CHAPTER

53

FUSELAGE



CHAPTER 53 FUSELAGE

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|--------------|-------------|-----|------------|-------------|-----|-------------|-------------|-----|
| 53-EFFECTIV | E PAGES | | 53-01-01 | (cont) | | 53-05-01 | (cont) | |
| 1 thru 6 | SEP 05/2018 | | 415 | Jul 25/2018 | | 209 | Sep 05/2016 | |
| 53-CONTENT | S | | 416 | Jul 25/2018 | | 210 | Sep 05/2016 | |
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| 2 | Jan 05/2017 | | 418 | Jul 25/2018 | | 212 | Sep 05/2016 | |
| 3 | Jan 05/2017 | | 419 | Jul 25/2018 | | 213 | Sep 05/2016 | |
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| 6 | Jan 05/2017 | | 422 | Jul 25/2018 | | 216 | Sep 05/2016 | |
| 7 | Jan 05/2018 | | 423 | Jul 25/2018 | | 217 | Sep 05/2016 | |
| 8 | Jan 05/2018 | | 424 | Jul 25/2018 | | 218 | Sep 05/2016 | |
| 9 | Jan 05/2018 | | 425 | Jul 25/2018 | | 219 | Sep 05/2016 | |
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| 53-01-01 | | | 702 | Sep 05/2017 | | 230 | Sep 05/2016 | |
| 401 | May 05/2017 | | 53-02-04 | | | 231 | Sep 05/2017 | |
| 402 | May 05/2017 | | 401 | May 05/2018 | | 232 | Sep 05/2017 | |
| 403 | May 05/2017 | | 402 | Sep 05/2017 | | 233 | Sep 05/2016 | |
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| 405 | May 05/2017 | | 404 | Sep 05/2017 | | 235 | Sep 05/2017 | |
| 406 | May 05/2017 | | 53-05-01 | | | 236 | Sep 05/2016 | |
| 407 | Jan 05/2018 | | 201 | Sep 05/2016 | | 237 | Sep 05/2017 | |
| 408 | Jan 05/2018 | | 202 | Sep 05/2017 | | 238 | Sep 05/2017 | |
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| 412 | Jul 25/2018 | | 206 | Sep 05/2016 | | 201 | May 05/2016 | |
| 413 | Jul 25/2018 | | 207 | Sep 05/2016 | | 202 | Sep 05/2017 | |
| 414 | Jul 25/2018 | | 208 | Sep 05/2016 | | 203 | Sep 05/2017 | |

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| 53-05-03 | (cont) | | 53-05-03 | (cont) | | 53-05-03 | (cont) | |
| 204 | Sep 05/2017 | | 240 | Jan 05/2017 | | 276 | Jan 05/2017 | |
| 205 | Sep 05/2017 | | 241 | Jan 05/2017 | | 277 | Jan 05/2017 | |
| 206 | Sep 05/2017 | | 242 | May 05/2017 | | 278 | Jan 05/2017 | |
| 207 | Jan 05/2017 | | 243 | May 05/2017 | | 279 | Jan 05/2017 | |
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| 209 | Sep 05/2016 | | 245 | Sep 05/2017 | | 281 | Jan 05/2017 | |
| 210 | Sep 05/2017 | | 246 | Jan 05/2017 | | 282 | Jan 05/2017 | |
| 211 | Sep 05/2017 | | 247 | Sep 05/2017 | | 283 | Jan 05/2017 | |
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| 213 | Jan 05/2017 | | 249 | Sep 05/2017 | | 285 | Jan 05/2017 | |
| 214 | Jan 05/2017 | | 250 | Jan 05/2017 | | 286 | Sep 05/2017 | |
| 215 | Jan 05/2017 | | 251 | Sep 05/2017 | | 287 | Jan 05/2017 | |
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| 217 | Sep 05/2017 | | 253 | Jan 05/2017 | | 289 | Jan 05/2017 | |
| 218 | Jan 05/2017 | | 254 | May 05/2017 | | 290 | Sep 05/2017 | |
| 219 | Sep 05/2017 | | 255 | Jan 05/2017 | | 291 | Jan 05/2017 | |
| 220 | Jan 05/2017 | | 256 | Sep 05/2017 | | 292 | Jan 05/2017 | |
| 221 | Sep 05/2017 | | 257 | Sep 05/2017 | | 293 | Sep 05/2017 | |
| 222 | Jan 05/2017 | | 258 | Sep 05/2017 | | 294 | Sep 05/2017 | |
| 223 | Sep 05/2017 | | 259 | Jan 05/2017 | | 295 | Jan 05/2017 | |
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| 225 | Sep 05/2017 | | 261 | Sep 05/2017 | | 297 | Jan 05/2017 | |
| 226 | Jan 05/2017 | | 262 | Jan 05/2017 | | 298 | Jan 05/2017 | |
| 227 | Sep 05/2017 | | 263 | Sep 05/2017 | | 298.1 | Jan 05/2017 | |
| 228 | Sep 05/2017 | | 264 | Jan 05/2017 | | 298.2 | Sep 05/2017 | |
| 229 | Sep 05/2017 | | 265 | Sep 05/2017 | | 298.3 | Jan 05/2017 | |
| 230 | Jan 05/2017 | | 266 | Sep 05/2017 | | 298.4 | Sep 05/2017 | |
| 231 | Jan 05/2017 | | 267 | Jan 05/2017 | | 298.5 | Jan 05/2017 | |
| 232 | Sep 05/2017 | | 268 | Jan 05/2017 | | 298.6 | Sep 05/2017 | |
| 233 | Sep 05/2017 | | 269 | Jan 05/2017 | | 298.7 | Sep 05/2017 | |
| 234 | Jan 05/2017 | | 270 | Jan 05/2017 | | 298.8 | Jan 05/2017 | |
| 235 | Sep 05/2017 | | 271 | Jan 05/2017 | | 298.9 | Sep 05/2017 | |
| 236 | Sep 05/2017 | | 272 | Sep 05/2017 | | 298.10 | · | |
| 237 | Jan 05/2017 | | 273 | Jan 05/2017 | | 298.11 | | |
| 238 | Sep 05/2017 | | 274 | Jan 05/2017 | | 298.12 | · | |
| 239 | Jan 05/2017 | | 275 | Jan 05/2017 | | 298.13 | Sep 05/2017 | |

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| 53-05-03 (co | ont) | | 53-05-03 (co | nt) | | 53-05-03 (co | nt) | |
| 298.14 | Jan 05/2017 | | 298.50 | Sep 05/2017 | | 298.86 | Jan 05/2018 | |
| 298.15 | Sep 05/2017 | | 298.51 | Jan 05/2017 | | 298.87 | Jan 05/2018 | |
| 298.16 | Sep 05/2017 | | 298.52 | Sep 05/2017 | | 298.88 | Jan 05/2018 | |
| 298.17 | Jan 05/2017 | | 298.53 | Jan 05/2017 | | 298.89 | Jan 05/2018 | |
| 298.18 | Sep 05/2017 | | 298.54 | Sep 05/2017 | | 298.90 | Jan 05/2018 | |
| 298.19 | Sep 05/2017 | | 298.55 | Jan 05/2017 | | 298.91 | Jan 05/2018 | |
| 298.20 | Jan 05/2017 | | 298.56 | Sep 05/2017 | | 298.92 | Jan 05/2018 | |
| 298.21 | Sep 05/2017 | | 298.57 | Jan 05/2017 | | 298.93 | Jan 05/2018 | |
| 298.22 | Sep 05/2017 | | 298.58 | Sep 05/2017 | | 298.94 | Jan 05/2018 | |
| 298.23 | Jan 05/2017 | | 298.59 | Jan 05/2017 | | 298.95 | Jan 05/2018 | |
| 298.24 | Sep 05/2017 | | 298.60 | Sep 05/2017 | | 298.96 | Jan 05/2018 | |
| 298.25 | Sep 05/2017 | | 298.61 | Jan 05/2017 | | 298.97 | Jan 05/2018 | |
| 298.26 | Jan 05/2017 | | 298.62 | Sep 05/2017 | | 298.98 | Jan 05/2018 | |
| 298.27 | Sep 05/2017 | | 298.63 | Jan 05/2017 | | 298.99 | Jan 05/2018 | |
| 298.28 | Sep 05/2017 | | 298.64 | Sep 05/2017 | | 298.100 | Jan 05/2018 | |
| 298.29 | Jan 05/2017 | | 298.65 | Jan 05/2017 | | 298.101 | Jan 05/2018 | |
| 298.30 | Sep 05/2017 | | 298.66 | Sep 05/2017 | | 298.102 | Jan 05/2018 | |
| 298.31 | Sep 05/2017 | | 298.67 | Jan 05/2017 | | 298.103 | Jan 05/2018 | |
| 298.32 | Jan 05/2017 | | 298.68 | Jan 05/2018 | | 298.104 | Jan 05/2018 | |
| 298.33 | Sep 05/2017 | | 298.69 | Jan 05/2018 | | 298.105 | Jan 05/2018 | |
| 298.34 | Jan 05/2017 | | 298.70 | Jan 05/2018 | | 298.106 | Jan 05/2018 | |
| 298.35 | Sep 05/2017 | | 298.71 | Jan 05/2018 | | 298.107 | Jan 05/2018 | |
| 298.36 | Sep 05/2017 | | R 298.72 | Sep 05/2018 | | 298.108 | Jan 05/2018 | |
| 298.37 | Sep 05/2017 | | R 298.73 | Sep 05/2018 | | 298.109 | Jan 05/2018 | |
| 298.38 | Jan 05/2017 | | 298.74 | Jan 05/2018 | | 298.110 | Jan 05/2018 | |
| 298.39 | Sep 05/2017 | | 298.75 | Jan 05/2018 | | 298.111 | Jan 05/2018 | |
| 298.40 | Jan 05/2017 | | 298.76 | Jan 05/2018 | | 298.112 | Jan 05/2018 | |
| 298.41 | Sep 05/2017 | | 298.77 | Jan 05/2018 | | 298.113 | Jan 05/2018 | |
| 298.42 | Jan 05/2017 | | 298.78 | Jan 05/2018 | | 298.114 | Jan 05/2018 | |
| 298.43 | Sep 05/2017 | | 298.79 | Jan 05/2018 | | 298.115 | Jan 05/2018 | |
| 298.44 | Jan 05/2017 | | 298.80 | Jan 05/2018 | | 298.116 | Jan 05/2018 | |
| 298.45 | Sep 05/2017 | | 298.81 | Jan 05/2018 | | 298.117 | Jan 05/2018 | |
| 298.46 | Jan 05/2017 | | 298.82 | Jan 05/2018 | | 298.118 | Jan 05/2018 | |
| 298.47 | Sep 05/2017 | | 298.83 | Jan 05/2018 | | 298.119 | Jan 05/2018 | |
| 298.48 | Jan 05/2017 | | 298.84 | Jan 05/2018 | | 298.120 | Jan 05/2018 | |
| 298.49 | Sep 05/2017 | | 298.85 | Jan 05/2018 | | 298.121 | Jan 05/2018 | |

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| 298.123 | Jan 05/2018 | | 298.159 | Jan 05/2018 | | 298.195 | Jan 05/2018 | |
| 298.124 | Jan 05/2018 | | 298.160 | Jan 05/2018 | | 298.196 | Jan 05/2018 | |
| 298.125 | Jan 05/2018 | | 298.161 | Jan 05/2018 | | 298.197 | Jan 05/2018 | |
| 298.126 | Jan 05/2018 | | 298.162 | Jan 05/2018 | | 298.198 | Jan 05/2018 | |
| 298.127 | Jan 05/2018 | | 298.163 | Jan 05/2018 | | 298.199 | Jan 05/2018 | |
| 298.128 | Jan 05/2018 | | 298.164 | Jan 05/2018 | | 298.200 | Jul 25/2018 | |
| 298.129 | Jan 05/2018 | | 298.165 | Jan 05/2018 | | 298.201 | Jan 05/2018 | |
| 298.130 | Jan 05/2018 | | 298.166 | Jan 05/2018 | | 298.202 | Jan 05/2018 | |
| 298.131 | Jan 05/2018 | | 298.167 | Jan 05/2018 | | 298.203 | Jan 05/2018 | |
| 298.132 | Jan 05/2018 | | 298.168 | Jan 05/2018 | | 298.204 | Jan 05/2018 | |
| 298.133 | Jan 05/2018 | | 298.169 | Jan 05/2018 | | 298.205 | Jan 05/2018 | |
| 298.134 | Jan 05/2018 | | 298.170 | Jan 05/2018 | | 298.206 | Jan 05/2018 | |
| 298.135 | Jan 05/2018 | | 298.171 | Jan 05/2018 | | 298.207 | Jan 05/2018 | |
| 298.136 | Jan 05/2018 | | 298.172 | Jan 05/2018 | | 298.208 | Jan 05/2018 | |
| 298.137 | Jan 05/2018 | | 298.173 | Jan 05/2018 | | 298.209 | Jan 05/2018 | |
| 298.138 | Jan 05/2018 | | 298.174 | Jan 05/2018 | | 298.210 | Jan 05/2018 | |
| 298.139 | Jan 05/2018 | | 298.175 | Jan 05/2018 | | 298.211 | Jan 05/2018 | |
| 298.140 | Jan 05/2018 | | 298.176 | Jan 05/2018 | | 298.212 | Jan 05/2018 | |
| 298.141 | Jan 05/2018 | | 298.177 | Jan 05/2018 | | 298.213 | Jan 05/2018 | |
| 298.142 | Jan 05/2018 | | 298.178 | Jan 05/2018 | | 298.214 | Jan 05/2018 | |
| 298.143 | Jan 05/2018 | | 298.179 | Jan 05/2018 | | 298.215 | Jan 05/2018 | |
| 298.144 | Jan 05/2018 | | 298.180 | Jan 05/2018 | | 298.216 | Jan 05/2018 | |
| 298.145 | Jan 05/2018 | | 298.181 | Jan 05/2018 | | 298.217 | Jan 05/2018 | |
| 298.146 | Jan 05/2018 | | 298.182 | Jan 05/2018 | | 298.218 | Jan 05/2018 | |
| 298.147 | Jan 05/2018 | | 298.183 | Jan 05/2018 | | 298.219 | Jan 05/2018 | |
| 298.148 | Jan 05/2018 | | 298.184 | Jan 05/2018 | | 298.220 | Jan 05/2018 | |
| 298.149 | Jan 05/2018 | | 298.185 | Jan 05/2018 | | 298.221 | Jan 05/2018 | |
| 298.150 | Jan 05/2018 | | 298.186 | Jan 05/2018 | | 298.222 | Jan 05/2018 | |
| 298.151 | Jan 05/2018 | | 298.187 | Jan 05/2018 | | 298.223 | Jan 05/2018 | |
| 298.152 | Jan 05/2018 | | 298.188 | Jan 05/2018 | | 298.224 | Jan 05/2018 | |
| 298.153 | Jan 05/2018 | | 298.189 | Jan 05/2018 | | 298.225 | Jan 05/2018 | |
| 298.154 | Jan 05/2018 | | 298.190 | Jan 05/2018 | | 298.226 | Jan 05/2018 | |
| 298.155 | Jan 05/2018 | | 298.191 | Jan 05/2018 | | 298.227 | Jan 05/2018 | |
| 298.156 | Jan 05/2018 | | 298.192 | Jan 05/2018 | | 298.228 | Jan 05/2018 | |
| 298.157 | Jan 05/2018 | | 298.193 | Jan 05/2018 | | 298.229 | Jan 05/2018 | |

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| 53-05-03 (cc | nt) | | 53-12-01 | (cont) | | 53-12-01 | (cont) | |
| 298.230 | Jan 05/2018 | | 405 | Jan 05/2018 | | 704 | May 05/2017 | |
| 298.231 | Jan 05/2018 | | 406 | Sep 05/2017 | | 705 | Sep 05/2017 | |
| 298.232 | Jan 05/2018 | | 407 | Sep 05/2017 | | 706 | Sep 05/2017 | |
| 298.233 | Jan 05/2018 | | 408 | May 05/2016 | | 53-12-01 | | |
| 298.234 | Jan 05/2018 | | 53-12-01 | | | 801 | Jan 05/2015 | |
| 53-11-01 | | | 501 | Jul 25/2018 | | 802 | BLANK | |
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| 53-11-02 | | | 508 | Sep 05/2017 | | 401 | Sep 05/2017 | |
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| 402 | Sep 05/2017 | | 510 | Sep 05/2017 | | 403 | Jan 05/2017 | |
| 403 | Jan 05/2015 | | 511 | Sep 05/2017 | | 404 | Sep 05/2017 | |
| 404 | Sep 05/2017 | | 512 | Sep 05/2017 | | 405 | Sep 05/2017 | |
| 405 | Sep 05/2017 | | 513 | Sep 05/2017 | | 406 | Sep 05/2017 | |
| 406 | BLANK | | 514 | Sep 05/2017 | | 53-12-03 | | |
| 53-11-03 | | | 515 | Sep 05/2017 | | 601 | May 05/2017 | |
| 401 | Sep 05/2017 | | 516 | Sep 05/2017 | | 602 | May 05/2017 | |
| 402 | Sep 05/2017 | | 517 | Sep 05/2017 | | 603 | Sep 05/2017 | |
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| 405 | Sep 05/2017 | | 520 | Sep 05/2017 | | 801 | May 05/2018 | |
| 406 | Sep 05/2017 | | 521 | Sep 05/2017 | | 802 | Jan 05/2015 | |
| 53-12-00 | | | 522 | Sep 05/2017 | | 53-12-04 | | |
| 201 | Sep 05/2017 | | 53-12-01 | | | 401 | Jan 05/2015 | |
| 202 | Sep 05/2017 | | 601 | May 05/2015 | | 402 | Jan 05/2015 | |
| 203 | Sep 05/2017 | | 602 | Jan 05/2015 | | 403 | Sep 05/2017 | |
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| 402 | Jan 05/2015 | | 701 | May 05/2017 | | 402 | Jan 05/2015 | |
| 403 | Jul 25/2018 | | 702 | Sep 05/2017 | | 403 | Sep 05/2017 | |
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| 53-12-06 | | | 53-17-00 | (cont) | | 53-61-51 Cor | nfig 2 | |
| 401 | May 05/2018 | | 223 | Sep 05/2017 | | 401 | Sep 05/2017 | |
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| 53-13-01 | | | 53-36-01 | | | 403 | Jan 05/2015 | |
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| 402 | Sep 05/2017 | | 402 | Sep 05/2015 | | 405 | Sep 05/2017 | |
| 403 | Sep 05/2017 | | 403 | Jan 05/2015 | | 406 | Jan 05/2015 | |
| 404 | Sep 05/2017 | | 404 | Sep 05/2017 | | 53-61-51 Cor | nfig 3 | |
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| 407 | Jan 05/2017 | | 53-36-02 | | | 403 | May 05/2017 | |
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| 410 | Sep 05/2017 | | 203 | Sep 05/2017 | | 401 | Jan 05/2015 | |
| 53-17-00 | | | 204 | Sep 05/2017 | | 402 | Jan 05/2018 | |
| 201 | Sep 05/2017 | | 53-46-01 | · | | 403 | Jan 05/2018 | |
| 202 | Sep 05/2017 | | 401 | Jan 05/2015 | | 404 | Jan 05/2018 | |
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| 213 | Sep 05/2017 | | 412 | Sep 05/2017 | | 404 | Sep 05/2017 | |
| 214 | Sep 05/2017 | | 413 | Sep 05/2017 | | | | |
| 215 | Sep 05/2017 | | 414 | Sep 05/2017 Sep 05/2017 | | | | |
| 216 | Sep 05/2017 | | 414 | Sep 05/2017 Sep 05/2017 | | | | |
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| 218 | Sep 05/2017 | | 416 | Sep 05/2017 | | | | |
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| 220 | Sep 05/2017 | | 418 | Sep 05/2017 | | | | |
| 221 | Sep 05/2017 | | 419 | Sep 05/2017 | | | | |
| 222 | Sep 05/2017 | | 420 | Sep 05/2017 | | | | |

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| FUSELAGE - MAINTENANCE PRACTICES | 53-00-00 | 201 | ARO ALL |
| Airworthiness Limitation Precautions TASK 53-00-00-912-801 | | 201 | ARO ALL |
| FLOOR PANELS - REMOVAL/INSTALLATION | 53-01-01 | 401 | ARO ALL |
| Floor Panel Removal TASK 53-01-01-000-801 | | 401 | ARO ALL |
| Floor Panel Installation TASK 53-01-01-400-801 | | 404 | ARO ALL |
| Aft and Forward Cargo Floor Panels Removal TASK 53-01-01-000-802 | | 417 | ARO ALL |
| Aft and Forward Cargo Floor Panels Installation TASK 53-01-01-400-802 | | 418 | ARO ALL |
| SEAT TRACKS - MAINTENANCE PRACTICES | 53-01-03 | 201 | ARO ALL |
| Seat Track Filler Application TASK 53-01-03-600-801 | | 201 | ARO ALL |
| SEAT TRACKS - CLEANING/PAINTING | 53-01-03 | 701 | ARO ALL |
| Seat Track Cleaning TASK 53-01-03-100-801 | | 701 | ARO ALL |
| SOUND DAMPENING ANGLES - REMOVAL/INSTALLATION | 53-02-04 | 401 | ARO ALL |
| Sound Dampening Angle Removal TASK 53-02-04-000-801 | | 401 | ARO ALL |
| Sound Dampening Angle Installation TASK 53-02-04-400-801 | | 402 | ARO ALL |
| FUSELAGE - CORROSION INSPECTIONS - MAINTENANCE PRACTICES | 53-05-01 | 201 | ARO ALL |
| INTERNAL - GENERAL VISUAL: MAIN EQUIPMENT CENTER ACCESS DOOR TASK 53-05-01-210-802 | | 201 | ARO ALL |
| INTERNAL - GENERAL VISUAL: LOWER FUSELAGE - SUBZONE 110 AND 120 TASK 53-05-01-210-813 | | 203 | ARO ALL |
| INTERNAL - GENERAL VISUAL: LEFT MAIN LANDING GEAR WHEEL WELL TASK 53-05-01-210-818 | | 206 | ARO ALL |



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| SUBJECT | SUBJECT CONF PAC | <u>EFFECT</u> |
| INTERNAL - GENERAL VISUAL: RIGHT MAIN LANDING GEAR WHEEL WELL TASK 53-05-01-210-819 | 20 | 9 ARO ALL |
| INTERNAL - GENERAL VISUAL: AREA BELOW AFT CARGO COMPARTMENT TASK 53-05-01-210-822 | 21 | 2 ARO ALL |
| INTERNAL - GENERAL VISUAL: LOWER FUSELAGE - SUBZONE 150 AND 160 TASK 53-05-01-210-823 | 21 | 5 ARO ALL |
| EXTERNAL - GENERAL VISUAL: UNDERWING WING-TO-BODY FAIRING - LEFT TASK 53-05-01-210-825 | 21 | 9 ARO ALL |
| EXTERNAL - GENERAL VISUAL: UNDERWING WING-TO-BODY FAIRING - RIGHT TASK 53-05-01-210-826 | 22 | 2 ARO ALL |
| INTERNAL - GENERAL VISUAL: SUBZONE BS 246 TO 655 - SECTION 41 TASK 53-05-01-210-828 | 22 | 5 ARO ALL |
| INTERNAL - GENERAL VISUAL: SUBZONE BS 655 TO 1035 - SECTION 43 TASK 53-05-01-210-829 | 22 | 7 ARO ALL |
| INTERNAL - GENERAL VISUAL: SUBZONE BS 1035 TO 1434 - SECTION 44 TASK 53-05-01-210-830 | 23 | 0 ARO ALL |
| INTERNAL - GENERAL VISUAL: SUBZONE BS 1434 TO 1832 - SECTION 46 TASK 53-05-01-210-831 | 23 | 3 ARO ALL |
| INTERNAL - GENERAL VISUAL: SUBZONE BS 1832 TO 2195.75 - SECTION 47 TASK 53-05-01-210-832 | 23 | 6 ARO ALL |
| FUSELAGE - STRUCTURAL INSPECTIONS - MAINTENANCE PRACTICES | 53-05-03 20 | 1 ARO ALL |
| INTERNAL - GENERAL VISUAL: AREA FORWARD OF NOSE LANDING GEAR WHEEL WELL TASK 53-05-03-210-801 | 20 | 1 ARO ALL |
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| INTERNAL - GENERAL VISUAL: AREA OUTBOARD AND ABOVE NOSE LANDING GEAR WHEEL WELL TASK 53-05-03-210-802 | 20 | 7 ARO ALL |
| INTERNAL - DETAILED: LEFT AREA OUTBOARD AND ABOVE NOSE LANDING GEAR WHEEL WELL TASK 53-05-03-211-801 | 21 | 6 ARO ALL |
| INTERNAL-DETAILED: RIGHT AREA OUTBOARD AND ABOVE NOSE LANDING GEAR WHEEL WELL TASK 53-05-03-211-844 | 21 | 8 ARO ALL |
| INTERNAL - DETAILED: MAIN EQUIPMENT CENTER TASK 53-05-03-211-802 | 22 | 20 ARO ALL |
| INTERNAL - DETAILED: MAIN EQUIPMENT CENTER TASK 53-05-03-211-803 | 22 | 22 ARO ALL |
| INTERNAL - GENERAL VISUAL: MAIN EQUIPMENT CENTER TASK 53-05-03-210-804 | 22 | 4 ARO ALL |
| INTERNAL - GENERAL VISUAL: MAIN EQUIPMENT CENTER TASK 53-05-03-210-875 | 22 | 6 ARO ALL |
| EXTERNAL - GENERAL VISUAL: FORWARD CARGO COMPARTMENT TASK 53-05-03-210-905 | 23 | 4 ARO ALL |
| INTERNAL - DETAILED: FORWARD CARGO COMPARTMENT TASK 53-05-03-211-804 | 23 | ARO ALL |
| INTERNAL - DETAILED: FORWARD CARGO COMPARTMENT — 300ER TASK 53-05-03-211-805-005 | 23 | 9 ARO ALL |
| EXTERNAL - GENERAL VISUAL: AREA BELOW FORWARD CARGO COMPARTMENT TASK 53-05-03-210-806 | 24 | 6 ARO ALL |
| INTERNAL - GENERAL VISUAL: AREA BELOW FORWARD CARGO COMPARTMENT TASK 53-05-03-211-806 | 24 | 8 ARO ALL |



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| INTERNAL - DETAILED: AREA BELOW FORWARD CARGO COMPARTMENT —300ER TASK 53-05-03-211-807-006 | | 250 | ARO ALL |
| INTERNAL - GENERAL VISUAL: AREA AFT OF FORWARD CARGO COMPARTMENT TASK 53-05-03-210-807 | | 255 | ARO ALL |
| EXTERNAL - DETAILED: MAIN LANDING GEAR WHEEL WELL, LEFT TASK 53-05-03-211-808 | | 260 | ARO ALL |
| EXTERNAL - DETAILED: MAIN LANDING GEAR WHEEL WELL, RIGHT TASK 53-05-03-211-809 | | 262 | ARO ALL |
| INTERNAL - GENERAL VISUAL: AREA ABOVE MAIN LANDING GEAR WHEEL WELL TASK 53-05-03-210-808 | | 264 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT TASK 53-05-03-210-809 | | 267 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT TASK 53-05-03-210-906 | | 269 | ARO ALL |
| INTERNAL - DETAILED: AFT CARGO COMPARTMENT TASK 53-05-03-211-810 | | 271 | ARO ALL |
| INTERNAL - DETAILED: AFT CARGO COMPARTMENT TASK 53-05-03-211-811 | | 273 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: AREA BELOW AFT CARGO COMPARTMENT TASK 53-05-03-210-812 | | 277 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: AREA BELOW AFT CARGO COMPARTMENT TASK 53-05-03-210-813 | | 279 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: AREA BELOW AFT CARGO COMPARTMENT TASK 53-05-03-210-908 | | 281 | ARO ALL |



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| INTERNAL - DETAILED: AREA BELOW AFT CARGO COMPARTMENT TASK 53-05-03-211-861 | | 283 | ARO ALL |
| INTERNAL - GENERAL VISUAL: AREA BELOW AFT CARGO COMPARTMENT TASK 53-05-03-211-815 | | 285 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: BULK CARGO COMPARTMENT TASK 53-05-03-210-816 | | 287 | ARO ALL |
| INTERNAL - DETAILED: BULK CARGO COMPARTMENT TASK 53-05-03-211-816 | | 289 | ARO ALL |
| INTERNAL - DETAILED: BULK CARGO COMPARTMENT -300ER TASK 53-05-03-211-817-005 | | 291 | ARO ALL |
| INTERNAL - DETAILED: AREA BELOW BULK CARGO COMPARTMENT TASK 53-05-03-211-818 | | 295 | ARO ALL |
| INTERNAL - DETAILED: AREA AFT OF BULK CARGO COMPARTMENT TASK 53-05-03-211-819 | | 298.1 | ARO ALL |
| INTERNAL - DETAILED: AREA AFT OF BULK CARGO COMPARTMENT TASK 53-05-03-211-820 | | 298.3 | ARO ALL |
| INTERNAL - GENERAL VISUAL: OVERWING WING-TO-BODY FAIRINGS, LEFT TASK 53-05-03-210-817 | | 298.5 | ARO ALL |
| INTERNAL - GENERAL VISUAL: OVERWING WING-TO-BODY FAIRINGS, RIGHT TASK 53-05-03-210-818 | | 298.8 | ARO ALL |
| INTERNAL - DETAILED: FORWARD WING-TO-BODY FAIRINGS - LEFT TASK 53-05-03-211-821 | | 298.11 | ARO ALL |
| INTERNAL - DETAILED: FORWARD WING-TO-BODY FAIRINGS - RIGHT TASK 53-05-03-211-822 | | 298.14 | ARO ALL |



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| INTERNAL - GENERAL VISUAL: OVERWING WING-TO-BODY FAIRINGS - LEFT TASK 53-05-03-210-819 | 298.17 | ARO ALL |
| INTERNAL - GENERAL VISUAL: OVERWING WING-TO-BODY FAIRINGS - RIGHT TASK 53-05-03-210-820 | 298.20 | ARO ALL |
| INTERNAL - DETAILED: AFT WING-TO-BODY FAIRINGS - LEFT TASK 53-05-03-211-862 | 298.23 | ARO ALL |
| INTERNAL - DETAILED: AFT WING-TO-BODY FAIRINGS - RIGHT TASK 53-05-03-211-863 | 298.26 | ARO ALL |
| EXTERNAL - SPECIAL DETAILED: FLIGHT COMPARTMENT TASK 53-05-03-211-825 | 298.29 | ARO ALL |
| INTERNAL - DETAILED: FLIGHT COMPARTMENT TASK 53-05-03-211-826 | 298.32 | ARO ALL |
| INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT TASK 53-05-03-210-821 | 298.34 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - LEFT TASK 53-05-03-210-822 | 298.38 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - RIGHT TASK 53-05-03-210-823 | 298.40 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - LEFT TASK 53-05-03-210-824 | 298.42 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT TASK 53-05-03-210-825 | 298.44 | ARO ALL |
| INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT TASK 53-05-03-210-826 | 298.46 | ARO ALL |



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| INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT TASK 53-05-03-210-827 | 298.48 | ARO ALL |
| INTERNAL - DETAILED: PASSENGER COMPARTMENT TASK 53-05-03-211-827 | 298.51 | ARO ALL |
| INTERNAL - DETAILED: PASSENGER COMPARTMENT TASK 53-05-03-211-828 | 298.53 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING TASK 53-05-03-210-828 | 298.55 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - LEFT TASK 53-05-03-210-829 | 298.57 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - RIGHT TASK 53-05-03-210-830 | 298.59 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - LEFT TASK 53-05-03-210-831 | 298.61 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - RIGHT TASK 53-05-03-210-832 | 298.63 | ARO ALL |
| INTERNAL - DETAILED: PASSENGER COMPARTMENT TASK 53-05-03-211-864 | 298.65 | ARO ALL |
| INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - LEFT - 300ER TASK 53-05-03-210-833-005 | 298.67 | ARO ALL |
| INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - RIGHT - 300ER TASK 53-05-03-210-834-005 | 298.76 | ARO ALL |
| INTERNAL - DETAILED: PASSENGER COMPARTMENT - LEFT TASK 53-05-03-211-829 | 298.86 | ARO ALL |



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| INTERNAL - DETAILED: PASSENGER COMPARTMENT - RIGHT TASK 53-05-03-211-830 | 298.88 | ARO ALL |
| INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - LEFT TASK 53-05-03-210-874 | 298.90 | ARO ALL |
| INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - RIGHT TASK 53-05-03-210-873 | 298.93 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING TASK 53-05-03-210-835 | 298.96 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING TASK 53-05-03-210-836 | 298.98 | ARO ALL |
| INTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING - 300ER TASK 53-05-03-210-837-006 | 298.100 | ARO ALL |
| INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT -300ER TASK 53-05-03-210-838-006 | 298.103 | ARO ALL |
| INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - 300ER TASK 53-05-03-210-839-006 | 298.110 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING TASK 53-05-03-210-840 | 298.121 | ARO ALL |
| INTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING TASK 53-05-03-210-841 | 298.123 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING TASK 53-05-03-210-842 | 298.126 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT TASK 53-05-03-210-843 | 298.128 | ARO ALL |



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| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT TASK 53-05-03-210-844 | 298.130 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT TASK 53-05-03-210-845 | 298.132 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT TASK 53-05-03-210-846 | 298.134 | ARO ALL |
| INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT TASK 53-05-03-210-848 | 298.137 | ARO ALL |
| INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT TASK 53-05-03-210-849 | 298.139 | ARO ALL |
| INTERNAL - DETAILED: PASSENGER COMPARTMENT TASK 53-05-03-211-843 | 298.142 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING TASK 53-05-03-210-851 | 298.146 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING TASK 53-05-03-210-852 | 298.148 | ARO ALL |
| INTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING -300ER TASK 53-05-03-210-853-006 | 298.151 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING TASK 53-05-03-210-854 | 298.155 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT TASK 53-05-03-210-855 | 298.158 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT TASK 53-05-03-210-856 | 298.160 | ARO ALL |



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| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT TASK 53-05-03-210-857 | 298.162 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT TASK 53-05-03-210-858 | 298.164 | ARO ALL |
| INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT TASK 53-05-03-210-859 | 298.166 | ARO ALL |
| INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT TASK 53-05-03-210-860 | 298.168 | ARO ALL |
| INTERNAL - DETAILED: PASSENGER COMPARTMENT TASK 53-05-03-211-835 | 298.170 | ARO ALL |
| INTERNAL - DETAILED: PASSENGER COMPARTMENT TASK 53-05-03-211-836 | 298.172 | ARO ALL |
| INTERNAL - DETAILED: AREA ABOVE WING CENTER SECTION - 300ER TASK 53-05-03-211-837-002 | 298.174 | ARO ALL |
| INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT LEFT AND RIGHT TASK 53-05-03-210-862 | 298.178 | ARO ALL |
| INTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING TASK 53-05-03-210-863 | 298.181 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT LEFT TASK 53-05-03-210-864 | 298.184 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - RIGHT TASK 53-05-03-210-865 | 298.186 | ARO ALL |
| INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT LEFT AND RIGHT - 300ER TASK 53-05-03-210-866-002 | 298.188 | ARO ALL |



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| INTERNAL - DETAILED: PASSENGER COMPARTMENT LEFT AND RIGHT TASK 53-05-03-211-838 | 298.195 | ARO ALL |
| INTERNAL - DETAILED: PASSENGER COMPARTMENT LEFT AND RIGHT - 300ER TASK 53-05-03-211-838-002 | 298.198 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - LEFT TASK 53-05-03-210-867 | 298.205 | ARO ALL |
| EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - RIGHT TASK 53-05-03-210-868 | 298.207 | ARO ALL |
| INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT LEFT AND RIGHT TASK 53-05-03-210-869 | 298.209 | ARO ALL |
| INTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING -300ER TASK 53-05-03-210-870-002 | 298.211 | ARO ALL |
| INTERNAL - DETAILED: FORWARD WING-TO-BODY FAIRINGS - LEFT TASK 53-05-03-211-839 | 298.215 | ARO ALL |
| INTERNAL - DETAILED: FORWARD WING-TO-BODY FAIRINGS - RIGHT TASK 53-05-03-211-840 | 298.218 | ARO ALL |
| INTERNAL - DETAILED: AFT WING-TO-BODY FAIRINGS - LEFT TASK 53-05-03-211-841 | 298.221 | ARO ALL |
| INTERNAL - DETAILED: AFT WING-TO-BODY FAIRINGS - RIGHT TASK 53-05-03-211-842 | 298.224 | ARO ALL |
| INTERNAL - DETAILED: PASSENGER COMPARTMENT CEILING TASK 53-05-03-211-846 | 298.227 | ARO ALL |
| INTERNAL - SPECIAL DETAILED: PASSENGER COMPARTMENT CEILING TASK 53-05-03-211-847 | 298.229 | ARO ALL |



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| INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT CEILING TASK 53-05-03-210-877 | | 298.231 | ARO ALL |
| INTERNAL — DETAILED: PASSENGER COMPARTMENT CEILING TASK 53-05-03-211-865 | | 298.233 | ARO ALL |
| PASSENGER ENTRY DOOR SCUFF PLATE - REMOVAL/INSTALLATION | 53-11-01 | 401 | ARO ALL |
| Remove the Scuff Plates TASK 53-11-01-000-801 | | 401 | ARO ALL |
| Install the Scuff Plates TASK 53-11-01-420-801 | | 404 | ARO ALL |
| SMALL AFT CARGO DOOR SCUFF PLATES - REMOVAL/INSTALLATION | 53-11-02 | 401 | ARO ALL |
| Remove the Scuff Plate TASK 53-11-02-020-801 | | 401 | ARO ALL |
| Install The Scuff Plates TASK 53-11-02-420-801 | | 404 | ARO ALL |
| BULK CARGO DOOR SCUFF PLATE | 53-11-03 | 401 | ARO ALL |
| Remove the Scuff Plate TASK 53-11-03-000-801 | | 401 | ARO ALL |
| Install the Scuff Plate TASK 53-11-03-400-801 | | 404 | ARO ALL |
| NOSE RADOME - MAINTENANCE PRACTICES | 53-12-00 | 201 | ARO ALL |
| Open the Nose Radome TASK 53-12-00-010-801 | | 201 | ARO ALL |
| Close the Nose Radome TASK 53-12-00-410-802 | | 203 | ARO ALL |
| NOSE RADOME - REMOVAL/INSTALLATION | 53-12-01 | 401 | ARO ALL |
| Nose Radome Removal TASK 53-12-01-000-801 | | 401 | ARO ALL |
| Nose Radome Installation TASK 53-12-01-400-801 | | 403 | ARO ALL |



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SECTION SUBJECT EFFECT SUBJECT CONF PAGE **NOSE RADOME - ADJUSTMENT/TEST** 501 53-12-01 **ARO ALL** Nose Radome Adjustment 501 **ARO ALL** TASK 53-12-01-820-801 **NOSE RADOME - INSPECTION/CHECK** 53-12-01 601 **ARO ALL** 601 Nose Radome Inspection ARO ALL TASK 53-12-01-200-801

| TASK 53-12-01-200-801 | | | |
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| NOSE RADOME - CLEANING/PAINTING | 53-12-01 | 701 | ARO ALL |
| Nose Radome - Painting TASK 53-12-01-100-801 | | 701 | ARO ALL |
| NOSE RADOME - REPAIRS | 53-12-01 | 801 | ARO ALL |
| Nose Radome Temporary Repair TASK 53-12-01-300-801 | | 801 | ARO ALL |
| LATCH - REMOVAL/INSTALLATION | 53-12-02 | 401 | ARO ALL |
| Latch Removal TASK 53-12-02-000-801 | | 401 | ARO ALL |
| Latch Installation TASK 53-12-02-400-801 | | 401 | ARO ALL |
| LIGHTNING DIVERTER STRIPS - REMOVAL/INSTALLATION | 53-12-03 | 401 | ARO ALL |
| Lightning Diverter Strip Removal TASK 53-12-03-000-801 | | 401 | ARO ALL |
| Lightning Diverter Strip Installation TASK 53-12-03-400-801 | | 401 | ARO ALL |
| LIGHTNING DIVERTER STRIPS - INSPECTION/CHECK | 53-12-03 | 601 | ARO ALL |
| Lightning Diverter Strip Inspection TASK 53-12-03-200-801 | | 601 | ARO ALL |
| LIGHTNING DIVERTER STRIPS - REPAIRS | 53-12-03 | 801 | ARO ALL |
| Lightning Diverter Strip Temporary Repair TASK 53-12-03-350-801 | | 801 | ARO ALL |
| SNUBBER - REMOVAL/INSTALLATION | 53-12-04 | 401 | ARO ALL |
| Snubber Removal TASK 53-12-04-000-801 | | 401 | ARO ALL |



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| Snubber Installation TASK 53-12-04-400-801 | | 401 | ARO ALL |
| GLIDE SLOPE DIRECTOR ELEMENT - REMOVAL/INSTALLATION | 53-12-05 | 401 | ARO ALL |
| Glide Slope Director Element Removal TASK 53-12-05-000-801 | | 401 | ARO ALL |
| Glide Slope Director Element Installation TASK 53-12-05-400-801 | | 401 | ARO ALL |
| GROUNDING BRACKETS - REMOVAL/INSTALLATION | 53-12-06 | 401 | ARO ALL |
| Radome Grounding Brackets Removal TASK 53-12-06-000-801 | | 401 | ARO ALL |
| Radome Grounding Brackets Installation TASK 53-12-06-400-801 | | 401 | ARO ALL |
| BAFFLE ASSEMBLY - REMOVAL/INSTALLATION | 53-13-01 | 401 | ARO ALL |
| Baffle Assembly Removal TASK 53-13-01-000-801 | | 401 | ARO ALL |
| Baffle Assembly Installation TASK 53-13-01-400-801 | | 406 | ARO ALL |
| FLIGHT AND CARGO COMPARTMENT INSULATION FOAM - MAINTENANCE PRACTICES | 53-17-00 | 201 | ARO ALL |
| Flight Compartment and Cargo Compartment Insulation Foam - Maintenance Practices TASK 53-17-00-800-801 | | 201 | ARO ALL |
| FORWARD WING-TO-BODY FAIRINGS PANEL - REMOVAL/INSTALLATION | 53-36-01 | 401 | ARO ALL |
| Forward Wing-To-Body Fairing Panel Removal TASK 53-36-01-000-801 | | 401 | ARO ALL |
| Forward Wing-To-Body Fairing Panel Installation TASK 53-36-01-400-801 | | 402 | ARO ALL |
| WING STRAKELET TO SIDE-OF-BODY - MAINTENANCE PRACTICES | 53-36-02 | 201 | ARO ALL |
| Forward Wing-To-Body Fairing Panel Removal TASK 53-36-02-000-801 | | 201 | ARO ALL |



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| Forward Wing-To-Body Fairing Panel Installation TASK 53-36-02-400-801 | | | 202 | ARO ALL |
| Wing Strakelet to Side-of-Body Inspection TASK 53-36-02-200-801 | | | 203 | ARO ALL |
| OVERWING AND UNDERWING-TO-BODY FAIRING PANEL - REMOVAL/INSTALLATION | 53-46-01 | | 401 | ARO ALL |
| Overwing and Underwing-to-Body Fairing Panel Removal | | | 401 | ARO ALL |
| TASK 53-46-01-000-801 | | | | |
| Overwing and Underwing-To-Body Fairing Panel Installation TASK 53-46-01-400-801 | | | 402 | ARO ALL |
| FUSELAGE SECTION 44 - 3 BAY SATCOM ANTENNA ADAPTER PLATE- REMOVAL/INSTALLATION | 53-61-51 | 2 | 401 | ARO ALL |
| Antenna Adapter Plate Removal TASK 53-61-51-000-802 | | 2 | 401 | ARO ALL |
| Antenna Adapter Plate Installation TASK 53-61-51-400-802 | | 2 | 405 | ARO ALL |
| FUSELAGE SECTION 46 - 2 BAY SATCOM ANTENNA ADAPTER PLATE - REMOVAL/INSTALLATION | 53-61-51 | 3 | 401 | ARO ALL |
| Satcom Antenna Adapter Plate Removal TASK 53-61-51-000-803 | | 3 | 401 | ARO ALL |
| Satcom Antenna Adapter Plate Installation TASK 53-61-51-400-803 | | 3 | 403 | ARO ALL |
| AFT WING TO BODY FAIRING PANEL - REMOVAL/INSTALLATION | 53-66-01 | | 401 | ARO ALL |
| Aft Wing-To-Body Fairing Panel Removal TASK 53-66-01-000-801 | | | 401 | ARO ALL |
| Aft Wing-To-Body Fairing Panel Installation TASK 53-66-01-400-801 | | | 402 | ARO ALL |
| DORSAL FIN - REMOVAL/INSTALLATION | 53-76-01 | | 401 | ARO ALL |
| Dorsal Fin Removal TASK 53-76-01-000-801 | | | 401 | ARO ALL |
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Dorsal Fin Installation 401 ARO ALL TASK 53-76-01-400-801



FUSELAGE - MAINTENANCE PRACTICES

1. General

A. This procedure contains scheduled maintenance task data.

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 identified as CDCCLs are defined and controlled by Special Federal Aviation Regulation (SFAR) 88, and can be found in Section 9 of the Maintenance Planning Data (MPD) 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. These design features are mandatory and cannot be changed or deleted without the approval of the FAA Oversight Office that is responsible for the airplane model Type Certificate. 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 Oversight Office that is responsible for the airplane model Type Certificate.
- (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 Section 9 of the Maintenance Planning Data (MPD) 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 Oversight Office that is responsible for the airplane model Type Certificate. 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 Oversight Office that is responsible for the airplane model Type Certificate.

B. Location Zones

| Zone | Area | |
|------|------------------------|--|
| 100 | Lower Half of Fuselage | |

ARO ALL

53-00-00



(Continued)

| Zone | Area |
|------|--------------------------------|
| 200 | Upper Half of Fuselage |
| 300 | Empennage and Body Section 48 |
| 400 | Powerplants and Nacelle Struts |
| 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 ANY MAINTENANCE THAT MAY AFFECT AN ALI. IF YOU DO NOT FOLLOW THE PROCEDURES, IT CAN INCREASE THE RISK OF A FUEL TANK IGNITION SOURCE.

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

| END | OF | TASK | |
|---------|----|------|--|

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53-00-00



FLOOR PANELS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Removal of the floor panels
 - (2) Installation of the floor panels.
 - (3) Removal of the floor panels and walkways in the forward and aft cargo compartments.
 - NOTE: The removal for the floor panels are the same as the walkways. The name depends on the location of the panels. This procedure refers to the floor panels and the walkways as the floor panels.
 - (4) Installation of the floor panels and walkways in the forward and aft cargo compartments.
 - NOTE: The installation for the floor panels are the same as the walkways. The name depends on the location of the panels. This procedure refers to the floor panels and the walkways as the floor panels.

TASK 53-01-01-000-801

2. Floor Panel Removal

A. General

- (1) This task removes the floor panel.
- (2) 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 Limitations 28-AWL-02 and 28-AWL-22.

B. References

| Reference | Title | |
|------------------|---|--|
| 28-11-00-210-801 | External Wires Over the Center Fuel Tank - Inspection (P/B 601) | |
| 53-00-00-912-801 | Airworthiness Limitation Precautions (P/B 201) | |

C. Consumable Materials

| Reference | Description | Specification |
|-----------|--|------------------|
| A00306 | Resin - Urethane - Flexane-80 | |
| A02315 | Sealant - Low Density, Synthetic Rubber. 2 Part | BMS5-142 Type II |
| A50007 | Sealant - Hot-Melt, Multipurpose - H.B. Fuller HL-6414-X | |
| A50436 | Sealant - Silicone, Lightweight Floor Panel Sealant | BMS5-170 |
| G02304 | Tape - Moisture Barrier, Adhesive One-side | BMS8-346 |
| G02482 | Seal - Extruded (Skyflex GUA1072, 1073, 1082, 1083, or 1092) | |
| G50029 | Sleeving - Expandable, Braided (Polyester, Tight Weave) | BMS13-52 Type V |

ARO ALL



D. Location Zones

| Zone | Area |
|------|------------------------|
| 200 | Upper Half of Fuselage |

E. Prepare for the Removal

SUBTASK 53-01-01-840-001

(1) Remove interior equipment, as it is necessary, to get access to the floor panels [1] (Figure 401).

SUBTASK 53-01-01-840-002

(2) Remove the floor covering from the floor panels [1].

F. Floor Panel Removal

ARO 001-015

SUBTASK 53-01-01-020-001

- (1) If the panel [1] is in a wet area (galleys, lavatories, and door areas), and if the panels are sealed with Flexane-80 resin, A00306 [3] or sealant, A02315 [3], do these steps to remove the sealant:
 - (a) Remove the moisture barrier tape, G02304 [2].
 - (b) Cut the Flexane-80 resin, A00306 [3], or sealant, A02315 [3] in one location.
 - (c) Pull up a 1.5 to 2.0 inch long section of Flexane-80 resin, A00306 [3], or sealant, A02315 [3].
 - (d) Install the point of an awl (or pry bar) under the Flexane-80 resin, A00306 [3], or sealant, A02315 [3].
 - (e) Pull up on the Flexane-80 resin, A00306 [3], or sealant, A02315 [3] while you lift with the awl (or pry bar).
 - (f) Pull the Flexane-80 resin, A00306 [3], or sealant, A02315 [3] until it is removed.
 - (g) Remove the Skyflex seal, G02482 [4] that is below the Flexane-80 resin, A00306 [3] or sealant, A02315 [3].

SUBTASK 53-01-01-000-001

- (2) If the panel [1] is in a wet area (galleys, lavatories, and door areas), and if the panels are sealed with hot melt, H.B. Fuller HL-6414-X sealant, A50007 [3], do these steps to remove the hot melt, H.B. Fuller HL-6414-X sealant, A50007 [3]:
 - (a) Remove the moisture barrier tape, G02304 [2].
 - (b) For Panel to Panel Gaps Only:
 - 1) Cut into the hot melt H.B. Fuller HL-6414-X sealant, A50007 [3] (using a non metallic scraper) until you reach the underlying sleeve, G50029 [4].
 - 2) Pull up on the sleeve, G50029 [4] allowing it to break the seal between panels.

ARO 016-999

SUBTASK 53-01-01-020-006

- (3) If the panel [1] is in a wet area (galleys, lavatories, and door areas), the panels are sealed with sealant, A50436 [3], do these steps to remove the sealant:
 - (a) Remove the moisture barrier tape, G02304 [2].
 - (b) Cut the sealant, A50436 [3] in one location.
 - (c) Pull up a 1.5 to 2.0 inch long section of sealant, A50436[3].

ARO ALL



ARO 016-999 (Continued)

- (d) Install the point of an awl (or pry bar) under the sealant, A50436 [3].
- (e) Pull up on the sealant, A50436 [3] while you lift with the awl (or pry bar).
- (f) Pull the sealant, A50436 [3] until it is removed.
- (g) Remove the Skyflex seal, G02482 [4] that is below the sealant, A50436 [3].

ARO ALL

SUBTASK 53-01-01-970-001

(4) Make a note of which panels [1] are located in wet areas.

SUBTASK 53-01-01-020-002

(5) Remove the fasteners that hold the floor panel [1] in its position.

SUBTASK 53-01-01-970-002

(6) Make a note of where the long and the short fasteners are located.

NOTE: Long fasteners are required through the sub-structure splices.

SUBTASK 53-01-01-010-001

28-AWL-02: CDCCL

(7) If you removed the panels over the center fuel tank and do maintenance or alterations 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 Critical Design Configuration
Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

28-AWL-02: CDCCL

(a) Make sure you do not change the existing (or newly approved) wire bundle routing, clamping and sleeving over the center fuel tank.

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 28-AWL-02.

28-AWL-02: CDCCL

(b) Before you install the panels over the center fuel tank, do this task only for the areas over the center fuel tank where you removed the panels: External Wires Over the Center Fuel Tank - Inspection, TASK 28-11-00-210-801.

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 28-AWL-02.

| | | _ | |
|--|-------|----|--|
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TASK 53-01-01-400-801

3. Floor Panel Installation

A. General

- (1) This task installs the floor panel.
- (2) 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 Limitations 28-AWL-02 and 28-AWL-22.

B. References

| Reference | Title | |
|------------------|---|--|
| 28-11-00-210-801 | External Wires Over the Center Fuel Tank - Inspection (P/B 601) | |
| 51-24-09-620-802 | Apply the Corrosion Inhibiting Compound (P/B 701) | |
| 53-00-00-912-801 | Airworthiness Limitation Precautions (P/B 201) | |
| 53-01-03-100-801 | Seat Track Cleaning (P/B 701) | |
| 53-01-03-600-801 | Seat Track Filler Application (P/B 201) | |

C. Tools/Equipment

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

| Reference | Description | |
|-----------|-------------------------------------|--|
| COM-2012 | Unit - Hot Melt, High Performance | |
| | Part #: DURABLUE 10 Supplier: 0AR98 | |
| | Opt Part #: KB20 Supplier: 61160 | |

D. Consumable Materials

| Reference | Description | Specification |
|-----------|--|------------------------------------|
| A00225 | Compound - Two Part Hole Filling, Polysulfide | BMS5-16 |
| 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 |
| A50007 | Sealant - Hot-Melt, Multipurpose - H.B. Fuller HL-6414-X | |
| A50436 | Sealant - Silicone, Lightweight Floor Panel Sealant | BMS5-170 |
| 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 | |
| G00270 | Tape - Scotch Flatback Masking 250 | ASTM D6123 (Supersedes A-A-883) |

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53-01-01

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(Continued)

| Reference | Description | Specification |
|-----------|--|-----------------|
| G02304 | Tape - Moisture Barrier, Adhesive One-side | BMS8-346 |
| G02482 | Seal - Extruded (Skyflex GUA1072, 1073, 1082, 1083, or 1092) | |
| G50029 | Sleeving - Expandable, Braided (Polyester, Tight Weave) | BMS13-52 Type V |

E. Location Zones

| Zone | Area |
|------|------------------------|
| 200 | Upper Half of Fuselage |

F. Prepare to Install the Floor Panel.

SUBTASK 53-01-01-210-003

28-AWL-02: CDCCL

(1) If you removed the panels over the center fuel tank and do maintenance or alterations 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 Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

28-AWL-02: CDCCL

(a) Make sure you do not change the existing (or newly approved) wire bundle routing, clamping and sleeving over the center fuel tank.

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 28-AWL-02.

28-AWL-02: CDCCL

(b) Before you install the panels over the center fuel tank, do this task only for the areas over the center fuel tank where you removed the panels: External Wires Over the Center Fuel Tank - Inspection, TASK 28-11-00-210-801.

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 28-AWL-02.

ARO 001-015

SUBTASK 53-01-01-840-003

- (2) Prepare the floor panel:
 - (a) Remove the unwanted sealant from the panel. This includes:
 - 1) Flexane-80 resin, A00306, applied with seal, G02482.
 - 2) Or H.B. Fuller HL-6414-X sealant, A50007, applied with sleeve, G50029.
 - 3) Or sealant, A02315.
 - 4) Or sealant, A00247.
 - (b) Clean the surface with solvent if it is necessary.

ARO ALL



ARO 016-999

SUBTASK 53-01-01-840-006

- (3) Prepare the floor panel:
 - (a) Remove the unwanted sealant from the panel.
 - 1) sealant, A50436, applied with seal, G02482.
 - (b) Clean the surface with solvent if it is necessary.

ARO 001-015

SUBTASK 53-01-01-840-004

- (4) Prepare the floor structure:
 - (a) Remove the unwanted sealant from the floor support structure. This includes:
 - 1) Flexane-80 resin, A00306, applied with the Skyflex seal, G02482.
 - 2) Or H.B. Fuller HL-6414-X sealant, A50007 applied with sleeve, G50029.
 - 3) Or sealant, A02315.
 - 4) Or sealant, A00247.

ARO 016-999

SUBTASK 53-01-01-840-007

- (5) Prepare the floor structure:
 - (a) Remove the unwanted sealant from the floor support structure:
 - 1) sealant, A50436, applied with the Skyflex seal, G02482.

ARO ALL

SUBTASK 53-01-01-390-001

- (6) Fill all unwanted clearances in the floor support structure with one of these sealants:
 - · sealant, A00247
 - Flexane-80 resin, A00306
 - compound, A00225

SUBTASK 53-01-01-420-001

- (7) Install the clip nuts:
 - (a) Apply primer, C00259, to the holes in the floor support structure.
 - (b) Do this task: Apply the Corrosion Inhibiting Compound, TASK 51-24-09-620-802, to the floor support structure at the attach points for the clip nuts.
 - (c) Install a shim to make the clip nut tight.
 - (d) Bond the shim in its correct position on the substructure with sealant, A00247.
 - (e) Install the clip nuts.

NOTE: Be careful not to make scratches on the floor support structure.

G. Installation.

SUBTASK 53-01-01-420-002

- (1) Install the floor panels:
 - (a) Align the floor panel with the holes in the floor support structure.
 - (b) Install the screws wet with compound, C00528.

NOTE: Screws in the wet areas have nylon bushings.

ARO ALL



- (c) Tighten the screws to 30 ±5 in-lb (3 ±1 N·m).
- (d) Make sure the top of the screw is no more than 0.04 in. (1.02 mm) below the top of the floor panel.

SUBTASK 53-01-01-940-001

(2) Apply sealant in wet areas to protect the floor beams from water and corrosion.

NOTE: The sealant will protect the floor beams from water and prevent corrosion.

NOTE: Configuration of floor panels may vary within the wet area but sealing will remain the same.

- (a) Wet area panels are in these locations:
 - 1) In the galleys and at least 36 in. (914 mm) around the galleys.
 - 2) In the lavatories and at least 36 in. (914 mm) around the lavatories.
 - 3) In entry and exit doorway areas.
 - 4) In Section 41, the wet area for sealing floor panels extends aft to Body Station 414. NOTE: This prevents moisture leakage into the Electrical Equipment (EE) Bay.
- (b) Dry area panels are in these locations:
 - 1) Outside of the 36 in. (914 mm) wet area around the galleys.
 - 2) Outside of the 36 in. (914 mm) wet area around the lavatories.
 - 3) Outside of the entry and exit doorway areas.

ARO 001-015

SUBTASK 53-01-01-420-003

- (3) Do these steps to apply Flexane-80 resin, A00306:
 - NOTE: To minimize galley mat buckling, it is recommended to use Flexane-80 between floor panels.
 - NOTE: Once Flexane-80 resin, A00306 sealant has cured between the floor panels, it can be very difficult to removed without damaging floor panels.
 - (a) Refer to Figure 401.
 - (b) Make sure that you remove all the unwanted sealant before you apply the Flexane-80 resin, A00306 sealant.
 - NOTE: Hot melt and sealant can not be mixed in areas specified as "HOT MELT OR SEALANT". It is necessary to use only one.
 - (c) Apply the Skyflex seal, G02482, and Flexane-80 resin, A00306, in the clearance around the floor panel:
 - NOTE: If the Skyflex seal, G02482, is not available, use sleeve, G50029, as an alternative.
 - 1) Make sure you do not apply sealant in these areas:
 - a) Around the access panel to the Main Equipment Bay.
 - b) At the edges of the aft wet area, aft of the doorway.
 - c) Lavatory cutouts.
 - d) In drains.
 - 2) Apply Scotch Flatback Masking Tape 250, G00270, on each side of the clearance.
 - 3) Apply Devcon Flexane FL-20 primer, C00953, between floor panel seams.

ARO ALL



ARO 001-015 (Continued)

- 4) If the clearance is more than 0.06 in. (1.52 mm) wide, fill the bottom 25 percent to 66 percent of the gap or clearance with Skyflex seal, G02482.
- 5) Refer to the manufacturer's instructions to prepare the Flexane-80 resin, A00306.
 - NOTE: The pot life of mixed sealant is 15 minutes. Make sure you apply it immediately.
- Fill the remainder of the clearance with the Flexane-80 resin, A00306, until it is level with the top of the floor panel.
- 7) Let the Flexane-80 resin, A00306, dry until it is smooth and constant.
 - a) The recommended dry times are as shown in Table 401:

Table 401/53-01-01-993-805 Recommended Dry Times

| Temperature (°F) | Time Range (Hours) |
|---------------------------|--------------------|
| 80°F (27°C) or over | 4-6 |
| 70°F (21°C) - 80°F (27°C) | 6-8 |
| 60°F (16°C) - 70°F (21°C) | 8-10 |

- Remove the Scotch Flatback Masking Tape 250, G00270.
- Apply tape moisture barrier tape, G02304, over the Flexane-80 resin, A00306.
 NOTE: The use of sealant on the floor panels outside the wet areas is optional.

SUBTASK 53-01-01-410-001

- (4) Do these steps to apply H.B. Fuller HL-6414-X sealant, A50007:
 - (a) Refer to Figure 401.
 - (b) Make sure that you remove all the unwanted hot melt sealant before you apply the H.B. Fuller HL-6414-X sealant, A50007 sealant.
 - NOTE: Hot melt and sealant can not be mixed in areas specified as "HOT MELT OR SEALANT". It is necessary to use only one.
 - (c) Apply the Expandable Braided fillersleeve, G50029, and H.B. Fuller HL-6414-X sealant, A50007, in the clearance around the floor panel as follows:
 - 1) Apply Scotch Flatback Masking Tape 250, G00270, on each side of clearance.
 - 2) Make sure that you do not apply hot melt H.B. Fuller HL-6414-X sealant, A50007, in these areas:
 - a) Around the access panel to the Main Equipment Bay.
 - b) At the edges of the aft wet area, aft of the doorway.
 - c) Lavatory cutouts.
 - d) In drains.
 - 3) Insert Expandable Braided filler, sleeve, G50029, in all floor panel to floor panel gaps.

NOTE: If the sleeve, G50029 is not available, use Skyflex seal, G02482 as an alternative.

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ARO 001-015 (Continued)

- 4) Use the hot melt unit, COM-2012, to heat the hot melt H.B. Fuller HL-6414-X sealant, A50007. Refer to the manufacturer's instructions for heating hot melt H.B. Fuller HL-6414-X sealant, A50007.
 - NOTE: Boeing recommends operating the machine at 285°F (141°C).
- 5) Place tip of nozzle in the bottom of the gap. Slightly overfill the gap with hot melt H.B. Fuller HL-6414-X sealant. A50007.
 - NOTE: Fill the gaps slowly allowing air to escape. This will minimize air bubbles.
- 6) After the hot melt H.B. Fuller HL-6414-X sealant, A50007, has solidified (about 10 minutes) remove excess material flush with the floor panel and/or seat track.
 - a) Use only non-metallic scrapers.
- 7) Remove the Scotch Flatback Masking Tape 250, G00270.
- 8) Apply the moisture barrier tape, G02304, over the hot melt H.B. Fuller HL-6414-X sealant, A50007.
 - <u>NOTE</u>: The use of sealant on the floor panels outside the wet areas is optional.

SUBTASK 53-01-01-410-002

- (5) Do these steps to apply sealant, A02315 or sealant, A00247:
 - (a) Refer to Figure 401.
 - (b) Apply the Expandable Braided filler sleeve, G50029, and sealant, A02315 or sealant, A00247, in the clearance around the floor panel:
 - 1) Apply Scotch Flatback Masking Tape 250, G00270, on each side of clearance.
 - 2) Insert expandable braided filler, sleeve, G50029 in bottom of the gap.
 - NOTE: If the sleeve, G50029, is not available, use Skyflex seal, G02482, as an alternative.
 - Refer to the manufacturer's instructions for thawing, mixing, or application of the sealant
 - 4) Fill the remainder of the gap with sealant, A02315 or sealant, A00247.
 - 5) Fair the sealant flush with panel and/or adjacent structure.
 - 6) Remove the Scotch Flatback Masking Tape 250, G00270, after the sealant is dried as given in the manufacturer's instructions.
 - 7) Remove the Scotch Flatback Masking Tape 250, G00270.
 - 8) Apply moisture barrier tape, G02304 over the sealant.
 - NOTE: The use of sealant on the floor panels outside the wet areas is optional.

ARO 016-999

SUBTASK 53-01-01-410-003

- (6) Do these steps to apply sealant, A50436:
 - (a) Refer to Figure 401.
 - (b) Apply the Expandable Braided filler sleeve, G50029, and sealant, A50436, in the clearance around the floor panel:
 - 1) Apply Scotch Flatback Masking Tape 250, G00270, on each side of clearance.

ARO ALL



ARO 016-999 (Continued)

- 2) Insert expandable braided filler, sleeve, G50029 in bottom of the gap.
 - NOTE: If the sleeve, G50029, is not available, use Skyflex seal, G02482, as an alternative.
- 3) Refer to the manufacturer's instructions for thawing, mixing, or application of the sealant.
- 4) Fill the remainder of the gap with sealant, A50436.
- 5) Fair the sealant flush with panel and/or adjacent structure.
- 6) Remove the Scotch Flatback Masking Tape 250, G00270, after the sealant is dried as given in the manufacturer's instructions.
- 7) Remove the Scotch Flatback Masking Tape 250, G00270.
- 8) Apply moisture barrier tape, G02304 over the sealant.NOTE: The use of sealant on the floor panels outside the wet areas is optional.

ARO ALL

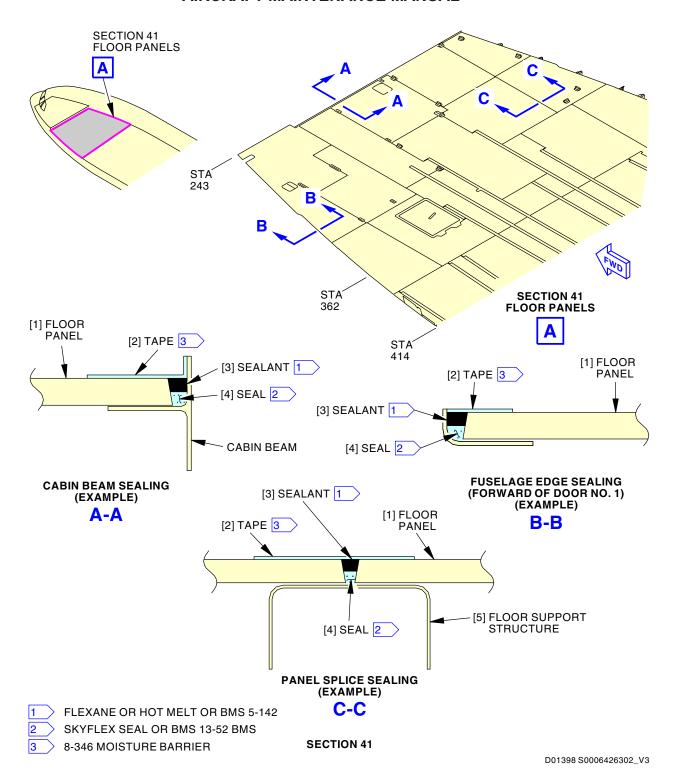
SUBTASK 53-01-01-420-004

- (7) Seat Tracks In Wet Areas:
 - (a) If it is necessary, do this task: Seat Track Cleaning, TASK 53-01-03-100-801.
 - (b) If it is necessary, do this task: Seat Track Filler Application, TASK 53-01-03-600-801.

----- END OF TASK -----

FFFECTIVITY 53-01-01

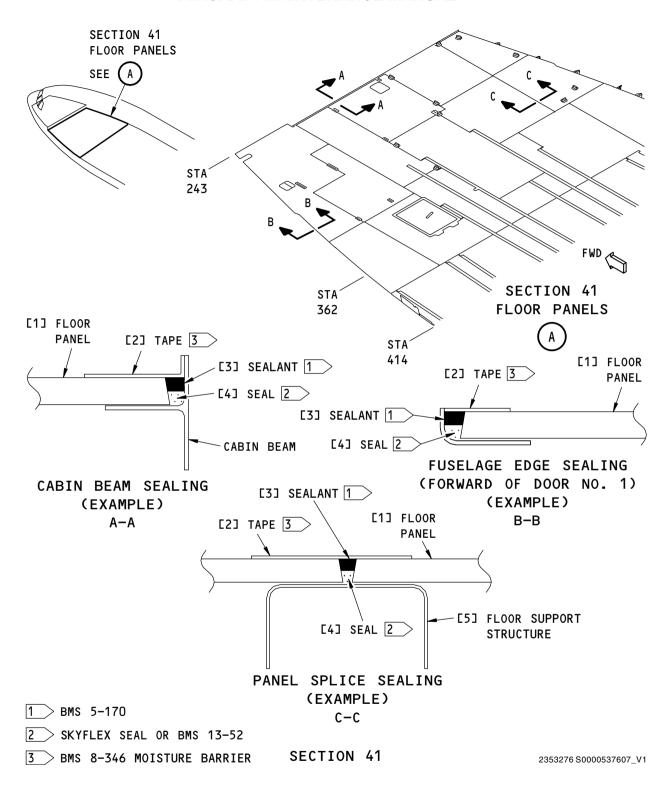




Floor Panel Sealing Figure 401/53-01-01-990-801 (Sheet 1 of 6)



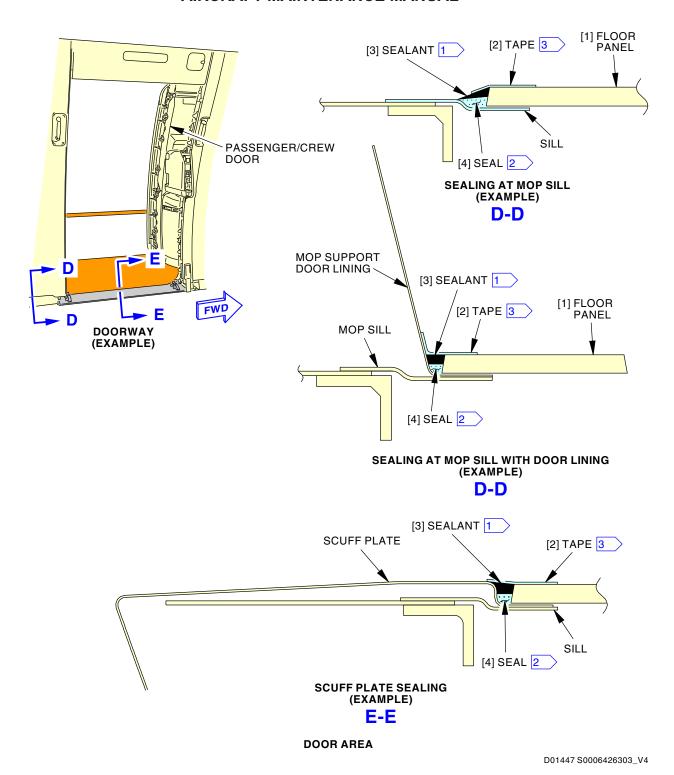




Floor Panel Sealing Figure 401/53-01-01-990-801 (Sheet 2 of 6)



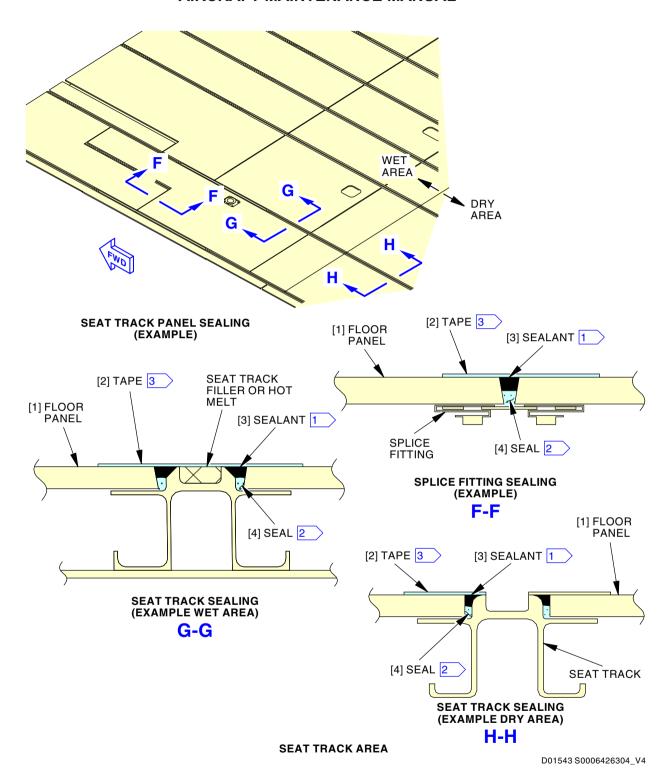




Floor Panel Sealing Figure 401/53-01-01-990-801 (Sheet 3 of 6)







Floor Panel Sealing Figure 401/53-01-01-990-801 (Sheet 4 of 6)

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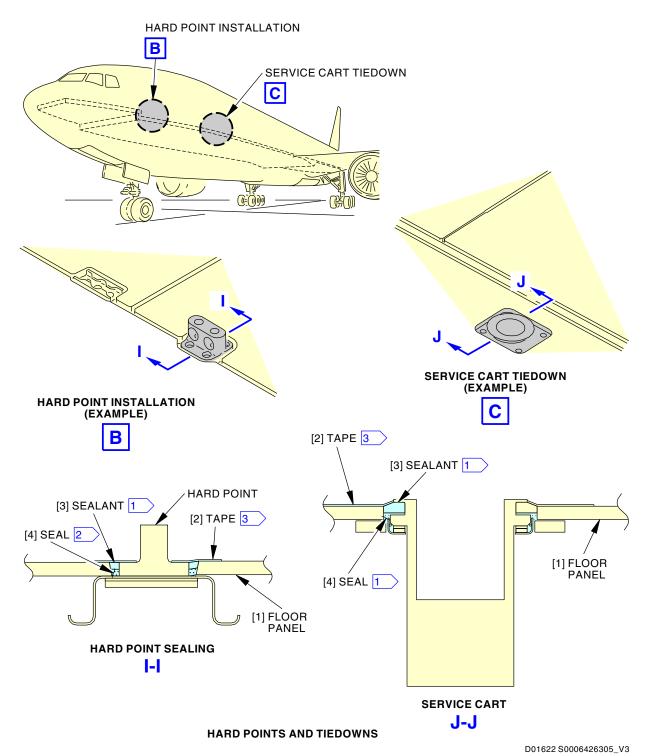
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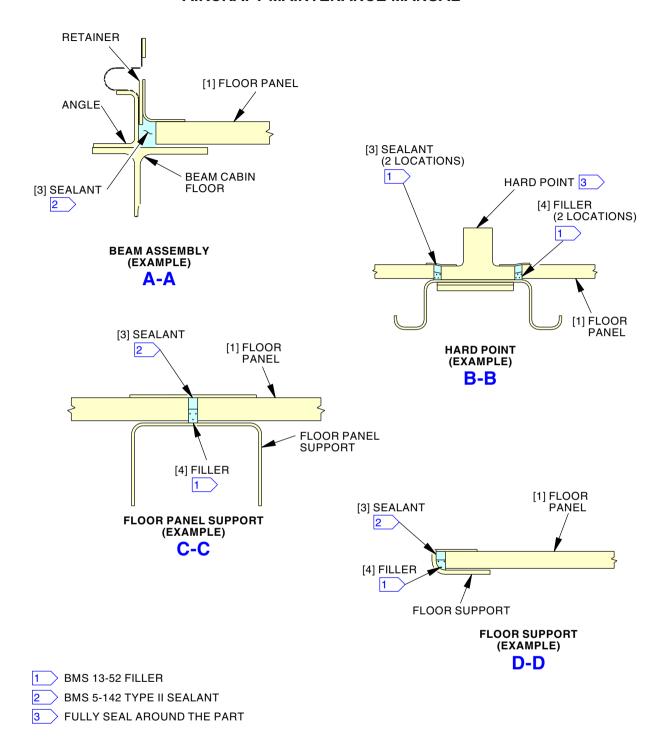




Floor Panel Sealing Figure 401/53-01-01-990-801 (Sheet 5 of 6)







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Floor Panel Sealing Figure 401/53-01-01-990-801 (Sheet 6 of 6)

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TASK 53-01-01-000-802

4. Aft and Forward Cargo Floor Panels Removal

(Figure 25-52-10-990-801, Figure 25-52-10-990-802)

A. References

| Reference | Title |
|------------------|--|
| 25-52-10-990-801 | Figure: Floor Panel Installation (P/B 401) |
| 25-52-10-990-802 | Figure: Floor and Walkway Panel - Bulb Seal, Aft Cargo |
| | Compartment Installation (P/B 401) |

B. Tools/Equipment

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

| Reference | Description |
|-----------|---|
| SPL-1988 | Barrier - Safety, Large Cargo Door |
| | Part #: J52011-1 Supplier: 81205 Part #: J52011-2 Supplier: 81205 Opt Part #: D0136-030 Supplier: 2S363 |

C. Location Zones

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

D. Prepare for the Removal

SUBTASK 53-01-01-420-006



INSTALL THE SAFETY BARRIER CORRECTLY WHEN THE CARGO DOOR IS OPEN. IF YOU DO NOT CORRECTLY INSTALL THE SAFETY BARRIER, PERSONS CAN FALL OUT OF THE CARGO COMPARTMENT AND INJURY CAN OCCUR.

(1) Install the large cargo door safety barrier, SPL-1988 across the cargo door opening.

E. Floor Panels and Walkways Removal

SUBTASK 53-01-01-000-002



ALWAYS INSTALL THE FLOOR PANELS OF THE FORWARD CARGO COMPARTMENT IMMEDIATELY AFTER YOU DO MAINTENANCE. IF YOU DO NOT INSTALL THE FLOOR PANELS, DAMAGE TO THE HYDRAULIC LINES OF THE NOSE LANDING GEAR CAN OCCUR.

(1) Remove the screws [2], [8] and washers [9] that attach the floor panel [1] to the support structure [6], [11].

SUBTASK 53-01-01-000-003

(2) Remove the floor panel [1].

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|---|--|-----|------|-----|---|--|

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TASK 53-01-01-400-802

5. Aft and Forward Cargo Floor Panels Installation

(Figure 25-52-10-990-801, Figure 25-52-10-990-802)

A. References

| Reference | Title |
|------------------|--|
| 25-52-10-990-801 | Figure: Floor Panel Installation (P/B 401) |
| 25-52-10-990-802 | Figure: Floor and Walkway Panel - Bulb Seal, Aft Cargo |
| | Compartment Installation (P/B 401) |

B. Tools/Equipment

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

| Reference | Description | |
|-----------|---------------------------------------|--|
| SPL-1988 | Barrier - Safety, Large Cargo Door | |
| | Part #: J52011-1 Supplier: 81205 | |
| | Part #: J52011-2 Supplier: 81205 | |
| | Opt Part #: D0136-030 Supplier: 2S363 | |

C. Consumable Materials

| Reference | Description | Specification |
|-----------|---|--|
| B00083 | Solvent - VM&P Naphthas | TT-N-95 Type II, ASTM D-3735 Type III |
| G00150 | Tape - Nitto P-421 NAT (Formerly Permacel) PTFE Film Tape | |

D. Location Zones

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

E. Floor Panels and Walkways Installation

SUBTASK 53-01-01-160-002

(1) Make sure the tape on the support structure [6], [11] and the shear web [4] is smooth.

SUBTASK 53-01-01-300-002

(2) If it is necessary to replace the tape, do the steps that follow:



DO NOT CUT OR MAKE SCRATCHES TO THE SUPPORT STRUCTURE OR SHEAR WEB WHEN YOU REMOVE THE TAPE. CUTS AND SCRATCHES IN THE SUPPORT STRUCTURE OR SHEAR WEB CAN INCREASE THE RISK OF CORROSION.

- (a) Remove the tape from the support structure [6], [11] or the shear web [4].
- (b) Use the solvent, B00083 to remove the remaining tape or adhesive from the support structure [6], [11] or shear web [4].
- (c) Install the Nitto P-421 tape, G00150 on the support structure [6], [11] or shear web [4] with a length the same as the width of the floor panel [1].

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SUBTASK 53-01-01-400-001

(3) Put the floor panel [1] in the correct location.

SUBTASK 53-01-01-400-002

- (4) For AFT Cargo Compartment floor and walkway panels at station 1885.
 - (a) Make sure the bulb seal [31] at the panel [1] edges is tucked under the protruding fasteners [32] on the side of the roller trays [30]. (Figure 25-52-10-990-802)

SUBTASK 53-01-01-400-003

- (5) Install the screws [2], [8] and washers [9] that attach the floor panel [1] to the support structure [6], [11] or shear web [4].
- F. Put the Airplane Back to Its Usual Condition

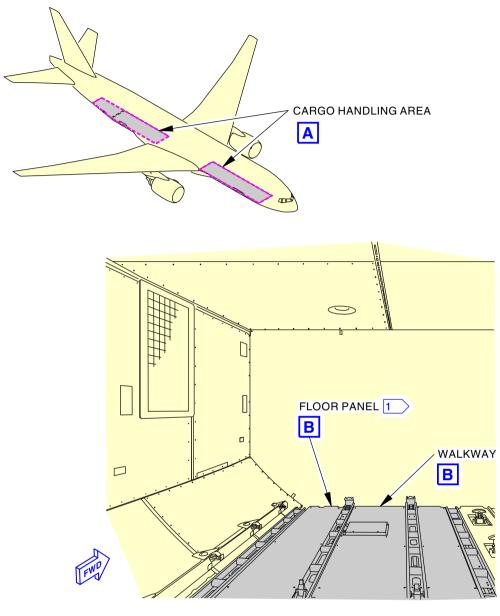
SUBTASK 53-01-01-000-004

(1) Remove the large cargo door safety barrier, SPL-1988.

----- END OF TASK -----

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FORWARD CARGO COMPARTMENT (AFT CARGO COMPARTMENT EQUIVALENT)



1 THE INSTALLATION OF THE FLOOR PANELS AND WALKWAYS IS THE SAME.

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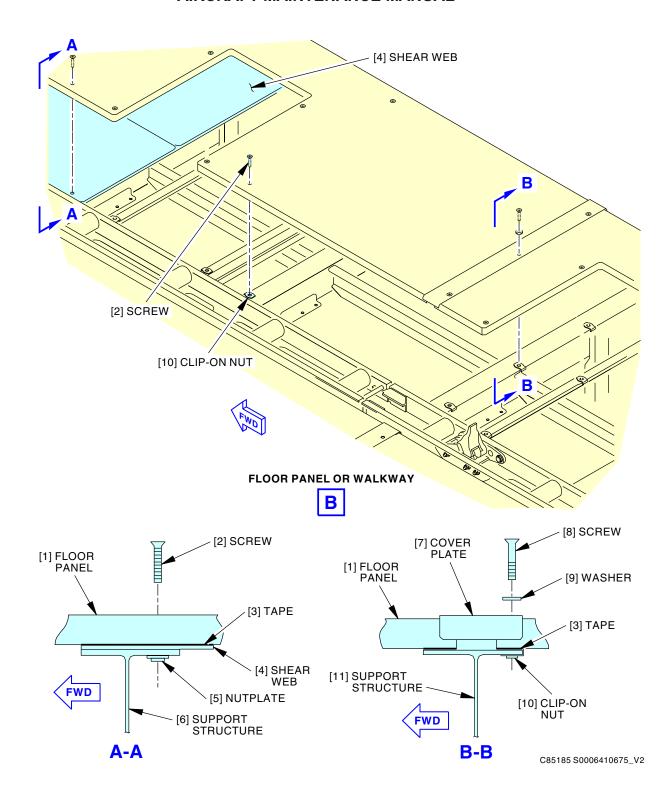
Floor Panel Installation Figure 402/53-01-01-990-807 (Sheet 1 of 2)

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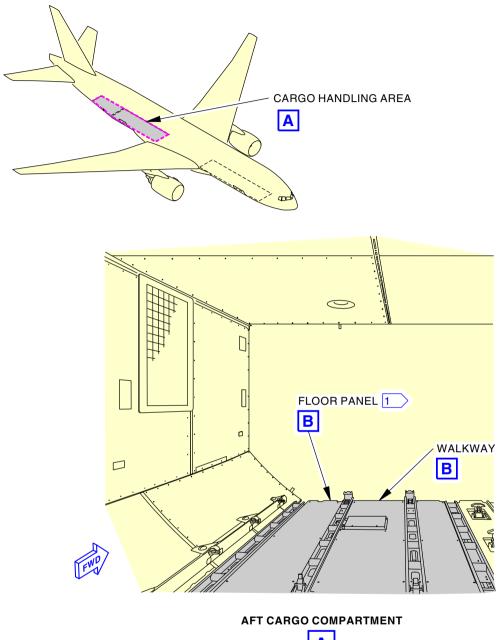




Floor Panel Installation Figure 402/53-01-01-990-807 (Sheet 2 of 2)









> THE INSTALLATION OF THE FLOOR PANELS AND WALKWAYS IS THE SAME.

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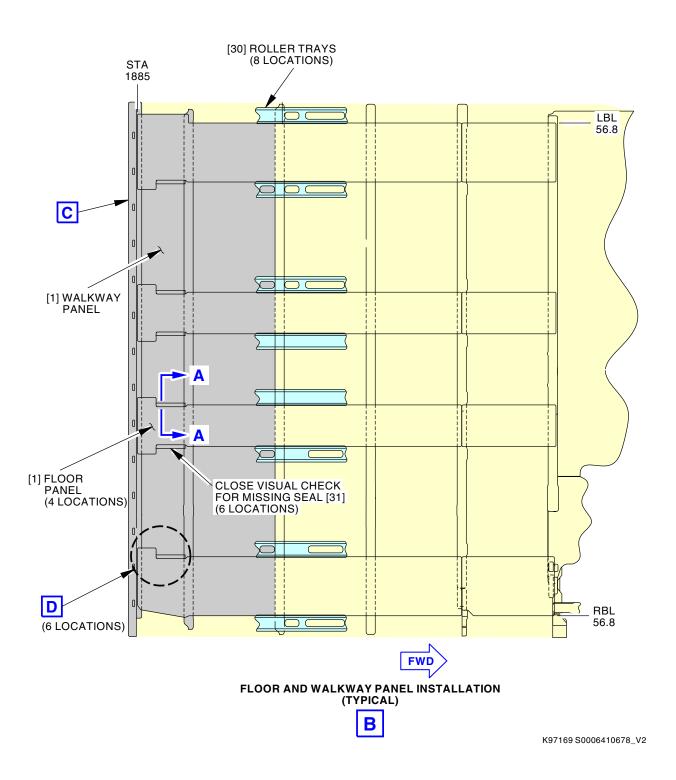
Floor and Walkway Panel - Bulb Seal, Aft Cargo Compartment Installation Figure 403/53-01-01-990-808 (Sheet 1 of 6)

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Floor and Walkway Panel - Bulb Seal, Aft Cargo Compartment Installation Figure 403/53-01-01-990-808 (Sheet 2 of 6)

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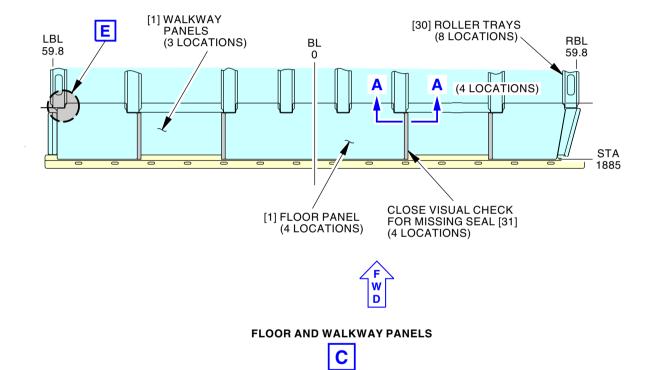
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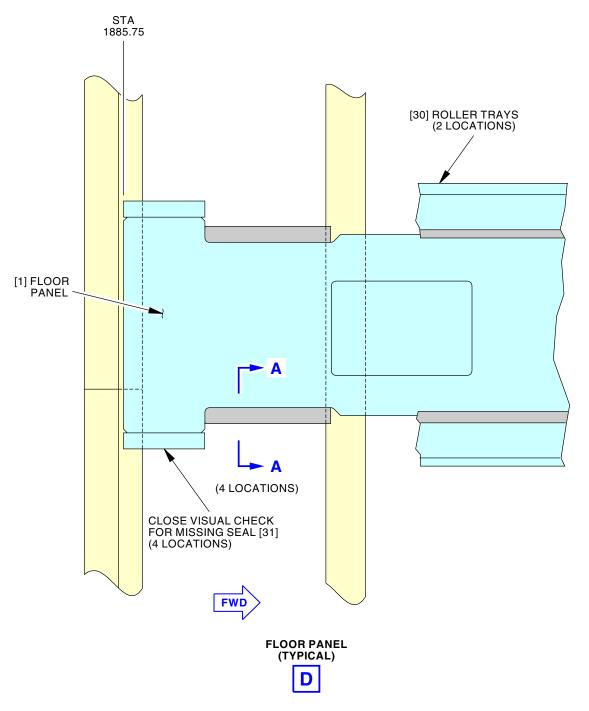
Floor and Walkway Panel - Bulb Seal, Aft Cargo Compartment Installation Figure 403/53-01-01-990-808 (Sheet 3 of 6)

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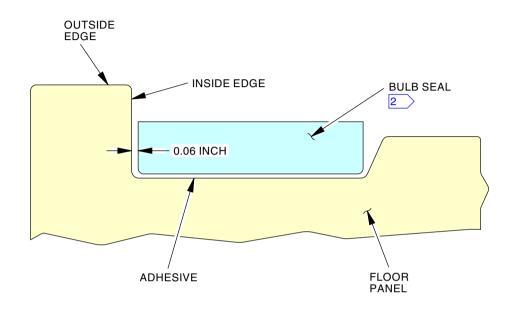


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Floor and Walkway Panel - Bulb Seal, Aft Cargo Compartment Installation Figure 403/53-01-01-990-808 (Sheet 4 of 6)









TRIM THE BULB SEAL FLUSH TO THE PANEL INSIDE EDGES.
THE MAXIMUM GAP BETWEEN THE BULB SEAL AND THE
FLOOR PANEL INSIDE EDGE IS 0.06 INCH

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Floor and Walkway Panel - Bulb Seal, Aft Cargo Compartment Installation Figure 403/53-01-01-990-808 (Sheet 5 of 6)

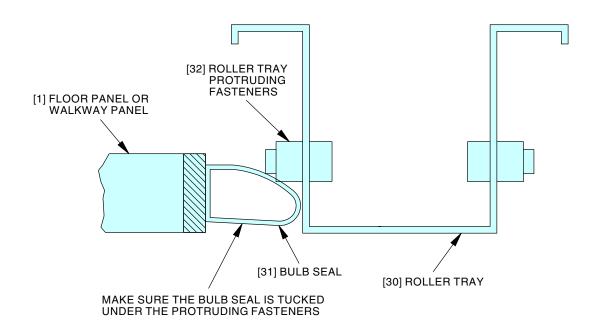
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AIRCRAFT MAINTENANCE MANUAL



BULB SEAL INSTALLATION A-A

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Floor and Walkway Panel - Bulb Seal, Aft Cargo Compartment Installation Figure 403/53-01-01-990-808 (Sheet 6 of 6)

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SEAT TRACKS - MAINTENANCE PRACTICES

1. General

- A. This procedure has this task:
 - (1) Apply Filler in the seat tracks.

TASK 53-01-03-600-801

2. Seat Track Filler Application

A. General

- (1) Seat track filler prevents corrosion in wet areas of the passenger compartment.
- (2) You can cut and remove parts of the seat track fillers when you remove and install galleys, lavs, and tie down fittings.

B. Consumable Materials

| Reference | Description | Specification |
|-----------|---|---------------|
| A50003 | Filler, Silicone Rubber - Silastic TR-55 | BMS1-62 |
| A50007 | Sealant - Hot-Melt, Multipurpose - H.B. Fuller HL-6414-X | |
| C00308 | Compound - Corrosion Preventive, Petrolatum Hot Application | MIL-C-11796 |
| G02304 | Tape - Moisture Barrier, Adhesive One-side | BMS8-346 |

C. Location Zones

| Zone | Area | |
|------|------------------------|--|
| 200 | Upper Half of Fuselage | |

D. Procedure

SUBTASK 53-01-03-620-001

- (1) If using extruded seat track filler [1], apply Silastic TR-55 filler, A50003 in the seat tracks [3] as follows: (Figure 201)
 - (a) Find the seat track [3] locations in the wet areas of the airplane.
 - (b) Cut the seat track filler, Silastic TR-55 filler, A50003 [1] to fit in the seat tracks [3].
 - NOTE: A gap of 0.25 inch is permitted at the skin splice areas.
 - (c) Fill the seat track [3] with corrosion preventive compound, C00308 as required.
 - (d) Install the seat track filler [1], Silastic TR-55 filler, A50003.
 - (e) Make sure the top surface of the seat track [3] and filler, Silastic TR-55 filler, A50003 [1] are clean and free of grease or debris.
 - (f) Apply tape moisture barrier tape, G02304 [2] bridging the seat track over the filler.

SUBTASK 53-01-03-400-001

- (2) If using Hot Melt [1] for seat track filler [2], apply filler as follows:
 - (a) Find the seat track locations in the wet areas of the airplane.
 - (b) Fill the seat tracks [3] with corrosion preventive compound, C00308
 - (c) Refer to the manufacturer's instructions for heating the H.B. Fuller HL-6414-X sealant, A50007 [1]

NOTE: Boeing recommends operating the machine at 285 °F.

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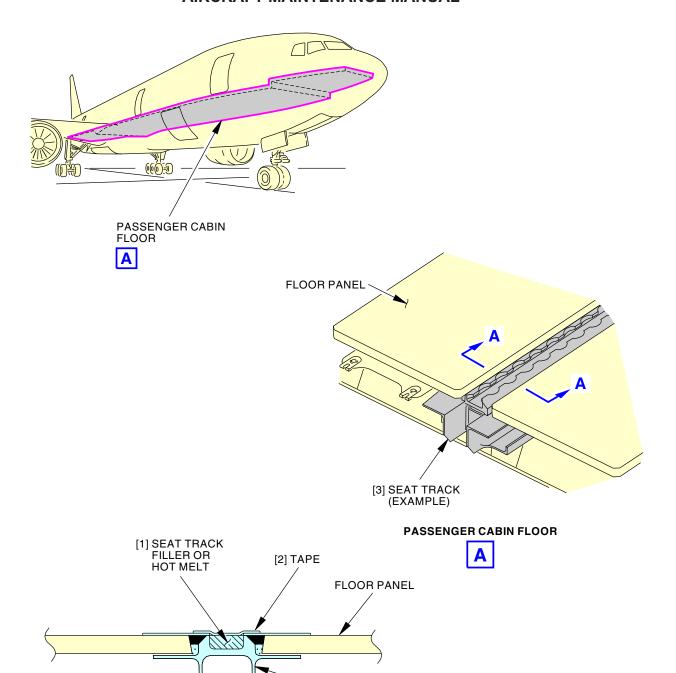


- (d) Place the tip of the nozzle in the bottom of the seat track [3]. Slightly overfill the seat track [3] with H.B. Fuller HL-6414-X sealant, A50007 [1]
- (e) After the Hot Melt, H.B. Fuller HL-6414-X sealant, A50007 [1] has solidified (about 10 minutes) remove excess material flush with the seat track [3]. (Use only non-metallic scrapers.)
- (f) Make sure the top surface of the seat track [3] and filler, H.B. Fuller HL-6414-X sealant, A50007 Hot Melt [1], are clean and free of grease or debris.
- (g) Apply the tape, moisture barrier tape, G02304 [2] over the Hot Melt, H.B. Fuller HL-6414-X sealant, A50007 [1].

—— END OF TASK ——

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Seat Track Filler Application Figure 201/53-01-03-990-801

[3] SEAT TRACK

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SEAT TRACKS - CLEANING/PAINTING

1. General

- A. This procedure has this task:
 - (1) Clean the aluminum seat tracks.

TASK 53-01-03-100-801

2. Seat Track Cleaning

A. General

- (1) Titanium seat tracks are located in the wet areas for corrosion resistance.
- (2) Aluminum seat tracks are located in the dry areas.

B. References

| Reference | Title |
|------------------|--|
| 51-21-04-620-801 | Alodine 600, 1000, 1200, and 1200S Coating Application |
| | (P/B 701) |

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 | |
| C00064 | Coating - Aluminum Chemical Conversion | BAC5719 Type II Class A (MIL-DTL-5541 Class 1A) |

D. Location Zones

| Zone | Area |
|------|------------------------|
| 200 | Upper Half of Fuselage |

E. Procedure

SUBTASK 53-01-03-120-001

- (1) Clean aluminum and titanium seat tracks as follows:
 - (a) Use solvent, B00083 to remove all the oil or grease.
 - (b) Rub the seat track with 320-grit abrasive cloth, B00102 until the corrosion is gone.
 - (c) Use a vacuum cleaner to remove all the loose unwanted materials.
 - (d) Clean the area with solvent, B00083 one more time.

SUBTASK 53-01-03-100-001

(2) For aluminum seat tracks only, do the following:



DO NOT GET ALODINE IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. PUT ON A PROTECTIVE SPLASH GOGGLE AND GLOVES WHEN YOU USE ALODINE. ALODINE CONTAINS CHROMIC ACID WHICH CAN CAUSE INJURY TO PERSONS.

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(WARNING PRECEDES)



DO NOT LET CLOTHES THAT ARE SOAKED WITH ALODINE BECOME DRY. SOAK THESE CLOTHES IN WATER WHEN YOU DISCARD THEM. DRY CLOTHES THAT HAVE ALODINE IN THE FABRIC CAN START TO BURN SUDDENLY.



PUT A COVER ON ALL ADJACENT CARPETS WHEN YOU APPLY ALODINE. ALODINE WILL CAUSE A STAIN ON FABRICS.

(a) Apply clear coating, C00064 to the surfaces of the seat tracks you can see (TASK 51-21-04-620-801).

----- END OF TASK -----

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SOUND DAMPENING ANGLES - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Removal of the sound dampening angles
 - (2) Installation of the sound dampening angles.
- B. Sound dampening angles are located on stringers and frames in the passenger and flight compartments.

TASK 53-02-04-000-801

2. Sound Dampening Angle 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 | Tool - Sealant Removal, BAC5000, PSD 6-184 Approved |
| | Part #: 1-6390-A Supplier: 63318 |
| | Part #: 10810 Supplier: \$0855 |
| | Part #: 234350 Supplier: \$0857 |
| | Part #: 311 Supplier: F6892 |
| | Part #: 411B60 Supplier: 3DN12 |
| | Part #: 411B90 Supplier: 3DN12 |
| | Part #: DAD5013 Supplier: \$0856 |
| | Part #: DFD5019 Supplier: \$0856 |
| | Part #: J5-0275-2010 Supplier: 435R8 |
| | Part #: SCD5019 Supplier: \$0856 |
| | Part #: ST982LF-9 Supplier: 62176 |
| | Part #: TS1275-4 Supplier: 1DWR5 |

B. Consumable Materials

| Reference | Description | Specification |
|-----------|--|-----------------|
| B00093 | Solvent - Tetrachloroethylene (Perchloroethylene) | ASTM D4081 |
| G00034 | Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze) | BMS15-5 Class A |

C. Location Zones

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

D. Sound Dampening Angle Removal

SUBTASK 53-02-04-010-001

(1) Get access to the sound dampening angle [1].

SUBTASK 53-02-04-020-001

- (2) Carefully lift and remove the sound dampening angle [1] from the frame [2] or the stringer [3].
 - (a) Remove tape remaining on stringer or frame with wood or plastic sealant removal tool, COM-2481.

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(b) Soften and remove residual tape with solvent, B00093 and cotton wiper, G00034.



TASK 53-02-04-400-801

3. Sound Dampening Angle Installation

(Figure 401)

A. Consumable Materials

| Reference | Description | Specification |
|-----------|--|--|
| B00083 | Solvent - VM&P Naphthas | TT-N-95 Type II, ASTM D-3735 Type III |
| B00093 | Solvent - Tetrachloroethylene (Perchloroethylene) | ASTM D4081 |
| B00130 | Alcohol - Isopropyl | TT-I-735 |
| G00034 | Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze) | BMS15-5 Class A |

B. Location Zones

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

C. Installation

SUBTASK 53-02-04-100-001

- (1) Prepare the frame [2] or the stringer [3] and the sound dampening angle [1] as follows:
 - (a) Use a cotton wiper, G00034 and solvent, B00083 or solvent, B00093 to clean the areas where you will install the tape.

NOTE: This area can include the frames, the stringers, and the sound dampening angles.

- (b) Make sure the sound dampening angle [1] is clean in the area where you will attach the tape.
- (c) Make sure the surfaces remain clean until you install the tape.
- (d) Cut the tape [4] to size.
- (e) Install the pre-cut tape to the sound dampening angle [1].
- (f) The tape [4] is to be installed on the sound dampening angle [1] without surface wrinkles or air trapped between the tape [4] and the sound dampening angle [1].

SUBTASK 53-02-04-420-001



DO NOT DRILL HOLES THROUGH THE SOUND DAMPENING ANGLE OR ATTACH THE SOUND DAMPENING ANGLE TO THE STRUCTURE WITH SCREWS. IF YOU DRILL HOLES OR USE FASTENERS OTHER THAN TAPE, YOU WILL CHANGE THE ACOUSTIC CHARACTERISTICS OF THE ANGLE.

- (2) Attach the sound dampening angles to the frame [2] or the stringer [3] as follows:
 - (a) Remove the paper from the tape [4].
 - (b) Clean the frame [1] or the stringer [2] with solvent, B00093.
 - (c) Spray the tape [4] with alcohol, B00130.

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- (d) Apply the dampening angle [3] to the frame [1] or the stringer [2] immediately after soraying the tape [4] with alcohol, B00130.
- (e) Carefully align the dampening angle [3] to the frame [1] or the stringer [2].
- (f) Press the dampening angle [3] into place onto the frame [1] or the stringer [2].
 - NOTE: Maintain pressure for 5 to 10 minutes. Light pressure clamping of the dampening angle to the frame or the stringer is acceptable.
 - NOTE: Tape that does not contact the frame or the stringer is acceptable, but must not be more than 10 percent of the total tape contact area.

