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**STABILIZERS**





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298.4	Feb 15/2024		298.40	Feb 15/2024		221	Jun 15/2024	
298.5	Feb 15/2024		298.41	Feb 15/2024		222	Jun 15/2024	
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298.11	Feb 15/2024		298.47	Feb 15/2024		228	Feb 15/2024	
298.12	Feb 15/2024		298.48	Feb 15/2024		229	Feb 15/2024	
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298.23	Feb 15/2024		204	Jun 15/2018		240	Feb 15/2024	
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247	Feb 15/2024		283	Jun 15/2024		298.21	Feb 15/2024	
248	Jun 15/2024		284	Feb 15/2024		298.22	Feb 15/2024	
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266	Feb 15/2024		298.4	Feb 15/2024		205	Feb 15/2023	
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268	Jun 15/2024		298.6	Feb 15/2024		55-10-00		
269	Feb 15/2024		298.7	Feb 15/2024		401	Oct 15/2023	
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271	Oct 15/2024		298.9	Feb 15/2024		403	Jun 15/2020	
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201	Oct 15/2018		404	Feb 15/2021		803	Oct 15/2024	
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405	Jun 15/2024		411	Oct 15/2023		810	Oct 15/2024	
406	Feb 15/2020		412	Oct 15/2023		811	Oct 15/2023	
407	Feb 15/2020		413	Oct 15/2024		812	Oct 15/2024	
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411	Feb 15/2020		55-33-11					
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RUDDER AND HORIZONTAL STABILIZERS - INSPECTION/CHECK

**1. General**

- A. This procedure has one task. The task gives instructions to do a visual inspection of the internal area of the rudder and the horizontal stabilizers.

**TASK 55-00-01-200-801**

**2. Examine the Composite Flight Controls**

**A. General**

- (1) 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 Fiberoptic 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 can not 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.

SUBTASK 55-00-01-410-001

- (6) Install the access panels.

— END OF TASK —

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LOM ALL

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STABILIZER - FATIGUE INSPECTIONS - MAINTENANCE PRACTICES

**TASK 55-05-02-130-801**

**1. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION REAR SPAR  
UPPER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

**B. Access Panels**

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

**C. Prepare for the inspection**

SUBTASK 55-05-02-860-005

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-02-860-006

- (2) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

**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

**D. Inspection**

SUBTASK 55-05-02-010-001

- (1) Open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

NOTE: Access horizontal stabilizer center section through opening in center of 1088 bulkhead.

SUBTASK 55-05-02-130-001

- (2) Do an Ultrasonic inspection of the spar chord between the web and shear tie at BL 1.3 on the left and right hand sides.

See Doc. D626A001 - DTR, DTR check form 55-10-01-1, alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-06.

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LOM ALL

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SUBTASK 55-05-02-410-001

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**E. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-05-02-860-007

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

**CAPT Electrical System Panel, P18-1**

**Row    Col    Number    Name**

C      2      C00849      AFCS STABILIZER TRIM

**F/O Electrical System Panel, P6-2**

**Row    Col    Number    Name**

B      10     C00207     FLIGHT CONTROL STAB TRIM CONT

D      10     C00840     FLIGHT CONTROL STAB TRIM ACTUATOR

SUBTASK 55-05-02-860-008

- (2) Set the stabilizer leading edge to the NORMAL position.

————— END OF TASK ————

**TASK 55-05-02-250-801**

**2. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION REAR SPAR  
UPPER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

**Zone      Area**

313      Stabilizer Torsion Box Compartment - Left

314      Stabilizer Torsion Box Compartment - Right

**B. Access Panels**

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**C. Prepare for the inspection**

SUBTASK 55-05-02-860-037

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-02-860-038

- (2) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-1**

**Row    Col    Number    Name**

C      2      C00849      AFCS STABILIZER TRIM

**F/O Electrical System Panel, P6-2**

**Row    Col    Number    Name**

B      10     C00207     FLIGHT CONTROL STAB TRIM CONT

D      10     C00840     FLIGHT CONTROL STAB TRIM ACTUATOR

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**D. Inspection**

SUBTASK 55-05-02-010-018

- (1) Open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**NOTE:** Access horizontal stabilizer center section through opening in center of 1088 bulkhead.

SUBTASK 55-05-02-250-001

- (2) Do a High Frequency Eddy Current inspection of the upper chord and around the fasteners common to the web at BL 2.7 to BL 6.7 on the left and right hand sides.

See Doc. D626A001 - DTR, DTR check form 55-10-01-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-16.

SUBTASK 55-05-02-410-018

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**E. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-05-02-860-039

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

**CAPT Electrical System Panel, P18-1**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
C	2	C00849	AFCS STABILIZER TRIM

**F/O Electrical System Panel, P6-2**

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

SUBTASK 55-05-02-860-040

- (2) Set the stabilizer leading edge to the NORMAL position.

———— END OF TASK ————

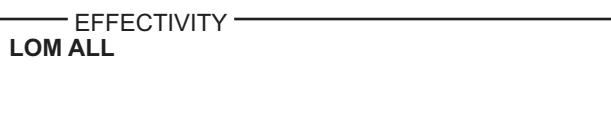
**TASK 55-05-02-250-802**

**3. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION REAR SPAR  
UPPER CHORD**

**NOTE:** This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right



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**B. Access Panels**

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

**C. Prepare for the inspection**

SUBTASK 55-05-02-860-041

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-02-860-042

- (2) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

**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

**D. Inspection**

SUBTASK 55-05-02-010-019

- (1) Open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

NOTE: Removal of fasteners from both LBL and RBL 8.1 to 19.7 is required. Access horizontal stabilizer center section through opening in center of 1088 bulkhead.

SUBTASK 55-05-02-250-002

- (2) Do a High Frequency Eddy Current inspection of the rear spar upper chord from BL 8.1 to BL 19.7 on the left and right sides.

See Doc. D626A001 - DTR, DTR check form 55-10-01-3, for alternative inspection.

The NDT method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-22.

SUBTASK 55-05-02-410-019

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**E. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-05-02-860-043

- (1) 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>
C	2	C00849	AFCS STABILIZER TRIM



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**F/O Electrical System Panel, P6-2**

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

SUBTASK 55-05-02-860-044

- (2) Set the stabilizer leading edge to the NORMAL position.

————— END OF TASK ————

**TASK 55-05-02-130-802**

**4. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION REAR SPAR  
UPPER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

**B. Access Panels**

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

**C. Prepare for the inspection**

SUBTASK 55-05-02-860-001

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-02-860-002

- (2) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

**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

**D. Inspection**

SUBTASK 55-05-02-010-002

- (1) Open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

NOTE: Access horizontal stabilizer center section through opening in center of 1088 bulkhead.

SUBTASK 55-05-02-130-002

- (2) Do an Ultrasonic inspection of the rear spar forward flange at the four Texas Star attachment points.

See Doc. D626A001 - DTR, DTR check form 55-10-01-4, for alternative inspection.

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The NDT method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-07.

SUBTASK 55-05-02-410-002

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**E. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-05-02-860-003

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

**CAPT Electrical System Panel, P18-1**

**Row    Col    Number    Name**

C        2        C00849      AFCS STABILIZER TRIM

**F/O Electrical System Panel, P6-2**

**Row    Col    Number    Name**

B        10       C00207      FLIGHT CONTROL STAB TRIM CONT

D        10       C00840      FLIGHT CONTROL STAB TRIM ACTUATOR

SUBTASK 55-05-02-860-004

- (2) Set the stabilizer leading edge to the NORMAL position.

———— END OF TASK ————

**TASK 55-05-02-250-803**

**5. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR UPPER CHORD, AFT FLANGE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**B. Inspection**

SUBTASK 55-05-02-250-003

- (1) Do a Low Frequency Eddy Current inspection of the front spar upper chord aft flange from stabilizer STA 66.5 to outboard tip.

See Doc. D626A001 - DTR, DTR check form 55-10-06-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-32.

———— END OF TASK ————



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**TASK 55-05-02-250-804**

**6. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD AT SIDE-OF-BODY**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**B. Inspection**

SUBTASK 55-05-02-250-004

- (1) Do a High Frequency Eddy Current inspection of the rear spar upper chord between the terminal fitting fork.

NOTE: Inspection is applicable to the outboard three bolt locations common to the chord and terminal fitting.

See Doc. D626A001-DTR, DTR check form 55-10-04-10B, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-27.

———— END OF TASK ————

**TASK 55-05-02-250-805**

**7. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR LOWER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

Reference	Title
55-10-11-000-801	Balance Bay Panels Removal (P/B 401)
55-10-11-400-801	Balance Bay Panels Installation (P/B 401)

**B. Location Zones**

Zone	Area
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**C. Access Panels**

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



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**D. Inspection**

**SUBTASK 55-05-02-010-068**

- (1) To remove the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Removal, TASK 55-10-11-000-801.

Open these access panels on the Left side:

<b>Number</b>	<b>Name/Location</b>
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge

Open these access panels on the Right side:

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

NOTE: Inspection requires removal of the Trailing Edge (TE) panel and fasteners. The TE panels are attached by nutplates.

**SUBTASK 55-05-02-250-005**

- (2) Do a High Frequency Eddy Current inspection of the rear spar lower chord AFT flange, at and between the ribs, from stabilizer STA 212.3 to stabilizer STA 310.54.

See Doc. D626A001 - DTR, DTR check form 55-10-04-3 for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-81.

**SUBTASK 55-05-02-410-066**

- (3) To install the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Installation, TASK 55-10-11-400-801.

Close these access panels on the Left side:

<b>Number</b>	<b>Name/Location</b>
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge

Close these access panels on the Right side:

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

**END OF TASK**

**TASK 55-05-02-250-806**

**8. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR LOWER CHORD**

NOTE: This procedure is a scheduled maintenance task.



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**A. Location Zones**

Zone	Area
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**B. Inspection**

SUBTASK 55-05-02-250-006

- (1) Do a High Frequency Eddy Current inspection of the visible portion of the lower chord between stabilizer STA 129.5 and stabilizer STA 212.3.

See Doc. D626A001 - DTR, DTR check form 55-10-04-1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-71.

————— END OF TASK ————

**TASK 55-05-02-130-803**

**9. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR LOWER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

Reference	Title
55-10-11-000-801	Balance Bay Panels Removal (P/B 401)
55-10-11-400-801	Balance Bay Panels Installation (P/B 401)

**B. Location Zones**

Zone	Area
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**C. Access Panels**

Number	Name/Location
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
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. Inspection**

SUBTASK 55-05-02-010-070

- (1) To remove the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Removal, TASK 55-10-11-000-801.

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Open these access panels on the Left side:

<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

Open these access panels on the Right side:

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

**SUBTASK 55-05-02-130-003**

- (2) Do an Ultrasonic inspection of the rear spar lower chord web flange at the Trailing Edge (TE) ribs and stiffeners from stabilizer STA 212.3 to stabilizer STA 310.54.

See Doc. D626A001 - DTR, DTR check form 55-10-04-4, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-18.

**SUBTASK 55-05-02-410-068**

- (3) To install the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Installation, TASK 55-10-11-400-801.

Close these access panels on the Left side:

<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

Close these access panels on the Right side:

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

————— END OF TASK ————

**TASK 55-05-02-250-807**

**10. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR LOWER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

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**B. Inspection**

SUBTASK 55-05-02-250-007

- (1) Do a Low Frequency Eddy Current inspection of both fastener rows in the FWD flange at, and between, the ribs at stabilizer STA 212.3 to stabilizer STA 310.54.

See Doc. D626A001 - DTR, DTR check form 55-10-04-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-74.

————— END OF TASK ————

**TASK 55-05-02-130-804**

**11. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION PIVOT FITTING**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

**B. Access Panels**

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

**C. Prepare for the inspection**

SUBTASK 55-05-02-860-009

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-02-860-010

- (2) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

**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

**D. Inspection**

SUBTASK 55-05-02-010-072

- (1) Open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

NOTE: Access horizontal stabilizer center section through opening in center of 1088 bulkhead.

SUBTASK 55-05-02-130-004

- (2) Do an Ultrasonic inspection of the pivot fittings on the horizontal stabilizer center section hinge house pivot lug.

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See Doc. D626A001 - DTR, DTR check form 55-10-02-1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-27.

SUBTASK 55-05-02-410-070

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**E. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-05-02-860-011

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

**CAPT Electrical System Panel, P18-1**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
C	2	C00849	AFCS STABILIZER TRIM

**F/O Electrical System Panel, P6-2**

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

SUBTASK 55-05-02-860-012

- (2) Set the stabilizer leading edge to the NORMAL position.

———— END OF TASK ————

**TASK 55-05-02-250-808**

**12. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR UPPER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**B. Inspection**

SUBTASK 55-05-02-250-008

- (1) Do a Low Frequency Eddy Current inspection of the front spar upper chord from the side of body to stabilizer STA 66.5.

See Doc. D626A001 - DTR, DTR check form 55-10-06-1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-28.

———— END OF TASK ————

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**TASK 55-05-02-250-809**

**13. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER UPPER INSPAR SKIN**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**B. Inspection**

SUBTASK 55-05-02-250-009

- (1) Do a High Frequency Eddy Current inspection around all fastener locations in the upper inspar skin between the SOB rib and the rib at stabilizer STA. 157.1.  
See Doc. D626A001 - DTR, DTR check form 55-10-09-1, alternative inspection.  
The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-72.

— END OF TASK —

**TASK 55-05-02-250-810**

**14. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD TERMINAL FITTING (L3)**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

Reference	Title
SRM 51-10-01	Structural Repair Manual

**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 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**D. Access Panels**

Number	Name/Location
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332EB	Horizontal Stabilizer, Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342EB	Horizontal Stabilizer, Access Door



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<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

**E. Inspection**

SUBTASK 55-05-02-010-149

- (1) Open these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332EB	Horizontal Stabilizer, Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

Open these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342EB	Horizontal Stabilizer, Access Door
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

NOTE: Removal of the tension bolt is required.

SUBTASK 55-05-02-250-010

- (2) Do a High Frequency Eddy Current inspection of the rear spar upper chord terminal fitting at the Side of Body (SOB) rib tension bolt hole.

See Doc. D626A001 - DTR, DTR check form 55-10-05-4, for alternative repeat inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-49.

SUBTASK 55-05-02-410-156

- (3) Close this access panel on the Left Side:

<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 track channel.

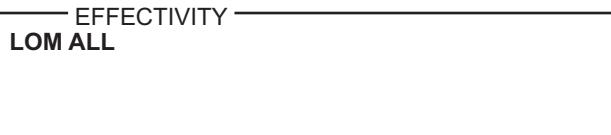
- (4) Close this access panel on the Right side:

<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 track channel.

- (5) Close these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332EB	Horizontal Stabilizer, Access Door



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<u>Number</u>	<u>Name/Location</u>
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

Close these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342EB	Horizontal Stabilizer, Access Door
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

SUBTASK 55-05-02-390-001

- (6) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-811**

**15. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR UPPER CHORD  
(DIRECTION 1)**

**A. Inspection**

SUBTASK 55-05-02-250-011

- (1) Do the inspection.

———— END OF TASK ————

**TASK 55-05-02-250-812**

**16. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD  
TERMINAL FITTING**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**D. Access Panels**

<u>Number</u>	<u>Name/Location</u>
332EB	Horizontal Stabilizer, Access Door
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

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<u>Number</u>	<u>Name/Location</u>
342EB	Horizontal Stabilizer, Access Door
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

**E. Inspection**

SUBTASK 55-05-02-010-073

- (1) Open these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
332EB	Horizontal Stabilizer, Access Door
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

Open these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
342EB	Horizontal Stabilizer, Access Door
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

NOTE: The aft side is accessed from the trailing edge. The forward side is accessed through the access panel in the inspar lower skin. Sealant, if present, must be removed for inspection.

SUBTASK 55-05-02-250-012

- (2) Do a High Frequency Eddy Current inspection of the forward and aft sides of the terminal fitting around the three inboard fasteners common to the spar chord.

See Doc. D626A001 - DTR, DTR check form 55-10-05-2A, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-18.

NOTE: Bolts and bushings should remain installed for the inspection. Remove any sealant present.

SUBTASK 55-05-02-410-071

- (3) Close these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
332EB	Horizontal Stabilizer, Access Door
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

Close these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
342EB	Horizontal Stabilizer, Access Door
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

SUBTASK 55-05-02-390-002

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

— END OF TASK —

**TASK 55-05-02-230-801**

**17. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR TERMINAL FITTING**

NOTE: This procedure is a scheduled maintenance task.

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**A. References**

<b>Reference</b>	<b>Title</b>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332EB	Horizontal Stabilizer, Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342EB	Horizontal Stabilizer, Access Door
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

**E. Inspection**

SUBTASK 55-05-02-010-030

- (1) Open these access panels on the Left side:

<b>Number</b>	<b>Name/Location</b>
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332EB	Horizontal Stabilizer, Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342EB	Horizontal Stabilizer, Access Door
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

NOTE: The removal of pins is necessary.



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SUBTASK 55-05-02-230-001

- (2) Do a penetrant inspection of the upper, lower and fail-safe pins at the side of the body on the horizontal-stabilizer rear-spar terminal-fitting for both the left and right sides.

See Doc. D626A001 - DTR, DTR check form 55-10-05-3, for alternative inspection.

SUBTASK 55-05-02-410-157

- (3) Close this access panel on the Left side:

**Number      Name/Location**

333AB      Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

(a) Make sure that the blade seal is installed correctly into the forward track channel.

- (4) Close this access panel on the Right side:

**Number      Name/Location**

343AB      Horizontal Stabilizer, Gap Cover - H. Stab. to Body

(a) Make sure that the blade seal is installed correctly into the forward track channel.

SUBTASK 55-05-02-410-028

- (5) Close these access panels on the Left side:

**Number      Name/Location**

332AB      Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

332EB      Horizontal Stabilizer, Access Door

333AT      Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

333BB      Horizontal Stabilizer, Access Panel, Trailing Edge

Close these access panels on the Right side:

**Number      Name/Location**

342AB      Horizontal Stabilizer, Gap Cover - H. Stab. to Body

342EB      Horizontal Stabilizer, Access Door

343AT      Horizontal Stabilizer, Gap Cover - H. Stab. to Body

343BB      Horizontal Stabilizer, Access Panel - T.E. Area

SUBTASK 55-05-02-390-031

- (6) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-813**

**18. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR LOWER CHORD**

**A. Inspection**

SUBTASK 55-05-02-250-013

- (1) Do the inspection.

———— END OF TASK ————

**TASK 55-05-02-250-815**

**19. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR LOWER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

**Zone      Area**

332      Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

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Zone	Area
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**B. Inspection**

SUBTASK 55-05-02-250-015

- (1) Do a Low Frequency Eddy Current inspection of the rear spar lower chord aft flange, at and between the ribs, from stabilizer STA 310.54 to outboard tip.

See Doc. D626A001 - DTR, DTR check form 55-10-04-7, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-55.

———— END OF TASK ————

**TASK 55-05-02-211-803**

**20. EXTERNAL - DETAILED: HORIZONTAL STABILIZER FRONT SPAR UPPER CHORD**

Figure 201

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**B. Inspection**

SUBTASK 55-05-02-211-003

- (1) Do a Detailed inspection of the exposed surface of the front spar upper chord between the upper skin and Leading Edge (LE) skin.

See Doc. D626A001 - DTR, DTR check form 55-10-07-2, for alternative inspection.

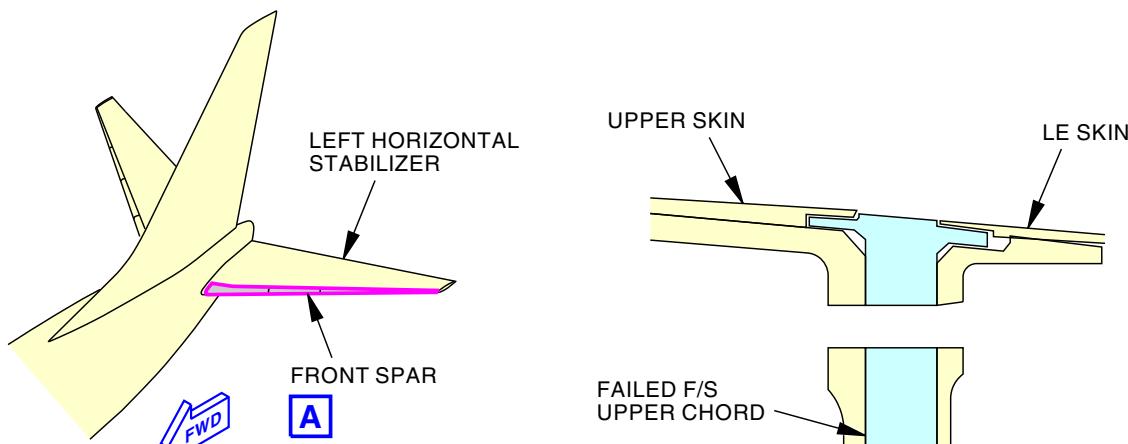
———— END OF TASK ————



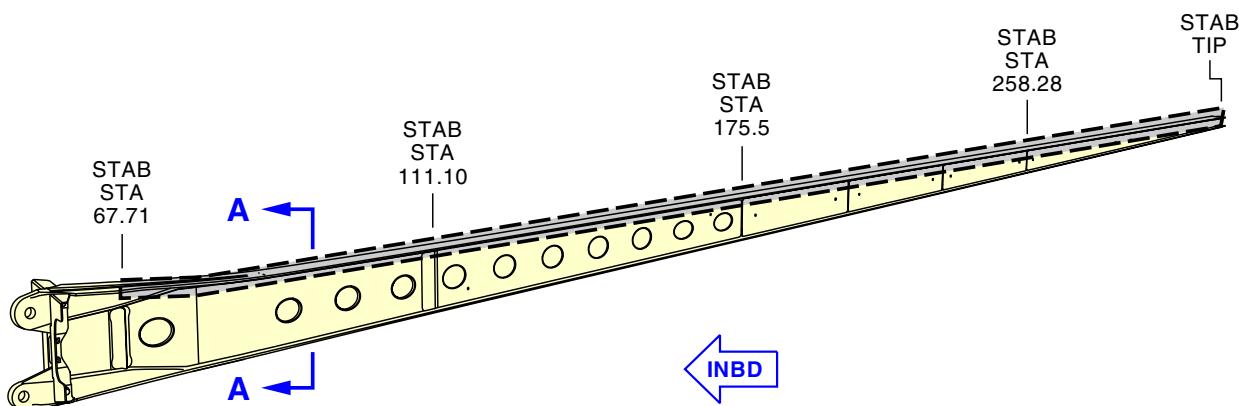
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FRONT SPAR UPPER CHORD  
**A-A**



FRONT SPAR OF THE HORIZONTAL STABILIZER  
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

**A**

3037056 S0000806153\_V1

Horizontal Stabilizer Front Spar - Upper Chord  
Figure 201/55-05-02-990-802

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



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**TASK 55-05-02-230-802**

**21. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR TERMINAL FITTING**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<u>Zone</u>	<u>Area</u>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**D. Access Panels**

<u>Number</u>	<u>Name/Location</u>
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342AT	Gap Cover, Horizontal Stabilizer

**E. Inspection**

**SUBTASK 55-05-02-010-017**

- (1) Open these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

Open these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342AT	Gap Cover, Horizontal Stabilizer

NOTE: Removal of upper and lower spar bolts is required.

**SUBTASK 55-05-02-230-002**

- (2) Do a Dye Penetrant inspection of the upper and lower Side of Body (SOB) spar bolts on the horizontal stabilizer front spar terminal fitting.

See Doc. D626A001 - DTR, DTR check form 55-10-07-3, for alternative inspection.

**SUBTASK 55-05-02-410-017**

- (3) Close these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

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Close these access panels on the Right side:

**Number      Name/Location**

- |       |   |
|-------|---|
| 342AB | Horizontal Stabilizer, Gap Cover - H. Stab. to Body |
| 342AT | Gap Cover, Horizontal Stabilizer                    |

SUBTASK 55-05-02-390-003

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-816**

**22. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER ELEVATOR HINGE RIBS**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

Reference	Title
SRM 51-10-01	Structural Repair Manual

**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
334	Left Horizontal Stabilizer - Elevator
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge
344	Right Horizontal Stabilizer - Elevator

**D. Access Panels**

Number	Name/Location
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
334JB	Horizontal Stabilizer, Elevator Hinge Cover
334KB	Horizontal Stabilizer, Elevator Hinge Cover
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
344JB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 121.59
344KB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 176.64

**E. Inspection**

SUBTASK 55-05-02-010-024

- (1) Open these access panels on the Left side:

**Number      Name/Location**

- |       |  |
|-------|--|
| 333CB | Horizontal Stabilizer, Access Panel, Trailing Edge |
| 333DB | Horizontal Stabilizer, Access Panel, Trailing Edge |
| 333EB | Horizontal Stabilizer, Access Panel, Trailing Edge |

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<u>Number</u>	<u>Name/Location</u>
334JB	Horizontal Stabilizer, Elevator Hinge Cover
334KB	Horizontal Stabilizer, Elevator Hinge Cover

Open these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
344JB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 121.59
344KB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 176.64

NOTE: Removal of hinge plate from assembly is required prior to inspection. The spherical bearing should not be removed.

SUBTASK 55-05-02-250-016

- (2) Do a High Frequency Eddy Current inspection of all holes on the hinge plate, around the bore, at elevator STA 121 and STA 176.

See Doc. D626A001 - DTR, DTR check form 55-10-08-1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-35.

SUBTASK 55-05-02-010-025

- (3) Close these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
334JB	Horizontal Stabilizer, Elevator Hinge Cover
334KB	Horizontal Stabilizer, Elevator Hinge Cover

Close these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
344JB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 121.59
344KB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 176.64

SUBTASK 55-05-02-390-004

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-817**

**23. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER ELEVATOR HINGE RIBS**

NOTE: This procedure is a scheduled maintenance task.

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**A. References**

<b>Reference</b>	<b>Title</b>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
334	Left Horizontal Stabilizer - Elevator
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge
344	Right Horizontal Stabilizer - Elevator

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334LB	Horizontal Stabilizer, Elevator Hinge Cover
334MB	Horizontal Stabilizer, Elevator Hinge Cover
334MT	Horizontal Stabilizer, Elevator Hinge Cover
334NB	Horizontal Stabilizer, Elevator Hinge Cover
334NT	Horizontal Stabilizer, Elevator Hinge Cover
343FB	Horizontal Stabilizer, Access Panel - T.E. Area
344LB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 213.32
344MB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 250.04
344MT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 250.04
344NB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45
344NT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

**E. Inspection**

SUBTASK 55-05-02-010-026

- (1) Open these access panels on the Left side:

<b>Number</b>	<b>Name/Location</b>
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334LB	Horizontal Stabilizer, Elevator Hinge Cover
334MB	Horizontal Stabilizer, Elevator Hinge Cover
334MT	Horizontal Stabilizer, Elevator Hinge Cover
334NB	Horizontal Stabilizer, Elevator Hinge Cover
334NT	Horizontal Stabilizer, Elevator Hinge Cover

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
343FB	Horizontal Stabilizer, Access Panel - T.E. Area
344LB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 213.32
344MB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 250.04
344MT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 250.04
344NB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45



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Number    Name/Location

344NT      Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

NOTE: Removal of hinge plate from assembly is required prior to inspection. The spherical bearing should not be removed.

SUBTASK 55-05-02-250-017

- (2) Do a High Frequency Eddy Current inspection of all of the holes on the hinge plate, around the bore, at elevator STA 213 and STA 250.

See Doc. D626A001 - DTR, DTR check form 55-10-08-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-35.

SUBTASK 55-05-02-410-024

- (3) Close these access panels on the Left side:

Number    Name/Location

333FB      Horizontal Stabilizer, Access Panel, Trailing Edge

334LB      Horizontal Stabilizer, Elevator Hinge Cover

334MB      Horizontal Stabilizer, Elevator Hinge Cover

334MT      Horizontal Stabilizer, Elevator Hinge Cover

334NB      Horizontal Stabilizer, Elevator Hinge Cover

334NT      Horizontal Stabilizer, Elevator Hinge Cover

Close these access panels on the Right side:

Number    Name/Location

343FB      Horizontal Stabilizer, Access Panel - T.E. Area

344LB      Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 213.32

344MB      Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 250.04

344MT      Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 250.04

344NB      Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

344NT      Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

SUBTASK 55-05-02-390-005

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-818**

**24. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER TRAILING EDGE HINGE PLATE  
LOWER FORWARD LUG**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

Reference	Title
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

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**C. Location Zones**

<b>Zone</b>	<b>Area</b>
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
334	Left Horizontal Stabilizer - Elevator
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge
344	Right Horizontal Stabilizer - Elevator

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
334NB	Horizontal Stabilizer, Elevator Hinge Cover
334NT	Horizontal Stabilizer, Elevator Hinge Cover
344NB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45
344NT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

**E. Inspection**

SUBTASK 55-05-02-010-027

- (1) Open these access panels on the Left side:

<b>Number</b>	<b>Name/Location</b>
334NB	Horizontal Stabilizer, Elevator Hinge Cover
334NT	Horizontal Stabilizer, Elevator Hinge Cover

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
344NB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45
344NT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

NOTE: Removal of hinge plate is required. The spherical bearing should not be removed.

SUBTASK 55-05-02-250-018

- (2) Do a High Frequency Eddy Current inspection of all the holes on the hinge plates around the bore at elevator STA 265.

See Doc. D626A001 - DTR, DTR check form 55-10-08-3, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-36.

SUBTASK 55-05-02-410-025

- (3) Close these access panels on the Left side:

<b>Number</b>	<b>Name/Location</b>
334NB	Horizontal Stabilizer, Elevator Hinge Cover
334NT	Horizontal Stabilizer, Elevator Hinge Cover

Close these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
344NB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45
344NT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

SUBTASK 55-05-02-390-006

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

EFFECTIVITY	
LOM ALL	

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TASK 55-05-02-250-819

25. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER ELEVATOR HINGE RIBS

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
SRM 51-10-01	Structural Repair Manual

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
334	Left Horizontal Stabilizer - Elevator
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge
344	Right Horizontal Stabilizer - Elevator

D. Access Panels

Number	Name/Location
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
334AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334GT	Horizontal Stabilizer, Elevator Hinge Cover
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
344AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344GT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 39.02

E. Inspection

SUBTASK 55-05-02-010-028

- (1) Open these access panels on the Left side:

Number	Name/Location
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
334AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334GT	Horizontal Stabilizer, Elevator Hinge Cover

Open these access panels on the Right side:

Number	Name/Location
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
344AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344GT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 39.02

NOTE: Removal of hinge plate is required. The spherical bearing should not be removed.

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SUBTASK 55-05-02-250-019

- (2) Do a High Frequency Eddy Current inspection of all holes on the hinge plate at elevator STA 66.

See Doc. D626A001 - DTR, DTR check form 55-10-08-4, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-36.

SUBTASK 55-05-02-410-026

- (3) Close these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
334AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334GT	Horizontal Stabilizer, Elevator Hinge Cover

Close these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
344AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344GT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 39.02

SUBTASK 55-05-02-390-007

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-821**

**26. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER ELEVATOR HINGE RIBS TRAILING EDGE CLEVIS**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<u>Zone</u>	<u>Area</u>
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
334	Left Horizontal Stabilizer - Elevator
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge
344	Right Horizontal Stabilizer - Elevator

**D. Access Panels**

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

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<u>Number</u>	<u>Name/Location</u>
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
334JB	Horizontal Stabilizer, Elevator Hinge Cover
334KB	Horizontal Stabilizer, Elevator Hinge Cover
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
344JB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 121.59
344KB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 176.64

**E. Inspection**

SUBTASK 55-05-02-010-032

- (1) Open these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
334JB	Horizontal Stabilizer, Elevator Hinge Cover
334KB	Horizontal Stabilizer, Elevator Hinge Cover

Open these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
344JB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 121.59
344KB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 176.64

SUBTASK 55-05-02-250-021

- (2) Do a High Frequency Eddy Current inspection around the outer edge of the bushing flange on both the upper and lower trailing edge clevis lugs at elevator STA 121 and elevator STA 176.  
See Doc. D626A001 - DTR, DTR check form 55-10-08-5B, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-23.

SUBTASK 55-05-02-410-030

- (3) Close these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
334JB	Horizontal Stabilizer, Elevator Hinge Cover
334KB	Horizontal Stabilizer, Elevator Hinge Cover



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Close these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
344JB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 121.59
344KB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 176.64

SUBTASK 55-05-02-390-009

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-822**

**27. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER ELEVATOR HINGE RIBS**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<u>Zone</u>	<u>Area</u>
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
334	Left Horizontal Stabilizer - Elevator
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge
344	Right Horizontal Stabilizer - Elevator

**D. Access Panels**

<u>Number</u>	<u>Name/Location</u>
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
334AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334GT	Horizontal Stabilizer, Elevator Hinge Cover
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
344AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344GT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 39.02

**E. Inspection**

SUBTASK 55-05-02-010-033

- (1) Open these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
334AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator

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<u>Number</u>	<u>Name/Location</u>
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334GT	Horizontal Stabilizer, Elevator Hinge Cover

Open these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
344AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344GT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 39.02

**SUBTASK 55-05-02-250-022**

- (2) Do a High Frequency Eddy Current inspection around the bushing flanges on both the upper and lower clevis lugs at elevator STA 66.

See Doc. D626A001 - DTR, DTR check form 55-10-08-6, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-23.

**SUBTASK 55-05-02-410-031**

- (3) Close these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
334AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334GT	Horizontal Stabilizer, Elevator Hinge Cover

Close these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
344AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344GT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 39.02

**SUBTASK 55-05-02-390-010**

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-823**

**28. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER ELEVATOR HINGE RIBS**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

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C. Location Zones

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

D. Access Panels

Number	Name/Location
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334LB	Horizontal Stabilizer, Elevator Hinge Cover
334MB	Horizontal Stabilizer, Elevator Hinge Cover
334NB	Horizontal Stabilizer, Elevator Hinge Cover
334NT	Horizontal Stabilizer, Elevator Hinge Cover
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
344NT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

E. Inspection

SUBTASK 55-05-02-010-034

- (1) Open these access panels on the Left side:

Number	Name/Location
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334LB	Horizontal Stabilizer, Elevator Hinge Cover
334MB	Horizontal Stabilizer, Elevator Hinge Cover
334NB	Horizontal Stabilizer, Elevator Hinge Cover
334NT	Horizontal Stabilizer, Elevator Hinge Cover

- (2) For the Right side, open these access panels:

Number	Name/Location
334FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
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
344NT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

SUBTASK 55-05-02-250-023

- (3) Do a High Frequency Eddy Current inspection around the bushing flanges at both the upper and lower clevis lugs at elevator STA 213 and elevator STA 250.

See Doc. D626A001 - DTR, DTR check form 55-10-08-7, alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-23.

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SUBTASK 55-05-02-410-032

- (4) For the Left side, close these access panels:

<u>Number</u>	<u>Name/Location</u>
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334LB	Horizontal Stabilizer, Elevator Hinge Cover
334MB	Horizontal Stabilizer, Elevator Hinge Cover
334NB	Horizontal Stabilizer, Elevator Hinge Cover
334NT	Horizontal Stabilizer, Elevator Hinge Cover

- (5) For the Right side, close these access panels:

<u>Number</u>	<u>Name/Location</u>
334FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
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
344NT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

SUBTASK 55-05-02-390-011

- (6) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

— END OF TASK —

**TASK 55-05-02-250-824**

**29. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER ELEVATOR HINGE RIBS**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<u>Zone</u>	<u>Area</u>
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
334	Left Horizontal Stabilizer - Elevator
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge
344	Right Horizontal Stabilizer - Elevator

**D. Access Panels**

<u>Number</u>	<u>Name/Location</u>
334NB	Horizontal Stabilizer, Elevator Hinge Cover
334NT	Horizontal Stabilizer, Elevator Hinge Cover
344NB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45
344NT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45



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**E. Inspection**

SUBTASK 55-05-02-010-035

- (1) Open these access panels on the Left side:

**Number      Name/Location**

334NB      Horizontal Stabilizer, Elevator Hinge Cover

334NT      Horizontal Stabilizer, Elevator Hinge Cover

Open these access panels on the Right side:

**Number      Name/Location**

344NB      Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

344NT      Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

SUBTASK 55-05-02-250-024

- (2) Do a High Frequency Eddy Current inspection around the edge of the bushing at both the upper and lower clevis lugs at elevator STA 265.

