

CHAPTER

55

STABILIZERS



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

**CHAPTER 55
STABILIZERS**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
55-EFFECTIVE PAGES			55-05-03 (cont)			55-05-03 (cont)		
1 thru 3	Sep 15/2023		225	May 15/2023		261	May 15/2023	
4	BLANK		226	May 15/2023		262	May 15/2023	
55-CONTENTS			227	May 15/2023		263	May 15/2023	
1	May 15/2023		228	May 15/2023		264	May 15/2023	
2	May 15/2023		229	May 15/2023		265	May 15/2023	
3	May 15/2023		230	May 15/2023		266	May 15/2023	
4	May 15/2022		231	May 15/2023		267	May 15/2023	
5	May 15/2022		232	May 15/2023		268	May 15/2023	
6	BLANK		233	May 15/2023		269	May 15/2023	
55-00-01			234	May 15/2023		270	May 15/2023	
601	Sep 15/2021		235	May 15/2023		271	May 15/2023	
602	Sep 15/2021		236	May 15/2023		272	May 15/2023	
55-05-03			237	May 15/2023		273	May 15/2023	
201	Sep 15/2021		238	May 15/2023		274	May 15/2023	
202	Sep 15/2021		239	May 15/2023		275	May 15/2023	
203	Sep 15/2021		R 240	Sep 15/2023		276	May 15/2023	
204	Sep 15/2021		R 241	Sep 15/2023		277	May 15/2023	
205	Sep 15/2021		R 242	Sep 15/2023		278	May 15/2023	
206	May 15/2023		243	May 15/2023		279	May 15/2023	
207	May 15/2023		244	May 15/2023		280	May 15/2023	
208	May 15/2023		R 245	Sep 15/2023		281	May 15/2023	
209	May 15/2023		R 246	Sep 15/2023		282	May 15/2023	
210	May 15/2023		R 247	Sep 15/2023		283	May 15/2023	
211	May 15/2023		248	May 15/2023		284	May 15/2023	
212	May 15/2023		249	May 15/2023		285	May 15/2023	
213	May 15/2023		250	May 15/2023		286	May 15/2023	
214	May 15/2023		251	May 15/2023		287	May 15/2023	
215	May 15/2023		252	May 15/2023		288	May 15/2023	
216	May 15/2023		253	May 15/2023		289	May 15/2023	
217	May 15/2023		254	May 15/2023		290	May 15/2023	
218	May 15/2023		255	May 15/2023		291	May 15/2023	
219	May 15/2023		256	May 15/2023		292	May 15/2023	
220	May 15/2023		257	May 15/2023		293	May 15/2023	
221	May 15/2023		258	May 15/2023		294	May 15/2023	
222	May 15/2023		259	May 15/2023		295	May 15/2023	
223	May 15/2023		260	May 15/2023		296	May 15/2023	
224	May 15/2023							

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55-EFFECTIVE PAGES



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

CHAPTER 55
STABILIZERS

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
55-05-03 (cont)			55-10-00 (cont)			55-30-00 (cont)		
297	May 15/2023		204	Sep 15/2021		O 403	Sep 15/2023	
298	May 15/2023		205	Jan 15/2023		O 404	Sep 15/2023	
298.1	May 15/2023		206	Jan 15/2023		405	Sep 15/2021	
298.2	May 15/2023		55-10-00			406	Sep 15/2021	
298.3	May 15/2023		401	Sep 15/2021		407	Sep 15/2021	
298.4	May 15/2023		402	Sep 15/2021		408	May 15/2022	
298.5	May 15/2023		403	Sep 15/2021		409	Sep 15/2021	
298.6	May 15/2023		404	May 15/2023		410	Sep 15/2021	
298.7	May 15/2023		405	Sep 15/2021		411	Sep 15/2021	
298.8	May 15/2023		406	BLANK		412	May 15/2023	
298.9	May 15/2023		55-10-01			O 413	Sep 15/2023	
298.10	May 15/2023		801	Sep 15/2021		R 414	Sep 15/2023	
298.11	May 15/2023		802	BLANK		O 415	Sep 15/2023	
298.12	May 15/2023		55-10-10			R 416	Sep 15/2023	
298.13	May 15/2023		401	Sep 15/2021		A 417	Sep 15/2023	
298.14	May 15/2023		402	Sep 15/2021		A 418	BLANK	
298.15	May 15/2023		403	Sep 15/2021		55-30-00		
298.16	May 15/2023		404	Sep 15/2021		601	Sep 15/2021	
298.17	May 15/2023		405	Sep 15/2021		602	Sep 15/2021	
298.18	May 15/2023		406	Sep 15/2021		603	Sep 15/2021	
298.19	May 15/2023		407	Sep 15/2021		604	Sep 15/2021	
298.20	May 15/2023		408	Sep 15/2021		605	Sep 15/2021	
298.21	May 15/2023		409	Sep 15/2021		606	BLANK	
298.22	May 15/2023		410	BLANK		55-30-01		
298.23	May 15/2023		55-10-11			601	May 15/2023	
298.24	May 15/2023		401	Sep 15/2021		602	May 15/2023	
298.25	May 15/2023		402	Sep 15/2021		603	Sep 15/2021	
298.26	May 15/2023		403	Sep 15/2021		604	Sep 15/2021	
298.27	May 15/2023		404	Jan 15/2022		55-32-11		
298.28	May 15/2023		405	Jan 15/2022		401	Sep 15/2021	
298.29	May 15/2023		406	Jan 15/2022		402	Sep 15/2021	
298.30	BLANK		55-30-00			403	Jan 15/2022	
55-10-00			201	Sep 15/2021		404	Jan 15/2022	
201	Jan 15/2023		202	Sep 15/2021		405	Jan 15/2022	
202	Jan 15/2023		55-30-00			406	Sep 15/2022	
203	Jan 15/2023		401	May 15/2023		407	Sep 15/2021	
			R 402	Sep 15/2023		408	BLANK	

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

55-EFFECTIVE PAGES



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

CHAPTER 55
STABILIZERS

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
55-33-11								
401	Sep 15/2021							
402	May 15/2022							
403	May 15/2022							
404	Sep 15/2021							
405	May 15/2022							
406	Jan 15/2023							
407	Jan 15/2023							
408	Jan 15/2023							
R 409	Sep 15/2023							
O 410	Sep 15/2023							
55-33-21								
401	Jan 15/2023							
402	Sep 15/2021							
403	Sep 15/2021							
404	Jan 15/2023							
405	Jan 15/2023							
406	Jan 15/2023							
55-33-31								
401	Sep 15/2021							
402	Sep 15/2021							
403	Sep 15/2021							
404	Sep 15/2021							
405	Sep 15/2021							
406	BLANK							
55-35-01								
801	Sep 15/2021							
802	Sep 15/2021							
803	Sep 15/2021							
804	Sep 15/2022							
805	Sep 15/2021							
806	Sep 15/2021							
807	Sep 15/2021							
808	Sep 15/2021							

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

55-EFFECTIVE PAGES



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

CHAPTER 55
STABILIZERS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>RUDDER AND HORIZONTAL STABILIZERS - INSPECTION/CHECK</u>	55-00-01		601	SIA ALL
Examine the Composite Flight Controls TASK 55-00-01-200-801			601	SIA ALL
<u>STABILIZER - STRUCTURAL INSPECTIONS - MAINTENANCE PRACTICES</u>	55-05-03		201	SIA ALL
INTERNAL - GENERAL VISUAL: HORIZONTAL STABILIZER CENTER SECTION TASK 55-05-03-210-801			201	SIA ALL
INTERNAL - GENERAL VISUAL: STABILIZER TORSION BOX COMPARTMENT TASK 55-05-03-210-802			203	SIA ALL
INTERNAL - GENERAL VISUAL: VERTICAL FIN LEADING EDGE TASK 55-05-03-210-803			206	SIA ALL
INTERNAL - GENERAL VISUAL: VERTICAL FIN TASK 55-05-03-210-804			211	SIA ALL
INTERNAL - GENERAL VISUAL: VERTICAL FIN TRAILING EDGE TASK 55-05-03-210-805			217	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT HORIZONTAL STABILIZER LEADING EDGE TASK 55-05-03-210-806			220	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER LEADING EDGE TASK 55-05-03-210-807			228	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT HORIZONTAL STABILIZER LEADING EDGE TASK 55-05-03-210-808			236	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER LEADING EDGE TASK 55-05-03-210-809			238	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT HORIZONTAL STABILIZER TASK 55-05-03-210-810			240	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER TASK 55-05-03-210-811			245	SIA ALL

55-CONTENTS



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

CHAPTER 55
STABILIZERS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
INTERNAL - GENERAL VISUAL: LEFT HORIZONTAL STABILIZER TRAILING EDGE AND ELEVATOR TAB LEADING EDGE TASK 55-05-03-210-812			250	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER TRAILING EDGE AND ELEVATOR TAB LEADING EDGE TASK 55-05-03-210-813			264	SIA ALL
INTERNAL - DETAILED: LEFT ELEVATOR TAB SUPT FTGS ON FRONT SPAR AND TAB SPAR AT LEADING EDGE TASK 55-05-03-211-801			278	SIA ALL
INTERNAL - DETAILED: RIGHT ELEVATOR TAB SUPT FTGS ON FRONT SPAR AND TAB SPAR AT LEADING EDGE TASK 55-05-03-211-802			283	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT HORIZONTAL STABILIZER TRAILING EDGE TASK 55-05-03-210-814			288	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER TRAILING EDGE TASK 55-05-03-210-815			292	SIA ALL
INTERNAL - DETAILED: INTERNAL - LEFT ELEVATOR TAB HINGE FITTING TASK 55-05-03-211-803			296	SIA ALL
INTERNAL - DETAILED: INTERNAL - RIGHT ELEVATOR TAB HINGE FITTING TASK 55-05-03-211-804			298	SIA ALL
INTERNAL - GENERAL VISUAL: RUDDER, ELEVATOR AND ELEVATOR TAB ATTACH FITTINGS TASK 55-05-03-210-816			298.2	SIA ALL
INTERNAL - DETAILED: LEFT ELEVATOR HINGE, ACTUATOR, AND TAB MAST ARM FTGS AND BALANCE WT SUPPT STRUC TASK 55-05-03-211-805			298.10	SIA ALL
INTERNAL - DETAILED: RIGHT ELEVATOR HINGE, ACTUATOR, AND TAB MAST ARM FTGS AND BALANCE WT SUPPT STRUCT TASK 55-05-03-211-806			298.18	SIA ALL

55-CONTENTS



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

CHAPTER 55
STABILIZERS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
INTERNAL - SPECIAL DETAILED: LEFT HORIZONTAL STABILIZER TRAILING EDGE TASK 55-05-03-290-801			298.26	SIA ALL
INTERNAL - SPECIAL DETAILED: RIGHT HORIZONTAL STABILIZER TRAILING EDGE TASK 55-05-03-290-802			298.28	SIA ALL
<u>HORIZONTAL STABILIZER TIP - REMOVAL/INSTALLATION</u>	55-10-00		401	SIA ALL
Horizontal Stabilizer Tip - Removal TASK 55-10-00-000-801			401	SIA ALL
Horizontal Stabilizer Tip - Installation TASK 55-10-00-400-801			404	SIA ALL
<u>HORIZONTAL STABILIZER - MAINTENANCE PRACTICES</u>	55-10-00		201	SIA ALL
Horizontal Stabilizer - Corrosion Prevention TASK 55-10-00-910-801			201	SIA ALL
Guidelines for Missing Fasteners in the Leading Edge Access Panels TASK 55-10-00-200-801			206	SIA ALL
<u>HORIZONTAL STABILIZER CONDUCTIVE STRIP - REPAIRS</u>	55-10-01		801	SIA ALL
Horizontal Stabilizer Conductive Strip Repair TASK 55-10-01-300-801			801	SIA ALL
<u>THRUST BRACE LINKS - REMOVAL/INSTALLATION</u>	55-10-10		401	SIA ALL
Thrust Brace Links Removal TASK 55-10-10-000-801			401	SIA ALL
Thrust Brace Link Installation TASK 55-10-10-400-801			407	SIA ALL
<u>BALANCE BAY PANELS - REMOVAL/INSTALLATION</u>	55-10-11		401	SIA ALL
Balance Bay Panels - Removal TASK 55-10-11-000-801			401	SIA ALL
Balance Bay Panels - Installation TASK 55-10-11-400-801			404	SIA ALL

55-CONTENTS



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

CHAPTER 55
STABILIZERS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>VERTICAL STABILIZER (FIN) - CORROSION PREVENTION</u>	55-30-00		201	SIA ALL
Vertical Stabilizer (Fin) - Corrosion Prevention TASK 55-30-00-910-801			201	SIA ALL
<u>VERTICAL STABILIZER (FIN) - REMOVAL/INSTALLATION</u>	55-30-00		401	SIA ALL
Vertical Stabilizer (Fin) Removal TASK 55-30-00-000-801			401	SIA ALL
Vertical Stabilizer (Fin) - Installation TASK 55-30-00-400-801			412	SIA ALL
<u>VERTICAL STABILIZER (FIN) - INSPECTION/CHECK</u>	55-30-00		601	SIA ALL
Vertical Stabilizer (Fin) Inspection TASK 55-30-00-200-801			601	SIA ALL
<u>VERTICAL FIN LUG SEALING - INSPECTION/CHECK</u>	55-30-01		601	SIA ALL
Vertical Fin Sealing Inspection TASK 55-30-01-200-801			601	SIA ALL
<u>DORSAL FIN - REMOVAL/INSTALLATION</u>	55-32-11		401	SIA ALL
Dorsal Fin Removal TASK 55-32-11-000-801			401	SIA ALL
Dorsal Fin Installation TASK 55-32-11-400-801			406	SIA ALL
<u>VERTICAL STABILIZER (FIN) LEADING EDGE - REMOVAL/INSTALLATION</u>	55-33-11		401	SIA ALL
Vertical Stabilizer (Fin) Leading Edge Removal TASK 55-33-11-000-801			401	SIA ALL
Vertical Stabilizer (Fin) Leading Edge Installation TASK 55-33-11-400-801			406	SIA ALL
<u>VERTICAL STABILIZER (FIN) TIP - REMOVAL/INSTALLATION</u>	55-33-21		401	SIA ALL
Vertical Stabilizer (Fin) Tip Removal TASK 55-33-21-000-801			401	SIA ALL
Vertical Stabilizer (Fin) Tip Installation TASK 55-33-21-400-801			404	SIA ALL

55-CONTENTS



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

CHAPTER 55
STABILIZERS

<u>SUBJECT</u>	<u>CHAPTER SECTION SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>VERTICAL STABILIZER (FIN) TRAILING EDGE PANELS - REMOVAL/INSTALLATION</u>	55-33-31		401	SIA ALL
Vertical Stabilizer (Fin) Trailing Edge Panels Removal TASK 55-33-31-000-801			401	SIA ALL
Vertical Stabilizer (Fin) Trailing Edge Panels Installation TASK 55-33-31-400-801			404	SIA ALL
<u>VERTICAL STABILIZER HF ANTENNA LEADING EDGE PANEL - REPAIRS</u>	55-35-01		801	SIA ALL
HF Antenna Fiberglass Panel Leading Edge Panel No. 4 - Inspection TASK 55-35-01-200-801			801	SIA ALL
Leading Edge Finish - Installation TASK 55-35-01-400-801			804	SIA ALL
Polyurethane Protective Tape (PPT) - Installation TASK 55-35-01-400-802			806	SIA ALL

55-CONTENTS



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

RUDDER AND HORIZONTAL STABILIZERS - INSPECTION/CHECK

1. General

- A. This procedure has this task:
- (1) Examine the composite flight controls.

TASK 55-00-01-200-801

2. Examine the Composite Flight Controls

A. **General**

- (1) This task gives instructions to do a visual inspection of the internal area of the rudder and the horizontal stabilizers.
- (2) Use the equipment listed below to examine the composite flight controls:
 - (a) Flexible Video Borescope with (4) four way articulation, .5 inch (12mm) diameter X 10 feet (3m) long insertion tube with forward and side viewing optical tip adapters.
 - (b) Flexible Fiber-optic Borescope with (4) four way articulation, .35 inch (8mm) diameter X 3 feet (1m) long insertion tube with forward and side viewing optical tip adapters.
 - (c) Flexible or rigid guide tube - Dekoron is a trade mark for a formable type metal cored tubing.

B. **Location Zones**

Zone	Area
320	Subzone - Vertical Fin and Rudder
330	Subzone - Left Horizontal Stabilizer and Elevator
340	Subzone - Right Horizontal Stabilizer and Elevator

C. **Procedure**

SUBTASK 55-00-01-010-001

- (1) Remove the access panels that are necessary.

SUBTASK 55-00-01-290-001

- (2) Put the borescope tube into an access hole that is 2 inches in diameter.

SUBTASK 55-00-01-290-002

- (3) Move the borescope tube until you can see an area where an inspection is necessary.

NOTE: If you cannot move the optical tip into the correct areas, use a guide tube.

SUBTASK 55-00-01-290-003

- (4) Examine the area for these unsatisfactory conditions:

NOTE: Do not move the borescope tube while you examine an area.

- (a) Signs of deterioration.
- (b) Bulges and cracks on the skins and the ribs.
- (c) Corrosion on the fasteners.
- (d) Other signs of the stress.

SUBTASK 55-00-01-970-001

- (5) Make a record of all the unsatisfactory conditions before you move the borescope to a different area.

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55-00-01

Page 601
Sep 15/2021



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

SUBTASK 55-00-01-410-001

(6) Install the access panels.

————— **END OF TASK** —————

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55-00-01

Page 602
Sep 15/2021



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

STABILIZER - STRUCTURAL INSPECTIONS - MAINTENANCE PRACTICES

TASK 55-05-03-210-801

1. INTERNAL - GENERAL VISUAL: HORIZONTAL STABILIZER CENTER SECTION

(Figure 201)

NOTE: This procedure is a scheduled maintenance task.

A. References

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

B. Location Zones

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

C. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door

D. Inspection

SUBTASK 55-05-03-010-001

- (1) Open this access panel:

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

SUBTASK 55-05-03-210-001

- (2) Do a General Visual inspection of the horizontal stabilizer center section jackscrew fitting.

SUBTASK 55-05-03-910-001

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

SUBTASK 55-05-03-410-001

- (4) Close this access panel:

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

———— **END OF TASK** ————

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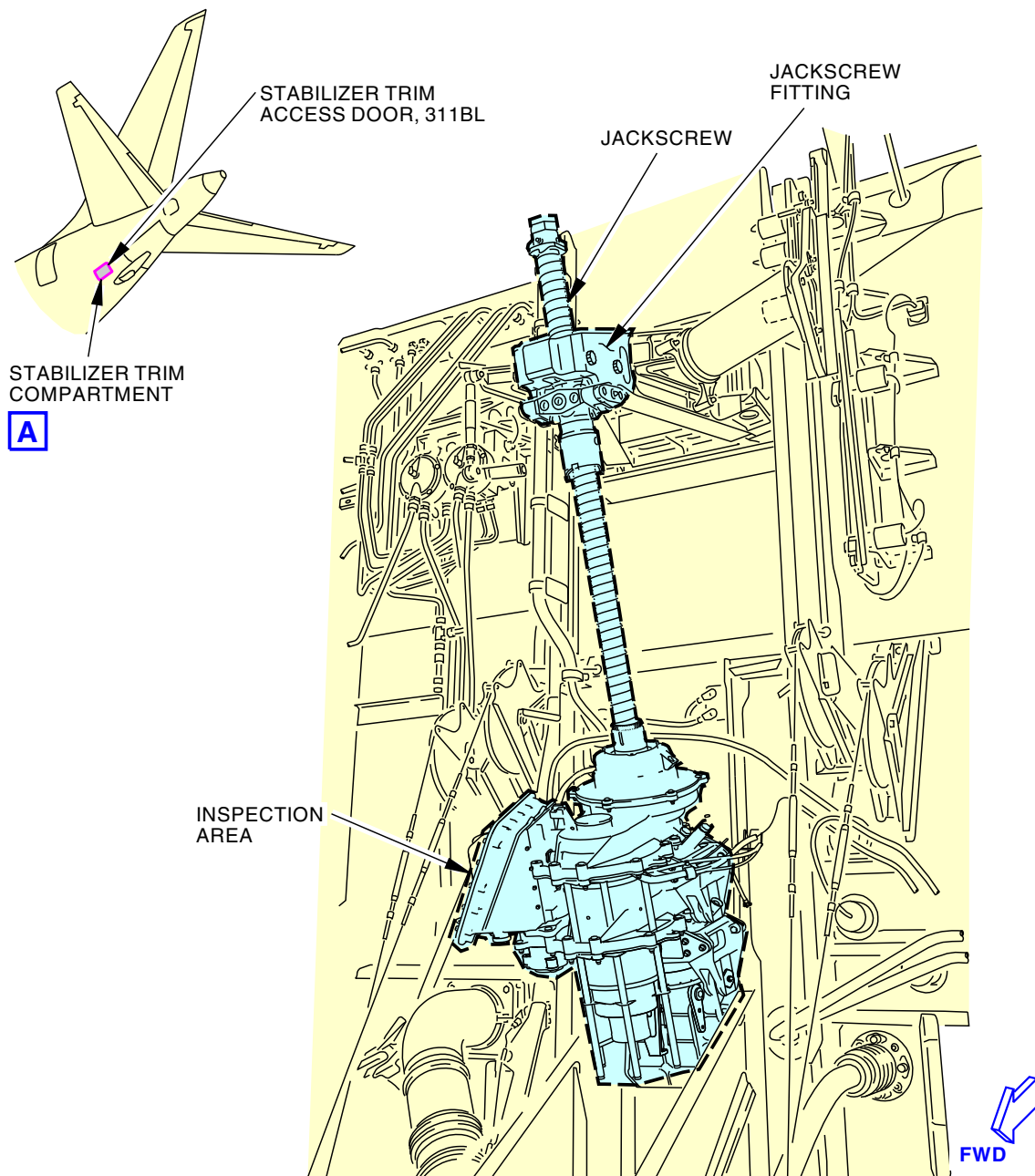
ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 201
Sep 15/2021



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



STABILIZER TRIM COMPARTMENT

A

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INTERNAL-GENERAL VISUAL: HORIZONTAL STABILIZER CENTER SECTION
Figure 201/55-05-03-990-801

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55-05-03

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 202
Sep 15/2021



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

TASK 55-05-03-210-802

2. INTERNAL - GENERAL VISUAL: STABILIZER TORSION BOX COMPARTMENT

(Figure 202)

NOTE: This procedure is a scheduled maintenance task.

A. References

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

B. Location Zones

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

C. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door
S3102	Stabilizer Torsion Box Compartment Inspection

D. Inspection

SUBTASK 55-05-03-010-002

- (1) Open this access panel:

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

Special Access:

<u>Number</u>	<u>Name/Location</u>
S3102	Stabilizer Torsion Box Compartment Inspection

NOTE: Adjust stabilizer trim as required. Remove gap seal and rear spar sliding seal to inspect pivot fittings.

SUBTASK 55-05-03-210-002

- (2) Do a General Visual inspection of the horizontal stabilizer center section front spar, rear spar, pivot fittings, and primary and secondary thrust beams.

SUBTASK 55-05-03-910-002

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

SUBTASK 55-05-03-410-002

- (4) Close this access panel:

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

————— **END OF TASK** —————

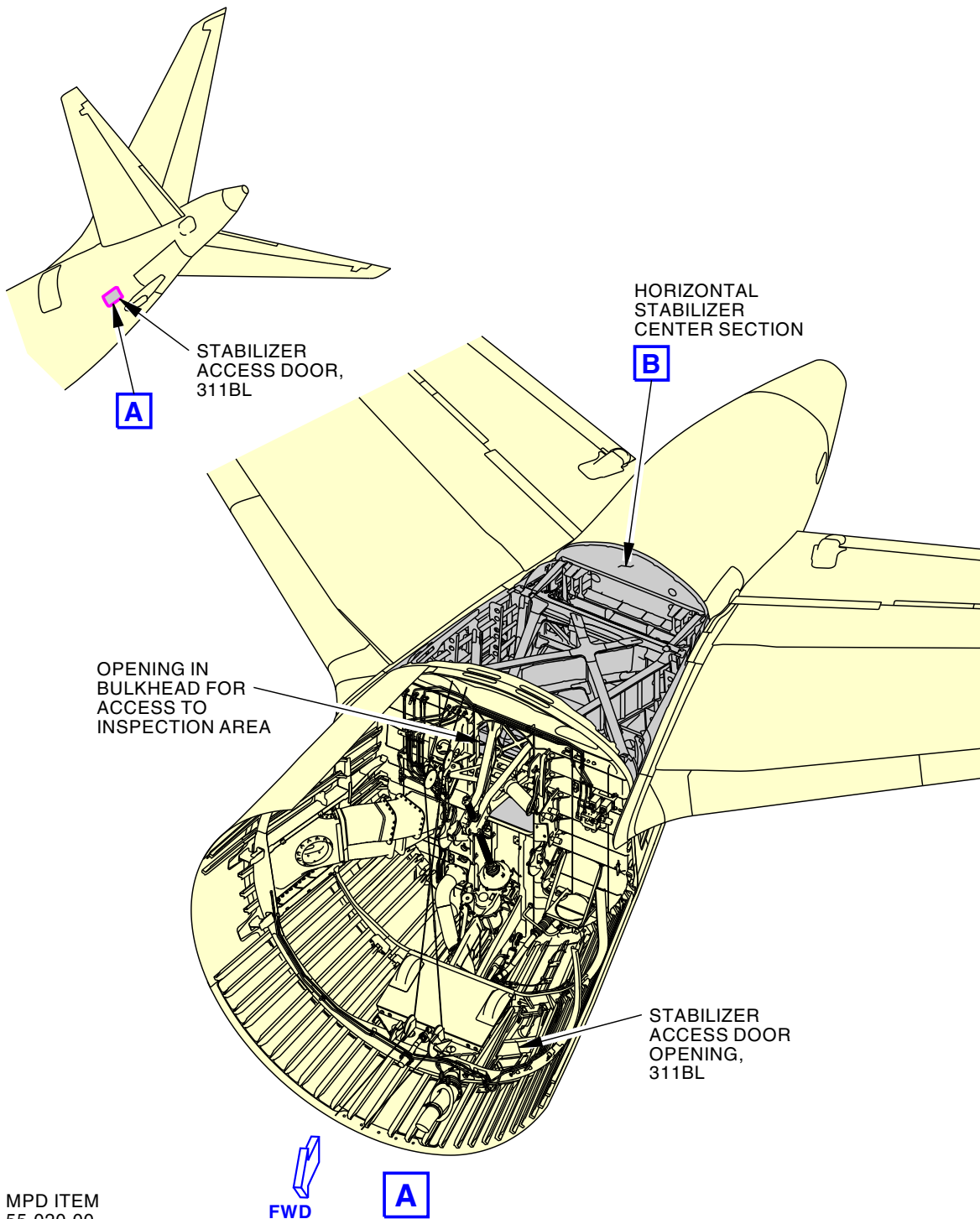
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 203
Sep 15/2021



MPD ITEM
55-020-00

2416320 S00061540438_V1

INTERNAL-GENERAL VISUAL: STABILIZER TORSION BOX COMPARTMENT
Figure 202/55-05-03-990-802 (Sheet 1 of 2)

EFFECTIVITY
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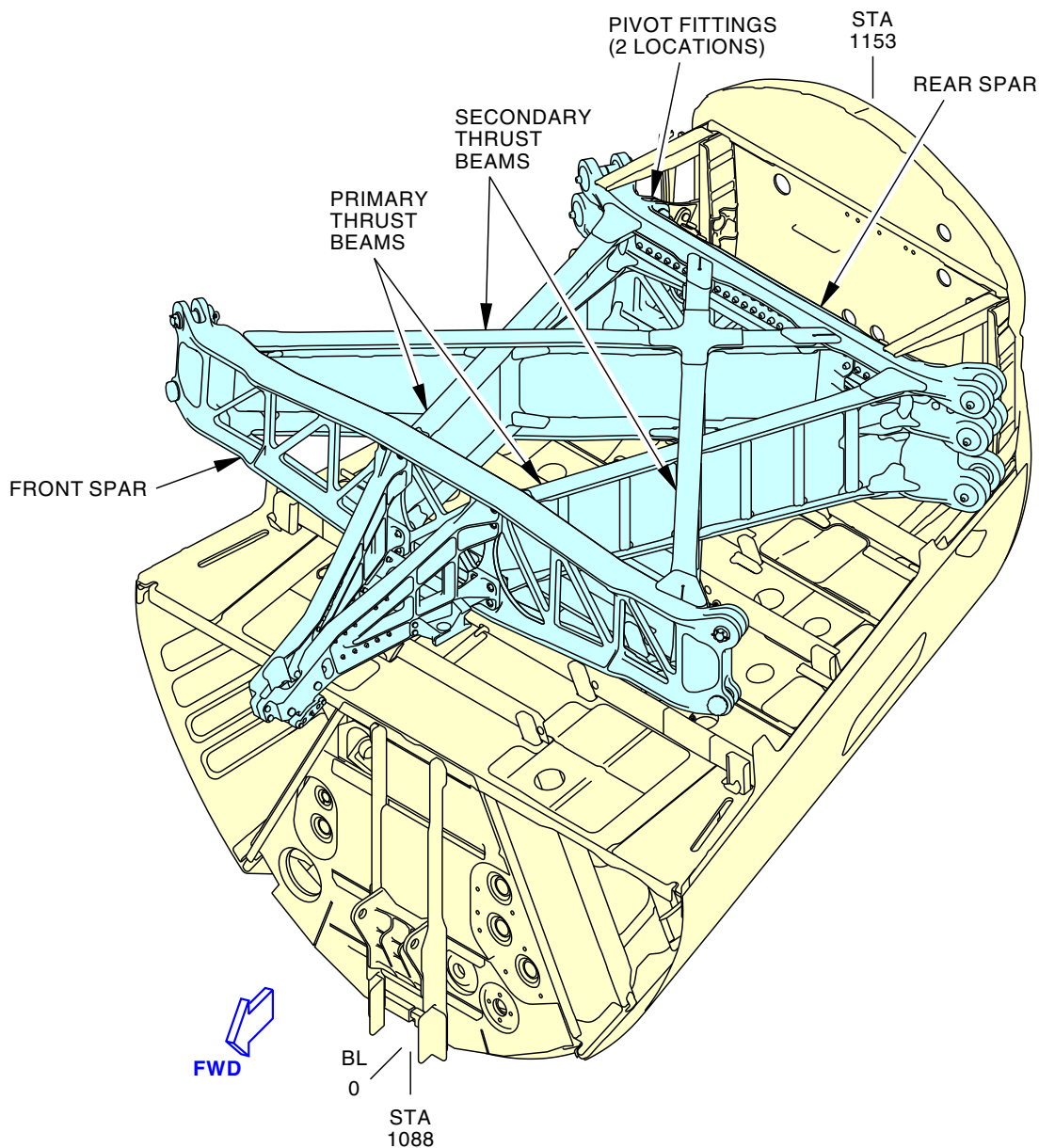
55-05-03

D633AM101-SIA

Page 204
Sep 15/2021



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



HORIZONTAL STABILIZER CENTER SECTION

B

MPD ITEM
55-020-00

2416321 S00061540439_V1

INTERNAL-GENERAL VISUAL: STABILIZER TORSION BOX COMPARTMENT
Figure 202/55-05-03-990-802 (Sheet 2 of 2)

EFFECTIVITY
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55-05-03

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Page 205
Sep 15/2021



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

TASK 55-05-03-210-803

3. INTERNAL - GENERAL VISUAL: VERTICAL FIN LEADING EDGE

(Figure 203)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

B. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II

C. Location Zones

Zone	Area
322	Vertical Fin - Removable Fin Leading Edge

D. Access Panels

Number	Name/Location
322BT	Vertical Fin, Removable Leading Edge
322C	Vertical Fin, Removable Leading Edge
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door

E. Inspection

SUBTASK 55-05-03-010-003

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
322BT	Vertical Fin, Removable Leading Edge
322C	Vertical Fin, Removable Leading Edge
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door

SUBTASK 55-05-03-210-003

- (2) Do a General Visual inspection of the forward side of the vertical fin front spar, including front spar chords, webs, and terminal fittings.

SUBTASK 55-05-03-910-003

- (3) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 55-05-03-410-003

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
322BT	Vertical Fin, Removable Leading Edge

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55-05-03

Page 206
May 15/2023



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

(Continued)

<u>Number</u>	<u>Name/Location</u>
322C	Vertical Fin, Removable Leading Edge
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door

SUBTASK 55-05-03-390-002

- (5) Apply an aerodynamic smoother sealant, A02315, to all non-bonded structural components contacting exterior skins.

NOTE: Sealant does not need to be applied to gaps between panels that are used for regular access as long as they are less than limits given in the Structural Repair Manual (SRM SUBJECT 51-10-01).

- (a) Do this task: Aerodynamic Smoother Application, TASK 51-22-00-390-809.

————— **END OF TASK** —————

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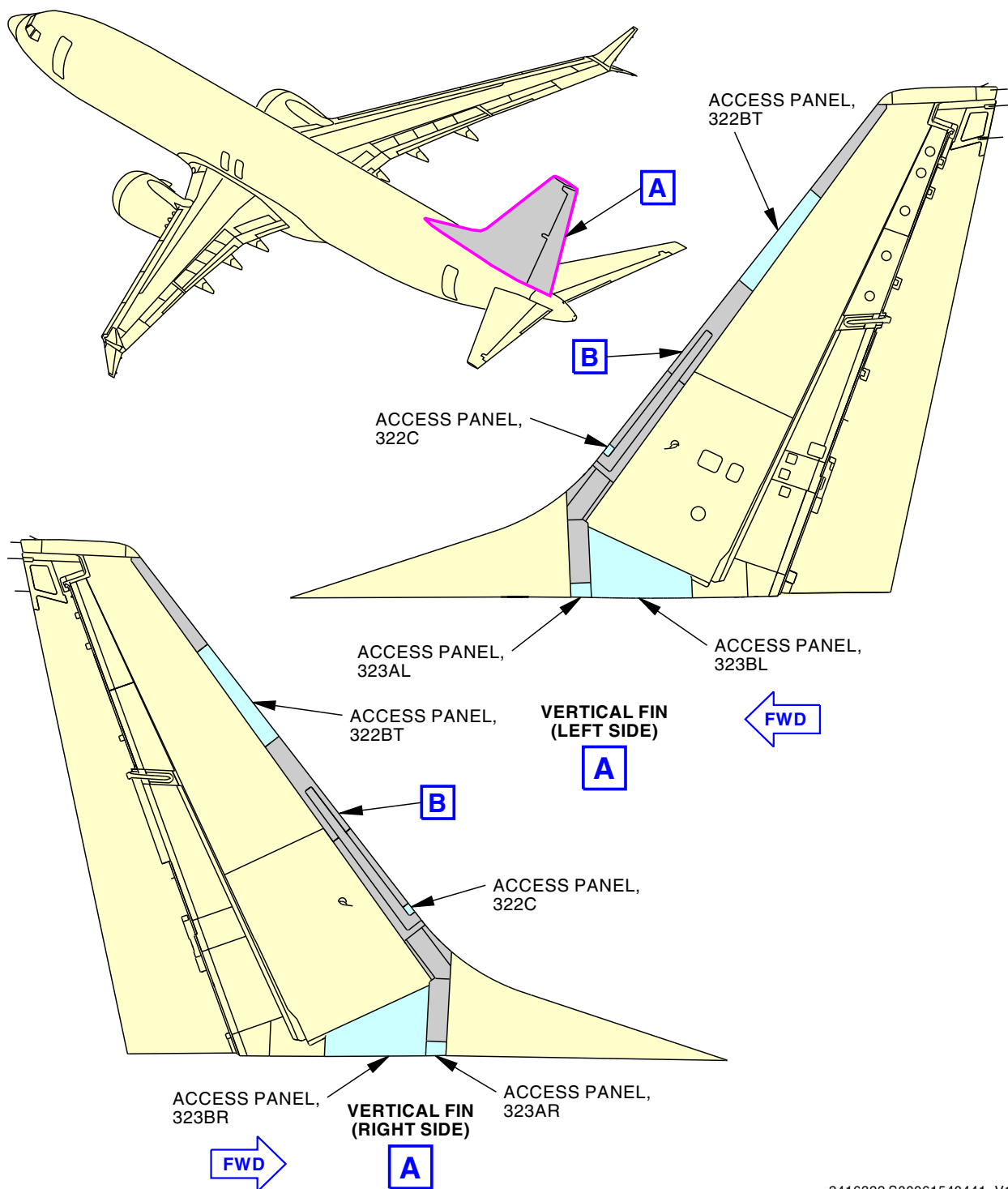
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55-05-03

Page 207
May 15/2023



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



2416322 S00061540441_V1

INTERNAL-GENERAL VISUAL: VERTICAL FIN LEADING EDGE
Figure 203/55-05-03-990-803 (Sheet 1 of 3)

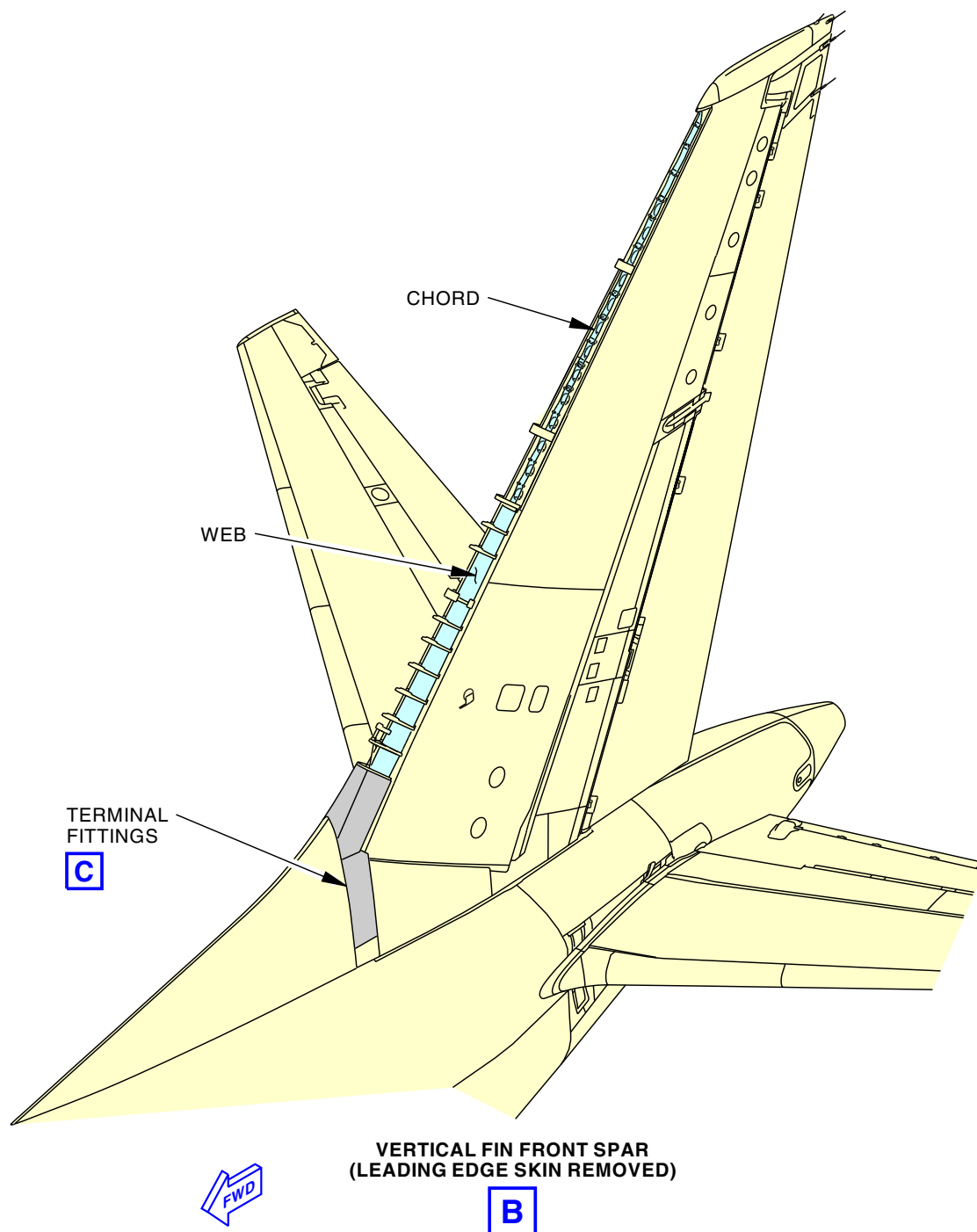
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55-05-03

Page 208
May 15/2023



2416323 S00061540442_V1

INTERNAL-GENERAL VISUAL: VERTICAL FIN LEADING EDGE
Figure 203/55-05-03-990-803 (Sheet 2 of 3)

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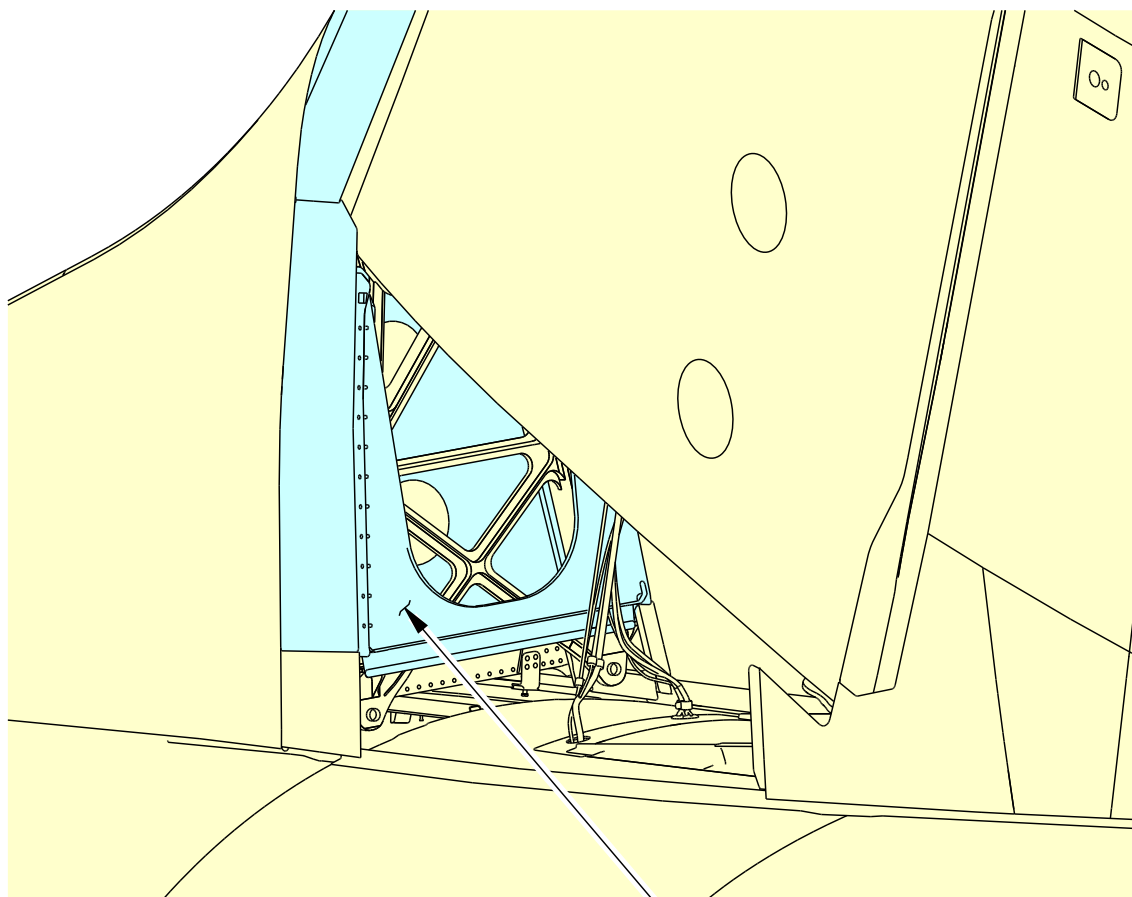
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55-05-03

Page 209
May 15/2023



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



TERMINAL FITTINGS
ASSEMBLY



TERMINAL FITTINGS ASSEMBLY



2416324 S00061540443_V1

INTERNAL-GENERAL VISUAL: VERTICAL FIN LEADING EDGE
Figure 203/55-05-03-990-803 (Sheet 3 of 3)

EFFECTIVITY
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 210
May 15/2023



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

TASK 55-05-03-210-804

4. INTERNAL - GENERAL VISUAL: VERTICAL FIN

(Figure 204)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-804	737-7/8/8200/9 Basic Task Description (P/B 201)
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

B. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II

C. Location Zones

Zone	Area
323	Vertical Fin - Front Spar To Rear Spar

D. Access Panels

Number	Name/Location
322A	Vertical Fin, Fixed Leading Edge
322AL	Vertical Fin, Fixed Leading Edge
322AR	Vertical Fin, Fixed Leading Edge
322BT	Vertical Fin, Removable Leading Edge
322C	Vertical Fin, Removable Leading Edge
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door
323DL	Vertical Fin, Access
323EL	Vertical Fin, Access
323FL	Vertical Fin, Access
323GL	Vertical Fin, Access
324AL	Vertical Fin, Aft Fin Access Door
324AR	Vertical Fin, Aft Fin Access Door
324BL	Vertical Fin, Trailing Edge Access
324BR	Vertical Fin, Trailing Edge Access
324DL	Trailing Edge Access
324DR	Vertical Fin, Trailing Edge Access
324JL	Vertical Fin, Access
324KL	Vertical Fin, Access
324LL	Vertical Fin, Access
324ML	Vertical Fin, Access
324NL	Vertical Fin, Access

EFFECTIVITY
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 211
May 15/2023



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

(Continued)

Number	Name/Location
S3232	Vertical Fin Inspection

E. Inspection

SUBTASK 55-05-03-040-001



REMOVE THE ELECTRICAL POWER FROM EACH HF COMMUNICATION SYSTEM BEFORE YOU REMOVE THE LEADING EDGE SECTIONS. HF SIGNALS CAN CAUSE ELECTRICAL SHOCKS AND INJURY TO PERSONS.

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

CAPT Electrical System Panel, P18-2

Row	Col	Number	Name
E	11	C00839	COMMUNICATIONS HF 1

F/O Electrical System Panel, P6-1

Row	Col	Number	Name
D	2	C00857	COMMUNICATIONS HF 2

SUBTASK 55-05-03-010-004

- (2) Open these access panels:

Number	Name/Location
322A	Vertical Fin, Fixed Leading Edge
322AL	Vertical Fin, Fixed Leading Edge
322AR	Vertical Fin, Fixed Leading Edge
322BT	Vertical Fin, Removable Leading Edge
322C	Vertical Fin, Removable Leading Edge
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door
323DL	Vertical Fin, Access
323EL	Vertical Fin, Access
323FL	Vertical Fin, Access
323GL	Vertical Fin, Access
324AL	Vertical Fin, Aft Fin Access Door
324AR	Vertical Fin, Aft Fin Access Door
324BL	Vertical Fin, Trailing Edge Access
324BR	Vertical Fin, Trailing Edge Access
324DL	Trailing Edge Access
324DR	Vertical Fin, Trailing Edge Access
324JL	Vertical Fin, Access
324KL	Vertical Fin, Access
324LL	Vertical Fin, Access
324ML	Vertical Fin, Access
324NL	Vertical Fin, Access

EFFECTIVITY
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 212
May 15/2023



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

Special Access:

<u>Number</u>	<u>Name/Location</u>
S3232	Vertical Fin Inspection

NOTE: Remove upper removable web. Pin removal is not required for terminal fitting inspection.

SUBTASK 55-05-03-210-004

- (3) Do a General Visual inspection of the vertical fin from front spar to rear spar, including spar chords and webs, inspar skins, lower closure rib, and rear spar terminal fittings.

SUBTASK 55-05-03-910-004

- (4) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 55-05-03-410-004

- (5) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
322A	Vertical Fin, Fixed Leading Edge
322AL	Vertical Fin, Fixed Leading Edge
322AR	Vertical Fin, Fixed Leading Edge
322BT	Vertical Fin, Removable Leading Edge
322C	Vertical Fin, Removable Leading Edge
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door
323DL	Vertical Fin, Access
323EL	Vertical Fin, Access
323FL	Vertical Fin, Access
323GL	Vertical Fin, Access
324AL	Vertical Fin, Aft Fin Access Door
324AR	Vertical Fin, Aft Fin Access Door
324BL	Vertical Fin, Trailing Edge Access
324BR	Vertical Fin, Trailing Edge Access
324DL	Trailing Edge Access
324DR	Vertical Fin, Trailing Edge Access
324JL	Vertical Fin, Access
324KL	Vertical Fin, Access
324LL	Vertical Fin, Access
324ML	Vertical Fin, Access
324NL	Vertical Fin, Access

SUBTASK 55-05-03-390-003

- (6) Apply an aerodynamic smoother sealant, A02315, to all non-bonded structural components contacting exterior skins.

NOTE: Sealant does not need to be applied to gaps between panels that are used for regular access as long as they are less than limits given in the Structural Repair Manual (SRM SUBJECT 51-10-01).

- (a) Do this task: Aerodynamic Smoother Application, TASK 51-22-00-390-809.

EFFECTIVITY
SIA ALL

55-05-03

D633AM101-SIA

Page 213
May 15/2023



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

SUBTASK 55-05-03-860-001

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

CAPT Electrical System Panel, P18-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
E	11	C00839	COMMUNICATIONS HF 1

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	2	C00857	COMMUNICATIONS HF 2

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

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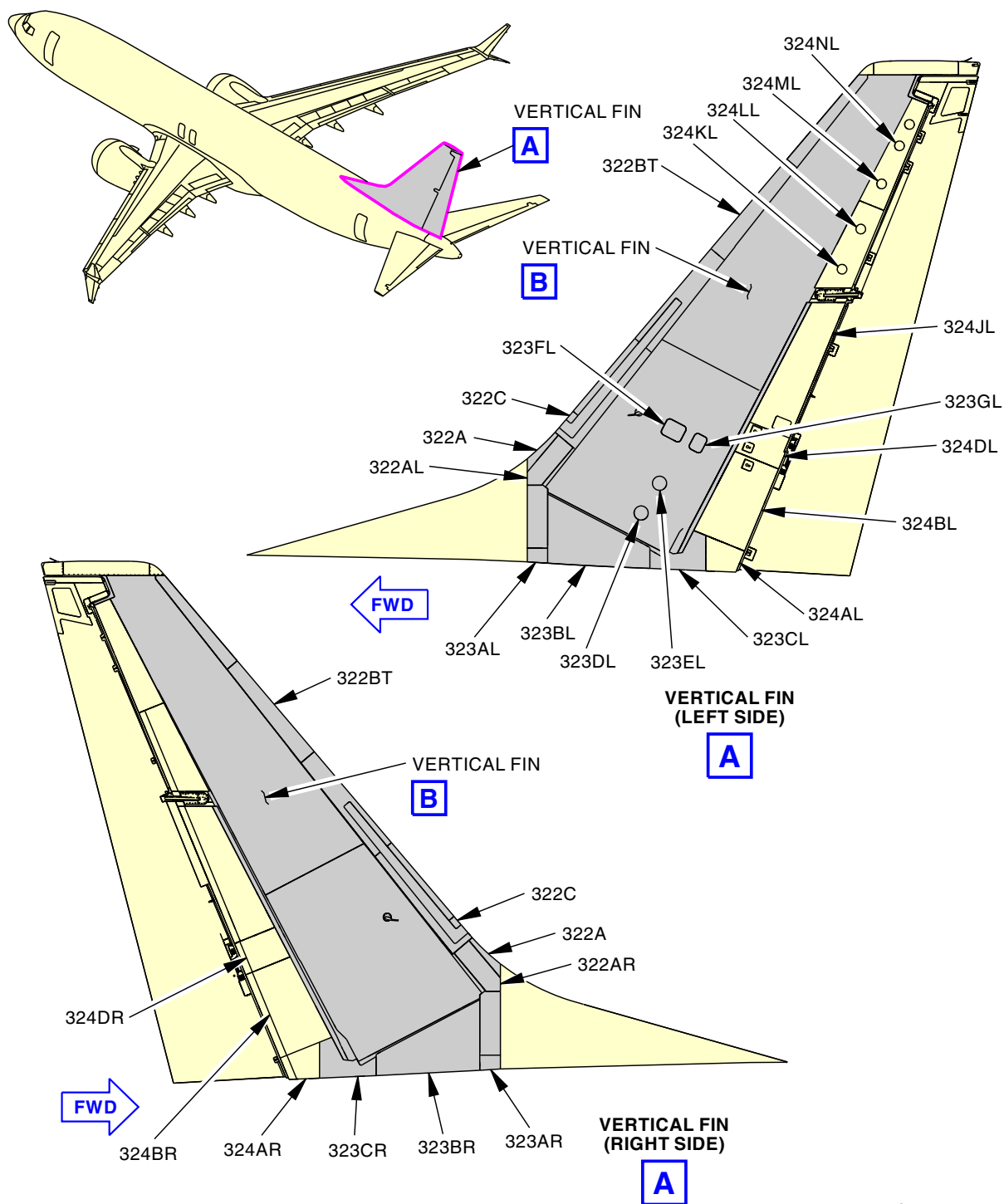
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55-05-03

Page 214
May 15/2023



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



2416325 S00061540445_V1

INTERNAL-GENERAL VISUAL: VERTICAL FIN
Figure 204/55-05-03-990-804 (Sheet 1 of 2)

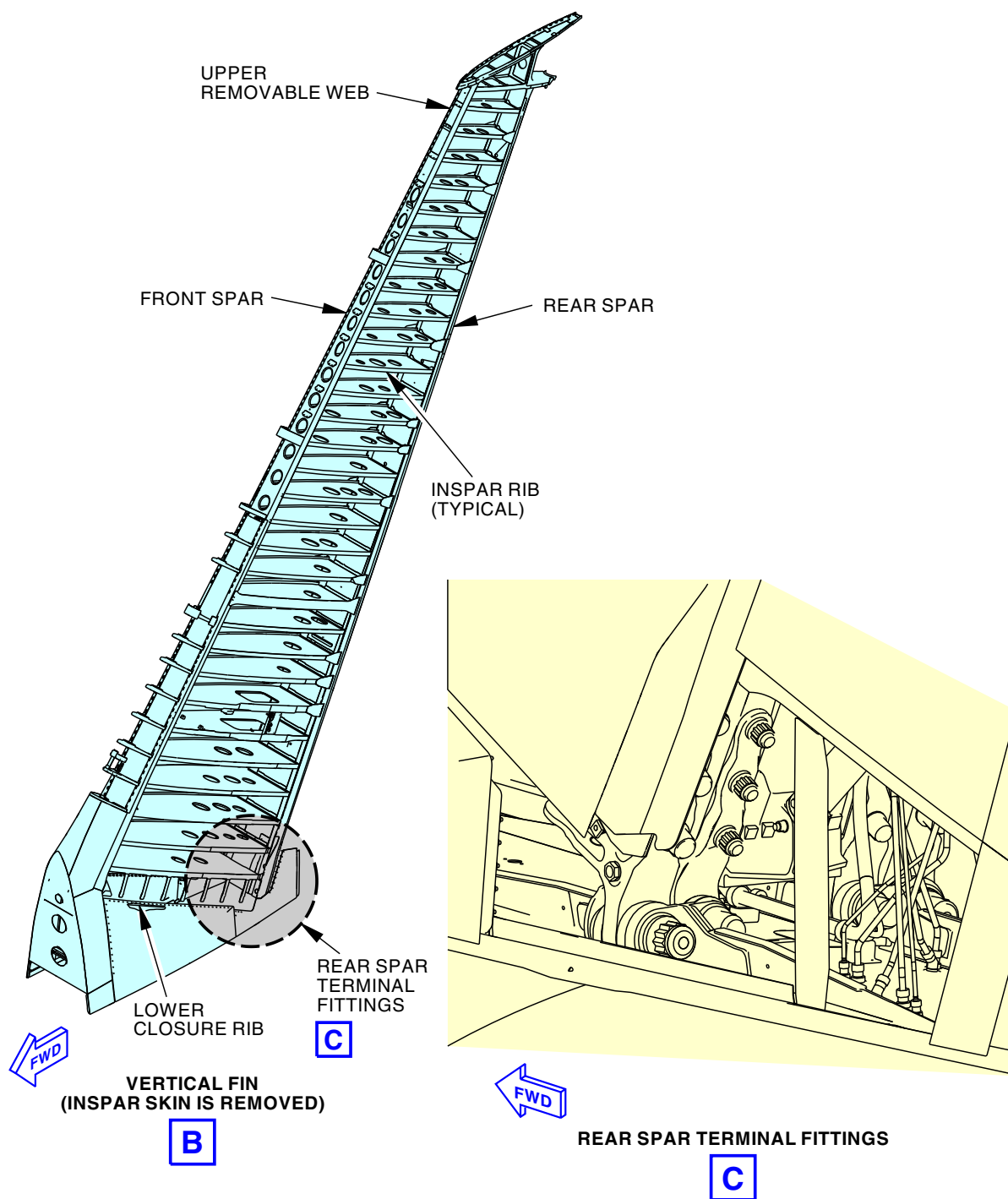
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55-05-03

Page 215
May 15/2023



2416326 S00061540446_V1

INTERNAL-GENERAL VISUAL: VERTICAL FIN
Figure 204/55-05-03-990-804 (Sheet 2 of 2)

EFFECTIVITY
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55-05-03

Page 216
May 15/2023



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

TASK 55-05-03-210-805

5. INTERNAL - GENERAL VISUAL: VERTICAL FIN TRAILING EDGE

Figure 205

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
324	Vertical Fin - Rear Spar To Trailing Edge

C. Access Panels

Number	Name/Location
323CL	Vertical Fin, Rear Spar Access Door
324BL	Vertical Fin, Trailing Edge Access
324DL	Trailing Edge Access
324JL	Vertical Fin, Access
324KL	Vertical Fin, Access
324LL	Vertical Fin, Access
324ML	Vertical Fin, Access
324NL	Vertical Fin, Access

D. Inspection

SUBTASK 55-05-03-010-005

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
323CL	Vertical Fin, Rear Spar Access Door
324BL	Vertical Fin, Trailing Edge Access
324DL	Trailing Edge Access
324JL	Vertical Fin, Access
324KL	Vertical Fin, Access
324LL	Vertical Fin, Access
324ML	Vertical Fin, Access
324NL	Vertical Fin, Access

SUBTASK 55-05-03-210-005

- (2) Do a General Visual inspection of the aft side of vertical fin rear spar, including rear spar chords and webs, and rudder hinge ribs.

SUBTASK 55-05-03-910-005

- (3) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 55-05-03-410-005

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
323CL	Vertical Fin, Rear Spar Access Door
324BL	Vertical Fin, Trailing Edge Access
324DL	Trailing Edge Access

EFFECTIVITY
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55-05-03

Page 217
May 15/2023



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

(Continued)

<u>Number</u>	<u>Name/Location</u>
324JL	Vertical Fin, Access
324KL	Vertical Fin, Access
324LL	Vertical Fin, Access
324ML	Vertical Fin, Access
324NL	Vertical Fin, Access

———— END OF TASK ————

EFFECTIVITY
SIA ALL

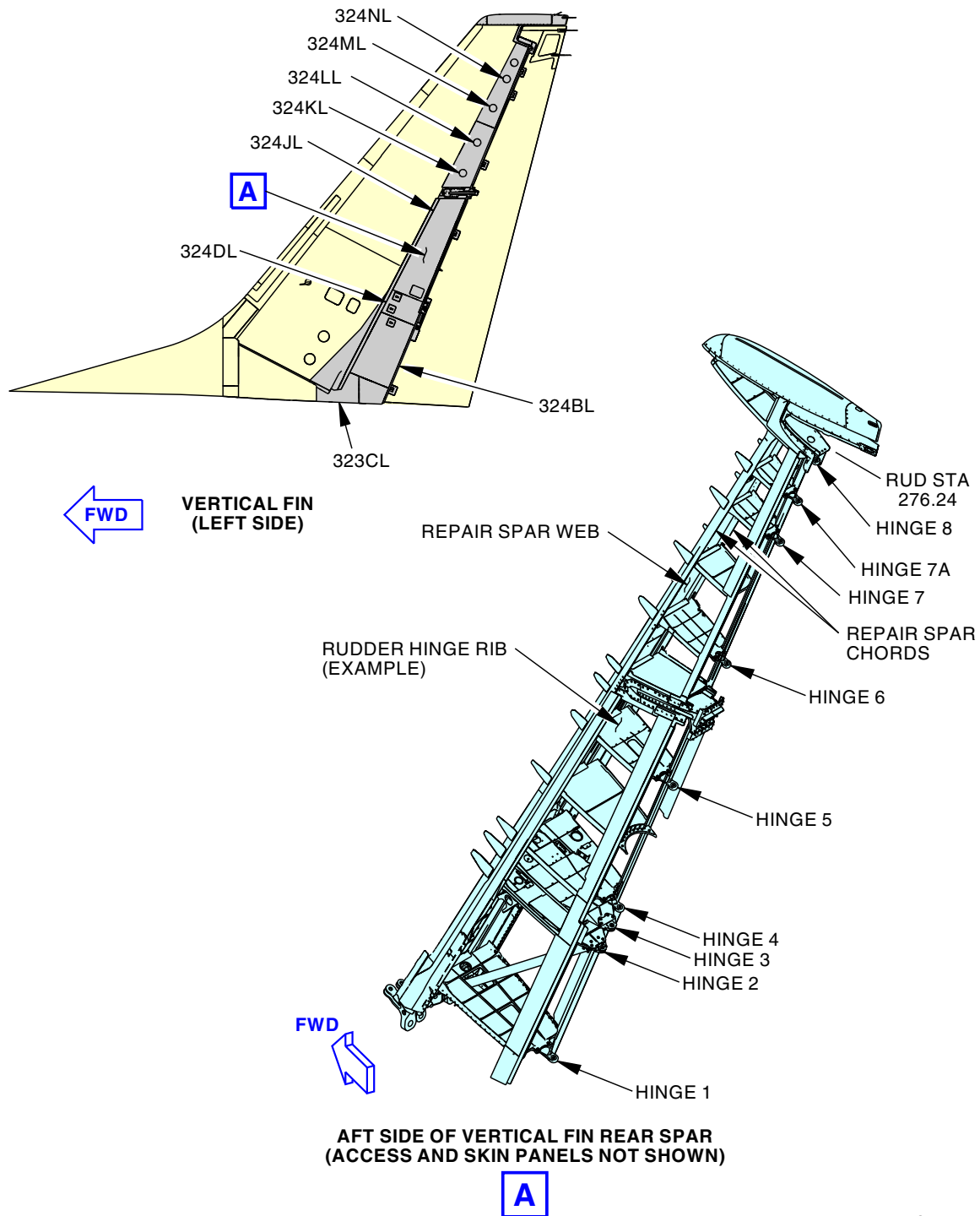
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55-05-03

Page 218
May 15/2023

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



2416327 S00061540448_V1

INTERNAL-GENERAL VISUAL: VERTICAL FIN TRAILING EDGE
Figure 205/55-05-03-990-805

EFFECTIVITY
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 219
May 15/2023



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

TASK 55-05-03-210-806

6. **INTERNAL - GENERAL VISUAL: LEFT HORIZONTAL STABILIZER LEADING EDGE**

(Figure 206)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
27-41-11-400-801	Horizontal Stabilizer Installation (P/B 401)
51-05-01-210-804	737-7/8/8200/9 Basic Task Description (P/B 201)
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

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-2035	Sling Equipment - Horizontal Stabilizer Part #: C55014-1 Supplier: 81205
STD-12395	Load Cell Equipment

C. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
7	Pin	55-10-00-18-010	SIA ALL

E. Location Zones

Zone	Area
331	Left Horizontal Stabilizer - Removable Leading Edge

F. Access Panels

Number	Name/Location
331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
331AZ	Horizontal Stabilizer, Access Panel, Inboard L.E. Closure Rib
331BL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331CL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331DL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331EL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
S3311	Left Horizontal Stabilizer Leading Edge Inspection

G. Prepare for the Inspection

SUBTASK 55-05-03-480-001

- (1) Install the sling equipment, SPL-2035.
 - (a) Remove the bolts [1] and bolts [2] from the stabilizer top surface.

EFFECTIVITY
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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 220
May 15/2023



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



MAKE SURE YOU INSTALL THE HOISTING SLING CORRECTLY WHEN YOU REMOVE THE HORIZONTAL STABILIZER WITH OR WITHOUT THE ELEVATOR INSTALLED. IF YOU DO NOT INSTALL THE HOISTING SLING CORRECTLY FOR THE REMOVAL OF THE HORIZONTAL STABILIZER, YOU CAN CAUSE DAMAGE TO EQUIPMENT.

- (b) Attach the sling equipment, SPL-2035, to the horizontal stabilizer with fasteners.

NOTE: Low clearance sling is used only with elevator removed.

- (c) Attach the load cell, STD-12395, to the sling equipment, SPL-2035.
(d) Attach a hoist to the load cell, STD-12395.



YOU MUST CAREFULLY LIFT THE HOISTING SLING. A SUDDEN MOVEMENT OF THE HOISTING SLING CAN CAUSE DAMAGE TO THE HORIZONTAL STABILIZER.

- (e) Lift the weight of the horizontal stabilizer.
- 1) Use the load cell, STD-12395, to make sure that the force used when lifting horizontal stabilizer is not more than:
 - 888 lb (403 kg) or (830 lb (376 kg) airplane part + 58 lb (26 kg) tool) with elevator attached.
 - 688 lb (312 kg) or (630 lb (286 kg) airplane part + 58 lb (26 kg) tool) without elevator attached.

H. Inspection

SUBTASK 55-05-03-010-006

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
331AZ	Horizontal Stabilizer, Access Panel, Inboard L.E. Closure Rib
331BL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331CL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331DL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331EL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER

Special Access:

<u>Number</u>	<u>Name/Location</u>
S3311	Left Horizontal Stabilizer Leading Edge Inspection

NOTE: Bolt removal is required to inspect terminal fittings and center section front spar lugs.

SUBTASK 55-05-03-020-001

- (2) At the horizontal stabilizer front spar do these steps:
- (a) Remove and discard the pins [7].
 - (b) Remove and keep the nuts [6], washers [5], shims [8], washers [9], bolts [4] and washers [3].

SUBTASK 55-05-03-100-001

- (3) Clean the joint per SOPM 20-30-03 to remove dirt, debris, and existing grime.

EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 221
May 15/2023



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

SUBTASK 55-05-03-210-006

- (4) Do a General Visual inspection of the forward side of front spar, including front spar chords and webs, terminal fittings, and center section front spar lugs.

SUBTASK 55-05-03-910-006

- (5) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 55-05-03-100-002

- (6) Apply the corrosion inhibiting material, G50136, to the bolts and joints, including the inner diameter of bushings.

SUBTASK 55-05-03-420-001

- (7) At the horizontal stabilizer front spar, install the washers [3], bolts [4], washers [9], shims [8], washers [5], nuts [6] and new pins [7] (TASK 27-41-11-400-801).

I. Put the Airplane Back to Its Usual Condition

SUBTASK 55-05-03-410-019

- (1) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
331AZ	Horizontal Stabilizer, Access Panel, Inboard L.E. Closure Rib
331BL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331CL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331DL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331EL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER

SUBTASK 55-05-03-390-004

- (2) Apply an aerodynamic smoother sealant, A02315, to all non-bonded structural components contacting exterior skins.

NOTE: Sealant does not need to be applied to gaps between panels that are used for regular access as long as they are less than limits given in the Structural Repair Manual (SRM SUBJECT 51-10-01).

- (a) Do this task: Aerodynamic Smoother Application, TASK 51-22-00-390-809.

SUBTASK 55-05-03-080-001

- (3) Remove the sling equipment, SPL-2035.
 - (a) Release tension applied to the sling equipment, SPL-2035.
 - (b) Remove the hoist from the load cell, STD-12395.
 - (c) Remove the load cell, STD-12395, from the sling equipment, SPL-2035.
 - (d) Remove the fasteners that attach the sling equipment, SPL-2035.
 - (e) Install the bolts [1] and bolts [2] at the horizontal stabilizer top surface.

————— END OF TASK —————

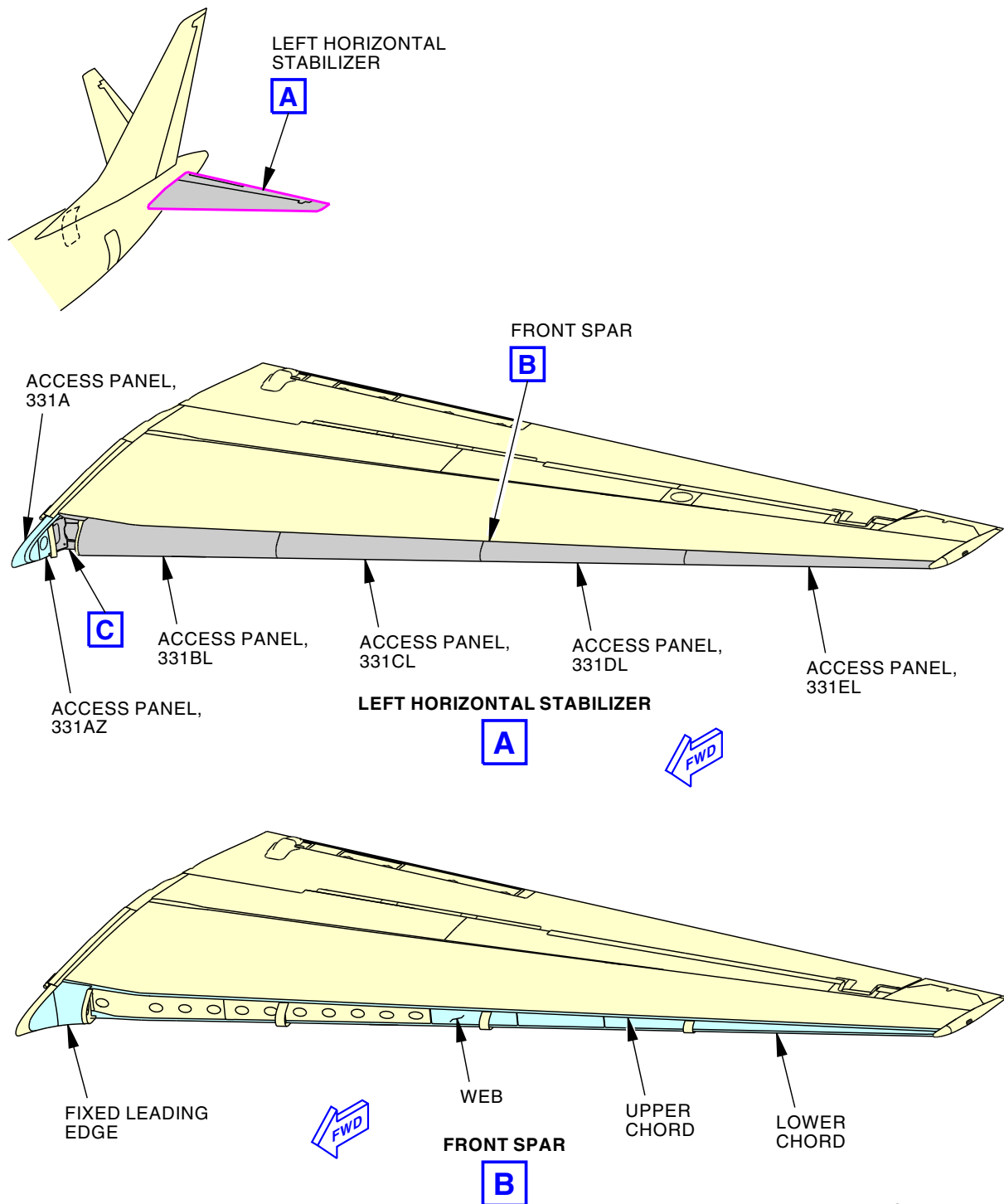
EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 222
May 15/2023



2416328 S00061540450_V1

INTERNAL-GENERAL VISUAL: LEFT HORIZONTAL STABILIZER LEADING EDGE
Figure 206/55-05-03-990-806 (Sheet 1 of 5)

EFFECTIVITY
SIA ALL

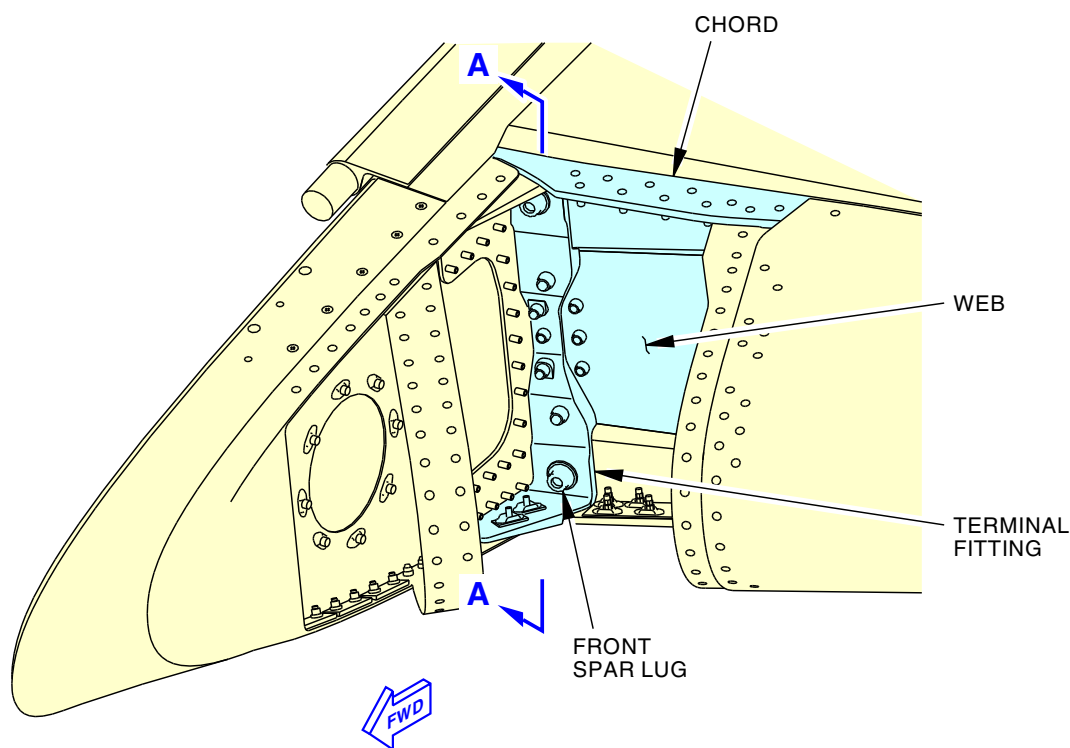
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55-05-03

Page 223
May 15/2023



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



(FIXED LEADING EDGE IS REMOVED)

C

2416329 S00061540451_V2

INTERNAL-GENERAL VISUAL: LEFT HORIZONTAL STABILIZER LEADING EDGE
Figure 206/55-05-03-990-806 (Sheet 2 of 5)

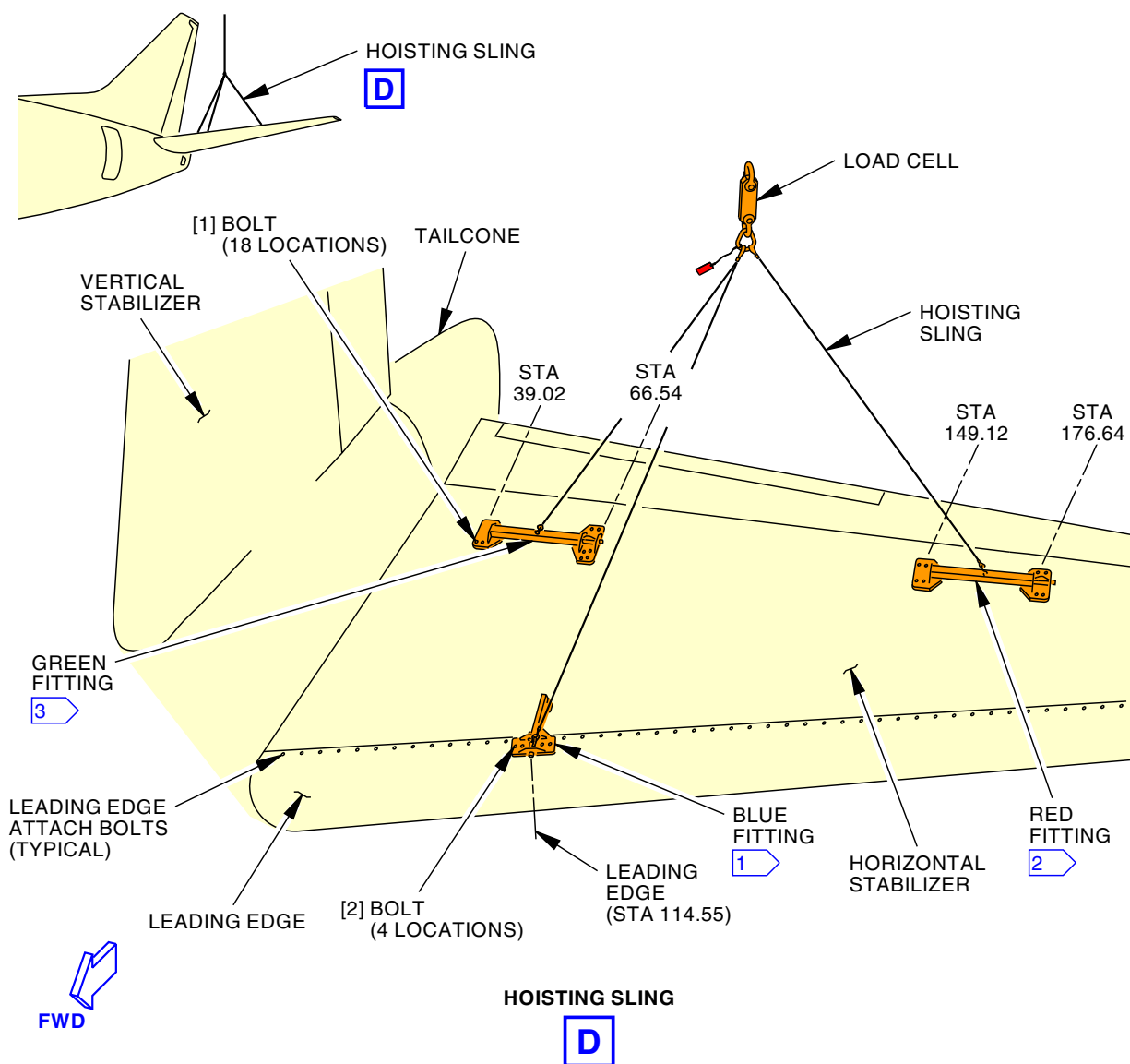
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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 224
May 15/2023



- 1 THE FORWARD ATTACH (BLUE) FITTING IS ATTACHED TO THE STABILIZER FRONT SPAR (LEADING EDGE ATTACH BOLTS). TWO BOLTS ARE USED ON THE INBOARD SIDE OF THE LEADING EDGE RIB (STA 114.55) AND TWO BOLTS ARE USED ON THE OUTBOARD SIDE OF THE LEADING EDGE RIB (STA 114.55).
- 2 THE AFT OUTBOARD ATTACH (RED) FITTING IS ATTACHED TO THE ELEVATOR HINGE SUPPORT RIBS, FOUR BOLTS ARE USED AT STA 176.64 AND FOUR BOLTS ARE USED AT STA 149.12.
- 3 THE AFT INBOARD ATTACH (GREEN) FITTING IS ATTACHED TO THE ELEVATOR HINGE SUPPORT RIBS, SIX BOLTS ARE USED AT STA 66.54 AND FOUR BOLTS ARE USED AT STA 39.02.