SUBTASK 53-02-04-410-001

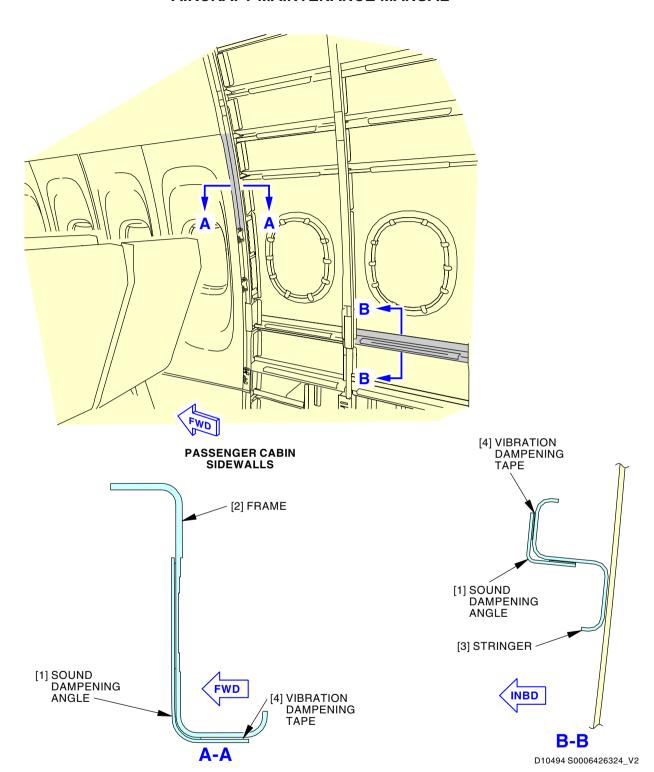
(3) Install the parts that you removed to get access to the sound dampening angles.



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Sound Dampening Angle Installation Figure 401/53-02-04-990-801





FUSELAGE - CORROSION INSPECTIONS - MAINTENANCE PRACTICES

1. General

A. This procedure contains MSG-3 task card data.

TASK 53-05-01-210-802

2. INTERNAL - GENERAL VISUAL: MAIN EQUIPMENT CENTER ACCESS DOOR

| Α. | References | 2 |
|--------|------------|---|
| \sim | | • |

| Reference | Title |
|------------------|--------------------------------------|
| 51-05-01-210-803 | 777 Basic Task Description (P/B 201) |

B. Inspection

SUBTASK 53-05-01-210-002

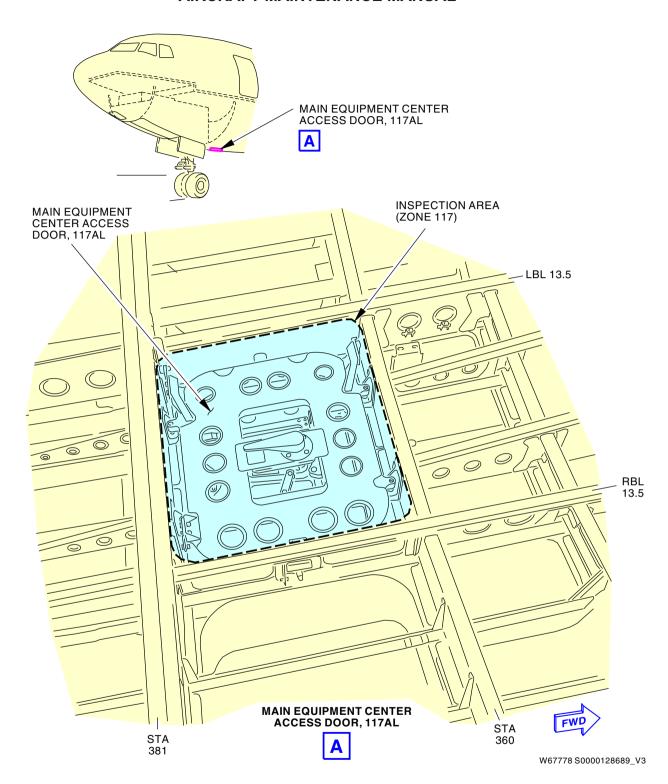
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----- END OF TASK -----

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Main Equipment Center Access Door, 117AL Figure 201/53-05-01-990-852

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TASK 53-05-01-210-813

3. INTERNAL - GENERAL VISUAL: LOWER FUSELAGE - SUBZONE 110 AND 120

| A. | References | |
|----|--------------------------|--------------------------------------|
| | Reference | Title |
| | 51-05-01-210-803 | 777 Basic Task Description (P/B 201) |
| В. | Inspection | |
| | SUBTASK 53-05-01-210-013 | |

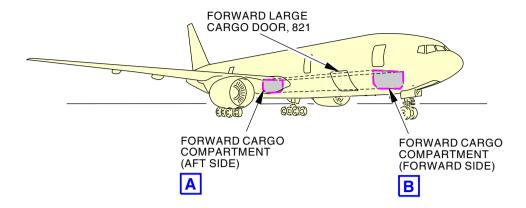
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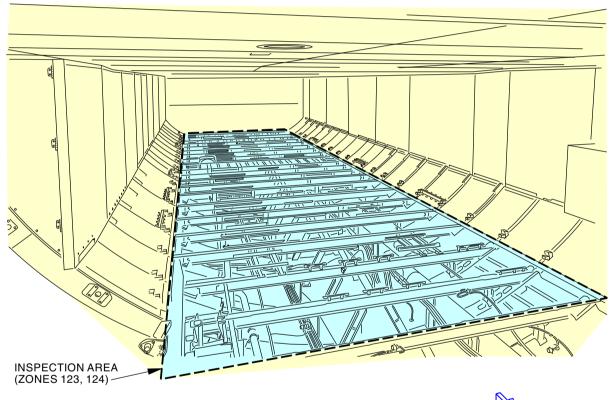
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FORWARD CARGO COMPARTMENT (AFT SIDE)





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Below the Forward Cargo compartment Figure 202/53-05-01-990-858 (Sheet 1 of 2)

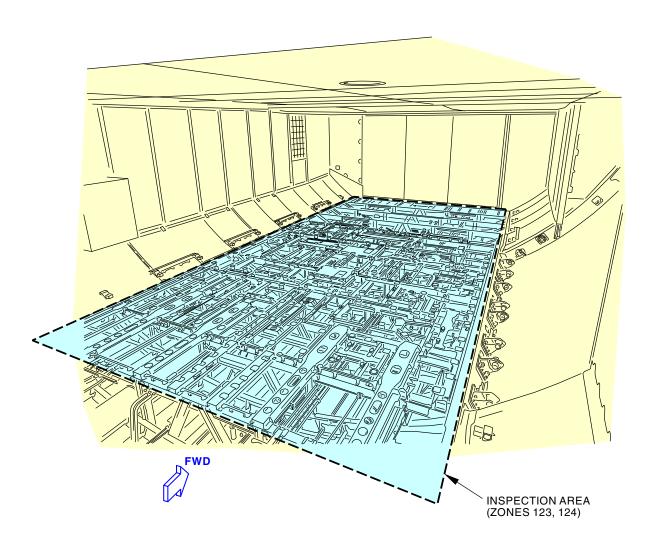
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FORWARD CARGO COMPARTMENT (FORWARD SIDE)



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Below the Forward Cargo compartment Figure 202/53-05-01-990-858 (Sheet 2 of 2)

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TASK 53-05-01-210-818

4. INTERNAL - GENERAL VISUAL: LEFT MAIN LANDING GEAR WHEEL WELL

| A. | References | | |
|----|------------------|--------------------------------------|--|
| | Reference | Title | |
| | 51-05-01-210-804 | 777 Basic Task Description (P/B 201) | |

B. Inspection

SUBTASK 53-05-01-210-018

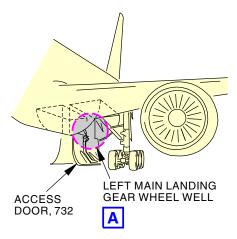
(1) Do the inspection777 Basic Task Description, TASK 51-05-01-210-804.

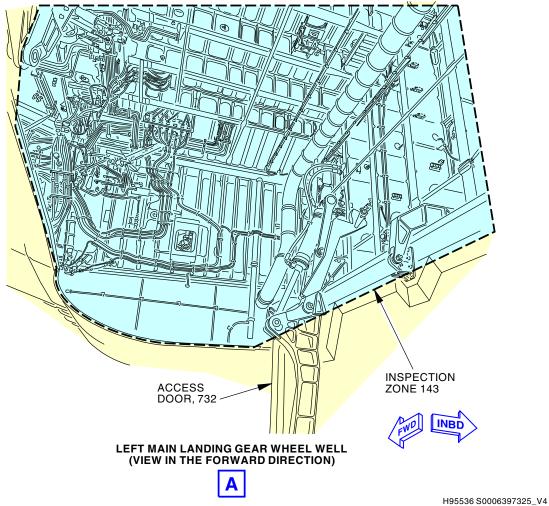
----- END OF TASK -----

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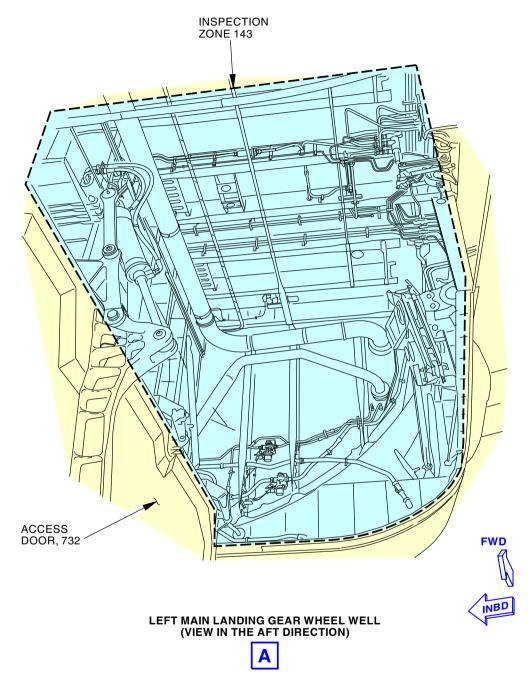
Left Main Landing Gear Wheel Well Figure 203/53-05-01-990-842 (Sheet 1 of 2)

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Left Main Landing Gear Wheel Well Figure 203/53-05-01-990-842 (Sheet 2 of 2)

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TASK 53-05-01-210-819

5. INTERNAL - GENERAL VISUAL: RIGHT MAIN LANDING GEAR WHEEL WELL

| A. | References | |
|----|--------------------------|--------------------------------------|
| | Reference | Title |
| | 51-05-01-210-804 | 777 Basic Task Description (P/B 201) |
| B. | Inspection | |
| | SUBTASK 53-05-01-210-019 | |

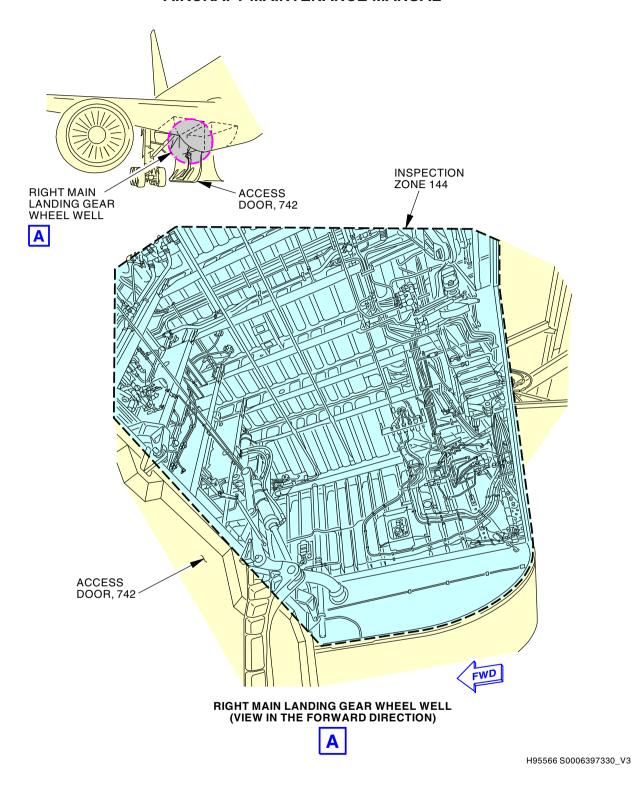
(1) Do the inspection 777 Basic Task Description, TASK 51-05-01-210-804.

——— END OF TASK ———

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53-05-01





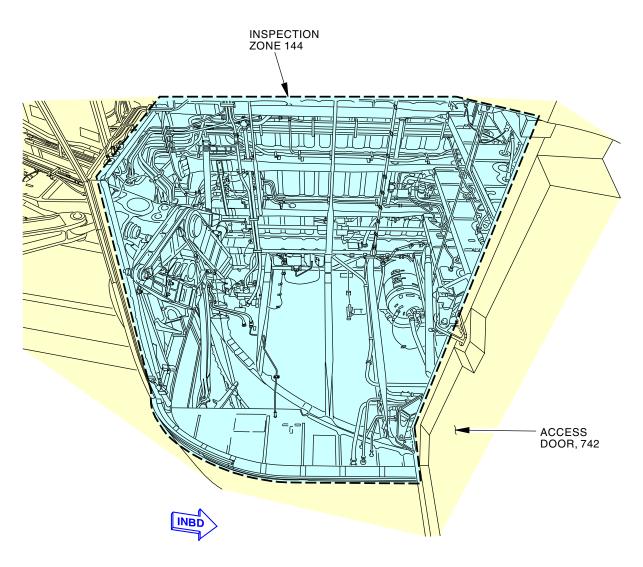
Wing Center Section Aft Bulkhead (Sta 1434) Figure 204/53-05-01-990-849 (Sheet 1 of 2)

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RIGHT MAIN LANDING GEAR WHEEL WELL (VIEW IN THE AFT DIRECTION)



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Wing Center Section Aft Bulkhead (Sta 1434) Figure 204/53-05-01-990-849 (Sheet 2 of 2)

ARO ALL

53-05-01

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TASK 53-05-01-210-822

SUBTASK 53-05-01-210-022

6. INTERNAL - GENERAL VISUAL: AREA BELOW AFT CARGO COMPARTMENT

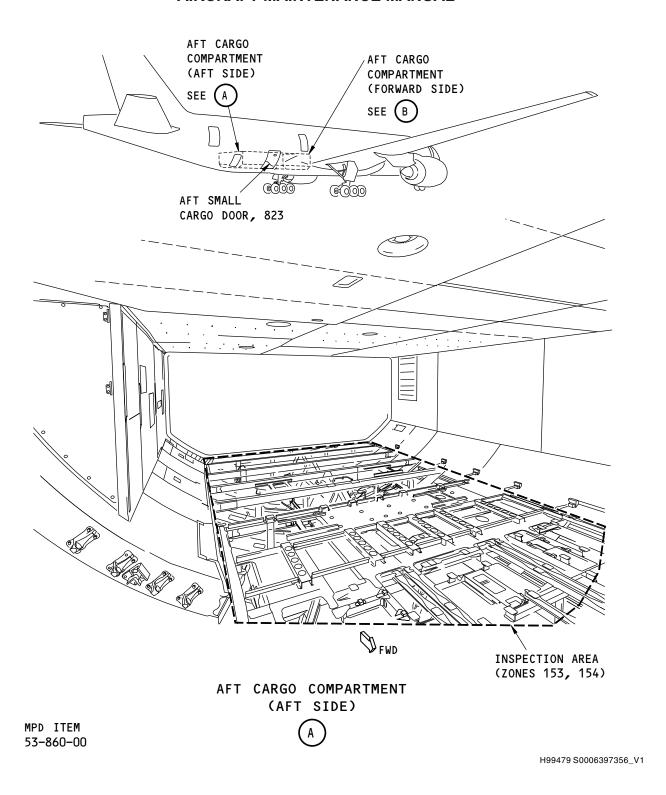
| A. | References | |
|----|------------------|--------------------------------------|
| | Reference | Title |
| | 51-05-01-210-803 | 777 Basic Task Description (P/B 201) |
| B. | Inspection | |

(1) Do the inspection 777 Basic Task Description, TASK 51-05-01-210-803.

----- END OF TASK -----

ARO ALL





Below The Aft Cargo Compartment (Floor Panels and Insulation Removed) Figure 205/53-05-01-990-854 (Sheet 1 of 2)

EFFECTIVITY

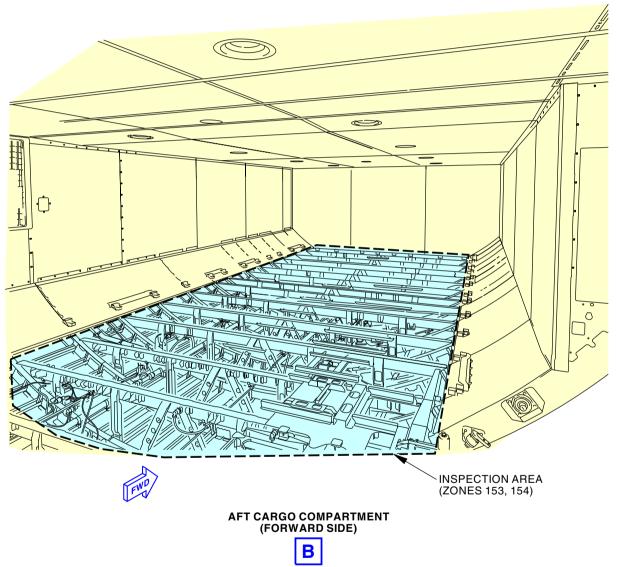
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Below The Aft Cargo Compartment (Floor Panels and Insulation Removed) Figure 205/53-05-01-990-854 (Sheet 2 of 2)

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TASK 53-05-01-210-823

7. INTERNAL - GENERAL VISUAL: LOWER FUSELAGE - SUBZONE 150 AND 160

<u>NOTE</u>: This procedure is a scheduled maintenance task.

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| Reference | Title |
|------------------|--------------------------------------|
| 51-05-01-210-803 | 777 Basic Task Description (P/B 201) |

B. Inspection

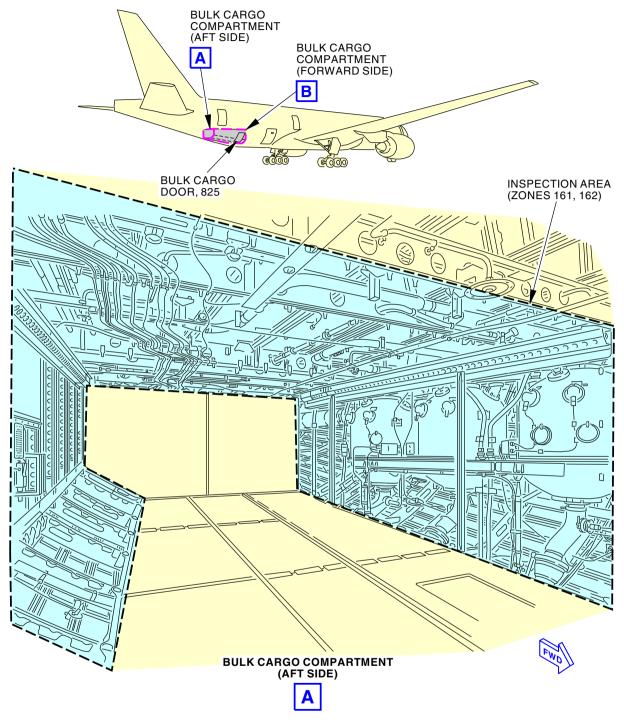
SUBTASK 53-05-01-210-023

(1) Do the inspection 777 Basic Task Description, TASK 51-05-01-210-803.

——— END OF TASK ———

ARO ALL





K02771 S0006397373_V4

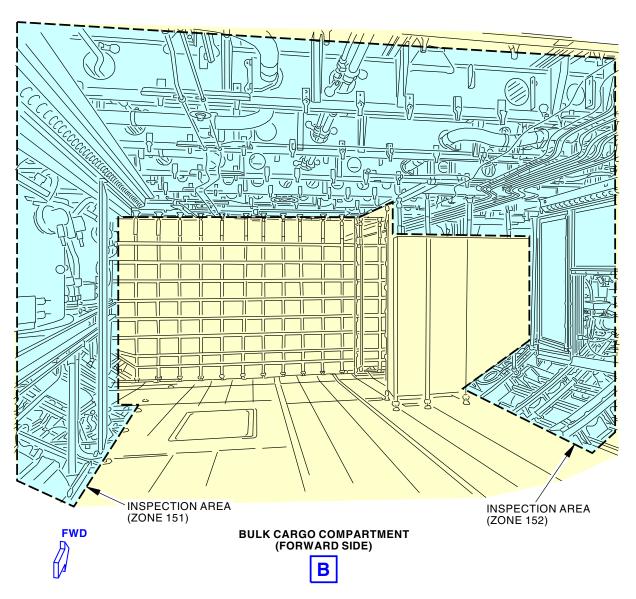
Bulk Cargo Compartment Figure 206/53-05-01-990-860 (Sheet 1 of 3)

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K02775 S0006397374_V4

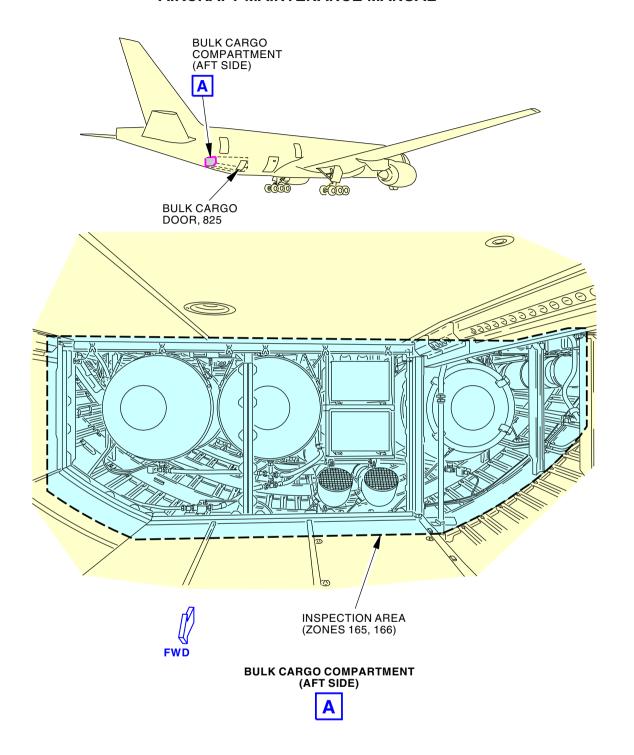
Bulk Cargo Compartment Figure 206/53-05-01-990-860 (Sheet 2 of 3)

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K02817 S0006397381_V3

Bulk Cargo Compartment Figure 206/53-05-01-990-860 (Sheet 3 of 3)

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TASK 53-05-01-210-825

8. EXTERNAL - GENERAL VISUAL: UNDERWING WING-TO-BODY FAIRING - LEFT

<u>NOTE</u>: This procedure is a scheduled maintenance task.

A. References

| Reference | Title |
|------------------|--------------------------------------|
| 51-05-01-210-804 | 777 Basic Task Description (P/B 201) |

B. Inspection

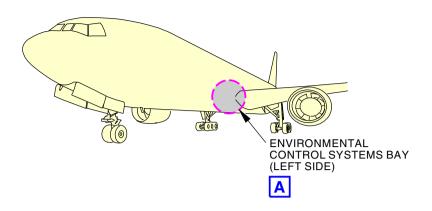
SUBTASK 53-05-01-210-025

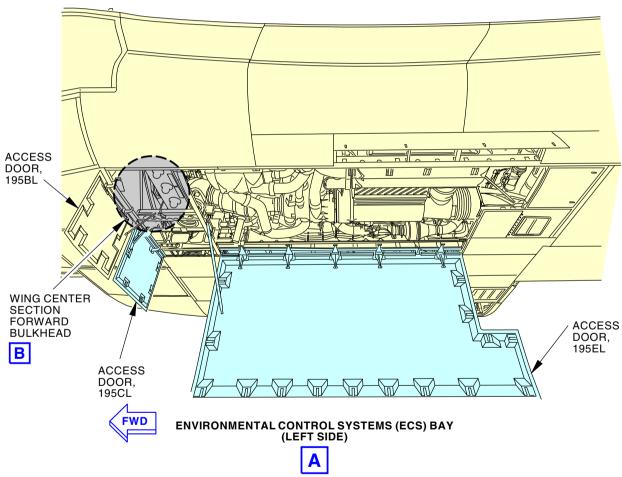
(1) Do the inspection 777 Basic Task Description, TASK 51-05-01-210-804.

——— END OF TASK ———

ARO ALL







W75365 S0000129860_V3

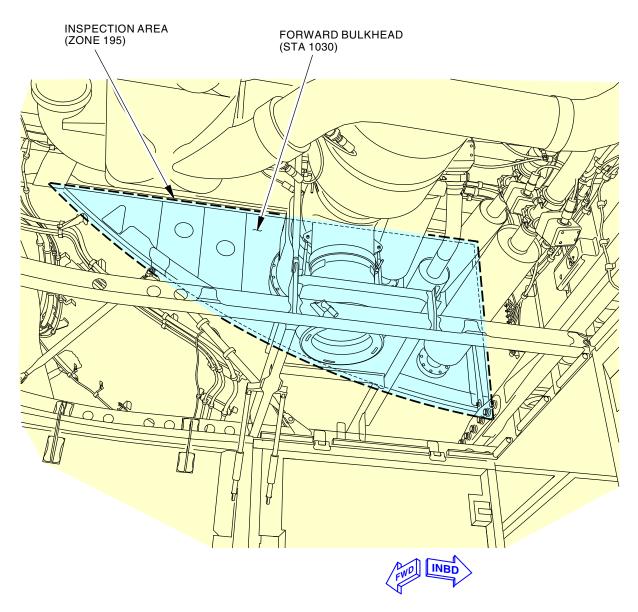
Underwing Wing -To-Body-Fairing Figure 207/53-05-01-990-862 (Sheet 1 of 2)

ARO ALL

53-05-01

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WING CENTER SECTION FORWARD BULKHEAD



W75367 S0000129861_V2

Underwing Wing -To-Body-Fairing Figure 207/53-05-01-990-862 (Sheet 2 of 2)

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D633W101-ARO

53-05-01

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TASK 53-05-01-210-826

9. EXTERNAL - GENERAL VISUAL: UNDERWING WING-TO-BODY FAIRING - RIGHT

NOTE: This procedure is a scheduled maintenance task.

A. References

| Reference | Title |
|------------------|--------------------------------------|
| 51-05-01-210-804 | 777 Basic Task Description (P/B 201) |

B. Inspection

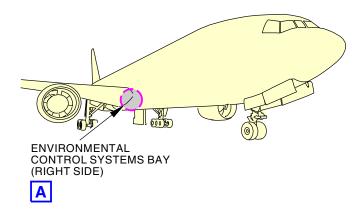
SUBTASK 53-05-01-210-026

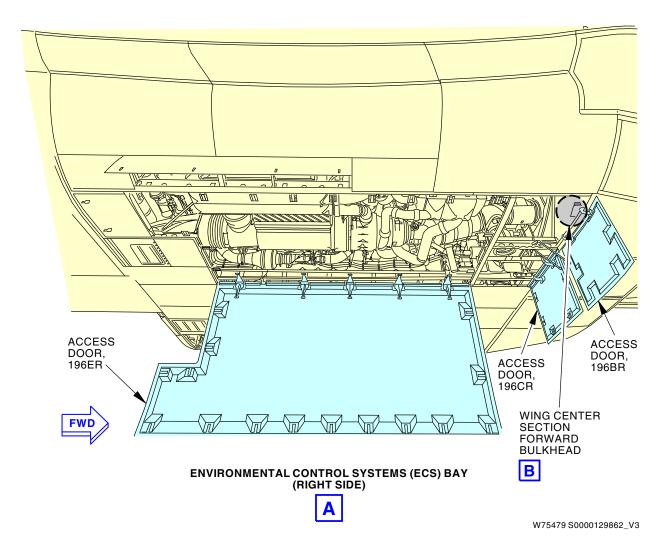
(1) Do the inspection 777 Basic Task Description, TASK 51-05-01-210-804.

——— END OF TASK ———

ARO ALL







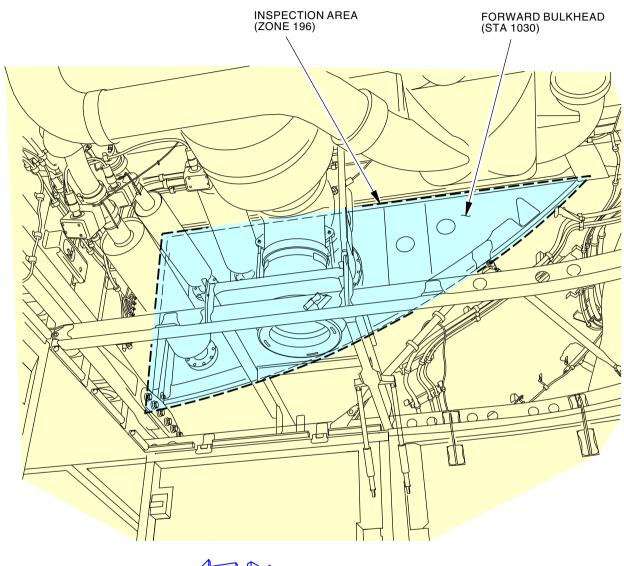
Underwing Wing-To-Body Fairing Figure 208/53-05-01-990-863 (Sheet 1 of 2)

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53-05-01

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WING CENTER SECTION FORWARD BULKHEAD



W75499 S0000129863_V2

Underwing Wing-To-Body Fairing Figure 208/53-05-01-990-863 (Sheet 2 of 2)

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D633W101-ARO

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TASK 53-05-01-210-828

10. INTERNAL - GENERAL VISUAL: SUBZONE BS 246 TO 655 - SECTION 41

NOTE: This procedure is a scheduled maintenance task.

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| 51-05-01-210-803 | 777 Basic Task Description (P/B 201) | |

B. Inspection

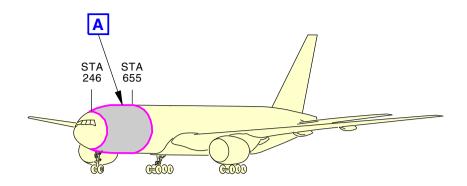
SUBTASK 53-05-01-210-028

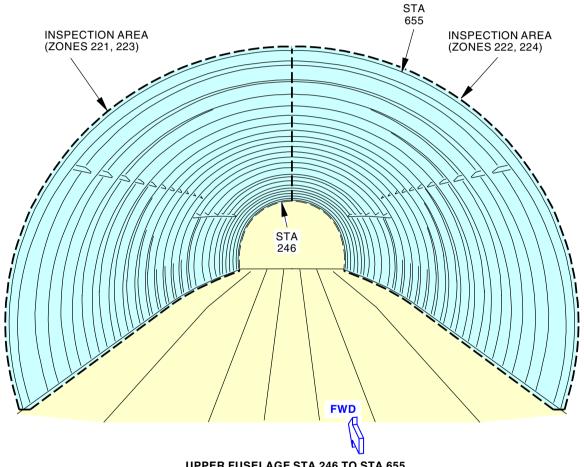
(1) Do the inspection 777 Basic Task Description, TASK 51-05-01-210-803.

----- END OF TASK -----

ARO ALL







UPPER FUSELAGE STA 246 TO STA 655 (CEILING PANELS, SIDEWALL PANELS AND INSULATION REMOVED) (VIEW IN THE FORWARD DIRECTION)



1301977 S0000223758_V3

Subzone BS 126.5 to 246 Figure 209/53-05-01-990-873

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53-05-01

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TASK 53-05-01-210-829

11. INTERNAL - GENERAL VISUAL: SUBZONE BS 655 TO 1035 - SECTION 43

NOTE: This procedure is a scheduled maintenance task.

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| 51-05-01-210-803 | 777 Basic Task Description (P/B 201) | |

B. Inspection

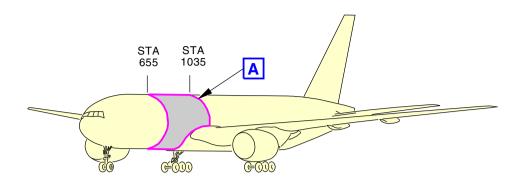
SUBTASK 53-05-01-210-029

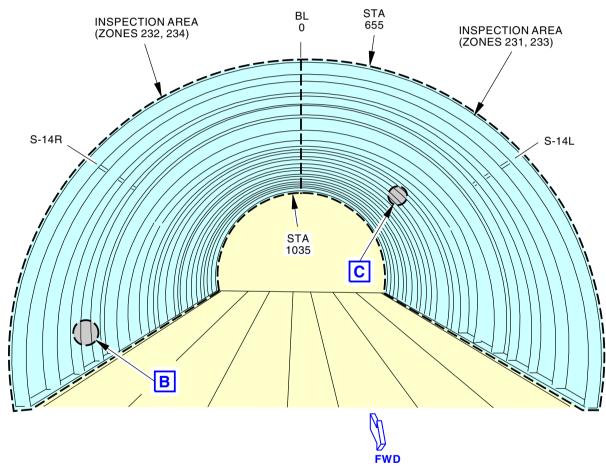
(1) Do the inspection 777 Basic Task Description, TASK 51-05-01-210-803.

----- END OF TASK -----

ARO ALL







(CEILINGS PANELS, SIDEWALL PANELS AND INSULATION REMOVED)



W76390 S0000130587_V3

Subzone Body Station 655 to 1035 (Section 43) Figure 210/53-05-01-990-869 (Sheet 1 of 2)

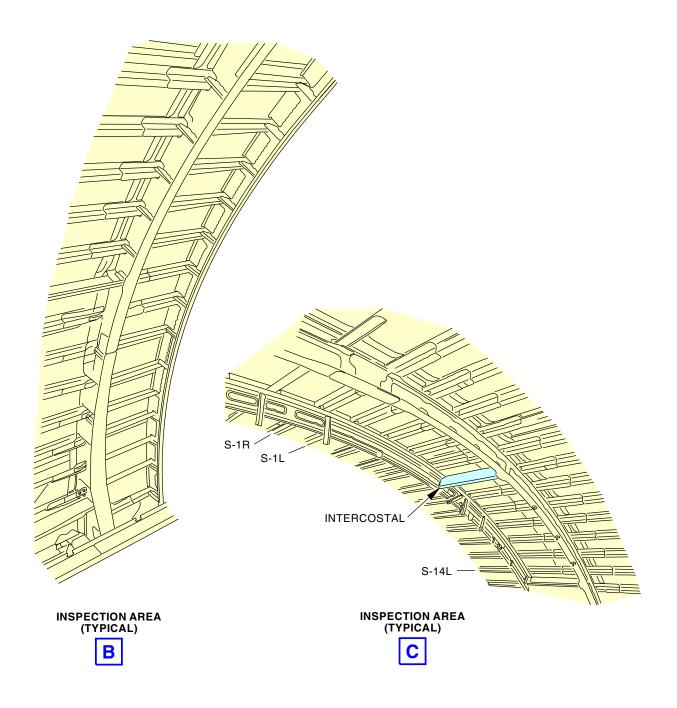
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W76864 S0000130586_V3

Subzone Body Station 655 to 1035 (Section 43) Figure 210/53-05-01-990-869 (Sheet 2 of 2)

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TASK 53-05-01-210-830

12. INTERNAL - GENERAL VISUAL: SUBZONE BS 1035 TO 1434 - SECTION 44

NOTE: This procedure is a scheduled maintenance task.

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| Reference | Title |
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| 51-05-01-210-803 | 777 Basic Task Description (P/B 201) |

B. Inspection

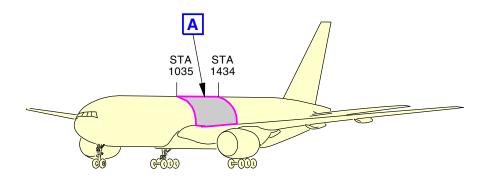
SUBTASK 53-05-01-210-030

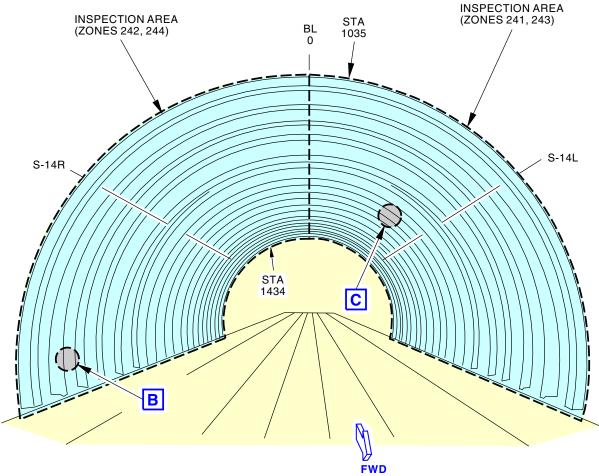
(1) Do the inspection 777 Basic Task Description, TASK 51-05-01-210-803.

——— END OF TASK ———

ARO ALL







(CEILINGS PANELS, SIDEWALL PANELS AND INSULATION REMOVED)



W76391 S0000130589_V3

Subzone Body Station 1035 to 1434 (Section 44) Figure 211/53-05-01-990-870 (Sheet 1 of 2)

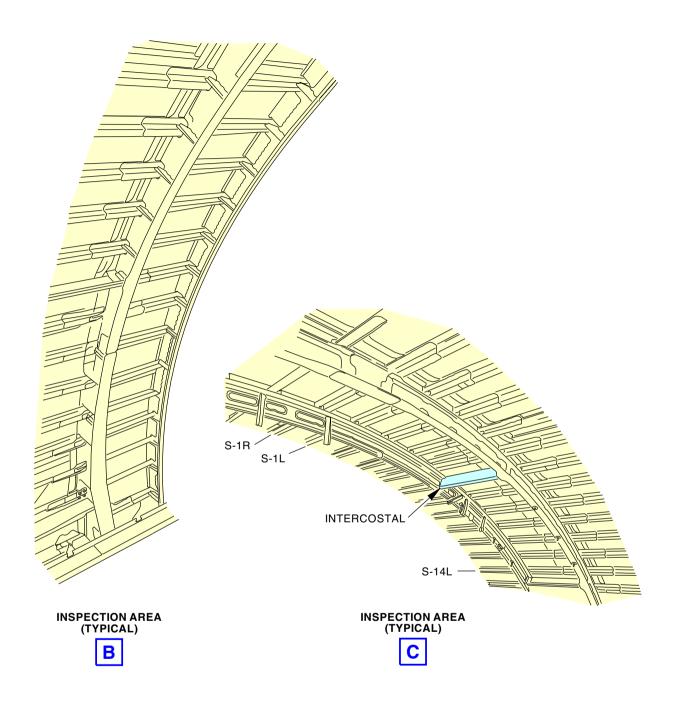
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W76864 S0000130586_V3

Subzone Body Station 1035 to 1434 (Section 44) Figure 211/53-05-01-990-870 (Sheet 2 of 2)

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TASK 53-05-01-210-831

13. INTERNAL - GENERAL VISUAL: SUBZONE BS 1434 TO 1832 - SECTION 46

NOTE: This procedure is a scheduled maintenance task.

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| Reference | Title | |
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| 51-05-01-210-803 | 777 Basic Task Description (P/B 201) | |

B. Inspection

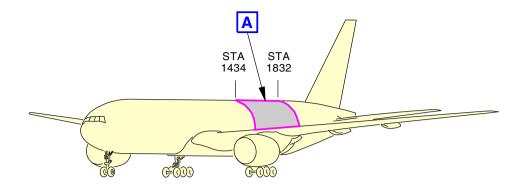
SUBTASK 53-05-01-210-031

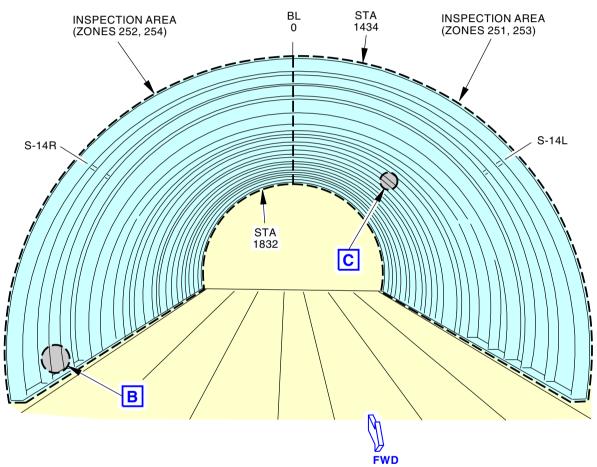
(1) Do the inspection 777 Basic Task Description, TASK 51-05-01-210-803.

——— END OF TASK ———

ARO ALL







(CEILINGS PANELS, SIDEWALL PANELS AND INSULATION REMOVED)



W76456 S0000130591_V3

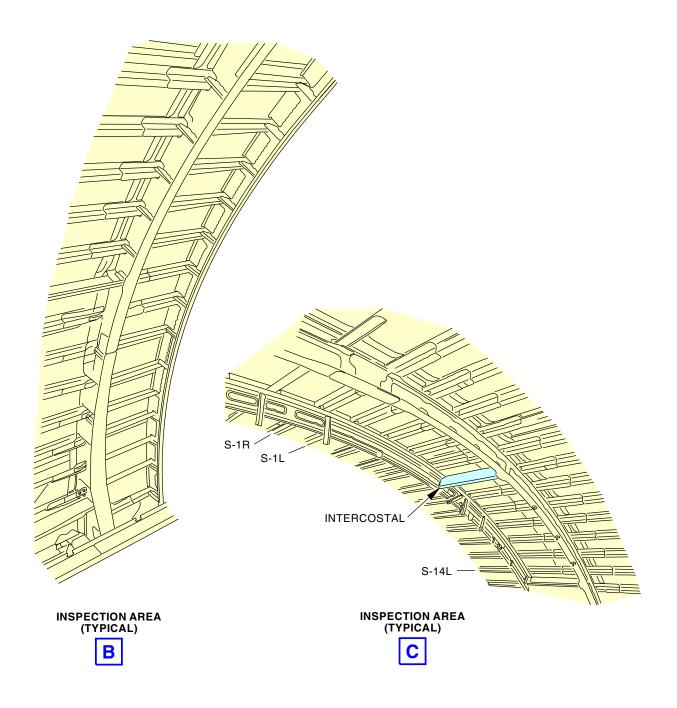
Subzone Body Station 1434 to 1832 (Section 46) Figure 212/53-05-01-990-871 (Sheet 1 of 2)

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W76864 S0000130586_V3

Subzone Body Station 1434 to 1832 (Section 46) Figure 212/53-05-01-990-871 (Sheet 2 of 2)

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TASK 53-05-01-210-832

14. INTERNAL - GENERAL VISUAL: SUBZONE BS 1832 TO 2195.75 - SECTION 47

NOTE: This procedure is a scheduled maintenance task.

A. References

 Reference
 Title

 51-05-01-210-803
 777 Basic Task Description (P/B 201)

B. Inspection

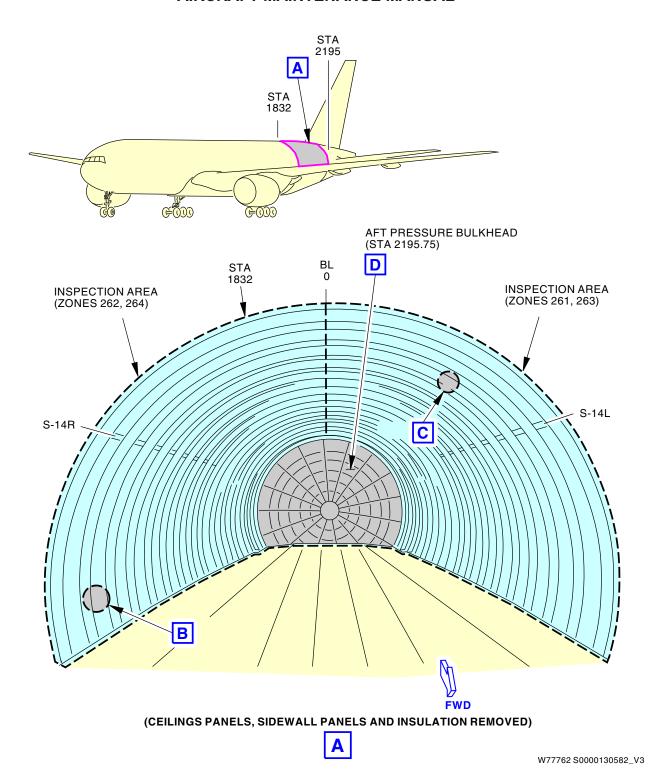
SUBTASK 53-05-01-210-032

(1) Do the inspection 777 Basic Task Description, TASK 51-05-01-210-803.

——— END OF TASK ———

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Subzone Body Station 1832 to 2195.75 (Section 47) Figure 213/53-05-01-990-867 (Sheet 1 of 3)

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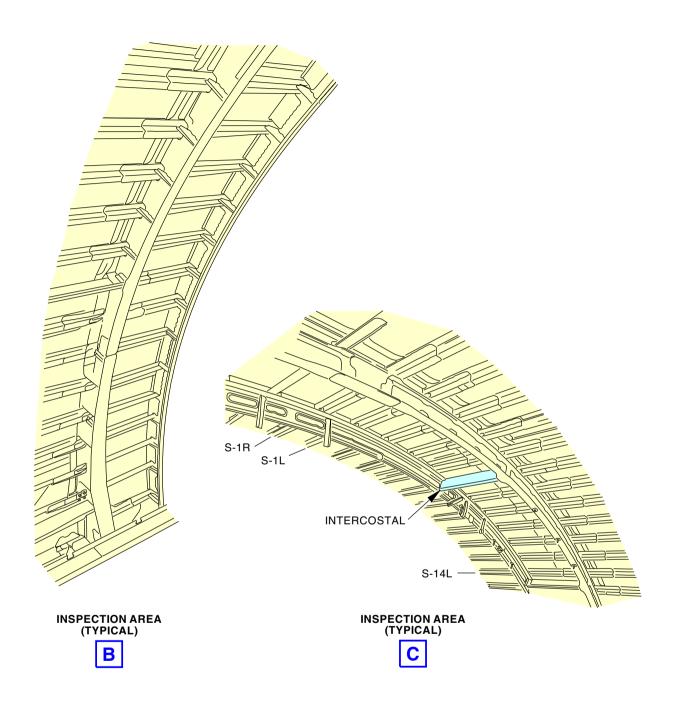
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W76864 S0000130586_V3

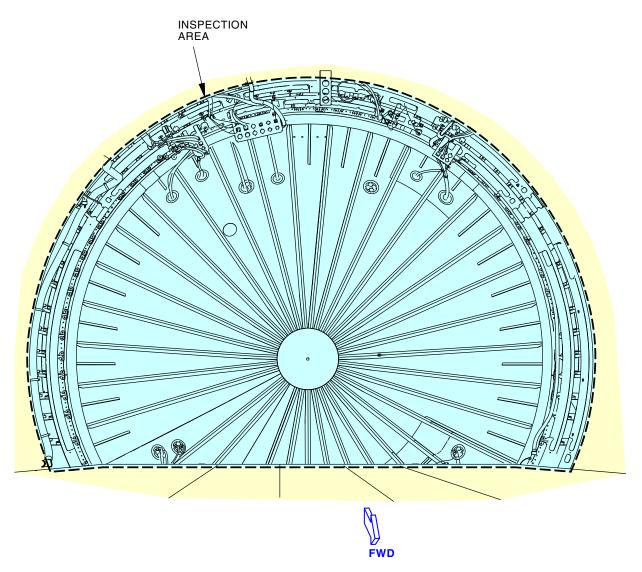
Subzone Body Station 1832 to 2195.75 (Section 47) Figure 213/53-05-01-990-867 (Sheet 2 of 3)

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AFT PRESSURE BULKHEAD (STA 2195.75)



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Subzone Body Station 1832 to 2195.75 (Section 47) Figure 213/53-05-01-990-867 (Sheet 3 of 3)

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FUSELAGE - STRUCTURAL INSPECTIONS - MAINTENANCE PRACTICES

- 1. General
 - A. This procedure contains MSG-3 task card data.

TASK 53-05-03-210-801

- 2. INTERNAL GENERAL VISUAL: AREA FORWARD OF NOSE LANDING GEAR WHEEL WELL (Figure 201)
 - A. Inspection

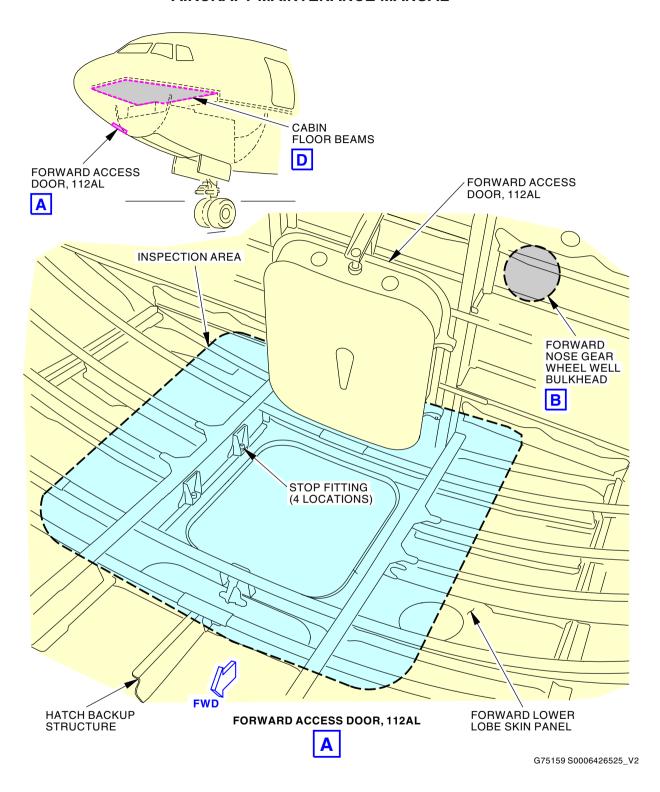
SUBTASK 53-05-03-210-001

(1) Do the inspection.

——— END OF TASK ———

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Area Forward of Nose Landing Gear Wheel Well General Visual (Internal) Figure 201/53-05-03-990-801 (Sheet 1 of 5)

EFFECTIVITY

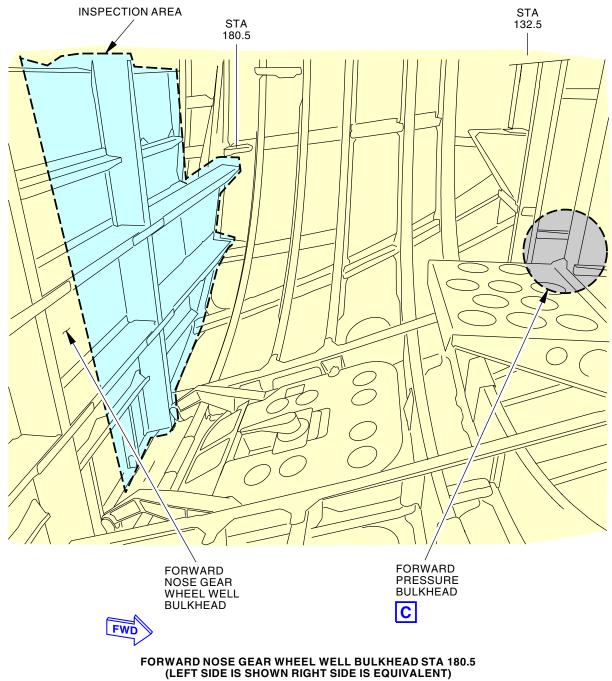
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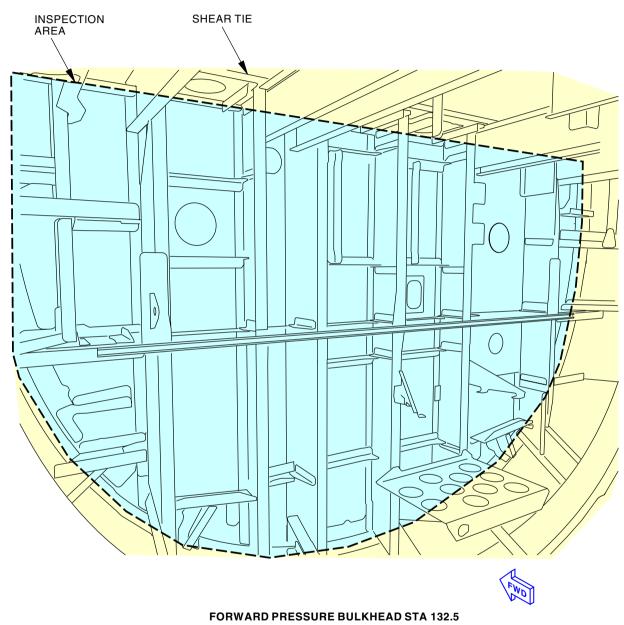
G75482 S0006426526_V2

Area Forward of Nose Landing Gear Wheel Well General Visual (Internal) Figure 201/53-05-03-990-801 (Sheet 2 of 5)

EFFECTIVITY · ARO ALL l D633W101-ARO 53-05-03

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G75390 S0006426527_V2

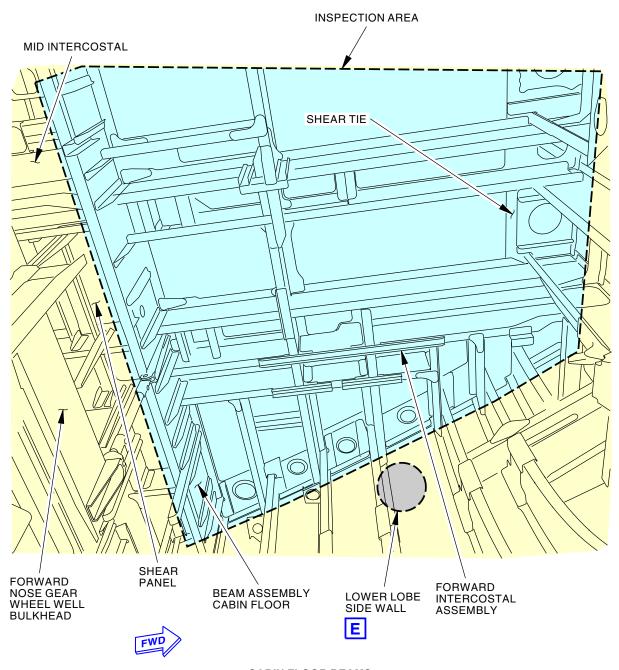
Area Forward of Nose Landing Gear Wheel Well General Visual (Internal) Figure 201/53-05-03-990-801 (Sheet 3 of 5)

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CABIN FLOOR BEAMS (LEFT SIDE IS SHOWN, RIGHT SIDE IS EQUIVALENT)



G76378 S0006426528_V2

Area Forward of Nose Landing Gear Wheel Well General Visual (Internal) Figure 201/53-05-03-990-801 (Sheet 4 of 5)

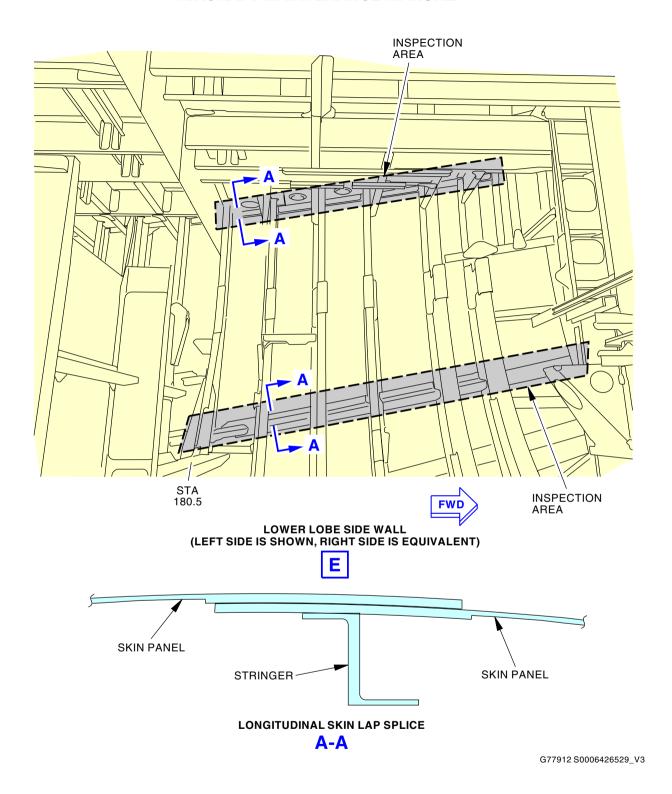
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Area Forward of Nose Landing Gear Wheel Well General Visual (Internal) Figure 201/53-05-03-990-801 (Sheet 5 of 5)

EFFECTIVITY

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TASK 53-05-03-210-802

3. INTERNAL - GENERAL VISUAL: AREA OUTBOARD AND ABOVE NOSE LANDING GEAR WHEEL WELL

(Figure 202, Figure 203 or Figure 204.)

A. Inspection

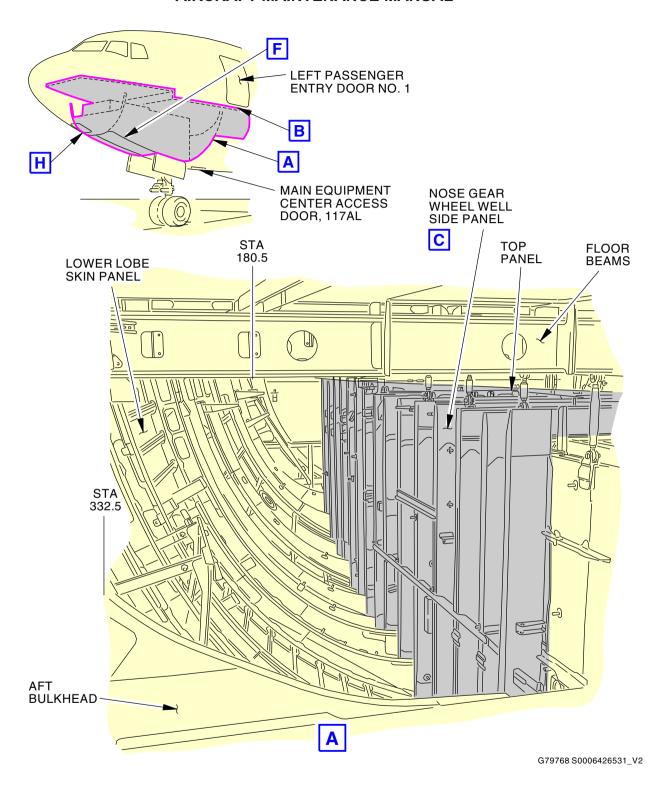
SUBTASK 53-05-03-210-002

(1) Do the inspection.

------ END OF TASK ------

ARO ALL





Area Outboard and Above Nose Landing Gear Wheel Well General Visual (Internal) Figure 202/53-05-03-990-802 (Sheet 1 of 5)

EFFECTIVITY

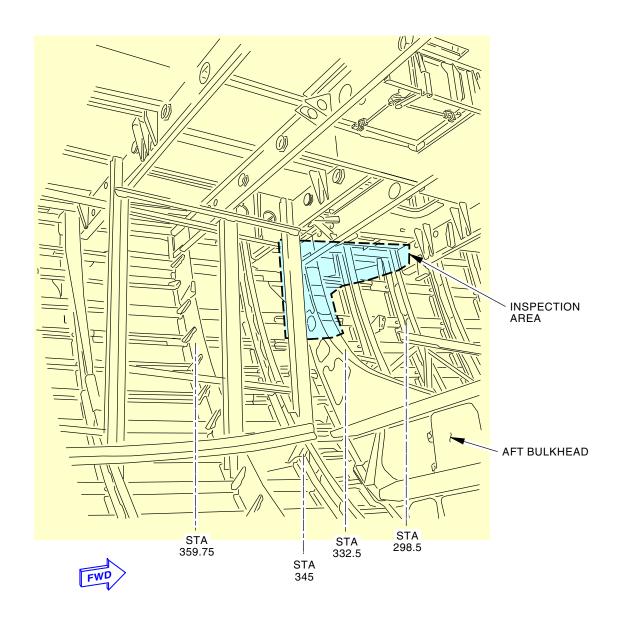
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CUTOUT STRUCTURE LEFT PASSENGER ENTRY DOOR NO. 1 (LOWER FORWARD CORNER) (LEFT SIDE IS SHOWN, RIGHT SIDE IS EQUIVALENT)



G82207 S0006426532_V3

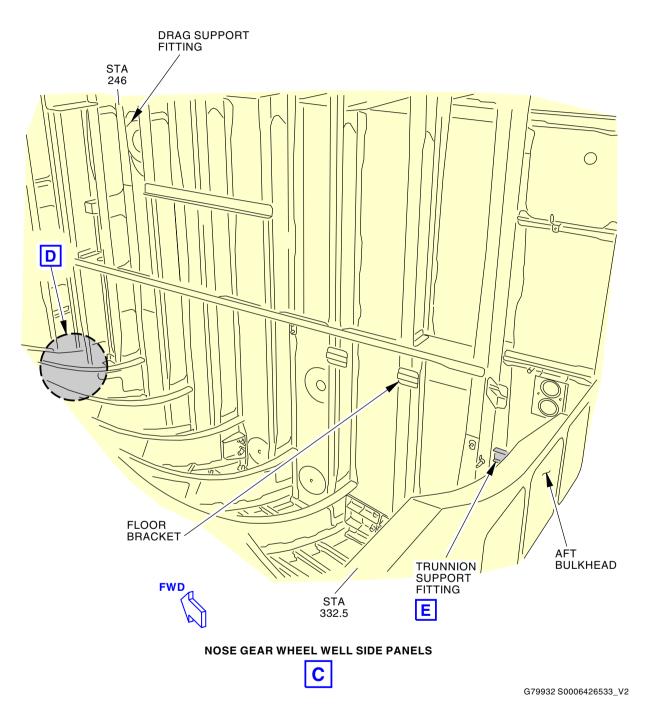
Area Outboard and Above Nose Landing Gear Wheel Well General Visual (Internal) Figure 202/53-05-03-990-802 (Sheet 2 of 5)

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53-05-03

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Area Outboard and Above Nose Landing Gear Wheel Well General Visual (Internal)

EFFECTIVITY

ARO ALL

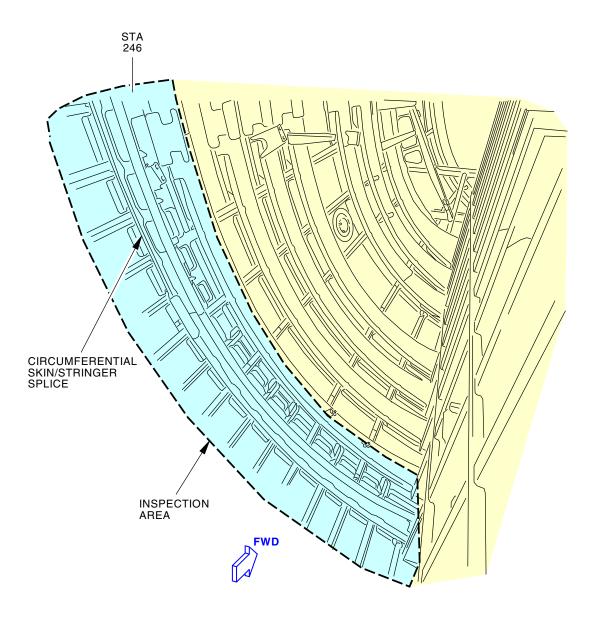
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Figure 202/53-05-03-990-802 (Sheet 3 of 5)





AREA OUTBOARD NOSE GEAR WHEEL WELL (LOWER FORWARD CORNER)



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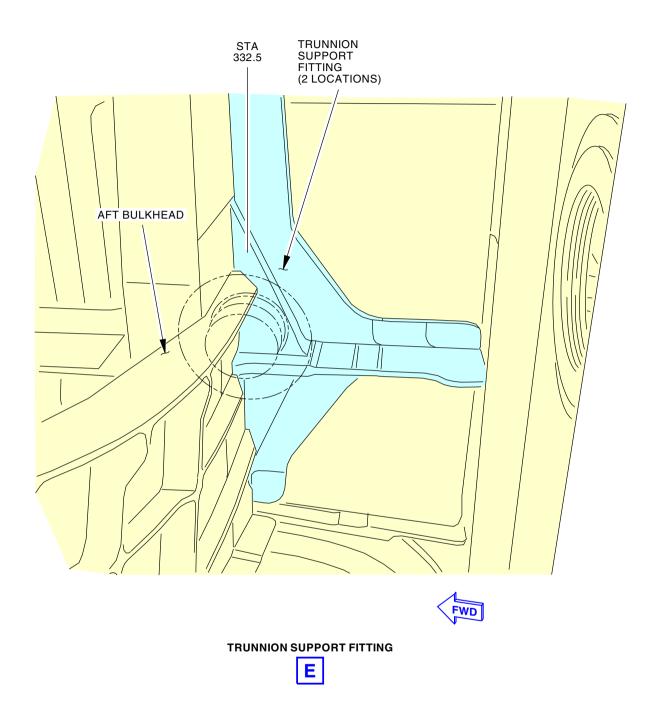
Area Outboard and Above Nose Landing Gear Wheel Well General Visual (Internal) Figure 202/53-05-03-990-802 (Sheet 4 of 5)

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53-05-03

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G82141 S0006426535_V2

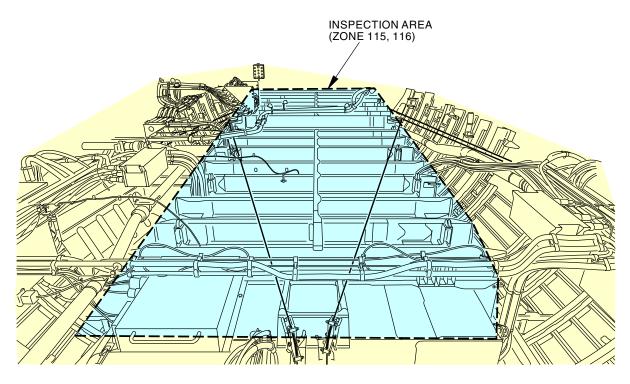
Area Outboard and Above Nose Landing Gear Wheel Well General Visual (Internal) Figure 202/53-05-03-990-802 (Sheet 5 of 5)

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ABOVE THE NOSE LANDING GEAR WHEEL WELL

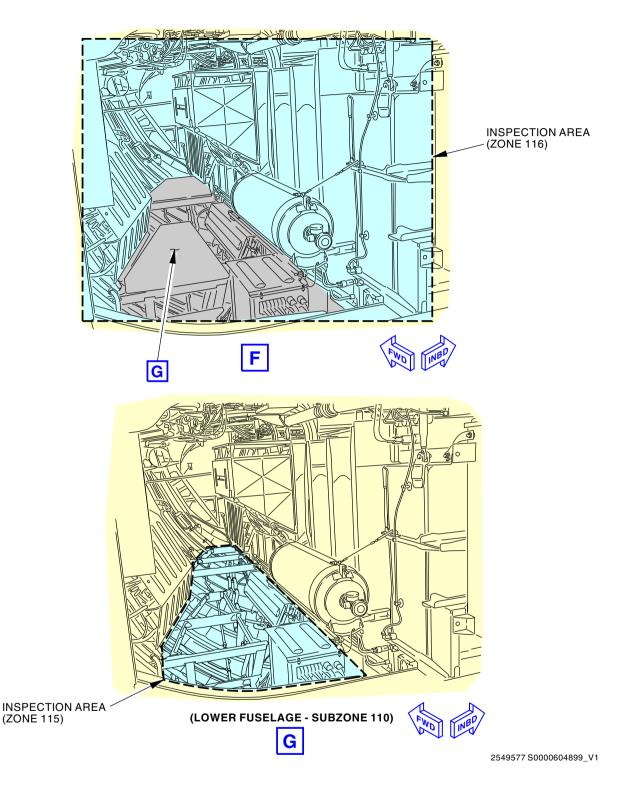


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Above and Outboard of the Nose Landing Gear Wheel Well General Visual (Internal) Figure 203/53-05-03-990-E85

ARO ALL





Above and Below the E/E Floor Level General Visual (Internal) Figure 204/53-05-03-990-E86 (Sheet 1 of 2)

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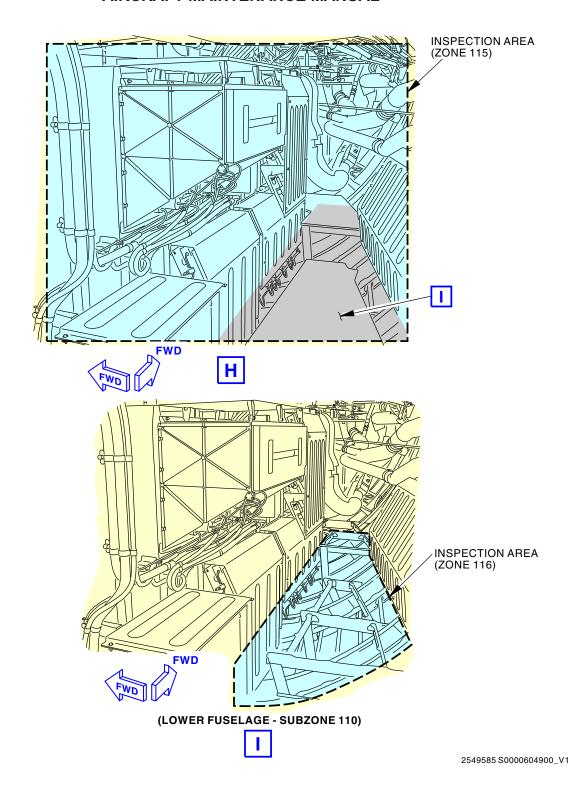
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Above and Below the E/E Floor Level General Visual (Internal) Figure 204/53-05-03-990-E86 (Sheet 2 of 2)

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TASK 53-05-03-211-801

4. INTERNAL - DETAILED: LEFT AREA OUTBOARD AND ABOVE NOSE LANDING GEAR WHEEL WELL

(Figure 205)

A. Inspection

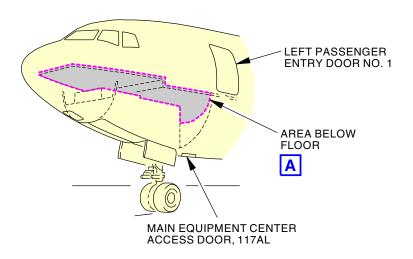
SUBTASK 53-05-03-211-001

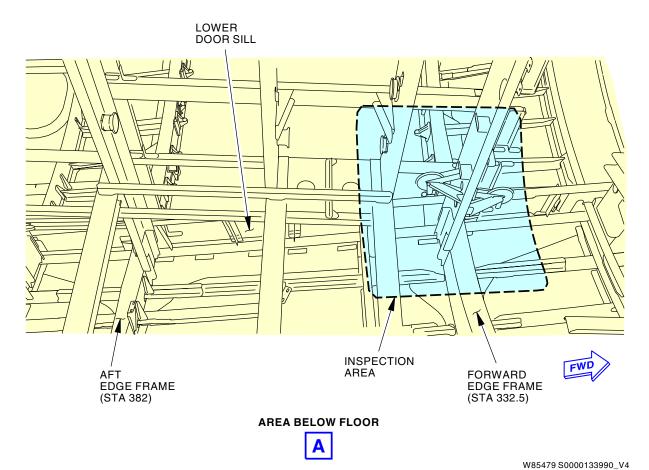
(1) Do the inspection.

——— END OF TASK ———

ARO ALL







Lower Door Sill and Edge Fame Interfaces Cutout Structure Left Passenger Entry Door No. 1 (Internal) Figure 205/53-05-03-990-903

EFFECTIVITY

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TASK 53-05-03-211-844

5. $\underline{\text{INTERNAL-DETAILED: RIGHT AREA OUTBOARD AND ABOVE NOSE LANDING GEAR WHEEL WELL}$

(Figure 206)

A. Inspection

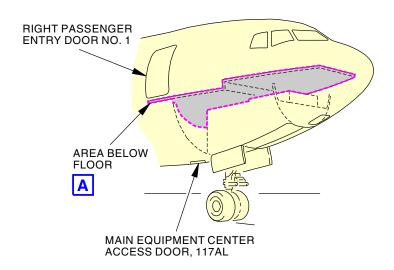
SUBTASK 53-05-03-211-043

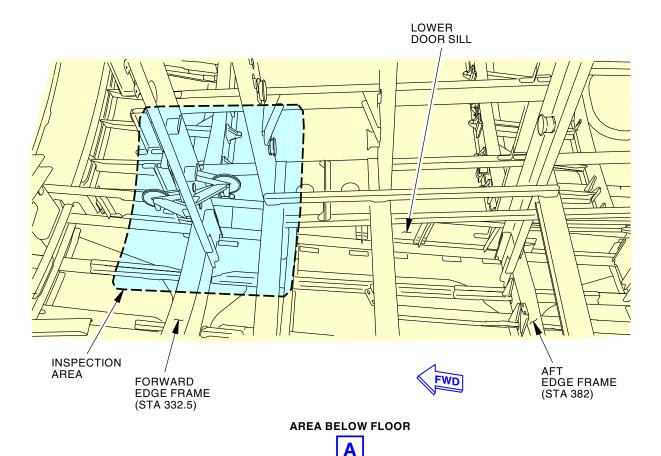
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







Lower Door SIII and Edge Frame Interfaces Figure 206/53-05-03-990-904

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TASK 53-05-03-211-802

6. INTERNAL - DETAILED: MAIN EQUIPMENT CENTER

(Figure 207)

A. Inspection

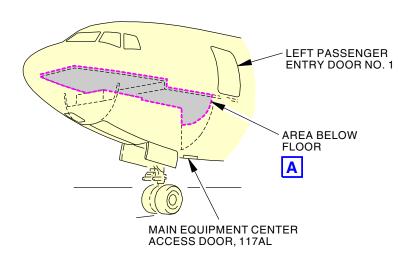
SUBTASK 53-05-03-211-002

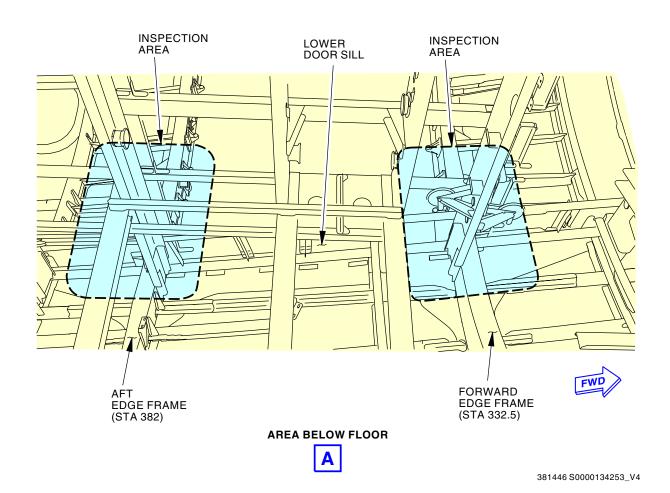
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







Lower Door Sill and Edge Frame Interfaces Cutout Structure Left Passenger Entry Door No. 1 (Internal) Figure 207/53-05-03-990-906

EFFECTIVITY

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TASK 53-05-03-211-803

7. INTERNAL - DETAILED: MAIN EQUIPMENT CENTER

(Figure 208)

A. Inspection

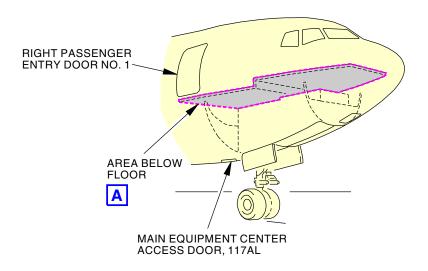
SUBTASK 53-05-03-211-003

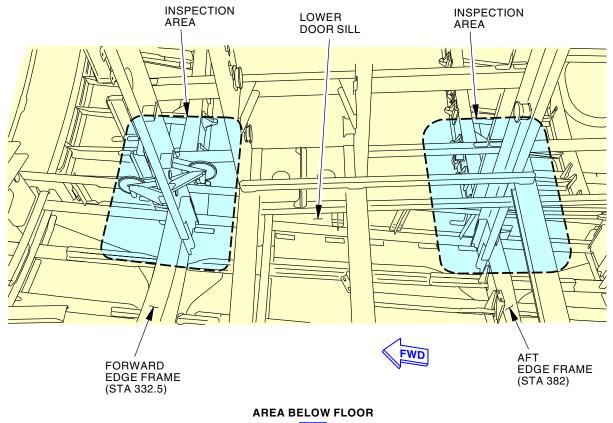
(1) Do the inspection.

----- END OF TASK -----

ARO ALL









381441 S0000134276_V4

Lower Door Sill and Edge Frame Interfaces Cut out Structure Right Passenger Entry Door No. 1
(Internal)
Figure 208/53-05-03-990-908

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TASK 53-05-03-210-804

8. INTERNAL - GENERAL VISUAL: MAIN EQUIPMENT CENTER (Figure 209)

A. Inspection

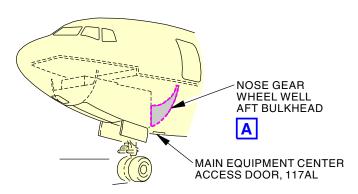
SUBTASK 53-05-03-210-004

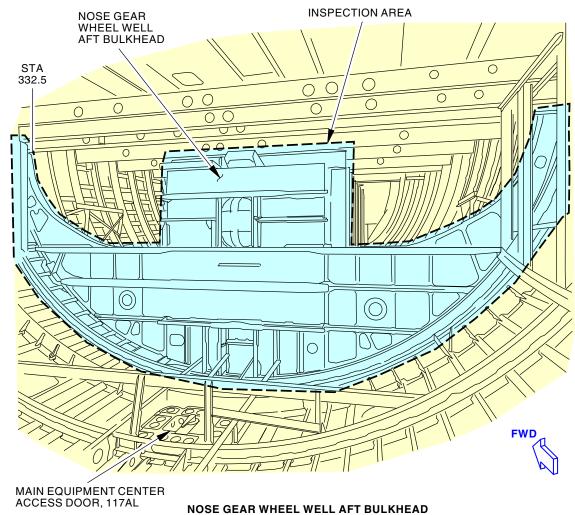
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







Area Aft of Nose Landing Gear Wheel Well General Visual (Internal) Figure 209/53-05-03-990-804

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TASK 53-05-03-210-875

9. INTERNAL - GENERAL VISUAL: MAIN EQUIPMENT CENTER

(Figure 210, Figure 211, Figure 212)

A. Inspection

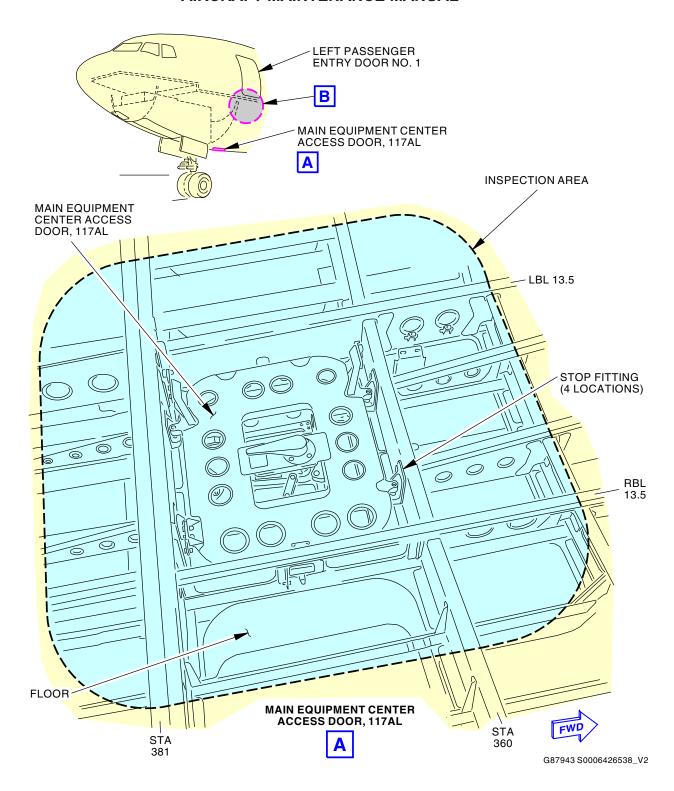
SUBTASK 53-05-03-210-072

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Lower Skin Panels Main Equipment Center General Visual (Internal) Figure 210/53-05-03-990-907 (Sheet 1 of 3)

EFFECTIVITY

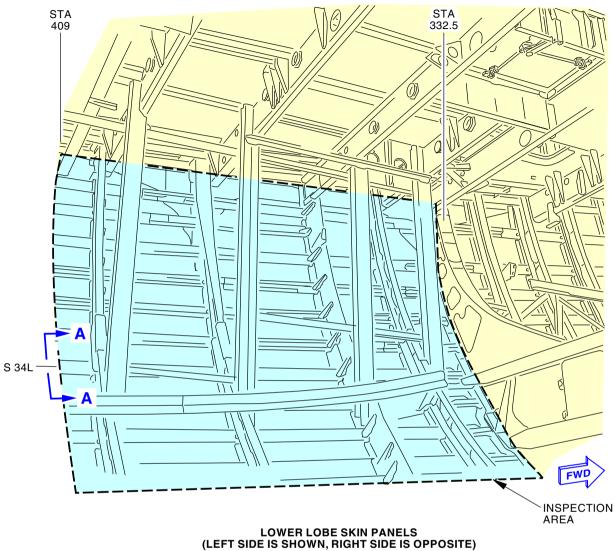
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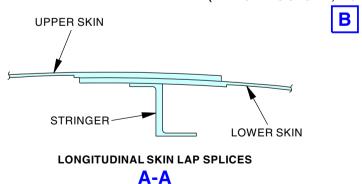
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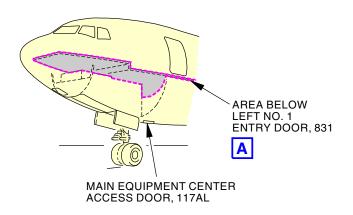
Lower Skin Panels Main Equipment Center General Visual (Internal) Figure 210/53-05-03-990-907 (Sheet 2 of 3)

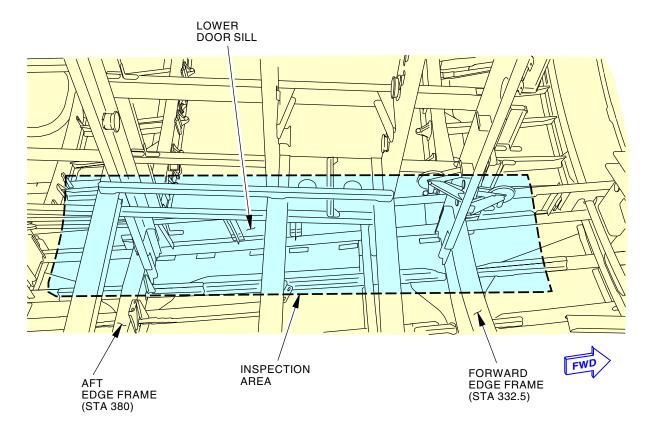
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AREA BELOW LEFT NO. 1 ENTRY DOOR, 831 (AREA BELOW RIGHT ENTRY DOOR, 841 IS OPPOSITE)



380684 S0000134249_V2

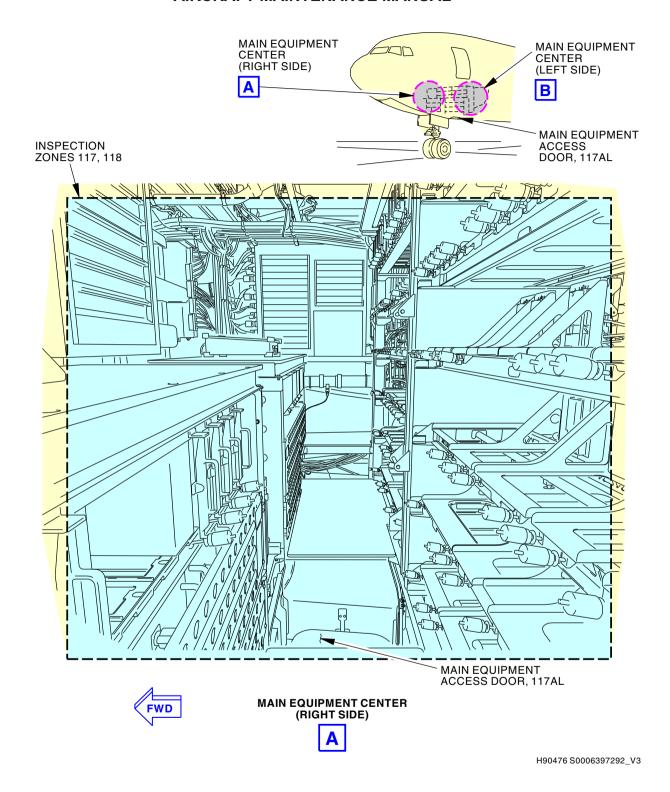
Lower Skin Panels Main Equipment Center General Visual (Internal) Figure 210/53-05-03-990-907 (Sheet 3 of 3)

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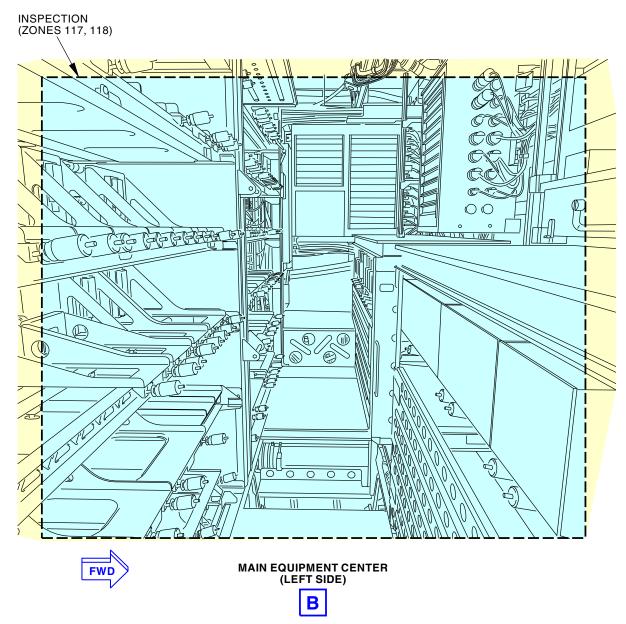
Main Equipment Center General Visual (Internal) Figure 211/53-05-03-990-E83 (Sheet 1 of 2)

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H90494 S0006397293_V3

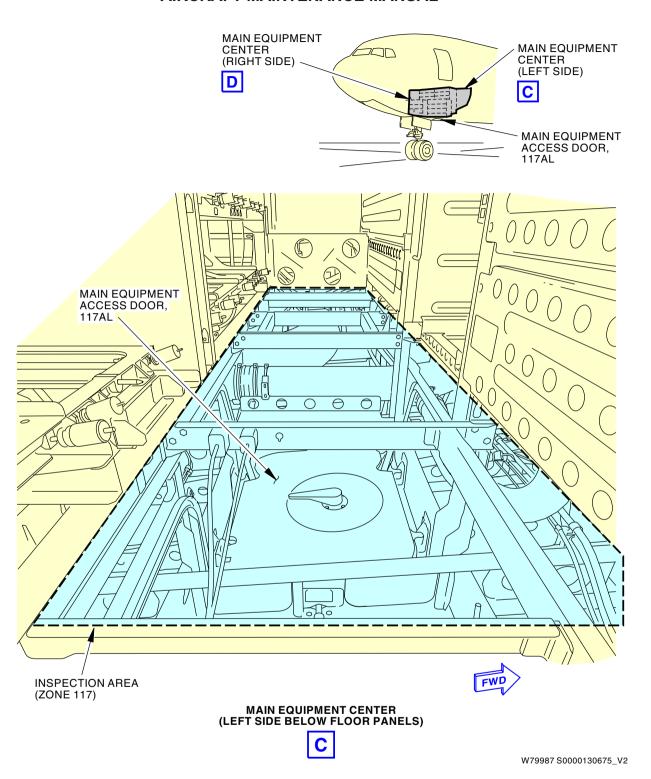
Main Equipment Center General Visual (Internal) Figure 211/53-05-03-990-E83 (Sheet 2 of 2)

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Lower Fuselage - Subzone 110 (Internal) Figure 212/53-05-03-990-E84 (Sheet 1 of 2)

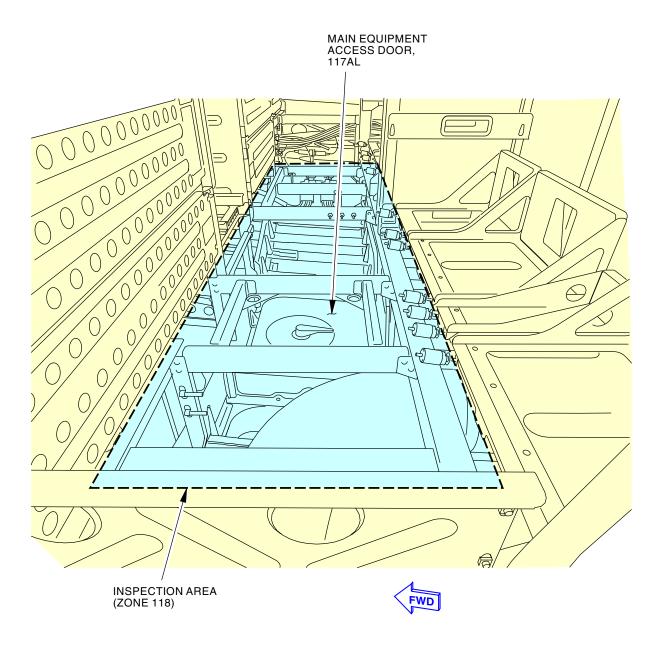
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MAIN EQUIPMENT CENTER (RIGHT SIDE BELOW FLOOR PANELS)



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Lower Fuselage - Subzone 110 (Internal) Figure 212/53-05-03-990-E84 (Sheet 2 of 2)

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TASK 53-05-03-210-905

- **10.** EXTERNAL GENERAL VISUAL: FORWARD CARGO COMPARTMENT (Figure 213)
 - A. Inspection

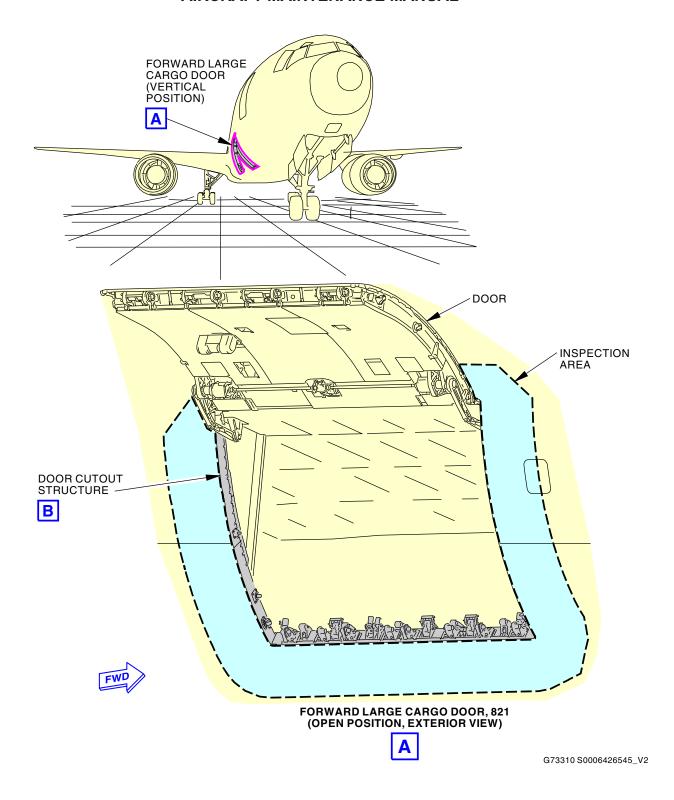
SUBTASK 53-05-03-210-125

(1) Do the inspection.

----- END OF TASK -----

ARO ALL



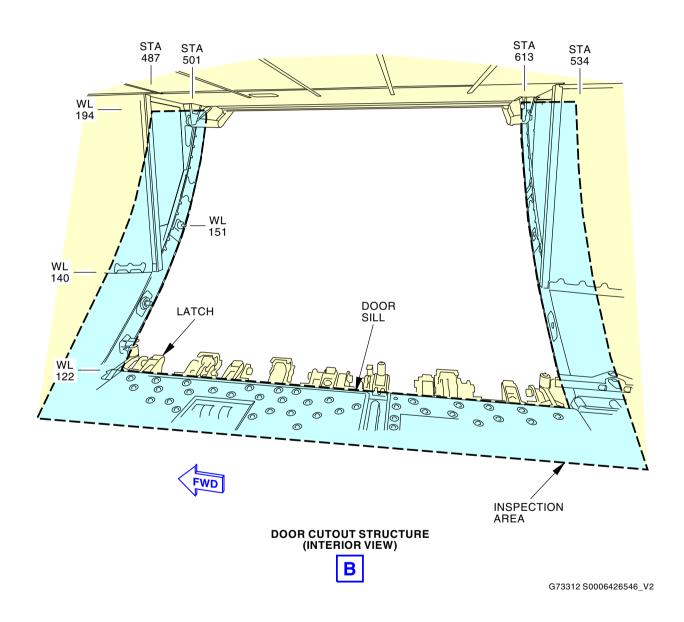


Forward Large Cargo Door General Visual (External) Figure 213/53-05-03-990-984 (Sheet 1 of 2)

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Forward Large Cargo Door General Visual (External) Figure 213/53-05-03-990-984 (Sheet 2 of 2)

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TASK 53-05-03-211-804

11. INTERNAL - DETAILED: FORWARD CARGO COMPARTMENT

(Figure 214)

A. Inspection

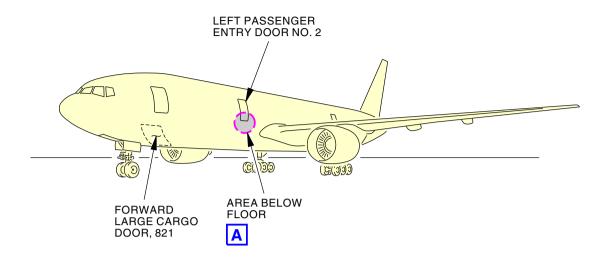
SUBTASK 53-05-03-211-004

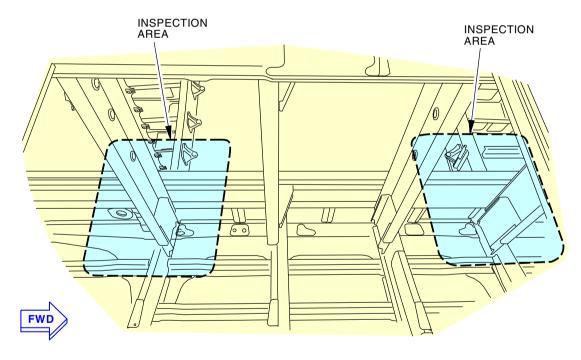
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







AREA BELOW FLOOR



G74235 S0006426548_V3

Sill and Edge Frames Left Passenger Entry Door 2 (Internal) Figure 214/53-05-03-990-806

EFFECTIVITY

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TASK 53-05-03-211-805-005

12. INTERNAL - DETAILED: FORWARD CARGO COMPARTMENT — 300ER

A. Job Set-up

SUBTASK 53-05-03-010-048

- (1) Open access panels, reference Figure 215, Figure 216, Figure 217, Figure 218, Figure 219, Figure 220
- B. Inspection

SUBTASK 53-05-03-211-087

- (1) Do the inspection.
- C. Job Close-up

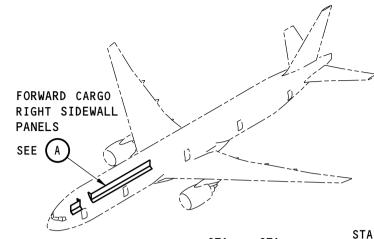
SUBTASK 53-05-03-410-048

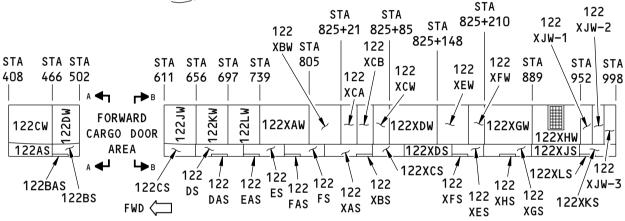
(1) Close access panels, reference Figure 215, Figure 216, Figure 217, Figure 218, Figure 219, Figure 220

----- END OF TASK -----

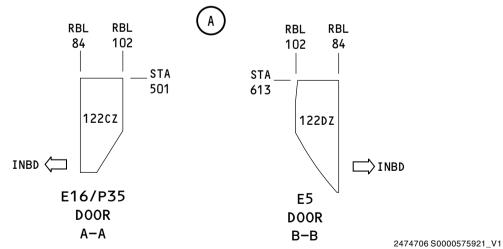
ARO ALL 53-05-03







(VIEW IN THE OUTBOARD DIRECTION) (777-300ER WITH NITROGEN GENERATION SYSTEM)



ZONE 122 FORWARD CARGO BAY SIDEWALL/BULKHEAD ACCESS PANELS W / NGS Figure 215/53-05-03-990-B43

EFFECTIVITY

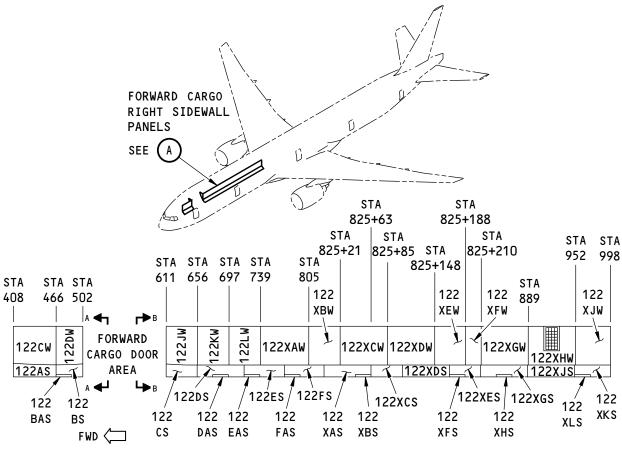
ARO ALL

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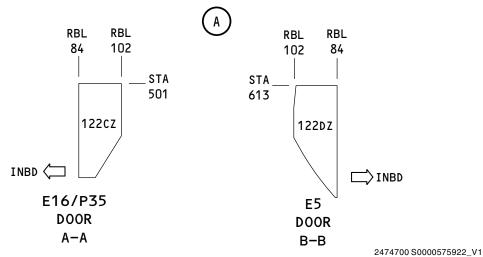
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(VIEW IN THE OUTBOARD DIRECTION)
(777-300ER WITHOUT NITROGEN GENERATION SYSTEM)



ZONE 122 FORWARD CARGO BAY SIDEWALL/BULKHEAD ACCESS PANELS W/O NGS Figure 216/53-05-03-990-B44

EFFECTIVITY

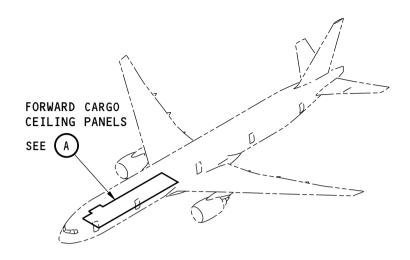
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| TA 09 | ST 50 | | ST 61 | | ΓΑ 97 | | S1 80 | | | | та +189 | S1 90 | | TA 98 |
|------------|----------|------------|--------------|---------|----------|------------|----------|----------|---|-------------|----------------|----------|---------|----------|
| 122AC | 0 | 122BC | | 122DC ° | | 122EC | 0 | 122XAC 。 | , | 122XBC | _122XCC | | 122GC | |
| 121AC° | | 121cc º | | 121EC | | °121 | GC | 121XAC ° | | 121XCC | 121XEC° | | 121LC | |
| ° 121BC | 0 | 0 121DC | | ° 121FC | | ° 121HC | 0 | 121XBC ° | , | ° 121XDC | ° ° 121XFC | | ° 121MC | |

FWD 📛

(VIEW IN THE DOWN DIRECTION) (777-300ER)



2474690 S0000575923_V1

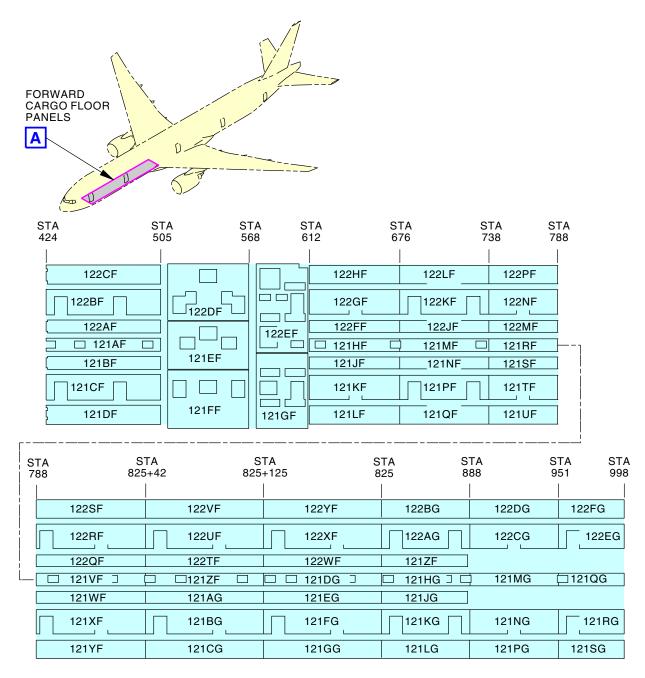
ZONE 121/122 FORWARD CARGO BAY CEILING PANELS Figure 217/53-05-03-990-B45

ARO ALL

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(VIEW IN THE DOWN DIRECTION) (777-300ER)



2474689 S0000575924_V2

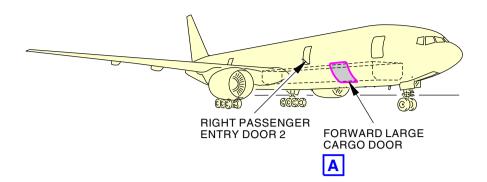
ZONE 121/122 FORWARD CARGO BAY FLOOR ACCESS PANELS Figure 218/53-05-03-990-B46

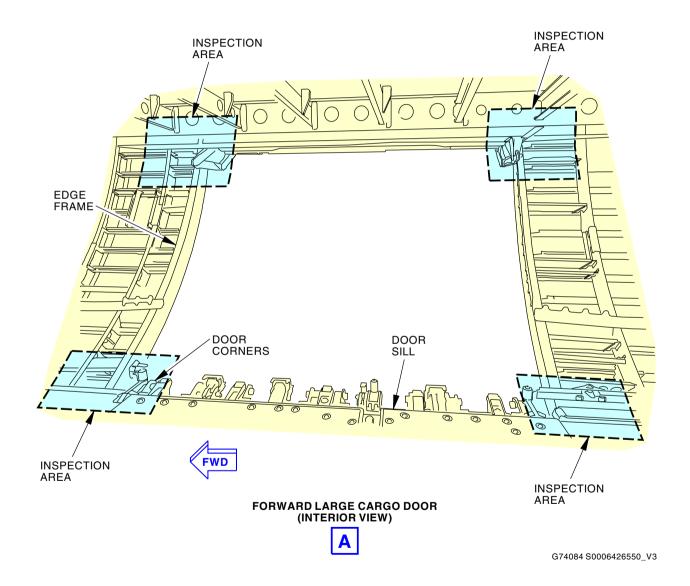
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Edge Frames and Corners Forward Large Cargo Door (Internal) Figure 219/53-05-03-990-B47

EFFECTIVITY

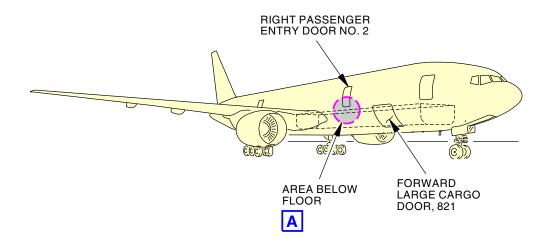
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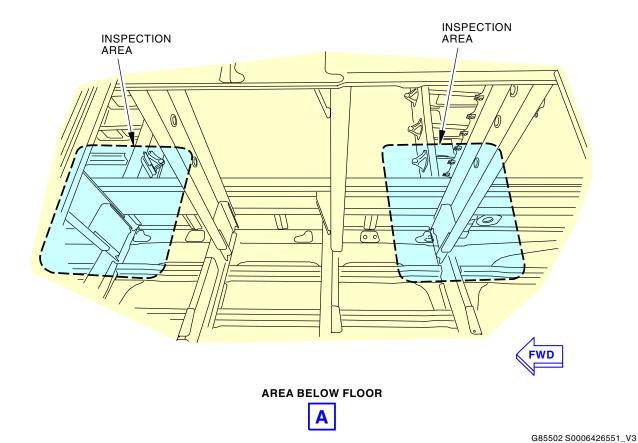
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Sill and Edge Frames Right Passenger Entry Door 2 (Internal) Figure 220/53-05-03-990-B48

EFFECTIVITY

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TASK 53-05-03-210-806

13. EXTERNAL - GENERAL VISUAL: AREA BELOW FORWARD CARGO COMPARTMENT (Figure 221)

A. Inspection

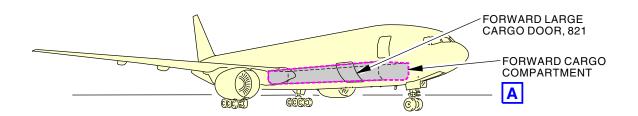
SUBTASK 53-05-03-210-006

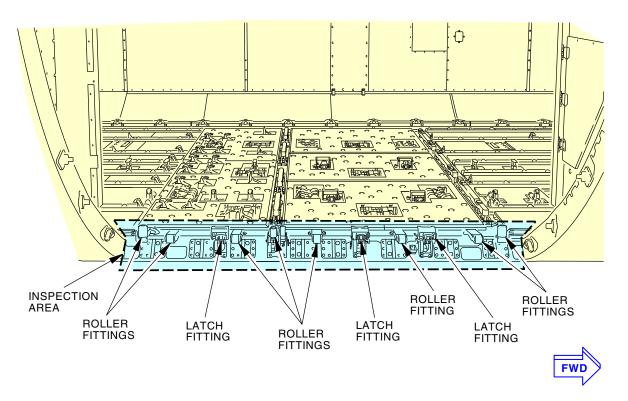
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







FORWARD CARGO COMPARTMENT



G73591 S0006426553_V4

Forward Cargo Door Below Floor Cutout Latch and Backup Structure Figure 221/53-05-03-990-809

EFFECTIVITY · ARO ALL l D633W101-ARO

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TASK 53-05-03-211-806

14. INTERNAL - GENERAL VISUAL: AREA BELOW FORWARD CARGO COMPARTMENT (Figure 222)

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|-------------|------|------|------|
| Α. | Inc | pect | tion |
| / \. | 1113 | | |

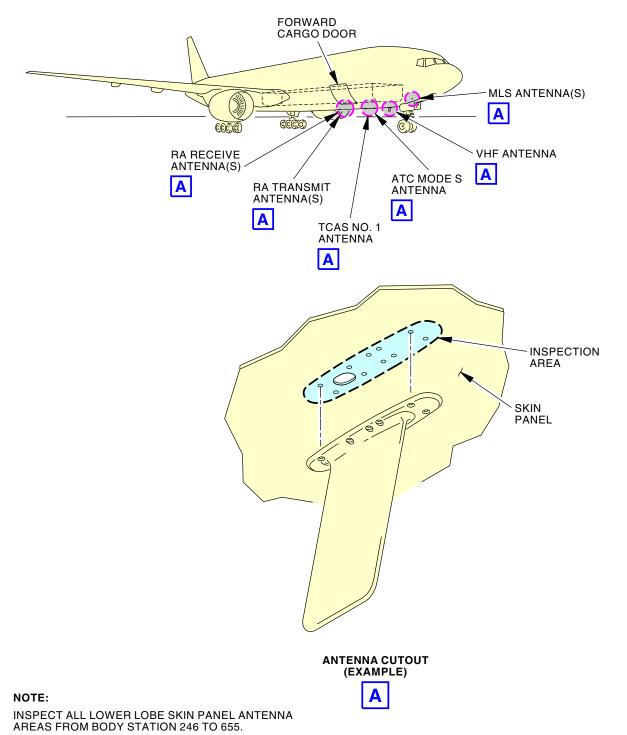
SUBTASK 53-05-03-211-006

(1) Do the inspection.