See Doc. D626A001 - DTR, DTR check form 55-10-08-8, alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-23.

**NOTE:** Bushing removal not required.

SUBTASK 55-05-02-410-033

- (3) Close these access panels on the Left side:

**Number      Name/Location**

334NB      Horizontal Stabilizer, Elevator Hinge Cover

334NT      Horizontal Stabilizer, Elevator Hinge Cover

Close these access panels on the Right side:

**Number      Name/Location**

344NB      Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

344NT      Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

SUBTASK 55-05-02-390-012

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-825**

**30. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER TRAILING EDGE ELEVATOR HINGE RIB**

**NOTE:** This procedure is a scheduled maintenance task.

**A. References**

Reference	Title
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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



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C. Location Zones

Zone	Area
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
334	Left Horizontal Stabilizer - Elevator
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge
344	Right 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
343BB	Horizontal Stabilizer, Access Panel - T.E. Area
343CB	Horizontal Stabilizer, Access Panel - T.E. Area
343DB	Horizontal Stabilizer, Access Panel - T.E. Area

E. Inspection

SUBTASK 55-05-02-010-075

- (1) Open these access panels on the Left side:

Number	Name/Location
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge

Open these access panels on the Right side:

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

NOTE: Removal of lower composite skin panels is required.

SUBTASK 55-05-02-250-025

- (2) Do a High Frequency Eddy Current inspection of the elevator hinge rib chord around the fasteners common to the upper and lower spar chords at elevator STA 66 and elevator STA 121.

See Doc. D626A001 - DTR, DTR check form 55-10-08-9, alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-24.

SUBTASK 55-05-02-410-073

- (3) Close these access panels on the Left side:

Number	Name/Location
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge



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Close these access panels on the Right side:

<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

SUBTASK 55-05-02-390-013

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-826**

**31. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER, TRAILING EDGE HINGE RIB TO REAR SPAR ATTACHMENT**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<u>Zone</u>	<u>Area</u>
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
334	Left Horizontal Stabilizer - Elevator
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge
344	Right Horizontal Stabilizer - Elevator

**D. Access Panels**

<u>Number</u>	<u>Name/Location</u>
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area

**E. Inspection**

SUBTASK 55-05-02-010-036

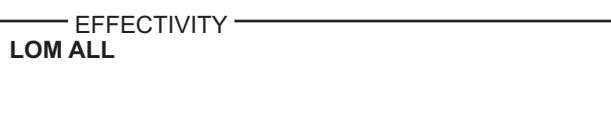
- (1) Open these access panels on the Left side:

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

Open these access panels on the Right side:

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

NOTE: Removal of lower trailing edge panels is required.



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SUBTASK 55-05-02-250-026

- (2) Do a High Frequency Eddy Current inspection of the rib chord around the fasteners common to the stabilizer upper and lower rear spar chord at Elevator STA 176.

See Doc. D626A001 - DTR, DTR check form 55-10-8-10, alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-24.

SUBTASK 55-05-02-410-042

- (3) Close these access panels on the Left side:

**Number      Name/Location**

333DB      Horizontal Stabilizer, Access Panel, Trailing Edge

333EB      Horizontal Stabilizer, Access Panel, Trailing Edge

Close these access panels on the Right side:

**Number      Name/Location**

343DB      Horizontal Stabilizer, Access Panel - T.E. Area

343EB      Horizontal Stabilizer, Access Panel - T.E. Area

SUBTASK 55-05-02-390-014

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-827**

**32. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER ELEVATOR HINGE RIBS**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

Reference	Title
SRM 51-10-01	Structural Repair Manual

**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
334	Left Horizontal Stabilizer - Elevator
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge
344	Right Horizontal Stabilizer - Elevator

**D. Access Panels**

Number	Name/Location
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
343FB	Horizontal Stabilizer, Access Panel - T.E. Area
344FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator



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**E. Inspection**

SUBTASK 55-05-02-010-043

- (1) Open these access panels on the Left side:

**Number      Name/Location**

333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator

Open these access panels on the Right side:

**Number      Name/Location**

343FB	Horizontal Stabilizer, Access Panel - T.E. Area
344FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator

NOTE: Removal of elevator and cover panel is required. No fastener removal is required.

SUBTASK 55-05-02-250-027

- (2) Do a High Frequency Eddy Current inspection of the hinge rib to rear spar attachment, on both the upper and lower chords, at elevator STA 213, elevator STA 250 and elevator STA 265.

See Doc. D626A001 - DTR, DTR check form 55-10-8-11, alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-24.

SUBTASK 55-05-02-410-040

- (3) Close these access panels on the Left side:

**Number      Name/Location**

333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
334FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator

Close these access panels on the Right side:

**Number      Name/Location**

343FB	Horizontal Stabilizer, Access Panel - T.E. Area
344FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator

SUBTASK 55-05-02-390-015

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-828**

**33. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER ELEVATOR HINGE RIBS**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

Reference	Title
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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



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**C. Location Zones**

<b>Zone</b>	<b>Area</b>
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
334	Left Horizontal Stabilizer - Elevator
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge
344	Right Horizontal Stabilizer - Elevator

**D. Access Panels**

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

**E. Inspection**

SUBTASK 55-05-02-010-041

- (1) Open these access panels on the Left side:

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

Open these access panels on the Right side:

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

NOTE: Removal of lower composite skin panels is required. No fastener removal required.

SUBTASK 55-05-02-250-028

- (2) Do a High Frequency Eddy Current inspection around the fastener holes that are used to attach the composite skin panels to the rib and the upper chord and lower chord fastener locations between the rear spar and trailing edge beam at Elevator STA 66 and elevator STA 121.

See Doc. D626A001 - DTR, DTR check form 55-10-8-13, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-33.

SUBTASK 55-05-02-410-038

- (3) Close these access panels on the Left side:

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

EFFECTIVITY  
LOM ALL

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Close these access panels on the Right side:

<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

SUBTASK 55-05-02-390-016

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-829**

**34. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER ELEVATOR HINGE RIBS**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<u>Zone</u>	<u>Area</u>
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
334	Left Horizontal Stabilizer - Elevator
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge
344	Right Horizontal Stabilizer - Elevator

**D. Access Panels**

<u>Number</u>	<u>Name/Location</u>
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area

**E. Inspection**

SUBTASK 55-05-02-010-039

- (1) Open these access panels on the Left side:

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

Open these access panels on the Right side:

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

NOTE: Removal of the lower trailing edge skin panels is required.

— EFFECTIVITY —

LOM ALL

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SUBTASK 55-05-02-250-029

- (2) Do a High Frequency Eddy Current inspection of both upper and lower rib chords around the fastener holes common to the trailing edge panels between the stabilizer rear spar and the trailing edge beam at elevator STA 176.

See Doc. D626A001 - DTR, DTR check form 55-10-08-14, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-33.

SUBTASK 55-05-02-410-036

- (3) Close these access panels on the Left side:

**Number      Name/Location**

333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge

Close these access panels on the Right side:

**Number      Name/Location**

343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area

SUBTASK 55-05-02-390-017

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

————— END OF TASK —————

**TASK 55-05-02-211-804**

**35. INTERNAL - DETAILED: HORIZONTAL STABILIZER FRONT SPAR LOWER CHORD - FORWARD FLANGE**

Figure 202

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)

**B. Location Zones**

Zone	Area
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**C. Access Panels**

Number	Name/Location
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

— EFFECTIVITY —

LOM ALL

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D. Inspection

SUBTASK 55-05-02-010-126

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.
  - (a) Open this access panel on the Left side:

**Number      Name/Location**

331B      Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Open this access panel on the Right side:

**Number      Name/Location**

341B      Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**NOTE:** Removal of the leading edge panels is required to gain access to the lower surface of the forward flange.

SUBTASK 55-05-02-211-004

- (2) Do a Detailed inspection of the front spar lower chord forward flange from stabilizer STA 67.71 to stabilizer STA 175.50.

See Doc. D626A001 - DTR, DTR check form 55-10-06-6A, for alternative inspection.

SUBTASK 55-05-02-410-124

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.

- (a) Close this access panel on the Left side:

**Number      Name/Location**

331B      Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Close this access panel on the Right side:

**Number      Name/Location**

341B      Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

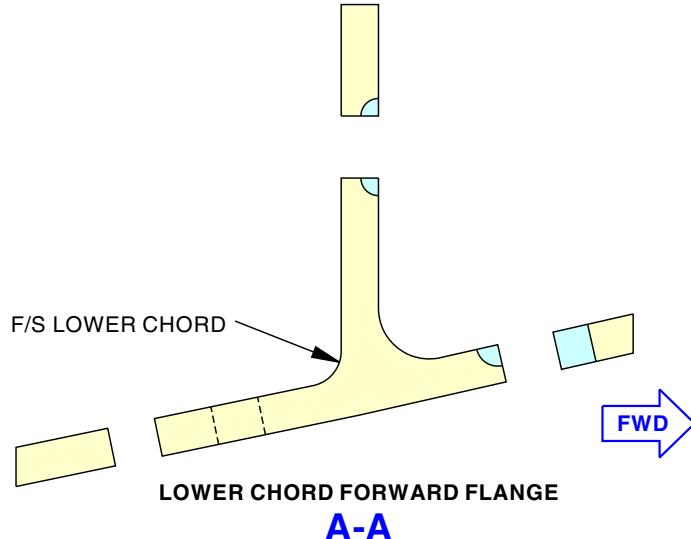
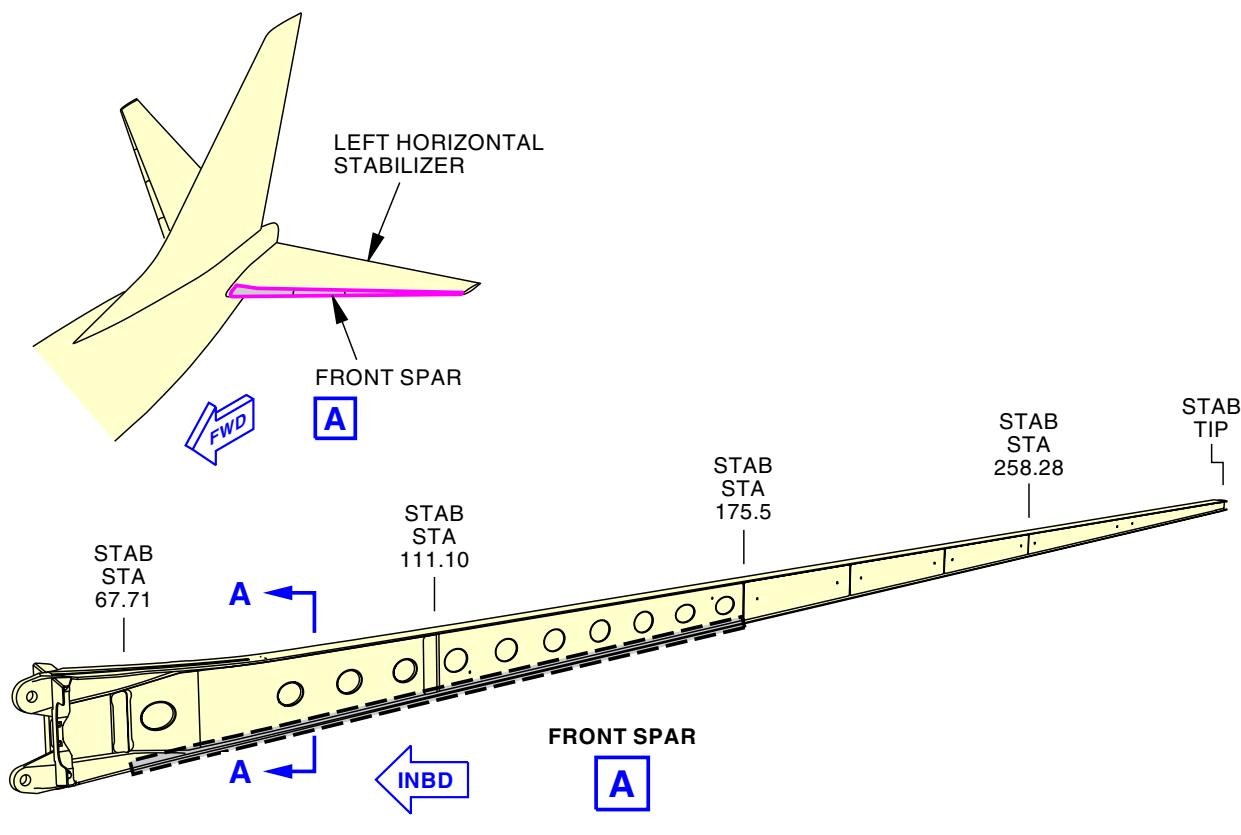
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

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Front Spar Lower Chord - Forward Flange  
Figure 202/55-05-02-990-801

EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**TASK 55-05-02-211-805**

**36. EXTERNAL - DETAILED: HORIZONTAL STABILIZER LOWER INSPAR SKIN**

Figure 203

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**B. Inspection**

SUBTASK 55-05-02-211-005

- (1) Do a Detailed inspection of the horizontal stabilizer lower inspar skin from side-of-body to the tip.

See Doc. D626A001 - DTR, DTR check form 55-10-10-1, for alternative inspection.

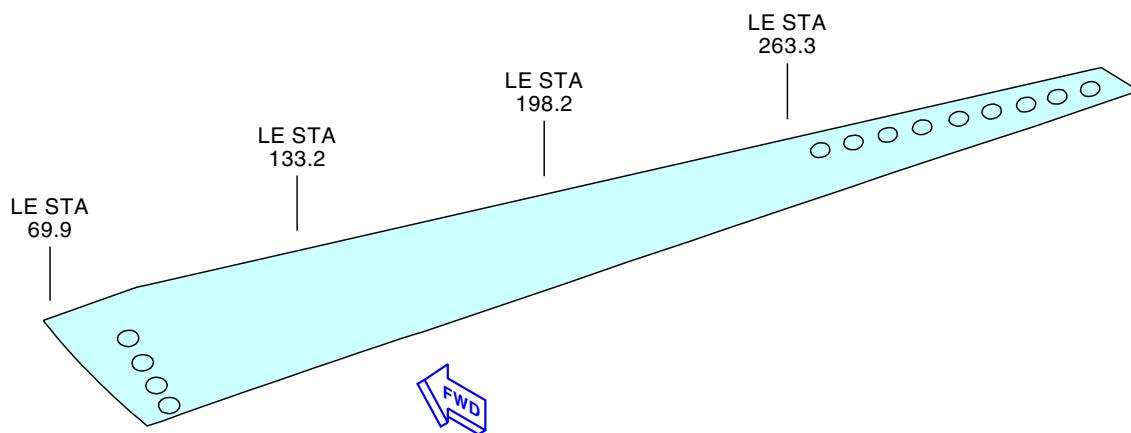
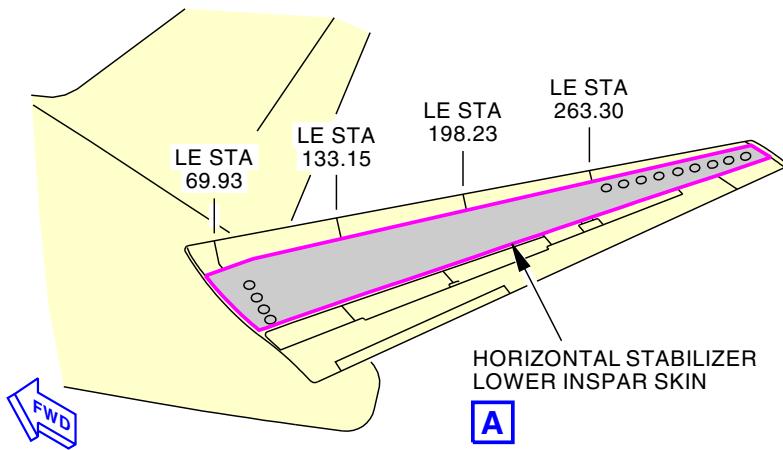
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

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HORIZONTAL STABILIZER LOWER INSPAR SKIN  
(LOWER SURFACE OF THE LOWER PANEL IS SHOWN)  
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

A

3036995 S0000806154\_V1

Horizontal Stabilizer - Lower Inspark Skin  
Figure 203/55-05-02-990-803

EFFECTIVITY  
LOM ALL

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**TASK 55-05-02-211-806**

**37. INTERNAL - DETAILED: HORIZONTAL STABILIZER CENTER SECTION FRONT SPAR UPPER CHORD**

Figure 204

**NOTE:** This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
331AZ	Horizontal Stabilizer, Access Panel, Inboard L.E. Closure Rib
341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
341AZ	Horizontal Stabilizer, Access Panel - Inbd L.E. Closure Rib

**C. Inspection**

SUBTASK 55-05-02-010-029

- (1) Open these access panels on the Left side:

<b>Number</b>	<b>Name/Location</b>
331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
331AZ	Horizontal Stabilizer, Access Panel, Inboard L.E. Closure Rib

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
341AZ	Horizontal Stabilizer, Access Panel - Inbd L.E. Closure Rib

**NOTE:** Removal of leading edge and gap seals is required.

SUBTASK 55-05-02-211-006

- (2) Do a Detailed inspection of all four (4) front spar upper side of body clevis lugs.

See Doc. D626A001 - DTR, DTR check form 55-10-11-1, for alternative inspection.

SUBTASK 55-05-02-410-027

- (3) Close these access panels on the Left side:

<b>Number</b>	<b>Name/Location</b>
331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
331AZ	Horizontal Stabilizer, Access Panel, Inboard L.E. Closure Rib

Close these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
341AZ	Horizontal Stabilizer, Access Panel - Inbd L.E. Closure Rib

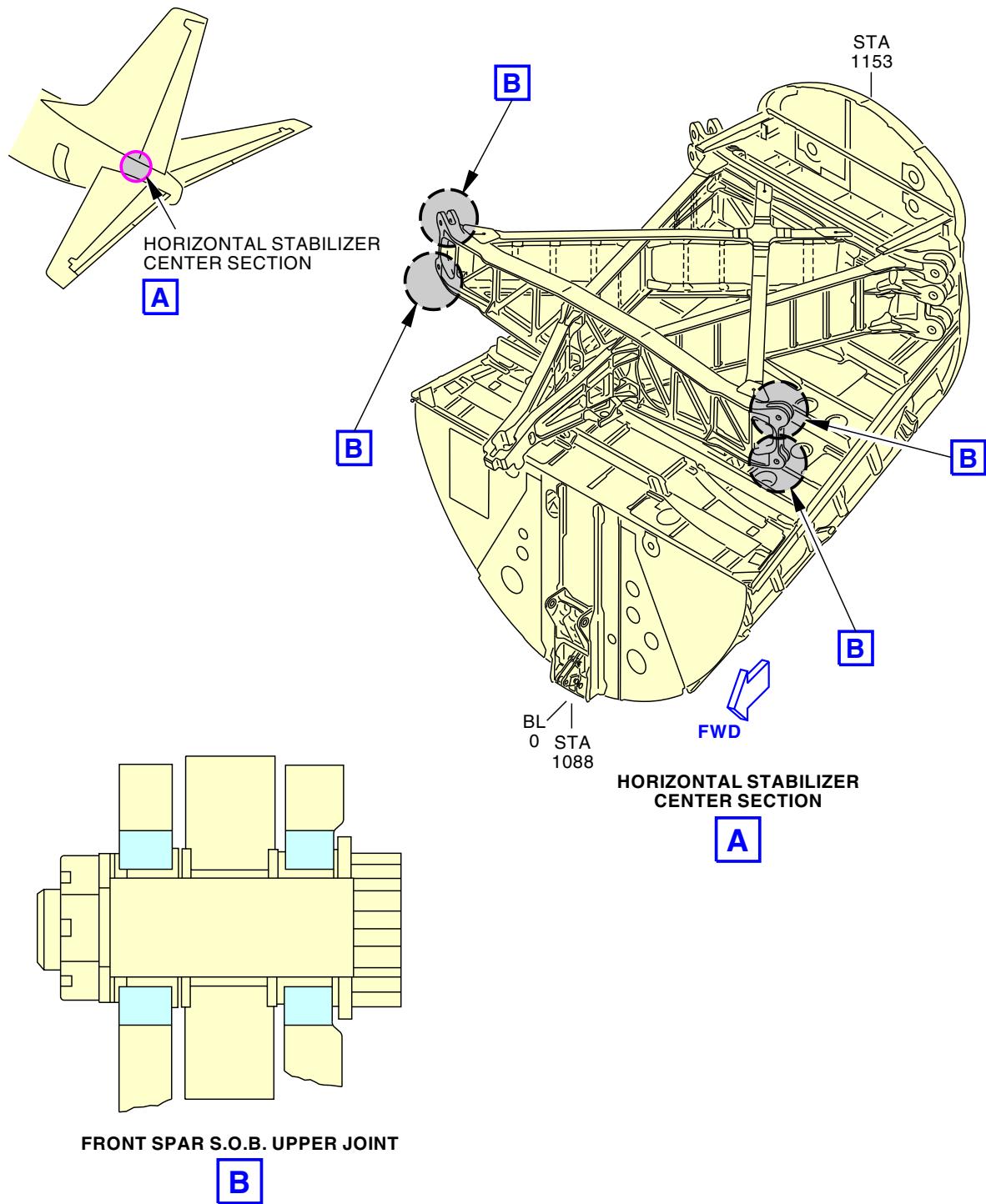
———— END OF TASK ————



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**HORIZONTAL STABILIZER CENTER SECTION REAR SPAR LUGS**  
Figure 204/55-05-02-990-804

EFFECTIVITY  
LOM ALL

**55-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**TASK 55-05-02-130-805**

**38. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION REAR SPAR LUGS**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

Reference	Title
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

Zone	Area
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**D. Access Panels**

Number	Name/Location
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
342AT	Gap Cover, Horizontal Stabilizer
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

**E. Inspection**

SUBTASK 55-05-02-010-003

- (1) Open these access panels on the Left side:

Number	Name/Location
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

Open these access panels on the Right side:

Number	Name/Location
342AT	Gap Cover, Horizontal Stabilizer
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

NOTE: Removal of the gap covers and sliding seals is required.

SUBTASK 55-05-02-130-005

- (2) Do an Ultrasonic inspection of all four (4) Lower Pivot Fitting Clevis Lugs for hidden damage at the lug bore.

See Doc. D626A001 - DTR, DTR check form 55-10-12-1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-05.

EFFECTIVITY  
LOM ALL

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SUBTASK 55-05-02-410-003

- (3) Close these access panels on the Left side:

**Number**

**Name/Location**

332AT

Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

333AT

Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

Close these access panels on the Right side:

**Number**

**Name/Location**

342AT

Gap Cover, Horizontal Stabilizer

343AT

Horizontal Stabilizer, Gap Cover - H. Stab. to Body

SUBTASK 55-05-02-390-018

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-130-806**

**39. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION REAR SPAR  
UPPER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

**E. Inspection**

SUBTASK 55-05-02-010-004

- (1) Open these access panels on the Left side:

**Number**

**Name/Location**

332AB

Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

EFFECTIVITY  
LOM ALL

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(Continued)

**Number      Name/Location**

333AT      Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

Open these access panels on the Right side:

**Number      Name/Location**

342AB      Horizontal Stabilizer, Gap Cover - H. Stab. to Body

343AT      Horizontal Stabilizer, Gap Cover - H. Stab. to Body

NOTE: Removal of gap covers is required.

SUBTASK 55-05-02-130-006

- (2) Do an Ultrasonic inspection of the side of body lug bore on the horizontal stabilizer center section rear spar upper chord.

See Doc. D626A001 - DTR, DTR check form 55-10-12-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-08.

SUBTASK 55-05-02-410-004

- (3) Close these access panels on the Left side:

**Number      Name/Location**

332AB      Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

333AT      Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

Close these access panels on the Right side:

**Number      Name/Location**

342AB      Horizontal Stabilizer, Gap Cover - H. Stab. to Body

343AT      Horizontal Stabilizer, Gap Cover - H. Stab. to Body

SUBTASK 55-05-02-390-019

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-211-807**

**40. INTERNAL - DETAILED: HORIZONTAL STABILIZER CENTER SECTION FRONT SPAR UPPER CHORD**

Figure 205

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

**B. Access Panels**

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



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C. Inspection

SUBTASK 55-05-02-010-012

- (1) Open this access panel:

Number      Name/Location

311BL      Stabilizer Trim Access Door

SUBTASK 55-05-02-211-007

- (2) Do a Detailed inspection of the thrust beam to spar joint on the horizontal stabilizer center section front spar upper chord.

See Doc. D626A001 - DTR, DTR check form 55-10-13-2, for alternative inspection.

SUBTASK 55-05-02-410-012

- (3) Close this access panel:

Number      Name/Location

311BL      Stabilizer Trim Access Door

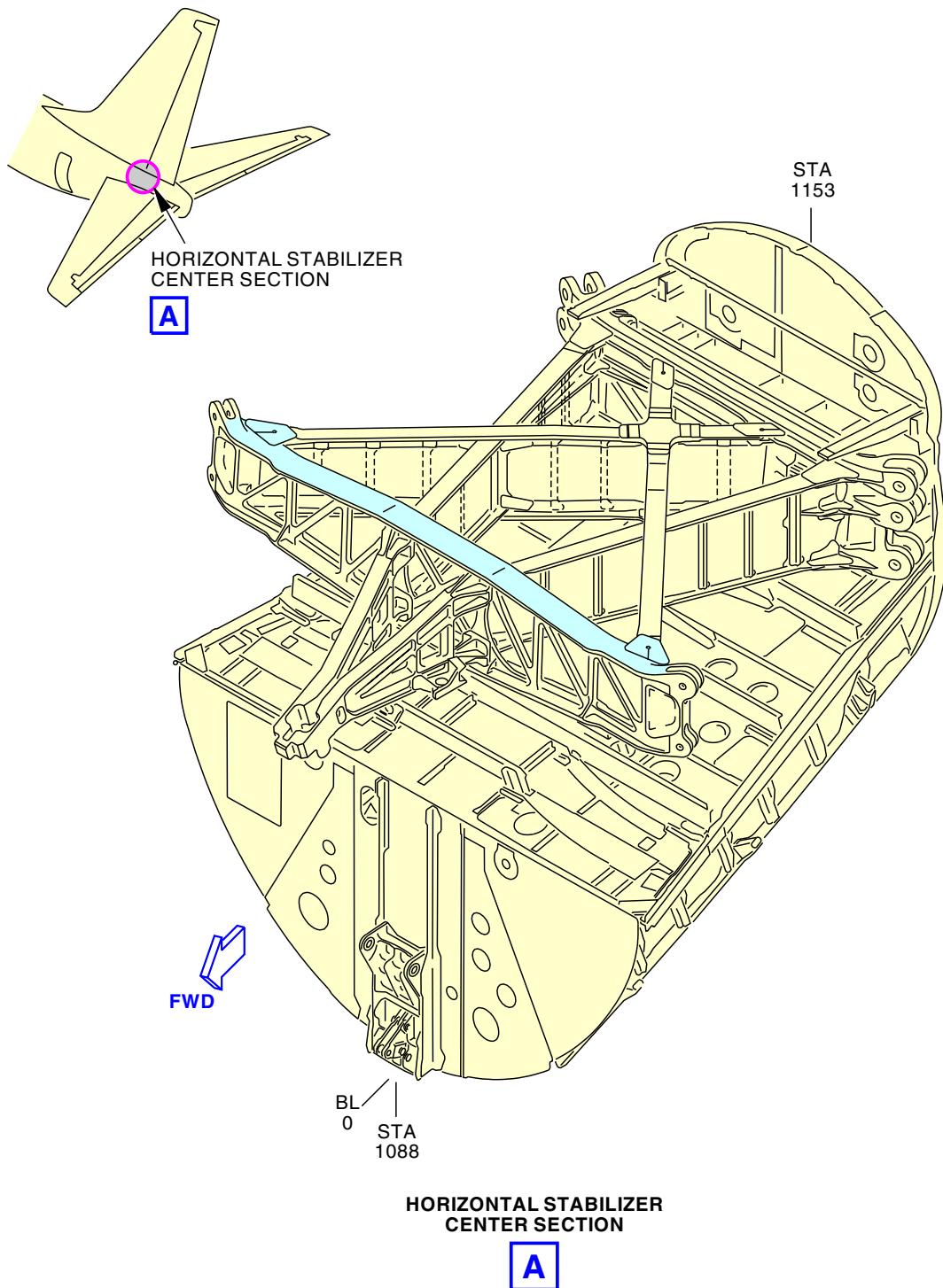
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

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**HORIZONTAL STABILIZER CENTER SECTION FRONT SPAR UPPER CHORD**  
Figure 205/55-05-02-990-807

EFFECTIVITY  
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**TASK 55-05-02-130-807**

**41. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION PRIMARY AND THRUST BEAMS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

**B. Access Panels**

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

**C. Prepare for the inspection**

SUBTASK 55-05-02-860-013

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-02-860-014

- (2) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

**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

**D. Inspection**

SUBTASK 55-05-02-010-005

- (1) Open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

NOTE: Access horizontal stabilizer center section through opening in center of 1088 bulkhead.

SUBTASK 55-05-02-130-007

- (2) Do an Ultrasonic inspection of the upper and lower chords on the primary beam at the front and rear spar joints.

See Doc. D626A001 - DTR, DTR check form 55-10-14-1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-20.

SUBTASK 55-05-02-410-005

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

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LOM ALL

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E. Put the Airplane Back to Its Usual Condition

SUBTASK 55-05-02-860-015

- (1) 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>
C	2	C00849	AFCS STABILIZER TRIM

**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

SUBTASK 55-05-02-860-016

- (2) Set the stabilizer leading edge to the NORMAL position.

———— END OF TASK ————

**TASK 55-05-02-250-830**

**42. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION PRIMARY AND THRUST BEAMS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

**B. Access Panels**

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

**C. Prepare for the inspection**

SUBTASK 55-05-02-860-045

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-02-860-046

- (2) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

**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



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**D. Inspection**

SUBTASK 55-05-02-010-038

- (1) Open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**NOTE:** Access horizontal stabilizer center section through opening in center of 1088 bulkhead.

SUBTASK 55-05-02-250-030

- (2) Do a High Frequency Eddy Current inspection of the upper and lower chord splice members of the upper primary beam at the front and rear spar joint plates and angles.

See Doc. D626A001 - DTR, DTR check form 55-10-14-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-38.

SUBTASK 55-05-02-410-035

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**E. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-05-02-860-047

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

**CAPT Electrical System Panel, P18-1**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
C	2	C00849	AFCS STABILIZER TRIM

**F/O Electrical System Panel, P6-2**

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

SUBTASK 55-05-02-860-048

- (2) Set the stabilizer leading edge to the NORMAL position.

———— END OF TASK ————

**TASK 55-05-02-130-808**

**43. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION PRIMARY AND THRUST BEAMS**

**NOTE:** This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

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**B. Access Panels**

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

**C. Prepare for the inspection**

SUBTASK 55-05-02-860-017

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-02-860-018

- (2) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

**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

**D. Inspection**

SUBTASK 55-05-02-010-006

- (1) Open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

NOTE: Access horizontal stabilizer center section through opening in center of 1088 bulkhead.

SUBTASK 55-05-02-130-008

- (2) Do an Ultrasonic inspection of the upper primary beam chord for damage under the thrust beam chord around fasteners common to the two chords and splice angle.

See Doc. D626A001 - DTR, DTR check form 55-10-14-3, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-14.

SUBTASK 55-05-02-410-006

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**E. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-05-02-860-019

- (1) 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>
C	2	C00849	AFCS STABILIZER TRIM



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**F/O Electrical System Panel, P6-2**

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

SUBTASK 55-05-02-860-020

- (2) Set the stabilizer leading edge to the NORMAL position.

————— END OF TASK ————

**TASK 55-05-02-130-809**

**44. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION THRUST BEAMS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

**B. Access Panels**

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

**C. Prepare for the inspection**

SUBTASK 55-05-02-860-021

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-02-860-022

- (2) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

**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

**D. Inspection**

SUBTASK 55-05-02-010-007

- (1) Open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

NOTE: Access horizontal stabilizer center section through opening in center of 1088 bulkhead.

SUBTASK 55-05-02-130-009

- (2) Do an Ultrasonic inspection of the thrust beam upper and lower chords around the first row of fasteners common to the splice members at both the front and rear spar joints.

See Doc. D626A001 - DTR, DTR check form 55-10-14-4, for alternative inspection.

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The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-25.

SUBTASK 55-05-02-410-007

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**E. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-05-02-860-023

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

**CAPT Electrical System Panel, P18-1**

**Row    Col    Number    Name**

C       2       C00849      AFCS STABILIZER TRIM

**F/O Electrical System Panel, P6-2**

**Row    Col    Number    Name**

B       10      C00207      FLIGHT CONTROL STAB TRIM CONT

D       10      C00840      FLIGHT CONTROL STAB TRIM ACTUATOR

SUBTASK 55-05-02-860-024

- (2) Set the stabilizer leading edge to the NORMAL position.

———— END OF TASK ————

**TASK 55-05-02-250-831**

**45. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION THRUST BEAMS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

**Zone      Area**

313      Stabilizer Torsion Box Compartment - Left

314      Stabilizer Torsion Box Compartment - Right

**B. Access Panels**

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**C. Prepare for the inspection**

SUBTASK 55-05-02-860-049

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-02-860-050

- (2) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-1**

**Row    Col    Number    Name**

C       2       C00849      AFCS STABILIZER TRIM

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**F/O Electrical System Panel, P6-2**

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

**D. Inspection**

SUBTASK 55-05-02-010-037

- (1) Open this access panel:

Number    Name/Location

311BL      Stabilizer Trim Access Door

NOTE: Access horizontal stabilizer center section through opening in center of 1088 bulkhead.

SUBTASK 55-05-02-250-031

- (2) Do a High Frequency Eddy Current inspection of the upper and lower thrust beam chords around the first row of fasteners common to the splice members at both the front and rear spars.

See Doc. D626A001 - DTR, DTR check form 55-10-14-5, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-39.

SUBTASK 55-05-02-410-034

- (3) Close this access panel:

Number    Name/Location

311BL      Stabilizer Trim Access Door

**E. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-05-02-860-051

- (1) 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>
C	2	C00849	AFCS STABILIZER TRIM

**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

SUBTASK 55-05-02-860-052

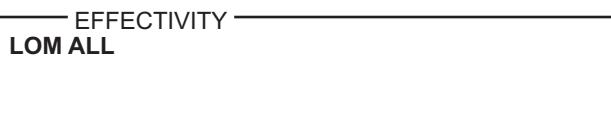
- (2) Set the stabilizer leading edge to the NORMAL position.

———— END OF TASK ————

**TASK 55-05-02-130-810**

**46. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION THRUST BEAMS**

NOTE: This procedure is a scheduled maintenance task.



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**A. Location Zones**

<u>Zone</u>	<u>Area</u>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

**B. Access Panels**

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

**C. Prepare for the inspection**

SUBTASK 55-05-02-860-025

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-02-860-026

- (2) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

**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

**D. Inspection**

SUBTASK 55-05-02-010-008

- (1) Open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

NOTE: Access horizontal stabilizer center section through opening in center of 1088 bulkhead.

SUBTASK 55-05-02-130-010

- (2) Do an Ultrasonic inspection of the upper and lower thrust beam chords forward and aft of the intersection joint (4 places).

See Doc. D626A001 - DTR, DTR check form 55-10-14-6, for alternative inspection.

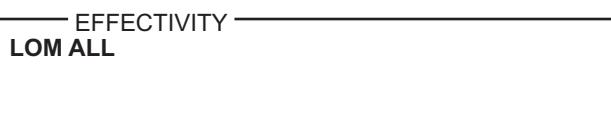
The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-09.

SUBTASK 55-05-02-410-008

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door



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E. Put the Airplane Back to Its Usual Condition

SUBTASK 55-05-02-860-027

- (1) 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>
C	2	C00849	AFCS STABILIZER TRIM

**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

SUBTASK 55-05-02-860-028

- (2) Set the stabilizer leading edge to the NORMAL position.

————— END OF TASK ————

**TASK 55-05-02-250-832**

**47. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION THRUST BEAM  
INTERSECTION**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

**B. Access Panels**

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

**C. Prepare for the inspection**

SUBTASK 55-05-02-860-053

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-02-860-054

- (2) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

**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



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**D. Inspection**

SUBTASK 55-05-02-010-046

- (1) Open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**NOTE:** Access horizontal stabilizer center section through opening in center of 1088 bulkhead.