2897837 S0000691416_V2

INTERNAL-GENERAL VISUAL: LEFT HORIZONTAL STABILIZER LEADING EDGE
Figure 206/55-05-03-990-806 (Sheet 3 of 5)

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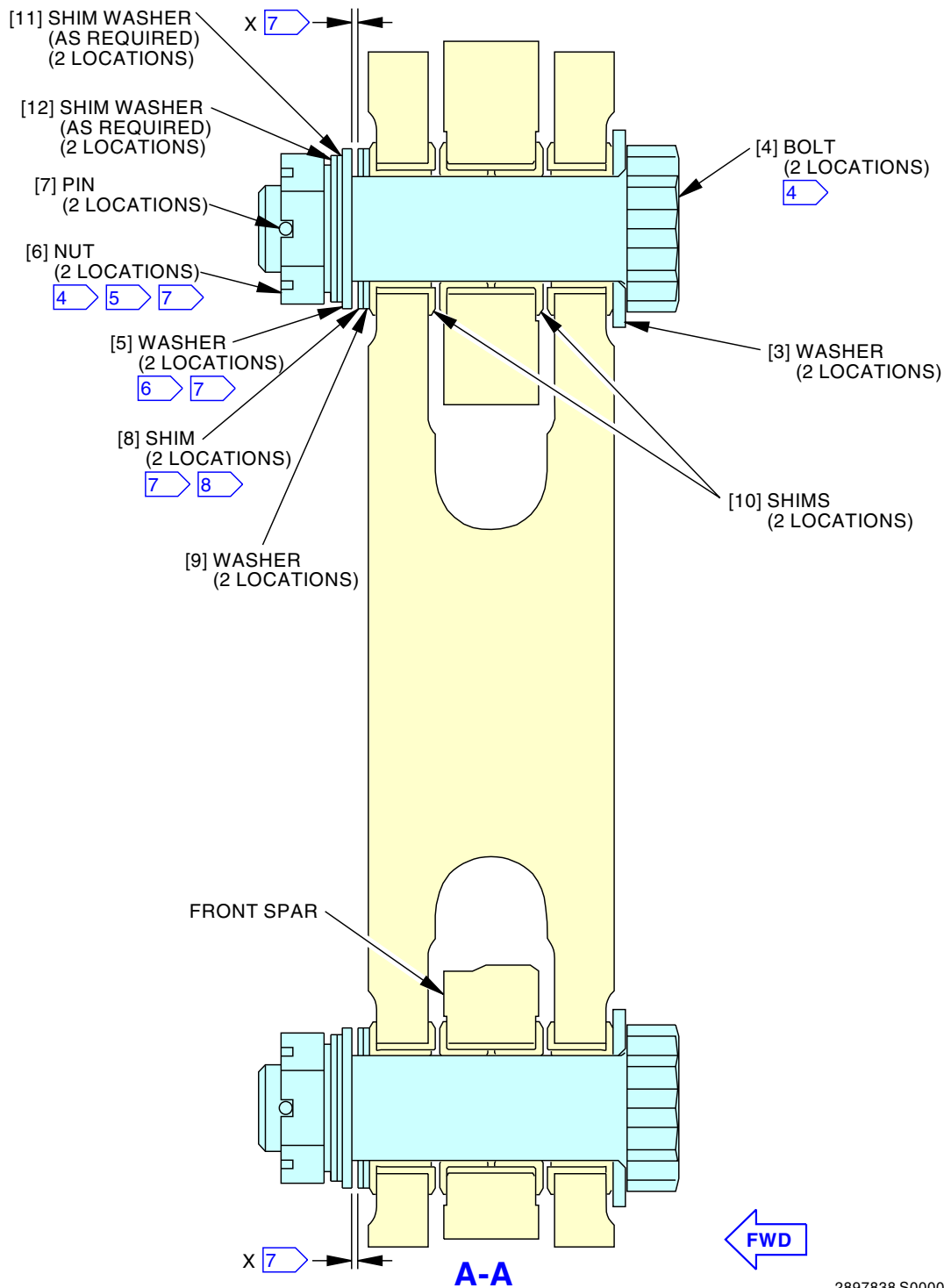
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 225
May 15/2023

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



2897838 S0000691417_V1

INTERNAL-GENERAL VISUAL: LEFT HORIZONTAL STABILIZER LEADING EDGE
Figure 206/55-05-03-990-806 (Sheet 4 of 5)

EFFECTIVITY
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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 226
May 15/2023



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

- 4** BEFORE INSTALLING NUT, COAT THREADS OF BOLT AND NUT WITH BMS 3-28 ANTI-SEIZE COMPOUND.
- 5** TORQUE NUT TO AN INITIAL TORQUE OF 50 POUND-INCHES (5.6 NEWTON-METERS)
- 6** AFTER INITIAL TORQUE, WASHER [5] OR SHIM WASHER [11]/[12] MUST TOUCH STEPPED PART OF BOLT [4]. IF THE WASHER [5] OR SHIM WASHER [11]/[12] DOES NOT CONTACT STEPPED PART OF BOLT [4], REMOVE LAMINATED SHIMS [8] UNTIL IT DOES.
- 7** THE GAP "X" BETWEEN THE SHIMS [8] AND WASHER [5] IS MORE THAN 0.002 INCH (0.05 mm), ADD SHIMS [8] UNTIL THE GAP "X" IS BETWEEN 0.002-0.000 INCH (0.05-0.00 mm).
- 8** WHEN SHIM [8] ADJUSTMENTS ARE COMPLETE, TORQUE NUT TO 950-1400 POUND-INCHES (107.4-158.2 NEWTON-METERS).

2897839 S0000691420_V1

INTERNAL-GENERAL VISUAL: LEFT HORIZONTAL STABILIZER LEADING EDGE
Figure 206/55-05-03-990-806 (Sheet 5 of 5)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 227
May 15/2023



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

TASK 55-05-03-210-807

7. **INTERNAL - GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER LEADING EDGE**

(Figure 207)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
27-41-11-400-801	Horizontal Stabilizer Installation (P/B 401)
51-05-01-210-804	737-7/8/8200/9 Basic Task Description (P/B 201)
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

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-2035	Sling Equipment - Horizontal Stabilizer Part #: C55014-1 Supplier: 81205
STD-12395	Load Cell Equipment

C. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
7	Pin	55-10-00-18-010	SIA ALL

E. Location Zones

Zone	Area
341	Right Horizontal Stabilizer - Removable Leading Edge

F. Access Panels

Number	Name/Location
341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
341AZ	Horizontal Stabilizer, Access Panel - Inbd L.E. Closure Rib
341BR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341CR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341DR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341ER	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
S3411	Right Horizontal Stabilizer Leading Edge Inspection

G. Prepare for the Inspection

SUBTASK 55-05-03-480-002

- (1) Install the sling equipment, SPL-2035.
 - (a) Remove the bolts [1] and bolts [2] from the stabilizer top surface.

EFFECTIVITY
SIA ALL

D633AM101-SIA

55-05-03

Page 228
May 15/2023



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



MAKE SURE YOU INSTALL THE HOISTING SLING CORRECTLY WHEN YOU REMOVE THE HORIZONTAL STABILIZER WITH OR WITHOUT THE ELEVATOR INSTALLED. IF YOU DO NOT INSTALL THE HOISTING SLING CORRECTLY FOR THE REMOVAL OF THE HORIZONTAL STABILIZER, YOU CAN CAUSE DAMAGE TO EQUIPMENT.

- (b) Attach the sling equipment, SPL-2035, to the horizontal stabilizer with fasteners.

NOTE: Low clearance sling is used only with elevator removed.

- (c) Attach the load cell, STD-12395, to the sling equipment, SPL-2035.
(d) Attach a hoist to the load cell, STD-12395.



YOU MUST CAREFULLY LIFT THE HOISTING SLING. A SUDDEN MOVEMENT OF THE HOISTING SLING CAN CAUSE DAMAGE TO THE HORIZONTAL STABILIZER.

- (e) Lift the weight of the horizontal stabilizer.
- 1) Use the load cell, STD-12395, to make sure that the force used when lifting horizontal stabilizer is not more than:
 - 888 lb (403 kg) or (830 lb (376 kg) airplane part + 58 lb (26 kg) tool) with elevator attached.
 - 688 lb (312 kg) or (630 lb (286 kg) airplane part + 58 lb (26 kg) tool) without elevator attached.

H. Inspection

SUBTASK 55-05-03-010-007

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
341AZ	Horizontal Stabilizer, Access Panel - Inbd L.E. Closure Rib
341BR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341CR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341DR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341ER	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER

Special Access:

<u>Number</u>	<u>Name/Location</u>
S3411	Right Horizontal Stabilizer Leading Edge Inspection

NOTE: Bolt removal is required to inspect terminal fittings and center section front spar lugs.

SUBTASK 55-05-03-390-005

- (2) Apply an aerodynamic smoother sealant, A02315, to all non-bonded structural components contacting exterior skins.

NOTE: Sealant does not need to be applied to gaps between panels that are used for regular access as long as they are less than limits given in the Structural Repair Manual (SRM SUBJECT 51-10-01).

- (a) Do this task: Aerodynamic Smoother Application, TASK 51-22-00-390-809.

SUBTASK 55-05-03-020-002

- (3) At the horizontal stabilizer front spar do these steps:

EFFECTIVITY
SIA ALL

55-05-03

D633AM101-SIA

Page 229
May 15/2023



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

- (a) Remove and discard the pins [7].
- (b) Remove and keep the nuts [6], washers [5], shims [8], washers [9], bolts [4] and washers [3].

SUBTASK 55-05-03-100-003

- (4) Clean the joint per SOPM 20-30-03 to remove dirt, debris, and existing grime.

SUBTASK 55-05-03-210-007

- (5) Do a General Visual inspection of the forward side of front spar, including front spar chords and webs, terminal fittings, and center section front spar lugs.

SUBTASK 55-05-03-910-007

- (6) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 55-05-03-100-004

- (7) Apply the corrosion inhibiting material, G50136, to the bolts and joints, including the inner diameter of bushings.

SUBTASK 55-05-03-420-002

- (8) At the horizontal stabilizer front spar, install the washers [3], bolts [4], washers [9], shims [8], washers [5], nuts [6] and new pins [7] (TASK 27-41-11-400-801).

I. Put the Airplane Back to Its Usual Condition

SUBTASK 55-05-03-410-020

- (1) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
341AZ	Horizontal Stabilizer, Access Panel - Inbd L.E. Closure Rib
341BR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341CR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341DR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341ER	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER

SUBTASK 55-05-03-080-002

- (2) Remove the sling equipment, SPL-2035.
 - (a) Release tension applied to the sling equipment, SPL-2035.
 - (b) Remove the hoist from the load cell, STD-12395.
 - (c) Remove the load cell, STD-12395, from the sling equipment, SPL-2035.
 - (d) Remove the fasteners that attach the sling equipment, SPL-2035.
 - (e) Install the bolts [1] and bolts [2] at the horizontal stabilizer top surface.

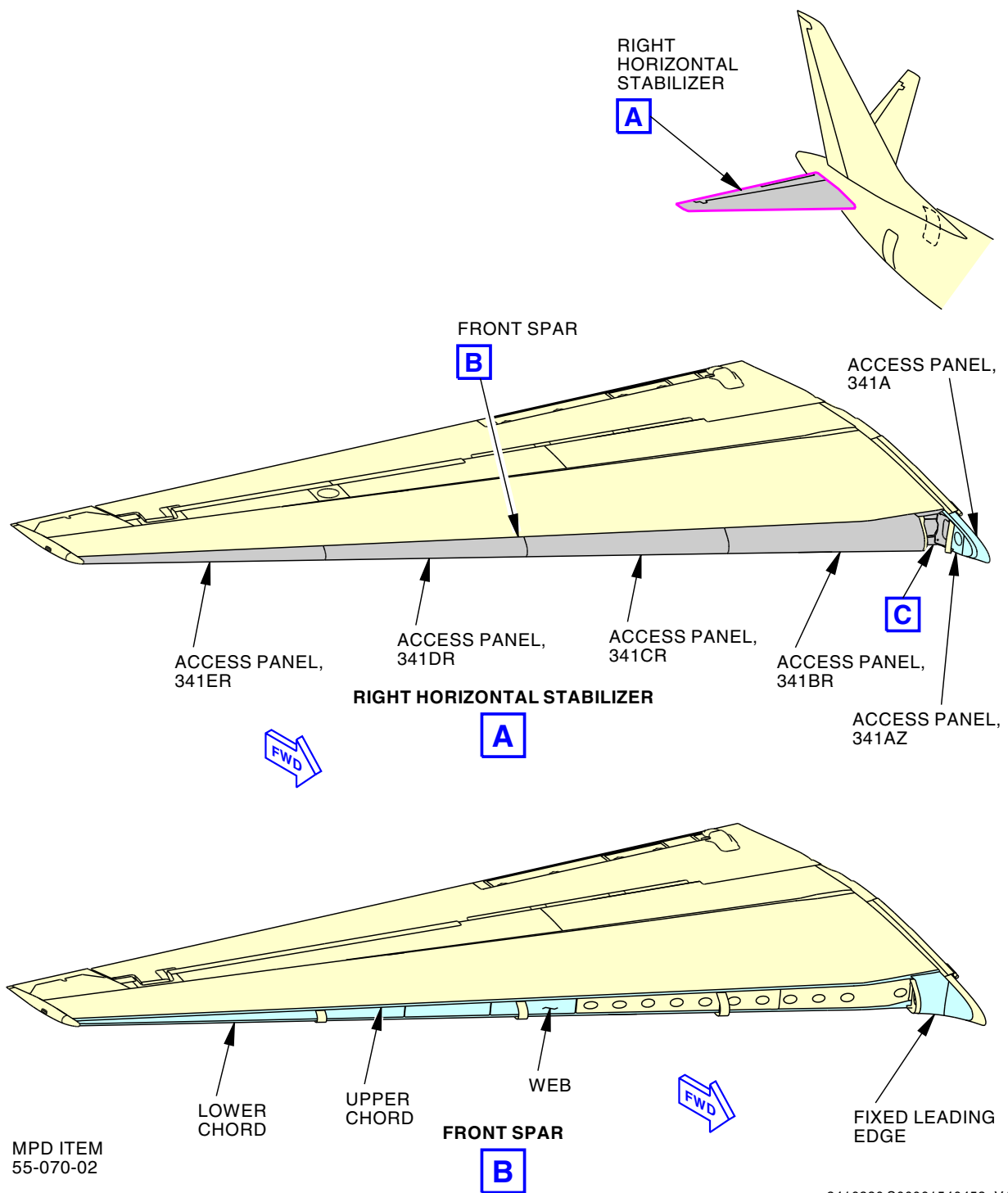
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EFFECTIVITY
SIA ALL

55-05-03

D633AM101-SIA

Page 230
May 15/2023



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INTERNAL-GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER LEADING EDGE
Figure 207/55-05-03-990-807 (Sheet 1 of 5)

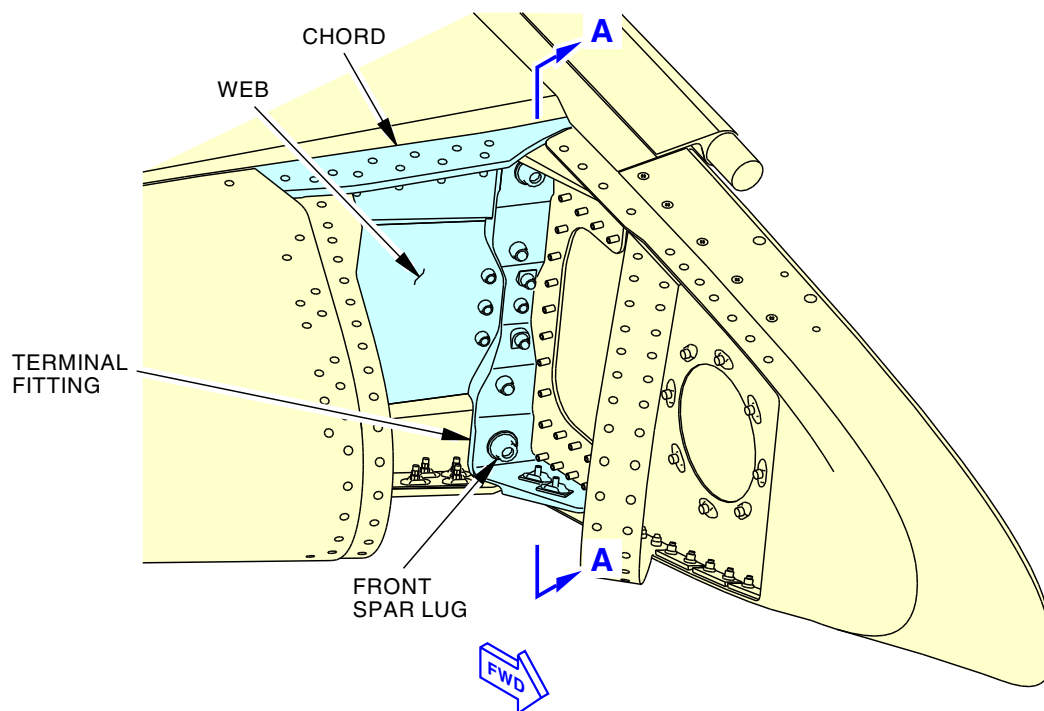
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 231
May 15/2023



(FIXED LEADING EDGE IS REMOVED)

C

2416331 S00061540454_V2

INTERNAL-GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER LEADING EDGE
Figure 207/55-05-03-990-807 (Sheet 2 of 5)

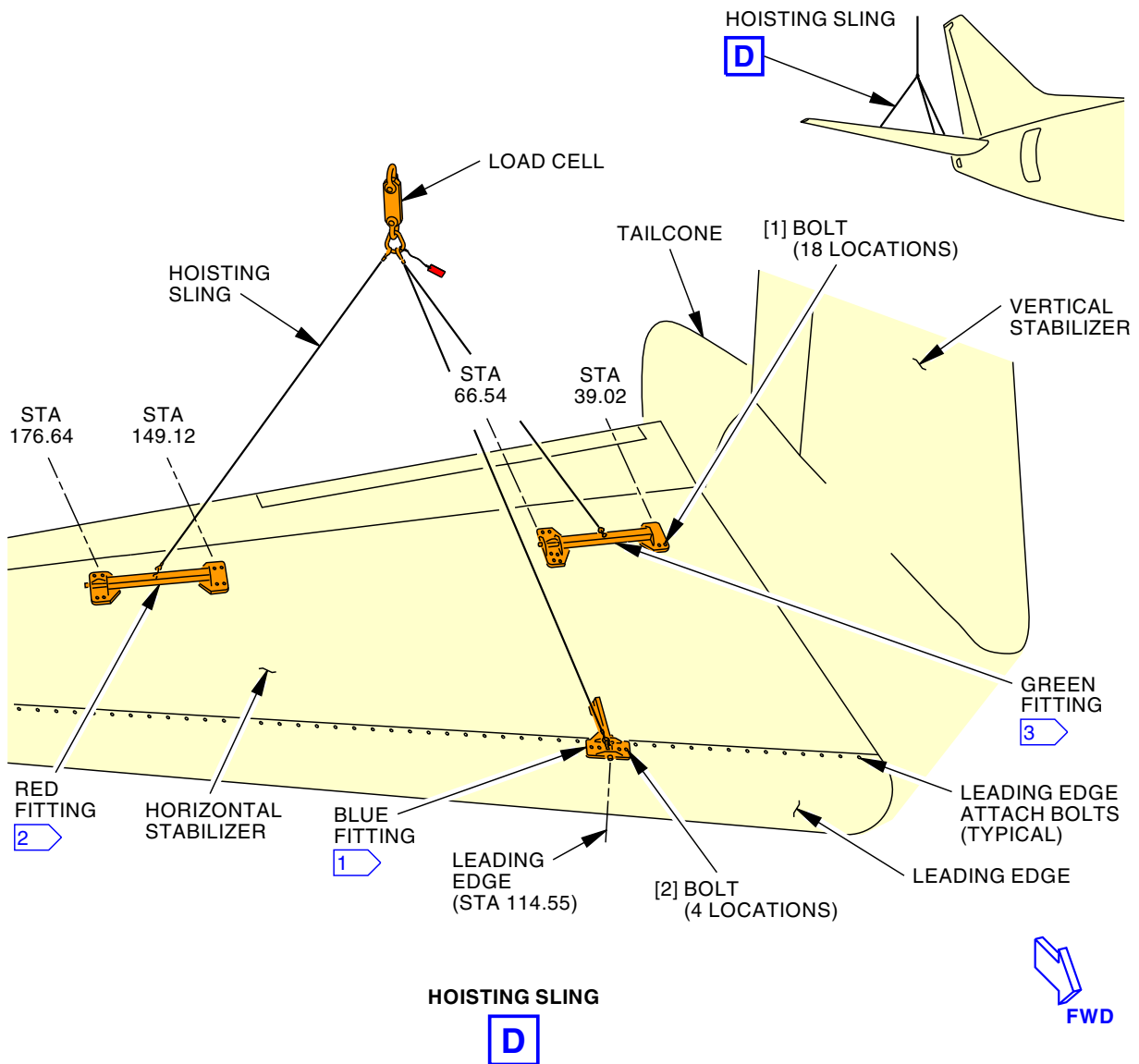
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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 232
May 15/2023



- 1 THE FORWARD ATTACH (BLUE) FITTING IS ATTACHED TO THE STABILIZER FRONT SPAR (LEADING EDGE ATTACH BOLTS). TWO BOLTS ARE USED ON THE INBOARD SIDE OF THE LEADING EDGE RIB (STA 114.55) AND TWO BOLTS ARE USED ON THE OUTBOARD SIDE OF THE LEADING EDGE RIB (STA 114.55).
- 2 THE AFT OUTBOARD ATTACH (RED) FITTING IS ATTACHED TO THE ELEVATOR HINGE SUPPORT RIBS, FOUR BOLTS ARE USED AT STA 176.64 AND FOUR BOLTS ARE USED AT STA 149.12.
- 3 THE AFT INBOARD ATTACH (GREEN) FITTING IS ATTACHED TO THE ELEVATOR HINGE SUPPORT RIBS, SIX BOLTS ARE USED AT STA 66.54 AND FOUR BOLTS ARE USED AT STA 39.02.

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INTERNAL-GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER LEADING EDGE
Figure 207/55-05-03-990-807 (Sheet 3 of 5)

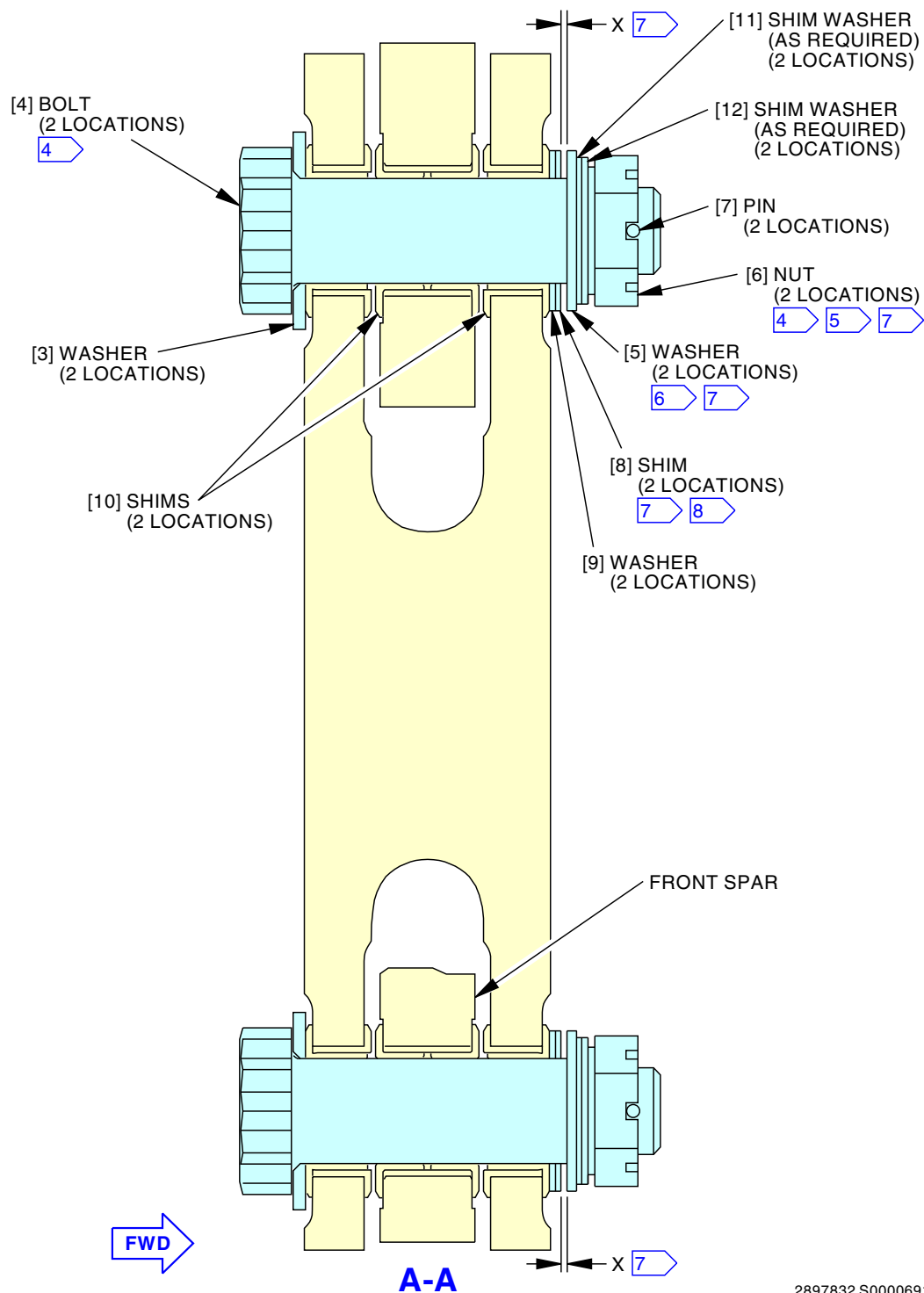
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D633AM101-SIA

55-05-03

Page 233
May 15/2023

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



2897832 S0000691379_V1

INTERNAL-GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER LEADING EDGE
Figure 207/55-05-03-990-807 (Sheet 4 of 5)

EFFECTIVITY
SIA ALL

55-05-03

D633AM101-SIA

Page 234
May 15/2023



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

- 4** BEFORE INSTALLING NUT, COAT THREADS OF BOLT AND NUT WITH BMS 3-28 ANTI-SEIZE COMPOUND.
- 5** TORQUE NUT TO AN INITIAL TORQUE OF 50 POUND-INCHES (5.6 NEWTON-METERS)
- 6** AFTER INITIAL TORQUE, WASHER [5] OR SHIM WASHER [11]/[12] MUST TOUCH STEPPED PART OF BOLT [4]. IF THE WASHER [5] OR SHIM WASHER [11]/[12] DOES NOT CONTACT STEPPED PART OF BOLT [4], REMOVE LAMINATED SHIMS [8] UNTIL IT DOES.
- 7** THE GAP "X" BETWEEN THE SHIMS [8] AND WASHER [5] IS MORE THAN 0.002 INCH (0.05 mm), ADD SHIMS [8] UNTIL THE GAP "X" IS BETWEEN 0.002-0.000 INCH (0.05-0.00 mm).
- 8** WHEN SHIM [8] ADJUSTMENTS ARE COMPLETE, TORQUE NUT TO 950-1400 POUND-INCHES (107.4-158.2 NEWTON-METERS).

2897833 S0000691380_V1

**INTERNAL-GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER LEADING EDGE
Figure 207/55-05-03-990-807 (Sheet 5 of 5)**

EFFECTIVITY
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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 235
May 15/2023



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

TASK 55-05-03-210-808

8. **INTERNAL - GENERAL VISUAL: LEFT HORIZONTAL STABILIZER LEADING EDGE**

(Figure 208)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
331	Left Horizontal Stabilizer - Removable Leading Edge

C. Access Panels

Number	Name/Location
331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body

D. Inspection

SUBTASK 55-05-03-010-008

- (1) Open this access panel:

Number	Name/Location
331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body

NOTE: Bolt removal is not required.

SUBTASK 55-05-03-210-008

- (2) Do a General Visual inspection of the left horizontal stabilizer front spar terminal fittings and center section front spar lugs.

SUBTASK 55-05-03-910-008

- (3) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 55-05-03-410-008

- (4) Close this access panel:

Number	Name/Location
331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body

————— **END OF TASK** —————

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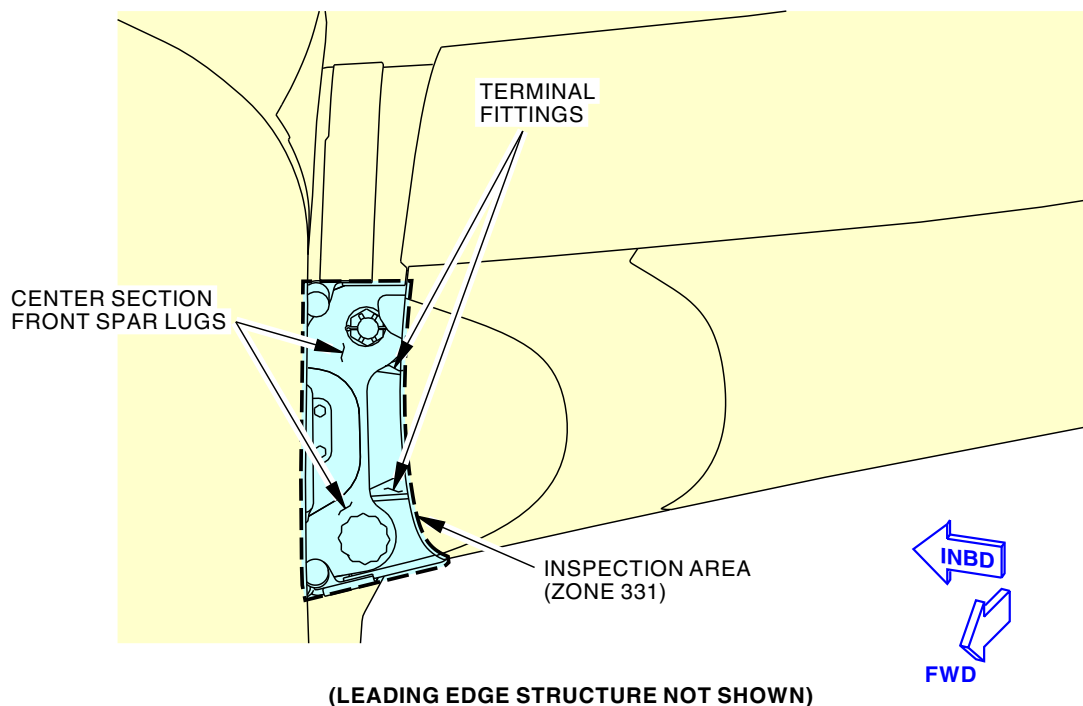
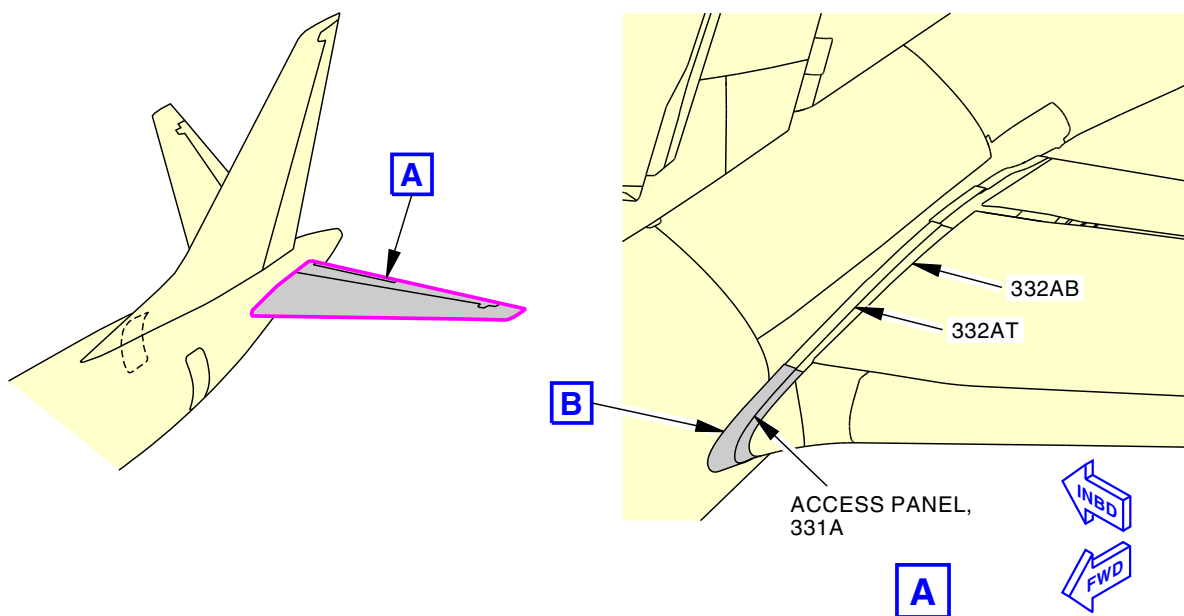
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55-05-03

Page 236
May 15/2023



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



MPD ITEM
55-080-01

2416332 S00061540456_V1

Left Horizontal Stabilizer Leading Edge General Visual (Internal)
Figure 208/55-05-03-990-808

EFFECTIVITY
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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 237
May 15/2023



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

TASK 55-05-03-210-809

9. **INTERNAL - GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER LEADING EDGE**

(Figure 209)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
341	Right Horizontal Stabilizer - Removable Leading Edge

C. Access Panels

Number	Name/Location
341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body

D. Inspection

SUBTASK 55-05-03-010-009

- (1) Open this access panel:

Number	Name/Location
341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body

NOTE: Bolt removal is not required.

SUBTASK 55-05-03-210-009

- (2) Do a General Visual inspection of the right horizontal stabilizer front spar terminal fittings and center section front spar lugs.

SUBTASK 55-05-03-910-009

- (3) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 55-05-03-410-009

- (4) Close this access panel:

Number	Name/Location
341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body

————— **END OF TASK** —————

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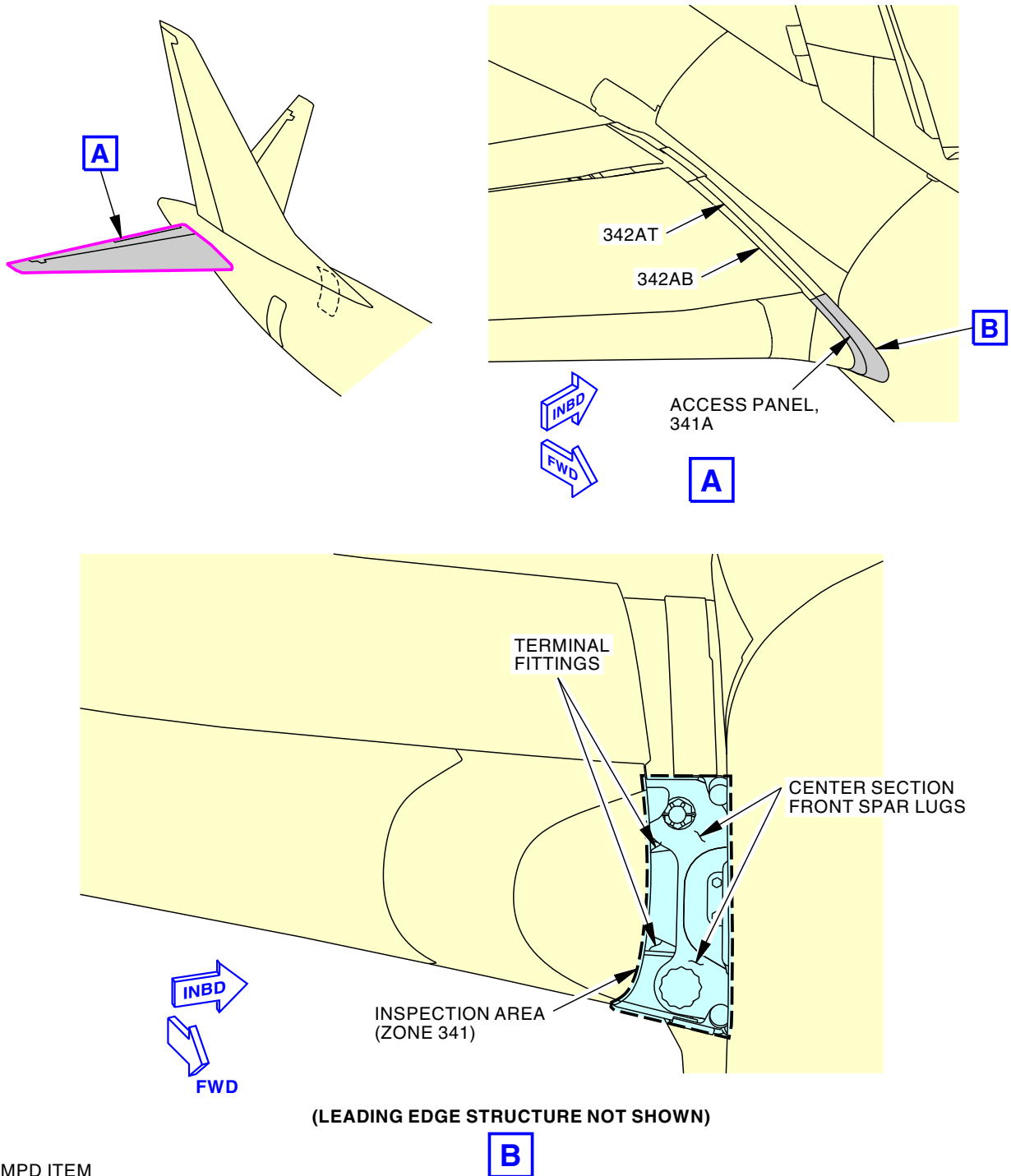
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 238
May 15/2023

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



MPD ITEM
55-080-02

2416333 S00061540458_V1

Right Horizontal Stabilizer Leading Edge General Visual (Internal)
Figure 209/55-05-03-990-809

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 239
May 15/2023



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

TASK 55-05-03-210-810

10. **INTERNAL - GENERAL VISUAL: LEFT HORIZONTAL STABILIZER**

(Figure 210)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
27-41-21-000-801	Horizontal Stabilizer Leading Edge Removal (P/B 401)
27-41-21-400-801	Horizontal Stabilizer Leading Edge Installation (P/B 401)
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

B. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II

C. Location Zones

Zone	Area
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 249.81

D. Access Panels

Number	Name/Location
331BL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331BZ	WEB ASSY - HORIZONTAL STABLIZER FRONT SPAR
331CL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331CZ	WEB ASSY - HORIZONTAL STABLIZER FRONT SPAR
331DL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331DZ	WEB ASSY - HORIZONTAL STABLIZER FRONT SPAR
331EL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332BB	Horizontal Stabilizer, Access Door
332CB	Horizontal Stabilizer, Access Door
332DB	Horizontal Stabilizer, Access Door
332EB	Horizontal Stabilizer, Access Door
332FB	Horizontal Stabilizer, Access Door
332GB	Horizontal Stabilizer, Access Door
332HB	Horizontal Stabilizer, Access Door
332JB	Horizontal Stabilizer, Access Door
332KB	Horizontal Stabilizer, Access Door
332LB	Horizontal Stabilizer, Access Door
332MB	Horizontal Stabilizer, Access Door
332NB	Horizontal Stabilizer, Access Door
335A	Horizontal Stabilizer, Removable Stabilizer Tip

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 240
Sep 15/2023



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

E. Inspection

SUBTASK 55-05-03-010-010

- (1) Open these access panels:

(TASK 27-41-21-000-801)

<u>Number</u>	<u>Name/Location</u>
331BL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331CL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331DL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331EL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER

SUBTASK 55-05-03-010-021

- (2) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
331BZ	WEB ASSY - HORIZONTAL STABILIZER FRONT SPAR
331CZ	WEB ASSY - HORIZONTAL STABILIZER FRONT SPAR
331DZ	WEB ASSY - HORIZONTAL STABILIZER FRONT SPAR
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332BB	Horizontal Stabilizer, Access Door
332CB	Horizontal Stabilizer, Access Door
332DB	Horizontal Stabilizer, Access Door
332EB	Horizontal Stabilizer, Access Door
332FB	Horizontal Stabilizer, Access Door
332GB	Horizontal Stabilizer, Access Door
332HB	Horizontal Stabilizer, Access Door
332JB	Horizontal Stabilizer, Access Door
332KB	Horizontal Stabilizer, Access Door
332LB	Horizontal Stabilizer, Access Door
332MB	Horizontal Stabilizer, Access Door
332NB	Horizontal Stabilizer, Access Door
335A	Horizontal Stabilizer, Removable Stabilizer Tip

SUBTASK 55-05-03-210-010

- (3) Do a General Visual inspection of the left horizontal stabilizer from front spar to rear spar including spar chords, webs, terminal fittings, upper and lower inspar skins.

SUBTASK 55-05-03-910-010

- (4) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 55-05-03-410-010

- (5) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
331BZ	WEB ASSY - HORIZONTAL STABILIZER FRONT SPAR
331CZ	WEB ASSY - HORIZONTAL STABILIZER FRONT SPAR
331DZ	WEB ASSY - HORIZONTAL STABILIZER FRONT SPAR
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332BB	Horizontal Stabilizer, Access Door
332CB	Horizontal Stabilizer, Access Door

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 241
Sep 15/2023



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

(Continued)

<u>Number</u>	<u>Name/Location</u>
332DB	Horizontal Stabilizer, Access Door
332EB	Horizontal Stabilizer, Access Door
332FB	Horizontal Stabilizer, Access Door
332GB	Horizontal Stabilizer, Access Door
332HB	Horizontal Stabilizer, Access Door
332JB	Horizontal Stabilizer, Access Door
332KB	Horizontal Stabilizer, Access Door
332LB	Horizontal Stabilizer, Access Door
332MB	Horizontal Stabilizer, Access Door
332NB	Horizontal Stabilizer, Access Door
335A	Horizontal Stabilizer, Removable Stabilizer Tip

SUBTASK 55-05-03-410-029

- (6) Close these access panels:

(TASK 27-41-21-400-801)

<u>Number</u>	<u>Name/Location</u>
331BL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331CL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331DL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER
331EL	LEADING EDGE - REMOVEABLE HORIZONTAL STABILIZER

SUBTASK 55-05-03-390-006

- (7) Apply an aerodynamic smoother sealant, A02315, to all non-bonded structural components contacting exterior skins.

NOTE: Sealant does not need to be applied to gaps between panels that are used for regular access as long as they are less than limits given in the Structural Repair Manual (SRM SUBJECT 51-10-01).

- (a) Do this task: Aerodynamic Smoother Application, TASK 51-22-00-390-809.

————— **END OF TASK** —————

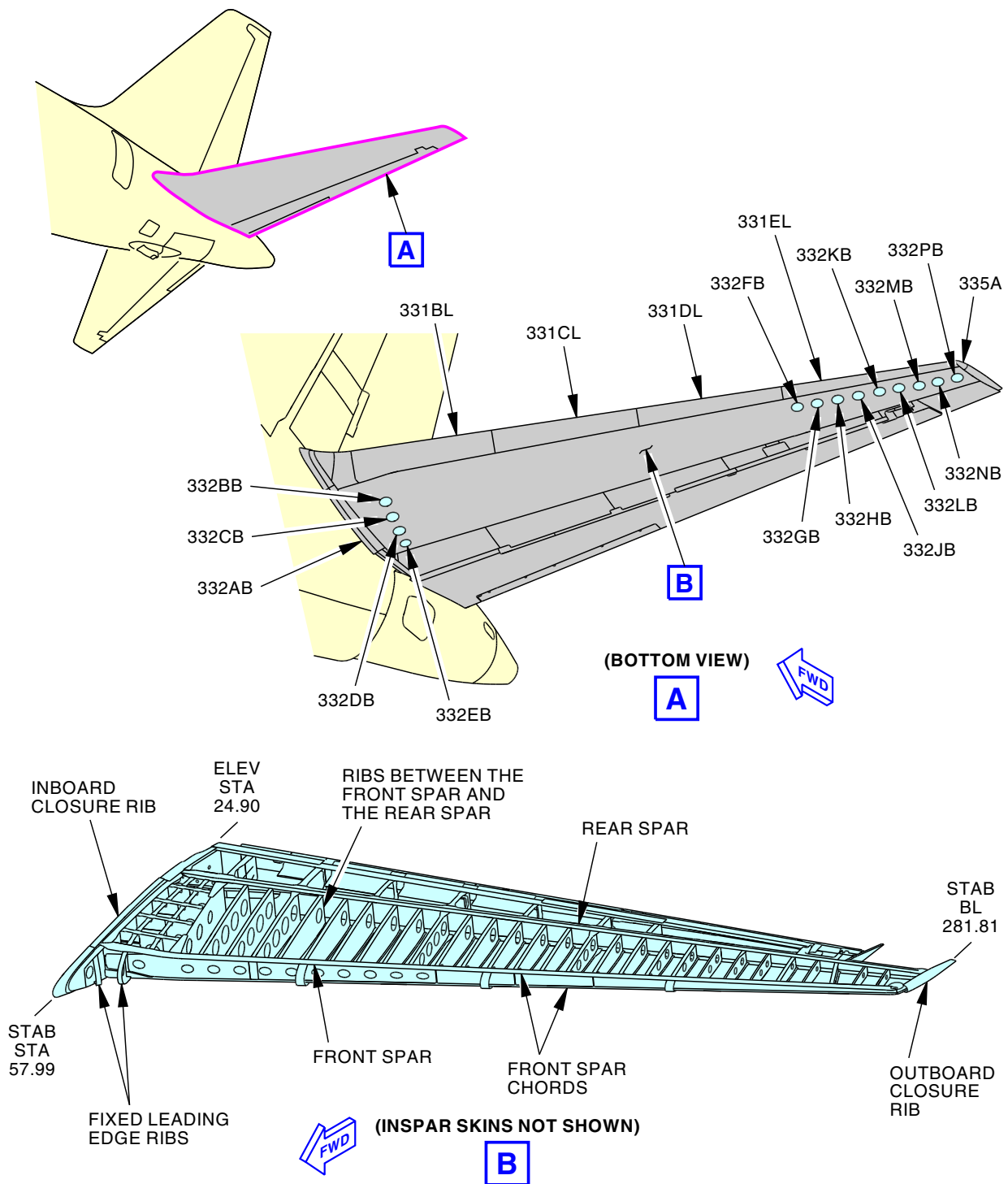
EFFECTIVITY
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 242
Sep 15/2023



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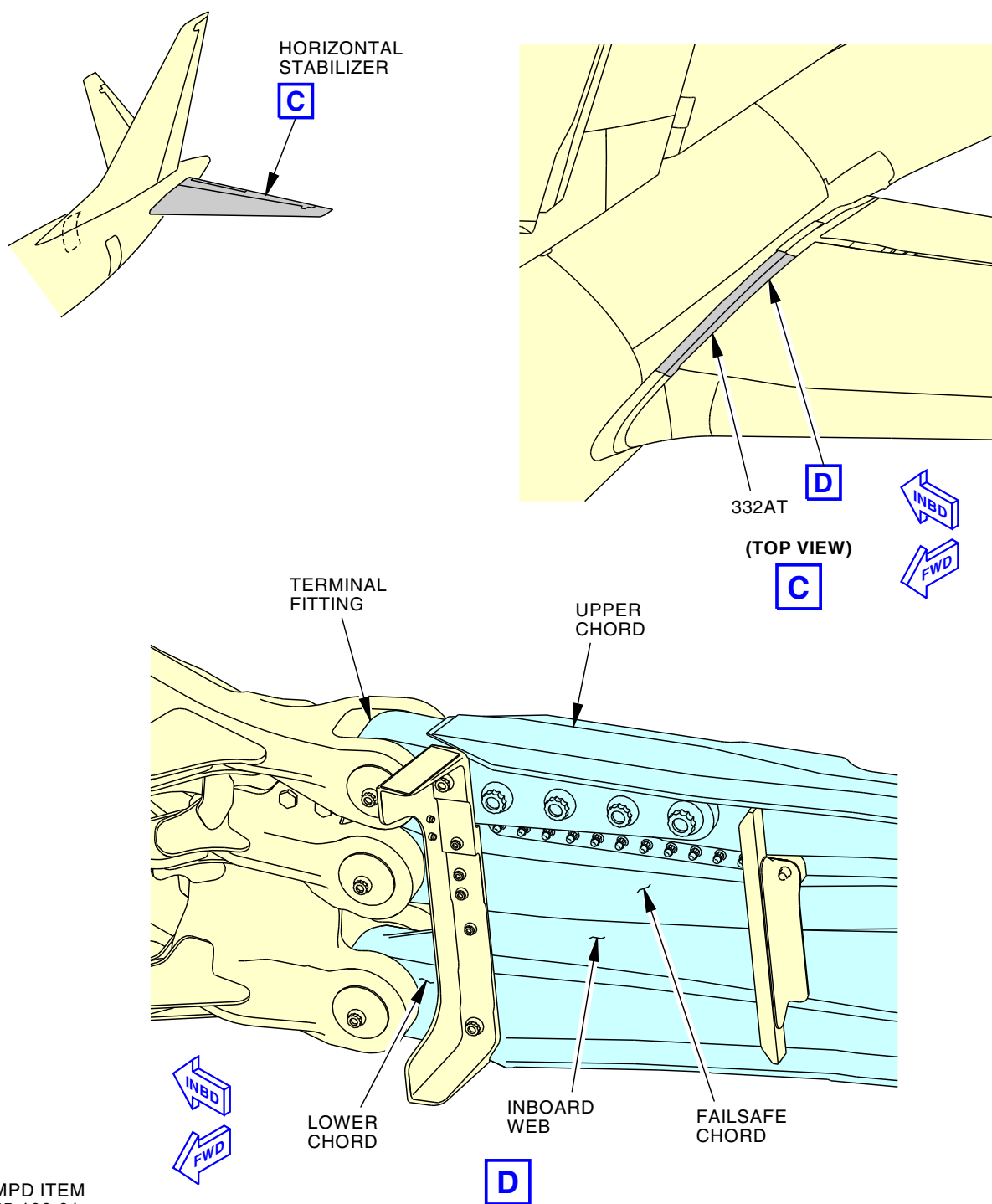
INTERNAL-GENERAL VISUAL: LEFT HORIZONTAL STABILIZER
Figure 210/55-05-03-990-810 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

55-05-03

Page 243
May 15/2023

D633AM101-SIA



MPD ITEM
55-100-01

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INTERNAL-GENERAL VISUAL: LEFT HORIZONTAL STABILIZER
Figure 210/55-05-03-990-810 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

55-05-03

D633AM101-SIA

Page 244
May 15/2023



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

TASK 55-05-03-210-811

11. **INTERNAL - GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER**

(Figure 211)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
27-41-21-000-801	Horizontal Stabilizer Leading Edge Removal (P/B 401)
27-41-21-400-801	Horizontal Stabilizer Leading Edge Installation (P/B 401)
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

B. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II

C. Location Zones

Zone	Area
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 249.81

D. Access Panels

Number	Name/Location
341BR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341BZ	WEB ASSY - HORIZONTAL STABLIZER FRONT SPAR
341CR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341CZ	WEB ASSY - HORIZONTAL STABLIZER FRONT SPAR
341DR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341DZ	WEB ASSY - HORIZONTAL STABLIZER FRONT SPAR
341ER	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342AT	Gap Cover, Horizontal Stabilizer
342BB	Horizontal Stabilizer, Access Door
342CB	Horizontal Stabilizer, Access Door
342DB	Horizontal Stabilizer, Access Door
342EB	Horizontal Stabilizer, Access Door
342FB	Horizontal Stabilizer, Access Door
342GB	Horizontal Stabilizer, Access Door
342HB	Horizontal Stabilizer, Access Door
342JB	Horizontal Stabilizer, Access Door
342KB	Horizontal Stabilizer, Access Door
342LB	Horizontal Stabilizer, Access Door
342MB	Horizontal Stabilizer, Access Door
342NB	Horizontal Stabilizer, Access Door
345A	Horizontal Stabilizer, Removable Stabilizer Tip

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 245
Sep 15/2023



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

E. Inspection

SUBTASK 55-05-03-010-011

- (1) Open these access panels:

(TASK 27-41-21-000-801)

<u>Number</u>	<u>Name/Location</u>
341BR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341CR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341DR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341ER	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER

SUBTASK 55-05-03-010-022

- (2) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
341BZ	WEB ASSY - HORIZONTAL STABILIZER FRONT SPAR
341CZ	WEB ASSY - HORIZONTAL STABILIZER FRONT SPAR
341DZ	WEB ASSY - HORIZONTAL STABILIZER FRONT SPAR
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342AT	Gap Cover, Horizontal Stabilizer
342BB	Horizontal Stabilizer, Access Door
342CB	Horizontal Stabilizer, Access Door
342DB	Horizontal Stabilizer, Access Door
342EB	Horizontal Stabilizer, Access Door
342FB	Horizontal Stabilizer, Access Door
342GB	Horizontal Stabilizer, Access Door
342HB	Horizontal Stabilizer, Access Door
342JB	Horizontal Stabilizer, Access Door
342KB	Horizontal Stabilizer, Access Door
342LB	Horizontal Stabilizer, Access Door
342MB	Horizontal Stabilizer, Access Door
342NB	Horizontal Stabilizer, Access Door
345A	Horizontal Stabilizer, Removable Stabilizer Tip

SUBTASK 55-05-03-210-011

- (3) Do a General Visual inspection of the right horizontal stabilizer from front spar to rear spar including spar chords, webs, terminal fittings, upper and lower inspar skins.

SUBTASK 55-05-03-910-011

- (4) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 55-05-03-410-011

- (5) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
341BZ	WEB ASSY - HORIZONTAL STABILIZER FRONT SPAR
341CZ	WEB ASSY - HORIZONTAL STABILIZER FRONT SPAR
341DZ	WEB ASSY - HORIZONTAL STABILIZER FRONT SPAR
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342AT	Gap Cover, Horizontal Stabilizer
342BB	Horizontal Stabilizer, Access Door
342CB	Horizontal Stabilizer, Access Door

EFFECTIVITY
SIA ALL

D633AM101-SIA

55-05-03

Page 246
Sep 15/2023



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

(Continued)

<u>Number</u>	<u>Name/Location</u>
342DB	Horizontal Stabilizer, Access Door
342EB	Horizontal Stabilizer, Access Door
342FB	Horizontal Stabilizer, Access Door
342GB	Horizontal Stabilizer, Access Door
342HB	Horizontal Stabilizer, Access Door
342JB	Horizontal Stabilizer, Access Door
342KB	Horizontal Stabilizer, Access Door
342LB	Horizontal Stabilizer, Access Door
342MB	Horizontal Stabilizer, Access Door
342NB	Horizontal Stabilizer, Access Door
345A	Horizontal Stabilizer, Removable Stabilizer Tip

SUBTASK 55-05-03-410-030

- (6) Close these access panels:

(TASK 27-41-21-400-801)

<u>Number</u>	<u>Name/Location</u>
341BR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341CR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341DR	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER
341ER	LEADING EDGE - REMOVABLE HORIZONTAL STABILIZER

SUBTASK 55-05-03-390-007

- (7) Apply an aerodynamic smoother sealant, A02315, to all non-bonded structural components contacting exterior skins.

NOTE: Sealant does not need to be applied to gaps between panels that are used for regular access as long as they are less than limits given in the Structural Repair Manual (SRM SUBJECT 51-10-01).

- (a) Do this task: Aerodynamic Smoother Application, TASK 51-22-00-390-809.

————— END OF TASK —————

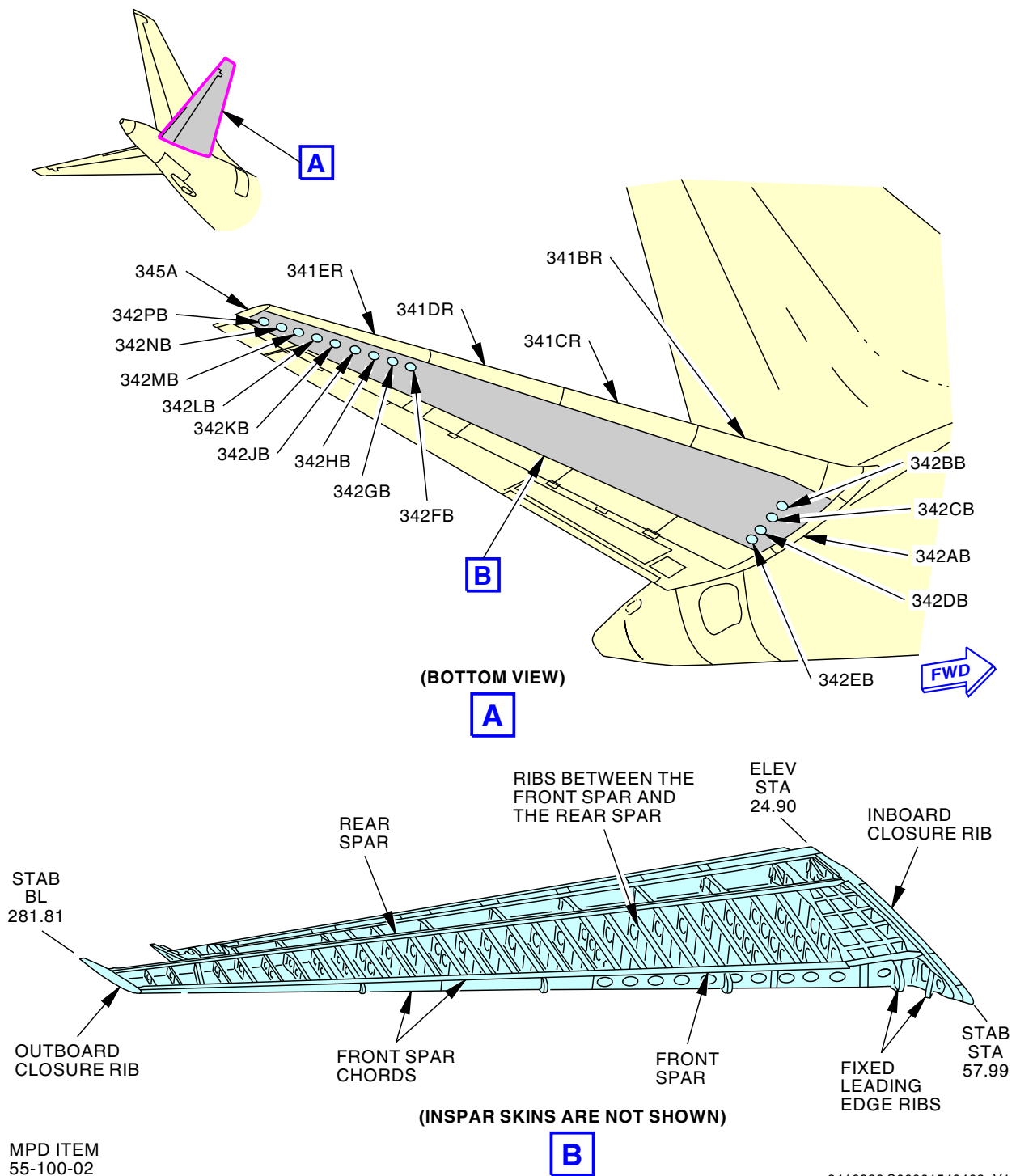
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 247
Sep 15/2023



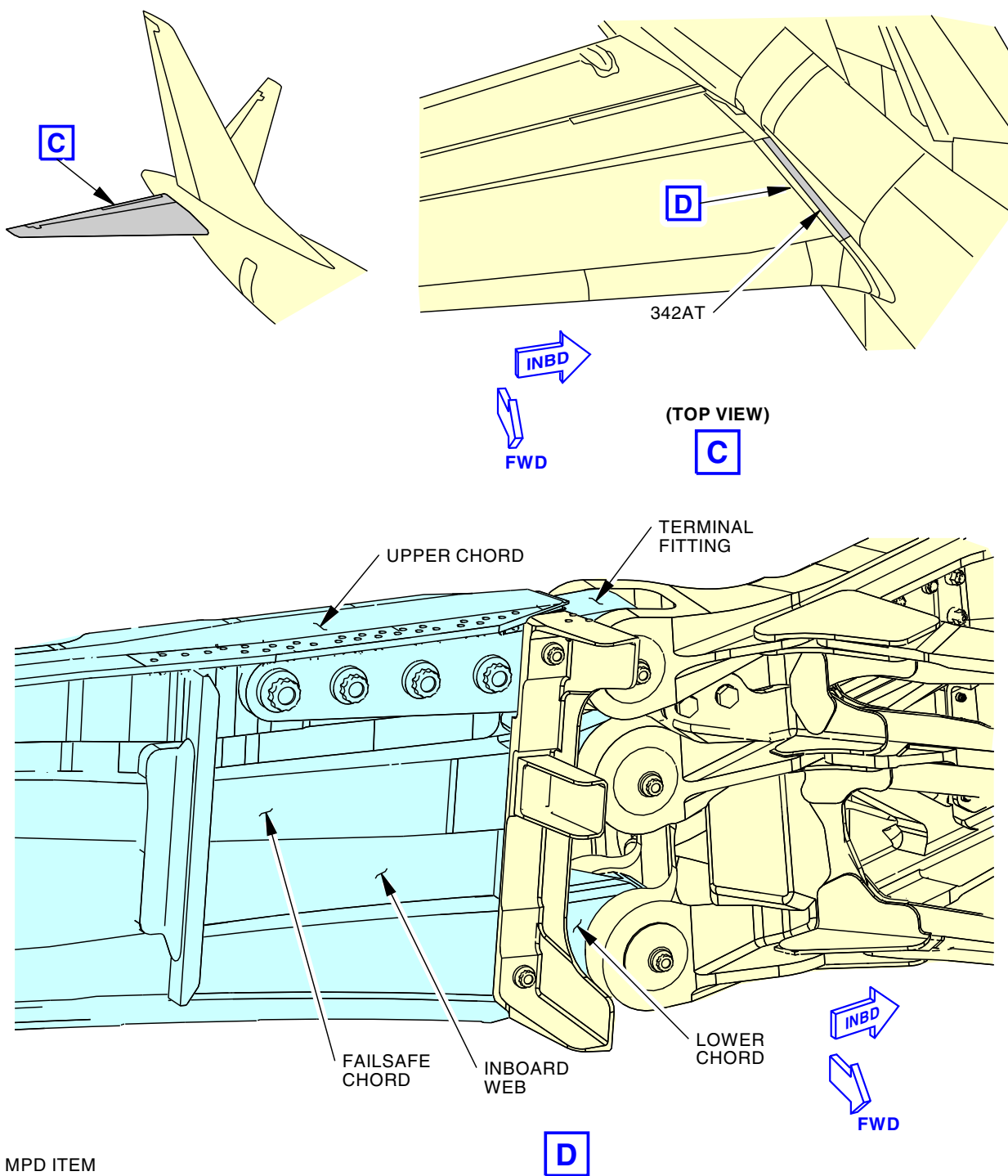
INTERNAL-GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER
Figure 211/55-05-03-990-811 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

55-05-03

Page 248
May 15/2023



MPD ITEM
55-100-02

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INTERNAL-GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER
Figure 211/55-05-03-990-811 (Sheet 2 of 2)

EFFECTIVITY
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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 249
May 15/2023



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

TASK 55-05-03-210-812

**12. INTERNAL - GENERAL VISUAL: LEFT HORIZONTAL STABILIZER TRAILING EDGE AND ELEVATOR
TAB LEADING EDGE**

(Figure 212)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
27-31-41-000-801	Elevator Balance Panel - Removal (P/B 401)
27-31-41-400-801	Elevator Balance Panel - Installation (P/B 401)
51-05-01-210-804	737-7/8/8200/9 Basic Task Description (P/B 201)
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

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-2035	Sling Equipment - Horizontal Stabilizer Part #: C55014-1 Supplier: 81205
STD-12395	Load Cell Equipment

C. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38

D. Location Zones

Zone	Area
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge

E. Access Panels

Number	Name/Location
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334BB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334CB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334DB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334EB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 250
May 15/2023



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

(Continued)

Number	Name/Location
335A	Horizontal Stabilizer, Removable Stabilizer Tip
S3331	Left Horizontal Stabilizer Trailing Edge Inspection

F. Prepare for the Inspection

SUBTASK 55-05-03-480-003

- (1) Install the sling equipment, SPL-2035.
 - (a) Remove the bolts [21] and bolts [22] from the stabilizer top surface.



CAUTION

MAKE SURE YOU INSTALL THE HOISTING SLING CORRECTLY WHEN YOU REMOVE THE HORIZONTAL STABILIZER WITH OR WITHOUT THE ELEVATOR INSTALLED. IF YOU DO NOT INSTALL THE HOISTING SLING CORRECTLY FOR THE REMOVAL OF THE HORIZONTAL STABILIZER, YOU CAN CAUSE DAMAGE TO EQUIPMENT.

- (b) Attach the sling equipment, SPL-2035, to the horizontal stabilizer with fasteners.

NOTE: Low clearance sling is used only with elevator removed.

- (c) Attach the load cell, STD-12395, to the sling equipment, SPL-2035.
 - (d) Attach a hoist to the load cell, STD-12395.



CAUTION

YOU MUST CAREFULLY LIFT THE HOISTING SLING. A SUDDEN MOVEMENT OF THE HOISTING SLING CAN CAUSE DAMAGE TO THE HORIZONTAL STABILIZER.

- (e) Lift the weight of the horizontal stabilizer.
 - 1) Use the load cell, STD-12395, to make sure that the force used when lifting horizontal stabilizer is not more than:
 - 888 lb (403 kg) or (830 lb (376 kg) airplane part + 58 lb (26 kg) tool) with elevator attached.
 - 688 lb (312 kg) or (630 lb (286 kg) airplane part + 58 lb (26 kg) tool) without elevator attached.

G. Inspection

SUBTASK 55-05-03-010-012

- (1) Open these access panels:

Number	Name/Location
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334BB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334CB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334DB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator

EFFECTIVITY
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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 251
May 15/2023



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

(Continued)

<u>Number</u>	<u>Name/Location</u>
334EB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
335A	Horizontal Stabilizer, Removable Stabilizer Tip

Special Access:

<u>Number</u>	<u>Name/Location</u>
S3331	Left Horizontal Stabilizer Trailing Edge Inspection

NOTE: Bolt removal is required to inspect terminal fittings and center section rear spar lugs, except at rear spar upper lugs and clevis.

SUBTASK 55-05-03-020-003

- (2) Disconnect the balance panels in the balance bays (TASK 27-31-41-000-801).

SUBTASK 55-05-03-020-004

- (3) If installed, remove tab hinge covers to inspect elevator tab leading edge.

SUBTASK 55-05-03-020-005

- (4) Remove the horizontal stabilizer rear spar bolts:

NOTE: It is not required to remove the bolts at the upper lugs and clevis at the rear spar.

NOTE: If the bolts are frozen, use equipment, SPL-2030, to assist in removal.

- (a) Remove and keep the nuts [25] and washers [24] from the bolt [28] and bolt [29].

1) Keep a record of where each part came from.

- (b) Remove and keep the bolt [28], bolt [29], washers [27], and washers [23].

1) Keep a record of where each part came from.

- (c) Remove and keep the pins [26] and washers [30].

1) Keep a record of where each part came from.

NOTE: If necessary, adjust the tension of the sling equipment, SPL-2035, to aid removal of the pins [26].

SUBTASK 55-05-03-100-005

- (5) Clean the joint per SOPM 20-30-03 to remove dirt, debris, and existing grime.

SUBTASK 55-05-03-210-012

- (6) Do a General Visual inspection of the aft side of left horizontal stabilizer rear spar, including spar chords and webs, terminal fittings, elevator tab actuator support fitting, center section rear spar lugs, elevator hinge ribs, elevator tab leading edge, and pins [26].

SUBTASK 55-05-03-910-012

- (7) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 55-05-03-100-006

- (8) Apply the corrosion inhibiting material, G50136, to the bolts and joints, including the inner diameter of bushings.

SUBTASK 55-05-03-420-003

- (9) Install the pins [26] and washers [30].

SUBTASK 55-05-03-420-004

- (10) Install the bolt [28], bolt [29], washers [27], and washers [23].

EFFECTIVITY
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 252
May 15/2023



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

SUBTASK 55-05-03-420-005

- (11) Install the nuts [25] and washers [24] on the bolt [28] and bolt [29].

H. Put the Airplane Back to Its Usual Condition

SUBTASK 55-05-03-420-006

- (1) If previously removed, reinstall the tab hinge covers.

SUBTASK 55-05-03-420-007

- (2) Reconnect the balance panels in the balance bay (TASK 27-31-41-400-801).

SUBTASK 55-05-03-410-021

- (3) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334BB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334CB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334DB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334EB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
335A	Horizontal Stabilizer, Removable Stabilizer Tip

SUBTASK 55-05-03-390-008

- (4) Apply an aerodynamic smoother sealant, A02315, to all non-bonded structural components contacting exterior skins.

NOTE: Sealant does not need to be applied to gaps between panels that are used for regular access as long as they are less than limits given in the Structural Repair Manual (SRM SUBJECT 51-10-01).

- (a) Do this task: Aerodynamic Smoother Application, TASK 51-22-00-390-809.

SUBTASK 55-05-03-080-003

- (5) Remove the sling equipment, SPL-2035.
- (a) Release tension applied to the sling equipment, SPL-2035.
- (b) Remove the hoist from the load cell, STD-12395.
- (c) Remove the load cell, STD-12395, from the sling equipment, SPL-2035.
- (d) Remove the fasteners that attach the sling equipment, SPL-2035.
- (e) Install the bolts [21] and bolts [22] at the horizontal stabilizer top surface.