——— END OF TASK ———

ARO ALL





G73680 S0006426555_V6

Forward Cargo Lower Lobe Skin Panel Figure 222/53-05-03-990-810

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TASK 53-05-03-211-807-006

15. INTERNAL - DETAILED: AREA BELOW FORWARD CARGO COMPARTMENT —300ER

A. Job Set-up

SUBTASK 53-05-03-010-122

(1) Open access panels. Figure 224, Figure 225, Figure 226.

B. Inspection

SUBTASK 53-05-03-211-111

(1) Do the inspection. Figure 223.

C. Job Close-up

SUBTASK 53-05-03-410-122

(1) Close access panels. Figure 224, Figure 225, Figure 226.

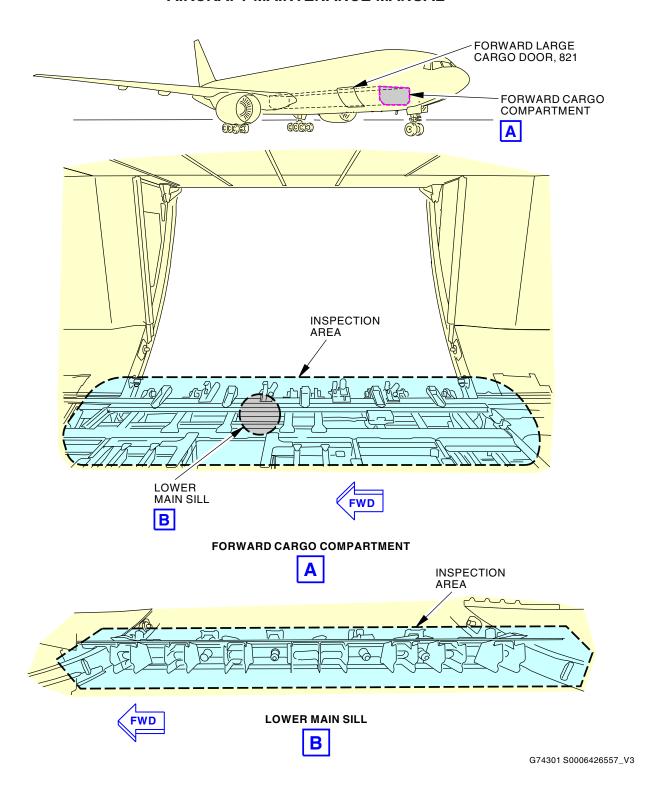
— END OF TASK ———

- EFFECTIVITY -ARO ALL

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Below Floor Cutout, Latch and Backup Structure Forward Large Cargo Door (Internal) Figure 223/53-05-03-990-E42

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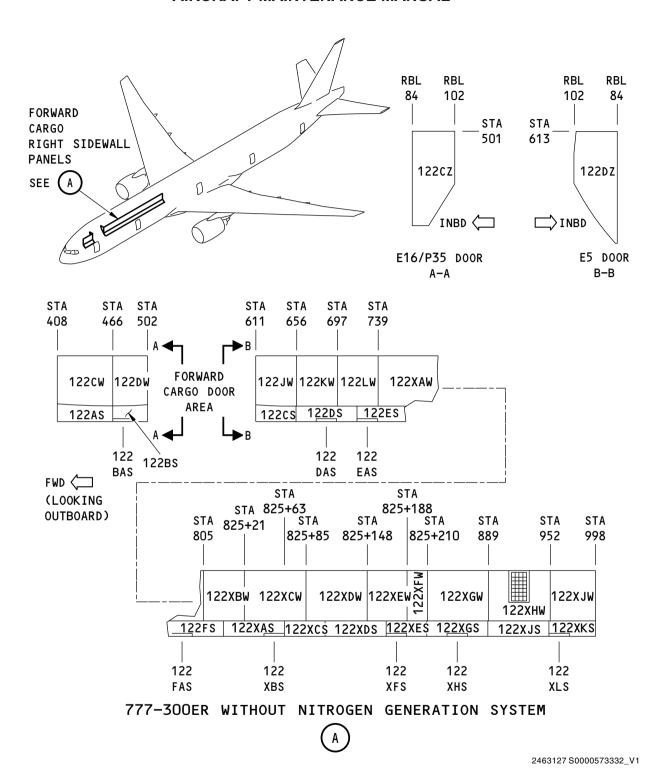
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Zone 122 - Forward Cargo Bay Compartment Sidewall/bulkhead Access Panels W/O NGS Figure 224/53-05-03-990-E43

EFFECTIVITY

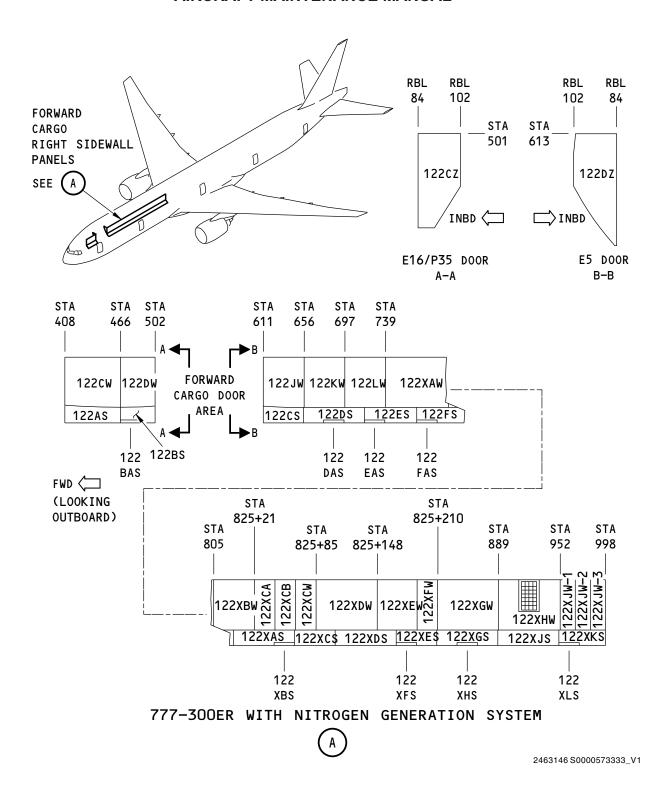
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Zone 122 - Forward Cargo Bay Sidewall / Bulkhead Access Panels W / NGS Figure 225/53-05-03-990-E44

EFFECTIVITY

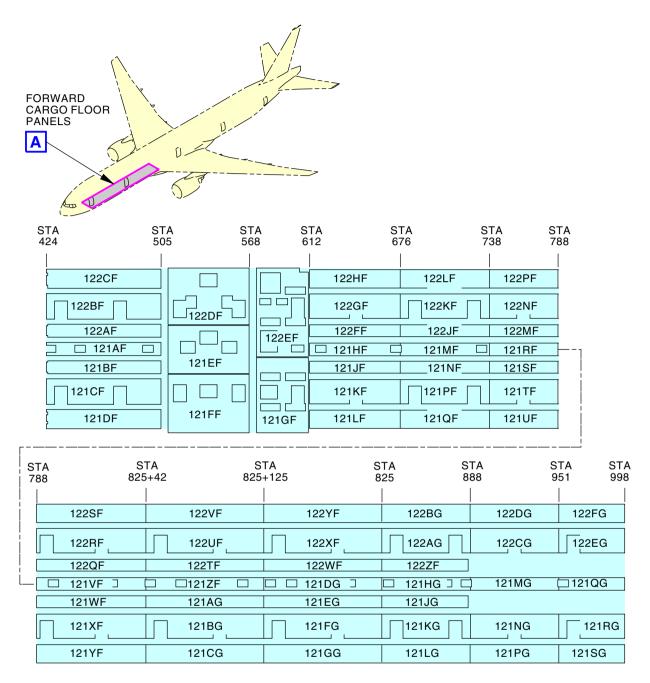
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Zones 121, 122 - Forward Cargo Bay Floor Access Panels Figure 226/53-05-03-990-E45

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TASK 53-05-03-210-807

16. INTERNAL - GENERAL VISUAL: AREA AFT OF FORWARD CARGO COMPARTMENT (Figure 227)

A. Inspection

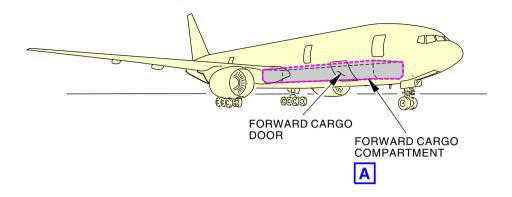
SUBTASK 53-05-03-210-007

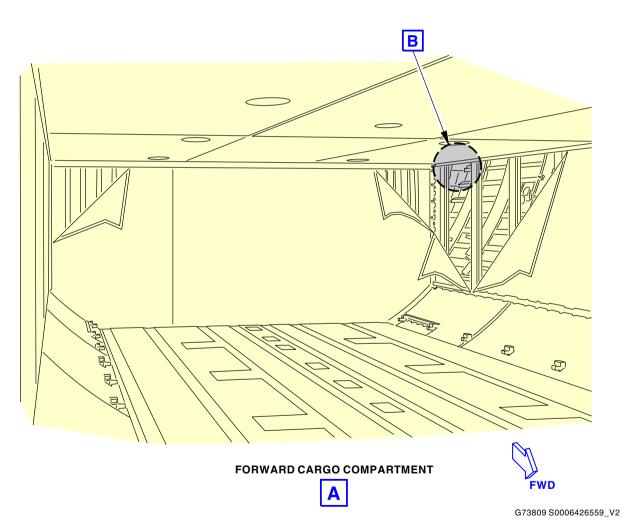
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







Forward Cargo Compartment Lower Lobe Structure Figure 227/53-05-03-990-812 (Sheet 1 of 3)

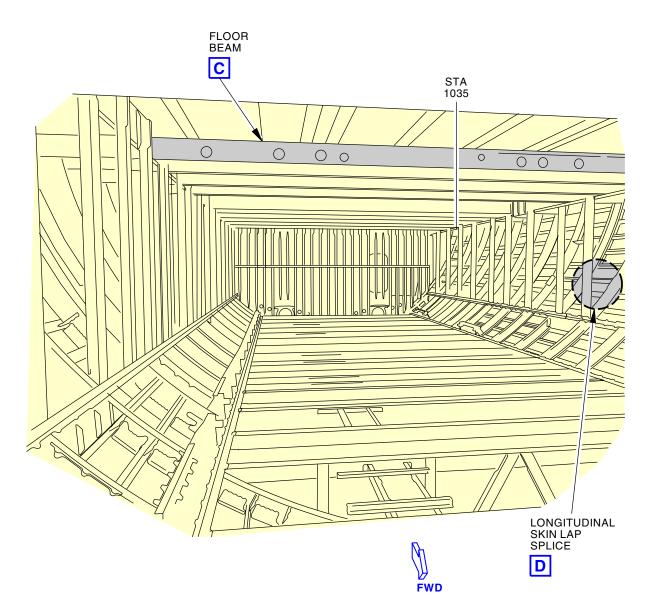
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FORWARD CARGO COMPARTMENT (LINERS AND FLOOR PANELS REMOVED)



G74025 S0006426560_V3

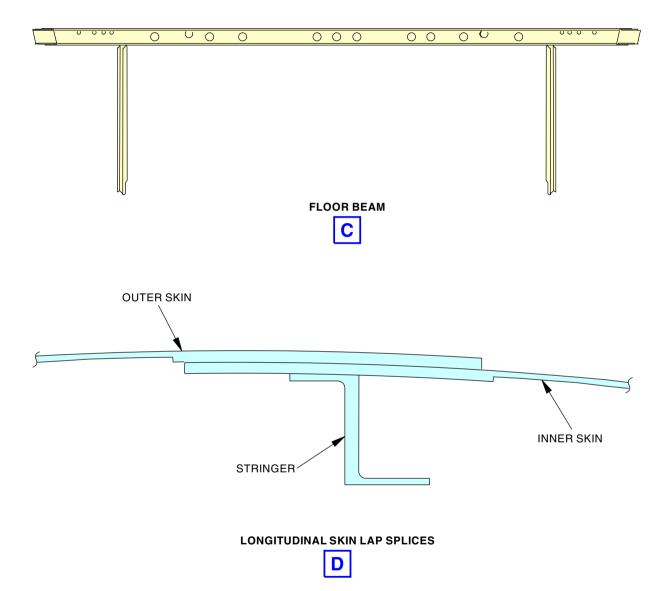
Forward Cargo Compartment Lower Lobe Structure Figure 227/53-05-03-990-812 (Sheet 2 of 3)

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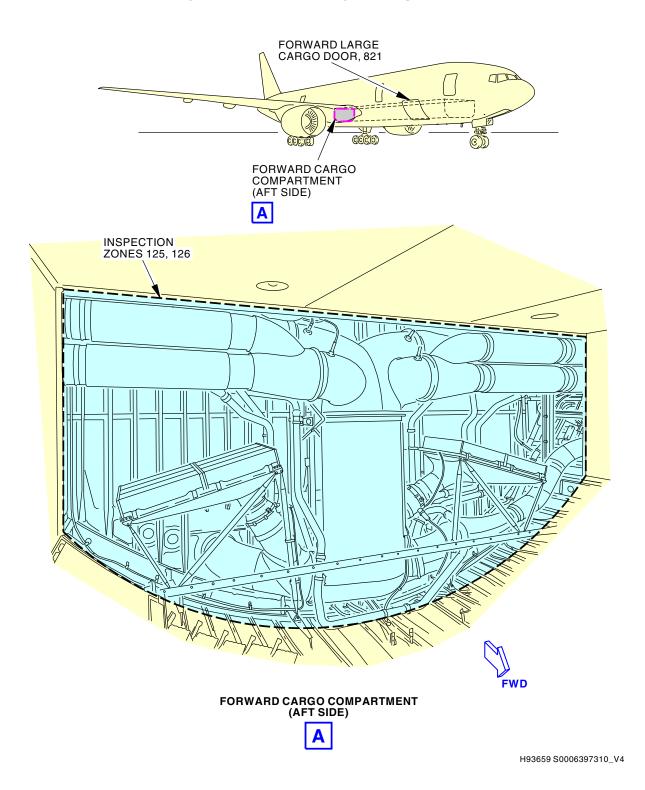


G74056 S0006426561_V2

Forward Cargo Compartment Lower Lobe Structure Figure 227/53-05-03-990-812 (Sheet 3 of 3)







Aft of Forward Cargo Compartment - General Visual (Internal) Figure 228/53-05-03-990-E74

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TASK 53-05-03-211-808

- 17. EXTERNAL DETAILED: MAIN LANDING GEAR WHEEL WELL, LEFT (Figure 229)
 - A. Inspection

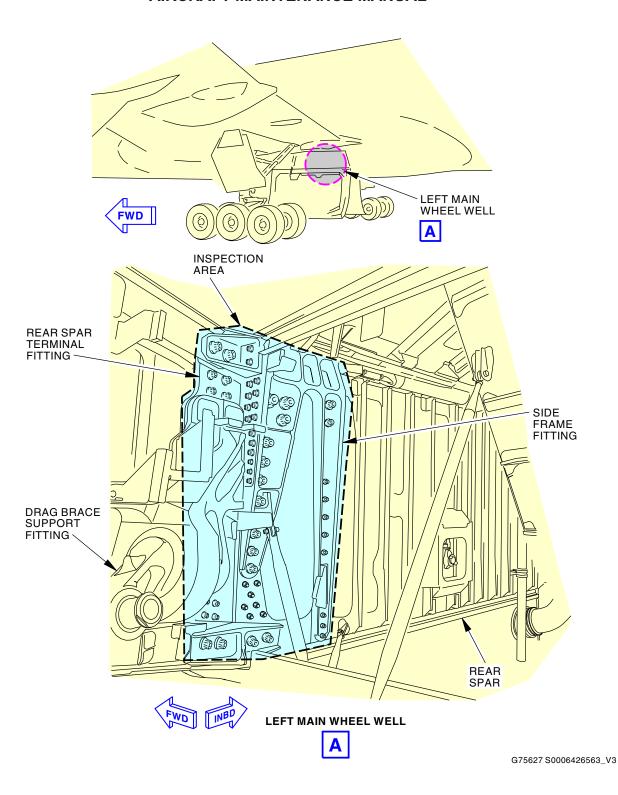
SUBTASK 53-05-03-211-008

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Left Rear Spar Side-of-Body Splice (External) Figure 229/53-05-03-990-813

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TASK 53-05-03-211-809

- **18.** EXTERNAL DETAILED: MAIN LANDING GEAR WHEEL WELL, RIGHT (Figure 230)
 - A. Inspection

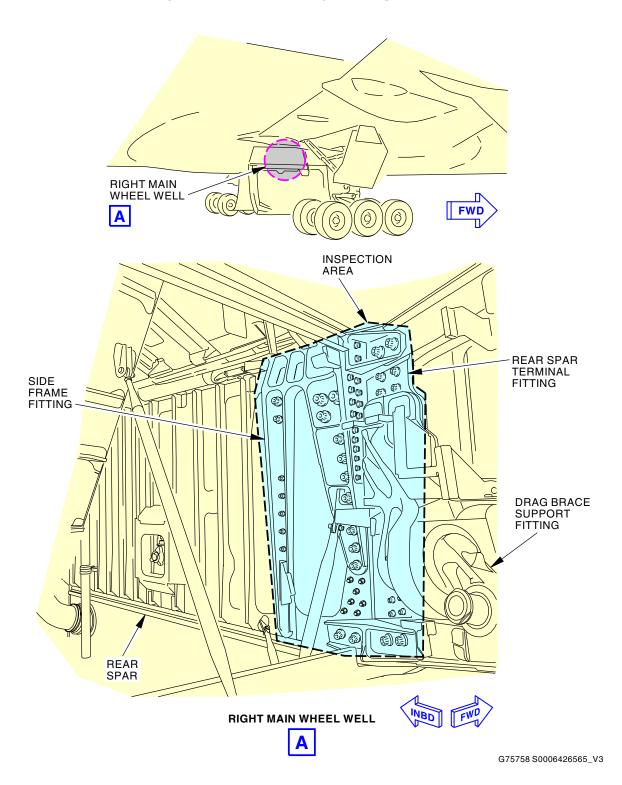
SUBTASK 53-05-03-211-009

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Right Rear Spar Side-of-Body Splice (External) Figure 230/53-05-03-990-814

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TASK 53-05-03-210-808

19. INTERNAL - GENERAL VISUAL: AREA ABOVE MAIN LANDING GEAR WHEEL WELL

(Figure 231) (Figure 232)

A. Inspection

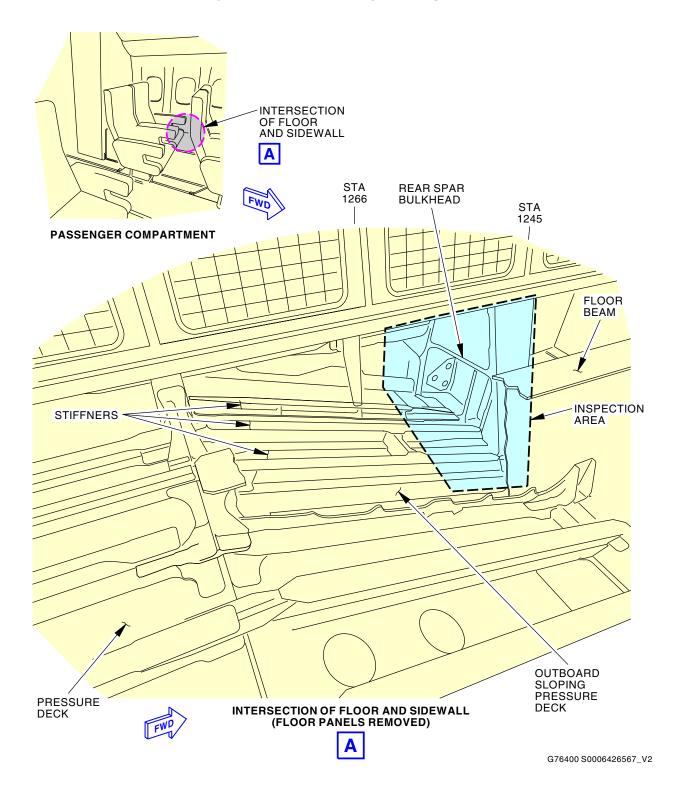
SUBTASK 53-05-03-210-008

(1) Do the inspection.

——— END OF TASK ———

ARO ALL





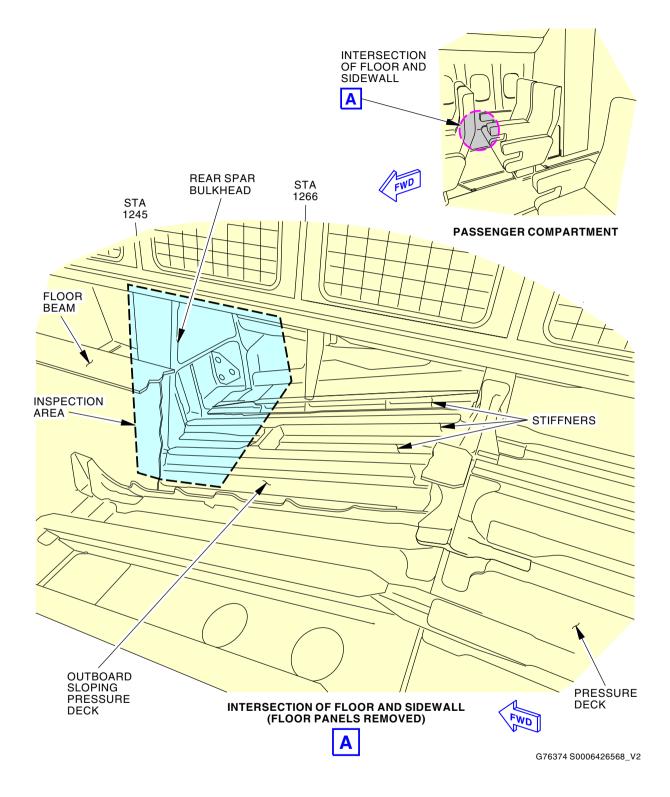
Outboard Pressure Deck Interfaces (Left Side) General Visual (Internal) Figure 231/53-05-03-990-815

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Outboard Pressure Deck Interfaces (Right Side) General Visual (Internal) Figure 232/53-05-03-990-816

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TASK 53-05-03-210-809

20. EXTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT

(Figure 233)

A. Inspection

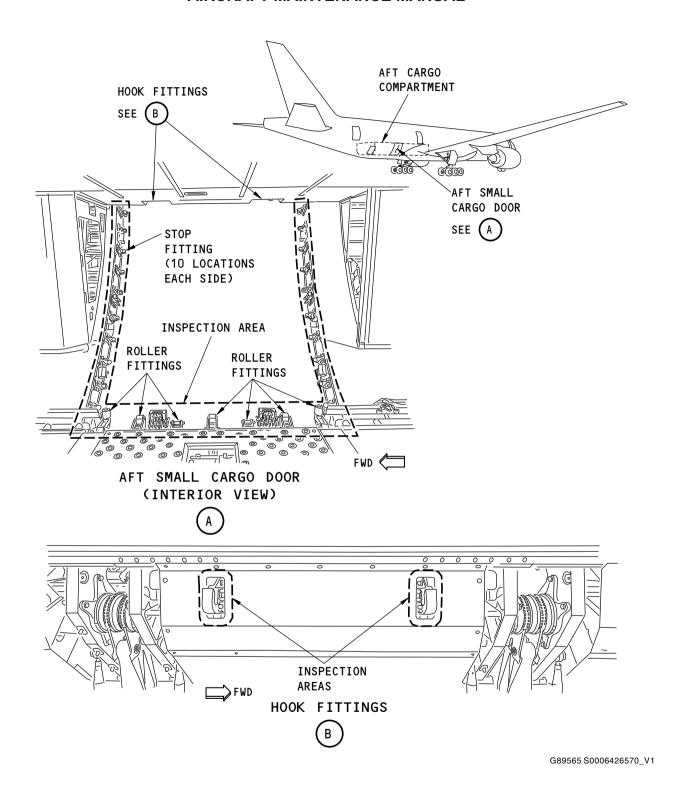
SUBTASK 53-05-03-210-009

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Stop/Roller/Hook Fittings (Aft Small Cargo Door) General Visual (External) Figure 233/53-05-03-990-817

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TASK 53-05-03-210-906

21. EXTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT

(Figure 234)

A. Inspection

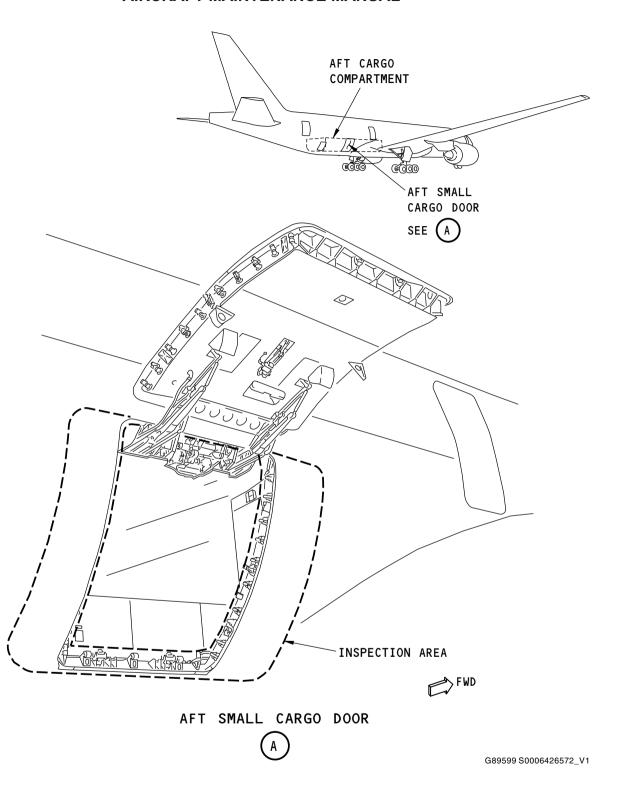
SUBTASK 53-05-03-210-126

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure Aft Small Cargo Door General Visual (External) Figure 234/53-05-03-990-985

ARO ALL
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TASK 53-05-03-211-810

22. INTERNAL - DETAILED: AFT CARGO COMPARTMENT

(Figure 235)

A. Inspection

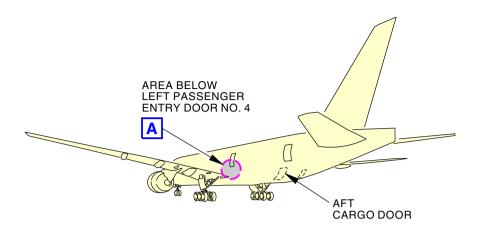
SUBTASK 53-05-03-211-010

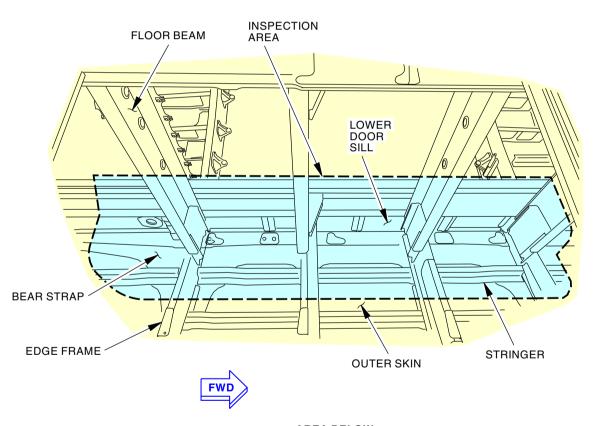
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







AREA BELOW LEFT PASSENGER ENTRY DOOR NO. 4



1581388 S0000217920_V2

Cutout Structure (Internal) Figure 235/53-05-03-990-820

ARO ALL
D633W101-ARO

53-05-03

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TASK 53-05-03-211-811

23. INTERNAL - DETAILED: AFT CARGO COMPARTMENT

(Figure 236 or Figure 237)

A. Inspection

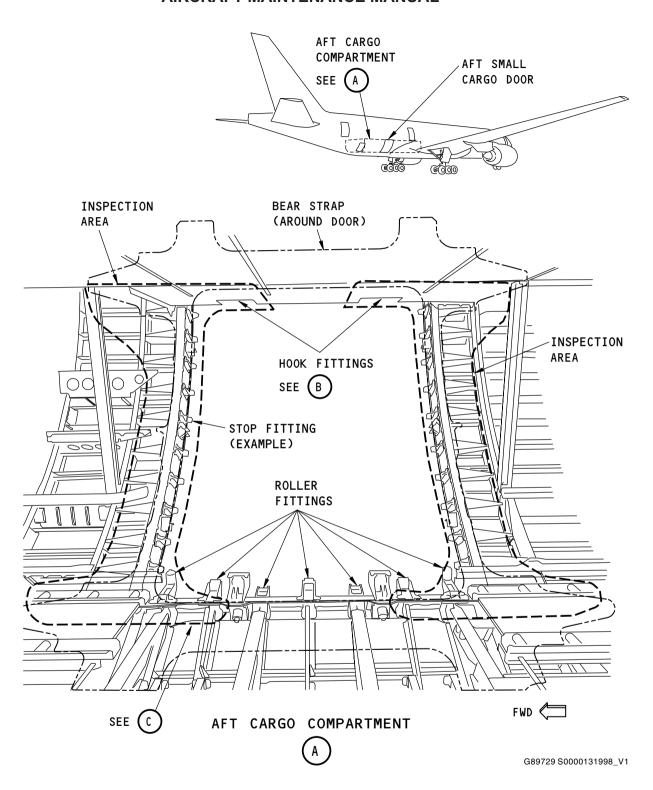
SUBTASK 53-05-03-211-011

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





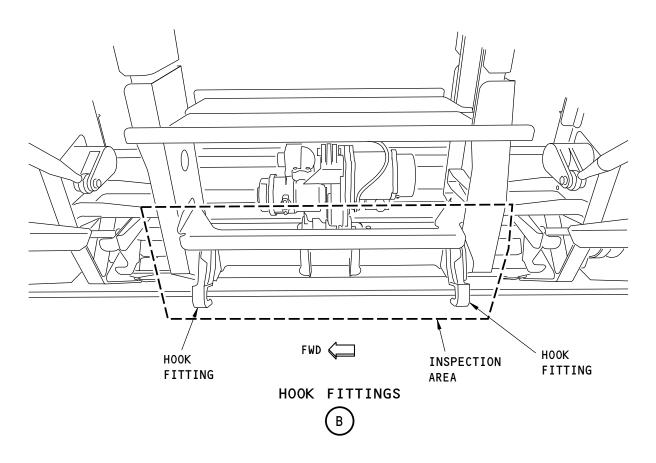
Aft Cargo Small Door Cutout Structure (Internal) Figure 236/53-05-03-990-821 (Sheet 1 of 2)

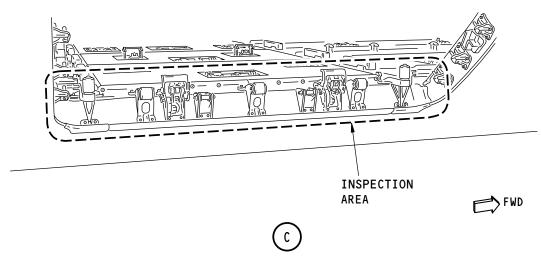
ARO ALL
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G89732 S0000131999_V2

Aft Cargo Small Door Cutout Structure (Internal) Figure 236/53-05-03-990-821 (Sheet 2 of 2)

EFFECTIVITY

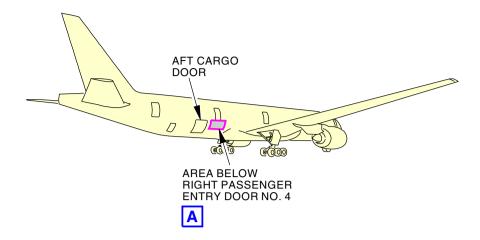
ARO ALL

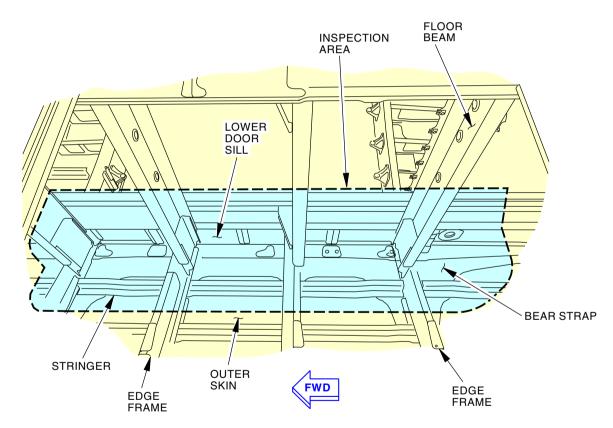
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AREA BELOW RIGHT PASSENGER ENTRY DOOR NO. 4



2551148 S0000606858_V1

Area Below Right Passenger Entry Door Cutout Structure (Internal) Figure 237/53-05-03-990-E87

EFFECTIVITY

ARO ALL

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TASK 53-05-03-210-812

24. EXTERNAL - GENERAL VISUAL: AREA BELOW AFT CARGO COMPARTMENT (Figure 238)

A. Inspection

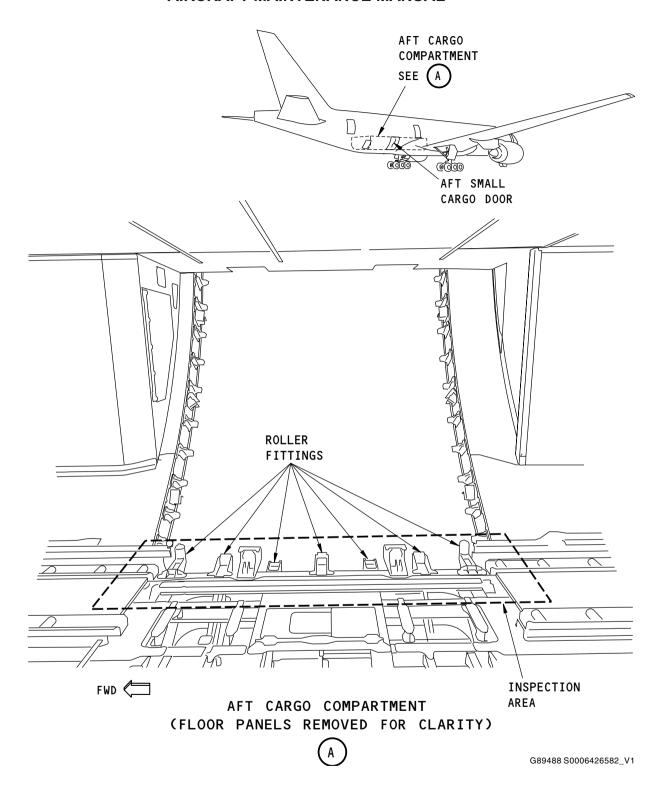
SUBTASK 53-05-03-210-012

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Roller Fittings and Backup Structure (Aft Small Cargo Door) General Visual (External) Figure 238/53-05-03-990-823

FFECTIVITY

ARO ALL

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TASK 53-05-03-210-813

25. EXTERNAL - GENERAL VISUAL: AREA BELOW AFT CARGO COMPARTMENT (Figure 239)

A. Inspection

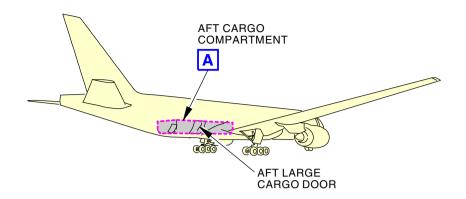
SUBTASK 53-05-03-210-013

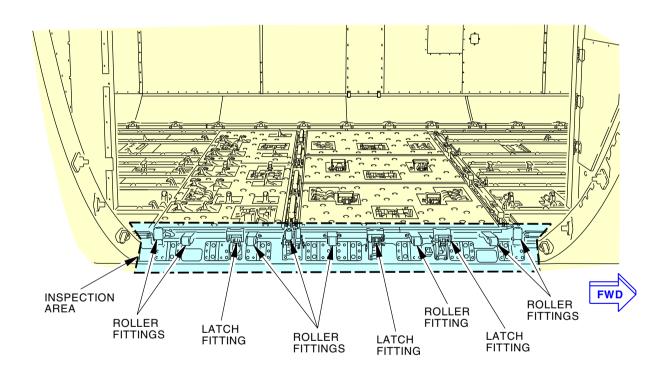
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







AFT CARGO COMPARTMENT



G89745 S0006426584_V3

Cutout Latches and Backup Structure Aft Large Cargo Door General Visual (External) Figure 239/53-05-03-990-824

ARO ALL

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TASK 53-05-03-210-908

26. EXTERNAL - GENERAL VISUAL: AREA BELOW AFT CARGO COMPARTMENT (Figure 240)

A. Inspection

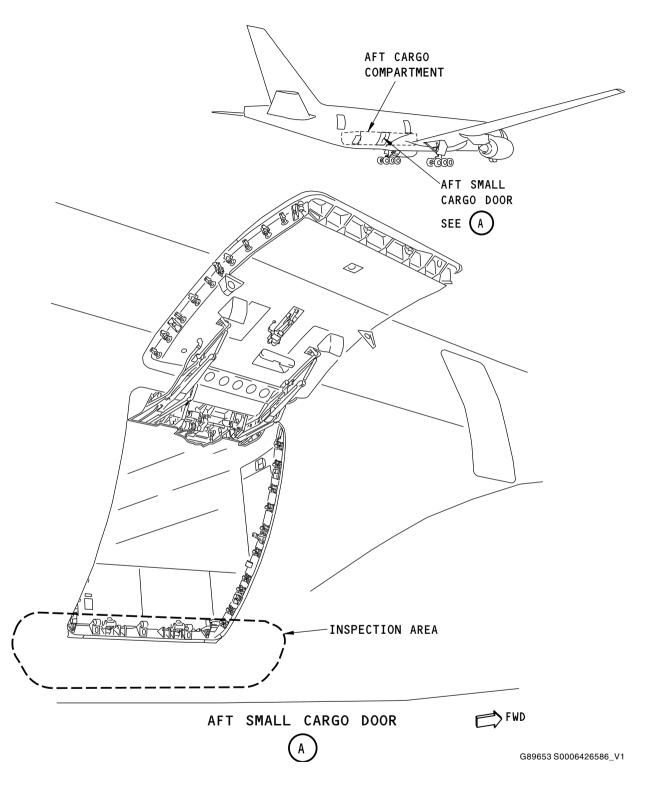
SUBTASK 53-05-03-210-128

(1) Do the inspection.

——— END OF TASK ———

ARO ALL





Cutout Structure Area Below Aft Small Cargo Door General Visual (External) Figure 240/53-05-03-990-987

ARO ALL

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TASK 53-05-03-211-861

27. INTERNAL - DETAILED: AREA BELOW AFT CARGO COMPARTMENT (Figure 241)

A. Inspection

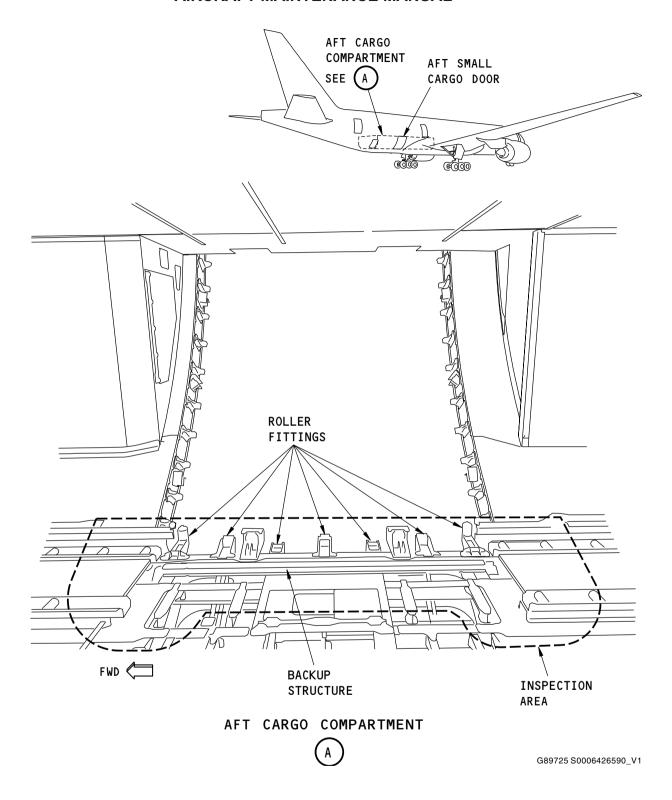
SUBTASK 53-05-03-211-061

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure, Cutout Roller Fittings and Backup Structure Aft Small Cargo Door (Internal) Figure 241/53-05-03-990-989

EFFECTIVITY

ARO ALL

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TASK 53-05-03-211-815

28. INTERNAL - GENERAL VISUAL: AREA BELOW AFT CARGO COMPARTMENT (Figure 242)

| | | | 4.5 | |
|------------|------|---------------------------|---|-----|
| Α. | Ins | nar | 2tia | ٦n |
| ~ : | 1113 | $\mathbf{p}_{\mathbf{c}}$ | ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,, | 911 |

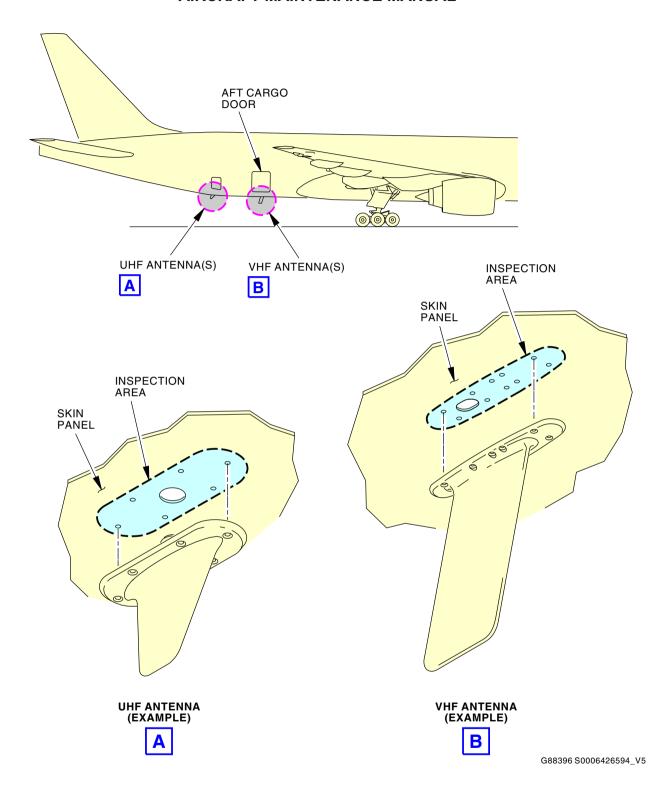
SUBTASK 53-05-03-211-015

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Lower Lobe Skin Panel (Sta 1434-1832) (Internal) Figure 242/53-05-03-990-829

ARO ALL

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TASK 53-05-03-210-816

29. EXTERNAL - GENERAL VISUAL: BULK CARGO COMPARTMENT

(Figure 243)

A. Inspection

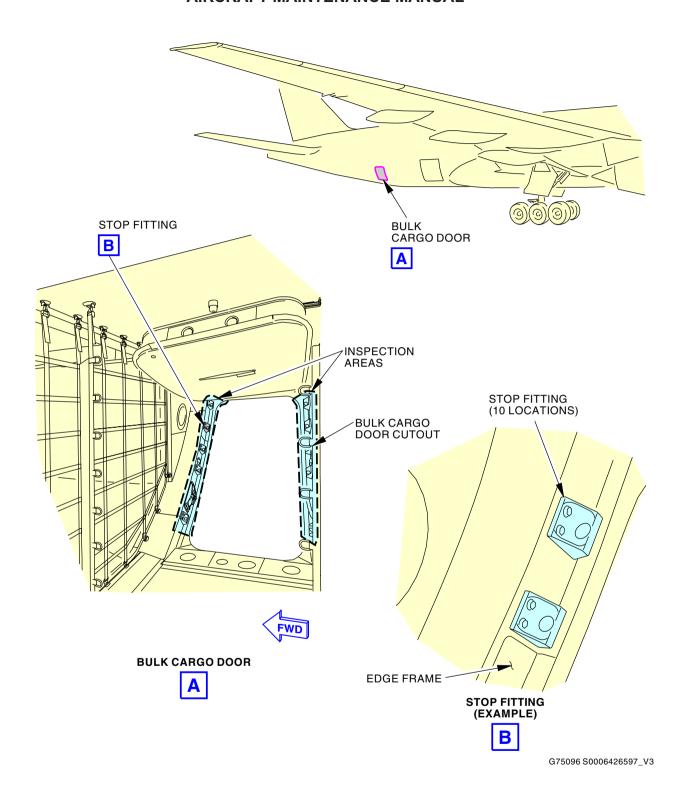
SUBTASK 53-05-03-210-016

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Stop Fittings (Bulk Cargo Door) General Visual (External) Figure 243/53-05-03-990-830

FFECTIVITY

ARO ALL

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TASK 53-05-03-211-816

30. INTERNAL - DETAILED: BULK CARGO COMPARTMENT

(Figure 244)

A. Inspection

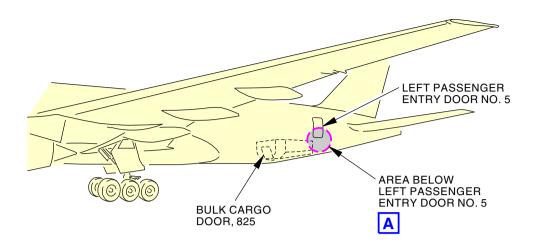
SUBTASK 53-05-03-211-016

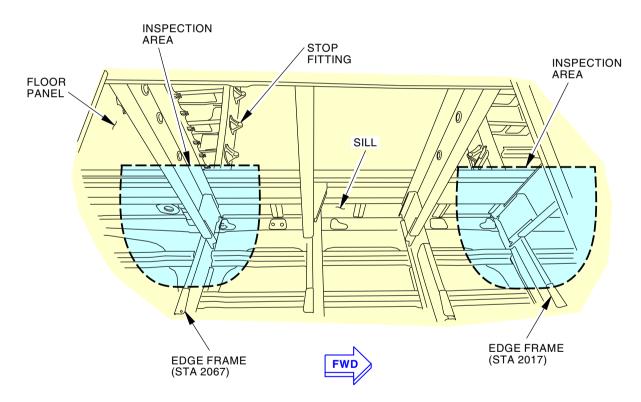
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







AREA BELOW LEFT PASSENGER ENTRY DOOR NO. 5



J89737 S0000185135_V2

Cutout Structure Left Passenger Entry Door No. 5 (Internal) Figure 244/53-05-03-990-923

ARO ALL
D633W101-ARO

53-05-03

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TASK 53-05-03-211-817-005

31. INTERNAL - DETAILED: BULK CARGO COMPARTMENT -300ER

A. Job Set-up

SUBTASK 53-05-03-010-088

(1) Open access panels, reference Figure 245, Figure 246 or Figure 247.

B. Inspection

SUBTASK 53-05-03-211-101

(1) Do the inspection.

C. Job Close-up

SUBTASK 53-05-03-410-088

(1) Close access panels, reference Figure 245, Figure 246 or Figure 247.

----- END OF TASK -----

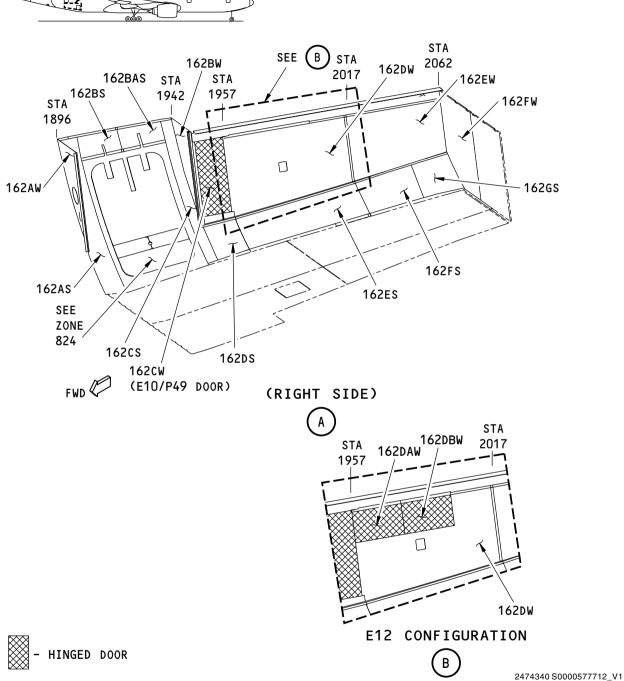
ARO ALL

53-05-03

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SUB-MAJOR ZONE 160 - BULK CARGO COMPARTMENT SIDEWALL LINERS - RIGHT SIDE Figure 245/53-05-03-990-D24

FFFECTIVITY

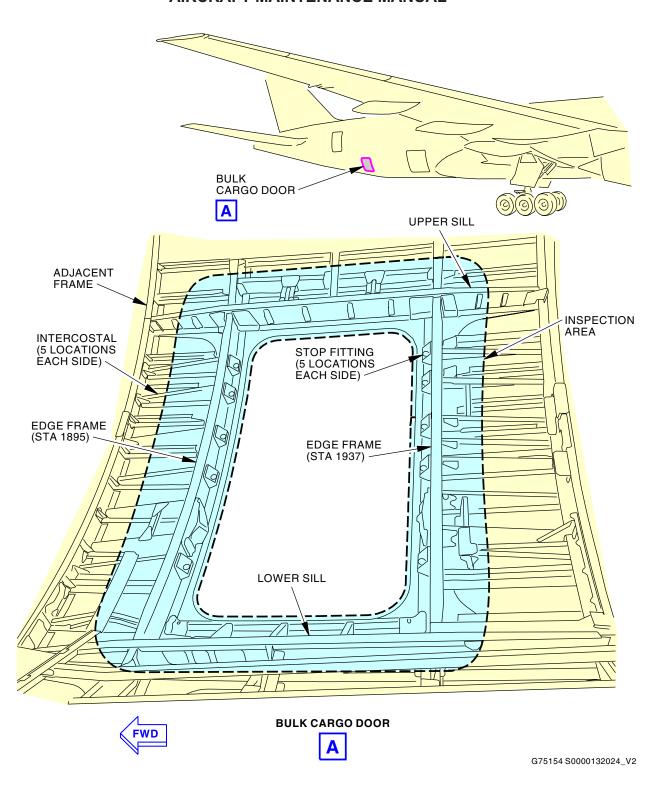
ARO ALL

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Door Coutout Structure Bulk Cargo Door (Internal) Figure 246/53-05-03-990-D30

EFFECTIVITY

ARO ALL

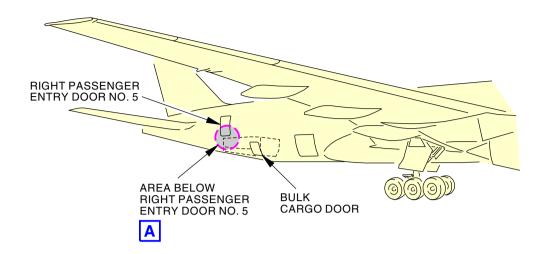
D633W101-ARO

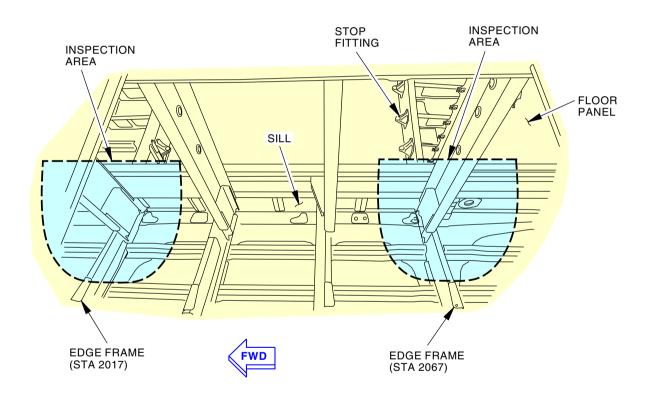
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AREA BELOW RIGHT PASSENGER ENTRY DOOR NO. 5



J89802 S0000185138_V2

Cutout Structure Right Passenger Entry Door No. 5 (Internal) Figure 247/53-05-03-990-D31

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53-05-03

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TASK 53-05-03-211-818

32. INTERNAL - DETAILED: AREA BELOW BULK CARGO COMPARTMENT

(Figure 248, Figure 249, Figure 250.)

A. Job Set-up

SUBTASK 53-05-03-010-123

- (1) Open access panels, reference Figure 249, Figure 250.
- B. Inspection

SUBTASK 53-05-03-211-018

- (1) Do the inspection. Figure 248.
- C. Job Close-up

SUBTASK 53-05-03-410-123

(1) Close access panels, reference Figure 249, Figure 250.

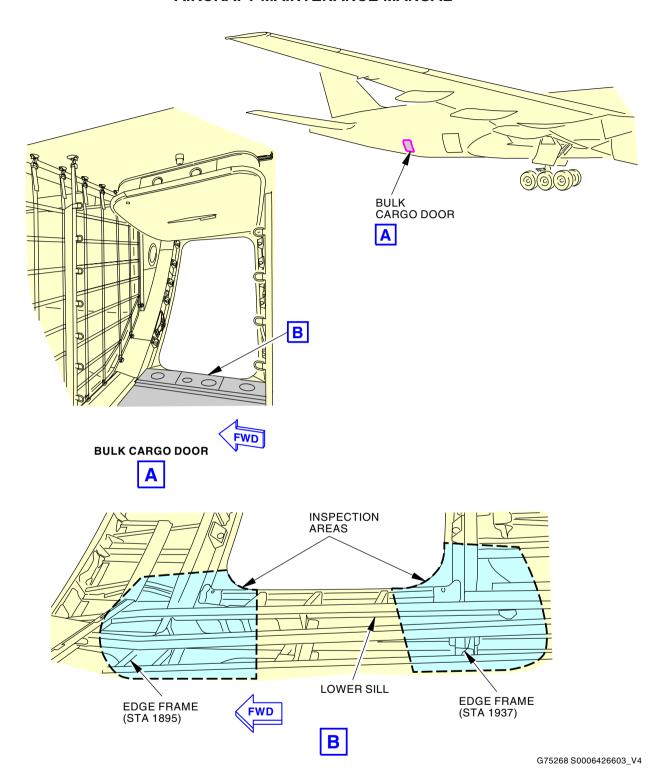
——— END OF TASK ———

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53-05-03

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Cutout Structure Bulk Cargo Door - Below Floor (Internal) Figure 248/53-05-03-990-833

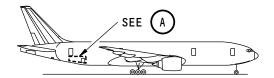
FARO ALL

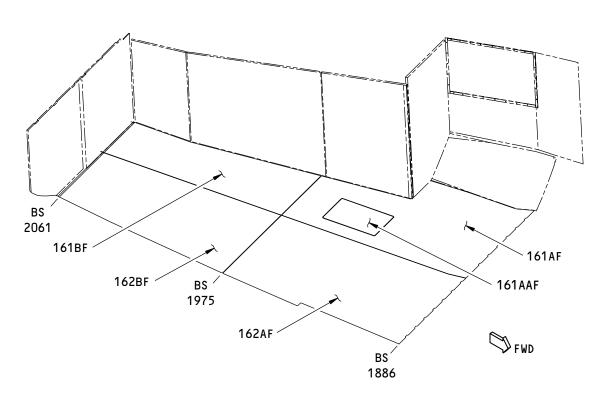
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(777–200) A

NOTE: AIRPLANE PRODUCTION LINE NUMBERS 1 THROUGH 53

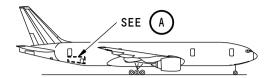
2474322 S0000577639_V1

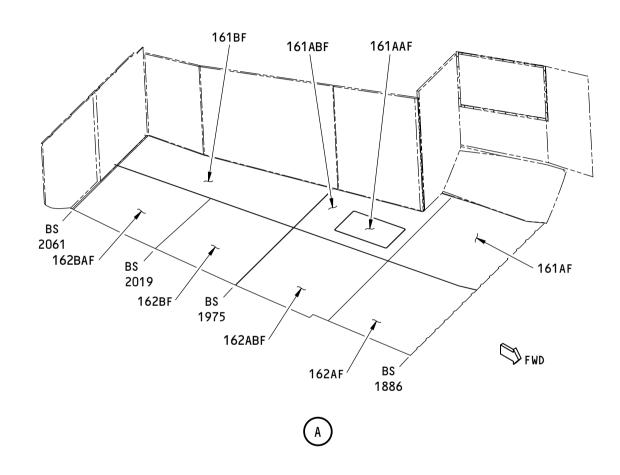
Sub-Major Zone 160 - Bulk Cargo Compartment Floor Panels - Production Line No. 1Through 53 - Detailed (Internal)
Figure 249/53-05-03-990-E46

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NOTE: AIRPLANE PRODUCTION LINE

NUMBERS 54 AND ON

2474323 S0000577640_V1

Sub-Major Zone 160 - Bulk Cargo Compartment Floor Panels - Production Line No. 54and On - Detailed (Internal)

Figure 250/53-05-03-990-E47

ARO ALL

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TASK 53-05-03-211-819

33. INTERNAL - DETAILED: AREA AFT OF BULK CARGO COMPARTMENT (Figure 251)

A. Inspection

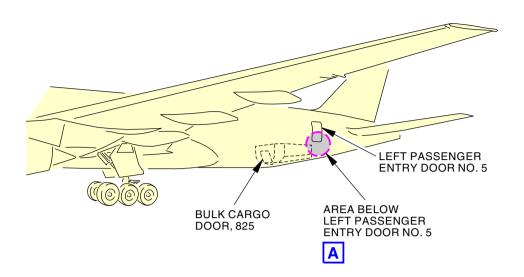
SUBTASK 53-05-03-211-019

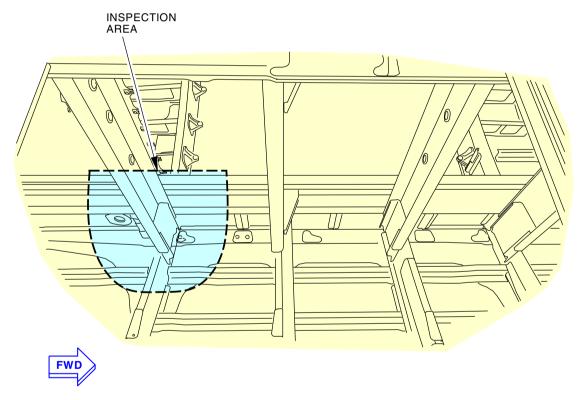
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







AREA BELOW LEFT PASSENGER ENTRY DOOR NO. 5



J89609 S0000183654_V2

Sill And Edge Frames Left Passenger Entry Door No. 5 (Internal) Figure 251/53-05-03-990-922

ARO ALL
D633W101-ARO

53-05-03

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TASK 53-05-03-211-820

34. INTERNAL - DETAILED: AREA AFT OF BULK CARGO COMPARTMENT (Figure 252)

A. Inspection

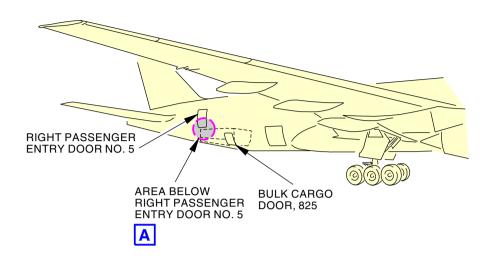
SUBTASK 53-05-03-211-020

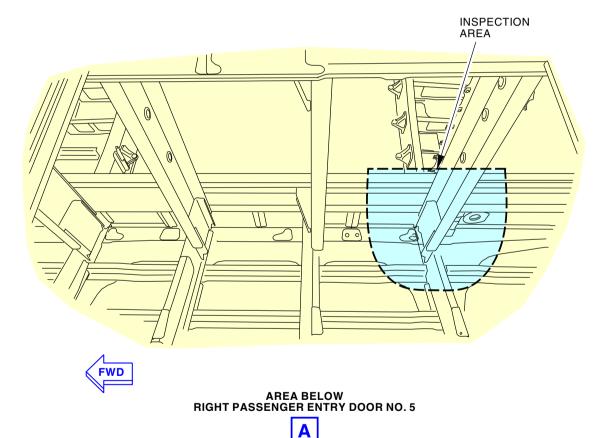
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







J89610 S0000183640_V2

Sill and Edge Frames Right Passenger Entry Door No. 5 (Internal) Figure 252/53-05-03-990-921

ARO ALL
D633W101-ARO

53-05-03

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TASK 53-05-03-210-817

35. INTERNAL - GENERAL VISUAL: OVERWING WING-TO-BODY FAIRINGS, LEFT (Figure 253)

A. Inspection

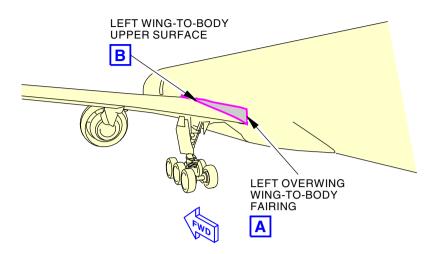
SUBTASK 53-05-03-210-017

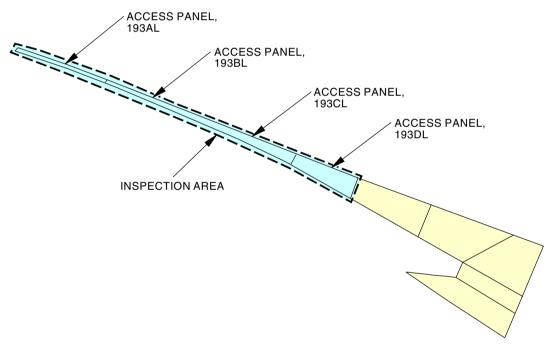
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







LEFT OVERWING WING-TO-BODY FAIRING



G72740 S0006426607_V3

Upper Surface Side-of-Body Splice (Left Wing) General Visual (Internal) Figure 253/53-05-03-990-834 (Sheet 1 of 2)

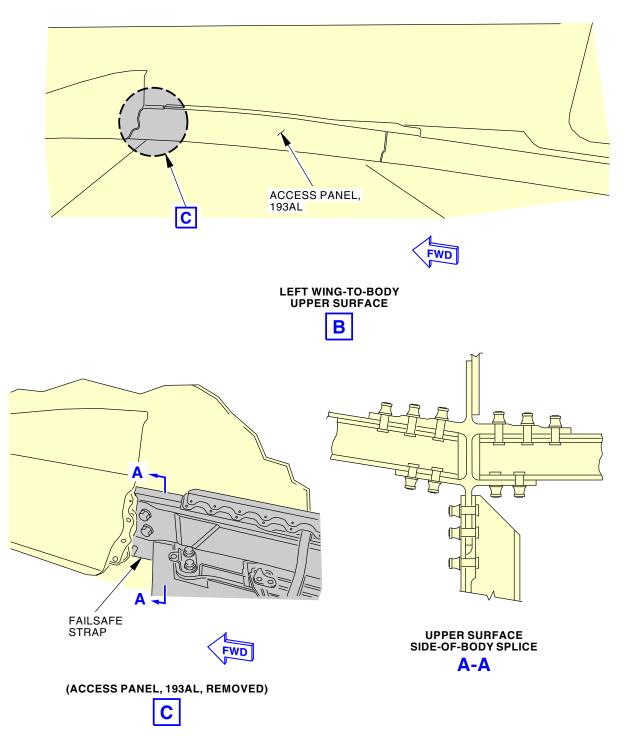
ARO ALL

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G72789 S0006426608_V2

Upper Surface Side-of-Body Splice (Left Wing) General Visual (Internal) Figure 253/53-05-03-990-834 (Sheet 2 of 2)

ARO ALL
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TASK 53-05-03-210-818

36. INTERNAL - GENERAL VISUAL: OVERWING WING-TO-BODY FAIRINGS, RIGHT (Figure 254)

A. Inspection

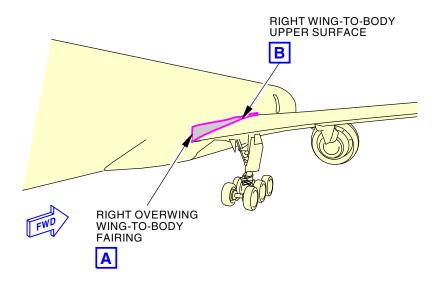
SUBTASK 53-05-03-210-018

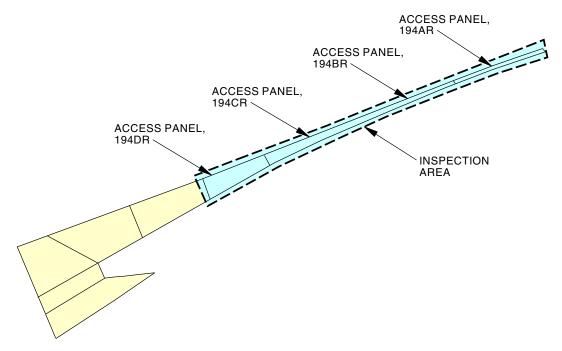
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







RIGHT OVERWING WING-TO-BODY FAIRING



G80076 S0006426610_V3

Upper Surface Side-of-Body Splice (Right Wing) General Visual (Internal) Figure 254/53-05-03-990-835 (Sheet 1 of 2)

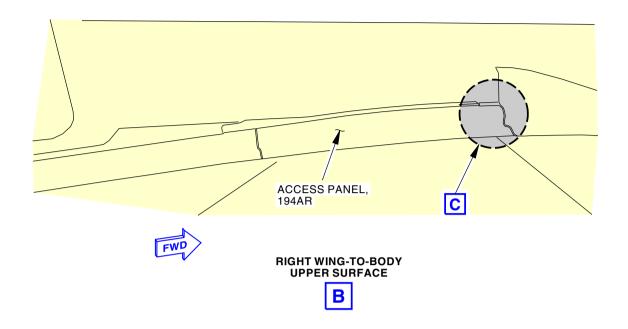
ARO ALL

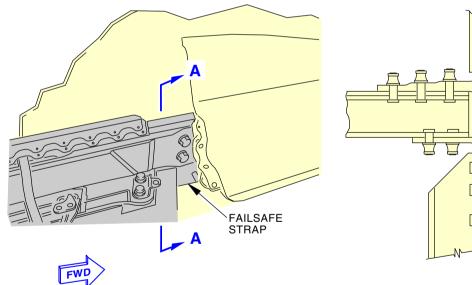
D633W101-ARO

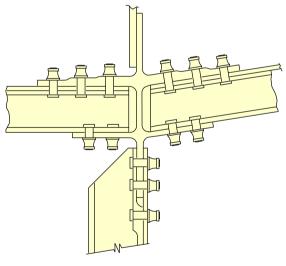
53-05-03

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(ACCESS PANEL, 194AR, REMOVED)

UPPER SURFACE SIDE-OF-BODY SPLICE A-A

G80075 S0006426611_V2

Upper Surface Side-of-Body Splice (Right Wing) General Visual (Internal) Figure 254/53-05-03-990-835 (Sheet 2 of 2)

ARO ALL
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TASK 53-05-03-211-821

- 37. INTERNAL DETAILED: FORWARD WING-TO-BODY FAIRINGS LEFT (Figure 255)
 - A. Inspection

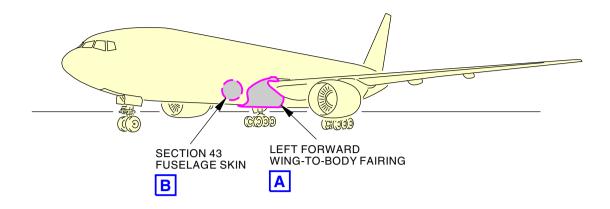
SUBTASK 53-05-03-211-021

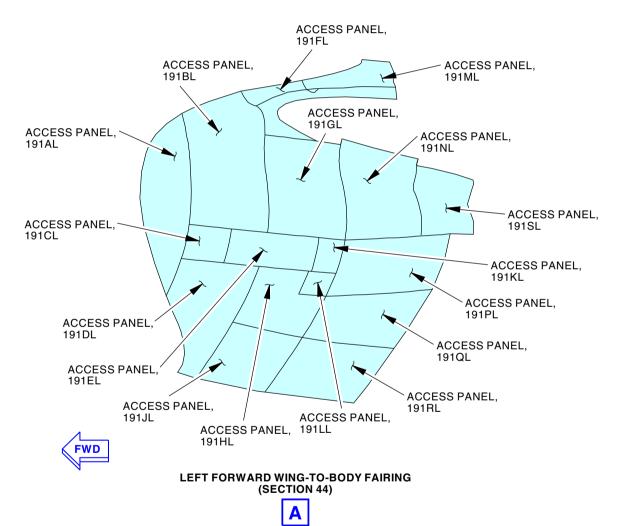
(1) Do the inspection.

——— END OF TASK ———

ARO ALL







G73135 S0006426613_V3

Longitudinal Skin Lap Splices (Left Forward Wing-to-Body Fairing) (Internal) Figure 255/53-05-03-990-836 (Sheet 1 of 2)

EFFECTIVITY

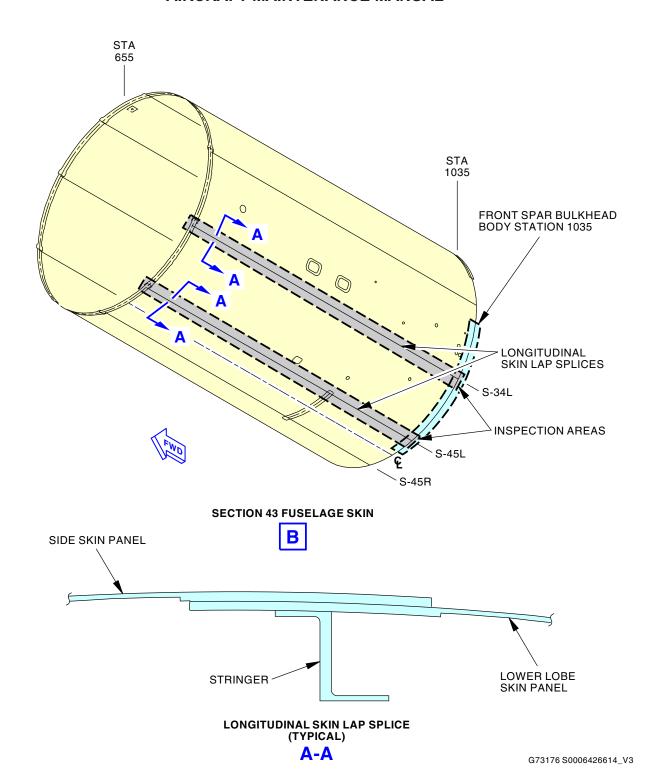
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Longitudinal Skin Lap Splices (Left Forward Wing-to-Body Fairing) (Internal) Figure 255/53-05-03-990-836 (Sheet 2 of 2)

EFFECTIVITY

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TASK 53-05-03-211-822

38. INTERNAL - DETAILED: FORWARD WING-TO-BODY FAIRINGS - RIGHT (Figure 256)

A. Inspection

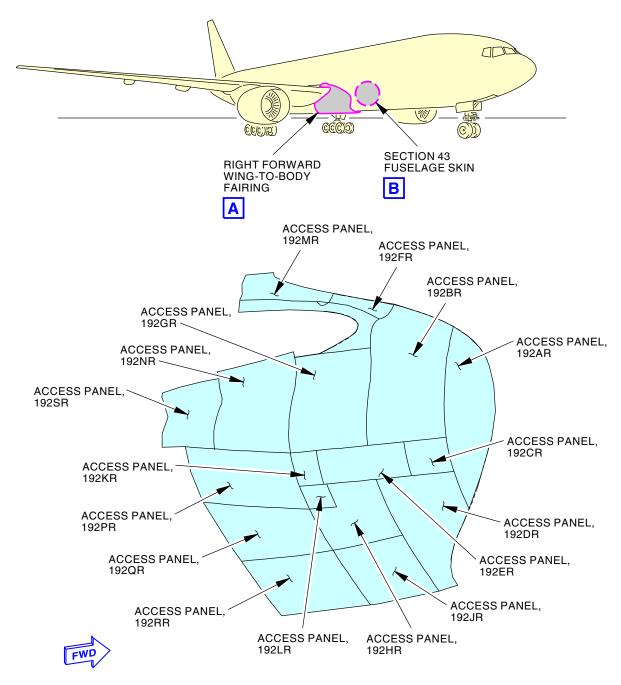
SUBTASK 53-05-03-211-022

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





RIGHT FORWARD WING-TO-BODY FAIRING (SECTION 44)



G80733 S0006426616_V3

Longitudinal Skin Lap Splices (Right Forward Wing-to-Body Fairing) (Internal) Figure 256/53-05-03-990-837 (Sheet 1 of 2)

FEFFECTIVITY

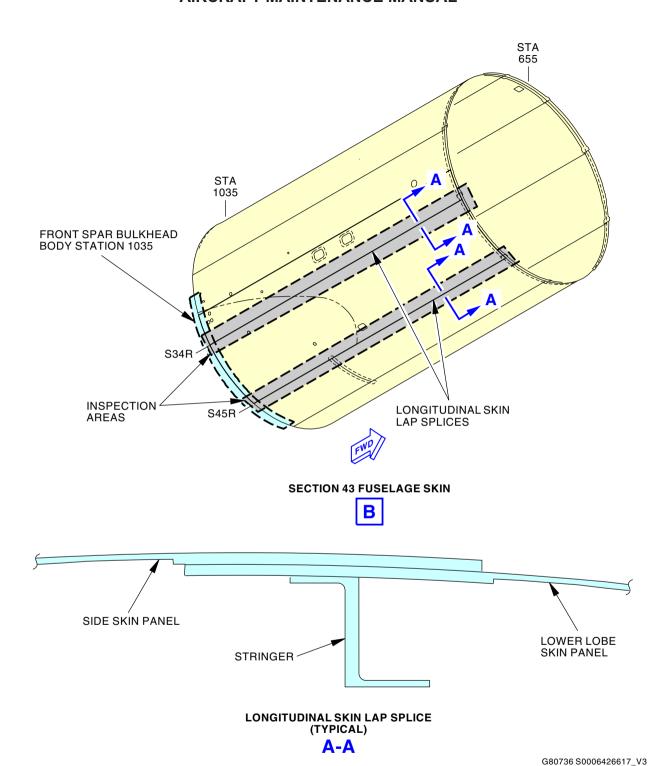
ARO ALL

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Longitudinal Skin Lap Splices (Right Forward Wing-to-Body Fairing) (Internal) Figure 256/53-05-03-990-837 (Sheet 2 of 2)





TASK 53-05-03-210-819

39. INTERNAL - GENERAL VISUAL: OVERWING WING-TO-BODY FAIRINGS - LEFT (Figure 257)

A. Inspection

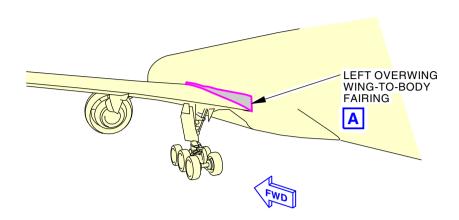
SUBTASK 53-05-03-210-019

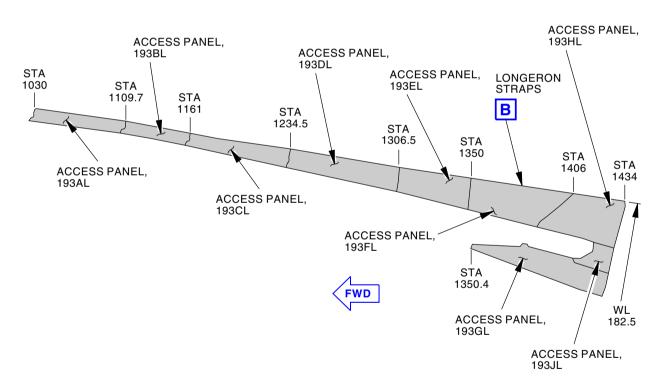
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







LEFT OVERWING WING-TO-BODY FAIRING



G72489 S0006426619_V3

Longeron Straps (Left Overwing Wing-to-Body Fairings) General Visual (Internal) Figure 257/53-05-03-990-838 (Sheet 1 of 2)

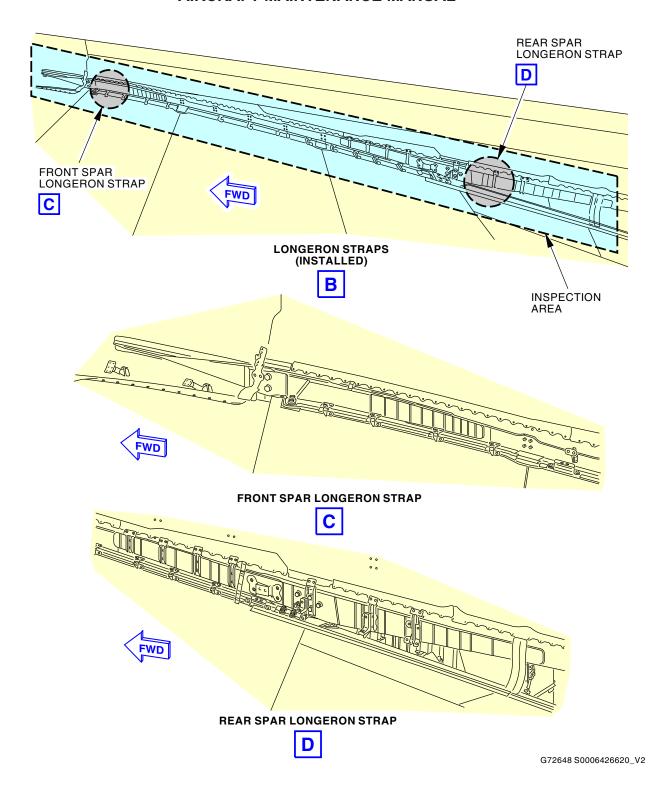
EFFECTIVITY

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Longeron Straps (Left Overwing Wing-to-Body Fairings) General Visual (Internal) Figure 257/53-05-03-990-838 (Sheet 2 of 2)

EFFECTIVITY

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TASK 53-05-03-210-820

40. INTERNAL - GENERAL VISUAL: OVERWING WING-TO-BODY FAIRINGS - RIGHT (Figure 258)

A. Inspection

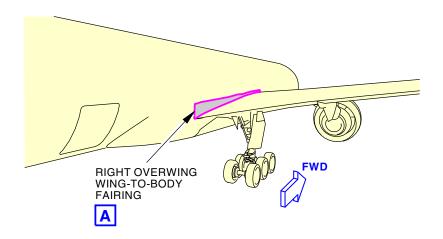
SUBTASK 53-05-03-210-020

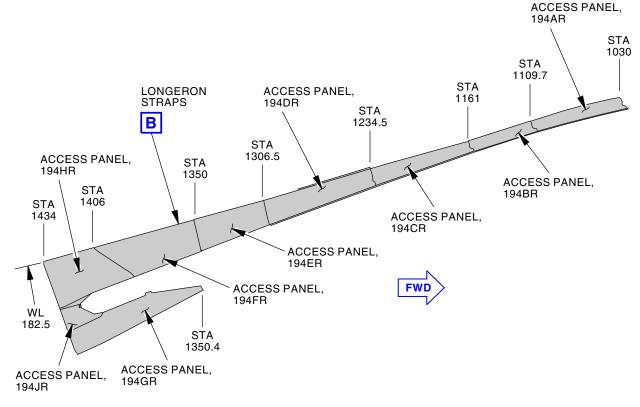
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







RIGHT OVERWING WING-TO-BODY FAIRING



G97399 S0006426622_V3

Longeron Straps (Right Overwing Wing-to-Body Fairing) General Visual (Internal) Figure 258/53-05-03-990-839 (Sheet 1 of 2)

EFFECTIVITY

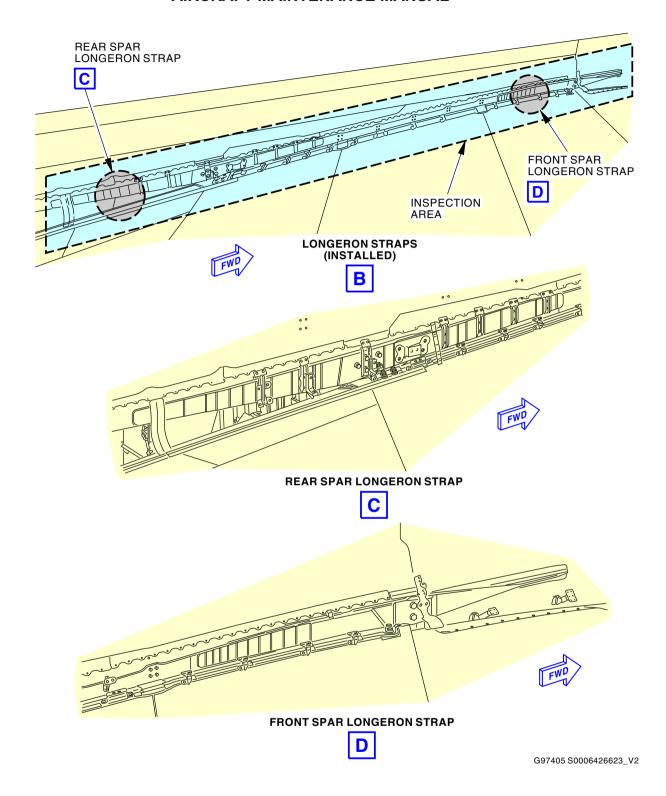
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Longeron Straps (Right Overwing Wing-to-Body Fairing) General Visual (Internal) Figure 258/53-05-03-990-839 (Sheet 2 of 2)

FFFECTIVITY

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TASK 53-05-03-211-862

- 41. INTERNAL DETAILED: AFT WING-TO-BODY FAIRINGS LEFT
 - A. Inspection

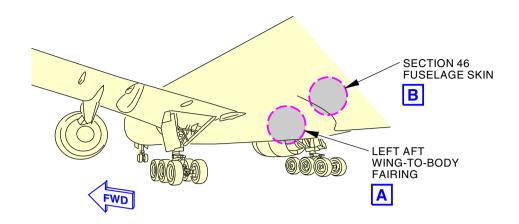
SUBTASK 53-05-03-211-062

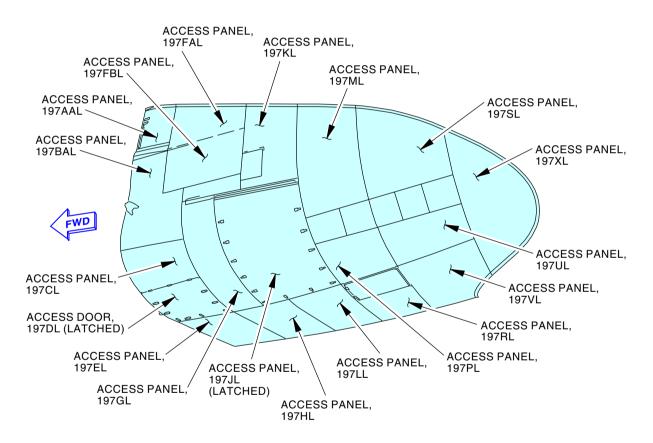
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







LEFT AFT WING-TO-BODY FAIRING



2086665 S0000438886_V2

Longitudinal Skin Lap Splices (Left Aft Wing-to-Body Fairing)(Internal) Figure 259/53-05-03-990-991 (Sheet 1 of 2)

FEFFECTIVITY

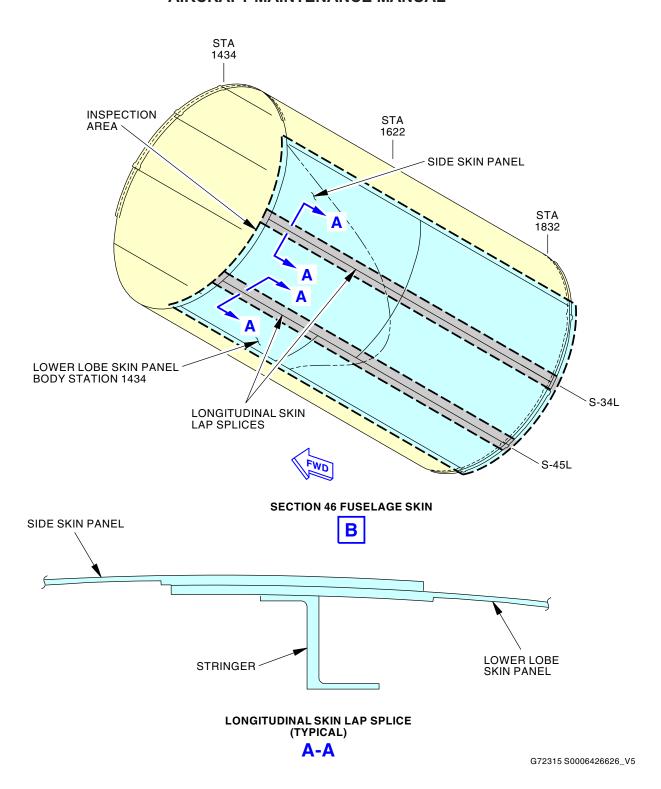
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Longitudinal Skin Lap Splices (Left Aft Wing-to-Body Fairing)(Internal) Figure 259/53-05-03-990-991 (Sheet 2 of 2)

EFFECTIVITY

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TASK 53-05-03-211-863

- 42. INTERNAL DETAILED: AFT WING-TO-BODY FAIRINGS RIGHT
 - A. Inspection

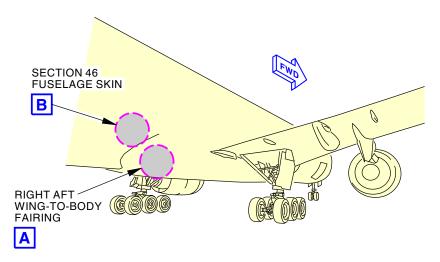
SUBTASK 53-05-03-211-063

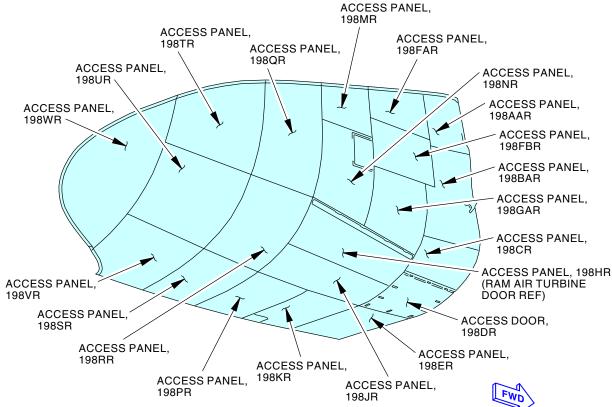
(1) Do the inspection.

——— END OF TASK ———

ARO ALL







RIGHT AFT WING-TO-BODY FAIRING



2086467 S0000438891_V2

Longitudinal Skin Lap Splices (Right Aft Wing-to-Body Fairing)(Internal) Figure 260/53-05-03-990-992 (Sheet 1 of 2)

EFFECTIVITY

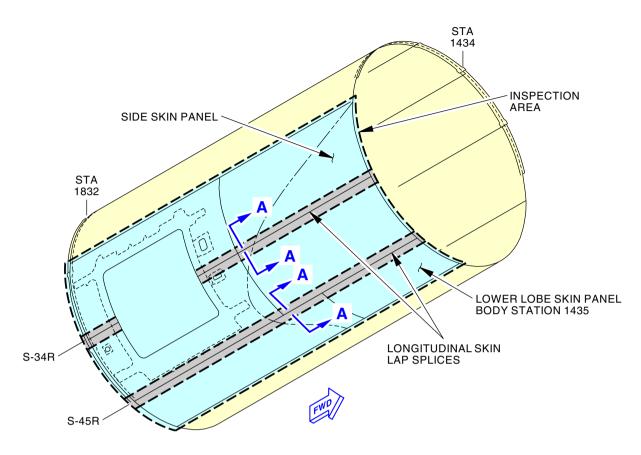
ARO ALL

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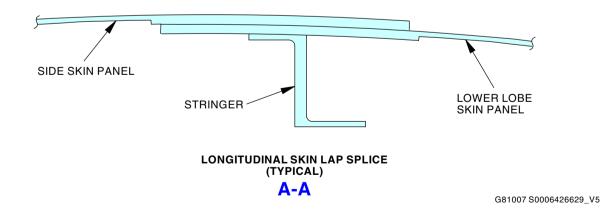
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SECTION 46 FUSELAGE SKIN





Longitudinal Skin Lap Splices (Right Aft Wing-to-Body Fairing)(Internal) Figure 260/53-05-03-990-992 (Sheet 2 of 2)

FFFECTIVITY

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TASK 53-05-03-211-825

43. EXTERNAL - SPECIAL DETAILED: FLIGHT COMPARTMENT

(Figure 261)

A. Inspection

SUBTASK 53-05-03-211-025

(1) Do the inspection.

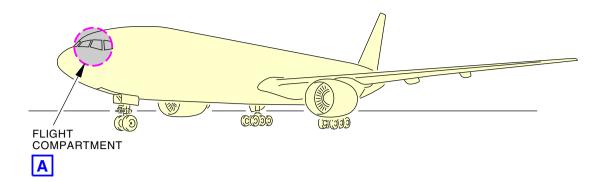
----- END OF TASK -----

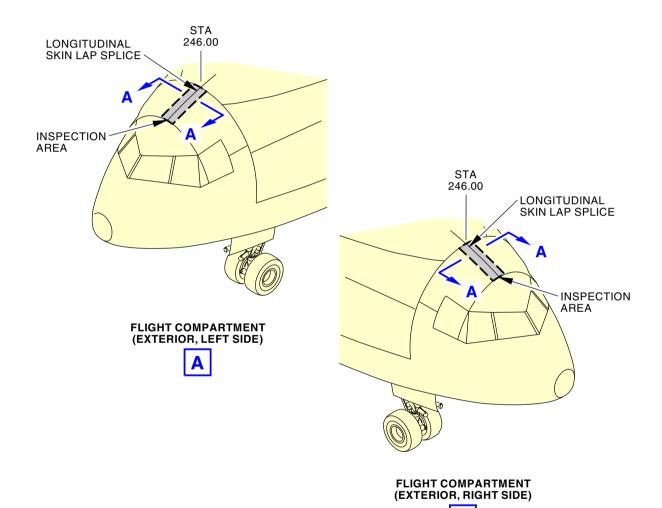
ARO ALL

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N78194 S0006426631_V4

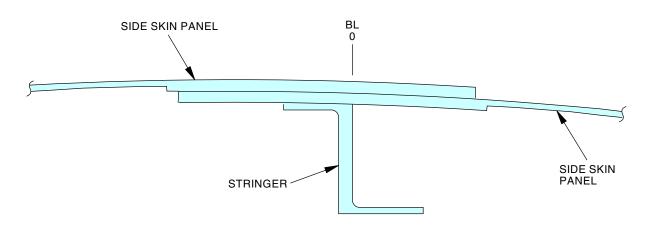
Longitudinal Skin Lap Splices (Flight Compartment) (External) Figure 261/53-05-03-990-842 (Sheet 1 of 2)

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LONGITUDINAL SKIN LAP SPLICE (TYPICAL) A-A

G72282 S0006426632_V3

Longitudinal Skin Lap Splices (Flight Compartment) (External) Figure 261/53-05-03-990-842 (Sheet 2 of 2)

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TASK 53-05-03-211-826

44. INTERNAL - DETAILED: FLIGHT COMPARTMENT

(Figure 262)

A. Inspection

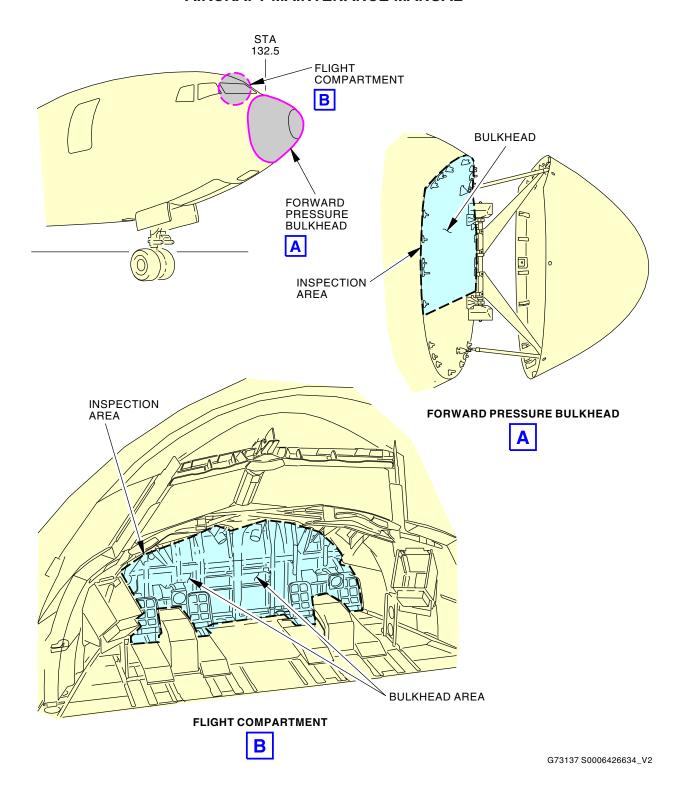
SUBTASK 53-05-03-211-026

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Forward Pressure Bulkhead (Flight Compartment)(Internal) Figure 262/53-05-03-990-843

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TASK 53-05-03-210-821

45. INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT

(Figure 263, Figure 264)

A. Inspection

SUBTASK 53-05-03-210-021

(1) Do the inspection.

