand the bond surface of the radome in the area that will receive the new lightning diverter strips.

SUBTASK 53-54-00-320-012

- (8) Use a cotton wiper, G00034 moistened with solvent to wipe the abraded surface of the radome.

SUBTASK 53-54-00-320-013

- (9) Use a narrow artist brush to apply Adhesion Promoter 86A, G50073 to the radome surface in the lightning diverter strip bond region.

SUBTASK 53-54-00-320-014

- (10) Wait 15 to 20 minutes for the Adhesion Promoter 86A, G50073 to air dry on the surface of the radome.

SUBTASK 53-54-00-320-015

- (11) Carefully peel the protective paper away from the bond side of a new lightning diverter strip.

SUBTASK 53-54-00-320-016

- (12) Apply the new lightning diverter strip to the radome.
(a) Work may begin at either the forward termination of the lightning diverter strip, or at the aft termination of the lightning diverter strip.

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- (b) Two lightning diverter strips will be applied to the radome.
- (c) The ends of both of these lightning diverter strips shall be positioned 0.060" to 0.100" from the edge of the dimpled washer countersink.

SUBTASK 53-54-00-320-017

- (13) After one of the lightning diverter strips has been applied along its full length to the radome surface, butt-join a second section of lightning diverter strip to the first section of lightning diverter strip, with no gap between these two sections of lightning diverter.

SUBTASK 53-54-00-320-018

- (14) Apply the second section of lightning diverter strip to within 1" to 3" of the dimpled washer countersink at the termination of the lightning diverter strip.

SUBTASK 53-54-00-320-019

- (15) Trim the end of the second section of lightning diverter strip such that the end of the lightning diverter strip is 0.060" to 0.100" from the edge of the dimpled washer countersink.

SUBTASK 53-54-00-320-020

- (16) Prepare to bond dimpled washers to termination of the lightning diverter strip sections by scuff sanding the radome surface in the region to receive the dimpled washers.

SUBTASK 53-54-00-320-021

- (17) Apply Loctite / Hysol Company paste adhesive product EA-934NA to the bond surface of the dimpled washer.

NOTE: This paste adhesive shall not be applied where it will come into contact with the "buttons/segments" of the lightning diverter strip.

SUBTASK 53-54-00-320-022

- (18) Apply the adhesive-coated dimpled washer to the radome surface.

SUBTASK 53-54-00-320-023

- (19) Use a cotton wiper, G00034 moistened with solvent to remove excess paste adhesive.

SUBTASK 53-54-00-320-024

- (20) Use only the minimum amount of solvent (acetone) required to wipe away excess adhesive.

SUBTASK 53-54-00-320-025

- (21) Apply a piece of tape over dimpled washers to secure them in place during the adhesive cure period.

SUBTASK 53-54-00-320-026

- (22) Let the adhesive cure for a period of 24 hours at 80 ±10°F (27 ±6°C).

SUBTASK 53-54-00-320-027

- (23) Apply narrow masking tape to the lightning diverter strips, centering the masking tape over the buttons/segments of the lightning diverter strips.

SUBTASK 53-54-00-320-028

- (24) Use 240 (or finer) sandpaper to scuff sand the diverter carrier laminate and the adjacent rain erosion coating in the area that received the new lightning diverter strips.

SUBTASK 53-54-00-320-029

- (25) Use a cotton wiper, G00034 moistened with alcohol, B00130 to remove particles left by the sanding.

SUBTASK 53-54-00-320-030

- (26) Apply coating to the exposed surface of the lightning diverter strips, do this task: Radome Exterior Coating Repair, TASK 53-54-00-300-808.



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SUBTASK 53-54-00-320-031

- (27) After the coating has cured, use a utility knife, or similar narrow-blade sharp knife, to very carefully cut the coating along the edge of the masking tape protecting the lightning diverter strip buttons/segments.

SUBTASK 53-54-00-320-032

- (28) Remove the masking tape.

————— END OF TASK —————

TASK 53-54-00-300-808

9. Radome Exterior Coating Repair

A. General

- (1) The exterior coating repair consists of the application of coating materials on the damaged area of the radome.