————— **END OF TASK** —————

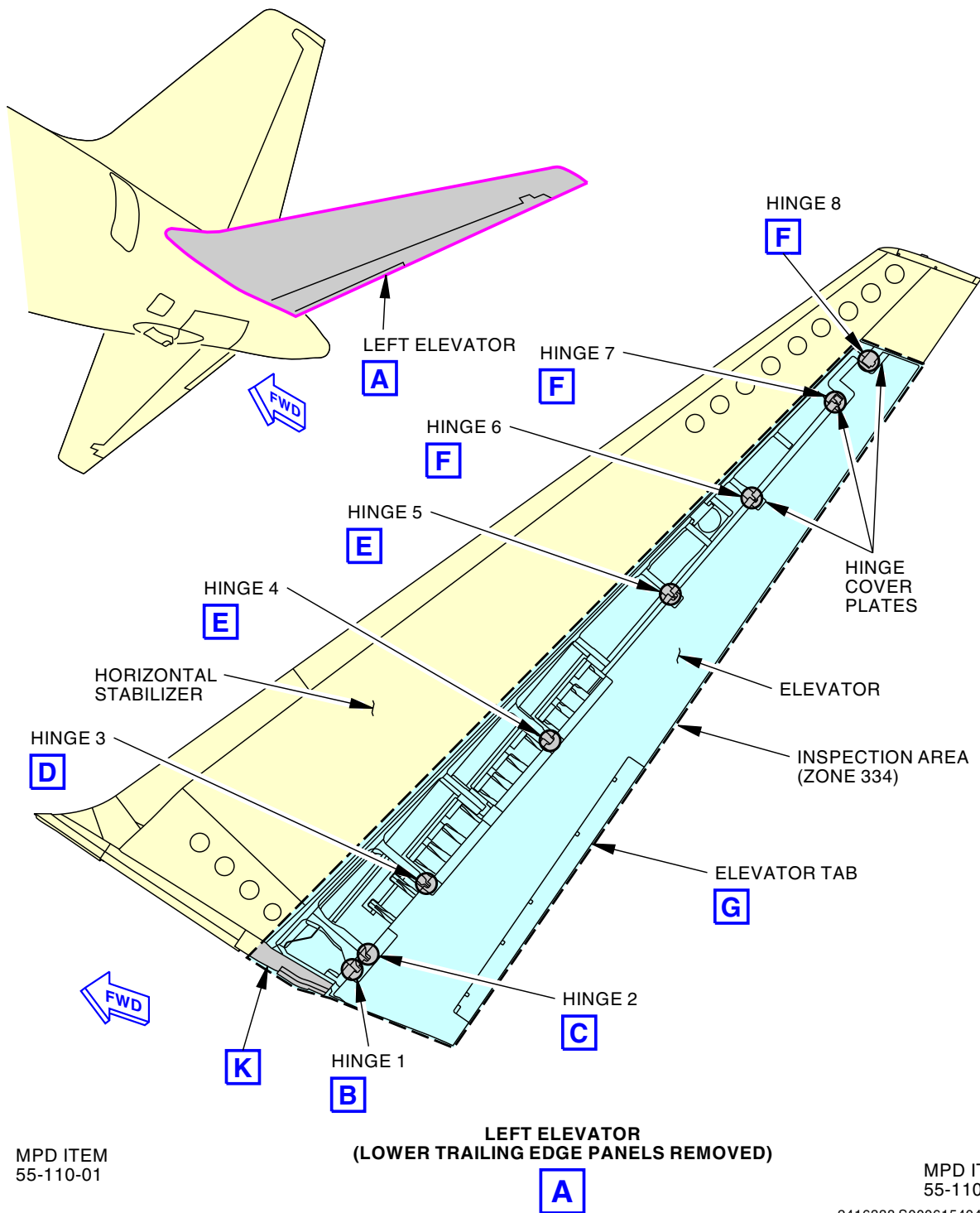
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 253
May 15/2023



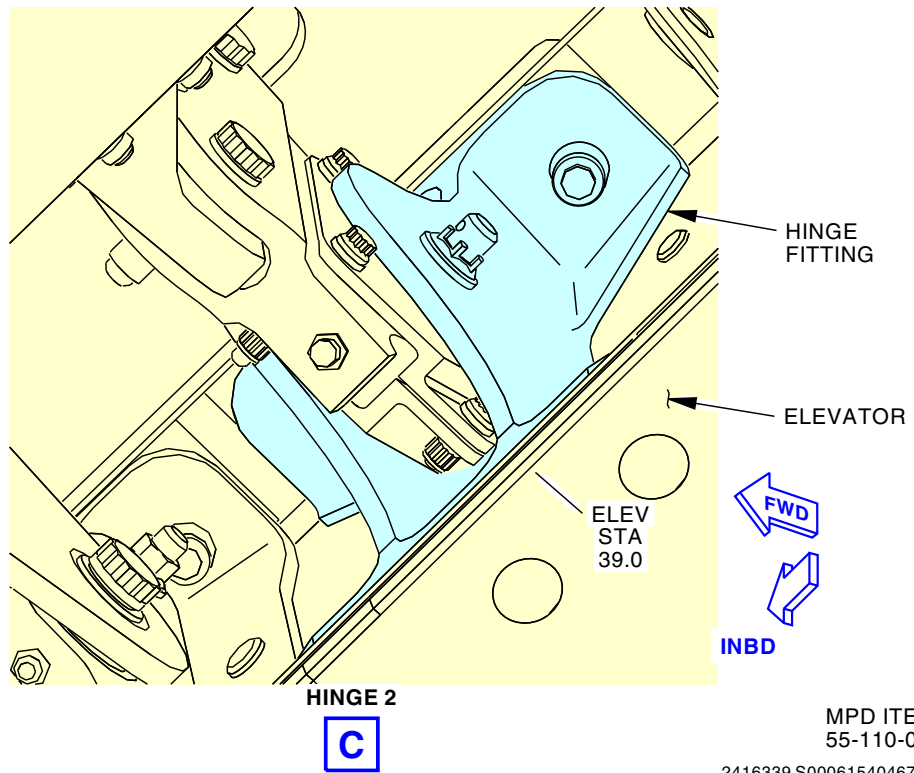
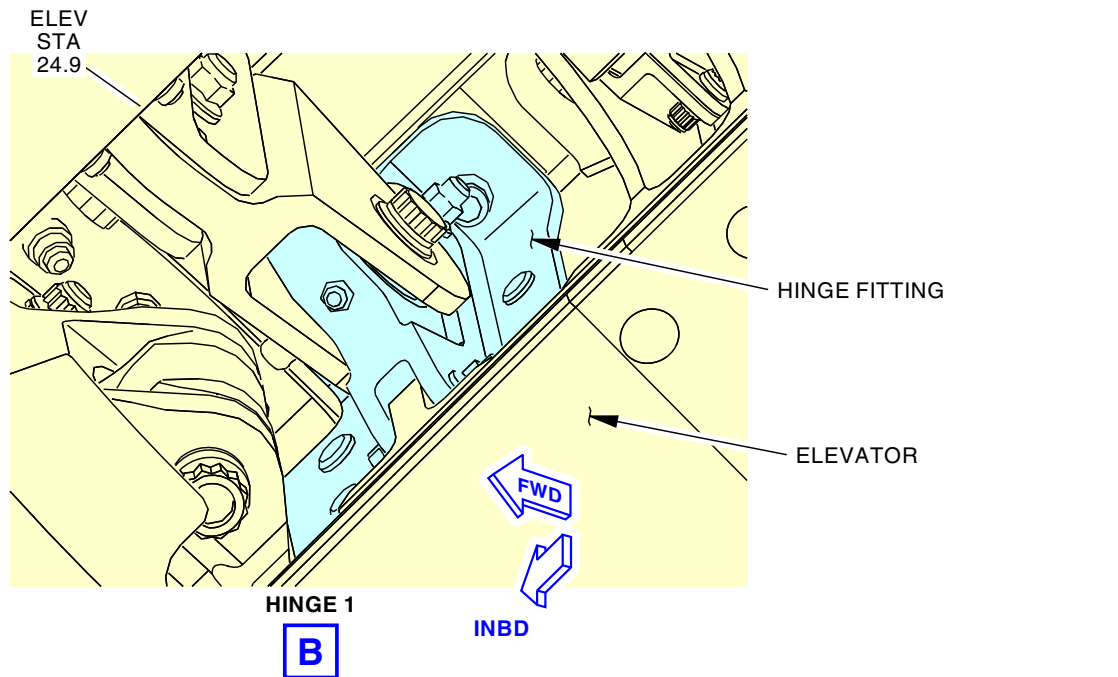
Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)

Figure 212/55-05-03-990-812 (Sheet 1 of 10)

EFFECTIVITY
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55-05-03

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



MPD ITEM
55-110-01

MPD ITEM
55-110-01

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Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)
Figure 212/55-05-03-990-812 (Sheet 2 of 10)

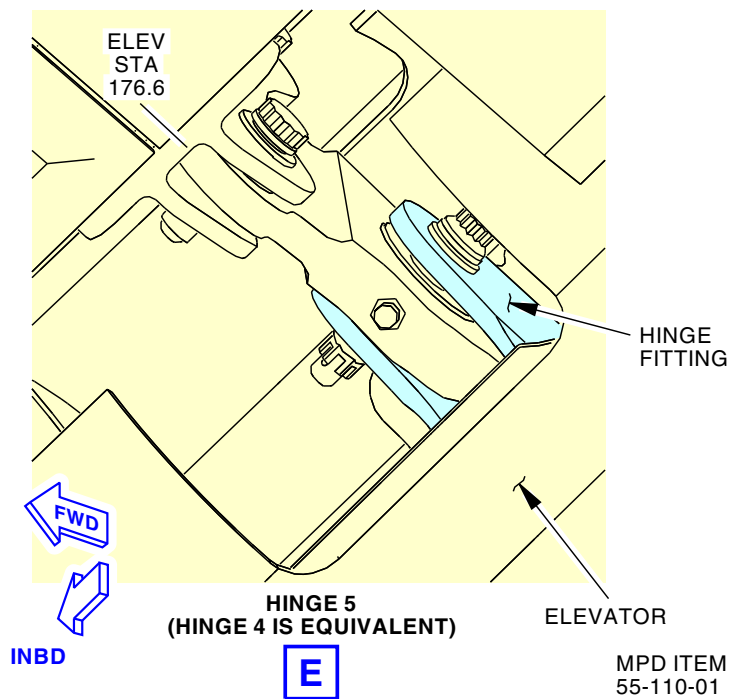
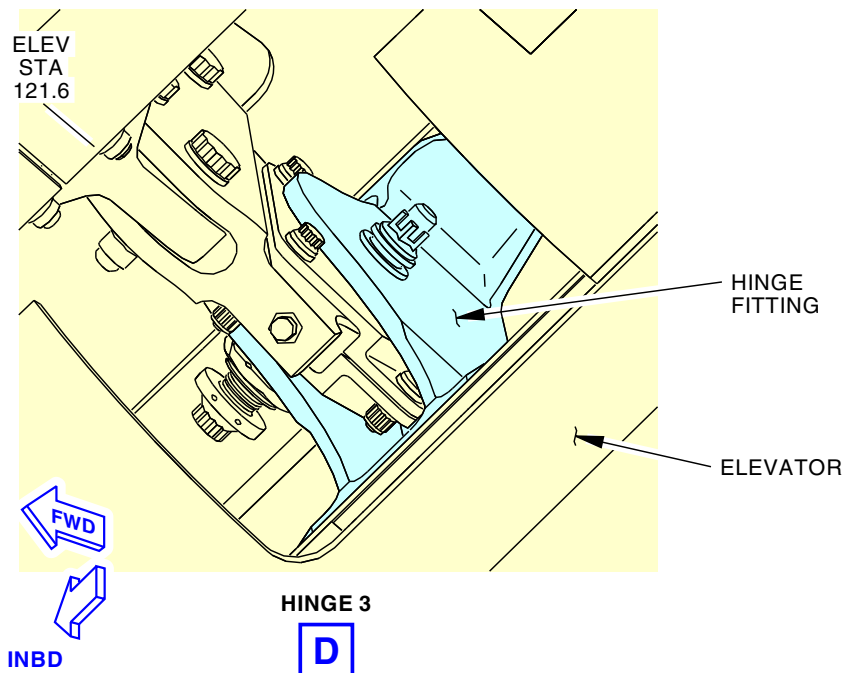
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 255
May 15/2023



MPD ITEM
55-110-01

MPD ITEM
55-110-01
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Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual
(Internal)

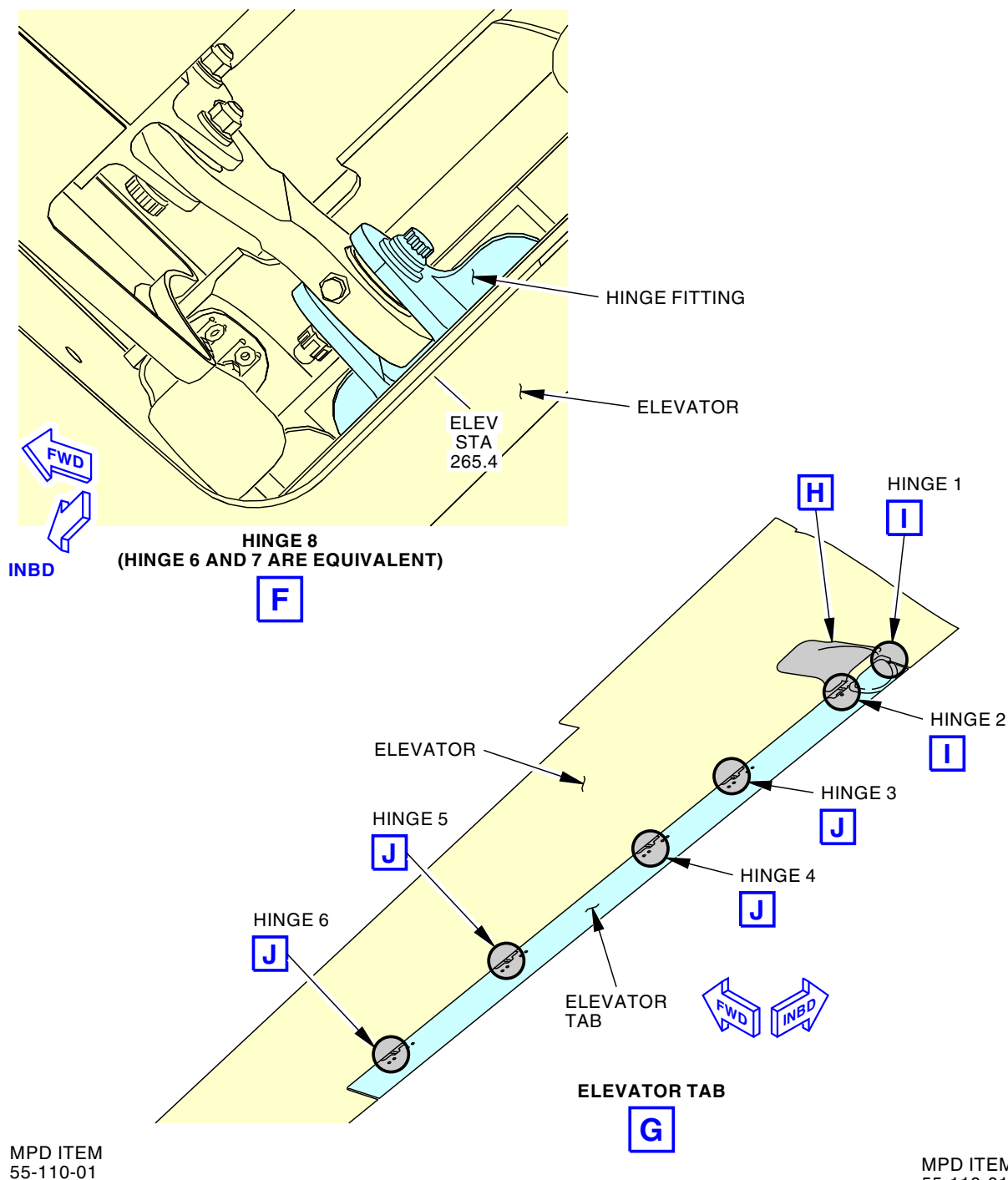
Figure 212/55-05-03-990-812 (Sheet 3 of 10)

EFFECTIVITY
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D633AM101-SIA

55-05-03

Page 256
May 15/2023



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Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual
(Internal)

Figure 212/55-05-03-990-812 (Sheet 4 of 10)

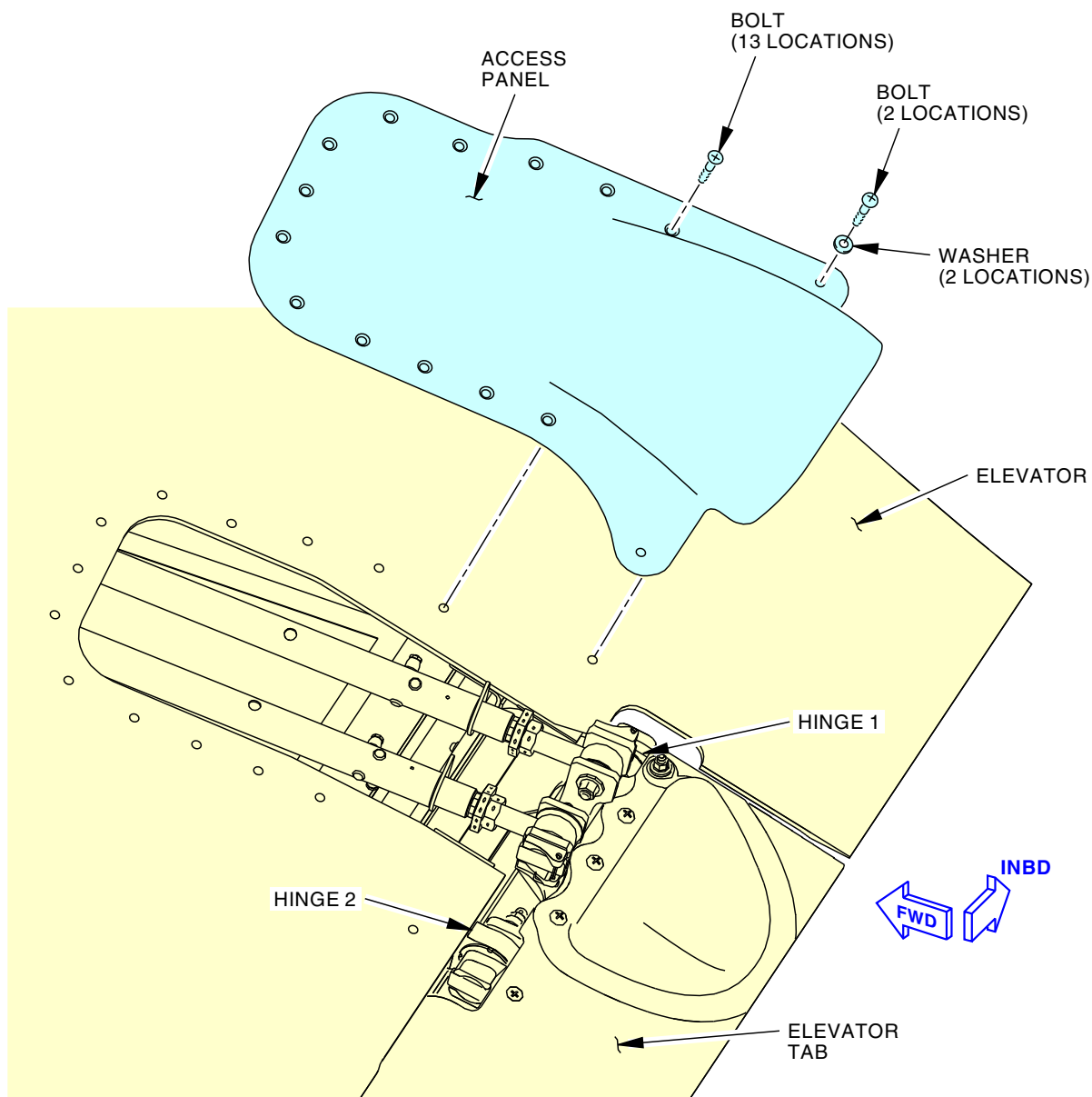
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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



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55-110-01

MPD ITEM
55-110-01

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Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual
(Internal)

Figure 212/55-05-03-990-812 (Sheet 5 of 10)

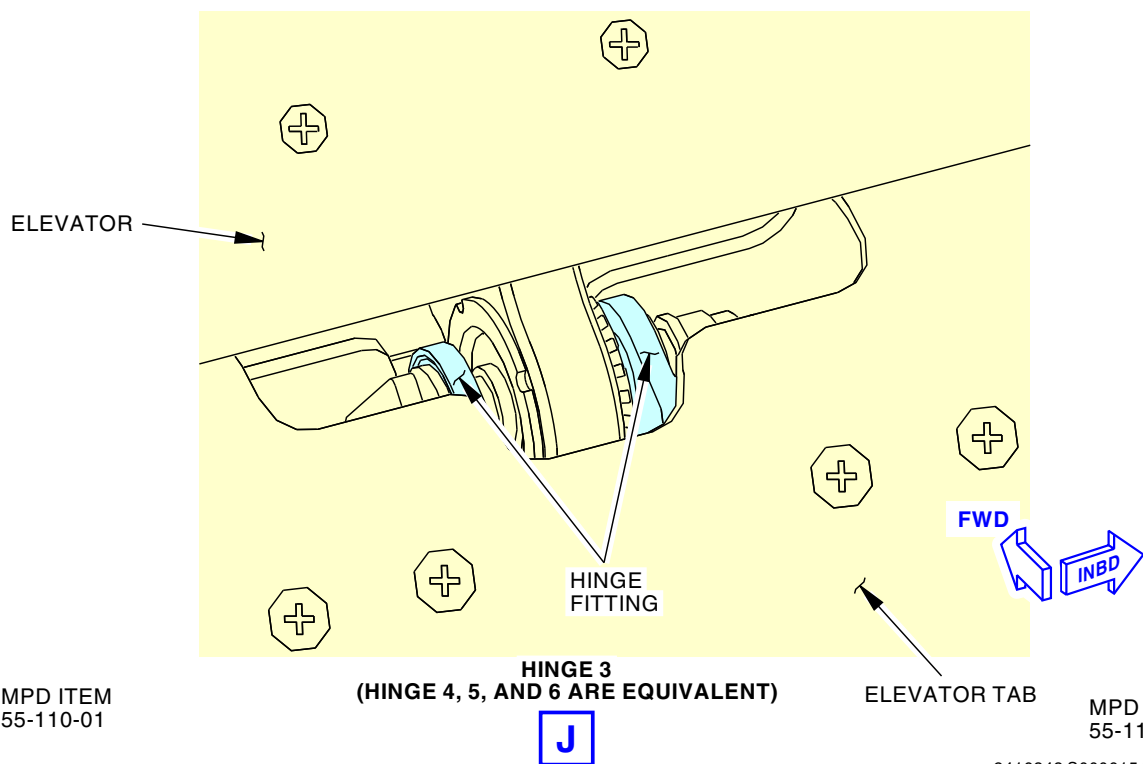
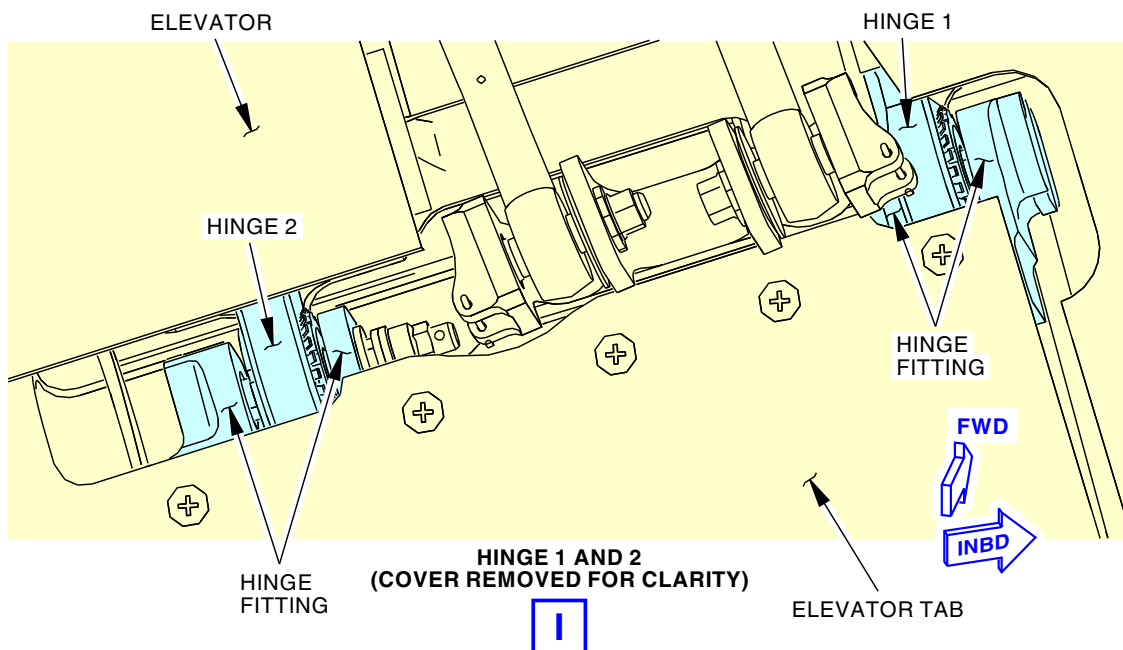
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55-05-03

D633AM101-SIA

Page 258
May 15/2023

ECCN 9E991 BOEING PROPRIETARY - See title page for details



MPD ITEM
55-110-01

HINGE 3
(HINGE 4, 5, AND 6 ARE EQUIVALENT)

ELEVATOR TAB

MPD ITEM
55-110-01

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Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual
(Internal)
Figure 212/55-05-03-990-812 (Sheet 6 of 10)

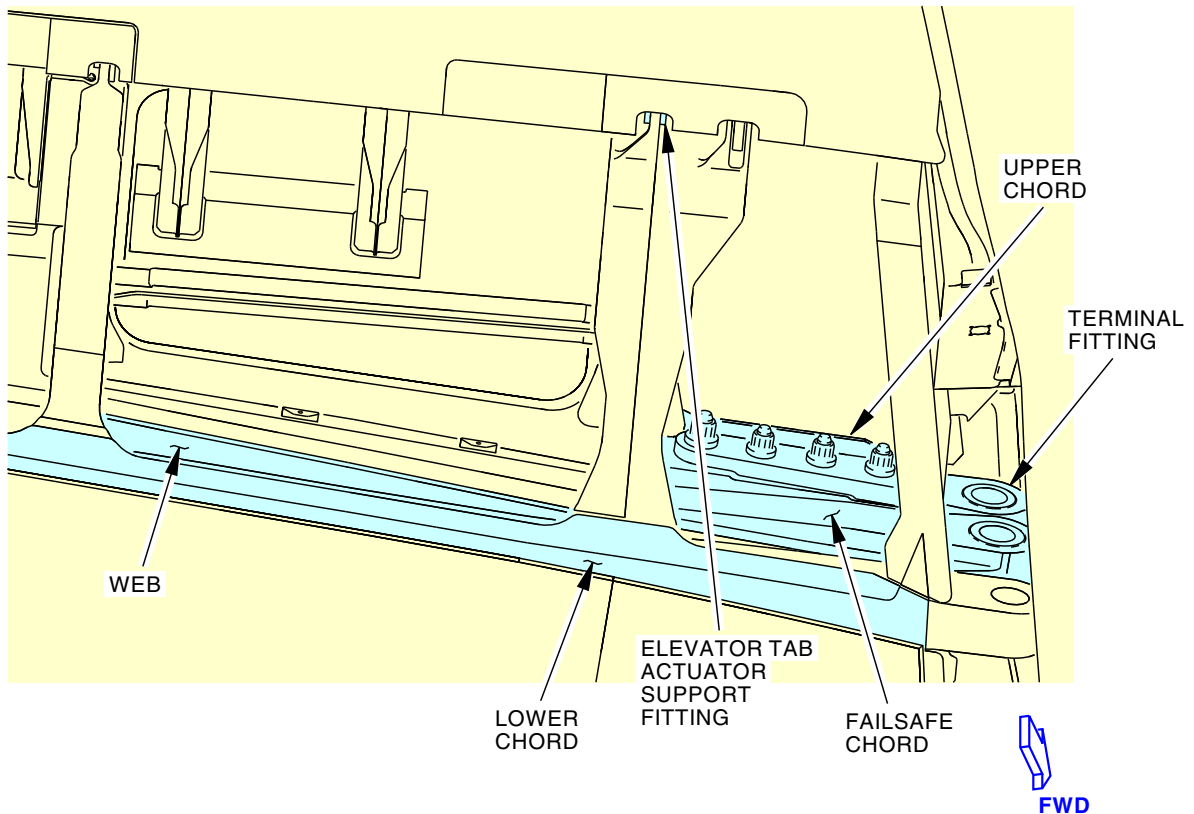
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 259
May 15/2023



LEFT HORIZONTAL STABILIZER REAR SPAR CHORDS, WEB, TERMINAL FITTINGS AND TAB ACTUATOR FITTING (PANELS REMOVED FOR CLARITY)

K

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55-110-01

MPD ITEM
55-110-01

2416344 S00061540472_V1

Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)

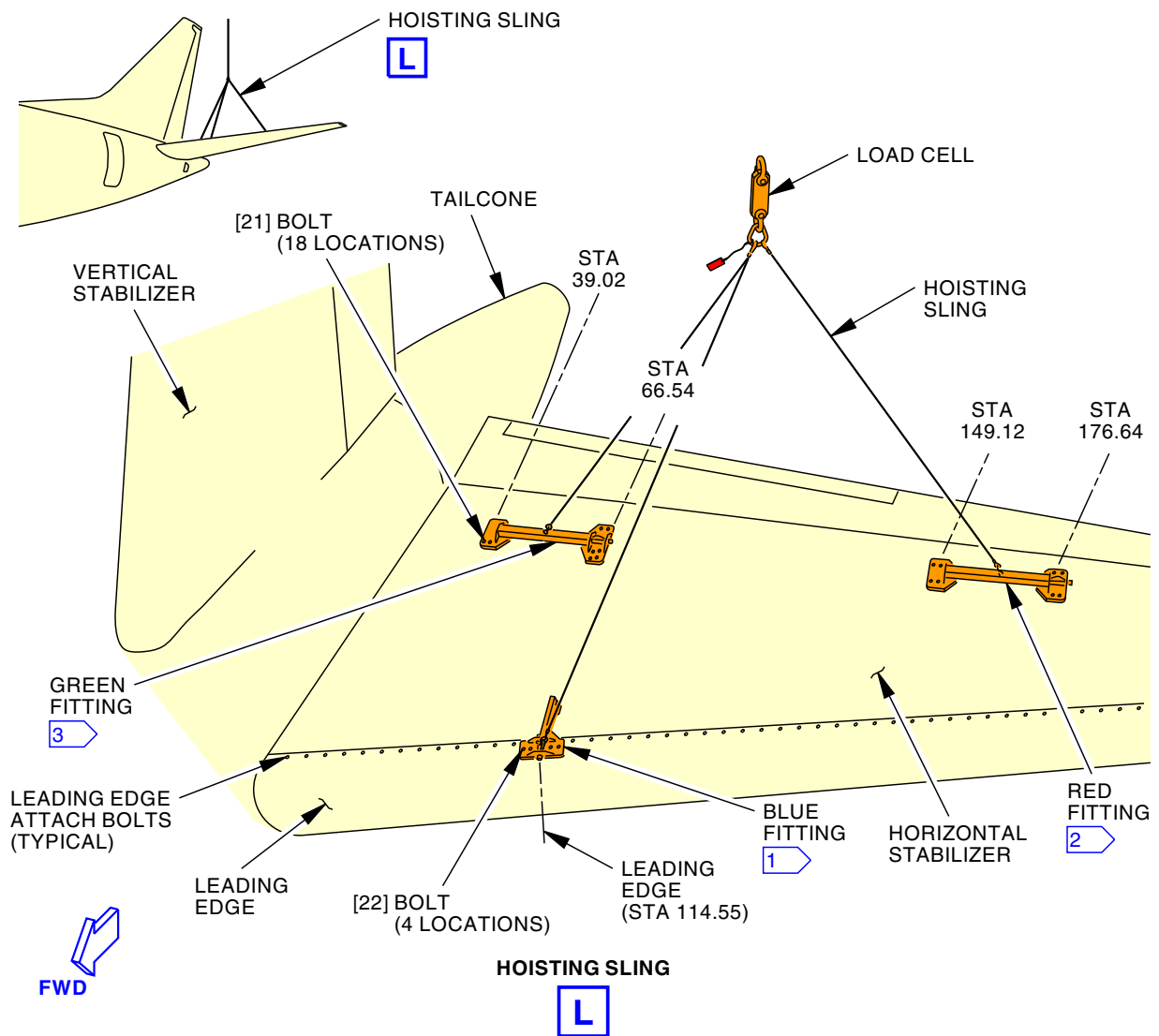
Figure 212/55-05-03-990-812 (Sheet 7 of 10)

EFFECTIVITY
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55-05-03

D633AM101-SIA

Page 260
May 15/2023



- 1 THE FORWARD ATTACH (BLUE) FITTING IS ATTACHED TO THE STABILIZER FRONT SPAR (LEADING EDGE ATTACH BOLTS). TWO BOLTS ARE USED ON THE INBOARD SIDE OF THE LEADING EDGE RIB (STA 114.55) AND TWO BOLTS ARE USED ON THE OUTBOARD SIDE OF THE LEADING EDGE RIB (STA 114.55).
- 2 THE AFT OUTBOARD ATTACH (RED) FITTING IS ATTACHED TO THE ELEVATOR HINGE SUPPORT RIBS, FOUR BOLTS ARE USED AT STA 176.64 AND FOUR BOLTS ARE USED AT STA 149.12.
- 3 THE AFT INBOARD ATTACH (GREEN) FITTING IS ATTACHED TO THE ELEVATOR HINGE SUPPORT RIBS, SIX BOLTS ARE USED AT STA 66.54 AND FOUR BOLTS ARE USED AT STA 39.02.

2898609 S0000691522_V2

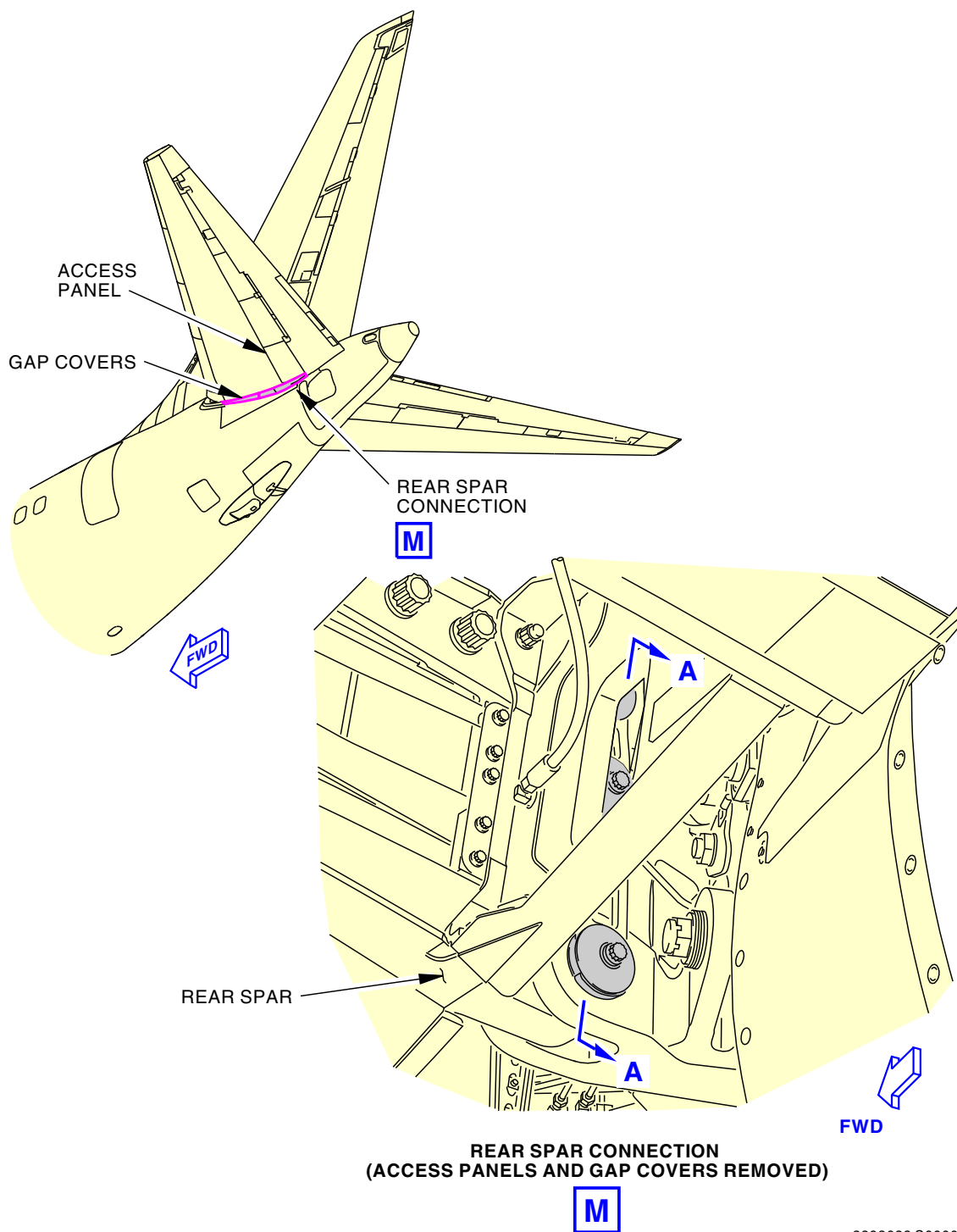
Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual
(Internal)

Figure 212/55-05-03-990-812 (Sheet 8 of 10)

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55-05-03



2898688 S0000691534_V1

Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)

Figure 212/55-05-03-990-812 (Sheet 9 of 10)

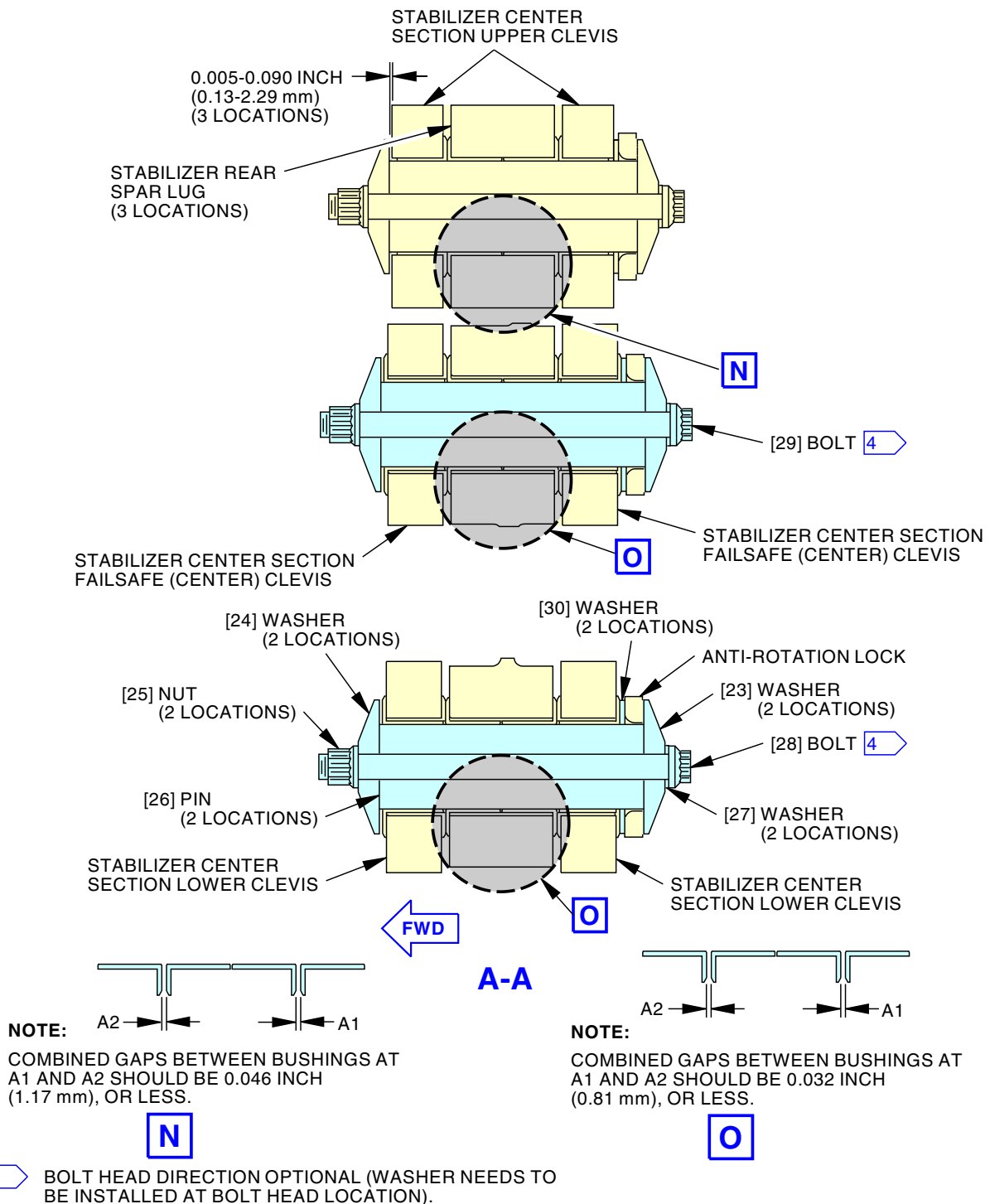
EFFECTIVITY
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D633AM101-SIA

Page 262
May 15/2023

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



2898667 S0000691536_V2

Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)

Figure 212/55-05-03-990-812 (Sheet 10 of 10)

EFFECTIVITY	
SIA ALL	

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55-05-03

Page 263
May 15/2023



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

TASK 55-05-03-210-813

13. **INTERNAL - GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER TRAILING EDGE AND
ELEVATOR TAB LEADING EDGE**

(Figure 213)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
27-31-41-000-801	Elevator Balance Panel - Removal (P/B 401)
27-31-41-400-801	Elevator Balance Panel - Installation (P/B 401)
51-05-01-210-804	737-7/8/8200/9 Basic Task Description (P/B 201)
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

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-2035	Sling Equipment - Horizontal Stabilizer Part #: C55014-1 Supplier: 81205
STD-12395	Load Cell Equipment

C. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38

D. Location Zones

Zone	Area
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

E. Access Panels

Number	Name/Location
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343BB	Horizontal Stabilizer, Access Panel - T.E. Area
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area
344AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344BB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344CB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344DB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344EB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator

EFFECTIVITY
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55-05-03

Page 264
May 15/2023

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

(Continued)

Number	Name/Location
--------	---------------

345A	Horizontal Stabilizer, Removable Stabilizer Tip
S3431	Right Horizontal Stabilizer Trailing Edge

F. Prepare for the Inspection

SUBTASK 55-05-03-480-004

(1) Install the sling equipment, SPL-2035.

(a) Remove the bolts [51] and bolts [52] from the stabilizer top surface.



CAUTION

MAKE SURE YOU INSTALL THE HOISTING SLING CORRECTLY WHEN YOU REMOVE THE HORIZONTAL STABILIZER WITH OR WITHOUT THE ELEVATOR INSTALLED. IF YOU DO NOT INSTALL THE HOISTING SLING CORRECTLY FOR THE REMOVAL OF THE HORIZONTAL STABILIZER, YOU CAN CAUSE DAMAGE TO EQUIPMENT.

(b) Attach the sling equipment, SPL-2035, to the horizontal stabilizer with fasteners.

NOTE: Low clearance sling is used only with elevator removed.

(c) Attach the load cell, STD-12395, to the sling equipment, SPL-2035.

(d) Attach a hoist to the load cell, STD-12395.



CAUTION

YOU MUST CAREFULLY LIFT THE HOISTING SLING. A SUDDEN MOVEMENT OF THE HOISTING SLING CAN CAUSE DAMAGE TO THE HORIZONTAL STABILIZER.

(e) Lift the weight of the horizontal stabilizer.

1) Use the load cell, STD-12395, to make sure that the force used when lifting horizontal stabilizer is not more than:

- 888 lb (403 kg) or (830 lb (376 kg) airplane part + 58 lb (26 kg) tool) with elevator attached.
- 688 lb (312 kg) or (630 lb (286 kg) airplane part + 58 lb (26 kg) tool) without elevator attached.

G. Inspection

SUBTASK 55-05-03-010-013

(1) Open these access panels:

Number	Name/Location
--------	---------------

343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343BB	Horizontal Stabilizer, Access Panel - T.E. Area
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area
344AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344BB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344CB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344DB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator

EFFECTIVITY
SIA ALL

D633AM101-SIA

55-05-03

Page 265
May 15/2023



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

(Continued)

<u>Number</u>	<u>Name/Location</u>
344EB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
345A	Horizontal Stabilizer, Removable Stabilizer Tip

Special Access:

<u>Number</u>	<u>Name/Location</u>
S3431	Right Horizontal Stabilizer Trailing Edge

NOTE: Bolt removal is required to inspect terminal fittings and center section rear spar lugs, except at rear spar upper lugs and clevis.

SUBTASK 55-05-03-020-006

- (2) Disconnect the balance panels in the balance bays (TASK 27-31-41-000-801).

SUBTASK 55-05-03-020-007

- (3) If installed, remove tab hinge covers to inspect elevator tab leading edge.

SUBTASK 55-05-03-020-008

- (4) Remove the horizontal stabilizer rear spar bolts:

NOTE: It is not required to remove the bolts at the upper lugs and clevis at the rear spar.

NOTE: If the bolts are frozen, use equipment, SPL-2030, to assist in removal.

- (a) Remove and keep the nuts [55] and washers [54] from the bolt [58] and bolt [59].

1) Keep a record of where each part came from.

- (b) Remove and keep the bolt [58], bolt [59], washers [57], and washers [53].

1) Keep a record of where each part came from.

- (c) Remove and keep the pins [56] and washers [60].

1) Keep a record of where each part came from.

NOTE: If necessary, adjust the tension of the sling equipment, SPL-2035, to aid removal of the pins [56].

SUBTASK 55-05-03-100-007

- (5) Clean the joint per SOPM 20-30-03 to remove dirt, debris, and existing grime.

SUBTASK 55-05-03-210-013

- (6) Do a General Visual inspection of the aft side of right horizontal stabilizer rear spar, including spar chords and webs, terminal fittings, elevator tab actuator support fitting, center section rear spar lugs, elevator hinge ribs, elevator tab leading edge, and pins [56].

SUBTASK 55-05-03-910-013

- (7) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 55-05-03-100-008

- (8) Apply the corrosion inhibiting material, G50136, to the bolts and joints, including the inner diameter of bushings.

SUBTASK 55-05-03-420-008

- (9) Install the pins [56] and washers [60].

SUBTASK 55-05-03-420-009

- (10) Install the bolt [58], bolt [59], washers [57], and washers [53].

EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 266
May 15/2023



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

SUBTASK 55-05-03-420-010

- (11) Install the nuts [55] and washers [54] on the bolt [58] and bolt [59].

H. Put the Airplane Back to Its Usual Condition

SUBTASK 55-05-03-420-011

- (1) If previously installed, reinstall the tab hinge covers.

SUBTASK 55-05-03-420-012

- (2) Reconnect the balance panels in the balance bay (TASK 27-31-41-400-801).

SUBTASK 55-05-03-410-022

- (3) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343BB	Horizontal Stabilizer, Access Panel - T.E. Area
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area
344AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344BB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344CB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344DB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344EB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
345A	Horizontal Stabilizer, Removable Stabilizer Tip
S3431	Right Horizontal Stabilizer Trailing Edge

SUBTASK 55-05-03-390-009

- (4) Apply an aerodynamic smoother sealant, A02315, to all non-bonded structural components contacting exterior skins.

NOTE: Sealant does not need to be applied to gaps between panels that are used for regular access as long as they are less than limits given in the Structural Repair Manual (SRM SUBJECT 51-10-01).

- (a) Do this task: Aerodynamic Smoother Application, TASK 51-22-00-390-809.

SUBTASK 55-05-03-080-004

- (5) Remove the sling equipment, SPL-2035.
- (a) Release tension applied to the sling equipment, SPL-2035.
- (b) Remove the hoist from the load cell, STD-12395.
- (c) Remove the load cell, STD-12395, from the sling equipment, SPL-2035.
- (d) Remove the fasteners that attach the sling equipment, SPL-2035.
- (e) Install the bolts [51] and bolts [52] at the horizontal stabilizer top surface.

————— **END OF TASK** —————

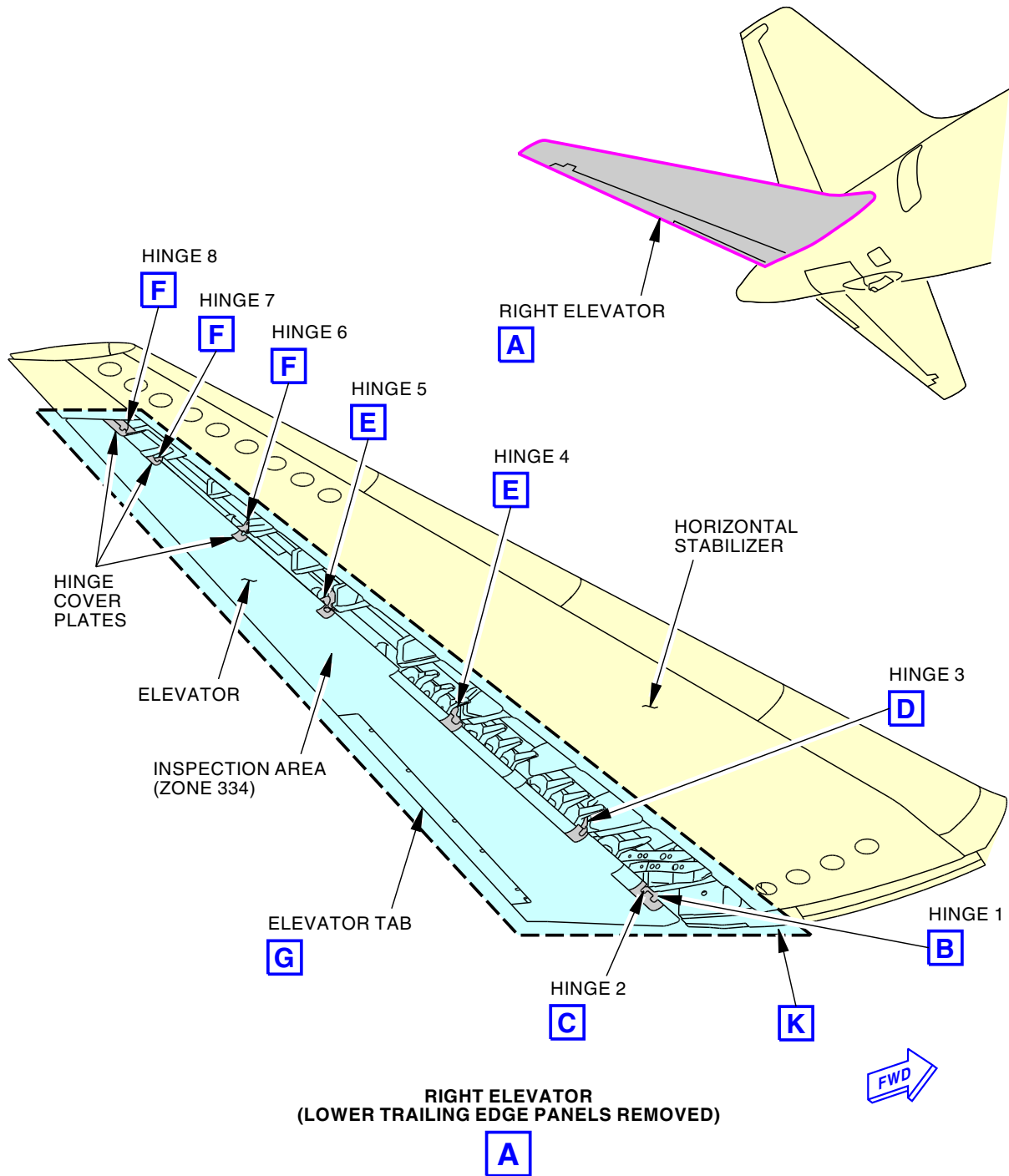
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 267
May 15/2023



2416345 S00061540474_V1

Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)

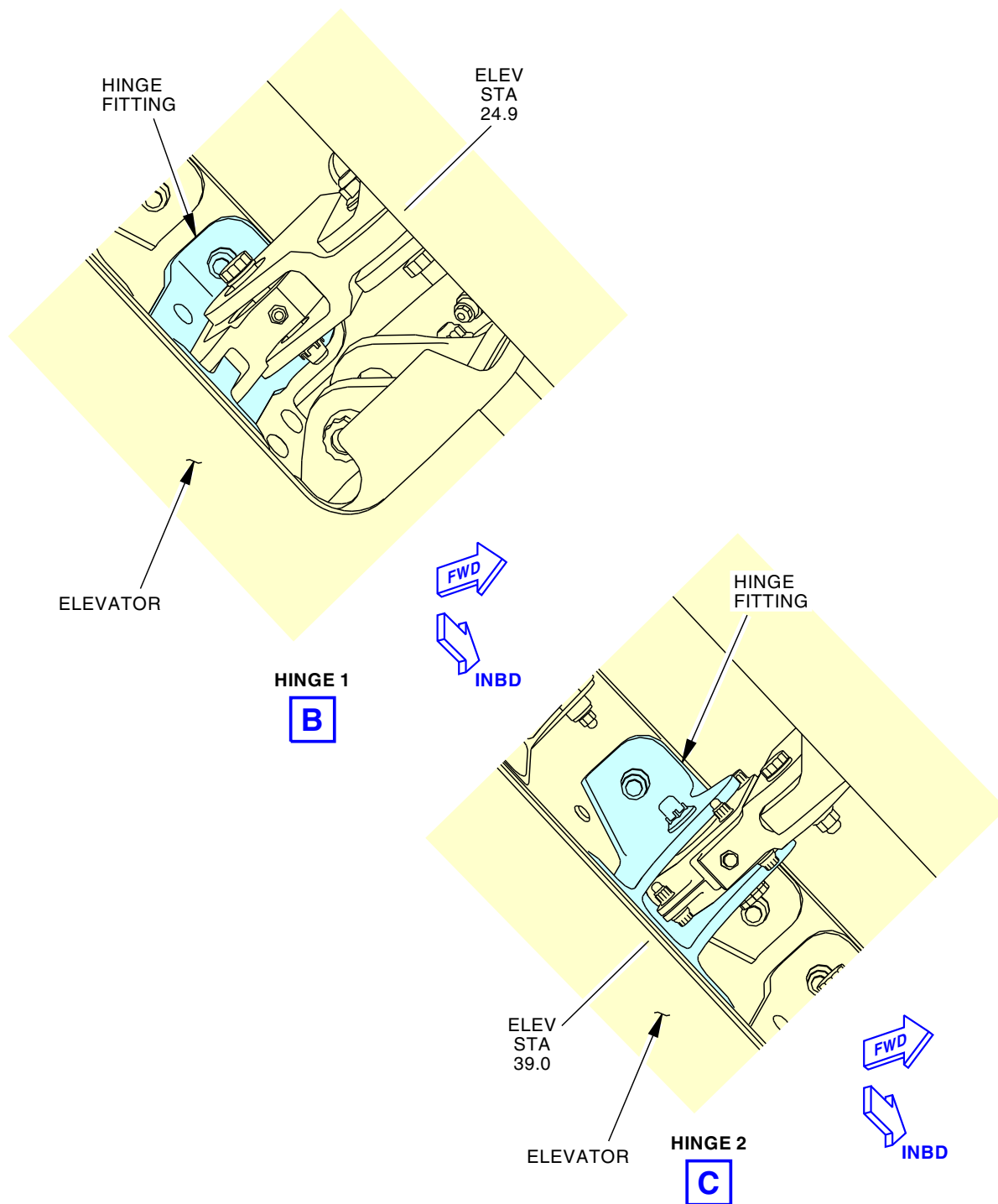
Figure 213/55-05-03-990-813 (Sheet 1 of 10)

EFFECTIVITY
SIA ALL

55-05-03

D633AM101-SIA

Page 268
May 15/2023



2416346 S00061540475_V1

Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)

Figure 213/55-05-03-990-813 (Sheet 2 of 10)

EFFECTIVITY SIA ALL

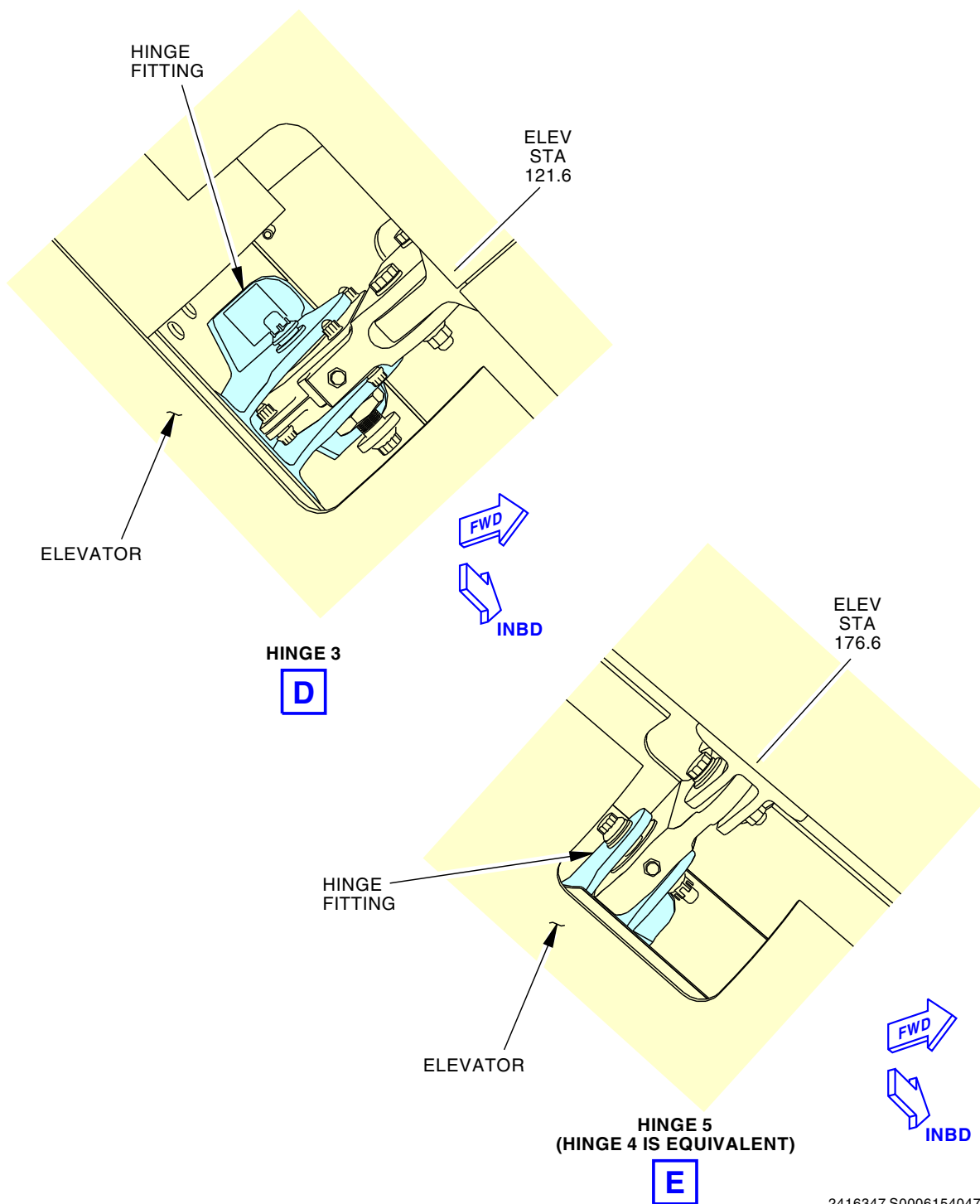
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Page 269
May 15/2023



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



2416347 S00061540476_V1

Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General
Visual (Internal)

Figure 213/55-05-03-990-813 (Sheet 3 of 10)

EFFECTIVITY
SIA ALL

D633AM101-SIA

55-05-03

Page 270
May 15/2023

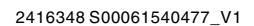
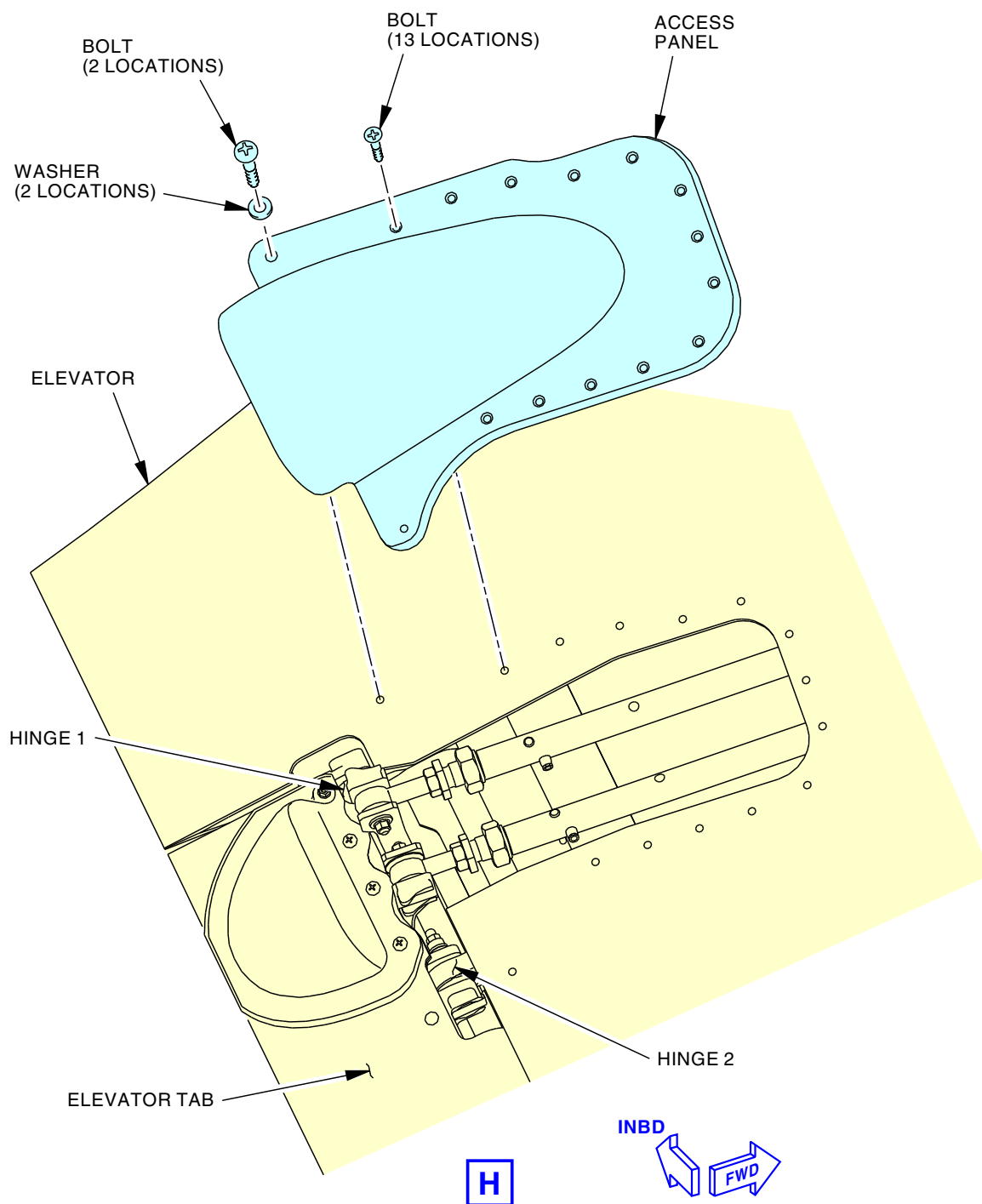


Figure 213/55-05-03-990-813 (Sheet 4 of 10)

55-05-03

D633AM101-SIA



2416349 S00061540478_V1

Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General
Visual (Internal)

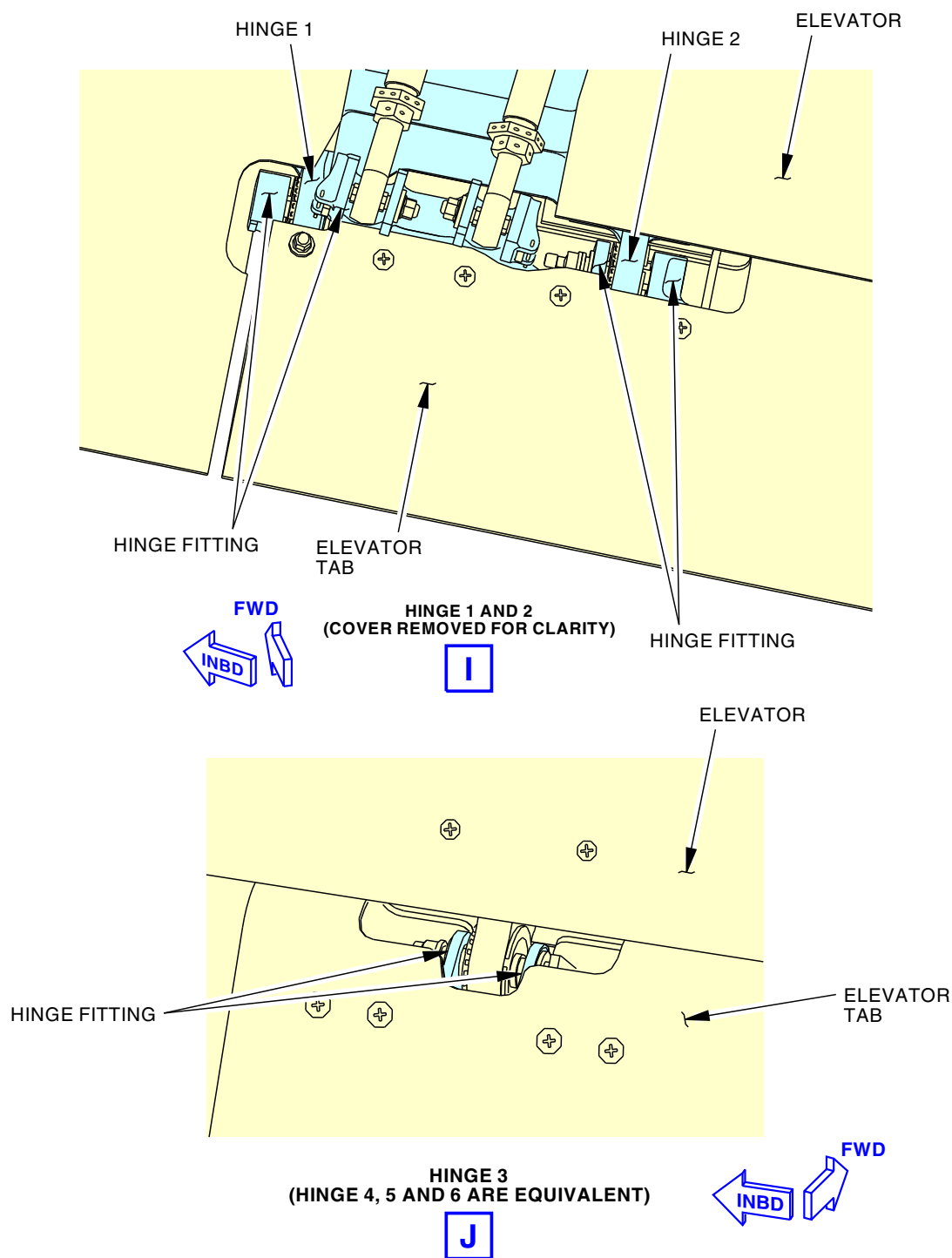
Figure 213/55-05-03-990-813 (Sheet 5 of 10)

EFFECTIVITY
SIA ALL

55-05-03

Page 272
May 15/2023

D633AM101-SIA



2416350 S00061540479_V1

Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)

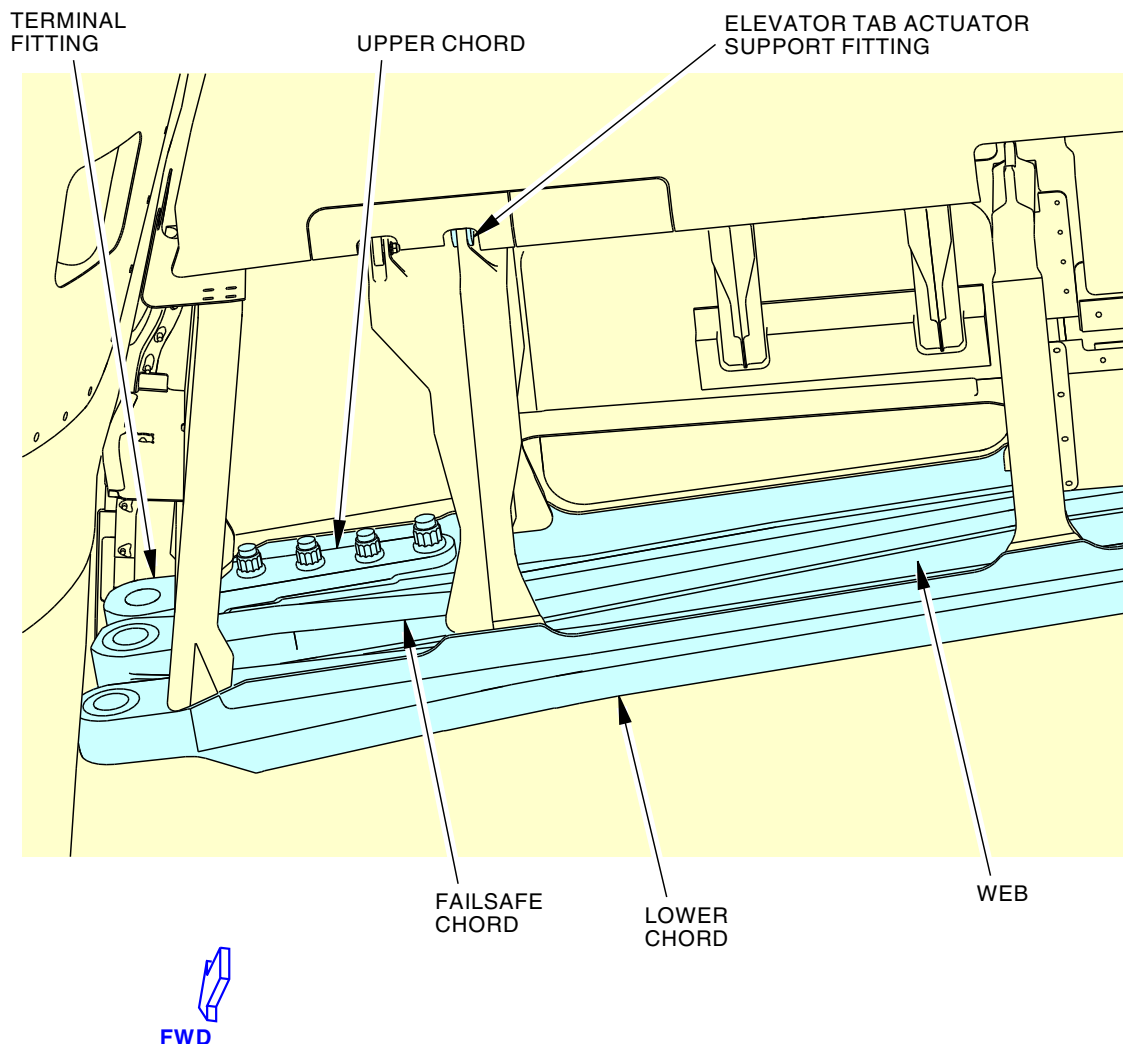
Figure 213/55-05-03-990-813 (Sheet 6 of 10)

EFFECTIVITY
SIA ALL

55-05-03

D633AM101-SIA

Page 273
May 15/2023



RIGHT HORIZONTAL STABILIZER REAR SPAR CHORDS, WEB,
TERMINAL FITTINGS AND TAB ACTUATOR FITTING
(PANELS REMOVED FOR CLARITY)

K

2416351 S00061540480_V1

Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)

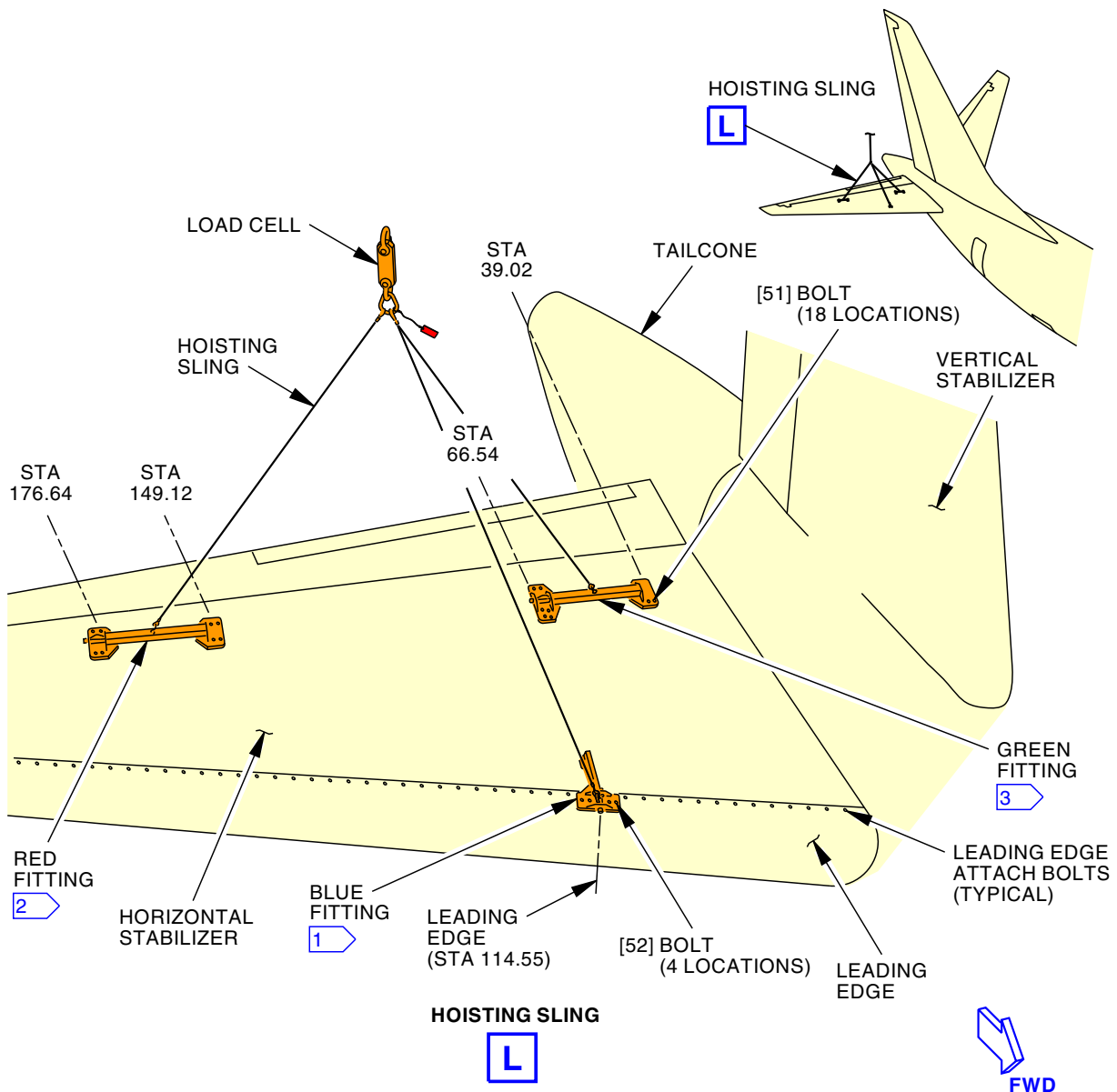
Figure 213/55-05-03-990-813 (Sheet 7 of 10)

EFFECTIVITY
SIA ALL

55-05-03

D633AM101-SIA

Page 274
May 15/2023



- 1 THE FORWARD ATTACH (BLUE) FITTING IS ATTACHED TO THE STABILIZER FRONT SPAR (LEADING EDGE ATTACH BOLTS). TWO BOLTS ARE USED ON THE INBOARD SIDE OF THE LEADING EDGE RIB (STA 114.55) AND TWO BOLTS ARE USED ON THE OUTBOARD SIDE OF THE LEADING EDGE RIB (STA 114.55).
- 2 THE AFT OUTBOARD ATTACH (RED) FITTING IS ATTACHED TO THE ELEVATOR HINGE SUPPORT RIBS, FOUR BOLTS ARE USED AT STA 176.64 AND FOUR BOLTS ARE USED AT STA 149.12.
- 3 THE AFT INBOARD ATTACH (GREEN) FITTING IS ATTACHED TO THE ELEVATOR HINGE SUPPORT RIBS, SIX BOLTS ARE USED AT STA 66.54 AND FOUR BOLTS ARE USED AT STA 39.02.