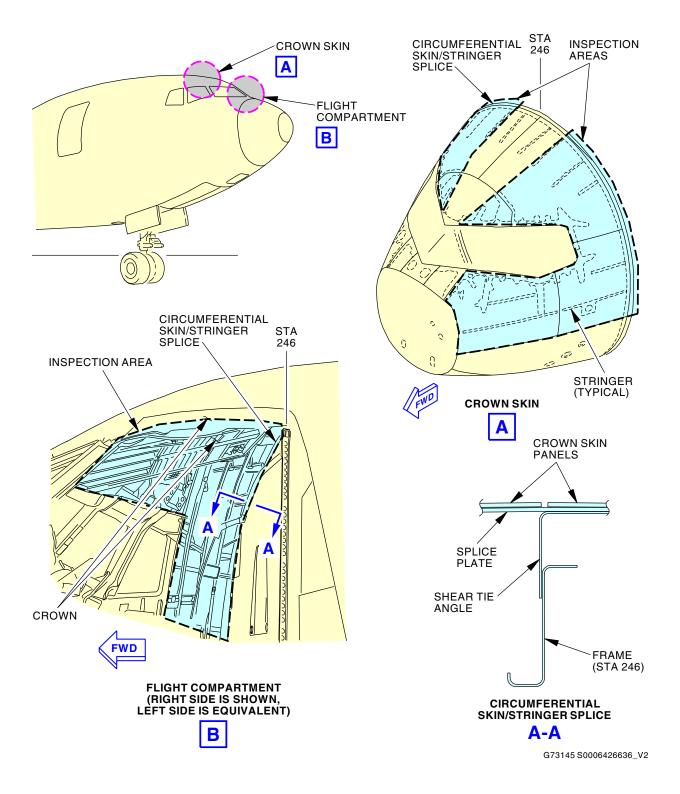
----- END OF TASK -----

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Circumferential Skin/Stringer Splice Sta 246 (Flight Compartment) General Visual (Internal) Figure 263/53-05-03-990-844

EFFECTIVITY

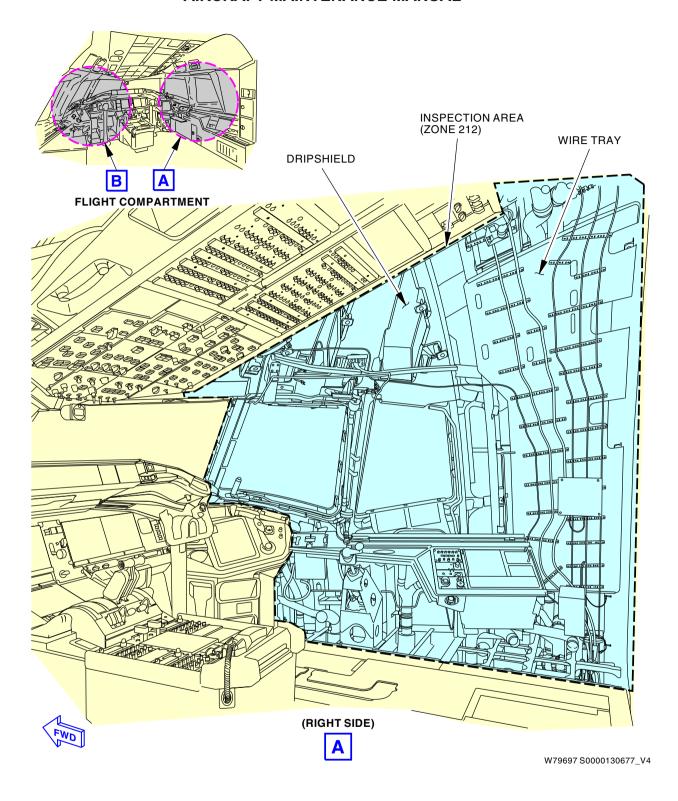
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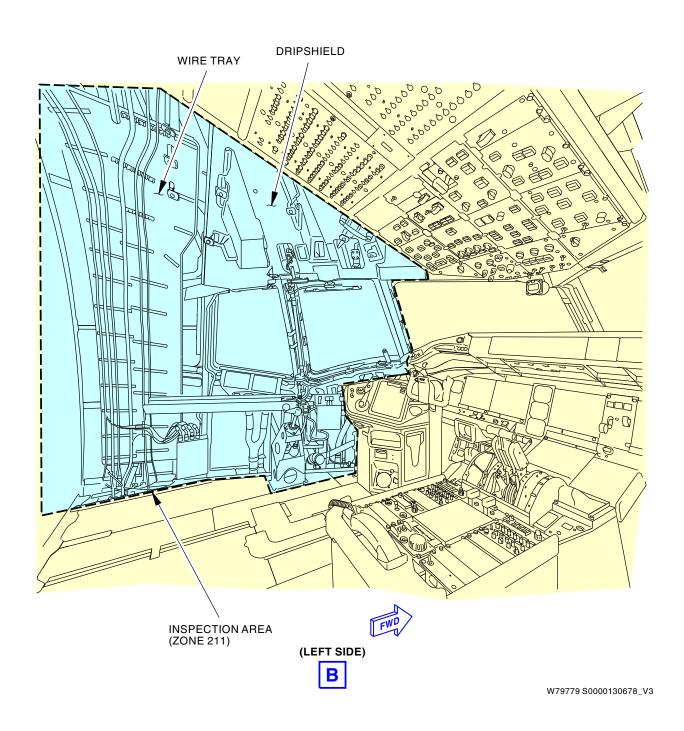
General Visual Subzone BS 126.5 To 246 (Internal) Figure 264/53-05-03-990-E78 (Sheet 1 of 2)

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General Visual Subzone BS 126.5 To 246 (Internal) Figure 264/53-05-03-990-E78 (Sheet 2 of 2)

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TASK 53-05-03-210-822

- **46.** EXTERNAL GENERAL VISUAL: PASSENGER COMPARTMENT LEFT (Figure 265)
 - A. Inspection

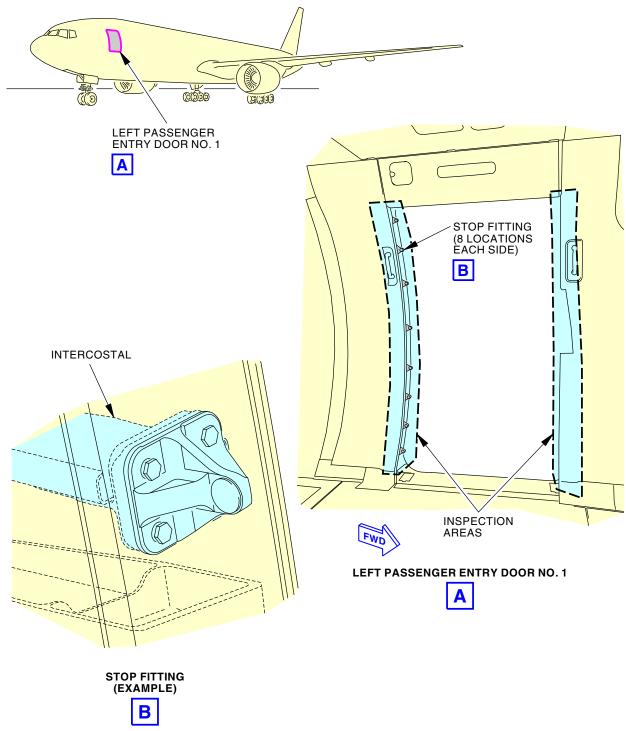
SUBTASK 53-05-03-210-022

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





G87395 S0006426638_V3

Cutout Structure, Stop Fittings and Intercostals, Left Passenger Entry Door No. 1 General Visual (External)
Figure 265/53-05-03-990-845

EFFECTIVITY

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TASK 53-05-03-210-823

47. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - RIGHT (Figure 266)

A. Inspection

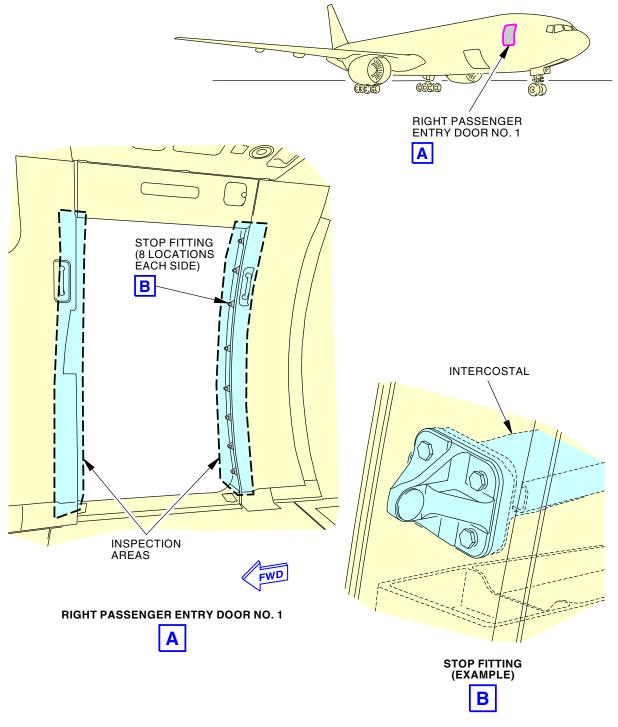
SUBTASK 53-05-03-210-023

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





G87447 S0006426640_V3

Cutout Structure, Stop Fittings and Intercostals Right Passenger Entry Door No. 1 General Visual (External)
Figure 266/53-05-03-990-846

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TASK 53-05-03-210-824

48. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - LEFT (Figure 267)

A. Inspection

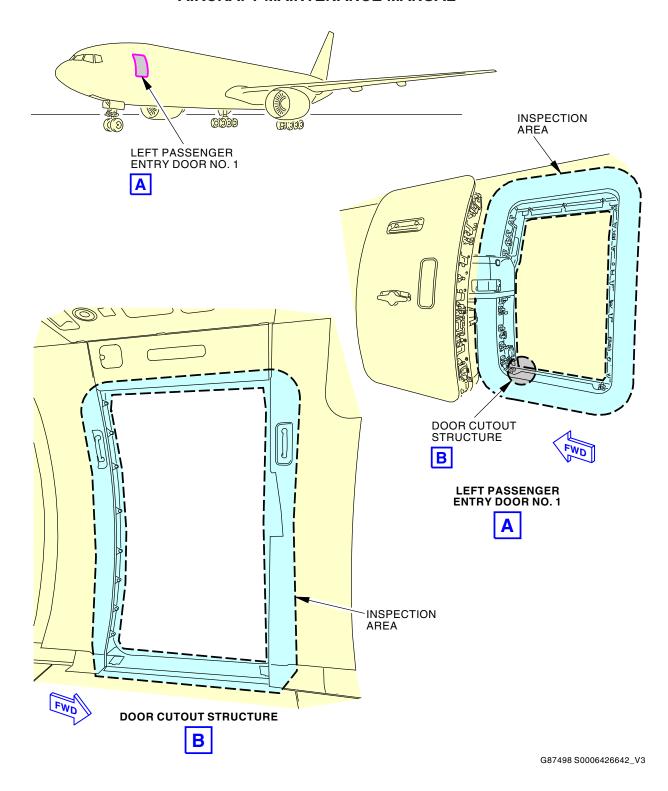
SUBTASK 53-05-03-210-024

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure Left Passenger Entry Door No. 1 General Visual (External) Figure 267/53-05-03-990-847

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TASK 53-05-03-210-825

49. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT

(Figure 268)

A. Inspection

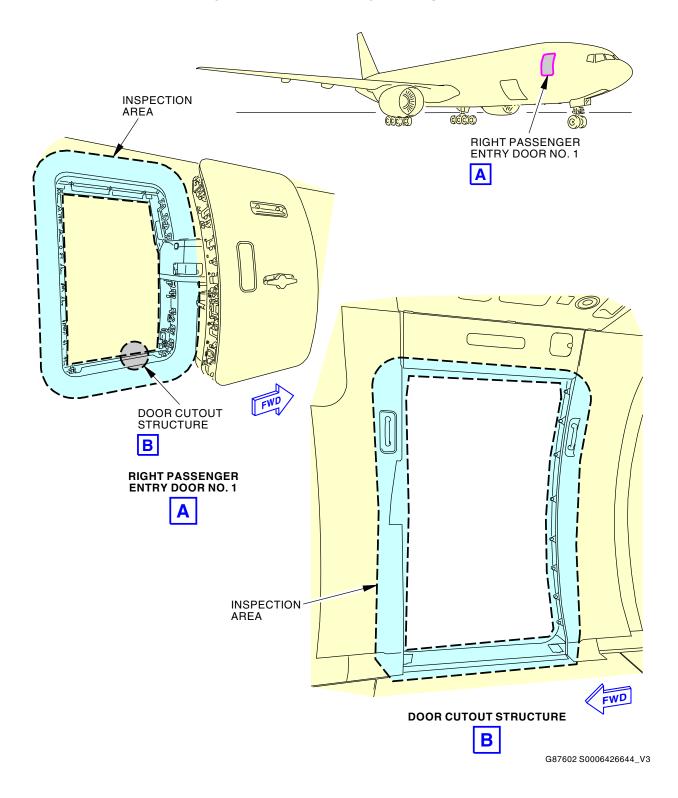
SUBTASK 53-05-03-210-025

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure Right Passenger Entry Door No. 1 General Visual (External) Figure 268/53-05-03-990-848

EFFECTIVITY

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TASK 53-05-03-210-826

50. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT (Figure 269)

A. Inspection

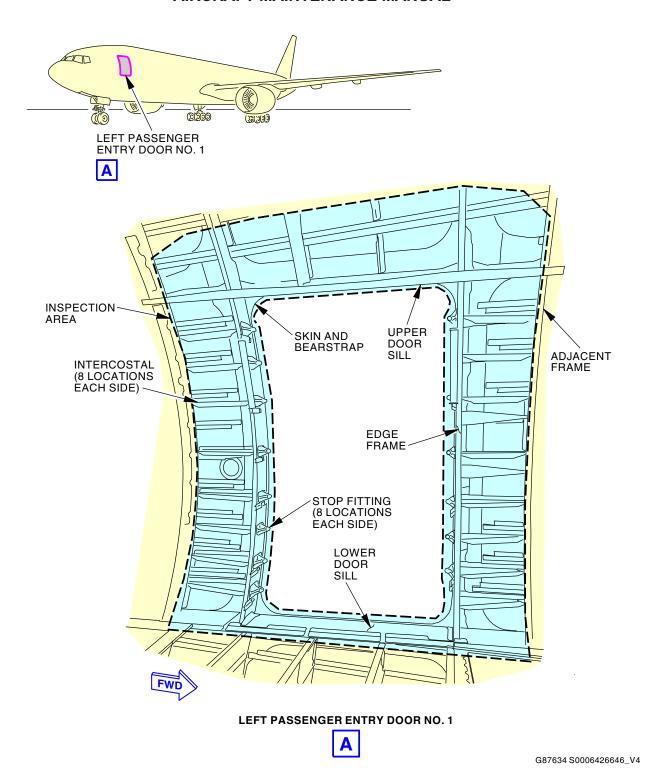
SUBTASK 53-05-03-210-026

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure, Cutout Stop Fittings and Intercostals Left Passenger Entry Door No. 1 General Visual (Internal)
Figure 269/53-05-03-990-849

EFFECTIVITY

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TASK 53-05-03-210-827

51. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT (Figure 270)

A. Inspection

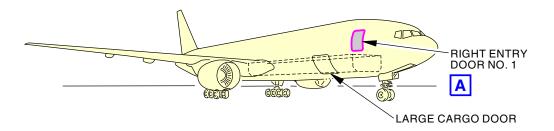
SUBTASK 53-05-03-210-027

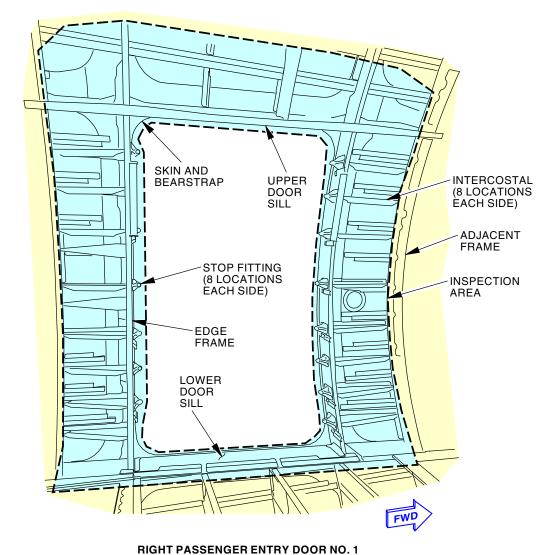
(1) Do the inspection.

----- END OF TASK -----

ARO ALL





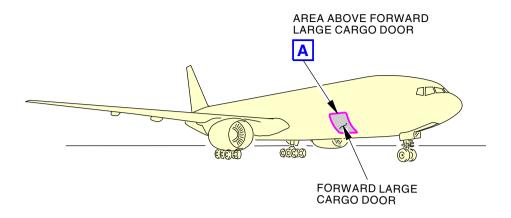


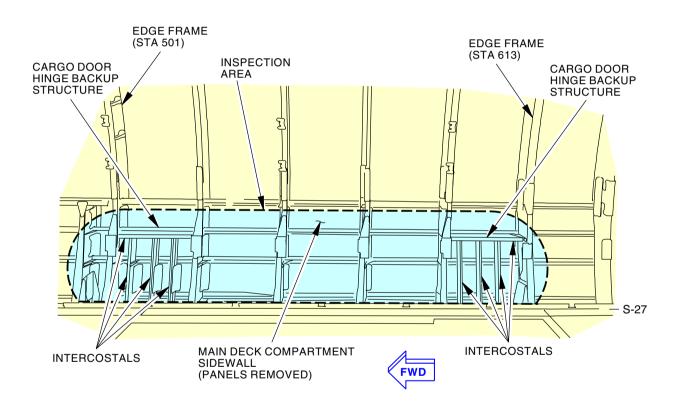
G87680 S0006426648_V5

Cutout Structure, Cutout Stop Fittings, and Intercostals Right Passenger Entry Door No. 1 General Visual (Internal) Figure 270/53-05-03-990-850 (Sheet 1 of 2)

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AREA ABOVE FORWARD LARGE CARGO DOOR (INTERIOR VIEW)



W89117 S0000132199_V4

Cutout Structure, Cutout Stop Fittings, and Intercostals Right Passenger Entry Door No. 1 General
Visual (Internal)
Figure 270/53-05-03-990-850 (Sheet 2 of 2)

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TASK 53-05-03-211-827

52. INTERNAL - DETAILED: PASSENGER COMPARTMENT

(Figure 271)

A. Inspection

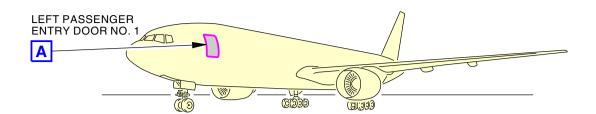
SUBTASK 53-05-03-211-027

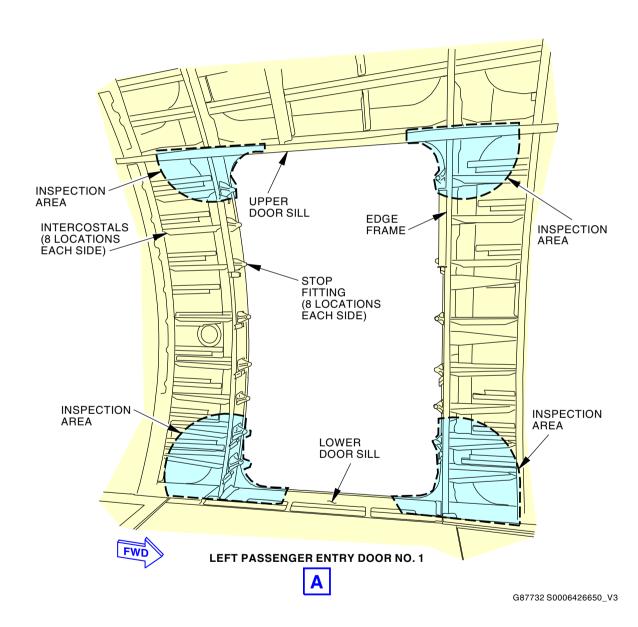
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







Cutout Structure, Cutout Stop Fittings and Intercostals Left Passenger Entry Door No. 1 (Internal) Figure 271/53-05-03-990-851

EFFECTIVITY

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TASK 53-05-03-211-828

53. INTERNAL - DETAILED: PASSENGER COMPARTMENT

(Figure 272)

A. Inspection

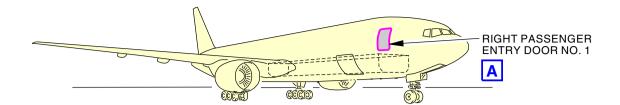
SUBTASK 53-05-03-211-028

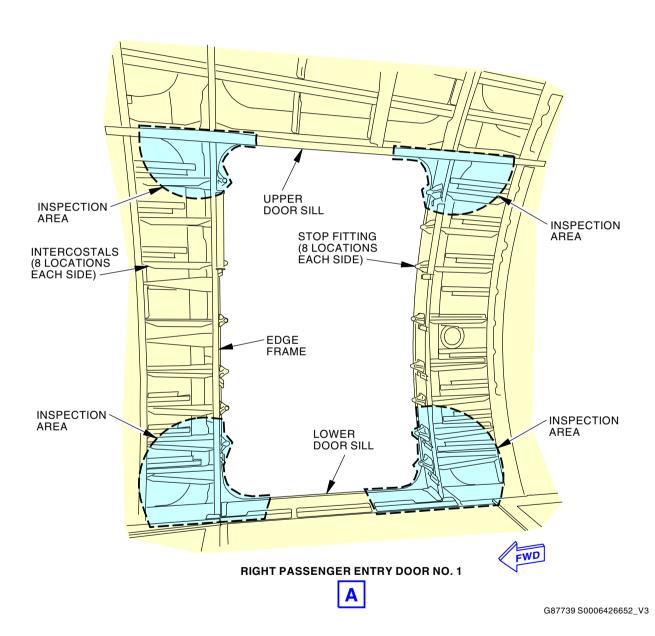
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







Cutout Structure, Cutout Stop Fittings and Intercostals Right Passenger Entry Door No. 1 (Internal) Figure 272/53-05-03-990-852

EFFECTIVITY

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TASK 53-05-03-210-828

54. EXTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING (Figure 273)

| Α. | Inc | pec | tion |
|-----|------|-----|------|
| /\· | 1113 | | |

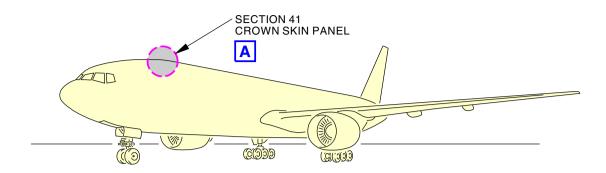
SUBTASK 53-05-03-210-028

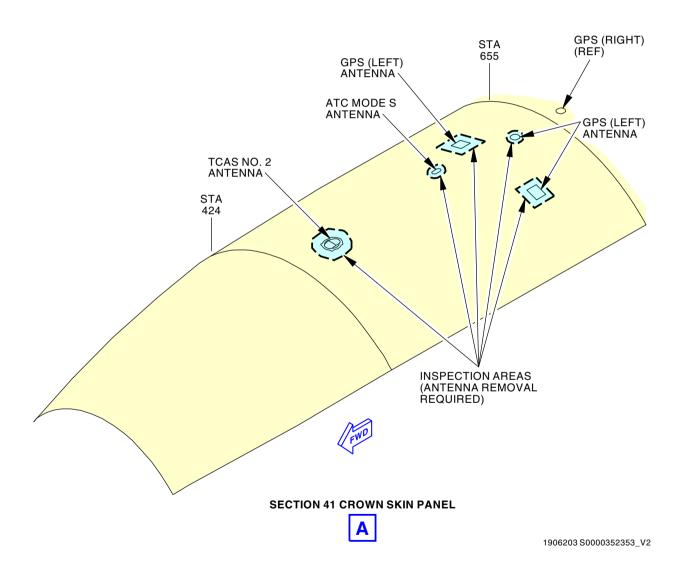
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







Fuselage Antennas Crown Skin Panel (Sta 424-655) General Visual (External) Figure 273/53-05-03-990-853

FFFECTIVITY

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TASK 53-05-03-210-829

55. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - LEFT (Figure 274)

A. Inspection

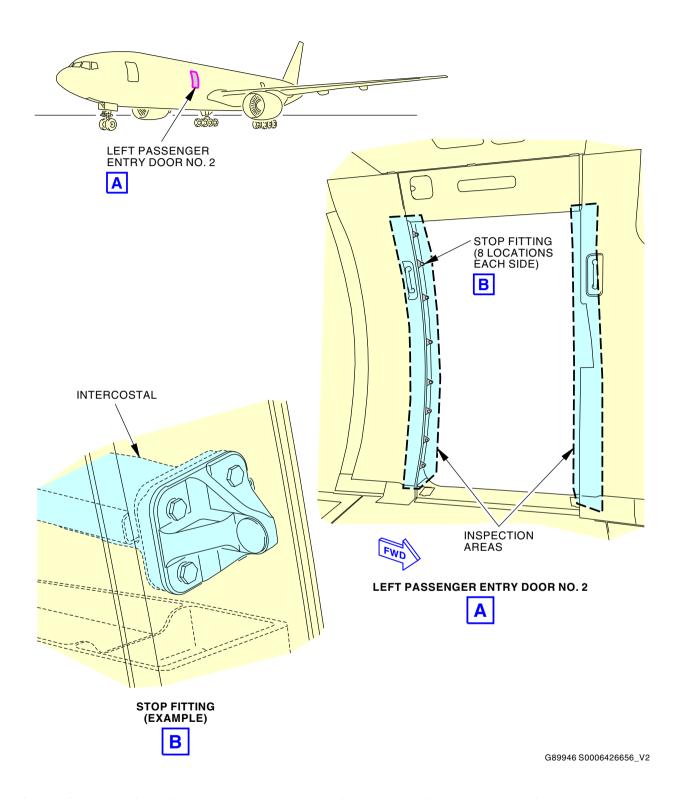
SUBTASK 53-05-03-210-029

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure, Stop Fittings and Intercostals Left Passenger Entry Door No. 2 General Visual (External)
Figure 274/53-05-03-990-854

EFFECTIVITY

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TASK 53-05-03-210-830

56. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - RIGHT (Figure 275)

A. Inspection

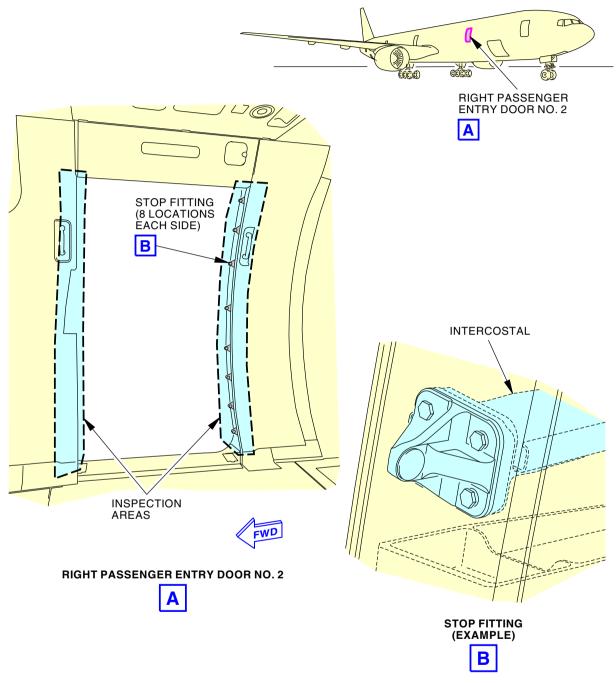
SUBTASK 53-05-03-210-030

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





G89936 S0006426658_V2

Cutout Structure, Stop Fittings and Intercostals Right Passenger Entry Door No. 2 General Visual (External)
Figure 275/53-05-03-990-855

EFFECTIVITY

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TASK 53-05-03-210-831

57. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - LEFT (Figure 276)

A. Inspection

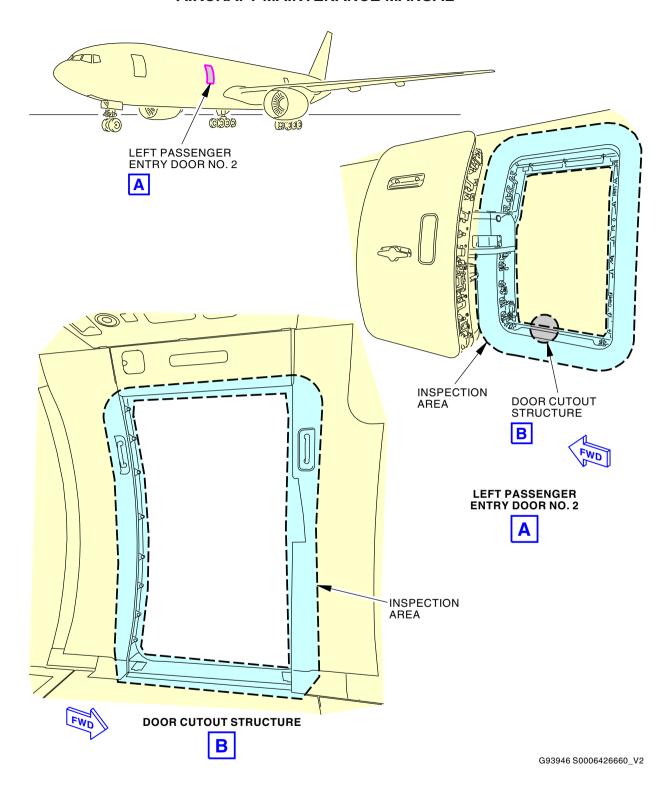
SUBTASK 53-05-03-210-031

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure Left Passenger Entry Door No. 2 General Visual (External) Figure 276/53-05-03-990-856

EFFECTIVITY

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TASK 53-05-03-210-832

58. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - RIGHT (Figure 277)

A. Inspection

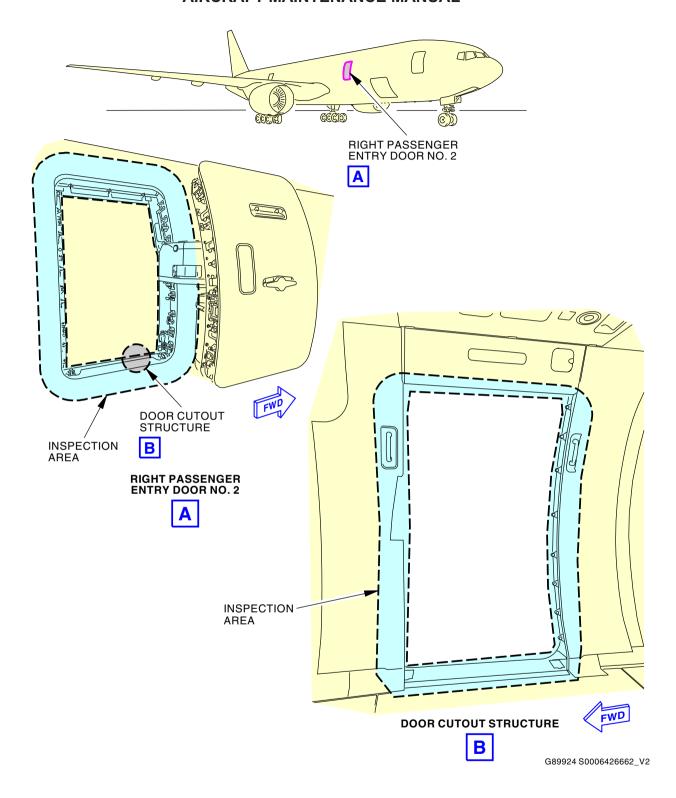
SUBTASK 53-05-03-210-032

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure Right Passenger Entry Door No. 2 General Visual (External) Figure 277/53-05-03-990-857

EFFECTIVITY

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TASK 53-05-03-211-864

59. INTERNAL - DETAILED: PASSENGER COMPARTMENT

(Figure 278)

A. Inspection

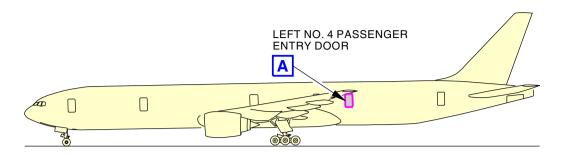
SUBTASK 53-05-03-211-112

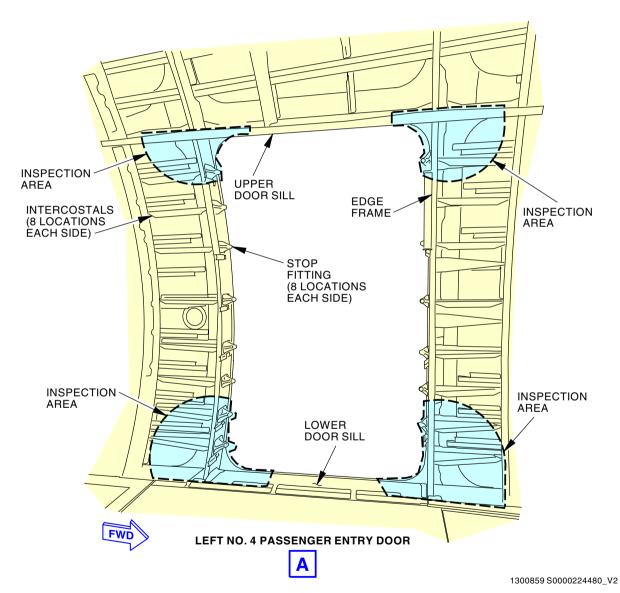
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







Cutout Structure, Cutout Stop Fittings and Intercostals Left No. 4 Passenger Entry Door (Internal) Figure 278/53-05-03-990-E71

FFFECTIVITY

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TASK 53-05-03-210-833-005

60. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - LEFT - 300ER

A. Job Set-up

SUBTASK 53-05-03-010-092

(1) Open access panels, reference Figure 279, Figure 280, Figure 281, Figure 282, Figure 283.

B. Inspection

SUBTASK 53-05-03-210-187

(1) Do the inspection.

C. Job Close-up

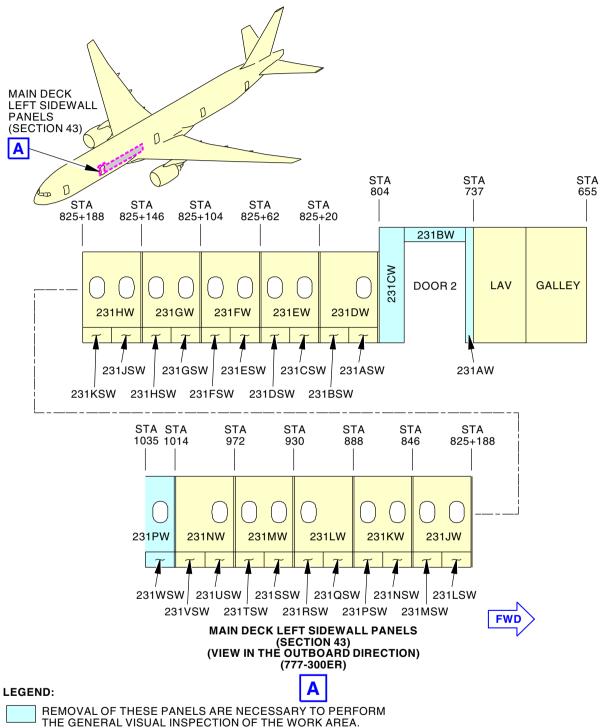
SUBTASK 53-05-03-410-092

(1) Close access panels, reference Figure 279, Figure 280, Figure 281, Figure 282, Figure 283.

----- END OF TASK -----

ARO ALL





2472630 S0000577750_V2

ZONE 231 PASSENGER CABIN SIDEWALL ACCESS PANELS Figure 279/53-05-03-990-D49 (Sheet 1 of 2)

EFFECTIVITY

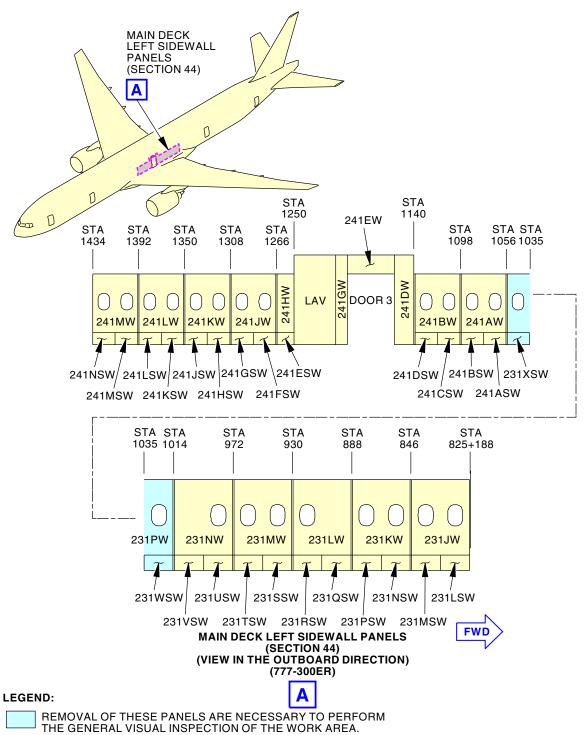
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2791852 S0000634061_V1

ZONE 231 PASSENGER CABIN SIDEWALL ACCESS PANELS Figure 279/53-05-03-990-D49 (Sheet 2 of 2)

EFFECTIVITY

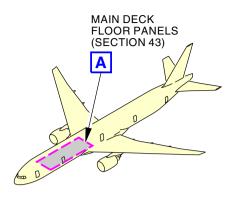
ARO ALL

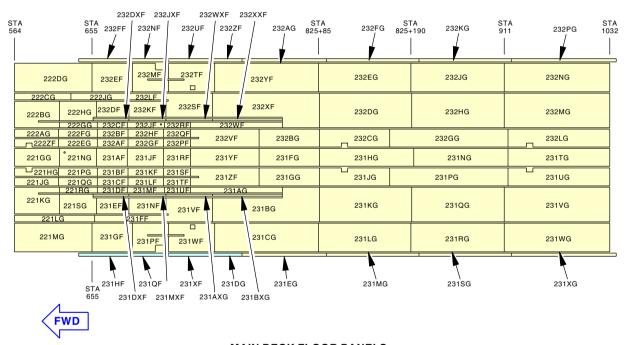
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MAIN DECK FLOOR PANELS (SECTION 43) (VIEW IN THE DOWN DIRECTION) (777-300ER)



LEGEND:

REMOVAL OF THESE PANELS ARE NECESSARY TO PERFORM THE GENERAL VISUAL INSPECTION OF THE WORK AREA.

2472649 S0000577751_V2

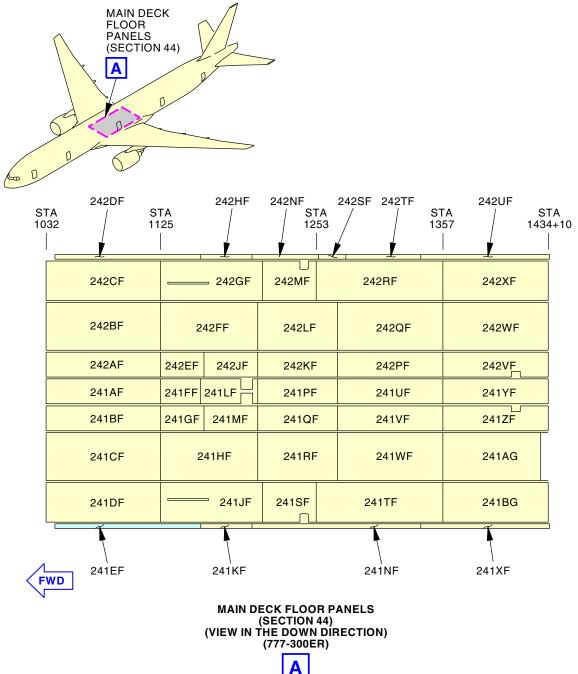
ZONE 221/222, 231/232 PASSENGER CABIN FLOOR ACCESS PANELS Figure 280/53-05-03-990-D50 (Sheet 1 of 2)

ARO ALL

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LEGEND:

REMOVAL OF THESE PANELS ARE NECESSARY TO PERFORM THE GENERAL VISUAL INSPECTION OF THE WORK AREA.

2791853 S0000634062_V1

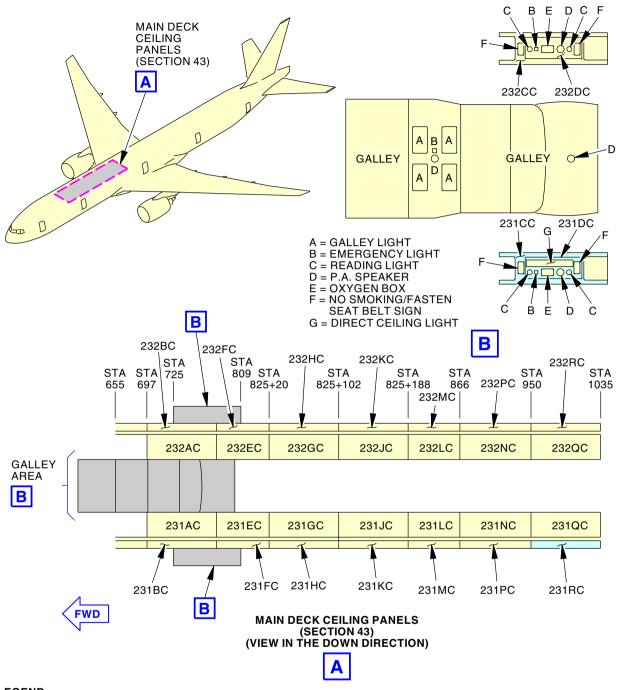
ZONE 221/222, 231/232 PASSENGER CABIN FLOOR ACCESS PANELS Figure 280/53-05-03-990-D50 (Sheet 2 of 2)

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LEGEND:

REMOVAL OF THESE PANELS ARE NECESSARY TO PERFORM THE GENERAL VISUAL INSPECTION OF THE WORK AREA.

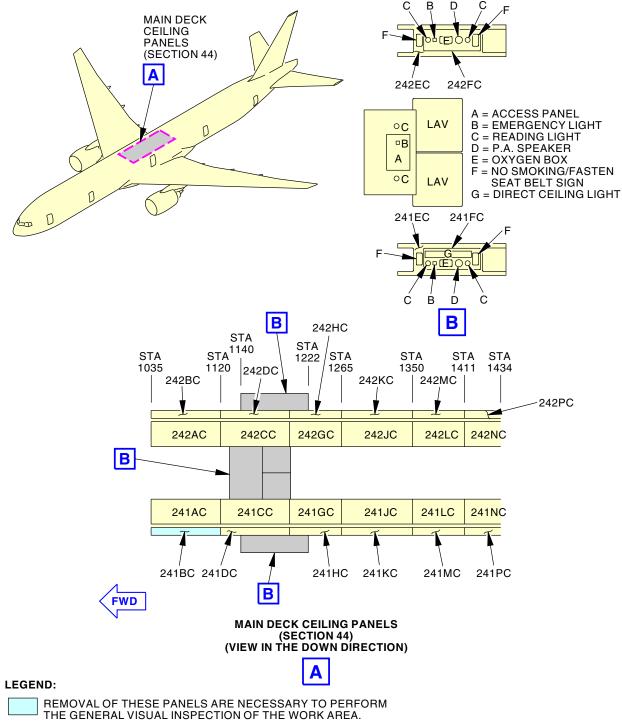
2472658 S0000577752_V3

ZONE 231/232 PASSENGER CABIN CEILING PANELS Figure 281/53-05-03-990-D51 (Sheet 1 of 2)

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2791854 S0000634071_V2

ZONE 231/232 PASSENGER CABIN CEILING PANELS Figure 281/53-05-03-990-D51 (Sheet 2 of 2)

EFFECTIVITY

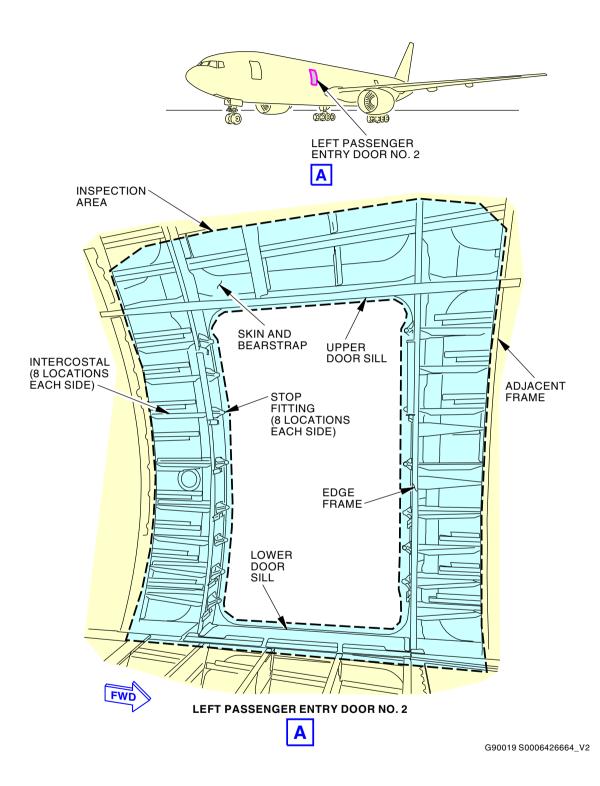
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Cutout Structure, Cutout Stop Fittings and Intercostals Left Passenger Entry Door No. 2 General Visual (Internal)

Figure 282/53-05-03-990-D52

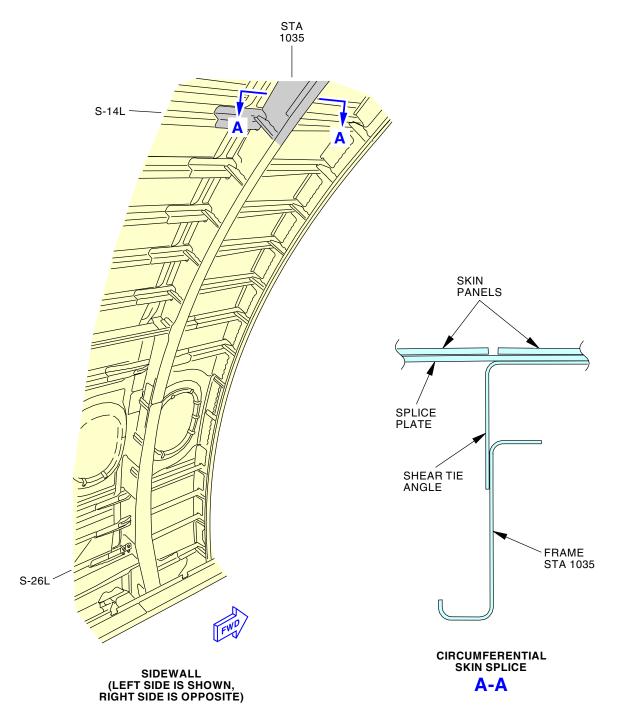
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D74988 S0000163932_V2

Passenger Compartment Fuselage Structure (Sta 1035) Gen. Visual (Int) Figure 283/53-05-03-990-D53

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TASK 53-05-03-210-834-005

61. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - RIGHT - 300ER

A. Job Set-up

SUBTASK 53-05-03-010-082

(1) Open access panels, reference Figure 284, Figure 285, Figure 286, Figure 287, Figure 288.

B. Inspection

SUBTASK 53-05-03-210-182

(1) Do the inspection.

C. Job Close-up

SUBTASK 53-05-03-410-082

(1) Close access panels, reference Figure 284, Figure 285, Figure 286, Figure 287, Figure 288.

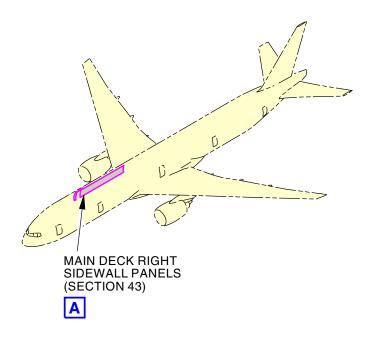
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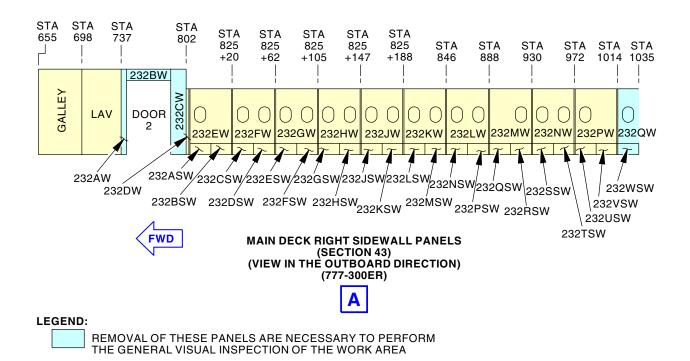
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2474506 S0000577573_V2

ZONE 232 PASSENGER CABIN SIDEWALL ACCESS PANELS Figure 284/53-05-03-990-C81 (Sheet 1 of 2)

EFFECTIVITY

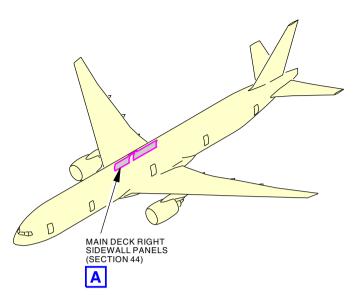
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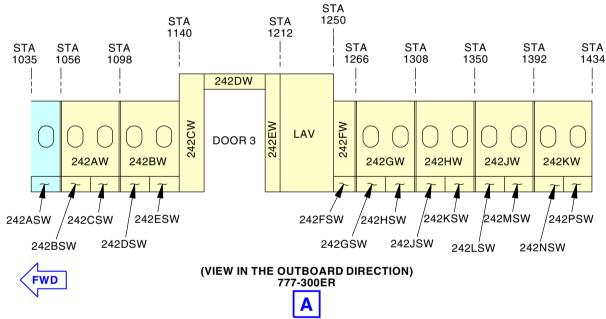
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LEGEND:

REMOVAL OF THESE PANELS ARE NECESSARY TO PERFORM THE GENERAL VISUAL INSPECTION OF THE WORK AREA

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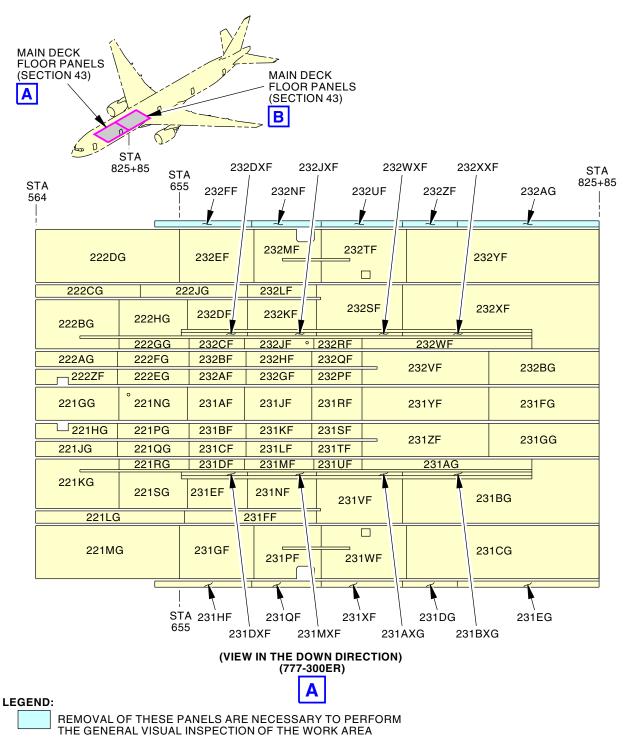
ZONE 232 PASSENGER CABIN SIDEWALL ACCESS PANELS Figure 284/53-05-03-990-C81 (Sheet 2 of 2)

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2474508 S0000577574_V2

ZONE 221/222, 231/232 PASSENGER CABIN FLOOR ACCESS PANELS Figure 285/53-05-03-990-C82 (Sheet 1 of 3)

EFFECTIVITY

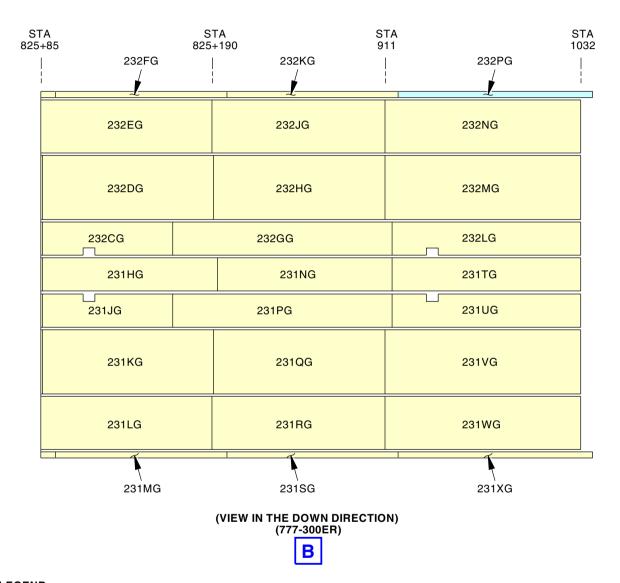
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LEGEND:

REMOVAL OF THESE PANELS ARE NECESSARY TO PERFORM THE GENERAL VISUAL INSPECTION OF THE WORK AREA

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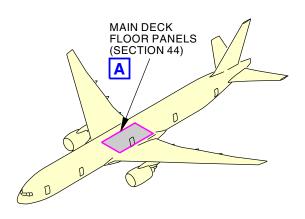
ZONE 221/222, 231/232 PASSENGER CABIN FLOOR ACCESS PANELS Figure 285/53-05-03-990-C82 (Sheet 2 of 3)

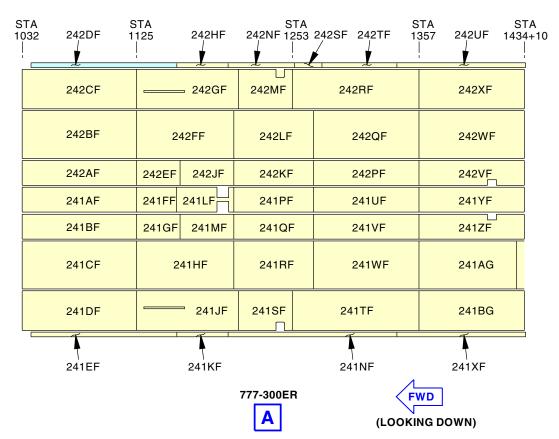
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LEGEND:

REMOVAL OF THESE PANELS ARE NECESSARY TO PERFORM THE GENERAL VISUAL INSPECTION OF THE WORK AREA

2632170 S0000627002_V1

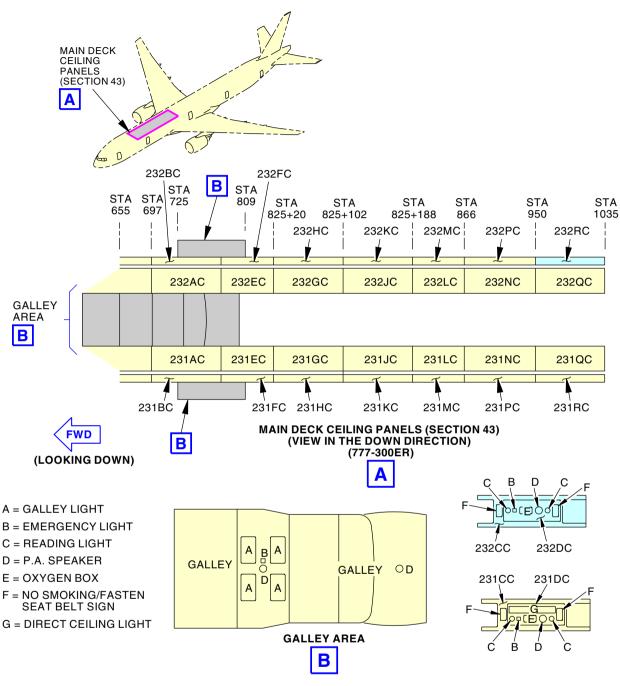
ZONE 221/222, 231/232 PASSENGER CABIN FLOOR ACCESS PANELS Figure 285/53-05-03-990-C82 (Sheet 3 of 3)

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LEGEND:

REMOVAL OF THESE PANELS ARE NECESSARY TO PERFORM THE GENERAL VISUAL INSPECTION OF THE WORK AREA

2474511 S0000577575_V2

ZONE 231/232 PASSENGER CABIN CEILING PANELS Figure 286/53-05-03-990-C83 (Sheet 1 of 2)

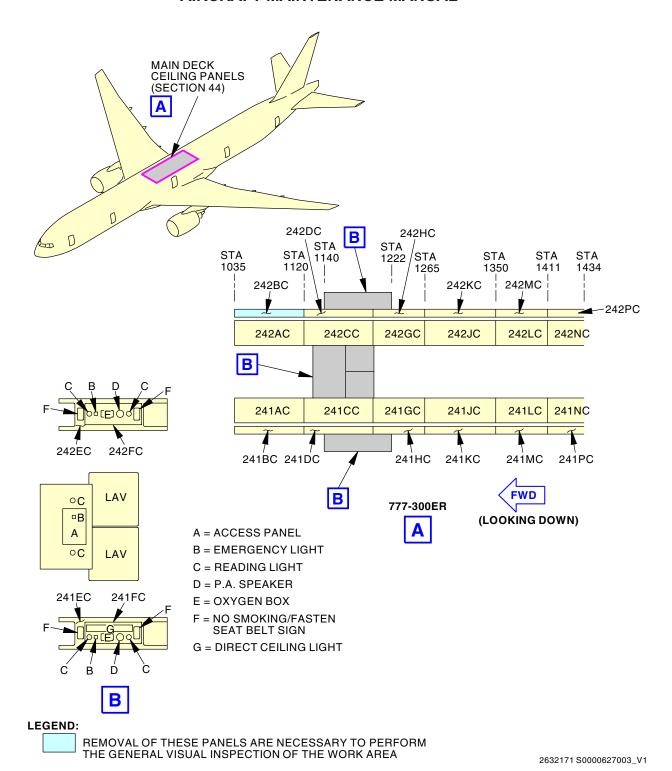
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ZONE 231/232 PASSENGER CABIN CEILING PANELS Figure 286/53-05-03-990-C83 (Sheet 2 of 2)

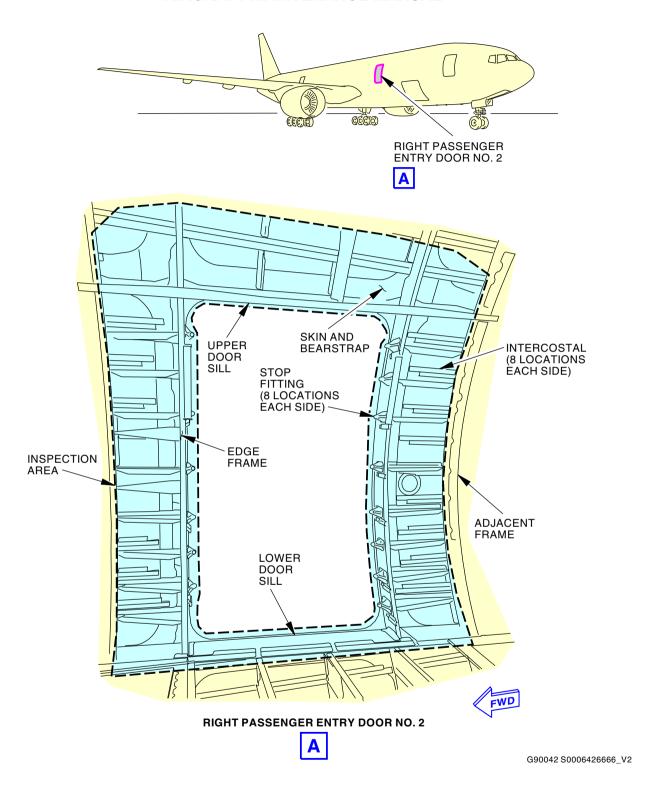
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Cutout Structure, Cutout Stop Fittings and Intercostals Right Passenger Entry Door No. 2 General Visual (Internal)
Figure 287/53-05-03-990-C84

EFFECTIVITY

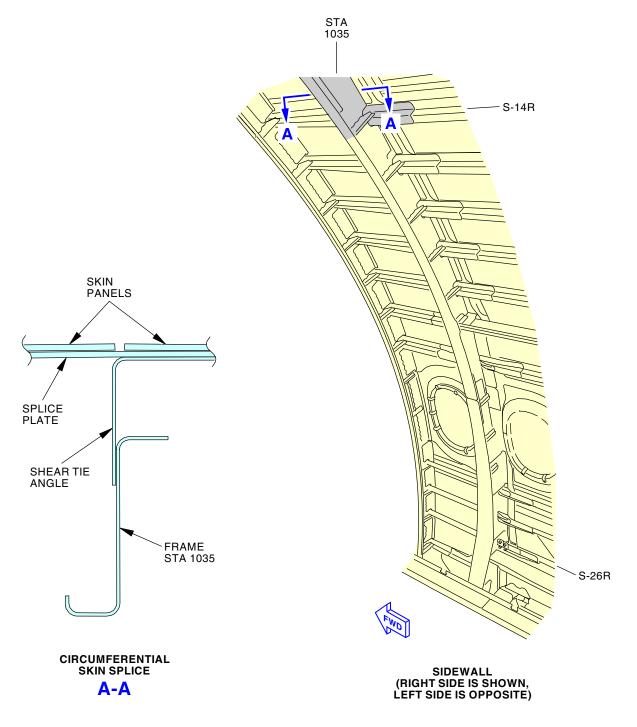
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D74994 S0000163931_V2

Passenger Compartment Fuselage Structure (Sta 1035) Gen. Visual (Int) Figure 288/53-05-03-990-C85

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TASK 53-05-03-211-829

62. INTERNAL - DETAILED: PASSENGER COMPARTMENT - LEFT

(Figure 289)

A. Inspection

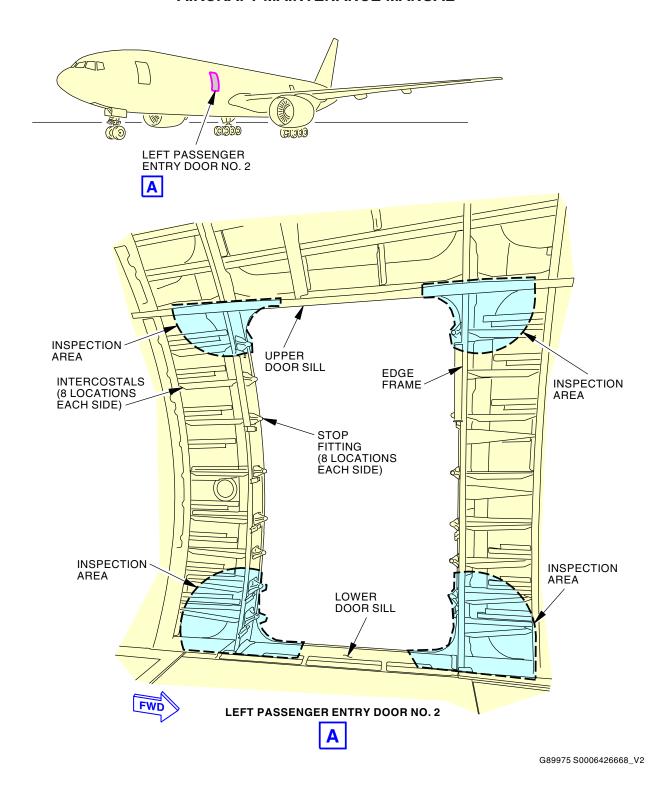
SUBTASK 53-05-03-211-029

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure, Cutout Stop Fittings and Intercostals Left Passenger Entry Door No. 2 (Internal) Figure 289/53-05-03-990-860

EFFECTIVITY

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TASK 53-05-03-211-830

63. INTERNAL - DETAILED: PASSENGER COMPARTMENT - RIGHT (Figure 290)

A. Inspection

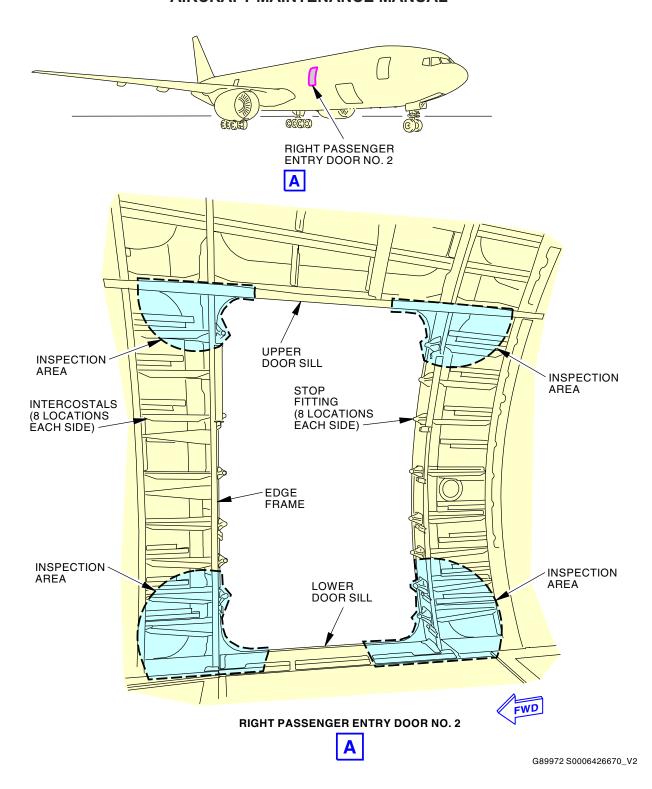
SUBTASK 53-05-03-211-030

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure, Cutout Stop Fittings and Intercostals Right Passenger Entry Door No. 2 (Internal) Figure 290/53-05-03-990-861

EFFECTIVITY

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TASK 53-05-03-210-874

- **64.** INTERNAL GENERAL VISUAL: PASSENGER COMPARTMENT LEFT (Figure 291)
 - A. Inspection

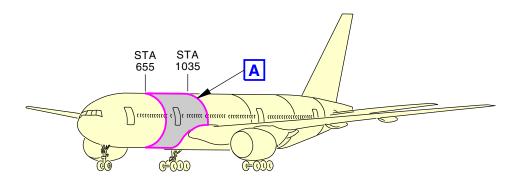
SUBTASK 53-05-03-211-031

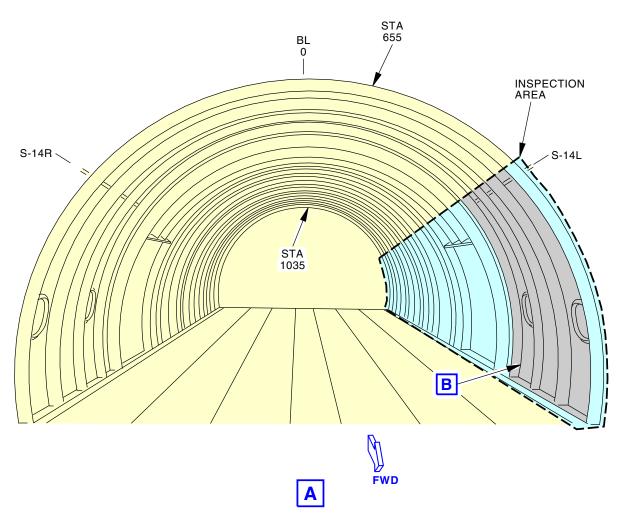
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







G93743 S0006426672_V3

Passenger Compartment Fuselage Structure (Sta 655-1035) General Visual (Internal) Figure 291/53-05-03-990-862 (Sheet 1 of 2)

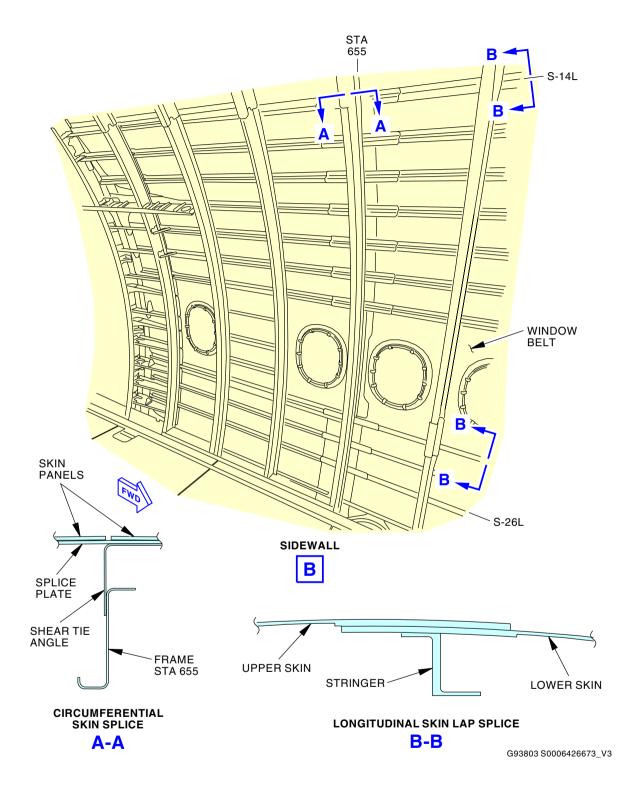
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Passenger Compartment Fuselage Structure (Sta 655-1035) General Visual (Internal) Figure 291/53-05-03-990-862 (Sheet 2 of 2)

FFFECTIVITY

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TASK 53-05-03-210-873

65. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - RIGHT (Figure 292)

A. Inspection

SUBTASK 53-05-03-210-071

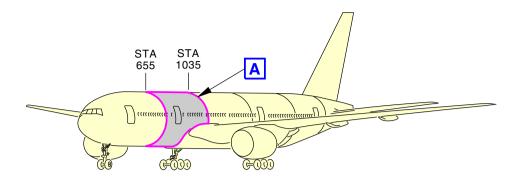
(1) Do the inspection.

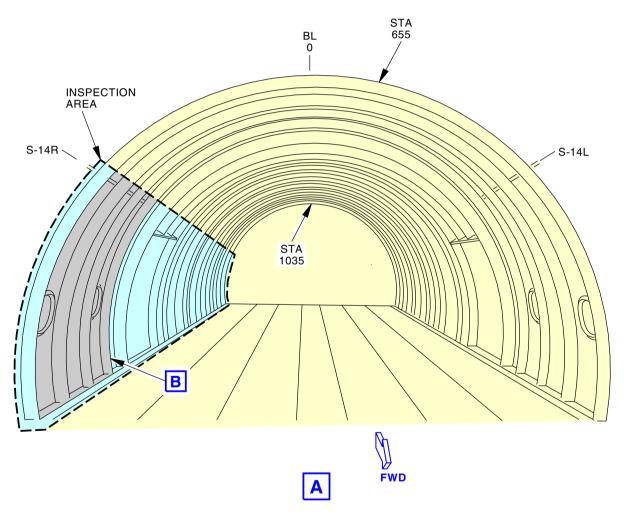
----- END OF TASK -----

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1910628 S0000354786_V2

Passenger Compartment Fuselage Structure (Sta 655-1035) General Visual (Internal) Figure 292/53-05-03-990-897 (Sheet 1 of 2)

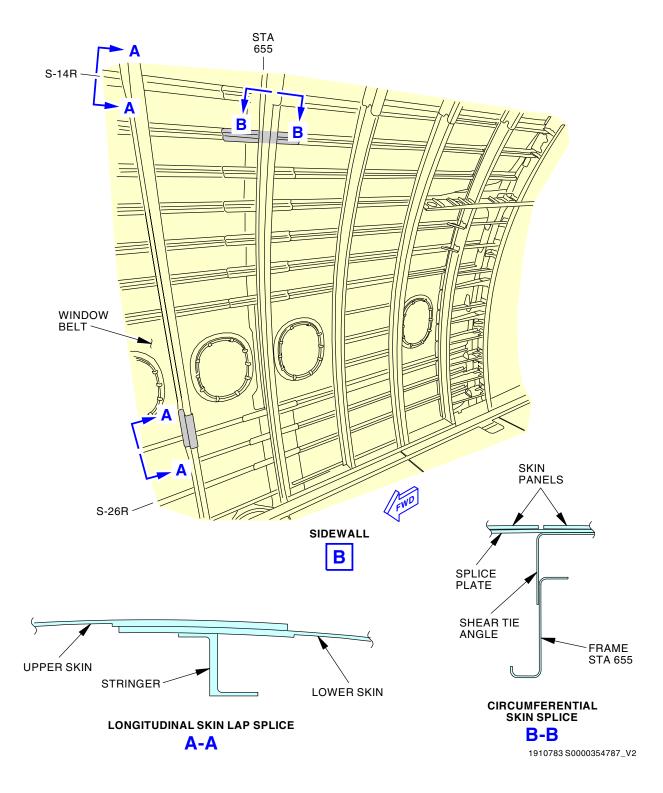
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Passenger Compartment Fuselage Structure (Sta 655-1035) General Visual (Internal) Figure 292/53-05-03-990-897 (Sheet 2 of 2)

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TASK 53-05-03-210-835

66. EXTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING (Figure 293)

| | | 4.0 |
|----|-------|-------|
| Α. | Inspe | ction |

SUBTASK 53-05-03-210-035

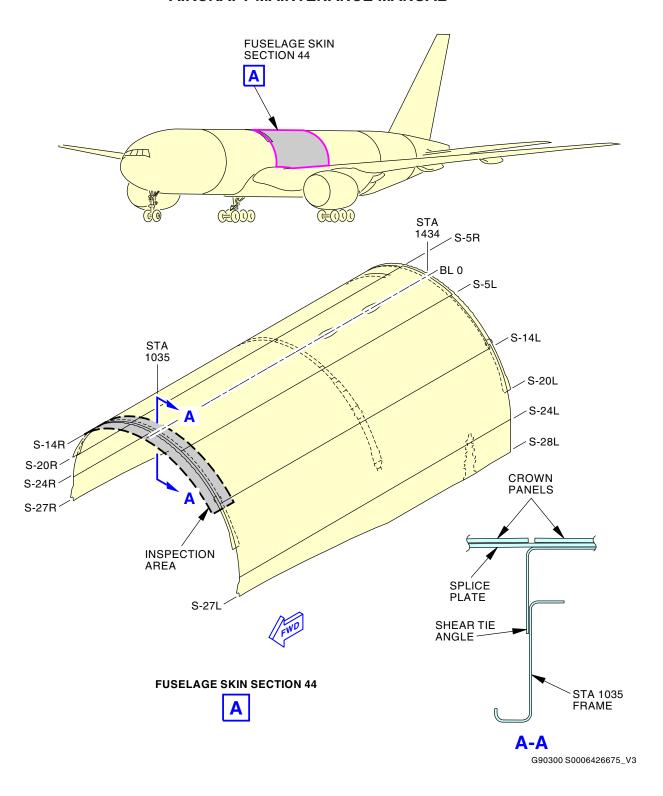
(1) Do the inspection.

——— END OF TASK ———

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Circumferential Skin/stringer Splice at Sta 1035 General Visual (External) Figure 293/53-05-03-990-863

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TASK 53-05-03-210-836

67. EXTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING (Figure 294)

| | | 4.5 |
|----|-------|-------|
| Α. | Inspe | ction |
| | | |

SUBTASK 53-05-03-210-036

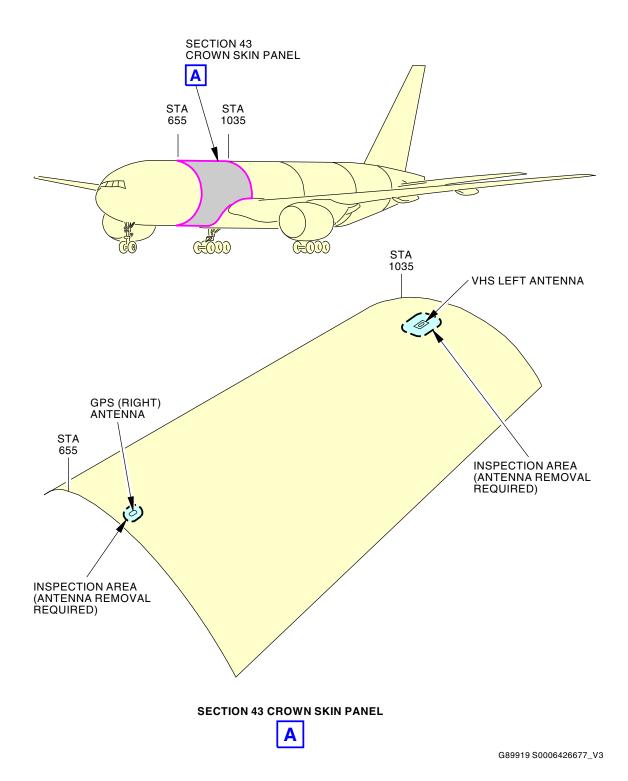
(1) Do the inspection.

----- END OF TASK -----

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Fuselage Antennas Crown Skin Panel (STA 655-1035) General Visual (External) Figure 294/53-05-03-990-864

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TASK 53-05-03-210-837-006

68. INTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING - 300ER

A. Job Set-up

SUBTASK 53-05-03-010-100

(1) Open access panels, reference Figure 295, Figure 296.

B. Inspection

SUBTASK 53-05-03-210-195

(1) Do the inspection.

C. Job Close-up

SUBTASK 53-05-03-410-100

(1) Close access panels, reference Figure 295, Figure 296.

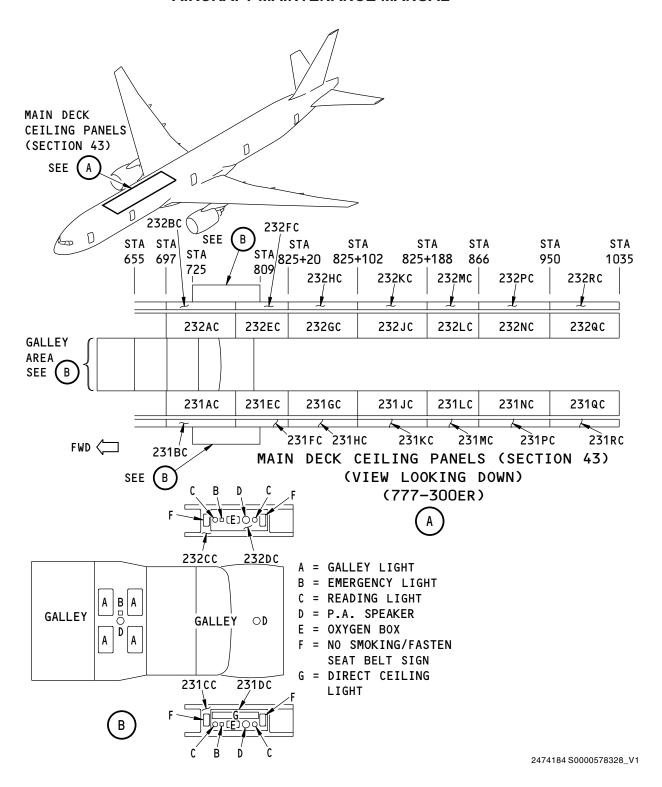
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ZONE 231/232 PASSENGER CABIN CEILING PANELS Figure 295/53-05-03-990-D84

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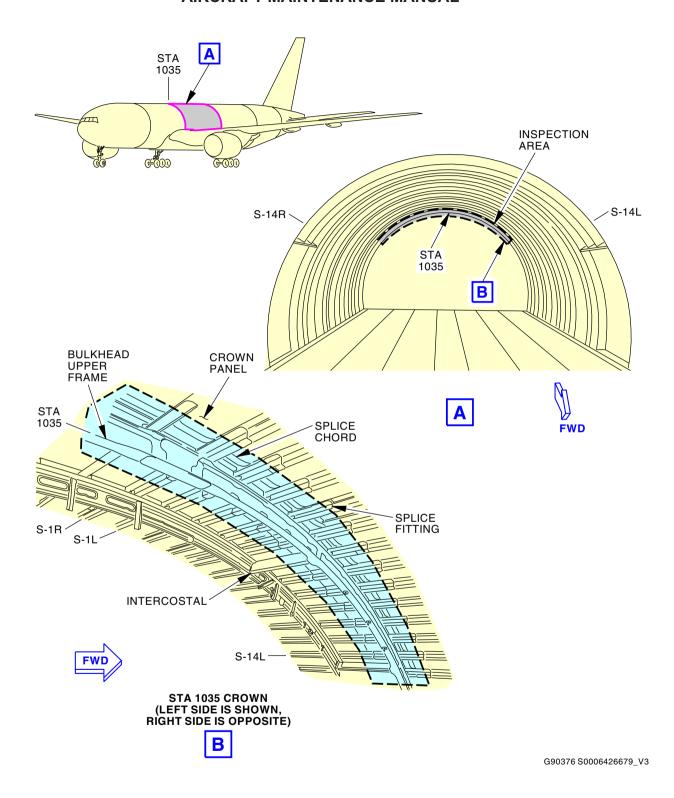
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Circumferential Skin and Stringer Splice at Sta 1035 Crown General Visual (Internal) Figure 296/53-05-03-990-D85

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TASK 53-05-03-210-838-006

69. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT -300ER

A. Job Set-up

SUBTASK 53-05-03-010-054

(1) Open access panels, reference Figure 297, Figure 298, Figure 299.

B. Inspection

SUBTASK 53-05-03-210-159

(1) Do the inspection.

C. Job Close-up

SUBTASK 53-05-03-410-054

(1) Close access panels, reference Figure 297, Figure 298, Figure 299.

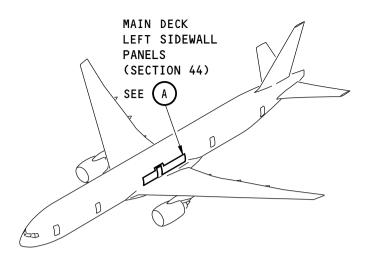
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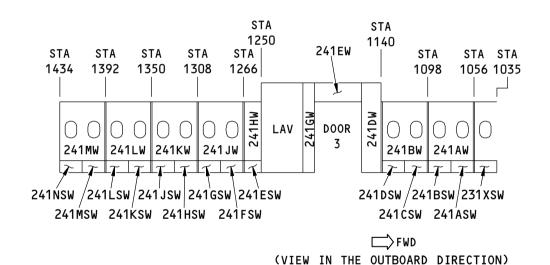
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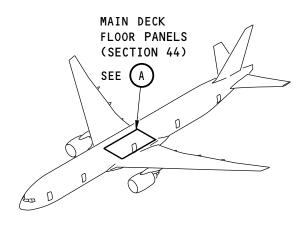
ZONE 231/241 PASSENGER CABIN SIDEWALL ACCESS PANELS Figure 297/53-05-03-990-B70

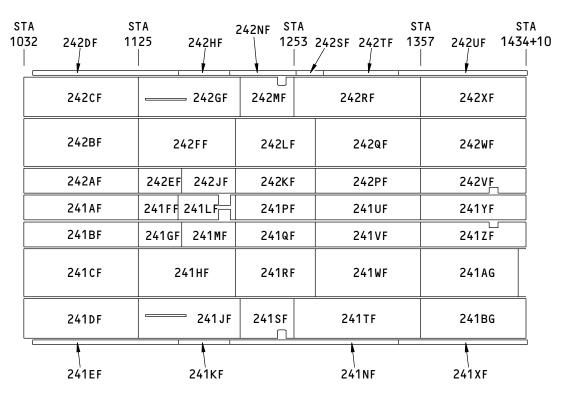
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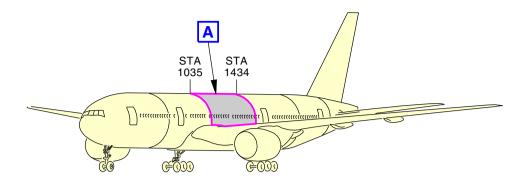
ZONE 241/242 PASSENGER CABIN FLOOR ACCESS PANELS Figure 298/53-05-03-990-B71

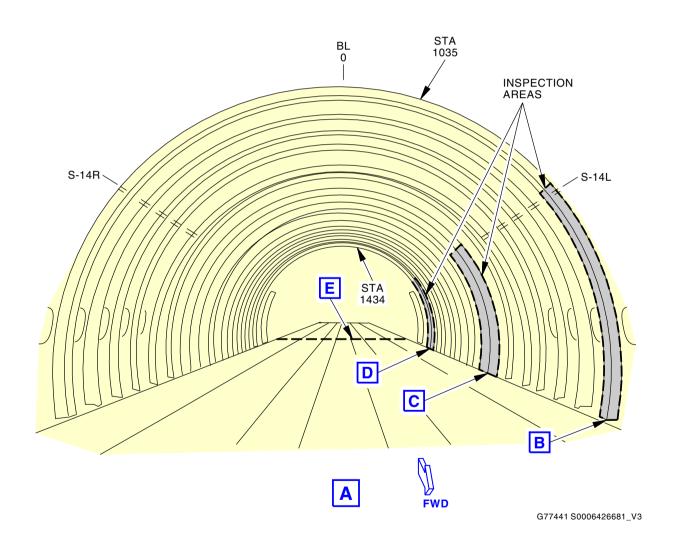
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Passenger Compartment Bulkheads and Frames (Sta 1035-1434) General Visual (Internal) Figure 299/53-05-03-990-B72 (Sheet 1 of 4)

EFFECTIVITY

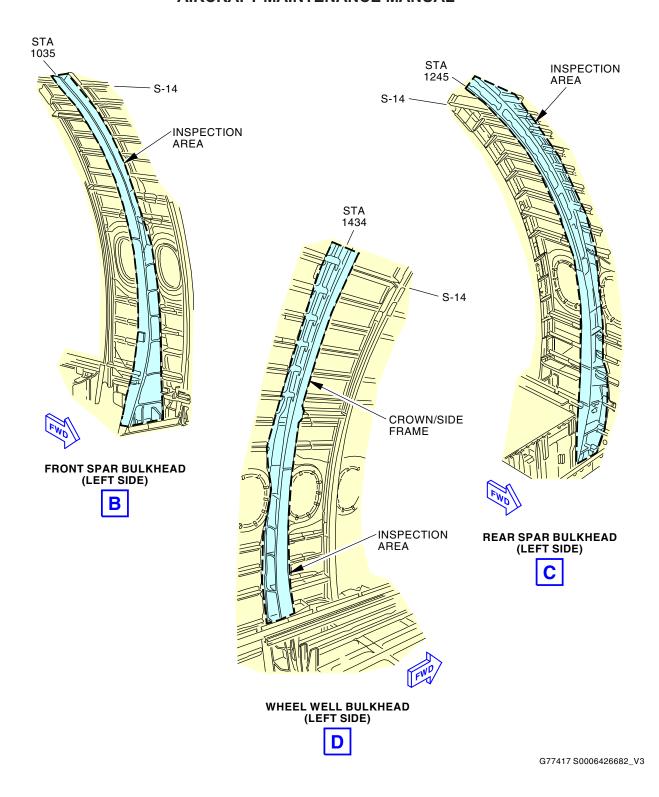
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Passenger Compartment Bulkheads and Frames (Sta 1035-1434) General Visual (Internal) Figure 299/53-05-03-990-B72 (Sheet 2 of 4)

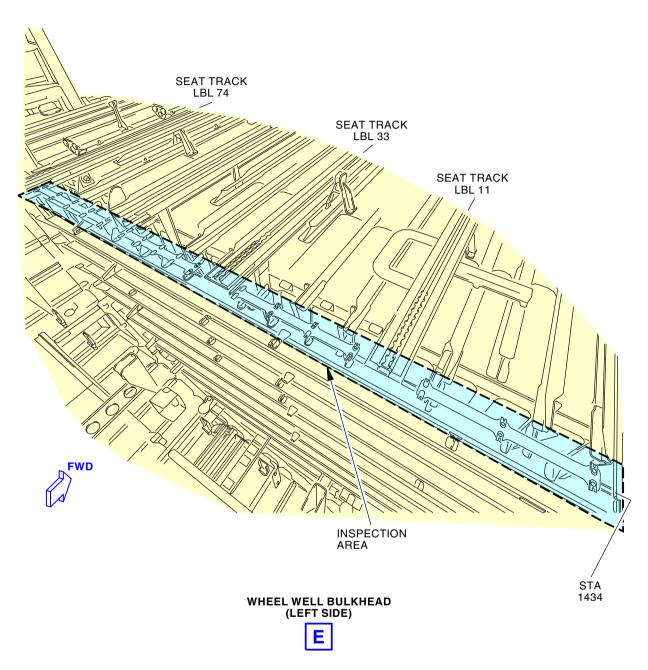
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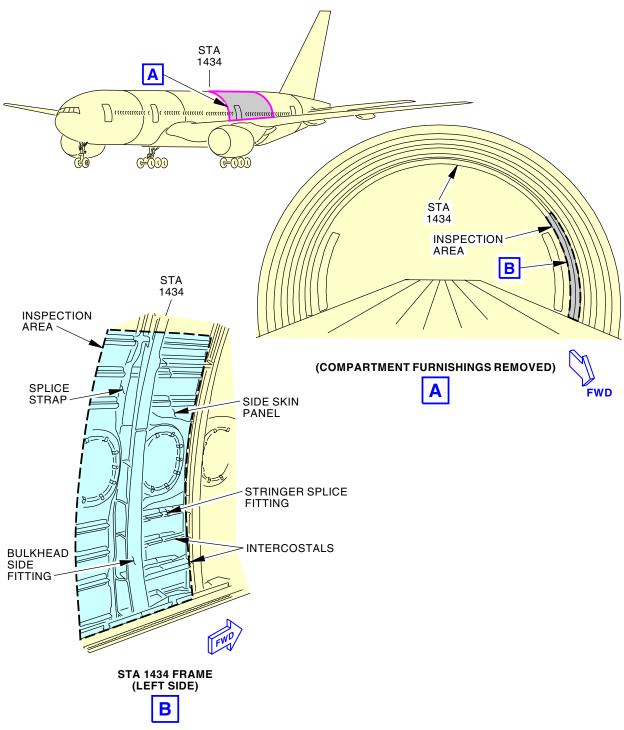
Passenger Compartment Bulkheads and Frames (Sta 1035-1434) General Visual (Internal) Figure 299/53-05-03-990-B72 (Sheet 3 of 4)

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Passenger Compartment Bulkheads and Frames (Sta 1035-1434) General Visual (Internal) Figure 299/53-05-03-990-B72 (Sheet 4 of 4)

EFFECTIVITY

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TASK 53-05-03-210-839-006

70. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - 300ER

A. Job Set-up

SUBTASK 53-05-03-010-060

(1) Open access panels, reference Figure 300, Figure 301, Figure 302.

B. Inspection

SUBTASK 53-05-03-210-165

(1) Do the inspection.

C. Job Close-up

SUBTASK 53-05-03-410-060

(1) Close access panels, reference Figure 300, Figure 301, Figure 302.

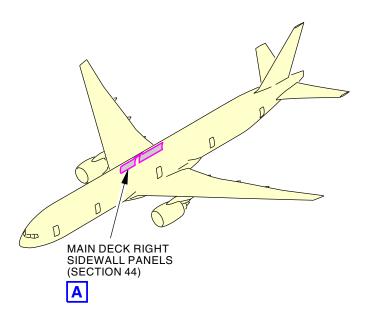
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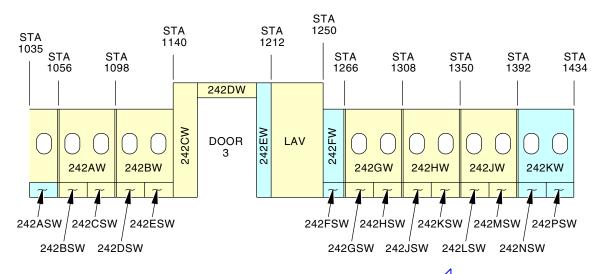
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MAIN DECK RIGHT SIDEWALL PANELS (SECTION 44) (VIEW IN THE OUTBOARD DIRECTION) 777-300ER



LEGEND:

REMOVAL OF THESE PANELS ARE NECESSARY TO PERFORM THE GENERAL VISUAL INSPECTION OF THE WORK AREA.

2471833 S0000577067_V2

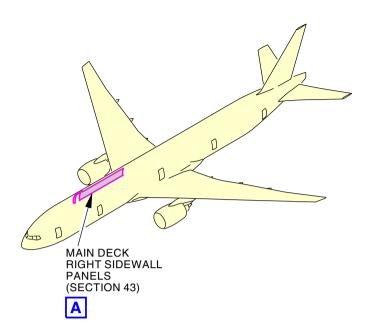
ZONE 242 PASSENGER CABIN SIDEWALL ACCESS PANELS Figure 300/53-05-03-990-B92 (Sheet 1 of 3)

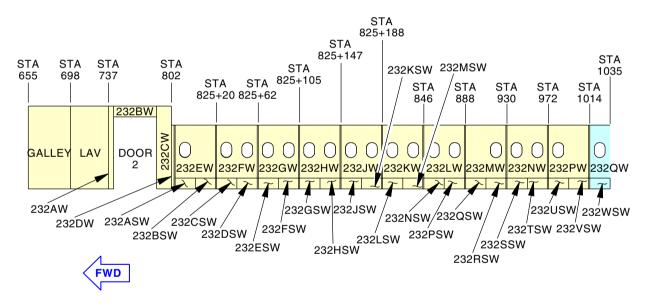
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(LOOKING OUTBOARD) 777-300ER

LEGEND:

REMOVAL OF THESE PANELS ARE NECESSARY TO PERFORM THE GENERAL VISUAL INSPECTION OF THE WORK AREA.

2678624 S0000627263_V1

ZONE 242 PASSENGER CABIN SIDEWALL ACCESS PANELS Figure 300/53-05-03-990-B92 (Sheet 2 of 3)

EFFECTIVITY

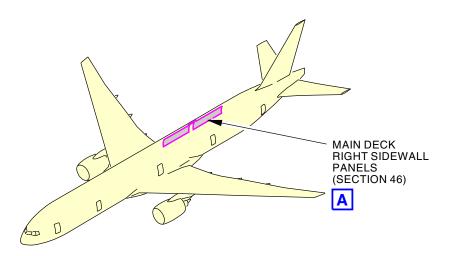
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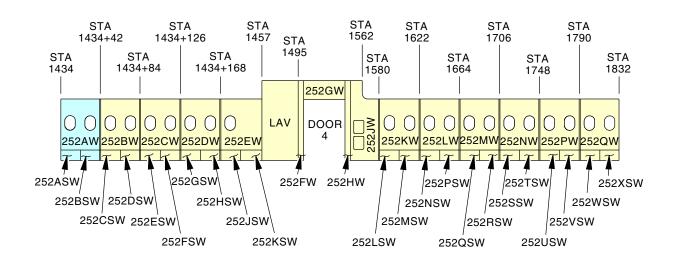
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MAIN DECK RIGHT SIDEWALL PANELS (SECTION 46) (VIEW IN THE OUTBOARD DIRECTION) 777-300ER



LEGEND:

REMOVAL OF THESE PANELS ARE NECESSARY TO PERFORM THE GENERAL VISUAL INSPECTION OF THE WORK AREA.

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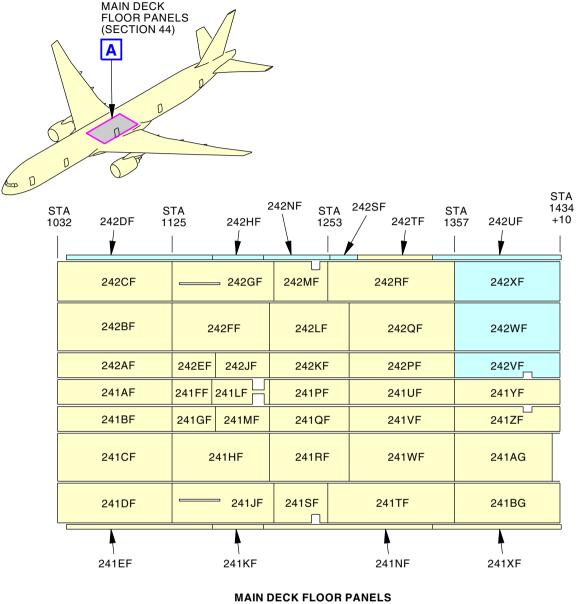
ZONE 242 PASSENGER CABIN SIDEWALL ACCESS PANELS Figure 300/53-05-03-990-B92 (Sheet 3 of 3)

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53-05-03

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MAIN DECK FLOOR PANELS (SECTION 44) (VIEW IN THE DOWN DIRECTION) 777-300ER



LEGEND:

REMOVAL OF THESE PANELS ARE NECESSARY TO PERFORM THE GENERAL VISUAL INSPECTION OF THE WORK AREA.

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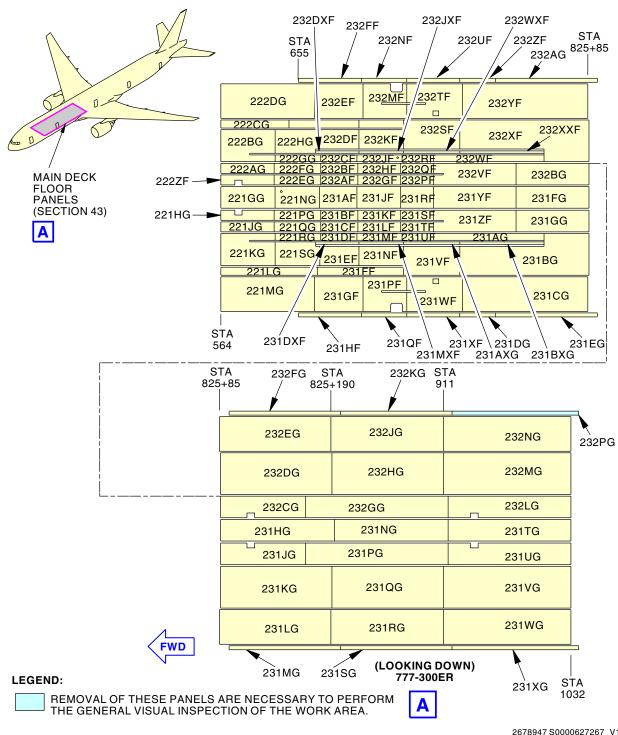
ZONE 241/242 PASSENGER CABIN FLOOR ACCESS PANELS Figure 301/53-05-03-990-B93 (Sheet 1 of 3)

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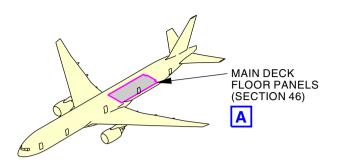


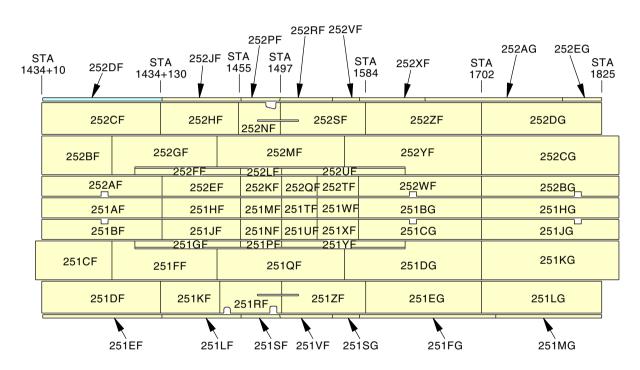
2678947 S0000627267_V1

ZONE 241/242 PASSENGER CABIN FLOOR ACCESS PANELS Figure 301/53-05-03-990-B93 (Sheet 2 of 3)

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LEGEND:

REMOVAL OF THESE PANELS ARE NECESSARY TO PERFORM THE GENERAL VISUAL INSPECTION OF THE WORK AREA.

2678966 S0000627269_V1

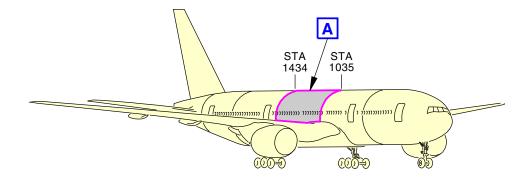
ZONE 241/242 PASSENGER CABIN FLOOR ACCESS PANELS Figure 301/53-05-03-990-B93 (Sheet 3 of 3)

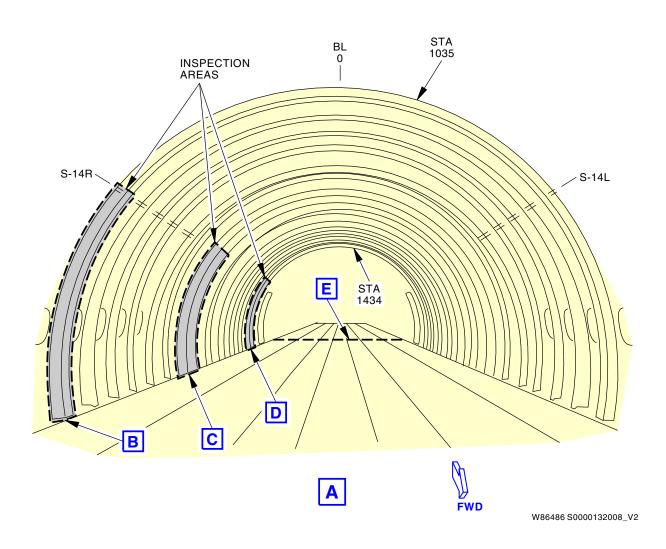
ARO ALL
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Passenger Compartment Bulkheads and Frames (Sta 1035-1434) Figure 302/53-05-03-990-B94 (Sheet 1 of 4)

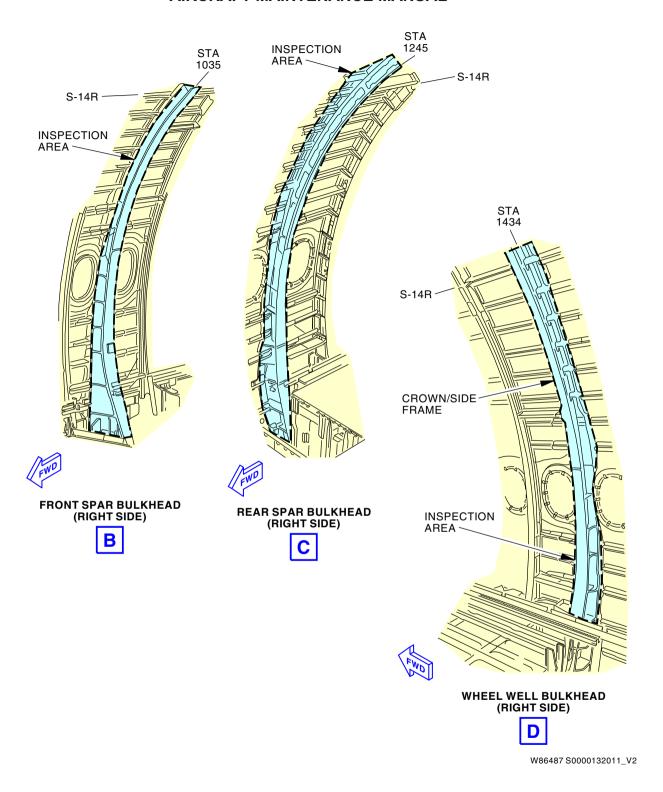
ARO ALL

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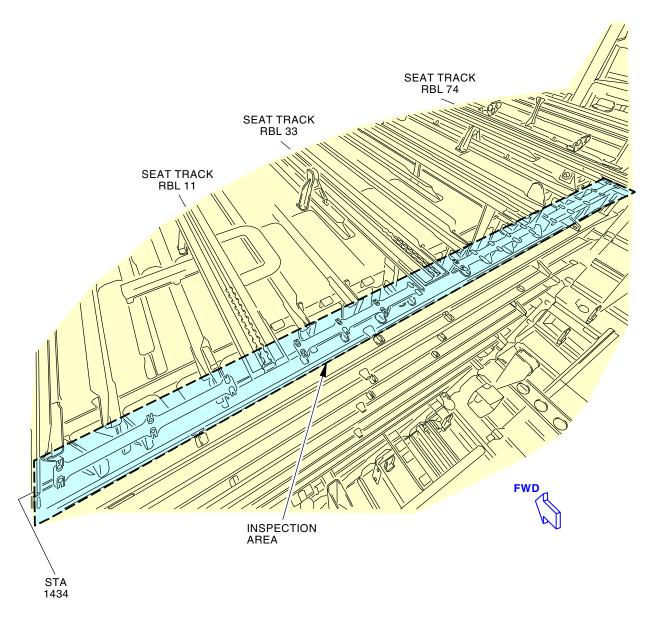
Passenger Compartment Bulkheads and Frames (Sta 1035-1434) Figure 302/53-05-03-990-B94 (Sheet 2 of 4)

STAND ALL Page 298.118

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WHEEL WELL BULKHEAD (RIGHT SIDE)



W86488 S0000132012_V3

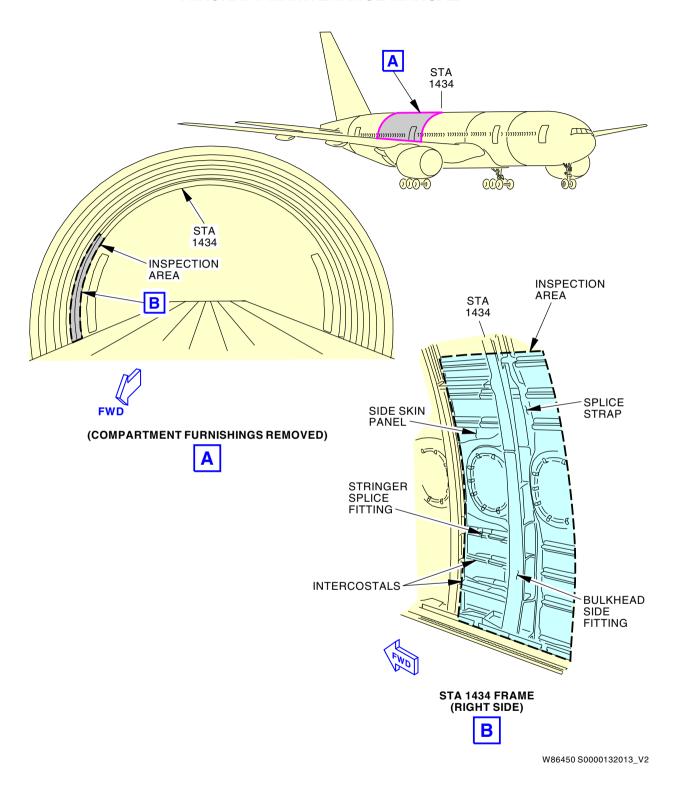
Passenger Compartment Bulkheads and Frames (Sta 1035-1434) Figure 302/53-05-03-990-B94 (Sheet 3 of 4)

ARO ALL
D633W101-ARO

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Passenger Compartment Bulkheads and Frames (Sta 1035-1434) Figure 302/53-05-03-990-B94 (Sheet 4 of 4)

EFFECTIVITY

ARO ALL

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TASK 53-05-03-210-840

71. EXTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING (Figure 303)

| Α. | Inc | nar | ction | |
|----|------|-----|-------|---|
| Λ. | 1113 | pet | LIOII | ı |

SUBTASK 53-05-03-210-040

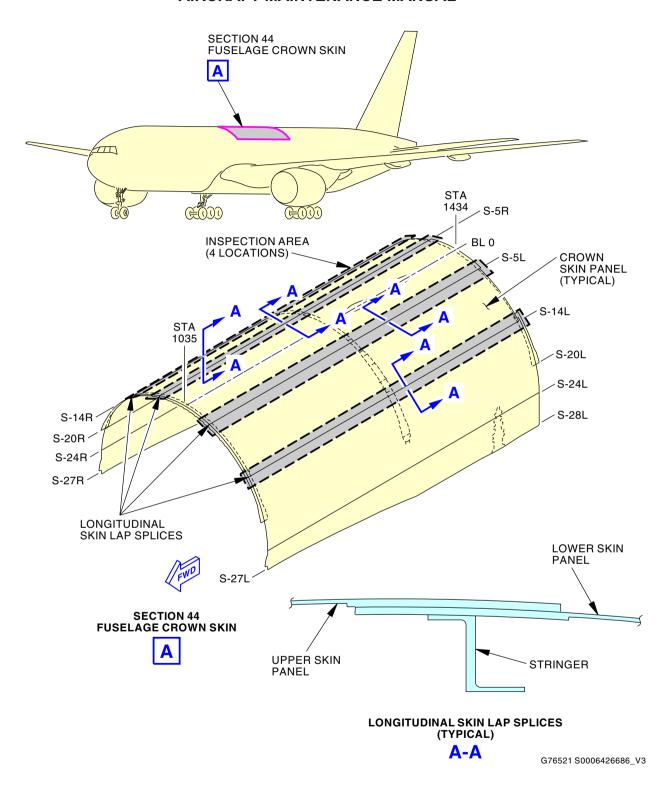
(1) Do the inspection.