SUBTASK 55-05-02-250-032

- (2) Do a High Frequency Eddy Current inspection of the upper and lower thrust beam splice plates.

See Doc. D626A001 - DTR, DTR check form 55-10-14-7, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-20.

SUBTASK 55-05-02-410-044

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**E. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-05-02-860-055

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

**CAPT Electrical System Panel, P18-1**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
C	2	C00849	AFCS STABILIZER TRIM

**F/O Electrical System Panel, P6-2**

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

SUBTASK 55-05-02-860-056

- (2) Set the stabilizer leading edge to the NORMAL position.

———— END OF TASK ————

**TASK 55-05-02-130-811**

**48. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION THRUST BEAMS**

**NOTE:** This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

**B. Access Panels**

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

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**C. Prepare for the inspection**

SUBTASK 55-05-02-860-029

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-02-860-030

- (2) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

**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

**D. Inspection**

SUBTASK 55-05-02-010-009

- (1) Open this access panel:

Number    Name/Location

311BL      Stabilizer Trim Access Door

NOTE: Access horizontal stabilizer center section through opening in center of 1088 bulkhead.

SUBTASK 55-05-02-130-011

- (2) Do an Ultrasonic inspection of the upper thrust beam chord for damage around the four fasteners common to the primary beam chord.

See Doc. D626A001 - DTR, DTR check form 55-10-14-8, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-10.

SUBTASK 55-05-02-410-009

- (3) Close this access panel:

Number    Name/Location

311BL      Stabilizer Trim Access Door

**E. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-05-02-860-031

- (1) 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>
C	2	C00849	AFCS STABILIZER TRIM

**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



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SUBTASK 55-05-02-860-032

- (2) Set the stabilizer leading edge to the NORMAL position.

———— END OF TASK ——

**TASK 55-05-02-250-833**

**49. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION PRIMARY BEAM CHORD TO WEB ATTACHMENT**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

**B. Access Panels**

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

**C. Prepare for the inspection**

SUBTASK 55-05-02-860-057

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-02-860-058

- (2) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

**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

**D. Inspection**

SUBTASK 55-05-02-010-047

- (1) Open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

NOTE: Access horizontal stabilizer center section through opening in center of 1088 bulkhead.

SUBTASK 55-05-02-250-033

- (2) Do a High Frequency Eddy Current inspection of the upper chord web flange around the fasteners common to the web between the front and rear spars from STA 1216 to STA 1242.

See Doc. D626A001 - DTR, DTR check form 55-10-14-9, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-25.



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SUBTASK 55-05-02-410-045

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**E. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-05-02-860-059

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

**CAPT Electrical System Panel, P18-1**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
C	2	C00849	AFCS STABILIZER TRIM

**F/O Electrical System Panel, P6-2**

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

SUBTASK 55-05-02-860-060

- (2) Set the stabilizer leading edge to the NORMAL position.

————— END OF TASK ————

**TASK 55-05-02-250-834**

**50. INTERNAL - SPECIAL DETAILED: ELEVATOR HINGE FITTINGS**

**NOTE:** This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
334	Left Horizontal Stabilizer - Elevator
344	Right Horizontal Stabilizer - Elevator

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334GT	Horizontal Stabilizer, Elevator Hinge Cover
334HB	Horizontal Stabilizer, Elevator Hinge Cover
334JB	Horizontal Stabilizer, Elevator Hinge Cover
334JT	Horizontal Stabilizer, Elevator Hinge Cover
334KB	Horizontal Stabilizer, Elevator Hinge Cover
334LB	Horizontal Stabilizer, Elevator Hinge Cover
334MB	Horizontal Stabilizer, Elevator Hinge Cover

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<u>Number</u>	<u>Name/Location</u>
334MT	Horizontal Stabilizer, Elevator Hinge Cover
334NB	Horizontal Stabilizer, Elevator Hinge Cover
334NT	Horizontal Stabilizer, Elevator Hinge Cover
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344GT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 39.02
344HB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 66.54
344JB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 121.59
344JT	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
344MT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 250.04
344NB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45
344NT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

**E. Inspection**

SUBTASK 55-05-02-010-067

- (1) Open these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334GT	Horizontal Stabilizer, Elevator Hinge Cover
334HB	Horizontal Stabilizer, Elevator Hinge Cover
334JB	Horizontal Stabilizer, Elevator Hinge Cover
334JT	Horizontal Stabilizer, Elevator Hinge Cover
334KB	Horizontal Stabilizer, Elevator Hinge Cover
334LB	Horizontal Stabilizer, Elevator Hinge Cover
334MB	Horizontal Stabilizer, Elevator Hinge Cover
334MT	Horizontal Stabilizer, Elevator Hinge Cover
334NB	Horizontal Stabilizer, Elevator Hinge Cover
334NT	Horizontal Stabilizer, Elevator Hinge Cover

Open these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344GT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 39.02
344HB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 66.54
344JB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 121.59
344JT	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
344MT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 250.04
344NB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45
344NT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45



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SUBTASK 55-05-02-250-034

- (2) Do a High Frequency Eddy Current inspection of all hinge fitting clevis lugs on lug face around the circumference of the bushing.

See Doc. D626A001 - DTR, DTR check form 55-20-05, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-50-07.

SUBTASK 55-05-02-410-065

- (3) Close these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334GT	Horizontal Stabilizer, Elevator Hinge Cover
334HB	Horizontal Stabilizer, Elevator Hinge Cover
334JB	Horizontal Stabilizer, Elevator Hinge Cover
334JT	Horizontal Stabilizer, Elevator Hinge Cover
334KB	Horizontal Stabilizer, Elevator Hinge Cover
334LB	Horizontal Stabilizer, Elevator Hinge Cover
334MB	Horizontal Stabilizer, Elevator Hinge Cover
334MT	Horizontal Stabilizer, Elevator Hinge Cover
334NB	Horizontal Stabilizer, Elevator Hinge Cover
334NT	Horizontal Stabilizer, Elevator Hinge Cover

Close these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344GT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 39.02
344HB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 66.54
344JB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 121.59
344JT	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
344MT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 250.04
344NB	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45
344NT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 265.45

SUBTASK 55-05-02-390-020

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

————— END OF TASK ————

**TASK 55-05-02-250-835**

**51. INTERNAL - SPECIAL DETAILED: ELEVATOR MAST ARM ASSEMBLY (ELEVATOR ACTUATOR FITTING)**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
SRM 51-10-01	Structural Repair Manual



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**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
334	Left Horizontal Stabilizer - Elevator
344	Right Horizontal Stabilizer - Elevator

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
334AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334GT	Horizontal Stabilizer, Elevator Hinge Cover
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
344AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344GT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 39.02

**E. Inspection**

SUBTASK 55-05-02-010-048

- (1) Open these access panels on the Left side::

<b>Number</b>	<b>Name/Location</b>
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
334AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334GT	Horizontal Stabilizer, Elevator Hinge Cover

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
344AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344GT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 39.02

NOTE: Remove the actuator rod assembly as required.

SUBTASK 55-05-02-250-035

- (2) Do a High Frequency Eddy Current inspection of each lug face of the elevator actuator fittings.  
See Doc. D626A001 - DTR, DTR check form 55-20-06, for alternative inspection.  
The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-50-09.

SUBTASK 55-05-02-410-158

- (3) Close this access panel on the Left side:

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

- (a) Make sure that the blade seal is installed correctly into the forward track channel.

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- (4) Close this access panel on the Right side:

**Number      Name/Location**

343AB      Horizontal Stabilizer, Gap Cover - H. Stab. to Body

- (a) Make sure that the blade seal is installed correctly into the forward track channel.

SUBTASK 55-05-02-410-046

- (5) Close these access panels on the Left side:

**Number      Name/Location**

334AB      Horizontal Stabilizer, Seal, Trailing Edge to Elevator

334GB      Horizontal Stabilizer, Elevator Hinge Cover

334GT      Horizontal Stabilizer, Elevator Hinge Cover

Close these access panels on the Right side:

**Number      Name/Location**

344AB      Horizontal Stabilizer, Seal, Trailing Edge to Elevator

344GB      Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09

344GT      Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 39.02

SUBTASK 55-05-02-390-021

- (6) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

————— END OF TASK ————

**TASK 55-05-02-210-801**

**52. INTERNAL - GENERAL VISUAL: ELEVATOR HORN BALANCE WEIGHT SUPPORT STRUCTURE**

Figure 206

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
334	Left Horizontal Stabilizer - Elevator
344	Right Horizontal Stabilizer - Elevator

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
334ET	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344ET	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator

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**E. Inspection**

SUBTASK 55-05-02-010-011

- (1) Open these access panels on the Left side:

**Number      Name/Location**

334ET      Horizontal Stabilizer, Seal, Trailing Edge to Elevator

334FB      Horizontal Stabilizer, Seal, Trailing Edge to Elevator

Open these access panels on the Right side:

**Number      Name/Location**

344ET      Horizontal Stabilizer, Seal, Trailing Edge to Elevator

344FB      Horizontal Stabilizer, Seal, Trailing Edge to Elevator

NOTE: Removal of the elevator horn balance weight fairing (183A7400) is required. Outboard rib is inspected through hole in inboard rib.

SUBTASK 55-05-02-210-001

- (2) Do a General Visual inspection of the elevator horn balance weight support structure at elevator STA 260.

See Doc. D626A001 - DTR, DTR check form 55-20-07, for alternative inspection.

SUBTASK 55-05-02-410-011

- (3) Close these access panels on the Left side:

**Number      Name/Location**

334ET      Horizontal Stabilizer, Seal, Trailing Edge to Elevator

334FB      Horizontal Stabilizer, Seal, Trailing Edge to Elevator

Close these access panels on the Right side:

**Number      Name/Location**

344ET      Horizontal Stabilizer, Seal, Trailing Edge to Elevator

344FB      Horizontal Stabilizer, Seal, Trailing Edge to Elevator

SUBTASK 55-05-02-390-022

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

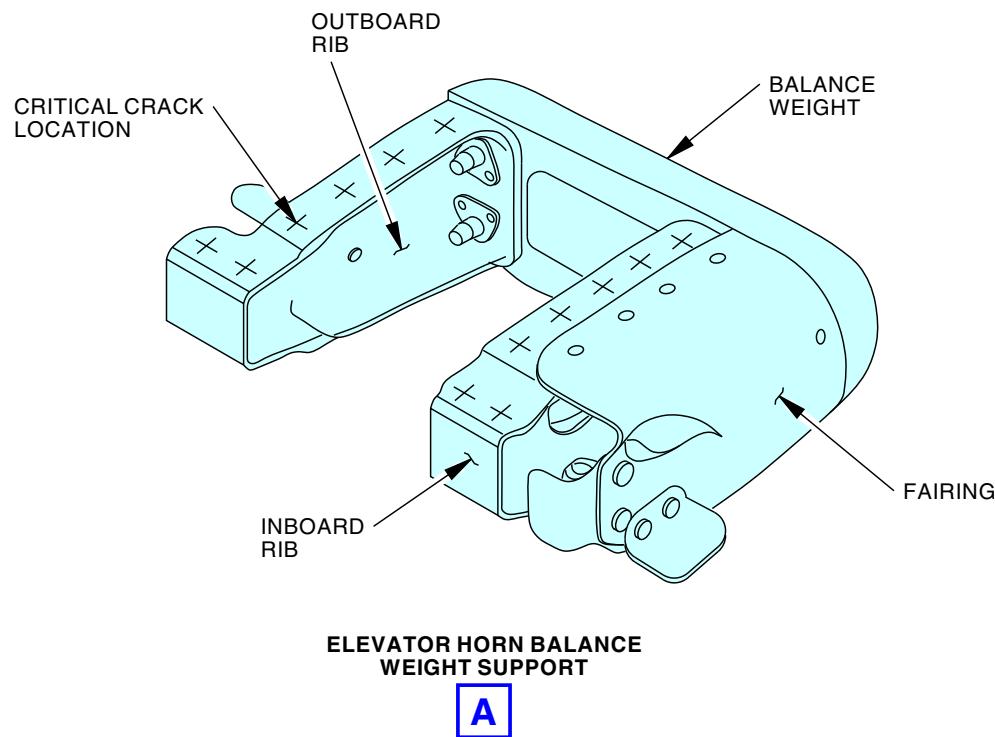
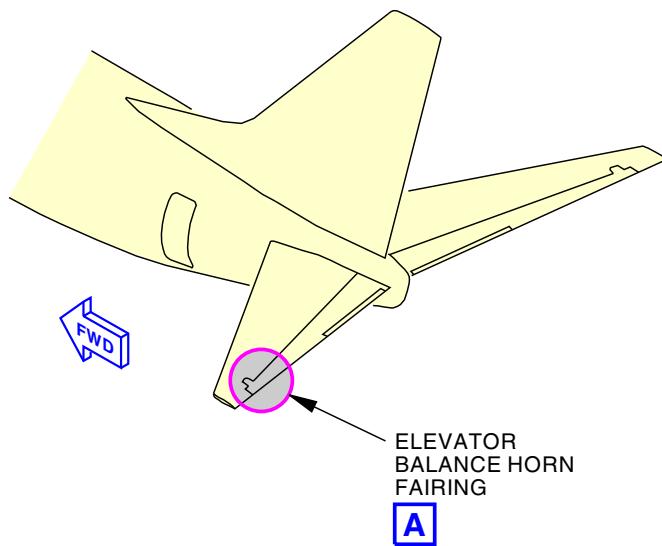
———— END OF TASK ————



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**Elevator Horn Balance Weight Support**  
**Figure 206/55-05-02-990-811**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details



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**TASK 55-05-02-250-838**

**53. INTERNAL - SPECIAL DETAILED: 183A8700 HINGE/MAST ARM FITTING UPPER FLANGE**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
334	Left Horizontal Stabilizer - Elevator
344	Right Horizontal Stabilizer - Elevator

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
334PT	Horizontal Stabilizer, Tab Control Rod Fairing
344PT	Horizontal Stabilizer, Tab Control Rod Fairing, Elevator Sta 34.0

**E. Inspection**

SUBTASK 55-05-02-010-054

- (1) Open this access panel on the Left side:

<b>Number</b>	<b>Name/Location</b>
334PT	Horizontal Stabilizer, Tab Control Rod Fairing

Open this access panel on the Right side:

<b>Number</b>	<b>Name/Location</b>
344PT	Horizontal Stabilizer, Tab Control Rod Fairing, Elevator Sta 34.0

SUBTASK 55-05-02-250-038

- (2) Do a High Frequency Eddy Current inspection around the circumference of the washer at bolt hole 2 and 3 on the mast arm fitting upper flange.

See Doc. D626A001 - DTR, DTR check form 55-20-08-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-15.

SUBTASK 55-05-02-410-052

- (3) Close this access panel on the Left side:

<b>Number</b>	<b>Name/Location</b>
334PT	Horizontal Stabilizer, Tab Control Rod Fairing

Close this access panel on the Right side:

<b>Number</b>	<b>Name/Location</b>
344PT	Horizontal Stabilizer, Tab Control Rod Fairing, Elevator Sta 34.0

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SUBTASK 55-05-02-390-024

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

— END OF TASK —

**TASK 55-05-02-260-802**

**54. EXTERNAL - SPECIAL DETAILED: 183A8300 BRIDGE FITTING UPPER/LOWER FLANGE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 55-05-02-260-002

- (1) Do an X-ray inspection of the upper and lower flanges of hinges 3, 4, 5, and 6.

See Doc. D626A001 - DTR, DTR check form 55-20-09-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 2, Subject 55-10-01.

— END OF TASK —

**TASK 55-05-02-250-841**

**55. INTERNAL - SPECIAL DETAILED: 183A1400 BRACKET ASSEMBLY - TAB CONTROL MECHANISM, ELEVATOR**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

Reference	Title
SRM 51-10-01	Structural Repair Manual

**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
344	Right Horizontal Stabilizer - Elevator

**D. Access Panels**

Number	Name/Location
334AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334GT	Horizontal Stabilizer, Elevator Hinge Cover
344AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator

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<b>Number</b>	<b>Name/Location</b>
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344GT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 39.02

**E. Inspection**

SUBTASK 55-05-02-010-060

- (1) Open these access panels on the Left Side:

<b>Number</b>	<b>Name/Location</b>
334AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334GT	Horizontal Stabilizer, Elevator Hinge Cover

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
344AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344GT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 39.02

NOTE: Remove upper or lower horizontal stabilizer trailing edge seal and elevator inboard hinge cover panel. Bushing removal is not required.

SUBTASK 55-05-02-250-041

- (2) Do a High Frequency Eddy Current inspection of the surface of the fitting and doublers of each bracket assembly around the lug bore.

See Doc. D626A001 - DTR, DTR check form 55-20-12-1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-73.

SUBTASK 55-05-02-410-058

- (3) Close these access panels on the Left Side:

<b>Number</b>	<b>Name/Location</b>
334AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
334GB	Horizontal Stabilizer, Elevator Hinge Cover
334GT	Horizontal Stabilizer, Elevator Hinge Cover

Close these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
344AB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344AT	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
344GB	Horizontal Stabilizer, Hinge Cover, Elevator Station 24.09
344GT	Horizontal Stabilizer, Elevator Hinge Cover, Elevator Sta 39.02

SUBTASK 55-05-02-390-028

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

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**TASK 55-05-02-250-842**

**56. EXTERNAL - SPECIAL DETAILED: VERTICAL FIN - REAR SPAR**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
323	Vertical Fin - Front Spar To Rear Spar
324	Vertical Fin - Rear Spar To Trailing Edge

**B. Inspection**

SUBTASK 55-05-02-250-042

- (1) Do a High Frequency Eddy Current inspection of the exposed chord between the inspar and trailing edge skin from Vertical Fin STA 73.4 to Vertical Fin tip.

See Doc. D626A001 - DTR, DTR check form 55-30-03-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-30-05.

————— END OF TASK ————

**TASK 55-05-02-211-808**

**57. INTERNAL - DETAILED: VERTICAL FIN - CLOSURE RIB**

Figure 207

NOTE: This procedure is a scheduled maintenance task.

**A. References**

Reference	Title
SRM 51-10-01	Structural Repair Manual

**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
324	Vertical Fin - Rear Spar To Trailing Edge

**D. Access Panels**

Number	Name/Location
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



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**E. Inspection**

SUBTASK 55-05-02-010-013

- (1) Open these access panels on the Left side:

**Number      Name/Location**

323BL      Vertical Fin, Forward Fin Access Door

323CL      Vertical Fin, Rear Spar Access Door

Open these access panels on the Right side:

**Number      Name/Location**

323BR      Vertical Fin, Forward Fin Access Door

323CR      Vertical Fin, Rear Spar Access Door

SUBTASK 55-05-02-211-008

- (2) Do a Detailed inspection of the chords lower flange and land-up at the forward end fastener location common to rear spar terminal fitting.

See Doc. D626A001 - DTR, DTR check form 55-30-05-1, for alternative inspection.

SUBTASK 55-05-02-410-013

- (3) Close these access panels on the Left side:

**Number      Name/Location**

323BL      Vertical Fin, Forward Fin Access Door

323CL      Vertical Fin, Rear Spar Access Door

Close these access panels on the Right side:

**Number      Name/Location**

323BR      Vertical Fin, Forward Fin Access Door

323CR      Vertical Fin, Rear Spar Access Door

SUBTASK 55-05-02-390-029

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

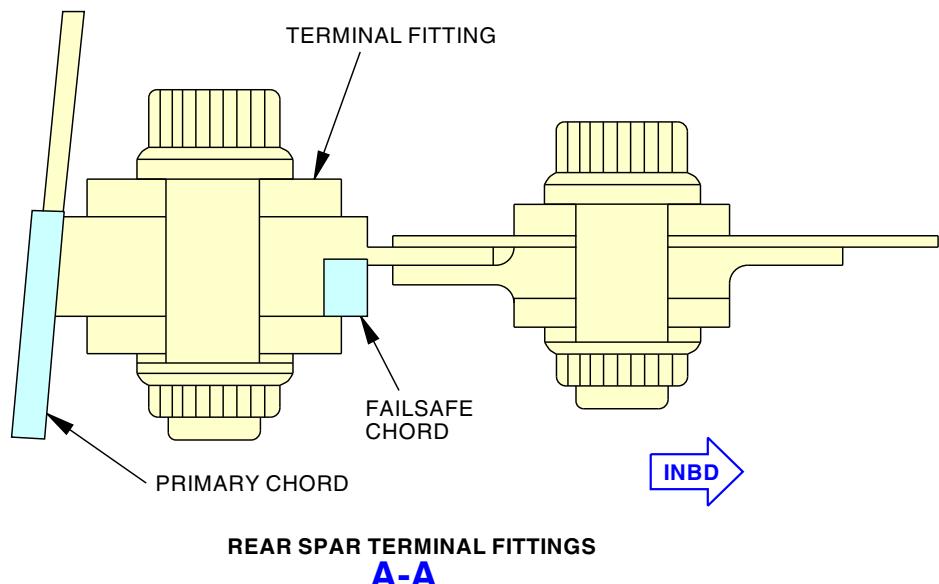
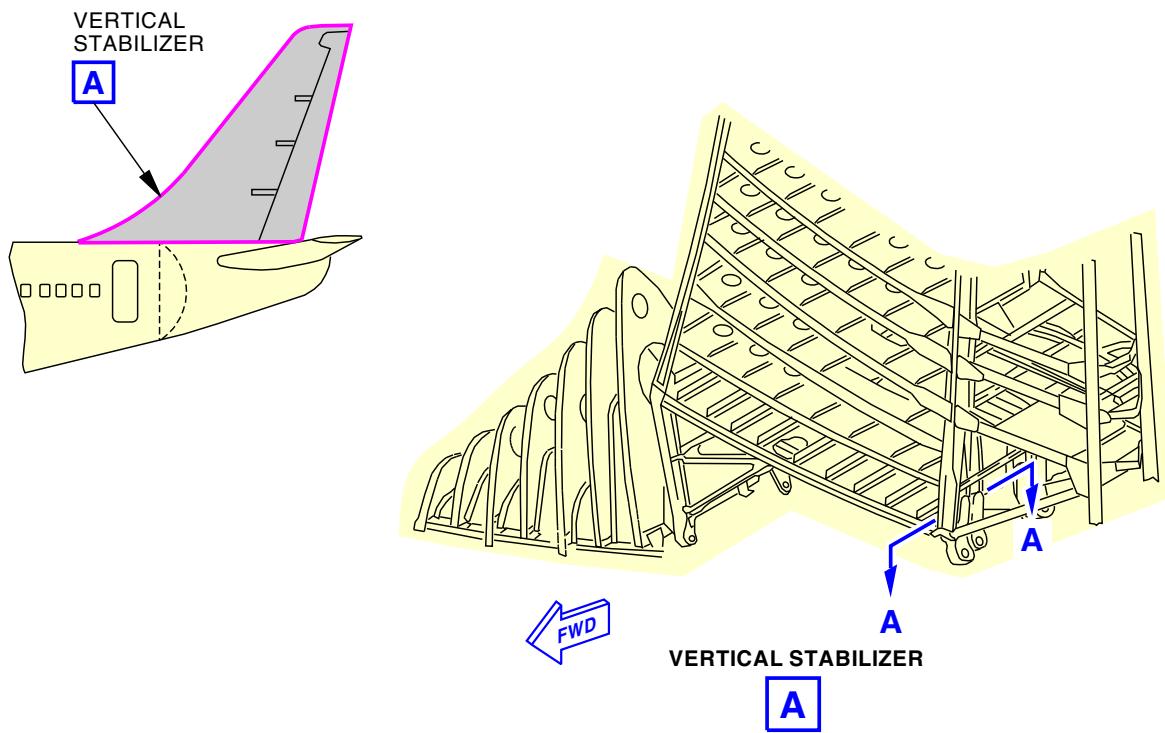
———— END OF TASK ————



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Vertical Fin Closure Rib  
Figure 207/55-05-02-990-808

EFFECTIVITY	LOM ALL
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**TASK 55-05-02-211-809**

**58. INTERNAL - DETAILED: RUDDER HINGE RIBS**

Figure 208

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
324	Vertical Fin - Rear Spar To Trailing Edge

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
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
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
324AL	Vertical Fin, Aft Fin Access Door
324ALL	Rudder Nose Cover/Rudder Hinge No. 1 At Rudder Station 6.96
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
324PL	Vertical Fin, Access

**C. Inspection**

SUBTASK 55-05-02-010-014

- (1) Open these access panels:

<b>Number</b>	<b>Name/Location</b>
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
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
324AL	Vertical Fin, Aft Fin Access Door
324ALL	Rudder Nose Cover/Rudder Hinge No. 1 At Rudder Station 6.96
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

EFFECTIVITY
LOM ALL

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(Continued)

<u>Number</u>	<u>Name/Location</u>
324NL	Vertical Fin, Access
324PL	Vertical Fin, Access

SUBTASK 55-05-02-211-009

- (2) Do a Detailed inspection of the hinge fitting lugs at rib attachment hinge #1, #2, #3, #4, #5, #6, #7, #7A and #8.

See Doc. D626A001 - DTR, DTR check form 55-30-06-1, for alternative inspection.

SUBTASK 55-05-02-410-014

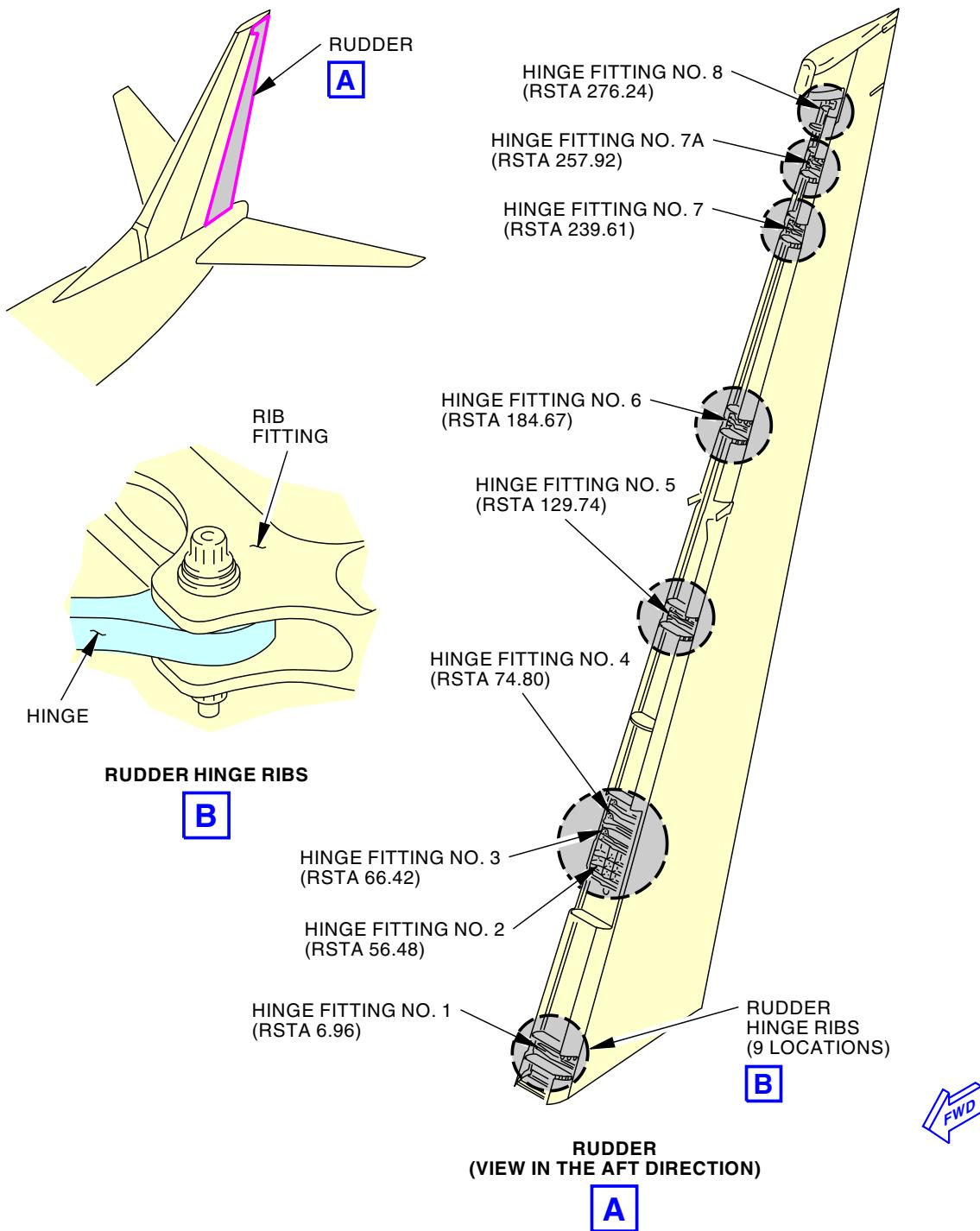
- (3) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
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
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
324AL	Vertical Fin, Aft Fin Access Door
324ALL	Rudder Nose Cover/Rudder Hinge No. 1 At Rudder Station 6.96
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
324PL	Vertical Fin, Access

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

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**Rudder Hinge Ribs**  
**Figure 208/55-05-02-990-806**

EFFECTIVITY  
 LOM ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**TASK 55-05-02-211-810**

**59. INTERNAL - DETAILED: RUDDER HINGE RIBS**

Figure 209

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
324	Vertical Fin - Rear Spar To Trailing Edge

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
323CL	Vertical Fin, Rear Spar Access Door
324AL	Vertical Fin, Aft Fin 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
324PL	Vertical Fin, Access

**C. Inspection**

SUBTASK 55-05-02-010-015

- (1) Open these access panels:

<b>Number</b>	<b>Name/Location</b>
323CL	Vertical Fin, Rear Spar Access Door
324AL	Vertical Fin, Aft Fin 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
324PL	Vertical Fin, Access

NOTE: Removal of the skin panels aft of the fin spar is required.

SUBTASK 55-05-02-211-010

- (2) Do a Detailed inspection of the Rudder Hinge Ribs 1 through 7A at attachment to both Rear Spar Chords.

See Doc. D626A001 - DTR, DTR check form 55-30-06-2, for alternative inspection.

SUBTASK 55-05-02-410-015

- (3) Close these access panels:

<b>Number</b>	<b>Name/Location</b>
323CL	Vertical Fin, Rear Spar Access Door
324AL	Vertical Fin, Aft Fin Access Door
324BL	Vertical Fin, Trailing Edge Access

EFFECTIVITY  
LOM ALL

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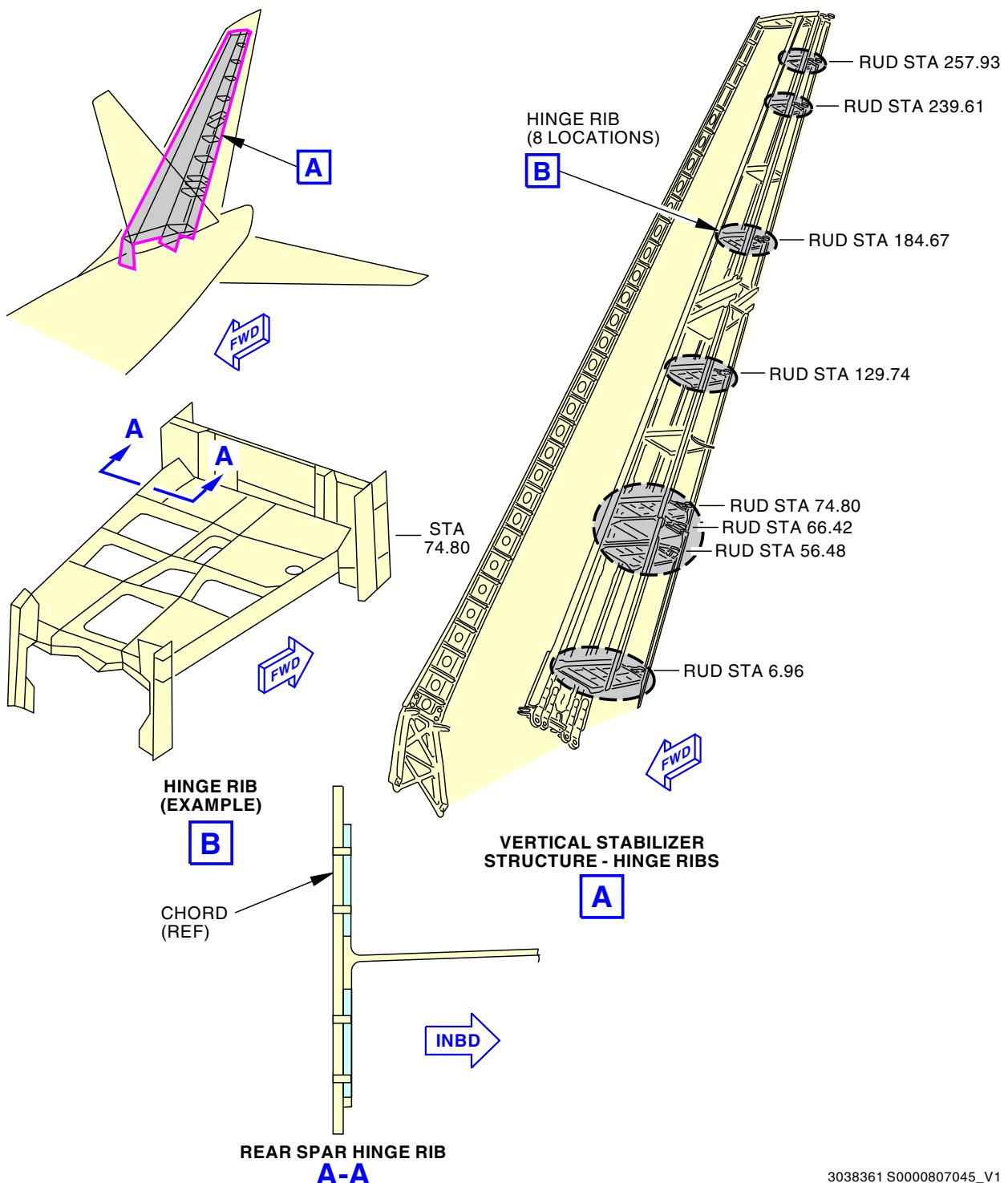
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<u>Number</u>	<u>Name/Location</u>
324DL	Trailing Edge Access
324JL	Vertical Fin, Access
324KL	Vertical Fin, Access
324LL	Vertical Fin, Access
324ML	Vertical Fin, Access
324NL	Vertical Fin, Access
324PL	Vertical Fin, Access

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

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**Rudder Hinge Ribs**  
**Figure 209/55-05-02-990-809**

EFFECTIVITY  
 LOM ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**TASK 55-05-02-211-811**

**60. INTERNAL - DETAILED: RUDDER HINGE FITTINGS**

Figure 210

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
325	Vertical Fin - Rudder

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
324ACL	Rudder Nose Cover/Rudder Hinge No. 8 At Rudder Station 276.24
324ACR	Upper Rudder Gap Cover At Rudder Station 164.90
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

**C. Inspection**

SUBTASK 55-05-02-010-016

- (1) Open these access panels:

<b>Number</b>	<b>Name/Location</b>
324ACL	Rudder Nose Cover/Rudder Hinge No. 8 At Rudder Station 276.24
324ACR	Upper Rudder Gap Cover At Rudder Station 164.90
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

SUBTASK 55-05-02-211-011

- (2) Do an a Detailed inspection of all the rudder hinge fitting clevis lugs and the hinge fitting attachments to the skin and the spar.

See Doc. D626A001 - DTR, DTR check from 55-40-05, for alternative inspection.