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Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)

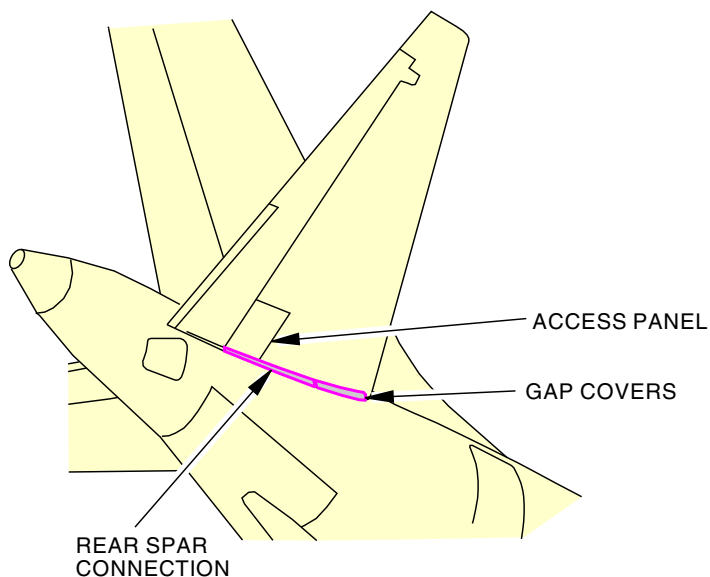
Figure 213/55-05-03-990-813 (Sheet 8 of 10)

EFFECTIVITY
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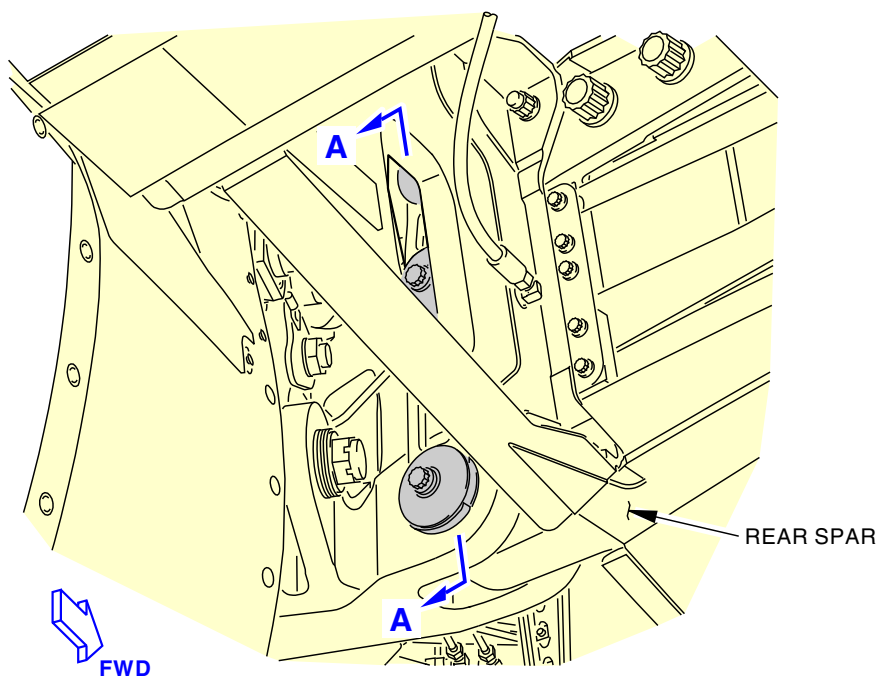
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D633AM101-SIA

Page 275
May 15/2023



M



REAR SPAR CONNECTION
(ACCESS PANELS AND GAP COVERS REMOVED)

M

2898806 S0000691640_V1

Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General
Visual (Internal)

Figure 213/55-05-03-990-813 (Sheet 9 of 10)

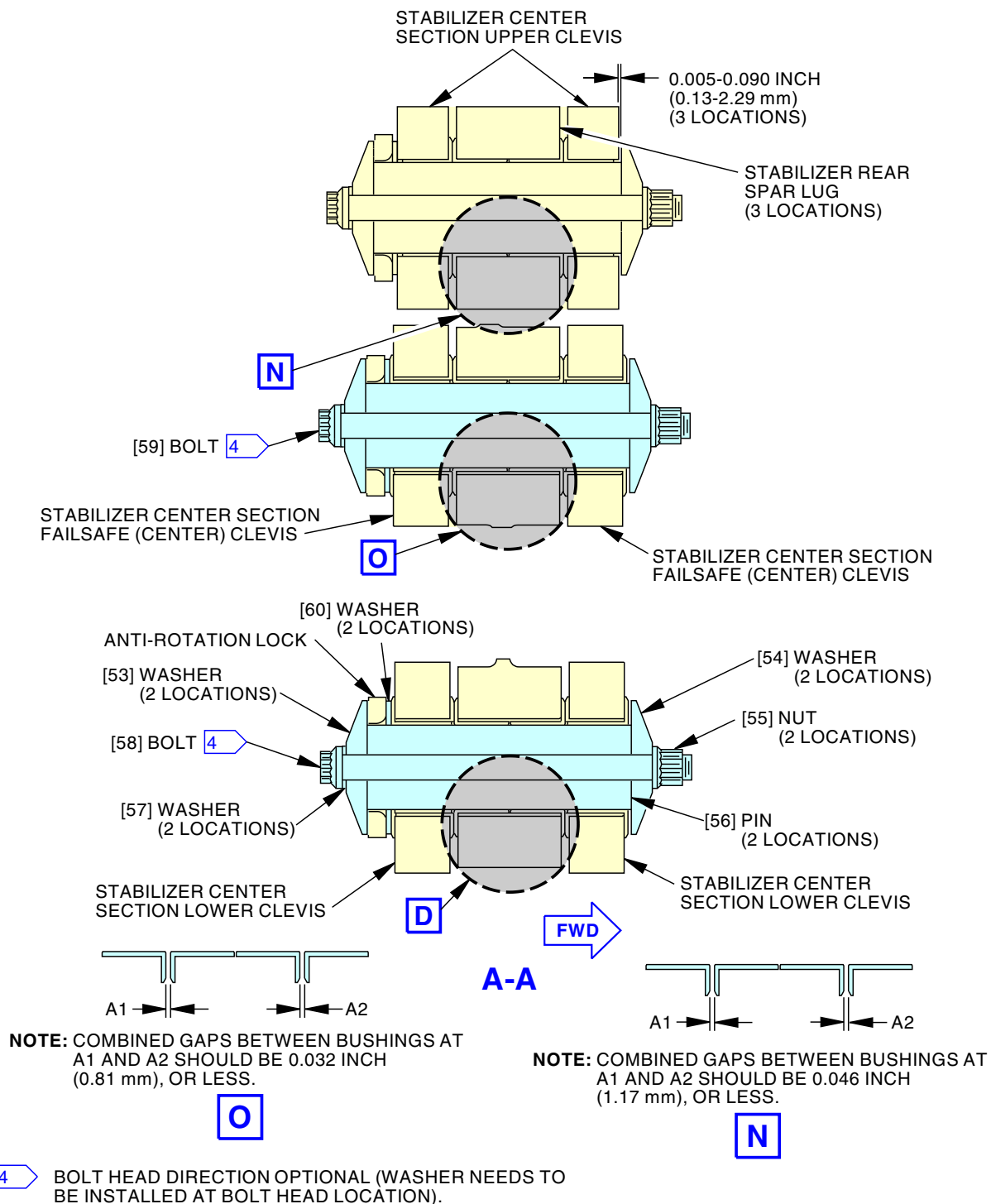
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D633AM101-SIA

Page 276
May 15/2023

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



2898805 S0000691646_V2

Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)

Figure 213/55-05-03-990-813 (Sheet 10 of 10)

EFFECTIVITY
SIA ALL

55-05-03

D633AM101-SIA

Page 277
May 15/2023



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

TASK 55-05-03-211-801

14. **INTERNAL - DETAILED: LEFT ELEVATOR TAB SUPT FTGS ON FRONT SPAR AND TAB SPAR AT LEADING EDGE**

(Figure 214)

NOTE: This procedure is a scheduled maintenance task.

A. References

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

B. Location Zones

Zone	Area
334	Left Horizontal Stabilizer - Elevator
344	Right Horizontal Stabilizer - Elevator

C. Inspection

NOTE: Remove upper or lower horizontal stabilizer trailing edge seal and elevator inboard hinge cover panel to inspect support fittings. Remove tab hinge covers to locally inspect forward face of spar.

SUBTASK 55-05-03-211-001

- (1) Do a Detailed inspection of the left elevator tab mechanism support fittings on elevator front spar and elevator tab spar at leading edge cutouts.

SUBTASK 55-05-03-910-014

- (2) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-804.

————— **END OF TASK** —————

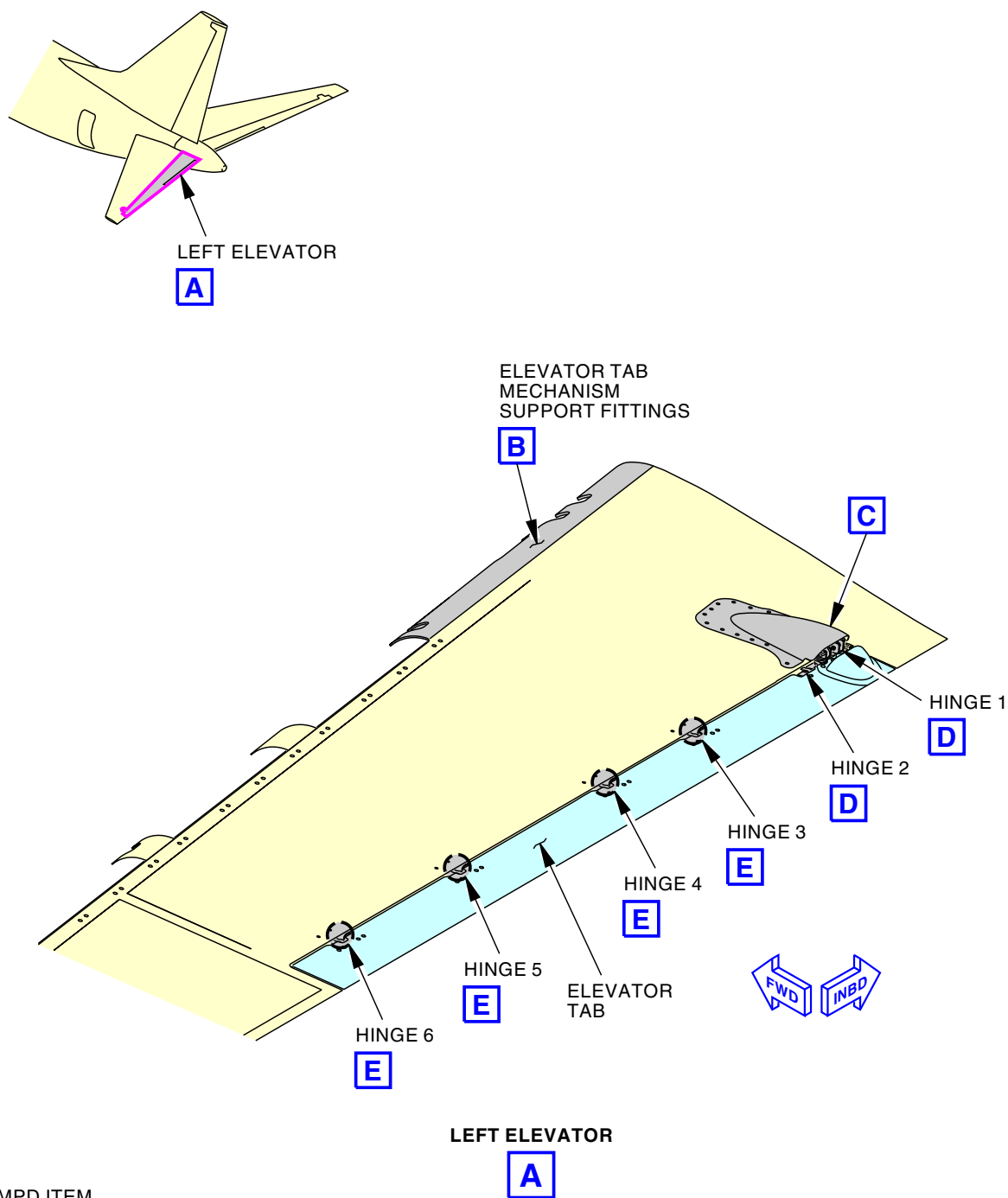
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55-05-03

Page 278
May 15/2023



MPD ITEM
55-115-01

2416352 S00061540482_V1

**INTERNAL-DETAILED: LEFT ELEVATOR TAB SUPT FTGS ON FRONT SPAR & TAB SPAR AT LEADING
EDGE CUTOUTS**

Figure 214/55-05-03-990-814 (Sheet 1 of 4)

EFFECTIVITY
SIA ALL

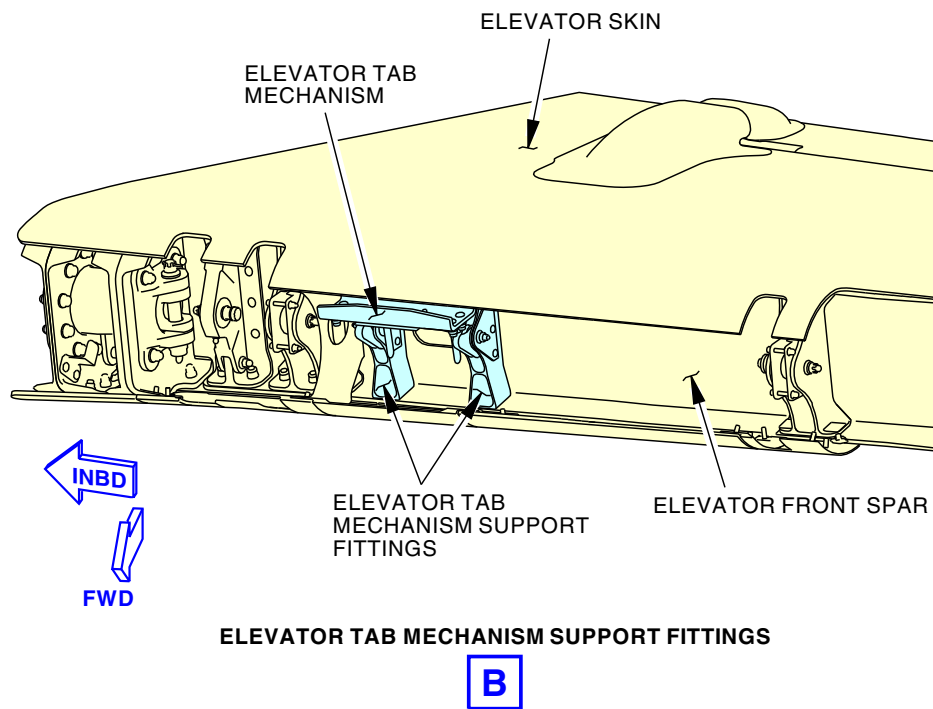
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55-05-03

Page 279
May 15/2023



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



MPD ITEM
55-115-01

2416353 S00061540483_V1

INTERNAL-DETAILED: LEFT ELEVATOR TAB SUPT FTGS ON FRONT SPAR & TAB SPAR AT LEADING
EDGE CUTOUTS

Figure 214/55-05-03-990-814 (Sheet 2 of 4)

EFFECTIVITY
SIA ALL

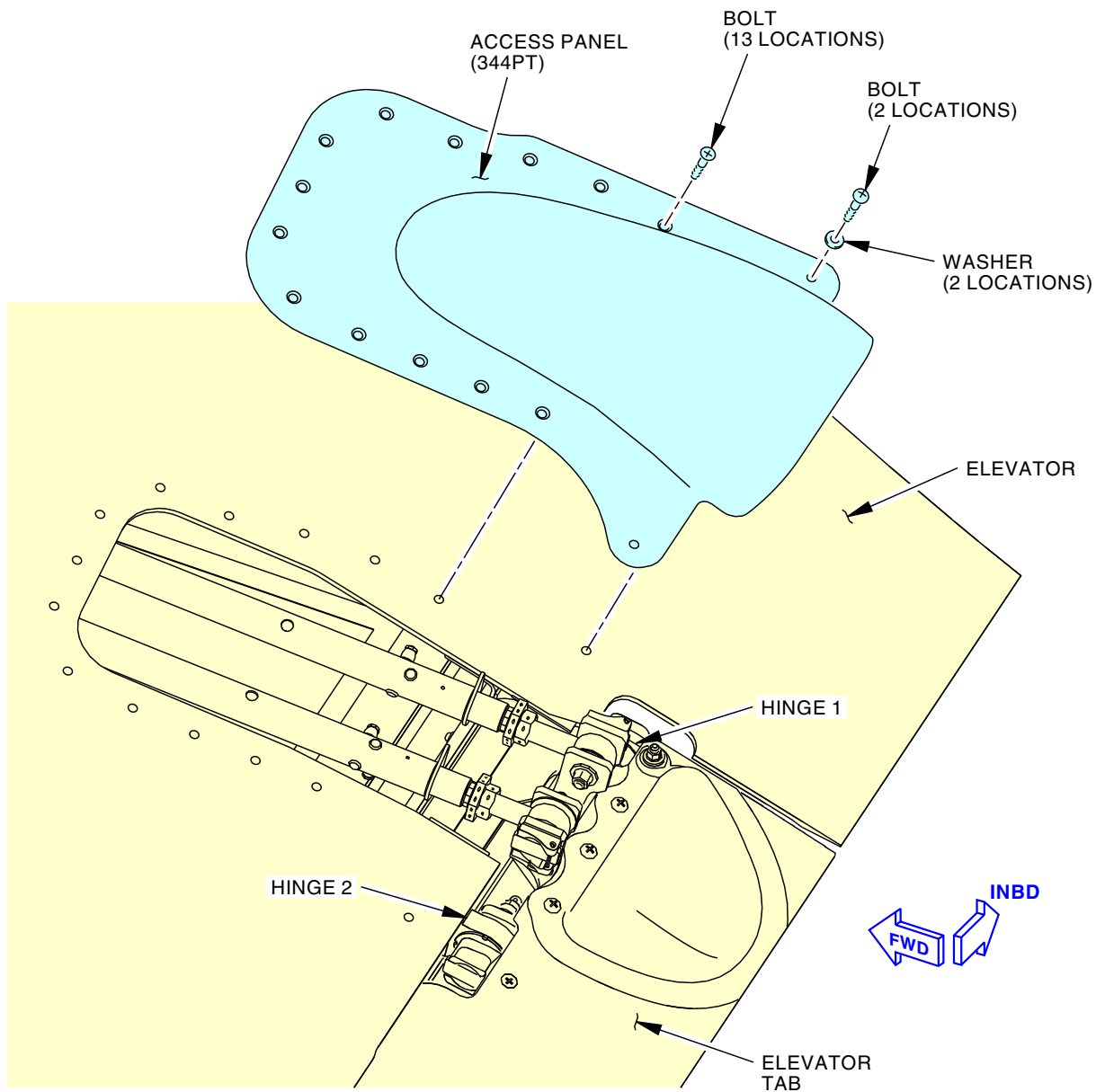
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Page 280
May 15/2023



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



C

MPD ITEM
55-115-01

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INTERNAL-DETAILED: LEFT ELEVATOR TAB SUPT FTGS ON FRONT SPAR & TAB SPAR AT LEADING
EDGE CUTOUTS

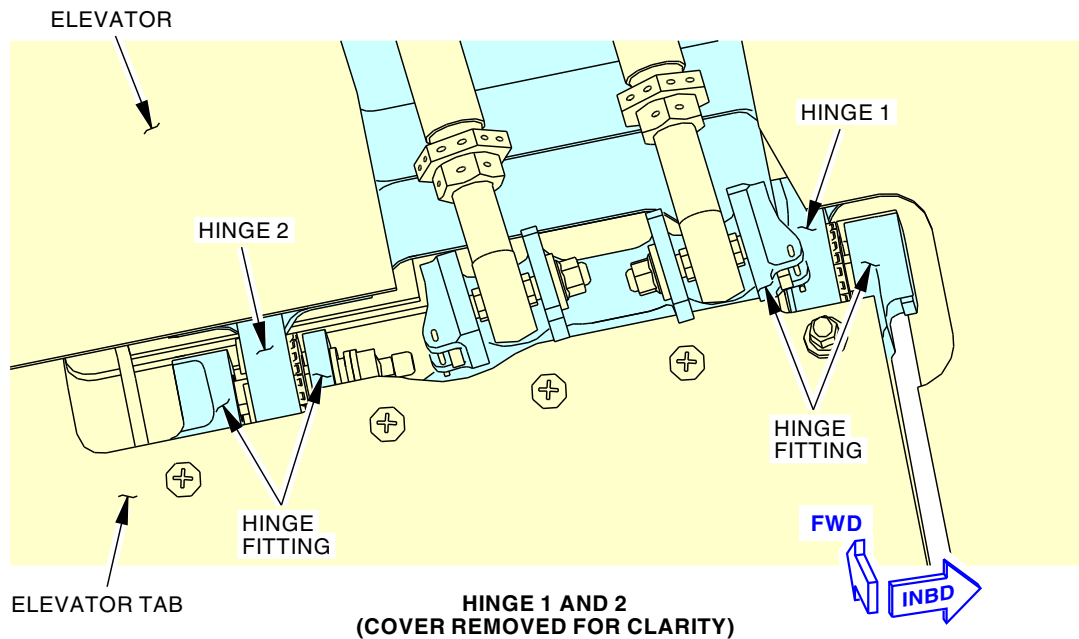
Figure 214/55-05-03-990-814 (Sheet 3 of 4)

EFFECTIVITY
SIA ALL

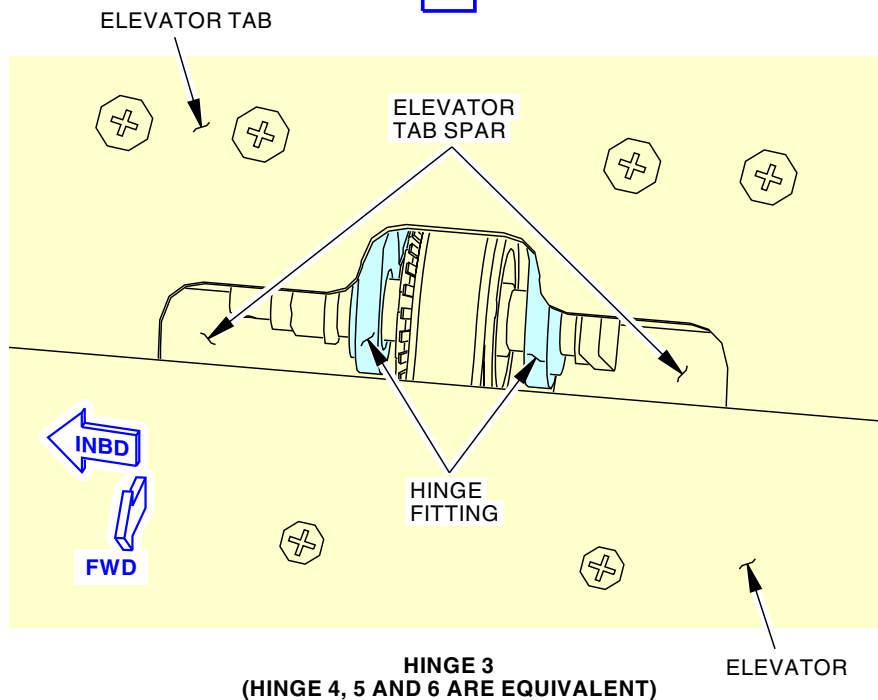
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55-05-03

Page 281
May 15/2023



D



E

MPD ITEM
55-115-01

2416355 S00061540485_V1

**INTERNAL-DETAILED: LEFT ELEVATOR TAB SUPT FTGS ON FRONT SPAR & TAB SPAR AT LEADING
EDGE CUTOUTS**

Figure 214/55-05-03-990-814 (Sheet 4 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

55-05-03

Page 282
May 15/2023



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

TASK 55-05-03-211-802

15. **INTERNAL - DETAILED: RIGHT ELEVATOR TAB SUPT FTGS ON FRONT SPAR AND TAB SPAR AT LEADING EDGE**

(Figure 215)

NOTE: This procedure is a scheduled maintenance task.

A. References

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

B. Location Zones

Zone	Area
334	Left Horizontal Stabilizer - Elevator
344	Right Horizontal Stabilizer - Elevator

C. Inspection

NOTE: Remove upper or lower horizontal stabilizer trailing edge seal and elevator inboard hinge cover panel to inspect support fittings. Remove tab hinge covers to locally inspect forward face of spar.

SUBTASK 55-05-03-211-002

- (1) Do a Detailed inspection of the right elevator tab mechanism support fittings on elevator front spar and elevator tab spar at leading edge cutouts.

SUBTASK 55-05-03-910-015

- (2) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-804.

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

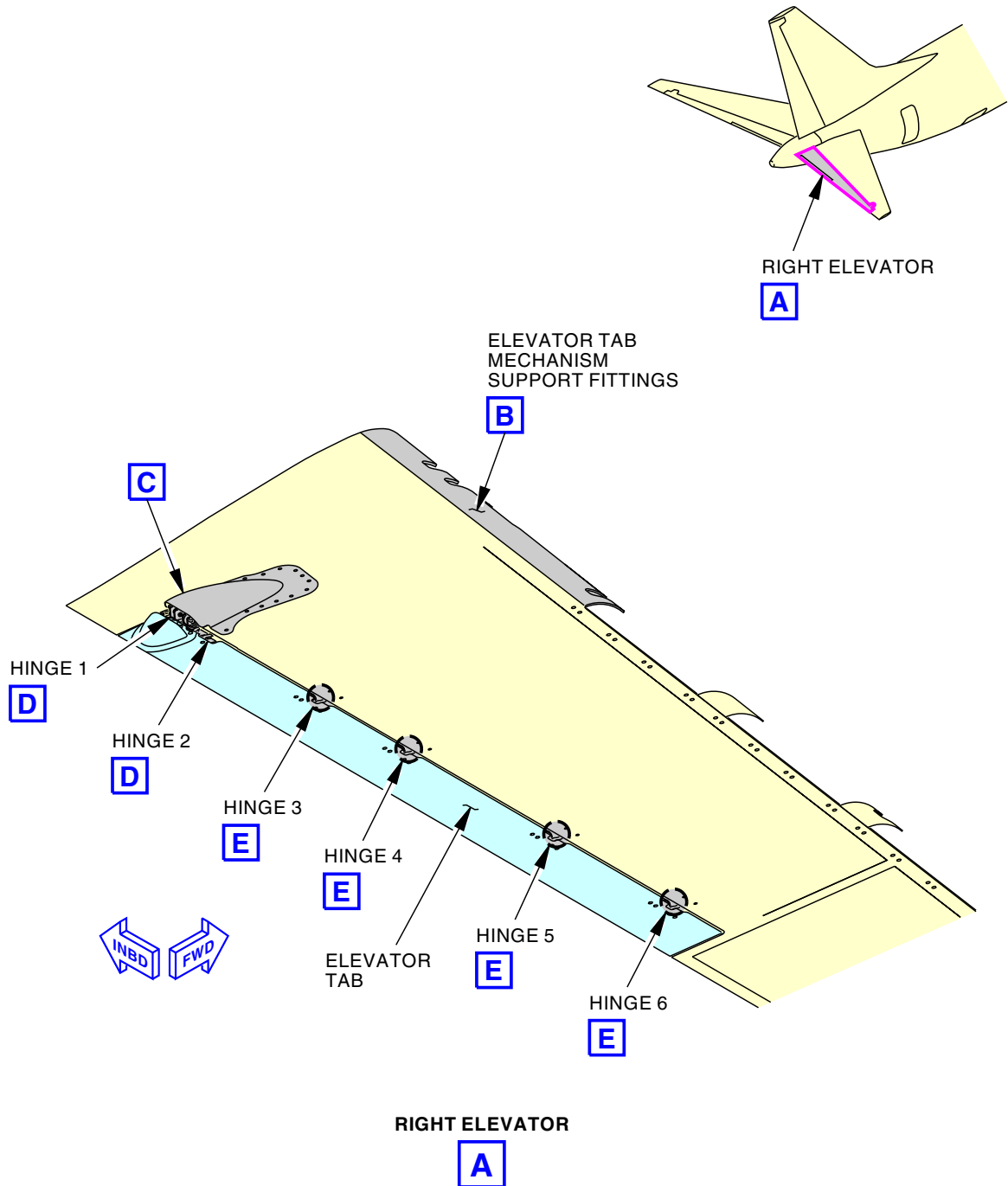
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 283
May 15/2023

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



MPD ITEM
55-115-02

2416356 S00061540487_V1

**INTERNAL-DETAILED: RIGHT ELEVATOR TAB SUPT FTGS ON FRONT SPAR & TAB SPAR AT LEADING
EDGE CUTOUTS**

Figure 215/55-05-03-990-815 (Sheet 1 of 4)

EFFECTIVITY
SIA ALL

55-05-03

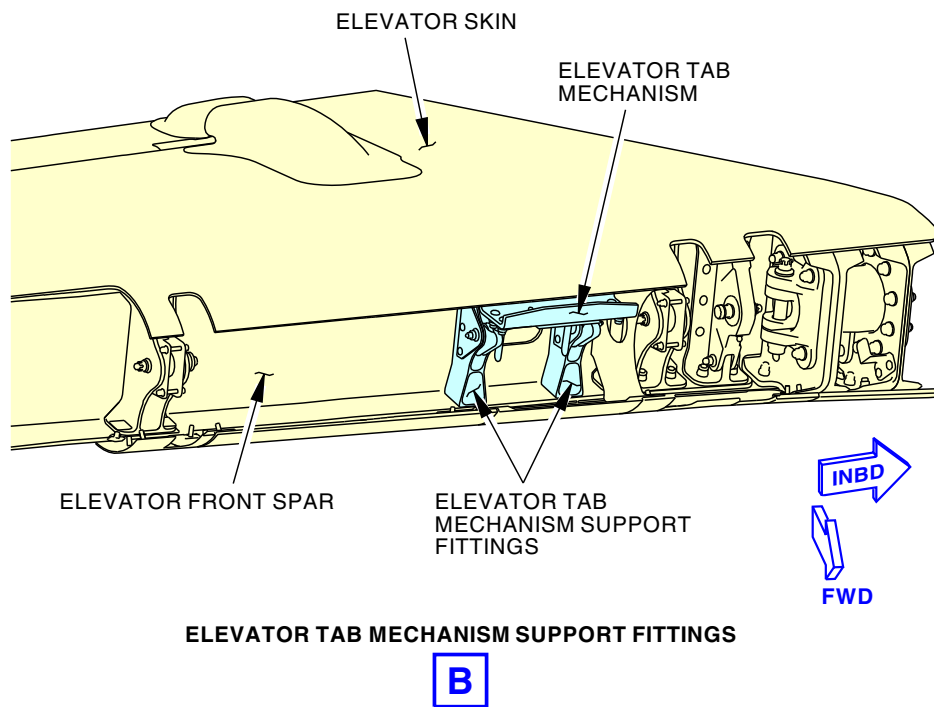
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Page 284
May 15/2023

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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



MPD ITEM
55-115-02

2416357 S00061540488_V1

INTERNAL-DETAILED: RIGHT ELEVATOR TAB SUPT FTGS ON FRONT SPAR & TAB SPAR AT LEADING
EDGE CUTOUTS

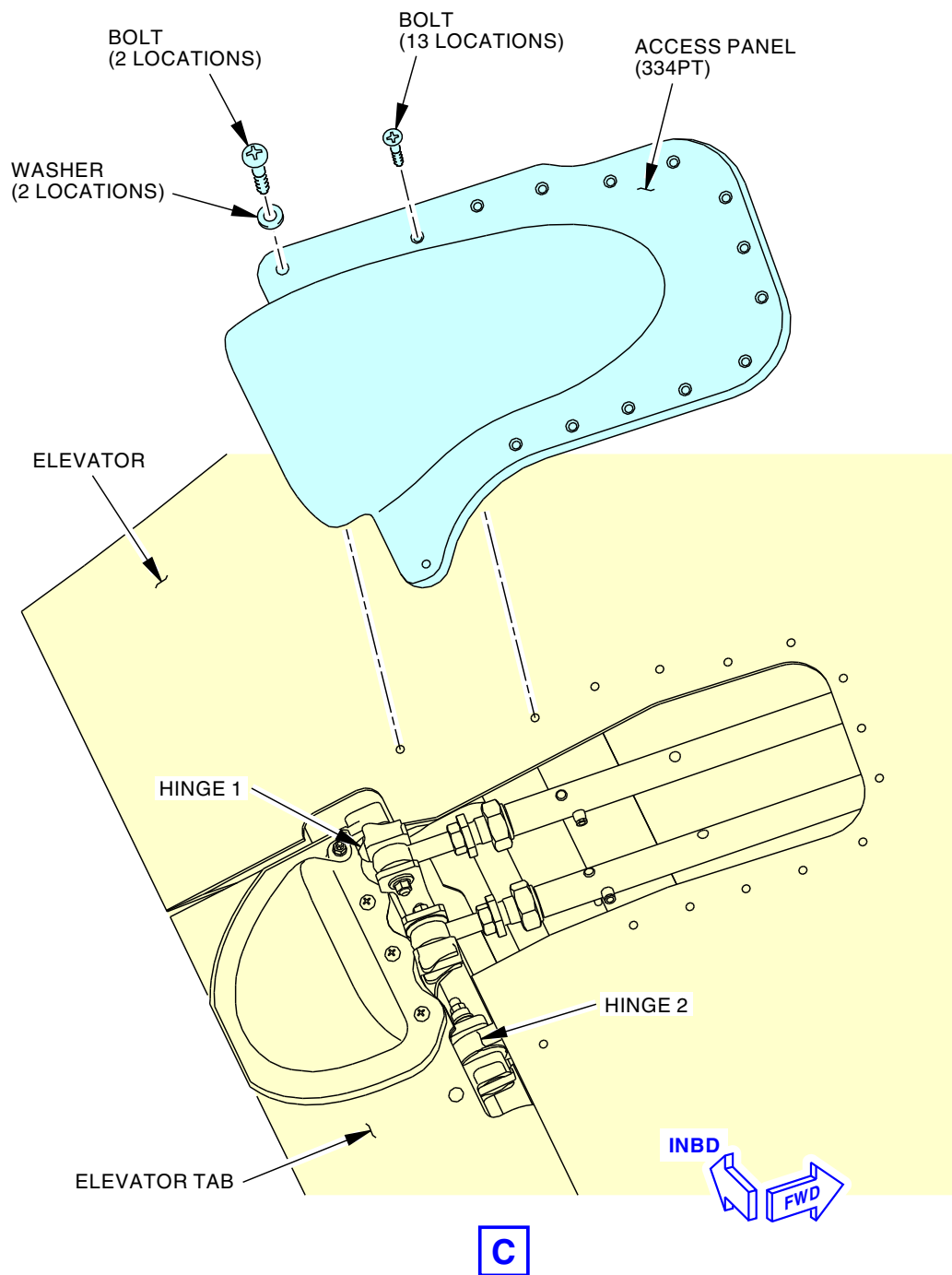
Figure 215/55-05-03-990-815 (Sheet 2 of 4)

EFFECTIVITY
SIA ALL

55-05-03

D633AM101-SIA

Page 285
May 15/2023



MPD ITEM
55-115-02

2416358 S00061540489_V1

**INTERNAL-DETAILED: RIGHT ELEVATOR TAB SUPT FTGS ON FRONT SPAR & TAB SPAR AT LEADING
EDGE CUTOUTS**

Figure 215/55-05-03-990-815 (Sheet 3 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

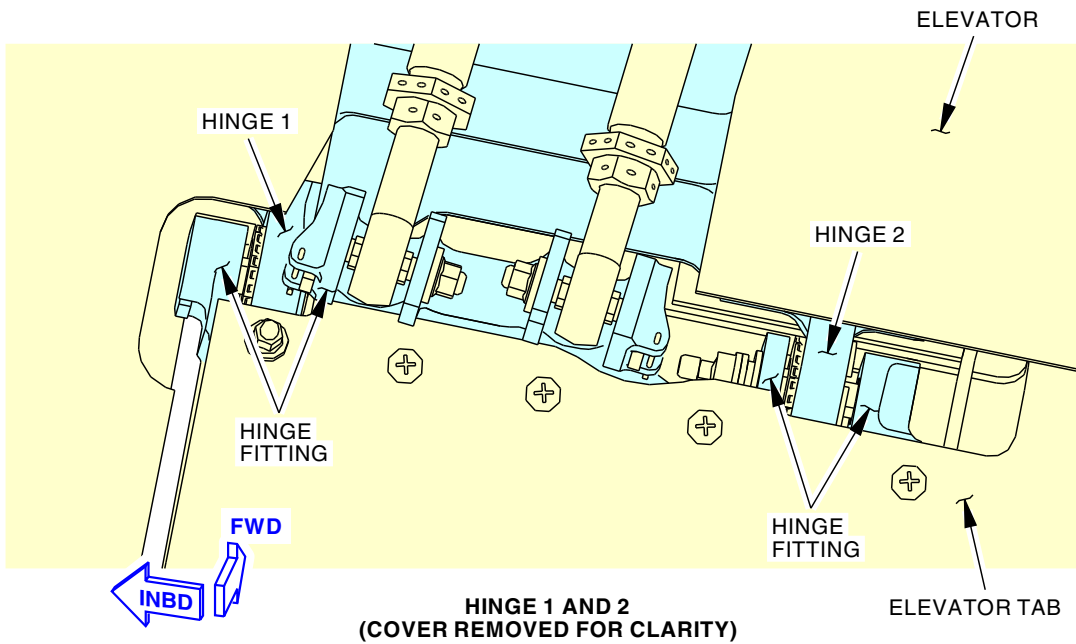
ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

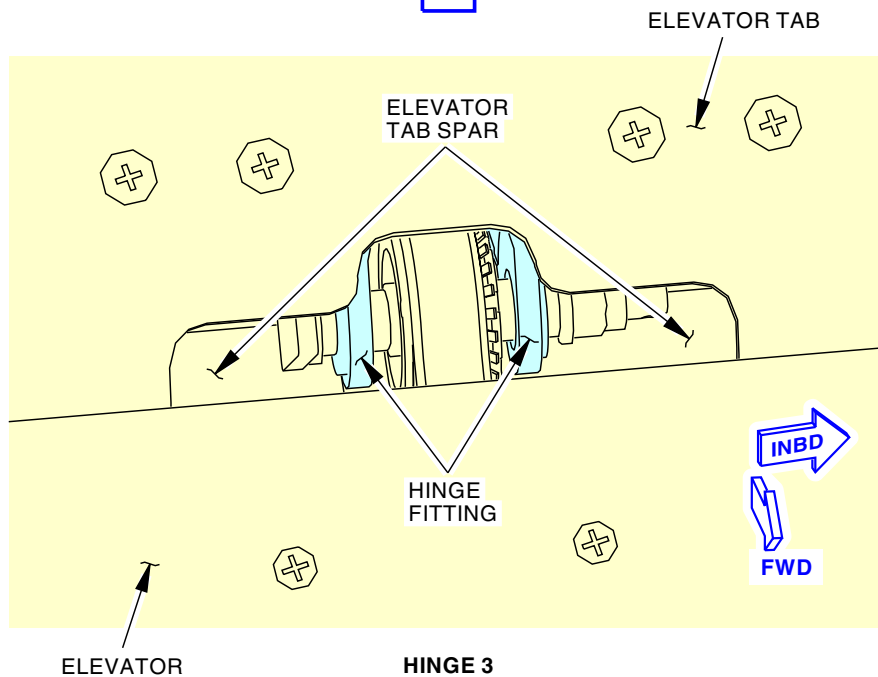
Page 286
May 15/2023



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



D



HINGE 3
(HINGE 4, 5 AND 6 ARE EQUIVALENT)

E

MPD ITEM
55-115-02

2416359 S00061540490_V1

INTERNAL-DETAILED: RIGHT ELEVATOR TAB SUPT FTGS ON FRONT SPAR & TAB SPAR AT LEADING
EDGE CUTOUTS

Figure 215/55-05-03-990-815 (Sheet 4 of 4)

EFFECTIVITY
SIA ALL

55-05-03

D633AM101-SIA

Page 287
May 15/2023



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

TASK 55-05-03-210-814

16. **INTERNAL - GENERAL VISUAL: LEFT HORIZONTAL STABILIZER TRAILING EDGE**

(Figure 216)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	737-7/8/8200/9 Basic Task Description (P/B 201)
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

B. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II

C. Location Zones

Zone	Area
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge

D. Access Panels

Number	Name/Location
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

E. Inspection

SUBTASK 55-05-03-010-014

- (1) Open these access panels:

Number	Name/Location
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

NOTE: Bolt removal is not necessary.

SUBTASK 55-05-03-210-014

- (2) Do a General Visual inspection of the left horizontal stabilizer rear spar terminal fittings and the center section rear spar lugs.

SUBTASK 55-05-03-910-016

- (3) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 55-05-03-410-014

- (4) Close these access panels:

Number	Name/Location
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

SUBTASK 55-05-03-390-010

- (5) Apply an aerodynamic smoother sealant, A02315, to all non-bonded structural components contacting exterior skins.

NOTE: Sealant does not need to be applied to gaps between panels that are used for regular access as long as they are less than limits given in the Structural Repair Manual (SRM SUBJECT 51-10-01).

EFFECTIVITY
SIA ALL

D633AM101-SIA

55-05-03

Page 288
May 15/2023



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

(a) Do this task: Aerodynamic Smoother Application, TASK 51-22-00-390-809.

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

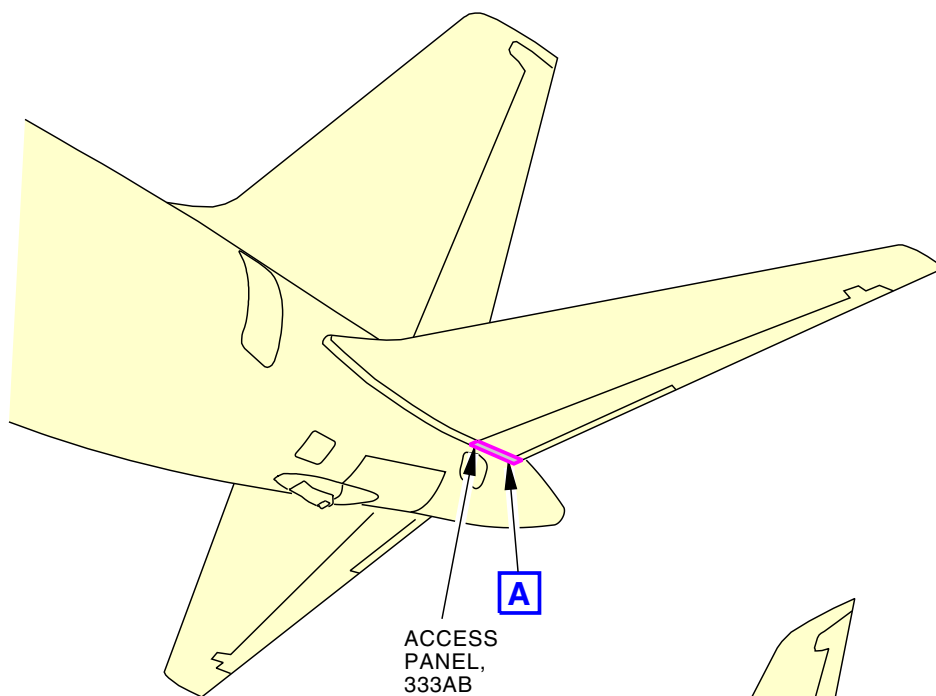
ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

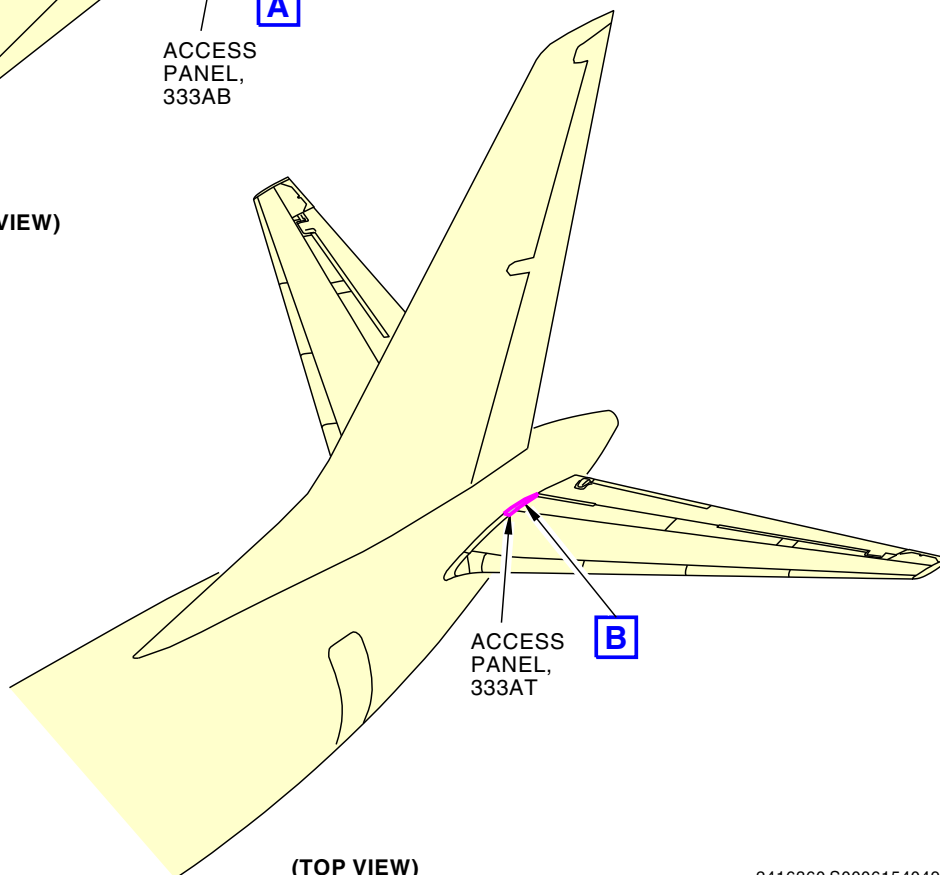
Page 289
May 15/2023



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



(BOTTOM VIEW)



(TOP VIEW)

MPD ITEM
55-120-01

2416360 S00061540492_V1

Left Horizontal Stabilizer Trailing Edge General Visual (Internal)
Figure 216/55-05-03-990-816 (Sheet 1 of 2)

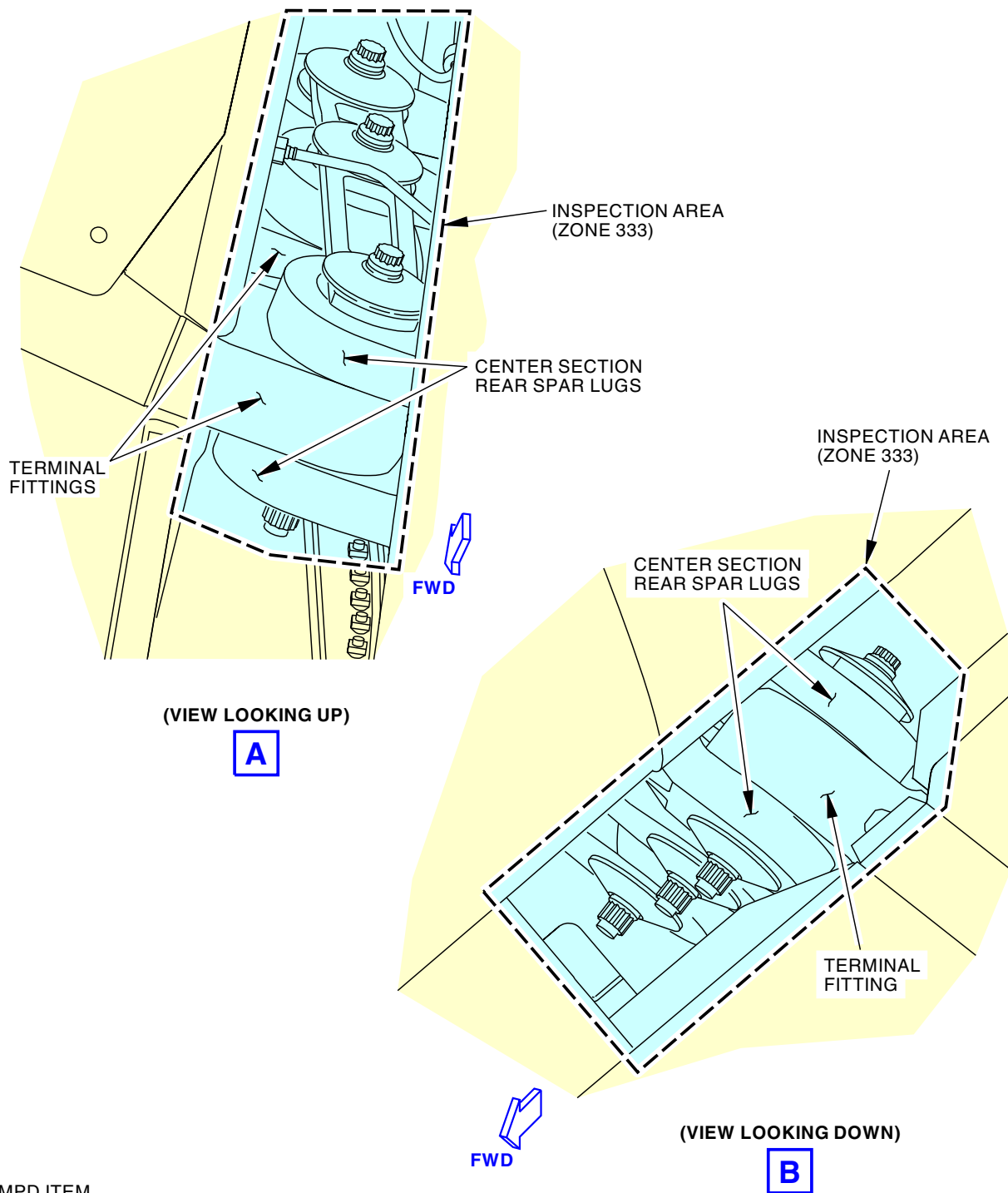
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 290
May 15/2023



MPD ITEM
55-120-01

2416361 S00061540493_V1

Left Horizontal Stabilizer Trailing Edge General Visual (Internal)
Figure 216/55-05-03-990-816 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 291
May 15/2023



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

TASK 55-05-03-210-815

17. **INTERNAL - GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER TRAILING EDGE**

(Figure 217)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	737-7/8/8200/9 Basic Task Description (P/B 201)
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

B. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II

C. Location Zones

Zone	Area
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

D. Access Panels

Number	Name/Location
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

E. Inspection

SUBTASK 55-05-03-010-015

- (1) Open these access panels:

Number	Name/Location
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

NOTE: Bolt removal is not necessary.

SUBTASK 55-05-03-210-015

- (2) Do a General Visual inspection of the right horizontal stabilizer rear spar terminal fittings and the center section rear spar lugs.

SUBTASK 55-05-03-910-017

- (3) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 55-05-03-410-015

- (4) Close these access panels:

Number	Name/Location
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

SUBTASK 55-05-03-390-011

- (5) Apply an aerodynamic smoother sealant, A02315, to all non-bonded structural components contacting exterior skins.

NOTE: Sealant does not need to be applied to gaps between panels that are used for regular access as long as they are less than limits given in the Structural Repair Manual (SRM SUBJECT 51-10-01).

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 292
May 15/2023



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

(a) Do this task: Aerodynamic Smoother Application, TASK 51-22-00-390-809.

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

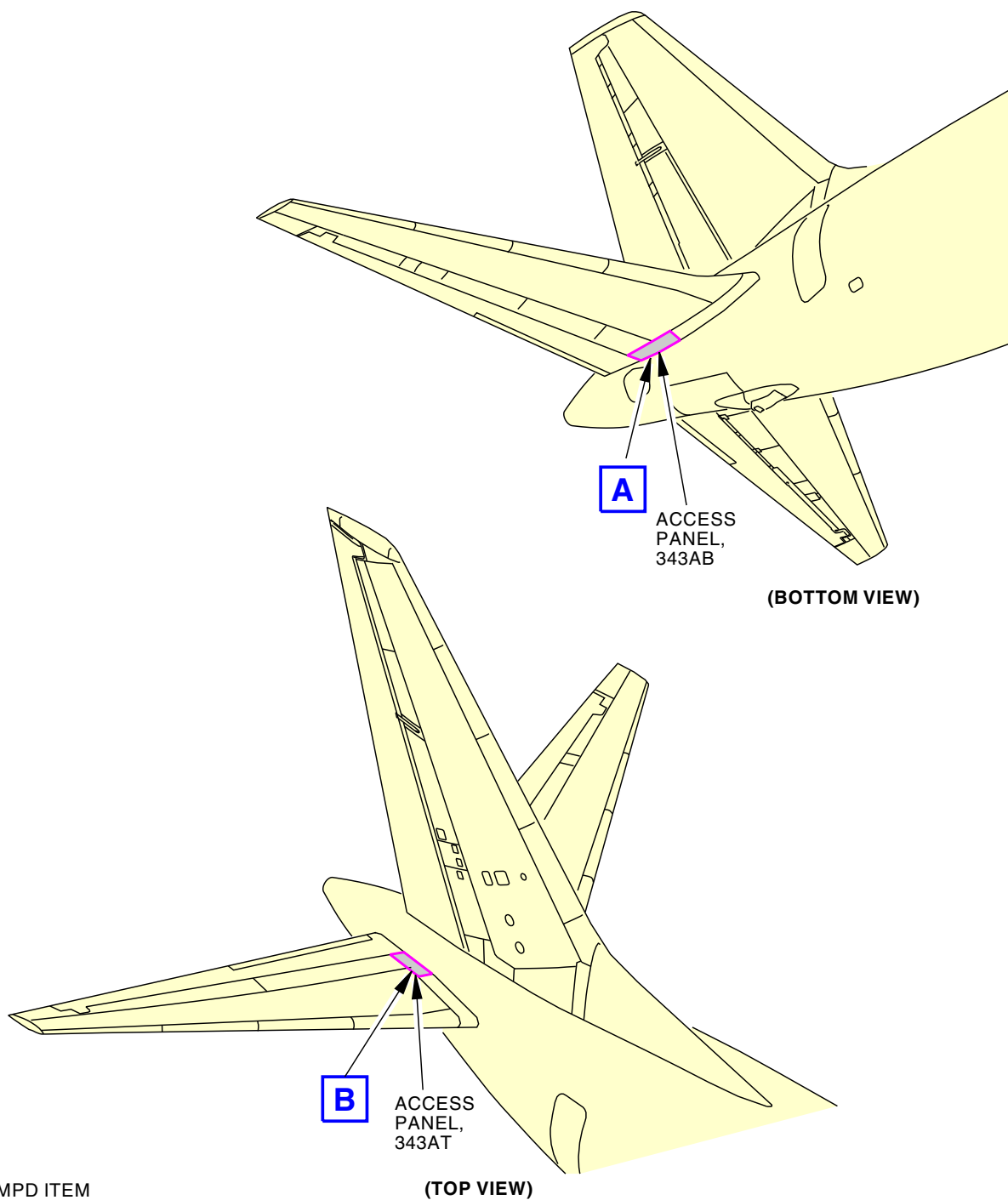
ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 293
May 15/2023



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



MPD ITEM
55-120-02

2416362 S00061540495_V1

Right Horizontal Stabilizer Trailing Edge General Visual (Internal)
Figure 217/55-05-03-990-817 (Sheet 1 of 2)

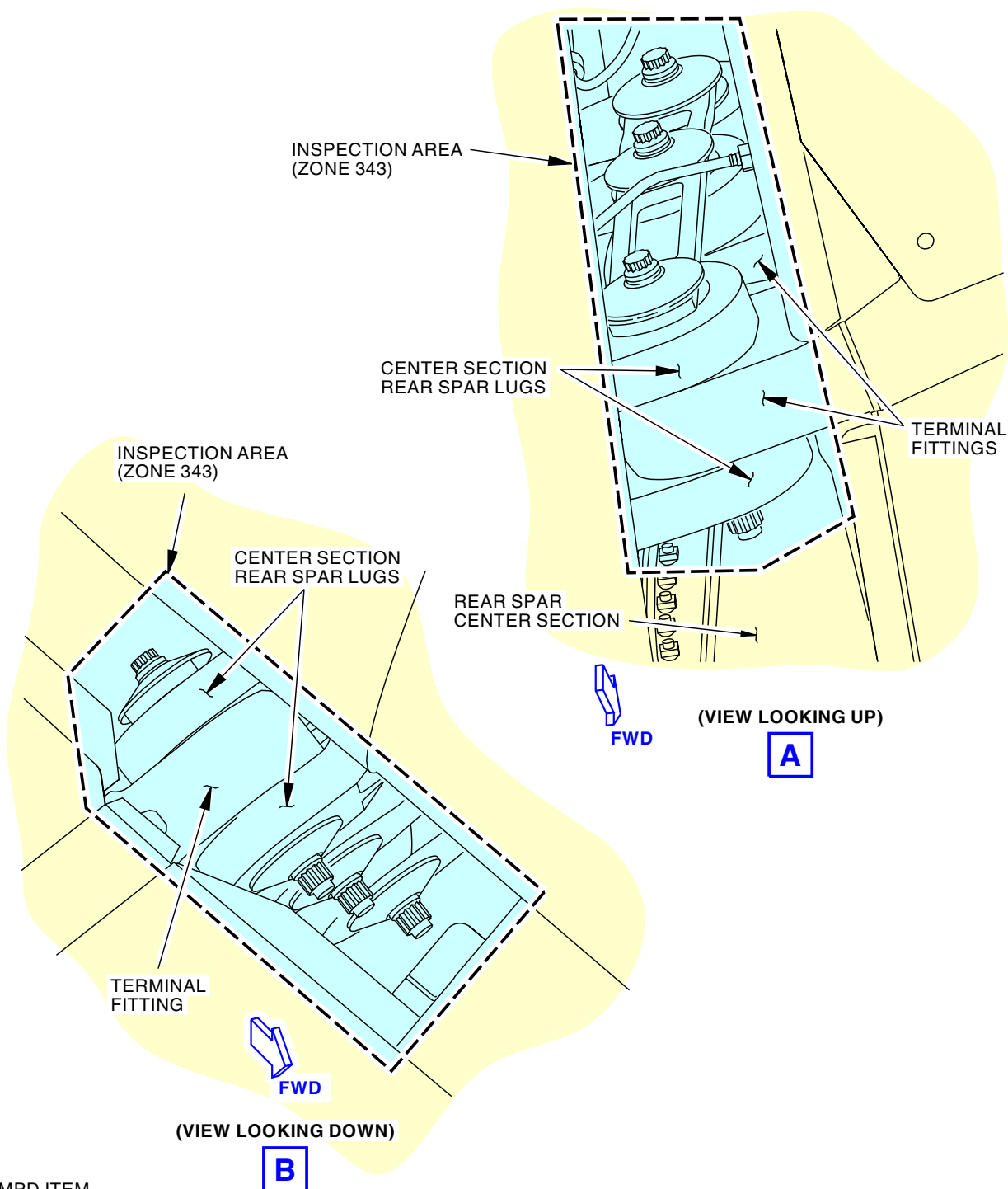
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 294
May 15/2023



MPD ITEM
55-120-02

2416363 S00061540496_V1

Right Horizontal Stabilizer Trailing Edge General Visual (Internal)
Figure 217/55-05-03-990-817 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 295
May 15/2023



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

TASK 55-05-03-211-803

18. INTERNAL - DETAILED: INTERNAL - LEFT ELEVATOR TAB HINGE FITTING
(Figure 218)

A. Inspection

SUBTASK 55-05-03-211-003

(1) Do the inspection.

————— END OF TASK —————

EFFECTIVITY
SIA ALL

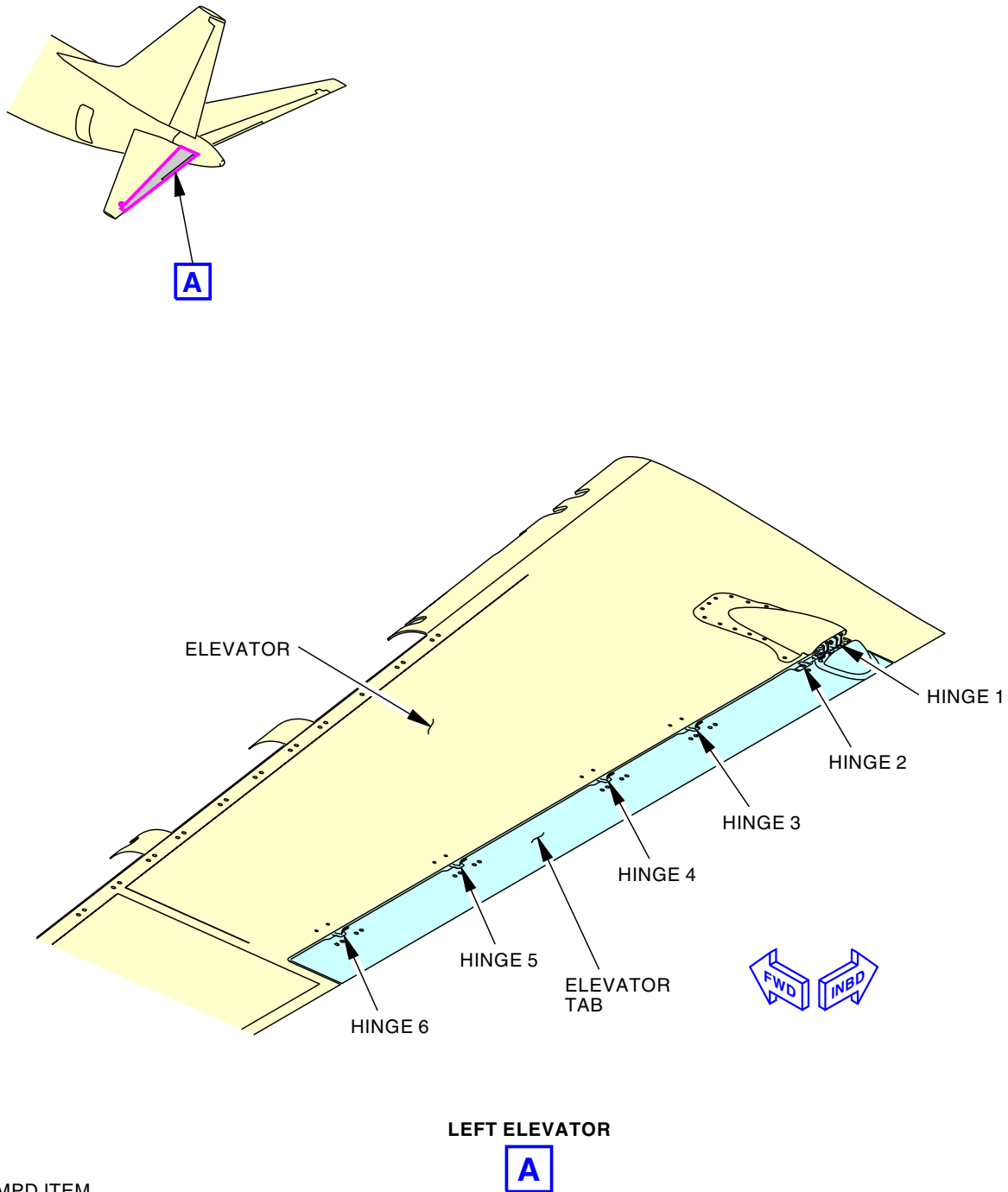
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 296
May 15/2023

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



MPD ITEM
55-115-01

2416364 S00061540498_V1

Left Elevator Tab
Figure 218/55-05-03-990-818

EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 297
May 15/2023



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

TASK 55-05-03-211-804

19. INTERNAL - DETAILED: INTERNAL - RIGHT ELEVATOR TAB HINGE FITTING
(Figure 219)

A. Inspection

SUBTASK 55-05-03-211-004

- (1) Do the inspection.

————— END OF TASK —————

EFFECTIVITY
SIA ALL

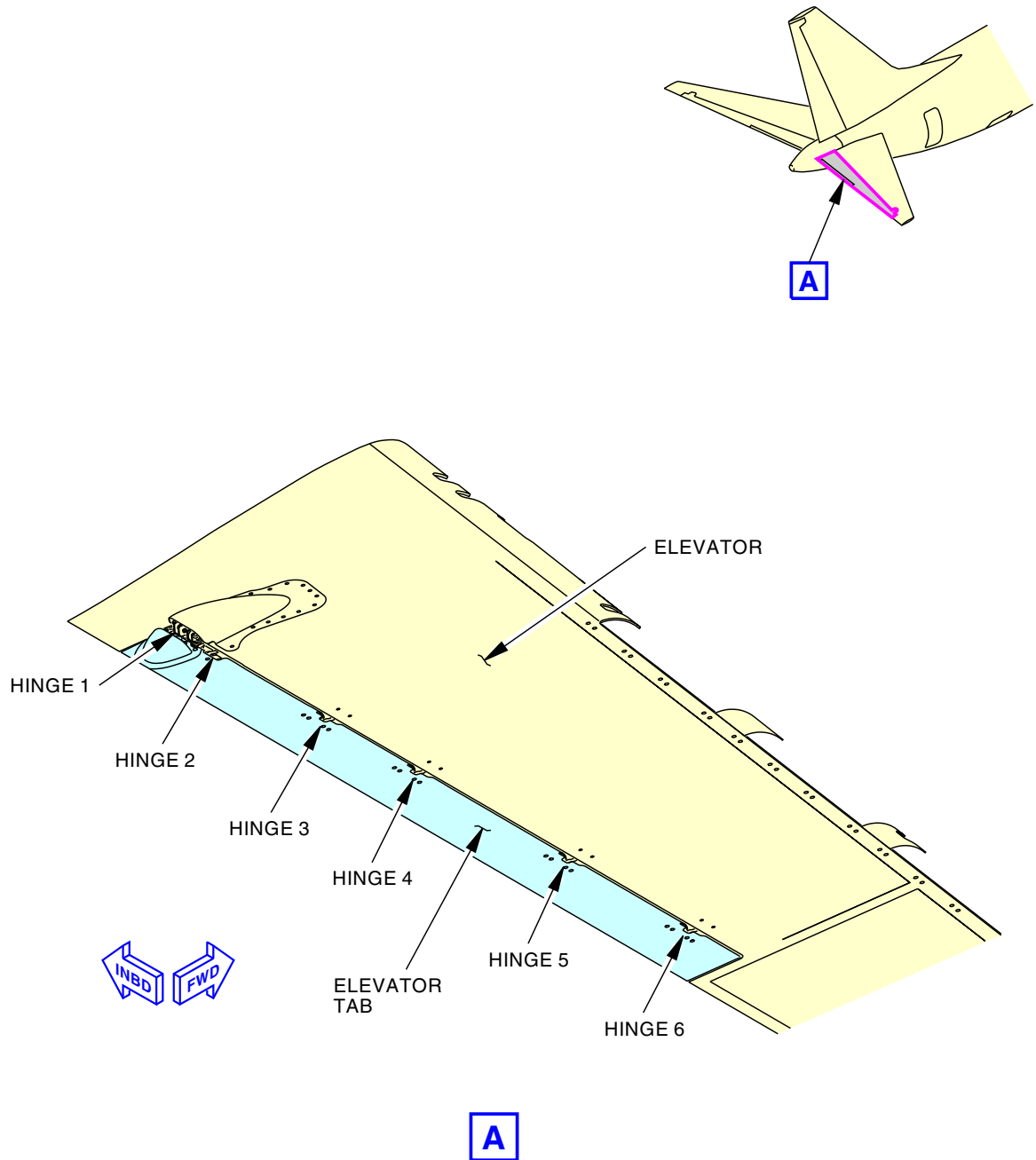
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298
May 15/2023

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



MPD ITEM
55-115-02

2416365 S00061540500_V1

Right Elevator Tab
Figure 219/55-05-03-990-819

EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.1
May 15/2023



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

TASK 55-05-03-210-816

20. **INTERNAL - GENERAL VISUAL: RUDDER, ELEVATOR AND ELEVATOR TAB ATTACH FITTINGS**

(Figure 220)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

B. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II

C. Location Zones

Zone	Area
325	Vertical Fin - Rudder
334	Left Horizontal Stabilizer - Elevator
344	Right Horizontal Stabilizer - Elevator

D. Access Panels

Number	Name/Location
324AAL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324ABL	Panel Assy - Trailing Edge, Beam Seal, Vertical Fin
324ACL	Rudder Nose Cover/Rudder Hinge No. 8 At Rudder Station 276.24
324ADL	Rudder Nose Cover/Rudder Hinge No. 7 At Rudder Station 257.92
324AEL	Rudder Nose Cover/Rudder Hinge No. 6 At Rudder Station 239.61
324AFL	Rudder Nose Cover/Rudder Hinge No. 5 At Rudder Station 184.67
324AGL	Upper Rudder Gap Cover At Rudder Station 164.90
324AHL	Rudder Nose Fairing/Rudder Hinge No. 4 At Rudder Station 129.74.
324AJL	Rudder Nose Fairing/Rudder Hinge No. 3 At Rudder Station 70.65
324AKL	Rudder Nose Fairing/Rudder Hinge No. 2 At Rudder Station 53.48
324ALL	Rudder Nose Cover/Rudder Hinge No. 1 At Rudder Station 6.96
324AXL	Lower Rudder Gap Cover
324QL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324RL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324SL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324TL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324UL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324VL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324WL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324XL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324YL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324ZL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.2
May 15/2023



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

(Continued)

Number	Name/Location
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334PT	Horizontal Stabilizer, Tab Control Rod Fairing
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343BB	Horizontal Stabilizer, Access Panel - T.E. Area
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area
344AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344PT	Horizontal Stabilizer, Tab Control Rod Fairing, Elevator Sta 34.0
S3001	Rudder, Elevator, and Elevator Tab Attach Fittings

E. Inspection

SUBTASK 55-05-03-010-016

- (1) Open these access panels:

Number	Name/Location
324AAL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324ABL	Panel Assy - Trailing Edge, Beam Seal, Vertical Fin
324ACL	Rudder Nose Cover/Rudder Hinge No. 8 At Rudder Station 276.24
324ADL	Rudder Nose Cover/Rudder Hinge No. 7 At Rudder Station 257.92
324AEL	Rudder Nose Cover/Rudder Hinge No. 6 At Rudder Station 239.61
324AFL	Rudder Nose Cover/Rudder Hinge No. 5 At Rudder Station 184.67
324AGL	Upper Rudder Gap Cover At Rudder Station 164.90
324AHL	Rudder Nose Fairing/Rudder Hinge No. 4 At Rudder Station 129.74.
324AJL	Rudder Nose Fairing/Rudder Hinge No. 3 At Rudder Station 70.65
324AKL	Rudder Nose Fairing/Rudder Hinge No. 2 At Rudder Station 53.48
324ALL	Rudder Nose Cover/Rudder Hinge No. 1 At Rudder Station 6.96
324AXL	Lower Rudder Gap Cover
324QL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324RL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324SL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324TL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324UL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324VL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324WL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324XL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324YL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324ZL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.3
May 15/2023



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

(Continued)

<u>Number</u>	<u>Name/Location</u>
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334PT	Horizontal Stabilizer, Tab Control Rod Fairing
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343BB	Horizontal Stabilizer, Access Panel - T.E. Area
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area
344AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344PT	Horizontal Stabilizer, Tab Control Rod Fairing, Elevator Sta 34.0

Special Access:

<u>Number</u>	<u>Name/Location</u>
S3001	Rudder, Elevator, and Elevator Tab Attach Fittings

SUBTASK 55-05-03-210-016

- (2) Do a General Visual inspection of the rudder, elevator and elevator tab skin panels, rudder and elevator spars, rudder and elevator inspar ribs, rudder and elevator leading edge skins, rudder and elevator leading edge ribs, and rudder and elevator leading edge spars.