----- END OF TASK -----

ARO ALL

53-05-03





Longitudinal Skin Lap Splices (Area Above Passenger Compartment Ceiling - Section 44) General Visual (External)
Figure 303/53-05-03-990-867

FARO ALL

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TASK 53-05-03-210-841

72. INTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING (Figure 304)

| Α. | Inc | nec | tion |
|----|------|-----|------|
| Λ. | 1113 | ԻԵՆ | uon |

SUBTASK 53-05-03-210-041

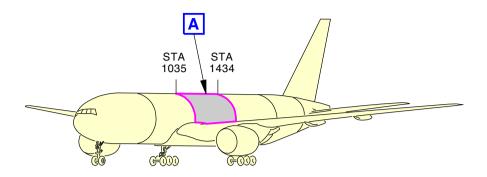
(1) Do the inspection.

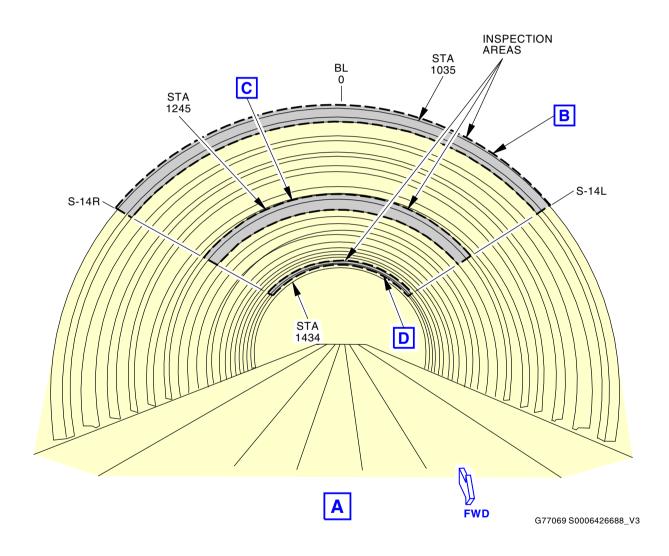
----- END OF TASK -----

ARO ALL

53-05-03







Passenger Compartment Ceiling Panels Sta (1035-1434) General Visual (Internal) Figure 304/53-05-03-990-868 (Sheet 1 of 2)

FFFECTIVITY

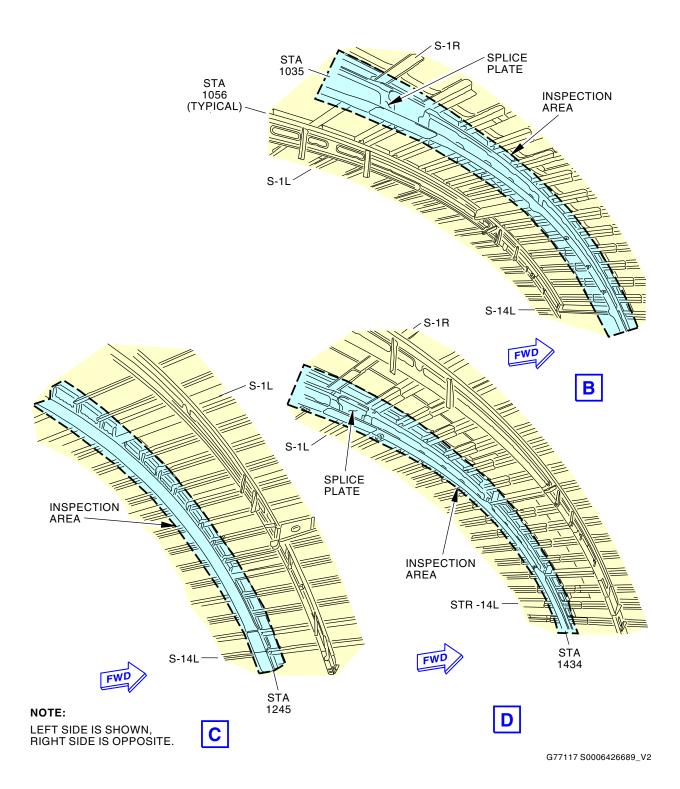
ARO ALL

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Passenger Compartment Ceiling Panels Sta (1035-1434) General Visual (Internal) Figure 304/53-05-03-990-868 (Sheet 2 of 2)

FFFECTIVITY

ARO ALL

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TASK 53-05-03-210-842

73. EXTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING (Figure 305)

| Α. | Ins | ne | cti | n |
|----------|------|----|------|-------------|
| <i>_</i> | 1113 | | O CI | U 11 |

SUBTASK 53-05-03-210-042

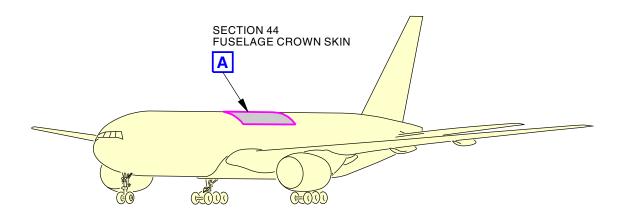
(1) Do the inspection.

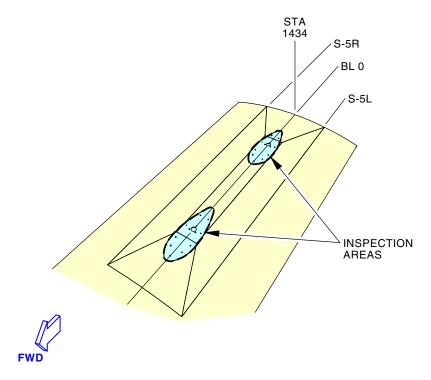
----- END OF TASK -----

ARO ALL

53-05-03







FUSELAGE CROWN SKIN PANELS UNDER ANTENNAS (ANTENNAS REMOVED)



G76534 S0006426691_V3

Fuselage Crown Skin Panels Under Antennas (Area Above Passenger Compartment Ceiling - Section 44) General Visual (External)
Figure 305/53-05-03-990-869

ARO ALL

53-05-03

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TASK 53-05-03-210-843

74. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT (Figure 306)

A. Inspection

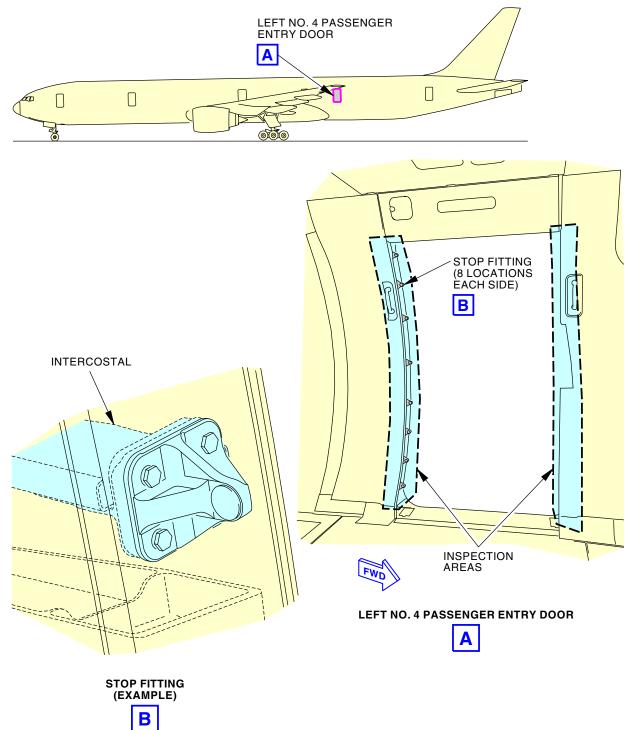
SUBTASK 53-05-03-210-043

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





1300767 S0000218023_V2

Cutout Structure, Stop Fittings and Intercostals,Left No. 4 Passenger Entry Door General Visual (External)
Figure 306/53-05-03-990-971

EFFECTIVITY

ARO ALL

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TASK 53-05-03-210-844

75. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT

(Figure 307)

A. Inspection

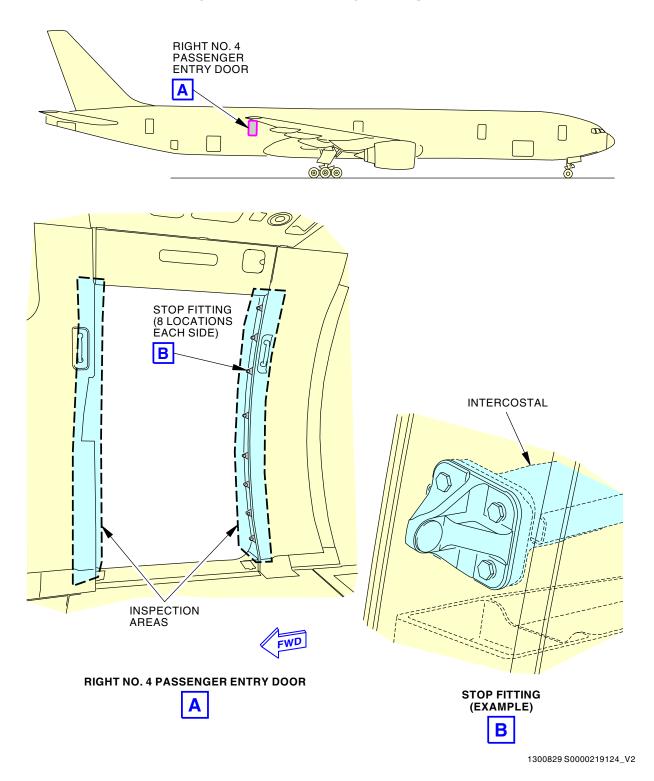
SUBTASK 53-05-03-210-044

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure, Cutout Stop Fittings and Intercostals Right Passenger Entry Door No. 4 General Visual (External)
Figure 307/53-05-03-990-972

EFFECTIVITY

ARO ALL

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TASK 53-05-03-210-845

76. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT

(Figure 308)

A. Inspection

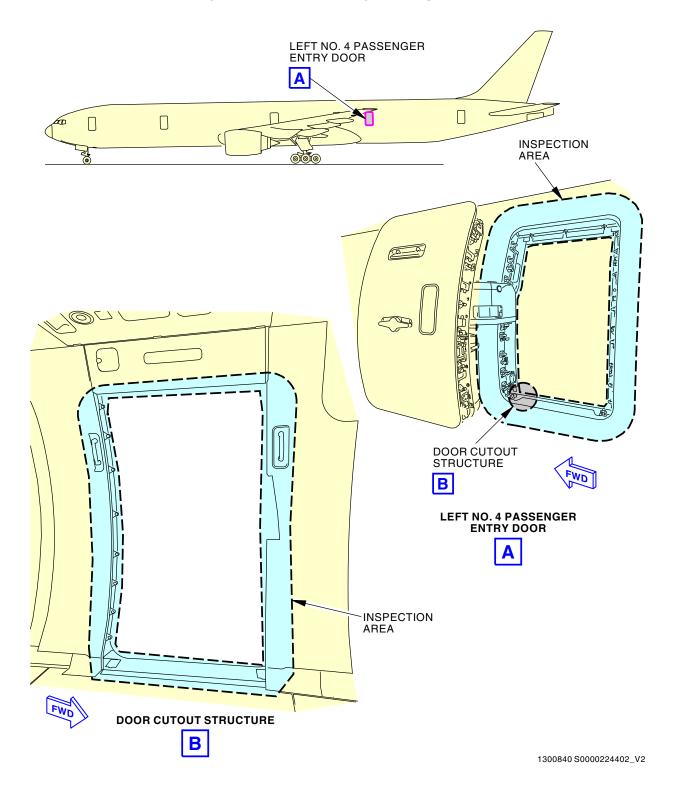
SUBTASK 53-05-03-210-045

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure Left Passenger Entry Door No. 4 General Visual (External) Figure 308/53-05-03-990-973

EFFECTIVITY

ARO ALL

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TASK 53-05-03-210-846

77. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT

(Figure 309)Figure 310

A. Inspection

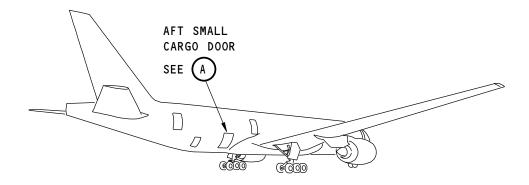
SUBTASK 53-05-03-210-046

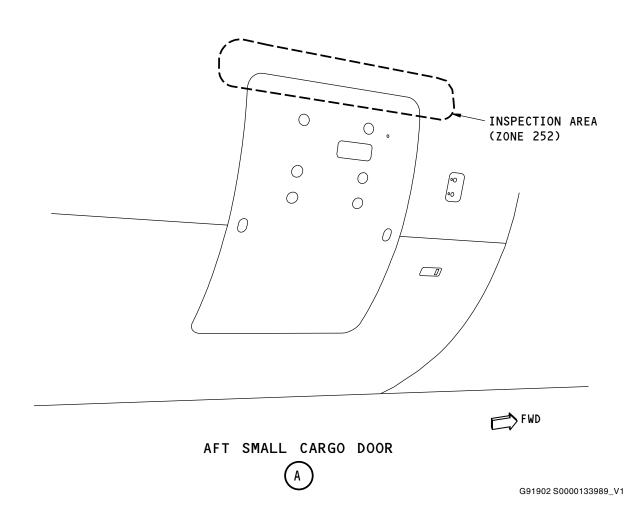
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







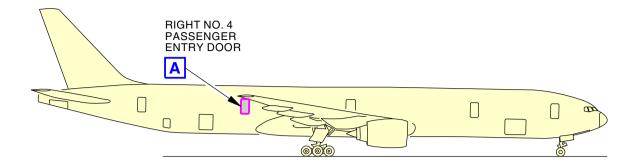
Cutout Structure Aft Small Cargo Door Figure 309/53-05-03-990-873

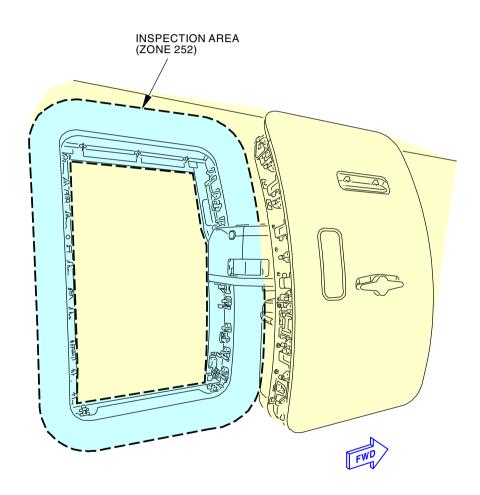
ARO ALL
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RIGHT NO. 4 PASSENGER ENTRY DOOR



1300846 S0000224405_V2

Right Passenger Entry Door General Visual (External) Figure 310/53-05-03-990-E89

ARO ALL
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TASK 53-05-03-210-848

78. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT

(Figure 311)

A. Inspection

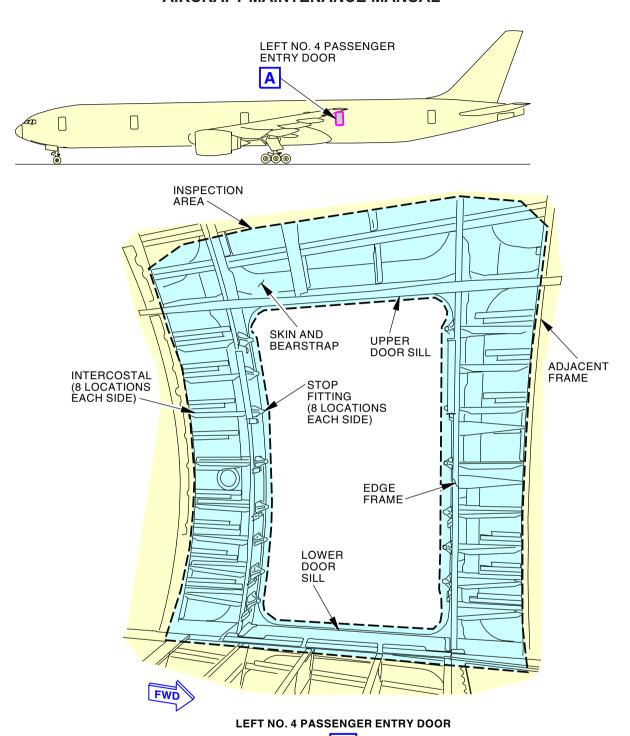
SUBTASK 53-05-03-210-048

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure, Cutout Stop Fittings and Intercostals Left Passenger Entry Door No. 4 General Visual (Internal)
Figure 311/53-05-03-990-974

1300854 S0000224430_V2

FARO ALL

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TASK 53-05-03-210-849

79. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT

(Figure 312)

A. Inspection

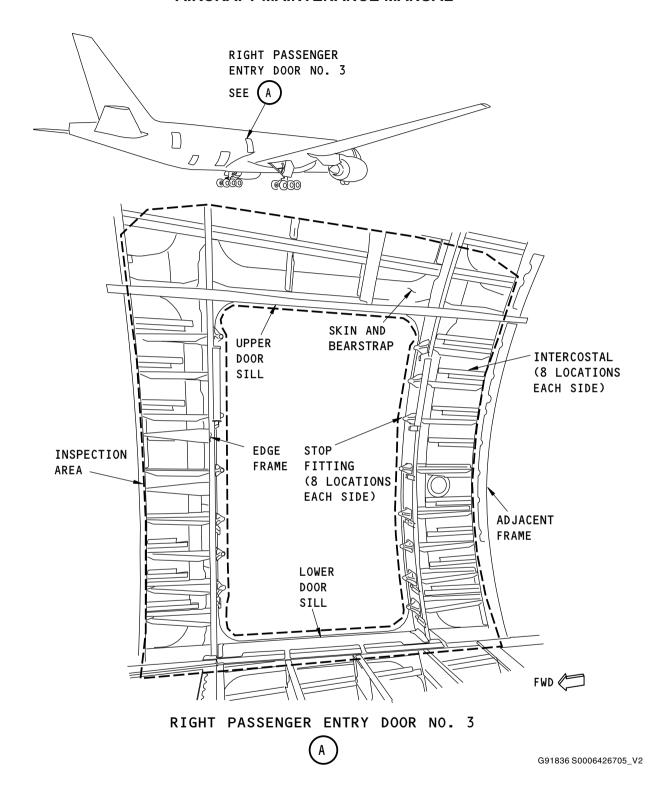
SUBTASK 53-05-03-210-049

(1) Do the inspection.

----- END OF TASK -----

ARO ALL



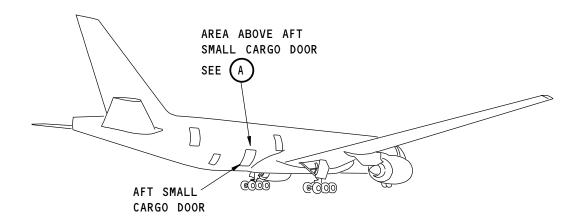


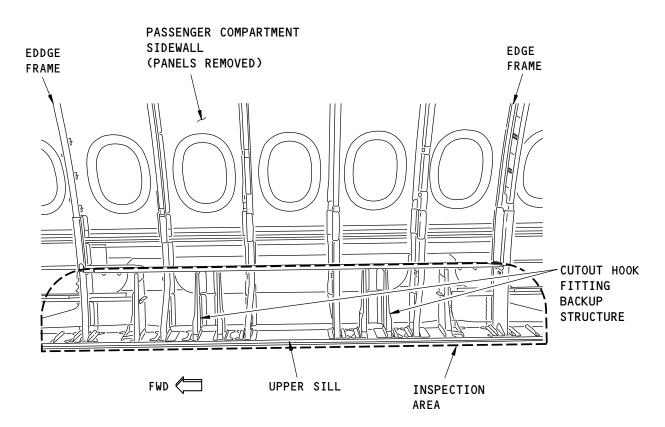
Cutout Structure, Cutout Stop Fittings and Intercostals Right Passenger Entry Door No. 3 General Visual (Internal)
Figure 312/53-05-03-990-876 (Sheet 1 of 2)

FARO ALL

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AREA ABOVE AFT SMALL CARGO DOOR (INTERIOR VIEW)



W87748 S0000132622_V2

Cutout Structure, Cutout Stop Fittings and Intercostals Right Passenger Entry Door No. 3 General
Visual (Internal)
Figure 312/53-05-03-990-876 (Sheet 2 of 2)

EFFECTIVITY

ARO ALL

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TASK 53-05-03-211-843

80. INTERNAL - DETAILED: PASSENGER COMPARTMENT

(Figure 313 or Figure 314)

A. Inspection

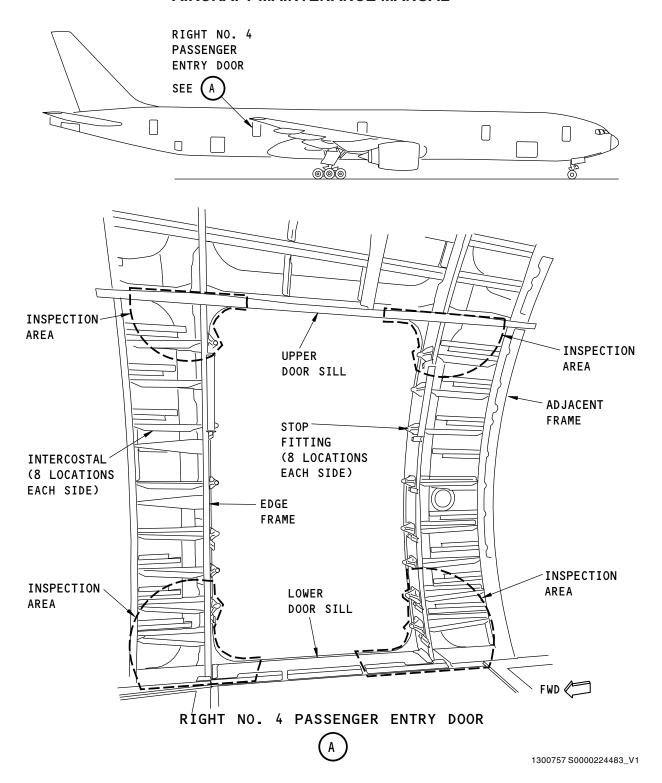
SUBTASK 53-05-03-211-033

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure, Cutout Stop Fittings and Intercostals Right Passenger Entry Door No. 3 (Internal) Figure 313/53-05-03-990-879

EFFECTIVITY

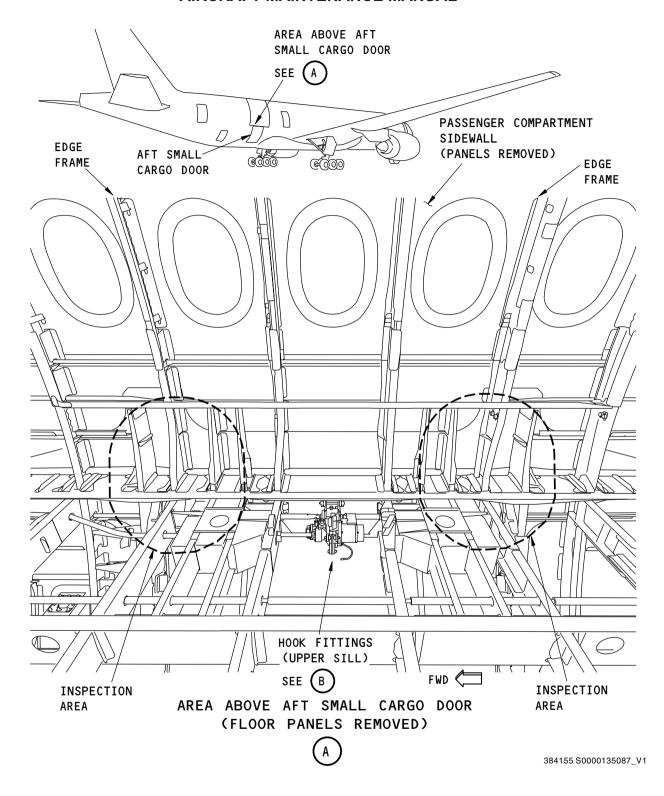
ARO ALL

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Cutout Structure, Cutout Stop/Roller/Hook Fittings and Backup Structure Aft Small Cargo Door (Internal)

Figure 314/53-05-03-990-902 (Sheet 1 of 2)

FFFECTIVITY

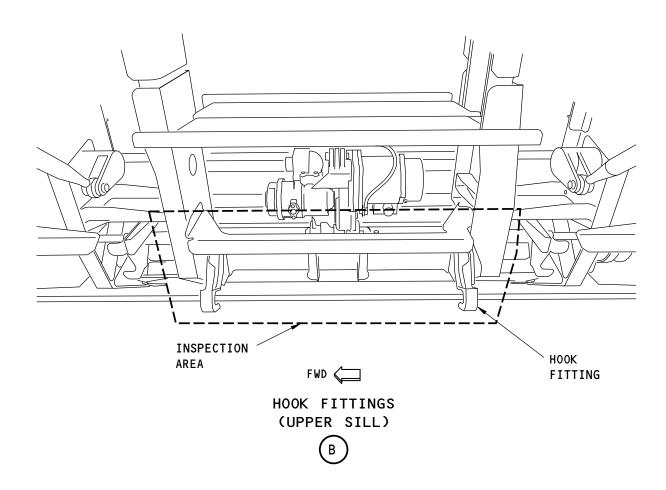
ARO ALL

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384157 S0000135088_V1

Cutout Structure, Cutout Stop/Roller/Hook Fittings and Backup Structure Aft Small Cargo Door (Internal)
Figure 314/53-05-03-990-902 (Sheet 2 of 2)

FFFECTIVITY

ARO ALL

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TASK 53-05-03-210-851

81. EXTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING (Figure 315)

| | | 4 | |
|----|------|------|-----|
| Α. | ınsı | pect | ion |

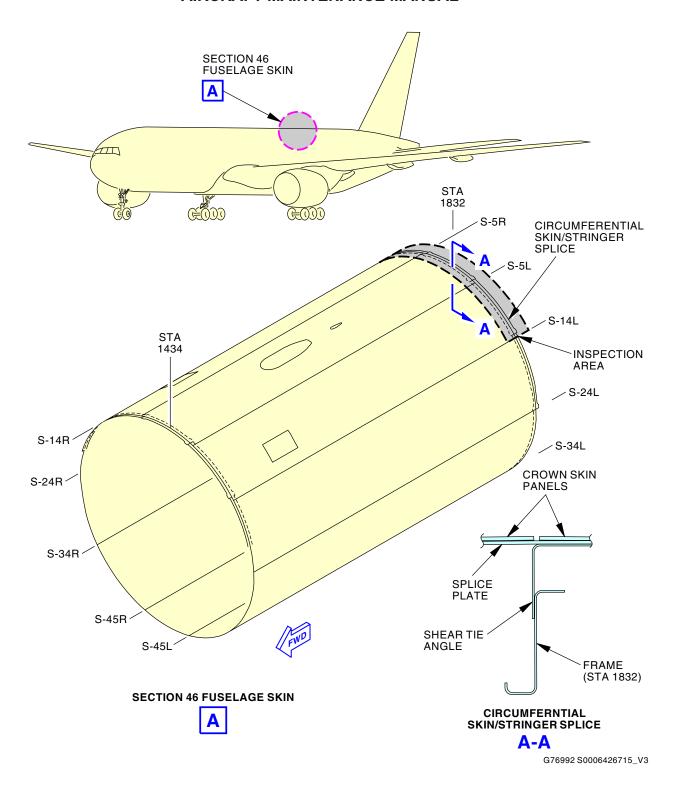
SUBTASK 53-05-03-210-051

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Circumferential Skin/Stringer Splice Sta 1832 (Area Above Passenger Compartment Ceiling General Visual (External)
Figure 315/53-05-03-990-881

EFFECTIVITY

ARO ALL

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TASK 53-05-03-210-852

82. EXTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING (Figure 316)

| _ | - | | |
|------|-----|------|------|
| Α. | Ins | neci | tion |
| / 11 | | | |

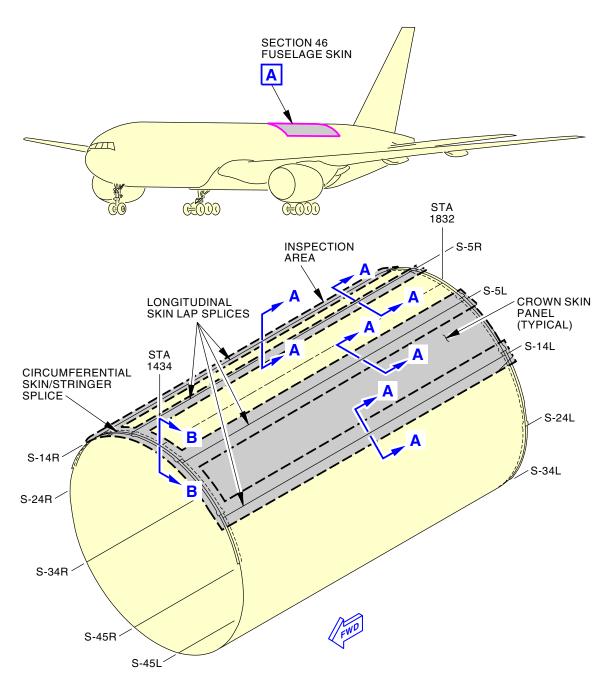
SUBTASK 53-05-03-210-052

(1) Do the inspection.

——— END OF TASK ———

ARO ALL





SECTION 46 FUSELAGE SKIN



G76599 S0006426717_V3

Circumferential Skin/Stringer Splice Sta 1434 and Longitudinal Skin Lap Splices (Area Above Passenger Compartment Ceiling - Section 46) General Visual (External)
Figure 316/53-05-03-990-882 (Sheet 1 of 2)

EFFECTIVITY

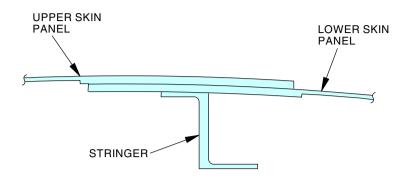
ARO ALL

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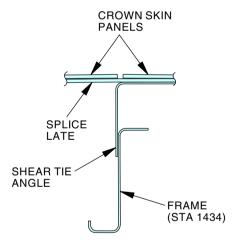
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LONGITUDINAL SKIN LAP SPLICE (TYPLICAL) A-A



CIRCUMFERENTIAL SKIN STRINGER SPLICE (TYPLICAL) 8-8

H10836 S0006426718_V2

Circumferential Skin/Stringer Splice Sta 1434 and Longitudinal Skin Lap Splices (Area Above Passenger Compartment Ceiling - Section 46) General Visual (External)

Figure 316/53-05-03-990-882 (Sheet 2 of 2)

ARO ALL
D633W101-ARO

53-05-03

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TASK 53-05-03-210-853-006

83. INTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING -300ER

A. Job Set-up

SUBTASK 53-05-03-010-129

(1) Open access panels, reference Figure 319, Figure 317, Figure 318.

B. Inspection

SUBTASK 53-05-03-210-213

(1) Do the inspection.

C. Job Close-up

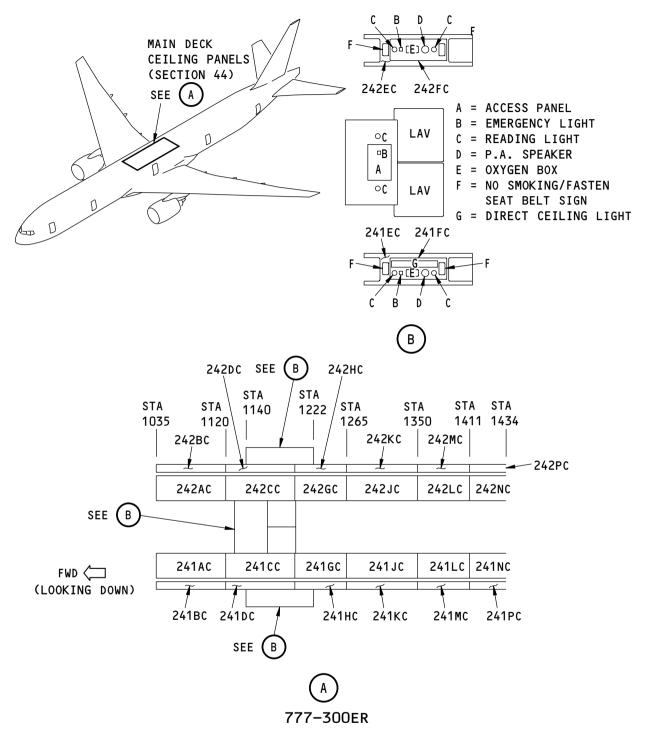
SUBTASK 53-05-03-410-129

(1) Close access panels, reference Figure 319, Figure 317, Figure 318.

----- END OF TASK -----

ARO ALL





2462591 S0000573304_V1

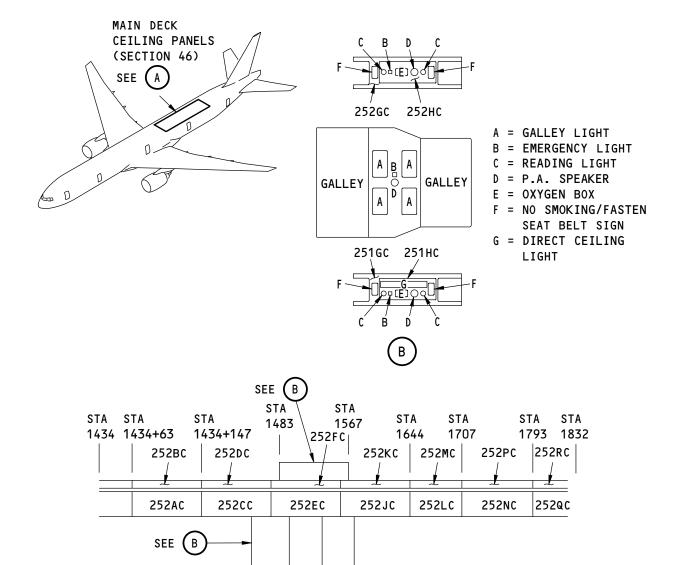
Zone 241/242 Passenger Cabin Ceiling Panels Figure 317/53-05-03-990-E68

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2462592 S0000573305_V1

Zone 251/252 Passenger Cabin Ceiling Panels Figure 318/53-05-03-990-E69

777-300ER

251EC

251JC

251KC

251LC

251MC

251NC

251PC

251QC

251RC

ARO ALL
D633W101-ARO

251CC

251DC 251FC

SEE (B

251AC

251BC

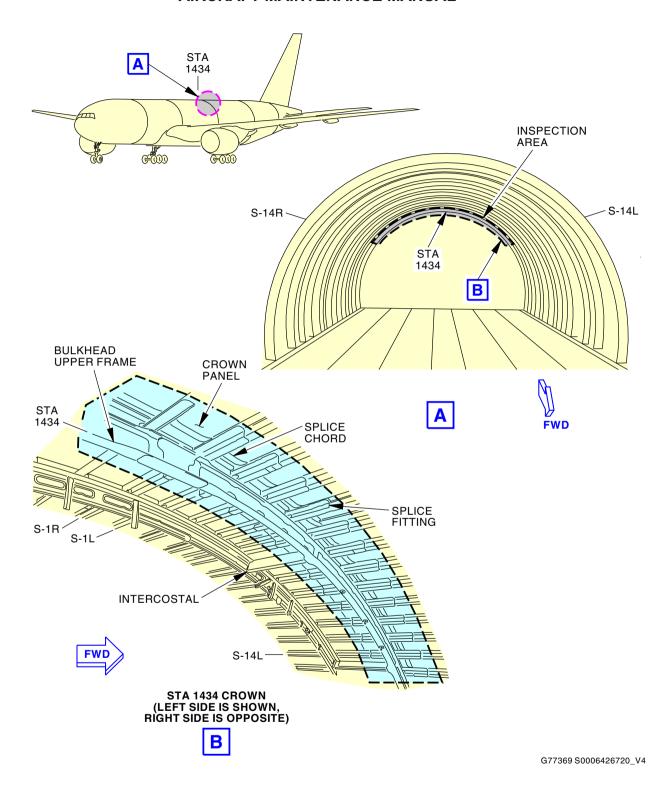
FWD 📛

(LOOKING DOWN)

53-05-03

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Circumferential Skin/Stringer Splice at Sta 1434 General Visual (Internal) Figure 319/53-05-03-990-E67

EFFECTIVITY

ARO ALL

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TASK 53-05-03-210-854

84. EXTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING (Figure 320)

A. Inspection

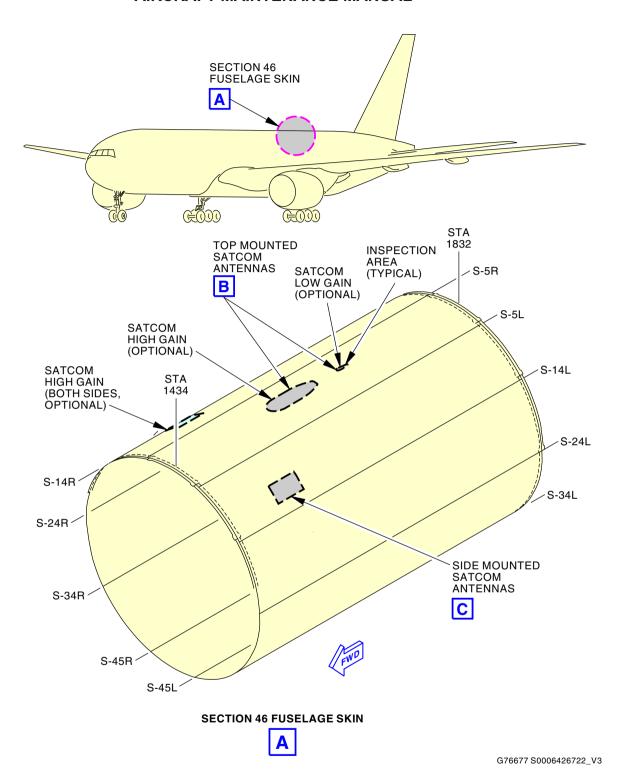
SUBTASK 53-05-03-210-054

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Fuselage Crown Skin Panels Under Antennas (Area Above Passenger Compartment Ceiling - Section 46) General Visual (External)
Figure 320/53-05-03-990-884 (Sheet 1 of 2)

EFFECTIVITY

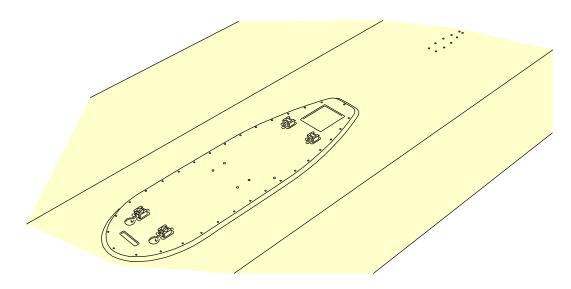
ARO ALL

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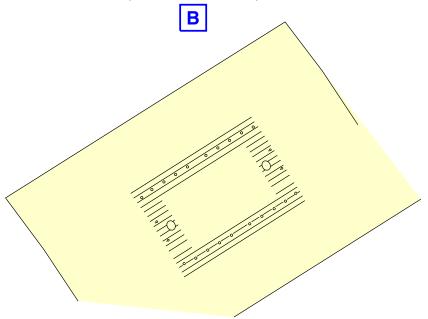
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FUSELAGE CROWN SKIN PANELS UNDER TOP MOUNTED SATCOM ANTENNAS (ANTENNAS REMOVED)



FUSELAGE CROWN SKIN UNDER SIDE MOUNTED SATCOM ANTENNA (ANTENNA REMOVED) (LEFT SIDE IS SHOWN, RIGHT SIDE IS EQUIVALENT)



G76855 S0006426723_V2

Fuselage Crown Skin Panels Under Antennas (Area Above Passenger Compartment Ceiling - Section 46) General Visual (External)
Figure 320/53-05-03-990-884 (Sheet 2 of 2)

ARO ALL

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TASK 53-05-03-210-855

85. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT

(Figure 321)

A. Inspection

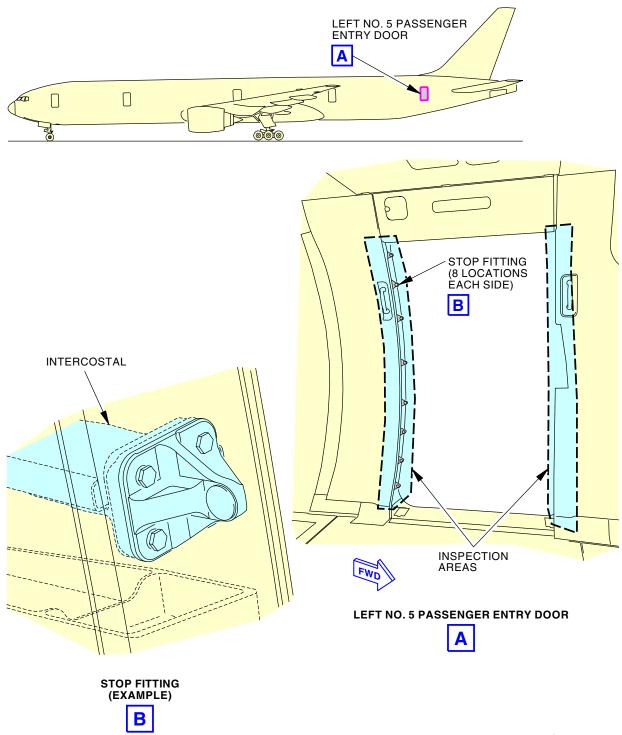
SUBTASK 53-05-03-210-055

(1) Do the inspection.

------ END OF TASK ------

ARO ALL





1300861 S0000224486_V2

Cutout Structure, Stop Fittings and Intercostals Left Passenger Entry Door No. 5 General Visual (External)
Figure 321/53-05-03-990-976

EFFECTIVITY

ARO ALL

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TASK 53-05-03-210-856

86. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT

(Figure 322)

A. Inspection

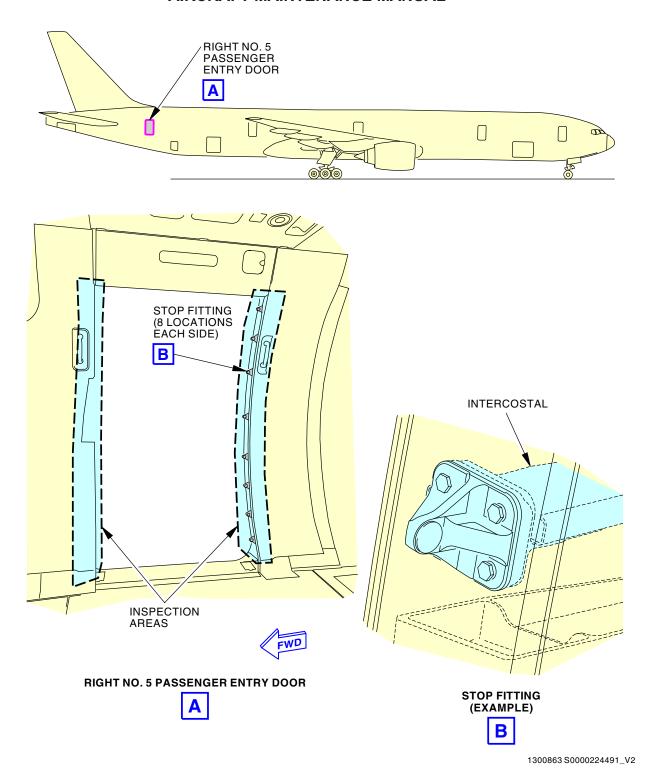
SUBTASK 53-05-03-210-056

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





_ _

Cutout Structure, Stop Fittings and Intercostals Right Passenger Entry Door No. 5 General Visual (External)
Figure 322/53-05-03-990-977

EFFECTIVITY

ARO ALL

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TASK 53-05-03-210-857

87. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT

(Figure 323)

A. Inspection

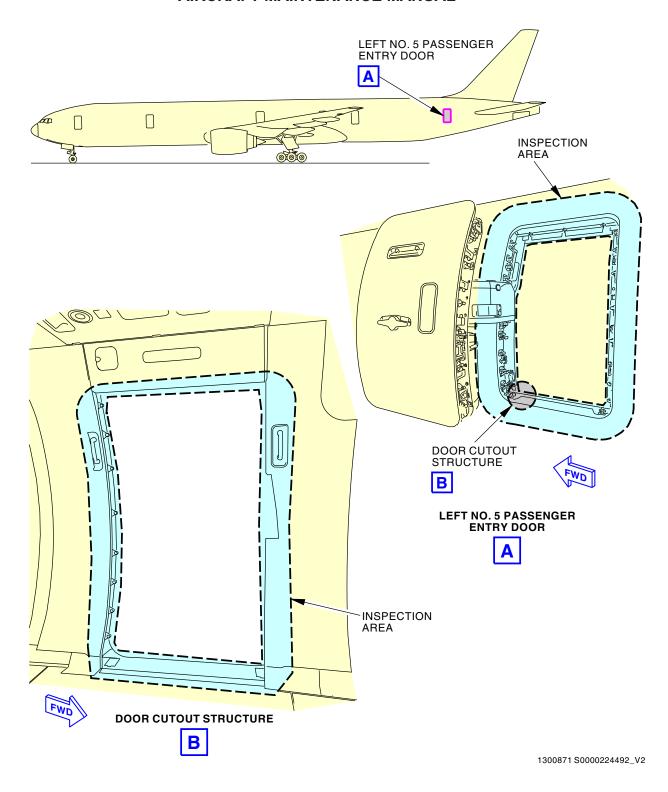
SUBTASK 53-05-03-210-057

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure Left Passenger Entry Door No. 5 General Visual (External) Figure 323/53-05-03-990-978

EFFECTIVITY

ARO ALL

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TASK 53-05-03-210-858

88. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT

(Figure 324)

A. Inspection

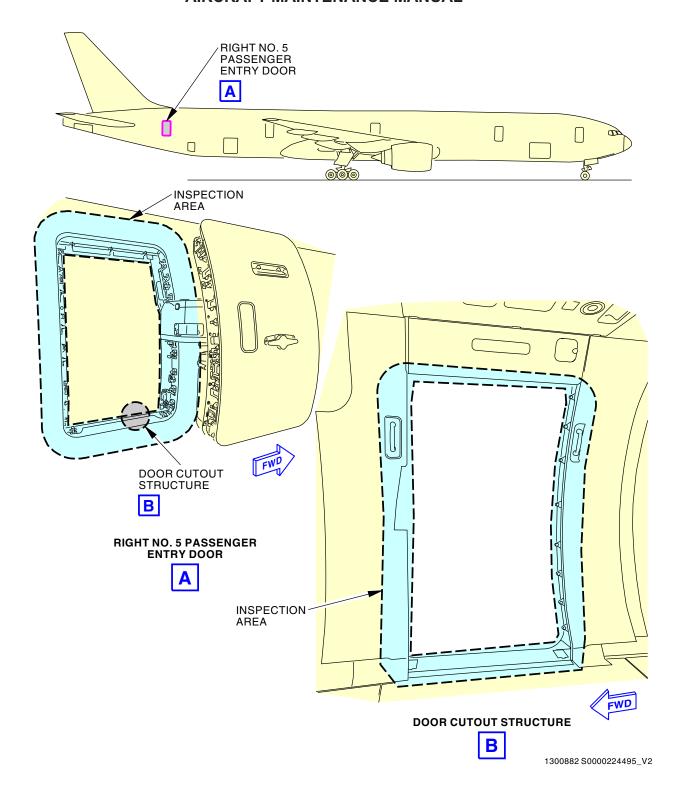
SUBTASK 53-05-03-210-058

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure Right Passenger Entry Door No. 5 General Visual (External) Figure 324/53-05-03-990-979

EFFECTIVITY

ARO ALL

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TASK 53-05-03-210-859

89. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT

(Figure 325)

A. Inspection

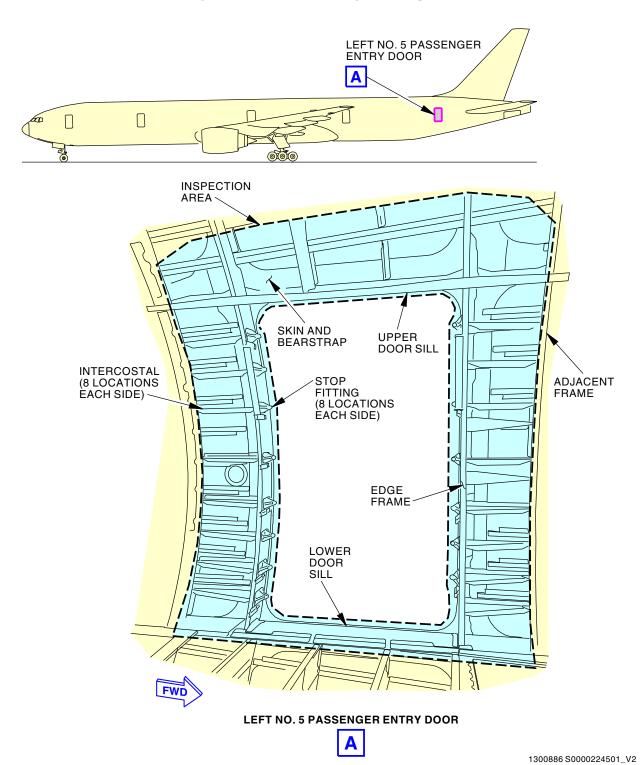
SUBTASK 53-05-03-210-059

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure, Stop Fittings and Intercostals Left Passenger Entry Door No. 5 General Visual (Internal)
Figure 325/53-05-03-990-980

EFFECTIVITY

ARO ALL

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TASK 53-05-03-210-860

90. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT

(Figure 326)

A. Inspection

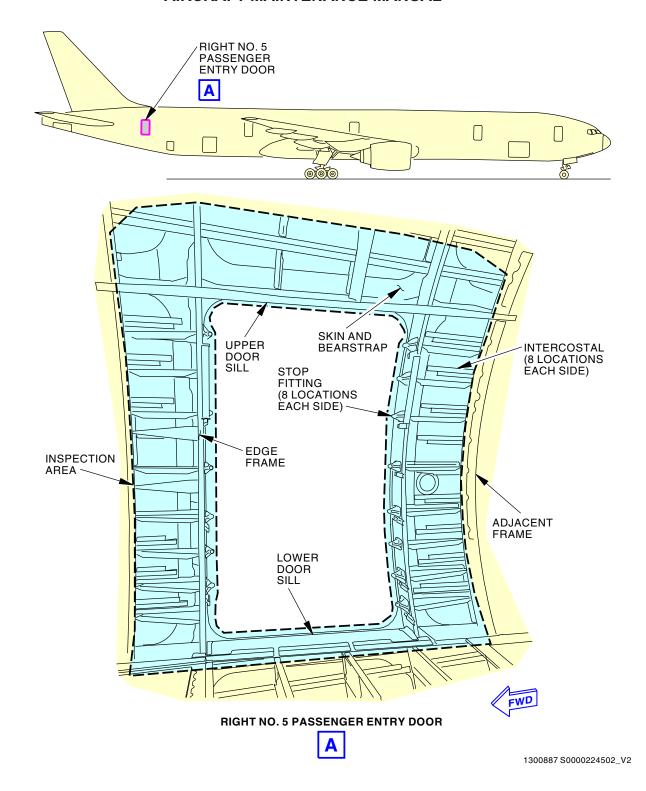
SUBTASK 53-05-03-210-060

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure, Cutout Stop Fittings and Intercostals Right Passenger Entry Door No. 5 General Visual (Internal)
Figure 326/53-05-03-990-981

EFFECTIVITY

ARO ALL

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TASK 53-05-03-211-835

91. INTERNAL - DETAILED: PASSENGER COMPARTMENT

(Figure 327)

A. Inspection

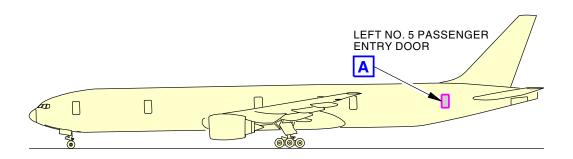
SUBTASK 53-05-03-211-035

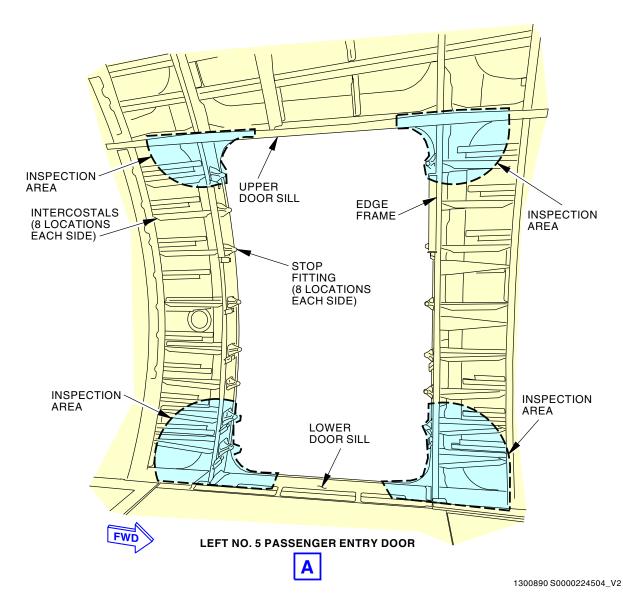
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







Cutout Structure, Cutout Stop Fittings and Intercostals Left Passenger Entry Door No. 5 (Internal) Figure 327/53-05-03-990-982

EFFECTIVITY

ARO ALL

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TASK 53-05-03-211-836

92. INTERNAL - DETAILED: PASSENGER COMPARTMENT

(Figure 328)

A. Inspection

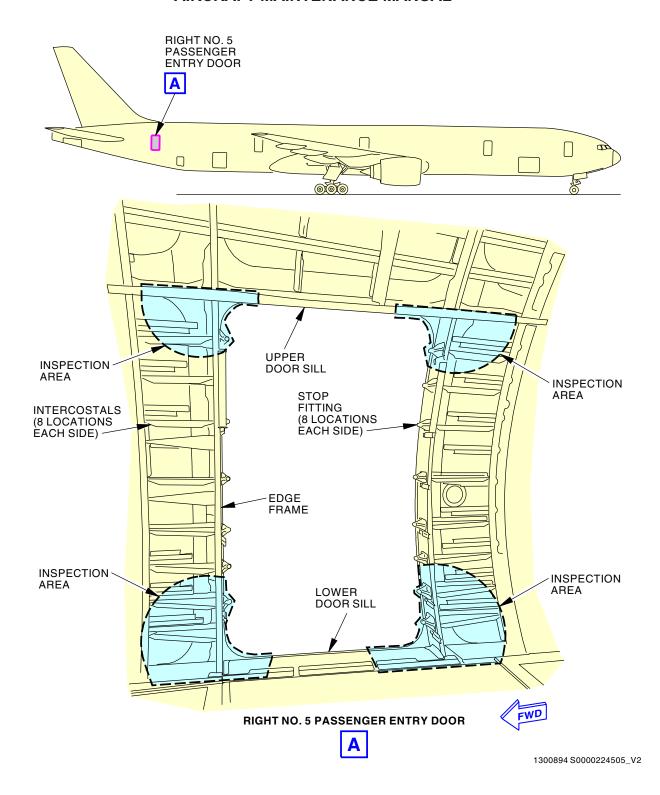
SUBTASK 53-05-03-211-036

(1) Do the inspection.

------ END OF TASK ------

ARO ALL





Cutout Structure, Cutout Stop Fittings and Intercostals Right Passenger Entry Door No. 5 (Internal) Figure 328/53-05-03-990-983

FFFECTIVITY

ARO ALL

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TASK 53-05-03-211-837-002

93. INTERNAL - DETAILED: AREA ABOVE WING CENTER SECTION - 300ER

A. Job Set-up

SUBTASK 53-05-03-010-114

(1) Open access panels, reference Figure 329, Figure 330.

B. Inspection

SUBTASK 53-05-03-211-103

(1) Do the inspection.

C. Job Close-up

SUBTASK 53-05-03-410-114

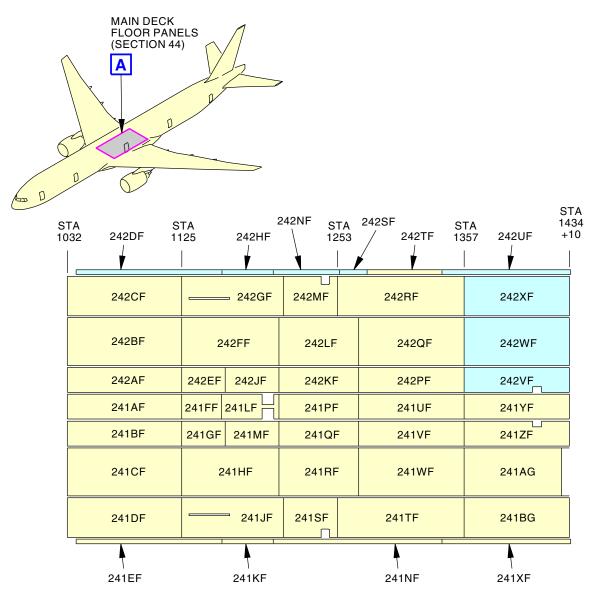
(1) Close access panels, referenceFigure 329, Figure 330.

----- END OF TASK -----

EFFECTIVITY -

ARO ALL





MAIN DECK FLOOR PANELS (SECTION 44) (VIEW IN THE DOWN DIRECTION) 777-300ER



LEGEND:

REMOVAL OF THESE PANELS ARE NECESSARY TO PERFORM THE GENERAL VISUAL INSPECTION OF THE WORK AREA.

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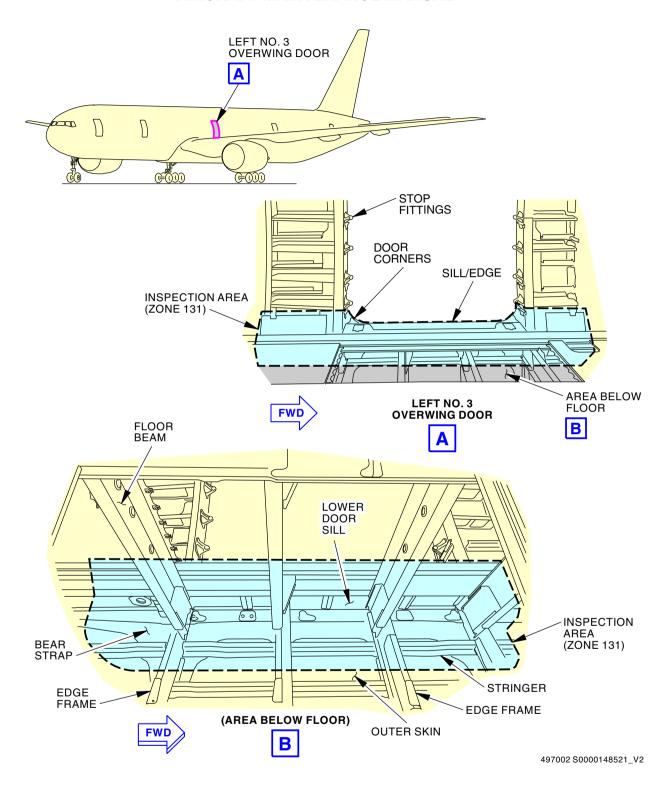
Zone 241/242 Passenger Cabin FloorAccess Panels Figure 329/53-05-03-990-E16

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Area Above Wing Center Section Figure 330/53-05-03-990-E02 (Sheet 1 of 2)

EFFECTIVITY

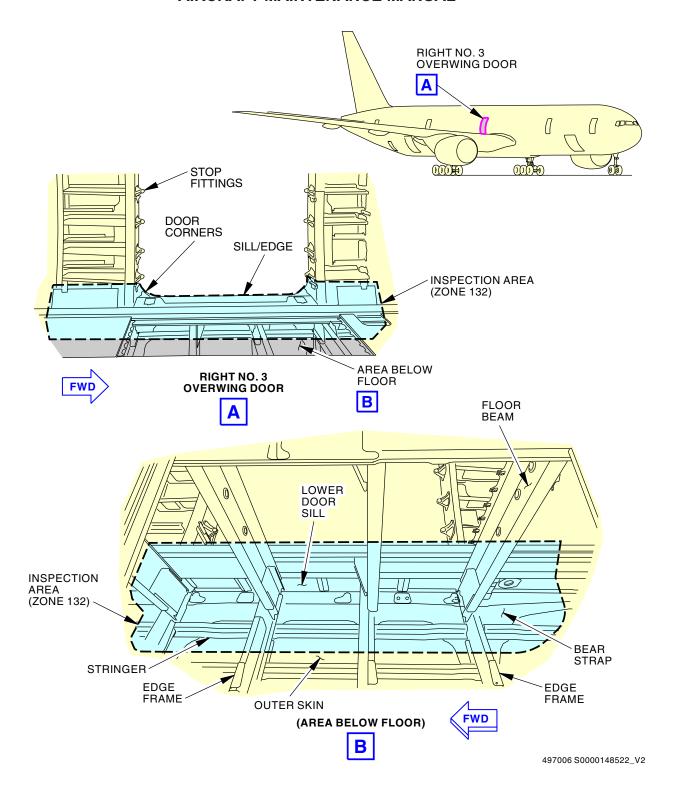
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Area Above Wing Center Section Figure 330/53-05-03-990-E02 (Sheet 2 of 2)

FFFECTIVITY

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TASK 53-05-03-210-862

94. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT LEFT AND RIGHT (Figure 331)

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| ~ : | шэ | \mathbf{r} | UЦ | vII |

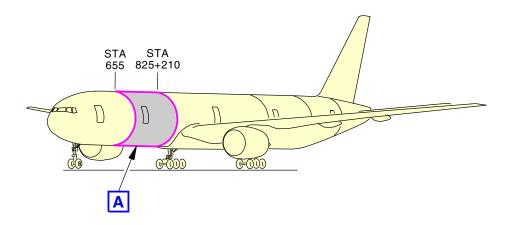
SUBTASK 53-05-03-210-062

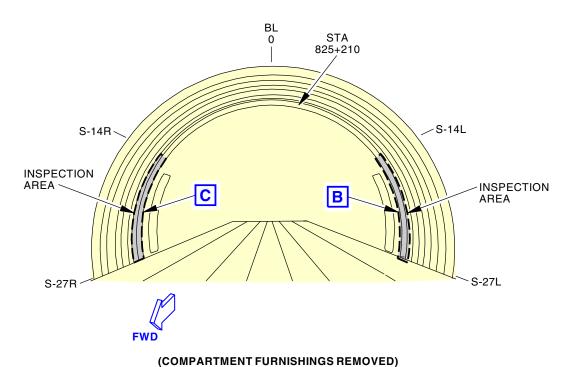
(1) Do the inspection.

----- END OF TASK -----

ARO ALL









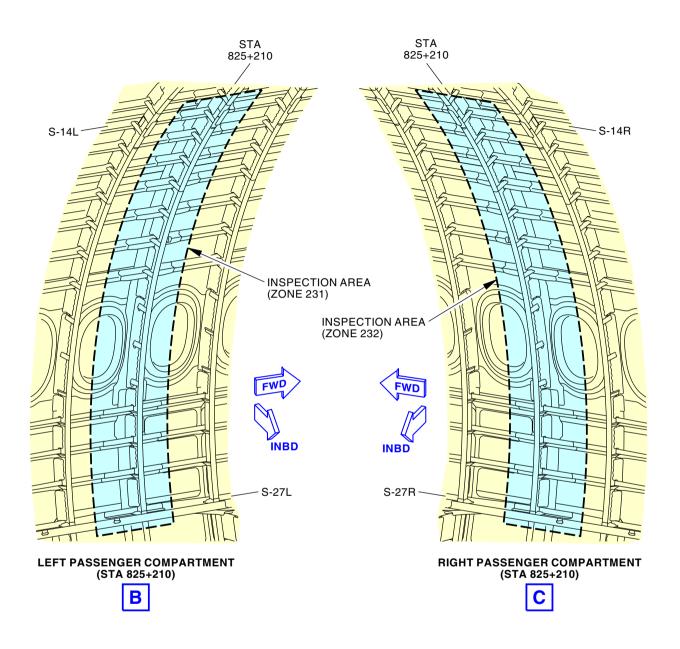
497061 S0000148523_V2

Passenger Compartment Left And Right Figure 331/53-05-03-990-912 (Sheet 1 of 2)

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497067 S0000148524_V2

Passenger Compartment Left And Right Figure 331/53-05-03-990-912 (Sheet 2 of 2)

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TASK 53-05-03-210-863

95. INTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING

A. Inspection

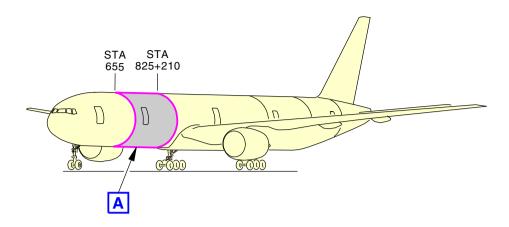
SUBTASK 53-05-03-210-063

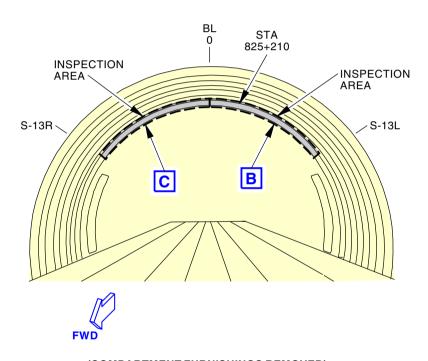
(1) Do the inspection.

----- END OF TASK -----

ARO ALL







(COMPARTMENT FURNISHINGS REMOVED)



495864 S0000148525_V2

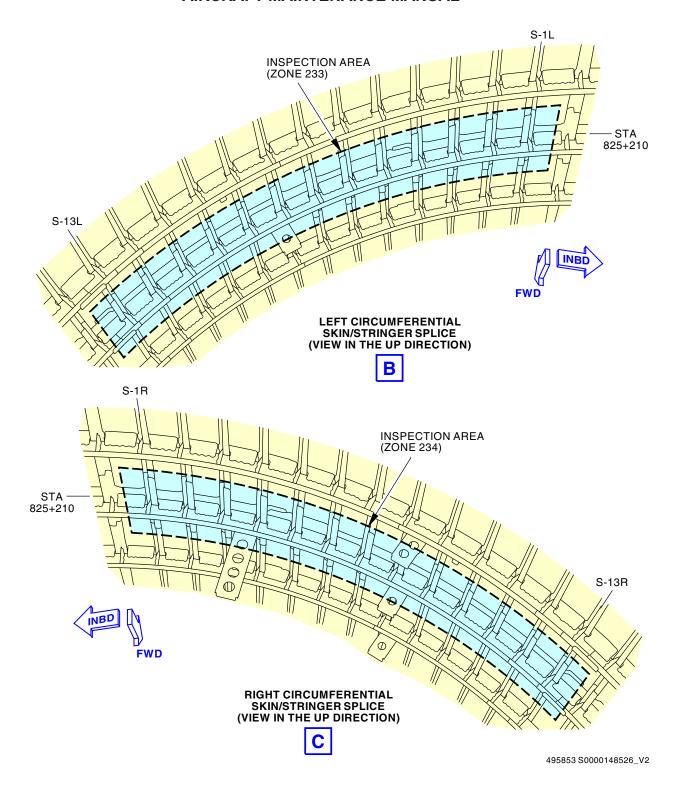
Area Above Passenger Compartment Ceiling Figure 332/53-05-03-990-913 (Sheet 1 of 2)

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Area Above Passenger Compartment Ceiling Figure 332/53-05-03-990-913 (Sheet 2 of 2)

EFFECTIVITY

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TASK 53-05-03-210-864

96. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT LEFT (Figure 333)

A. Inspection

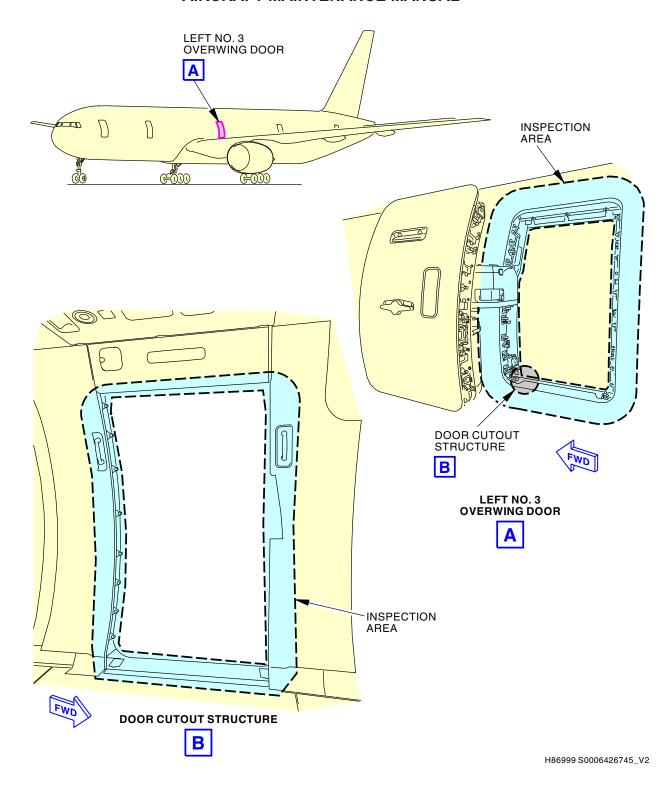
SUBTASK 53-05-03-210-064

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure Left No. 3 Overwing Door General Visual (External) Figure 333/53-05-03-990-893

EFFECTIVITY

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TASK 53-05-03-210-865

97. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - RIGHT (Figure 334)

A. Inspection

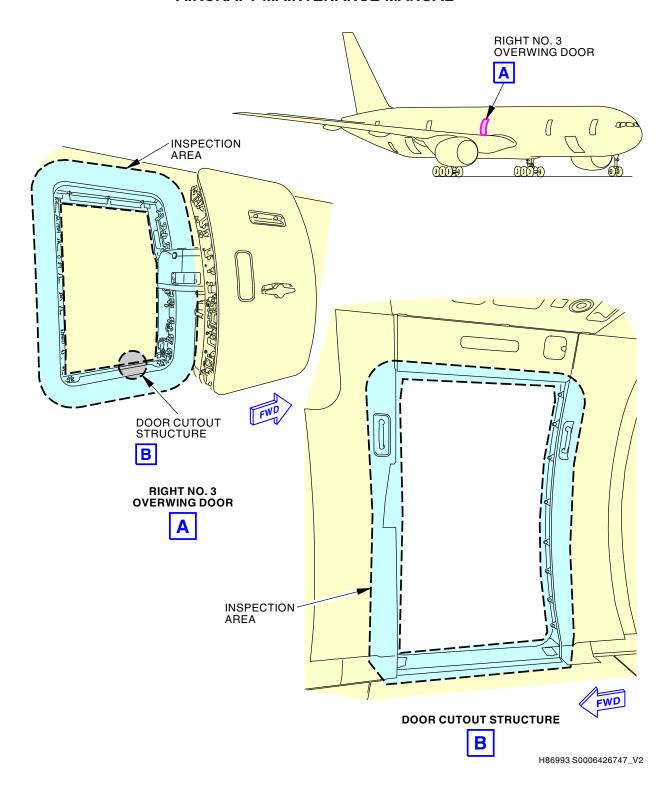
SUBTASK 53-05-03-210-065

(1) Do the inspection.

------ END OF TASK ------

ARO ALL





Cutout Structure Right No. 3 Overwing Door General Visual (External) Figure 334/53-05-03-990-894

EFFECTIVITY

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TASK 53-05-03-210-866-002

98. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT LEFT AND RIGHT - 300ER

A. Job Set-up

SUBTASK 53-05-03-010-094

(1) Open access panels, reference Figure 335, Figure 336, Figure 337, Figure 338, Figure 339.

B. Inspection

SUBTASK 53-05-03-210-189

(1) Do the inspection.

C. Job Close-up

SUBTASK 53-05-03-410-094

(1) Close access panels, reference Figure 335, Figure 336, Figure 337, Figure 338, Figure 339.

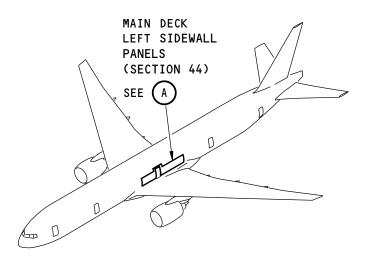
----- END OF TASK -----

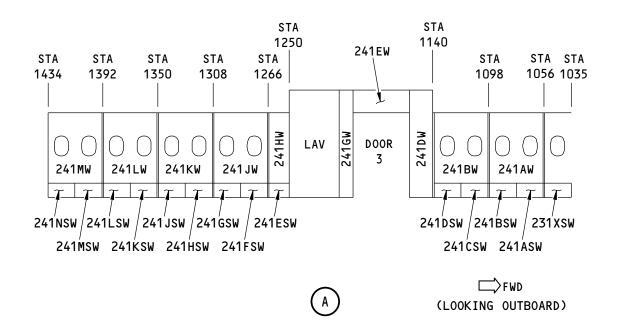
ARO ALL

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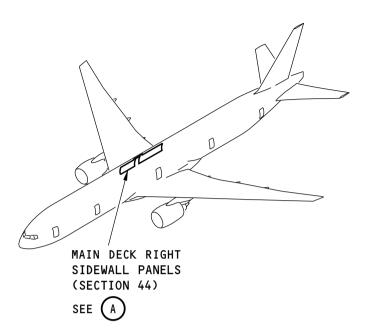
Zone 241 Passenger Cabin Sidewall Access Panels Figure 335/53-05-03-990-E11

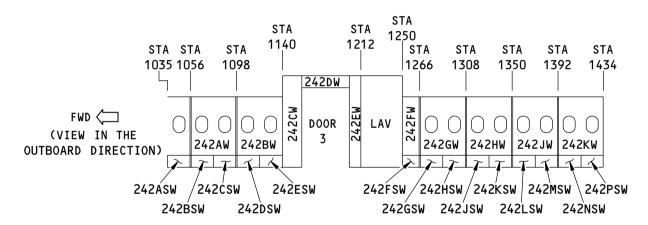
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MAIN DECK RIGHT SIDEWALL PANELS (SECTION 44)



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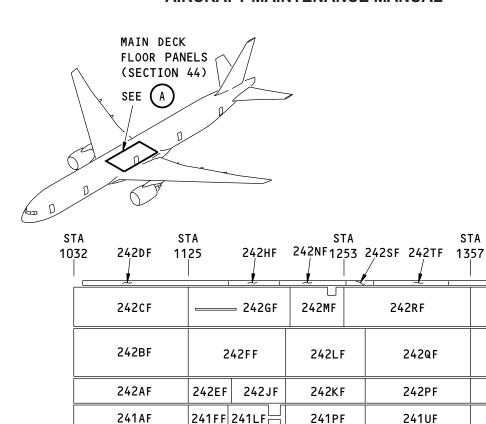
ZONE 242 PASSENGER CABIN SIDEWALL ACCESS PANELS Figure 336/53-05-03-990-D64

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241GF

241MF

241JF

241KF

241HF

(VIEW IN THE DOWN DIRECTION)

FWD 📛

241BF

241CF

241DF

241EF

MAIN DECK FLOOR PANELS (SECTION 44)

241QF

241RF

241SF

241VF

241WF

241TF

241NF



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2471719 S0000578067_V1

STA

242UF 1434+10

242XF

242WF

242VF

241YF

241ZF

241AG

241BG

241XF

STA

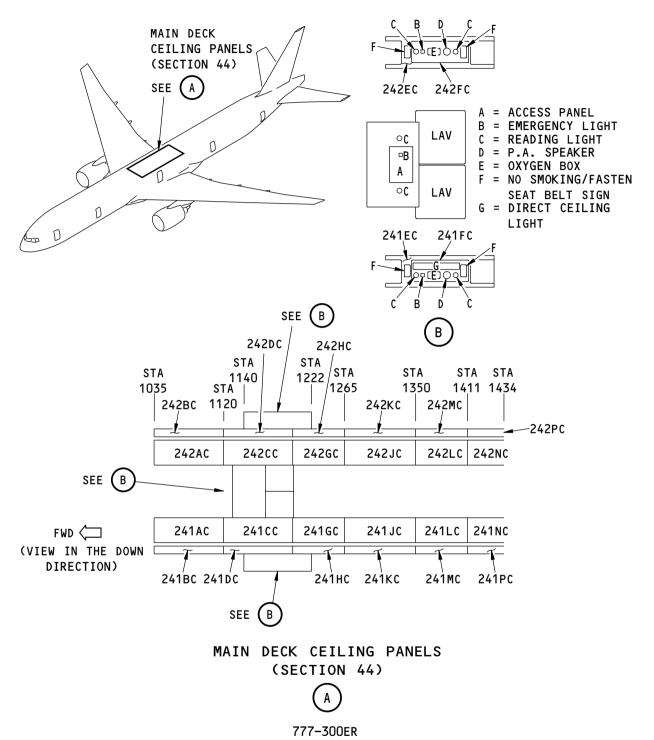
ZONE 241/242 PASSENGER CABIN FLOOR ACCESS PANELS Figure 337/53-05-03-990-D65

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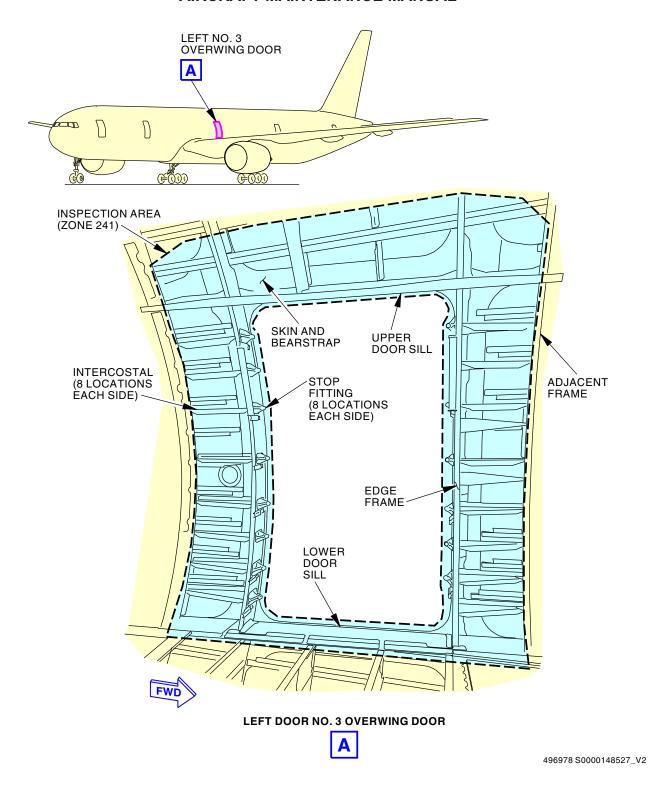
ZONE 241/242 PASSENGER CABIN CEILING PANELS Figure 338/53-05-03-990-D66

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Passenger Compartment Left And Right Figure 339/53-05-03-990-D67 (Sheet 1 of 2)

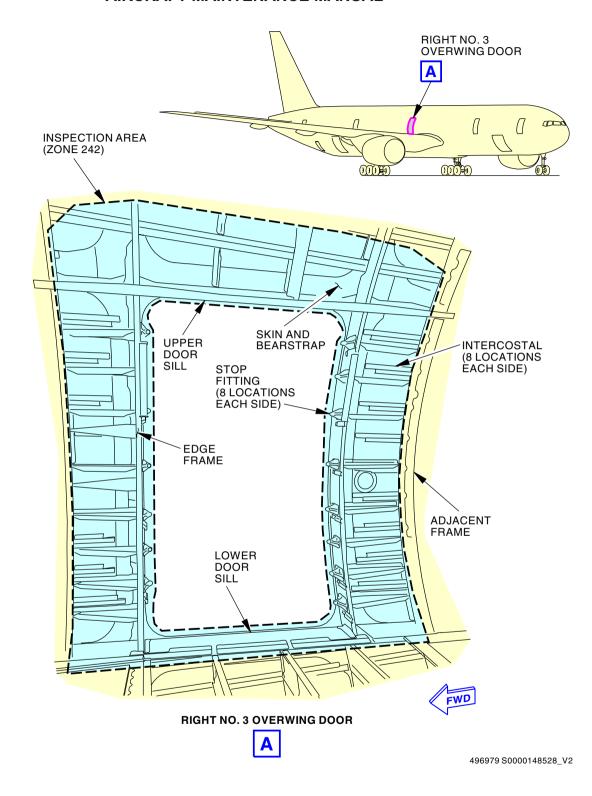
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Passenger Compartment Left And Right Figure 339/53-05-03-990-D67 (Sheet 2 of 2)

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TASK 53-05-03-211-838

99. INTERNAL - DETAILED: PASSENGER COMPARTMENT LEFT AND RIGHT (Figure 340)

A. Inspection

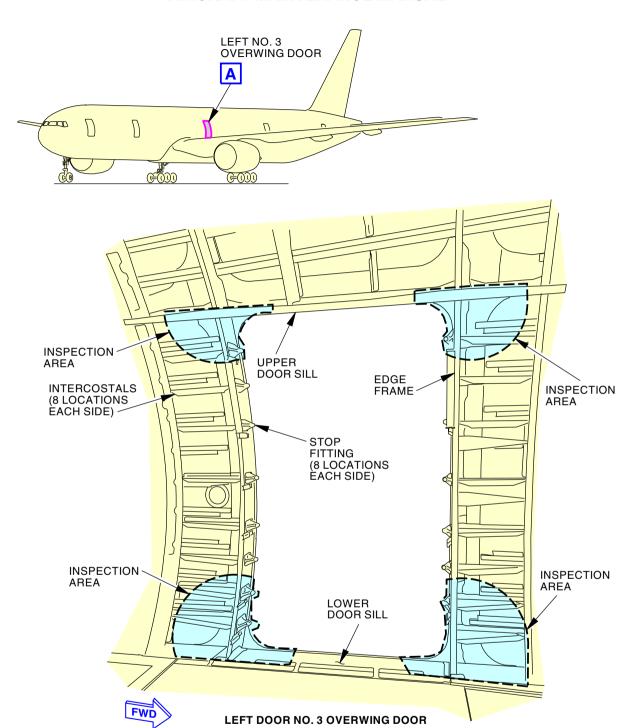
SUBTASK 53-05-03-211-038

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Passenger Compartment Left And Right Figure 340/53-05-03-990-915 (Sheet 1 of 2)

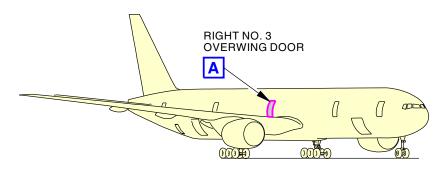
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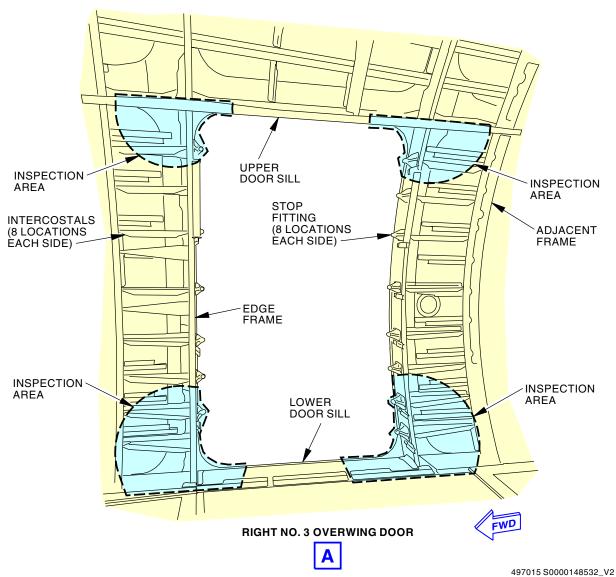
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Passenger Compartment Left And Right Figure 340/53-05-03-990-915 (Sheet 2 of 2)

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TASK 53-05-03-211-838-002

100. INTERNAL - DETAILED: PASSENGER COMPARTMENT LEFT AND RIGHT - 300ER

A. Job Set-up

SUBTASK 53-05-03-010-116

(1) Open access panels, referenceFigure 341, Figure 342, Figure 343, Figure 344, Figure 345.

B. Inspection

SUBTASK 53-05-03-211-105

(1) Do the inspection.

C. Job Close-up

SUBTASK 53-05-03-410-116

(1) Close access panels, referenceFigure 341, Figure 342, Figure 343, Figure 344, Figure 345.

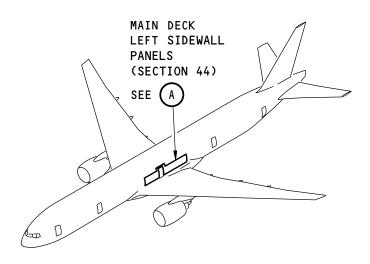
——— END OF TASK ———

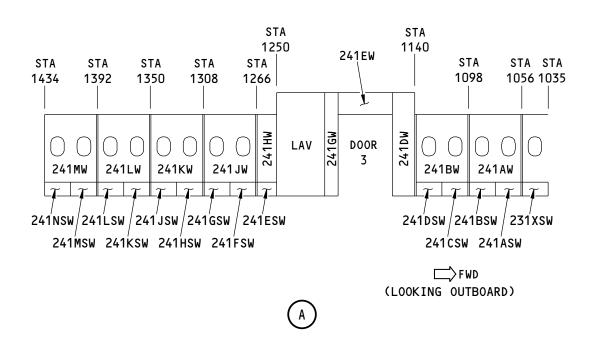
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2441205 S0000566883_V1

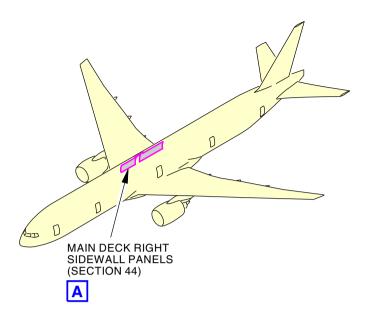
Zone 231/241 Passenger Cabin Sidewall Access Panels Figure 341/53-05-03-990-E23

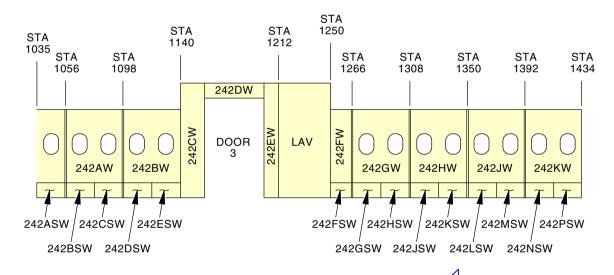
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MAIN DECK RIGHT SIDEWALL PANELS (SECTION 44) (VIEW IN THE OUTBOARD DIRECTION) 777-300ER





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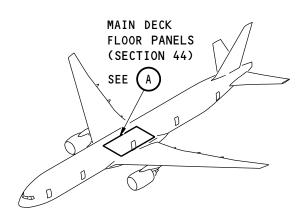
Zone 242 Passenger Cabin Sidewall Access Panels Figure 342/53-05-03-990-E24

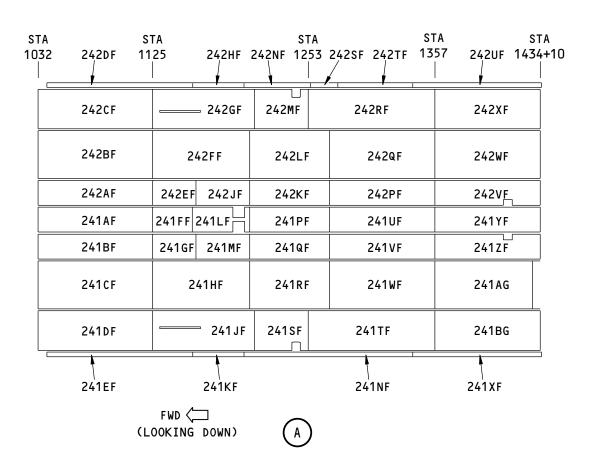
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777-300ER

2450469 S0000569223_V1

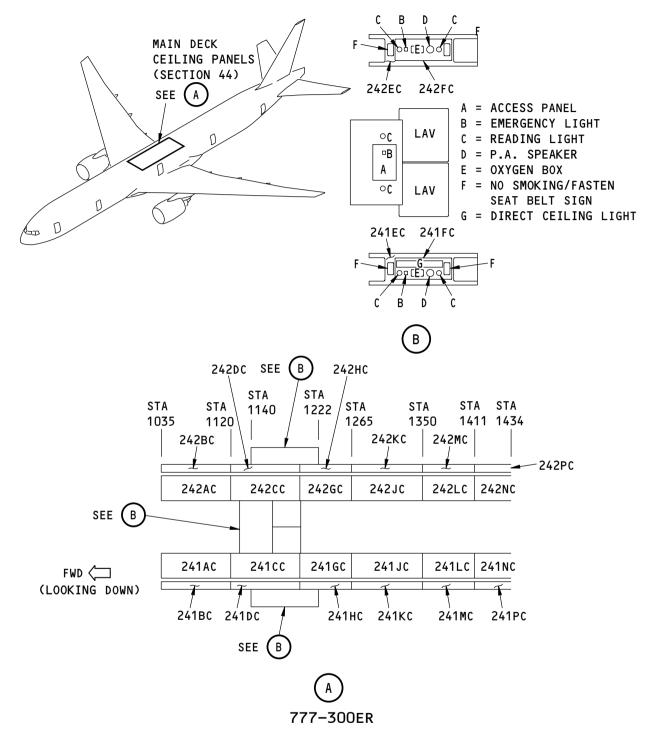
Zone 241/242 Passenger Cabin Floor Access Panels Figure 343/53-05-03-990-E25

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2462591 S0000573304_V1

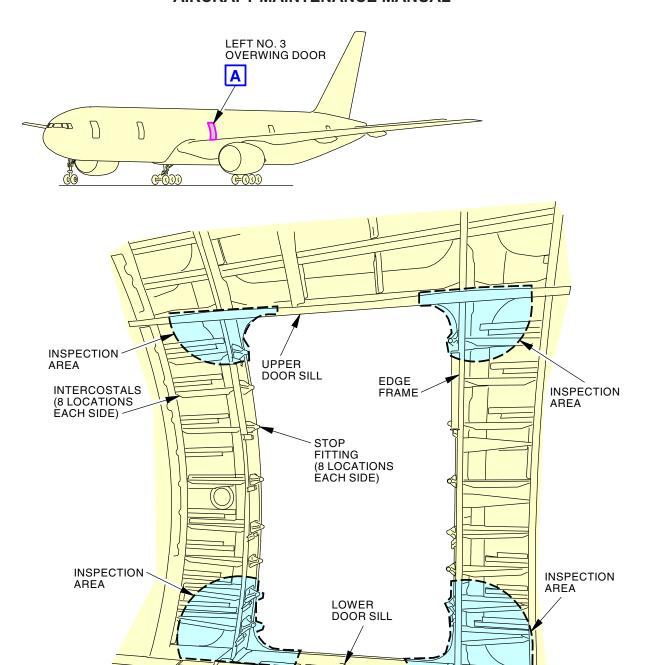
Zone 241/242 Passenger Cabin Ceiling Panels Figure 344/53-05-03-990-E26

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Passenger Compartment Left And Right Figure 345/53-05-03-990-E09 (Sheet 1 of 2)

LEFT DOOR NO. 3 OVERWING DOOR

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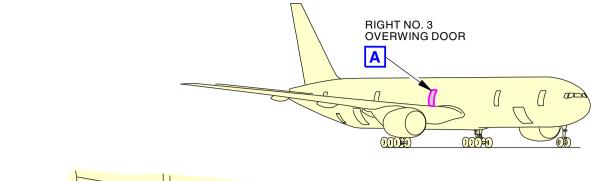
FWD

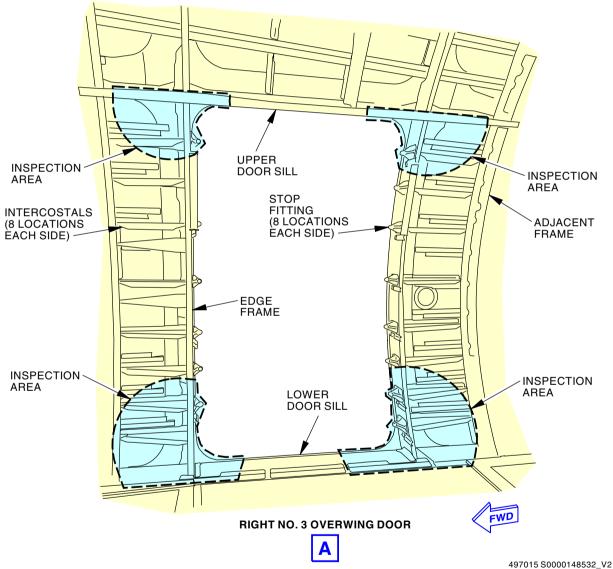
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Passenger Compartment Left And Right Figure 345/53-05-03-990-E09 (Sheet 2 of 2)

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TASK 53-05-03-210-867

101. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - LEFT (Figure 346)

A. Inspection

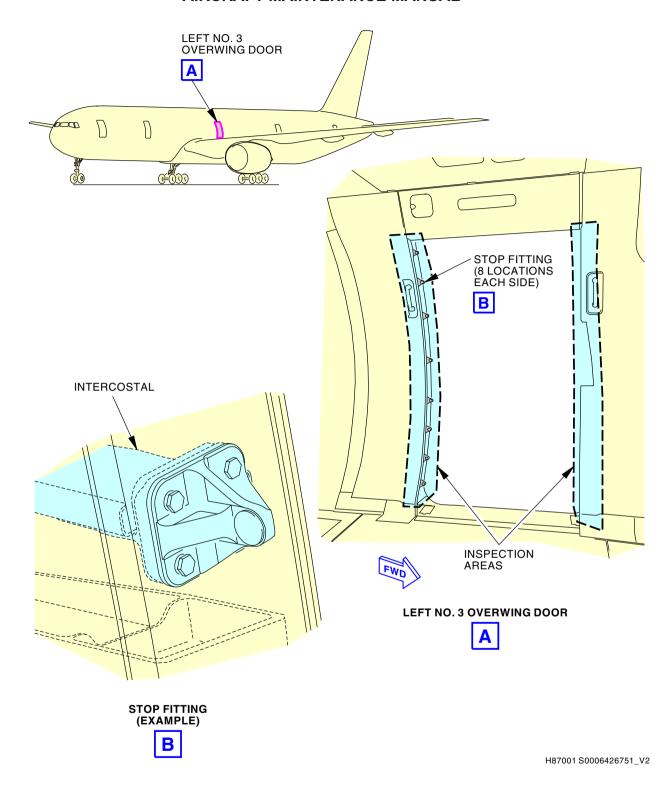
SUBTASK 53-05-03-210-067

(1) Do the inspection.

——— END OF TASK ———

ARO ALL





Cutout Structure, Stop Fittings and Intercostals, Left No. 3 Overwing Door General Visual (External) Figure 346/53-05-03-990-895

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TASK 53-05-03-210-868

102. EXTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT - RIGHT

(Figure 347)

A. Inspection

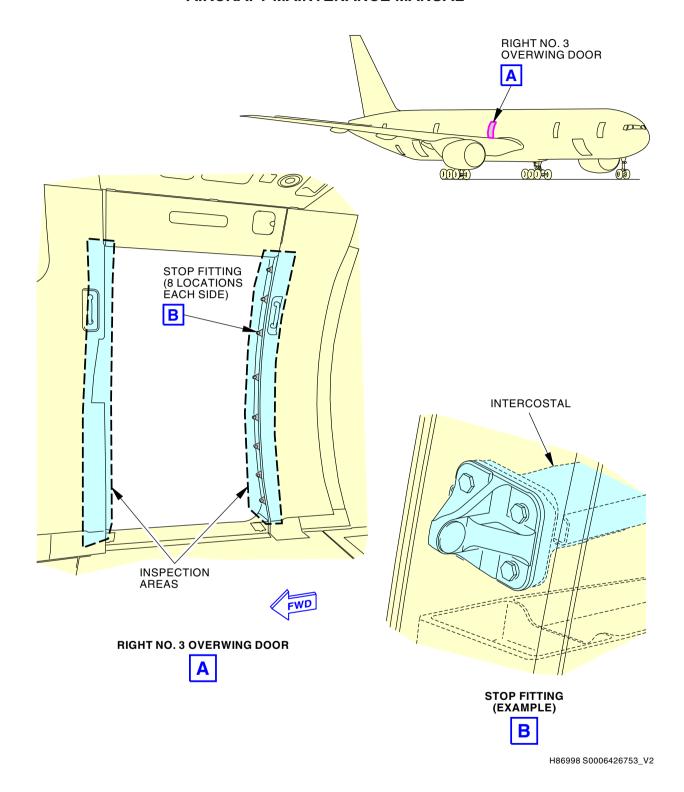
SUBTASK 53-05-03-210-068

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Cutout Structure, Stop Fittings and Intercostals Right No. 3 Overwing Door General Visual (External) Figure 347/53-05-03-990-896

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TASK 53-05-03-210-869

103. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT LEFT AND RIGHT

A. Inspection

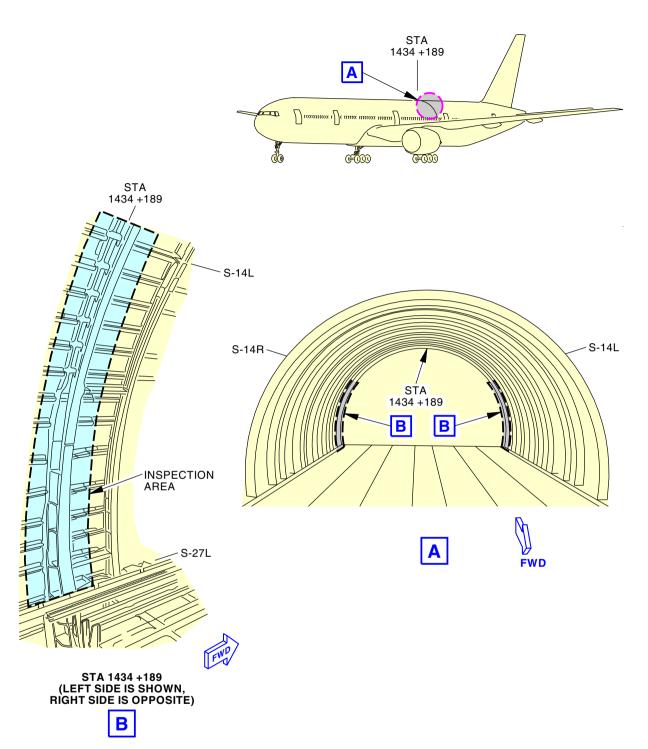
SUBTASK 53-05-03-210-069

(1) Do the inspection. (Figure 348)

——— END OF TASK ———

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Subzone Body Station 1434 +189 Figure 348/53-05-03-990-997

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TASK 53-05-03-210-870-002

104. INTERNAL - GENERAL VISUAL: AREA ABOVE PASSENGER COMPARTMENT CEILING -300ER (Figure 351)

A. Job Set-up

SUBTASK 53-05-03-010-072

- (1) Open access panels, reference Figure 349, Figure 350, Figure 351.
- B. Inspection

SUBTASK 53-05-03-210-172

- (1) Do the inspection.
- C. Job Close-up

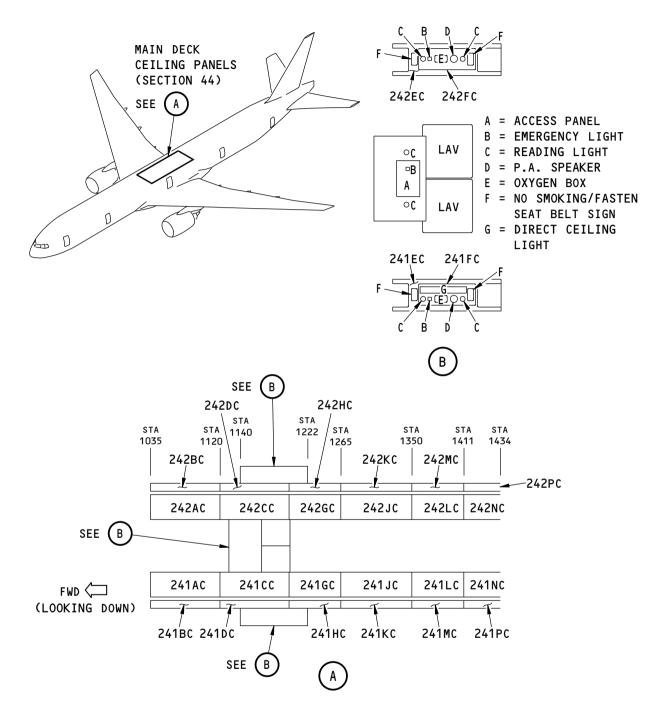
SUBTASK 53-05-03-410-072

(1) Close access panels, reference Figure 349, Figure 350, Figure 351.