SUBTASK 55-05-02-410-016

- (3) Close these access panels:

<b>Number</b>	<b>Name/Location</b>
324ACL	Rudder Nose Cover/Rudder Hinge No. 8 At Rudder Station 276.24
324ACR	Upper Rudder Gap Cover At Rudder Station 164.90
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  
LOM ALL

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(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

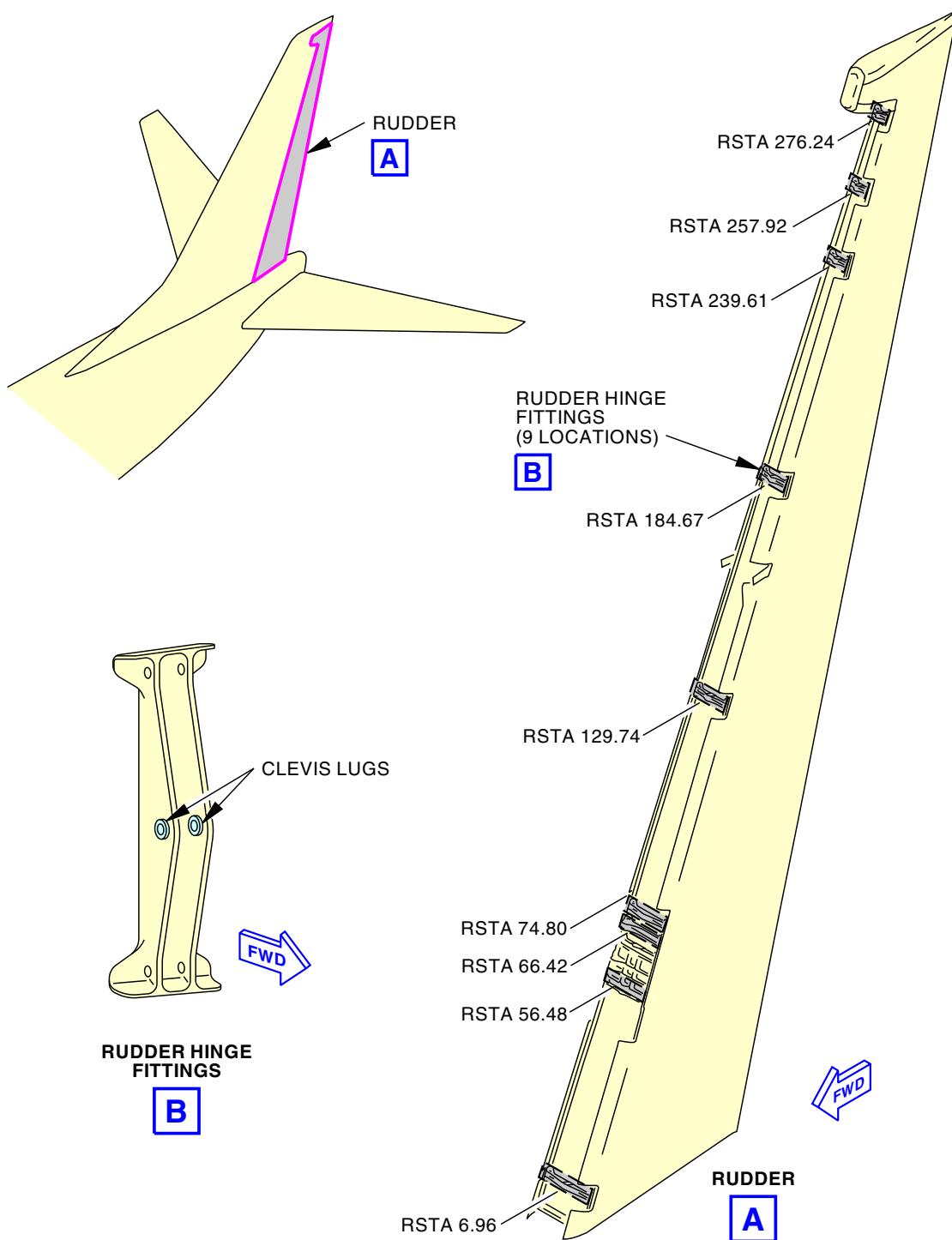
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EFFECTIVITY  
LOM ALL

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Rudder Hinge Fittings  
Figure 210/55-05-02-990-805

EFFECTIVITY  
LOM ALL

**55-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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**TASK 55-05-02-250-844**

**61. INTERNAL - SPECIAL DETAILED: RUDDER ACTUATOR FITTINGS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
325	Vertical Fin - Rudder

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
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

**C. Inspection**

SUBTASK 55-05-02-010-062

- (1) Open these access panels:

<b>Number</b>	<b>Name/Location</b>
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

NOTE: Removal of the actuator rod for access to the inner lug faces is required.

SUBTASK 55-05-02-250-044

- (2) Do a High Frequency Eddy Current inspection of the rudder actuator fitting clevis lugs at rudder STA 60.85 and rudder STA 70.65, as well as visually inspect the hinge fitting attachments to the skin and the spar.

See Doc. D626A001 - DTR, DTR check form 55-40-06, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-50-08.

SUBTASK 55-05-02-410-060

- (3) Close these access panels:

<b>Number</b>	<b>Name/Location</b>
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

———— END OF TASK ————

**TASK 55-05-02-211-812**

**62. INTERNAL - DETAILED: RUDDER BALANCE ARM**

Figure 211

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
325	Vertical Fin - Rudder

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
324ACR	Upper Rudder Gap Cover At Rudder Station 164.90
324ADR	Lower Rudder Gap Cover

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(Continued)

<u>Number</u>	<u>Name/Location</u>
324AGL	Upper Rudder Gap Cover At Rudder Station 164.90
324AXL	Lower Rudder Gap Cover
324WL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin

**C. Inspection**

SUBTASK 55-05-02-010-148

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
324ACR	Upper Rudder Gap Cover At Rudder Station 164.90
324ADR	Lower Rudder Gap Cover
324AGL	Upper Rudder Gap Cover At Rudder Station 164.90
324AXL	Lower Rudder Gap Cover
324WL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin

SUBTASK 55-05-02-211-012

- (2) Do a Detailed inspection of the casting in the area around the doubler as well as the balance arm assembly attachment to the rudder front spar. Additionally, visually inspect the remainder of the balance arm assembly.

See Doc. D626A001 - DTR, DTR check form 55-40-07, for alternative inspection.

SUBTASK 55-05-02-410-146

- (3) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
324ACR	Upper Rudder Gap Cover At Rudder Station 164.90
324ADR	Lower Rudder Gap Cover
324AGL	Upper Rudder Gap Cover At Rudder Station 164.90
324AXL	Lower Rudder Gap Cover
324WL	Panel Assy - Trailing Edge, Beam Seal, Vert Fin

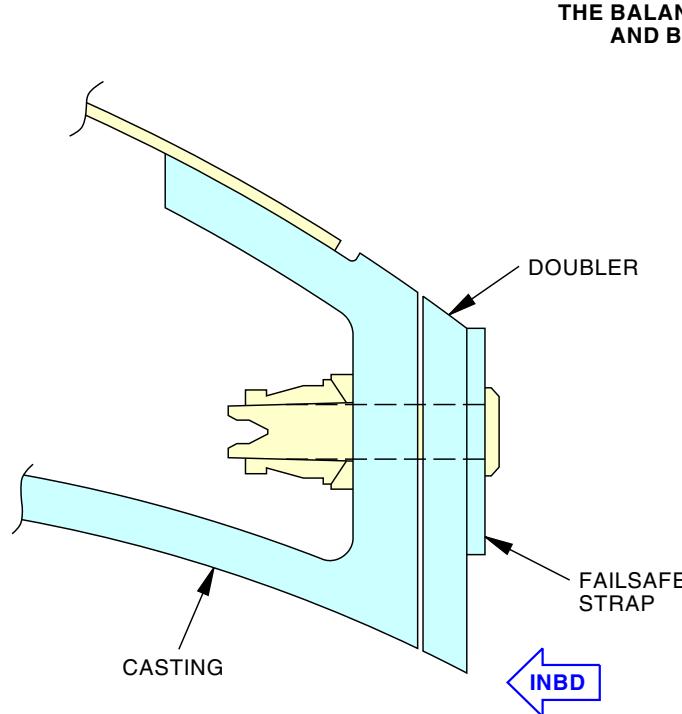
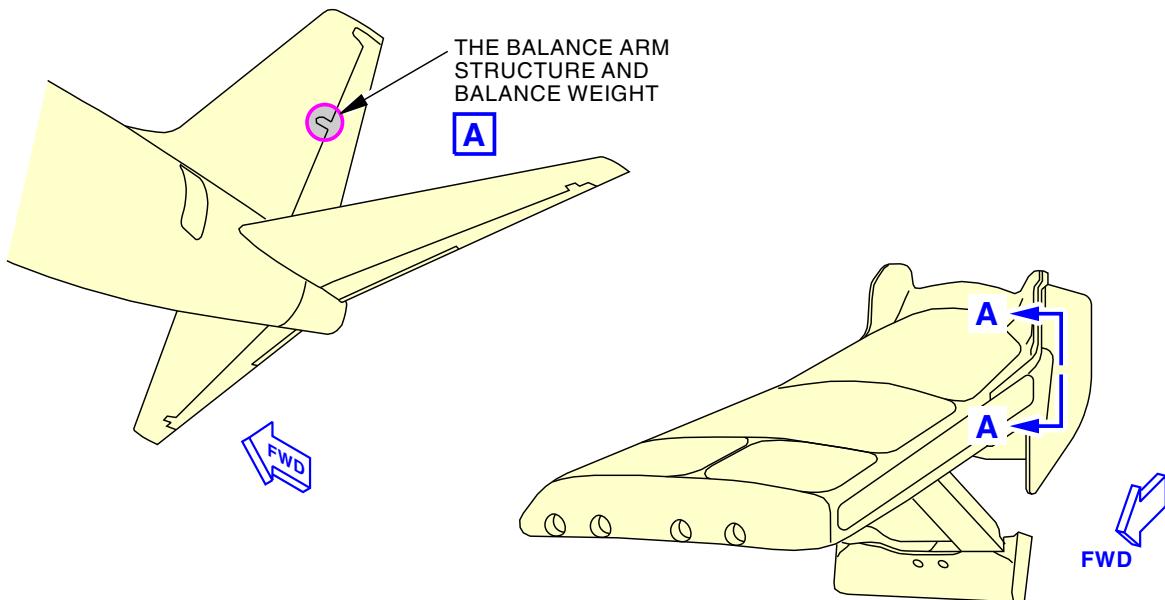
———— END OF TASK ————



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DOUBLER COMMON TO FAILSAFE STRAP  
AND FRONT SPAR CHORD

A-A

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737NG Rudder Balance Arm  
Figure 211/55-05-02-990-810

EFFECTIVITY  
LOM ALL

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**TASK 55-05-02-250-845**

**63. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR LOWER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
55-10-11-000-801	Balance Bay Panels Removal (P/B 401)
55-10-11-400-801	Balance Bay Panels Installation (P/B 401)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
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. Inspection**

**SUBTASK 55-05-02-010-077**

- (1) To remove the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Removal, TASK 55-10-11-000-801.

Open these access panels on the Left side:

<b>Number</b>	<b>Name/Location</b>
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge

Open these access panels on the Right side:

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

**SUBTASK 55-05-02-250-045**

- (2) Do a High Frequency Eddy Current inspection of the rear spar lower chord web flange between the Trailing Edge (TE) ribs from stabilizer STA 212.3 to stabilizer STA 310.54.

See Doc. D626A001 - DTR, DTR check form 55-10-04-5, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-69.

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SUBTASK 55-05-02-410-075

- (3) To install the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Installation, TASK 55-10-11-400-801.

Close these access panels on the Left side:

<b>Number</b>	<b>Name/Location</b>
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge

Close these access panels on the Right side:

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

———— END OF TASK ————

**TASK 55-05-02-250-846**

**64. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR LOWER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**B. Inspection**

SUBTASK 55-05-02-250-046

- (1) Do a Low Frequency Eddy Current inspection of both the fastener rows on the rear spar lower chord FWD flange, at and between the ribs, from stabilizer STA 310.54 to outboard tip.

See Doc. D626A001 - DTR, DTR check form 55-10-04-6, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-56.

———— END OF TASK ————

**TASK 55-05-02-250-847**

**65. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR LOWER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
SRM 51-10-01	Structural Repair Manual



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**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
332MB	Horizontal Stabilizer, Access Door
332NB	Horizontal Stabilizer, Access Door
332PB	Horizontal Stabilizer, Access Door
342MB	Horizontal Stabilizer, Access Door
342NB	Horizontal Stabilizer, Access Door
342PB	Horizontal Stabilizer, Access Door

**E. Inspection**

SUBTASK 55-05-02-010-079

- (1) Open these access panels on the Left side:

<b>Number</b>	<b>Name/Location</b>
332MB	Horizontal Stabilizer, Access Door
332NB	Horizontal Stabilizer, Access Door
332PB	Horizontal Stabilizer, Access Door

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
342MB	Horizontal Stabilizer, Access Door
342NB	Horizontal Stabilizer, Access Door
342PB	Horizontal Stabilizer, Access Door

SUBTASK 55-05-02-250-047

- (2) Do a Low Frequency Eddy Current inspection of the rear spar lower chord from stabilizer STA 310.54 to outboard tip web flange, at and between, the ribs.

See Doc. D626A001-DTR, DTR check form 55-10-04-8, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-50.

SUBTASK 55-05-02-410-077

- (3) Close these access panels on the Left side:

<b>Number</b>	<b>Name/Location</b>
332MB	Horizontal Stabilizer, Access Door
332NB	Horizontal Stabilizer, Access Door
332PB	Horizontal Stabilizer, Access Door

EFFECTIVITY  
LOM ALL

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Close these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
342MB	Horizontal Stabilizer, Access Door
342NB	Horizontal Stabilizer, Access Door
342PB	Horizontal Stabilizer, Access Door

SUBTASK 55-05-02-390-032

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-848**

**66. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR LOWER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**B. Inspection**

SUBTASK 55-05-02-250-082

- (1) Do a High Frequency Eddy Current inspection of the rear spar lower chord at Bay 21-AFT flange at the hinge, from stabilizer STA 242 to stabilizer STA 247, and elevator STA 197 to elevator STA 203.

NOTE: Open the lower trailing edge panel at elevator STA 205.5.

See Doc. D626A001– DTR, DTR check form 55–10–04–9, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-52.

———— END OF TASK ————

**TASK 55-05-02-250-849**

**67. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD AT SIDE-OF-BODY**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

EFFECTIVITY  
LOM ALL

**55-05-02**



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**B. Inspection**

SUBTASK 55-05-02-250-049

- (1) Do a High Frequency Eddy Current inspection of the rear spar upper chord between the terminal fitting fork.

NOTE: Inspection is applicable to all four bolt locations common to the chord and terminal fitting.

- (2) See Doc. D626A001 - DTR, DTR check form 55-10-04-10A, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-27.

———— END OF TASK ————

**TASK 55-05-02-130-815**

**68. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD AT SIDE OF BODY**

**A. Location Zones**

Zone	Area
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**B. Inspection**

SUBTASK 55-05-02-130-015

- (1) Do an Ultrasonic inspection of the rear spar upper chord between the terminal fitting fork.

NOTE: Inspection is applicable to all four bolt locations common to the chord and terminal fitting.

See Doc. D626A001 - DTR, DTR check form 55-10-04-10A, for alternative inspection.

———— END OF TASK ————

**TASK 55-05-02-250-850**

**69. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD AT SIDE OF BODY**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

EFFECTIVITY  
LOM ALL

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**B. Inspection**

SUBTASK 55-05-02-250-050

- (1) Do a High Frequency Eddy Current inspection of the rear spar upper chord between the terminal fitting fork.

NOTE: Inspection is applicable to the inboard bolt location common to the chord and terminal fitting.

See Doc. D626A001 - DTR, DTR check form 55-10-04-10C, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-27.

———— END OF TASK ————

**TASK 55-05-02-130-814**

**70. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD AT SIDE-OF-BODY**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

Reference	Title
55-10-11-000-801	Balance Bay Panels Removal (P/B 401)
55-10-11-400-801	Balance Bay Panels Installation (P/B 401)

**B. Location Zones**

Zone	Area
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**C. Access Panels**

Number	Name/Location
332EB	Horizontal Stabilizer, Access Door
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
342EB	Horizontal Stabilizer, Access Door
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

**D. Inspection**

SUBTASK 55-05-02-010-085

- (1) To remove the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Removal, TASK 55-10-11-000-801.

Open these access panels on the Left side:

Number	Name/Location
332EB	Horizontal Stabilizer, Access Door
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

Open these access panels on the Right side:

Number	Name/Location
342EB	Horizontal Stabilizer, Access Door

EFFECTIVITY  
LOM ALL

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(Continued)

Number    Name/Location

343BB      Horizontal Stabilizer, Access Panel - T.E. Area

NOTE: The aft side is accessed from the trailing edge. The forward side is accessed through the access panel in the lower inspar skin. Sealant removal is required.

SUBTASK 55-05-02-130-025

- (2) Do an Ultrasonic inspection of the rear spar upper chord between the terminal fitting fork.

NOTE: Inspection is applicable to the outboard three bolt locations common to the chord and terminal fitting.

See Doc. D626A001 - DTR, DTR check form 55-10-04-10B, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-24.

SUBTASK 55-05-02-410-083

- (3) To install the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Installation, TASK 55-10-11-400-801.

Close these access panels on the Left side:

Number    Name/Location

332EB      Horizontal Stabilizer, Access Door

333BB      Horizontal Stabilizer, Access Panel, Trailing Edge

Close these access panels on the Right side:

Number    Name/Location

342EB      Horizontal Stabilizer, Access Door

343BB      Horizontal Stabilizer, Access Panel - T.E. Area

———— END OF TASK ————

**TASK 55-05-02-130-816**

**71. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD AT SIDE-OF-BODY**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**B. Inspection**

SUBTASK 55-05-02-130-016

- (1) Do an Ultrasonic inspection of the rear spar upper chord between the terminal fitting fork.

See Doc. D626A001 - DTR, DTR check form 55-10-04-10C, for alternative inspection.

— EFFECTIVITY —  
**LOM ALL**

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The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-24.

NOTE: Inspection is applicable to the inboard bolt location common to the chord and terminal fitting.

————— END OF TASK ————

**TASK 55-05-02-250-851**

**72. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**B. Inspection**

SUBTASK 55-05-02-250-051

- (1) Do a Low Frequency Eddy Current inspection of both the forward and aft rear spar upper chord flanges from stabilizer STA 67.78 to stabilizer STA 203.10.

See Doc. D626A001 - DTR, DTR check form 55-10-04-11A, for alternative inspection.

————— END OF TASK ————

**TASK 55-05-02-250-852**

**73. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**B. Inspection**

SUBTASK 55-05-02-250-052

- (1) Do a High Frequency Eddy Current inspection of the rear spar upper cord from stabilizer STA 67.78 to stabilizer STA 203.10.

See Doc. D626A001 - DTR, DTR check form 55-10-04-11A, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-76.

————— END OF TASK ————

————— EFFECTIVITY ————  
LOM ALL

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**TASK 55-05-02-250-853**

**74. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**B. Inspection**

SUBTASK 55-05-02-250-053

- (1) Do a Low Frequency Eddy Current inspection of both the forward and aft rear spar upper chord skin flanges from stabilizer STA 203.10 to stabilizer STA 258.28.

See Doc. D626A001 - DTR, DTR check form 55-10-04-11B, for alternative inspection.

————— END OF TASK ————

**TASK 55-05-02-130-817**

**75. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

Reference	Title
55-10-11-000-801	Balance Bay Panels Removal (P/B 401)
55-10-11-400-801	Balance Bay Panels Installation (P/B 401)

**B. Location Zones**

Zone	Area
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**C. Access Panels**

Number	Name/Location
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
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. Inspection**

SUBTASK 55-05-02-010-083

- (1) To remove the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Removal, TASK 55-10-11-000-801.

EFFECTIVITY  
LOM ALL

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Open these access panels on the Left side:

<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

Open these access panels on the Right side:

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

**SUBTASK 55-05-02-130-017**

- (2) Do an Ultrasonic inspection of the rear spar upper chord web flange at the rib and stiffener locations from stabilizer STA 203.1 to stabilizer STA 258.28.

See Doc. D626A001 - DTR, DTR check form 55-10-04-11C, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-19.

**SUBTASK 55-05-02-410-081**

- (3) To install the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Installation, TASK 55-10-11-400-801.

Close these access panels on the Left side:

<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

Close these access panels on the Right side:

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

— END OF TASK —

**TASK 55-05-02-250-854**

**76. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
55-10-11-000-801	Balance Bay Panels Removal (P/B 401)
55-10-11-400-801	Balance Bay Panels Installation (P/B 401)

**B. Location Zones**

<u>Zone</u>	<u>Area</u>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge



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**Zone      Area**

342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**C. Access Panels**

**Number      Name/Location**

333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
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. Inspection**

SUBTASK 55-05-02-010-087

- (1) To remove the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Removal, TASK 55-10-11-000-801.

Open these access panels on the Left side:

**Number      Name/Location**

333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge

Open these access panels on the Right side:

**Number      Name/Location**

343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area

SUBTASK 55-05-02-250-054

- (2) Do a High Frequency Eddy Current inspection of the rear spar upper chord web flange between the ribs and stiffeners from stabilizer STA 203.10 to stabilizer STA 258.28.

NOTE: Remove sealant in excess of .20" on either side of the fastener head or collar.

See Doc. D626A001 - DTR, DTR check form 55-10-04-11D, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-59.

SUBTASK 55-05-02-410-085

- (3) To install the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Installation, TASK 55-10-11-400-801.

Close these access panels on the Left side:

**Number      Name/Location**

333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge



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Close these access panels on the Right side:

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

———— END OF TASK ————

**TASK 55-05-02-250-855**

**77. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**B. Inspection**

SUBTASK 55-05-02-250-055

- (1) Do a Low Frequency Eddy Current inspection of the rear spar upper chord, at the forward flange of the chord, from stabilizer STA 258.28 to the tip.

See Doc. D626A001 - DTR, DTR check form 55-10-04-12A, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-62.

———— END OF TASK ————

**TASK 55-05-02-250-856**

**78. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**B. Inspection**

SUBTASK 55-05-02-250-056

- (1) Do a Low Frequency Eddy Current inspection of the rear spar upper cord, at the aft flange of the cord, from stabilizer STA 258.28 to the tip.

See Doc. D626A001 - DTR, DTR check form 55-10-04-12B, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-62.

———— END OF TASK ————

EFFECTIVITY
LOM ALL

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**TASK 55-05-02-130-818**

**79. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area

**E. Inspection**

SUBTASK 55-05-02-010-089

- (1) Open these access panels on the Left side:

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

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area

SUBTASK 55-05-02-130-018

- (2) Do an Ultrasonic inspection of the rear spar upper cord web flange, at the rib and stiffener locations, from stabilizer STA 258.28 to stabilizer STA 310.54.

See Doc. D626A001 - DTR, DTR check form 55-10-04-13A, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Section 55-10-19.

EFFECTIVITY
LOM ALL

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SUBTASK 55-05-02-410-087

- (3) Close these access panels on the Left side:

**Number**

**Name/Location**

333EB Horizontal Stabilizer, Access Panel, Trailing Edge

333FB Horizontal Stabilizer, Access Panel, Trailing Edge

Close these access panels on the Right side:

**Number**

**Name/Location**

343EB Horizontal Stabilizer, Access Panel - T.E. Area

343FB Horizontal Stabilizer, Access Panel - T.E. Area

SUBTASK 55-05-02-390-033

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-130-819**

**80. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION THRUST LINK FITTINGS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

**Zone**

**Area**

313 Stabilizer Torsion Box Compartment - Left

314 Stabilizer Torsion Box Compartment - Right

**B. Access Panels**

**Number**

**Name/Location**

311BL Stabilizer Trim Access Door

**C. Prepare for the inspection**

SUBTASK 55-05-02-860-033

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-02-860-034

- (2) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-1**

**Row**

**Col**

**Number**

**Name**

C 2 C00849 AFCS STABILIZER TRIM

**F/O Electrical System Panel, P6-2**

**Row**

**Col**

**Number**

**Name**

B 10 C00207 FLIGHT CONTROL STAB TRIM CONT

D 10 C00840 FLIGHT CONTROL STAB TRIM ACTUATOR

**D. Inspection**

SUBTASK 55-05-02-010-105

- (1) Open this access panel:

**Number**

**Name/Location**

311BL Stabilizer Trim Access Door

EFFECTIVITY
LOM ALL

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NOTE: Remove fittings to inspect the fitting lugs, 4 lugs per fitting. Access horizontal stabilizer center section through opening in center of 1088 bulkhead.

SUBTASK 55-05-02-130-023

- (2) Do an Ultrasonic inspection of the fitting lugs on the horizontal stabilizer center section thrust link fittings. There are 4 lugs per fitting.

See Doc. D626A001 - DTR, DTR check form 55-10-02-3, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-23.

SUBTASK 55-05-02-410-103

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**E. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-05-02-860-035

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

**CAPT Electrical System Panel, P18-1**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
C	2	C00849	AFCS STABILIZER TRIM

**F/O Electrical System Panel, P6-2**

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

SUBTASK 55-05-02-860-036

- (2) Set the stabilizer leading edge to the NORMAL position.

———— END OF TASK ————

**TASK 55-05-02-250-857**

**81. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81



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(Continued)

**Zone      Area**

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

**D. Access Panels**

**Number      Name/Location**

332MB	Horizontal Stabilizer, Access Door
332NB	Horizontal Stabilizer, Access Door
332PB	Horizontal Stabilizer, Access Door
342MB	Horizontal Stabilizer, Access Door
342NB	Horizontal Stabilizer, Access Door
342PB	Horizontal Stabilizer, Access Door

**E. Inspection**

SUBTASK 55-05-02-010-093

- (1) Open these access panels on the Left side:

**Number      Name/Location**

332MB	Horizontal Stabilizer, Access Door
332NB	Horizontal Stabilizer, Access Door
332PB	Horizontal Stabilizer, Access Door

Open these access panels on the Right side:

**Number      Name/Location**

342MB	Horizontal Stabilizer, Access Door
342NB	Horizontal Stabilizer, Access Door
342PB	Horizontal Stabilizer, Access Door

NOTE: Access is through the lower inspar skin access hole. Subsurface inspection of the chord is through the web or through the web and stiffener.

SUBTASK 55-05-02-250-057

- (2) Do a Low Frequency Eddy Current inspection of the rear spar upper cord web flange, at and between the ribs/stiffeners, from stabilizer STA 310.54 to tip.

See Doc. D626A001 - DTR, DTR check form 55-10-04-13C, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-60.

SUBTASK 55-05-02-410-091

- (3) Close these access panels on the Left side:

**Number      Name/Location**

332MB	Horizontal Stabilizer, Access Door
332NB	Horizontal Stabilizer, Access Door
332PB	Horizontal Stabilizer, Access Door

Close these access panels on the Right side:

**Number      Name/Location**

342MB	Horizontal Stabilizer, Access Door
342NB	Horizontal Stabilizer, Access Door
342PB	Horizontal Stabilizer, Access Door

EFFECTIVITY  
LOM ALL

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SUBTASK 55-05-02-390-034

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-858**

**82. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR WEB**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
55-10-11-000-801	Balance Bay Panels Removal (P/B 401)
55-10-11-400-801	Balance Bay Panels Installation (P/B 401)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**C. Access Panels**

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

**D. Inspection**

SUBTASK 55-05-02-010-095

- (1) To remove the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Removal, TASK 55-10-11-000-801.

Open these access panels on the Left side:

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

Open these access panels on the Right side:

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

NOTE: Access is through the removable trailing edge lower skin panels. The DTR curve assumes no fillet seal. Remove any fillet seals present.

SUBTASK 55-05-02-250-058

- (2) Do a High Frequency Eddy Current inspection of the rear spar web at the lower edge of the fail-safe chord, at and between the stiffeners, from stabilizer STA 83.5 to stabilizer STA 184.7.

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LOM ALL

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See Doc. D626A001 - DTR, DTR check form 55-10-04-20, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-68.

SUBTASK 55-05-02-410-093

- (3) To install the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Installation, TASK 55-10-11-400-801.

Close these access panels on the Left side:

**Number      Name/Location**

333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge

Close these access panels on the Right side:

**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

———— END OF TASK ————

**TASK 55-05-02-250-859**

**83. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR WEB**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

Reference	Title
55-10-11-000-801	Balance Bay Panels Removal (P/B 401)
55-10-11-400-801	Balance Bay Panels Installation (P/B 401)

**B. Location Zones**

Zone	Area
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**C. Access Panels**

Number	Name/Location
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
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. Inspection**

SUBTASK 55-05-02-010-097

- (1) To remove the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Removal, TASK 55-10-11-000-801.

EFFECTIVITY  
LOM ALL

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Open these access panels on the Left side:

<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

Open these access panels on the Right side:

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

**SUBTASK 55-05-02-250-059**

NOTE: Access is through the removable Trailing Edge Lower Skin Panels. The DTR curve assumes no fillet seal. Remove any fillet seals present.

- (2) Do a High Frequency Eddy Current inspection of the rear spar web at the lower edge of the upper chord, at and between the stiffeners, from stabilizer STA 184.7 to stabilizer STA 285.9.

See Doc. D626A001 - DTR, DTR check form 55-10-04-21, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-68.

**SUBTASK 55-05-02-410-095**

- (3) To install the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Installation, TASK 55-10-11-400-801.

Close these access panels on the Left side:

<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

Close these access panels on the Right side:

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

———— END OF TASK ————

**TASK 55-05-02-250-860**

**84. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR WEB**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
55-10-11-000-801	Balance Bay Panels Removal (P/B 401)
55-10-11-400-801	Balance Bay Panels Installation (P/B 401)

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LOM ALL

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**B. Location Zones**

<b>Zone</b>	<b>Area</b>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
343FB	Horizontal Stabilizer, Access Panel - T.E. Area

**D. Inspection**

SUBTASK 55-05-02-010-099

- (1) To remove the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Removal, TASK 55-10-11-000-801.

Open this access panel on the Left side:

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

Open this access panel on the Right side:

<b>Number</b>	<b>Name/Location</b>
343FB	Horizontal Stabilizer, Access Panel - T.E. Area

NOTE: Access is through the removable Trailing Edge Panel Lower Skin Panels. The DTR curve assumes no fillet seal. Remove any fillet seals present.

SUBTASK 55-05-02-250-060

- (2) Do a High Frequency Eddy Current inspection of the rear spar web at the upper and lower chord edges, at and between the stiffeners, from stabilizer STA 285.9 to stabilizer STA 310.5.

See Doc. D626A001 - DTR, DTR check form 55-10-04-22, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-68.

SUBTASK 55-05-02-410-097

- (3) To install the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Installation, TASK 55-10-11-400-801.

Close this access panel on the Left side:

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

Close this access panel on the Right side:

<b>Number</b>	<b>Name/Location</b>
343FB	Horizontal Stabilizer, Access Panel - T.E. Area

— END OF TASK —

**TASK 55-05-02-250-861**

**85. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR WEB**

NOTE: This procedure is a scheduled maintenance task.



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**A. References**

<b>Reference</b>	<b>Title</b>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
332MB	Horizontal Stabilizer, Access Door
332NB	Horizontal Stabilizer, Access Door
332PB	Horizontal Stabilizer, Access Door
342MB	Horizontal Stabilizer, Access Door
342NB	Horizontal Stabilizer, Access Door
342PB	Horizontal Stabilizer, Access Door

**E. Inspection**

SUBTASK 55-05-02-010-101

- (1) Open these access panels on the Left side:

<b>Number</b>	<b>Name/Location</b>
332MB	Horizontal Stabilizer, Access Door
332NB	Horizontal Stabilizer, Access Door
332PB	Horizontal Stabilizer, Access Door

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
342MB	Horizontal Stabilizer, Access Door
342NB	Horizontal Stabilizer, Access Door
342PB	Horizontal Stabilizer, Access Door

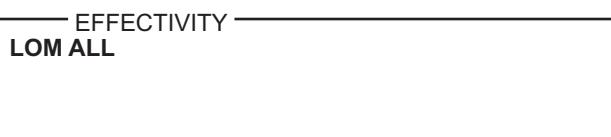
NOTE: Access is through the inspar lower skin access panels. The DTR curve assumes no fillet seal. Remove any fillet seals present.

SUBTASK 55-05-02-250-061

- (2) Do a High Frequency Eddy Current inspection of the rear spar web at the upper and lower web to chord fastener locations, between the stiffeners, from stabilizer STA 310.5 to outboard tip.

See Doc. D626A001 - DTR, DTR check form 55-10-04-23, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-68.



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SUBTASK 55-05-02-410-099

- (3) Close these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
332MB	Horizontal Stabilizer, Access Door
332NB	Horizontal Stabilizer, Access Door
332PB	Horizontal Stabilizer, Access Door

Close these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
342MB	Horizontal Stabilizer, Access Door
342NB	Horizontal Stabilizer, Access Door
342PB	Horizontal Stabilizer, Access Door

SUBTASK 55-05-02-390-035

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-130-820**

**86. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR WEB**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<u>Zone</u>	<u>Area</u>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**D. Access Panels**

<u>Number</u>	<u>Name/Location</u>
332MB	Horizontal Stabilizer, Access Door
332NB	Horizontal Stabilizer, Access Door
332PB	Horizontal Stabilizer, Access Door
342MB	Horizontal Stabilizer, Access Door
342NB	Horizontal Stabilizer, Access Door
342PB	Horizontal Stabilizer, Access Door



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**E. Inspection**

SUBTASK 55-05-02-010-103

- (1) Open these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
332MB	Horizontal Stabilizer, Access Door
332NB	Horizontal Stabilizer, Access Door
332PB	Horizontal Stabilizer, Access Door

Open these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
342MB	Horizontal Stabilizer, Access Door
342NB	Horizontal Stabilizer, Access Door
342PB	Horizontal Stabilizer, Access Door

NOTE: Access is through the inspar lower skin access panels.

SUBTASK 55-05-02-130-020

- (2) Do an Ultrasonic inspection of the rear spar web at the stiffeners common to both the upper and lower chords from stabilizer STA 310.5 to outboard tip.

See Doc. D626A001 - DTR, DTR check form 55-10-04-24, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-22.

SUBTASK 55-05-02-410-101

- (3) Close these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
332MB	Horizontal Stabilizer, Access Door
332NB	Horizontal Stabilizer, Access Door
332PB	Horizontal Stabilizer, Access Door

Close these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
342MB	Horizontal Stabilizer, Access Door
342NB	Horizontal Stabilizer, Access Door
342PB	Horizontal Stabilizer, Access Door

SUBTASK 55-05-02-390-036

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-130-821**

**87. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER AND FAILSAFE CHORD LUGS**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
SRM 51-10-01	Structural Repair Manual

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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 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

D. Access Panels

Number	Name/Location
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

E. Inspection

SUBTASK 55-05-02-010-106

- (1) Open these access panels on the Left side:

Number	Name/Location
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

Open these access panels on the Right side:

Number	Name/Location
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

NOTE: Removal of gap covers is required.

SUBTASK 55-05-02-130-021

- (2) Do an Ultrasonic inspection of the rear spar upper and failsafe chord lugs.

See Doc. D626A001 - DTR, DTR check form 55-10-05-1, for alternative inspection.

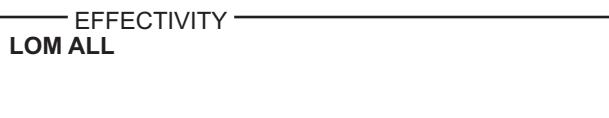
The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-15.

SUBTASK 55-05-02-410-159

- (3) Close this access panel on the Left side:

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

- (a) Make sure that the blade seal is installed correctly into the forward track channel.



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- (4) Close this access panel on the Right side:

**Number      Name/Location**

343AB      Horizontal Stabilizer, Gap Cover - H. Stab. to Body

- (a) Make sure that the blade seal is installed correctly into the forward track channel.

SUBTASK 55-05-02-410-104

- (5) Close these access panels on the Left side:

**Number      Name/Location**

332AB      Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

333AT      Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

Close these access panels on the Right side:

**Number      Name/Location**

342AB      Horizontal Stabilizer, Gap Cover - H. Stab. to Body

343AT      Horizontal Stabilizer, Gap Cover - H. Stab. to Body

SUBTASK 55-05-02-390-037

- (6) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-130-822**

**88. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD  
TERMINAL FITTING**

Figure 212

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
55-10-11-000-801	Balance Bay Panels Removal (P/B 401)
55-10-11-400-801	Balance Bay Panels Installation (P/B 401)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
332EB	Horizontal Stabilizer, Access Door
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
342EB	Horizontal Stabilizer, Access Door
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

**D. Inspection**

SUBTASK 55-05-02-010-108

- (1) To remove the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Removal, TASK 55-10-11-000-801.

EFFECTIVITY
LOM ALL

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Open these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
332EB	Horizontal Stabilizer, Access Door
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

Open these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
342EB	Horizontal Stabilizer, Access Door
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

NOTE: The aft side is accessed from the trailing edge. The forward side is accessed through the access panel in the inspar lower skin. Sealant, if present, must be removed for inspection.