SUBTASK 55-05-03-910-018

- (3) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 55-05-03-410-027

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

- (a) Make sure that the blade seal is installed correctly into the forward and aft track of the channels.

SUBTASK 55-05-03-410-028

- (5) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

- (a) Make sure that the blade seal is installed correctly into the forward and aft track of the channels.

SUBTASK 55-05-03-410-016

- (6) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
324AAL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324ABL	Panel Assy - Trailing Edge, Beam Seal, Vertical Fin
324ACL	Rudder Nose Cover/Rudder Hinge No. 8 At Rudder Station 276.24
324ADL	Rudder Nose Cover/Rudder Hinge No. 7 At Rudder Station 257.92
324AEL	Rudder Nose Cover/Rudder Hinge No. 6 At Rudder Station 239.61

EFFECTIVITY
SIA ALL

D633AM101-SIA

55-05-03

Page 298.4
May 15/2023



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

(Continued)

<u>Number</u>	<u>Name/Location</u>
324AFL	Rudder Nose Cover/Rudder Hinge No. 5 At Rudder Station 184.67
324AGL	Upper Rudder Gap Cover At Rudder Station 164.90
324AHL	Rudder Nose Fairing/Rudder Hinge No. 4 At Rudder Station 129.74.
324AJL	Rudder Nose Fairing/Rudder Hinge No. 3 At Rudder Station 70.65
324AKL	Rudder Nose Fairing/Rudder Hinge No. 2 At Rudder Station 53.48
324ALL	Rudder Nose Cover/Rudder Hinge No. 1 At Rudder Station 6.96
324AXL	Lower Rudder Gap Cover
324QL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324RL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324SL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324TL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324UL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324VL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324WL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324XL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324YL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
324ZL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334PT	Horizontal Stabilizer, Tab Control Rod Fairing
343BB	Horizontal Stabilizer, Access Panel - T.E. Area
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area
344AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344PT	Horizontal Stabilizer, Tab Control Rod Fairing, Elevator Sta 34.0

SUBTASK 55-05-03-390-012

- (7) Apply an aerodynamic smoother sealant, A02315, to all non-bonded structural components contacting exterior skins.

NOTE: Sealant does not need to be applied to gaps between panels that are used for regular access as long as they are less than limits given in the Structural Repair Manual (SRM SUBJECT 51-10-01).

- (a) Do this task: Aerodynamic Smoother Application, TASK 51-22-00-390-809.

———— **END OF TASK** ————

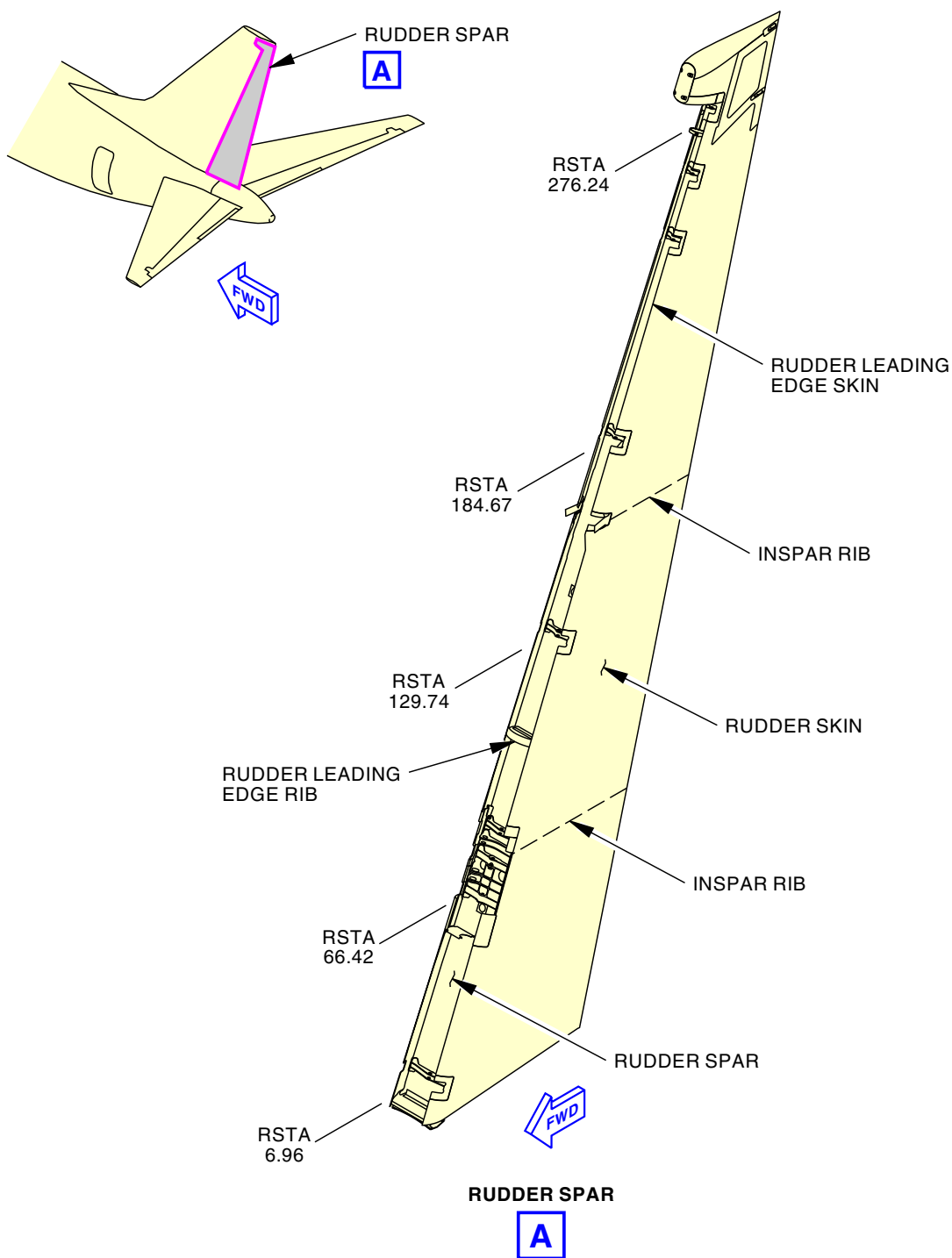
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.5
May 15/2023



2416366 S00061540502_V1

INTERNAL-GENERAL VISUAL: RUDDER, ELEVATOR & ELEVATOR TAB ATTACH FITTINGS
Figure 220/55-05-03-990-820 (Sheet 1 of 4)

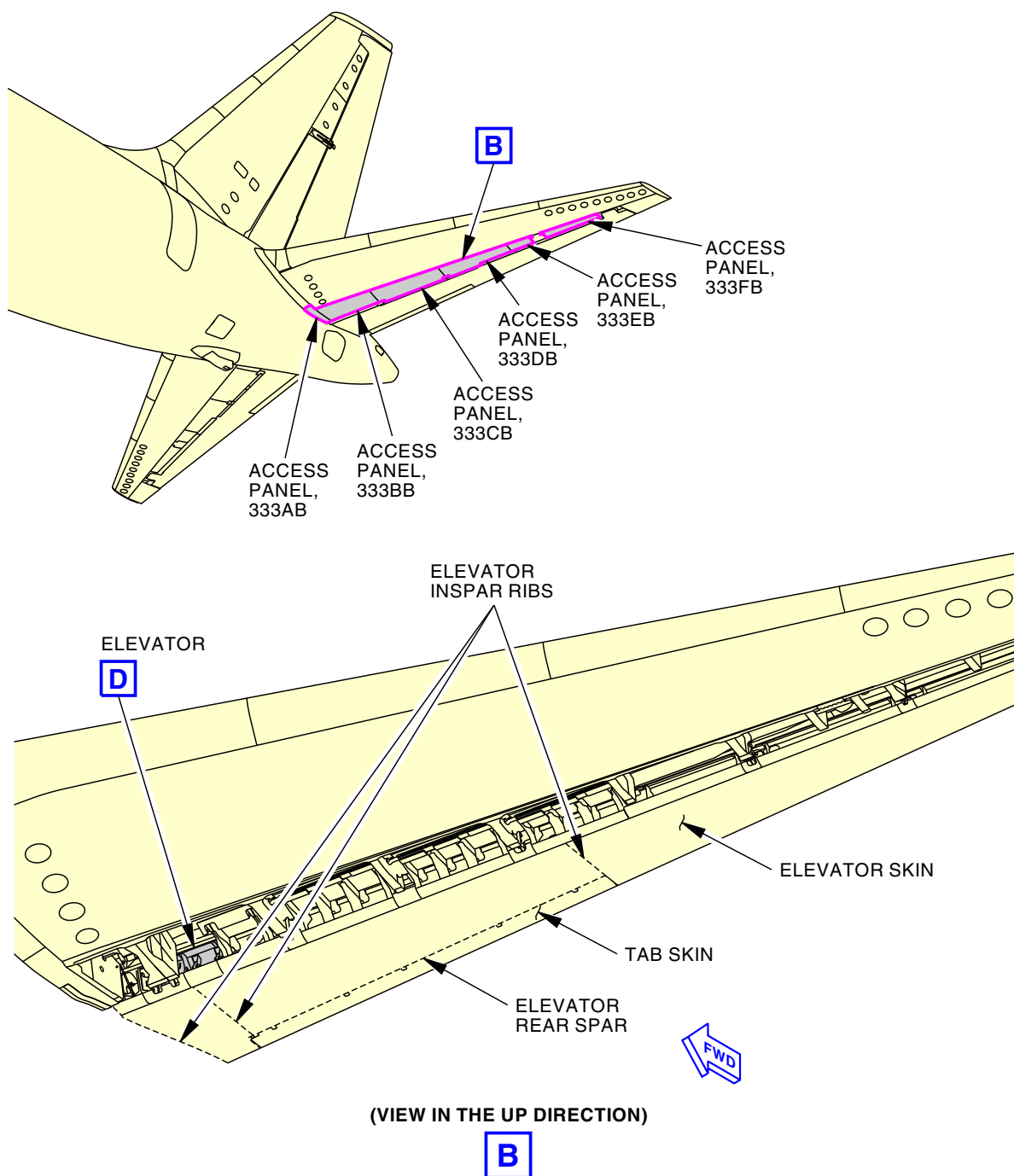
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.6
May 15/2023



2416367 S00061540503_V1

INTERNAL-GENERAL VISUAL: RUDDER, ELEVATOR & ELEVATOR TAB ATTACH FITTINGS
Figure 220/55-05-03-990-820 (Sheet 2 of 4)

EFFECTIVITY	
SIA ALL	

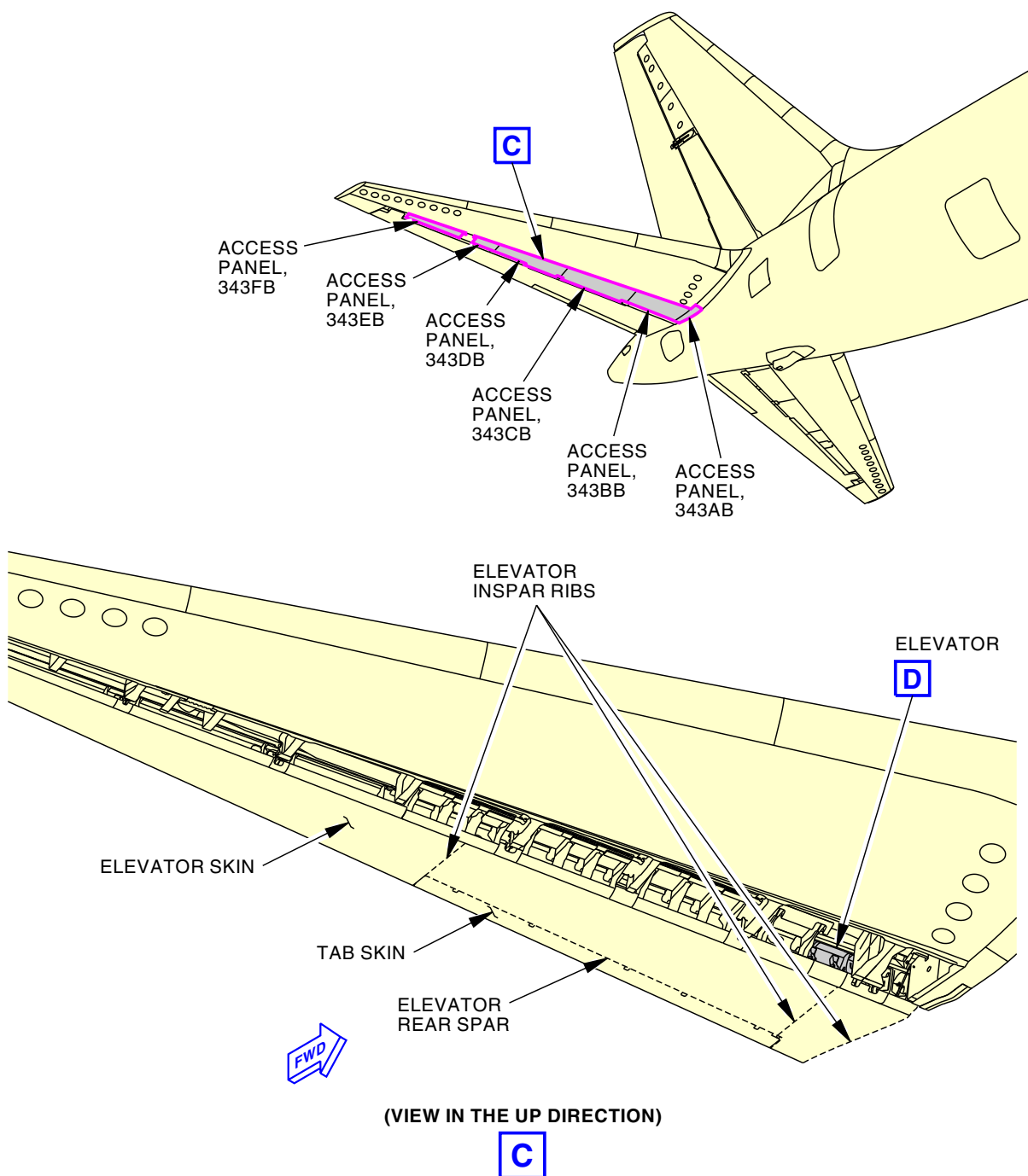
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03



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



2416368 S00061540504_V1

INTERNAL-GENERAL VISUAL: RUDDER, ELEVATOR & ELEVATOR TAB ATTACH FITTINGS
Figure 220/55-05-03-990-820 (Sheet 3 of 4)

EFFECTIVITY	
SIA ALL	

D633AM101-SIA

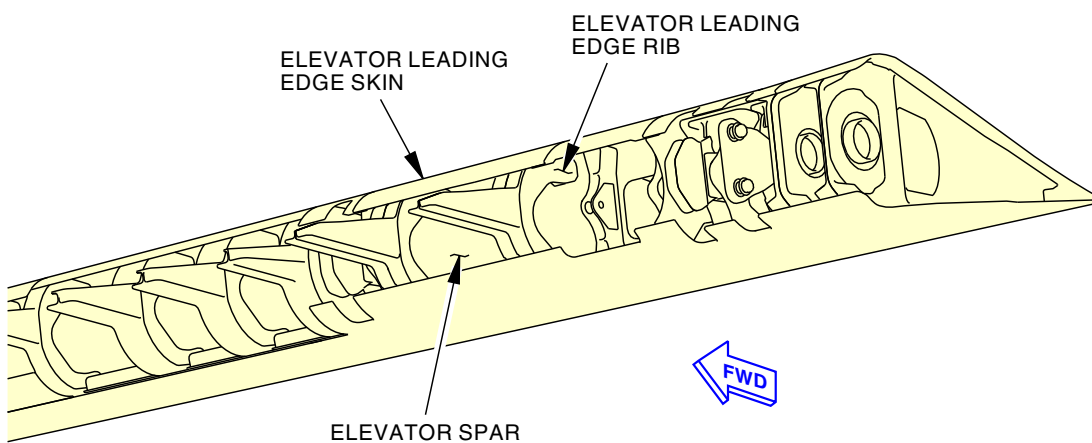
ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.8
May 15/2023



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



ELEVATOR
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

D

2416369 S00061540505_V1

INTERNAL-GENERAL VISUAL: RUDDER, ELEVATOR & ELEVATOR TAB ATTACH FITTINGS
Figure 220/55-05-03-990-820 (Sheet 4 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.9
May 15/2023



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

TASK 55-05-03-211-805

21. **INTERNAL - DETAILED: LEFT ELEVATOR HINGE, ACTUATOR, AND TAB MAST ARM FTGS AND
BALANCE WT SUPPT STRUC**

(Figure 221)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-803	737-7/8/8200/9 Basic Task Description (P/B 201)
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

B. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II

C. Location Zones

Zone	Area
334	Left Horizontal Stabilizer - Elevator

D. Access Panels

Number	Name/Location
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334HB	Horizontal Stabilizer, Elevator Hinge Cover
334JB	Horizontal Stabilizer, Elevator Hinge Cover
334KB	Horizontal Stabilizer, Elevator Hinge Cover
334LB	Horizontal Stabilizer, Elevator Hinge Cover
334MB	Horizontal Stabilizer, Elevator Hinge Cover
334NB	Horizontal Stabilizer, Elevator Hinge Cover

E. Inspection

SUBTASK 55-05-03-010-017

(1) Open these access panels:

Number	Name/Location
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334HB	Horizontal Stabilizer, Elevator Hinge Cover
334JB	Horizontal Stabilizer, Elevator Hinge Cover
334KB	Horizontal Stabilizer, Elevator Hinge Cover

EFFECTIVITY
SIA ALL

D633AM101-SIA

55-05-03

Page 298.10
May 15/2023



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

(Continued)

<u>Number</u>	<u>Name/Location</u>
334LB	Horizontal Stabilizer, Elevator Hinge Cover
334MB	Horizontal Stabilizer, Elevator Hinge Cover
334NB	Horizontal Stabilizer, Elevator Hinge Cover

NOTE: Remove lower trailing edge panels and disconnect balance bay panels. Remove elevator hinge cover plates. Alternative - Remove elevator from horizontal stabilizer. For elevator tab mast arm fittings, remove fairing on upper surface of elevator to gain access.

SUBTASK 55-05-03-211-005

- (2) Do a Detailed inspection of the left elevator hinge fittings, left elevator actuator fittings, left elevator balance weight support structure, left elevator tab mast arm fitting and left elevator tab hinge fittings.

SUBTASK 55-05-03-910-019

- (3) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-803.

SUBTASK 55-05-03-410-017

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334HB	Horizontal Stabilizer, Elevator Hinge Cover
334JB	Horizontal Stabilizer, Elevator Hinge Cover
334KB	Horizontal Stabilizer, Elevator Hinge Cover
334LB	Horizontal Stabilizer, Elevator Hinge Cover
334MB	Horizontal Stabilizer, Elevator Hinge Cover
334NB	Horizontal Stabilizer, Elevator Hinge Cover

SUBTASK 55-05-03-390-013

- (5) Apply an aerodynamic smoother sealant, A02315, to all non-bonded structural components contacting exterior skins.

NOTE: Sealant does not need to be applied to gaps between panels that are used for regular access as long as they are less than limits given in the Structural Repair Manual (SRM SUBJECT 51-10-01).

- (a) Do this task: Aerodynamic Smoother Application, TASK 51-22-00-390-809.

———— **END OF TASK** ————

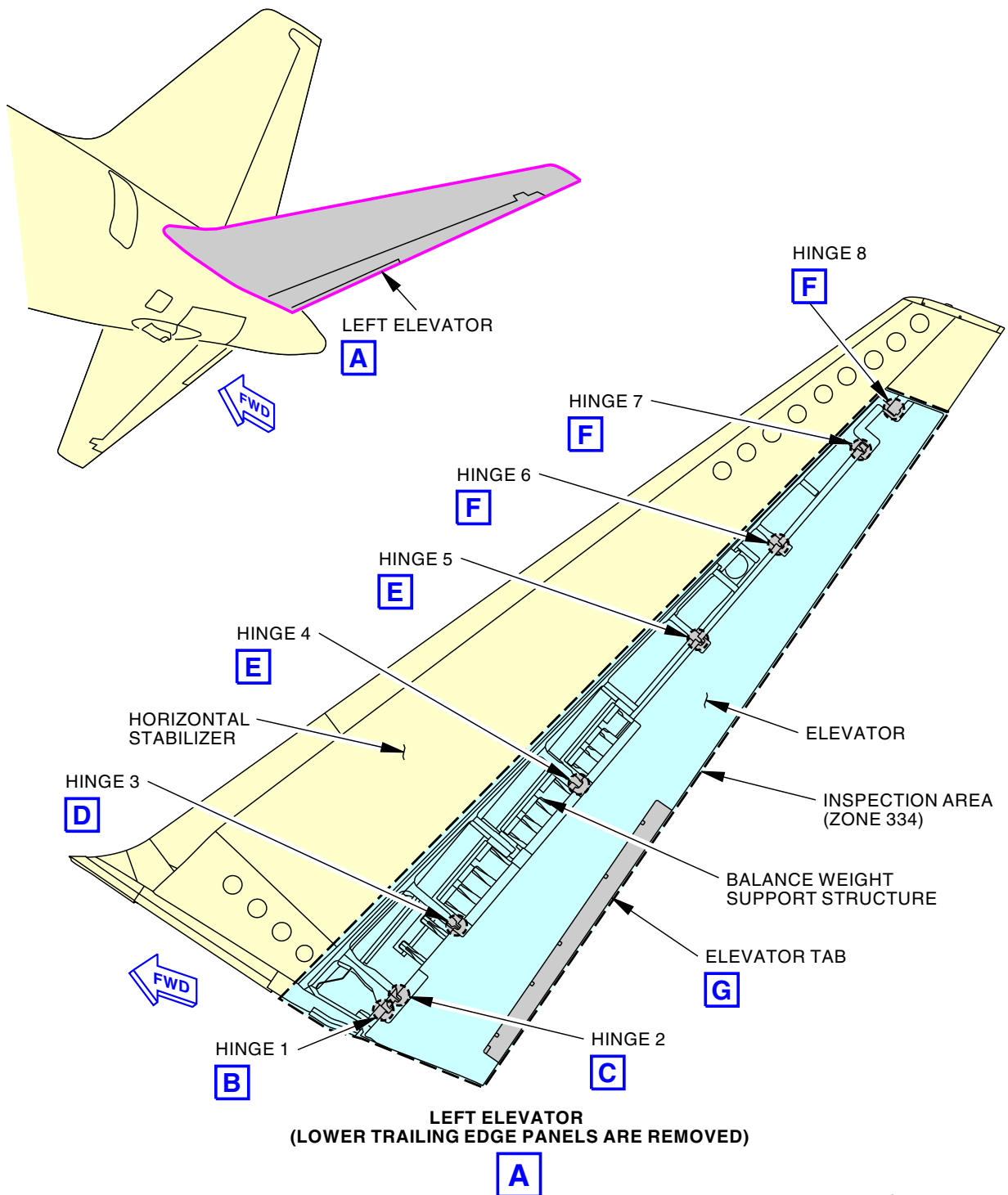
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.11
May 15/2023



2416370 S00061540507_V1

Lft Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt
Figure 221/55-05-03-990-821 (Sheet 1 of 6)

EFFECTIVITY
SIA ALL

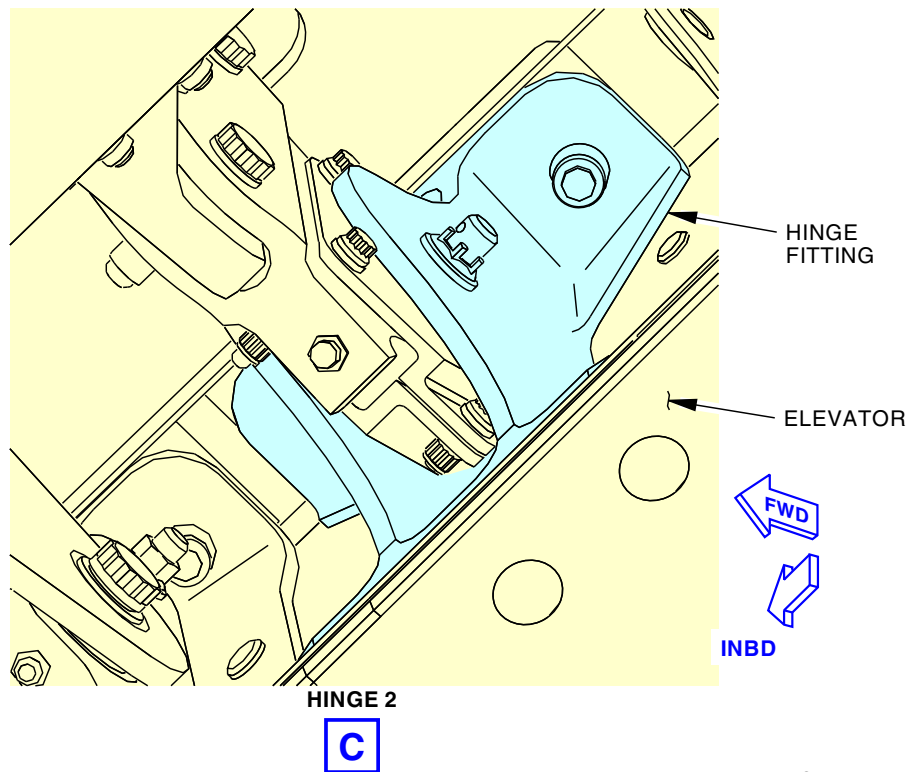
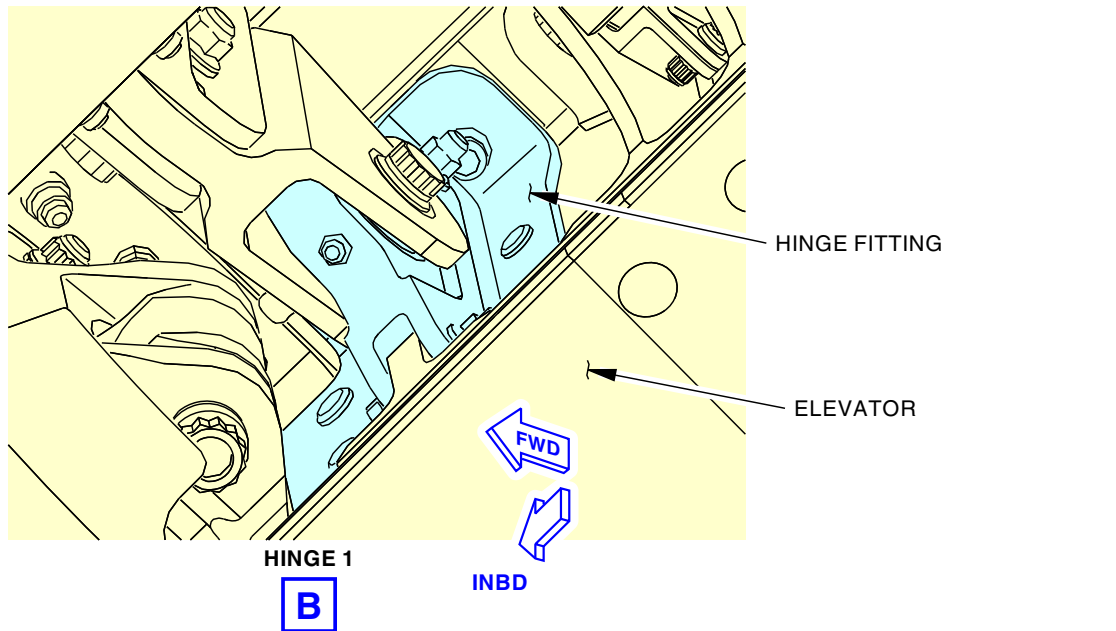
D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.12
May 15/2023

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



2416371 S00061540508_V1

Lft Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt
Figure 221/55-05-03-990-821 (Sheet 2 of 6)

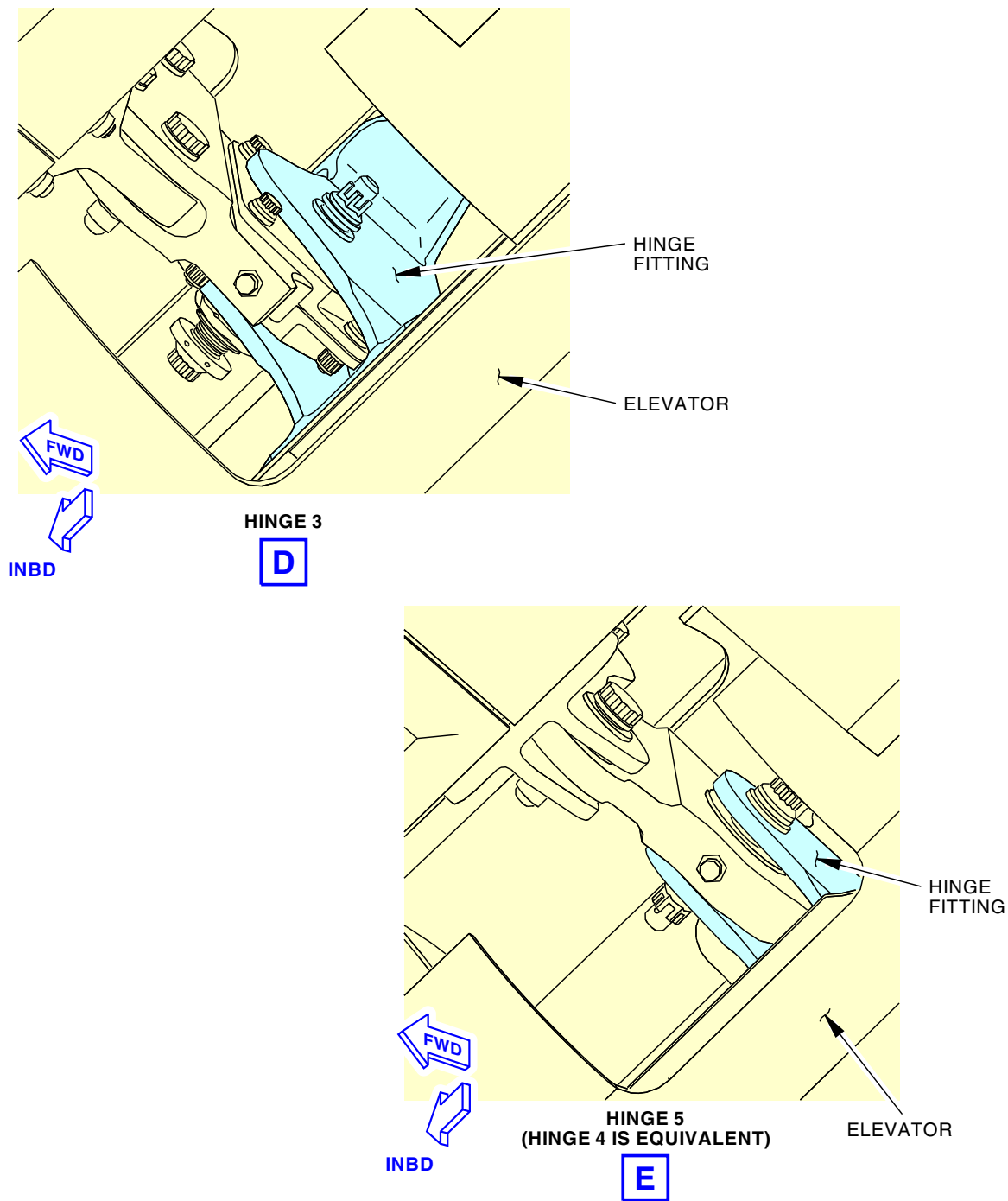
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.13
May 15/2023



2416372 S00061540509_V1

Lft Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt
Figure 221/55-05-03-990-821 (Sheet 3 of 6)

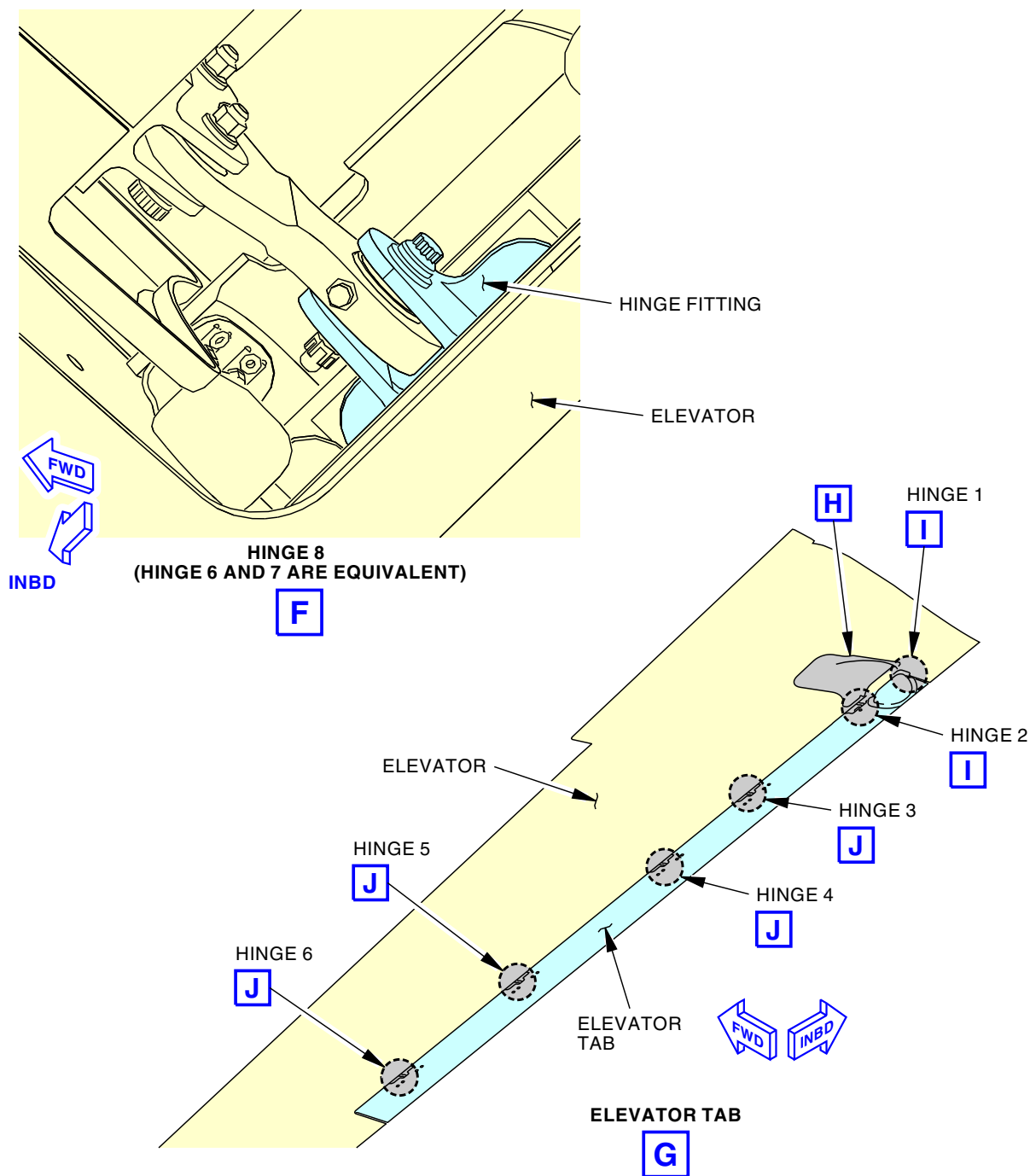
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.14
May 15/2023



2416373 S00061540510_V1

Lft Ele. Hinge, Actuator, and Tab Mast Arm Ftg and Balance WT Suppt
Figure 221/55-05-03-990-821 (Sheet 4 of 6)

EFFECTIVITY
SIA ALL

D633AM101-SIA

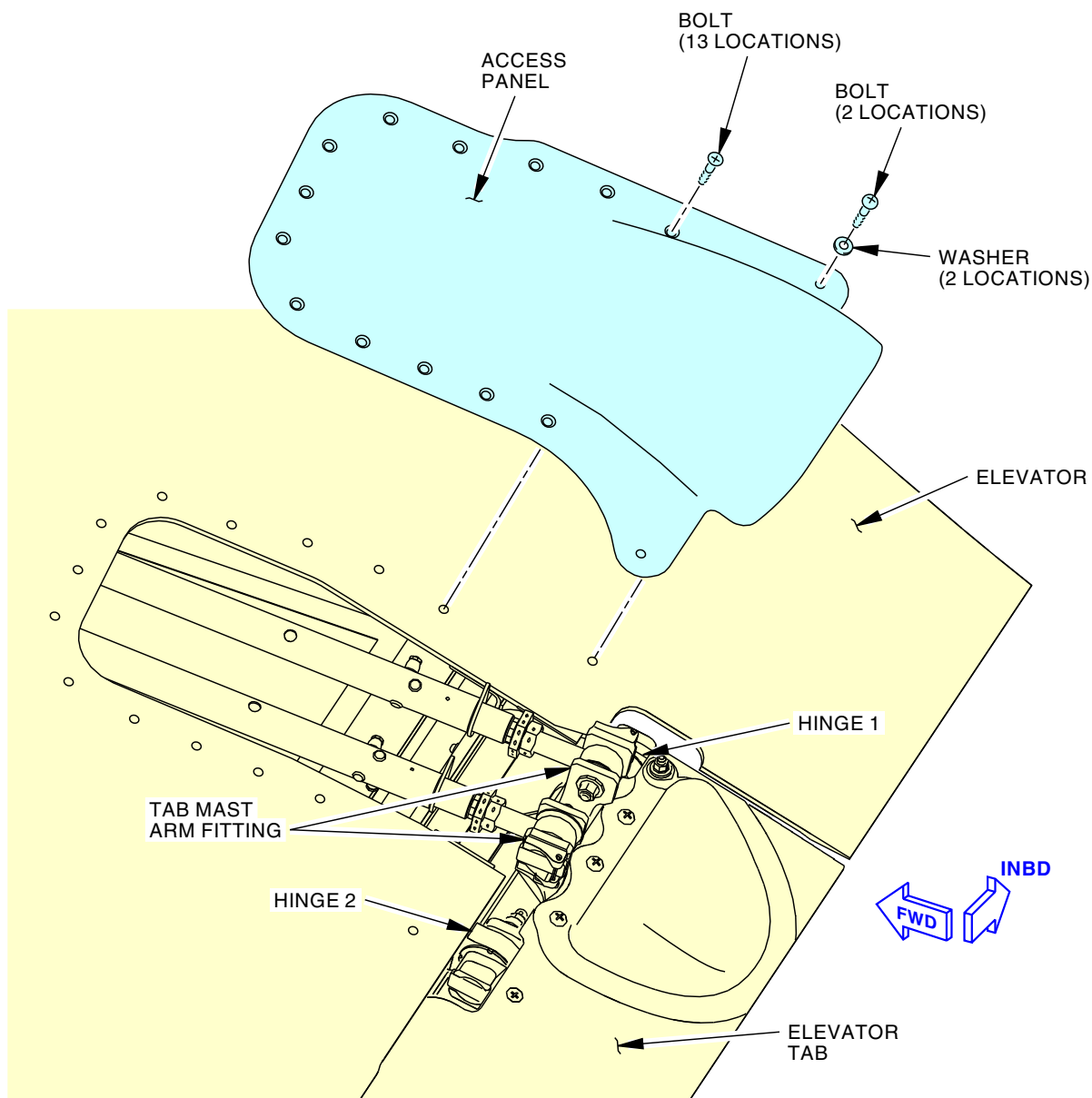
ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.15
May 15/2023



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



H

2416374 S00061540511_V1

Lft Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt
Figure 221/55-05-03-990-821 (Sheet 5 of 6)

EFFECTIVITY
SIA ALL

D633AM101-SIA

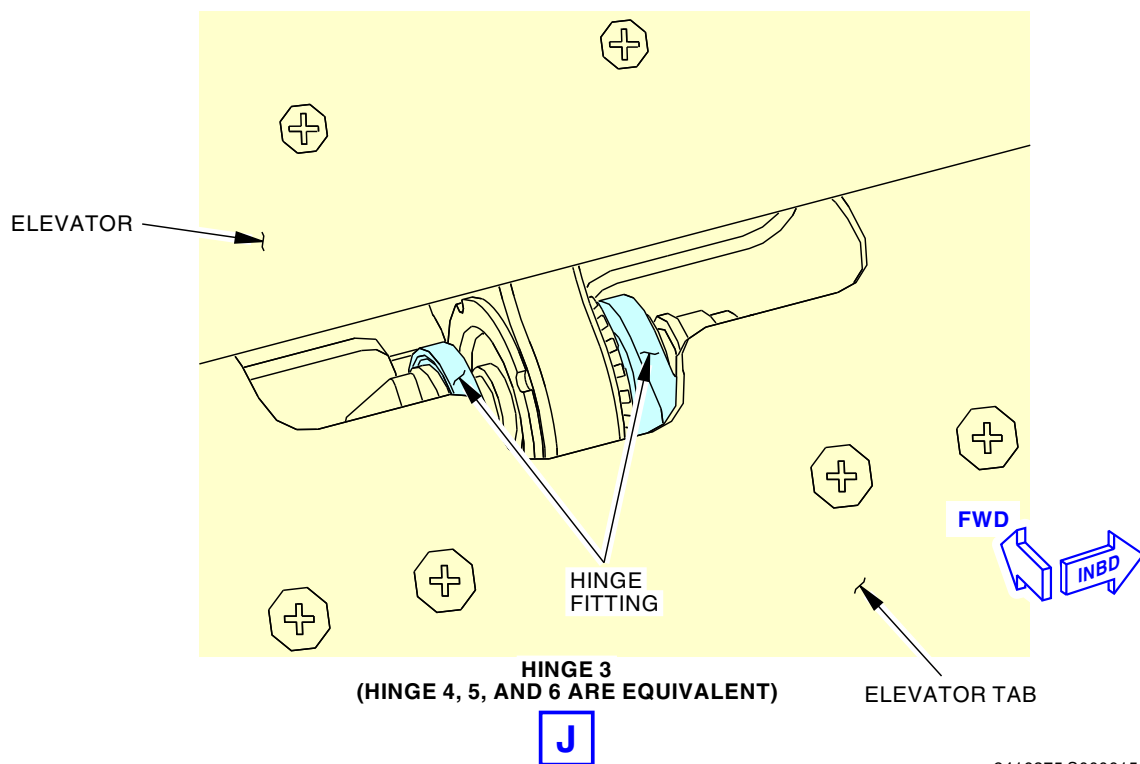
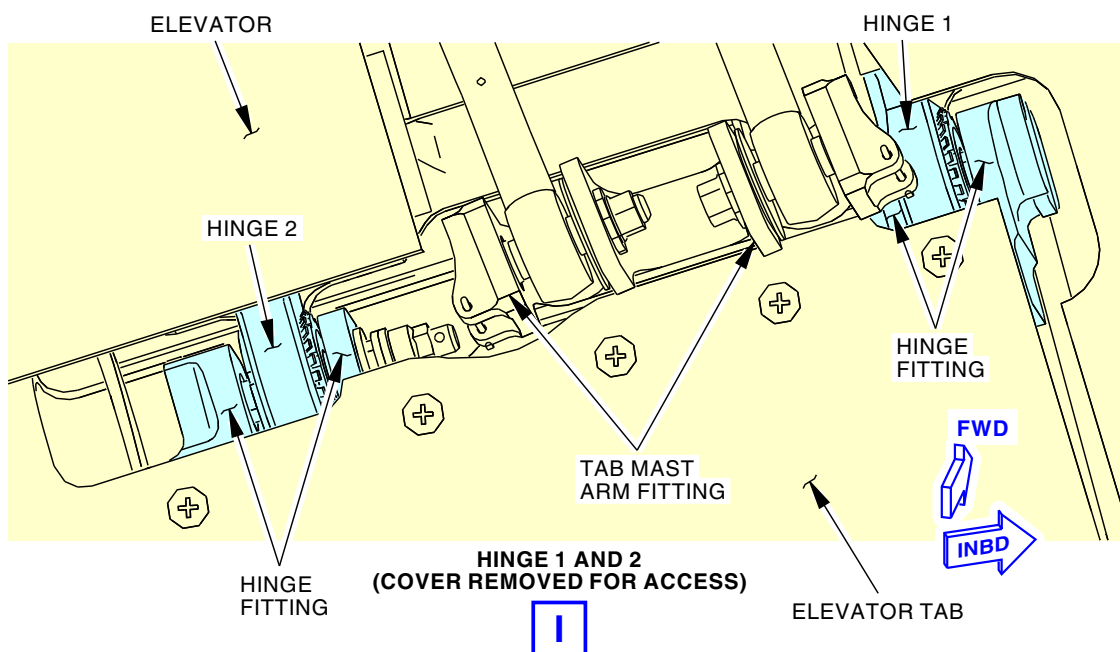
ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.16
May 15/2023



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



2416375 S00061540512_V1

Lft Ele. Hinge, Actuator, and Tab Mast Arm Ftg and Balance WT Suppt
Figure 221/55-05-03-990-821 (Sheet 6 of 6)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.17
May 15/2023



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

TASK 55-05-03-211-806

22. **INTERNAL - DETAILED: RIGHT ELEVATOR HINGE, ACTUATOR, AND TAB MAST ARM FTGS AND
BALANCE WT SUPPT STRUCT**

(Figure 222)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-803	737-7/8/8200/9 Basic Task Description (P/B 201)
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

B. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II

C. Location Zones

Zone	Area
344	Right Horizontal Stabilizer - Elevator

D. Access Panels

Number	Name/Location
343BB	Horizontal Stabilizer, Access Panel - T.E. Area
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344HB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 66.54
344JB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 121.59
344KB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 176.64
344LB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 213.32
344MB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 250.04
344NB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

E. Inspection

SUBTASK 55-05-03-010-018

(1) Open these access panels:

Number	Name/Location
343BB	Horizontal Stabilizer, Access Panel - T.E. Area
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344HB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 66.54
344JB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 121.59
344KB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 176.64

EFFECTIVITY
SIA ALL

D633AM101-SIA

55-05-03

Page 298.18
May 15/2023



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

(Continued)

<u>Number</u>	<u>Name/Location</u>
344LB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 213.32
344MB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 250.04
344NB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

NOTE: Remove lower trailing edge panels and disconnect balance bay panels. Remove elevator hinge cover plates. Alternative - Remove elevator from horizontal stabilizer. For elevator tab mast arm fittings, remove fairing on upper surface of elevator to gain access.

SUBTASK 55-05-03-211-006

- (2) Do a Detailed inspection of the right elevator hinge fittings, right elevator actuator fittings, right elevator balance weight support structure, right elevator tab mast arm fitting and right elevator tab hinge fittings.

SUBTASK 55-05-03-910-020

- (3) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-803.

SUBTASK 55-05-03-410-018

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
343BB	Horizontal Stabilizer, Access Panel - T.E. Area
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344HB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 66.54
344JB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 121.59
344KB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 176.64
344LB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 213.32
344MB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 250.04
344NB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

SUBTASK 55-05-03-390-014

- (5) Apply an aerodynamic smoother sealant, A02315, to all non-bonded structural components contacting exterior skins.

NOTE: Sealant does not need to be applied to gaps between panels that are used for regular access as long as they are less than limits given in the Structural Repair Manual (SRM SUBJECT 51-10-01).

- (a) Do this task: Aerodynamic Smoother Application, TASK 51-22-00-390-809.

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

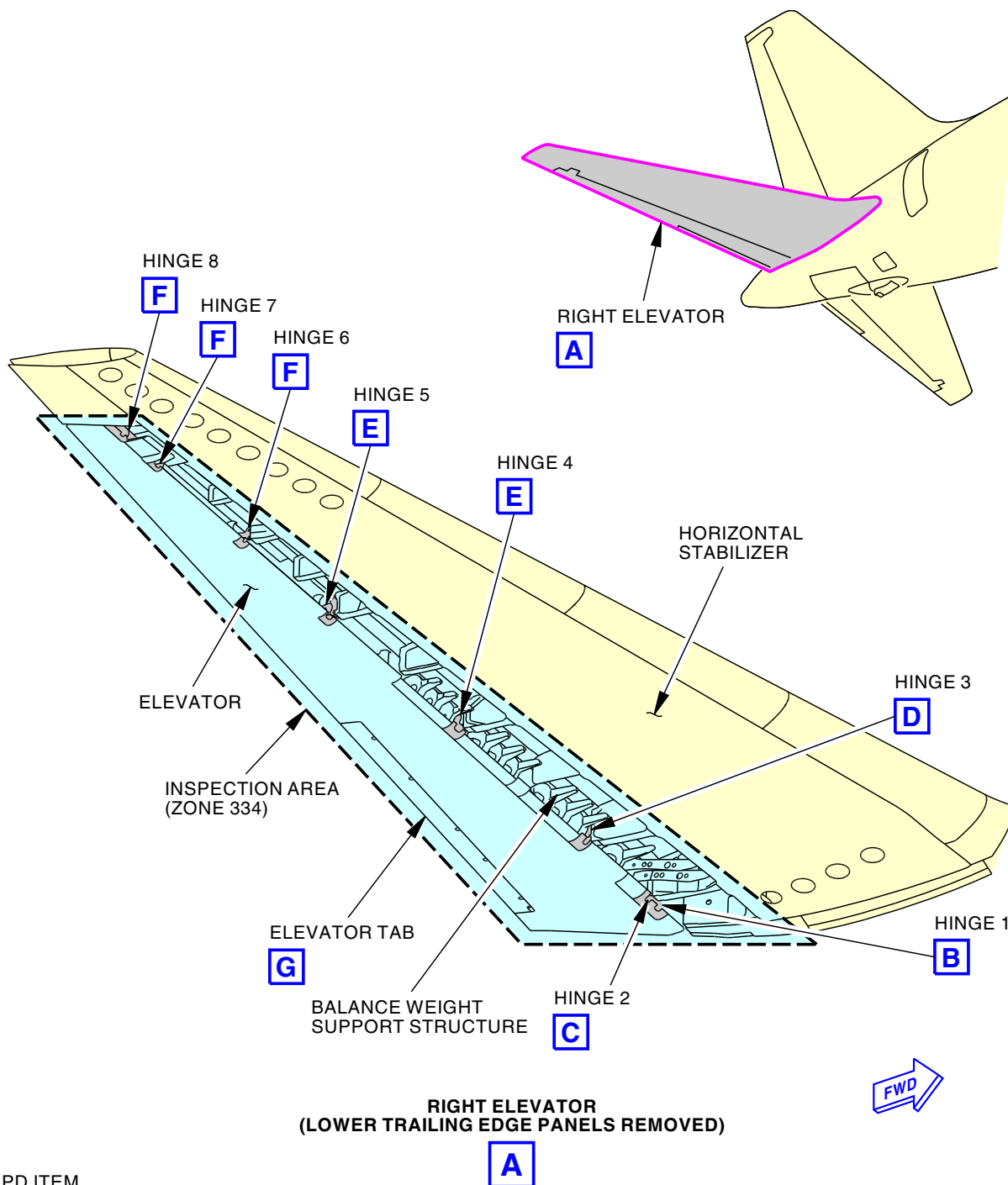
ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.19
May 15/2023



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



MPD ITEM
55-135-02

2416376 S00061540514_V1

Rt. Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt
Figure 222/55-05-03-990-822 (Sheet 1 of 6)

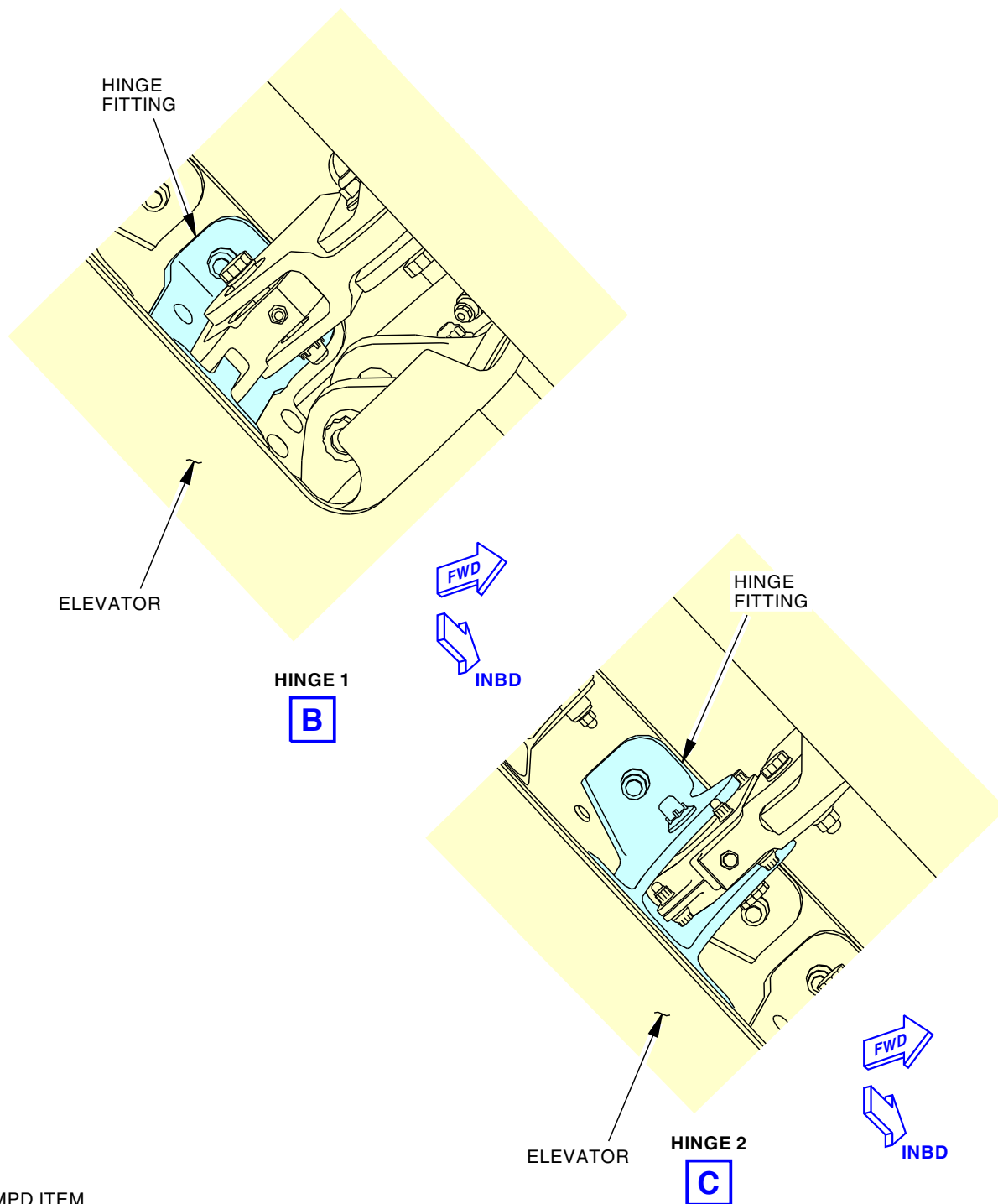
EFFECTIVITY
SIA ALL

55-05-03

Page 298.20
May 15/2023

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details



MPD ITEM
55-135-02

2416377 S00061540515_V1

Rt. Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt
Figure 222/55-05-03-990-822 (Sheet 2 of 6)

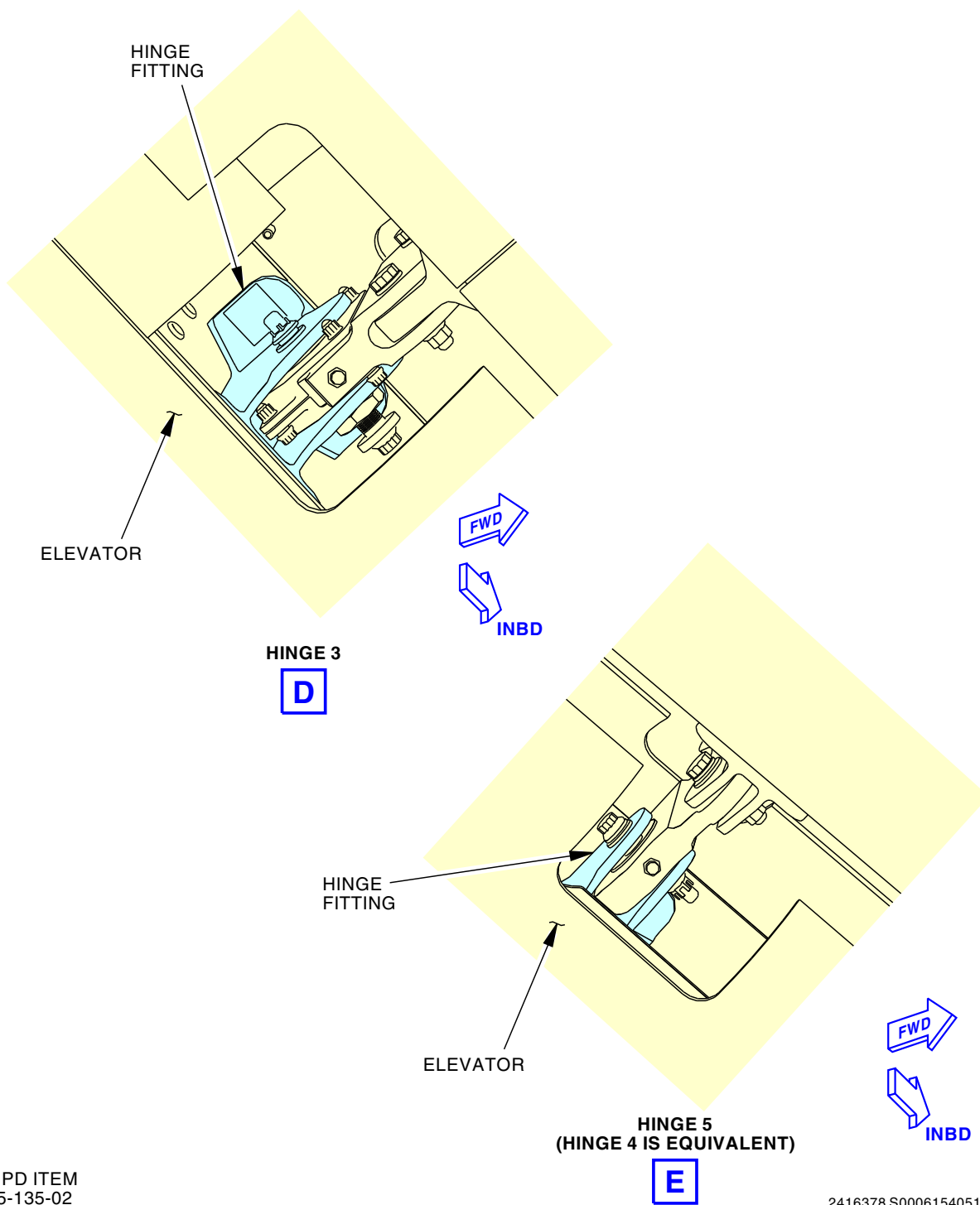
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.21
May 15/2023



Rt. Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt
Figure 222/55-05-03-990-822 (Sheet 3 of 6)

EFFECTIVITY
SIA ALL

D633AM101-SIA

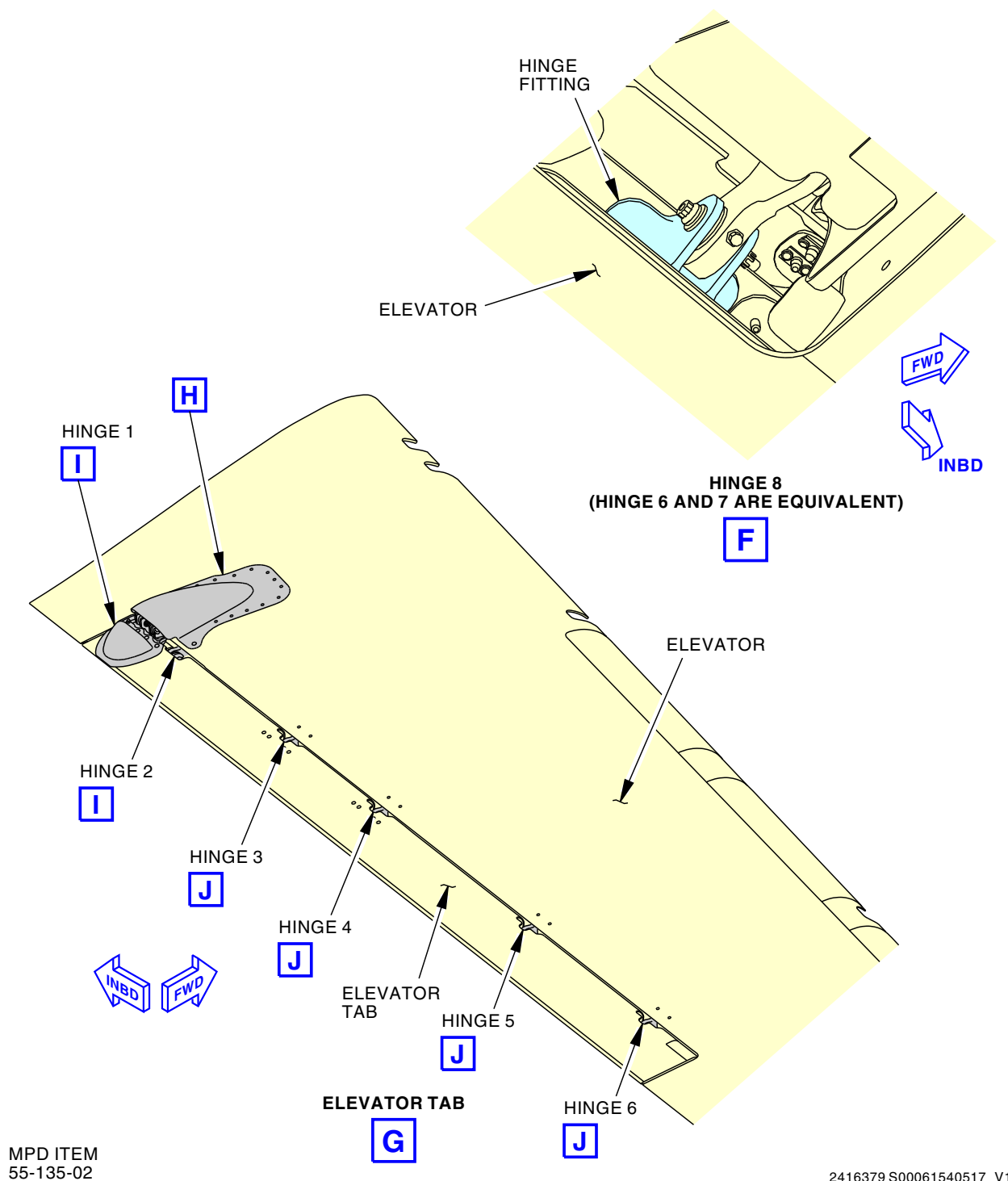
ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.22
May 15/2023



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



Rt. Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt
Figure 222/55-05-03-990-822 (Sheet 4 of 6)

EFFECTIVITY
SIA ALL

55-05-03

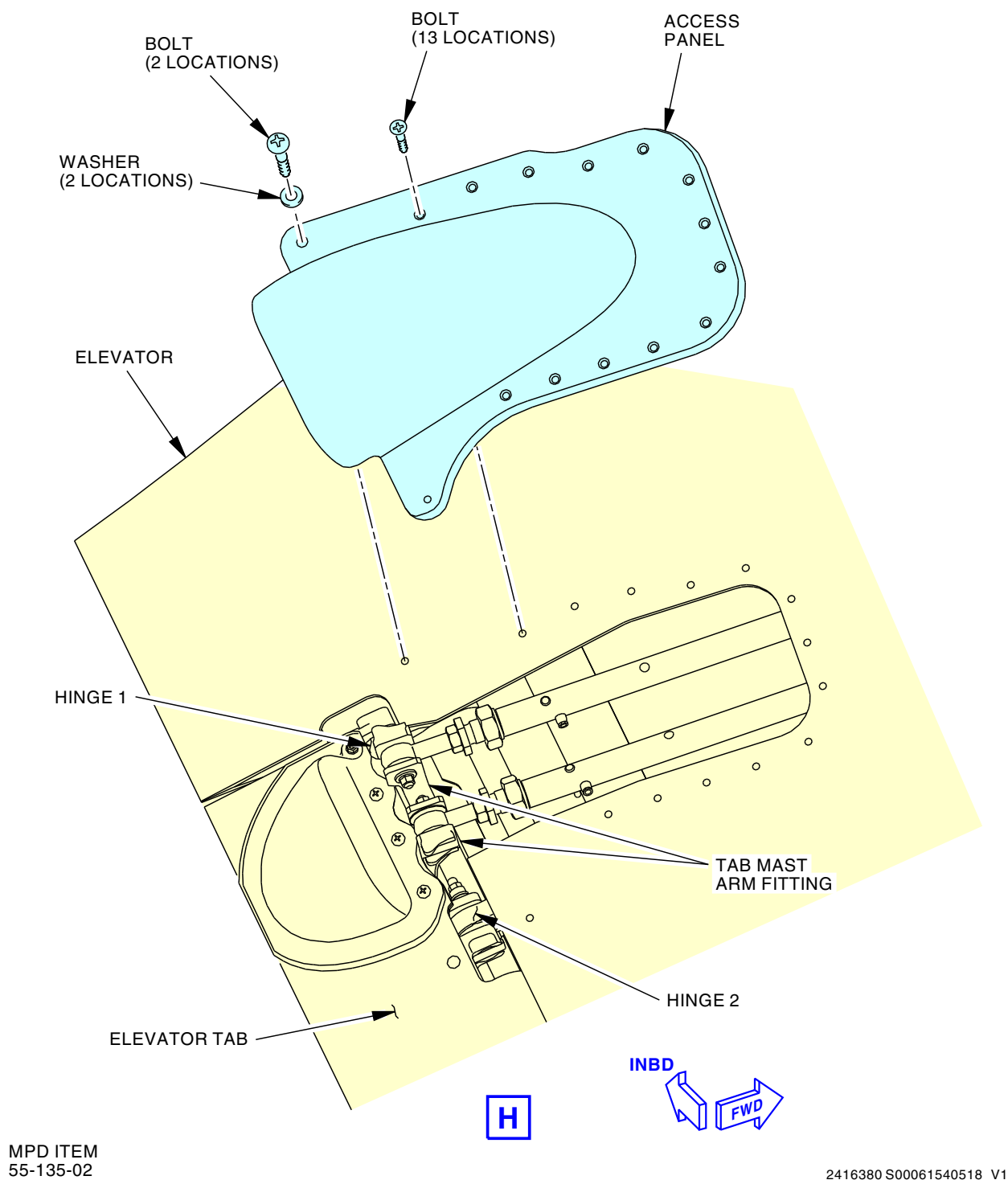
Page 298.23
May 15/2023

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ECCN 9E991 BOEING PROPRIETARY - See title page for details



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



Rt. Ele. Hinge, Actuator, and Tab Mast Arm Ftg and Balance WT Suppt
Figure 222/55-05-03-990-822 (Sheet 5 of 6)

EFFECTIVITY
SIA ALL

D633AM101-SIA

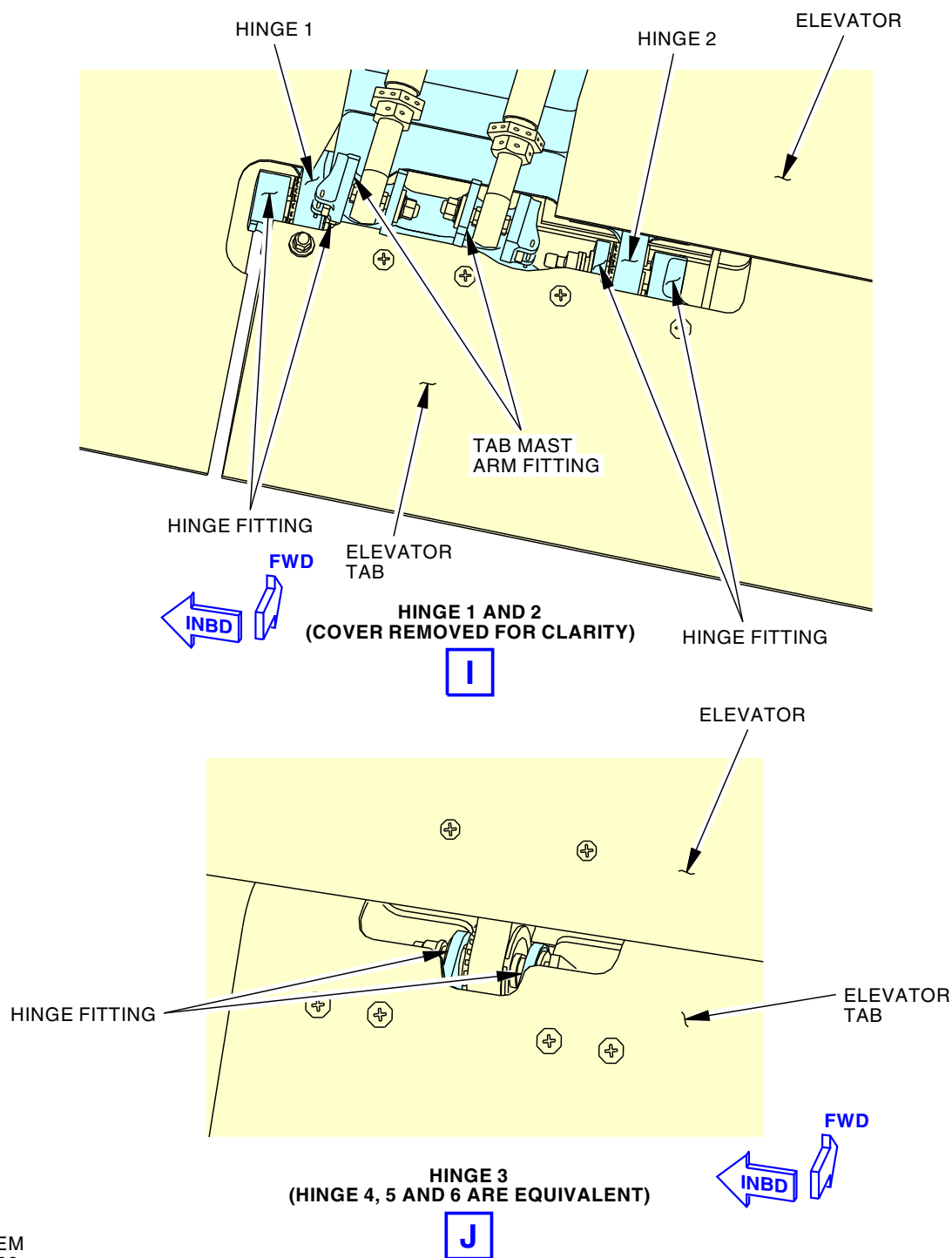
ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.24
May 15/2023



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



MPD ITEM
55-135-02

2416381 S00061540519_V1

Rt. Ele. Hinge, Actuator, and Tab Mast Arm Fgts and Balance WT Suppt
Figure 222/55-05-03-990-822 (Sheet 6 of 6)

EFFECTIVITY
SIA ALL

55-05-03

D633AM101-SIA

Page 298.25
May 15/2023



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

TASK 55-05-03-290-801

23. **INTERNAL - SPECIAL DETAILED: LEFT HORIZONTAL STABILIZER TRAILING EDGE**

(Figure 223)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-804	737-7/8/8200/9 Basic Task Description (P/B 201)
55-10-00-000-801	Horizontal Stabilizer Tip - Removal (P/B 401)
55-10-00-400-801	Horizontal Stabilizer Tip - Installation (P/B 401)

B. Location Zones

Zone	Area
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge

C. Access Panels

Number	Name/Location
335A	Horizontal Stabilizer, Removable Stabilizer Tip

D. Inspection

SUBTASK 55-05-03-010-019

- (1) Open this access panel:

Number	Name/Location
335A	Horizontal Stabilizer, Removable Stabilizer Tip

- (a) Do this task: Horizontal Stabilizer Tip - Removal, TASK 55-10-00-000-801

SUBTASK 55-05-03-290-001

- (2) Do a Special Detailed (borescope) inspection of the aft side of the left horizontal stabilizer rear spar from STAB BL 254.66 to STAB BL 281.81, including the spar chords and webs.