——— END OF TASK ———

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ZONE 241/242 PASSENGER CABIN CEILING PANELS Figure 349/53-05-03-990-C45

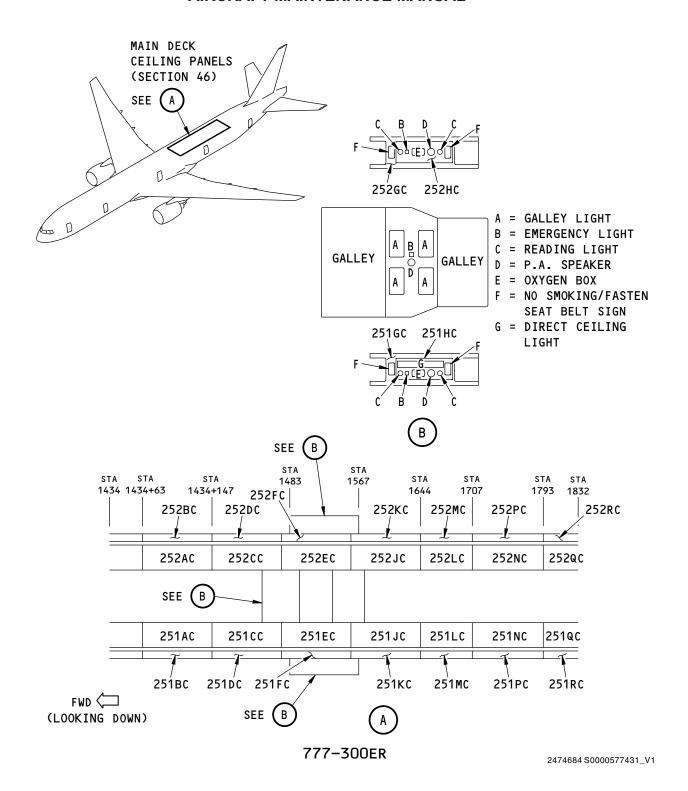
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ZONE 251/252 PASSENGER CABIN CEILING PANELS Figure 350/53-05-03-990-C46

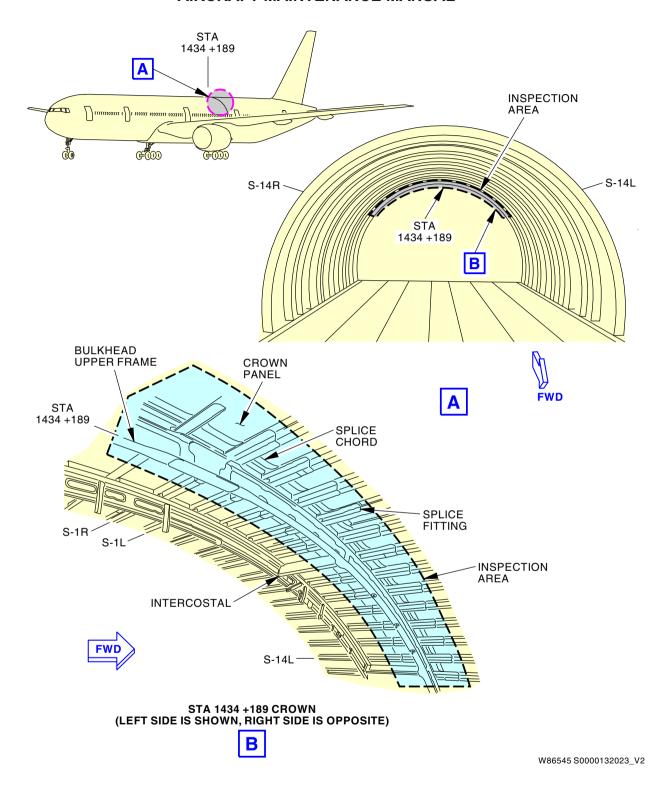
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Circumferential Skin/Stringer Splice at Sta 1434 Figure 351/53-05-03-990-C47

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TASK 53-05-03-211-839

105. INTERNAL - DETAILED: FORWARD WING-TO-BODY FAIRINGS - LEFT (Figure 352)

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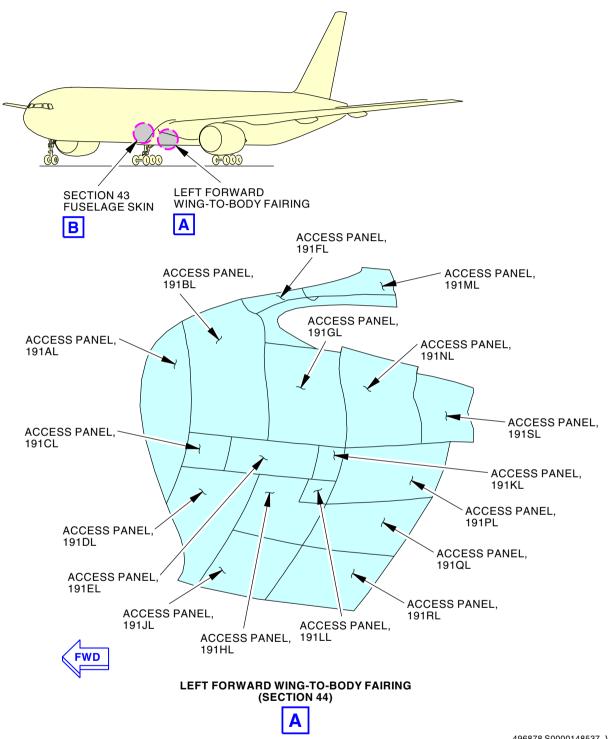
SUBTASK 53-05-03-211-039

(1) Do the inspection.

----- END OF TASK -----

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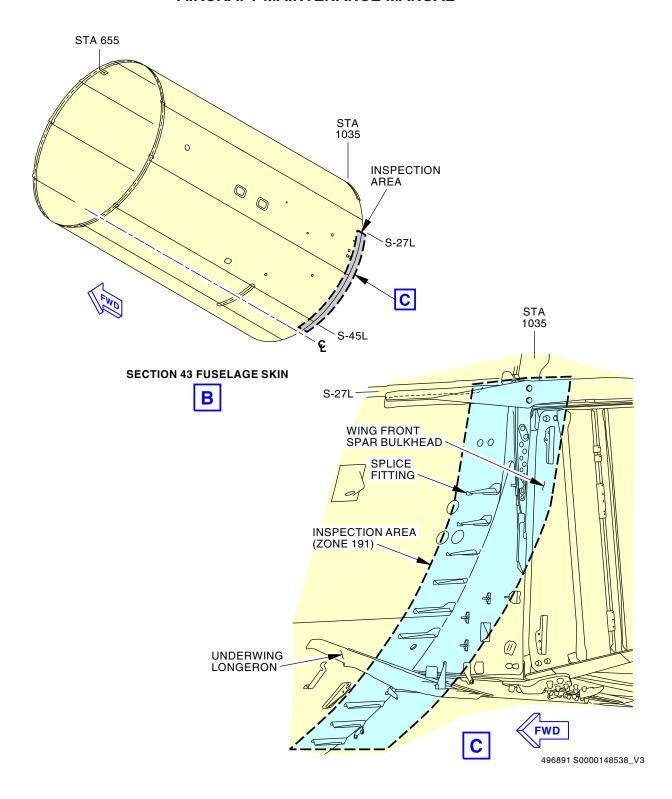
Forward Wing-To-Body Fairings - Left Figure 352/53-05-03-990-916 (Sheet 1 of 2)

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Forward Wing-To-Body Fairings - Left Figure 352/53-05-03-990-916 (Sheet 2 of 2)

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TASK 53-05-03-211-840

106. INTERNAL - DETAILED: FORWARD WING-TO-BODY FAIRINGS - RIGHT (Figure 353)

A. Inspection

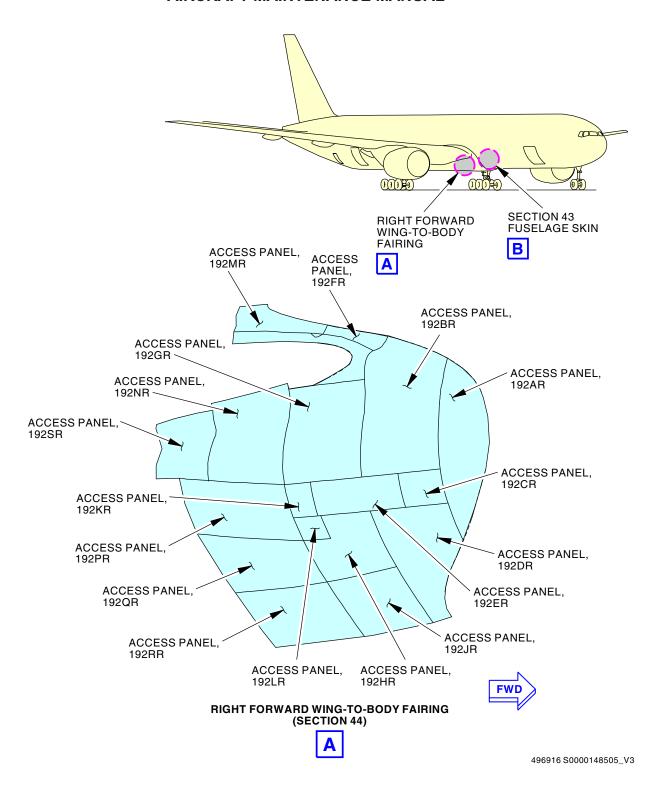
SUBTASK 53-05-03-211-040

(1) Do the inspection.

----- END OF TASK -----

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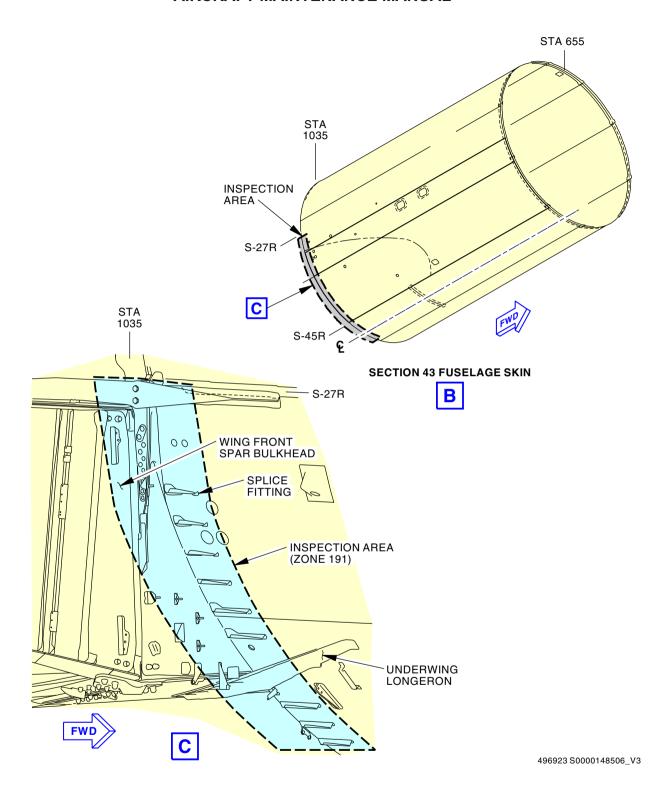
Forward Wing-to -Body Fairings - Right Figure 353/53-05-03-990-910 (Sheet 1 of 2)

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Forward Wing-to -Body Fairings - Right Figure 353/53-05-03-990-910 (Sheet 2 of 2)

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TASK 53-05-03-211-841

107. INTERNAL - DETAILED: AFT WING-TO-BODY FAIRINGS - LEFT

(Figure 354)

A. Inspection

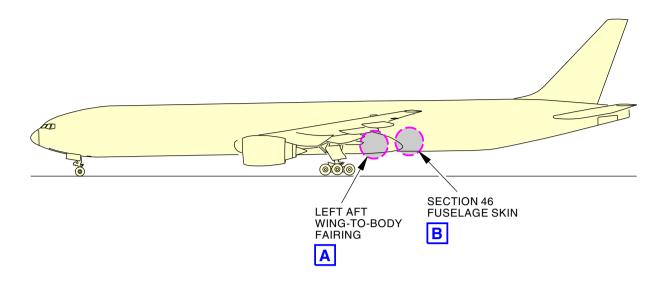
SUBTASK 53-05-03-211-041

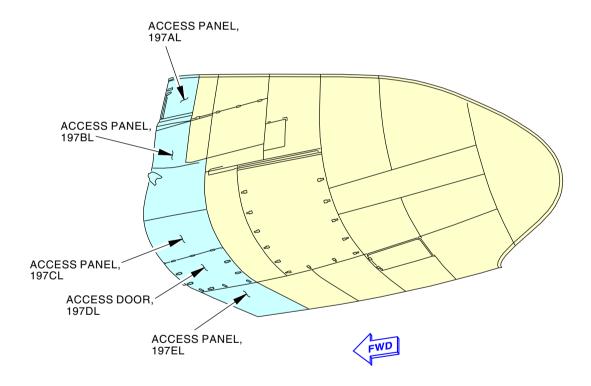
(1) Do the inspection.

----- END OF TASK -----

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LEFT AFT WING-TO-BODY FAIRING



496936 S0000148502_V3

Aft Wing-to-Body Fairings, Left Figure 354/53-05-03-990-909 (Sheet 1 of 2)

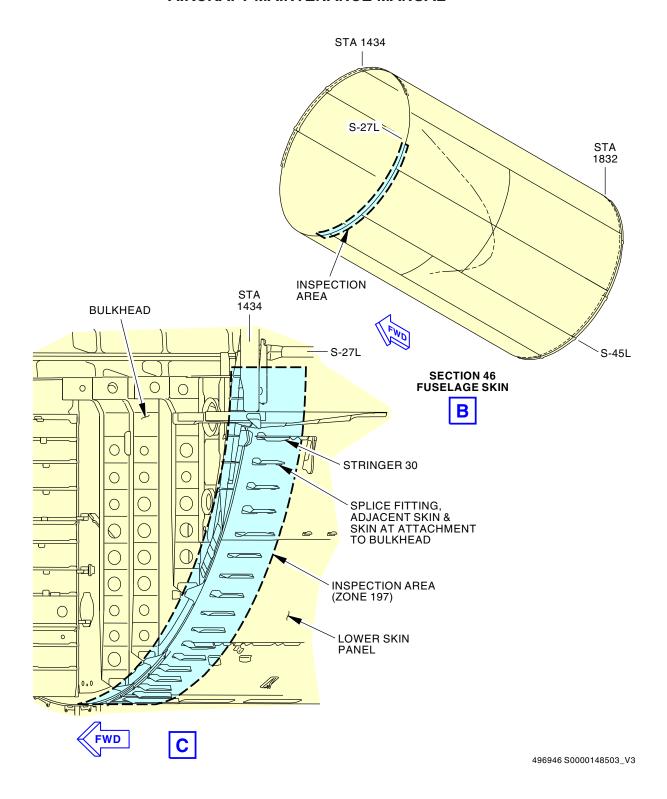
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Aft Wing-to-Body Fairings, Left Figure 354/53-05-03-990-909 (Sheet 2 of 2)

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TASK 53-05-03-211-842

108. INTERNAL - DETAILED: AFT WING-TO-BODY FAIRINGS - RIGHT

(Figure 355)

A. Inspection

SUBTASK 53-05-03-211-042

(1) Do the inspection.

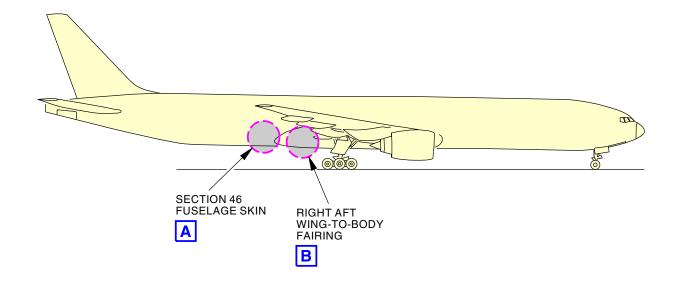
----- END OF TASK -----

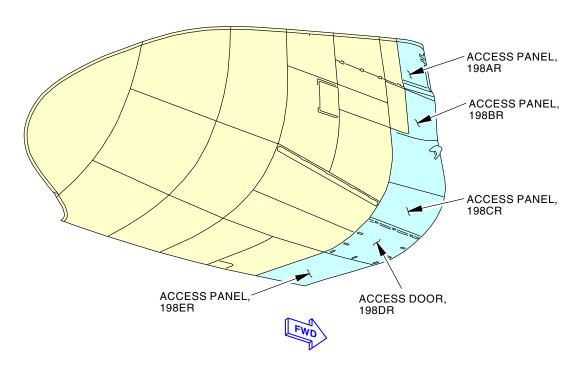
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RIGHT AFT WING-TO-BODY FAIRING



496955 S0000148543_V3

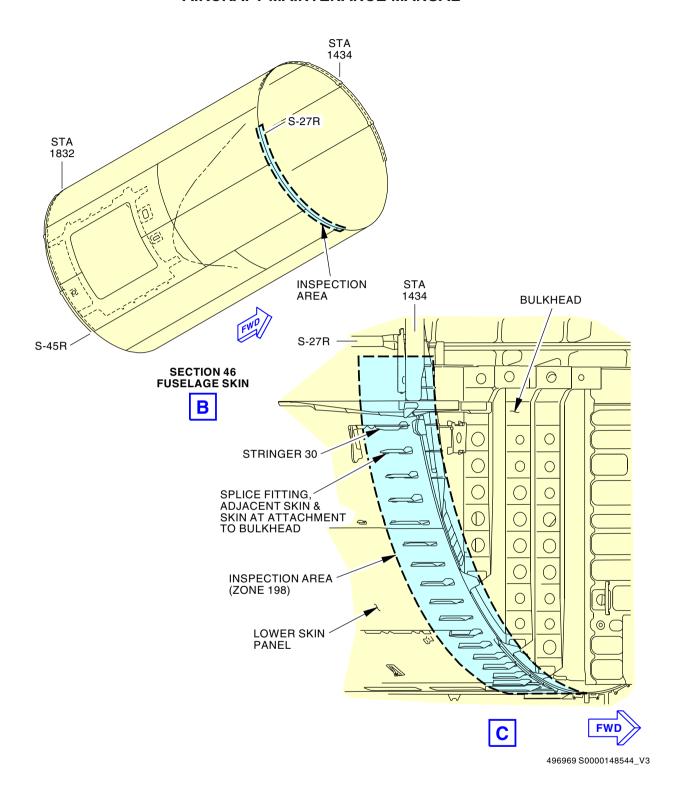
Aft Wing-To-Body Fairings - Right Figure 355/53-05-03-990-917 (Sheet 1 of 2)

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Aft Wing-To-Body Fairings - Right Figure 355/53-05-03-990-917 (Sheet 2 of 2)

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TASK 53-05-03-211-846 109. INTERNAL - DETAILED: PASSENGER COMPARTMENT CEILING

A. Inspection

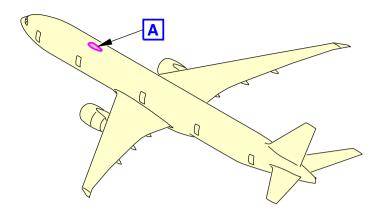
SUBTASK 53-05-03-211-044

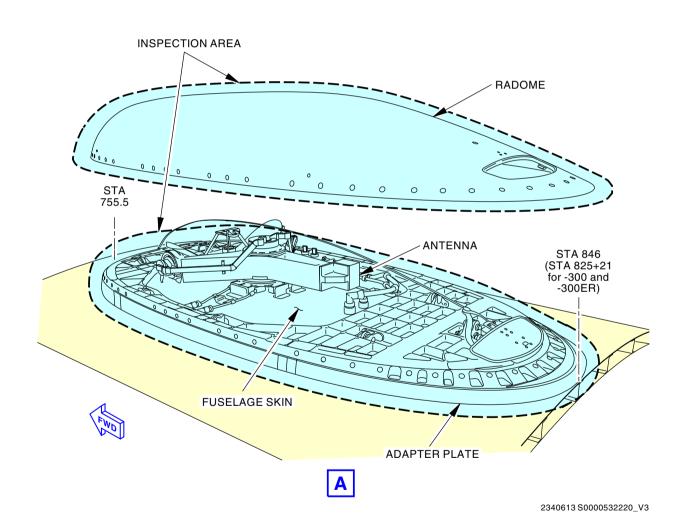
(1) Do the inspection.

----- END OF TASK -----

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Radome installed at BS 755.5 to 846 (BS 825+21 for -300 and -300ER) Figure 356/53-05-03-990-995

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TASK 53-05-03-211-847

110. INTERNAL - SPECIAL DETAILED: PASSENGER COMPARTMENT CEILING

A. Inspection

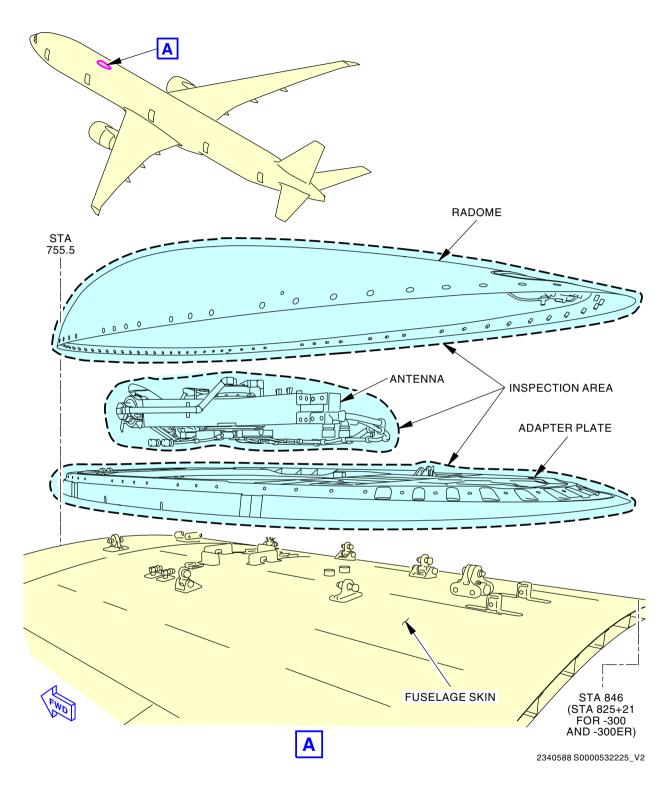
SUBTASK 53-05-03-211-045

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Radome installed at BS 755.5 to 846 (BS 825+21 for -300 and -300ER) Figure 357/53-05-03-990-996

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TASK 53-05-03-210-877 111. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT CEILING

A. Inspection

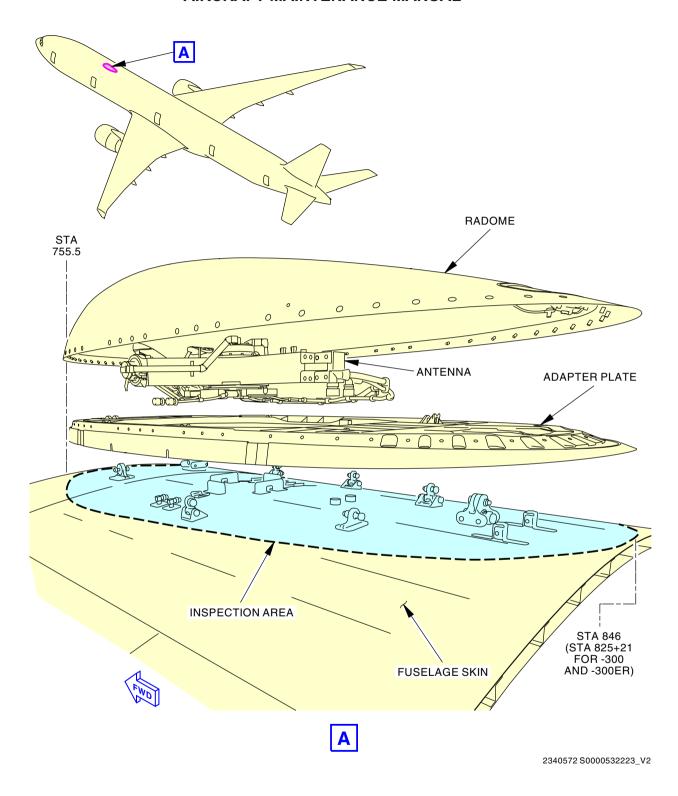
SUBTASK 53-05-03-210-074

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Radome installed at BS 755.5 to 846 (BS 825+21 for -300 and -300ER) Figure 358/53-05-03-990-994

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TASK 53-05-03-211-865

112. INTERNAL — DETAILED: PASSENGER COMPARTMENT CEILING

A. Inspection

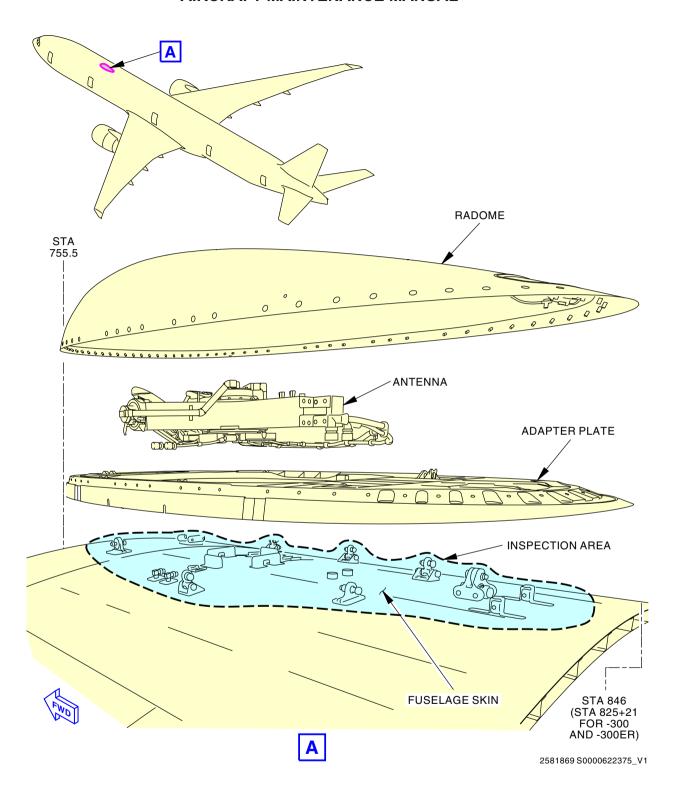
SUBTASK 53-05-03-211-113

(1) Do the inspection.

----- END OF TASK -----

ARO ALL





Radome Installed at BS 755.5 to 846 (BS 825+21 for -300 and -300ER) Figure 359/53-05-03-990-E90

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PASSENGER ENTRY DOOR SCUFF PLATE - REMOVAL/INSTALLATION

1. General

- A. This procedure contains two tasks:
 - (1) The first task is the removal of the scuff plates for the passenger entry door.
 - (2) The second task is the installation of the scuff plates for the passenger entry door.
- B. You must replace the scuff plates for a passenger entry door when the scuff plates are worn or defective.
- C. The clearances between the scuff plates and the airplane structure are sealed for aerodynamic smoothness.

TASK 53-11-01-000-801

2. Remove the Scuff Plates

A. References

| Reference | Title |
|------------------|-------------------------------|
| 53-01-01-000-801 | Floor Panel Removal (P/B 401) |

B. Consumable Materials

| Reference | Description | Specification |
|-----------|-------------------------------------|---------------|
| B00148 | Solvent - Methyl Ethyl Ketone (MFK) | ASTM D740 |

C. Location Zones

| Zone | Area |
|------|--|
| 830 | Subzone 830 - Passenger Compartment Doors, Left |
| 840 | Subzone 840 - Passenger Compartment Doors, Right |

D. Procedure

(Figure 401)

SUBTASK 53-11-01-020-001

- (1) Remove the girt bar floor fittings:
 - (a) Mark the location of the girt bar floor fittings on the scuff plates.
 - (b) Remove the fasteners that attach the girt bar floor fittings to the scuff plate.
 - (c) Remove the girt bar floor fittings.

SUBTASK 53-11-01-010-001

(2) Remove the floor panel adjacent to the scuff plate(Floor Panel Removal, TASK 53-01-01-000-801).

SUBTASK 53-11-01-020-002



BE CAREFUL WHEN YOU REMOVE SEALANT FROM THE EXTERNAL PORTION OF THE SCUFF PLATE. IF YOU ARE NOT CAREFUL, DAMAGE TO THE FUSELAGE SKIN CAN OCCUR.

(3) Remove the scuff plate fasteners.

NOTE: Be careful not to damage the scuff plate or the airplane skin.

NOTE: If a 1.0 inch (25.4 mm) to 1.5 inch (38.1 mm) strip was left without parting agent to improve the sealant to scuff plate bond, extreme care will be required to remove the scuff plate to avoid damage.

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SUBTASK 53-11-01-020-003



BE CAREFUL NOT TO DAMAGE THE SCUFF PLATES OR THE AIPLANE SKIN AS YOU REMOVE THE SCUFF PLATE.

(4) Remove the scuff plate from the airplane.

SUBTASK 53-11-01-110-001



DO NOT GET SOLVENTS IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM THE SOLVENTS. SOLVENTS ARE HAZARDOUS MATERIALS. REFER TO PRODUCT SAFETY DATA SHEETS (MSDS) AND LOCAL REQUIREMENTS FOR PROPER HANDLING PROCEDURES.

(5) Clean all faying surfaces by removing old sealant and parting agent with solvent, B00148 and a plastic scraper.

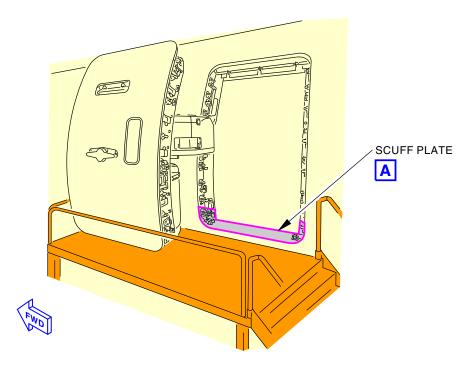
NOTE: If you do not clean the fay surface of the new scuff plate before installation and application of new sealant, an incorrect seal can occur. Whistling, moisture penetration, or pressure leaks can occur if scuff plates are not installed with a new seal.

SUBTASK 53-11-01-210-001

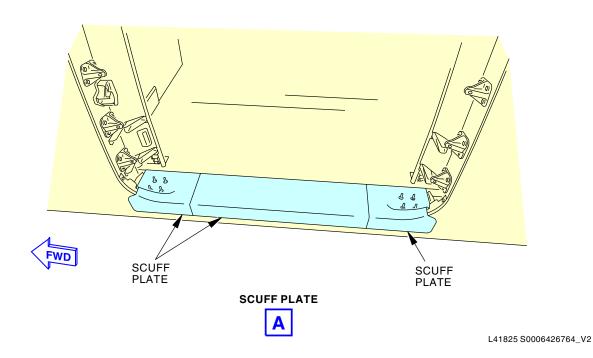
(6) Make sure that the nut plates are in a serviceable condition.

——— END OF TASK ———





PASSENGER ENTRY DOOR (EXAMPLE)



Passenger Entry Door Scuff Plate Installation Figure 401/53-11-01-990-801

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TASK 53-11-01-420-801

3. Install the Scuff Plates

A. References

| Reference | Title |
|------------------|---|
| 51-31-01-160-801 | Prepare For Sealing (P/B 201) |
| 52-12-00-820-801 | Passenger Entry Door Adjustment (P/B 501) |

B. Consumable Materials

| Reference | Description | Specification |
|-----------|--|---|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS5-95 |
| A01024 | Compound - Fairing - 3M EC-3587B | BAC5530 |
| B00148 | Solvent - Methyl Ethyl Ketone (MEK) | ASTM D740 |
| C00064 | Coating - Aluminum Chemical Conversion | BAC5719 Type II Class A (MIL-DTL-5541 Class 1A) |
| G00009 | Compound - Organic Corrosion Inhibiting | BMS3-23 |
| G02185 | Agent - Peelable Parting (Valspar - 4A-183 Green Strippable Coating)Manufacturing discontinued, use stock until depleted | |
| 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. Location Zones

| Zone | Area |
|------|--|
| 830 | Subzone 830 - Passenger Compartment Doors, Left |
| 840 | Subzone 840 - Passenger Compartment Doors, Right |

D. Procedure

(Figure 401)

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SUBTASK 53-11-01-110-002



DO NOT GET SOLVENTS IN YOUR MOUTH, OR YOUR EYES, OR ON YOUR SKIN. SOLVENTS ARE HAZARDOUS MATERIALS. REFER TO PRODUCT MATERIAL SAFETY DATA SHEETS (MSDS) AND LOCAL REQUIREMENTS FOR PROPER HANDLING PROCEDURES.

(1) Clean all faying surfaces with a solvent, B00148 MEK, and wipe.

NOTE: If you do not clean the fay surface of the new scuff plate before installation and application of new sealant, an incorrect seal can occur. Whistling, moisture penetration, or pressure leaks can occur if scuff plates are not installed with a new seal.

SUBTASK 53-11-01-840-001

(2) Apply coating, C00064 alodine and one coat of BMS10-11 Type I primer to the skin surface located underneath the scuff plate including edges of the passenger door entry cutout, except maintain a 0.05 to 0.15 inch (1.27 - 3.81 mm) boundary from the edge of the scuff plate on the underside of the scuff plate on all sides.

SUBTASK 53-11-01-840-002

(3) Apply a coat of peelable parting agent to the scuff plate in all areas that contact a fay surface or pressure seal.

NOTE: You can leave a 1.0 inch (25.4 mm) to 1.5 inch (38.1 mm) strip without parting agent around the perimeter of the scuff plate to provide a better sealant to scuff plate bond. Be aware that the increased adhesion of the sealant will greatly increase the difficulty in scuff plate removal without damage.

- (4) Preferred AC962-73C peelable parting agent, G50365.
 - (a) Alternate Valspar 4A-183 green strippable coating, G02185.
 - (b) Alternate peelable parting agent, G50366.
 - (c) Alternate AZ 634-2 peelable parting agent, G50367.
 - (d) Alternate Rexco Partall Coverall Film peelable parting agent, G50368.
 - (e) Alternate temporary coating, G50369

SUBTASK 53-11-01-840-003

(5) Apply corrosion inhibiting compound, G00009 Type II corrosion inhibiting compound to the area under the threshold.

NOTE: The area in contact with the scuff plate should be masked to prevent exposure to the corrosion inhibiting compound so the sealant will adhere.

SUBTASK 53-11-01-200-001

(6) Check that the nut plates are in the proper position.

SUBTASK 53-11-01-340-001

(7) It is acceptable to trim the phenolic supports prior to bonding if it is required to achieve the scuff plate gage location and fastener clearance.

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SUBTASK 53-11-01-390-001

(8) Prepack sealant, do this task: (Prepare For Sealing, TASK 51-31-01-160-801) sealant, A00247 to the cap, doorsill mating surface and the skin mating surface. Apply a pressure faying surface seal to the skin over the entire area that contacts the scuff plate. Install the scuff plates with fasteners according to the production drawings.

NOTE: It is critical that sufficient sealant be prepacked into the scuff plates to completely fill the gap between the plates and the fuselage skin along the lower edge of the doorway. Continuous sealant squeeze-out is required along all gaps.

SUBTASK 53-11-01-390-002



DRAINAGE HOLES MUST BE CLEAR OF SEALANT. REMOVE ANY SEALANT THAT GETS INTO THE DRAINAGE HOLES.

- (9) Remove excess sealant from the gap and the edge after squeeze-out has stopped.
- (10) Apply fairing compound 3M EC-3587B compound, A01024 as a ramp at a 10 to 1 ratio in the upper corners of the scuff plates to the doorway frame in order to provide a smooth transition for the door seal.

<u>NOTE</u>: No voids, ripples or lumps are allowed in the compound. Final finish of the ramp should be visually equivalent to a 125 AA microinches finish.

SUBTASK 53-11-01-410-001

- (11) Install the girt bar floor fittings:
 - (a) Install the girt bar floor fittings on the scuff plates.
 - (b) Use the location marks to make sure the floor fittings are in the correct location.
 - (c) Install the fasteners that attach the girt bar floor fittings to the scuff plates.
 - (d) Use the steps in the girt bar floor fitting adjustment (TASK 52-12-00-820-801) to make sure the girt bar floor fittings are correctly adjusted.

——— END OF TASK ———



SMALL AFT CARGO DOOR SCUFF PLATES - REMOVAL/INSTALLATION

1. General

- A. This procedure contains two tasks:
 - (1) The first task is the removal of the scuff plats.
 - (2) The second task is the installation of the scuff plates.

TASK 53-11-02-020-801

2. Remove the Scuff Plate

A. References

| Reference | Title |
|------------------|-------------------------------|
| 51-31-01-160-801 | Prepare For Sealing (P/B 201) |

B. Consumable Materials

| Reference | Description | Specification |
|-----------|-------------------------------------|---------------|
| B00148 | Solvent - Methyl Ethyl Ketone (MEK) | ASTM D740 |

C. Location Zones

| Zone | Area |
|------|---------------------------------------|
| 820 | Subzone 820 - Cargo Compartment Doors |

D. Procedure

(Figure 401)

SUBTASK 53-11-02-020-001



BE CAREFUL WHEN YOU REMOVE THE SEALANT FROM THE EXTERNAL PORTION OF THE SCUFF PLATES. IF YOU ARE NOT CAREFUL, DAMAGE TO THE FUSELAGE SKIN CAN OCCUR.

- (1) Prepare the scuff plates for removal.
 - (a) Use a plastic scrapper to remove the sealant around the edge of the scuff plate, do this task: Prepare For Sealing, TASK 51-31-01-160-801.
 - (b) Mark the position of the seal depressors at the fuselage cutout.

SUBTASK 53-11-02-020-002

(2) Remove the scuff plate fasteners.

SUBTASK 53-11-02-020-003



BE CAREFUL NOT TO DAMAGE THE SCUFF PLATES OR THE AIRPLANE SKIN. EXCESS SEALANT THAT IS APPLIED DURING MANUFACTURING MAY BOND SOME AREAS OF THE SCUFF PLATES TO THE AIRPLANE STRUCTURE.

(3) Gently lift and push the scuff plates outboard.

SUBTASK 53-11-02-020-004



DO NOT DAMAGE THE SEAL DEPRESSORS. THE SEAL DEPRESSORS ARE LOCATED BETWEEN THE SCUFF PLATES AND THE FUSELAGE.

(4) Carefully remove the scuff plates from the cargo door cutout on the fuselage.

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SUBTASK 53-11-02-020-005

(5) Remove the scuff plates from the airplane.

SUBTASK 53-11-02-020-006

(6) Mark the locations of shims and their position, if applicable.

SUBTASK 53-11-02-110-001



DO NOT GET SOLVENTS IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. SOLVENTS ARE HAZARDOUS MATERIIALS. REFER TO THE PRODUCT MATERIAL SAFETY DATA SHEETS (MSDS) AND LOCAL REQUIREMENTS FOR PROPER HANDLING PROCEDURES.

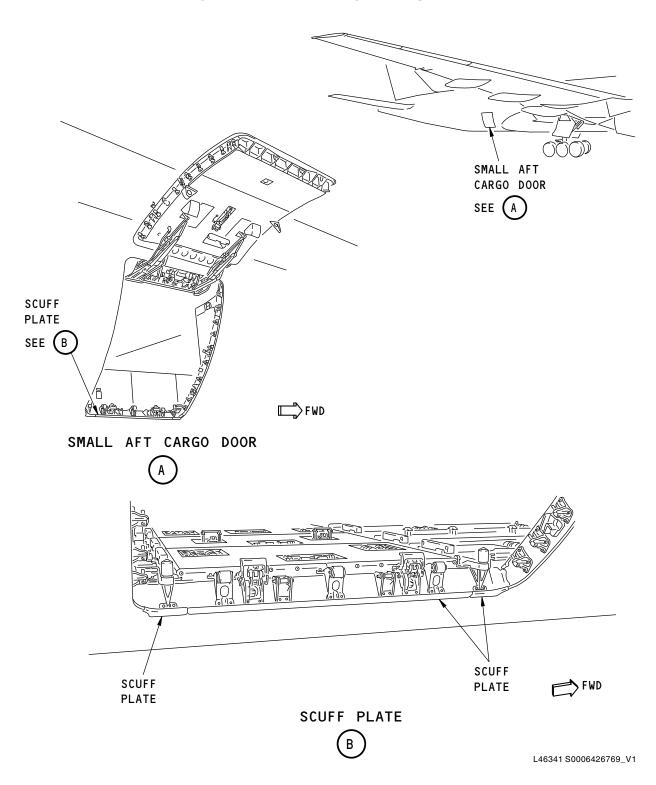
(7) Clean all faying surfaces by removing old sealant and parting agent using a plastic scraper and solvent, B00148.

NOTE: If you do not clean the fay surface of the new scuff plate before installation and application of new sealant, an incorrect seal can occur. Whistling, moisture penetration, or pressure leaks can occur if scuff plates are not installed with a new seal.

----- END OF TASK -----

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Small Aft Cargo Door Scuff Plate Installation Figure 401/53-11-02-990-801

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TASK 53-11-02-420-801

3. Install The Scuff Plates

A. References

| Reference | Title |
|------------------|---|
| 51-31-01 P/B 201 | SEALS AND SEALING - MAINTENANCE PRACTICES |
| 51-31-01-160-801 | Prepare For Sealing (P/B 201) |

B. Consumable Materials

| Reference | Description | Specification |
|----------------|--|---|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS5-95 |
| B00148 | Solvent - Methyl Ethyl Ketone (MEK) | ASTM D740 |
| 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 |
| G00009 | Compound - Organic Corrosion Inhibiting | BMS3-23 |
| Location Zones | | |

C. Location Zones

| 2004.10.1. 201100 | |
|-------------------|---------------------------------------|
| Zone | Area |
| 820 | Subzone 820 - Cargo Compartment Doors |

D. Procedure

(Figure 401)

SUBTASK 53-11-02-210-00

(1) Make sure the scuff plates are in good repair. If not, replace the scuff plates.

SUBTASK 53-11-02-390-001



DO NOT GET SOLVENTS IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM THE SOLVENTS. SOLVENTS ARE HAZARDOUS MATERIALS. REFER TO PRODUCT SAFETY DATA SHEETS (MSDS) AND LOCAL REQUIREMENTS FOR PROPER HANDLING PROCEDURES.

(2) Remove the old sealant with solvent, B00148 and a hardwood or plexiglass scraper from the scuff plates if they are to be reused.

NOTE: If you do not clean the fay surface of the new scuff plate before installation and application of new sealant, an incorrect seal can occur. Whistling, moisture penetration, or pressure leaks can occur if scuff plates are not installed with a new seal.

SUBTASK 53-11-02-110-002



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DO NOT GET SOLVENTS IN YOUR MOUTH OR EYES, OR ON YOUR SKIN. DO NOT BREATH THE FUMES FROM SOLVENTS. SOLVENTS ARE HAZARDOUS MATERIALS. REFER TO THE PRODUCT MATERIAL SAFETY DATA SHEETS (MSDS) AND LOCAL REQUIREMENTS FOR PROPER HANDLING PROCEDURES.

(3) Clean all faying surfaces with solvent, B00148.

53-11-02

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SUBTASK 53-11-02-390-002

(4) Make sure the airplane mating surface for the scuff plates is clean and all of the old sealant is removed, do this task: Prepare For Sealing, TASK 51-31-01-160-801.

SUBTASK 53-11-02-840-001

(5) Apply coating, C00064 alodine and one coat of primer, C00259 to all bare aluminum surfaces including the faying surface of the fuselage skin if applicable.

SUBTASK 53-11-02-350-001

(6) Apply a coat of strippable parting agent to the scuff plates in all areas that contact a faying surface (SEALS AND SEALING - MAINTENANCE PRACTICES, PAGEBLOCK 51-31-01/201).

SUBTASK 53-11-02-350-002

(7) Apply corrosion inhibiting compound, G00009 Type II to the area under the threshold.

<u>NOTE</u>: The area in contact with the scuff plate should be masked to prevent exposure to the corrosion inhibiting compound so the sealant will adhere.

SUBTASK 53-11-02-210-002

(8) Make sure the shims are in good repair and in their correct position, if applicable.

SUBTASK 53-11-02-390-003

(9) Make sure the seal depressors are in the correct position.

SUBTASK 53-11-02-390-004

(10) Prepack sealant sealant, A00247 to the cap, and doorsill mating surface.

NOTE: It is critical that sufficient sealant be prepacked into the scuff plates to completely fill the gap between the scuff plates and the fuselage skin along the lower edge of the doorway. Continuous sealant squeeze-out is required along the gaps.

SUBTASK 53-11-02-390-005

(11) Apply fay surface seal, sealant, A00247, between the entire mating surface of the scuff plates and the skin.

SUBTASK 53-11-02-410-001

(12) Gently push the scuff plates inboard.

SUBTASK 53-11-02-410-002

(13) Install and tighten the fasteners that hold the scuff plates in position.

NOTE: Do not get sealant on the fasteners.

SUBTASK 53-11-02-390-006



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DRAINAGE HOLES MUST BE CLEAR OF SEALANT. REMOVE ANY SEALANT THAT GETS INTO THE DRAINAGE HOLES.

(14) Remove excess sealant from the gap and the edge after squeeze-out has stopped.

——— END OF TASK ———



BULK CARGO DOOR SCUFF PLATE

1. General

- A. This procedure contains two tasks:
 - (1) The first task is the removal of the Bulk Cargo Door Scuff Plate.
 - (2) The second task is the installation of the Bulk Cargo Door Scuff Plate.

TASK 53-11-03-000-801

2. Remove the Scuff Plate

A. References

| Reference | Title |
|------------------|-------------------------------|
| 51-31-01-160-801 | Prepare For Sealing (P/B 201) |

B. Consumable Materials

| Reference | Description | Specification | |
|-----------|-------------------------------------|---------------|--|
| B00148 | Solvent - Methyl Ethyl Ketone (MEK) | ASTM D740 | |

C. Location Zones

| Zone | Area | |
|------|---|--|
| 164 | Area Below Bulk Cargo Compartment Right | |

D. Procedure

(Figure 401)

SUBTASK 53-11-03-140-001



BE CAREFUL WHEN YOU REMOVE THE SEAL WITH THE SEALANT REMOVAL TOOL. DAMAGE TO THE AIRPLANE SKIN CAN OCCUR.

- (1) Prepare the scuff plates for removal.
 - (a) Use a plastic scrapper to remove the sealant around the edge of the scuff plate, do this task: Prepare For Sealing, TASK 51-31-01-160-801.
 - (b) Mark the position of the seal depressors at the fuselage cutout.

SUBTASK 53-11-03-010-001

(2) Remove the scuff plate fasteners.

SUBTASK 53-11-03-010-002



BE CAREFUL WHEN YOU REMOVE THE SCUFF PLATES FROM THE AIRPLANE SKIN. TOO MUCH FORCE APPLIED TO THE SCUFF PLATE CAN CAUSE DAMAGE TO THE SKIN.

(3) Gently lift and push the scuff plates outboard.

SUBTASK 53-11-03-010-003

(4) Carefully remove the scuff plates from the cargo door cutout on the fuselage.

SUBTASK 53-11-03-010-004

(5) Remove the scuff plates from the airplane.

SUBTASK 53-11-03-930-001

(6) Mark the locations of shims and their position, if applicable.

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SUBTASK 53-11-03-010-005



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.

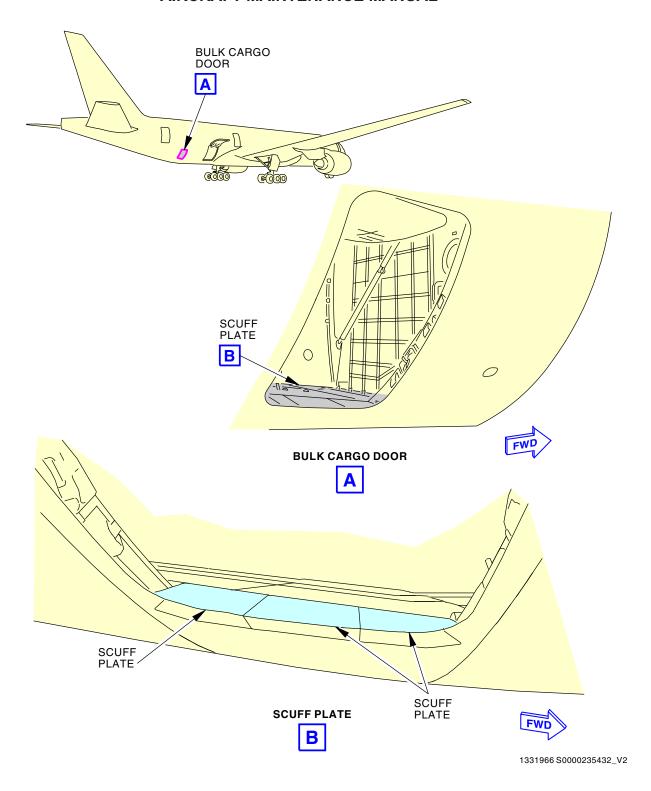
(7) Remove all sealant and parting agent with a plastic scraper and solvent, B00148 to clean the mating surface.

NOTE: If you do not clean the fay surface of the new scuff plate before installation and application of new sealant, an incorrect seal can occur. Whistling, moisture penetration, or pressure leaks can occur if scuff plates are not installed with a new seal.

------ END OF TASK ------

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Bulk Cargo Door Scuff Plate Installation Figure 401/53-11-03-990-801

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TASK 53-11-03-400-801

Install the Scuff Plate

References

| Reference | Title |
|------------------|---|
| 51-31-01 P/B 201 | SEALS AND SEALING - MAINTENANCE PRACTICES |
| 51-31-01-160-801 | Prepare For Sealing (P/B 201) |

B. Consumable Materials

| Reference | Description | Specification |
|-----------------------|--|---|
| A01076 | Adhesive - Synthetic Rubber | BAC5010 Type 93 (BMS5-95 Class B) |
| B00148 | Solvent - Methyl Ethyl Ketone (MEK) | ASTM D740 |
| 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 |
| G00009 | Compound - Organic Corrosion Inhibiting | BMS3-23 |
| Location Zones | | |

C.

| Zone | Area | |
|------|--|--|
| 164 | Area Below Bulk Cargo Compartment, Right | |

D. Procedure

(Figure 401)

SUBTASK 53-11-03-110-001



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

- Make sure that the scuff plate is clean before installation:
 - Remove the remaining sealant with solvent, B00148 and a hardwood or plexiglass scraper from the scuff plates.

NOTE: If you do not clean the fay surface of the new scuff plate before installation and application of new sealant, an incorrect seal can occur. Whistling, moisture penetration, or pressure leaks can occur if scuff plates are not installed with a new seal.

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SUBTASK 53-11-03-110-002



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) Clean all faying surfaces with solvent, B00148.

SUBTASK 53-11-03-010-006

(3) Make sure that the airplane mating surface for the scuff plates is clean and that all of the remaining sealant is removed, do this task: Prepare For Sealing, TASK 51-31-01-160-801.

SUBTASK 53-11-03-620-001

(4) Apply coating, C00064 alodine and one coat of primer, C00259 to all bare aluminum surfaces including the faying surface of the fuselage skin if applicable.

SUBTASK 53-11-03-620-002

(5) Apply a coat of strippable parting agent to the scuff plates in all areas that contact a faying surface (SEALS AND SEALING - MAINTENANCE PRACTICES, PAGEBLOCK 51-31-01/201).

SUBTASK 53-11-03-410-001

(6) Apply corrosion inhibiting compound, G00009 Type II to the area under the threshold.

NOTE: The area in contact with the scuff plate should be masked to prevent exposure to the corrosion inhibiting compound so the sealant will adhere.

SUBTASK 53-11-03-410-002

- (7) Make sure that the shims are in good repair and in their correct position, if applicable:
 - (a) Add shims if clearance is more than 0.005 in. (0.127 mm).
 - (b) The maximum shim thickness is 0.050 in. (1.270 mm).
 - (c) Make sure that the clearance is not more than 0.010 in. (0.254 mm) after shims are added.

SUBTASK 53-11-03-410-003

(8) Make sure the seal depressors are in the correct position.

SUBTASK 53-11-03-410-004

(9) Apply pre-pack seal withadhesive, A01076 to the cap, and doorsill mating surface.

NOTE: It is very important that sufficient sealant be pre-packed into the scuff plates. It is necessary to fill the clearance between the scuff plates and the fuselage skin along the lower edge of the doorway. Continuous sealant squeeze-out is necessary along the clearance.

SUBTASK 53-11-03-410-005

(10) Apply a fay surface seal, adhesive, A01076 between the full mating surface of the scuff plates and the skin.

SUBTASK 53-11-03-410-006

(11) Gently push the scuff plates inboard.

SUBTASK 53-11-03-410-007

(12) Install and tighten the fasteners that hold the scuff plates in position.

NOTE: Do not get sealant on the fasteners.

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SUBTASK 53-11-03-610-001



MAKE SURE THAT THE DRAIN HOLES AND PATHS ARE CLEAR. IF THE DRAIN HOLES AND PATHS ARE NOT CLEAR, CORROSION CAN OCCUR.

(13) Remove excess sealant from the gap and the edge after squeeze-out has stopped.

SUBTASK 53-11-03-410-008

(14) Do the task again if necessary for the adjacent scuff plates.

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|-----|-----|------|--|

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NOSE RADOME - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
 - (1) Open the nose radome.
 - (2) Close the nose radome.

TASK 53-12-00-010-801

2. Open the Nose Radome

(Figure 201)

A. Location Zones

| Zone | Area |
|------|--------|
| 111 | Radome |

B. Prepare to open the nose radome.

SUBTASK 53-12-00-840-001



BE VERY CAREFUL IF YOU OPEN THE NOSE RADOME WHEN THERE IS WIND. DO NOT OPEN THE NOSE RADOME WHEN THE WIND WILL CAUSE DAMAGE. WIND CAN CAUSE DAMAGE TO THE NOSE RADOME AND INJURY TO PERSONS.

(1) Make sure the wind is less than 65 knots before you open the nose radome.

C. Procedure

SUBTASK 53-12-00-020-001



WHEN YOU OPEN THE NOSE RADOME LATCHES, MAKE SURE TO ALIGN THE HEX WRENCH WITH THE WRENCH RECESS (APPROXIMATELY 60 DEGREES TO THE RADOME SURFACE). YOU CAN EASILY CAUSE DAMAGE TO THE LATCH MECHANISM IF YOU DO NOT ALIGN THE WRENCH CORRECTLY.

(1) Use the hex wrench to open the latches.

NOTE: Start with the bottom latches and move toward the top.

SUBTASK 53-12-00-010-001

(2) Move the nose radome to the open position.

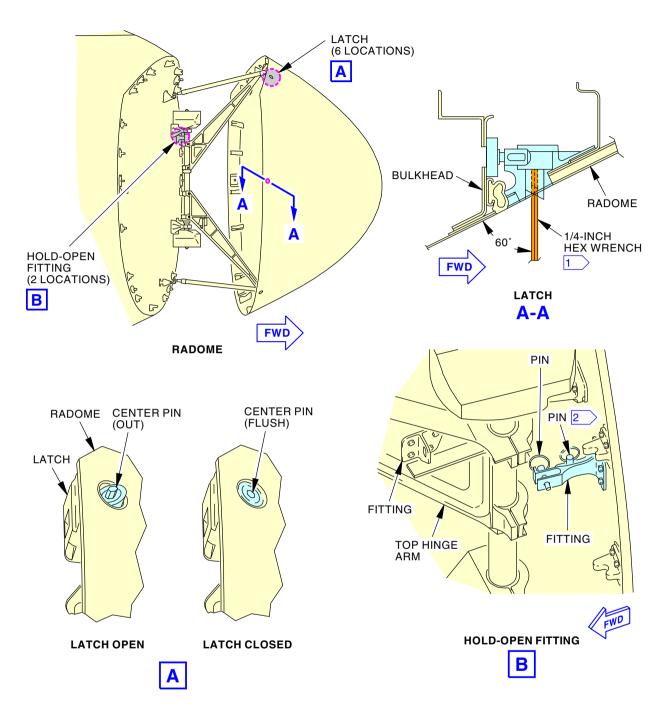
SUBTASK 53-12-00-480-001

- (3) Safety the nose radome as follows:
 - (a) Remove the two pins from the hold-open fittings.
 - (b) Move the nose radome until the fittings on the hinge arms are in the hold-open fitting clevises on the bulkhead.
 - (c) Insert the two pins through the clevis fittings to hold the nose radome in the fully open position.

| END | OF T | ΔSK - | |
|---------|------|-------|--|

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1 THE LATCH MUST OPERATE BETWEEN 100-150 POUND-INCHES OF TORQUE.
2 STOW THE PIN HERE WHEN NOT IN USE, IF HOLE EXISTS.

C25217 S0006426778_V3

Radome Operation Figure 201/53-12-00-990-802

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TASK 53-12-00-410-802

3. Close the Nose Radome

A. References

| Reference | Title |
|------------------|---|
| 53-12-01-820-801 | Nose Radome Adjustment (P/B 501) |
| 53-12-01-990-805 | Figure: Radome Hold-Open Fitting Necessary Conditions (P/B 501) |

B. Location Zones

| Zone | Area | | |
|------|--------|--|--|
| 111 | Radome | | |

C. Prepare to close the nose radome.

SUBTASK 53-12-00-160-001

(1) Dry the front surface of the antenna flatplate for the weather-radar.

NOTE: If the water such as the raindrop remain on the flatplate, transmitting and receiving radio wave becomes weak, and the radar performance gets worse. Thus, do not open the radome in the rainy condition. If the water remains on the flatplate, wipe off the water completely before the radome is closed.

SUBTASK 53-12-00-080-001

(2) Remove the two pins that safety the radome in the fully open position.

SUBTASK 53-12-00-410-003

(3) Move the radome toward the closed position so that the fitting lugs on the hinge arms are removed from the bulkhead fitting clevises.

SUBTASK 53-12-00-410-005



MAKE SURE THAT THE PIN RINGS ARE STOWED INBOARD OF THE BULKHEAD FITTINGS CLEVISES. PIN RINGS THAT ARE OUTBOARD OF THE CLEVISES CAN CAUSE DAMAGE TO THE RADOME WHEN THE RADOME IS CLOSED.

- (4) Put the pins in the bulkhead fitting clevises so the rings are inboard of the fitting if the open hole does not exist (Figure 53-12-01-990-805).
 - (a) Stow the pins in the vertical position on the bulkhead fitting if the open hole exists.

D. Procedure

SUBTASK 53-12-00-410-001

- (1) Move the nose radome to the fully closed position.
 - (a) Make sure each eyebolt on the bulkhead is in its applicable latch on the nose radome.

SUBTASK 53-12-00-410-002



WHEN YOU CLOSE THE NOSE RADOME LATCHES, MAKE SURE TO ALIGN THE HEX WRENCH WITH THE WRENCH RECESS (APPROXIMATELY 60 DEGREES TO THE RADOME SURFACE). YOU CAN EASILY CAUSE DAMAGE TO THE LATCH MECHANISM IF YOU DO NOT ALIGN THE WRENCH CORRECTLY.

- (2) Use the hex wrench to close the latches as follows:
 - (a) Hold the nose radome in the closed position.

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- (b) Latch the top latches.
- (c) Latch the middle latches.
- (d) Latch the bottom latches.
- (e) Make sure the torque necessary to close each latch is between 100 and 150 pound-inches.
- (f) Adjust the latch torque if it is necessary; (TASK 53-12-01-820-801).
- (g) Make sure each latch is fully turned to the latched position.
- (h) Make sure the pin in the latch is flush with the radome to show that the latch is fully closed.

----- END OF TASK -----

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NOSE RADOME - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Removal of the nose radome.
 - (2) Installation of the nose radome.

TASK 53-12-01-000-801

2. Nose Radome Removal

(Figure 401)

A. References

| Reference | Title |
|------------------|----------------------------------|
| 53-12-00-010-801 | Open the Nose Radome (P/B 201) |
| 53-12-01-200-801 | Nose Radome Inspection (P/B 601) |

B. Tools/Equipment

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

| Reference | Description | |
|-----------|--|--|
| SPL-2008 | Sling, Radome | |
| | Part #: A53001-14 Supplier: 81205 | |
| STD-1095 | Crane - Lift, 2000 lb Capacity, 30 Foot Height | |

C. Consumable Materials

| Reference | Description | Specification |
|-----------|--|---------------|
| A00247 | Sealant - Pressure And Environmental - | BMS5-95 |
| | Chromate Type | |

D. Location Zones

| Zone | Area |
|------|--------|
| 111 | Radome |

E. Prepare to Remove the Radome

SUBTASK 53-12-01-020-005

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

Overhead Circuit Breaker Panel, P11

| Row | <u>Col</u> | <u>Number</u> | <u>Name</u> |
|-----|------------|---------------|-------------|
| Ε | 6 | C34439 | WXR L R/T |
| E | 16 | C34438 | WXR R R/T |

SUBTASK 53-12-01-420-001

- (2) Attach the radome sling, SPL-2008, [1] to the radome assembly [12], as follows:
 - (a) Open the radome assembly [12], do this task: Open the Nose Radome, TASK 53-12-00-010-801.
 - (b) Put the radome sling, SPL-2008, [1] around the radome assembly [12].
 - (c) Attach the radome sling, SPL-2008, [1] to the 30 foot height (2000 lb capacity) lift crane, STD-1095.

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(d) Lift the 30 foot height (2000 lb capacity) lift crane, STD-1095 the minimum distance necessary to tighten the radome sling, SPL-2008, [1].

F. Removal

SUBTASK 53-12-01-020-001

- (1) Disconnect the top and bottom guide links [6] from their fittings [5] on the radome assembly [12] as follows.
 - (a) Remove the pin [2], castle nut [3], and washer [4] from the guide link fittings [5].
 - (b) Move the two guide links [6] off the fittings [5].

SUBTASK 53-12-01-020-002

- (2) Disconnect the bottom hinge arm [11] as follows:
 - (a) Remove the locking strap [7], nut [8], and washer [9] from the bottom fitting [10].
 - (b) Use your hand or knee to apply a downward force to the lower portion of the radome to clear radome bottom fitting [10] from the lower hinge arm [11].
 - (c) If the lower hinge arm can not be removed from the fitting, loosen the lower hinge arm [11]:
 - NOTE: These steps are only necessary if the usual removal of the radome is not easy and can not be done. Changes to the hinge arm locations on the torque tube will make it necessary to put back the hinge arms to their initial location before radome installation.
 - 1) Loosen the 4 bolts that hold the lower hinge arm [11] to the radome torque tube.
 - 2) Carefully move the lower hinge arm [11] up, but do not hit the bolt that is installed through the torque tube.
 - NOTE: This will make approximately 0.5 in. (1.3 cm) more clearance at the [10] fitting.

SUBTASK 53-12-01-020-003

- (3) Disconnect the top hinge arm [11] as follows:
 - (a) Remove the pin [2], nut [8], and washer [9] from the fitting [10].

SUBTASK 53-12-01-010-001

- (4) Remove the nose radome assembly [12] as follows:
 - (a) Carefully lift the radome assembly [12] with the sling [1] until the top stud is clear of the top hinge arm.
 - (b) Move the radome assembly [12] away from the airplane.

SUBTASK 53-12-01-200-016

- (5) Examine the nose radome seal for damage.
 - (a) Do this task: Nose Radome Inspection, TASK 53-12-01-200-801.

SUBTASK 53-12-01-200-017

(6) Make sure that there is sealant around the radome seal retainer.

SUBTASK 53-12-01-020-006

- (7) If you find damage, replace the radome seal (Figure 402):
 - (a) Remove the radome seal from the retainer.
 - (b) Apply the sealant, A00247.
 - (c) Fully fill the area between the retainer, the forward pressure bulkhead, and the skin with the sealant, A00247.

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- (d) Install the radome seal while the sealant, A00247 is wet.
- (e) Clean the area from unwanted sealant.

----- END OF TASK -----

TASK 53-12-01-400-801

3. Nose Radome Installation

(Figure 401)

A. References

| Reference | Title |
|------------------|----------------------------------|
| 53-12-00-410-802 | Close the Nose Radome (P/B 201) |
| 53-12-01-820-801 | Nose Radome Adjustment (P/B 501) |

B. Tools/Equipment

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

| Reference | Description |
|-----------|---|
| COM-614 | Bonding Meters - Non-Intrinsically Safe (For use in outside Class I, Divisions I & II non-hazardous locations. For hazardous locations, use COM-1550). |
| | Part #: 247000 Supplier: 00426 Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: T477W Supplier: 01014 Opt Part #: 247001 Supplier: 00426 Opt Part #: M1B Supplier: 3AD17 |
| COM-1550 | Bonding Meters - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). |
| | Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: T477W Supplier: 01014 Opt Part #: M1B Supplier: 3AD17 |
| SPL-2008 | Sling, Radome Part #: A53001-14 Supplier: 81205 |
| STD-1095 | Crane - Lift, 2000 lb Capacity, 30 Foot Height |

C. Consumable Materials

| Reference | Description | Specification |
|-----------|--|-----------------------|
| A00159 | Compound - Sealing, Thread-Locking, | ASTM D5363 Grp 3 Cl 2 |
| | Anaerobic, Single-Component (100-200 In-lbs) | Grd 1 (SUPERSEDES |
| | | MIL-S-46163) |

D. Expendables/Parts

| AMM Item | Description | AIPC Reference | AIPC Effectivity |
|----------|-------------|-----------------|------------------|
| 2 | Pin | 53-12-01-01-025 | ARO ALL |
| 7 | Strap | 53-12-01-01-020 | ARO ALL |

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E. Location Zones

| Zone | Area |
|------|--------|
| 111 | Radome |

F. Installation

SUBTASK 53-12-01-420-002

(1) Put the radome sling, SPL-2008, [1] on the radome assembly [12].

SUBTASK 53-12-01-410-001

(2) Lift the radome assembly [12] into position with the 30 foot height (2000 lb capacity) lift crane, STD-1095.

SUBTASK 53-12-01-420-003

- (3) Attach the top hinge arm [11] as follows:
 - (a) Carefully lower the radome assembly [12] until the top stud goes through the bearing at the end of the top hinge arm [11].
 - (b) Install the washers [4] and the castle nut [3] on the fitting [10].
 - (c) Tighten the castle nut [3] with your hand.

SUBTASK 53-12-01-420-004

- (4) Attach the bottom hinge arm [11] as follows:
 - (a) For a loosened lower hinge arm only, follow the steps to tighten the hinge arm.

NOTE: These steps are only necessary if the bolts of the lower hinge arm [11] were loosened in the removal task.

- 1) Make sure that the lower hinge arm is in its initial position before it was loose.
- 2) Tighten the 4 bolts that hold the lower hinge arm [11] to the radome torque tube.
- 3) Install lockwire on the 4 bolts that hold the lower hinge arm [11] to the radome torque tube.
- (b) Install one of the two washer [9] on the bottom radome fitting [10].
- (c) Use your hand or knee to force the bottom radome stud under the hinge arm [11] and into the bearing.
- (d) Apply compound, A00159 to the threads on the bottom fitting [10].
- (e) Put the washer [9] and nut [8] on the bottom fitting [10] but do not tighten them fully.
- (f) Tighten the castle nut [3] on the top fitting [10] and install the pin [2].



DO NOT TIGHTEN THE NUT TOO MUCH. IF YOU TIGHTEN THE NUT MORE THAN 60 POUND-INCHES, YOU WILL DAMAGE THE BOTTOM STUD.

- (g) Tighten the nut [8] on the bottom stud to 50-60 pound-inches.
- (h) Install the locking strap [7] on the bottom fitting [10].

SUBTASK 53-12-01-020-004

(5) Remove the radome sling, SPL-2008, [1] from the radome assembly [12].

SUBTASK 53-12-01-420-005

- (6) Connect the guide links [6] to the fittings [5] on the radome assembly [12].
 - (a) Put the end of the top guide link [6] over the stud on the radome assembly [12].
 - (b) Install the washer [4], castle nut [3], and pin [2] on the top fitting [5].

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- (c) Put the end of the bottom guide link [6] over the stud on the radome assembly [12].
- (d) Install the washer [4], castle nut [3], and pin [2] on the bottom fitting [5].
- (e) Make sure the drain holes in each guide link [6] point down.

SUBTASK 53-12-01-420-007

(7) Make sure that these circuit breakers are closed:

Overhead Circuit Breaker Panel, P11

| Row | <u>Col</u> | <u>Number</u> | <u>Name</u> |
|-----|------------|---------------|-------------|
| E | 6 | C34439 | WXR L R/T |
| Ε | 16 | C34438 | WXR R R/T |

SUBTASK 53-12-01-820-012

(8) Before you close the radome assembly [12], do this task: Nose Radome Adjustment, TASK 53-12-01-820-801.

SUBTASK 53-12-01-940-001

- (9) Close the radome assembly [12], do this task: Close the Nose Radome, TASK 53-12-00-410-802.
 - (a) Measure the resistance between the ground plates on the radome and the airplane skin with an intrinsically safe approved bonding meter, COM-1550, or non-intrinsically safe bonding meter, COM-614 (Figure 403).
 - (b) Make sure the maximum resistance does not exceed 0.01 Ohms.

SUBTASK 53-12-01-820-001

(10) Return airplane to normal operating condition.

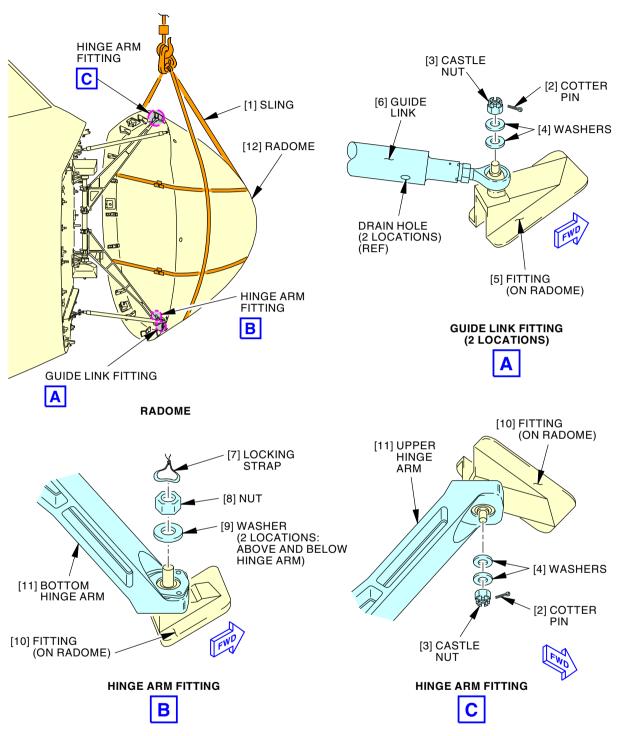
----- END OF TASK -----

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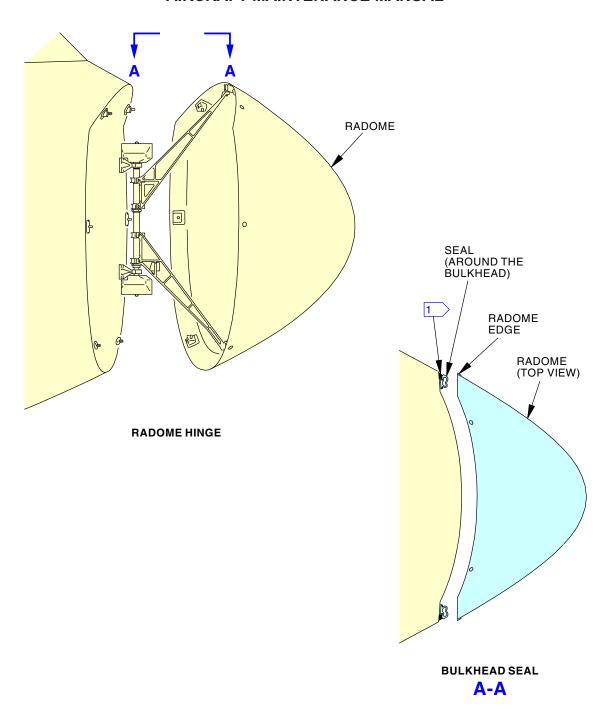
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Nose Radome - Removal and Installation Figure 401/53-12-01-990-801

53-12-01 EFFECTIVITY **ARO ALL** D633W101-ARO ${\tt ECCN\,9E991\,BOEING\,PROPRIETARY\,-\,Copyright\,@\,Unpublished\,Work\,-\,See\,title\,page\,for\,details}$

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1 FILL THE VOID BETWEEN THE BULKHEAD, THE SEAL RETAINER, AND THE SEAL WITH BMS 5-95 SEALANT.

1464048 S0000266879_V2

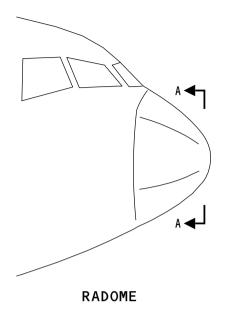
Bulkhead Seal - Apply BMS 5-95 Sealant Figure 402/53-12-01-990-816

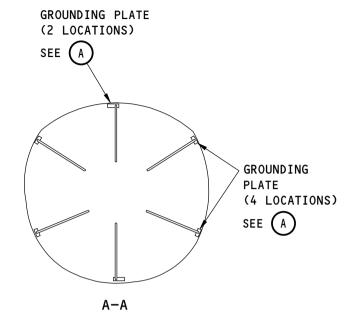
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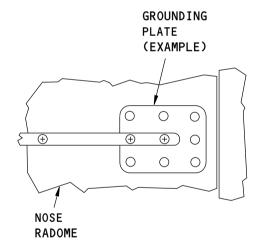
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GROUNDING PLATE
(EXTERNAL SIDE)
(EXAMPLE)

2473908 S0000578700_V1

Nose Radome - Grounding Plates Figure 403/53-12-01-990-820

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D633W101-ARO

53-12-01

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NOSE RADOME - ADJUSTMENT/TEST

1. General

- A. This procedure has one task:
 - (1) Adjustment of the nose radome.

TASK 53-12-01-820-801

2. Nose Radome Adjustment

(Figure 501, Figure 502, Figure 503, Figure 504, Figure 505, Figure 506, Figure 507, Figure 508, Figure 509, Figure 510, Figure 511, Figure 512, Figure 513)

A. General

(1) Do a check on each part of the radome to find problem areas.

B. References

| Reference | Title |
|------------------|--------------------------------|
| 53-12-00-010-801 | Open the Nose Radome (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-4401 | Wrench Set, Radome Latch Torque Adjustment | |
| | Part #: J53004-1 Supplier: 81205 | |

D. Consumable Materials

| Reference | Description | Specification |
|-----------|--|---|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS5-95 |
| C00064 | Coating - Aluminum Chemical Conversion | BAC5719 Type II Class A (MIL-DTL-5541 Class 1A) |
| C00259 | Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer | BMS10-11 Type I |

E. Location Zones

| Zone | Area | |
|------|--------|--|
| 111 | Radome | |

F. Prepare to Adjust the Nose Radome.

SUBTASK 53-12-01-820-002

(1) Do the adjustment for each part of the radome to correct problem areas.

SUBTASK 53-12-01-820-003

(2) Use (Figure 501) as a checklist and guide for all checks, adjustments, and necessary conditions while you rig the nose radome.

ARO ALL



SUBTASK 53-12-01-820-004

(3) Do the checks and adjustments in (Figure 503) until you have all the necessary conditions at the same time.

NOTE: Adjustments are related. When you change one of them, you must continue to check and change the other adjustments until they are all satisfactory.

SUBTASK 53-12-01-010-002



BE VERY CAREFUL WHEN YOU MOVE THE RADOME BEFORE IT IS FULLY ADJUSTED. PARTS THAT ARE NOT ALIGNED CORRECTLY CAN ACCIDENTALLY TOUCH. LOOK AT THE PARTS WHEN YOU MOVE THE RADOME OR YOU CAN CAUSE DAMAGE TO IT.

(4) If it is necessary, do this task: Open the Nose Radome, TASK 53-12-00-010-801.

G. Adjust Radome Hinge

SUBTASK 53-12-01-210-001

- (1) Do a check of the nose radome hinge (Figure 501) as follows:
 - (a) Move the radome to the closed position.
 - (b) Look at keeper pins L1, L2, and L3 to make sure they go into their latches.
 - (c) Make sure the pins do not hit their latches while they go into them.

SUBTASK 53-12-01-420-006



DO NOT MAKE CHANGES TO THE UPPER/LOWER HINGE ARM ASSEMBLIES ON THE TORQUE TUBE ASSEMBLY. TRY ALL OTHER RIGGING OPTIONS FIRST. HINGE ARM ASSEMBLIES ON TORQUE TUBE ASSEMBLY ARE TOOL LOCATED. IF YOU CHANGE THE POSITION OF HINGE ARM ASSEMBLIES, EXTENSIVE ADJUSTMENT WILL BE REQUIRED TO PROPERLY RIG HINGE ARM ASSEMBLIES DURING RADOME INSTALLATION.

(2) Adjust the hinge (Figure 506), if it is necessary:

NOTE: If you choose to adjust hinge arm assemblies, adjust one hinge assembly at a time. Check the adjustment of the first hinge assembly before adjusting the other hinge assembly.

- (a) Open the nose radome.
- (b) Remove the keyed retainer caps from the hinge arms.
- (c) Loosen the other retainer caps (without the key).
- (d) Turn the nut below the bottom hinge arm until it is away from the hinge arm.
- (e) Turn the adjustment nut to move the radome up or down.
- (f) Tighten the retainer caps.
- (g) Install the keyed retainer caps.
- (h) Tighten the keyed retainer caps.
- (i) Tighten the bottom nut against the bottom hinge arm.

H. Adjust Guide Links

SUBTASK 53-12-01-200-005

- (1) Do a check of the guide links (Figure 505), as follows:
 - (a) Move the radome to the closed position.

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- (b) See when the edges of the nose radome touch the seal at all locations.
- (c) Make sure each part of the radome edge touches the seal at the same time.

SUBTASK 53-12-01-820-005

- (2) Adjust the guide links (Figure 507), if it is necessary:
 - (a) Open the nose radome.
 - (b) Turn the top or bottom guide link to make it longer or shorter.
 - (c) Make sure the drain holes in the guide link point down.
 - (d) Safety the guide link with lockwire.

I. Adjust Latch Torque

SUBTASK 53-12-01-200-006

- (1) Do a check of the torque for each torque (Figure 502), as follows:
 - (a) Move the radome to the closed position.
 - (b) Put a 1/4-inch hex wrench fully in the latch.
 - (c) Measure the torque necessary to fully close the latch.
 - (d) Make sure the torque is between 100 in-lb (11 N·m) to 150 in-lb (17 N·m).

SUBTASK 53-12-01-820-006

- (2) Adjust the latch torque (Figure 508), if it is necessary:
 - (a) Open the nose radome.



DO NOT TURN THE EYEBOLT. TURN THE ADJUSTMENT BOLT IN THE KEEPER ASSEMBLY. IF YOU TRY TO TURN THE EYEBOLT, YOU WILL CAUSE DAMAGE TO THE LATCH.

(b) Put the eyebolt adjustment tool (radome latch wrench set, SPL-4401) through the slot in the keeper assembly.

NOTE: Use adjustment tool "C" (Figure 508) for eyebolt adjustment at latches L1 and L6. Use adjustment tool "D" (Figure 508) for eyebolt adjustment at latches L2, L3, L4, and L5).

- (c) Engage the tool with the adjustment nut in the housing.
- (d) Turn the adjusting nut to move the eyebolt in or out.

NOTE: The nut is held by a spring-loaded detent.

- (e) Turn the nut to the next detent.
 - 1) Move the eyebolt in to increase the latch torque.
 - 2) Move the eyebolt out to decrease the latch torque.

J. Adjust Alignment Fittings

SUBTASK 53-12-01-200-007

- (1) Do a check of the roller engagement in each alignment fitting (Figure 502), as follows:
 - (a) Open the nose radome.
 - (b) Put clay on each alignment fitting in the area where the roller will touch the fitting.
 - (c) Close and latch the nose radome.
 - (d) Open the nose radome.

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(e) Look at the imprint in the clay to make sure all of the rollers were fully engaged in their alignment fittings.

SUBTASK 53-12-01-820-007

- (2) Adjust the alignment fitting engagement (Figure 509), if it is necessary:
 - (a) Remove the bolts that hold the alignment fitting to the bulkhead.
 - (b) Remove the fitting and the serrated plate.
 - (c) Remove the shims if they are damaged.
 - (d) Remove old sealant and paint with a scraper if it will interfere with the installation.
 - (e) Add or remove shims between the alignment fitting and the serrated plate to move the fitting in or out from the bulkhead.
 - <u>NOTE</u>: You can remove laminations from the shims for a more accurate adjustment.
 - (f) Install the shim, serrated plate, and the fitting with the bolts.

K. Adjust Radome Flushness

SUBTASK 53-12-01-200-008

- (1) Do a check of the radome flushness (Figure 503) as follows:
 - (a) Close and latch the radome.
 - (b) Measure the flushness around the radome.
 - (c) Make sure the radome flushness is within the tolerances shown in (Figure 503).

SUBTASK 53-12-01-820-008

- (2) Adjust the radome flushness (Figure 510) if it is necessary:
 - (a) Open the nose radome.
 - (b) Loosen the bolts on the alignment fitting until it will just float along the serrations.
 - (c) Move the alignment fitting along the serrations to change the flushness.
 - (d) Tighten the bolts when the alignment fitting is in the correct position.

L. Adjust Radome Clearance

SUBTASK 53-12-01-200-009

- (1) Do a check of the radome clearance (Figure 503) as follows:
 - (a) Close and latch the nose radome.
 - (b) Measure the clearance around the radome.
 - (c) Make sure the radome clearance is within the tolerances shown in (Figure 503).

SUBTASK 53-12-01-820-009

- (2) Adjust the radome clearance (Figure 511), if it is necessary:
 - (a) Open the nose radome.
 - (b) Add or remove shims behind the adjustment fittings to get the correct clearance.

M. Adjust Seal Flushness

SUBTASK 53-12-01-200-010

- (1) Do a check of the seal flushness (Figure 503):
 - (a) Close and latch the nose radome.
 - (b) Measure the seal flushness around the radome.
 - (c) Make sure the seal flushness is within the tolerances shown in (Figure 503).

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SUBTASK 53-12-01-820-010

- (2) Adjust the seal flushness (Figure 512), if it is necessary:
 - (a) Open the nose radome.
 - (b) To correct a negative flushness, remove the corner of the skin as shown in (Figure 512).

N. Adjust Hold-Open Fittings

SUBTASK 53-12-01-200-011

- (1) Do a check of the hold-open fittings (Figure 504) as follows:
 - (a) Open and close the nose radome.
 - (b) Make sure the hold-open fitting does not interfere with nose radome operation.
 - (c) Open the nose radome fully.
 - (d) See that the fittings on the top and bottom hinge arms engage their fittings on the bulkhead.
 - (e) Make sure the fittings hits their bumpers.
 - (f) Put the hold-open pins through the fittings to safety the door in the open position.

SUBTASK 53-12-01-820-011

- (2) Adjust the hold-open fittings (Figure 513), if it is necessary:
 - (a) Open the nose radome.
 - (b) Loosen the bolts that hold the fitting on the hinge.
 - (c) Move the fitting along its serrated plate until the fitting engages correctly.
 - (d) Tighten the bolts.
 - (e) Make sure the serrations engage correctly.

O. Put the Airplane Back in Its Usual Condition.

SUBTASK 53-12-01-370-001

- (1) Paint the alignment fittings that you adjusted, as follows:
 - (a) Remove the alignment fittings and shims that you adjusted.
 - NOTE: Identify the locations to help you when you install them again.
 - (b) Apply coating, C00064 to delaminated shims to remove the adhesive left on the shim.
 - (c) Apply primer, C00259 to laminated shims.
 - (d) Apply sealant, A00247 to the bulkhead side of the shim and the serrated plate.
 - (e) Install the shim, serrated plate, and fitting at their correct locations.
 - (f) Tighten the bolts.

Table 501/53-12-01-993-801 Nose Radome Rigging Summary - Reference Table

| CHECK | | ADJUSTMENT | | NECESSARY CONDITION | RADOME | |
|--------|------|------------|------|--|----------|--|
| NAME | FIG. | NAME | FIG. | | POSITION | |
| RADOME | 501 | Hinge | 506 | 1. The radome latches L1, L2, and L3 must align correctly with their latch keepers. | Closing | |
| | | Guide Link | 507 | 2. When you close the radome, each part of the radome edge must touch the seal at the same time. | Closing | |

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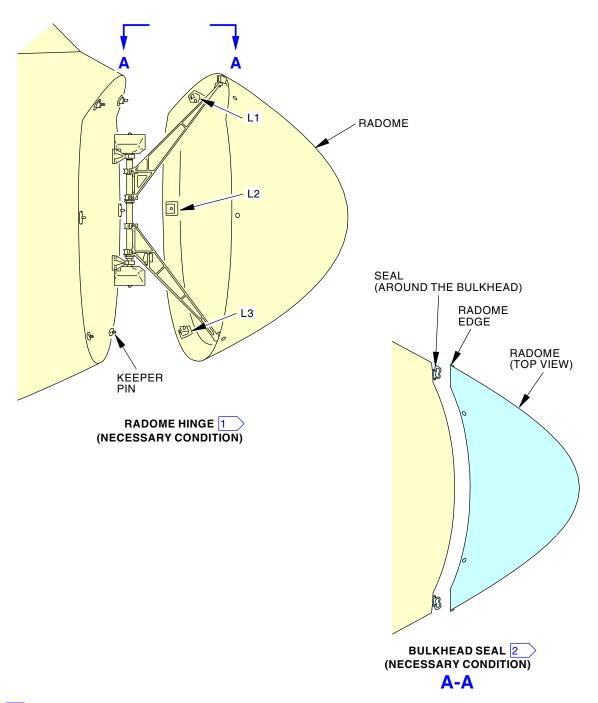
Table 501/53-12-01-993-801 Nose Radome Rigging Summary - Reference Table (Continued)

| CHECK | | ADJUSTMENT | | NECESSARY CONDITION | RADOME |
|--------------------------------------|------|---------------------|------|--|----------------------|
| NAME | FIG. | NAME | FIG. | | POSITION |
| LATCHES AND ALIGNMENT FITTINGS | 502 | Latch Torque | 508 | 3. Each latch must operate between 100-150 pound- inches of torque. | Latching |
| | | Alignment Roller | 509 | 4. Each alignment roller must fully engage its alignment fittings. | Latched |
| FLUSHNESS AND CLEARANCES | 503 | Radome Flushness | 510 | 5. The radome flushness must be in the tolerance shown in Fig. 503, Sheet 1. | Latched |
| | | Radome Clearance | 511 | 6. The radome clearance must be in the tolerance shown in Fig. 503, Sheet 2. | Latched |
| | | Seal Flushness | 512 | 7. The seal flushness must be in the tolerance shown in Fig. 503, Sheet 3. | Latched |
| Hold-Open FITTING | 504 | Hold-Open | 513 | 8. The hold-open fittings must not interfere when you open and close the radome. | Full range of motion |
| | | | | 9. The hold-open fittings must engage to hold the door in the fully open position. | Fully open |

----- END OF TASK -----

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1 THE RADOME LATCHES L1,L2,L3 MUST ALIGN CORRECTLY WITH THEIR LATCH KEEPERS.

WHEN YOU CLOSE THE RADOME, THE RADOME EDGE AT ALL LOCATIONS MUST TOUCH THE BULKHEAD SEAL AT THE SAME TIME.

C29537 S0006426787_V2

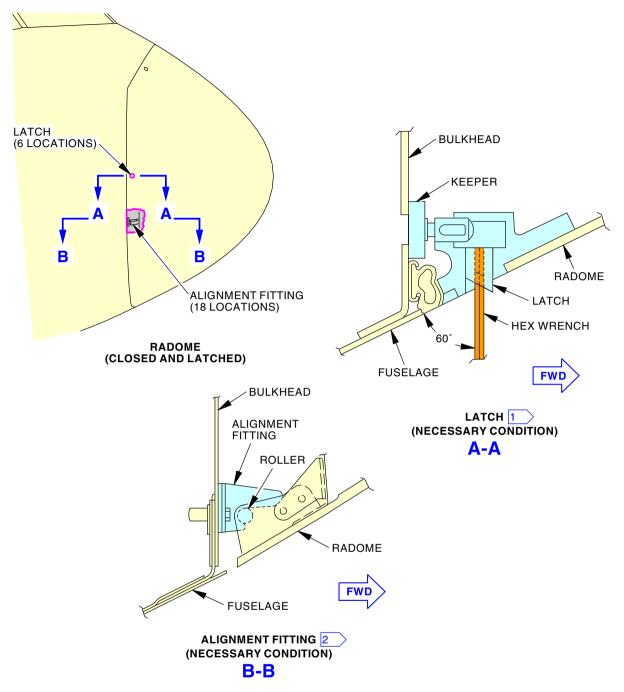
Radome Necessary Conditions Figure 501/53-12-01-990-802

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EACH LATCH MUST OPERATE BETWEEN 100-150 POUND-INCHES OF TORQUE.

EACH ALIGNMENT ROLLER MUST FULLY ENGAGE ITS ALIGNMENT FITTING WHEN THE RADOME IS FULLY CLOSED AND LATCHED.

C30529 S0006426788_V2

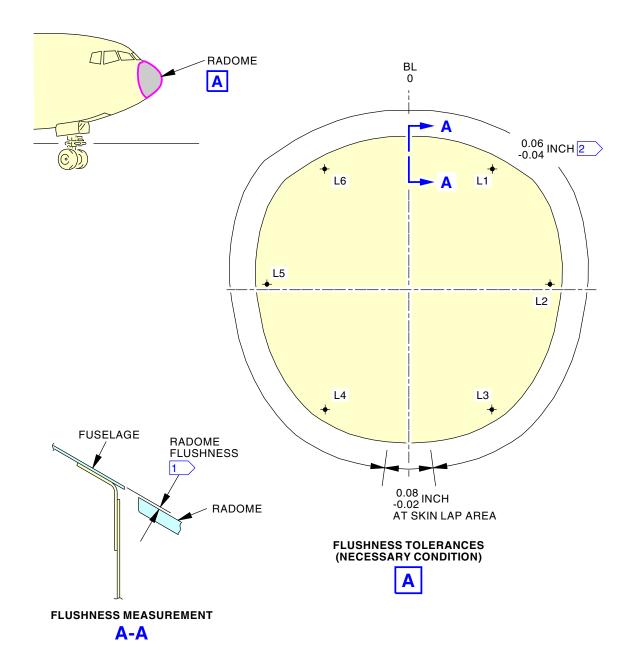
Latch and Alignment Fitting Necessary Conditions Figure 502/53-12-01-990-803

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- A NEGATIVE FLUSHNESS IS WHEN THE RADOME IS INSIDE THE FUSELAGE CONTOUR. A POSITIVE FLUSHNESS IS WHEN THE RADOME IS OUTSIDE THE FUSELAGE CONTOUR.
- 2 IN SERVICE LIMIT $^{0.10}_{-0.04}$ INCH

C30568 S0006426789_V2

Radome Flushness and Clearance Necessary Conditions Figure 503/53-12-01-990-804 (Sheet 1 of 3)

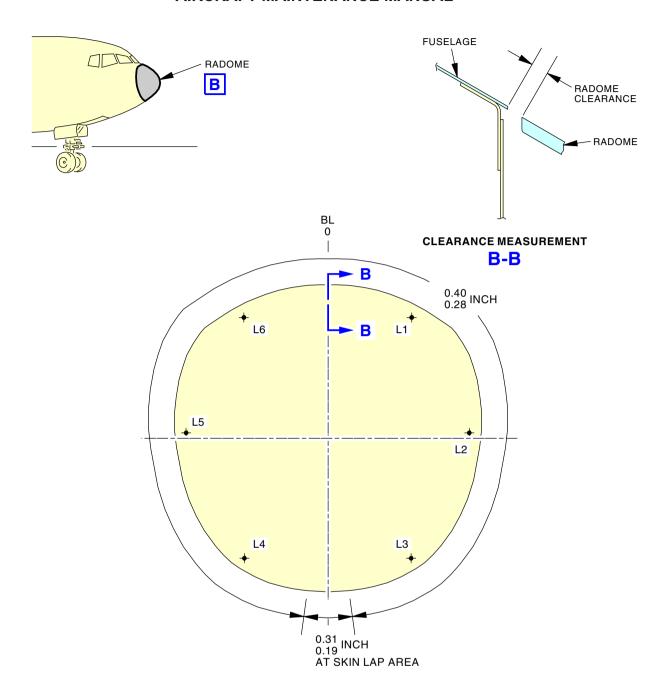
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CLEARANCE TOLERANCES (NECESSARY CONDITION)



C31370 S0006426790_V2

Radome Flushness and Clearance Necessary Conditions Figure 503/53-12-01-990-804 (Sheet 2 of 3)

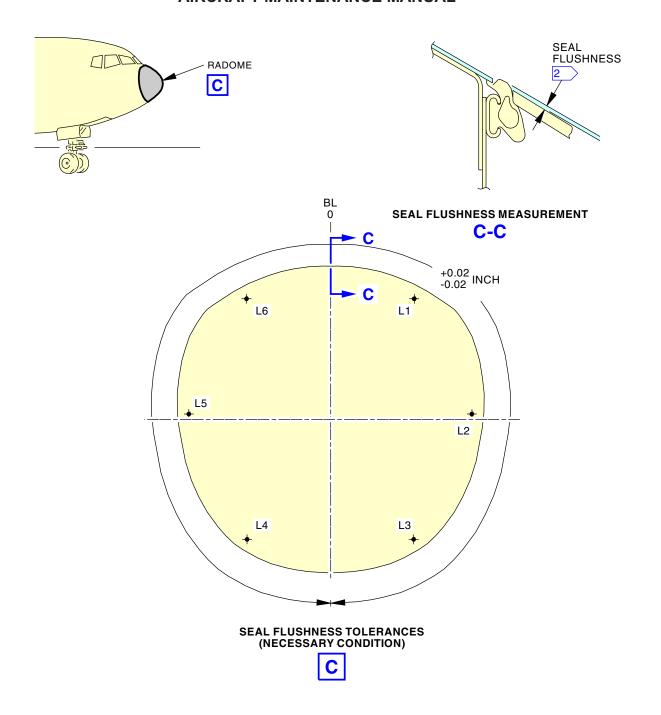
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2 MEASURE THE FLUSHNESS FROM A LINE BETWEEN THE RADOME TO THE FUSELAGE SKIN AND THE OUTSIDE OF THE FUSELAGE.

C31374 S0006426791_V2

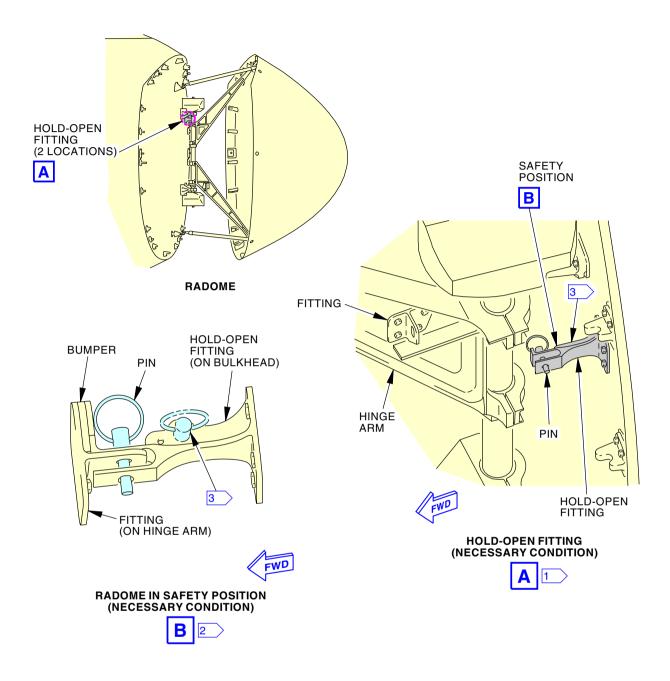
Radome Flushness and Clearance Necessary Conditions Figure 503/53-12-01-990-804 (Sheet 3 of 3)

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THE HOLD-OPEN FITTINGS MUST NOT INTERFERE WHEN YOU OPEN OR CLOSE THE RADOME.

THE HOLD-OPEN FITTINGS MUST ENGAGE TO HOLD THE DOOR IN THE FULLY OPEN POSITION.

STOW PIN HERE WHEN MOT IN USE, IF HOLE EXIST.

C31383 S0006426792_V3

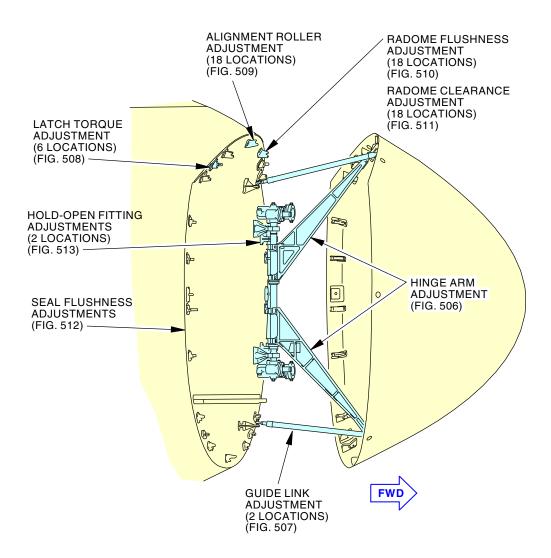
Radome Hold-Open Fitting Necessary Conditions Figure 504/53-12-01-990-805

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RADOME

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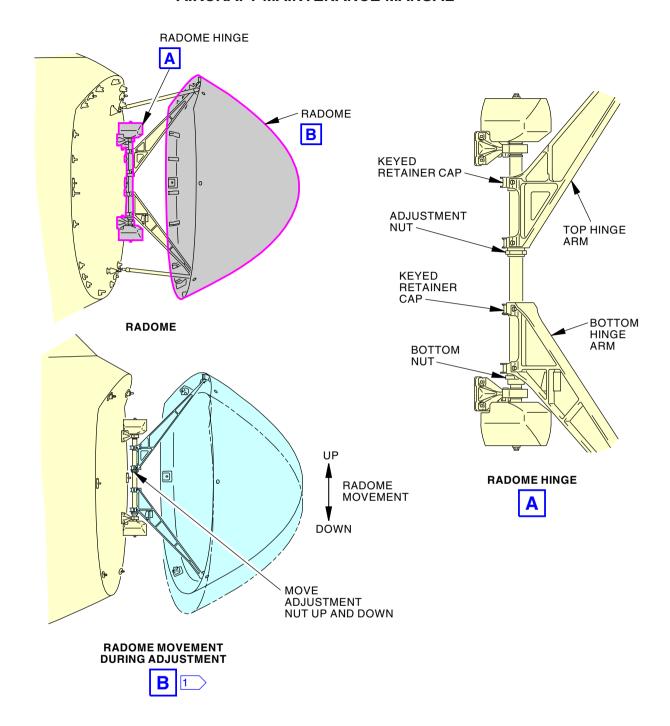
Radome Adjustments Figure 505/53-12-01-990-806

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1 THE RADOME LATCHES L1,L2,L3 MUST ALIGN CORRECTLY WITH THEIR LATCH KEEPERS.

C32129 S0006426794_V2

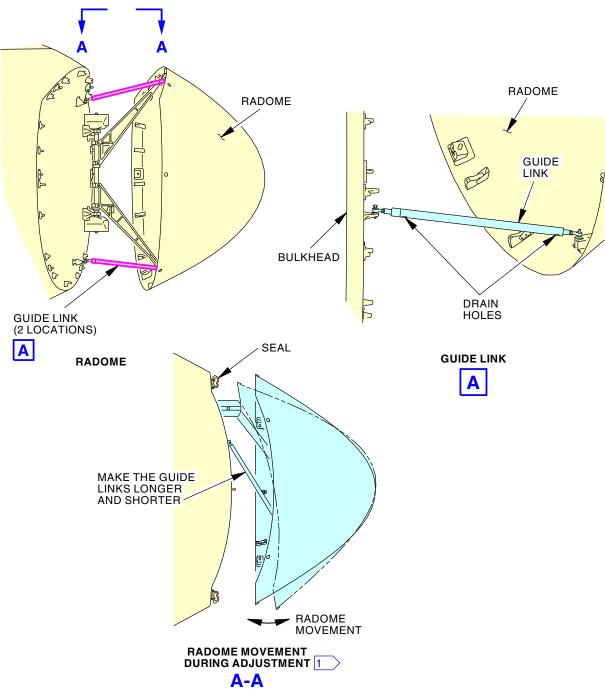
Radome Hinge Adjustment Figure 506/53-12-01-990-807

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1 EVERY PART OF THE RADOME EDGE MUST TOUCH THE BULKHEAD SEAL AT THE SAME TIME WHEN YOU CLOSE THE RADOME.