B. References

Reference	Title
53-54-00-000-801	Broadband Radome 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-6457	Meter - Insulation (Range: 1-1,000 VDC or equivalent, select meter per test requirements) Part #: 1864-9700 Supplier: 62015 Part #: 1865PLUS Supplier: 62015 Part #: 1865PLUSCE Supplier: 62015 Part #: 2471F Supplier: 21844 Opt Part #: 1865-00-CE Supplier: 62015

D. Consumable Materials

Reference	Description	Specification
B00130	Alcohol - Isopropyl	TT-I-735
C00766	Primer - Nonchromated Primer For Composites	BMS10-103 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)

E. Radome Exterior Coating Repair

SUBTASK 53-54-00-370-001

- (1) Use 240 grit (or finer) sandpaper to feather the coating around the damaged area for a distance of 1 to 2 inches.

SUBTASK 53-54-00-370-002

- (2) Use a cotton wiper, G00034 moistened with alcohol, B00130 to remove particles left by the sanding.

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SUBTASK 53-54-00-370-003

- (3) If bare laminate is exposed as a result of the sanding, do these steps:
- (a) If the radome is still installed on the airplane, remove it, do this task: Broadband Radome Removal, TASK 53-54-00-000-801.
 - (b) Mix and apply primer, C00766 to the damaged area.
 - 1) Apply the primer to a thickness of 0.0003" to 0.0008" per Boeing BAC5325.
 - (c) Mix and apply Caapcoat FP-100CM coating system. To apply the coating system, do these steps:

NOTE: If provided in the coating kit, discard the components of the Aeroglaze 9947 wash primer kit. DO NOT apply these components to the radome.

 - 1) Add the contents of the polyurethane accelerator container to the polyurethane basecoat/curing agent mixture container and mix well.
 - 2) Add the volume of polyurethane thinner to the polyurethane basecoat/curing agent/accelerator mixture necessary to obtain a viscosity of 22 to 28 seconds on a Number 2 Zahn viscosity measuring cup and mix thoroughly.
 - 3) Allow the thinned mixture to set at room temperature for 30 minutes or more after mixing.

NOTE: The thinned mixture has a 4 to 6 hour pot life.
 - 4) Spray or brush the thinned mixture on the primed area of the radome.
 - a) Apply as many coats as required to achieve a thickness of 0.0085" to 0.010".
 - b) Allow the coating to dry for 5 to 20 minutes between coats.
 - 5) Allow polyurethane basecoat to air dry at room temperature for 15 to 30 minutes before beginning to apply tiecoat.
 - (d) Mix and apply the tiecoat. To apply the tiecoat, do these steps:
 - 1) Add the contents of the curing agent container to the FE-AS fluoroelastomer tiecoat container and mix well.

NOTE: The tiecoat mixture has a 6 hour pot life.
 - 2) Apply the tiecoat mixture onto the polyurethane coating to a depth of 0.0005" to 0.002" (1-2 coats).
 - 3) Allow 45 to 90 minutes of air drying time prior to the application of the anti-static topcoat.
 - (e) Mix and apply the anti-static topcoat. To apply the anti-static topcoat, do these steps:
 - 1) Thoroughly mix the liquid container (Can A) contents.
 - 2) Filter the contents of the liquid container (Can A) into the fibers container (Can B).
 - 3) Add the contents of the curing agent container to the mixture now in the fibers container (Can B) and mix thoroughly.
 - 4) Apply the anti-static topcoat over the previously applied tiecoat to a thickness of 0.001" to 0.002" (1 or 2 coats).

SUBTASK 53-54-00-370-004

- (4) Let the coating cure for 24 hours at room temperature.

SUBTASK 53-54-00-370-005

- (5) Use an insulation meter, COM-6457 to test the antistatic topcoat for surface resistance per AMS 3138-6.

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- (a) Make sure that the resistance is between 0.5 and 15 megaohms.

SUBTASK 53-54-00-370-006

- (6) Test the coating in the repair area and at least one area which includes the repair topcoat bridged to the original radome topcoat.

———— **END OF TASK** ————

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