SUBTASK 55-05-03-910-021

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

SUBTASK 55-05-03-410-023

- (4) Close this access panel:

Number	Name/Location
335A	Horizontal Stabilizer, Removable Stabilizer Tip

- (a) Do this task: Horizontal Stabilizer Tip - Installation, TASK 55-10-00-400-801

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

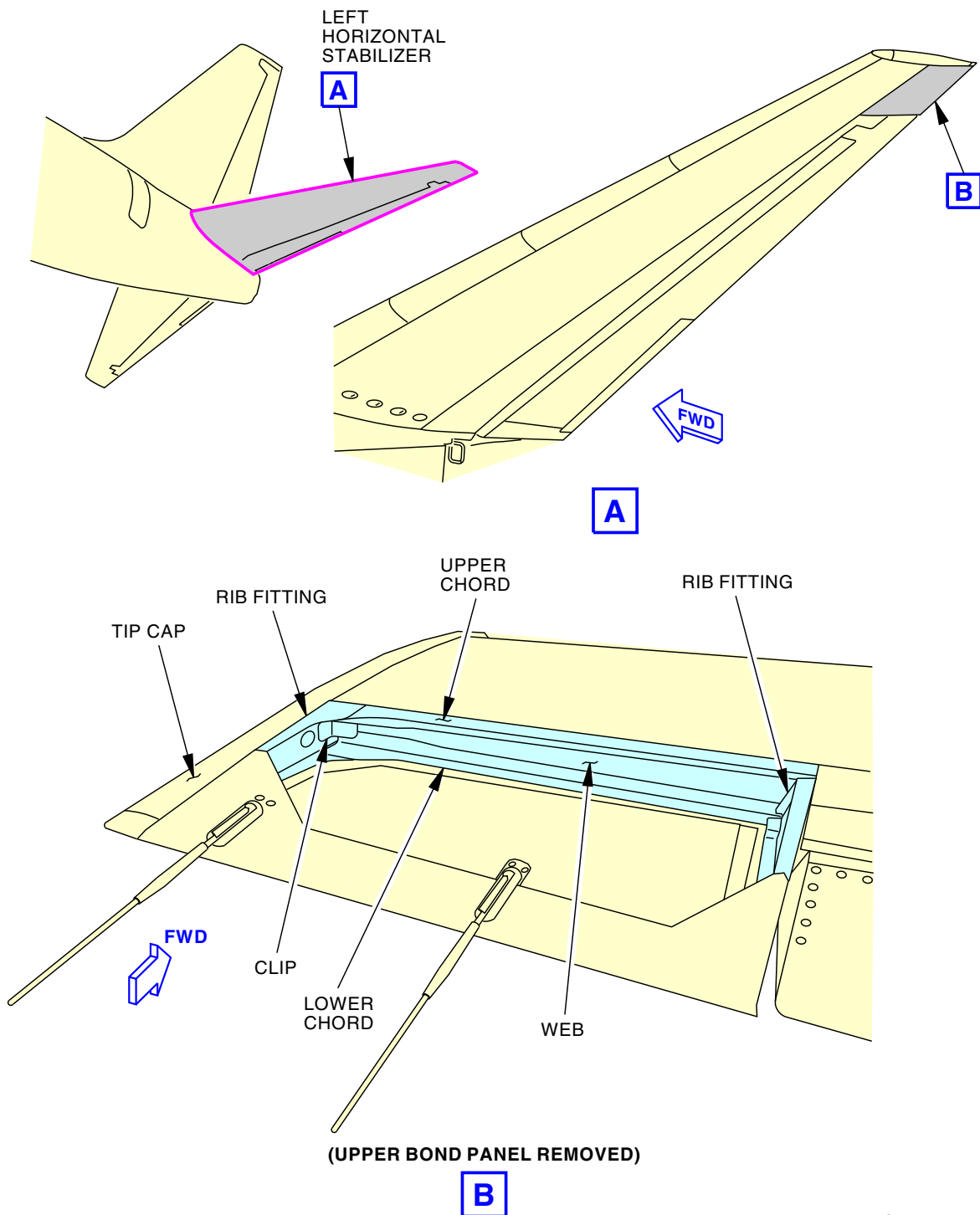
ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.26
May 15/2023



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



3003892 S0000779017_V1

Left Horizontal Stabilizer Trailing Edge STAB BL 254.66 to STAB BL 281.81 - Special Detailed (Internal)
Figure 223/55-05-03-990-823

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.27
May 15/2023



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

TASK 55-05-03-290-802

24. **INTERNAL - SPECIAL DETAILED: RIGHT HORIZONTAL STABILIZER TRAILING EDGE**

(Figure 224)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-804	737-7/8/8200/9 Basic Task Description (P/B 201)
55-10-00-000-801	Horizontal Stabilizer Tip - Removal (P/B 401)
55-10-00-400-801	Horizontal Stabilizer Tip - Installation (P/B 401)

B. Location Zones

Zone	Area
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

C. Access Panels

Number	Name/Location
345A	Horizontal Stabilizer, Removable Stabilizer Tip

D. Inspection

SUBTASK 55-05-03-010-020

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
345A	Horizontal Stabilizer, Removable Stabilizer Tip

- (a) Do this task: Horizontal Stabilizer Tip - Removal, TASK 55-10-00-000-801

SUBTASK 55-05-03-290-002

- (2) Do a Special Detailed (borescope) inspection of the aft side of the right horizontal stabilizer rear spar from STAB BL 254.66 to STAB BL 281.81, including the spar chords and webs

SUBTASK 55-05-03-910-022

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

SUBTASK 55-05-03-410-024

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
345A	Horizontal Stabilizer, Removable Stabilizer Tip

- (a) Do this task: Horizontal Stabilizer Tip - Installation, TASK 55-10-00-400-801

———— **END OF TASK** ————

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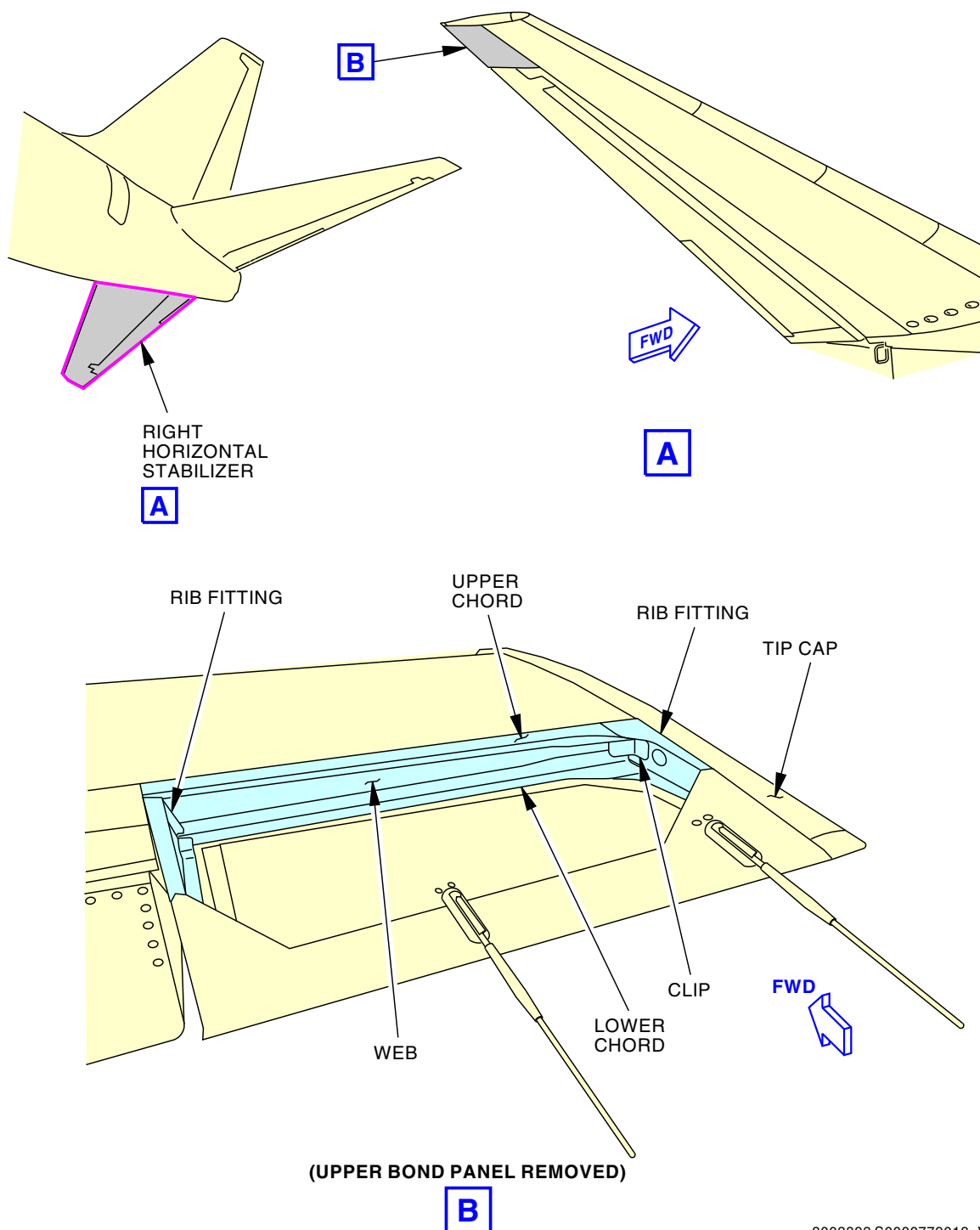
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55-05-03

Page 298.28
May 15/2023



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



3003893 S0000779018_V1

Right Horizontal Stabilizer Trailing Edge STAB BL 254.66 to STAB BL 281.81 - Special Detailed (Internal)
Figure 224/55-05-03-990-824

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-05-03

Page 298.29
May 15/2023



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

HORIZONTAL STABILIZER TIP - REMOVAL/INSTALLATION

1. General

- A. This procedure contains the following tasks:
- (1) A removal of the horizontal stabilizer tip.
 - (2) An installation of the horizontal stabilizer tip.
- B. The procedure that follows refers to the horizontal stabilizer tip as the tip.
- C. The tip includes a forward leading edge cap, a middle composite tip cap and an aft trailing edge tip.
- D. The forward leading edge cap and aft trailing edge tip are an aluminum alloy sheet. They attach to the fiberglass composite tip cap with rivets. Thus, you remove the three fairings together as one unit.

TASK 55-10-00-000-801

2. Horizontal Stabilizer Tip - Removal

Figure 401

A. **Location Zones**

Zone	Area
------	------

335	Left Horizontal Stabilizer - Tip
345	Right Horizontal Stabilizer - Tip

B. **Prepare for the Removal**

SUBTASK 55-10-00-860-002

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

F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	10	C00207	FLIGHT CONTROL STAB TRIM CONT
D	10	C00840	FLIGHT CONTROL STAB TRIM ACTUATOR

C. **Remove the Horizontal Stabilizer Tip**

SUBTASK 55-10-00-020-001

- (1) Remove the fasteners that attach the tip assembly [1] to the horizontal stabilizer.
- (a) Remove the bolts [3], bolts [4] and washers [5].

SUBTASK 55-10-00-010-001

- (2) Remove the tip assembly [1] from closure rib for the horizontal stabilizer.

SUBTASK 55-10-00-940-001

- (3) Put a cover on the closure ribs if the tip will be off for a long time.

————— **END OF TASK** —————

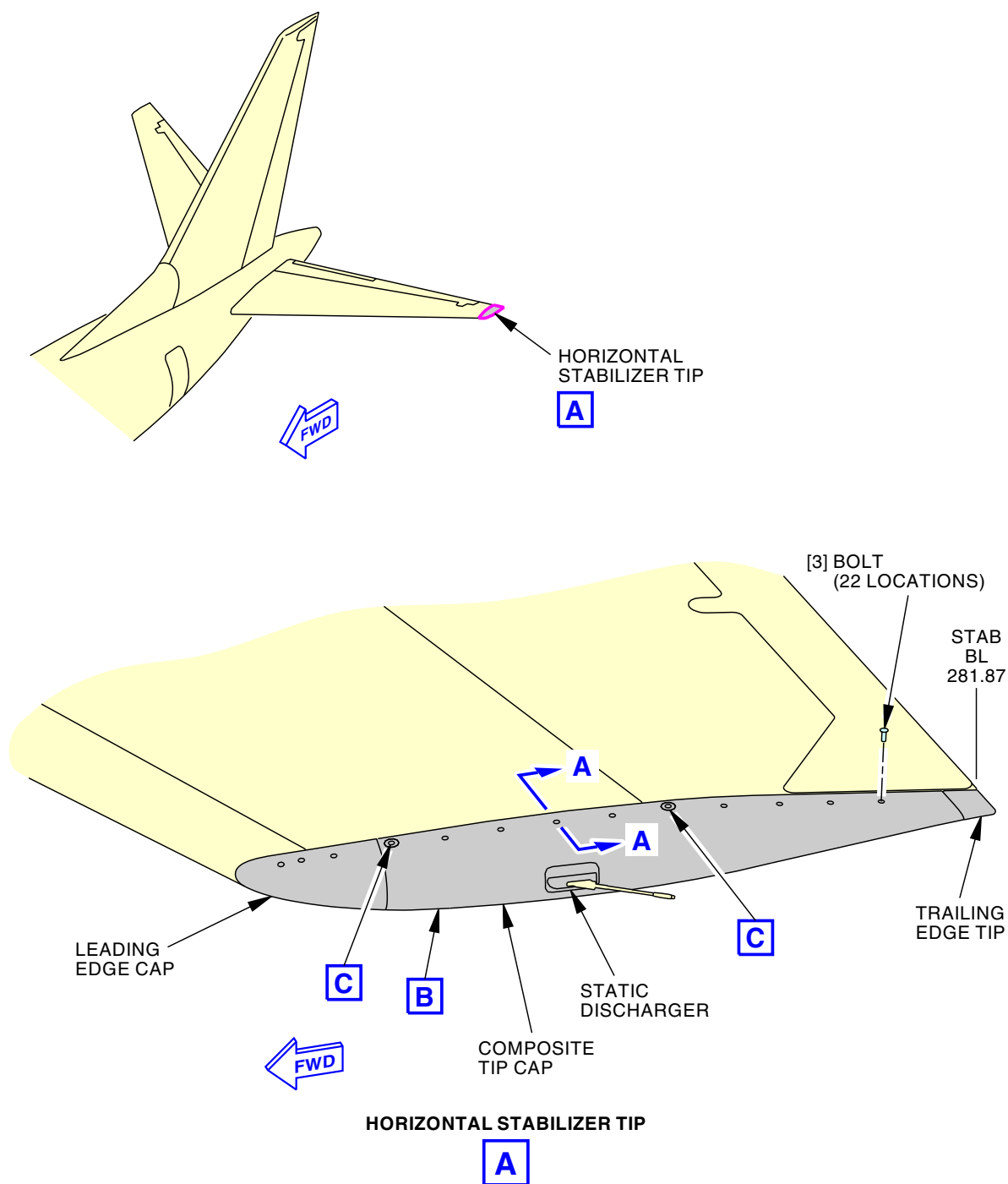
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55-10-00

Page 401
Sep 15/2021



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Horizontal Stabilizer Tip Installation
Figure 401/55-10-00-990-802 (Sheet 1 of 2)

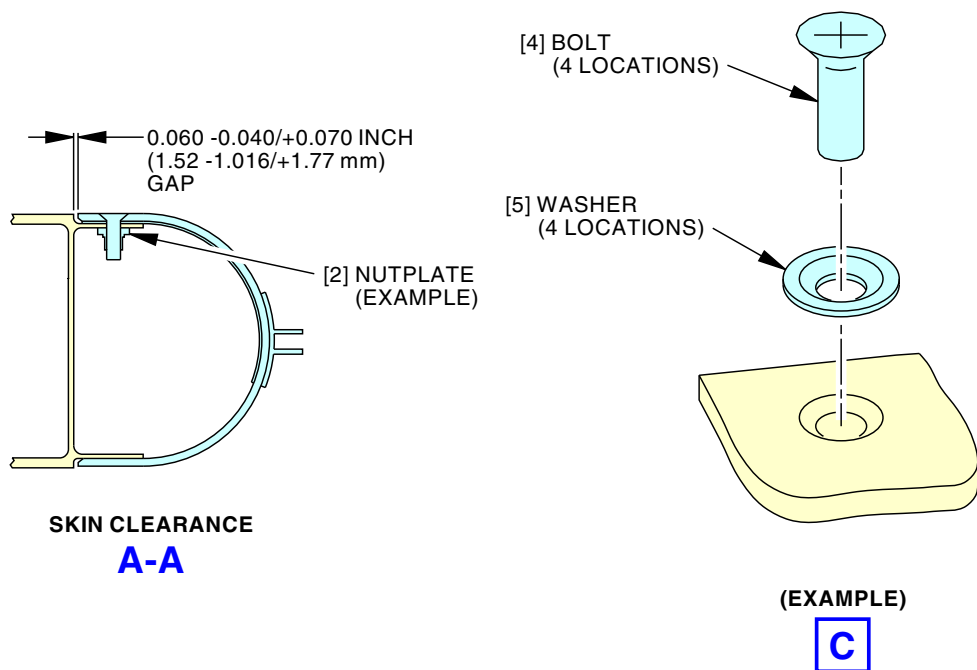
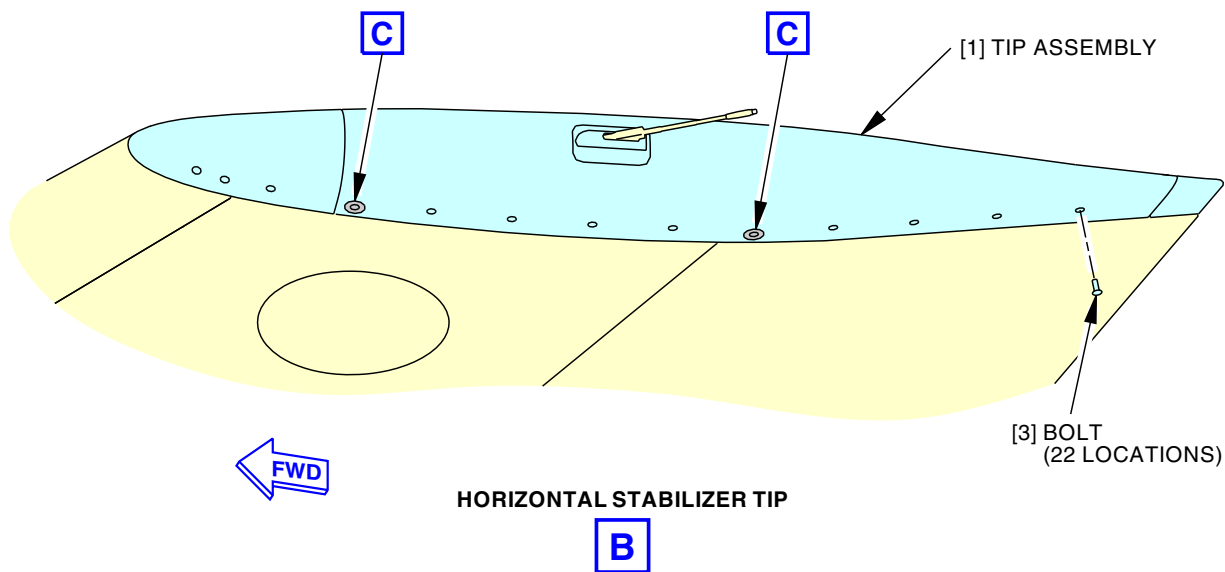
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-00

Page 402
Sep 15/2021



2927754 S0000707034_V1

Horizontal Stabilizer Tip Installation
Figure 401/55-10-00-990-802 (Sheet 2 of 2)

EFFECTIVITY
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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-00

Page 403
Sep 15/2021



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

TASK 55-10-00-400-801

3. Horizontal Stabilizer Tip - Installation

A. References

Reference	Title
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES

B. Tools/Equipment

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

Reference	Description
COM-1550	Bonding Meter - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III

D. Location Zones

Zone	Area
335	Left Horizontal Stabilizer - Tip
345	Right Horizontal Stabilizer - Tip

E. Prepare for the Installation

SUBTASK 55-10-00-840-001

- (1) Prepare the nutplates [2] as follows:
 - (a) Examine the nutplates [2] on the inner side of the tip assembly [1].
 - (b) Remove all damaged nutplates [2].
 - (c) Install new nutplates [2] in areas where there are no nutplates [2].
- (2) Remove the cover from the closure ribs for the horizontal stabilizer.

F. Horizontal Stabilizer Tip Installation

SUBTASK 55-10-00-420-002

- (1) Put the tip assembly [1] in the correct position on the horizontal stabilizer.

SUBTASK 55-10-00-400-001

- (2) Install the bolts [3], bolts [4] and washers [5] as follows:
 - (a) Apply compound, C00528, to all areas of the hole with any countersink and counter bore.
 - (b) Immediately Install the bolts [3], bolts [4] and washers [5] loosely.

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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-00

Page 404
May 15/2023



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

- (c) Tighten the bolts [3] and bolts [4] gradually, in a sequence which will not cause the skin to buckle.
- (d) Make sure that you have the correct clearance between the tip skin and the horizontal stabilizer (View A-A, Figure 401).
- (e) Do an electrical bonding test between the airplane structure and the bolts [4] and washers [5] with a, intrinsically safe approved bonding meter, COM-1550, (SWPM 20-20-00).
- (f) Make sure the resistance is less than 0.001 ohms.

SUBTASK 55-10-00-390-001

- (3) Fill the clearance between the tip and the horizontal stabilizer around periphery with sealant, A00247.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 55-10-00-860-003

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

F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	10	C00207	FLIGHT CONTROL STAB TRIM CONT
D	10	C00840	FLIGHT CONTROL STAB TRIM ACTUATOR

———— **END OF TASK** ————

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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-00

Page 405
Sep 15/2021



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

HORIZONTAL STABILIZER - MAINTENANCE PRACTICES

1. General

- A. This procedure contains the following tasks:
 - (1) Horizontal Stabilizer - Corrosion Prevention.
 - (2) Guidelines for missing fasteners in the leading edge access panels.
- B. Corrosion can occur on the horizontal stabilizer rear spar, and filiform corrosion can occur on the inspar skin.
- C. Corrosion can occur on the jackscrew support truss.
- D. Corrosion can occur at the faying surfaces of the inspar skin and inspar rib chords.
- E. Corrosion can occur on the rear spar attachment bolts which may result in chrome plating flaking.
- F. Corrosion can occur on the stabilizer and stabilizer center section clevises and lugs.
- G. Corrosion and plating deterioration can occur on hinge pins at the horizontal stabilizer center section.
- H. Corrosion can occur between the horizontal stabilizer skin panel and the forward flange of upper and lower trailing edge beams. The corroded areas, two to ten inches long, can occur at several locations along the beam between elevator stations 23 and 213. Corrosion is caused by water trapped in the unsealed seam.
- I. Corrosion can occur on the horizontal stabilizer pivot pins.
- J. Corrosion can occur on the horizontal stabilizer attachment lugs.
- K. Stress corrosion can cause broken lower attach bolt on the RH horizontal stabilizer. The attach bolts are made of a special alloy steel.
- L. Corrosion can occur in the stabilizer center section attach fittings. The deepest corrosion can occur on the gap between the two flanged bushings in the lug holes. Corrosion spots can also occur on the lug faces.
- M. Corrosion can occur on the surfaces of the horizontal stabilizer that touches the upper and lower trailing-edge skin and the trailing-edge beam. The corrosion is caused by moisture that can get into the joints between these parts.
- N. Corrosion can occur on the elevator balance panels and similar structure to the elevator front spar.
- O. Corrosion can occur between elevator nose skins and hinge fittings for elevator balance panels, and between hinge halves and adjacent faying structure.
- P. Moisture can collect between the trailing edge skin panel mating surfaces.

TASK 55-10-00-910-801

2. Horizontal Stabilizer - Corrosion Prevention

(Figure 201)

A. General

- (1) Do the regular inspection to prevent or find the start of corrosion. Missing fasteners, white powder, or other corrosion deposits are signs of corrosion. Do the corrosion prevention procedures to decrease the amount of corrosion.
- (2) Clean the suspected areas (PAGEBLOCK 51-21-31/701). Do a full inspection to make sure that the protective finishes applied during manufacture are not damaged.

EFFECTIVITY
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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-00

Page 201
Jan 15/2023



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

- (3) If corrosion is found (noticeable bulges of the skin or white deposits of corrosion products at fastener heads or joint edges), refer to the Structural Repair Manual for details to remove corrosion.
- (4) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by the application of a corrosion inhibiting compound to the affected area to decrease the corrosion process (PAGEBLOCK 51-21-91/701). Repair the finish at the next maintenance opportunity.
- (5) If there is hydraulic fluid contamination on the lugs or clevises, examine the components in the vertical fin for external leakage. This includes the main and standby rudder PCU, hydraulic hoses and tubing.

NOTE: An example of hydraulic fluid contamination is damaged or blistered paint.

- (6) Examine the trailing edge skin panels for delamination and moisture. Moisture accumulation can cause corrosion on the aluminum sub-structure and skin panel delamination. Accumulations of water can be detected radio-graphically.

B. References

Reference	Title
51-21-31 P/B 701	CORROSION REMOVAL AND CONTROL - CLEANING/PAINTING
51-21-91 P/B 701	CORROSION INHIBITING COMPOUND - CLEANING/PAINTING
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)

C. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. Location Zones

Zone	Area
330	Subzone - Left Horizontal Stabilizer and Elevator
340	Subzone - Right Horizontal Stabilizer and Elevator

E. Horizontal Stabilizer Corrosion Prevention

SUBTASK 55-10-00-370-001

- (1) At the next maintenance opportunity, apply corrosion prevention treatment to the horizontal stabilizer.

SUBTASK 55-10-00-200-001

- (2) Periodically examine the stabilizer for damaged finish and evidence of corrosion.
 - (a) On skin surfaces, apply water displacing corrosion inhibitor compound to rivet heads and panel edges where the paint has cracked or flaked.
 - (b) After 30 minutes, wipe off the excess compound with a clean, dry rag.

SUBTASK 55-10-00-200-002

- (3) Restore any damaged finish at the next maintenance opportunity.

SUBTASK 55-10-00-370-002

- (4) At one year intervals, apply water displacing corrosion inhibiting compound to the aft side of the rear spar cavity.

EFFECTIVITY
SIA ALL

55-10-00

D633AM101-SIA

Page 202
Jan 15/2023



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

- (a) Make sure that the compound is applied to attachment points and faying surfaces.

SUBTASK 55-10-00-370-003

- (5) At one year intervals, apply water displacing corrosion inhibiting compound to the fastener heads and skin joint on the upper and lower surfaces at the rear spar.
 - (a) After 30 minutes, wipe off the excess compound with a clean, dry rag.

SUBTASK 55-10-00-370-004

- (6) At one year intervals, apply water displacing corrosion inhibiting compound to the jackscrew support truss.
 - (a) Make sure that the compound is applied to attachment points.
 - (b) Do not apply the compound on the jackscrew.

SUBTASK 55-10-00-370-005

- (7) At two year intervals, remove the leading edge and spray water displacing corrosion inhibiting compound to the forward side of the rear spar with a proper extension tube.
 - (a) Make sure that the compound is applied to the upper and lower spar chords.
 - (b) Apply corrosion inhibitor at the intersection of skin and rib chords.

SUBTASK 55-10-00-370-006

- (8) At one year intervals, apply water displacing corrosion inhibiting compound to exposed areas of the elevator spar.
 - (a) Make sure that the compound is applied to attachment points.

SUBTASK 55-10-00-370-007

 CAUTION	DO NOT APPLY CORROSION-INHIBITING COMPOUND TO THE SEALS OF THE ELEVATOR BALANCE PANEL. DO NOT APPLY IT TO THE AREAS THAT THE SEALS WILL TOUCH. THE CORROSION-INHIBITING COMPOUND CAUSES DAMAGE, OR DETERIORATION OF THE SEALS.
---	---

- (9) At one year intervals, apply water displacing corrosion inhibiting compound to the elevator balance panels.

SUBTASK 55-10-00-370-008

- (10) Apply water displacing corrosion inhibiting compound to the horizontal stabilizer terminal fittings.

SUBTASK 55-10-00-370-009

- (11) Apply a fillet seal with sealant, A02315, around the trailing edge panels (TASK 51-22-00-390-809).

SUBTASK 55-10-00-200-003

- (12) Do inspections and apply compound as follows:
 - (a) Periodic inspection is required in areas identified as susceptible to corrosion and should be consistent to the schedules specified in the Maintenance Planning Document.
NOTE: Operators must be aware of reported problems and areas of occurrences.
 - (b) Periodic application of corrosion inhibiting compound, G00009, is necessary to areas identified and should be consistent to the schedule specified in the Maintenance Planning Document.

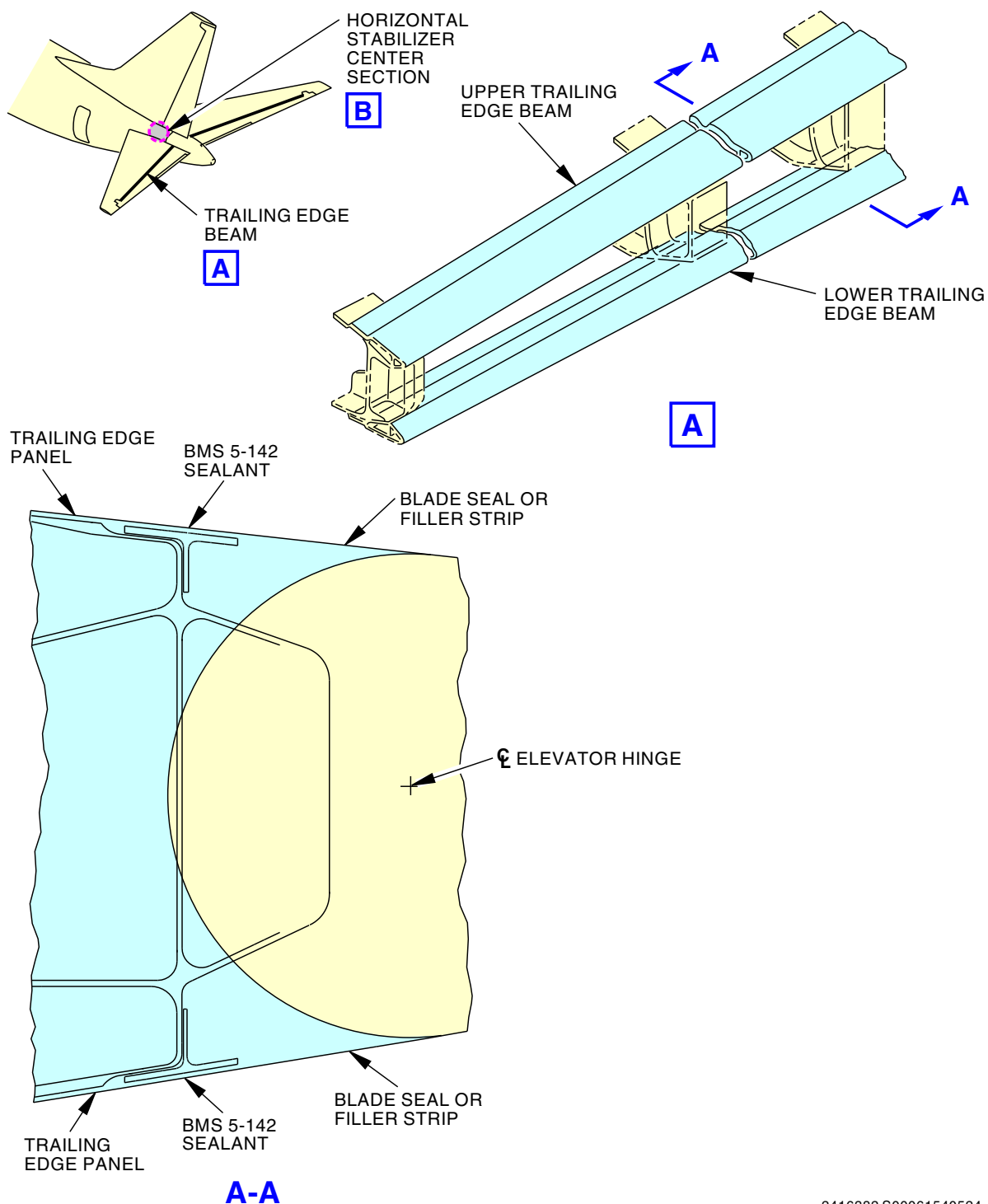
———— **END OF TASK** ————

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D633AM101-SIA

55-10-00

Page 203
Jan 15/2023



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Horizontal Stabilizer - Corrosion Prevention
Figure 201/55-10-00-990-801 (Sheet 1 of 2)

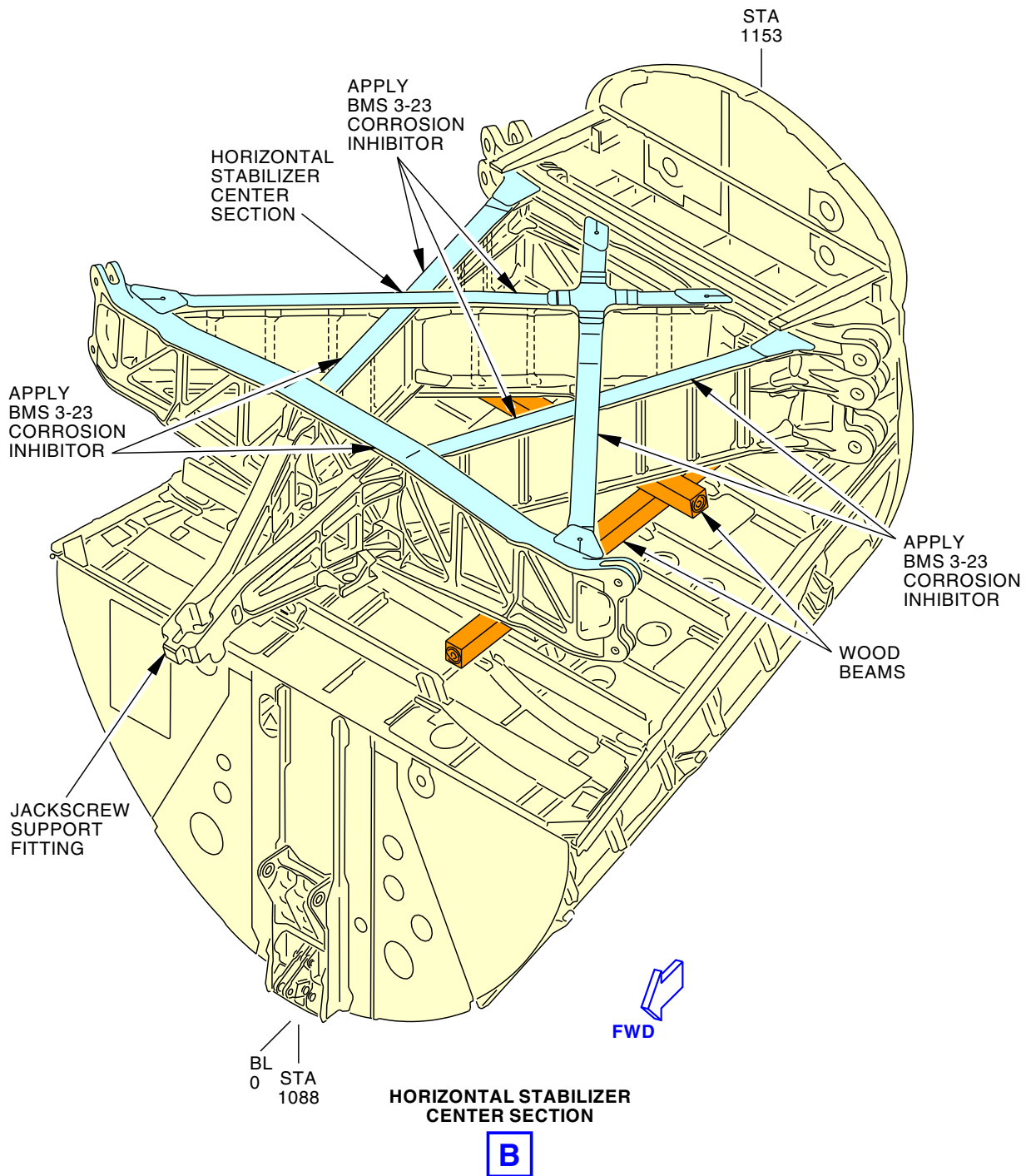
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-00

Page 204
Sep 15/2021



2416383 S00061540525_V3

Horizontal Stabilizer - Corrosion Prevention
Figure 201/55-10-00-990-801 (Sheet 2 of 2)

EFFECTIVITY
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55-10-00

D633AM101-SIA

Page 205
Jan 15/2023



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

TASK 55-10-00-200-801

3. Guidelines for Missing Fasteners in the Leading Edge Access Panels

A. General

- (1) This procedure gives the task guidelines for missing fasteners from the leading edge panels on the horizontal stabilizer.

B. References

Reference	Title
06-42-00-800-801	Finding an Access Door or Panel in the Empennage (P/B 201)
20-50-11-910-801	Standard Torque Values (P/B 201)

C. Location Zones

Zone	Area
331	Left Horizontal Stabilizer - Removable Leading Edge
341	Right Horizontal Stabilizer - Removable Leading Edge

D. Guidelines for Missing Fasteners in the Leading Edge Access Panels

SUBTASK 55-10-00-860-001

- (1) Find the applicable horizontal stabilizer leading edge panel (TASK 06-42-00-800-801).

SUBTASK 55-10-00-211-001

- (2) Make sure that the horizontal stabilizer leading edge access panel meet these guidelines:
- (a) One fastener can be missing from a panel if the panel has six to twelve fasteners to keep the panel on the airplane.
 - (b) Two fasteners can be missing from a panel if the panel has more than twelve fasteners to keep the panel on the airplane.
 - 1) The two missing fasteners must not be adjacent to each other.

SUBTASK 55-10-00-211-002

 WARNING	DO NOT LET OBJECTS GET IN THE HOUSING ASSEMBLY OF THE SLAT TRACK. THIS WILL HELP PREVENT A PUNCTURE OF THE HOUSING ASSEMBLY THAT COULD CAUSE A FUEL LEAK. THE FUEL LEAK COULD CAUSE A FIRE AND POSSIBLE DEATH OR INJURY TO PERSONNEL.
---	---

- (3) Make sure that the missing fasteners are not inside the leading edge housing.

SUBTASK 55-10-00-420-001

- (4) Install the fastener with the applicable torques (TASK 20-50-11-910-801).

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

55-10-00

D633AM101-SIA

Page 206
Jan 15/2023



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

HORIZONTAL STABILIZER CONDUCTIVE STRIP - REPAIRS

1. General

- A. This section contains one task for the horizontal stabilizer conductive strip:
(1) Horizontal Stabilizer Conductive Strip Repair

TASK 55-10-01-300-801

2. Horizontal Stabilizer Conductive Strip Repair

A. **References**

Reference	Title
SRM 55-10-01-2R-10	Horizontal Stabilizer Trailing Edge Panel Conductive Strip

B. **Repair the Conductive Strip**

SUBTASK 55-10-01-030-001

- (1) For the repair of the horizontal stabilizer conductive strip, do this task:
(SRM PROCEDURE 55-10-01-2R-10).

———— **END OF TASK** ————

EFFECTIVITY
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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-01

Page 801
Sep 15/2021



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

THRUST BRACE LINKS - REMOVAL/INSTALLATION

1. General

- A. This procedure has two tasks:
 - (1) A removal of the thrust brace links.
 - (2) An installation of the thrust brace links.
- B. The thrust brace links are located at the rear spar of the horizontal stabilizer center section.
- C. There are four thrust brace links (two on each side).

TASK 55-10-10-000-801

2. Thrust Brace Links Removal

(Figure 401, Figure 402, Figure 403)

A. **References**

Reference	Title
29-11-00-860-805	Hydraulic System A or B Power Removal (P/B 201)

B. **Tools/Equipment**

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

Reference	Description
SPL-1672	Assembly - Lock, Stabilizer Trim Part #: F71336-501 Supplier: 81205

C. **Location Zones**

Zone	Area
300	Empennage

D. **Access Panels**

Number	Name/Location
311BL	Stabilizer Trim Access Door

E. **Prepare for the Removal**

SUBTASK 55-10-10-860-001

- (1) Do this task: Hydraulic System A or B Power Removal, TASK 29-11-00-860-805.

SUBTASK 55-10-10-860-002

- (2) Set the stabilizer trim cutout switches to the CUTOFF position.

NOTE: The stabilizer trim cutout switches are installed on the control stand.

SUBTASK 55-10-10-860-004

- (3) Use the stabilizer trim wheel [12] on the control stand to set the horizontal stabilizer at zero degree (3 units of trim).

SUBTASK 55-10-10-480-001

- (4) Install the lock, SPL-1672 on the stabilizer trim wheel [12] at the control stand.
 - (a) Turn the stabilizer trim wheel [12] to put the handle at the top of the wheel.
 - (b) Adjust the height of the stabilizer trim lock [11] to put the stabilizer trim wheel [12] handle correctly on the yoke [9].
 - (c) Install the pin [10] through the yoke [9].

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55-10-10

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 401
Sep 15/2021



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

- (d) Install the safety pin [13].

SUBTASK 55-10-10-010-001

- (5) Open this access panel:

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

SUBTASK 55-10-10-480-002

- (6) Install applicable wood beams to hold the center section in a horizontal position (Figure 402).

F. Remove the Thrust Brace Links

SUBTASK 55-10-10-020-001

- (1) Disconnect the inboard side of the upper thrust brace link [2].
- (a) Remove the cotter pin [4] and nut [5].
 - (b) Remove the two washers [8], washer [3], and bolt [1].
 - (c) Discard the two washers [8].
 - (d) Disconnect the thrust brace link [2] from the center section fitting.

SUBTASK 55-10-10-020-002

- (2) Disconnect the inboard side of the lower thrust brace link [7].
- (a) Remove the cotter pin [4] and nut [5].
 - (b) Remove the two washers [8], washer [3], and bolt [6].
 - (c) Discard the two washers [8].
 - (d) Disconnect the thrust brace link [7] from the center section fitting.

SUBTASK 55-10-10-020-003

- (3) Disconnect the outboard side of the upper thrust brace link [2].
- (a) Remove the cotter pin [4] and nut [5].
 - (b) Remove the two washers [8], washer [3], and bolt [1].
 - (c) Discard the two washers [8].
 - (d) Remove thrust brace link [2] from the fitting.

SUBTASK 55-10-10-020-004

- (4) Disconnect the outboard side of the lower thrust brace link [7].
- (a) Remove the cotter pin [4] and nut [5].
 - (b) Remove the two washers [8], washer [3], and bolt [1].
 - (c) Discard the two washers [8].
 - (d) Remove the thrust brace link [7] from the fitting.

———— **END OF TASK** ————

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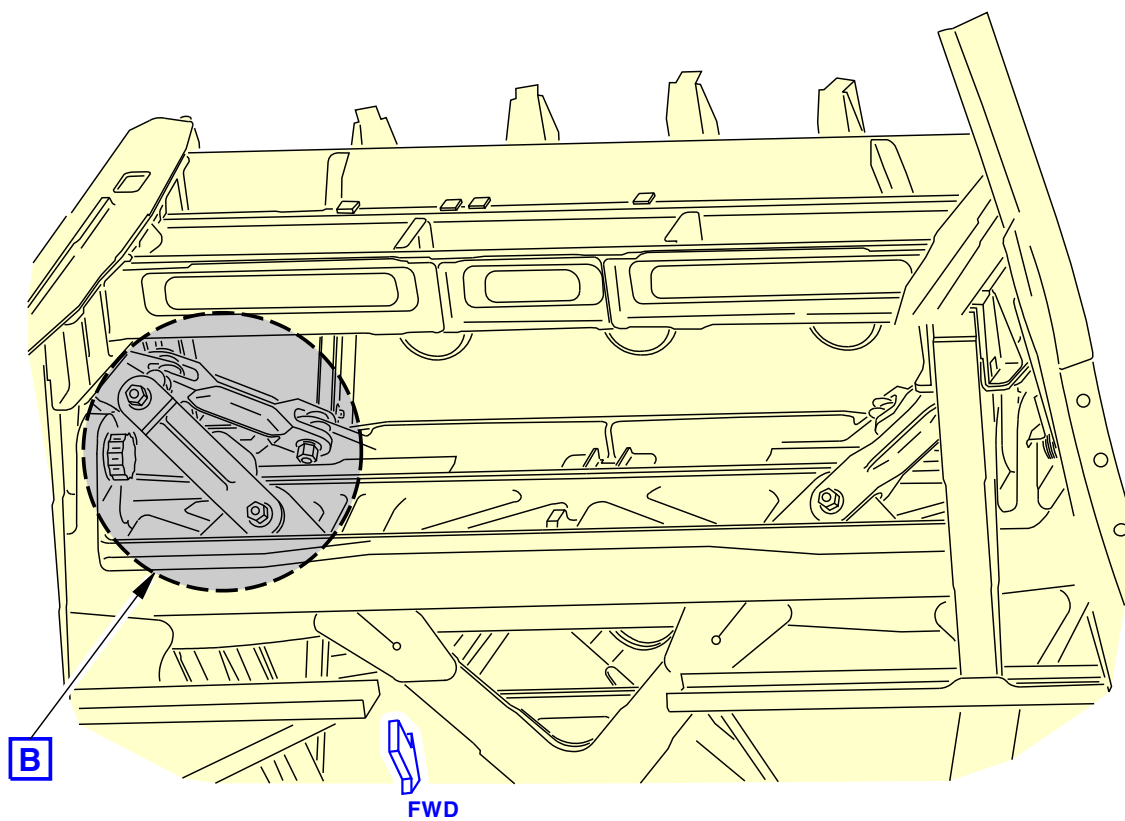
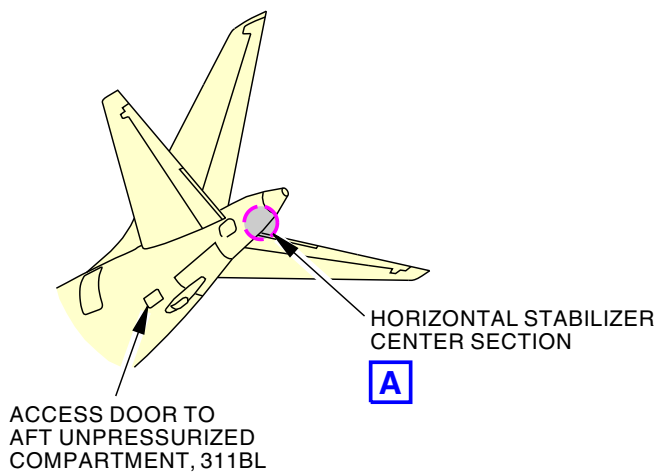
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55-10-10

Page 402
Sep 15/2021



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



HORIZONTAL STABILIZER CENTER SECTION

A

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Thrust Brace Links Installation
Figure 401/55-10-10-990-801 (Sheet 1 of 2)

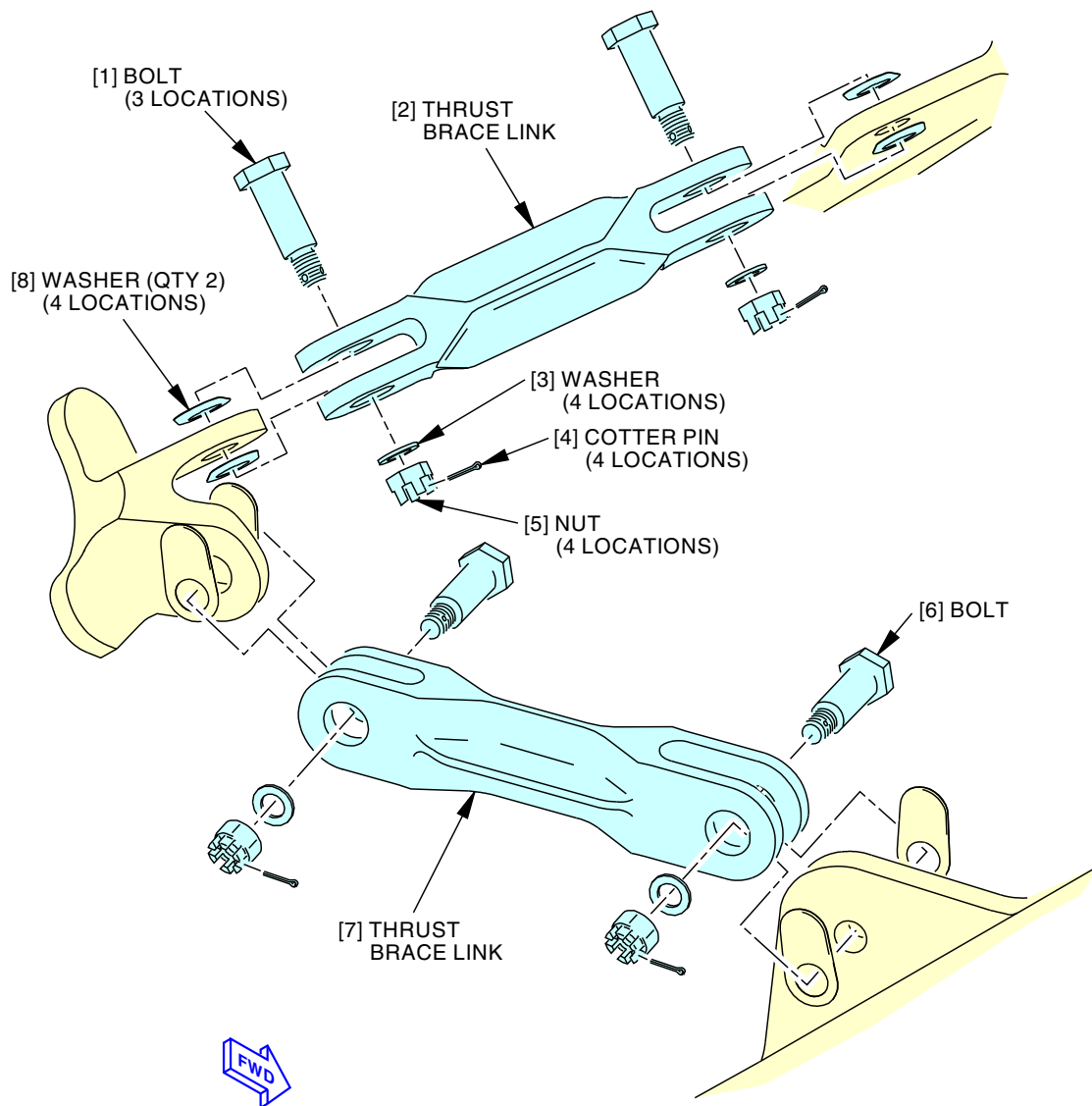
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-10

Page 403
Sep 15/2021



(LEFT SIDE IS SHOWN,
RIGHT SIDE IS OPPOSITE)

B

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Thrust Brace Links Installation
Figure 401/55-10-10-990-801 (Sheet 2 of 2)

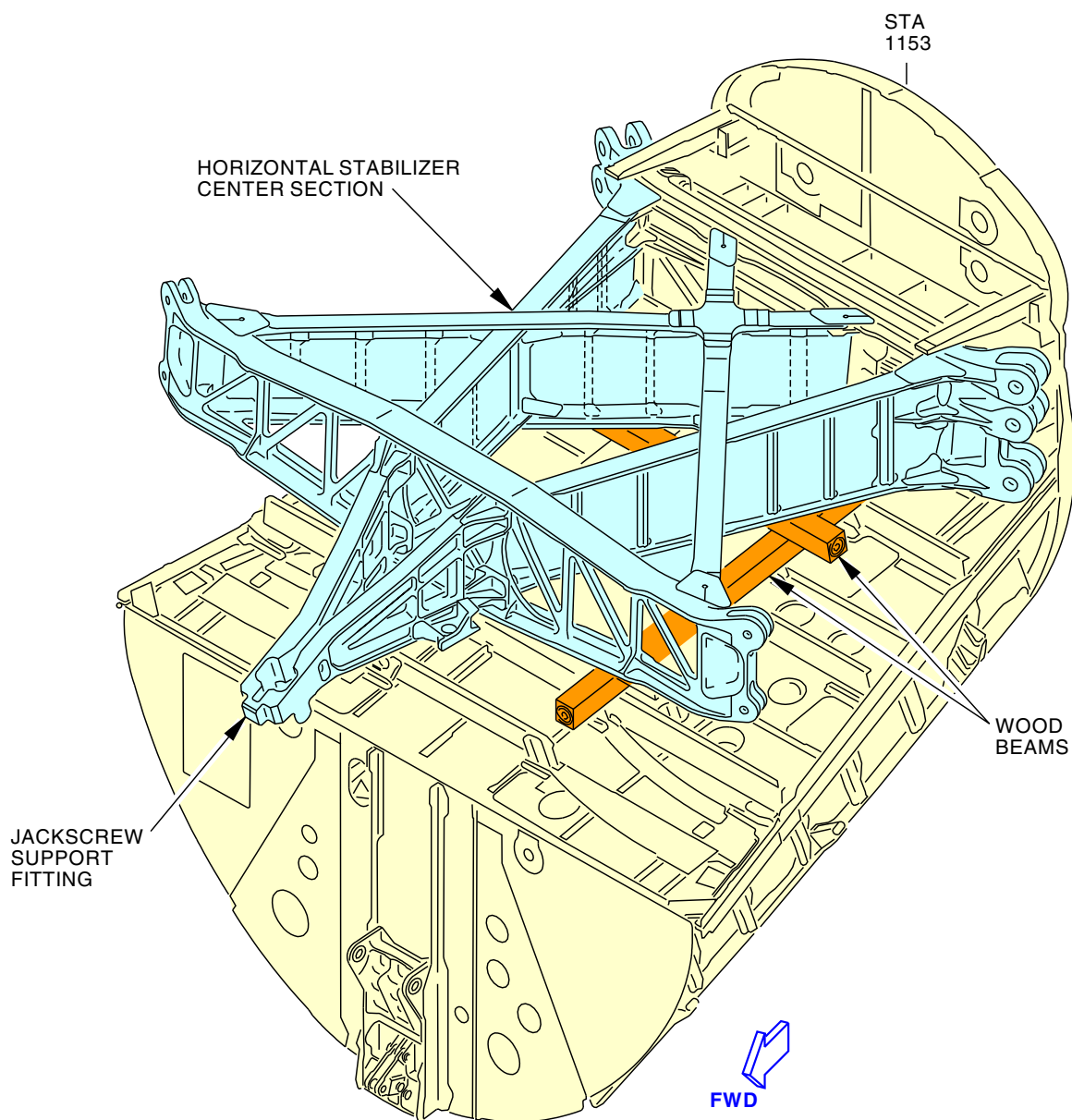
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-10

Page 404
Sep 15/2021



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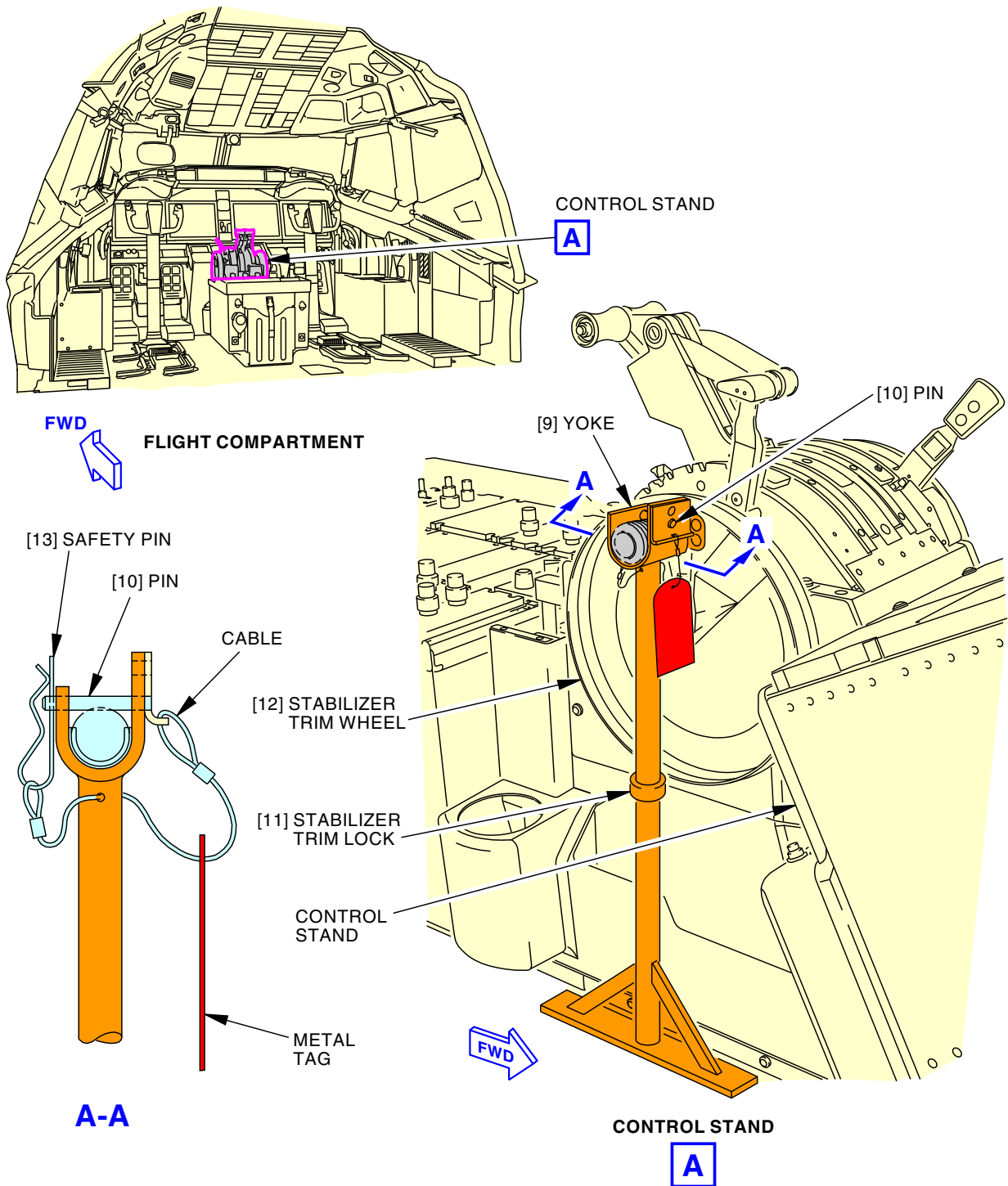
Horizontal Stabilizer Center Section Installation
Figure 402/55-10-10-990-802

EFFECTIVITY
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D633AM101-SIA

55-10-10

Page 405
Sep 15/2021



2416388 S00061540537_V1

Stabilizer Trim Lock Installation
Figure 403/55-10-10-990-803

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-10

Page 406
Sep 15/2021



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

TASK 55-10-10-400-801

3. **Thrust Brace Link Installation**

(Figure 401, Figure 402, Figure 403)

A. References

Reference	Title
29-11-00-860-801	Hydraulic System A or B Pressurization (P/B 201)

B. Tools/Equipment

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

Reference	Description
SPL-1672	Assembly - Lock, Stabilizer Trim Part #: F71336-501 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
2	Thrust brace link	55-10-52-01Q-085	SIA ALL
4	Cotter pin	55-10-52-01Q-045	SIA ALL
7	Thrust brace link	55-10-52-01Q-090	SIA ALL
8	Washer	55-10-52-01Q-065	SIA ALL

E. Location Zones

Zone	Area
300	Empennage

F. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door

G. Install the Thrust Brace Links

SUBTASK 55-10-10-420-001

(1) Connect the inboard side of the upper thrust brace link [2].

(a) Install the thrust brace link [2] to the center section fitting.

1) Apply grease, D00633 to the shank and thread of the bolt [1].

2) Install the two washers [8], bolt [1] and washer [3].

NOTE: The two washer [8] must be new.

3) Install the nut [5] and cotter pin [4].

a) Tighten the nut [5] to 440 in-lb (49.7 N·m) - 540 in-lb (61.0 N·m).

NOTE: If the cotter pin slot in the nut does not align with the cotter pin hole in the bolt within the specified torque range, tighten the nut to get cotter pin hole alignment, but do not exceed 650 in-lb (73.4 N·m).

SUBTASK 55-10-10-420-002

(2) Connect the inboard side of the lower thrust brace link [7].

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-10

Page 407
Sep 15/2021



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

- (a) Install the thrust brace link [7] to the center section fitting.
 - 1) Apply grease, D00633 to the shank and thread of the bolt [6].
 - 2) Install the two washers [8], the bolt [6] and the washer [3].
NOTE: The two washers [8] must be new.
 - 3) Install the nut [5] and cotter pin [4].
 - a) Tighten the nut [5] to 440 in-lb (49.7 N·m) - 540 in-lb (61.0 N·m).
NOTE: If the cotter pin slot in the nut does not align with the cotter pin hole in the bolt within the specified torque range, tighten the nut to get cotter pin hole alignment, but do not exceed 650 in-lb (73.4 N·m).

SUBTASK 55-10-10-420-003

- (3) Connect the outboard side of the upper thrust brace link [2].
 - (a) Install the thrust brace link [2] to the fitting.
 - 1) Apply grease, D00633 to the shank and thread of the bolt [1].
 - 2) Install the two washers [8], bolt [1], and washer [3].
NOTE: The two washers [8] must be new.
 - 3) Install the cotter pin [4] and nut [5].
 - a) Tighten the nut [5] to 440 in-lb (49.7 N·m) - 540 in-lb (61.0 N·m).
NOTE: If the cotter pin slot in the nut does not align with the cotter pin hole in the bolt within the specified torque range, tighten the nut to get cotter pin hole alignment, but do not exceed 650 in-lb (73.4 N·m).

SUBTASK 55-10-10-420-004

- (4) Connect the outboard side of the lower thrust brace link [7].
 - (a) Install the thrust brace link [7] to the fitting.
 - 1) Apply grease, D00633 to the shank and thread of bolt [1].
 - 2) Install the two washers [8], bolt [1], and washer [3].
NOTE: The two washers [8] must be new.
 - 3) Install the cotter pin [4] and nut [5].
 - a) Tighten the nut [5] to 440 in-lb (49.7 N·m) - 540 in-lb (61.0 N·m).
NOTE: If the cotter pin slot in the nut does not align with the cotter pin hole in the bolt within the specified torque range, tighten the nut to get cotter pin hole alignment, but do not exceed 650 in-lb (73.4 N·m).

SUBTASK 55-10-10-080-001

- (5) Remove the wood beams (Figure 402).

SUBTASK 55-10-10-080-002

- (6) Remove the lock, SPL-1672 from the stabilizer trim wheel [12] at the control stand.

SUBTASK 55-10-10-860-005

- (7) Set the stabilizer trim cutout switches to the NORMAL position.

SUBTASK 55-10-10-410-001

- (8) Close this access panel:

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

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-10

Page 408
Sep 15/2021



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

SUBTASK 55-10-10-860-007

(9) Do this task: Hydraulic System A or B Pressurization, TASK 29-11-00-860-801.

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-10

Page 409
Sep 15/2021



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

BALANCE BAY PANELS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Removal of the Balance Bay Panels.
 - (2) Installation of the Balance Bay Panels.

TASK 55-10-11-000-801

2. Balance Bay Panels - Removal

(Figure 401)

A. **References**

Reference	Title
51-22-00-160-801	Prepare For Sealing (P/B 201)

B. **Location Zones**

Zone	Area
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

C. **Access Panels**

Number	Name/Location
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
343BB	Horizontal Stabilizer, Access Panel - T.E. Area
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area

D. **Balance Bay Panels Removal**

SUBTASK 55-10-11-020-001

- (1) Remove sealant from the edge of the applicable panel.

NOTE: You can remove a section of the fillet seal (TASK 51-22-00-160-801).

SUBTASK 55-10-11-020-002

- (2) Do these steps to remove the applicable panels:
- (a) Hold the panel until all the fasteners have been removed.
 - (b) Left side panels:
 - 1) Remove the fasteners for these panels:

<u>Number</u>	<u>Name/Location</u>
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-11

Page 401
Sep 15/2021



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

(Continued)

<u>Number</u>	<u>Name/Location</u>
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge

(c) Right side panels:

1) Remove the fasteners for these panels:

<u>Number</u>	<u>Name/Location</u>
343BB	Horizontal Stabilizer, Access Panel - T.E. Area
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area

(d) Remove the panel from the airplane.

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

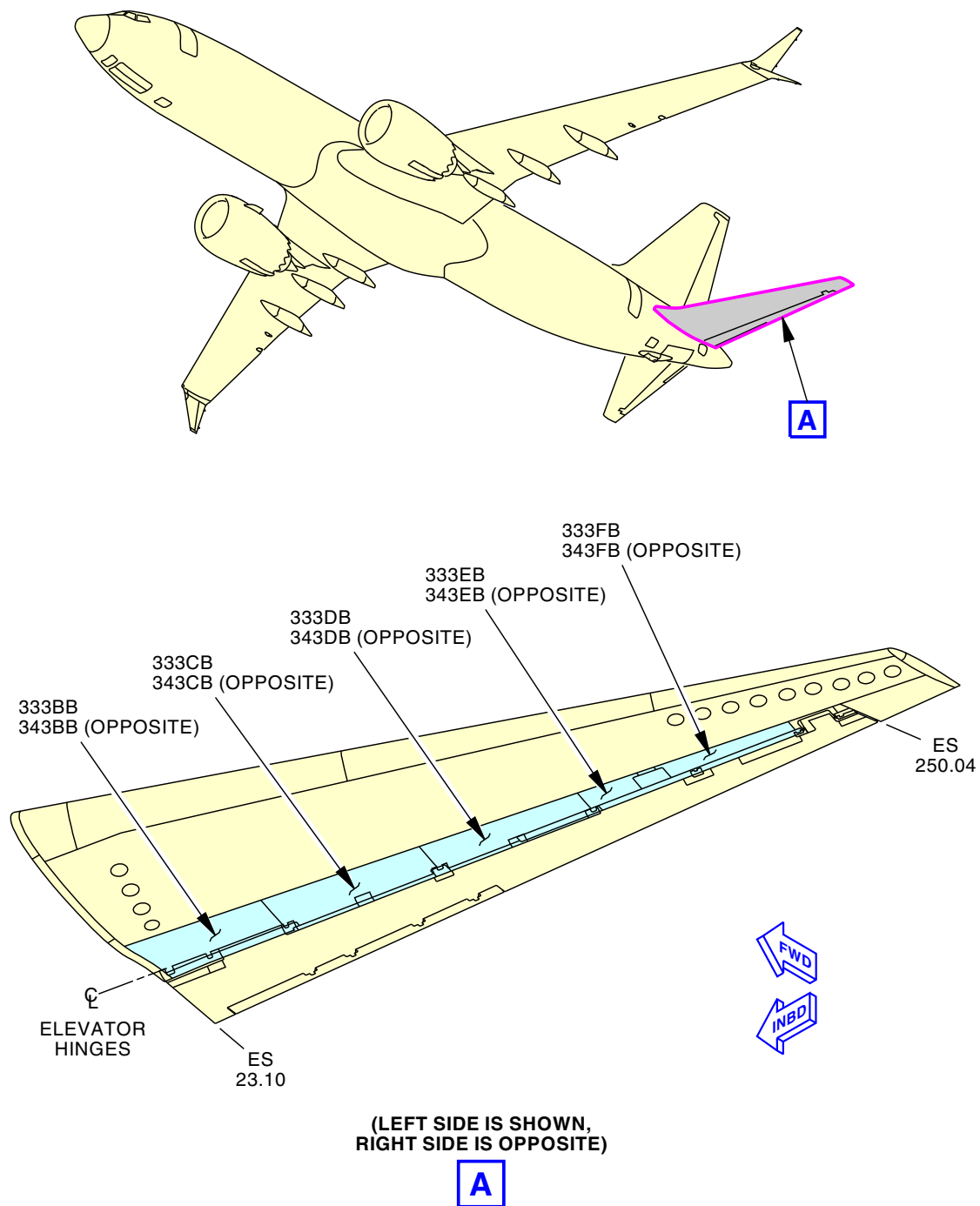
ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-11

Page 402
Sep 15/2021



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



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Balance Bay Panels - Installation
Figure 401/55-10-11-990-801

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-11

Page 403
Sep 15/2021



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

TASK 55-10-11-400-801

3. **Balance Bay Panels - Installation**

(Figure 401)

A. References

Reference	Title
51-22-00-390-802	Removable Faying (Mated) Surface Seal Application (P/B 201)
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
SRM 51-20-01-0G-0	Protective Treatment of Metallic and Composite Materials
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES

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
D00633	Grease - Aircraft General Purpose	BMS3-33
D50039	Lubricant - PTFE Release Agent - Miller-Stephenson MS-122RB (use until stock depleted)	
D50119	Lubricant - Fluorocarbon PTFE Release Agent - Miller-Stephenson MS-122DF	
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23
G02185	Agent - Peelable Parting (Valspar - 4A-183 Green Strippable Coating)Manufacturing discontinued, use stock until depleted	
G50313	Agent - Non-Peelable Parting (Henkel Loctite - Frekote 710-NC Mold Release)	BAC5000
G50335	Agent - Non-Peelable Parting (Henkel Loctite - Frekote 44-NC Mold Release).	BAC5000
G50365	Agent - Peelable Parting (AC Products - AC962-73C) Production discontinued, use stock until depleted.	BAC5000
G50366	Agent - Parting, Peelable, AZ 534-2B (0A3C8 - Aztec Chemical, Inc., El Monte, CA)	BAC5000, PSD 6-187
G50367	Agent - Peelable Parting (Aztec Chemical AZ 634-2)	MIL-PRF-6799, BAC5000
G50368	Agent - Peelable Parting (Rexco Chemical Company - Partall Coverall Film)	BAC5000
G50370	Tubing - Vinyl	AMS-I-7444
G50371	Reagent - Cyclohexanone	BAC5000
G50372	Pigment - Green, F-20629 Cobalt Chromite Blue-Green Spinel (11280 - Ferro Corporation)	BAC5000
G50636	Lubricant - PTFE Release Agent - Miller-Stephenson MS-122RA (use until stock depleted)	
G50711	Agent - Non-Peelable Parting (Henkel Loctite - Frekote 48-NC Mold Release).	BAC5000

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-10-11

Page 404
Jan 15/2022



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

(Continued)

Reference	Description	Specification
G50961	Coating - Corrosion Inhibiting Epoxy Primer - (BAC 377 Yellow Color)	BMS10-11 Type I
G51035	Release Agent - Miller-Stephenson MS-122AD	
G51368	Agent - Protective, Sprayable Strippable Coating - Spraylat SC-1071H-1 (Blue Color)	BAC5000
G51400	Lubricant - PTFE Release Agent - Miller-Stephenson MS-143N	
G51444	Release Agent - Miller-Stephenson MS-122SEL	BMS15-21

C. Location Zones

Zone	Area
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

D. Access Panels

Number	Name/Location
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
343BB	Horizontal Stabilizer, Access Panel - T.E. Area
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area

E. Balance Bay Panels Installation

SUBTASK 55-10-11-370-001

- (1) Apply corrosion inhibiting compound, G00009, as necessary before panels are installed (Protective Treatment of Metallic and Composite Materials/SRM PROCEDURE 51-20-01-0G-0).

SUBTASK 55-10-11-370-002

- (2) For the removable fasteners except at the grounding fastener locations, do these steps:
 - (a) Apply coating, G50961, to all areas of the hole.
 - (b) Apply grease, D00633, to the counter bore surface of the hole and fastener.

SUBTASK 55-10-11-410-001

- (3) Do these steps to install the panels:
 - (a) Check the panel for damage to the sealant.
 - 1) If no damage is present, then apply a parting agent to the panel and install it.
 - a) Use one of these parting agents:
 - <1> AC962-73C peelable parting agent, G50365.
 - <2> peelable parting agent, G50366.
 - <3> AZ 634-2 peelable parting agent, G50367.

EFFECTIVITY
SIA ALL

D633AM101-SIA

55-10-11

Page 405
Jan 15/2022



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

- <4> Coating solution - 1 weight part vinyl tubing, G50370, dissolved in 4 weight parts reagent, G50371, with 1 weight percent pigment, G50372.
 - <5> Frekote 44-NC non-peelable parting agent, G50335.
 - <6> Frekote 48 NC non-peelable parting agent, G50711.
 - <7> Frekote 710-NC non-peelable parting agent, G50313.
 - <8> Valspar 4A-183 green strippable coating, G02185.
 - <9> Miller-Stephenson MS-122AD release agent, G51035.
 - <10> MS-122DF lubricant, D50119.
 - <11> MS-143N release agent, G51400.
 - <12> MS-122RA release agent, G50636, or MS-122SEL release agent, G51444.
 - <13> MS-122RB lubricant, D50039, or MS-122SEL release agent, G51444.
 - <14> Rexco Partall Coverall Film peelable parting agent, G50368.
 - <15> Spraylat SC-1071H-1 agent, G51368.
- b) Do not apply parting agent to the edges of the panel.
- 2) If there is a damage to the sealant or sealant is omitted, do these steps:
 - a) Remove the sealant if there is a damaged sealant.
 - b) Install the panel and apply sealant, A00247 (TASK 51-22-00-390-802).
 - c) Make sure that each fastener is installed in the correct location.
 - d) Install all fasteners.
 - e) Do an electrical bonding check for each applicable fastener (SWPM 20-20-00).
 - 3) If there is no sealant, do the steps above to install the panel and apply sealant.
 - 4) As necessary, install these access panels:

<u>Number</u>	<u>Name/Location</u>
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
 - 5) As necessary, install these access panels:

<u>Number</u>	<u>Name/Location</u>
343BB	Horizontal Stabilizer, Access Panel - T.E. Area
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area
 - 6) Apply sealant, A02315, after installation as necessary (TASK 51-22-00-390-809).

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

55-10-11

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 406
Jan 15/2022



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

VERTICAL STABILIZER (FIN) - CORROSION PREVENTION

1. **General**

- A. Corrosion can occur on the vertical stabilizer skin, on the rear spar and at attach fittings.
- B. Corrosion can occur on the rudder front spar and the attach fittings.
- C. Moisture can collect between the trailing edge skin panel mating surfaces.
- D. Corrosion and broken attach bolts have been found in the vertical stabilizer attach fitting. The attach bolts are made from H-11 or PH13-8M0 steel alloy, which can get cracks caused by stress corrosion.

TASK 55-30-00-910-801

2. **Vertical Stabilizer (Fin) - Corrosion Prevention**

A. **References**

Reference	Title
51-21-31 P/B 701	CORROSION REMOVAL AND CONTROL - CLEANING/PAINTING
51-21-91 P/B 701	CORROSION INHIBITING COMPOUND - CLEANING/PAINTING

B. **Consumable Materials**

Reference	Description	Specification
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

C. **Location Zones**

Zone	Area
320	Subzone - Vertical Fin and Rudder

D. **Corrosion Prevention**

SUBTASK 55-30-00-200-001

- (1) Make the regular inspection to prevent or find the start of corrosion. Missing fasteners, white powdery, or other corrosion deposits are signs of corrosion. Initiate the corrosion prevention practices to decrease the occurrence of corrosion.

SUBTASK 55-30-00-200-002

- (2) Following cleaning of suspected areas PAGEBLOCK 51-21-31/701, a full inspection is effective to ensure that protective finishes provided during manufacture remain intact.

SUBTASK 55-30-00-910-001

- (3) Where corrosion exists (noticeable bulges of the skin or white deposits of corrosion products at fastener heads or joint edges), refer to Structural Repair Manual for details of corrosion removal.

SUBTASK 55-30-00-370-001

- (4) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by the application of a corrosion inhibiting compound into the affected area to decrease the corrosion process. Refer to PAGEBLOCK 51-21-91/701 for details on applying corrosion inhibiting compound. The finish system should be repaired at the next maintenance opportunity.

SUBTASK 55-30-00-370-002

- (5) Frequency of Application

EFFECTIVITY
SIA ALL

55-30-00

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 201
Sep 15/2021



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

- (a) Periodic inspection is required in areas identified as susceptible to corrosion and should be consistent to the schedules specified in the Maintenance Planning Document. Operators must be aware of reported problems and areas of occurrences.
- (b) Periodic application of corrosion inhibiting compound, G00009 is necessary to areas identified and should be consistent to the schedule specified in the Maintenance Planning Document.

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-30-00

Page 202
Sep 15/2021



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

VERTICAL STABILIZER (FIN) - REMOVAL/INSTALLATION

1. **General**

A. This procedure has these tasks:

- (1) A removal of the vertical stabilizer (fin)
- (2) An installation of the vertical stabilizer (fin).

TASK 55-30-00-000-801

2. **Vertical Stabilizer (Fin) Removal**

(Figure 401 and Figure 402)

A. **General**

- (1) This task gives the instructions to remove the vertical stabilizer (fin).