C31595 S0006426795_V2

Radome Guide Link Adjustment Figure 507/53-12-01-990-808

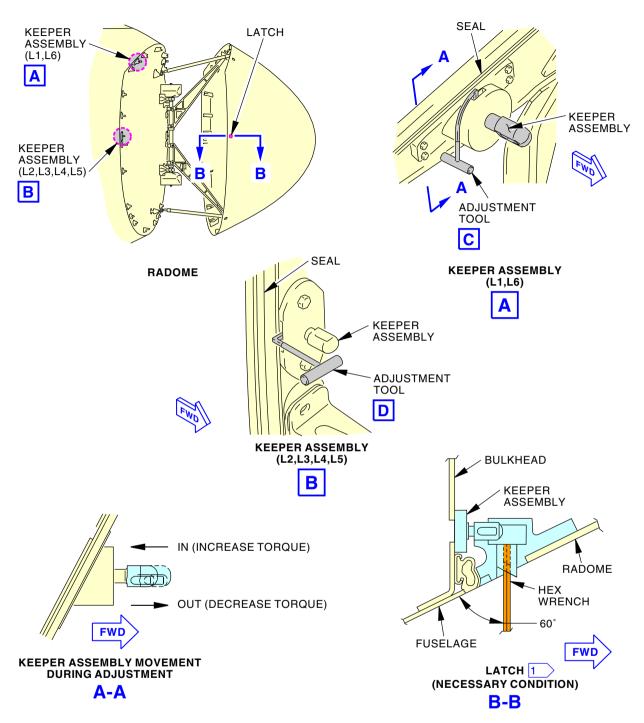
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1 EACH LATCH MUST OPERATE BETWEEN 100-150 POUND-INCHES OF TORQUE.

C32342 S0006426796_V2

Radome Latch Torque Adjustment Figure 508/53-12-01-990-809 (Sheet 1 of 2)

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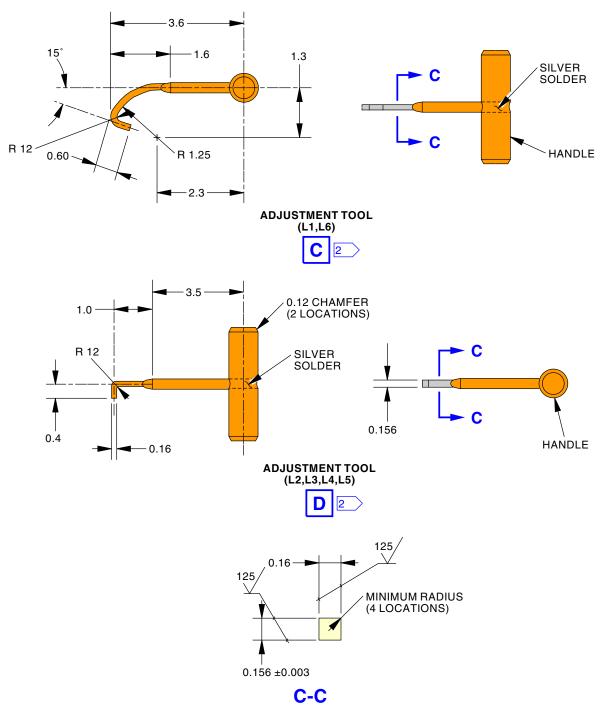
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MAKE FROM ROUND TOOL STEEL STOCK. HEAT TREAT TO Rc 44-48.

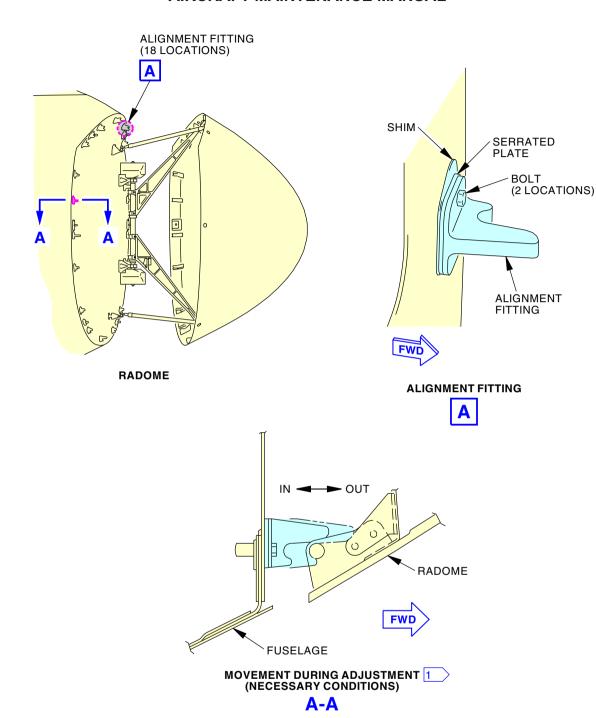
ALL DIMENSIONS ARE IN INCHES.

G13453 S0006426797_V2

Radome Latch Torque Adjustment Figure 508/53-12-01-990-809 (Sheet 2 of 2)

53-12-01 EFFECTIVITY ARO ALL Page 517 Sep 05/2017 l D633W101-ARO ECCN 9E991 BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details





1 EACH ALIGNMENT ROLLER MUST FULLY ENGAGE ITS ALIGNMENT FITTING WHEN THE RADOME IS FULLY CLOSED AND LATCHED

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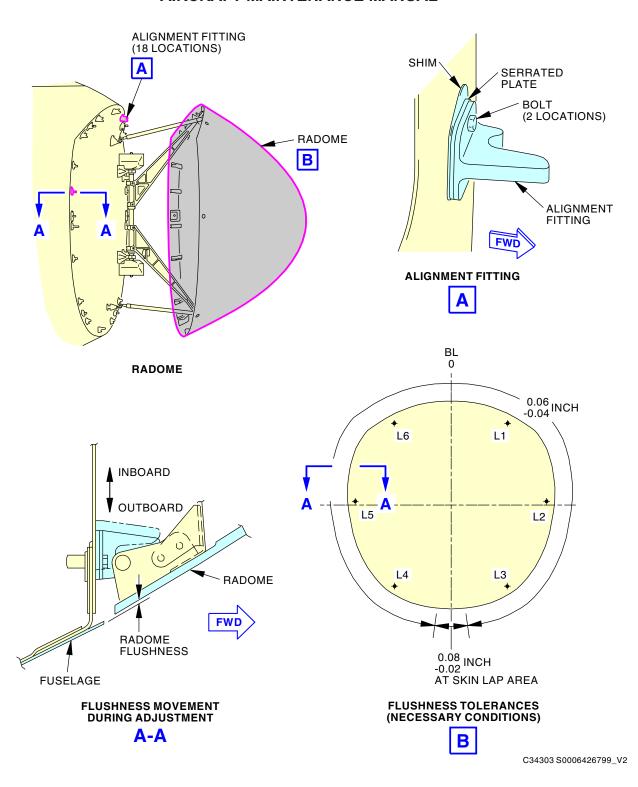
Radome Alignment Roller Adjustment Figure 509/53-12-01-990-810

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Radome Flushness Adjustment Figure 510/53-12-01-990-811

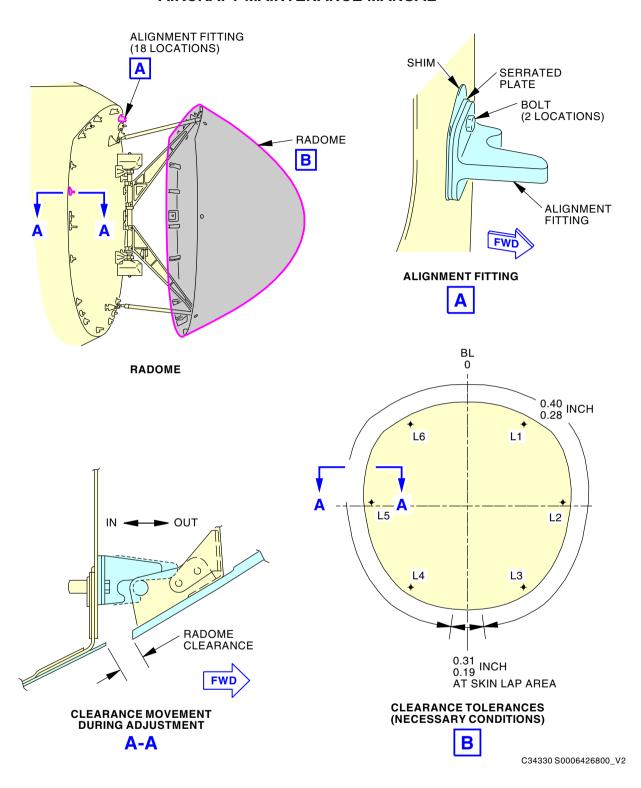
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Radome Clearance Adjustment Figure 511/53-12-01-990-812

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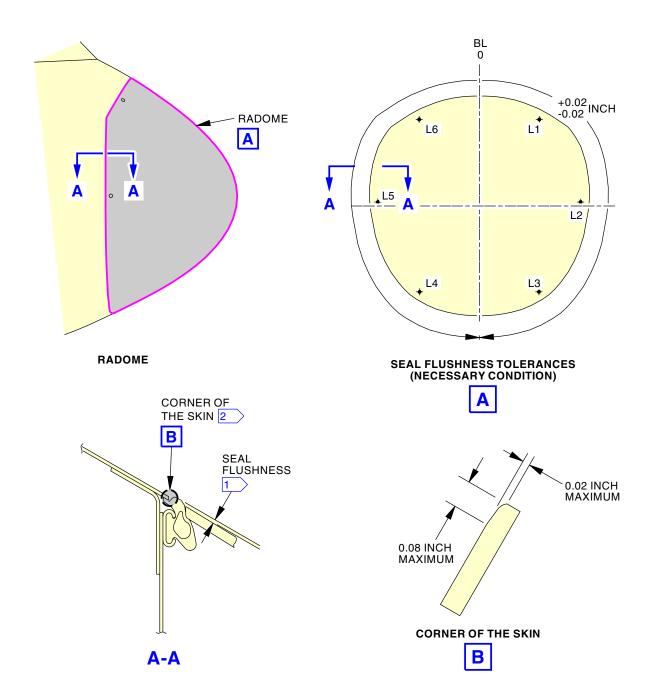
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- MEASURE THE FLUSHNESS FROM A LINE BETWEEN THE RADOME TO THE FUSELAGE SKIN AND THE OUTSIDE OF THE FUSELAGE.
- IF THERE IS A NEGATIVE FLUSHNESS, REMOVE THE CORNER OF THE SKIN TO MAKE AROUND EDGE. DO NOT MAKE A CHAMFER.

C34409 S0006426801_V2

Radome Seal Flushness Adjustment Figure 512/53-12-01-990-813

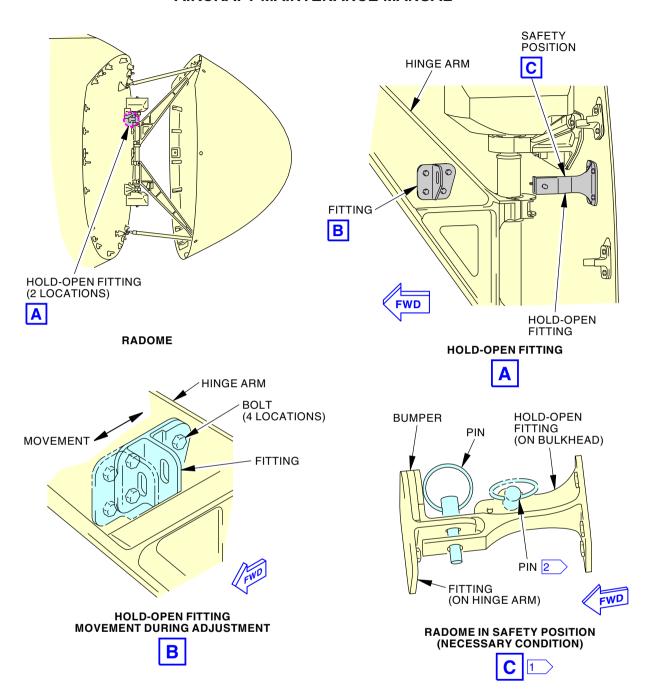
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THE HOLD-OPEN FITTINGS MUST NOT INTERFERE WHEN YOU OPEN OR CLOSE THE RADOME. THE HOLD-OPEN FITTINGS MUST ENGAGE TO HOLD THE DOOR IN THE FULLY OPEN POSITION.

2 STOW PIN HERE WHEN NOT IN USE, IF HOLE EXISTS.

C34469 S0006426802_V3

Radome Hold-Open Fitting Adjustment Figure 513/53-12-01-990-814

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NOSE RADOME - INSPECTION/CHECK

1. General

- A. This procedure has this task:
 - (1) Inspection of the nose radome.

TASK 53-12-01-200-801

2. Nose Radome Inspection

A. References

| Reference | Title |
|----------------------|--|
| 53-12-00-010-801 | Open the Nose Radome (P/B 201) |
| 53-12-01-000-801 | Nose Radome Removal (P/B 401) |
| 53-12-01-300-801 | Nose Radome Temporary Repair (P/B 801) |
| 53-12-03-200-801 | Lightning Diverter Strip Inspection (P/B 601) |
| 53-12-05-000-801 | Glide Slope Director Element Removal (P/B 401) |
| NDT Part 9, 51-00-01 | Inspection for Ice or Water in Honeycomb Parts |
| NDT Part 9, 51-00-02 | Inspection for Water in Honeycomb With Liquid Crystal Sheets |
| SRM 51-00-01 | Structural Repair Manual |
| SRM 53-10-72 | Structural Repair Manual |

B. Tools/Equipment

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

| Reference | Description | |
|--|-----------------------------------|--|
| COM-2010 Equipment - Moisture Indicator/Register, RADOME | | |
| | Part #: MRC005574 Supplier: 0CT97 | |
| | Part #: MRC006507 Supplier: 0CT97 | |

C. Location Zones

| Zone | Area | |
|------|--------|--|
| 111 | Radome | |

D. Procedure

SUBTASK 53-12-01-200-001

(1) Inspect the fiberglass dome for damage.

NOTE: This includes holes, scuffs, cracks, blisters, and delamination.

- (a) Repair the nose radome, if it is necessary (TASK 53-12-01-300-801).
- (b) Replace the nose radome if it is necessary.

SUBTASK 53-12-01-200-013

- Do a check for moisture.
 - (a) Moisture that enters the honeycomb cells of a radome can cause the radar transmission to decrease. Periodic radome inspection is necessary to ensure sufficient radar transmission. Water that is entrapped in the honeycomb cells can be detected with the three methods that follow.

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(b) 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 Part 9, 51-00-01 and SRM 51-00-01).

SUBTASK 53-12-01-200-002

(3) 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). Any 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 all metallic parts be removed from the area on the radome that is being tested for moisture content.

- (a) Push the ON-OFF switch on the case to the ON position.
- (b) Hold the sensor head at least 1 ft (30.5 cm) away from any object and push the null button to zero the instrument.

NOTE: If you release the handle button or turn the instrument off, you must zero the instrument again before you continue the radome examination.

NOTE: Some moisture meters have a meter zero control that must be manually adjusted.

- (c) Put the sensor head on the inner surface of the radome.
 - 1) Make sure that all the electrodes contact the radome surface.
 - If necessary, apply light force to make sure the sensor headcontacts the radome surface.
- (d) Move the sensor head over all of the inner surface of the radome. 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.
- (e) In areas that cause a meter reading of 20 or greater, move the sensor head away from the center of the indication (in an adjacent area with a reading of less than 20). Monitor the meter reading as you move the sensor head toward the area.
- (f) 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.
- (g) Do these steps until the boundary of the entrapped water is marked.
- (h) If the area that you marked is greater than the maximum allowable surface area shown in Table 601, the area should be dried and re-sealed
- (i) To dry the radome refer to SRM 53-10-72 to remove the moisture and seal it.

Table 601/53-12-01-993-802 Rejection Criteria for Entrapped Water

| RADOME CONDITION | NUMERICAL SCALE | MAXIMUM ALLOWABLE SURFACE AREA of WATER |
|------------------|-----------------|--|
| Good | 0 to 5 | N/A |
| Fair | 6 to 10 | N/A |
| Poor | 11 to 19 | N/A |

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Table 601/53-12-01-993-802 Rejection Criteria for Entrapped Water (Continued)

| RADOME CONDITION | NUMERICAL SCALE | MAXIMUM ALLOWABLE SURFACE AREA of WATER |
|---|-----------------|--|
| Reject | >20 | 5 in. (127 mm) diameter or equivalent area |
| 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. | | |
| NOTE: The "Allowable surface area of water" reject criteria is only applicable to the unrepaired areas of the radome. That is, no moisture is allowed within an area bordered by the outermost ply. | | |

- (4) Method 2 Electronic Thermography (alternative) Inspection Method.
 - (a) Refer to the NDT Part 9, 51-00-01 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 601, remove the moisture in the marked area and seal it (SRM 53-10-72).
- (5) Method 3 Liquid Crystal (alternative) Inspection Method.
 - (a) Refer to the NDT Part 9, 51-00-02 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 while you 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 601, remove the moisture in the marked area and seal it (SRM 53-10-72).
 - NOTE: These methods can be used during the drying process to ensure that all subsurface water has been removed from the radome.

SUBTASK 53-12-01-200-003

- (6) Inspect the glideslope director element for damage.
 - (a) Open the radome to get access to the glideslope element.
 - (b) Examine the glideslope director element for these conditions:
 - 1) cuts
 - 2) unsatisfactory adhesion
 - 3) other damage.

SUBTASK 53-12-01-960-001

(7) If you find damage, do the task to replace the element (TASK 53-12-05-000-801).

SUBTASK 53-12-01-200-004

- (8) Examine the lightning diverter strips for these conditions:
 - (a) tears

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- (b) loose areas
- (c) burned areas
- (d) general deterioration.

SUBTASK 53-12-01-200-012

(9) To check the lightning diverter strips, do this task: Lightning Diverter Strip Inspection, TASK 53-12-03-200-801.

SUBTASK 53-12-01-200-014

- (10) Inspect the nose radome seal for damage.
 - (a) Open the Nose Radome, TASK 53-12-00-010-801, to get access to the radome seal.
 - (b) Examine the nose radome seal for these conditions:
 - 1) cuts
 - 2) tears
 - 3) loose areas
 - 4) general deterioration
 - 5) other damage.

SUBTASK 53-12-01-200-015

(11) If you find damage, do the task to replace the seal (TASK 53-12-01-000-801).

----- END OF TASK -----

FFFECTIVITY 53-12-01



NOSE RADOME - CLEANING/PAINTING

1. General

- A. This procedure has the task:
 - (1) Paint the nose radome.

TASK 53-12-01-100-801

2. Nose Radome - Painting

(Figure 701, Figure 702)

A. General

- (1) This procedure has steps for the following.
 - (a) Prepare to paint the nose radome.
 - (b) Paint the nose radome.

B. References

| Reference | Title |
|------------------|---|
| 51-21-01-150-801 | Paint Stripping (P/B 701) |
| 51-21-02-100-802 | Cleaning and Preparation of Internal and External Plastic Surfaces (P/B 701) |
| 51-21-04 P/B 701 | CHEMICAL CONVERSION COATING - CLEANING/PAINTING |
| 51-24-02-370-803 | Apply The BMS 10-21 Type IV Conductive Coating To Specified External Surfaces (P/B 701) |
| 51-24-10-370-802 | BMS10-103 Primer Application (P/B 701) |
| 51-24-11-370-802 | BMS10-72 Topcoat Application (P/B 701) |
| 53-12-03-000-801 | Lightning Diverter Strip Removal (P/B 401) |
| 53-12-03-400-801 | Lightning Diverter Strip Installation (P/B 401) |

C. Tools/Equipment

| Reference | Description |
|-----------|-------------|
| STD-604 | Multimeter |

D. Consumable Materials

| Reference | Description | Specification |
|-----------|--|---|
| A00028 | Adhesive - Modified Epoxy For Rigid PVC, Foam Cored Sandwiches | BAC5010 Type 70 (BMS5-92 Type 1) |
| C00058 | Compound - Magna Static Conditioner Filler 28C1 (Formerly Dexter 28-C-1) | BAC5837 |
| C00064 | Coating - Aluminum Chemical Conversion | BAC5719 Type II Class A (MIL-DTL-5541 Class 1A) |
| 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 |

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(Continued)

| Reference | Description | Specification |
|-----------|---|------------------------------------|
| G00034 | Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze) | BMS15-5 Class A |
| G00270 | Tape - Scotch Flatback Masking 250 | ASTM D6123 (Supersedes A-A-883) |
| G02219 | Tape - Yellow Vinyl Adhesive, Scotch Brand No.471, 1.5 Inches (38.1 mm) Wide | |
| G50509 | Tape - Masking (3M Scotch Fine Line Tape 218) | AMS-T-21595 |

E. Location Zones

| Zone | Area |
|------|--------|
| 111 | Radome |

F. Prepare to Paint the Nose Radome

SUBTASK 53-12-01-020-008

- (1) If it is necessary to remove the diveter strips from the radome, do the following steps:
 - (a) Remove the lightning diverter strips from the radome, do this task: Lightning Diverter Strip Removal, TASK 53-12-03-000-801.
 - NOTE: Take care not to damage the inserts.
 - (b) Identify the lightning diverter strips to be re-installed.
 - (c) Use Tape Masking, G50509 or Scotch Brand No.471 tape, G02219 to mask-off the holes from the removed lightning diverter strips and conductor straps on the radome.
 - Make sure the coating, C00841 does not enter the holes from the removed lightning diverter strips.

SUBTASK 53-12-01-150-002

- (2) Prepare the diverter strips.
 - (a) Remove all finishes (Paint Stripping, TASK 51-21-01-150-801).
 - (b) Apply coating, C00064 to the bare metal of the Diverter Strips CHEMICAL CONVERSION COATING CLEANING/PAINTING, PAGEBLOCK 51-21-04/701.

SUBTASK 53-12-01-150-001

(3) Remove the existing paint (Paint Stripping, TASK 51-21-01-150-801).

SUBTASK 53-12-01-350-001

- (4) Clean the nose radome external surface, do this task: Cleaning and Preparation of Internal and External Plastic Surfaces, TASK 51-21-02-100-802.
 - (a) If there are surface defects, do the steps that follow:



ONLY USE THE STATIC CONDITIONER FILLER TO FILL SMALL SURFACE DEFECTS. DO NOT USE THE FILLER TO MAKE LARGE AREAS SMOOTHER. A CONTINUOUS LAYER OF FILLER WILL CAUSE A BAD PAINT BOND.

1) For surface defects less than 0.002 in. (0.051 mm) deep, apply the Magna 28C1 conditioner filler, C00058 to the small surface defect with your hand.

NOTE: BMS10-103, Grade E primer (C00766) can't be used over 28C1 pinhole filler (C00058). If BMS10-103, Grade E primer (C00766) is being used, use the 8W5 pinhole filler A50099 instead of 28C1 pinhole filler (C00058).

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- Let the filler dry at temperatures between 70°F (21°C) to 90°F (32°C) for 30 minutes or until the filler becomes white.
 - NOTE: Cure time can be accelerated with additional heat.
- b) Remove unwanted filler with a cotton wiper, G00034.
- 2) For surface defects deeper than 0.002 in. (0.051 mm), apply adhesive, A00028 or an applicable equivalent.

SUBTASK 53-12-01-420-009

- (5) If the diverter strips are removed, do the steps that follow:
 - (a) Do this task: Lightning Diverter Strip Installation, TASK 53-12-03-400-801.
 - (b) Mask the diverter strips after installation to protect them from the primer and paint. Use Scotch Flatback Masking Tape 250, G00270.

G. Paint the Nose Radome

SUBTASK 53-12-01-350-004

Apply primer, C00766 to the external surface (BMS10-103 Primer Application, TASK 51-24-10-370-802).

SUBTASK 53-12-01-370-026

- Apply erosion protection.
 - (a) Apply one coat of BMS10-60 type II polyurethane, coating, C50075 to the external surface of the radome.
 - (b) Apply coats of BMS10-60 type II polyurethane, coating, C50075 forward of STA 100.25 to a dry layer thickness between 8 and 10 Mils thick.
 - (c) Remove masking from the diverter strips area forward of STA 100.25.

SUBTASK 53-12-01-370-027

- Apply anti-static coating.
 - Apply BMS10-21 Type IV anti-static coating, C50219 to the 6.0 in. (152.4 mm) vertical band between STA 94.3 and STA 100.25. Refer to TASK 51-24-02-370-803.

SUBTASK 53-12-01-700-011

- Measure the surface resistance of the anti-static paint as follows:
 - Find 5 pairs of equidistant points in each quadrant of the anti-static paint band (20 total pairs).
 - Do the steps found in the "Square Test Method" procedure as shown in Apply The BMS 10-21 Type IV Conductive Coating To Specified External Surfaces, TASK 51-24-02-370-803

SUBTASK 53-12-01-700-012

- Make another resistance measurement as follows:
 - (a) Find the upper aft spring clip and the lower aft spring clip inside the nose radome.
 - (b) Put one multimeter, STD-604 probe on the anti-static paint 1 in. (25.4 mm) from the strip conductor and the second probe on the upper spring clip.
 - Measure the electrical resistance.
 - (c) Put one multimeter, STD-604 probe on the anti-static paint 1 in. (25.4 mm) from the strip conductor and the second probe on the lower spring clip.
 - Measure the electrical resistance.



- (d) Make sure the measured electrical resistance is between 250 kilo Ohms and 100 mega Ohms.
- (e) The indicated electrical resistance range must agree at 2 of the 6 strip conductors.

SUBTASK 53-12-01-370-028

- (6) Apply the primer.
 - (a) Apply BMS10-103 primer, C00766 primer, to the vertical band between STA 94.3 and STA 100.25. Do this task: BMS10-103 Primer Application, TASK 51-24-10-370-802.

SUBTASK 53-12-01-840-001

(7) Remove all masking tape from the diverter strips.

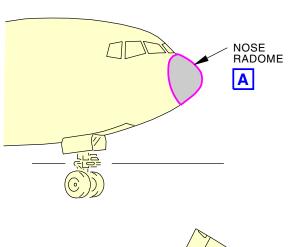
SUBTASK 53-12-01-370-029

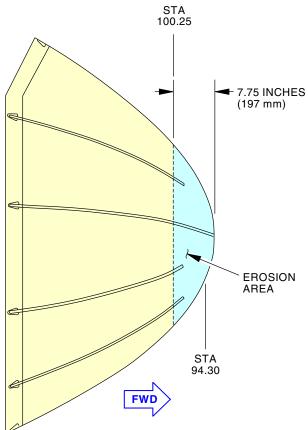
- (8) Apply the radome decorative paint.
 - (a) Apply BMS10-72 coating, C00921 or AMS3095 Exterior Gloss Paint (TASK 51-24-11-370-802) to match the applicable decorative paint livery.

----- END OF TASK -----

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NOSE RADOME



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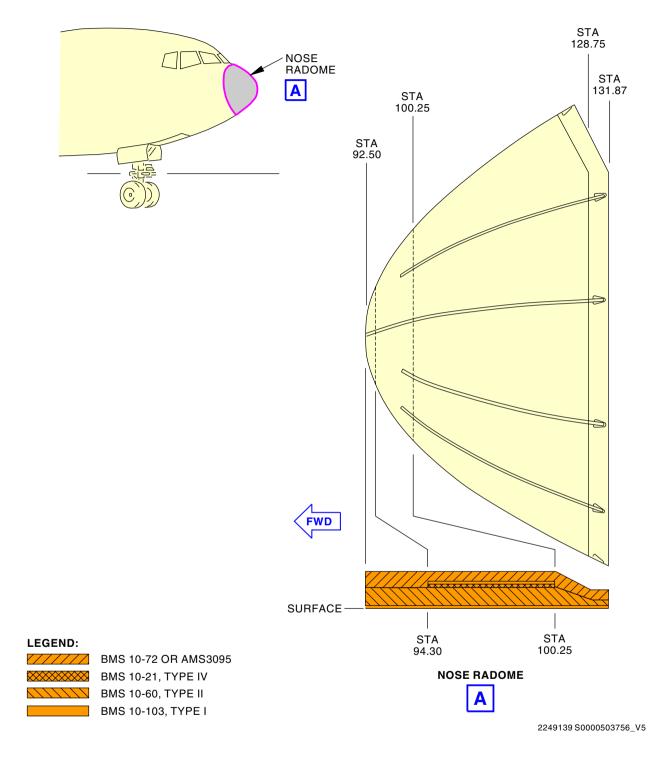
Nose Radome Erosion Area Figure 701/53-12-01-990-815

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Nose Radome Painting Figure 702/53-12-01-990-818

EFFECTIVITY

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NOSE RADOME - REPAIRS

1. General

- A. This procedure has one task:
 - (1) A temporary repair of the nose radome.

TASK 53-12-01-300-801

- 2. Nose Radome Temporary Repair
 - A. References

| Reference | Title |
|--------------|--------------------------|
| SRM 53-10-72 | Structural Repair Manual |

B. Location Zones

| Zone | Area | |
|------|--------|--|
| 111 | Radome | |

C. Procedure

SUBTASK 53-12-01-350-002

(1) To do this task refer to SRM 53-10-72allowable damage 1.

——— END OF TASK ———

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LATCH - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Latch removal
 - (2) Latch installation.

TASK 53-12-02-000-801

2. Latch Removal

(Figure 401)

A. References

| Reference | Title |
|------------------|--|
| 20-30-83-910-801 | General Cleaning of Composites (Series 83) (P/B 201) |

B. Consumable Materials

| Reference | Description | Specification |
|-----------|--|---------------|
| B01003 | Solvent - General Cleaning Of Composites - | |
| | Series 83 | |

C. Location Zones

| Zone | Area | |
|------|--------|--|
| 111 | Radome | |

D. Removal

SUBTASK 53-12-02-010-001

(1) Open the radome [4] to get access to the latch [3].

SUBTASK 53-12-02-020-001

(2) Remove the nut [8] and the washer [7] from the bolt [2] that hold the latch [3] to the radome [4].

SUBTASK 53-12-02-000-001

(3) Pull the latch [3] from the radome [4].

SUBTASK 53-12-02-100-001

(4) Remove the old sealant from the latch [3] and the radome [4].

SUBTASK 53-12-02-900-001

(5) Replace the shims [6] if they are damaged.

SUBTASK 53-12-02-100-002

(6) Clean the shim area with Series 83 solvent, B01003 (TASK 20-30-83-910-801) if you removed the shims [6].

------ END OF TASK ------

TASK 53-12-02-400-801

3. Latch Installation

(Figure 401)

A. References

| Reference | Title |
|------------------|--|
| 20-30-87-910-801 | Final Cleaning of Composites Prior to Painting (Series 87) (P/B 201) |

ARO ALL



(Continued)

| Reference | Title |
|------------------|----------------------------------|
| 53-12-01-820-801 | Nose Radome Adjustment (P/B 501) |

B. Consumable Materials

| Reference | Description | Specification |
|-----------|--|---------------|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS5-95 |
| B01007 | Solvent - Final Cleaning Of Composites Prior To Painting - Series 87 | |

C. Expendables/Parts

| AMM Item | Description | AIPC Reference | AIPC Effectivity | |
|----------|-------------|-----------------|------------------|--|
| 3 | Latch | 53-13-51-01-060 | ARO ALL | |
| | | 53-13-51-01-065 | ARO ALL | |
| | | 53-13-51-01-070 | ARO ALL | |
| | | 53-13-51-01-075 | ARO ALL | |

D. Location Zones

| Zone | Area |
|------|--------|
| 111 | Radome |

E. Installation

SUBTASK 53-12-02-420-001

(1) Install a shim [6] if you removed it.



DO NOT GET SOLVENTS IN YOUR MOUTH, OR YOUR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. SOLVENTS ARE HAZARDOUS MATERIALS. SOLVENTS MAY BE FLAMMABLE OR HARMFUL TO THE ENVIRONMENT. REFER TO PRODUCT MATERIALS SAFETY DATA SHEETS (MSDS) AND LOCAL REQUIREMENTS FOR PROPER HANDLING PROCEDURES.

(a) Remove laminates, clean with Series 87 solvent, B01007 (TASK 20-30-87-910-801), and apply primer if necessary.

SUBTASK 53-12-02-390-001

(2) Put wet sealant, A00247 on the latch [3] so it will completely fill the area between the latch [3] and the hole in the radome [4].

SUBTASK 53-12-02-420-002

(3) Put the latch [3] in the hole on the radome [4].

SUBTASK 53-12-02-820-001

(4) Put the latch [3] in its correct position (TASK 53-12-01-820-801).

SUBTASK 53-12-02-420-003

(5) Install the nut [8] and the washer [7] on the bolt [2].

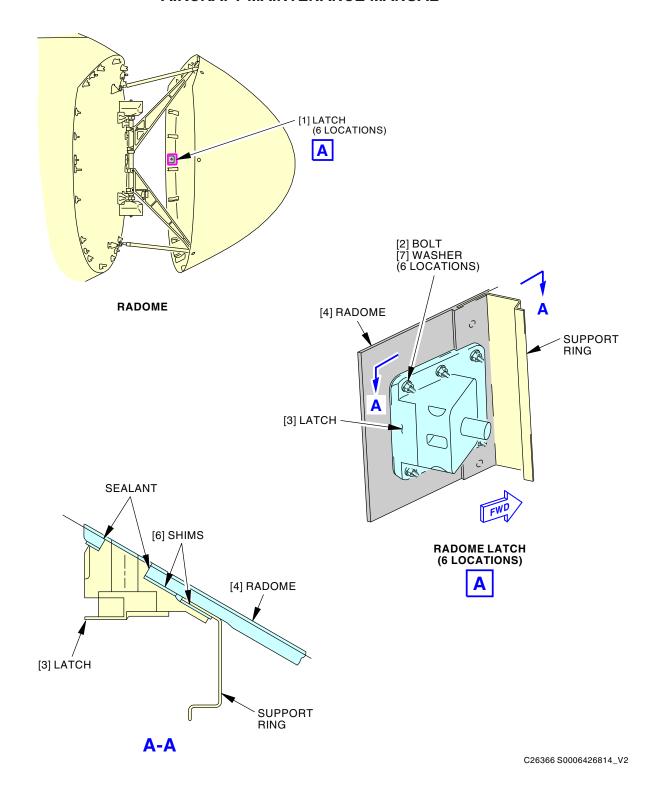
----- END OF TASK -----

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- EFFECTIVITY -





Nose Radome Latch Installation Figure 401/53-12-02-990-801

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LIGHTNING DIVERTER STRIPS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Lightning diverter strip removal
 - (2) Lightning diverter strip installation.

TASK 53-12-03-000-801

2. Lightning Diverter Strip Removal

(Figure 401)

A. Location Zones

| Zone | Area |
|------|--------|
| 111 | Radome |

B. Procedure

SUBTASK 53-12-03-010-001

(1) Open the radome and move the supports into position.

SUBTASK 53-12-03-020-001

(2) Remove the radome, if it is necessary.

SUBTASK 53-12-03-020-002

- (3) Remove each lightning diverter strip [1] as follows:
 - (a) Remove the screw [4] that hold the diverter strip [1] to the radome.
 - (b) Carefully lift the diverter strip [1] away from the radome.



DO NOT GET SOLVENTS IN YOUR MOUTH, OR YOUR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. SOLVENTS ARE HAZARDOUS MATERIALS. SOLVENTS MAY BE FLAMMABLE OR HARMFUL TO THE ENVIRONMENT. REFER TO PRODUCT MATERIAL SAFETY DATA SHEETS (MSDS) AND LOCAL REQUIREMENTS FOR PROPER HANDLING PROCEDURES.

(c) Remove all the remaining sealant with a clean cheesecloth that is moist with the solvent.

----- END OF TASK -----

TASK 53-12-03-400-801

3. Lightning Diverter Strip Installation

(Figure 401)

A. References

| Reference | Title | |
|------------------|----------------------------------|--|
| 53-12-01 P/B 701 | NOSE RADOME - CLEANING/PAINTING | |
| 53-12-01-100-801 | Nose Radome - Painting (P/B 701) | |
| 53-12-01-200-801 | Nose Radome Inspection (P/B 601) | |

B. Tools/Equipment

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

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| Reference | Description |
|-----------|---|
| COM-1550 | Bonding Meters - Approved, Intrinsically Safe (Approved for use in |
| | Class I, Divisions I & II hazardous (classified) locations. Outside |
| | these hazardous locations, COM-614 can be used in lieu of |
| | COM-1550). |
| | Part #: 620LK Supplier: 1CRL2 |
| | Part #: M1 Supplier: 3AD17 |
| | Part #: T477W Supplier: 01014 |
| | Opt Part #: M1B Supplier: 3AD17 |

C. Consumable Materials

| Reference | Description | Specification |
|-----------|--|--|
| A00247 | Sealant - Pressure And Environmental - | BMS5-95 |
| | Chromate Type | |
| B00083 | Solvent - VM&P Naphthas | TT-N-95 Type II, ASTM D-3735 Type III |

D. Expendables/Parts

| AMM Item | Description | AIPC Reference | AIPC Effectivity |
|----------|-------------|-----------------|------------------|
| 1 | Strip | 53-12-03-02-050 | ARO ALL |
| | | 53-12-03-02-055 | ARO ALL |
| | | 53-12-03-02-060 | ARO ALL |
| | | 53-12-03-02-065 | ARO ALL |

E. Location Zones

| Zone | Area |
|------|--------|
| 111 | Radome |

F. Procedure

SUBTASK 53-12-03-350-001

- (1) Prepare to install the lightning diverter strip [1].
 - (a) If the finish has damage, do this task to clean and paint the radome: do this task: Nose Radome Painting, TASK 53-12-01-100-801.
 - (b) Fill the clearances around the grounding plates with the sealant, A00247.
 - (c) Clean the mating surfaces of the grounding plate and diverter strip [1] to make sure that you get a good electrical bond.

SUBTASK 53-12-03-390-001

- (2) Seal the nose radome lightning diverter strip attach inserts (Figure 402).
 - (a) Clean the insert surface with a solvent, B00083 moist rag and let dry.
 - (b) Clean the radome surface around the insert hole with a solvent, B00083 moist rag and let dry.
 - (c) Apply sealant, A00247 on and around the insert hole in the nose radome and the mating surface of the insert. Fully soak the honeycomb core cells with sealant.
 - (d) Install the insert immediately before the sealant starts to dry.
 - (e) Make sure that the sealant comes out of the full insert hole on the two surfaces of the nose radome. The sealant that comes out on the aerodynamic surface of the nose radome must be flush with the surface. This is to help with the installation of the diverter strips.

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(f) Apply a fillet seal, 0.12 inch, of sealant, A00247 around the flange of the insert on the non aerodynamic side of the radome.

<u>NOTE</u>: It is important to make sure that the inserts are fully sealed. This prevents the entry of moisture into the honeycomb core.

SUBTASK 53-12-03-420-001

- (3) Install each strip [1].
 - (a) Apply a thin layer of the sealant, A00247 between the lightning diverter strip [1] and the radome.

NOTE: Make sure that the sealant does not get between the diverter strip and the grounding plate.

- (b) Put the diverter strip [1] on the radome and install the screw [4].
- (c) Make sure that there are no clearances between the diverter strip [1] and the radome.
- (d) Fill all the clearances around the diverter strip [1] and screw [4] with sealant, A00247.

SUBTASK 53-12-03-200-003

(4) Do an electrical resistance check of the lightning diverter strips with an intrinsically safe approved bonding meter, COM-1550.

NOTE: You must measure the resistance from the grounding plate, not from the diverter strip.

- (a) Open the radome and move supports into their position.
- (b) Remove the radome if it is necessary.
- (c) Make sure that the electrical resistance between each grounding plate and lightning diverter strip is not more than 0.001 ohms.
- (d) Make sure that the electrical resistance between each grounding plate and the spring clip is not more than .0025 ohms.
- (e) Close or install the nose radome.
- (f) Make sure that the electrical resistance between each grounding plate and the fuselage skin is not more than 0.01 ohms.

SUBTASK 53-12-03-370-002

(5) Apply anti-static coating and decorative coatings to the diverter strips as shown in NOSE RADOME - CLEANING/PAINTING. PAGEBLOCK 53-12-01/701.

SUBTASK 53-12-03-750-001

(6) Do this task: Nose Radome Inspection, TASK 53-12-01-200-801.

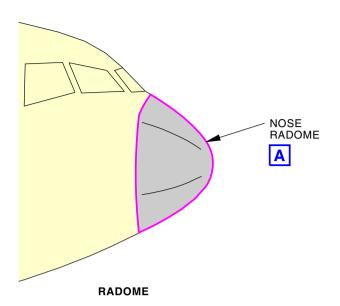
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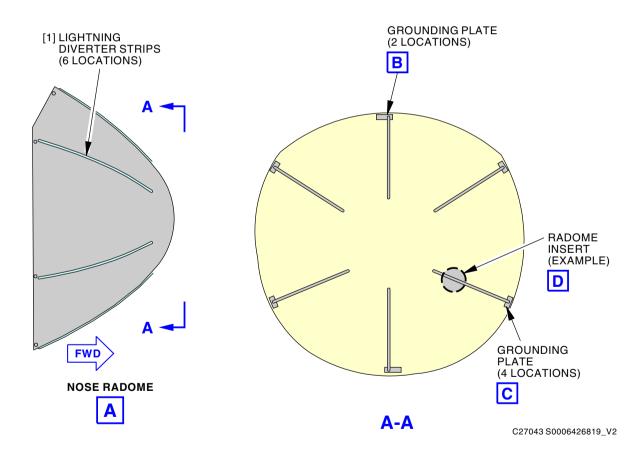
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Lightning Diverter Strip Figure 401/53-12-03-990-801 (Sheet 1 of 2)

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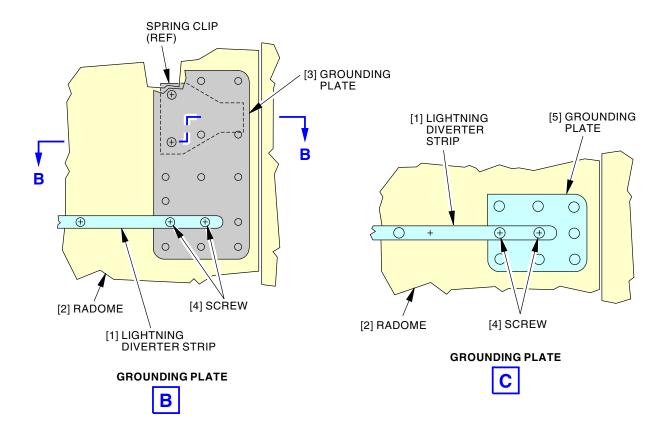
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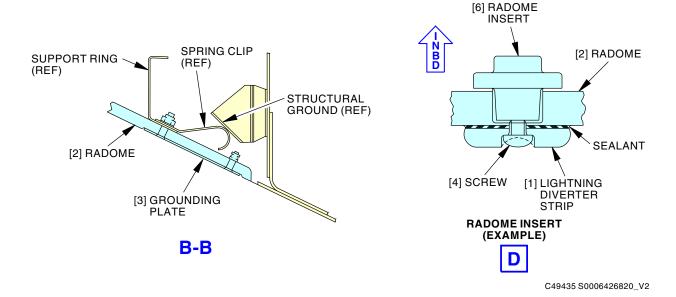
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Lightning Diverter Strip Figure 401/53-12-03-990-801 (Sheet 2 of 2)

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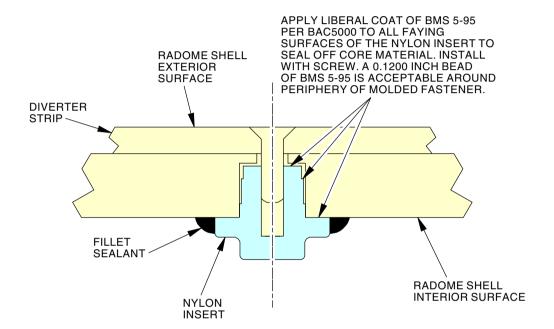
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Insert/Sealant Installation Figure 402/53-12-03-990-803

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LIGHTNING DIVERTER STRIPS - INSPECTION/CHECK

1. General

- A. This procedure has this task:
 - (1) Inspection of the lightning diverter strips.
- B. This task must be done at these times:
 - (1) After you install a new diverter strip
 - (2) When you find damage that can cause radio noise interference.

TASK 53-12-03-200-801

2. Lightning Diverter Strip Inspection

(Figure 601)

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-1550 | Bonding Meters - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). |
| | Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: T477W Supplier: 01014 Opt Part #: M1B Supplier: 3AD17 |

B. Location Zones

| Zone | Area |
|------|--------|
| 111 | Radome |

C. Procedure

SUBTASK 53-12-03-200-001

(1) Examine the lightning diverter strips for deterioration.

NOTE: Deterioration can cause radio noise interference.

SUBTASK 53-12-03-960-001

(2) Replace the lightning diverter strip if it is necessary.

SUBTASK 53-12-03-200-002

(3) Do an electrical resistance check of the lightning diverter strips with an intrinsically safe approved bonding meter, COM-1550 as follows:

NOTE: You must measure the resistance from the grounding plate, not from the diverter strip.

- (a) Open the radome and move the supports into their position.
- (b) Remove the radome if it is necessary.
- (c) Make sure that the electrical resistance between each grounding plate and lightning diverter strip is not more than 0.001 ohms.
- (d) Make sure that the electrical resistance between each grounding plate and the spring clip is not more than 0.0025 ohms.

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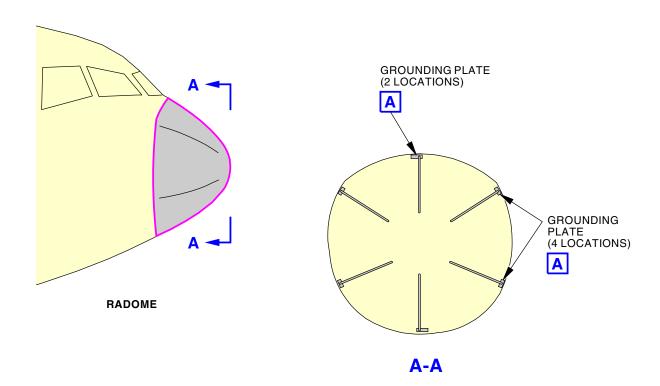


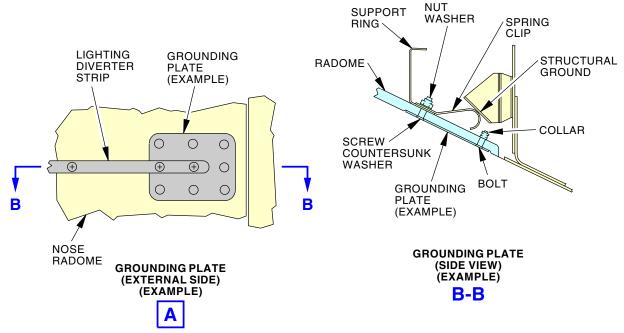
- (e) Close or install the nose radome.
- (f) Make sure that the electrical resistance between each grounding plate and the fuselage skin is not more than 0.01 ohms.

——— END OF TASK ———

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Electrical Resistance Check of the Lightning Diverter Strip Figure 601/53-12-03-990-802

EFFECTIVITY

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LIGHTNING DIVERTER STRIPS - REPAIRS

1. General

A. This procedure has one task:



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.

- (1) A temporary repair of the Lighting Diverter Strips.
- B. A partially removed diverter on the nose radome should be made symmetrical around the vertical plane at Butt Line (BL) 0. For example, if the forward half of the diverter installed at the 4 o'clock position is removed, then the forward half of the diverter installed at the 8 o'clock position should be removed.
- C. 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. On radomes with 10 diverter strips there must be no more than 4 diverter strips in symmetrical pairs missing or damaged.
- D. Sections of diverter strips not connected to the grounding plate can cause interference with communications equipment.

TASK 53-12-03-350-801

2. Lightning Diverter Strip Temporary Repair

A. References

| Reference | Title |
|------------------|--|
| 53-12-03-000-801 | Lightning Diverter Strip Removal (P/B 401) |

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 3M | |
| | No. 853 Tape) | |

C. Location Zones

| Zone | Area |
|------|--------|
| 111 | Radome |

D. Procedure

SUBTASK 53-12-03-350-003

- (1) For damaged diverter strips
 - (a) Remove all loose pieces of the lightning diverter strip Lightning Diverter Strip Removal, TASK 53-12-03-000-801.
 - (b) Make sure that the remaining section of the damaged strip is safely held.
 - (c) Make sure that the grounding plate is not damaged.
 - (d) Make sure that there is a continuous connection with the remaining section of the damaged strip and the grounding plate.

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SUBTASK 53-12-03-350-004

- (2) For missing or removed diverter strips
 - (a) Seal openings from missing bolts with speed 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 | ΩE | TACK | |
|------------|----|------|--|
| END | OF | IASK | |

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SNUBBER - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Removal of the snubber
 - (2) Installation of the snubber.

TASK 53-12-04-000-801

2. Snubber Removal

(Figure 401)

A. Location Zones

| Zone | Area |
|------|--------|
| 111 | Radome |

B. Snubber Removal

SUBTASK 53-12-04-010-001

(1) Open the radome.

SUBTASK 53-12-04-020-001

(2) Remove the attach nut [2] and washer [3] that holds the top snubber [1].

SUBTASK 53-12-04-020-002

(3) Remove the top snubber [1].

SUBTASK 53-12-04-020-003

(4) Remove the attach nut [2] and washer [3] that holds the bottom snubber [1].

SUBTASK 53-12-04-020-004

(5) Remove the bottom snubber [1].



TASK 53-12-04-400-801

3. Snubber Installation

(Figure 401)

A. References

| Reference | Title |
|------------------|---|
| 12-12-03-870-801 | Bleed the Nose Radome Snubber (P/B 301) |

B. Expendables/Parts

| AMM Item | Description | AIPC Reference | AIPC Effectivity |
|----------|-------------|-----------------|------------------|
| 1 | Snubber | 53-12-51-01-050 | ARO ALL |

C. Location Zones

| Zone | Area |
|------|--------|
| 111 | Radome |

D. Snubber Installation

SUBTASK 53-12-04-010-002

(1) Move the radome to the open position.

SUBTASK 53-12-04-640-001

(2) Apply a light layer of grease to the splines in the top snubber [1] and the bottom snubber [1].

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SUBTASK 53-12-04-420-001

(3) Put the top snubber [1] on the torque tube.

SUBTASK 53-12-04-420-002

(4) Install the attach nut [2] and washer [3].

SUBTASK 53-12-04-820-001

(5) Turn the shaft index tooth of the bottom snubber [1] 180 degrees from the installed position of the index tooth in the top snubber [1] shaft.

SUBTASK 53-12-04-420-003

(6) Put the bottom snubber [1] on the torque tube.

SUBTASK 53-12-04-420-004

(7) Install the attach nut [2] and washer [3].

SUBTASK 53-12-04-820-002

(8) Make sure the index teeth on the top and bottom snubber shafts are 180 degrees apart.

SUBTASK 53-12-04-610-001

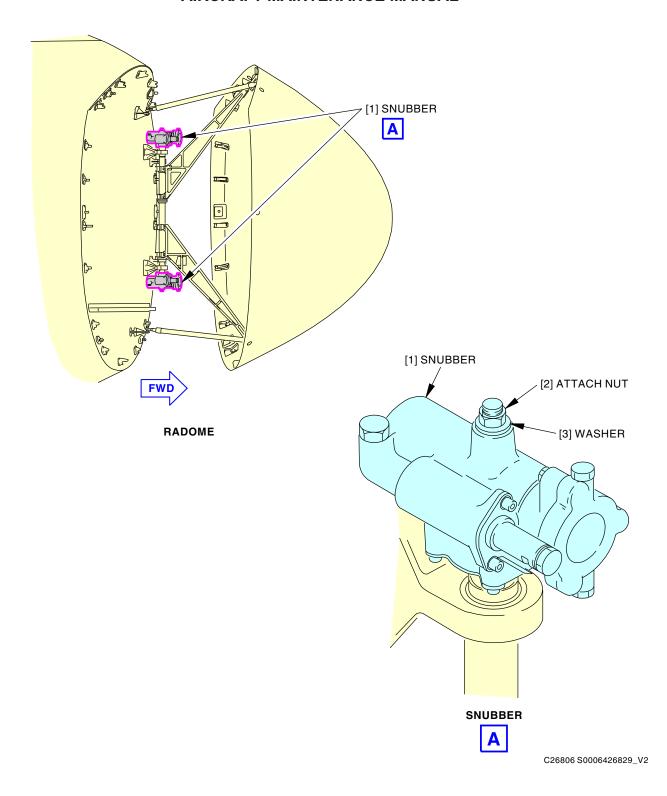
(9) Do this task: Bleed the Nose Radome Snubber, TASK 12-12-03-870-801.

SUBTASK 53-12-04-840-001

(10) Close the nose radome.

——— END OF TASK ———





Nose Radome Snubber Installation Figure 401/53-12-04-990-801

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GLIDE SLOPE DIRECTOR ELEMENT - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Removal of the glide slope director element
 - (2) Installation of the glide slope director element.
- B. The director element is a pressure sensitive tape that is made of aluminum foil.
- C. The element is attached to the inner surface of the nose radome.
- D. The element changes the patterns of the glide slope radiation antenna.

TASK 53-12-05-000-801

2. Glide Slope Director Element Removal

(Figure 401)

A. References

| Reference | Title |
|------------------|-------------------------------|
| 53-12-01-000-801 | Nose Radome Removal (P/B 401) |

B. Location Zones

| Zone | Area |
|------|--------|
| 111 | Radome |

C. Removal

SUBTASK 53-12-05-010-001

(1) Open the nose radome [1] (TASK 53-12-01-000-801)

SUBTASK 53-12-05-020-001

(2) Pull the director element [3] off the nose radome [1].

——— END OF TASK ———

TASK 53-12-05-400-801

3. Glide Slope Director Element Installation

(Figure 401)

A. 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 | BMS10-11 Type I |
| | Finish, Corrosion Inhibiting Primer | |
| G00291 | Tape - Aluminum Foil, Scotch 425 | AMS-T-23397 / L-T-80 |

B. Location Zones

| Zone | Area |
|------|--------|
| 111 | Radome |

C. Installation

SUBTASK 53-12-05-110-001

(1) Clean the surface of the radome [1] with the solvent, B00083 where you will install the director element [3].

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SUBTASK 53-12-05-370-001

- (2) Apply one layer of primer, C00259 to the area where you will install the director element [3].
 - (a) Make sure there will be a 0.25 inch area of extra primer, C00259 around all sides of the director element [3] after you install it.
 - (b) Let the primer, C00259 dry fully.

SUBTASK 53-12-05-110-002

(3) Clean the area with the solvent, B00083.

SUBTASK 53-12-05-910-001

- (4) Apply the Scotch 425 Aluminum Foil Tape, G00291 in the correct position directly from the roll.
 - (a) Make sure the Scotch 425 Aluminum Foil Tape, G00291 is clear of the lightning diverter strip fasteners.
 - (b) Make sure the marker [2] is tightly attached in the correct position.

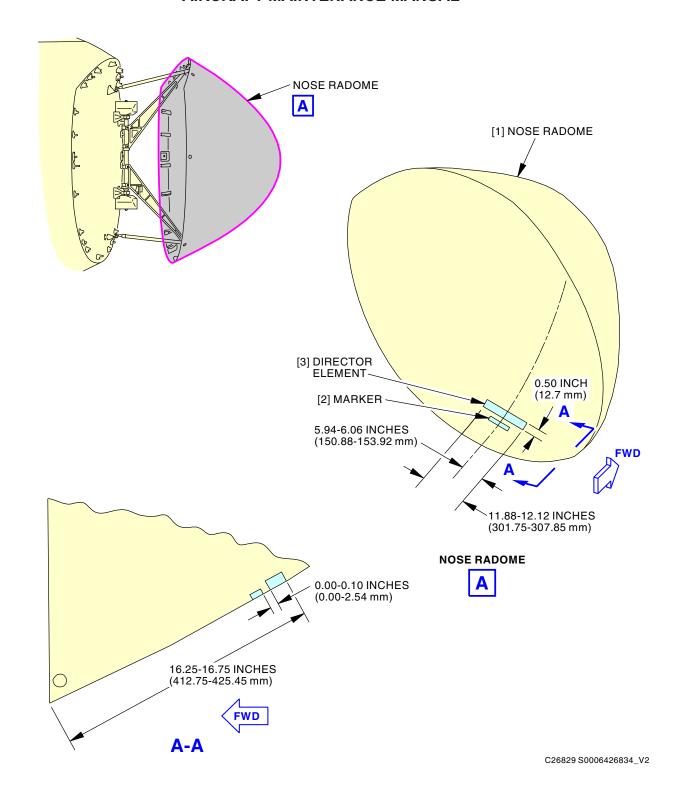
SUBTASK 53-12-05-410-001

(5) Close the nose radome [1].

----- END OF TASK -----

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Glide Slope Director Element Installation Figure 401/53-12-05-990-802

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GROUNDING BRACKETS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Removal of the Radome Grounding Brackets.
 - (2) Installation of the Radome Grounding Brackets.

TASK 53-12-06-000-801

2. Radome Grounding Brackets Removal

A. References

| Reference | Title |
|------------------|-------------------------------------|
| 53-12-00 P/B 201 | NOSE RADOME - MAINTENANCE PRACTICES |
| 53-12-01 P/B 401 | NOSE RADOME - REMOVAL/INSTALLATION |

B. Tools/Equipment

| Reference | Description |
|-----------|-------------------|
| STD-765 | Scraper - Plastic |

C. Location Zones

| Zone | Area | | |
|------|--------|--|--|
| 111 | Radome | | |

D. Procedure

SUBTASK 53-12-06-010-001

 Open the radome and move the supports into their positions. (NOSE RADOME -MAINTENANCE PRACTICES, PAGEBLOCK 53-12-00/201).

SUBTASK 53-12-06-020-001

(2) Remove the radome, if it is necessary (NOSE RADOME - REMOVAL/INSTALLATION, PAGEBLOCK 53-12-01/401).

SUBTASK 53-12-06-030-001

- (3) Remove the grounding bracket:
 - (a) Remove the fasteners, washers and clip nuts that hold the grounding bracket.
 - (b) Use a plastic scraper, STD-765 to remove the grounding bracket and sealant from the fuselage structure.



TASK 53-12-06-400-801

3. Radome Grounding Brackets Installation

A. References

| Reference | Title |
|---------------|----------------------------------|
| SWPM 20-20-00 | Standard Wiring Practices Manual |

B. Tools/Equipment

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

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| Reference | Description |
|-----------|---|
| COM-1550 | Bonding Meters - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). |
| | Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: T477W Supplier: 01014 Opt Part #: M1B Supplier: 3AD17 |
| STD-6470 | Wheel - Abrasive, 2 inch (51 mm) |

C. Consumable Materials

| Reference | Description | Specification |
|-----------------------|--|---------------|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS5-95 |
| B50095 | Solvent | BAC5750 |
| Location Zones | | |

D.

| Zone | Area |
|------|--------|
| 111 | Radome |

E. Procedure

SUBTASK 53-12-06-120-001

(1) Use an abrasive wheel, STD-6470 to clean the mating surface free of used sealant on the fuselage structure.

SUBTASK 53-12-06-110-001

(2) Use solvent, B50095 to clean the mating surface of the grounding bracket.

SUBTASK 53-12-06-420-001

(3) Apply a 0.005 in. (0.127 mm) thick layer of sealant, A00247 to the mating surface of the grounding bracket.

SUBTASK 53-12-06-420-002

- Install the grounding bracket:
 - (a) Install the grounding bracket to the fuselage structure.
 - Install the fasteners, washers and clip nuts that hold the grounding bracket.
 - (c) Remove the sealant, A00247 pushed out from the mating surfaces until the surface is flush.

SUBTASK 53-12-06-760-001

- Measure the resistance with an intrinsically safe approved bonding meter, COM-1550:
 - (a) Make sure that the electrical resistance between the grounding bracket and the fuselage structure is not more than 0.01 Ohms. (SWPM 20-20-00)

| | OE. | TASK | |
|--|-----|------|--|
| | V)F | IASN | |

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BAFFLE ASSEMBLY - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Removal of the Baffle Assembly.
 - (2) Installation of the Baffle Assembly.

TASK 53-13-01-000-801

2. Baffle Assembly Removal

Figure 401

A. General

(1) This procedure supplies instructions to remove the baffle assembly [1] in the nose wheel well.

B. References

| Reference | Title |
|------------------|--|
| 29-11-00-860-808 | Main Hydraulic System Power Removal (P/B 201) |
| 32-00-15-480-801 | Landing Gear Door Safety Pins Installation (P/B 201) |
| 32-00-30-480-801 | Landing Gear Downlock Pins Installation (P/B 201) |

C. Location Zones

| Zone | Area |
|------|-------------------------------------|
| 113 | Nose Landing Gear Wheel Well, Left |
| 114 | Nose Landing Gear Wheel Well, Right |

D. Prepare for the Removal

SUBTASK 53-13-01-480-001



MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED IN ALL OF THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT AND CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

 If the downlock pins are not installed in the nose and main landing gear, do this task: Landing Gear Downlock Pins Installation, TASK 32-00-30-480-801.

SUBTASK 53-13-01-010-001



OBEY THE INSTALLATION PROCEDURE FOR THE DOOR SAFETY PINS. THE DOORS OPEN AND CLOSE QUICKLY. THE MOVEMENT OF THE DOORS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

(2) Do this task: Landing Gear Door Safety Pins Installation, TASK 32-00-15-480-801.

SUBTASK 53-13-01-860-001

(3) For the center hydraulic system, do this task: Main Hydraulic System Power Removal, TASK 29-11-00-860-808.

E. Baffle Assembly Removal

SUBTASK 53-13-01-020-001

- (1) Remove the baffle plate [2] from the tee chord [8] on the side wall.
 - (a) Remove the bolts [5], washers [6], washers [29] and the nuts [7] that attach the baffle plate [2] to the tee chord [8].

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- (b) Remove the bolts [9], washers [10], washers [30] and the nuts [11] that attach the baffle plate [2] to the tee chord [8].
- (c) Remove the bolts [12], washers [6], washers [29] and the nuts [7] that attach the baffle plate [2] to the tee chord [8].

SUBTASK 53-13-01-020-002

- (2) Remove the tire stop [3].
 - (a) Remove the bolt [13], washers [10], washers [30] and the nut [11] of the tire stop [3] from the baffle plate [2].
 - (b) Remove the bolt [12], the washer [6], the washer [29], the nut [7], and the fitting [14] of the tire stop [3] from the top of the nose wheel well.

SUBTASK 53-13-01-020-003

- (3) Remove the lower baffle strut [4] assembly from the baffle plate [2].
 - (a) Remove the lockwire and the pin [15] from the strut.
 - (b) Remove the bolt [25], first washer [19], second washer [20], the bushing [26], and the nut [21] from the strut.

SUBTASK 53-13-01-020-004

- (4) Remove the top baffle strut [16] assembly from the baffle plate [2].
 - (a) Remove the lockwire and the pin [15] from the strut.
 - (b) Remove the bolt [27], the washer [19], the bushing [28], the washer [20], and the nut [21] from the strut.

SUBTASK 53-13-01-020-005

(5) Remove baffle plate [2].

SUBTASK 53-13-01-020-006

- (6) Remove the lower baffle strut [4] assembly from the side wall of the nose wheel well.
 - (a) Remove the lockwire and the pin [15] from the strut.
 - (b) Remove the bolt [22], the washer [19], the bushing [23], the washer [20], and the nut [21] from the strut.

SUBTASK 53-13-01-020-007

- (7) Remove the top baffle strut [16] assembly from the side wall of the nose wheel well.
 - (a) Remove the lockwire and the pin [15] from the strut.
 - (b) Remove the bolt [17], the washer [19], the bushing [18], the washer [20], and the nut [21] from the strut.

SUBTASK 53-13-01-140-001

(8) Remove remaining sealant and parting agent from faying surfaces.

SUBTASK 53-13-01-020-008

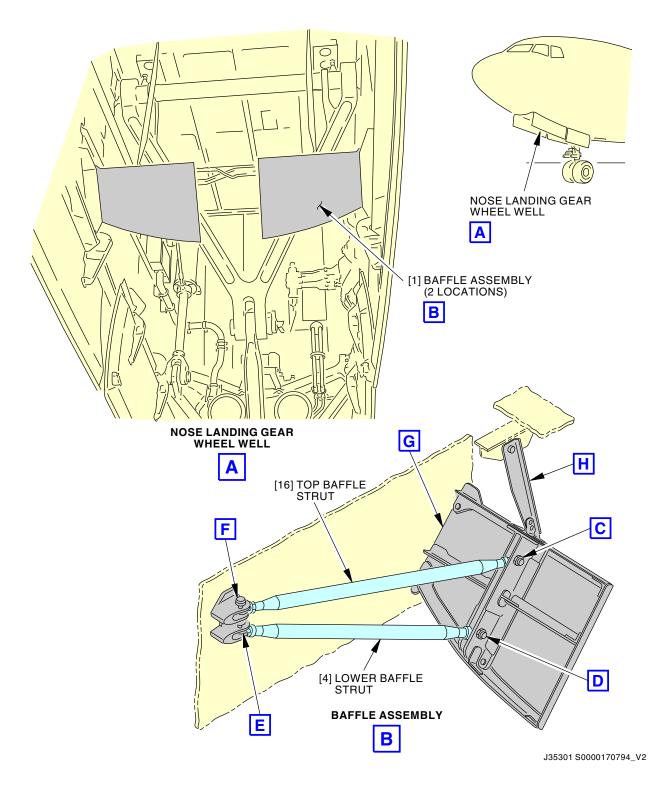
(9) Do this task again to remove the baffle assembly [1] on the opposite side of the wheel well if necessary.

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Nose Wheel Baffle Assembly Figure 401/53-13-01-990-801 (Sheet 1 of 3)

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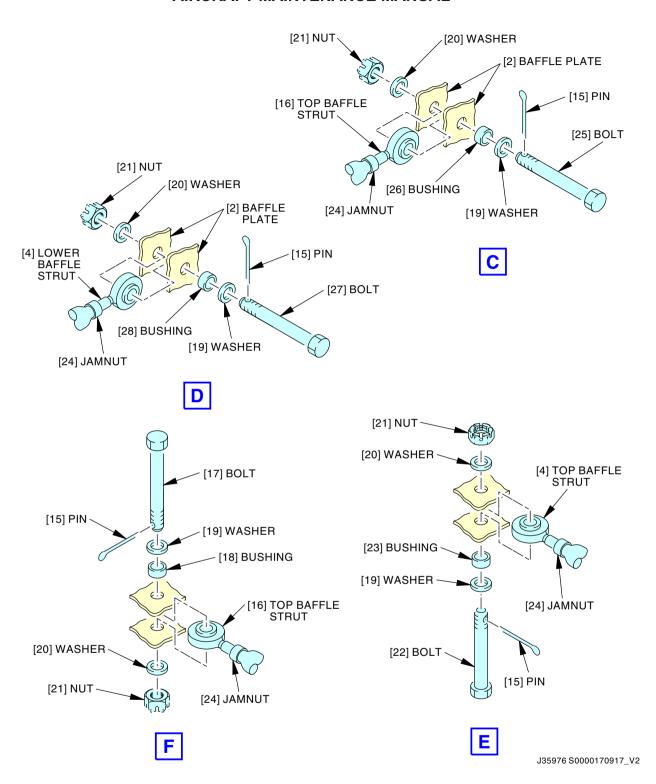
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Nose Wheel Baffle Assembly Figure 401/53-13-01-990-801 (Sheet 2 of 3)

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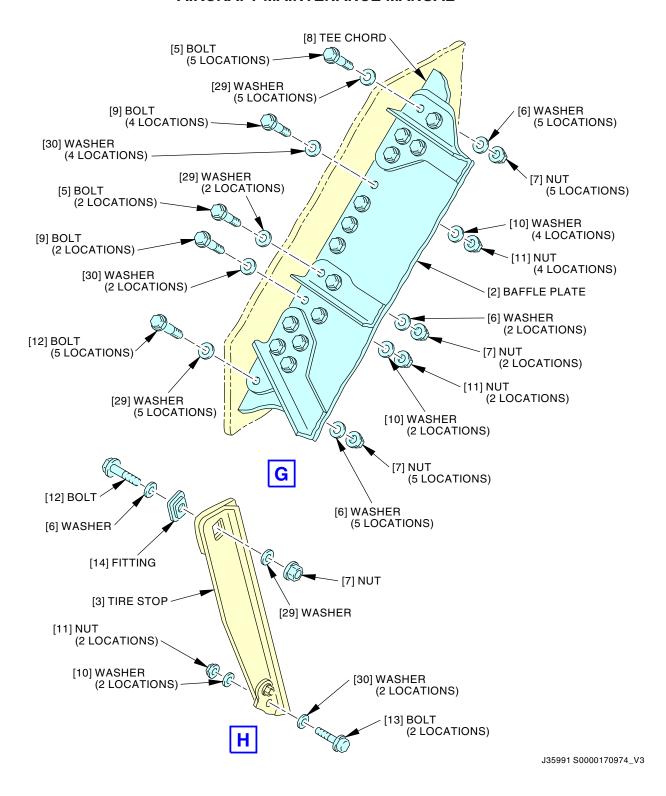
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Nose Wheel Baffle Assembly Figure 401/53-13-01-990-801 (Sheet 3 of 3)

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TASK 53-13-01-400-801

3. Baffle Assembly Installation

Figure 401

A. General

(1) This procedure supplies instructions to install the baffle assembly [1] in the nose wheel well.

B. References

| Reference | Title |
|------------------|---|
| 20-11-00-910-801 | Standard Torque Values (P/B 201) |
| 32-00-15-080-801 | Landing Gear Door Safety Pins Removal (P/B 201) |
| 32-00-30-080-801 | Landing Gear Downlock Pins Removal (P/B 201) |

C. Consumable Materials

| Reference | Description | Specification |
|-----------|--|-------------------------------|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS5-95 |
| B50085 | Solvent - Skykleen 1000 | BAC5750 PSD 6-80, PSD 9-22 |
| C00913 | Compound - Corrosion Inhibiting Material, Nondrying Resin Mix | BMS3-27 |
| G01912 | Lockwire - MS20995NC32, Monel - 0.032 Inch (0.8128 mm) Diameter | NASM20995 |
| G50237 | Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L | BMS3-38 |

D. Location Zones

| Zone | Area |
|------|-------------------------------------|
| 113 | Nose Landing Gear Wheel Well, Left |
| 114 | Nose Landing Gear Wheel Well, Right |

E. Baffle Assembly Installation

SUBTASK 53-13-01-420-001

- (1) Install the top baffle strut [16] assembly to side wall of wheel well.
 - (a) Loosen jamnut [24] at end of the strut assembly.
 - (b) Hold the top baffle strut [16] in its position in the side wall of the nose wheel well.
 - (c) Turn the rod assembly clockwise or counterclockwise to adjust rod length.
 - (d) Point a lower drain hole down if possible.
 - (e) Attach the bolt [17], the washer [19], the bushing [18], the washer [20], and the nut [21] to the strut.
 - NOTE: Make sure that the inspection holes at each end of the tube assembly are fully engaged.
 - (f) Tighten jamnut [24] at end of the tube assembly to 290 in-lb (33 N·m) 510 in-lb (58 N·m).
 - (g) Tighten the nut [21] to 160 in-lb (18 N·m).
 - (h) Loosen a maximum 1/6 of a turn if necessary to align the nearest slot in the nut [21] with the hole in the bolt [17].

NOTE: Head side torque is permitted.

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Install pin [15] and MS20995NC32 lockwire, G01912, use double twist method.

SUBTASK 53-13-01-420-002

- (2) Install the lower baffle strut [4] assembly to side wall of wheel well.
 - (a) Loosen jamnut [24] at end of the strut assembly.
 - (b) Hold the lower baffle strut [4] in its position in the side wall of the nose wheel well.
 - (c) Turn the rod assembly clockwise or counterclockwise to adjust rod length.
 - (d) Point a lower drain hole down if possible.
 - (e) Attach the bolt [22], the washer [19], the bushing [23], the washer [20], and the nut [21] to the strut
 - NOTE: Make sure that the inspection holes at each end of the tube assembly are fully engaged.
 - (f) Tighten jamnut [24] at end of the tube assembly to 290 in-lb (33 N·m) 510 in-lb (58 N·m).
 - (g) Tighten the nut [21] to 160 in-lb (18 N·m).
 - (h) Loosen a maximum 1/6 of a turn if necessary to align the nearest slot in the nut [21] with the hole in the bolt [22].
 - NOTE: Head side torque is permitted.
 - (i) Install pin [15] and MS20995NC32 lockwire, G01912, use double twist method.

SUBTASK 53-13-01-420-003

- (3) Install the top baffle strut [16] assembly to baffle plate [2].
 - (a) Loosen jamnut [24] at end of the strut assembly.
 - (b) Hold the top baffle strut [16] in its position in the side wall of the nose wheel well.
 - (c) Turn the rod assembly clockwise or counterclockwise to adjust rod length.
 - (d) Point a lower drain hole down if possible.
 - (e) Attach the bolt [25], first washer [19], the bushing [26], second washer [20], and the nut [21] to the strut.
 - NOTE: Make sure that the inspection holes at each end of the tube assembly are fully engaged.
 - (f) Tighten jamnut [24] at end of the tube assembly to 290 in-lb (33 N·m) 510 in-lb (58 N·m).
 - (g) Tighten the nut [21] to 160 in-lb (18 N·m).
 - (h) Loosen a maximum 1/6 of a turn if necessary to align the nearest slot in the nut [21] with the hole in the bolt [25].
 - NOTE: Head side torque is permitted.
 - (i) Install pin [15] and MS20995NC32 lockwire, G01912, use double twist method.

SUBTASK 53-13-01-420-004

- (4) Install the lower baffle strut [4] assembly to baffle plate [2].
 - (a) Loosen jamnut [24] at end of the strut assembly.
 - (b) Hold the lower baffle strut [4] in its position in the side wall of the nose wheel well.
 - (c) Turn the rod assembly clockwise or counterclockwise to adjust rod length.
 - (d) Point a lower drain hole down if possible.

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(e) Attach the bolt [27], first washer [19], the bushing [28], second washer [20], and the nut [21] to the strut.

NOTE: Make sure that the inspection holes at each end of the tube assembly are fully engaged.

- (f) Tighten jamnut [24] at end of the tube assembly to 290 in-lb (33 N·m) − 510 in-lb (58 N·m).
- (g) Tighten the nut [21] to 160 in-lb (18 N·m).
- (h) Loosen a maximum 1/6 of a turn if necessary to align the nearest slot in the nut [21] with the hole in the bolt [27].
 - NOTE: Head side torque is permitted.
 - Install pin [15] and MS20995NC32 lockwire, G01912, use double twist method.

SUBTASK 53-13-01-420-005



USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.



DO NOT GET THIS MATERIAL IN YOUR MOUTH, EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM THIS MATERIAL. PUT ON A RESPIRATOR, EYE PROTECTION (GOGGLES, OR OTHER APPROVED PROTECTION), AND GLOVES BEFORE YOU USE THIS MATERIAL. MAKE SURE THAT THERE IS SUFFICIENT AIRFLOW. KEEP THIS MATERIAL AWAY FROM SPARKS, FLAME, AND HEAT. THIS MATERIAL CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (5) Install the tire stop [3].
 - (a) Apply a removable corrosion fay surface seal with (sealant, A00247 class C/parting agent) to all of the mating surfaces of the tire stop [3].
 - (b) Apply Cor-Ban 27L Compound, G50237 or Mastinox 6856 K, C00913 to the threads and the shanks of all bolts.
 - (c) Attach the tire stop [3] to the baffle plate [2] with bolts [13], washers [10], washers [30] and nuts [11].
 - (d) Tighten the nuts [11].
 - 1) If using Cor-Ban 27L Compound, G50237, refer to Standard Torque Values, TASK 20-11-00-910-801.
 - 2) If using Mastinox 6856 K, C00913, tighten the nuts [11] to 65 in-lb (7 N·m) 100 in-lb (11 N·m).
 - (e) Attach fitting [14] to tire stop [3].
 - (f) Attach the tire stop [3] to the wheel well clip tee with bolt [12], the washer [6], washer [29], and the nut [7].
 - (g) Tighten the nut [7].
 - If using Cor-Ban 27L Compound, G50237, refer to Standard Torque Values, TASK 20-11-00-910-801.

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2) If using Mastinox 6856 K, C00913, tighten the nut [7] to 30 in-lb (3 N·m) - 35 in-lb (4 N·m).

SUBTASK 53-13-01-420-006



USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.



DO NOT GET THIS MATERIAL IN YOUR MOUTH, EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM THIS MATERIAL. PUT ON A RESPIRATOR, EYE PROTECTION (GOGGLES, OR OTHER APPROVED PROTECTION), AND GLOVES BEFORE YOU USE THIS MATERIAL. MAKE SURE THAT THERE IS SUFFICIENT AIRFLOW. KEEP THIS MATERIAL AWAY FROM SPARKS, FLAME, AND HEAT. THIS MATERIAL CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (6) Attach the baffle plate [2] to the side wall.
 - (a) Apply Cor-Ban 27L Compound, G50237 or Mastinox 6856 K, C00913 to the threads and the shanks of all bolts.
 - (b) Attach the bolts [5], washers [6], washers [29], and the nuts [7] that attach the baffle plate [2] to the tee chord [8].
 - (c) Tighten the nuts [7].
 - 1) If using Cor-Ban 27L Compound, G50237, refer to Standard Torque Values, TASK 20-11-00-910-801.
 - 2) If using Mastinox 6856 K, C00913, tighten the nuts [7] to 30 in-lb (3 N·m) 35 in-lb (4 N·m).
 - (d) Attach the bolts [9], washers [10], washers [30], and the nuts [11] that attach the baffle plate [2] to the tee chord [8].
 - (e) Tighten the nuts [11].
 - 1) If using Cor-Ban 27L Compound, G50237, refer to Standard Torque Values, TASK 20-11-00-910-801.
 - 2) If using Mastinox 6856 K, C00913, tighten the nuts [11] to 65 in-lb (7 N·m) 100 in-lb (11 N·m).
 - (f) Attach the bolts [12], washers [6], washers [29], and the nuts [7] that attach the baffle plate [2] to the tee chord [8].
 - (g) Tighten the nuts [7].
 - 1) If using Cor-Ban 27L Compound, G50237, refer to Standard Torque Values, TASK 20-11-00-910-801.
 - 2) If using Mastinox 6856 K, C00913, tighten the nuts [7] to 30 in-lb (3 N·m) 35 in-lb (4 N·m).
 - (h) Clean unwanted sealant from bolt heads with solvent, B50085.

SUBTASK 53-13-01-420-007

(7) Do this task again to install the baffle assembly [1] on the opposite side of the wheel well if necessary.

ARO ALL

53-13-01



F. Put the Airplane Back to its Usual Condition

SUBTASK 53-13-01-410-001



OBEY THE REMOVAL PROCEDURE FOR THE DOOR SAFETY PINS. THE DOORS OPEN AND CLOSE QUICKLY. THE MOVEMENT OF THE DOORS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

(1) Do this task: Landing Gear Door Safety Pins Removal, TASK 32-00-15-080-801.

SUBTASK 53-13-01-410-002

(2) Do this task: Landing Gear Downlock Pins Removal, TASK 32-00-30-080-801.

----- END OF TASK -----

ARO ALL

53-13-01



FLIGHT AND CARGO COMPARTMENT INSULATION FOAM - MAINTENANCE PRACTICES

1. General

- A. This procedure has information for repair and replacement of specific insulation foam for smoke and Halon retention, and fire blocking.
- B. BMS8-371 insulation foam or BMS1-68 silicone foam rubber replaces BMS8-39 Urethane foam. The selection of either BMS8-371 or BMS1-68 material will be based on requirements for use and its location in the airplane.
- C. BMS8-39 foam will degrade over time and no longer satisfy the requirements for flammability, smoke and Halon retention and fire blocking. Degraded material can be an unacceptable fuel source for a fire if exposed to an ignition source. The degraded material will also compromise Halon and smoke retention and fire blocking, which could result in the inability to keep sufficient Halon concentrations within the cargo compartment. Nomex Felt is also used to replace the BMS8-39 foam pads in the crown area of the airplane.
- D. SB 777-25-0362 and SB 777-25-0621 replace BMS8-39 foam in areas where it is used to prevent fire or smoke penetration. It is not replaced in areas where it is encapsulated by a protective fire resistant barrier or where it is physically isolated from an ignition source.
- E. Federal Aviation Administration (FAA) Airworthiness Directive AD 2013-11-04 is related to SB 777-25-0362 and SB 777-25-0621.
- F. The use of BMS8-39 Urethane foam for replacement or repairs is not permitted due to the degradation in flammability properties over time.

TASK 53-17-00-800-801

2. Flight Compartment and Cargo Compartment Insulation Foam - Maintenance Practices

A. General

- (1) This task shows specific locations where insulation must be located for flammability, smoke containment, Halon retention and fire blocking requirements.
- (2) BMS8-371 insulation foam or BMS1-68 silicone foam rubber replace BMS8-39 foam. The selection of either BMS8-371 or BMS1-68 material will be based on requirements for use and its location in the airplane. Nomex Felt is also used to replace the BMS8-39 foam pads in the crown area of the airplane.

B. Procedure

SUBTASK 53-17-00-800-001



DO NOT USE BMS8-39 FOAM MATERIAL FOR FOAM PADS AROUND INSULATION BLANKETS OR FOAM SEALS AROUND SYSTEMS THROUGH THE STRUCTURE. HOLES IN THE FOAM WILL OCCUR AFTER A PERIOD OF TIME. FIRE, SMOKE, AND HALON WILL GO INTO THE FLIGHT AND PASSENGER COMPARTMENTS DURING AN EMERGENCY. INJURIES TO THE PASSENGERS, AND THE CREW WILL OCCUR.

(1) Make sure the BMS8-371 insulation foam or BMS1-68 silicone foam rubber are replaced after all maintenance actions in the locations shown below.

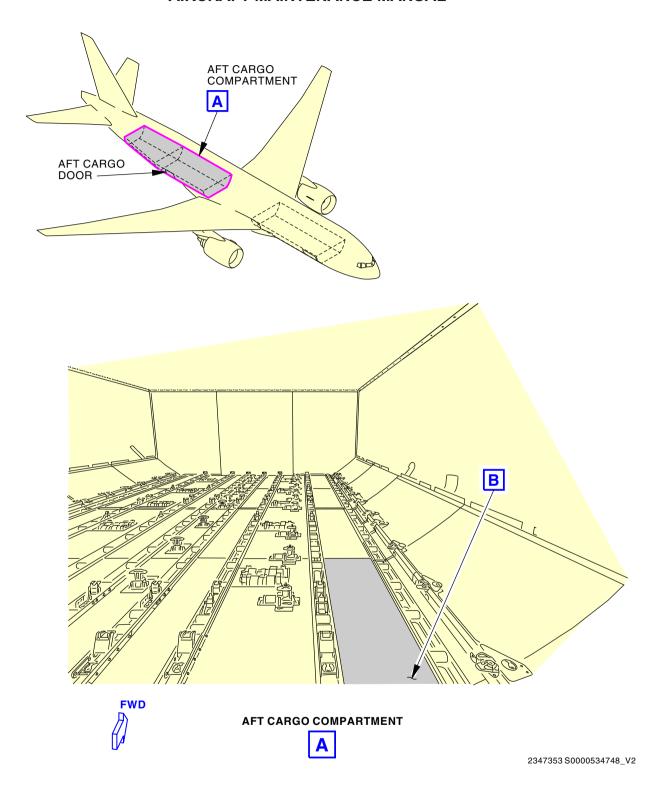
NOTE: Foam pads installed at insulation blanket penetrations and foam seals around systems penetrations are affected by AD 2013-11-04.

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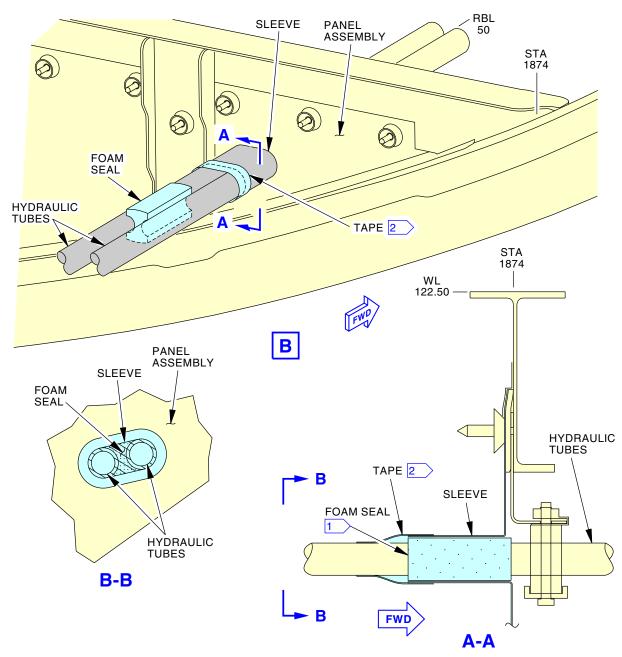
Aft Cargo Floor at STA 1874 and RBL 50 Foam Seal Replacement Figure 201/53-17-00-990-801 (Sheet 1 of 2)

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1 MOVE THE FOAM SEAL ALONG HYDRAULIC TUBES AND INTO THE SLEEVE.

CUT THE LENGTH FROM THE BULK ROLL AS REQUIRED. OVERLAP HALF OF THE TAPE AROUND THE SLEEVE AND OVERLAP THE OTHER HALF OF THE TAPE AROUND HYDRAULIC TUBES. MAKE SURE ALL GAPS BETWEEN THE SLEEVE AND HYDRAULIC TUBES ARE SEALED WITH TAPE TO CREATE A SMOKE BARRIER.

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Aft Cargo Floor at STA 1874 and RBL 50 Foam Seal Replacement Figure 201/53-17-00-990-801 (Sheet 2 of 2)

EFFECTIVITY

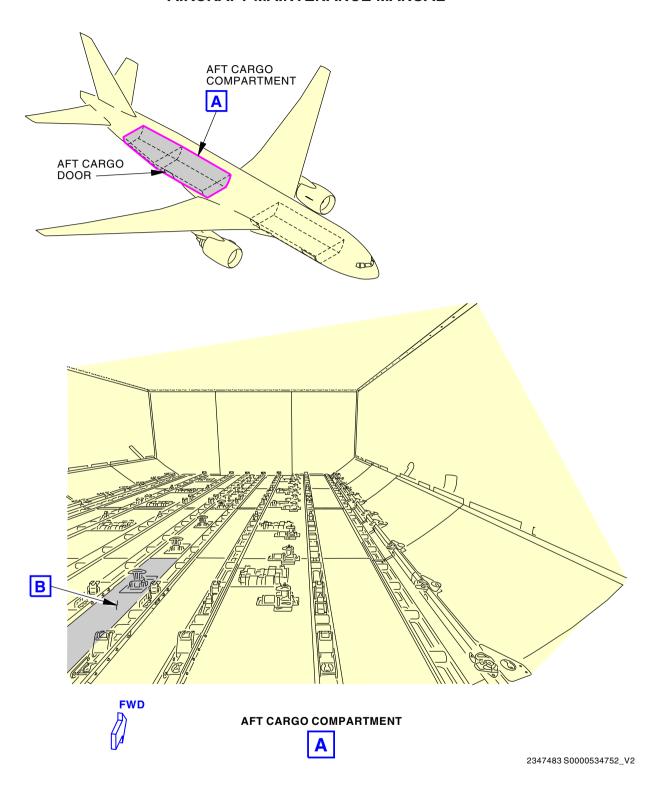
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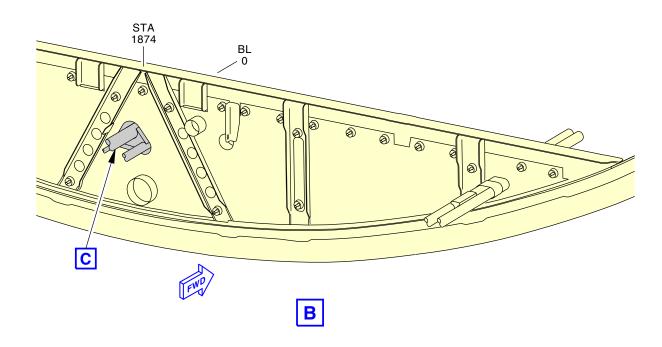
Aft Cargo Floor at Station 1874 and BL 0 Foam Seal Replacement Figure 202/53-17-00-990-802 (Sheet 1 of 3)

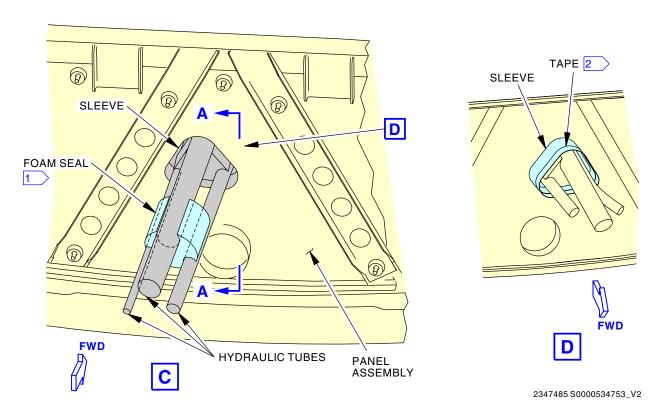
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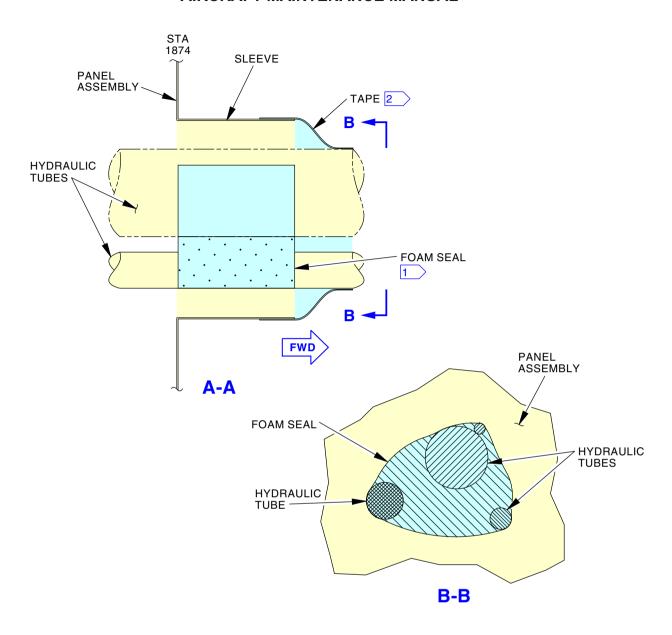
Aft Cargo Floor at Station 1874 and BL 0 Foam Seal Replacement Figure 202/53-17-00-990-802 (Sheet 2 of 3)

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MOVE THE FOAM SEAL AFT ALONG HYDRAULIC TUBES AWAY FROM THE SLEEVE.

CUT THE LENGTH FROM THE BULK ROLL AS REQUIRED. OVERLAP HALF OF THE TAPE AROUND THE SLEEVE AND OVERLAP THE OTHER HALF OF THE TAPE AROUND HYDRAULIC TUBES. MAKE SURE ALL GAPS BETWEEN THE SLEEVE AND HYDRAULIC TUBES ARE SEALED WITH TAPE TO CREATE A SMOKE BARRIER.

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Aft Cargo Floor at Station 1874 and BL 0 Foam Seal Replacement Figure 202/53-17-00-990-802 (Sheet 3 of 3)

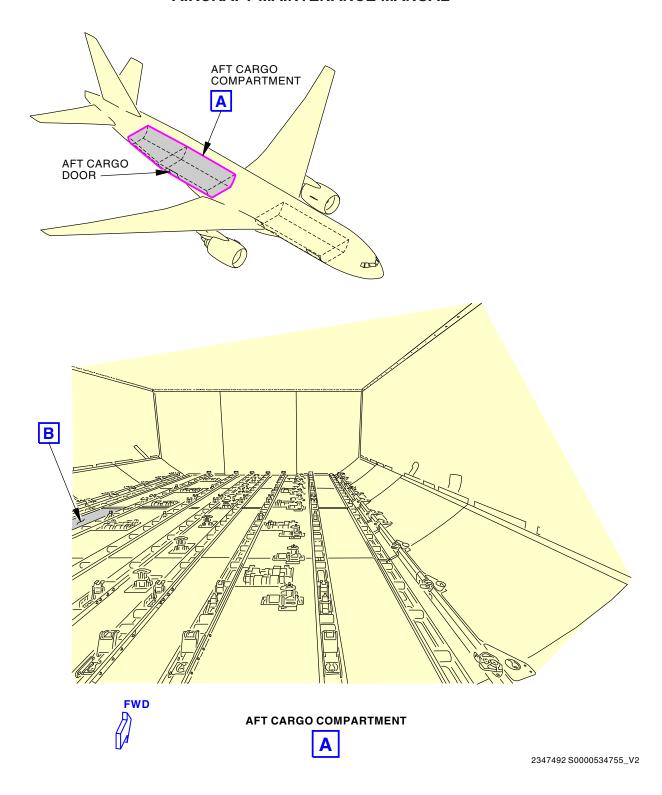
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Aft Cargo Floor at Station 1874 and LBL 60 Foam Seal Replacement Figure 203/53-17-00-990-803 (Sheet 1 of 2)

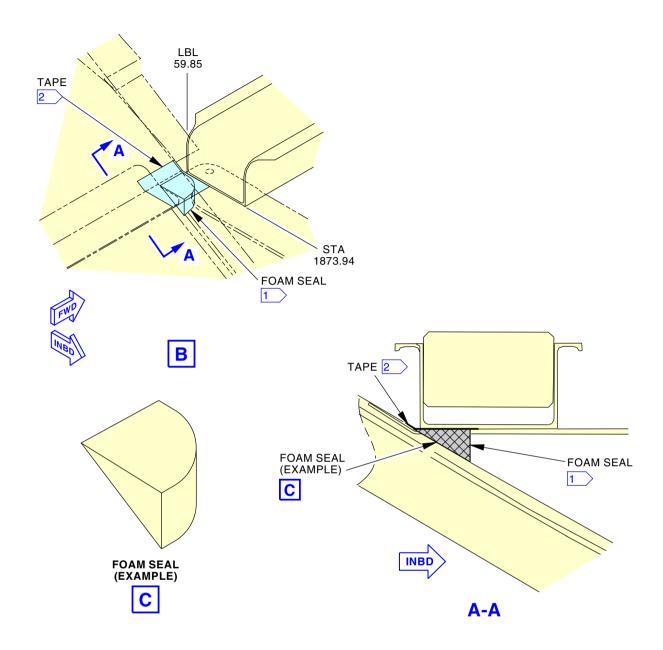
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1 PUT FOAM SEAL ON STRUCTURE. FILL ALL GAPS TO MAKE A SMOKE SEAL WITH THE STRUCTURE.

2 CUT THE LENGTH FROM THE BULK ROLL AS REQUIRED. APPLY CARGO TAPE OVER THE TOP OF THE FOAM SEAL AND OVERLAP THE ADJACENT SIDE WALL AND STRUCTURE WITH TAPE TO MAKE SURE ALL GAPS ARE SEALED TO CREATE A SMOKE BARRIER.

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Aft Cargo Floor at Station 1874 and LBL 60 Foam Seal Replacement Figure 203/53-17-00-990-803 (Sheet 2 of 2)

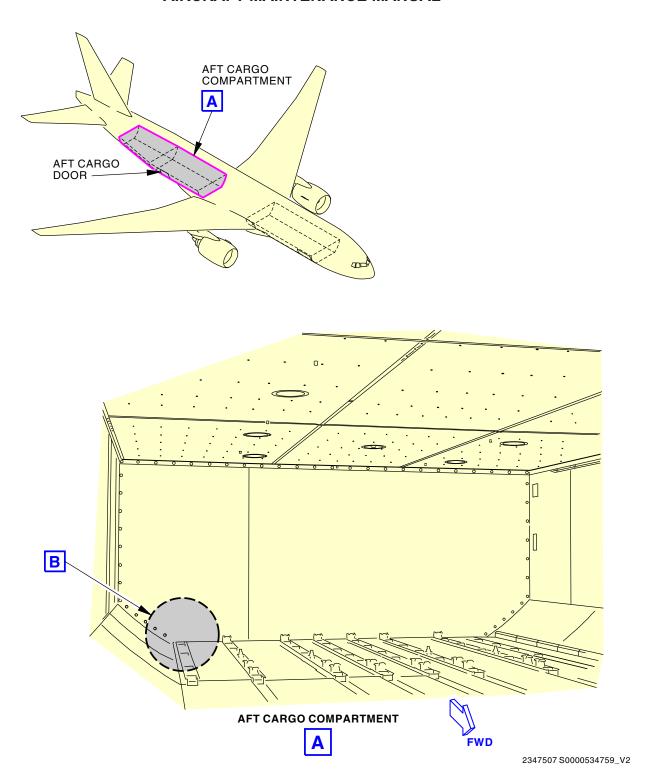
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Aft Cargo Floor at Station 1884 and RBL 57 Foam Seal Replacement Figure 204/53-17-00-990-805 (Sheet 1 of 2)

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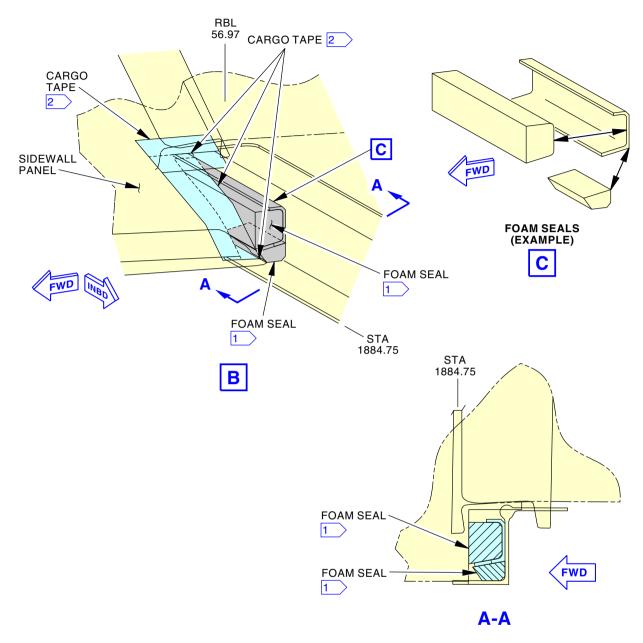
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1 PUT FOAM SEAL ON STRUCTURE. FILL ALL GAPS TO MAKE A SMOKE SEAL WITH THE STRUCTURE.

CUT THE LENGTH FROM THE BULK ROLL AS REQUIRED. APPLY CARGO TAPE ALONG THE FORWARD FACE OF THE FOAM SEAL AND THE SIDE WALL LINER ALONG AN INBD-OUTBD DIRECTION. MAKE SURE ALL GAPS BETWEEN THE FOAM SEAL AND SIDE WALL LINER ARE SEALED TO CREATE A SMOKE BARRIER.