SUBTASK 55-05-02-130-022

- (2) Do an Ultrasonic inspection of the forward and aft sides of the terminal fitting around the three inboard fasteners common to the spar chord.

NOTE: Bolts and bushings should remain installed for the inspection. Remove any sealant present.

See Doc. D626A001 - DTR, DTR check form 55-10-05-2A, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-13.

SUBTASK 55-05-02-410-106

- (3) To install the applicable trailing edge access panels for the horizontal stabilizer, refer to Balance Bay Panels Installation, TASK 55-10-11-400-801.

Close these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
332EB	Horizontal Stabilizer, Access Door
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

Close these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
342EB	Horizontal Stabilizer, Access Door
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

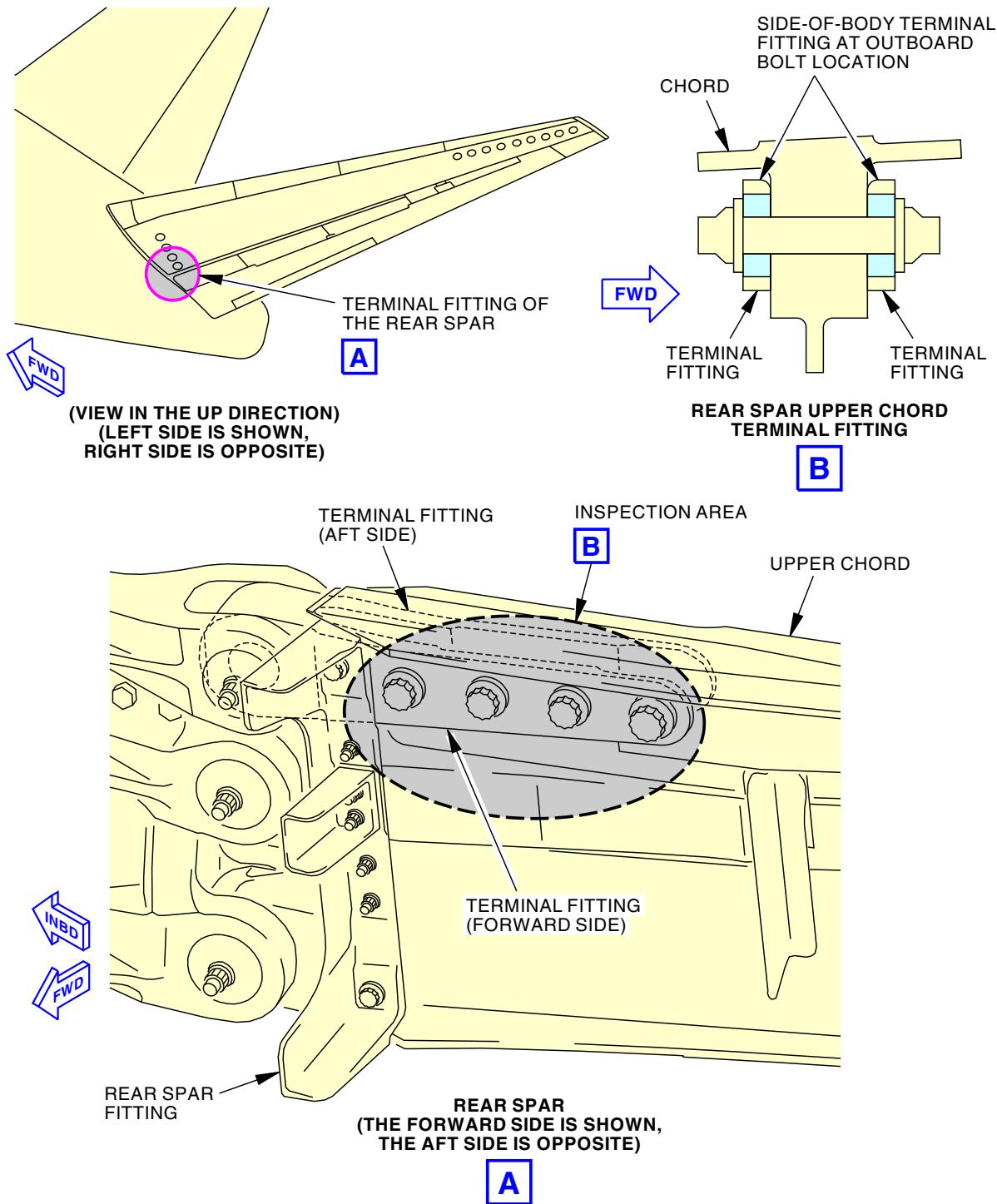
**55-05-02**

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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Horizontal Stabilizer Rear Spar Upper Chord Terminal Fitting  
Figure 212/55-05-02-990-812

EFFECTIVITY  
LOM ALL

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TASK 55-05-02-250-862

89. **INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD TERMINAL FITTING**

**A. References**

Reference	Title
SRM 51-10-01	Structural Repair Manual

**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 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**D. Access Panels**

Number	Name/Location
332EB	Horizontal Stabilizer, Access Door
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
342EB	Horizontal Stabilizer, Access Door
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

**E. Inspection**

SUBTASK 55-05-02-010-110

- (1) For the Left Stabilizer, open these access panels:

Number	Name/Location
332EB	Horizontal Stabilizer, Access Door
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

SUBTASK 55-05-02-010-111

- (2) For the Right Stabilizer, open these access panels:

Number	Name/Location
342EB	Horizontal Stabilizer, Access Door
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

SUBTASK 55-05-02-250-062

NOTE: The aft side is accessed from the trailing edge. The forward side is accessed through the access panel in the inspar lower skin. Sealant, if present, must be removed for inspection.

EFFECTIVITY
LOM ALL

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- (3) Do an inspection (High Frequency Eddy Current) of the forward and aft sides of the terminal fitting around the three inboard fasteners common to the spar chord.

NOTE: Bolts and bushings should remain installed for the inspection. Remove any sealant present.

NOTE: See Doc. D626A001 - DTR, DTR check form 55-10-05-2A, for alternative inspection.

NOTE: The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-18.

SUBTASK 55-05-02-410-108

- (4) For the Left Stabilizer, close these access panels:

<u>Number</u>	<u>Name/Location</u>
332EB	Horizontal Stabilizer, Access Door
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

SUBTASK 55-05-02-410-109

- (5) For the Right Stabilizer, close these access panels:

<u>Number</u>	<u>Name/Location</u>
342EB	Horizontal Stabilizer, Access Door
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

SUBTASK 55-05-02-390-038

- (6) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

————— END OF TASK ————

**TASK 55-05-02-211-813**

**90. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD  
TERMINAL FITTING**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<u>Zone</u>	<u>Area</u>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**D. Access Panels**

<u>Number</u>	<u>Name/Location</u>
332EB	Horizontal Stabilizer, Access Door
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge



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(Continued)

<u>Number</u>	<u>Name/Location</u>
342EB	Horizontal Stabilizer, Access Door
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

**E. Inspection**

SUBTASK 55-05-02-010-112

- (1) Open these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
332EB	Horizontal Stabilizer, Access Door
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

Open these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
342EB	Horizontal Stabilizer, Access Door
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

NOTE: The aft side is accessed from the trailing edge. The forward side is accessed through the access panel in the lower inspar skin. Use of a Bore scope is required.

SUBTASK 55-05-02-211-013

- (2) Do a Detailed inspection of the forward and aft sides of the terminal fitting at the outboard attach bolt location.

NOTE: Bolts and bushings should remain installed for the inspection. Sealant removal is required.

See Doc. D626A001 - DTR, DTR check form 55-10-05-2B, for alternative inspection.

SUBTASK 55-05-02-410-110

- (3) Close these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
332EB	Horizontal Stabilizer, Access Door
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

Close these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
342EB	Horizontal Stabilizer, Access Door
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

SUBTASK 55-05-02-390-039

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

— END OF TASK —

**TASK 55-05-02-250-863**

**91. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR LOWER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
SRM 51-10-01	Structural Repair Manual



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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 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

D. Access Panels

Number	Name/Location
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332EB	Horizontal Stabilizer, Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342EB	Horizontal Stabilizer, Access Door
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

E. Inspection

SUBTASK 55-05-02-010-119

- (1) Open these access panels on the Left side:

Number	Name/Location
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332EB	Horizontal Stabilizer, Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

Open these access panels on the Right side:

Number	Name/Location
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342EB	Horizontal Stabilizer, Access Door
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

NOTE: The inspection requires the removal of the bolt.

SUBTASK 55-05-02-250-063

- (2) Do a High Frequency Eddy Current inspection of the rear spar lower chord at the side of body, common to the Side of Body (SOB) rib tension bolt hole.

See Doc. D626A001 - DTR, DTR check form 55-10-05-5, for alternative inspection.

EFFECTIVITY
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The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-48.

**SUBTASK 55-05-02-410-160**

- (3) Close this access panel on the Left side:

**Number      Name/Location**

333AB      Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

(a) Make sure that the blade seal is installed correctly into the forward track channel.

- (4) Close this access panel on the Right side:

**Number      Name/Location**

343AB      Horizontal Stabilizer, Gap Cover - H. Stab. to Body

(a) Make sure that the blade seal is installed correctly into the forward track channel.

**SUBTASK 55-05-02-410-117**

- (5) Close these access panels on the Left side:

**Number      Name/Location**

332AB      Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

332EB      Horizontal Stabilizer, Access Door

333AT      Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

333BB      Horizontal Stabilizer, Access Panel, Trailing Edge

Close these access panels on the Right side:

**Number      Name/Location**

342AB      Horizontal Stabilizer, Gap Cover - H. Stab. to Body

342EB      Horizontal Stabilizer, Access Door

343AT      Horizontal Stabilizer, Gap Cover - H. Stab. to Body

343BB      Horizontal Stabilizer, Access Panel - T.E. Area

**SUBTASK 55-05-02-390-040**

- (6) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-864**

**92. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR UPPER CHORD,  
FORWARD FLANGE**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
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)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

EFFECTIVITY  
LOM ALL

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**C. Access Panels**

<u>Number</u>	<u>Name/Location</u>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**D. Inspection**

SUBTASK 55-05-02-010-115

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.

- (a) Open this access panel on the Left side:

Number    Name/Location

331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
------	--

Open this access panel on the Right side:

Number    Name/Location

341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ
------	--

NOTE: Removal of the horizontal stabilizer removable leading edge is required.

SUBTASK 55-05-02-250-064

- (2) Do a High Frequency Eddy Current inspection of the front spar upper chord forward flange from stabilizer STA 67.71 to outboard tip.

NOTE: Inspection requires probe placement on primed metal surface.

See Doc. D626A001 - DTR, DTR check form 55-10-06-3, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-46.

SUBTASK 55-05-02-410-113

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.

- (a) Close this access panel on the Left side:

Number    Name/Location

331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
------	--

Close this access panel on the Right side:

Number    Name/Location

341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ
------	--

———— END OF TASK ————

**TASK 55-05-02-250-865**

**93. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR UPPER CHORD - WEB FLANGE**

NOTE: This procedure is a scheduled maintenance task.

EFFECTIVITY
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**A. References**

<b>Reference</b>	<b>Title</b>
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)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**D. Inspection**

SUBTASK 55-05-02-010-116

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.
  - (a) Open this access panel on the Left side:

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Open this access panel on the Right side:

<b>Number</b>	<b>Name/Location</b>
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

NOTE: Removal of the Leading Edge is required for inspection access.

SUBTASK 55-05-02-250-065

- (2) Do a Low Frequency Eddy Current inspection of the front spar upper chord web flange from stabilizer STA 66.5 to stabilizer STA 75.0.

See Doc. D626A001 - DTR, DTR check form 55-10-06-4A, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-45.

SUBTASK 55-05-02-410-114

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.

(a) Close this access panel on the Left side:

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

EFFECTIVITY  
LOM ALL

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Close this access panel on the Right side:

**Number      Name/Location**

341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ
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———— END OF TASK ————

**TASK 55-05-02-250-866**

**94. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR UPPER CHORD - WEB FLANGE**

**A. References**

<b>Reference</b>	<b>Title</b>
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)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**D. Inspection**

**SUBTASK 55-05-02-010-121**

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.
  - (a) Open this access panel on the Left side:

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Open this access panel on the Right side:

<b>Number</b>	<b>Name/Location</b>
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

NOTE: Removal of the Leading Edge is required for inspection access.

**SUBTASK 55-05-02-250-066**

- (2) Do a High Frequency Eddy Current inspection of the front spar upper chord web flange from stabilizer STA 66.5 to stabilizer STA 175.5 and stabilizer STA 258.28 to stabilizer tip.

NOTE: Inspection requires probe placement on primed metal surface.

See Doc. D626A001 - DTR, DTR check form 55-10-06-4A, for alternative inspection.

EFFECTIVITY  
LOM ALL

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The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-47.

SUBTASK 55-05-02-410-119

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.  
(a) Close this access panel on the Left side:

**Number      Name/Location**

331B      Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Close this access panel on the Right side:

**Number      Name/Location**

341B      Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

————— END OF TASK ————

**TASK 55-05-02-250-868**

**95. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR UPPER CHORD - WEB FLANGE**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
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)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**D. Inspection**

SUBTASK 55-05-02-010-124

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.  
(a) Open this access panel on the Left side:

**Number      Name/Location**

331B      Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

EFFECTIVITY  
LOM ALL

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Open this access panel on the Right side:

**Number      Name/Location**

341B      Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**NOTE:** Removal of the horizontal stabilizer leading edge and the removable front spar web is required for inspection access.

**SUBTASK 55-05-02-250-068**

- (2) Do a High Frequency Eddy Current inspection of the front spar upper chord web flange from stabilizer STA 175.5 to stabilizer STA 258.28.

**NOTE:** Inspection requires probe placement on primed metal surface.

See Doc. D626A001 - DTR, DTR check form 55-10-06-4B, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-47.

**SUBTASK 55-05-02-410-122**

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.

- (a) Close this access panel on the Left side:

**Number      Name/Location**

331B      Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Close this access panel on the Right side:

**Number      Name/Location**

341B      Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

———— END OF TASK ————

**TASK 55-05-02-250-869**

**96. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR LOWER CHORD - AFT FLANGE**

**NOTE:** This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**B. Inspection**

**SUBTASK 55-05-02-250-069**

- (1) Do a Low Frequency Eddy Current inspection of the front spar lower chord aft flange from stabilizer STA 66.50 to stabilizer STA 175.50.

See Doc. D626A001 - DTR, DTR check form 55-10-06-6B, for alternative inspection.

— EFFECTIVITY —  
LOM ALL

**55-05-02**



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The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-53.

————— END OF TASK ————

**TASK 55-05-02-250-870**

**97. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR LOWER CHORD,  
FORWARD FLANGE**

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)

**B. Location Zones**

Zone	Area
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**C. Access Panels**

Number	Name/Location
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**D. Inspection**

SUBTASK 55-05-02-010-128

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.
  - (a) Open this access panel on the Left side:

Number	Name/Location
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Open this access panel on the Right side:

Number	Name/Location
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

NOTE: Removal of the leading edge panel is required to gain access to the lower surface of the forward flange.

SUBTASK 55-05-02-250-070

- (2) Do a High Frequency Eddy Current inspection of the front spar lower chord forward flange from stabilizer STA 175.50 to stabilizer STA 258.28.

See Doc. D626A001 - DTR, DTR check form 55-10-06-7A, for alternative inspection.

EFFECTIVITY  
LOM ALL

**55-05-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-51.

SUBTASK 55-05-02-410-126

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.  
(a) Close this access panel on the Left side:

**Number      Name/Location**

331B      Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Close this access panel on the Right side:

**Number      Name/Location**

341B      Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

————— END OF TASK ————

**TASK 55-05-02-250-871**

**98. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge
333FB	Horizontal Stabilizer, Access Panel, Trailing Edge
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area

**E. Inspection**

SUBTASK 55-05-02-010-091

- (1) Open these access panels on the Left side:

**Number      Name/Location**

333EB      Horizontal Stabilizer, Access Panel, Trailing Edge

EFFECTIVITY  
LOM ALL

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**AIRCRAFT MAINTENANCE MANUAL**

(Continued)

**Number      Name/Location**

333FB      Horizontal Stabilizer, Access Panel, Trailing Edge

Open these access panels on the Right side:

**Number      Name/Location**

343EB      Horizontal Stabilizer, Access Panel - T.E. Area

343FB      Horizontal Stabilizer, Access Panel - T.E. Area

SUBTASK 55-05-02-250-071

- (2) Do a High Frequency Eddy Current inspection of the rear spar upper chord web flange, between the rib and stiffener locations, from stabilizer STA 258.28 to stabilizer STA 310.54.

See Doc. D626A001 - DTR, DTR check form 55-10-04-13B, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-59.

SUBTASK 55-05-02-410-089

- (3) Close these access panels on the Left side:

**Number      Name/Location**

333EB      Horizontal Stabilizer, Access Panel, Trailing Edge

333FB      Horizontal Stabilizer, Access Panel, Trailing Edge

Close these access panels on the Right side:

**Number      Name/Location**

343EB      Horizontal Stabilizer, Access Panel - T.E. Area

343FB      Horizontal Stabilizer, Access Panel - T.E. Area

SUBTASK 55-05-02-390-041

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-872**

**99. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR LOWER CHORD, AFT FLANGE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

**Zone      Area**

331      Left Horizontal Stabilizer - Removable Leading Edge

332      Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

341      Right Horizontal Stabilizer - Removable Leading Edge

342      Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**B. Inspection**

SUBTASK 55-05-02-250-072

- (1) Do a Low Frequency Eddy Current inspection of the front spar lower chord aft flange from stabilizer STA 175.50 to stabilizer STA 258.28.

See Doc. D626A001 - DTR, DTR check form 55-10-06-7B, for alternative inspection.

EFFECTIVITY  
LOM ALL

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The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-57.

————— END OF TASK ————

**TASK 55-05-02-250-873**

**100. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR LOWER CHORD, AFT FLANGE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**B. Inspection**

SUBTASK 55-05-02-250-073

- (1) Do a Low Frequency Eddy Current inspection of the front spar lower chord aft flange from stabilizer STA 258.28 to stabilizer BL 281.81 (tip).

See Doc. D626A001 - DTR, DTR check form 55-10-06-8B, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-57.

————— END OF TASK ————

**TASK 55-05-02-250-874**

**101. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR LOWER CHORD, FORWARD FLANGE**

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)

**B. Location Zones**

Zone	Area
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**C. Access Panels**

Number	Name/Location
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

— EFFECTIVITY —

LOM ALL

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(Continued)

<u>Number</u>	<u>Name/Location</u>
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**D. Inspection**

SUBTASK 55-05-02-010-130

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.
  - (a) Open this access panel on the Left side:

<u>Number</u>	<u>Name/Location</u>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Open this access panel on the Right side:

<u>Number</u>	<u>Name/Location</u>
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

NOTE: Leading edge skin assembly removal is required for the inspection.

SUBTASK 55-05-02-250-074

- (2) Do a High Frequency Eddy Current inspection of the front spar lower chord forward flange from stabilizer STA 258.28 to stabilizer BL 281.81.

See Doc. D626A001 - DTR, DTR check form 55-10-06-8A, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-51.

SUBTASK 55-05-02-410-128

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.

(a) Close this access panel on the Left side:

<u>Number</u>	<u>Name/Location</u>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Close this access panel on the Right side:

<u>Number</u>	<u>Name/Location</u>
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

———— END OF TASK ————

**TASK 55-05-02-250-875**

**102. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR WEB**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
27-41-21-000-801	Horizontal Stabilizer Leading Edge - Removal (P/B 401)

EFFECTIVITY
LOM ALL

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(Continued)

Reference	Title
27-41-21-400-801	Horizontal Stabilizer Leading Edge - Installation (P/B 401)

**B. Location Zones**

Zone	Area
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**C. Access Panels**

Number	Name/Location
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**D. Inspection**

SUBTASK 55-05-02-010-132

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.
  - (a) Open this access panel on the Left side:

Number	Name/Location
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Open this access panel on the Right side:

Number	Name/Location
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**NOTE:** The inspection requires removal of the horizontal stabilizer leading edge.

SUBTASK 55-05-02-250-075

- (2) Do a High Frequency Eddy Current inspection of the front spar web, at the upper and lower spar chord attachments, from stabilizer STA 66.5 to stabilizer STA 111.1.

See Doc. D626A001 - DTR, DTR check form 55-10-06-W1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-58.

SUBTASK 55-05-02-410-130

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.

(a) Close this access panel on the Left side:

Number	Name/Location
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

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LOM ALL

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Close this access panel on the Right side:

**Number      Name/Location**

341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ
------	--

———— END OF TASK ————

**TASK 55-05-02-250-876**

**103. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR WEB**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
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)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**D. Inspection**

**SUBTASK 55-05-02-010-134**

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.
  - (a) Open this access panel on the Left side:

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Open this access panel on the Right side:

<b>Number</b>	<b>Name/Location</b>
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

NOTE: The inspection requires removal of the horizontal stabilizer leading edge.

**SUBTASK 55-05-02-250-076**

- (2) Do a High Frequency Eddy Current inspection of the front spar web splice, at the upper and lower web edges at stabilizer STA 111.1.

See Doc. D626A001 - DTR, DTR check form 55-10-06-WS, for alternative inspection.

EFFECTIVITY  
LOM ALL

**55-05-02**



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The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-58.

NOTE: Inspection requires probe placement on primed metal surface.

SUBTASK 55-05-02-410-132

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.  
(a) Close this access panel on the Left side:

**Number      Name/Location**

331B      Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Close this access panel on the Right side:

**Number      Name/Location**

341B      Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

———— END OF TASK ————

**TASK 55-05-02-250-877**

**104. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR WEB**

**A. Inspection**

SUBTASK 55-05-02-250-077

- (1) Do the inspection

———— END OF TASK ————

**TASK 55-05-02-250-878**

**105. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR WEB**

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)

**B. Location Zones**

Zone	Area
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**C. Access Panels**

Number	Name/Location
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

— EFFECTIVITY —

LOM ALL

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**D. Inspection**

SUBTASK 55-05-02-010-138

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.  
(a) Open this access panel on the Left side:

**Number      Name/Location**

331B      Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Open this access panel on the Right side:

**Number      Name/Location**

341B      Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**NOTE:** The inspection requires removal of the horizontal stabilizer leading edge.  
Remove any cap seal, that is present, on nut plated BACB30NM fasteners.

SUBTASK 55-05-02-250-078

- (2) Do a High Frequency Eddy Current inspection of the front spar web, at the upper and lower spar chord attachments, from stabilizer STA 175.5 to stabilizer STA 258.28.

See Doc. D626A001 - DTR, DTR check form 55-10-06-W3, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-58.

SUBTASK 55-05-02-410-136

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.

(a) Close this access panel on the Left side:

**Number      Name/Location**

331B      Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Close this access panel on the Right side:

**Number      Name/Location**

341B      Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

———— END OF TASK ————

**TASK 55-05-02-250-879**

**106. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR WEB**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
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)

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LOM ALL

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**B. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**D. Inspection**

SUBTASK 55-05-02-010-140

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.

- (a) Open this access panel on the Left side:

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Open this access panel on the Right side:

<b>Number</b>	<b>Name/Location</b>
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

NOTE: The inspection requires removal of the horizontal stabilizer leading edge.  
Remove any cap sealant that is present.

SUBTASK 55-05-02-250-079

- (2) Do a High Frequency Eddy Current inspection of the front spar web, at the upper and lower spar chord attachments, from stabilizer STA 258.28 to stabilizer tip.

See Doc. D626A001 - DTR, DTR check form 55-10-06-W4, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-58.

SUBTASK 55-05-02-410-138

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.

- (a) Close this access panel on the Left side:

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Close this access panel on the Right side:

<b>Number</b>	<b>Name/Location</b>
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

EFFECTIVITY  
LOM ALL

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— END OF TASK —

**TASK 55-05-02-250-880**

**107. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR LOWER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342AT	Gap Cover, Horizontal Stabilizer

**E. Inspection**

**SUBTASK 55-05-02-010-142**

- (1) Open these access panels on the Left side:

<b>Number</b>	<b>Name/Location</b>
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342AT	Gap Cover, Horizontal Stabilizer

NOTE: The inspection requires the removal of the bolt.

**SUBTASK 55-05-02-250-080**

- (2) Do a High frequency Eddy Current inspection of the lower chord at the end rib tension fitting installation bolt hole.

See Doc. D626A001 - DTR, DTR check form 55-10-07-4, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-83.

— EFFECTIVITY —  
**LOM ALL**

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SUBTASK 55-05-02-410-140

- (3) Close these access panels on the Left side:

**Number      Name/Location**

332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

Close these access panels on the Right side:

**Number      Name/Location**

342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342AT	Gap Cover, Horizontal Stabilizer

SUBTASK 55-05-02-390-042

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

**TASK 55-05-02-250-881**

**108. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER UPPER INSPAR SKIN**

**A. Inspection**

SUBTASK 55-05-02-250-081

- (1) Do the inspection

———— END OF TASK ————

**TASK 55-05-02-130-823**

**109. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION JACKSCREW FITTING**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

**Zone      Area**

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

**B. Access Panels**

**Number      Name/Location**

311BL	Stabilizer Trim Access Door
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**C. Inspection**

SUBTASK 55-05-02-010-123

- (1) Open this access panel:

**Number      Name/Location**

311BL	Stabilizer Trim Access Door
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SUBTASK 55-05-02-130-024

- (2) Do an Ultrasonic inspection of the horizontal stabilizer center section jackscrew fitting lugs.

See Doc. D626A001 - DTR, DTR check form 55-10-03-1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-04.

EFFECTIVITY  
LOM ALL

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SUBTASK 55-05-02-410-121

- (3) Close this access panel:

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

————— END OF TASK ————

**TASK 55-05-02-211-814**

**110. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR WEB**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
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)

**B. Location Zones**

<u>Zone</u>	<u>Area</u>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**C. Access Panels**

<u>Number</u>	<u>Name/Location</u>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**D. Inspection**

SUBTASK 55-05-02-010-136

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.  
(a) Open this access panel on the Left side:

<u>Number</u>	<u>Name/Location</u>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Open this access panel on the Right side:

<u>Number</u>	<u>Name/Location</u>
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

NOTE: The inspection requires removal of the horizontal stabilizer leading edge.  
Remove any sealant which exceeds .30" on either side of a fastener head or collar.

SUBTASK 55-05-02-211-014

- (2) Do a High Frequency Eddy Current inspection of the front spar web, at the upper and lower spar chord attachments, from stabilizer STA 111.1 to stabilizer STA 175.5.

See Doc. D626A001 - DTR, DTR check form 55-10-06-W2, for alternative inspection.

EFFECTIVITY  
LOM ALL

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The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 55-10-58.

SUBTASK 55-05-02-410-134

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.  
(a) Close this access panel on the Left side:

**Number      Name/Location**

331B      Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Close this access panel on the Right side:

**Number      Name/Location**

341B      Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

————— END OF TASK ————

**TASK 55-05-02-130-824**

**111. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER CENTER SECTION PIVOT FITTING**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

**B. Access Panels**

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

**C. Prepare for the inspection**

SUBTASK 55-05-02-860-061

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-02-860-062

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

**CAPT Electrical System Panel, P18-1**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
C	2	C00849	AFCS STABILIZER TRIM

**F/O Electrical System Panel, P6-2**

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



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**D. Inspection**

SUBTASK 55-05-02-130-026

- (1) Open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

NOTE: Removal of gap covers and sliding seals is required.

SUBTASK 55-05-02-130-027

- (2) Do an Ultrasonic inspection of the pivot fitting plates at the lower hinge housing lugs.

See Doc. D626A001 - DTR, DTR check form 55-10-02-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 55-10-27.

SUBTASK 55-05-02-130-028

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

**E. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-05-02-860-063

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

**CAPT Electrical System Panel, P18-1**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
C	2	C00849	AFCS STABILIZER TRIM

**F/O Electrical System Panel, P6-2**

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

SUBTASK 55-05-02-860-064

- (2) Set the stabilizer leading edge to the NORMAL position.

———— END OF TASK ————

**TASK 55-05-02-250-882**

**112. EXTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR UPPER CHORD**

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**B. Inspection**

SUBTASK 55-05-02-250-084

- (1) Do a High Frequency Eddy Current inspection of the front spar upper chord from the side of body to stabilizer STA 66.5.

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See Doc. D626A001 - DTR, DTR check form 55-10-06-1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-44.

NOTE: Inspection requires probe placement on primed metal surface.

————— END OF TASK ————

**TASK 55-05-02-250-883**

**113. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER REAR SPAR UPPER CHORD  
TERMINAL FITTING (L4)**

**A. References**

Reference	Title
SRM 51-10-01	Structural Repair Manual

**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 281.81
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**D. Access Panels**

Number	Name/Location
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332EB	Horizontal Stabilizer, Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342EB	Horizontal Stabilizer, Access Door
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

**E. Inspection**

SUBTASK 55-05-02-010-151

- (1) Open these access panels on the Left side:

Number	Name/Location
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332EB	Horizontal Stabilizer, Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

— EFFECTIVITY —  
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Open these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342EB	Horizontal Stabilizer, Access Door
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

NOTE: Removal of the tension bolt is required.

**SUBTASK 55-05-02-250-085**

- (2) Do a High Frequency Eddy Current inspection of the rear spar upper chord terminal fitting at the Side of Body (SOB) rib tension bolt hole.

See Doc. D626A001 - DTR, DTR check form 55-10-05-4, for alternative repeat inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-49.

**SUBTASK 55-05-02-410-161**

- (3) Close this access panel on the Left side:

<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 track channel.

- (4) Close this access panel on the Right side:

<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 track channel.

**SUBTASK 55-05-02-410-149**

- (5) Close these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332EB	Horizontal Stabilizer, Access Door
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge

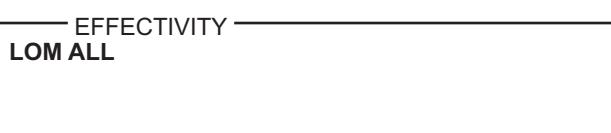
Close these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342EB	Horizontal Stabilizer, Access Door
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

**SUBTASK 55-05-02-390-043**

- (6) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————



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**TASK 55-05-02-250-884**

**114. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR UPPER CHORD - WEB FLANGE**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
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)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**D. Inspection**

**SUBTASK 55-05-02-010-152**

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.
  - (a) Open this access panel on the Left side:

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Open this access panel on the Right side:

<b>Number</b>	<b>Name/Location</b>
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

NOTE: Removal of the Leading Edge is required for inspection access.

**SUBTASK 55-05-02-250-086**

- (2) Do a High Frequency Eddy Current inspection of the front spar upper chord web flange from stabilizer STA 258.28 to outboard tip.

NOTE: Inspection requires probe placement on primed metal surface.

See Doc. D626A001 - DTR, DTR check form 55-10-06-4E, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-54.

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SUBTASK 55-05-02-410-150

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.  
(a) Close this access panel on the Left side:

**Number**

**Name/Location**

331B

Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Close this access panel on the Right side:

**Number**

**Name/Location**

341B

Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

— END OF TASK —

**TASK 55-05-02-250-885**

**115. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR UPPER CHORD - WEB FLANGE**

**NOTE:** This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
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)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**D. Inspection**

SUBTASK 55-05-02-010-153

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.  
(a) Open this access panel on the Left side:

**Number**

**Name/Location**

331B

Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

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Open this access panel on the Right side:

**Number**    **Name/Location**

341B        Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

NOTE: Removal of the Leading Edge is required for inspection access.

SUBTASK 55-05-02-250-087

- (2) Do a Low Frequency Eddy Current inspection of the front spar upper chord web flange from stabilizer STA 75.0 to stabilizer STA 175.5 except at web splice, stabilizer STA 111.1.

NOTE: Inspection requires probe placement on primed metal surface.

See Doc. D626A001 - DTR, DTR check form 55-10-06-4C, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-66.

SUBTASK 55-05-02-410-151

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.

- (a) Close this access panel on the Left side:

**Number**    **Name/Location**

331B        Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Close this access panel on the Right side:

**Number**    **Name/Location**

341B        Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

———— END OF TASK ————

**TASK 55-05-02-250-886**

**116. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR UPPER CHORD - WEB FLANGE**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
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)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

EFFECTIVITY  
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C. Access Panels

Number	Name/Location
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

D. Inspection

SUBTASK 55-05-02-010-154

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.

- (a) Open this access panel on the Left side:

Number    Name/Location

331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
------	--

Open this access panel on the Right side:

Number    Name/Location

341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ
------	--

NOTE: Removal of the Leading Edge is required for inspection access.

SUBTASK 55-05-02-250-088

- (2) Do a High Frequency Eddy Current inspection of the front spar upper chord web flange from stabilizer STA 75.0 to stabilizer STA 175.5 except at web splice, stabilizer STA 111.1.

NOTE: Inspection requires probe placement on primed metal surface.

See Doc. D626A001 - DTR, DTR check form 55-10-06-4C, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-66.

SUBTASK 55-05-02-410-152

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.

- (a) Close this access panel on the Left side:

Number    Name/Location

331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
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Close this access panel on the Right side:

Number    Name/Location

341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ
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———— END OF TASK ————

**TASK 55-05-02-250-887**

**117. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR UPPER CHORD - WEB FLANGE**

NOTE: This procedure is a scheduled maintenance task.

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**A. References**

<b>Reference</b>	<b>Title</b>
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)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**D. Inspection**

SUBTASK 55-05-02-010-155

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.
  - (a) Open this access panel on the Left side:

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Open this access panel on the Right side:

<b>Number</b>	<b>Name/Location</b>
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

NOTE: Removal of the Leading Edge is required for inspection access.

SUBTASK 55-05-02-250-089

- (2) Do a Low Frequency Eddy Current inspection of the front spar upper chord web flange at web splice from STA 110.24 to STA 111.96.

NOTE: Inspection requires probe placement on primed metal surface.

See Doc. D626A001 - DTR, DTR check form 55-10-06-4D, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-70.

SUBTASK 55-05-02-410-153

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.

EFFECTIVITY
LOM ALL

**55-05-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (a) Close this access panel on the Left side:

**Number      Name/Location**

331B      Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Close this access panel on the Right side:

**Number      Name/Location**

341B      Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

———— END OF TASK ————

**TASK 55-05-02-250-888**

**118. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR UPPER CHORD - WEB FLANGE**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
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)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

**D. Inspection**

**SUBTASK 55-05-02-010-156**

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.

- (a) Open this access panel on the Left side:

**Number      Name/Location**

331B      Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Open this access panel on the Right side:

**Number      Name/Location**

341B      Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

NOTE: Removal of the Leading Edge is required for inspection access.

EFFECTIVITY LOM ALL
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**55-05-02**



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SUBTASK 55-05-02-250-090

- (2) Do a High Frequency Eddy Current inspection of the front spar upper chord web flange at web splice from STA 110.24 to STA 111.96.

NOTE: Inspection requires probe placement on primed metal surface.

See Doc. D626A001 - DTR, DTR check form 55-10-06-4D, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-70.

SUBTASK 55-05-02-410-154

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.

- (a) Close this access panel on the Left side:

**Number**    **Name/Location**

331B        Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Close this access panel on the Right side:

**Number**    **Name/Location**

341B        Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

————— END OF TASK ————

**TASK 55-05-02-250-889**

**119. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER FRONT SPAR UPPER CHORD,  
FORWARD FLANGE**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
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)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge
332	Left Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
341	Right Horizontal Stabilizer - Removable Leading Edge
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ



**55-05-02**



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D. Inspection

SUBTASK 55-05-02-010-157

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.
  - (a) Open this access panel on the Left side:

Number    Name/Location

331B        Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Open this access panel on the Right side:

Number    Name/Location

341B        Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

NOTE: Removal of the horizontal stabilizer removable leading edge is required.

SUBTASK 55-05-02-250-091

- (2) Do a Low Frequency Eddy Current inspection of the front spar upper chord forward flange from stabilizer STA 67.71 to outboard tip.

NOTE: Inspection requires probe placement on primed metal surface.

See Doc. D626A001 - DTR, DTR check form 55-10-06-3, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 55-10-84.

SUBTASK 55-05-02-410-155

- (3) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.

- (a) Close this access panel on the Left side:

Number    Name/Location

331B        Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Close this access panel on the Right side:

Number    Name/Location

341B        Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**55-05-02**





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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. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 55-05-03-010-001

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
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) 737-6789 Basic Task Description, AMM Task 51-05-01-210-809.