B. **References**

Reference	Title
06-42-00-800-801	Finding an Access Door or Panel in the Empennage (P/B 201)
27-21-00-800-802	Pressure from the Rudder Hydraulic Systems A, B, and Standby - Deactivation (P/B 201)
27-21-91-000-801	Main Rudder Power Control Unit Removal (P/B 401)
27-31-37-000-801	Elevator Feel Computer Removal (P/B 401)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

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-1727	Lock - Ground, Rudder, PCU Removed Part #: C27057-1 Supplier: 81205
SPL-2032	Sling Equipment - Vertical Fin Part #: C55010-33 Supplier: 81205 Opt Part #: C55010-1 Supplier: 81205

D. **Location Zones**

Zone	Area
300	Empennage

E. **Access Panels**

Number	Name/Location
311BL	Stabilizer Trim Access Door
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-30-00

Page 401
May 15/2023



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

F. Prepare for the Removal

SUBTASK 55-30-00-860-002



RELEASE THE PRESSURE IN THE RUDDER HYDRAULIC SYSTEM. THE RUDDER CAN MOVE IF YOU PRESSURIZE THE SYSTEM. IF THE RUDDER MOVES, THE RUDDER CAN CAUSE INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.

- (1) Do this task: Pressure from the Rudder Hydraulic Systems A, B, and Standby - Deactivation, TASK 27-21-00-800-802.

SUBTASK 55-30-00-410-001

- (2) Open these access panels:

(Finding an Access Door or Panel in the Empennage, TASK 06-42-00-800-801)

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

SUBTASK 55-30-00-480-001

- (3) Do this task: Main Rudder Power Control Unit Removal, TASK 27-21-91-000-801.

SUBTASK 55-30-00-410-005

- (4) Install the lock, SPL-1727, with a warning streamer.

G. Vertical Stabilizer (Fin) Removal



DO NOT REMOVE OR INSTALL THE VERTICAL FIN IN WINDS MORE THAN 15 KNOTS. IF YOU DO NOT OBEY, INJURY TO PERSONNEL AND DAMAGE TO THE AIRPLANE CAN OCCUR.

SUBTASK 55-30-00-020-001

- (1) Disconnect the hydraulic tubes from the bottom of the vertical fin [29] and install caps.

SUBTASK 55-30-00-020-002

- (2) Disconnect the electrical wires.

- (a) Disconnect the VOR and HF cables in the stabilizer jackscrew compartment, above and aft of the pressure bulkhead.

SUBTASK 55-30-00-030-001

- (3) Disconnect the pitot lines from the elevator feel computer assembly.

- (a) Install the tags on the lines and port fittings to clearly show the correct connection location.

- 1) Use these instructions on correct tubing removal (TASK 27-31-37-000-801).

SUBTASK 55-30-00-020-003

- (4) Disconnect the rudder control cables from the power unit for the rudder control.

SUBTASK 55-30-00-020-004

- (5) Disconnect the rudder control cables.

- (a) Move the rudder trim indicator in the control cabin to NEUTRAL.

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-30-00

Page 402
Sep 15/2023



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

- (b) Install the rig pin in the rudder centering unit output crank.
- (c) Disconnect the rudder control cables from the turnbuckles in the stabilizer jackscrew compartment.
 - 1) Install the cable clamps on the control cables.

SUBTASK 55-30-00-480-002

- (6) Install the sling equipment, SPL-2032, assembly:
 - (a) Install the three sling attach fittings to the applicable sides of the vertical fin [29] (Figure 401).

NOTE: Determine on which side you will put down the vertical fin [29]. This will show which side of the vertical fin [29] to install the sling attach fittings.

NOTE: No access doors need to be opened to install the attach fittings.

 - 1) Remove the bolts on the vertical fin [29] skin at the three applicable lift fitting locations.
 - 2) Install the lift fittings with the accompanying bolts.
 - a) Add the washers to lift fitting bolts, if bolts are too long.
 - b) Tighten the fasteners to 25 in-lb (2.8 N·m).
 - (b) Attach the sling equipment, SPL-2032, assembly to the crane.
 - (c) At lift fitting #1, connect 50 ft (15 m) length of $\frac{3}{8}$ in. (9.5 mm) to $\frac{1}{2}$ in. (12.7 mm) braided nylon rope on both sides of the vertical fin [29].

NOTE: This rope will be a tether line.
 - (d) Put the sling equipment, SPL-2032, assembly in its position.
 - (e) Connect the sling equipment, SPL-2032, to the lift fittings on the vertical fin [29].
 - (f) Tighten the sling equipment, SPL-2032, assembly to decrease the load on the vertical fin [29] attachment bolts.

SUBTASK 55-30-00-020-005

- (7) Remove the vertical fin [29] (Figure 402).
 - (a) Remove the bolts and fasteners of the rear spar fittings on the left and right hand side of the airplane:
 - 1) Remove the bolt [11], washer [12], retainer cap [13], lockwire [14], and antirotation lock [15] from the inboard rear spar fitting.

NOTE: If you remove the bolts for inspection, remove one bolt at a time to keep the vertical fin [29] aligned.
 - 2) Remove the cotter pin [22], self-locking nut [21], bolt [16], washer [20], washer [17], and two washers [18] from the inboard rear spar fitting.

NOTE: There may be one more washer [20] for grip length adjustment.
 - 3) Remove the self-locking nut [27], bolt [23], washer [24], washers [25], washer [26], washer [19], and washers [28] from the outboard rear spar fitting.

NOTE: There may be one more washer [26] for grip length adjustment.

 - a) If you remove the bolts for inspection, remove one bolt at a time to keep the vertical fin [29] aligned.
 - (b) Remove the bolts and the fasteners of the front spar fitting:
 - 1) Remove the cotter pins [5], nuts [4], washers [2], washers [3], washers [6], and bolts [1] from the front spar attach fittings.

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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-30-00

Page 403
Sep 15/2023



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

- a) If you remove the bolts for inspection, remove one bolt at a time to keep the vertical fin [29] aligned.
- (c) Lift the vertical fin [29] from the airplane.
 - 1) Make sure that there are no side loads on the sling lift fittings.
- (d) Lower the crane hook #1 to lay the vertical fin [29] down in a horizontal position.
 - 1) Use the tether lines to position the vertical fin [29] horizontally.

SUBTASK 55-30-00-950-001

- (8) Install the protective cover on the open structure on the fuselage.

SUBTASK 55-30-00-210-001

- (9) To examine the leading edge of the vertical fin [29] for aerodynamic smoothness (SRM SUBJECT 51-10-01).

———— **END OF TASK** ————

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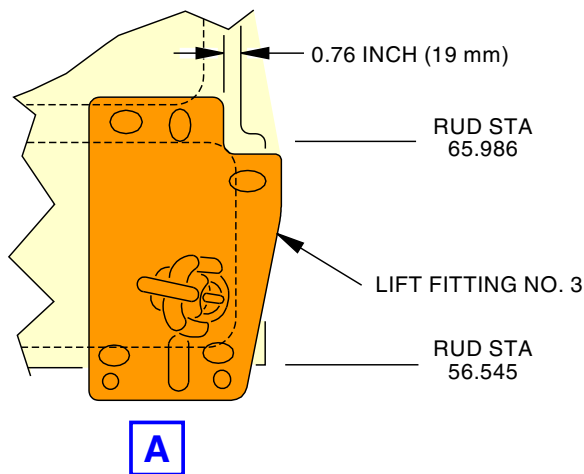
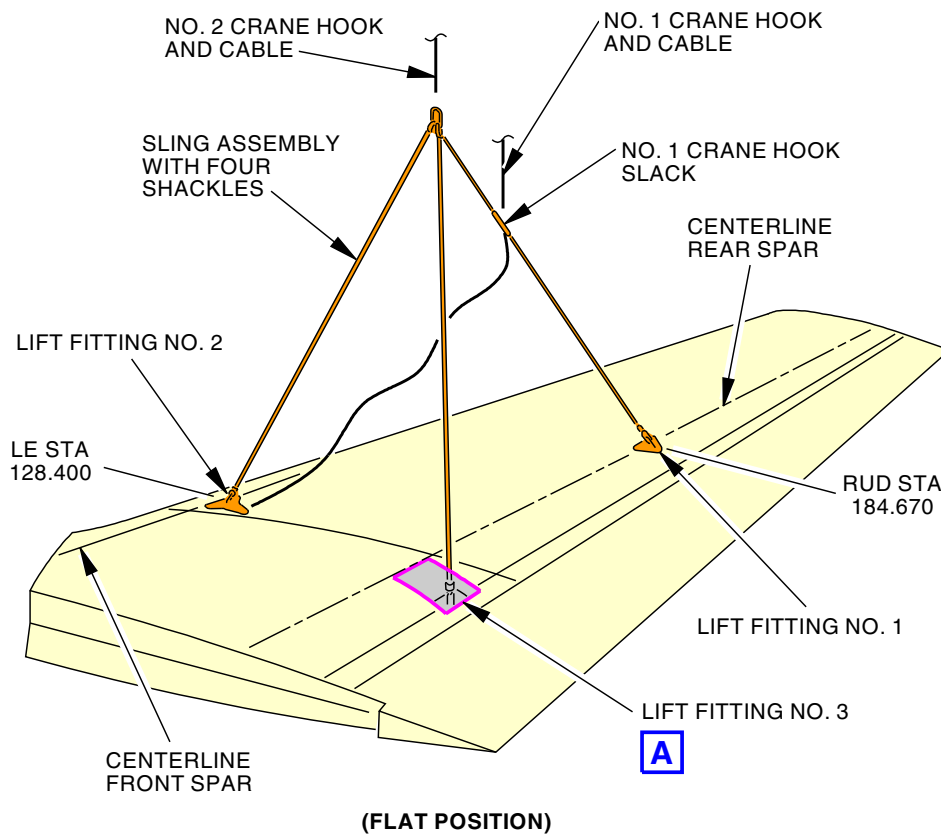
ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-30-00

Page 404
Sep 15/2023



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



2416390 S00061540550_V3

Vertical Fin Sling Installation
Figure 401/55-30-00-990-801 (Sheet 1 of 2)

EFFECTIVITY
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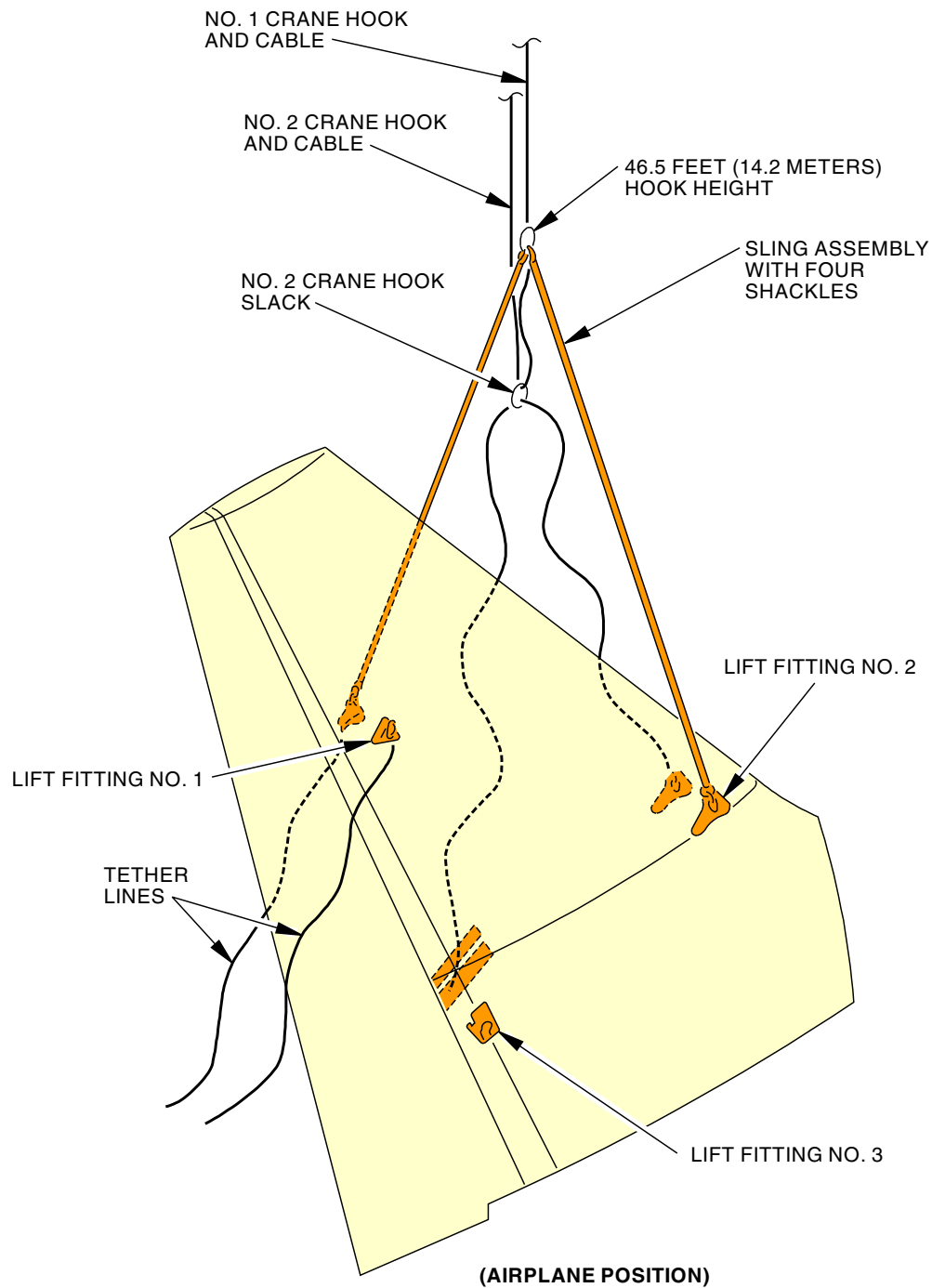
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-30-00

Page 405
Sep 15/2021

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



2416391 S00061540551_V1

Vertical Fin Sling Installation
Figure 401/55-30-00-990-801 (Sheet 2 of 2)

EFFECTIVITY
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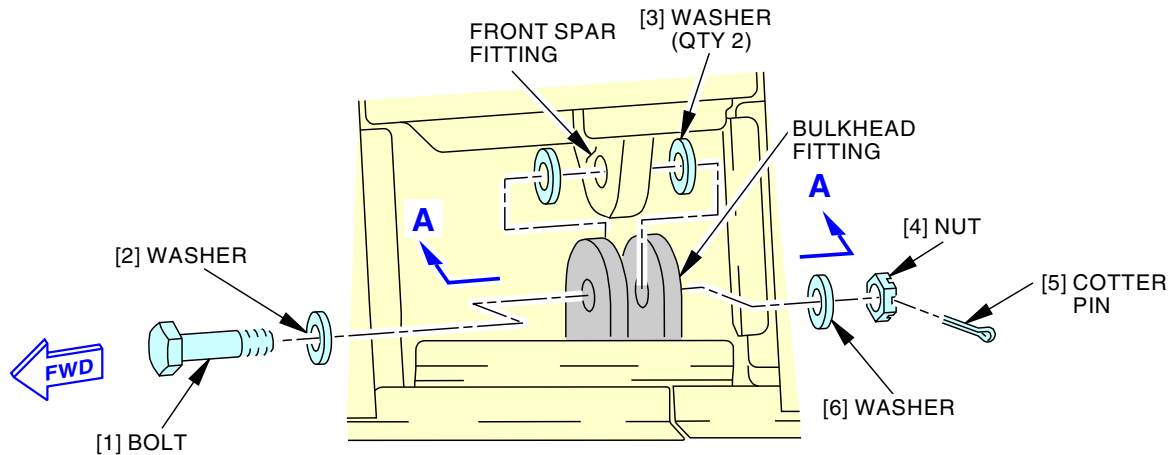
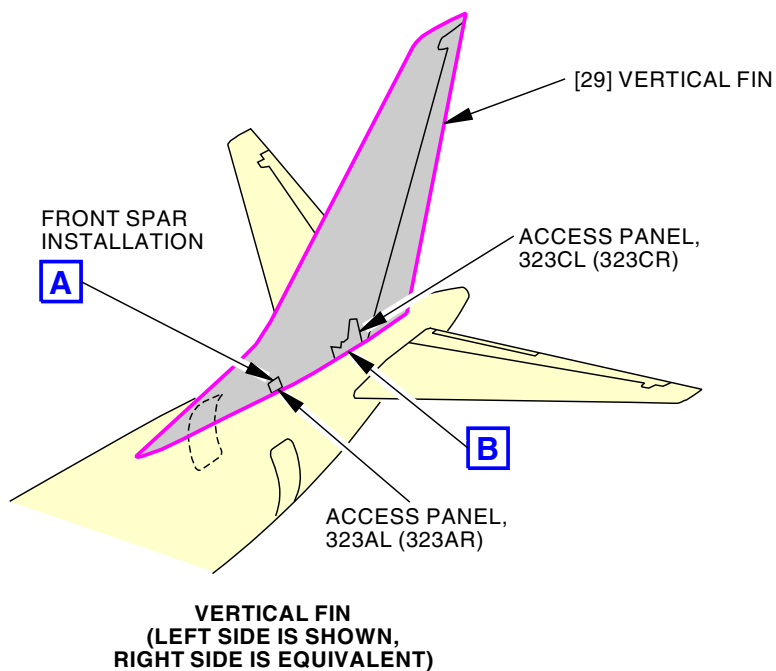
ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-30-00

Page 406
Sep 15/2021



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



FRONT SPAR INSTALLATION
(ACCESS PANEL IS REMOVED)

[A]

2416392 S00061540552_V2

Vertical Stabilizer (Fin) Installation
Figure 402/55-30-00-990-802 (Sheet 1 of 4)

EFFECTIVITY
SIA ALL

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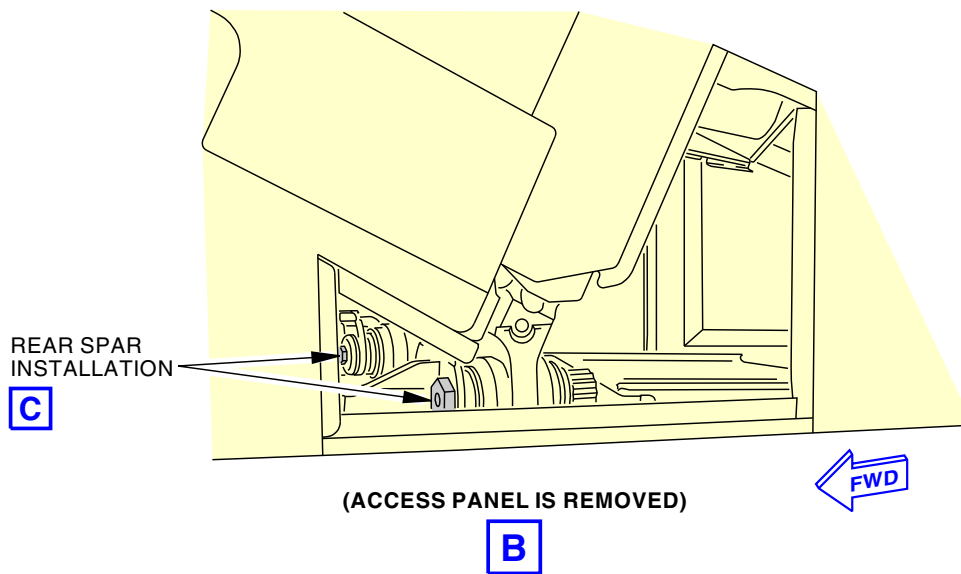
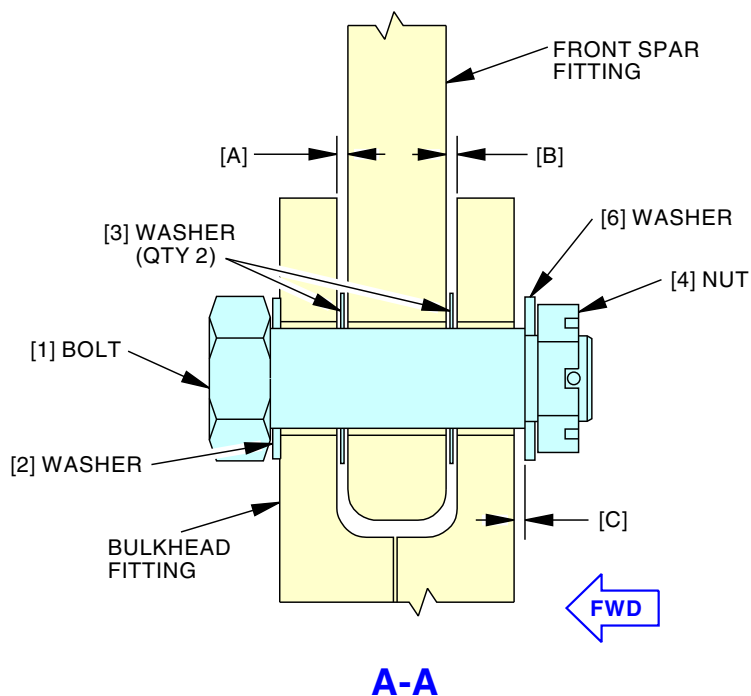
ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-30-00

Page 407
Sep 15/2021



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



2416393 S00061540553_V3

Vertical Stabilizer (Fin) Installation
Figure 402/55-30-00-990-802 (Sheet 2 of 4)

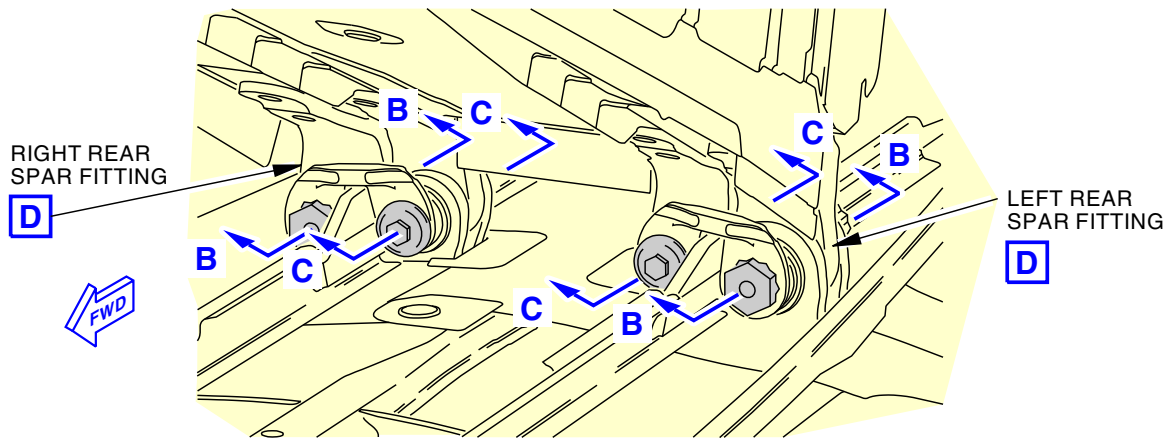
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

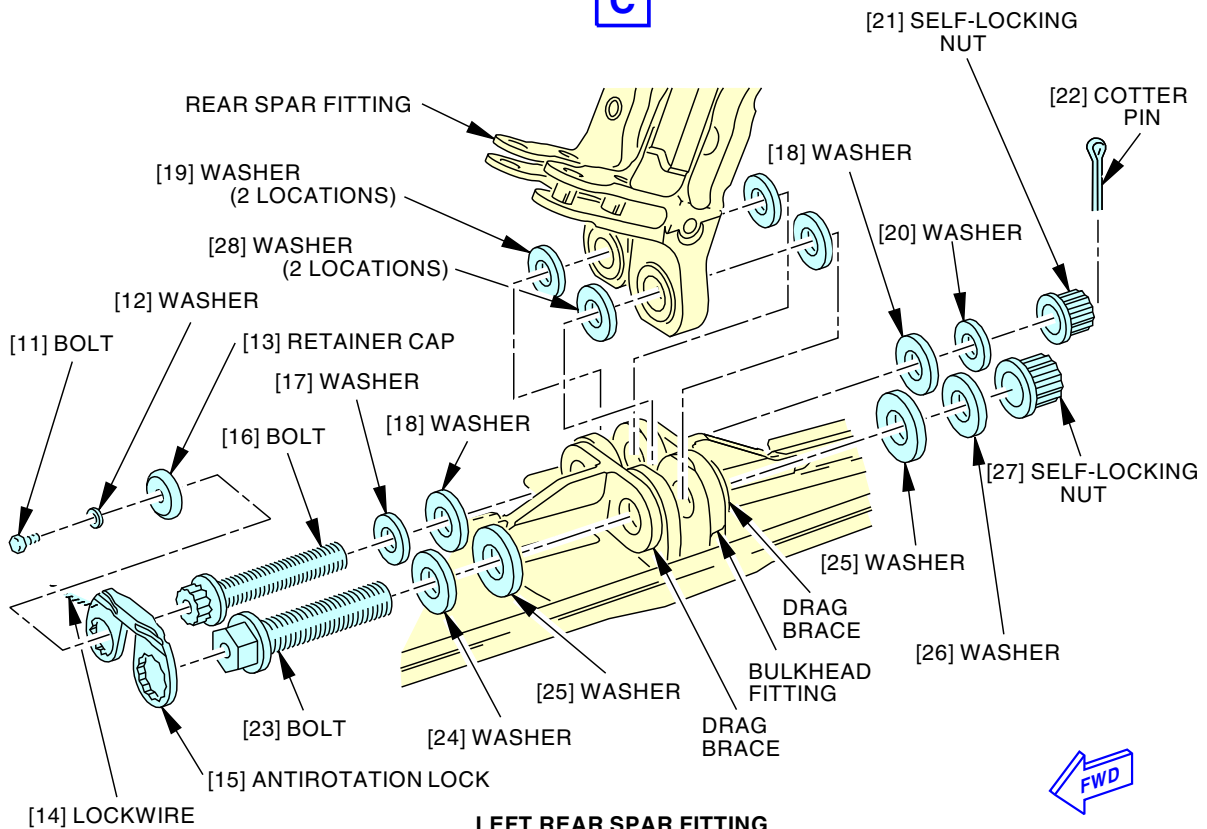
55-30-00

Page 408
May 15/2022



REAR SPAR INSTALLATION

[C]



LEFT REAR SPAR FITTING
(RIGHT REAR SPAR FITTING IS OPPOSITE)

[D]

2416394 S00061540554_V1

Vertical Stabilizer (Fin) Installation
Figure 402/55-30-00-990-802 (Sheet 3 of 4)

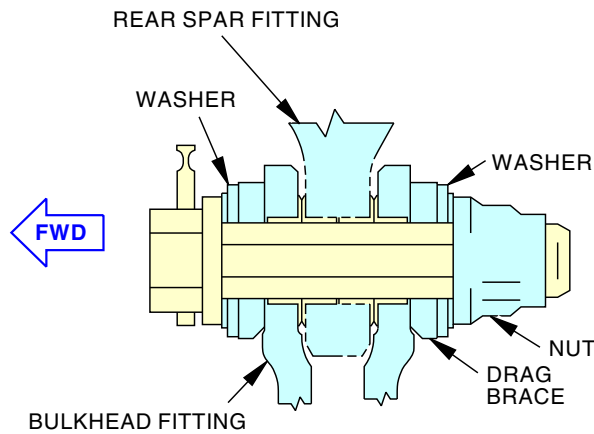
EFFECTIVITY
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55-30-00

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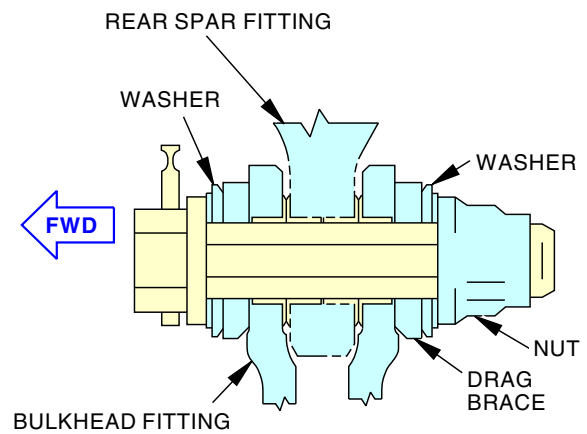
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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



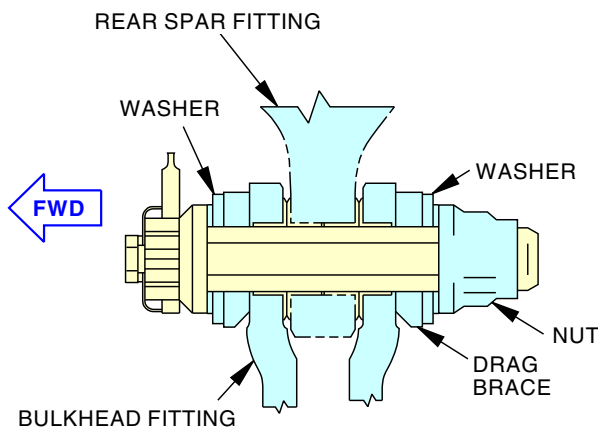
OUTBOARD REAR SPAR FITTING

B-B 1



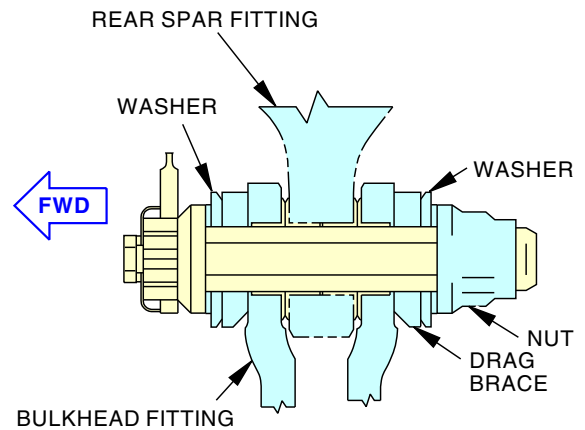
OUTBOARD REAR SPAR FITTING

B-B 3



INBOARD REAR SPAR FITTING

C-C 2



INBOARD REAR SPAR FITTING

C-C 4

- 1** FOR P/N 170A1614-1 D-SHAPED WASHERS
- 2** FOR P/N 170A1614-2 D-SHAPED WASHERS
- 3** FOR P/N 170A1614-9 CIRCULAR WASHERS
- 4** FOR P/N 170A1614-8 CIRCULAR WASHERS

NOTE:

IF THE P/N 170A1614-1/-2 WASHERS ARE USED, CAUTION MUST BE TAKEN TO ENSURE THE WASHER IS POSITIONED PROPERLY WITH THE FLAT SIDE OF THE WASHER FACING THE RADIUS OF THE DRAG BRACE FITTINGS AND THAT WASHERS DO NOT ROTATE WHEN APPLYING TORQUE.

2416395 S00061540555_V1

Vertical Stabilizer (Fin) Installation
Figure 402/55-30-00-990-802 (Sheet 4 of 4)

EFFECTIVITY
SIA ALL

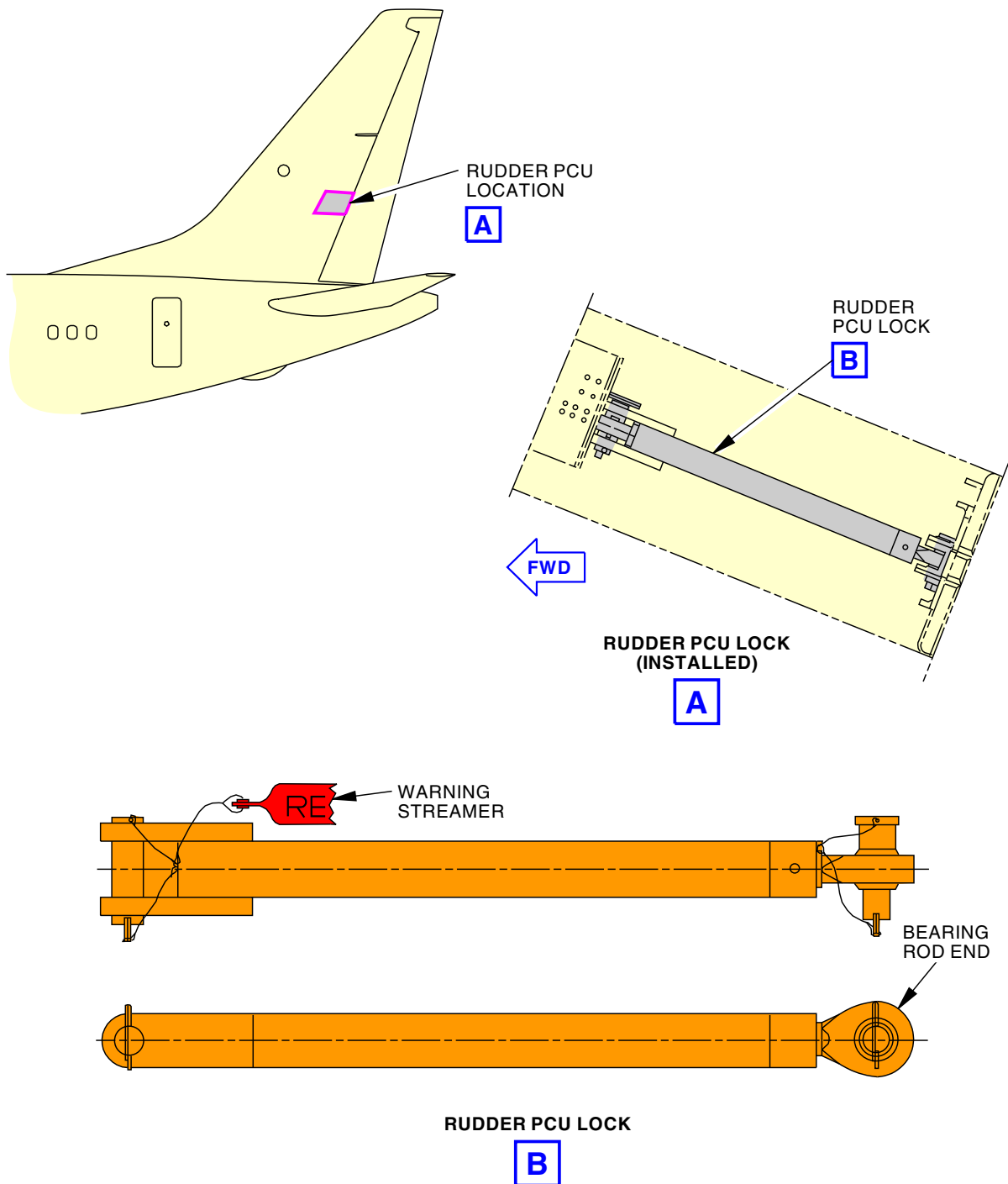
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-30-00

Page 410
Sep 15/2021

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



2416396 S00061540556_V2

LOCK-RUDDER PCU
Figure 403/55-30-00-990-803

EFFECTIVITY
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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-30-00

Page 411
Sep 15/2021



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

TASK 55-30-00-400-801

3. **Vertical Stabilizer (Fin) - Installation**

(Figure 401, Figure 402, and Figure 403)

A. General

(1) This task gives the instructions to install the vertical stabilizer (fin).

B. References

Reference	Title
06-42-00-800-801	Finding an Access Door or Panel in the Empennage (P/B 201)
27-21-00-800-801	Rudder Hydraulic System A, B, or Standby Pressurization (P/B 201)
27-21-00-800-802	Pressure from the Rudder Hydraulic Systems A, B, and Standby - Deactivation (P/B 201)
27-21-00-820-803	Rudder Control Cables RA and RB Adjustment (P/B 501)
27-21-91-400-801	Main Rudder Power Control Unit Installation (P/B 401)
27-31-37-400-801	Elevator Feel Computer Installation (P/B 401)
34-51-00-730-801	VOR System - System Test (P/B 501)
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

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-1727	Lock - Ground, Rudder, PCU Removed Part #: C27057-1 Supplier: 81205
SPL-2031	Equipment - Alignment Pins and Guide, Vertical Fin Installation Part #: C55009-1 Supplier: 81205
SPL-2032	Sling Equipment - Vertical Fin Part #: C55010-33 Supplier: 81205 Opt Part #: C55010-1 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
D00633	Grease - Aircraft General Purpose	BMS3-33
D50004	Compound - Antiseize	BMS3-28

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
29	Vertical fin	55-30-00-01-010	SIA ALL

EFFECTIVITY
SIA ALL

55-30-00

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 412
May 15/2023



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

F. Location Zones

Zone	Area
300	Empennage

G. Access Panels

Number	Name/Location
311BL	Stabilizer Trim Access Door
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

H. Prepare for the Installation

SUBTASK 55-30-00-860-003



RELEASE THE PRESSURE IN THE RUDDER HYDRAULIC SYSTEM. THE RUDDER CAN MOVE IF YOU PRESSURIZE THE SYSTEM. IF THE RUDDER MOVES, THE RUDDER CAN CAUSE INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.

- (1) Do this task: Pressure from the Rudder Hydraulic Systems A, B, and Standby - Deactivation, TASK 27-21-00-800-802.

SUBTASK 55-30-00-010-001

- (2) Open these access panels:

(Figure 402)

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

SUBTASK 55-30-00-160-001

- (3) Clean the bolts and bolt holes that attach the vertical fin [29] with solvent, B00083.

SUBTASK 55-30-00-480-003

- (4) Make sure that the lock, SPL-1727, with the warning streamer is installed.

SUBTASK 55-30-00-020-006

- (5) Remove the three lower screws on the panel forward of the rudder.

NOTE: This will make installation easier without interference with the structure.

- (a) Pull the lower panel away from the vertical fin [29].

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-30-00

Page 413
Sep 15/2023



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

I. Vertical Stabilizer (Fin) Installation



DO NOT REMOVE OR INSTALL THE VERTICAL FIN IN WINDS MORE THAN 15 KNOTS. IF YOU DO NOT OBEY, INJURY TO PERSONNEL AND DAMAGE TO THE AIRPLANE CAN OCCUR.

SUBTASK 55-30-00-420-001

NOTE: Do an inspection of the area in the vicinity of the vertical stabilizer identification plate for any stenciled note or placard which restricts the vertical stabilizer to an individual airplane due to a matched set approval.

(1) Install the vertical fin [29] (Figure 401).

- (a) Lift the vertical fin [29] into its position with the sling equipment, SPL-2032.

NOTE: Use the tether lines to control the position of the vertical fin while moving it.

- 1) Turn the vertical fin [29] from a horizontal position to a vertical position by lifting the crane hook #1.
- (b) Use the alignment pin equipment, SPL-2031, to align the holes in the attachment fittings.
- (c) Install the fasteners that attach the left and right sides of the vertical fin [29] to the rear spar.
 - 1) Apply anti-seize compound, D50004, to the threads of the bolt [16], bolt [23], self-locking nut [21], and self-locking nut [27].
 - 2) Apply grease, D00633, on the shank of the bolt [16] and bolt [23].
 - 3) Loosely install the bolt [16], bolt [23], washer [17], washer [18], washer [19], washer [24], washer [25], and washer [28].

NOTE: There may be one more washer [20] or washer [26] for grip length adjustment.

- (d) Apply a layer of grease, D00633, on the shank of the bolts [1] that attach the vertical fin [29] at the front spar.
- (e) Apply anti-seize compound, D50004, to the bolt threads and nut threads.
- (f) Loosely install the two bolts [1], washers [2], and washers [3] that attach the vertical fin [29] to the fuselage at the front spar fittings.
- (g) Measure the clearance between the rear spar fitting and drag brace:
 - 1) If the clearance on one of the sides of the rear spar fitting is more than 0.007 in. (0.178 mm), do these steps:
 - a) Select the necessary washer [19] or washer [28] to make sure that the clearance is equal to or less than 0.007 in. (0.178 mm).

NOTE: Only one non-laminated washer is permitted on each side of the rear spar fitting.
 - b) Remove one bolt [16] or bolt [23] at a time to install the washers [19] or washers [28].
 - c) Apply anti-seize compound, D50004 to the washers [19] or washers [28].
 - 2) Apply sealant, A00247, between the washers [18] and drag brace.
 - 3) Apply sealant, A00247, between the washers [25] and drag brace.

SUBTASK 55-30-00-420-002

(2) Tighten the fasteners that attach the vertical fin [29].

EFFECTIVITY
SIA ALL

D633AM101-SIA

55-30-00

Page 414
Sep 15/2023



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

- (a) Install the washer [18], washer [19], washer [20], washer [25], washer [26], self-locking nut [21], and self-locking nut [27].
NOTE: There may be one more washer [20] or washer [26] for grip length adjustment.
- (b) Install the antirotation lock [15] on the heads of the bolt [16] and bolt [23].
- (c) Tighten the nuts on the rear spar fasteners:
 - 1) On the inboard fitting, tighten the self-locking nut [21] to 6500 in-lb (734.4 N·m) - 7500 in-lb (847.4 N·m).
 - 2) On the outboard fitting, tighten the self-locking nut [27] to 7500 in-lb (847.4 N·m) - 8500 in-lb (960.4 N·m).
- (d) Install the cotter pin [22] in the bolt [16] attach fitting.
- (e) Install the two washers [6] and nuts [4] that attach the vertical fin [29] to the fuselage at the front spar fittings.
 - 1) Tighten the nuts [4] to 50 in-lb (5.6 N·m) - 1500 in-lb (169.5 N·m).
 - a) Make sure that the gaps are as shown on Table 401.

Table 401/55-30-00-993-801 Vertical Stabilizer (Fin) Installation Clearances

EDGE ZONE	SECTION	CLEARANCE
[A]	A-A	0.050 in. (1.27 mm) minimum
[B]	A-A	0.050 in. (1.27 mm) minimum
SIA 016-999		
[B]	A-A	0.034 in. (0.86 mm) minimum (Right Side) 0.050 in. (1.27 mm) minimum (Left Side)
SIA ALL		
[C]	A-A	0.015 in. (0.38 mm) minimum

NOTE: Align the nut with the cotter pin in the bolt.

- 2) Install the cotter pins [5].

SUBTASK 55-30-00-420-003

- (3) Install the retainer cap [13], washer [12], and bolt [11] that attach the antirotation lock [15] to the bolt [16]:
 - (a) Apply compound, D50004, to the threads of the bolt [11] and threads in the head of bolt [16].
 - (b) Tighten the bolt [11] to 660 in-lb (75 N·m) - 980 in-lb (111 N·m).
 - (c) Install the lockwire between the bolt [11] and antirotation lock [15].

SUBTASK 55-30-00-420-004

- (4) Install the three screws on the lower panel forward of the rudder.

SUBTASK 55-30-00-080-001

- (5) Remove the sling and lift fittings.

SUBTASK 55-30-00-420-005

- (6) Attach the rudder flight control cables.

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-30-00

Page 415
Sep 15/2023



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

- (a) Connect the rudder control cables at the turnbuckles in the stabilizer jackscrew compartment.
- (b) Remove the rig pin from the centering unit output crank.

SUBTASK 55-30-00-410-002

- (7) Connect the electrical cables.

- (a) Connect the VHF Omnidirectional Range (VOR) cables, when it is necessary, in the jackscrew compartment above and aft of the pressure bulkhead.

SUBTASK 55-30-00-420-006

- (8) Connect the pitot lines to the elevator feel computer assembly (TASK 27-31-37-400-801).

SUBTASK 55-30-00-420-007

- (9) Connect the rudder control cables at the rudder control power unit.

SUBTASK 55-30-00-420-008

- (10) Connect the hydraulic lines.

SUBTASK 55-30-00-080-002

- (11) Do this task: Main Rudder Power Control Unit Installation, TASK 27-21-91-400-801 (Figure 403).

SUBTASK 55-30-00-080-003

- (12) Remove the lock, SPL-1727, and warning streamer.

SUBTASK 55-30-00-860-004

- (13) Examine the rudder hydraulic system for leaks.
 - (a) Do this task: Rudder Hydraulic System A, B, or Standby Pressurization, TASK 27-21-00-800-801.

SUBTASK 55-30-00-860-005

- (14) Do this task: Pressure from the Rudder Hydraulic Systems A, B, and Standby - Deactivation, TASK 27-21-00-800-802.

SUBTASK 55-30-00-820-001

- (15) Do this task: Rudder Control Cables RA and RB Adjustment, TASK 27-21-00-820-803.

SUBTASK 55-30-00-730-001

- (16) Do this task: VOR System - System Test, TASK 34-51-00-730-801.

J. Put the Airplane Back to Its Usual Condition

SUBTASK 55-30-00-410-003

- (1) Close these access panels:

(Finding an Access Door or Panel in the Empennage, TASK 06-42-00-800-801)

<u>Number</u>	<u>Name/Location</u>
311BL	Stabilizer Trim Access Door
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-30-00

Page 416
Sep 15/2023



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

SUBTASK 55-30-00-390-002

- (2) Apply an aerodynamic smoother sealant, A02315, to all non-bonded structural components contacting exterior skins.

NOTE: Sealant does not need to be applied to gaps between panels that are used for regular access as long as they are less than limits given in the Structural Repair Manual (SRM SUBJECT 51-10-01).

- (a) Do this task: Aerodynamic Smoother Application, TASK 51-22-00-390-809.

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-30-00

Page 417
Sep 15/2023



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

VERTICAL STABILIZER (FIN) - INSPECTION/CHECK

1. General

A. There is one task in this procedure:

- (1) Inspection and Check of the Vertical Stabilizer (Fin).

TASK 55-30-00-200-801

2. Vertical Stabilizer (Fin) Inspection

(Figure 601)

A. References

Reference	Title
55-30-00-000-801	Vertical Stabilizer (Fin) Removal (P/B 401)
55-30-00-400-801	Vertical Stabilizer (Fin) - Installation (P/B 401)

B. Location Zones

Zone	Area
300	Empennage

C. Procedure

SUBTASK 55-30-00-010-002

- (1) Do this task: Vertical Stabilizer (Fin) Removal, TASK 55-30-00-000-801.

NOTE: If you do an inspection on the airplane, remove one bolt at a time. The fin will then stay in its position.

SUBTASK 55-30-00-220-001

- (2) Examine the bolts and the bushings which attach the fin to the fuselage for worn areas.
 - (a) Measure the diameters of the bolts and the bushings.
 - (b) Compare the measured dimensions with the permitted dimensions shown in the table below.

Wear Limits

INDEX NO.	PART NAME	DIM.	DESIGN LIMITS		WEAR LIMITS		REPLACE WORN PART	REPAIR WORN PART
			DIAMETER		PERMITTED WEAR DIMENSION INCHES / (mm)	MAXIMUM DIAMETER CLEARANCE INCHES / (mm)		
			MINIMUM INCHES / (mm)	MAXIMUM INCHES / (mm)				
1	BUSHING (FRONT SPAR)	ID	0.8780 (22.301)	0.8790 (22.327)	0.8835 (22.441)	0.0100 (0.254)	X	
	BOLT (FRONT SPAR)	OD	0.8730 (22.174)	0.8740 (22.200)	0.8685 (22.060)		X	X
2 *[1]	BUSHING (REAR SPAR)	ID	1.7530 (44.526)	1.7540 (44.552)	1.7600 (44.704)	0.0100 (0.254)	X	
	BOLT (REAR SPAR)	OD	1.7480 (44.399)	1.7490 (44.425)	1.7420 (44.247)		X	X

EFFECTIVITY
SIA ALL

55-30-00

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 601
Sep 15/2021



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

Wear Limits (Continued)

INDEX NO.	PART NAME	DIM.	DESIGN LIMITS		WEAR LIMITS		REPLACE WORN PART	REPAIR WORN PART
			DIAMETER		PERMITTED WEAR DIMENSION INCHES / (mm)	MAXIMUM DIAMETER CLEARANCE INCHES / (mm)		
			MINIMUM INCHES / (mm)	MAXIMUM INCHES / (mm)				
3 *[2]	BUSHING (REAR SPAR)	ID	1.5030 (38.176)	1.5040 (38.202)	1.5095 (38.341)	0.0100 (0.254)	X	
	BOLT (REAR SPAR)	OD	1.4980 (38.049)	1.4990 (38.075)	1.4925 (37.910)		X	X

*[1] THIS BUSHING/BOLT SET IS IN THE OUTBOARD REAR SPAR FITTINGS.

*[2] THIS BUSHING/BOLT SET IS IN THE INBOARD REAR SPAR FITTINGS.

(c) Repair or replace the parts which are not in the tolerance.

SUBTASK 55-30-00-410-004

(3) Do this task: Vertical Stabilizer (Fin) - Installation, TASK 55-30-00-400-801.

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

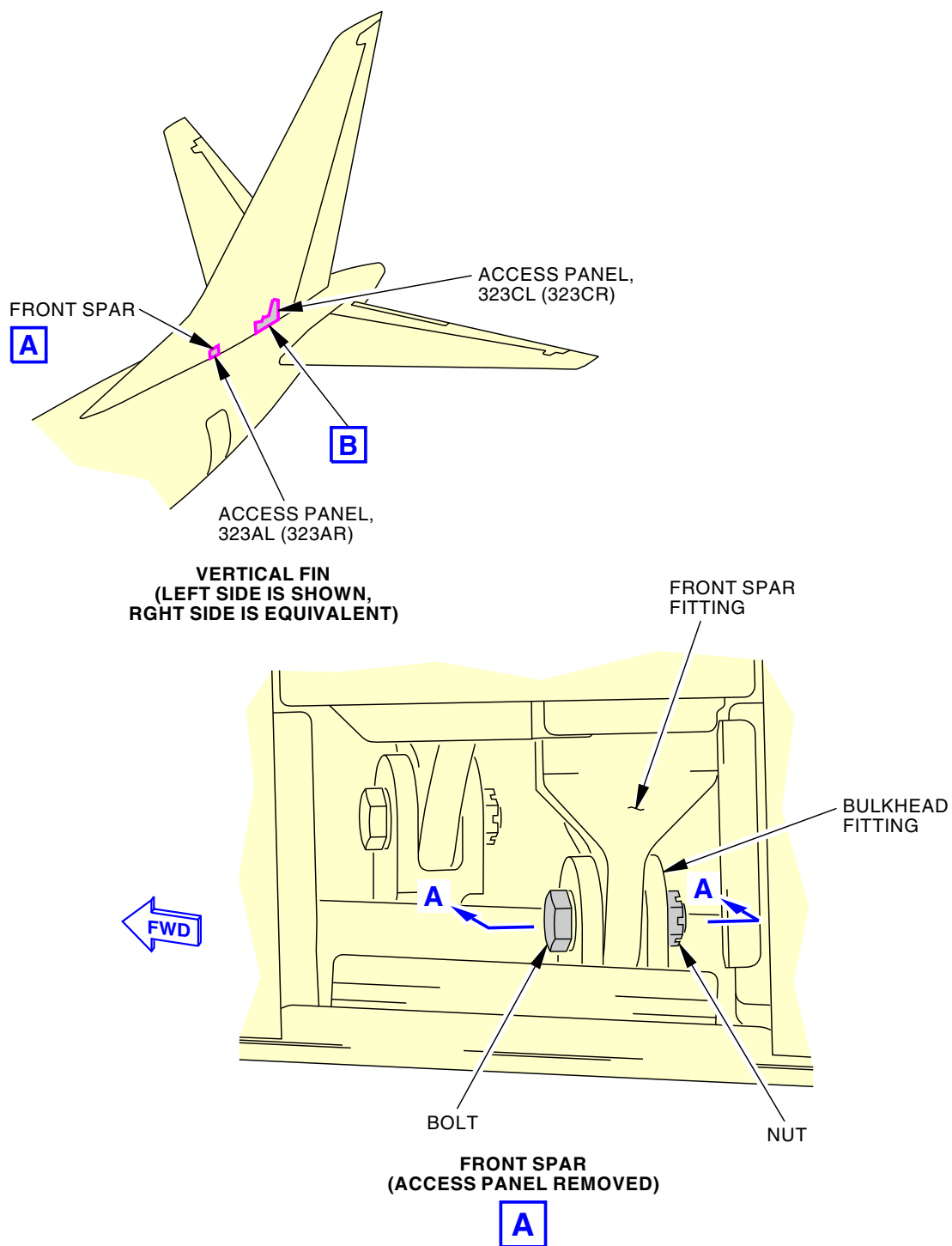
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Page 602
Sep 15/2021



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



2416397 S00061540559_V1

Vertical Stabilizer (Fin) Inspection
Figure 601/55-30-00-990-804 (Sheet 1 of 3)

EFFECTIVITY
SIA ALL

D633AM101-SIA

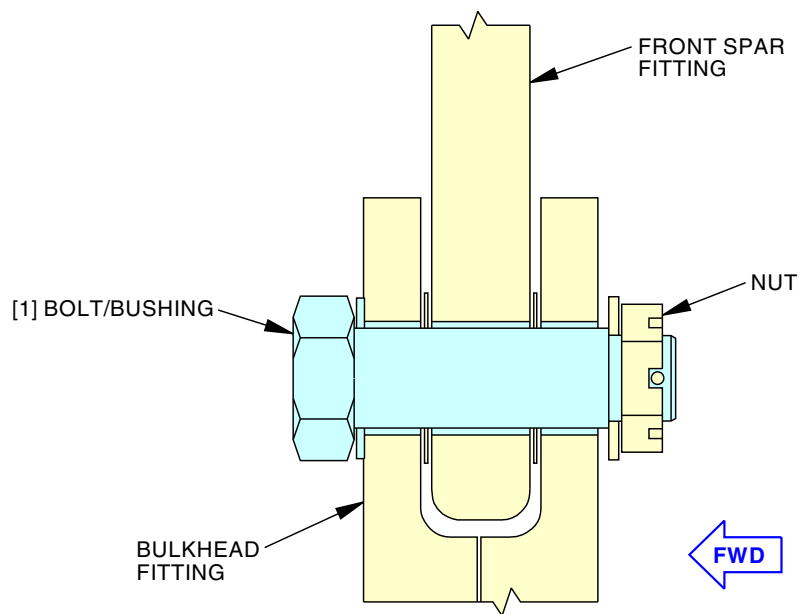
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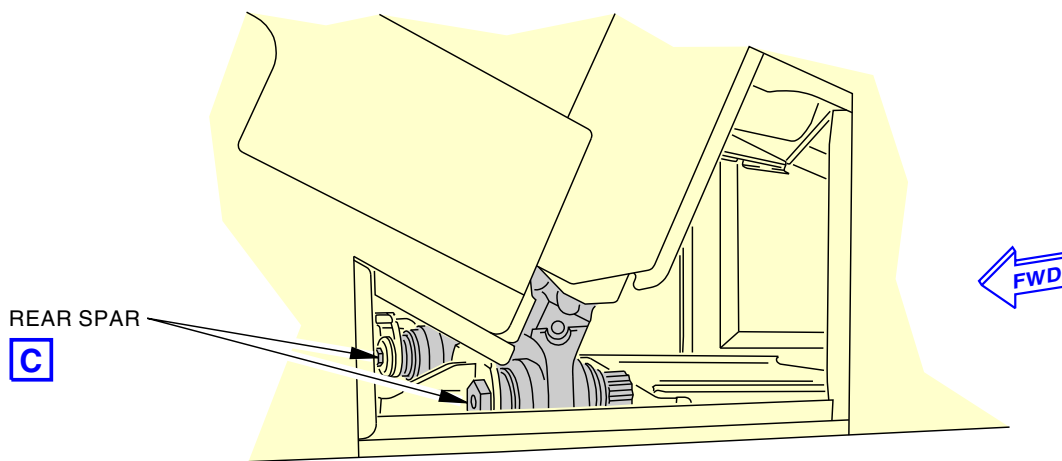
Page 603
Sep 15/2021



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



FRONT SPAR FITTING
A-A



(ACCESS PANEL REMOVED)

B

2416398 S00061540560_V1

Vertical Stabilizer (Fin) Inspection
Figure 601/55-30-00-990-804 (Sheet 2 of 3)

EFFECTIVITY
SIA ALL

D633AM101-SIA

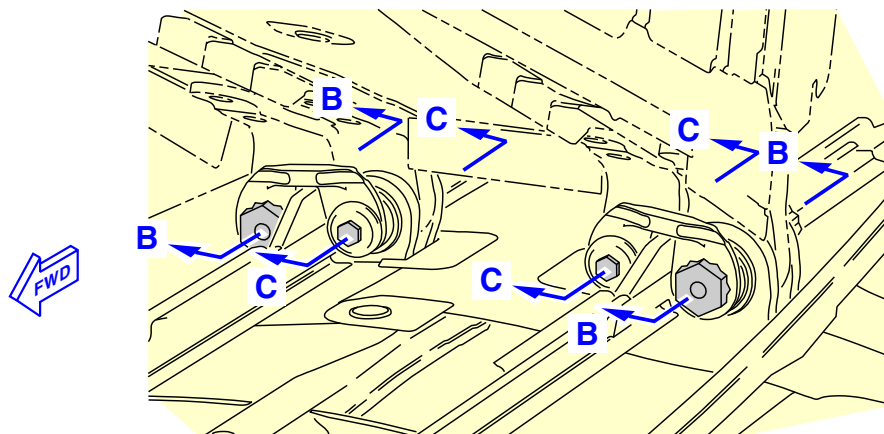
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Page 604
Sep 15/2021

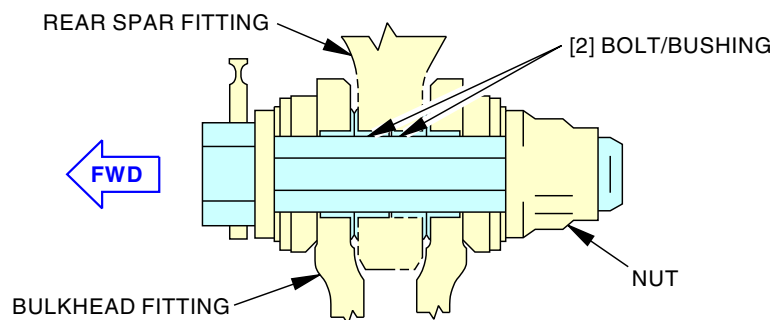


737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



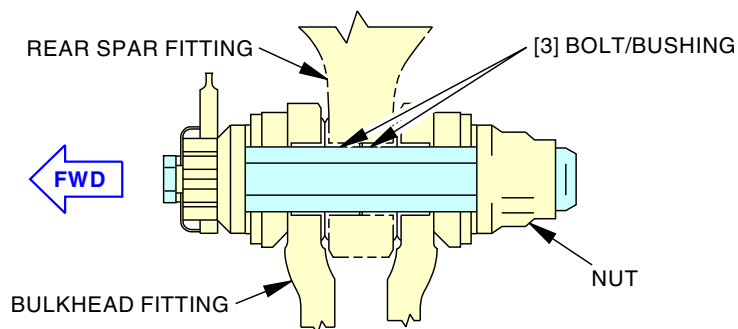
REAR SPAR

C



OUTBOARD REAR SPAR FITTING

B-B



INBOARD REAR SPAR FITTING

C-C

2416399 S00061540561_V1

Vertical Stabilizer (Fin) Inspection
Figure 601/55-30-00-990-804 (Sheet 3 of 3)

EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-30-00

Page 605
Sep 15/2021



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

VERTICAL FIN LUG SEALING - INSPECTION/CHECK

1. General

- A. There is one task in this procedure:
- (1) An inspection of the vertical fin lug sealing

TASK 55-30-01-200-801

2. Vertical Fin Sealing Inspection

(Figure 601)

A. **References**

Reference	Title
51-22-00-390-809	Aerodynamic Smoother Application (P/B 201)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

B. **Consumable Materials**

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II

C. **Location Zones**

Zone	Area
300	Empennage

D. **Access Panels**

Number	Name/Location
311BL	Stabilizer Trim Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

E. **Procedure**

SUBTASK 55-30-01-010-001

- (1) Get access to the vertical fin lugs.
 - (a) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

- (2) Examine all areas for water ingress, corrosion damage and missing, insufficient, or cracked sealant. (Figure 601)

NOTE: If there is no missing sealant, no more steps are necessary.

SUBTASK 55-30-01-010-002

- (3) Get access to the stabilizer trim.

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55-30-01

Page 601
May 15/2023



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

- (a) Open this access panel:

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

311BL	Stabilizer Trim Access Door
-------	-----------------------------

- 1) Examine the skin edges for gaps.
 - a) Make sure that the gaps have been filled with sealant.
- 2) Examine the flight control cables, fittings, and pulleys for corrosion.
- 3) Examine the horizontal stabilizer jackscrew, ball nut, and gimbal pins for corrosion.

SUBTASK 55-30-01-410-001

- (4) Close these access panels:

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

311BL	Stabilizer Trim Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

SUBTASK 55-30-01-390-001

- (5) Apply an aerodynamic smoother sealant, A02315, to all non-bonded structural components contacting exterior skins.

NOTE: Sealant does not need to be applied to gaps between panels that are used for regular access as long as they are less than limits given in the Structural Repair Manual (SRM SUBJECT 51-10-01).

- (a) Do this task: Aerodynamic Smoother Application, TASK 51-22-00-390-809.

———— **END OF TASK** ————

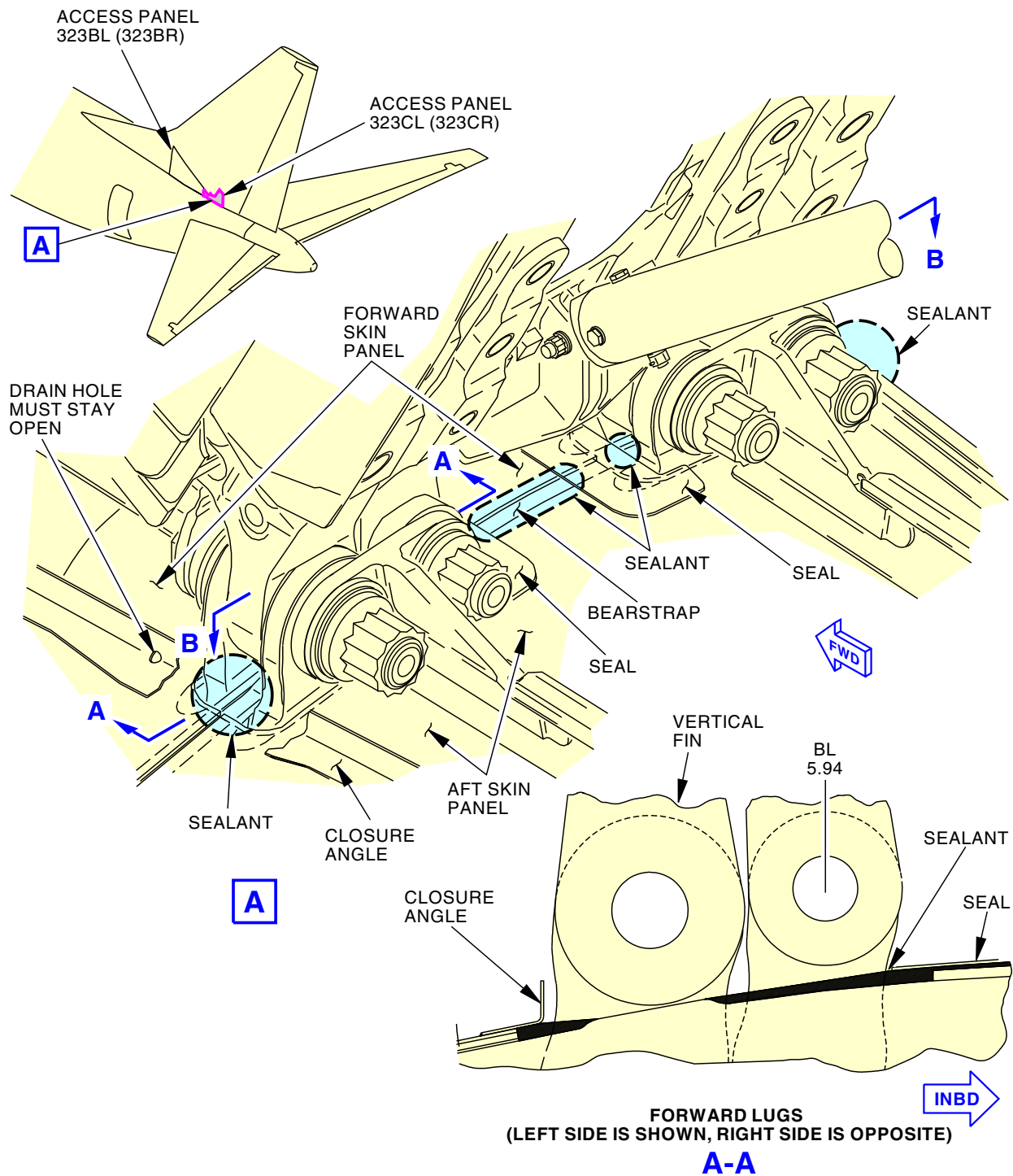
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55-30-01

Page 602
May 15/2023



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Vertical Fin Lugs - Inspection/Check
Figure 601/55-30-01-990-801 (Sheet 1 of 2)

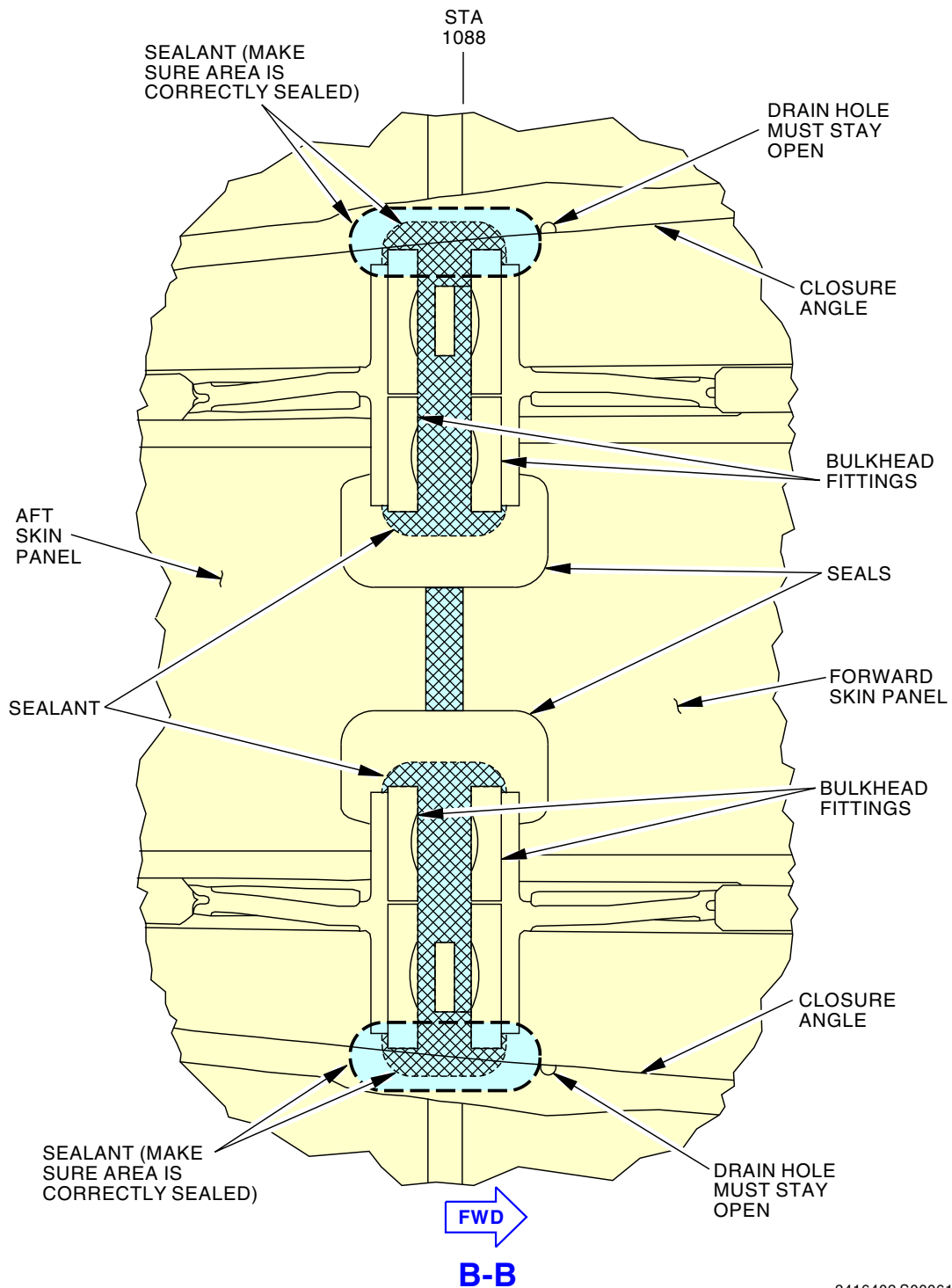
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-30-01

Page 603
Sep 15/2021



2416402 S00061540567_V1

Vertical Fin Lugs - Inspection/Check
Figure 601/55-30-01-990-801 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

55-30-01

D633AM101-SIA

Page 604
Sep 15/2021



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

DORSAL FIN - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) Dorsal fin removal
- (2) Dorsal fin installation.

TASK 55-32-11-000-801

2. Dorsal Fin Removal

(Figure 401)

A. **General**

- (1) This task gives the instructions to remove the dorsal fin.

B. **References**

Reference	Title
21-23-01-000-801	Overhead Distribution Duct Removal (P/B 201)
25-21-71-000-807	Aft Entry Ceiling Panel Removal (P/B 401)
25-80-00-000-801	Insulation Blanket Removal (P/B 401)

C. **Location Zones**

Zone	Area
321	Vertical Fin - Dorsal Fin

D. **Dorsal Fin Removal**

SUBTASK 55-32-11-010-001

- (1) Do this task: Aft Entry Ceiling Panel Removal, TASK 25-21-71-000-807.

SUBTASK 55-32-11-010-002

- (2) Remove the entry light lens on the center part of the aft lowered ceiling panel.
 - (a) Open the entry light lens.
 - (b) Remove the screws which attach the entry light fixture.

SUBTASK 55-32-11-010-003

- (3) Do this task: Overhead Distribution Duct Removal, TASK 21-23-01-000-801.

SUBTASK 55-32-11-010-004

- (4) Move the insulation blankets sufficiently to get access to the bolts [5], bolts [6], bolts [7], and bolts [8] of the dorsal fin [1].
 - (a) When necessary, remove the insulation blankets to get access to the bolts [5], bolts [6], bolts [7], and bolts [8] (TASK 25-80-00-000-801).

SUBTASK 55-32-11-020-001

- (5) Remove the dorsal fin [1].
 - (a) Remove the sealant from the bolts [5], bolts [6], bolts [7], and bolts [8].



CAUTION

MAKE SURE THAT YOU MONITOR WHERE YOU REMOVE EACH FASTENER AT EACH LOCATION. THERE ARE DIFFERENT SIZES FOR THE FASTENERS. IF YOU INSTALL THE FASTENERS AT THE INCORRECT LOCATIONS, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (b) Remove the shims [2], washers [3], washers [4], bolts [5], bolts [6], bolts [7], and bolts [8] that attach the dorsal fin [1] to the body structure.

EFFECTIVITY
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D633AM101-SIA

55-32-11

Page 401
Sep 15/2021



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

(c) Lift the dorsal fin [1] from the fuselage.

———— **END OF TASK** ————

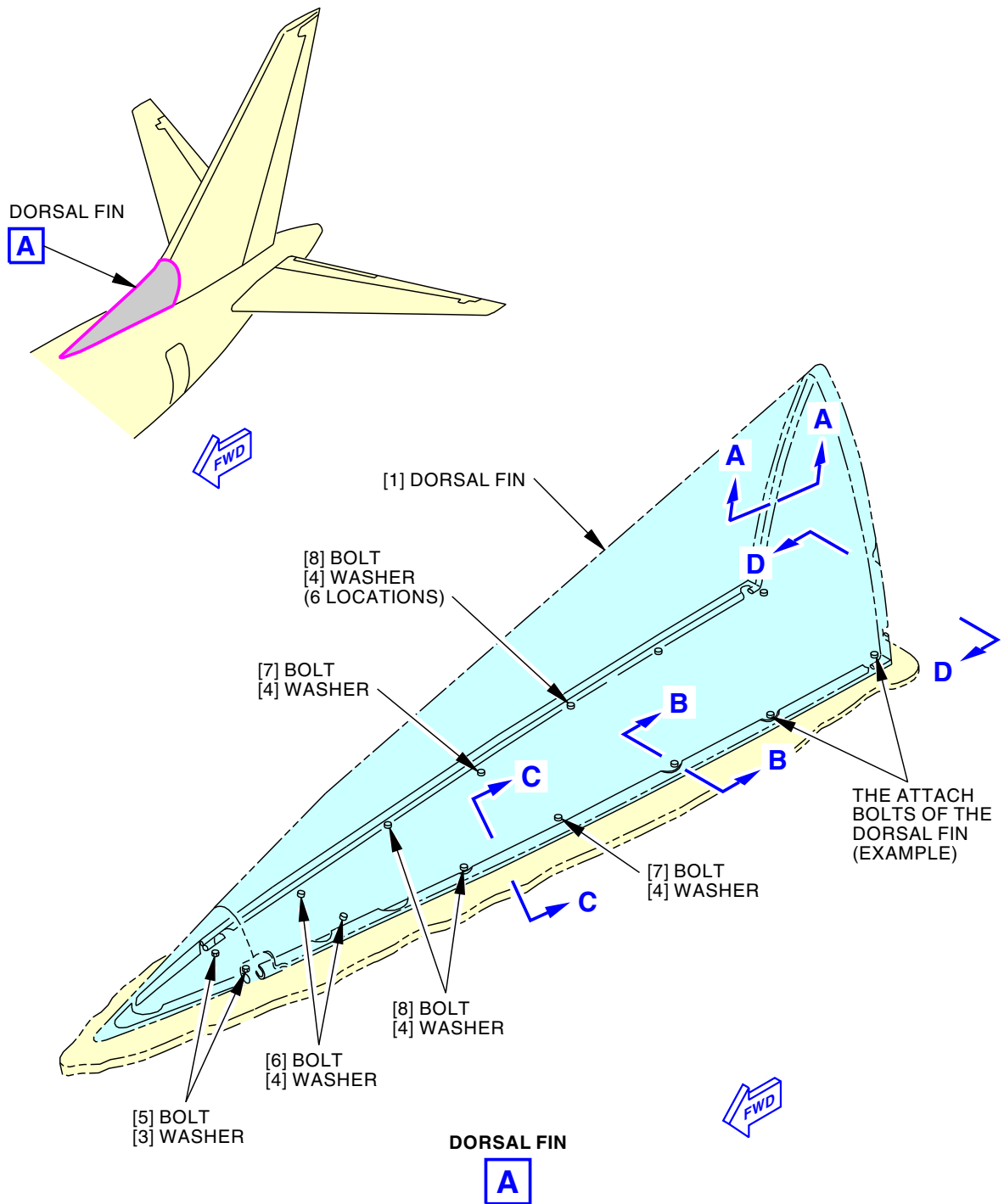
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55-32-11

Page 402
Sep 15/2021



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Dorsal Fin Installation
Figure 401/55-32-11-990-803 (Sheet 1 of 3)

EFFECTIVITY
SIA ALL

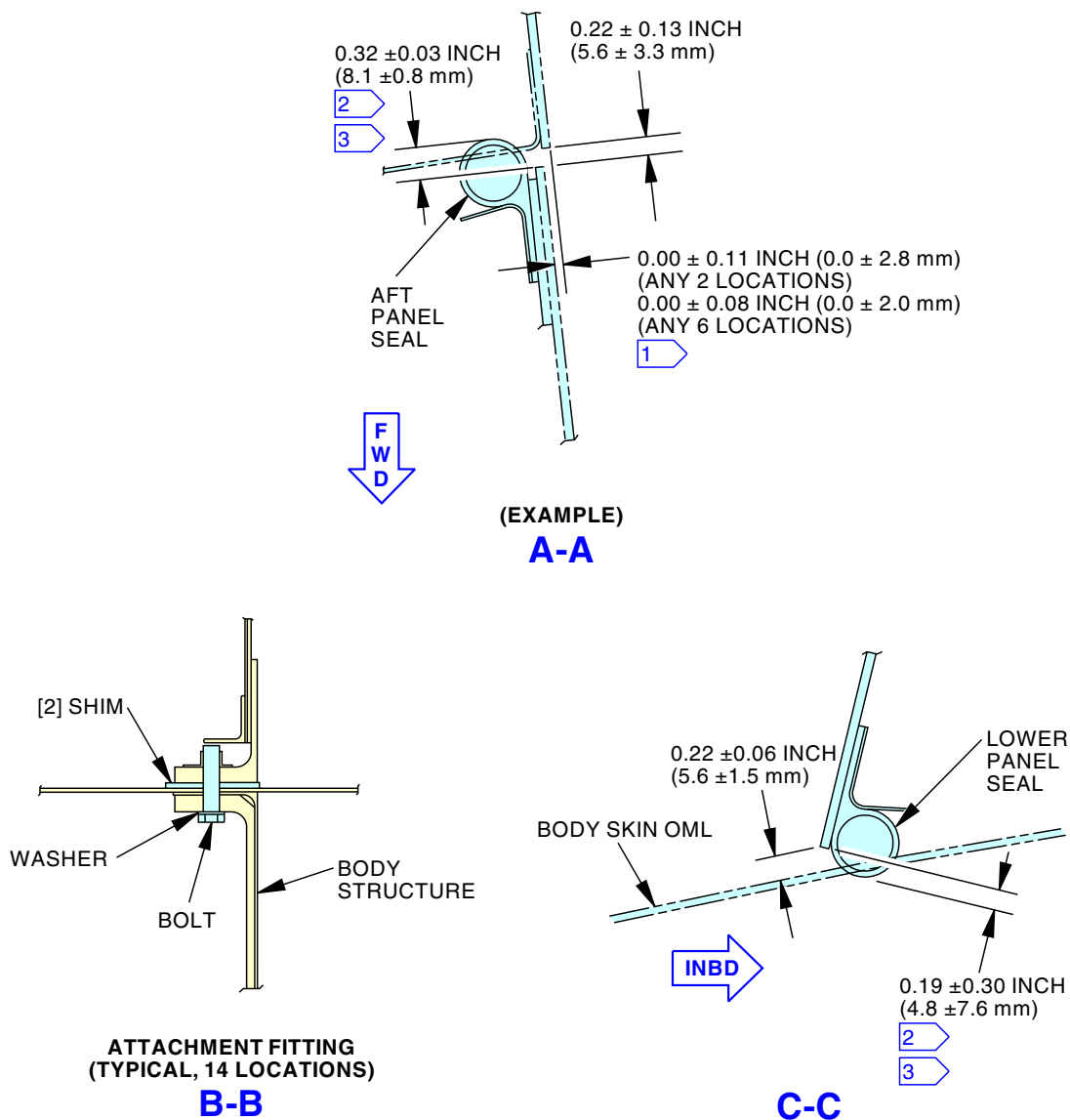
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55-32-11

Page 403
Jan 15/2022

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



- 1 A POSITIVE TOLERANCE FOR THE FLUSHNESS SHOWS THE DORSAL FIN IS INBOARD OF THE VERTICAL FIN CONTOUR.
- 2 THIS DIMENSION IS FOR REFERENCE ONLY. NOT AN INSTALLATION REQUIREMENT.
- 3 APPROXIMATELY 1/3 OF THE SEAL DIAMETER SHOULD BE IN CONTACT.