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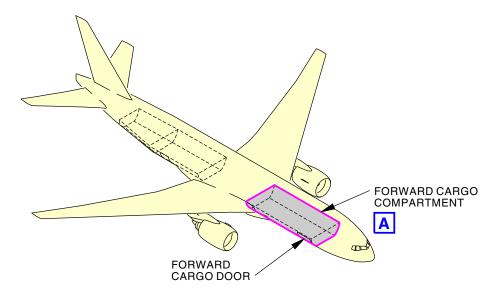
Aft Cargo Floor at Station 1884 and RBL 57 Foam Seal Replacement Figure 204/53-17-00-990-805 (Sheet 2 of 2)

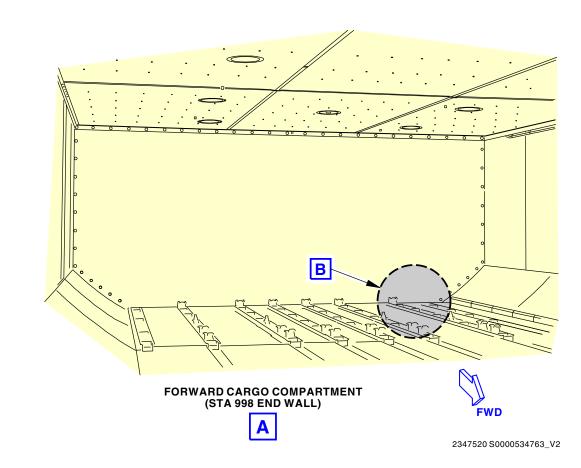
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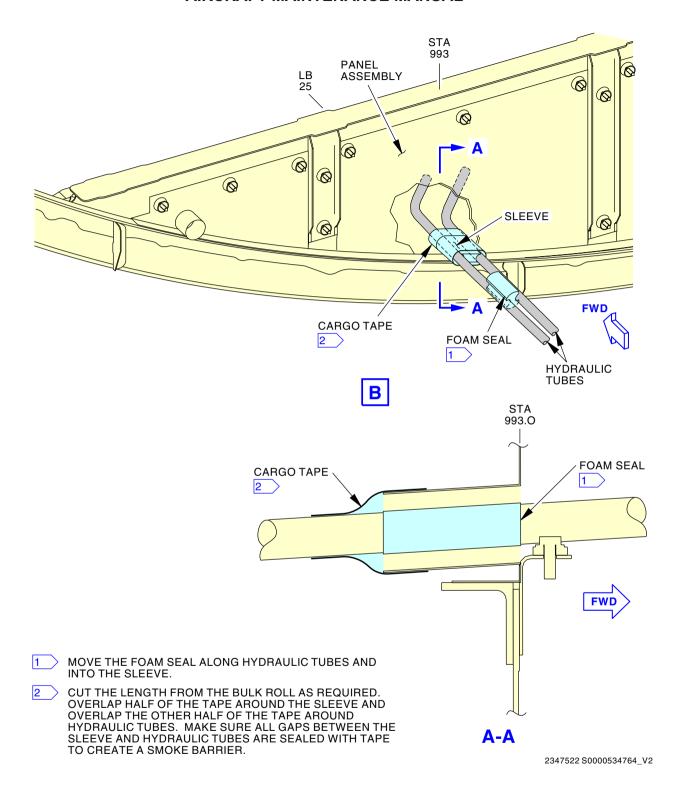
Forward Cargo Floor at Station 993 and LBL 25 Foam Seal Replacement Figure 205/53-17-00-990-807 (Sheet 1 of 2)

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Forward Cargo Floor at Station 993 and LBL 25 Foam Seal Replacement Figure 205/53-17-00-990-807 (Sheet 2 of 2)

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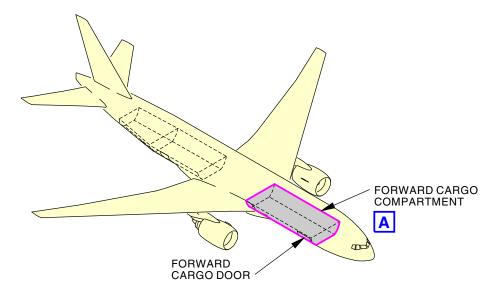
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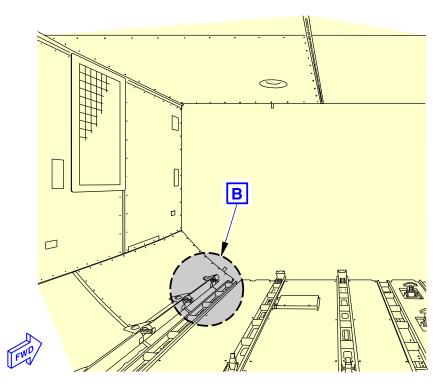
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FORWARD CARGO COMPARTMENT



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Forward Cargo Floor at Station 424 and LBL 15 Foam Seal Replacement Figure 206/53-17-00-990-808 (Sheet 1 of 3)

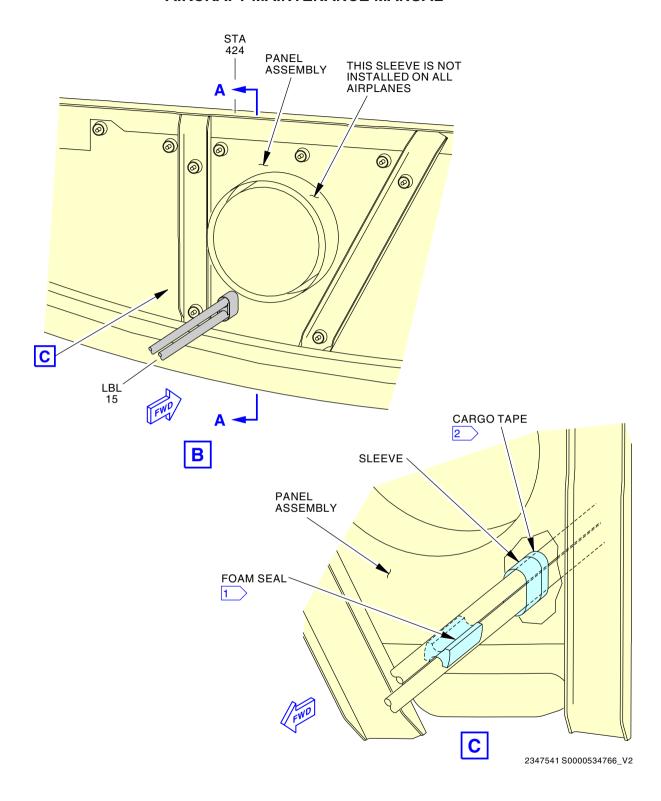
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Forward Cargo Floor at Station 424 and LBL 15 Foam Seal Replacement Figure 206/53-17-00-990-808 (Sheet 2 of 3)

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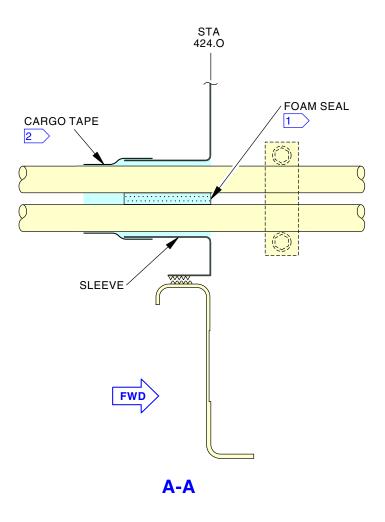
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1 MOVE THE FOAM SEAL ALONG HYDRAULIC TUBES AND INTO THE SLEEVE.

2 CUT THE LENGTH FROM THE BULK ROLL AS REQUIRED.
OVERLAP HALF OF THE TAPE AROUND THE SLEEVE
AND OVERLAP THE OTHER HALF OF THE TAPE AROUND
HYDRAULIC TUBES. MAKE SURE ALL GAPS BETWEEN
THE SLEEVE AND HYDRAULIC TUBES ARE SEALED WITH
TAPE TO CREATE A SMOKE BARRIER.

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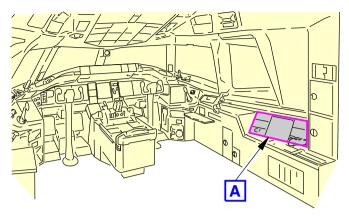
Forward Cargo Floor at Station 424 and LBL 15 Foam Seal Replacement Figure 206/53-17-00-990-808 (Sheet 3 of 3)

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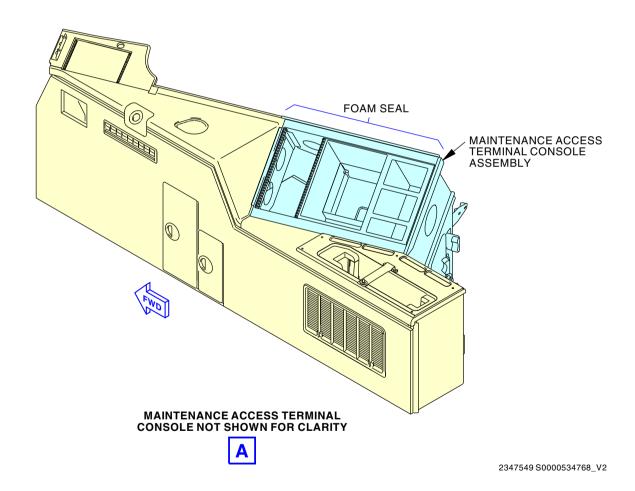
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FLIGHT COMPARTMENT



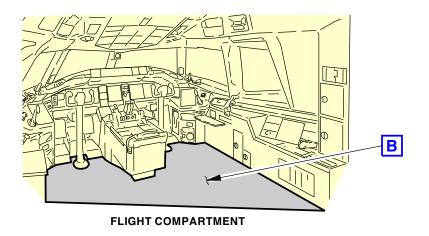
Flight Compartment Foam Seal Replacement Figure 207/53-17-00-990-810 (Sheet 1 of 3)

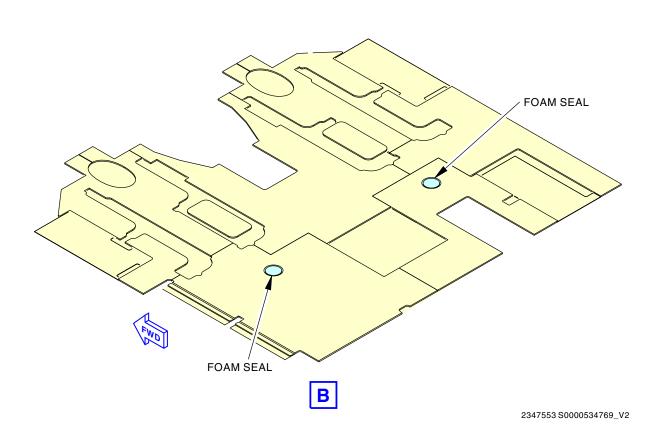
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Flight Compartment Foam Seal Replacement Figure 207/53-17-00-990-810 (Sheet 2 of 3)

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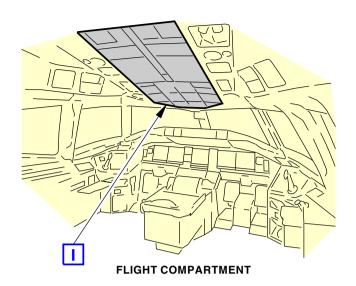
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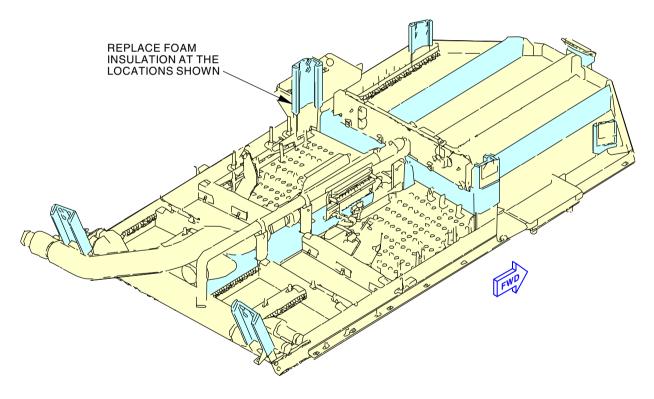
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OVERHEAD PANEL (WIRE BUNDLES NOT SHOWN FOR CLARITY)



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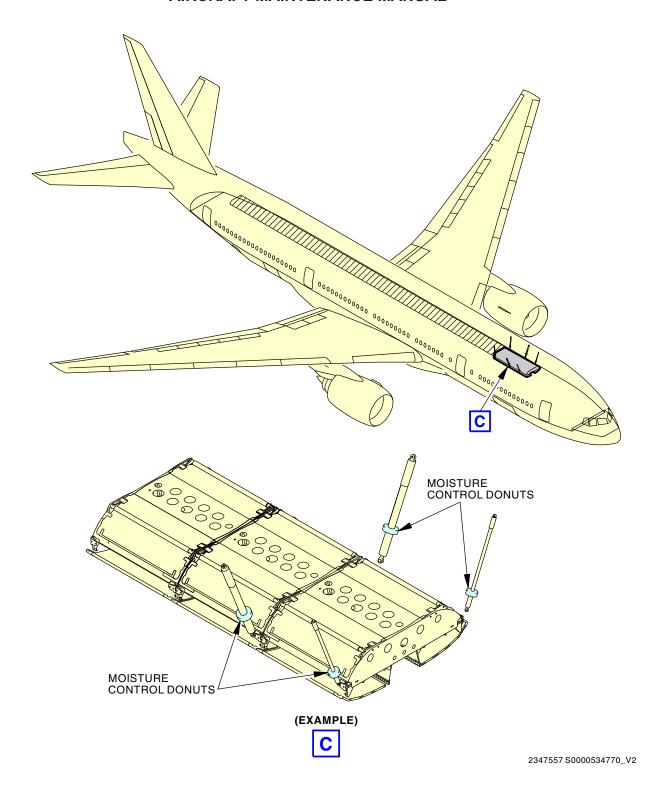
Flight Compartment Foam Seal Replacement Figure 207/53-17-00-990-810 (Sheet 3 of 3)

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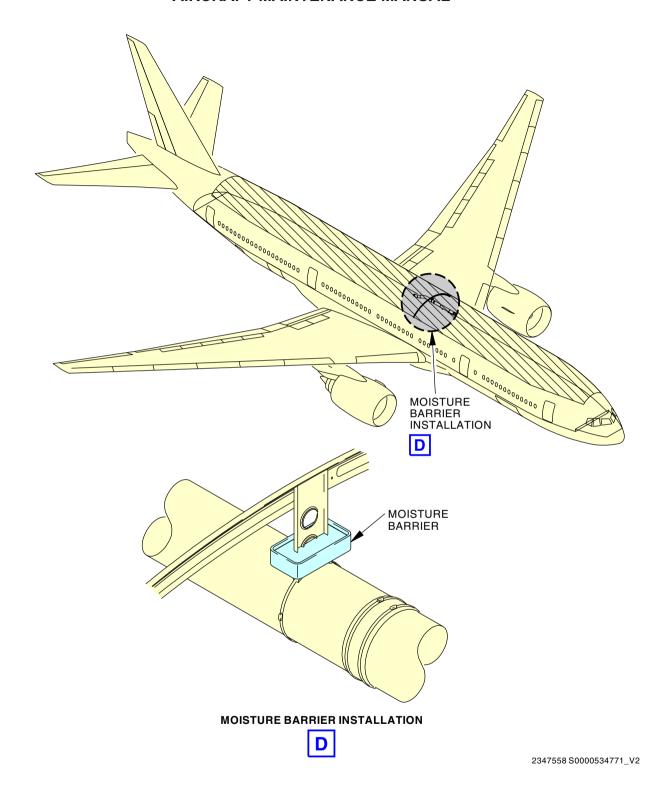
Passenger Compartment Foam Seal Replacement Figure 208/53-17-00-990-811 (Sheet 1 of 3)

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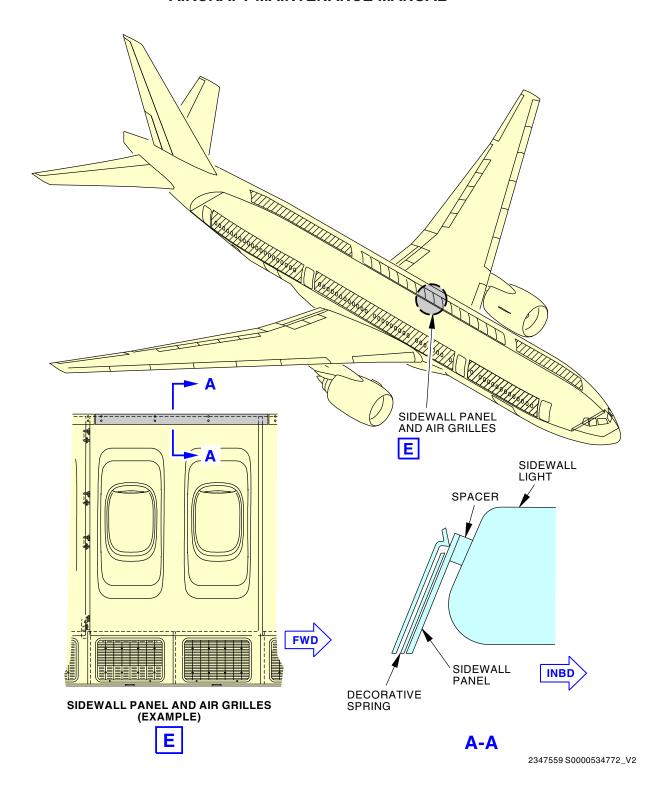
Passenger Compartment Foam Seal Replacement Figure 208/53-17-00-990-811 (Sheet 2 of 3)

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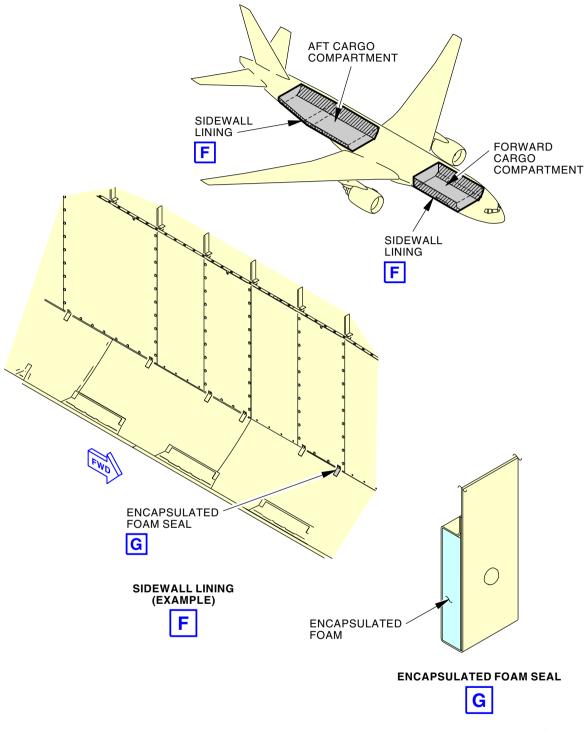


Passenger Compartment Foam Seal Replacement Figure 208/53-17-00-990-811 (Sheet 3 of 3)

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Forward And Aft Cargo Compartment Foam Seal Replacement Figure 209/53-17-00-990-812 (Sheet 1 of 2)

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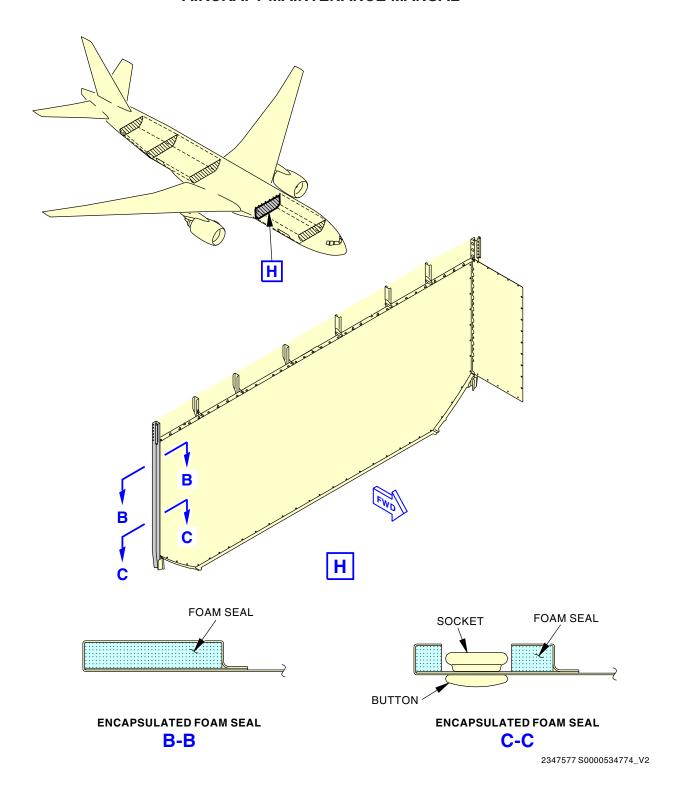
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Forward And Aft Cargo Compartment Foam Seal Replacement Figure 209/53-17-00-990-812 (Sheet 2 of 2)





FORWARD WING-TO-BODY FAIRINGS PANEL - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Removal of the forward wing-to-body fairings
 - (2) Installation of the forward wing-to-body fairings.
- B. The forward wing-to-body fairing has these parts:
 - (1) Fairing panels
 - (2) ECS Ram Inlet
 - (3) Actuator access panel
 - (4) Jack pad cover.

TASK 53-36-01-000-801

2. Forward Wing-To-Body Fairing Panel Removal

(Figure 401)

A. References

| Reference | Title |
|------------------|-------------------------------|
| 51-31-01-160-801 | Prepare For Sealing (P/B 201) |

B. Location Zones

| Zone | Area |
|------|--------------------------------------|
| 191 | Forward Wing-to-Body Fairings, Left |
| 192 | Forward Wing-to-Body Fairings, Right |

C. Removal

SUBTASK 53-36-01-020-001

- (1) Remove a fairing panel as follows:
 - (a) If there is sealant on the edge of the panel, remove it (TASK 51-31-01-160-801).

NOTE: You can remove a section of the fillet seal.

- (b) Remove the fasteners that hold the fairing panel.
- (c) Remove the fairing panel.

SUBTASK 53-36-01-020-002

- (2) Remove the actuator access panel as follows:
 - (a) Remove the fasteners that hold the panel closed.
 - (b) Open the panel.
 - (c) Disconnect the electrical jumpers from the fuselage side of the hinge assembly.
 - (d) Remove the bolts to disconnect the hinges from the fuselage.
 - (e) Remove the panel.

| END | \cap E | TΛ | CK. | |
|----------------|----------|----|-----|--|

ARO ALL

53-36-01



TASK 53-36-01-400-801

3. Forward Wing-To-Body Fairing Panel Installation

(Figure 401)

A. References

| Reference | Title |
|------------------|---|
| 05-51-38 | AIRFRAME VIBRATION CONDITION |
| 06-41-00 P/B 201 | FUSELAGE (MAJOR ZONES 100 AND 200) ACCESS DOORS |
| | AND PANELS - MAINTENANCE PRACTICES |

B. Consumable Materials

| Reference | Description | Specification |
|-----------|--|-------------------|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS5-95 |
| A02315 | Sealant - Low Density, Synthetic Rubber. 2 Part | BMS5-142 Type II |
| C00767 | Coating - Anti-Static Coating | BMS10-21 Type III |
| C00915 | Compound - Organic Corrosion Inhibiting, Advanced | BMS3-29 |

C. Location Zones

| Zone | Area |
|------|--------------------------------------|
| 191 | Forward Wing-to-Body Fairings, Left |
| 192 | Forward Wing-to-Body Fairings, Right |

D. Actuator Access Panel Installation

SUBTASK 53-36-01-420-001

- (1) Attach the panel as follows:
 - (a) Put the panel in its correct position.
 - (b) Install the bolts to attach the hinges to the fuselage.
 - (c) Connect the electrical jumpers across the hinge assemblies.
 - (d) Close the panel.
 - (e) Install the fasteners.

SUBTASK 53-36-01-220-001

(2) If the actuator access panel is a new or replacement panel, make sure the mismatches and gaps are as follows:

NOTE: The actuator access panel mismatches and gaps are non-adjustable after the initial installation. No adjustment is necessary for routine maintenance removal and installation.

- (a) Measure the flushness and the gap between the panels.
 - 1) Make sure the flushness between panels is within 0.02 in. (0.51 mm).
 - 2) Make sure the gap between the hinge edge of the panel and its adjacent panel is 0.24 to 0.36 inch.
 - 3) Make sure the gap between the other edges of the panel and its adjacent panel is 0.14 ±0.06 inch.

EFFECTIVITY 53-36-01



E. Fairing Panel Installation

SUBTASK 53-36-01-210-001

- (1) Prepare to install the panel as follows:
 - (a) Make sure the surface between the structure and the fairing panel is clean.
 - (b) Make sure the area around each fastener hole and each fastener is very clean.

SUBTASK 53-36-01-620-001

- (2) Apply corrosion inhibiting compound, C00915 to the skin below the fairing between stringers S-47R and S-47L.
- (3) Apply fillet seal around skin splice plate and attach fittings using sealant, A00247.
- (4) Apply a flush fillet seal across the separation of the intercostal assembly and the fairing frame assembly using sealant, A00247.
- (5) Add scuppers to drain holes.

SUBTASK 53-36-01-910-001

- (6) Make an electrical ground as follows:
 - (a) Find the fastener locations for the electrical grounding.
 - NOTE: The fastener locations that have an electrical ground have a black countersunk area. There are usually two fastener locations per panel.
 - (b) Apply coating, C00767 to the composite part of each hole.
 - (c) Let the coating dry.
 - (d) Put the panel in its position on the airplane.
 - (e) Install the fasteners without sealant.

SUBTASK 53-36-01-910-002

- Install all the remaining fasteners.
 - (a) Apply a brush fillet seal to the fasteners between stringers S-47R and S-47L with sealant, A00247.

NOTE: Make sure that the fasteners are secured.

SUBTASK 53-36-01-220-002

(8) If the fairing panel is a new or replacement panel, make sure the mismatches and gaps are as follows:

NOTE: The fairing panel mismatches and gaps are non-adjustable after the initial installation. No adjustment is necessary for routine maintenance removal and installation.

- (a) Measure the flushness and gap between the panels.
 - 1) Make sure the flushness between panels is within 0.02 inch.
 - 2) Make sure the flushness between the jackpad fairing panel and the adjacent panel is between 0.02 inch and 0.06 inch.
 - 3) Make sure the gap between the panels is 0.14 ± 0.06 inch.

53-36-01

EFFECTIVITY



SUBTASK 53-36-01-910-003



DO NOT APPLY SEALANT BETWEEN THE FAIRING PANELS. SEALANT IN THE INCORRECT LOCATION CAN CAUSE STRUCTURAL DAMAGE TO THE FAIRING PANELS DURING FLIGHT.

(9) Apply sealant, A02315 (or alternate sealant, A00247 B-1/2 Type 1) to make a fillet seal where the panel touches the fuselage as shown in (Figure 401).

NOTE: This makes an aerodynamic and a weather seal.

NOTE: If continuous high cabin noise and vibration are reported near the wing area, inspect

and repair the panels. AIRFRAME VIBRATION CONDITION,

SUBJECT 05-51-38FUSELAGE (MAJOR ZONES 100 AND 200) ACCESS DOORS

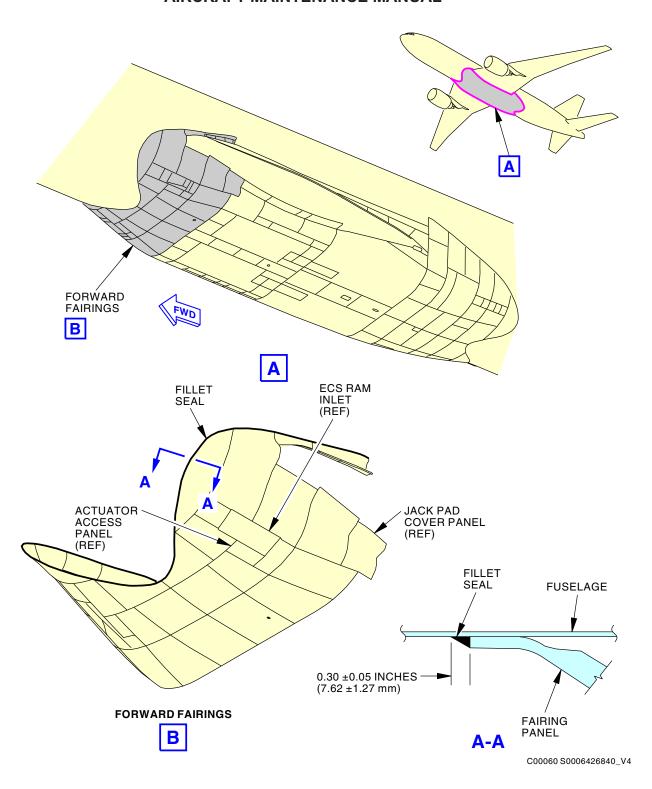
AND PANELS - MAINTENANCE PRACTICES, PAGEBLOCK 06-41-00/201.

----- END OF TASK -----

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Forward Wing-to-Body Fairings Figure 401/53-36-01-990-801

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WING STRAKELET TO SIDE-OF-BODY - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
 - (1) Removal of the forward wing-to-body fairing at STA 972.00 above the ram air inlet.
 - (2) Installation of the forward wing-to-body fairing at STA 972.00.
 - (3) Inspection of the strakelet to side-of-body structure.
- B. The forward wing-to-body fairing has these parts:
 - (1) Fairing panels
 - (2) ECS Ram Inlet
 - (3) Actuator access panel
 - (4) Jack pad cover.

TASK 53-36-02-000-801

2. Forward Wing-To-Body Fairing Panel Removal

(Figure 201)

A. References

| Reference | Title |
|------------------|-------------------------------|
| 51-31-01-160-801 | Prepare For Sealing (P/B 201) |

B. Location Zones

| Zone | Area |
|------|--------------------------------------|
| 191 | Forward Wing-to-Body Fairings, Left |
| 192 | Forward Wing-to-Body Fairings, Right |

C. Removal

SUBTASK 53-36-02-020-001

(1) Remove the fairing panel at STA 972.00 as follows:

NOTE: The access panels are independent from each other and can be removed individually. Remove as many access panels as necessary to perform the procedures.

(a) If there is sealant on the edge of the panel, remove it (TASK 51-31-01-160-801).

NOTE: You can remove a section of the fillet seal.

- (b) Remove the fasteners that hold the fairing panel.
- (c) Remove the fairing panel.

SUBTASK 53-36-02-210-001

(2) Do this task: Wing Strakelet to Side-of-Body Inspection, TASK 53-36-02-200-801.

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TASK 53-36-02-400-801

3. Forward Wing-To-Body Fairing Panel Installation

(Figure 201)

A. Consumable Materials

| Reference | Description | Specification |
|-----------|---|-------------------|
| A02315 | Sealant - Low Density, Synthetic Rubber. 2 Part | BMS5-142 Type II |
| C00767 | Coating - Anti-Static Coating | BMS10-21 Type III |

B. Location Zones

| Zone | Area |
|------|--------------------------------------|
| 191 | Forward Wing-to-Body Fairings, Left |
| 192 | Forward Wing-to-Body Fairings, Right |

C. Fairing Panel Installation

SUBTASK 53-36-02-210-002

- (1) Prepare to install the fairing panel at STA 972.00 as follows:
 - (a) Make sure the surface between the structure and the fairing panel is clean.
 - (b) Make sure the area around each fastener hole and each fastener is very clean.

SUBTASK 53-36-02-910-001

- (2) Make an electrical bond as follows:
 - (a) Find the fastener locations for the electrical bonding.
 - (b) Apply coating, C00767 to the composite part of each hole.
 - (c) Let the coating dry.
 - (d) Put the panel in its position on the airplane.
 - (e) Install the fasteners without sealant.

SUBTASK 53-36-02-910-002

(3) Install all the remaining fasteners.

SUBTASK 53-36-02-220-001

(4) If the fairing panel is a new or replacement panel, make sure the mismatches and gaps are correct as follows:

NOTE: The fairing panel mismatches and gaps are non-adjustable after the initial installation. No adjustment is necessary for routine maintenance removal and installation.

- (a) Measure the flushness and gap between the panels.
 - 1) Make sure the flushness between panels is within 0.02 inch.
 - 2) Make sure the gap between the panels is 0.14 ±0.06 inch.

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SUBTASK 53-36-02-910-003



DO NOT APPLY SEALANT BETWEEN THE FAIRING PANELS. SEALANT IN THE INCORRECT LOCATION CAN CAUSE STRUCTURAL DAMAGE TO THE FAIRING PANELS DURING FLIGHT.

(5) Apply sealant, A02315 to make a fillet seal where the panel touches the fuselage as shown in (Figure 201).

NOTE: This makes an aerodynamic and a weather seal.

----- END OF TASK -----

TASK 53-36-02-200-801

4. Wing Strakelet to Side-of-Body Inspection

(Figure 201)

A. Location Zones

| Zone | Area |
|------|--------------------------------------|
| 191 | Forward Wing-to-Body Fairings, Left |
| 192 | Forward Wing-to-Body Fairings, Right |

B. Strakelet structure inspection.

SUBTASK 53-36-02-210-003

- (1) Inspect the Strakelet structure as follows.
 - (a) Make a note of the locations of the following parts.
 - 1) The strakelet cruciform fitting assembly,
 - 2) The wing-to-body fairing struts,
 - 3) The body fittings.
 - (b) Swing the struts out of the way to observe the lower bearings.

NOTE: You must disassemble the joints between the wing-to-body fairing struts.

- (c) Visually inspect the two lower bearings in the cruciform fitting and the blade web in which the bearings are installed.
- (d) Visually inspect the side of body fittings which attach to the struts.
- (e) Visually inspect the fasteners that attach the fitting to the side of the body.
- (f) Visually inspect the fasteners that are common to the body skin and the stringers in the area around the fittings.

SUBTASK 53-36-02-960-001

(2) Repair or replace any broken or damaged parts.

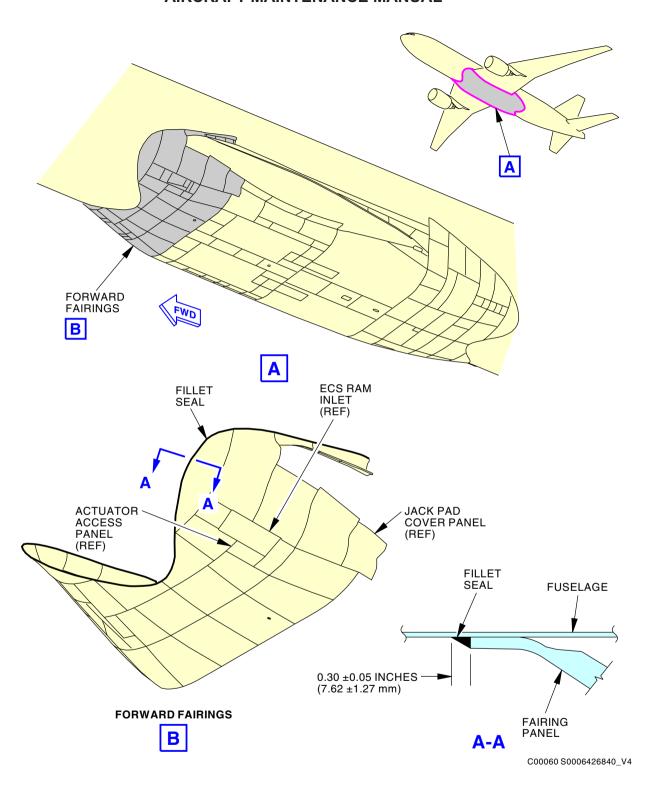
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Forward Wing-to-Body Fairing Locations for Strakelet Inspection Figure 201/53-36-02-990-801

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OVERWING AND UNDERWING-TO-BODY FAIRING PANEL - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks for the Wing-to-Body fairings:
 - (1) Removal of the overwing and underwing fairing panels.
 - (2) Installation of the overwing and underwing fairing panels.
- B. These access doors and panels are in this procedure:
 - (1) Fairing panels
 - (2) Trailing Edge Flap Door
 - (3) Low Pressure Connect Door
 - (4) High Pressure Connect Door
 - (5) Heat Exchanger Door
 - (6) Heat Exchanger Blowout Door.
- C. These access doors are in different MM locations:
 - (1) ECS Door
 - (2) Main Landing Gear Door.

TASK 53-46-01-000-801

2. Overwing and Underwing-to-Body Fairing Panel Removal

(Figure 401, Figure 402, Figure 403, Figure 404, Figure 405, Figure 406, Figure 408, Figure 409)

A. References

| Reference | Title |
|------------------|-------------------------------|
| 51-31-01-160-801 | Prepare For Sealing (P/B 201) |

B. Location Zones

| Zone | Area |
|------|--|
| 193 | Overwing Wing-to-Body Fairings, Left |
| 194 | Overwing Wing-to-Body Fairings, Right |
| 195 | Underwing Wing-to-Body Fairings, Left |
| 196 | Underwing Wing-to-Body Fairings, Right |

C. Removal

SUBTASK 53-46-01-020-001

- (1) Remove a fairing panel as follows:
 - (a) If there is sealant on the edge of the panel, remove it (TASK 51-31-01-160-801).

NOTE: You can cut out a section of the fillet seal.

- (b) Remove the fasteners that hold the fairing panel.
- (c) Make a record of the correct grip length for each fastener location
- (d) Remove the fairing panel.

SUBTASK 53-46-01-020-002

- (2) Remove the trailing edge flap door as follows:
 - (a) Move the trailing edge flaps to their fully lowered position.
 - (b) Remove the large fairing panel above the flap door to get access to the hinges.
 - (c) Disconnect the electrical jumpers from the door.

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- (d) Remove the bolts that hold the door to the hinge.
- (e) Remove the door.

SUBTASK 53-46-01-020-003

- (3) Remove the access and service doors as follows:
 - (a) Open the door.
 - (b) Disconnect the folding strut from the fitting on the door.
 - (c) Disconnect the electrical jumpers from the hinge assemblies.
 - (d) Remove the hinge bolts to disconnect the hinge assembly.
 - (e) Remove the door assembly.



TASK 53-46-01-400-801

3. Overwing and Underwing-To-Body Fairing Panel Installation

(Figure 401, Figure 402, Figure 403, Figure 404, Figure 405, Figure 406, Figure 408, Figure 409)

A. Consumable Materials

| Reference | Description | Specification |
|-----------|--|-------------------|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS5-95 |
| A02315 | Sealant - Low Density, Synthetic Rubber. 2 Part | BMS5-142 Type II |
| C00767 | Coating - Anti-Static Coating | BMS10-21 Type III |
| C00915 | Compound - Organic Corrosion Inhibiting, Advanced | BMS3-29 |
| G01505 | Lockwire - Safety And Lock | NASM20995 |

B. Location Zones

| Zone | Area |
|------|--|
| 193 | Overwing Wing-to-Body Fairings, Left |
| 194 | Overwing Wing-to-Body Fairings, Right |
| 195 | Underwing Wing-to-Body Fairings, Left |
| 196 | Underwing Wing-to-Body Fairings, Right |

C. Fairing Panel Installation

SUBTASK 53-46-01-210-001

- (1) Prepare to install the fairing panel [1] as follows:
 - (a) Make sure the surface between the structure and the fairing panel is clean.
 - (b) Make sure the area around each fastener hole and each fastener is very clean.

SUBTASK 53-46-01-620-001

(2) Apply corrosion inhibiting compound, C00915 to the skin below the fairing between stringers S-47R and S-47L.

SUBTASK 53-46-01-910-001

- (3) Make an electrical ground as follows:
 - (a) Find the fastener locations for the electrical grounding.

NOTE: The fastener locations that have an electrical ground have a black countersunk area. There are usually two fastener locations per panel.

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- (b) Apply coating, C00767 to the composite part of each hole.
- (c) Let the coating dry.
- (d) Put the panel in its position.

SUBTASK 53-46-01-910-004

(4) Without sealant, install the fasteners with the correct grip length as recorded in the removal procedure.

NOTE: Installation of the fasteners without the correct grip length can cause panel vibration during flight.

SUBTASK 53-46-01-910-002

- Install all the remaining fasteners.
 - (a) Apply a brush fillet seal to the fasteners between stringers S-47R and S-47L with sealant, A00247.

NOTE: Make sure that the fasteners are secured.

SUBTASK 53-46-01-220-001

- (6) Do a check of the panel as follows:
 - (a) Measure the flushness and clearance around the panel.
 - 1) Make sure the gap between the panels is 0.08 in. (2.03 mm) to 0.20 in. (5.08 mm).
 - 2) Make sure the flushness is equal to or less than 0.04 in. (1.02 mm).

ARO 012

NOTE: The flushness at STA 1161 WL 194 LBL 125 between the aft edge of panel 149W3210-15 and the forward edge of panel 149W3210-17 can measure up to -0.090 in. (-2.286 mm). The flushness at STA 1234 WL 194 LBL 125 between the aft edge of panel 149W3210-17 and the forward edge of panel 149W4210-27 can measure up to -0.060 in. (-1.524 mm).

ARO 013

NOTE: The flushness at STA 1234, WL 190, RBL 120 is between the aft edge of panel 149W3210-18 and the forward edge of panel 149W4220-6. This is located between the lower edges of the two panels measuring -0.060 in. (-1.524 mm) outboard tapering to 0.040 in. (1.016 mm) inboard for a length of 2.50 in. (63.50 mm).

NOTE: The flushness at STA 1109, WL194, LBL 125 between the outboard aft edge of panel 149W3210–9 and the outboard forward edge of panel 149W3210–15 is measuring 0.060 in. (1.524 mm) tapering inboard for a length of 2.10 in. (53.34 mm).

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SUBTASK 53-46-01-910-003



DO NOT APPLY SEALANT BETWEEN THE FAIRING PANELS. SEALANT IN THE INCORRECT LOCATION CAN CAUSE STRUCTURAL DAMAGE TO THE FAIRING PANELS DURING FLIGHT.

(7) Apply sealant, A02315 (or alternative sealant, A00247 B-1/2 Type 1) to make a fillet seal where the panel touches the fuselage as shown in (Figure 401).

NOTE: This makes an aerodynamic and a weather seal.

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D. Trailing Edge Flap Door Installation

SUBTASK 53-46-01-420-001

- (1) Attach the door as follows:
 - (a) Move the flaps to the fully extended position.
 - (b) Put the door in its position.
 - (c) Install the bolts to attach the door to the hinge.
 - (d) Connect the electrical jumpers.
 - (e) Move the door from the closed to the fully open position.
 - 1) Make sure the hinge springs do not bind.
 - 2) Make sure the door moves easily.

E. Access and Service Door Installation

SUBTASK 53-46-01-420-002

- (1) Attach the door as follows:
 - (a) Engage the hinges of the door with the hinges on the fairing support.
 - (b) Install the bolts to connect the hinge assemblies.
 - (c) Connect the electrical jumpers across the hinge assemblies.
 - (d) Attach the folding strut to the fitting on the door.

SUBTASK 53-46-01-220-002

- (2) Do a check of the door flushness and clearance as follows:
 - (a) Close and latch the door.
 - (b) Measure the clearance and the flushness around the door.
 - 1) Make sure the clearance is as shown in (Figure 409).
 - 2) Make sure the flushness is within 0.04 inches maximum.

SUBTASK 53-46-01-200-001

- (3) Do a check of the latch engagement:
 - (a) Use clay to make an imprint of the latch engagement on each bearing plate.
 - (b) Make sure the engagement is more than shown in the figure for the door.

SUBTASK 53-46-01-200-002

- (4) Do a check of the latch free play:
 - (a) Move the door to the closed position.
 - (b) Lock the latch.
 - (c) Make sure it holds the door firmly latched.
 - 1) Make sure you do not need too much force to close the latch.
 - 2) Make sure the latch is not loose after you close it.
 - NOTE: The correct amount of free play is approximately 0.00 to 0.01 inch at the latch bumper.

SUBTASK 53-46-01-820-001

- (5) Adjust the latch free play as follows:
 - (a) Remove the lockwire.
 - (b) Loosen the lock nut.

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- (c) Adjust the bumper in or out as necessary.
- (d) Tighten the lock nut.
- (e) Install the lockwire, G01505.
- F. Heat Exchanger Door, High Pressure Connection Door and Low Pressure Connection Door Installation Rigging

SUBTASK 53-46-01-010-001

(1) Open the access door

SUBTASK 53-46-01-220-003

(2) Measure the stack-up.

NOTE: The stack-up is measured from the bottom of the fairing support structure to where the latch bumper touches the top of the structure.

SUBTASK 53-46-01-010-002

(3) Move the door latch to the locked position.

SUBTASK 53-46-01-820-002

(4) Set the clearance between the door panel and the latch bumper to 0.006 in. (0.152 mm) more than the clearance of the measured stack-up.

SUBTASK 53-46-01-410-001

- (5) Close the door:
 - (a) Un-lock the latch.
 - (b) Close the door
 - (c) Lock all latches.

NOTE: Too much latch closing force is an indication that the latch bumper to door panel clearance is too small. An off center measure can help find the thickest part of the stack-up.

- (d) If it is necessary to continue to use excessive force to close the latch:
 - 1) Add 0.001 in. (0.025 mm) more to the rigging measurement to a maximum of 0.004 in. (0.102 mm).

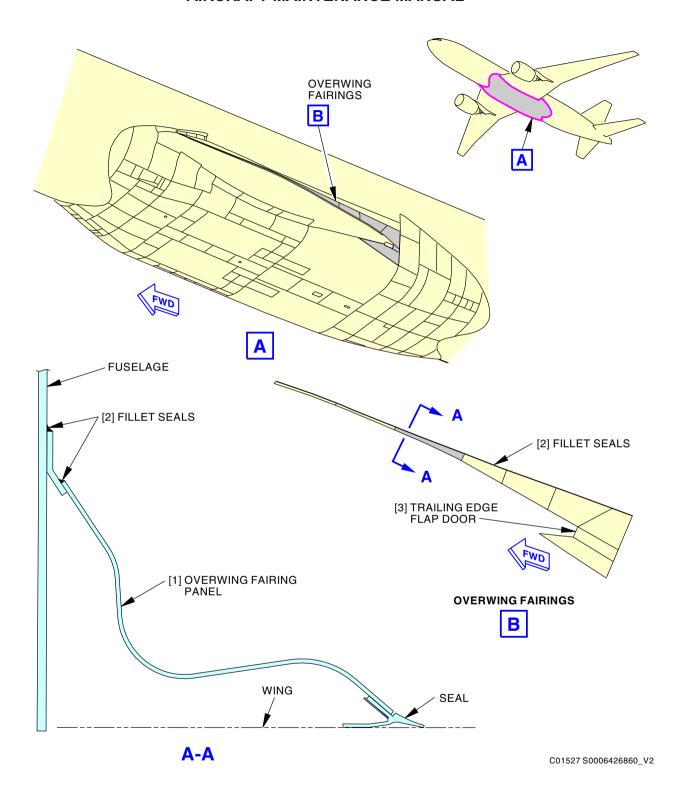
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Overwing Wing-to-Body Fairings Figure 401/53-46-01-990-801

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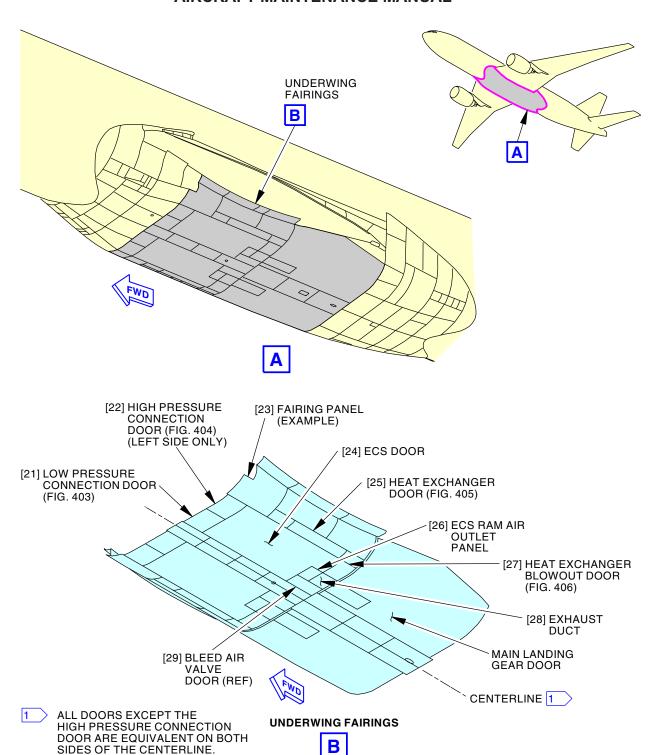
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Underwing Wing-to-Body Fairings Figure 402/53-46-01-990-802

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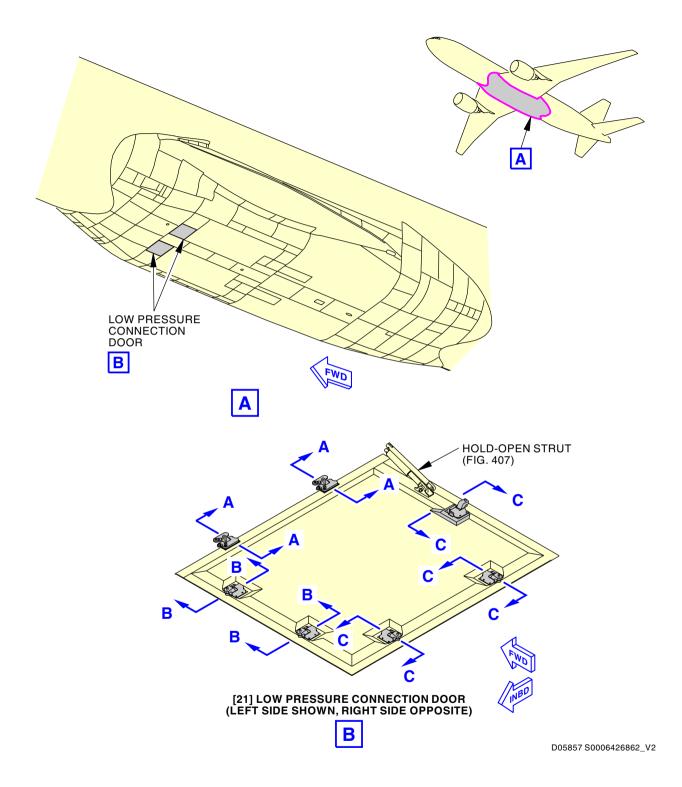
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Low Pressure Connect Door Installation Figure 403/53-46-01-990-803 (Sheet 1 of 2)

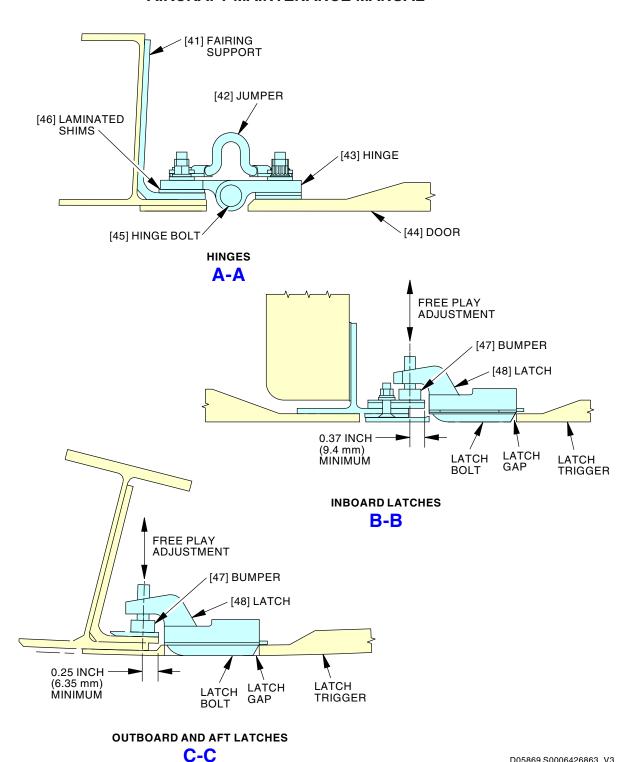
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Low Pressure Connect Door Installation Figure 403/53-46-01-990-803 (Sheet 2 of 2)

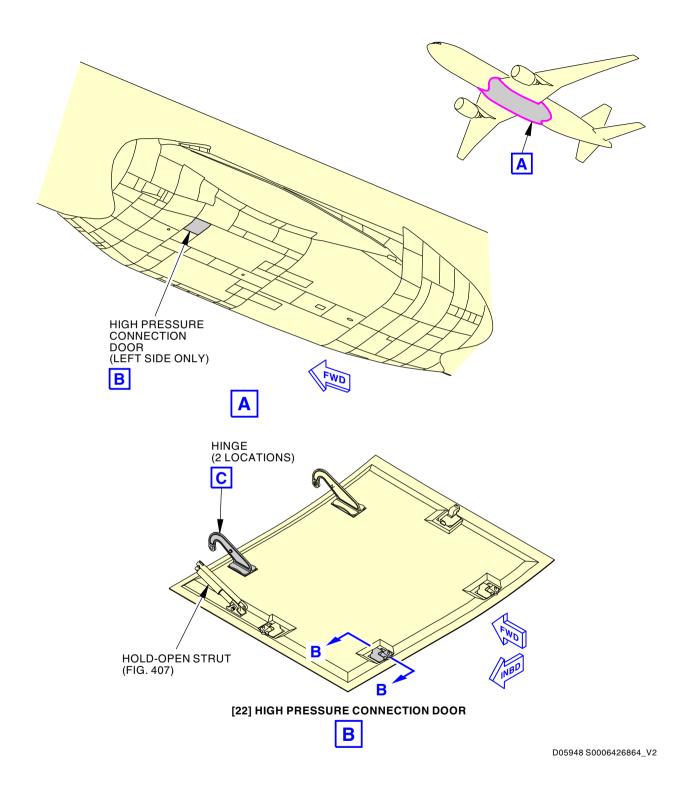
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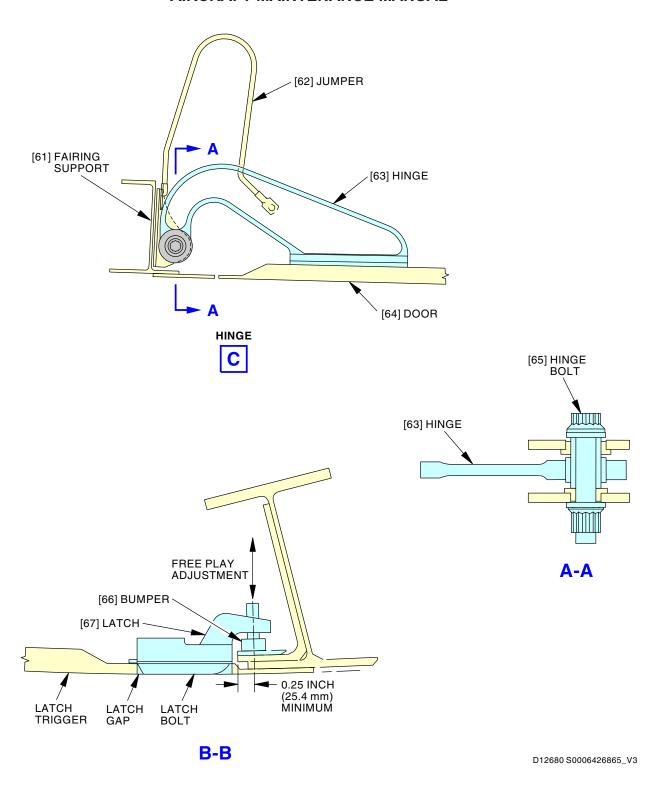
High Pressure Connect Door Installation Figure 404/53-46-01-990-804 (Sheet 1 of 2)

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High Pressure Connect Door Installation Figure 404/53-46-01-990-804 (Sheet 2 of 2)

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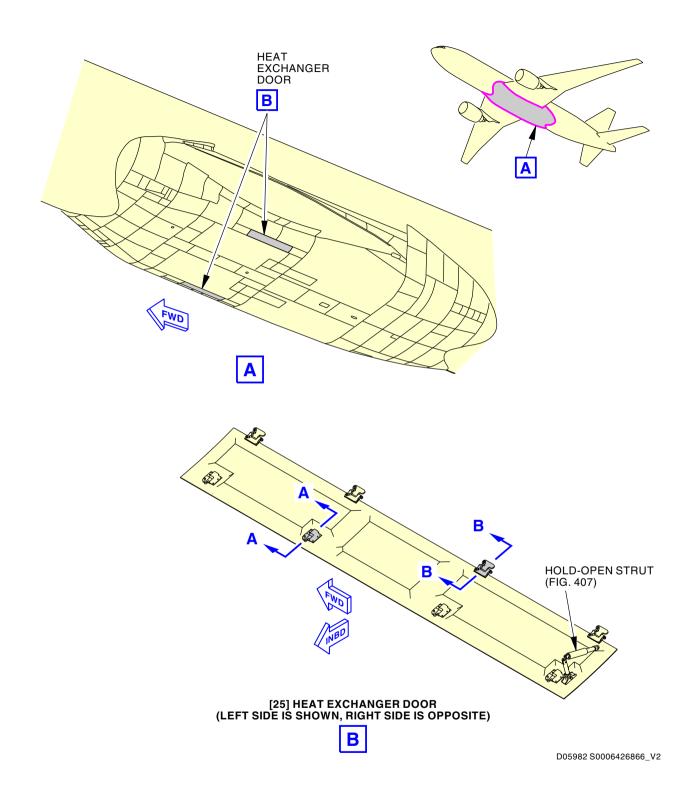
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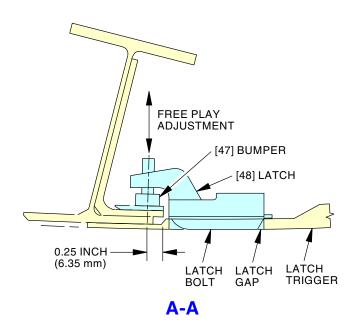
Heat Exchanger Door Installation Figure 405/53-46-01-990-805 (Sheet 1 of 2)

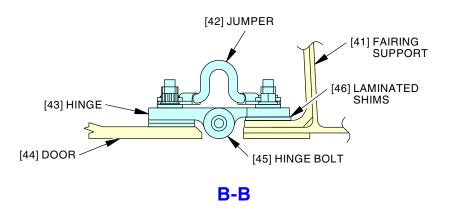
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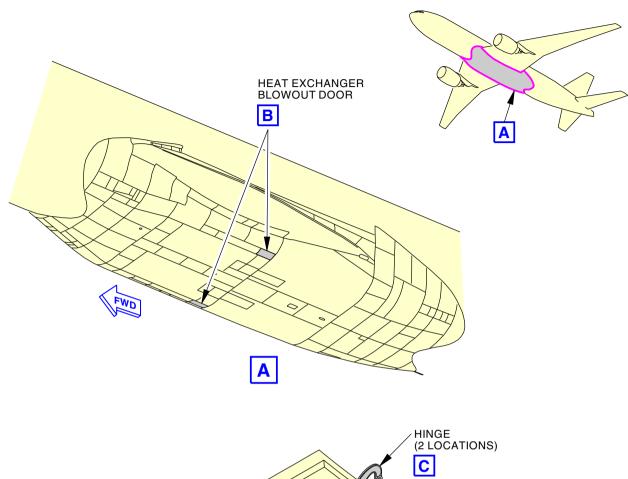
Heat Exchanger Door Installation Figure 405/53-46-01-990-805 (Sheet 2 of 2)

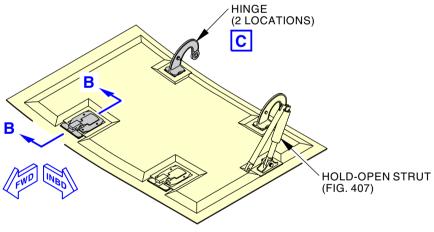


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[27] HEAT EXCHANGER BLOWOUT DOOR (LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

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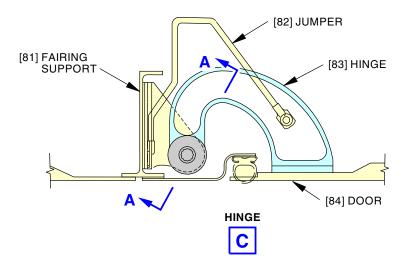
Heat Exchanger Blowout Door Installation Figure 406/53-46-01-990-806 (Sheet 1 of 2)

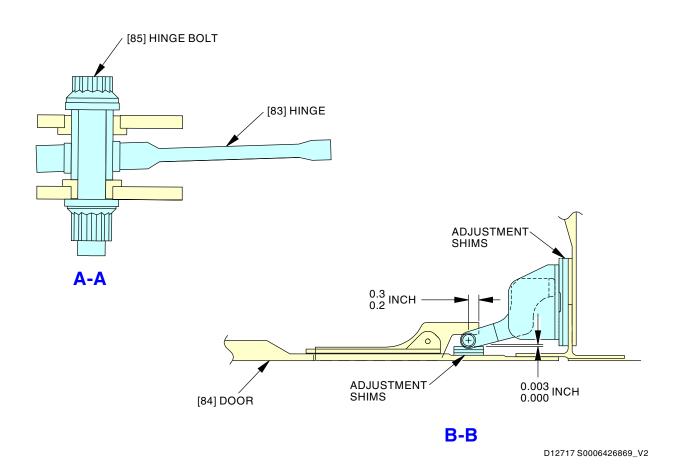
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Heat Exchanger Blowout Door Installation Figure 406/53-46-01-990-806 (Sheet 2 of 2)

EFFECTIVITY

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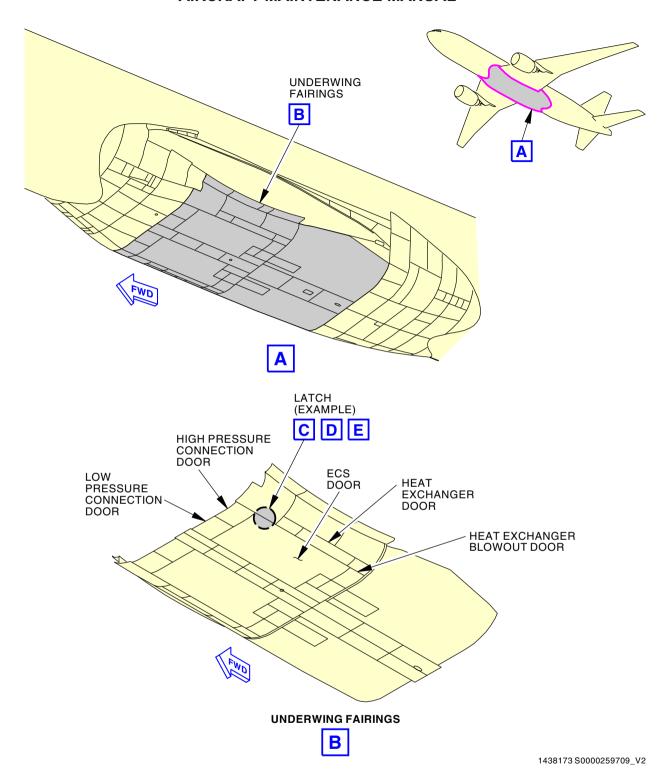
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Fairing Door Latch (Example)
Figure 407/53-46-01-990-809 (Sheet 1 of 2)

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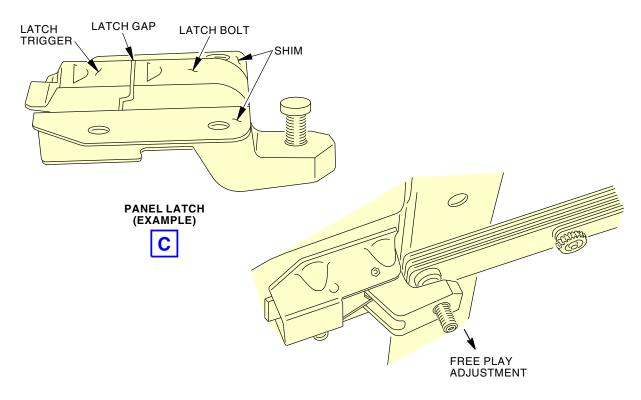
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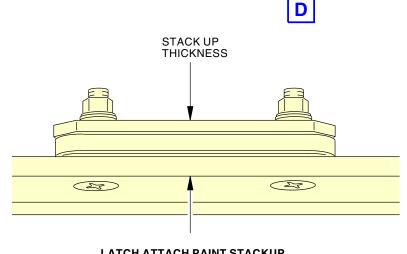
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LATCH FREE PLAY REMOVAL (EXAMPLE)



LATCH ATTACH PAINT STACKUP (EXAMPLE)



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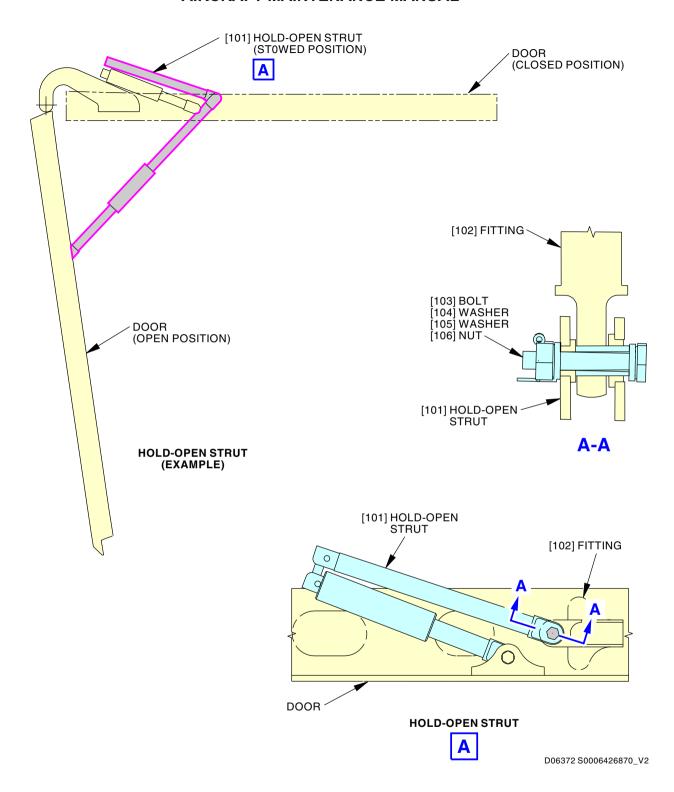
Fairing Door Latch (Example)
Figure 407/53-46-01-990-809 (Sheet 2 of 2)

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Hold-Open Strut Figure 408/53-46-01-990-807

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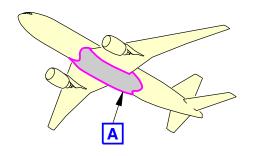
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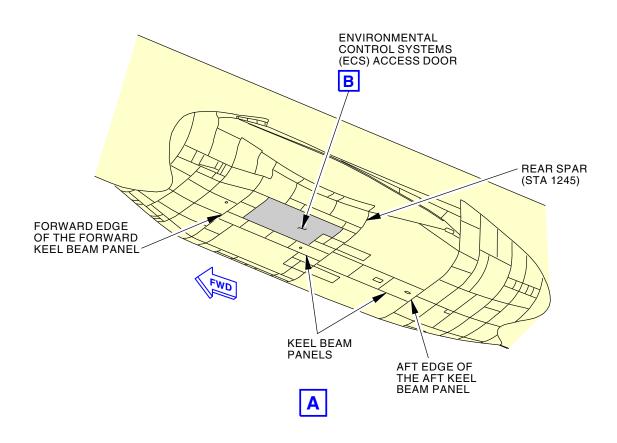
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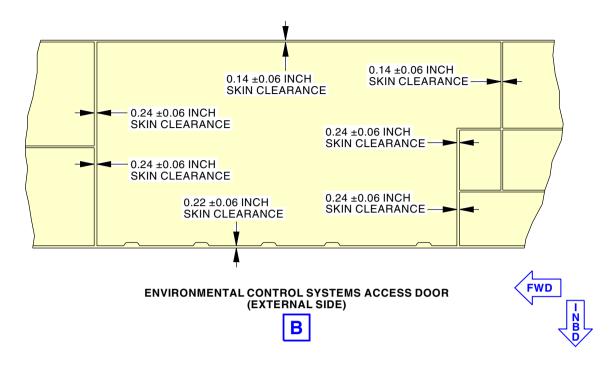
Fairing Clearance and Flushness Tolerances Figure 409/53-46-01-990-808 (Sheet 1 of 2)

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| TOLERANCES | PANEL/DOOR | EDGE LOCATION | TOLERANCE (INCH) |
|-------------------------|---------------------|--------------------------------------|---------------------|
| | ECS DOOR | FORWARD, AFT, INBOARD EDGES | (VIEW B) |
| CLEARANCE TOLERANCES | ECS DOOR | OUTBOARD (HINGE) EDGE | (VIEW B) |
| | KEEL BEAM | EDGES BETWEEN FORWARD AND AFT PANELS | 0.24 ±0.06 |
| | FORWARD KEEL BEAM | FORWARD EDGE | 0.19 ±0.06 |
| | AFT KEEL BEAM | AFT EDGE | 0.19 ±0.06 |
| | FAIRING PANELS | ALL EDGES BUT 1 | 0.14 ±0.06 |
| | ACCESS DOORS | ALL EDGES BUT 1 | 0.14 ±0.06 |
| FLUSHNESS TOLERANCES | FORWARD OF STA 1030 | ALL | 0.02 MAX |
| | AFT OF STA 1030 | ALL | 0.04 MAX |

1

FOR PANELS ADJACENT TO THE ECS DOOR, USE THE ECS DOOR TOLERANCE AT THE ADJACENT EDGE.

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Fairing Clearance and Flushness Tolerances Figure 409/53-46-01-990-808 (Sheet 2 of 2)

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FUSELAGE SECTION 44 - 3 BAY SATCOM ANTENNA ADAPTER PLATE- REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Removal of the adapter plate.
 - (2) Installation of the adapter plate.

TASK 53-61-51-000-802

2. Antenna Adapter Plate Removal

A. General



INSTALL A SAFETY HARNESS BEFORE YOU DO MAINTENANCE. IF YOU FALL, INJURIES WILL OCCUR.

(1) This task includes the steps to remove the adapter plate [1].

B. References

| Reference | Title |
|------------------|---|
| 23-15-23-000-802 | Top-Mounted High Gain Antenna (Broadband) Removal |
| | (P/B 401) |

C. Location Zones

| Zone | Area |
|------|--|
| 243 | Area Above Passenger Compartment Ceiling, Left - Section 44 |
| 244 | Area Above Passenger Compartment Ceiling, Right - Section 44 |

D. Prepare for the Removal

SUBTASK 53-61-51-000-001

 If necessary, do this task: Top-Mounted High Gain Antenna (Broadband) Removal, TASK 23-15-23-000-802.

E. Adapter Plate Removal

SUBTASK 53-61-51-000-002

(1) Remove the cotter pins [10].

SUBTASK 53-61-51-000-003

(2) Remove the bolts [6], nuts [9] and washer [7] washer [8] to disconnect the adapter plate [1] from the structure.

SUBTASK 53-61-51-000-004

ARO 001 PRE SB 777-53A0070

(3) Remove the screw [2], washers [3], and nut [4] and the ground strap from the adapter plate [1].

ARO 002-999; ARO 001 POST SB 777-53A0070

(4) Remove the nut [15], washer [14], washer [13], washer [12], and bolt [11], to disconnect the ground strap from the adapter plate [1].

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SUBTASK 53-61-51-000-005

(5) Remove the screws [5] that attach the adapter plate to the structure.

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SUBTASK 53-61-51-000-006

(6) Remove the adapter plate.

SUBTASK 53-61-51-800-001

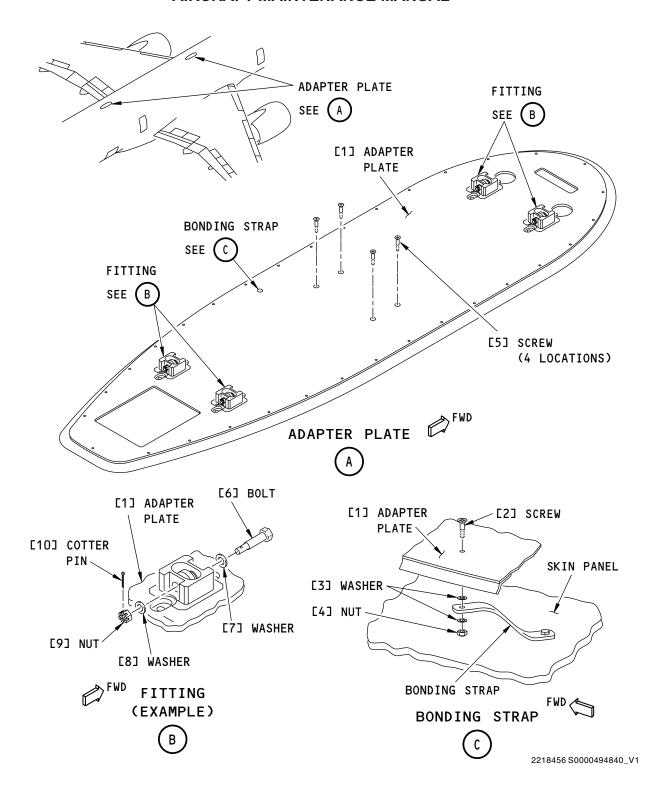
(7) Make sure that the adapter plate seal is not deformed when the adapter plate is not installed.

----- END OF TASK -----

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Satcom Antenna Adapter Plate Figure 401/53-61-51-990-802 (Sheet 1 of 2)

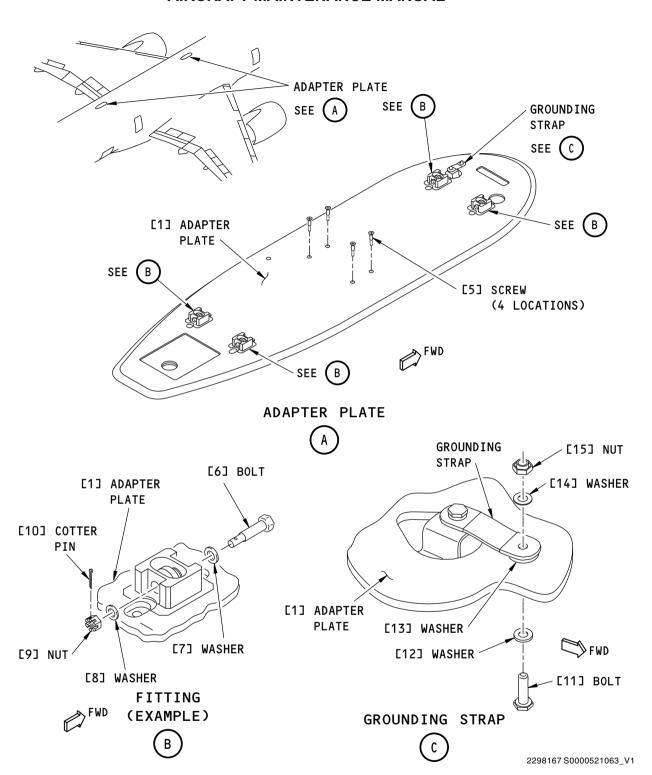
ARO 001 PRE SB 777-53A0070

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Satcom Antenna Adapter Plate Figure 401/53-61-51-990-802 (Sheet 2 of 2)

EFFECTIVITY ARO 002-999; ARO 001 POST SB 777-53A0070

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TASK 53-61-51-400-802

3. Antenna Adapter Plate 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 |
|-----------|---|
| COM-1550 | Bonding Meters - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). |
| | Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: T477W Supplier: 01014 Opt Part #: M1B Supplier: 3AD17 |

B. Consumable Materials

| Reference | Description | Specification |
|-----------|--|-----------------|
| A50296 | Sealant - Pressure And Environmental - Chromate Type | BMS5-95 Class C |
| B00184 | Solvent - Presealing, Cleaning Solvent | BMS11-7 |

C. Location Zones

| Zone | Area |
|------|--|
| 243 | Area Above Passenger Compartment Ceiling, Left - Section 44 |
| 244 | Area Above Passenger Compartment Ceiling, Right - Section 44 |

D. Adapter Plate Installation

SUBTASK 53-61-51-400-003



INSTALL A SAFETY HARNESS BEFORE YOU DO MAINTENANCE. IF YOU FALL, INJURIES WILL OCCUR.

(1) Make sure that the ground strap is installed on the skin panel.

SUBTASK 53-61-51-160-001

(2) Clean the mating surface of the adapter plate [1] and the skin panel with solvent, B00184.

SUBTASK 53-61-51-390-001

(3) Apply fay sealant, A50296 on the mating surfaces between the adapter plate and the fuselage surface.

SUBTASK 53-61-51-410-001

ARO 001 PRE SB 777-53A0070

- (4) Install the ground strap with the screw [2], washers [3] and nut [4] onto the adapter plate [1].
 - (a) Apply sealant, A50296 to cover the screw [2], washers [3], nut [4] and the ground strap.

ARO 002-999; ARO 001 POST SB 777-53A0070

(5) Install the ground strap with the bolt [11], washer [12], washer [13], washer [14], and nut [15], onto the adapter plate [1].

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ARO 002-999; ARO 001 POST SB 777-53A0070 (Continued)

(a) Apply sealant, A50296 to cover the bolt [11], washer [12], washer [13], washer [14], nut [15], and the ground strap.

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SUBTASK 53-61-51-400-004

- (6) Install the adapter plate on the fuselage.
 - (a) Apply sealant, A50296 to the screws [5] and install them with your fingers in the adapter plate.
 - (b) Install the bolts [6], washers [7], washers [8], nuts [9].
 - 1) Tighten nuts [9] to 125 in-lb (14 N·m)and install cotter pins [10].
 - (c) Tighten the fasteners [5] to 84 ±4 in-lb (9 ±1 N·m).

SUBTASK 53-61-51-700-001

- (7) Measure the resistance between the adapter plate and the fuselage with the intrinsically safe approved bonding meter, COM-1550.
 - (a) Make sure that the resistance between the adapter plate and the fuselage is less than 1 miliohm.



EFFECTIVITY 53-61-51



FUSELAGE SECTION 46 - 2 BAY SATCOM ANTENNA ADAPTER PLATE - REMOVAL/INSTALLATION

TASK 53-61-51-000-803

1. Satcom Antenna Adapter Plate Removal

A. Location Zones

| Zone | Area |
|------|--|
| 253 | Area Above Passenger Compartment Ceiling, Left - Section 46 |
| 254 | Area Above Passenger Compartment Ceiling, Right - Section 46 |

B. Prepare for the Removal

C. Adapter Plate Removal

SUBTASK 53-61-51-000-008

(1) Remove nut [4], washers [3], and screw [2] from the bonding strap and the adapter plate.

SUBTASK 53-61-51-000-009

(2) Remove the cotter pins [10], nuts [9], washers [7], washers [8] and bolts [6] that attach the adapter plate [1] to the structure.

SUBTASK 53-61-51-000-010

(3) Remove the screws [5] that attach the adapter plate [1] to the fuselage.

SUBTASK 53-61-51-000-011

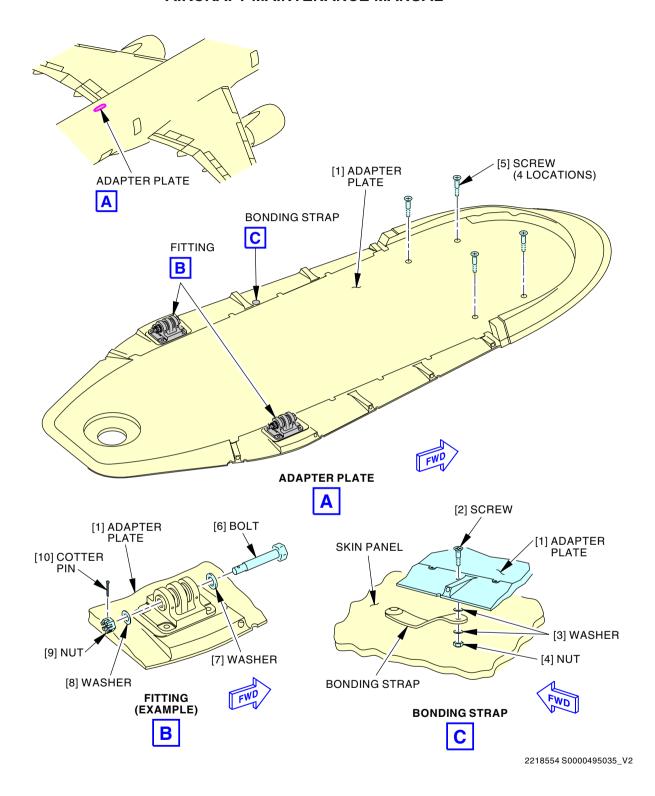
(4) Remove the adapter plate from the airplane.

——— END OF TASK ———

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2 Bay Antenna Adapter Plate Installation Figure 401/53-61-51-990-803

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TASK 53-61-51-400-803

2. Satcom Antenna Adapter Plate 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 |
|-----------|---|
| COM-1550 | Bonding Meters - Approved, Intrinsically Safe (Approved for use in |
| | Class I, Divisions I & II hazardous (classified) locations. Outside |
| | these hazardous locations, COM-614 can be used in lieu of |
| | COM-1550). |
| | Part #: 620LK Supplier: 1CRL2 |
| | Part #: M1 Supplier: 3AD17 |
| | Part #: T477W Supplier: 01014 |
| | Opt Part #: M1B Supplier: 3AD17 |

B. Consumable Materials

| Reference | Description | Specification |
|-----------|--|-----------------|
| A50296 | Sealant - Pressure And Environmental - Chromate Type | BMS5-95 Class C |
| B00184 | Solvent - Presealing, Cleaning Solvent | BMS11-7 |

C. Location Zones

| Zone | Area |
|------|--|
| 253 | Area Above Passenger Compartment Ceiling, Left - Section 46 |
| 254 | Area Above Passenger Compartment Ceiling, Right - Section 46 |

D. Prepare for the Installation

SUBTASK 53-61-51-160-002

- (1) Clean the adapter plate [1] and the fuselage mating surfaces with solvent, B00184
- (2) Make sure that the ground strap is installed on the skin panel.

E. Adapter Plate Installation

SUBTASK 53-61-51-390-002

- (1) Apply fay sealant, A50296 to the mating surface of the adapter plate [1] and the skin panel mating surfaces.
- (2) Position the adapter plate [1] on the fuselage.

SUBTASK 53-61-51-400-007

- (3) Apply sealant, A50296 to the screws [5] and partially install them with your fingers.
- (4) Install the bolts [6], washers [7], washers [8] and nuts [9], on the adapter plate.
- (5) Tighten the screws [5] to 84 ±4 in-lb (97 ±5 kg-cm).
- (6) Tighten the bolts [6], washers [7], washers [8], nuts [9] and install the cotter pins [10].

SUBTASK 53-61-51-400-008

- (7) Install the screw [2], washers [3] and nut [4] to attach the ground strap to the adapter plate
- (8) Tighten the nut [4] to 65 ±2 in-lb (75 ±2 kg-cm).
- (9) Seal the screw [2], washers [3], nut [4], and the ground strap with sealant, A50296.

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| SUBTASK | 53-61-51 | 1-200-001 |
|----------------|----------|-----------|
| | | |

| | END OF TASK |
|------|---|
| | milliohm with the intrinsically safe approved bonding meter, COM-1550. |
| (10) | Make sure that the resistance between the adapter plate and the skin panel is not more than 1 |

EFFECTIVITY ARO ALL

53-61-51



AFT WING TO BODY FAIRING PANEL - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Removal of the aft wing to body fairings.
 - (2) Installation of the aft wing to body fairings.
- B. These access doors and panels are in this procedure:
 - (1) Fairing panels.
 - (2) ADU pressure-relief panel.
 - (3) ADU filter access door.
 - (4) RAT service door.
 - (5) Access door for the main landing gear door release.
- C. These access doors are in different MM locations:
 - (1) ADU door.
 - (2) RAT door.

TASK 53-66-01-000-801

2. Aft Wing-To-Body Fairing Panel Removal

(Figure 401, Figure 402, Figure 403, Figure 404)

A. References

| Reference | Title | |
|------------------|-------------------------------|--|
| 51-31-01-160-801 | Prepare For Sealing (P/B 201) | |

B. Location Zones

| Zone | Area |
|------|----------------------------------|
| 197 | Aft Wing-to-Body Fairings, Left |
| 198 | Aft Wing-to-Body Fairings, Right |

C. Removal

SUBTASK 53-66-01-020-001

- (1) Remove a fairing panel as follows:
 - (a) If there is sealant on the edge of the panel, remove it (TASK 51-31-01-160-801).

NOTE: You can cut out a section of the fillet seal.

- (b) Remove the fasteners that hold the fairing panel.
- (c) Remove the fairing panel.

SUBTASK 53-66-01-020-002

- (2) Remove the ADU pressure-relief panel as follows:
 - (a) Open the ADU pressure-relief panel [6].
 - (b) Disconnect the two rod end assemblies [42] from their fittings [41].
 - (c) Disconnect the electrical jumpers [45] from the fuselage side of the hinge assemblies.
 - (d) Remove the hinge bolts [44] to disconnect the hinge assembly.
 - (e) Remove the panel assembly.

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SUBTASK 53-66-01-020-003

(3) Remove the Access and Service Doors

NOTE: The RAT Service door is the same as the ADU Filter Access door.

- (a) Open the door [61].
- (b) Disconnect the folding strut [67] from the fitting [68] on the door.
- (c) Disconnect the electrical jumpers [70] from the fuselage side of the hinge assemblies [66].
- (d) Remove the bolts from one side of the hinge assembly [66].
- (e) Remove the door assembly [61].



TASK 53-66-01-400-801

3. Aft Wing-To-Body Fairing Panel Installation

(Figure 401, Figure 402, Figure 403, Figure 404)

A. General

(1) This task installs the aft wing-to-body fairing panel.

B. References

| Reference | Title | |
|--------------|--------------------------|--|
| SRM 51-10-08 | Structural Repair Manual | |

C. Consumable Materials

| Reference | Description | Specification |
|-----------|--|-----------------------|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS5-95 |
| A02315 | Sealant - Low Density, Synthetic Rubber. 2 Part | BMS5-142 Type II |
| C00528 | Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film) | MIL-C-11796 Class III |
| C00767 | Coating - Anti-Static Coating | BMS10-21 Type III |
| C00915 | Compound - Organic Corrosion Inhibiting, Advanced | BMS3-29 |
| G02020 | Clay, Modeling | |

D. Location Zones

| Zone | Area |
|------|----------------------------------|
| 197 | Aft Wing-to-Body Fairings, Left |
| 198 | Aft Wing-to-Body Fairings, Right |

E. Panel Installation

SUBTASK 53-66-01-210-001

(1) Make sure the surface between the structure and the fairing panel is clean.

SUBTASK 53-66-01-210-002

(2) Make sure the area around each fastener hole and each fastener is very clean.

SUBTASK 53-66-01-620-001

(3) Apply corrosion inhibiting compound, C00915, to the skin below the fairing between stringers S-47R and S-47L.

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SUBTASK 53-66-01-980-001



DO NOT APPLY SEALANT BETWEEN THE FAIRING PANELS. SEALANT IN THE INCORRECT LOCATION CAN CAUSE STRUCTURAL DAMAGE TO THE FAIRING PANELS DURING FLIGHT.

(4) Put the fairing panel in its position.

SUBTASK 53-66-01-910-001

- (5) Make an electrical ground as follows:
 - (a) Find the fastener locations for the electrical grounding.

NOTE: The fastener locations that have an electrical ground have a black countersunk area. There are usually two fastener locations per panel.

- (b) Apply coating, C00767, to the composite part of each hole.
- (c) Let the coating, C00767, dry.
- (d) Install the fasteners without sealant.

SUBTASK 53-66-01-910-002

- (6) Install all the remaining fasteners.
 - (a) Apply a brush fillet seal to the fasteners between stringers S-47R and S-47L with sealant, A00247.
 - (b) Apply corrosion preventive compound, C00528 to fairing panel fastener holes that penetrate the skin.

SUBTASK 53-66-01-220-001

- (7) Do a check of the panel as follows:
 - (a) Measure the flushness and clearance around the panel.
 - 1) Make sure the flushness and clearance around the panel are within range:

| Panels | Maximum Flushness | Maximum Gap |
|----------------------------|-------------------|----------------|
| 149W3210-18 to 149W4210-28 | 0.08 inch | 0.14±0.06 inch |

SUBTASK 53-66-01-910-003

(8) Apply sealant, A02315 (or alternative sealant, A00247 B-1/2 Type 1) to make a fillet seal [21] where the fairing panel [22] touches the fuselage as shown in (Figure 402).

NOTE: This makes an aerodynamic and a weather seal.

SUBTASK 53-66-01-400-001

(9) See SRM 51-10-08 for missing fastener requirements in the wing to body fairing panels.

F. Pressure-Relief Panel Installation

SUBTASK 53-66-01-420-001

- (1) Attach the pressure-relief panel [6] as follows:
 - (a) Engage the hinges [46] of the door [6] with the hinges on the fairing support.
 - (b) Install the hinge bolts [44] to connect the hinges [46].
 - (c) Connect the electrical jumpers [45] across the hinges [46].
 - (d) Attach the end of the rod assembly [42] to the fitting [41].

SUBTASK 53-66-01-220-002

(2) Do a check of the panel as follows:

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- (a) Close the door [6].
- (b) Measure the clearance and the flushness around the door [6].
 - 1) Make sure the clearance is as shown in figure 403.
 - 2) Make sure the flushness is within 0.04 inches maximum.

G. Access and Service Door Installation

NOTE: The RAT Service door is equivalent to the ADU Filter Access door.

SUBTASK 53-66-01-420-002

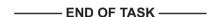
- (1) Attach the door [61] as follows:
 - (a) Engage the hinges [66] of the door [6] with the hinges [66] on the fairing support [69].
 - (b) Install the bolts to connect the hinges [66].
 - (c) Connect the electrical jumpers [70] across the hinges [66].
 - (d) Attach the folding strut [67] to the fitting [68] on the door [61].

SUBTASK 53-66-01-220-003

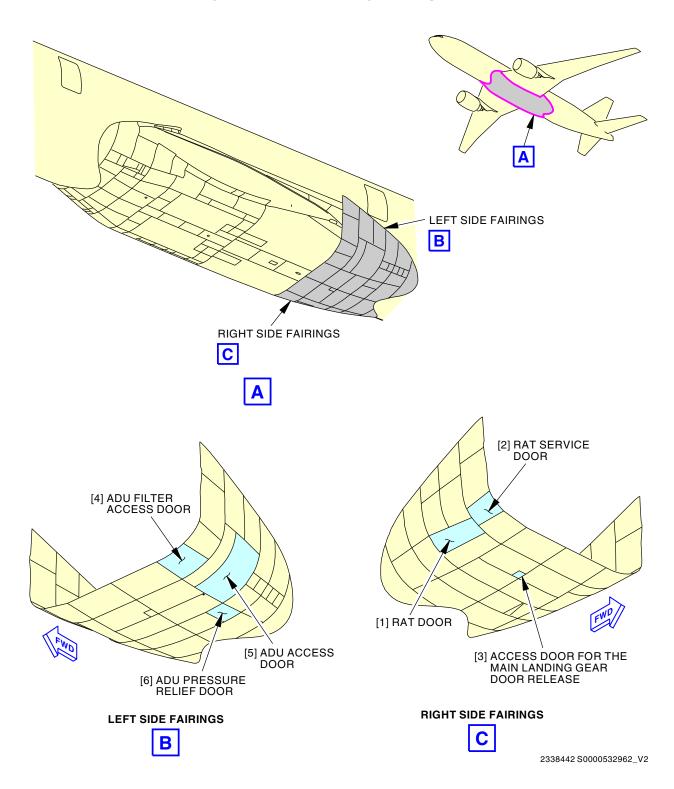
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- (2) Do a check of the door [61] as follows:
 - (a) Close and latch the door [61].
 - (b) Measure the clearance and the flushness around the door [61].
 - 1) Make sure the clearance is as shown in figure 404.
 - 2) Make sure the flushness is within 0.04 inch maximum.
 - (c) Use clay, G02020, to make an imprint of the latch engagement on each bearing block [64].
 - 1) Make sure the engagement is more than 0.35 inch.







Aft Wing-to-Body Fairing Figure 401/53-66-01-990-801

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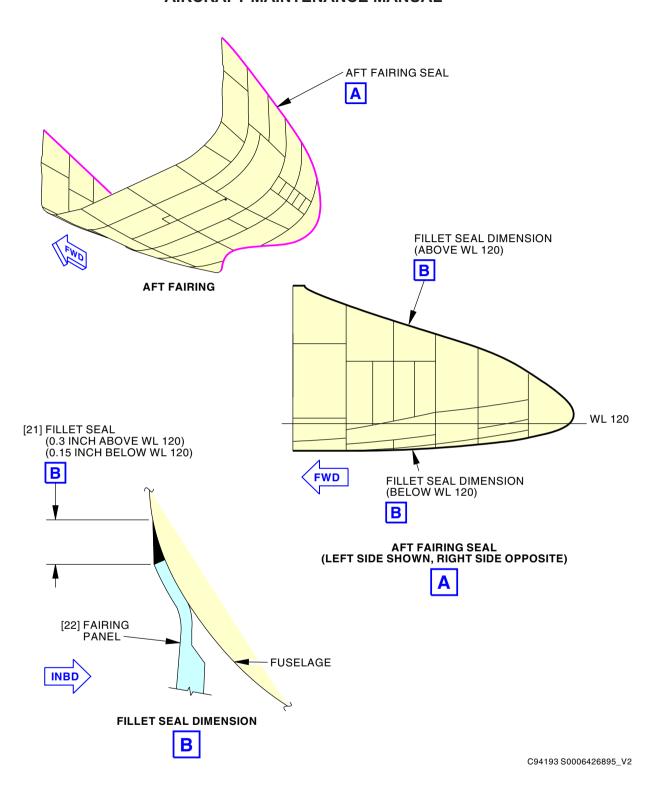
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Aft Fairing Aerodynamic/Weather Seal Installation Figure 402/53-66-01-990-802

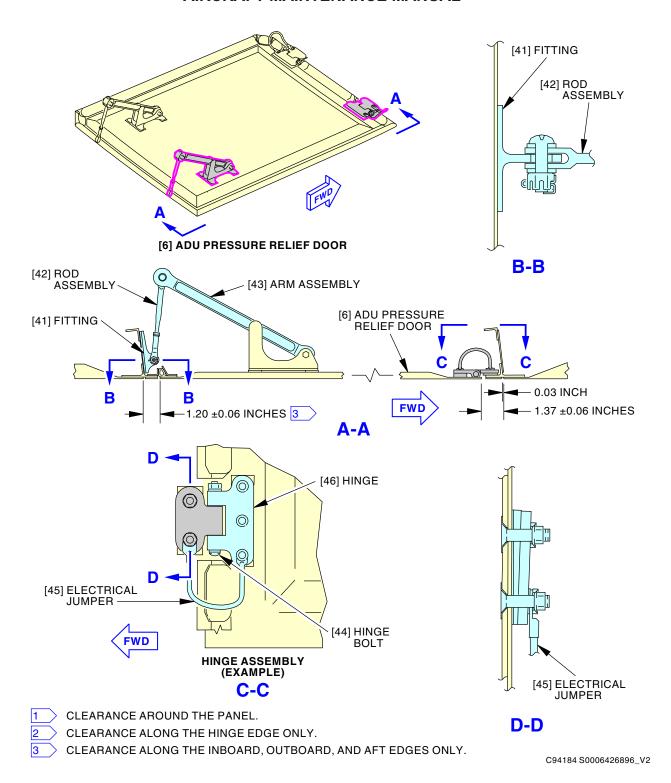
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ADU Pressure Relief Door Installation Figure 403/53-66-01-990-803

EFFECTIVITY

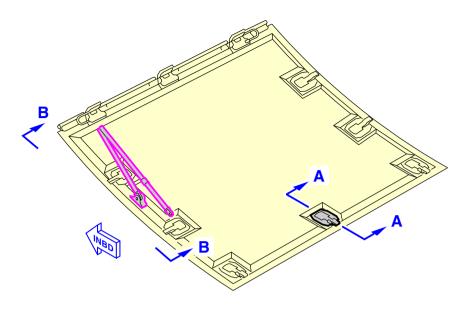
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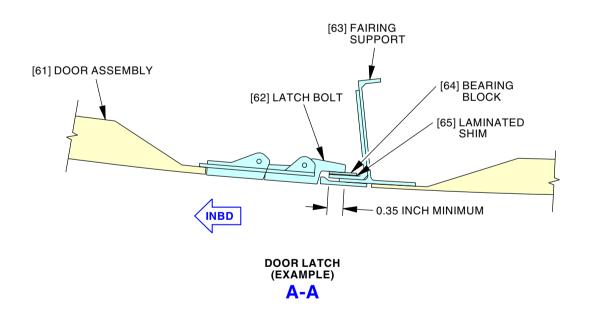
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ADU FILTER ACCESS DOOR AND RAT SERVICE DOOR



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ADU Filter Access Door and RAT Service Door Installation Figure 404/53-66-01-990-804 (Sheet 1 of 2)

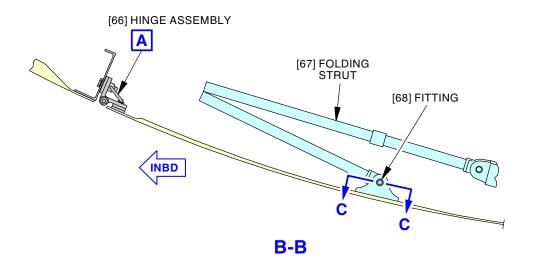
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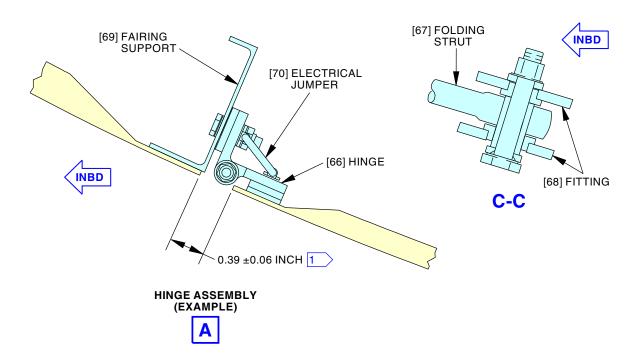
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CLEARANCE AROUND THE DOOR.

C93716 S0006426898_V2

ADU Filter Access Door and RAT Service Door Installation Figure 404/53-66-01-990-804 (Sheet 2 of 2)

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DORSAL FIN - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) Removal of the dorsal fin
 - (2) Installation of the dorsal fin.
- B. The dorsal fin is located at the forward root of the vertical tail.

TASK 53-76-01-000-801

2. Dorsal Fin Removal

(Figure 401)

A. Location Zones

| Zone | Area |
|------|--|
| 253 | Area Above Passenger Compartment Ceiling, Left - Section 46 |
| 254 | Area Above Passenger Compartment Ceiling, Right - Section 46 |
| 321 | Vertical Stabilizer Leading Edge |

B. Prepare to remove the dorsal fin.

SUBTASK 53-76-01-020-001

(1) Remove the applicable ceiling panels to get access to the dorsal fin bolt [2].

SUBTASK 53-76-01-020-002

(2) Remove the applicable insulation blankets.

C. Removal

SUBTASK 53-76-01-020-003

(1) Remove the five bolt [2], and the washer [3] that hold the dorsal fin assembly [1] to the fuselage.

SUBTASK 53-76-01-020-004

- (2) Remove the dorsal fin assembly [1] from the fuselage.
 - (a) Keep the shim [4] in their positions if it is possible.

----- END OF TASK -----

TASK 53-76-01-400-801

3. Dorsal Fin Installation

(Figure 401)

A. Location Zones

| Zone | Area |
|------|--|
| 253 | Area Above Passenger Compartment Ceiling, Left - Section 46 |
| 254 | Area Above Passenger Compartment Ceiling, Right - Section 46 |
| 321 | Vertical Stabilizer Leading Edge |

B. Installation

SUBTASK 53-76-01-820-001

- (1) Make sure the seal compression is correct as follows:
 - (a) Align the dorsal fin brackets with the bolt holes in the fuselage.
 - (b) Push the dorsal fin assembly [1] down until the brackets touch the fuselage.

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- (c) Make sure the seal [6] is compressed around the entire dorsal fin assembly [1] as shown in Figure 401.
 - 1) Loosen the fasteners [7] to adjust the seal retainer [5] and change the seal compression if it is necessary.

SUBTASK 53-76-01-820-002

- (2) Attach the dorsal fin assembly [1] as follows:
 - (a) Align the dorsal fin brackets with the bolt holes in the fuselage.
 - (b) From inside the airplane, install the five bolts [2] and washers [3] that hold the dorsal fin assembly [1] to the fuselage.

SUBTASK 53-76-01-820-003

- (3) Make sure the dorsal flushness is correct as follows:
 - (a) Measure the difference in height between the dorsal fin assembly [1] and the vertical stabilizer at BL=0 (dimension X, (Figure 401)).
 - (b) Make sure the difference in height (dimension X) is ± 0.05 inch.
 - (c) If the height is not correct, add or remove shim [4] at locations A and B to get the total shim thickness as shown in Figure 401.

SUBTASK 53-76-01-410-001

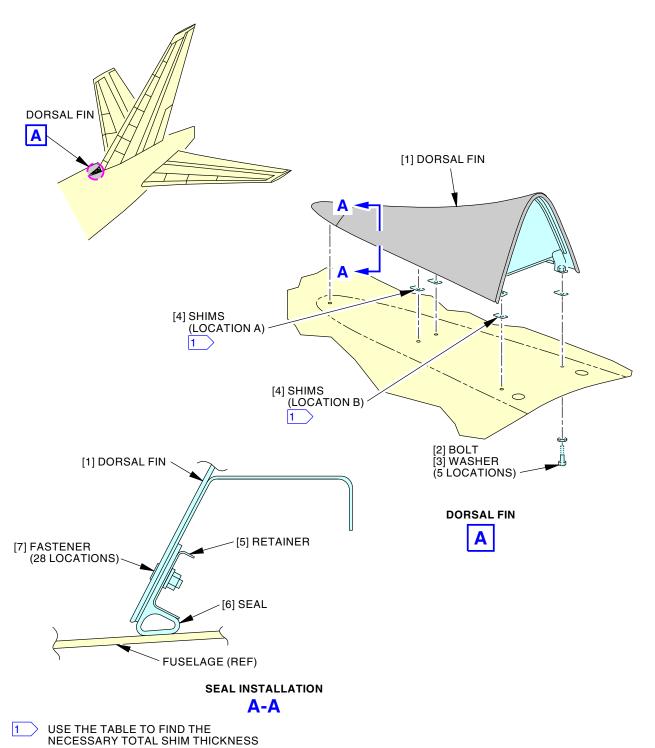
- (4) Put the airplane back in its usual condition.
 - (a) Install the insulation blankets that you removed.
 - (b) Install the ceiling panels that you removed.

----- END OF TASK -----

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Dorsal Fin Installation Figure 401/53-76-01-990-801 (Sheet 1 of 2)

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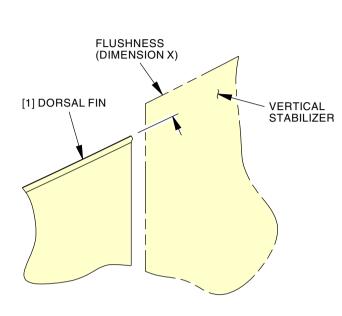
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DIMENSION X AT BL = 0

| DIMENSION X | LOCATION A | LOCATION B |
|----------------|------------|------------|
| 0.2499 | 0.1170 | 0.2250 |
| 0.2403 | 0.1140 | 0.2150 |
| 0.2211 | 0.1080 | 0.2060 |
| 0.2115 | 0.1050 | 0.1970 |
| 0.2019 | 0.0990 | 0.1880 |
| 0.1923 | 0.0960 | 0.1790 |
| 0.1826 | 0.0930 | 0.1700 |
| 0.1730 | 0.0870 | 0.1610 |
| 0.1634 | 0.0840 | 0.1520 |
| 0.1538 | 0.0780 | 0.1430 |
| 0.1442 | 0.0750 | 0.1340 |
| 0.1346 | 0.0690 | 0.1250 |
| 0.1250 | 0.0660 | 0.1170 |
| 0.1153 | 0.0600 | 0.1080 |
| 0.1057 | 0.0570 | 0.0990 |
| 0.0961 | 0.0510 | 0.0900 |
| 0.0865 | 0.0480 | 0.0810 |
| 0.0769 | 0.0420 | 0.0720 |
| 0.0673 | 0.0390 | 0.0630 |
| 0.0576 | 0.0330 | 0.0540 |
| 0.0480 | 0.0300 | 0.0450 |
| 0.0384 | 0.0240 | 0.0360 |
| 0.0288 | 0.0210 | 0.0270 |
| 0.0192 | 0.0180 | 0.0180 |
| 0.0096 | 0.0120 | 0.0090 |

NOTE:ALL DIMENSIONS ARE IN INCHES.

TOTAL SHIM THICKNESS TABLE

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Dorsal Fin Installation Figure 401/53-76-01-990-801 (Sheet 2 of 2)

ARO ALL

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