SUBTASK 55-05-03-410-001

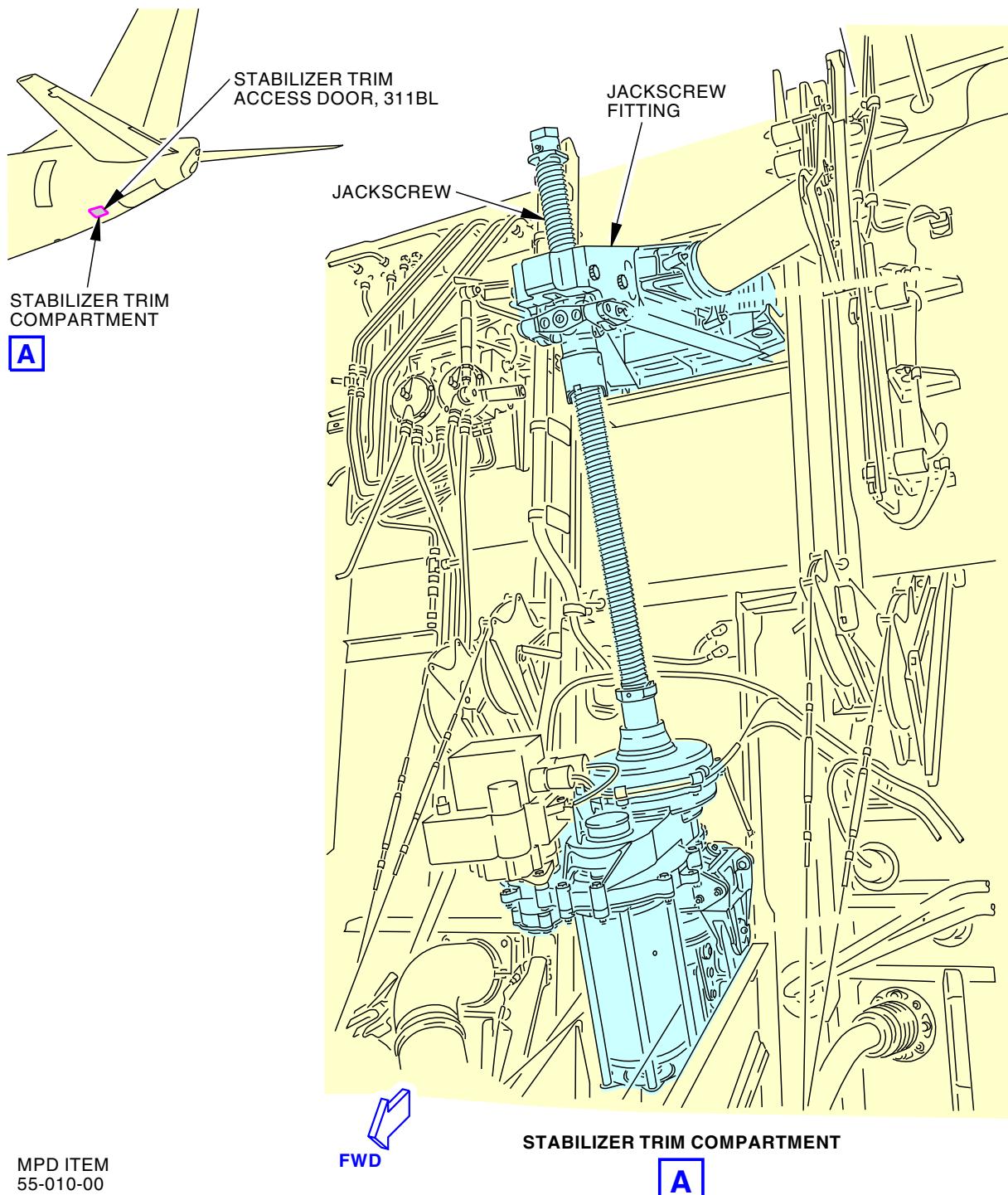
- (4) Close this access panel:

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

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**55-05-03**

MPD ITEM  
55-010-00

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INTERNAL-GENERAL VISUAL: HORIZONTAL STABILIZER CENTER SECTION  
Figure 201/55-05-03-990-821EFFECTIVITY  
LOM ALL

55-05-03

D633A101-LOM



737-600/700/800/900  
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**

<u>Reference</u>	<u>Title</u>
51-05-01-210-804	737-6789 Basic Task Description (P/B 201)

**B. Location Zones**

<u>Zone</u>	<u>Area</u>
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right

**C. Access Panels**

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

**D. Prepare for the inspection**

SUBTASK 55-05-03-860-003

- (1) Set the stabilizer leading edge to the full up (airplane nose down) position.

SUBTASK 55-05-03-860-004

- (2) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	2	C00849	AFCS STABILIZER TRIM

**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

**E. Inspection**

SUBTASK 55-05-03-010-002

- (1) Open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

Special Access:

**Number      Name/Location**

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.

EFFECTIVITY
LOM ALL

**55-05-03**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 55-05-03-910-002

- (3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 55-05-03-410-002

- (4) Close this access panel:

Number    Name/Location

311BL      Stabilizer Trim Access Door

**F. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-05-03-860-001

- (1) 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>
C	2	C00849	AFCS STABILIZER TRIM

**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

SUBTASK 55-05-03-860-002

- (2) Set the stabilizer leading edge to the NORMAL position.

———— END OF TASK ————

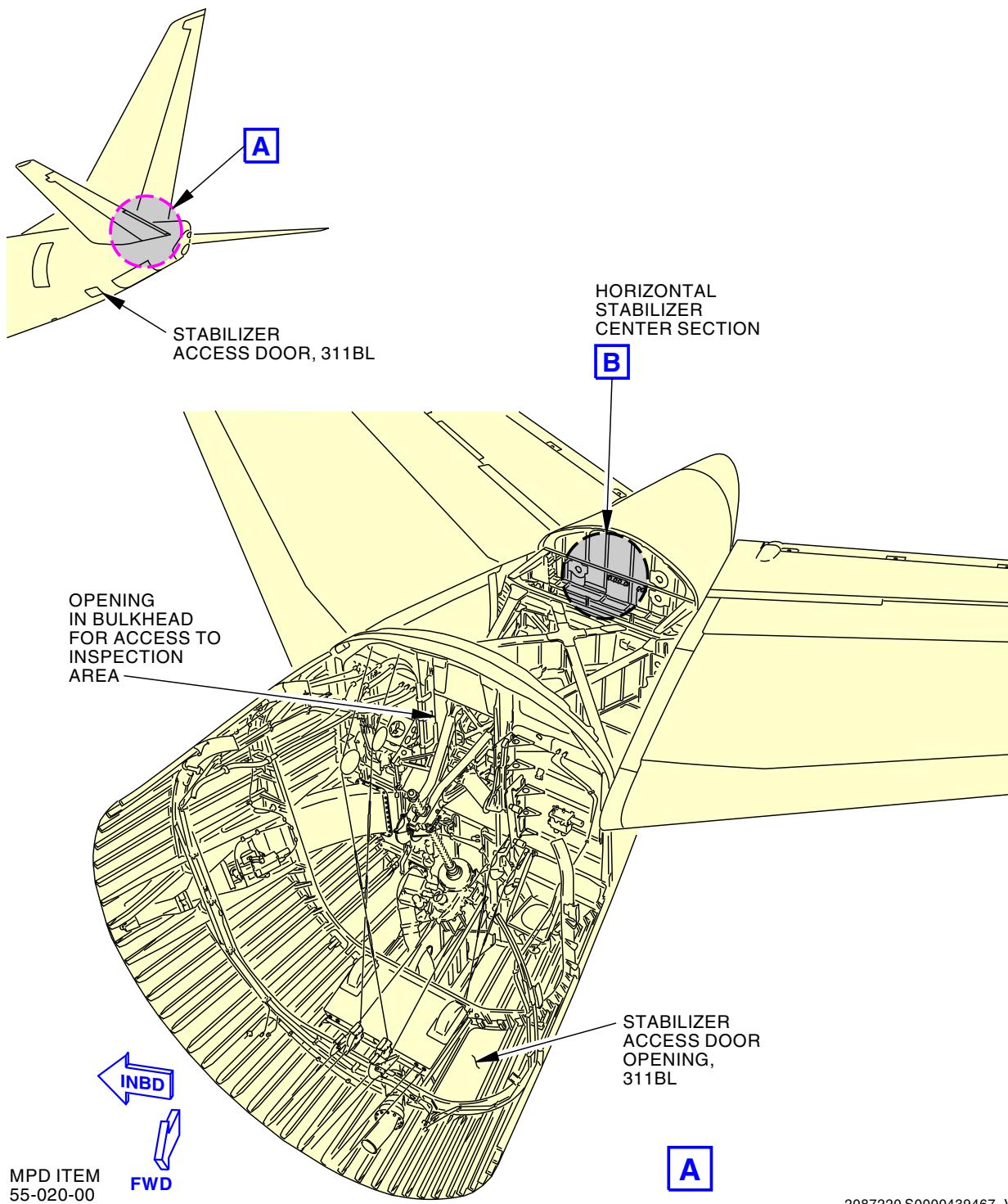
EFFECTIVITY  
LOM ALL

**55-05-03**

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D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



**INTERNAL-GENERAL VISUAL: STABILIZER TORSION BOX COMPARTMENT**  
**Figure 202/55-05-03-990-820 (Sheet 1 of 2)**

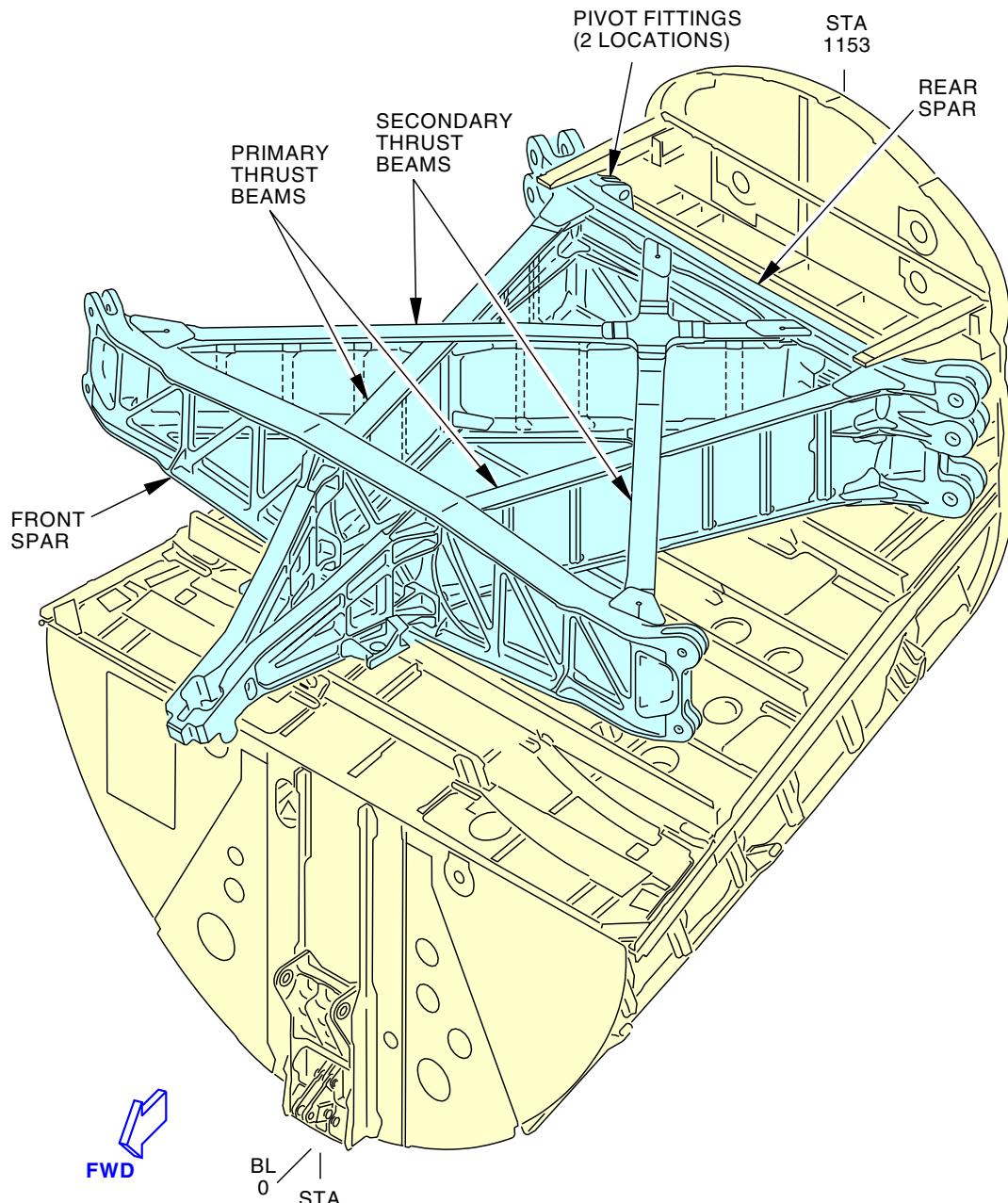
EFFECTIVITY
LOM ALL

**55-05-03**

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AIRCRAFT MAINTENANCE MANUAL



HORIZONTAL STABILIZER CENTER SECTION

B

MPD ITEM  
55-020-00

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INTERNAL-GENERAL VISUAL: STABILIZER TORSION BOX COMPARTMENT  
Figure 202/55-05-03-990-820 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

**55-05-03**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**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**

<b>Reference</b>	<b>Title</b>
51-05-01-210-806	737-6789 Basic Task Description (P/B 201)
55-33-11-000-801	Vertical Stabilizer (Fin) Leading Edge Removal (P/B 401)
55-33-11-400-801	Vertical Stabilizer (Fin) Leading Edge Installation (P/B 401)
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
322	Vertical Fin - Removable Fin Leading Edge

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
322B	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:

TASK 55-33-11-000-801

<b>Number</b>	<b>Name/Location</b>
322B	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: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

EFFECTIVITY  
LOM ALL

**55-05-03**



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SUBTASK 55-05-03-410-003

- (4) Close these access panels:

(TASK 55-33-11-400-801)

**Number      Name/Location**

322B	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 55-05-03-390-001

- (5) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

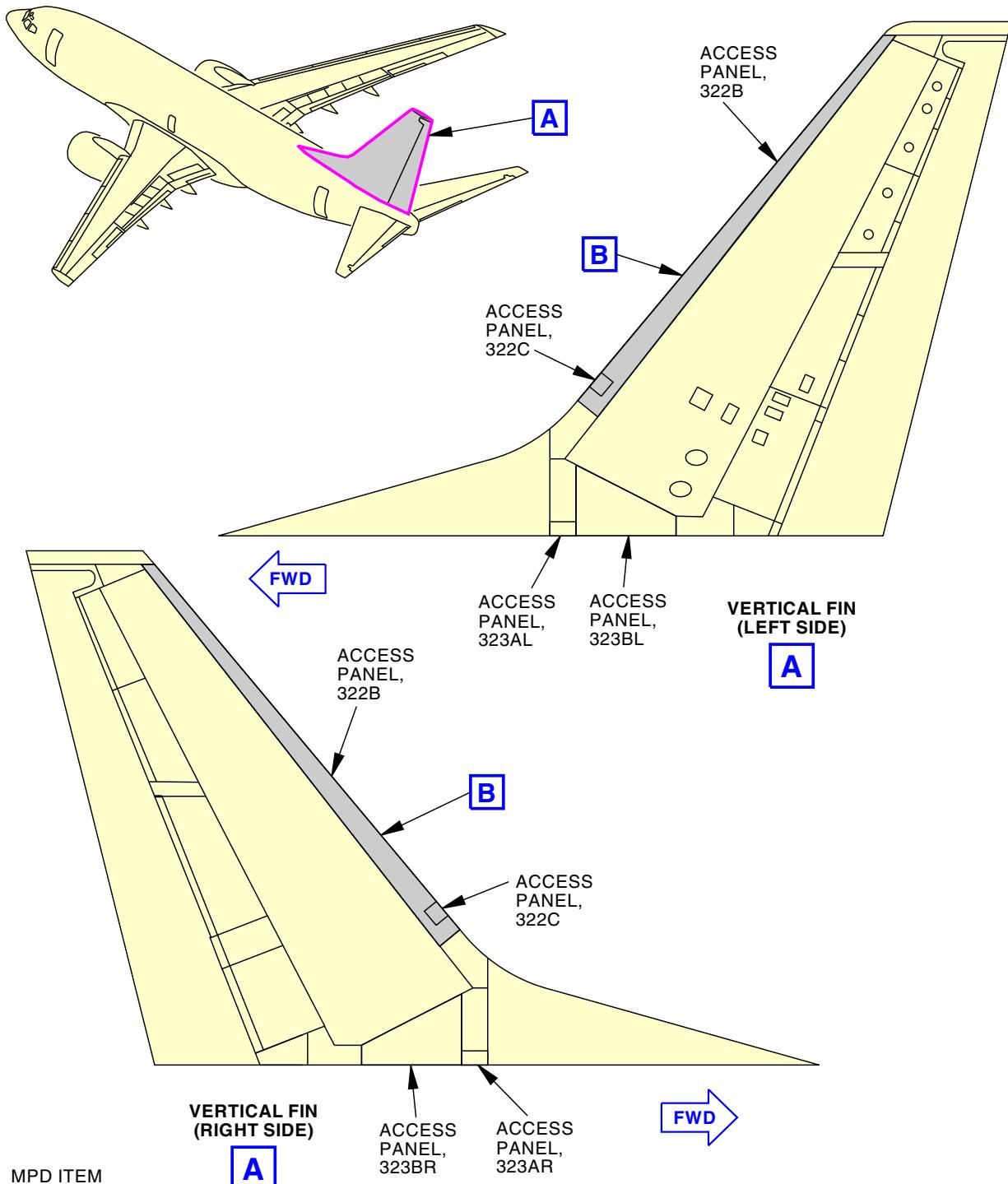
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**55-05-03**



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MPD ITEM  
55-030-00

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INTERNAL-GENERAL VISUAL: VERTICAL FIN LEADING EDGE  
Figure 203/55-05-03-990-812 (Sheet 1 of 3)

EFFECTIVITY  
LOM ALL

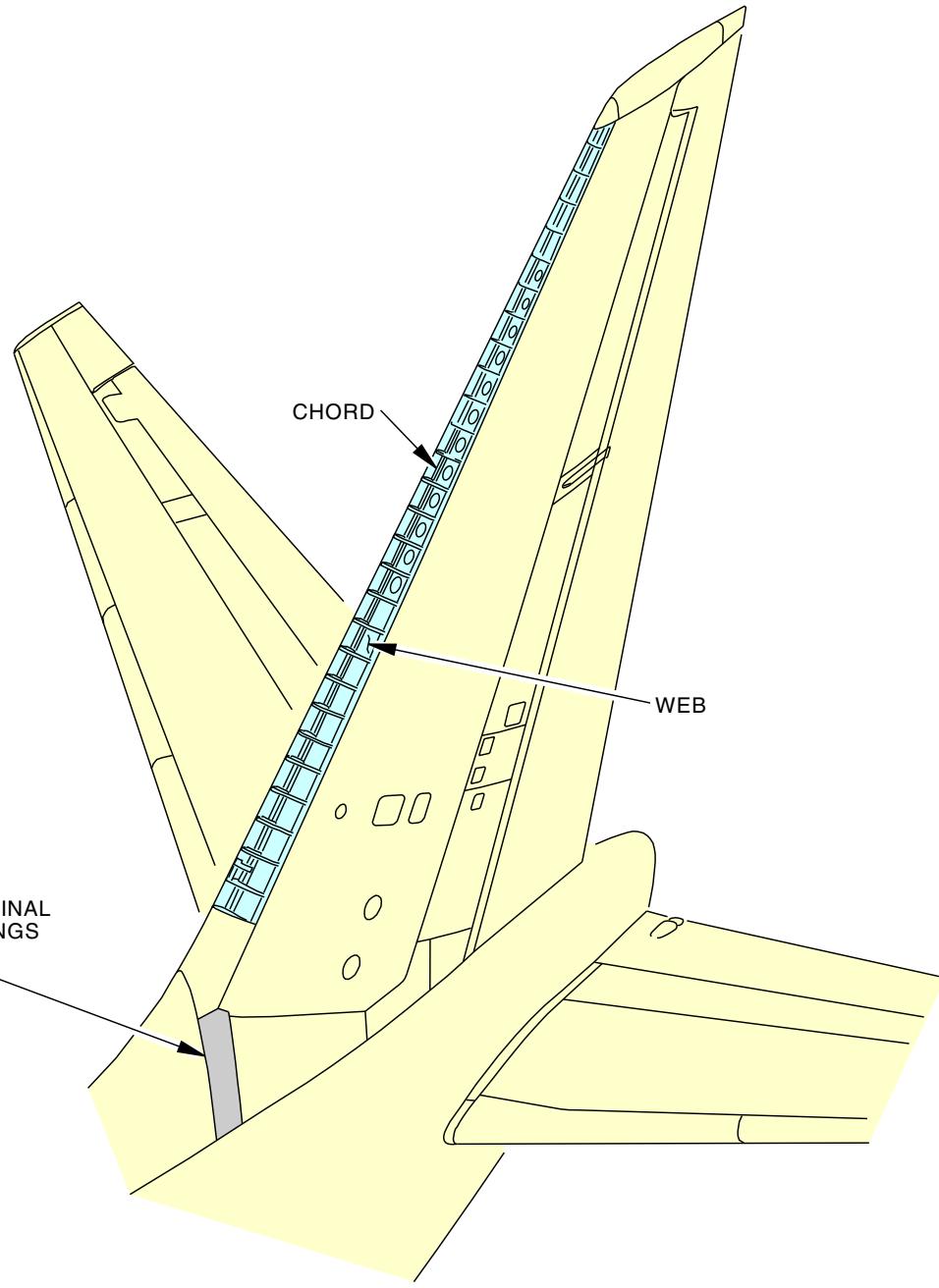
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ECCN 9E991 BOEING PROPRIETARY - See title page for details



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VERTICAL FIN FRONT SPAR  
(LEADING EDGE SKIN REMOVED)

MPD ITEM  
55-030-00

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INTERNAL-GENERAL VISUAL: VERTICAL FIN LEADING EDGE  
Figure 203/55-05-03-990-812 (Sheet 2 of 3)

EFFECTIVITY  
LOM ALL

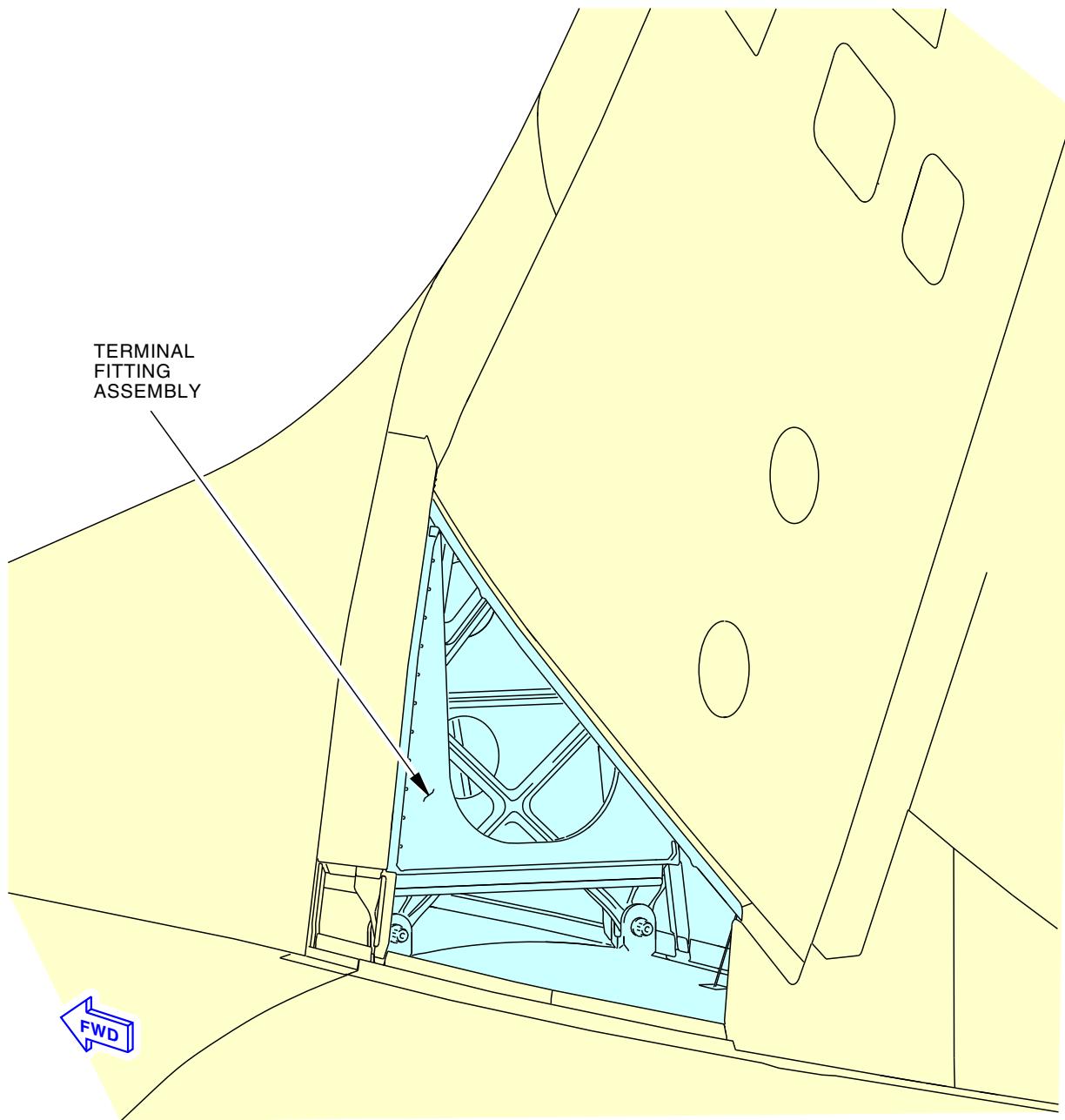
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**55-05-03**

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TERMINAL FITTING ASSEMBLY

C

MPD ITEM  
55-030-00

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INTERNAL-GENERAL VISUAL: VERTICAL FIN LEADING EDGE  
Figure 203/55-05-03-990-812 (Sheet 3 of 3)

EFFECTIVITY  
LOM ALL

**55-05-03**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**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	737-6789 Basic Task Description (P/B 201)
55-33-11-000-801	Vertical Stabilizer (Fin) Leading Edge Removal (P/B 401)
55-33-11-400-801	Vertical Stabilizer (Fin) Leading Edge Installation (P/B 401)
SRM 51-10-01	Structural Repair Manual

**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
322B	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

EFFECTIVITY  
LOM ALL

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(Continued)

<u>Number</u>	<u>Name/Location</u>
324NL	Vertical Fin, Access
S3232	Vertical Fin Inspection

**E. Inspection**

SUBTASK 55-05-03-040-001



**WARNING**

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

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-431, 433, 434, 437-447, 450-999  
E        11      C00839     COMMUNICATIONS HF 1

**F/O Electrical System Panel, P6-1**

Row    Col    Number    Name

LOM 404, 412, 415, 416, 422-426, 433, 434, 439-445, 451-454, 457, 464-999  
D        2        C00857     COMMUNICATIONS HF 2

**LOM ALL**

These circuit breakers are inoperative and should remain open:

**CAPT Electrical System Panel, P18-2**

Row    Col    Number    Name

**LOM 432**

E        11      C00839     COMMUNICATIONS HF 1 (INOP)

**F/O Electrical System Panel, P6-1**

Row    Col    Number    Name

LOM 402, 406, 407, 411, 420, 427-432, 437, 438, 446, 447, 450, 455, 456, 458-463  
D        2        C00857     COMMUNICATIONS HF 2 (INOP)

**LOM ALL**

SUBTASK 55-05-03-010-004

- (2) Open these access panels:

(TASK 55-33-11-000-801)

**Number**    **Name/Location**

322A	Vertical Fin, Fixed Leading Edge
322AL	Vertical Fin, Fixed Leading Edge
322AR	Vertical Fin, Fixed Leading Edge
322B	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

EFFECTIVITY  
**LOM ALL**

**55-05-03**

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(Continued)

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

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: 737-6789 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 55-05-03-410-004

- (5) Close these access panels:

(TASK 55-33-11-400-801)

<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
322B	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

EFFECTIVITY  
LOM ALL

**55-05-03**

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AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
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 55-05-03-390-002

- (6) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

SUBTASK 55-05-03-860-005

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

**CAPT Electrical System Panel, P18-2**

Row    Col    Number    Name

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-431, 433, 434, 437-447, 450-999  
E        11      C00839     COMMUNICATIONS HF 1

**F/O Electrical System Panel, P6-1**

Row    Col    Number    Name

LOM 404, 412, 415, 416, 422-426, 433, 434, 439-445, 451-454, 457, 464-999  
D        2        C00857     COMMUNICATIONS HF 2

**LOM ALL**

These circuit breakers are inoperative and should remain open:

**CAPT Electrical System Panel, P18-2**

Row    Col    Number    Name

LOM 432  
E        11      C00839     COMMUNICATIONS HF 1 (INOP)

**F/O Electrical System Panel, P6-1**

Row    Col    Number    Name

LOM 402, 406, 407, 411, 420, 427-432, 437, 438, 446, 447, 450, 455, 456, 458-463  
D        2        C00857     COMMUNICATIONS HF 2 (INOP)

**LOM ALL**

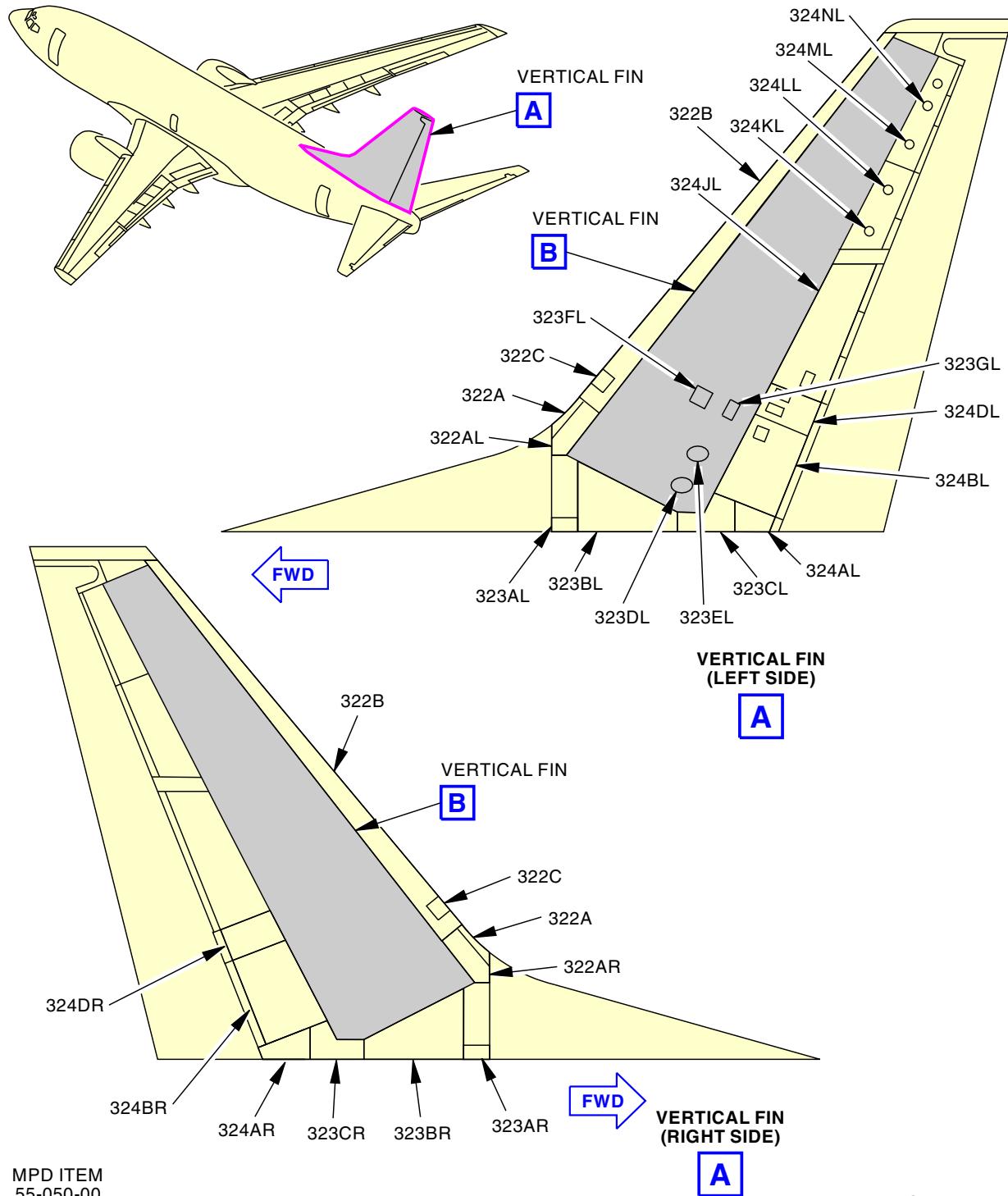
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EFFECTIVITY  
LOM ALL

**55-05-03**



737-600/700/800/900  
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MPD ITEM  
55-050-00

2089274 S0000440578\_V3

INTERNAL-GENERAL VISUAL: VERTICAL FIN  
Figure 204/55-05-03-990-813 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

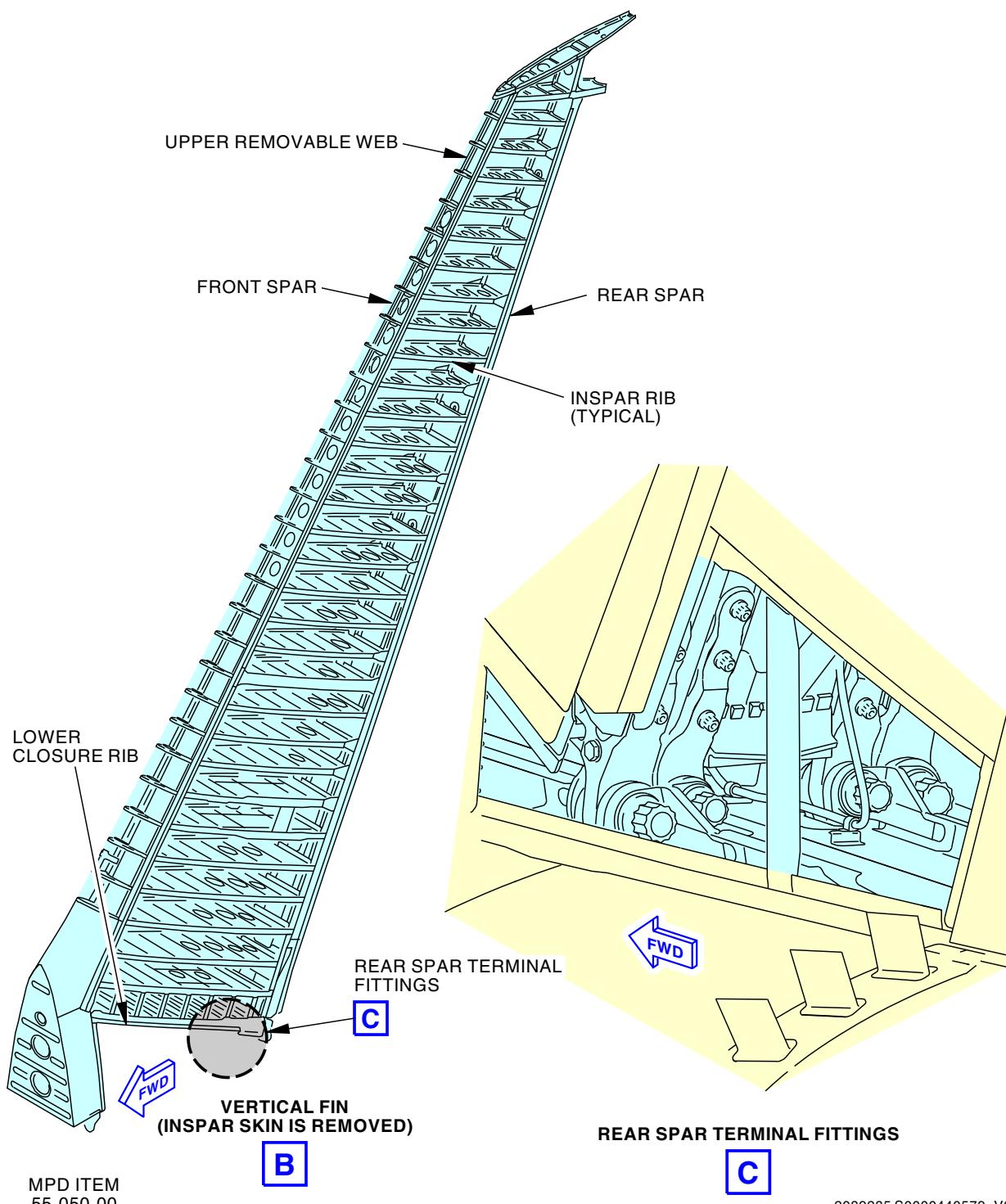
**55-05-03**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details