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Dorsal Fin Installation
Figure 401/55-32-11-990-803 (Sheet 2 of 3)

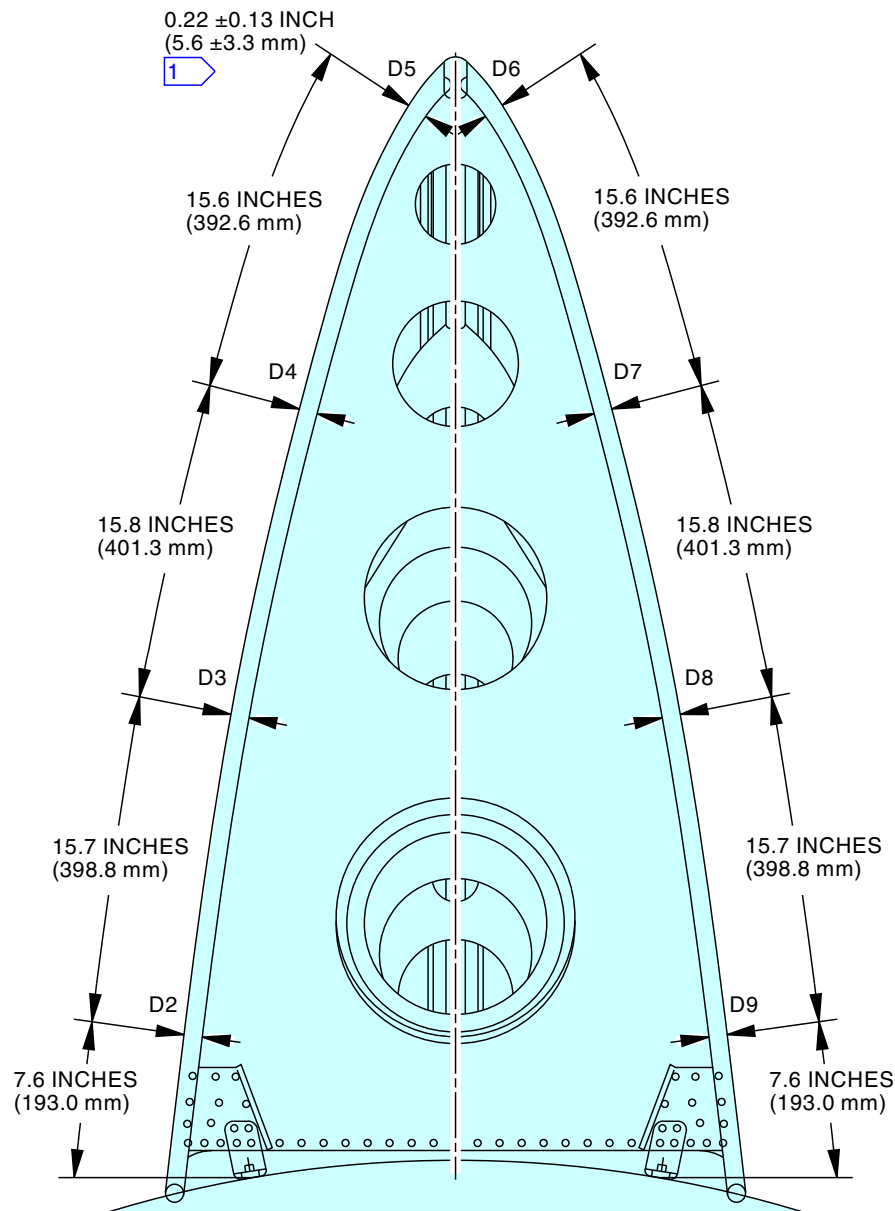
EFFECTIVITY
SIA ALL

D633AM101-SIA

55-32-11

Page 404
Jan 15/2022

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



(VIEW IN THE FORWARD DIRECTION)

D-D

1 CLEARANCE VALUE IS COMMON FOR ALL
D2-D9 LOCATIONS

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Dorsal Fin Installation
Figure 401/55-32-11-990-803 (Sheet 3 of 3)

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55-32-11

Page 405
Jan 15/2022



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

TASK 55-32-11-400-801

3. Dorsal Fin Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the dorsal fin.

B. References

Reference	Title
21-23-01-400-801	Overhead Distribution Duct Installation (P/B 201)
25-21-71-400-807	Aft Entry Ceiling Panel Installation (P/B 401)
25-80-00-400-801	Insulation Blanket Installation (P/B 401)
51-22-00-390-806	Fillet Seal Application (P/B 201)
SRM 51-10-01-0G-0	Aerodynamic Smoothness Requirements
SWPM 20-20-00, Section 21-A	Resistance of Faying Surface Bonds

C. Tools/Equipment

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

Reference	Description
COM-614	Bonding Meters - Non-Intrinsically Safe (For use in outside Class I, Divisions I & II non-hazardous locations. For hazardous locations, use COM-1550). Part #: 247000 Supplier: 00426 Part #: 620LK Supplier: 1CRL2 Part #: BLR-0003-XX Supplier: KC432 Part #: BT51 Supplier: 00426 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659 Opt Part #: 247001 Supplier: 00426

D. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Dorsal fin	55-32-11-01A-045	SIA ALL

F. Location Zones

Zone	Area
321	Vertical Fin - Dorsal Fin

G. Dorsal Fin Installation

SUBTASK 55-32-11-420-001

(1) Install the dorsal fin [1] (Figure 401).

(a) Put the dorsal fin [1] in its position on the airplane.

EFFECTIVITY
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55-32-11

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 406
Sep 15/2022

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



MAKE SURE THAT YOU INSTALL EACH FASTENER AT THE CORRECT LOCATION. THERE ARE DIFFERENT DIMENSIONS FOR THE FASTENERS. IF YOU DO NOT INSTALL THE FASTENERS AT THE CORRECT LOCATIONS, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (b) Install the shims [2], washers [3], and bolts [5] that attach the dorsal fin [1] to the body structure.
- 1) Tighten the bolts [5] to 80 $\pm$ 2 in-lb (9 $\pm$ 0 N·m).



MAKE SURE THAT YOU INSTALL EACH FASTENER AT THE CORRECT LOCATION. THERE ARE DIFFERENT DIMENSIONS FOR THE FASTENERS. IF YOU DO NOT INSTALL THE FASTENERS AT THE CORRECT LOCATIONS, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (c) Install the shims [2], washers [4], bolts [6], bolts [7], and bolts [8] that attach the dorsal fin [1] to the body structure.
- 1) Tighten the bolts [6], bolts [7], and bolts [8] to 150 +5 / -4 in-lb (17 +1 / -0 N·m).

SUBTASK 55-32-11-220-001

- (2) Make sure that the clearances and flushness are in the tolerance shown in Figure 401.
- (a) Make sure that the full length of the lower panel seal touches the body.

SUBTASK 55-32-11-220-004

- (3) Make sure that the dorsal fin [1] is within aerodynamic smoothness limits (SRM PROCEDURE 51-10-01-0G-0).

SUBTASK 55-32-11-760-001

- (4) With a non-intrinsically safe bonding meter, COM-614, make sure that the resistance between the body and the dorsal fin [1] is 0.005 ohm (5 milliohms) or less (SWPM 20-20-00, Section 21-A).
- (a) Measure two locations on each side of the dorsal fin [1].

SUBTASK 55-32-11-390-001

- (5) Apply sealant, A02315, to the bolts [5], bolts [6], bolts [7], and bolts [8], do this task: Fillet Seal Application, TASK 51-22-00-390-806.

SUBTASK 55-32-11-410-001

- (6) If the insulation blankets were removed to get access to the bolts [5], bolts [6], bolts [7], and bolts [8], do this task: Insulation Blanket Installation, TASK 25-80-00-400-801.

SUBTASK 55-32-11-410-002

- (7) Do this task: Overhead Distribution Duct Installation, TASK 21-23-01-400-801.

SUBTASK 55-32-11-410-003

- (8) Install the entry light fixture.

SUBTASK 55-32-11-410-004

- (9) Do this task: Aft Entry Ceiling Panel Installation, TASK 25-21-71-400-807.

————— END OF TASK —————

EFFECTIVITY
SIA ALL

55-32-11

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 407
Sep 15/2021



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

VERTICAL STABILIZER (FIN) LEADING EDGE - REMOVAL/INSTALLATION

1. **General**

A. This procedure has these tasks:

- (1) Vertical stabilizer (fin) leading edge removal
- (2) Vertical stabilizer (fin) leading edge installation.

TASK 55-33-11-000-801

2. **Vertical Stabilizer (Fin) Leading Edge Removal**

(Figure 401)

A. **General**

- (1) This task gives the instructions to remove the vertical stabilizer (fin) leading edge.

B. **References**

Reference	Title
55-33-21-000-801	Vertical Stabilizer (Fin) Tip Removal (P/B 401)
SRM 51-10-01	AERODYNAMIC SMOOTHNESS

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-1558	Adapter - Access Panel, Leverage Part #: 3008-550 Supplier: 55856 Part #: B20004-42 Supplier: 81205 Opt Part #: B20004-21 Supplier: 81205

D. **Location Zones**

Zone	Area
322	Vertical Fin - Removable Fin Leading Edge

E. **Access Panels**

Number	Name/Location
322A	Vertical Fin, Fixed Leading Edge
322AL	Vertical Fin, Fixed Leading Edge
322AR	Vertical Fin, Fixed Leading Edge
322AT	Vertical Fin, Removable Leading Edge
322BT	Vertical Fin, Removable Leading Edge
322C	Vertical Fin, Removable Leading Edge
322CT	Vertical Fin, Removable Leading Edge

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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-33-11

Page 401
Sep 15/2021



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

F. Vertical Stabilizer (Fin) Leading Edge Removal

SUBTASK 55-33-11-010-001



MAKE SURE THAT THE DRIVER BIT ALIGNS WITH THE INSTALLED FASTENERS. THIS WILL PREVENT DAMAGE TO THE FASTENER RECESSES AND THREADS.

- (1) Use a leverage access panel adapter, SPL-1558, or a removal Anti Cam-out Ribbed (ACR) bit to remove the fasteners from the applicable vertical fin leading edge access panels.

NOTE: A combination removal/installation ACR bit is not recommended. The bit must have a hardness of 56-58 RC.

SUBTASK 55-33-11-640-001



IF NECESSARY, APPLY FASTENER REMOVAL COMPOUND TO THE BIT. CLEAN THE BIT AFTER EACH USE. DO NOT APPLY FASTENER REMOVAL COMPOUND TO THE FASTENER RECESSES, HOLES, OR THREADS. THIS CAN CAUSE DAMAGE TO THE FASTENERS.

- (2) Apply a fastener removal compound on the driver bit if a fastener is difficult to remove.

SUBTASK 55-33-11-010-007



KEEP PERSONS AWAY FROM THE AREA BELOW THE VERTICAL STABILIZER. INJURY TO PERSONS AND DAMAGE TO THE EQUIPMENT CAN OCCUR IF EQUIPMENT OR PARTS FALL.



BE CAREFUL WHEN YOU REMOVE THE LEADING EDGE SECTIONS. IF YOU RUB THE SKIN OR STRUCTURE, DAMAGE TO THE PAINT CAN OCCUR.

- (3) These access panels are required to be removed in this procedure (follow the steps in the procedure to remove the applicable access panels):

<u>Number</u>	<u>Name/Location</u>
322A	Vertical Fin, Fixed Leading Edge
322AL	Vertical Fin, Fixed Leading Edge
322AR	Vertical Fin, Fixed Leading Edge
322AT	Vertical Fin, Removable Leading Edge
322BT	Vertical Fin, Removable Leading Edge
322C	Vertical Fin, Removable Leading Edge
322CT	Vertical Fin, Removable Leading Edge

SUBTASK 55-33-11-030-001

- (4) Disconnect the upper end of the feedline tube [9], as follows:

- (a) Remove the removable leading edge panel, 322C [4].
- (b) Remove the screw [12] and washer [13].

SUBTASK 55-33-11-020-002

- (5) Remove the sleeve [10], as follows:

- (a) Remove the fixed leading edge panel, 322AL [2].
- (b) Remove the hose clamps [8] from the feedline tube assembly.

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D633AM101-SIA

55-33-11

Page 402
May 15/2022



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

- (c) Slide the sleeve [10] back.

SUBTASK 55-33-11-010-002

- (6) Disconnect the lower end of the feedline tube [9], as follows:
 - (a) Remove the fixed leading edge panel, 322A [3].
 - (b) Remove the coupler tray assembly cover [11].
 - (c) Remove the screw [14], washer [15], and nut [16].
 - (d) Remove the feedline tube [9].

SUBTASK 55-33-11-010-003

- (7) Remove the fasteners from the removable leading edge panel, 322AT [5], removable leading edge panel, 322BT [6], and removable leading edge panel, 322CT [7].

SUBTASK 55-33-11-010-004

- (8) Remove the fasteners from vertical stabilizer tip forward fairing (TASK 55-33-21-000-801).

SUBTASK 55-33-11-010-005

- (9) Move the removable leading edge panel, 322AT [5], removable leading edge panel, 322BT [6], and removable leading edge panel, 322CT [7] slightly up and remove.

SUBTASK 55-33-11-210-001

- (10) Examine the leading edge for aerodynamic smoothness (SRM SUBJECT 51-10-01).

SUBTASK 55-33-11-210-002

- (11) Install the protective cover on the leading edge area.

———— **END OF TASK** ————

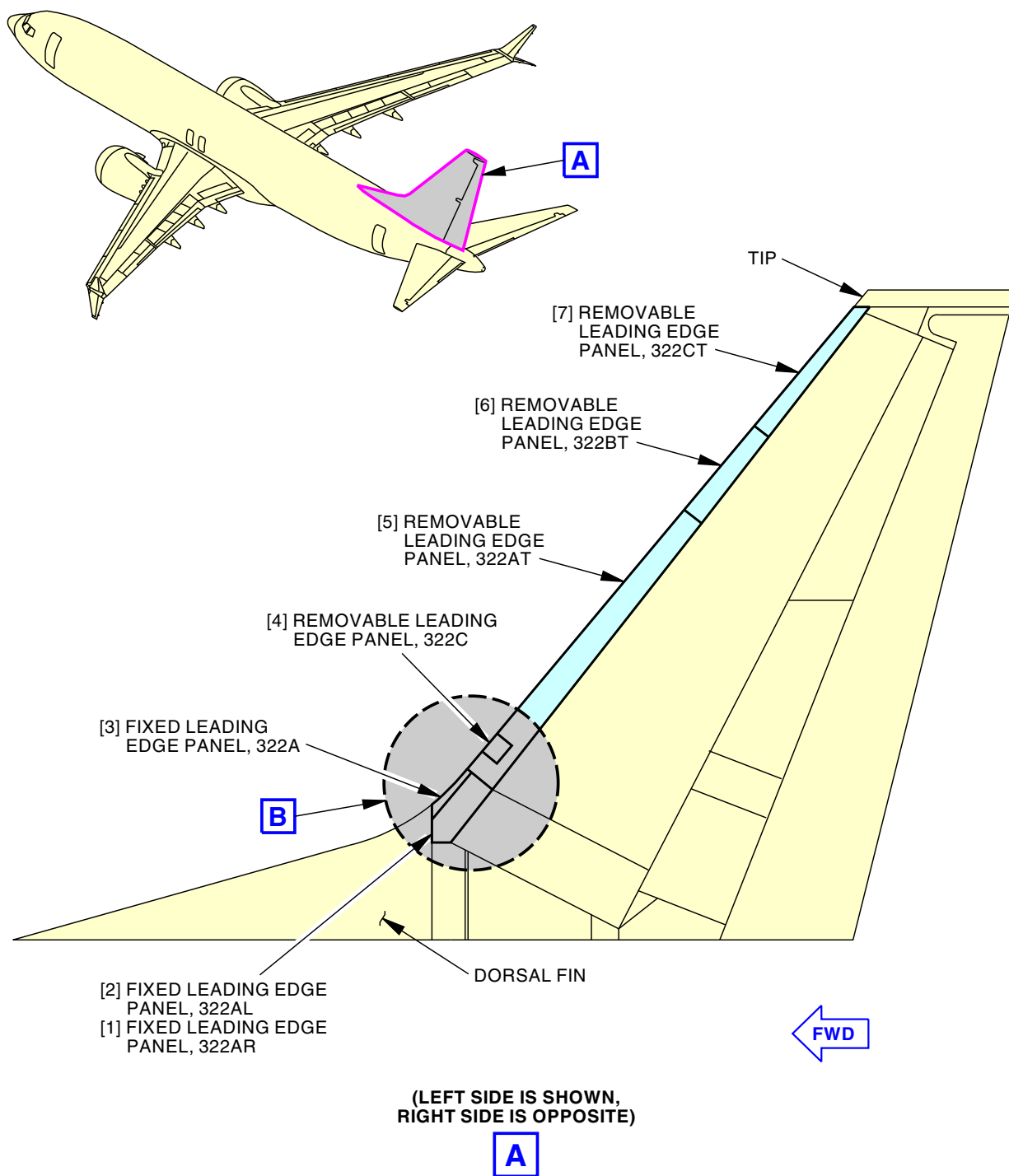
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55-33-11

Page 403
May 15/2022



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Vertical Stabilizer (Fin) Leading Edge Panels Installation
Figure 401/55-33-11-990-801 (Sheet 1 of 2)

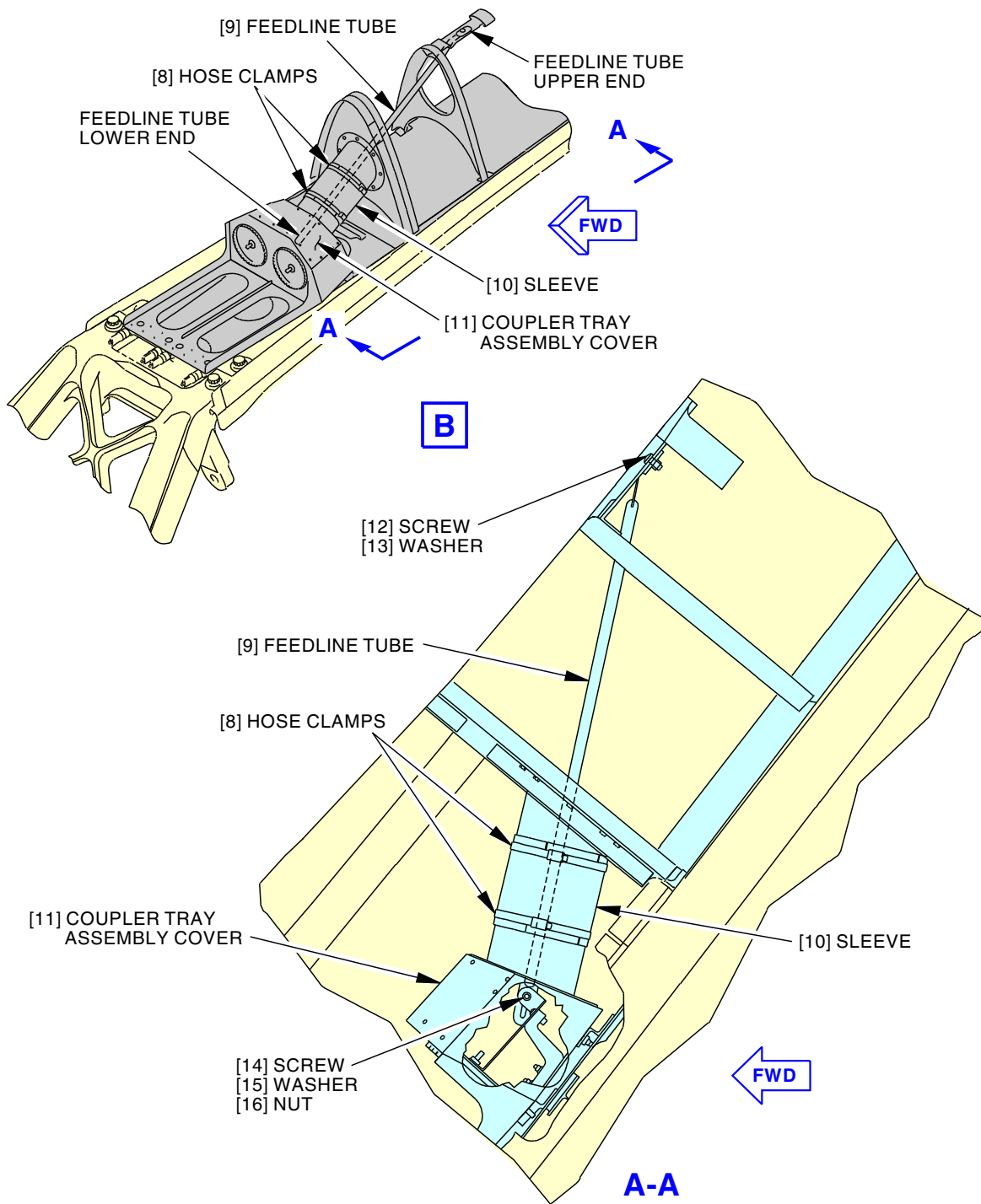
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55-33-11

Page 404
Sep 15/2021



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Vertical Stabilizer (Fin) Leading Edge Panels Installation
Figure 401/55-33-11-990-801 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-33-11

Page 405
May 15/2022



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

TASK 55-33-11-400-801

3. Vertical Stabilizer (Fin) Leading Edge Installation

(Figure 401)

A. General

(1) This task gives the instructions to install the vertical stabilizer (fin) leading edge.

B. References

Reference	Title
20-10-37 P/B 601	ELECTRICAL BONDING - INSPECTION/CHECK
20-50-11 P/B 201	STANDARD TORQUE VALUES - MAINTENANCE PRACTICES
23-11-00-730-801	HF Communication System - System Test (P/B 501)
51-21-41-370-801	Apply Bonderite M-CR 1001 Aero Solution (P/B 701)
55-33-21-400-801	Vertical Stabilizer (Fin) Tip Installation (P/B 401)
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES

C. Tools/Equipment

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

Reference	Description
COM-614	Bonding Meters - Non-Intrinsically Safe (For use in outside Class I, Divisions I & II non-hazardous locations. For hazardous locations, use COM-1550). Part #: 247000 Supplier: 00426 Part #: 620LK Supplier: 1CRL2 Part #: BLR-0003-XX Supplier: KC432 Part #: BT51 Supplier: 00426 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659 Opt Part #: 247001 Supplier: 00426
SPL-1558	Adapter - Access Panel, Leverage Part #: 3008-550 Supplier: 55856 Part #: B20004-42 Supplier: 81205 Opt Part #: B20004-21 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A50231	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class B
B00130	Alcohol - Isopropyl	TT-I-735
C00064	Coating - Aluminum Chemical Conversion	BAC5719 Type II Class A (MIL-DTL-5541 Class 1A)
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-33-11

Page 406
Jan 15/2023



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

(Continued)

Reference	Description	Specification
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)
G50381	Abrasive - Aluminum Oxide Paper, 180 Grit	
G50961	Coating - Corrosion Inhibiting Epoxy Primer - (BAC 377 Yellow Color)	BMS10-11 Type I

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
4	Removable leading edge panel, 322C	55-33-11-01-065	SIA ALL
5	Removable leading edge panel, 322AT	55-33-11-01-065	SIA ALL
6	Removable leading edge panel, 322BT	55-33-11-01-065	SIA ALL
7	Removable leading edge panel, 322CT	55-33-11-01-065	SIA ALL

F. Location Zones

Zone	Area
322	Vertical Fin - Removable Fin Leading Edge

G. Access Panels

Number	Name/Location
322A	Vertical Fin, Fixed Leading Edge
322AL	Vertical Fin, Fixed Leading Edge
322AR	Vertical Fin, Fixed Leading Edge
322AT	Vertical Fin, Removable Leading Edge
322BT	Vertical Fin, Removable Leading Edge
322C	Vertical Fin, Removable Leading Edge
322CT	Vertical Fin, Removable Leading Edge

H. Vertical Stabilizer (Fin) Leading Edge Installation

SUBTASK 55-33-11-010-006

- (1) Remove the protective cover from the leading edge area.

SUBTASK 55-33-11-410-001

- (2) Attach the lower end of the feedline tube [9].
 - (a) Install the screw [14], washer [15], and nut [16].
 - (b) Tighten the screw [14] to 25 in-lb (2.8 N·m).
 - (c) Install the coupler tray assembly cover [11].

SUBTASK 55-33-11-410-002

- (3) Install the sleeve [10] to the feedline tube assembly.
 - (a) Attach the hose clamps [8].
 - (b) Tighten the hose clamps [8] to 16 in-lb (1.8 N·m) - 18 in-lb (2.0 N·m).

EFFECTIVITY
SIA ALL

55-33-11

D633AM101-SIA

Page 407
Jan 15/2023



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

SUBTASK 55-33-11-420-001



WARNING

KEEP PERSONS AWAY FROM THE AREA BELOW THE VERTICAL STABILIZER. INJURY TO PERSONS AND DAMAGE TO THE EQUIPMENT CAN OCCUR IF EQUIPMENT OR PARTS FALL.



CAUTION

BE CAREFUL WHEN YOU INSTALL THE LEADING EDGE. YOU CAN EASILY CAUSE DAMAGE TO THE LEADING EDGE FINISH.

- (4) Put the applicable leading edge panel in the correct position on the stabilizer.



CAUTION

ALIGN THE LEADING EDGE ASSEMBLY ALONG THE FULL LENGTH OF THE EDGE BEFORE YOU INSTALL THE FASTENERS. IF YOU PUSH THE ASSEMBLY INTO ITS POSITION AND INSTALL THE FASTENERS, DAMAGE CAN OCCUR TO THE RIB CHORDS.

- (a) Make sure that the leading edge assembly aligns the full length before you install the fasteners.

Install these access panels:

<u>Number</u>	<u>Name/Location</u>
322A	Vertical Fin, Fixed Leading Edge
322AL	Vertical Fin, Fixed Leading Edge
322AR	Vertical Fin, Fixed Leading Edge
322AT	Vertical Fin, Removable Leading Edge
322BT	Vertical Fin, Removable Leading Edge
322C	Vertical Fin, Removable Leading Edge
322CT	Vertical Fin, Removable Leading Edge

SUBTASK 55-33-11-420-002

- (5) Put the applicable vertical stabilizer tip forward fairing in the correct position on the stabilizer (TASK 55-33-21-400-801).

SUBTASK 55-33-11-420-003

- (6) Install the fasteners on the vertical fin leading edge and vertical tip forward fairing:

- (a) Make sure that the fasteners have the correct grip length and do not have damaged threads or recesses.

NOTE: If fasteners need to be replaced, it is recommended that K-coated titanium bolts with cadmium plated Cres nut-plates be installed.

- (b) Remove unwanted paint on the fastener recesses.



WARNING

DO NOT LUBRICATE FASTENERS OTHER THAN THE ACCESS PANELS. IF YOU LUBRICATE OTHER FASTENERS, IT CAN CAUSE DEFECTIVE EQUIPMENT AND INJURIES.

- (c) Apply corrosion preventive compound, C00528, to the hole and the countersink.

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-33-11

Page 408
Jan 15/2023



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



MAKE SURE THAT THE DRIVER BIT ALIGNS WITH THE INSTALLED FASTENERS. THIS WILL PREVENT DAMAGE TO THE FASTENER RECESSES AND THREADS.

- (d) Immediately install the fasteners with a leverage access panel adapter, SPL-1558, or an installation Anti Cam-out Ribbed (ACR) driver bit.

NOTE: Use decreased lubricated fastener torques (PAGEBLOCK 20-50-11/201).

NOTE: A combination removal/installation ACR bit is not recommended. The bit must have a hardness of 56-58 RC.

SUBTASK 55-33-11-400-001

- (7) Install the leading edge that has the High Frequency (HF) antenna:
- (a) Clean the mating surfaces between the attach plates and the antenna feedlines with 180 grit abrasive paper, G50381.
 - (b) Clean the surface with a clean cotton wiper, G00034, moist with alcohol, B00130.
 - 1) Continue to clean until a cotton wiper, G00034, shows clean.
 - (c) Apply coating, C00064, to the cleaned surfaces (TASK 51-21-41-370-801).
 - (d) Put the part of the leading edge that contains the HF antenna in the correct position.
 - (e) Make sure that the attach plate is below the antenna feedline tube [9].
 - (f) Connect the antenna feedline tube [9] to the attach plates.
 - 1) Install the screw [12] and washer [13].
 - (g) Measure the electrical bonding resistance between the feedline tube [9] and structure (PAGEBLOCK 20-10-37/601, SWPM 20-20-00).
 - 1) Use a non-intrinsically safe bonding meter, COM-614.
 - 2) Make sure that the bonding resistance is 0.001 ohms (1 milliohm) or less.
 - (h) If the resistance between the antenna feedline tube [9] and structure is more than 0.001 ohm (1 milliohm), clean the antenna feedline tube [9] again.
 - (i) Apply coating, G50961, to the mating surfaces of the installed parts.
 - (j) Tighten the screw [12] to 80 in-lb (9.0 N·m).
 - (k) Apply sealant, A50231, to make a fillet seal around the screw [12], washer [13] and the nutplate on the feedline tube [9].

SUBTASK 55-33-11-220-001

- (8) Do a check of the leading edge panel as follows:
- (a) Measure the clearance at the edges of the panels:
 - 1) Make sure that the clearance for the fixed leading edge panel, 322AR [1], fixed leading edge panel, 322AL [2], fixed leading edge panel, 322A [3], removable leading edge panel, 322AT [5], removable leading edge panel, 322BT [6], and removable leading edge panel, 322CT [7] is 0.08 +0.06 / -0.04 in. (2.03 +1.53 / -1.02 mm).
 - 2) Make sure that the clearance for the removable leading edge panel, 322C [4] is 0.08 +0.06 / -0.04 in. (2.03 +1.53 / -1.02 mm) on the top edge and 0.14 +0.06 / -0.04 in. (3.56 +1.53 / -1.02 mm) on the bottom edge.
 - (b) Make sure that the misfair is not more than 0.010 in. (0.254 mm).

EFFECTIVITY
SIA ALL

D633AM101-SIA

55-33-11

Page 409
Sep 15/2023



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

- (c) Make sure that the bolts are aligned within the tolerance of 0.002 in. (0.051 mm) below the surface to 0.004 in. (0.102 mm) above the surface.

SUBTASK 55-33-11-410-003

- (9) Apply aerodynamic sealant, A00247, to the panel joints.
 - (a) Make sure that the cured sealant, A00247, is aligned within the tolerance of 0.000 in. (0.000 mm) at the surface to 0.010 in. (0.254 mm) below the surface.
 - (b) Do not cover the fasteners with aerodynamic sealant, A00247.

I. Installation Test

SUBTASK 55-33-11-730-001

- (1) Do this task: HF Communication System - System Test, TASK 23-11-00-730-801.

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-33-11

Page 410
Sep 15/2023



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

VERTICAL STABILIZER (FIN) TIP - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the vertical stabilizer (fin) tip
 - (2) An installation of the vertical stabilizer (fin) tip.

TASK 55-33-21-000-801

2. Vertical Stabilizer (Fin) Tip Removal

(Figure 401)

A. **General**

- (1) This task gives the instructions to remove the vertical stabilizer (fin) tip.

B. **Location Zones**

<u>Zone</u>	<u>Area</u>
326	Vertical Fin - Fin Tip

C. **Vertical Stabilizer (Fin) Tip Removal**

SUBTASK 55-33-21-040-001

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

CAPT Electrical System Panel, P18-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
SIA 001-005			
A	1	C01374	RADIO NAVIGATION VOR/MKR BCN 1

CAPT Electrical System Panel, P18-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
SIA ALL			
E	2	C00412	INSTR XFR

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
SIA 001-005			
A	12	C01375	RADIO NAVIGATION VOR 2
SIA ALL			

These circuit breakers are inoperative and should remain open:

CAPT Electrical System Panel, P18-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
SIA 006, 007			
A	1	C01374	RADIO NAVIGATION VOR/MKR BCN 1 (INOP)

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	12	C01375	RADIO NAVIGATION VOR 2 (INOP)

SIA ALL

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-33-21

Page 401
Jan 15/2023



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

SUBTASK 55-33-21-020-001



WARNING

MAKE SURE THAT PERSONNEL STAY A MINIMUM OF 6 FEET (1.8 METERS) AWAY FROM THE VERTICAL STABILIZER WHEN THE SYSTEM TRANSMITS. RADIO FREQUENCY ENERGY FROM THE ANTENNA CAN CAUSE INJURIES TO PERSONNEL.

- (2) Remove the fairings on the (fin) tip.
 - (a) Remove the fasteners from the forward fairing [1].
 - (b) Remove the forward fairing [1].
 - (c) Disconnect the wires from the VOR antenna.
 - (d) Remove the fasteners from the middle fairing [2].
 - (e) Remove the middle fairing [2].
 - (f) Remove the fasteners from the aft fairing [4].
 - (g) Remove the aft fairing [4].

———— **END OF TASK** ————

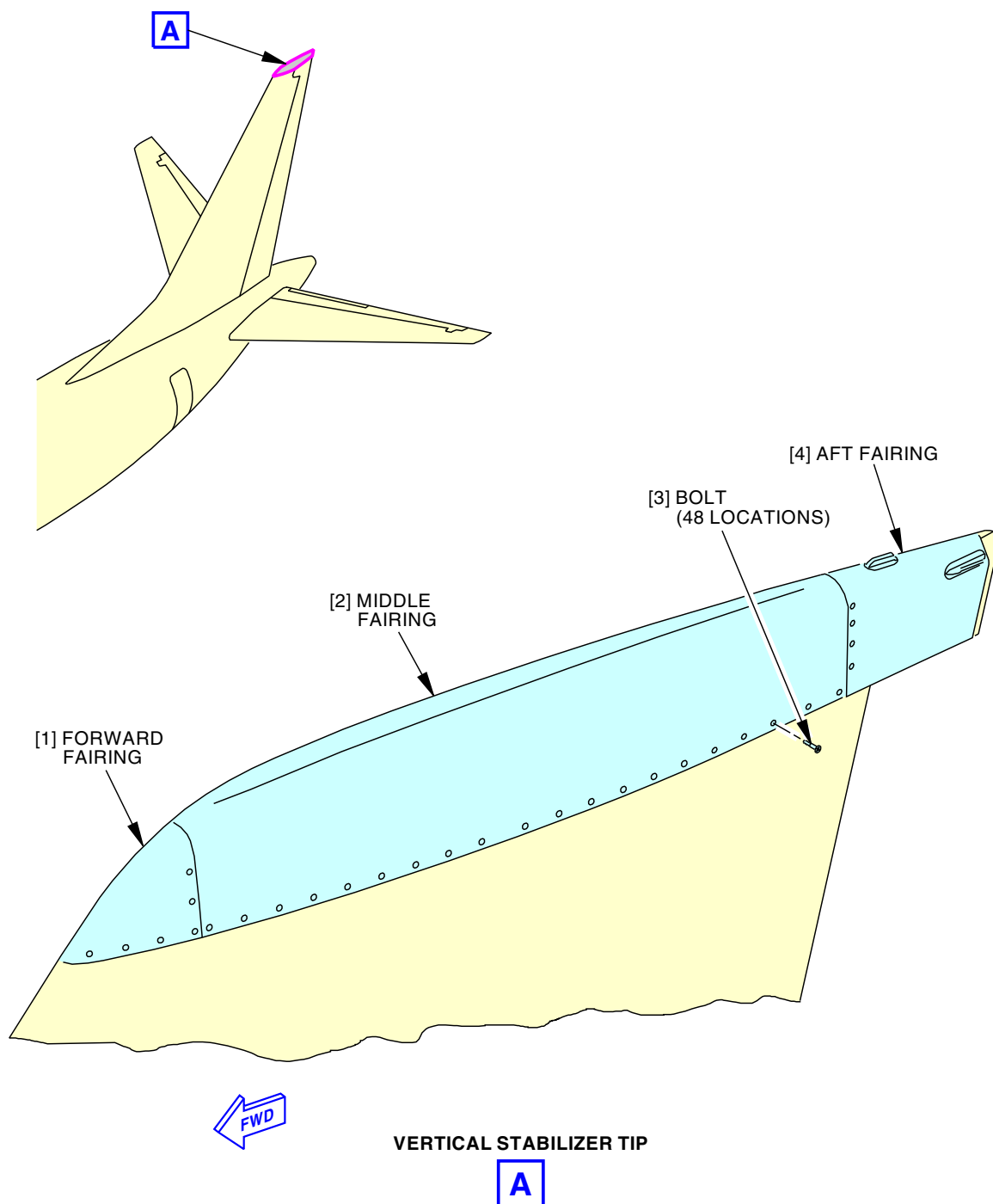
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-33-21

Page 402
Sep 15/2021



2416411 S00061540590_V1

Vertical Stabilizer Tip Installation
Figure 401/55-33-21-990-801

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-33-21

Page 403
Sep 15/2021



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

TASK 55-33-21-400-801

3. **Vertical Stabilizer (Fin) Tip Installation**

(Figure 401)

A. General

(1) This task gives the instructions to install the vertical stabilizer (fin) tip.

B. References

Reference	Title
34-31-00-710-801	Instrument Landing System - Operational Test (P/B 501)
34-51-00-710-801	VOR System - Operational Test (P/B 501)

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A50359	Sealant - Low Density, Non-Chromate Type	BMS5-142 Type II Class B

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Forward fairing	34-51-02-01-015	SIA ALL
2	Middle fairing	34-51-02-01-015	SIA ALL
4	Aft fairing	34-51-02-01-020	SIA ALL

E. Location Zones

Zone	Area
326	Vertical Fin - Fin Tip

F. Vertical Stabilizer (Fin) Tip Installation

SUBTASK 55-33-21-420-001



WARNING

MAKE SURE THAT PERSONNEL STAY A MINIMUM OF 6 FEET (1.8 METERS) AWAY FROM THE VERTICAL STABILIZER WHEN THE SYSTEM TRANSMITS. RADIO FREQUENCY ENERGY FROM THE ANTENNA CAN CAUSE INJURIES TO PERSONNEL.

- (1) Install the fairings on the (fin) tip.
- (a) Put the aft fairing [4] in its position on the fin.
 - (b) Install the fasteners in the aft fairing [4].
 - (c) Put the middle fairing [2] in its position.
 - (d) Install the fasteners on the middle fairing [2].
 - (e) Connect the VOR antenna wires.
 - (f) Put the forward fairing [1] in its position.
 - (g) Install the fasteners on the forward fairing [1].

NOTE: Make sure that all fasteners forward of the rear spar are installed between 0.010 in. (0.254 mm) below the surface and 0.002 in. (0.051 mm) above the surface. Do not shave the heads of the fasteners.

SUBTASK 55-33-21-210-001

- (2) Make sure that the distance between the fairings and the fin is in tolerance.

EFFECTIVITY
SIA ALL

D633AM101-SIA

55-33-21

Page 404
Jan 15/2023



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

- (a) Measure the flushness between the fairings and the fin.
 - 1) Make sure that the flushness of the leading edge is 0.0000 +0.0600 / -0.0300 in. (0.00 +1.52 / -0.76 mm).
 - 2) Make sure that the flushness of the fairings is 0.0000 ±0.0300 in. (0.00 ±0.76 mm).
- (b) Measure the clearance between the fairings and the fin.
 - 1) Make sure that the clearance is 0.0000 +0.1500 / -0.0000 in. (0.00 +3.81 / -0.00 mm)

SUBTASK 55-33-21-390-002

- (3) Apply sealant, A50359, or sealant, A00247, between the forward fairing [1] and middle fairing [2] to make an aerodynamic seal.

SUBTASK 55-33-21-390-003

- (4) Apply sealant, A50359, or sealant, A00247, between the middle fairing [2] and aft fairing [4] to make an aerodynamic seal.

SUBTASK 55-33-21-390-001

- (5) Apply sealant, A50359, to make an aerodynamic seal where the clearances are more than 0.02 in. (0.51 mm).

SUBTASK 55-33-21-860-001

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

CAPT Electrical System Panel, P18-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
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SIA 001-005

A	1	C01374	RADIO NAVIGATION VOR/MKR BCN 1
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CAPT Electrical System Panel, P18-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
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SIA ALL

E	2	C00412	INSTR XFR
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F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
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SIA 001-005

A	12	C01375	RADIO NAVIGATION VOR 2
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SIA ALL

These circuit breakers are inoperative and should remain open:

CAPT Electrical System Panel, P18-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
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SIA 006, 007

A	1	C01374	RADIO NAVIGATION VOR/MKR BCN 1 (INOP)
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F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
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A	12	C01375	RADIO NAVIGATION VOR 2 (INOP)
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SIA ALL

EFFECTIVITY
SIA ALL

55-33-21

D633AM101-SIA

Page 405
Jan 15/2023



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

SUBTASK 55-33-21-730-001

(7) Do this task: Instrument Landing System - Operational Test, TASK 34-31-00-710-801.

SUBTASK 55-33-21-730-002

(8) Do this task: VOR System - Operational Test, TASK 34-51-00-710-801.

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-33-21

Page 406
Jan 15/2023



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

VERTICAL STABILIZER (FIN) TRAILING EDGE PANELS - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) Vertical stabilizer (fin) trailing edge panels removal
- (2) Vertical stabilizer (fin) trailing edge panels installation.

TASK 55-33-31-000-801

2. Vertical Stabilizer (Fin) Trailing Edge Panels Removal

(Figure 401)

A. **General**

- (1) This task gives the instructions to remove the stabilizer (fin) trailing edge panels.

B. **Tools/Equipment**

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

Reference	Description
SPL-1558	Adapter - Access Panel, Leverage Part #: 3008-550 Supplier: 55856 Part #: B20004-42 Supplier: 81205 Opt Part #: B20004-21 Supplier: 81205

C. **Location Zones**

Zone	Area
324	Vertical Fin - Rear Spar To Trailing Edge

D. **Access Panels**

Number	Name/Location
324AL	Vertical Fin, Aft Fin Access Door
324AR	Vertical Fin, Aft Fin Access Door
324BL	Vertical Fin, Trailing Edge Access
324BR	Vertical Fin, Trailing Edge Access
324DL	Trailing Edge Access
324DR	Vertical Fin, Trailing Edge Access
324JL	Vertical Fin, Access

E. **Vertical Stabilizer (Fin) Trailing Edge Panels Removal**

SUBTASK 55-33-31-010-001



PREVENT THE OPERATION OF THE RUDDER WHEN YOU DO WORK ON IT OR NEAR IT. THE RUDDER MOVES QUICKLY AND ITS FORCE IS VERY LARGE. IF THE RUDDER MOVES WHEN PERSONNEL ARE NEAR IT, IT CAN CAUSE INJURIES TO THEM.

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-33-31

Page 401
Sep 15/2021



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

(WARNING PRECEDES)



WARNING

KEEP PERSONNEL AWAY FROM THE AREA BELOW THE VERTICAL STABILIZER. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR IF EQUIPMENT OR PARTS FALL.

- (1) Remove the fasteners from the applicable vertical fin trailing edge access panels.
NOTE: A leverage access panel adapter, SPL-1558 can help remove the fasteners.

SUBTASK 55-33-31-010-002

- (2) Remove the applicable trailing edge panels:

<u>Number</u>	<u>Name/Location</u>
324AL	Vertical Fin, Aft Fin Access Door
324AR	Vertical Fin, Aft Fin Access Door
324BL	Vertical Fin, Trailing Edge Access
324BR	Vertical Fin, Trailing Edge Access
324DL	Trailing Edge Access
324DR	Vertical Fin, Trailing Edge Access
324JL	Vertical Fin, Access

————— **END OF TASK** —————

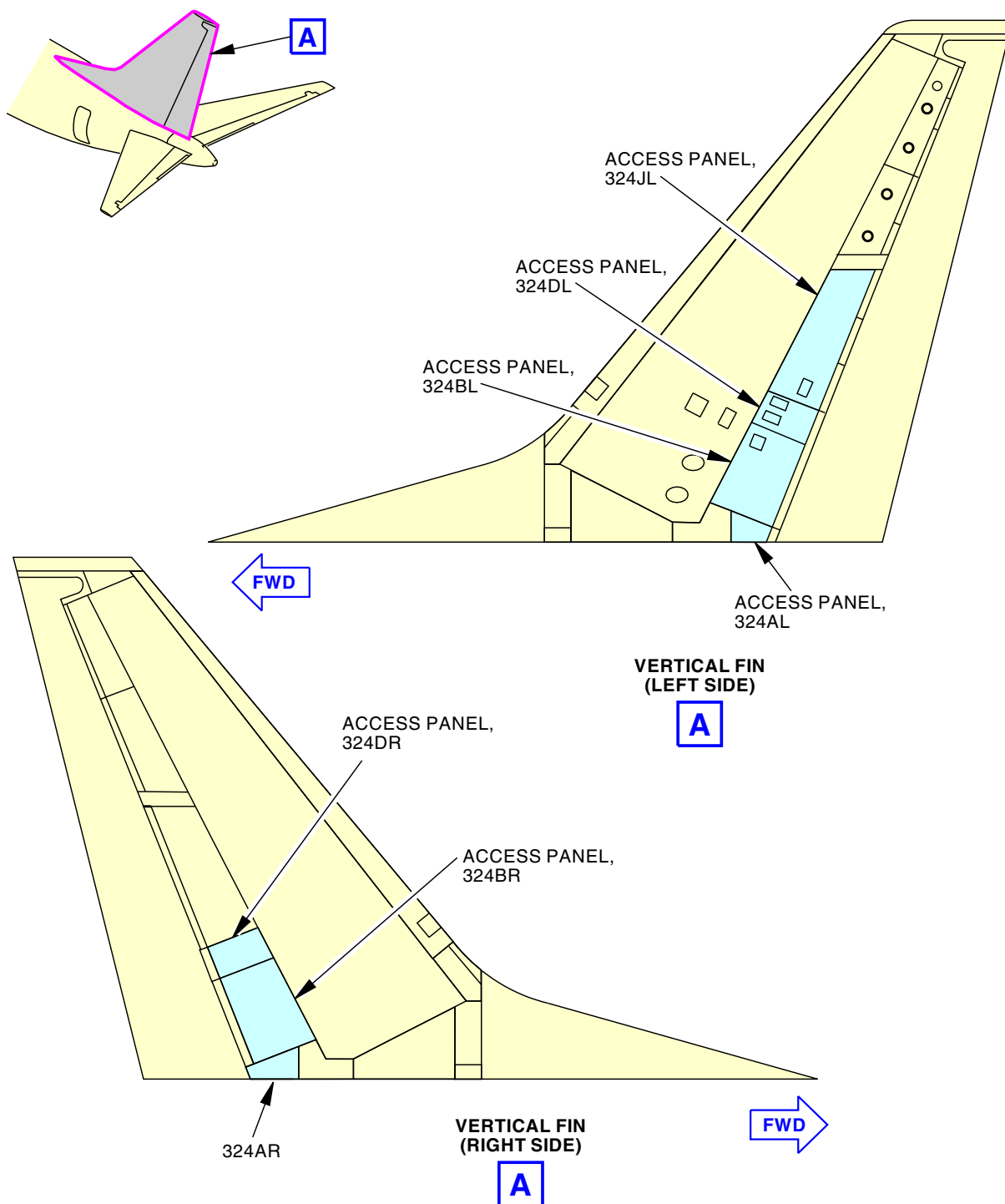
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-33-31

Page 402
Sep 15/2021



2416412 S00061540595_V1

Vertical Stabilizer (Fin) Trailing Edge Panels Installation
Figure 401/55-33-31-990-801

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-33-31

Page 403
Sep 15/2021



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

TASK 55-33-31-400-801

3. Vertical Stabilizer (Fin) Trailing Edge Panels Installation

A. General

(1) This task gives the instructions to install the stabilizer (fin) trailing edge panels.

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

C. Location Zones

Zone	Area
324	Vertical Fin - Rear Spar To Trailing Edge

D. Access Panels

Number	Name/Location
324AL	Vertical Fin, Aft Fin Access Door
324AR	Vertical Fin, Aft Fin Access Door
324BL	Vertical Fin, Trailing Edge Access
324BR	Vertical Fin, Trailing Edge Access
324DL	Trailing Edge Access
324DR	Vertical Fin, Trailing Edge Access
324JL	Vertical Fin, Access

E. Vertical Stabilizer (Fin) Trailing Edge Panels Installation

SUBTASK 55-33-31-400-001



WARNING

PREVENT THE OPERATION OF THE RUDDER WHEN YOU DO WORK ON IT OR NEAR IT. THE RUDDER MOVES QUICKLY AND ITS FORCE IS VERY LARGE. IF THE RUDDER MOVES WHEN PERSONNEL ARE NEAR IT, IT CAN CAUSE INJURIES TO THEM.



WARNING

KEEP PERSONNEL AWAY FROM THE AREA BELOW THE VERTICAL STABILIZER. INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR IF EQUIPMENT OR PARTS FALL.

(1) Install the applicable trailing edge panels:

<u>Number</u>	<u>Name/Location</u>
324AL	Vertical Fin, Aft Fin Access Door
324AR	Vertical Fin, Aft Fin Access Door
324BL	Vertical Fin, Trailing Edge Access
324BR	Vertical Fin, Trailing Edge Access
324DL	Trailing Edge Access
324DR	Vertical Fin, Trailing Edge Access
324JL	Vertical Fin, Access

SUBTASK 55-33-31-410-001

(2) Install the fasteners that attach the trailing edge panels.

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-33-31

Page 404
Sep 15/2021



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

SUBTASK 55-33-31-410-002

- (3) Fill gaps 0.040 in. (0.102 cm) and larger with aerodynamic sealant, A00247 and smooth flush with outer contour.

NOTE: Largest gap must be less than 0.15 in. (3.81 mm).

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-33-31

Page 405
Sep 15/2021



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

VERTICAL STABILIZER HF ANTENNA LEADING EDGE PANEL - REPAIRS

1. General

A. There are three tasks in this procedure:

- (1) Inspection of the HF Antenna Fiberglass Panel Leading Edge Panel No. 4.
- (2) Installation of the leading edge finish.
- (3) Installation of the Polyurethane Protective Tape (PPT).

TASK 55-35-01-200-801

2. HF Antenna Fiberglass Panel Leading Edge Panel No. 4 - Inspection

(Figure 801)

A. **Location Zones**

Zone	Area
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322	Vertical Fin - Removable Fin Leading Edge
-----	---

B. **Visually inspect the HF antenna fiberglass panel leading edge panel number 4.**

SUBTASK 55-35-01-211-002

- (1) Look for the conditions that follow.

NOTE: There must be no indication of exposed fiberglass.

- (a) Damaged structure.
- (b) Missing Caapcoat FP-200 erosion coating.
- (c) Missing BMS 10-21 Type II or Type IV anti-static coating.

SUBTASK 55-35-01-211-003

- (2) If there is no peeling of the erosion coating, do one of the steps that follow:

- (a) No more steps are necessary.
- (b) Install the Polyurethane Protective Tape (PPT) for added protection (TASK 55-35-01-400-802).

NOTE: Installing the PPT is not necessary but it can increase the durability and longevity of the HF antenna fiberglass panel leading edge panel installation.

SUBTASK 55-35-01-211-004

- (3) If there is peeling of the erosion coating or anti-static coating but no damage to the fiberglass composite structure, do one of the steps that follow:

- (a) Temporarily repair the area (TASK 55-35-01-400-802).
- (b) Repair the original finish by re-applying the finish (TASK 55-35-01-400-801).

———— **END OF TASK** ————

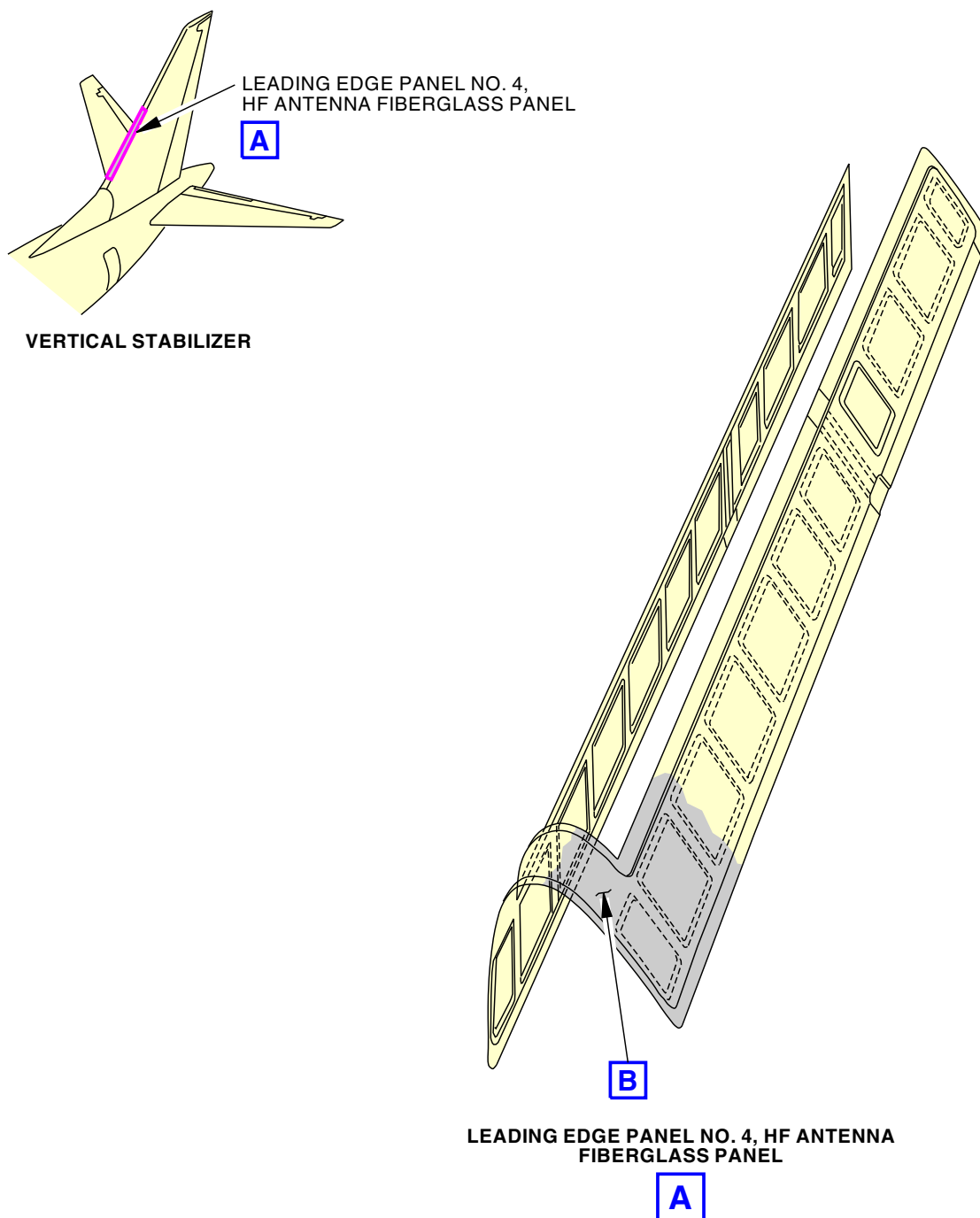
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55-35-01

Page 801
Sep 15/2021



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HF Antenna Fiberglass Panel Leading Edge Panel No. 4
Figure 801/55-35-01-990-801 (Sheet 1 of 2)

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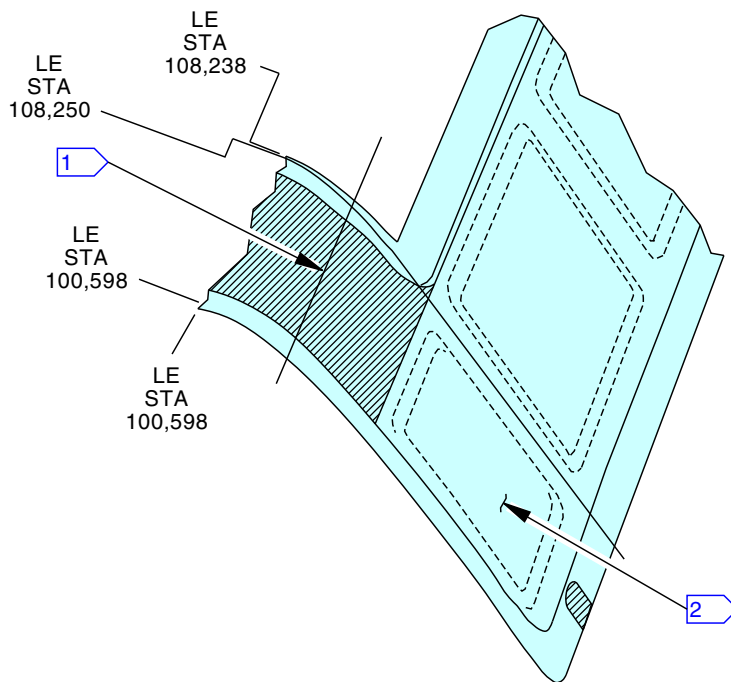
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-35-01

Page 802
Sep 15/2021

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



(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

B

1

APPLICATION SEQUENCE:

1. BMS 10-21 TYPE IV ANTI-STATIC COATING
2. BMS 10-103 TYPE I PRIMER
3. CAAPCOAT FP-200 RAIN EROSION COATING

2

APPLICATION SEQUENCE FOR REMAINDER OF FIBERGLASS PANEL:

1. BMS 10-21, TYPE IV ANTI-STATIC COATING
2. BMS 10-103, TYPE I PRIMER
3. BMS 10-60, TYPE II ENAMEL (SEE NOTE)
4. DECORATIVE PAINT-ONLY IF SPECIFIED ON LIVERY DRAWING (SEE NOTE)

NOTE:

WHEN REPAINTING, APPLY BMS 10-60, TYPE II ENAMEL AND EXTERIOR DECORATIVE PAINT TO COVER THE PRIMER. IT IS OPTIONAL TO OMIT THE BMS 10-60, TYPE II ENAMEL.

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HF Antenna Fiberglass Panel Leading Edge Panel No. 4
Figure 801/55-35-01-990-801 (Sheet 2 of 2)

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55-35-01



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

TASK 55-35-01-400-801

3. Leading Edge Finish - Installation

(Figure 801)

A. References

Reference	Title
51-21-11-150-801	Paint Stripping (P/B 701)
51-21-21-100-802	Cleaning and Preparation of Internal and External Plastic Surfaces (P/B 701)
51-21-71-370-803	Apply BMS 10-21 Type IV Conductive Coating To Specified External Surfaces (P/B 701)
51-21-99-300-801	Decorative Exterior Paint System Application (P/B 701)

B. Consumable Materials

Reference	Description	Specification
C00033	Coating - Protective Enamel, Flexibility Use	BMS10-60 Type II
C00766	Primer - Nonchromated Primer For Composites	BMS10-103 Type I
C50006	Coating - Gloss Polyurethane - Caapcoat FP-200	BAC5880 TYPE I CLASS 5
C50219	Coating - Anti-Static Coating	BMS10-21 Type IV
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)
G02428	Abrasive - Aluminum Oxide Paper, 150 grit	A-A-1048

C. Location Zones

Zone	Area
322	Vertical Fin - Removable Fin Leading Edge

D. Prepare to Re-apply the Leading Edge Primer

SUBTASK 55-35-01-150-001

- (1) Remove the remaining erosion coating, if necessary (TASK 51-21-11-150-801).

SUBTASK 55-35-01-160-001

- (2) Prepare the surface for the finish (TASK 51-21-21-100-802).

SUBTASK 55-35-01-160-002

- (3) Prepare the area for the primer.
 - (a) Clean the area.
 - (b) Abrade the side of the panel to be painted with 150 grit abrasive paper, G02428.
 - (c) Remove remaining material with a clean cotton wiper, G00034.

E. Re-apply the Leading Edge Primer

SUBTASK 55-35-01-300-001

- (1) If the anti-static coating is worn, apply coating, C50219, to the specified external surfaces (TASK 51-21-71-370-803).

SUBTASK 55-35-01-300-002

- (2) Apply primer, C00766.

EFFECTIVITY
SIA ALL

D633AM101-SIA

55-35-01

Page 804
Sep 15/2022



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

- (a) Spray the primer, C00766, in an equal coat to the tool side surface of the panel.

NOTE: The dry primer paint layer should be a continuous coat, free of runs, wrinkles and pinholes.

- (b) Make sure that the dry paint layer thickness is between 0.3 mil (0.0076 mm) and 0.8 mil (0.0203 mm).
- (c) Cure the panel for a minimum of 30 minutes at a minimum temperature of 65°F (18°C).

F. Prepare to Re-apply the Leading Edge Erosion Coating

SUBTASK 55-35-01-300-003

- (1) Make sure that there is a coat of primer, C00766, on the surface before you apply the Caapcoat FP-200 coating, C50006.

SUBTASK 55-35-01-950-001

- (2) Mask all areas adjacent to the area in which you will be working.

G. Re-apply the Leading Edge Erosion Coating

SUBTASK 55-35-01-800-001

- (1) Prepare and mix the Caapcoat FP-200 coating, C50006.

NOTE: Use a thinner, if necessary, to get the Zahn viscosity requirement (Table 801).

SUBTASK 55-35-01-300-004

- (2) Apply the Caapcoat FP-200 coating, C50006.
- (a) Spray the Caapcoat FP-200 coating, C50006, in an even coat.
- 1) Make sure that the dry paint film thickness for the first coat is a maximum of 1.500 mils (0.038 mm).
- 2) Make sure that the dry paint film thickness for the second coat (and additional coats) is a maximum of 2.000 mils (0.051 mm).
- 3) Make sure that the total dry film thickness is less between 10.000 mils (0.254 mm) and 14.000 mils (0.356 mm).
- (b) Between coats, make sure that there are no bubbles in the applied coating.
- 1) If there are bubbles, do one or both of the steps that follow.
- a) Decrease the thickness of the coat.
- b) Wait for a longer period of time between coat applications.
- (c) Cure the Caapcoat FP-200 coating, C50006 (Table 801).

Table 801/55-35-01-993-801

MATERIAL (MIN. RELATIVE HUMIDITY 30)	MIX RATION (PARTS BY VOLUME)	VISCOSITY, SECS ZAHN #2 *[2]	DRY FILM THICKNESS		CURE TIMES		
			PER COAT	TOTAL	TO RECOAT (Mins)	TO OVERCOAT (Hrs)	FINAL (Hrs)
FP-200 VEHICLE	64	22-28 AT 70°F (21°C) - 80°F (27°C)	MAXIMUM: 1ST: 1.500 mils (0.038 mm)	10 mils (0 mm) -	MIN: 20 MAX: 120	2 - 8	TO HANDLE: 36 *[1]
CURING AGENT	3		2ND AND ON: 2.000 mils (0.051 mm)	14 mils (0 mm)			
ACCELERATOR	4						

*[1] Cure can be made faster by 24 hours at room temperature followed by oven cure at 150°F (66°C) for 3 hours.

EFFECTIVITY
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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

55-35-01

Page 805
Sep 15/2021



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

*[2] Recommended viscosity.

SUBTASK 55-35-01-370-001

- (3) Re-apply the enamel coating, C00033, or decorative external paint as needed on the rest of the panel (TASK 51-21-99-300-801) (View B, Figure 801).
 - (a) Mask all areas adjacent to the area in which you will be working.
 - (b) Apply the enamel coating, C00033, or decorative exterior paint to cover the primer.

————— END OF TASK —————

TASK 55-35-01-400-802

4. Polyurethane Protective Tape (PPT) - Installation

(Figure 802)

A. Tools/Equipment

Reference	Description
STD-821	Squeegee - Plastic

B. Consumable Materials

Reference	Description	Specification
B00130	Alcohol - Isopropyl	TT-I-735
C00012	Coating - Akzo Nobel Clear Polyurethane Topcoat, 683-3-2 Base with X-310A Catalyst (Akzo Nobel Aerospace Coatings)	
C50006	Coating - Gloss Polyurethane - Caapcoat FP-200	BAC5880 TYPE I CLASS 5
C50238	Coating - Akzo Nobel Clear Polyurethane Topcoat, 683-3-20 Base with X-310A Catalyst (Akzo Nobel Aerospace Coatings)	
G50078	Abrasive - Aluminum Oxide Paper, 320 grit or finer	
G50632	Towel - Paper, Wypall X80 (Packaged in Brag-Box, 1¼ Fold, Pop-Up Box and Jumbo Rolls)	
G51114	Tape - 3M 8673 Polyurethane Protective Tape	

C. Location Zones

Zone	Area
322	Vertical Fin - Removable Fin Leading Edge

D. Prepare to Install the Polyurethane Protective Tape (PPT)

SUBTASK 55-35-01-010-001

- (1) If you are installing the 3M 8673 tape, G51114 or equivalent as a temporary repair, do the steps that follow:
 - (a) If the Caapcoat FP-200 coating, C50006 is damaged, remove as much of the Caapcoat FP-200 coating, C50006 as possible without damaging the fiberglass window of the HF antenna.
 - 1) The preferred method for removal is to peel off the Caapcoat FP-200 coating, C50006.
 - 2) If you cannot peel off the Caapcoat FP-200 coating, C50006, trim the loose material.

EFFECTIVITY
SIA ALL

D633AM101-SIA

55-35-01

Page 806
Sep 15/2021



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

- a) Make sure that you do not damage the fiberglass window.
- (b) Carefully sand the surface of the HF antenna with 320 grit or finer abrasive paper, G50078 until it is smooth.
- (c) Clean the surface of the HF antenna with a Wypall X80 Paper Towel, G50632 or equivalent saturated with alcohol, B00130.

E. Install the Polyurethane Protective Tape (PPT)

SUBTASK 55-35-01-800-002

- (1) Cut the 3M 8673 tape, G51114 or equivalent to a dimension that overlaps the surface adjacent to the not damaged surface.
 - (a) The overlap should be 2 in. (51 mm).
 - (b) If you are applying the 3M 8673 tape, G51114 or equivalent over the entire fiberglass HF leading edge, the overlap can extend to a maximum of 2 in. (51 mm) onto the metal leading edge.

SUBTASK 55-35-01-400-001

- (2) Remove the plastic lining from the 3M 8673 tape, G51114 or equivalent.

SUBTASK 55-35-01-400-002

- (3) Install the 3M 8673 tape, G51114 or equivalent to the area to cover.
 - (a) Install the 3M 8673 tape, G51114 or equivalent to dry.
 - (b) Put one end of the 3M 8673 tape, G51114 or equivalent onto the surface. Use a plastic squeegee, STD-821 to make sure that there is no air between the tape and the HF leading edge while you apply the tape.

SUBTASK 55-35-01-400-003

- (4) Apply Akzo Nobel 683-3-2 coating, C00012 or Akzo Nobel 683-3-20 coating, C50238 to edge seal the edges of the 3M 8673 tape, G51114 or equivalent.

NOTE: This is to increase durability and longevity of the 3M 8673 tape, G51114 or equivalent. It is optional to edge seal the tape.

- (a) Refer to manufacturers instructions for cure times and temperatures for the edge seal coatings.

SUBTASK 55-35-01-230-001

- (5) Make sure that the edge seal cures.
 - (a) Rub your fingernail perpendicular to the edge seal.

SUBTASK 55-35-01-800-003

- (6) If you do not edge seal the 3M 8673 tape, G51114 or equivalent, wait 2 hours at 70°F (21°C) for the patch to cure.

———— **END OF TASK** ————

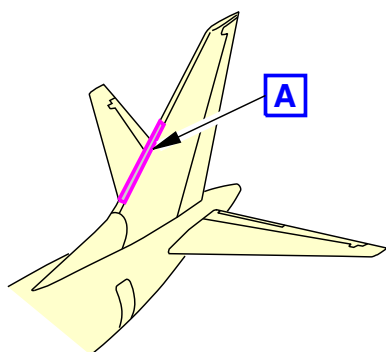
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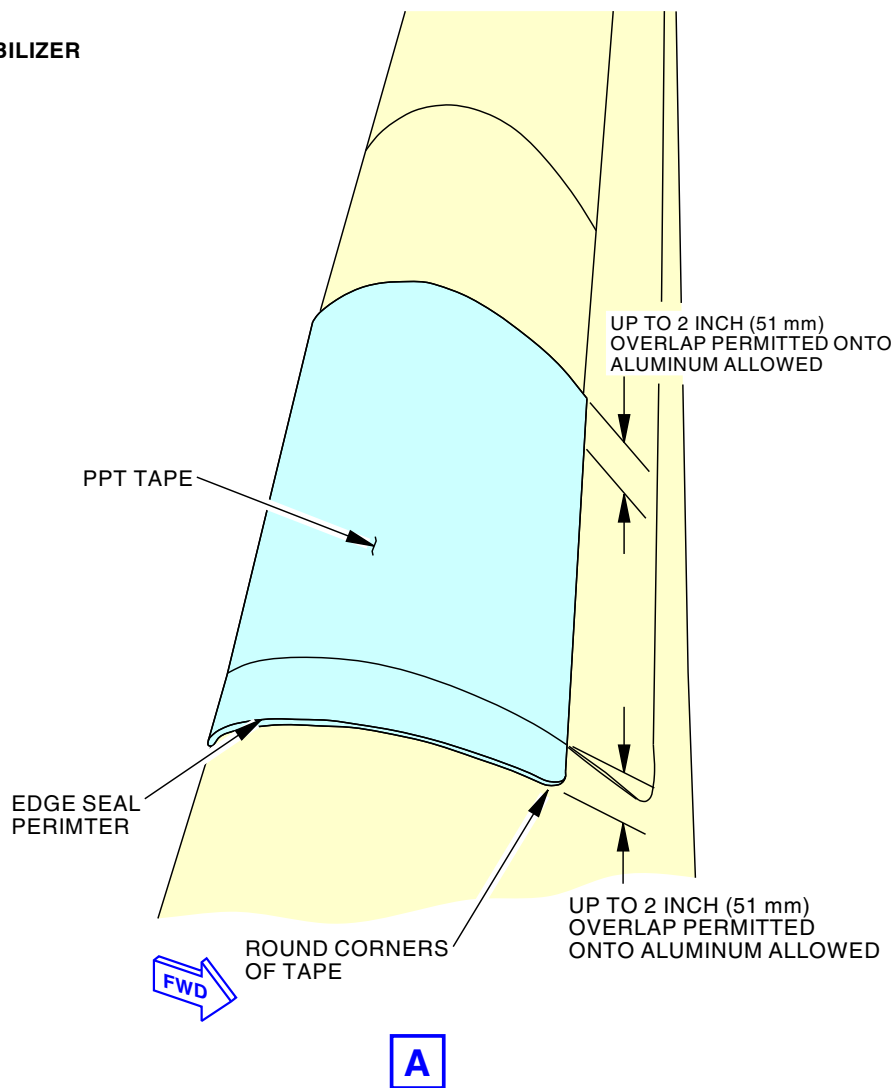
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55-35-01

Page 807
Sep 15/2021



VERTICAL STABILIZER



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Polyurethane Protective Tape (PPT) - Installation
Figure 802/55-35-01-990-802

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55-35-01