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INTERNAL-GENERAL VISUAL: VERTICAL FIN  
Figure 204/55-05-03-990-813 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

**55-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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**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. Location Zones**

<b>Zone</b>	<b>Area</b>
324	Vertical Fin - Rear Spar To Trailing Edge

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
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

**C. Inspection**

SUBTASK 55-05-03-010-018

- (1) Open these access panels:

<b>Number</b>	<b>Name/Location</b>
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) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 55-05-03-410-018

- (4) Close these access panels:

<b>Number</b>	<b>Name/Location</b>
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

EFFECTIVITY
LOM ALL

**55-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
324NL	Vertical Fin, Access

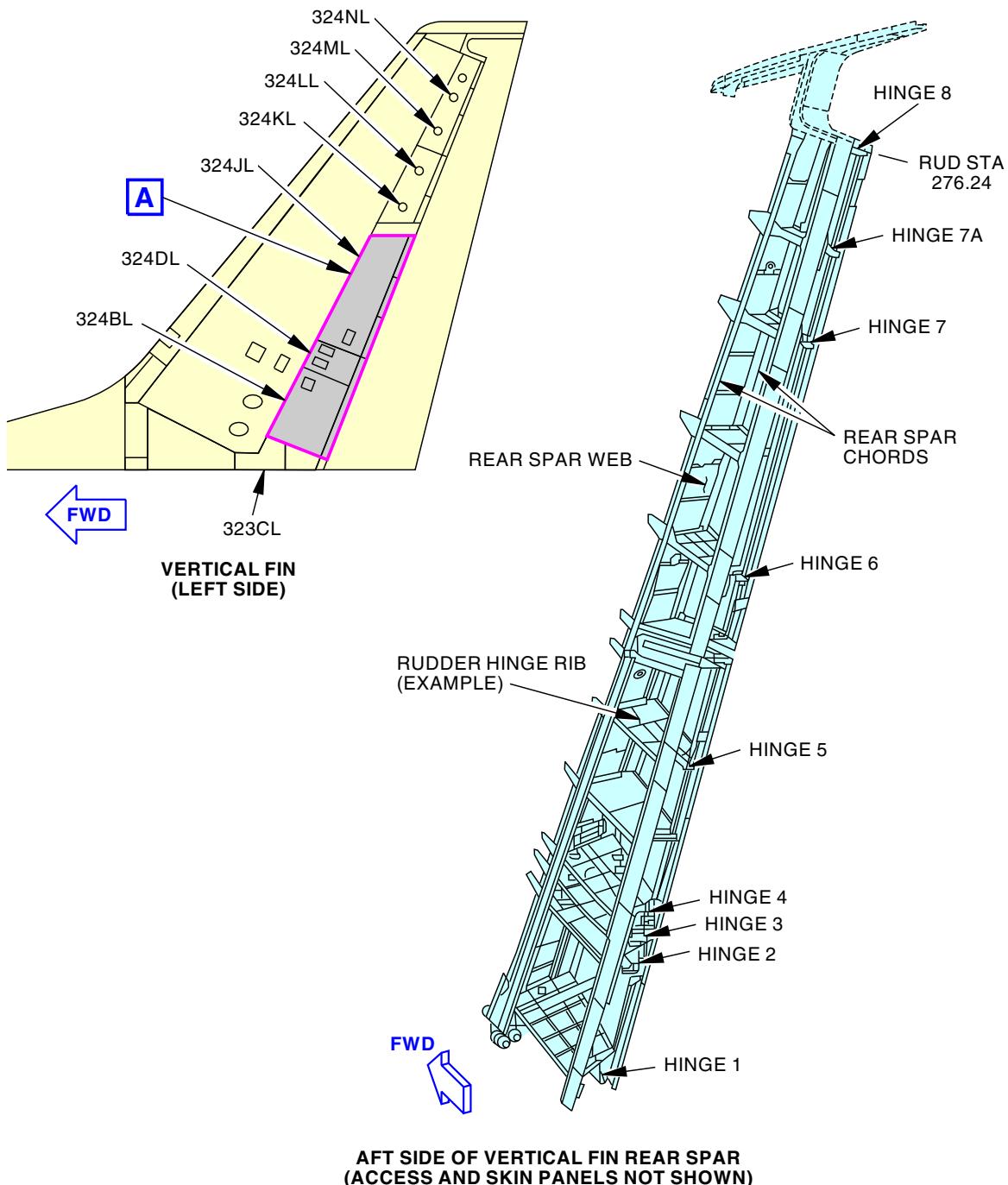
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**55-05-03**

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**737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL**


MPD ITEM  
55-060-00

2089247 S0000440581\_V3

**INTERNAL-GENERAL VISUAL: VERTICAL FIN TRAILING EDGE**  
**Figure 205/55-05-03-990-811**

EFFECTIVITY  
LOM ALL

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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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
27-41-21-000-801	Horizontal Stabilizer Leading Edge - Removal (P/B 401)
27-41-21-400-801	Horizontal Stabilizer Leading Edge - Installation (P/B 401)
51-05-01-210-804	737-6789 Basic Task Description (P/B 201)
SOPM 20-30-03	General Cleaning Procedures

**B. Tools/Equipment**

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

Reference	Description
SPL-2035	Sling Equipment - Horizontal Stabilizer
	Part #: C55007-47 Supplier: 81205
	Part #: C55007-48 (low clearance) Supplier: 81205
STD-12395	Load Cell Equipment

**C. Consumable Materials**

Reference	Description	Specification
D50004	Compound - Antiseize	BMS3-28
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	LOM 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
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
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.

NOTE: For more information on the sling equipment, SPL-2035, see the Illustrated Tool and Equipment Manual (ITEM) subject 27-40-12.

- (a) Remove the bolts [1] and bolts [2] from the stabilizer top surface.

EFFECTIVITY  
LOM ALL

**55-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



**WARNING**

MAKE SURE YOU INSTALL THE HOISTING SLING CORRECTLY WHEN YOU REMOVE THE BOLTS. IF YOU DO NOT INSTALL THE HOISTING SLING CORRECTLY, YOU CAN CAUSE DAMAGE TO EQUIPMENT OR INJURY TO PERSONNEL.

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

## H. Inspection

SUBTASK 55-05-03-010-005

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.

- (a) Open these access panels:

**Number      Name/Location**

331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
331AZ	Horizontal Stabilizer, Access Panel, Inboard L.E. Closure Rib
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

Special Access:

**Number      Name/Location**

S3311	Left Horizontal Stabilizer Leading Edge Inspection
-------	--

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], shim washers [12], shim washers [11], washers [5], shims [8], shims [10], washers [9], bolts [4], and washers [3].

SUBTASK 55-05-03-100-001

- (3) To remove dirt, debris, and existing grime, clean the joint (SOPM 20-30-03).

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.

EFFECTIVITY  
LOM ALL

**55-05-03**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 55-05-03-910-006

- (5) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 55-05-03-100-008

- (6) Apply corrosion inhibiting material, G50136, to the bolts and joints, including the inner diameter of bushings.  
(a) Do not put corrosion inhibiting material, G50136, on the threaded portion of the bolts.

SUBTASK 55-05-03-640-001

- (7) Apply compound, D50004, to the threads of the bolts [4] and nuts [6].

NOTE: This anti-seize compound will prevent galling of the threads.

SUBTASK 55-05-03-420-001

- (8) At the front spar of the horizontal stabilizer, do these steps:

- (a) Remove the bolts [4].
- (b) Measure the clearance between the bushing faces of the lugs and clevises.
- (c) Install the shims [10] to get a maximum clearance of 0.005 in. (0.127 mm) for each side of the lugs (maximum of 0.010 in. (0.254 mm) total allowable clearance for each clevis).
- (d) Install the washers [3], bolts [4], washers [9], washers [5], shims [8], and nuts [6].
  - 1) If it is necessary, add the shim washers [11] and/or shim washers [12] between the nut [6] and washer [5] to align pin hole of the bolt [4] and nut [6].
  - 2) Tighten the nuts [6] to an initial torque of 50 in-lb (5.6 N·m).
  - 3) Make sure that the stepped portion of the bolts [4] touch the washers [5] or shim washers [11] and/or shim washers [12], if used.
    - a) If it is necessary, remove the shims [8] until the stepped portion of the bolts [4] touch the washers [5] or shim washers [11] and/or shim washers [12], if used.
  - 4) Make sure that the gap "X" between the shims [8] and washers [5] is not greater than 0.002 in. (0.051 mm).
    - a) If it is necessary, add shims [8] until the gap "X" is between 0.002 in. (0.051 mm) - 0.000 in. (0.000 mm).
  - 5) Tighten the nuts [6] to 950 in-lb (107.3 N·m) - 1400 in-lb (158.2 N·m).
  - 6) Install the new pins [7].
    - a) If it is necessary, tighten or loosen the nuts [6], to get the pin hole alignment.

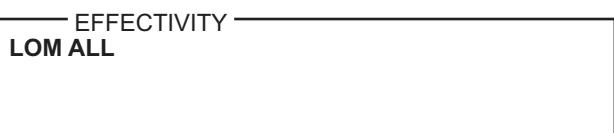
## I. Put the Airplane Back to Its Usual Condition

SUBTASK 55-05-03-410-019

- (1) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.

- (a) 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
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ



**55-05-03**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details



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Special Access:

Number    Name/Location

S3311        Left Horizontal Stabilizer Leading Edge Inspection

SUBTASK 55-05-03-080-001

- (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 stabilizer top surface.

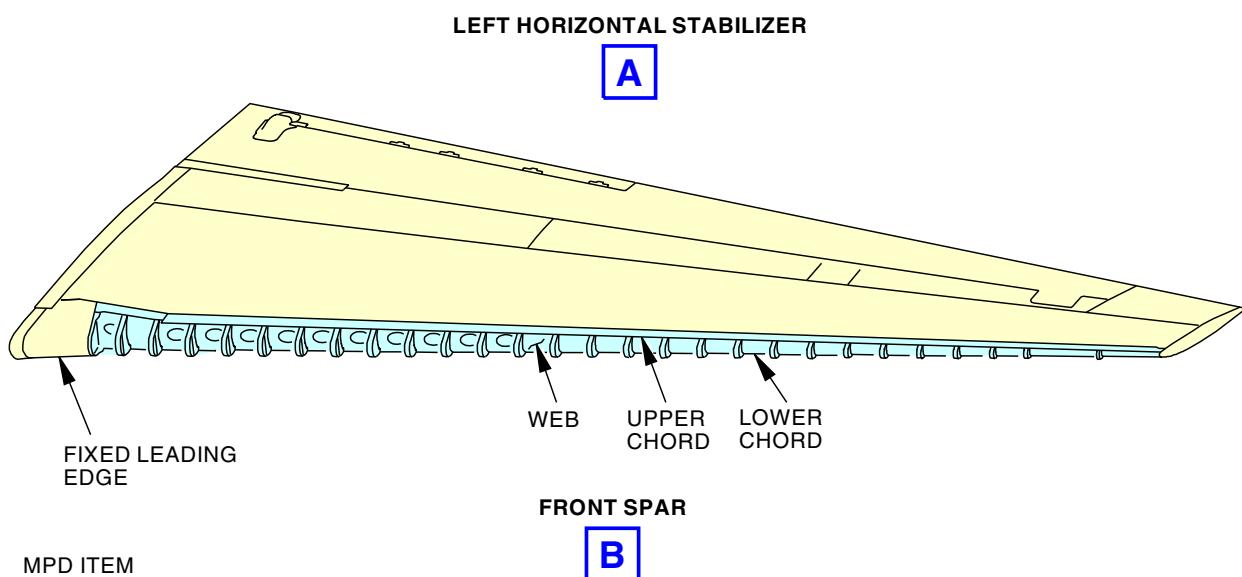
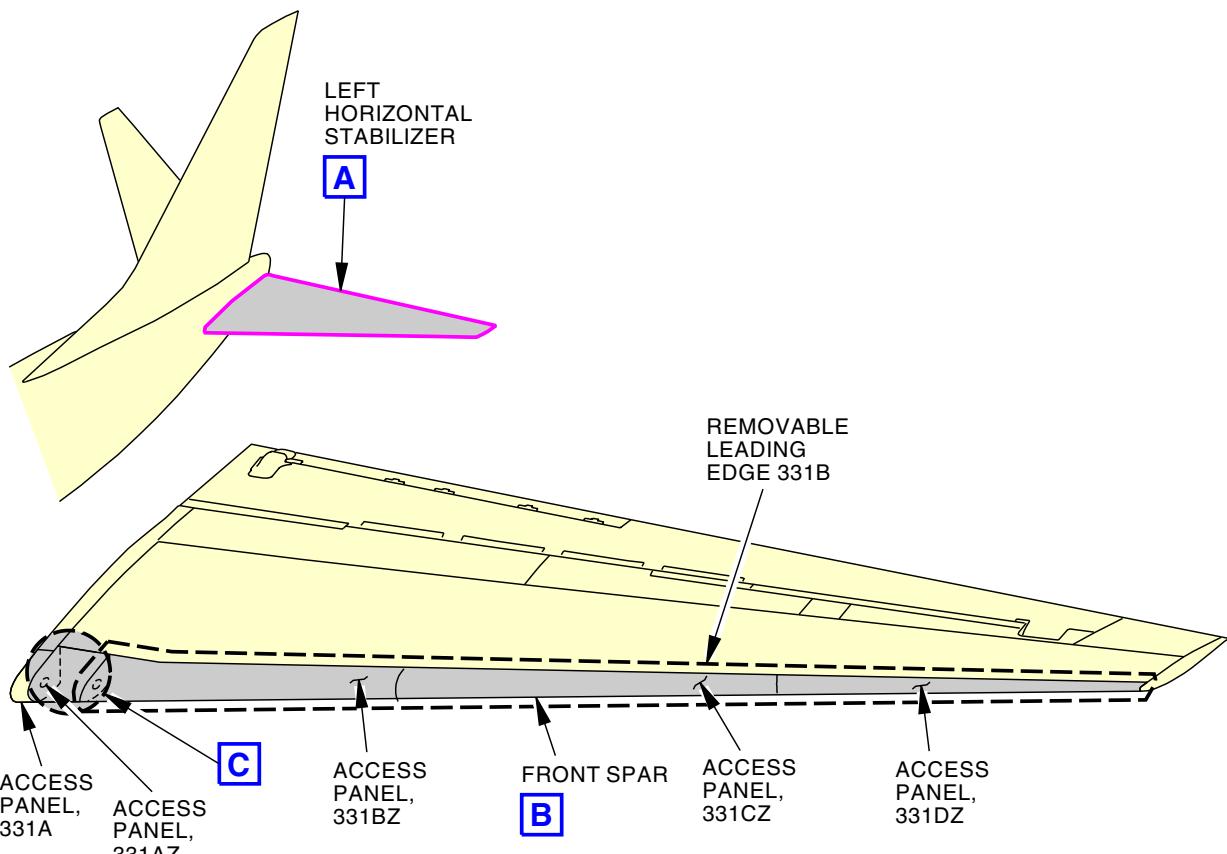
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**55-05-03**



737-600/700/800/900  
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INTERNAL-GENERAL VISUAL: LEFT HORIZONTAL STABILIZER LEADING EDGE  
Figure 206/55-05-03-990-824 (Sheet 1 of 5)

EFFECTIVITY  
LOM ALL

**55-05-03**

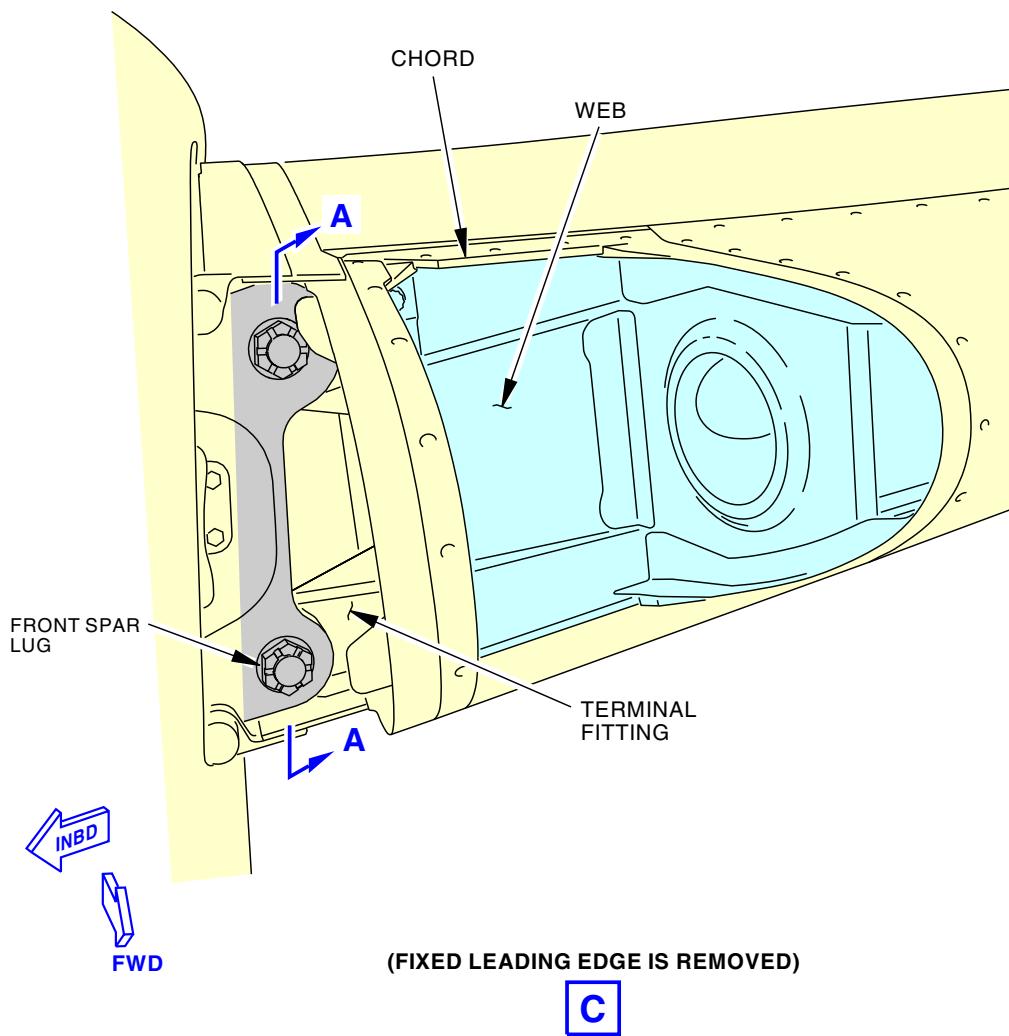
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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MPD ITEM  
55-070-01

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INTERNAL-GENERAL VISUAL: LEFT HORIZONTAL STABILIZER LEADING EDGE  
Figure 206/55-05-03-990-824 (Sheet 2 of 5)

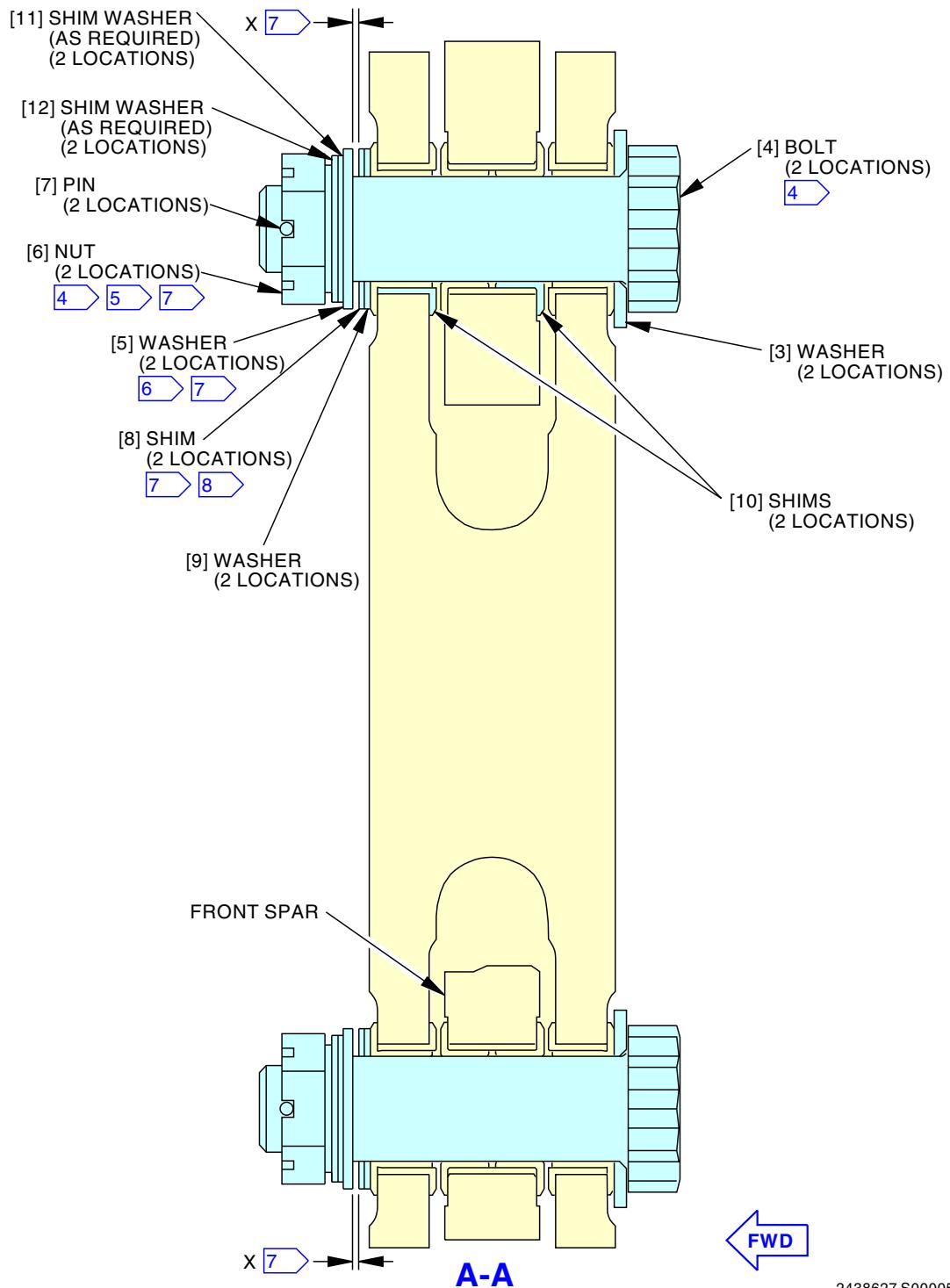
EFFECTIVITY  
LOM ALL

**55-05-03**

D633A101-LOM



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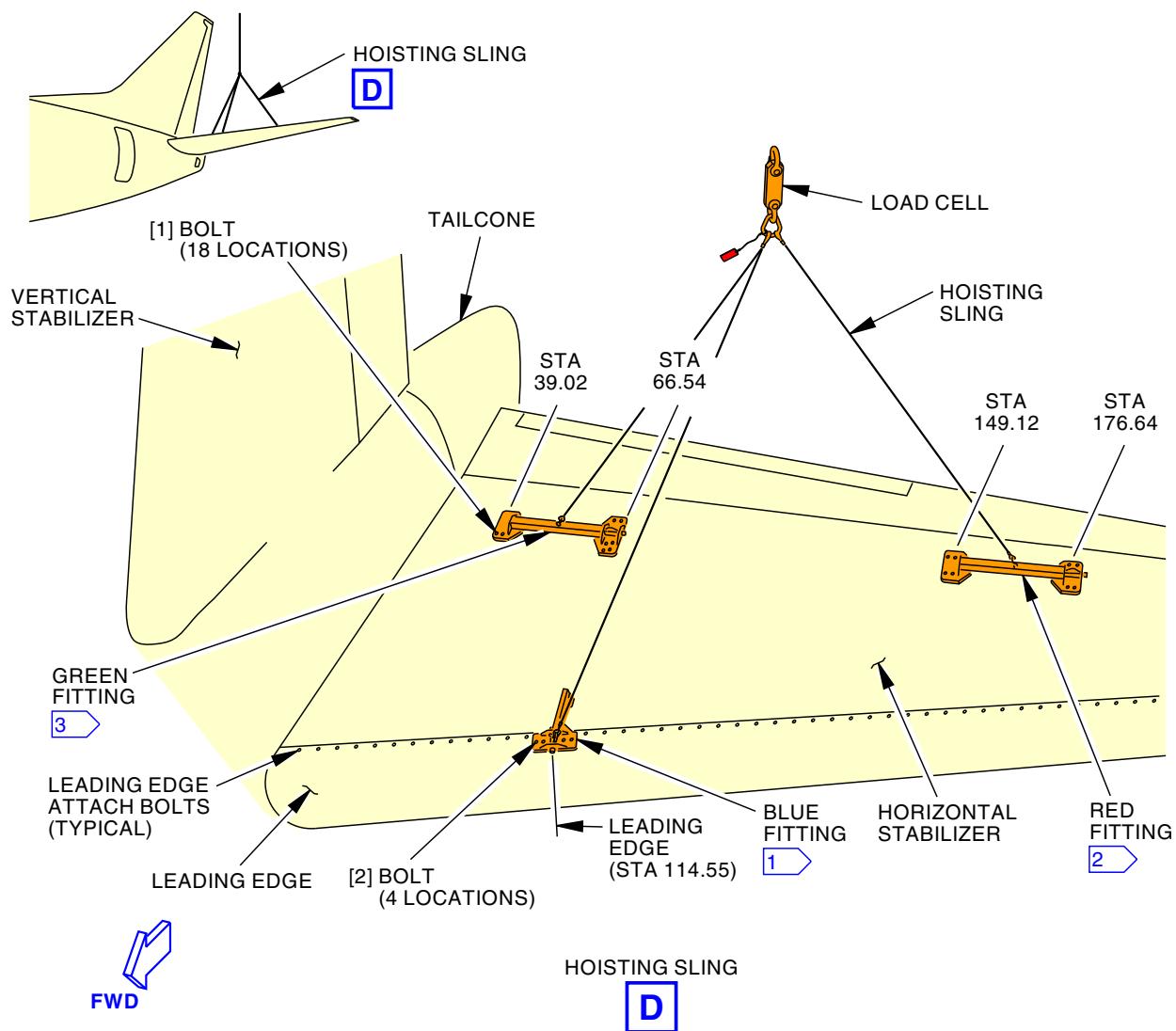
INTERNAL-GENERAL VISUAL: LEFT HORIZONTAL STABILIZER LEADING EDGE  
Figure 206/55-05-03-990-824 (Sheet 3 of 5)

EFFECTIVITY  
LOM ALL

**55-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



**[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.

2438621 S0000565964\_V2

**INTERNAL-GENERAL VISUAL: LEFT HORIZONTAL STABILIZER LEADING EDGE**  
Figure 206/55-05-03-990-824 (Sheet 4 of 5)

EFFECTIVITY  
LOM ALL

**55-05-03**



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- 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).

2438674 S0000565966\_V1

**INTERNAL-GENERAL VISUAL: LEFT HORIZONTAL STABILIZER LEADING EDGE**  
**Figure 206/55-05-03-990-824 (Sheet 5 of 5)**

EFFECTIVITY  
LOM ALL

**55-05-03**



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**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
27-41-21-000-801	Horizontal Stabilizer Leading Edge - Removal (P/B 401)
27-41-21-400-801	Horizontal Stabilizer Leading Edge - Installation (P/B 401)
51-05-01-210-804	737-6789 Basic Task Description (P/B 201)
SOPM 20-30-03	General Cleaning Procedures

**B. Tools/Equipment**

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

Reference	Description
SPL-2035	Sling Equipment - Horizontal Stabilizer Part #: C55007-47 Supplier: 81205 Part #: C55007-48 (low clearance) Supplier: 81205
STD-12395	Load Cell Equipment

**C. Consumable Materials**

Reference	Description	Specification
D50004	Compound - Antiseize	BMS3-28
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	LOM 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
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ
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.

NOTE: For more information on the sling equipment, SPL-2035, see the Illustrated Tool and Equipment Manual (ITEM) subject 27-40-12.

- (a) Remove the bolts [1] and bolts [2] from the stabilizer top surface.

EFFECTIVITY  
LOM ALL



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**WARNING**

MAKE SURE YOU INSTALL THE HOISTING SLING CORRECTLY WHEN YOU REMOVE THE BOLTS. IF YOU DO NOT INSTALL THE HOISTING SLING CORRECTLY, YOU CAN CAUSE DAMAGE TO EQUIPMENT OR INJURY TO PERSONNEL.

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

## H. Inspection

SUBTASK 55-05-03-010-006

- (1) To remove the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Removal, TASK 27-41-21-000-801.

- (a) Open these access panels:

**Number      Name/Location**

341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
341AZ	Horizontal Stabilizer, Access Panel - Inbd L.E. Closure Rib
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

Special Access:

**Number      Name/Location**

S3411	Right Horizontal Stabilizer Leading Edge Inspection
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SUBTASK 55-05-03-020-002

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

- (a) Remove and discard the pins [7].
- (b) Remove and keep the nuts [6], shim washers [12], shim washers [11], washers [5], shims [8], shims [10], washers [9], bolts [4], and washers [3].

SUBTASK 55-05-03-100-002

- (3) To remove dirt, debris, and existing grime, clean the joint (SOPM 20-30-03).

SUBTASK 55-05-03-210-007

- (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.

EFFECTIVITY  
LOM ALL

**55-05-03**



**737-600/700/800/900**  
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SUBTASK 55-05-03-910-007

- (5) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 55-05-03-100-004

- (6) Apply corrosion inhibiting material, G50136, to the bolts and joints, including the inner diameter of bushings.  
(a) Do not put corrosion inhibiting material, G50136, on the threaded portion of the bolts.

SUBTASK 55-05-03-640-002

- (7) Apply compound, D50004, to the threads of the bolts [4] and nuts [6].

NOTE: This anti-seize compound will prevent galling of the threads.

SUBTASK 55-05-03-400-001

- (8) At the front spar of the horizontal stabilizer, do these steps:

- (a) Remove the bolts [4].
- (b) Measure the clearance between the bushing faces of the lugs and clevises.
- (c) Install the shims [10] to get a maximum clearance of 0.005 in. (0.127 mm) for each side of the lugs (maximum of 0.010 in. (0.254 mm) total allowable clearance for each clevis).
- (d) Install the washers [3], bolts [4], washers [9], washers [5], shims [8], and nuts [6].
  - 1) If it is necessary, add the shim washers [11] and/or shim washers [12] between the nut [6] and washer [5] to align pin hole of the bolt [4] and nut [6].
  - 2) Tighten the nuts [6] to an initial torque of 50 in-lb (5.6 N·m).
  - 3) Make sure that the stepped portion of the bolts [4] touch the washers [5] or shim washers [11] and/or shim washers [12], if used.
    - a) If it is necessary, remove the shims [8] until the stepped portion of the bolts [4] touch the washers [5] or shim washers [11] and/or shim washers [12], if used.
  - 4) Make sure that the gap "X" between the shims [8] and washers [5] is not greater than 0.002 in. (0.051 mm).
    - a) If it is necessary, add shims [8] until the gap "X" is between 0.002 in. (0.051 mm) - 0.000 in. (0.000 mm).
  - 5) Tighten the nuts [6] to 950 in-lb (107.3 N·m) - 1400 in-lb (158.2 N·m).
  - 6) Install the new pins [7].
    - a) If it is necessary, tighten or loosen the nuts [6], to get the pin hole alignment.

## I. Put the Airplane Back to Its Usual Condition

SUBTASK 55-05-03-410-006

- (1) To install the applicable leading edge access panels for the horizontal stabilizer, refer to Horizontal Stabilizer Leading Edge - Installation, TASK 27-41-21-400-801.

- (a) 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
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ



**55-05-03**

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Special Access:

Number    Name/Location

S3411       Right Horizontal Stabilizer Leading Edge Inspection

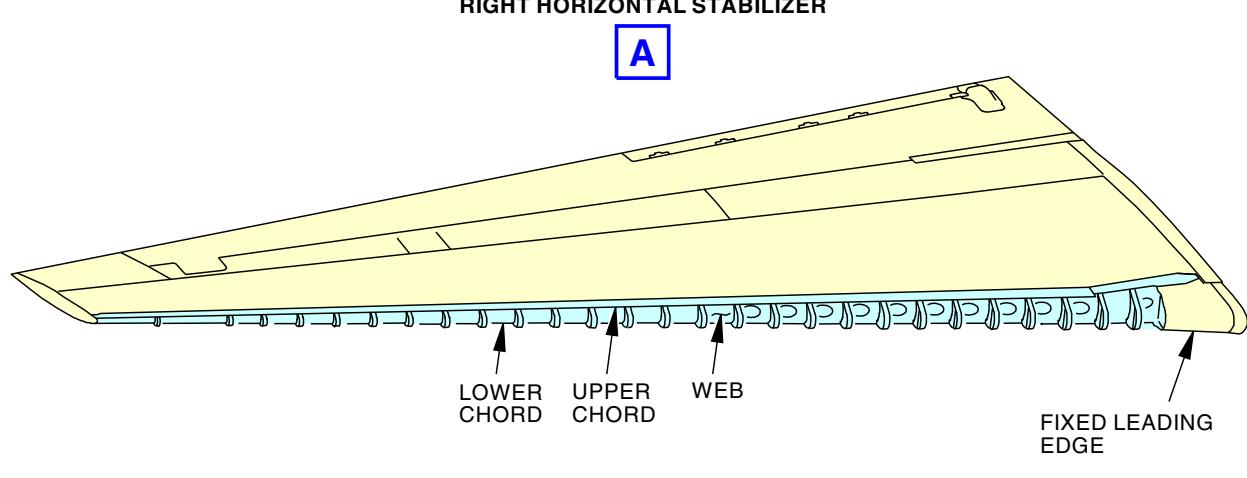
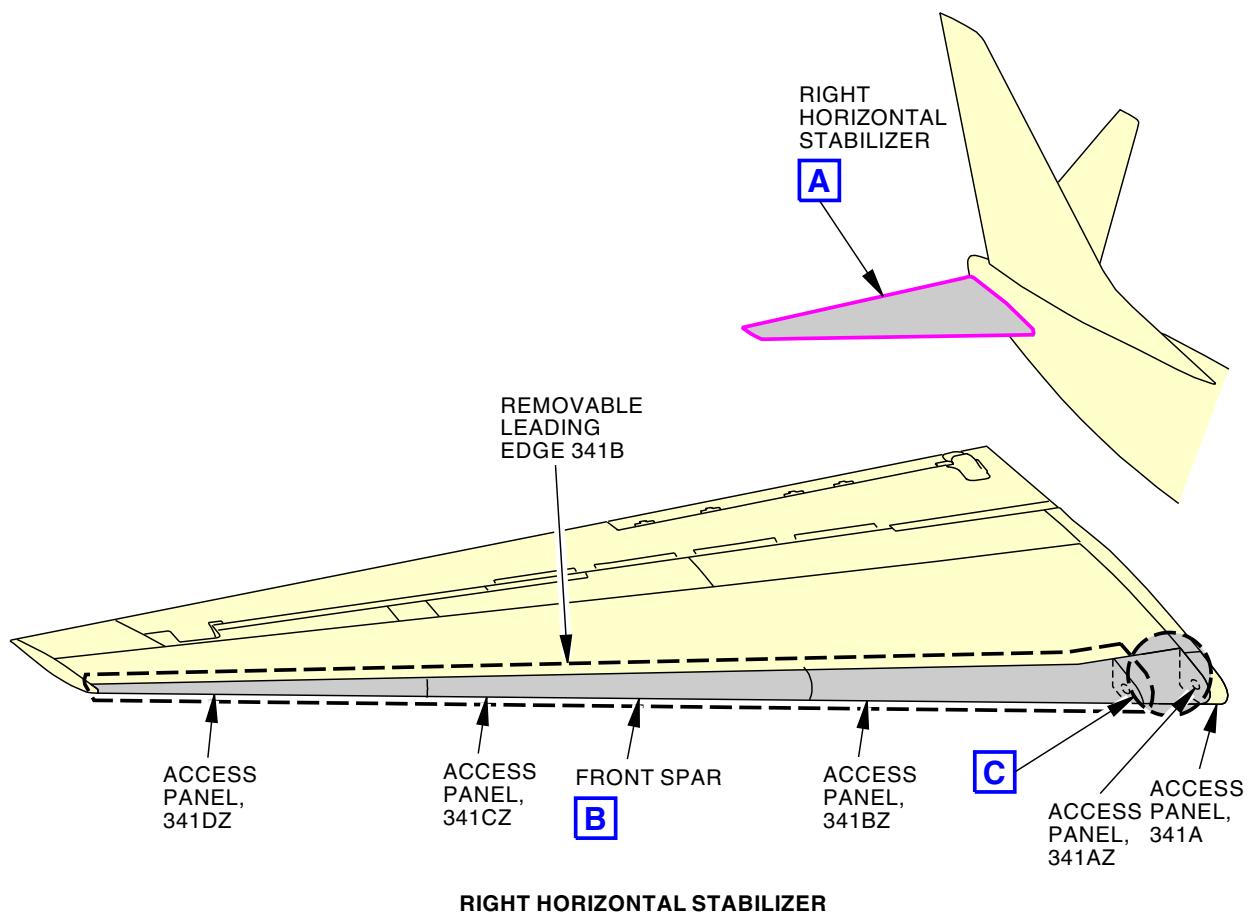
SUBTASK 55-05-03-080-002

- (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 stabilizer top surface.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**55-05-03**



MPD ITEM  
55-070-02

2082191 S0000437290\_V3

**INTERNAL-GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER LEADING EDGE**  
**Figure 207/55-05-03-990-825 (Sheet 1 of 5)**

EFFECTIVITY  
LOM ALL

D633A101-LOM

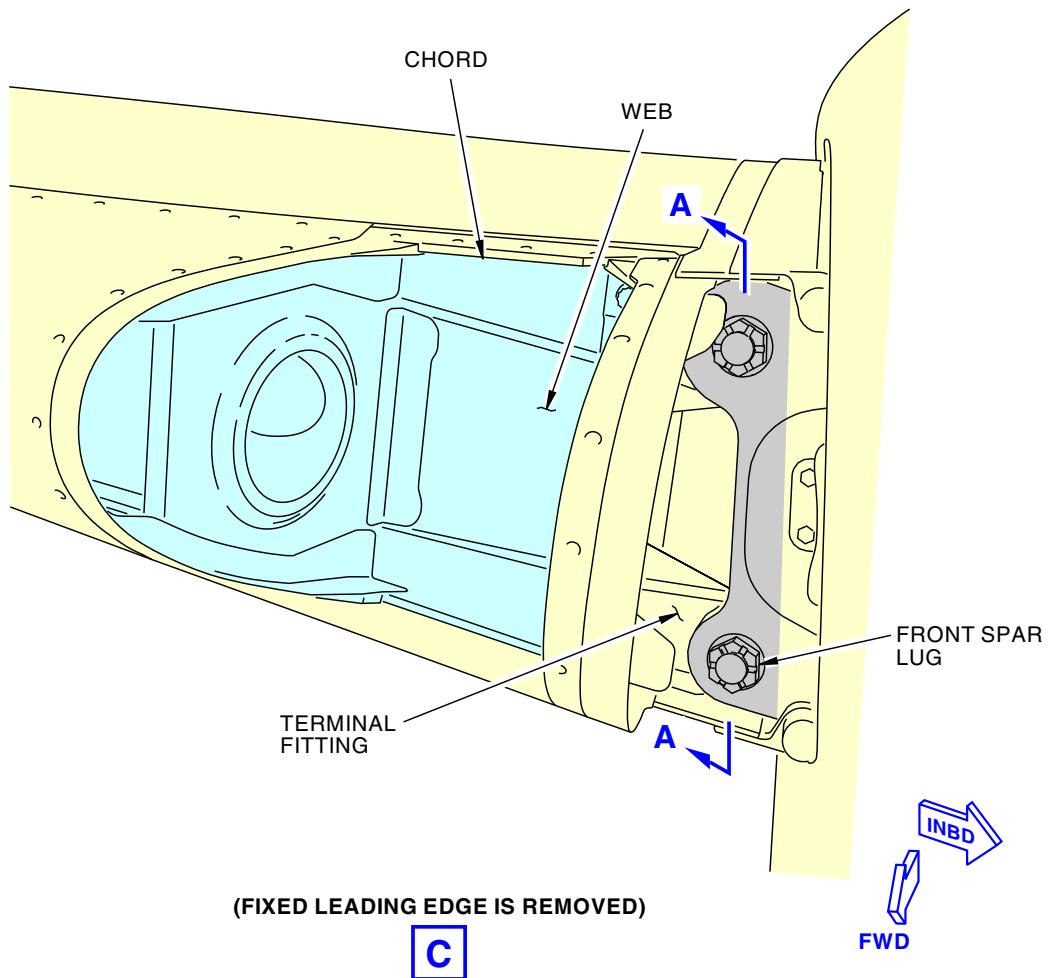
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**55-05-03**

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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
55-070-02

2082192 S0000437291\_V3

INTERNAL-GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER LEADING EDGE  
Figure 207/55-05-03-990-825 (Sheet 2 of 5)

EFFECTIVITY  
LOM ALL

**55-05-03**

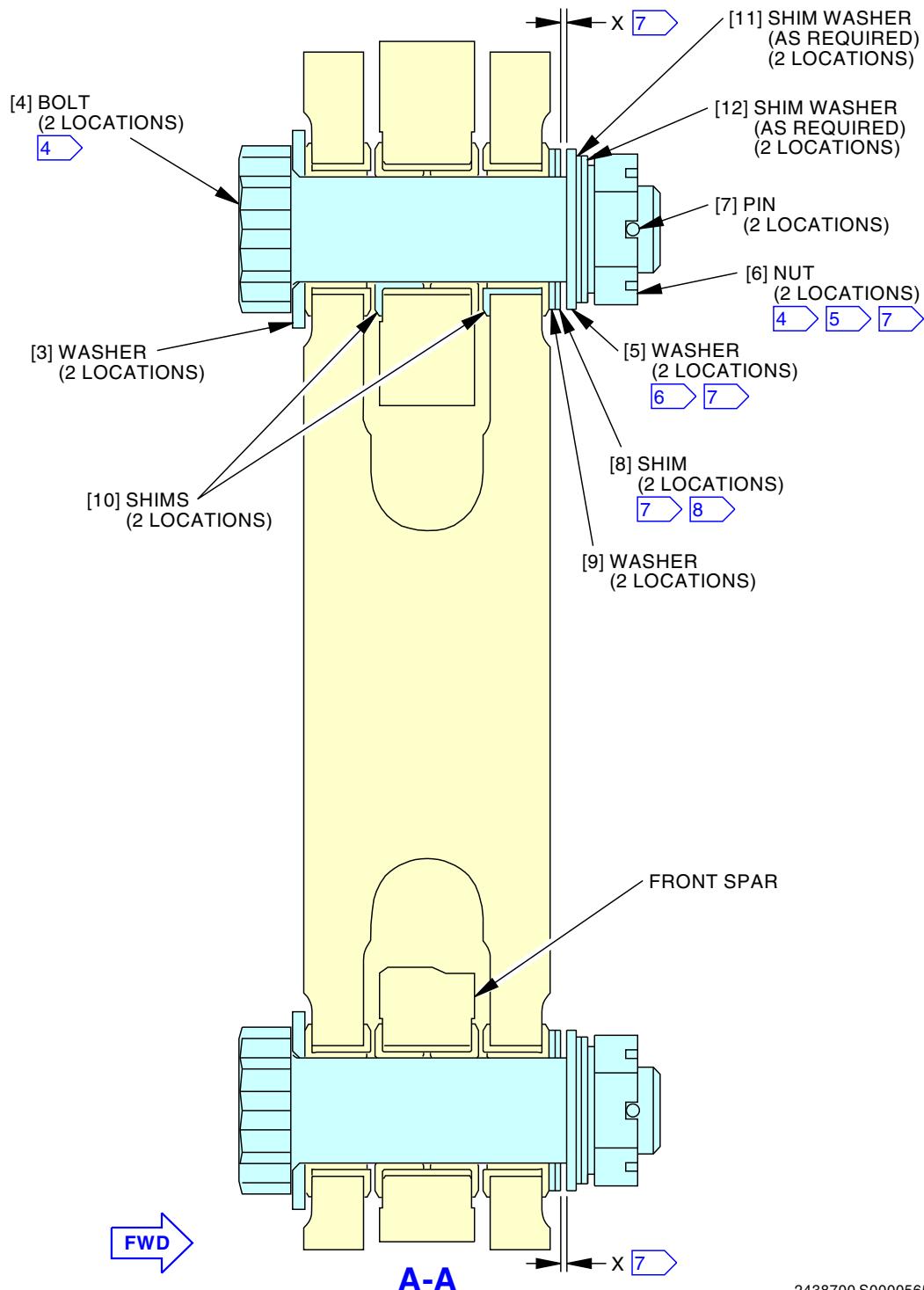
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**AIRCRAFT MAINTENANCE MANUAL**

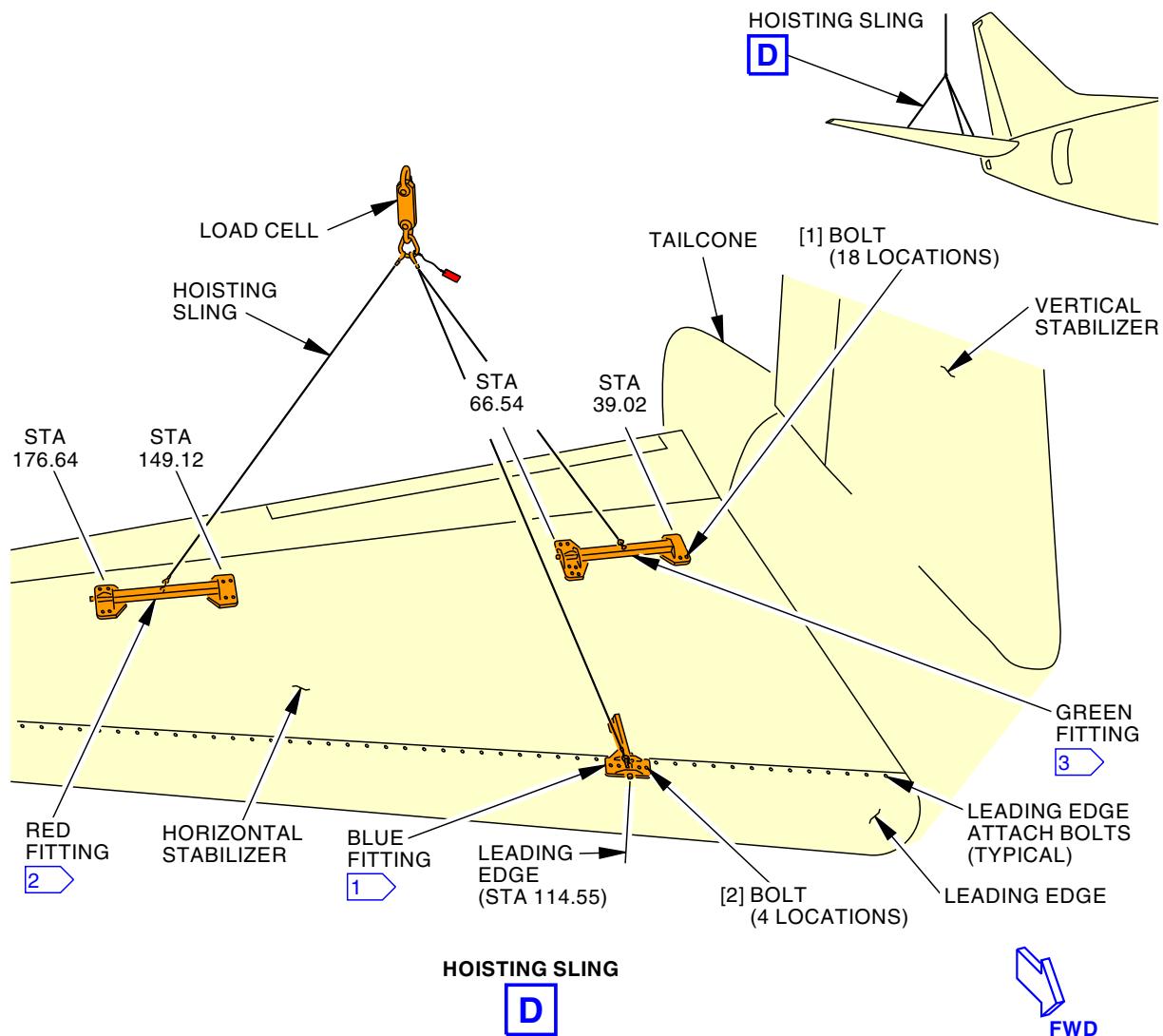


2438700 S0000565971\_V1

**INTERNAL-GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER LEADING EDGE**  
Figure 207/55-05-03-990-825 (Sheet 3 of 5)

EFFECTIVITY  
LOM ALL

**55-05-03**



- 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.

2438684 S0000565970\_V2

**INTERNAL-GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER LEADING EDGE**  
Figure 207/55-05-03-990-825 (Sheet 4 of 5)

EFFECTIVITY  
LOM ALL

**55-05-03**



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- 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).

2438709 S0000565972\_V1

**INTERNAL-GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER LEADING EDGE**  
**Figure 207/55-05-03-990-825 (Sheet 5 of 5)**

EFFECTIVITY  
LOM ALL

**55-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**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. Location Zones**

<b>Zone</b>	<b>Area</b>
331	Left Horizontal Stabilizer - Removable Leading Edge

**B. Access Panels**

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

**C. Inspection**

SUBTASK 55-05-03-010-007

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
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) 737-6789 Basic Task Description, AMM Task 51-05-01-210-801.

SUBTASK 55-05-03-410-007

- (4) Close this access panel:

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

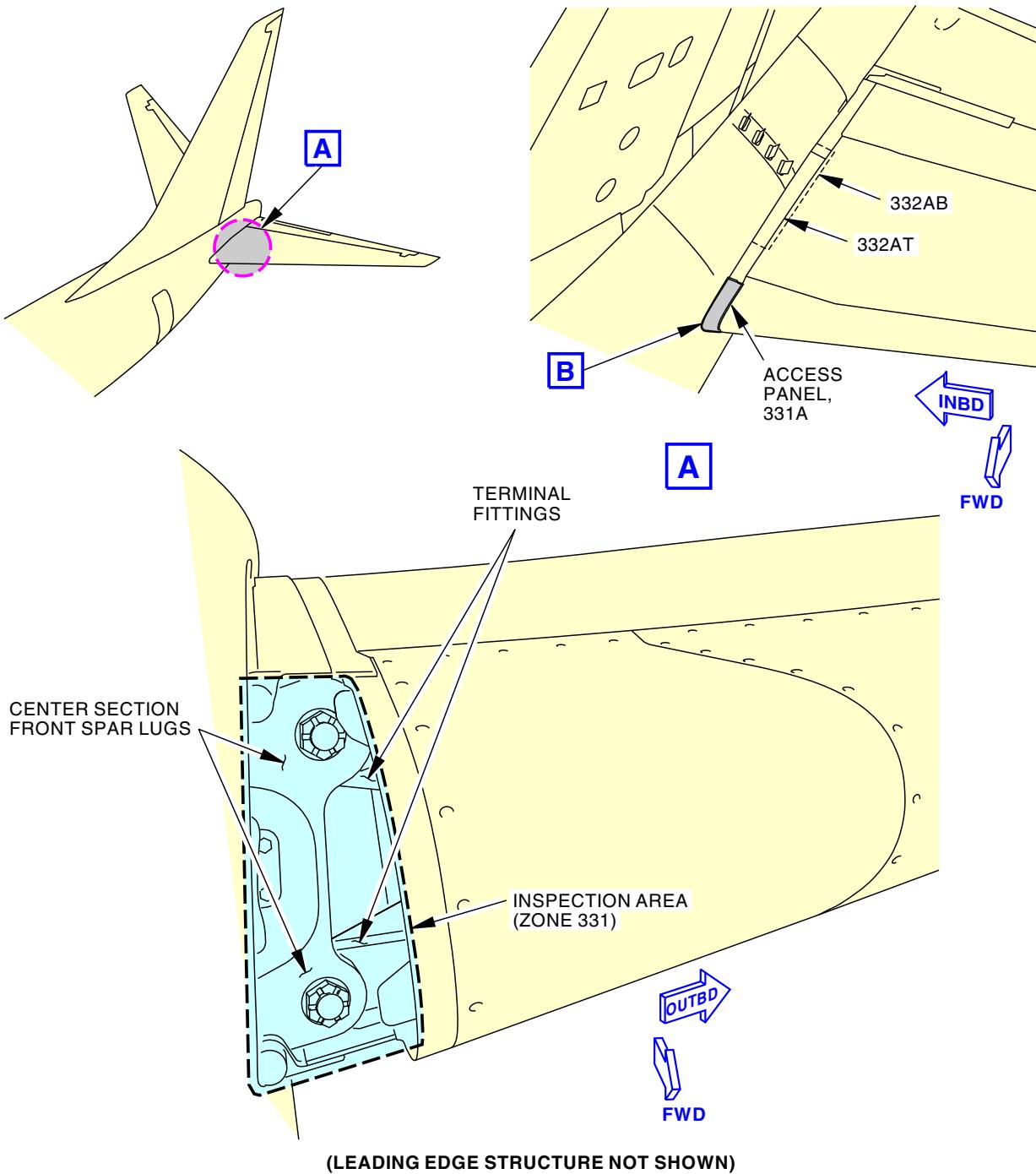
— END OF TASK —

EFFECTIVITY  
LOM ALL

**55-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
55-080-01

491949 S0000147488\_V2

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

EFFECTIVITY  
LOM ALL

**55-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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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. Location Zones**

<b>Zone</b>	<b>Area</b>
341	Right Horizontal Stabilizer - Removable Leading Edge

**B. Access Panels**

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

**C. Inspection**

SUBTASK 55-05-03-010-008

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
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) 737-6789 Basic Task Description, AMM Task 51-05-01-210-801.

SUBTASK 55-05-03-410-008

- (4) Close this access panel:

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

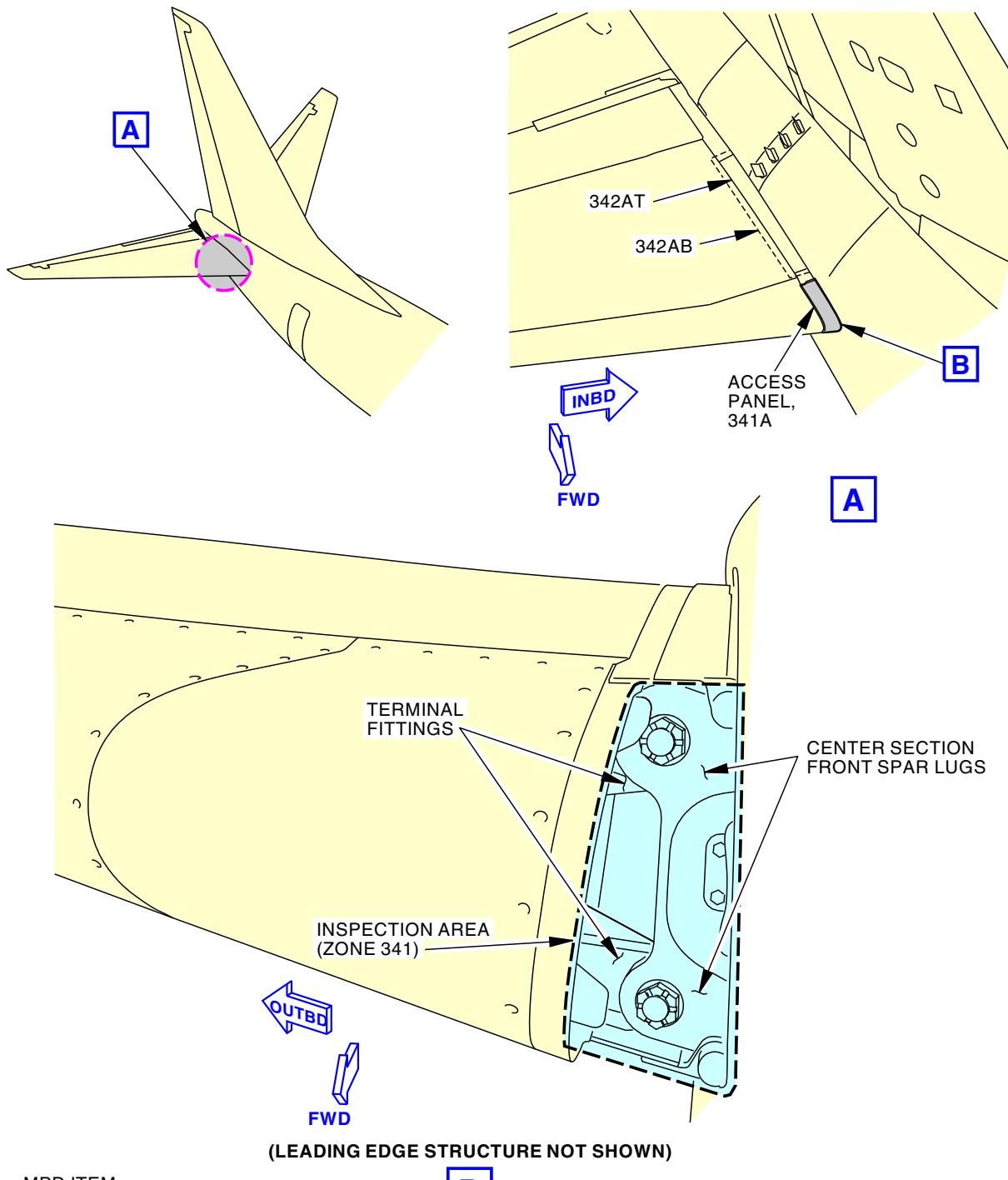
— END OF TASK —

EFFECTIVITY  
LOM ALL

**55-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
55-080-02

491976 S0000147487\_V2

Right Horizontal Stabilizer Leading Edge General Visual (Internal)  
Figure 209/55-05-03-990-807

EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**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	737-6789 Basic Task Description (P/B 201)
SRM 51-10-01	Structural Repair Manual

**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 281.81

**D. Access Panels**

Number	Name/Location
331B	Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ
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
332PB	Horizontal Stabilizer, Access Door
335A	Horizontal Stabilizer, Removable Stabilizer Tip

**E. Inspection**

SUBTASK 55-05-03-010-009

- (1) Open this access panel:  
(TASK 27-41-21-000-801)

EFFECTIVITY
LOM ALL

**55-05-03**



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**Number**    **Name/Location**

331B      Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

SUBTASK 55-05-03-010-023

- (2) Open these access panels:

**Number**    **Name/Location**

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  
332PB     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: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 55-05-03-410-009

- (5) Close these access panels:

**Number**    **Name/Location**

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  
332PB     Horizontal Stabilizer, Access Door  
335A      Horizontal Stabilizer, Removable Stabilizer Tip

EFFECTIVITY  
LOM ALL

**55-05-03**



**737-600/700/800/900**  
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SUBTASK 55-05-03-410-027

- (6) Close this access panel:

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

**Number      Name/Location**

331B      Horizontal Stabilizer - 331B is the Removable leading edge that includes individual panels 331BZ, 331CZ, 331DZ

SUBTASK 55-05-03-390-010

- (7) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

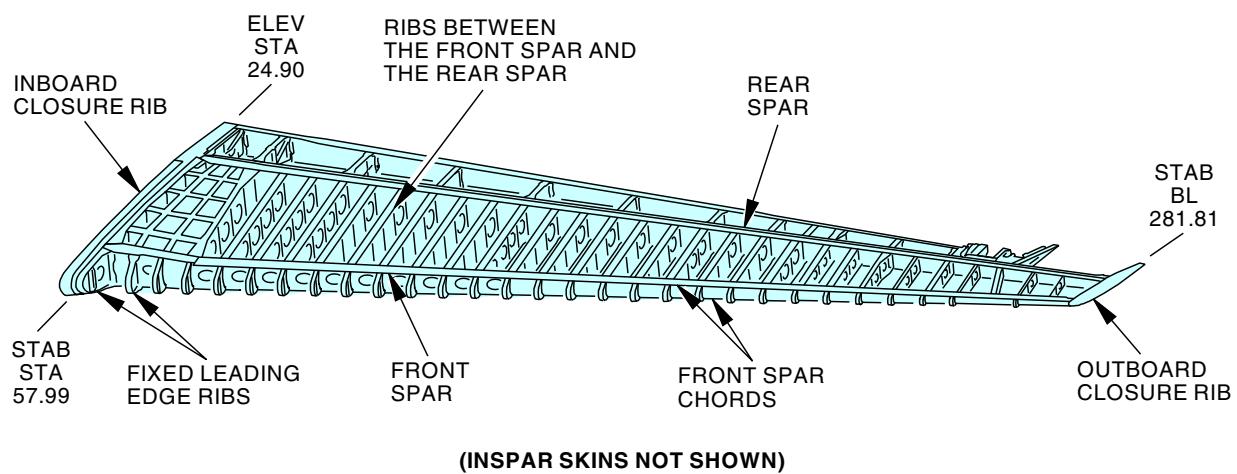
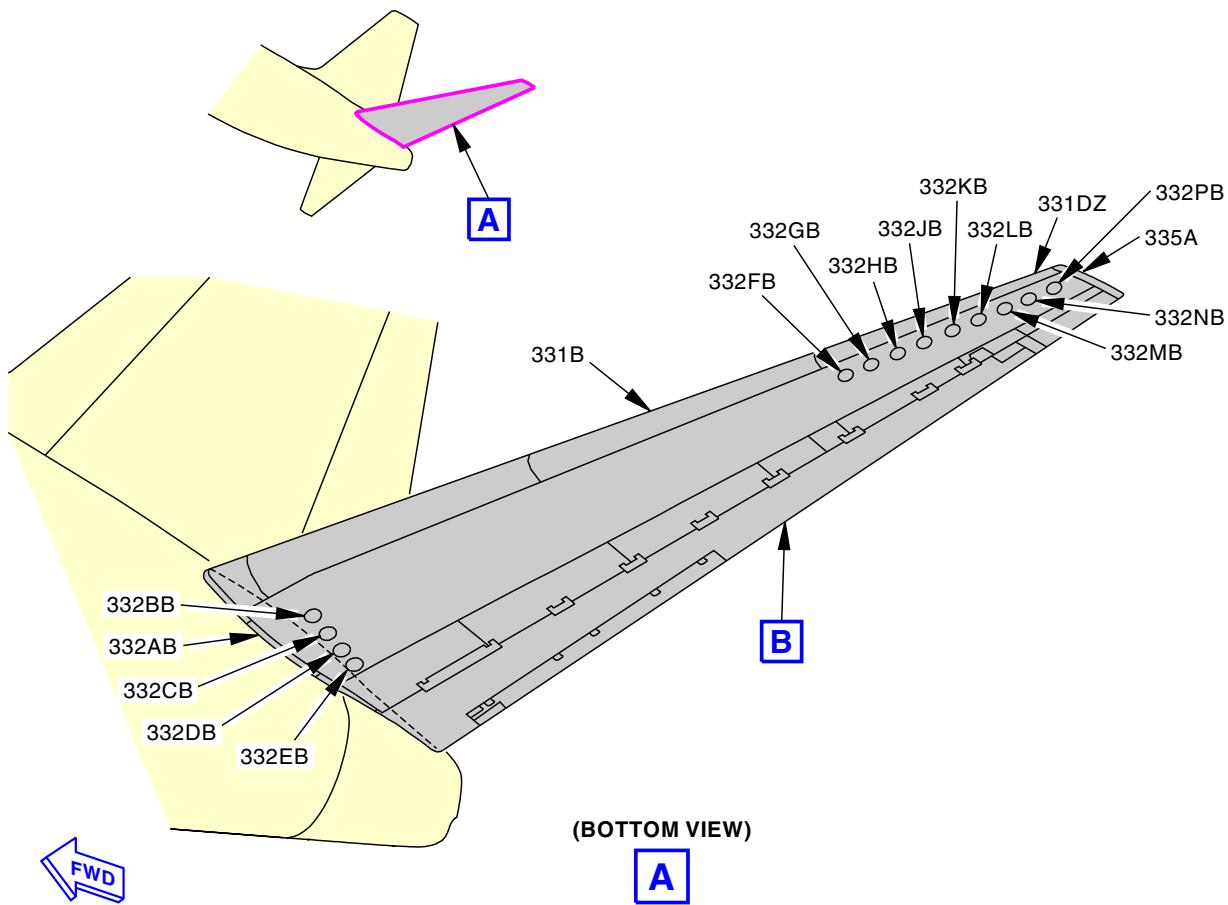
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**55-05-03**



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MPD ITEM  
55-100-01

2084317 S0000438551\_V2

INTERNAL-GENERAL VISUAL: LEFT HORIZONTAL STABILIZER  
Figure 210/55-05-03-990-822 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

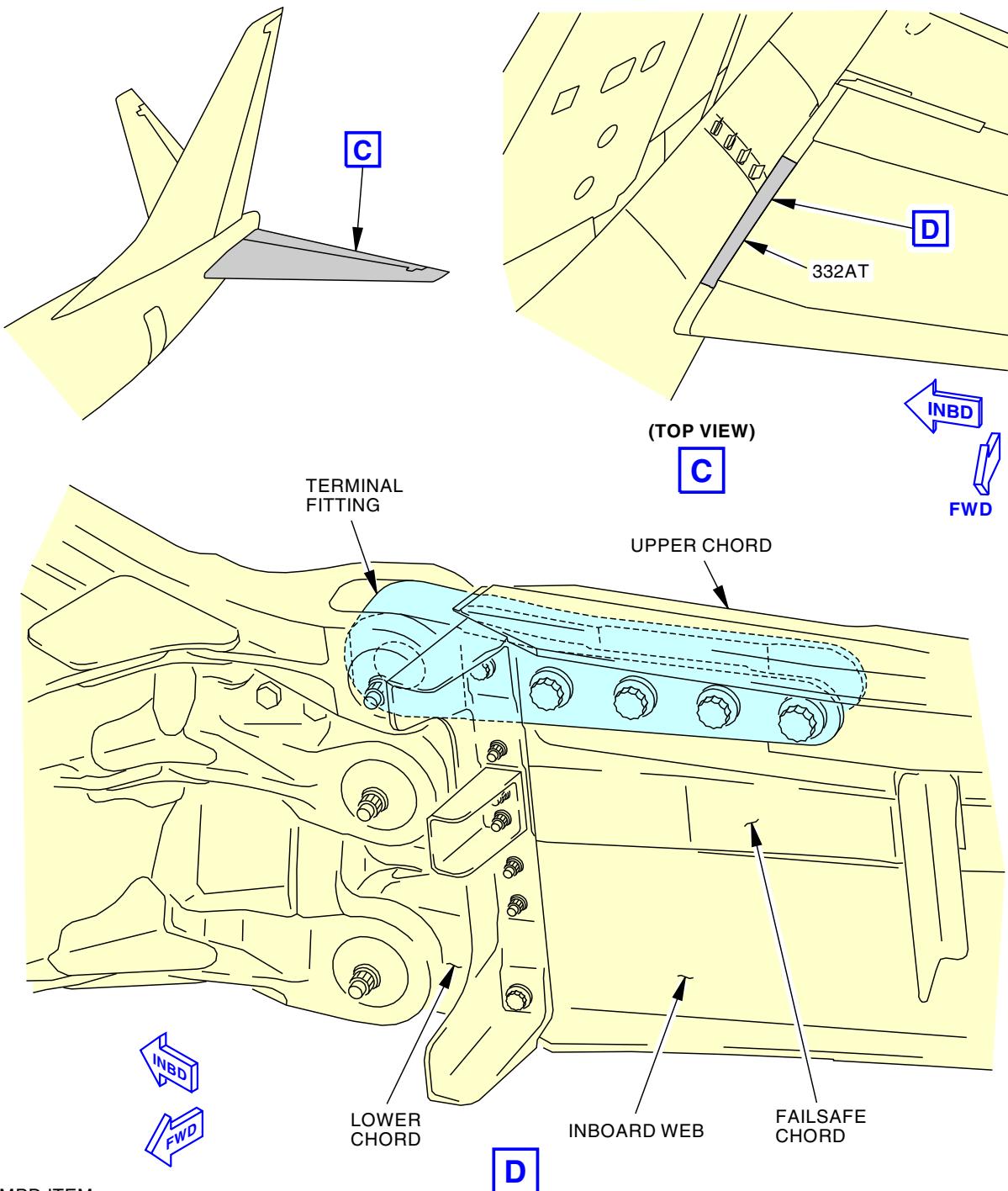
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MPD ITEM  
55-100-01

2084318 S0000438552\_V2

INTERNAL-GENERAL VISUAL: LEFT HORIZONTAL STABILIZER  
Figure 210/55-05-03-990-822 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**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	737-6789 Basic Task Description (P/B 201)
SRM 51-10-01	Structural Repair Manual

**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 281.81

**D. Access Panels**

Number	Name/Location
341B	Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ
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
342PB	Horizontal Stabilizer, Access Door
345A	Horizontal Stabilizer, Removable Stabilizer Tip

**E. Inspection**

SUBTASK 55-05-03-010-010

- (1) Open this access panel:  
(TASK 27-41-21-000-801)

EFFECTIVITY  
LOM ALL

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**Number**    **Name/Location**

341B      Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

SUBTASK 55-05-03-010-024

- (2) Open these access panels:

**Number**    **Name/Location**

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  
342PB      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: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 55-05-03-410-010

- (5) Close these access panels:

**Number**    **Name/Location**

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  
342PB      Horizontal Stabilizer, Access Door  
345A      Horizontal Stabilizer, Removable Stabilizer Tip

EFFECTIVITY  
LOM ALL

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SUBTASK 55-05-03-410-028

- (6) Close this access panel:

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

**Number      Name/Location**

341B      Horizontal Stabilizer - 341B is the Removable leading edge that includes individual panels 341BZ, 341CZ, 341DZ

SUBTASK 55-05-03-390-011

- (7) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

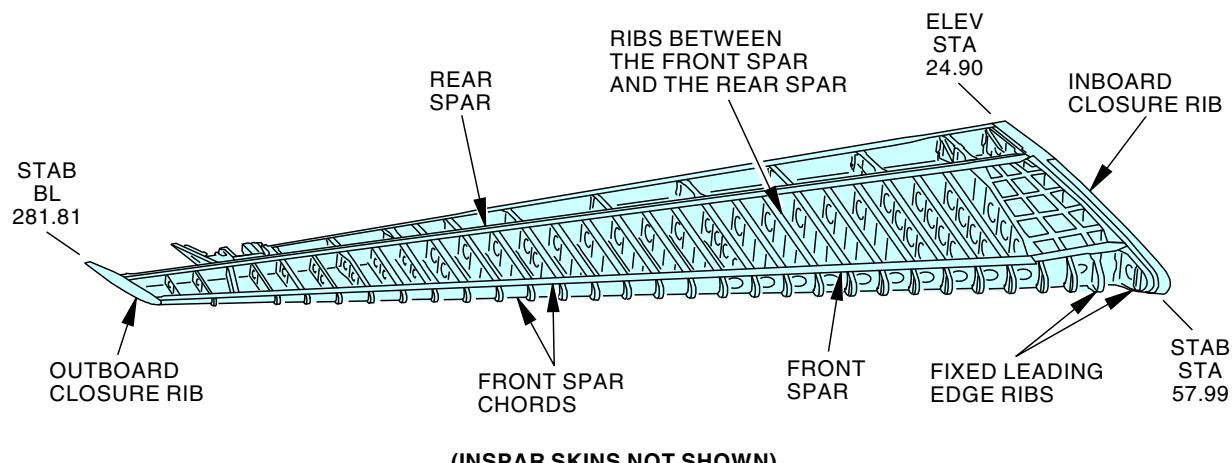
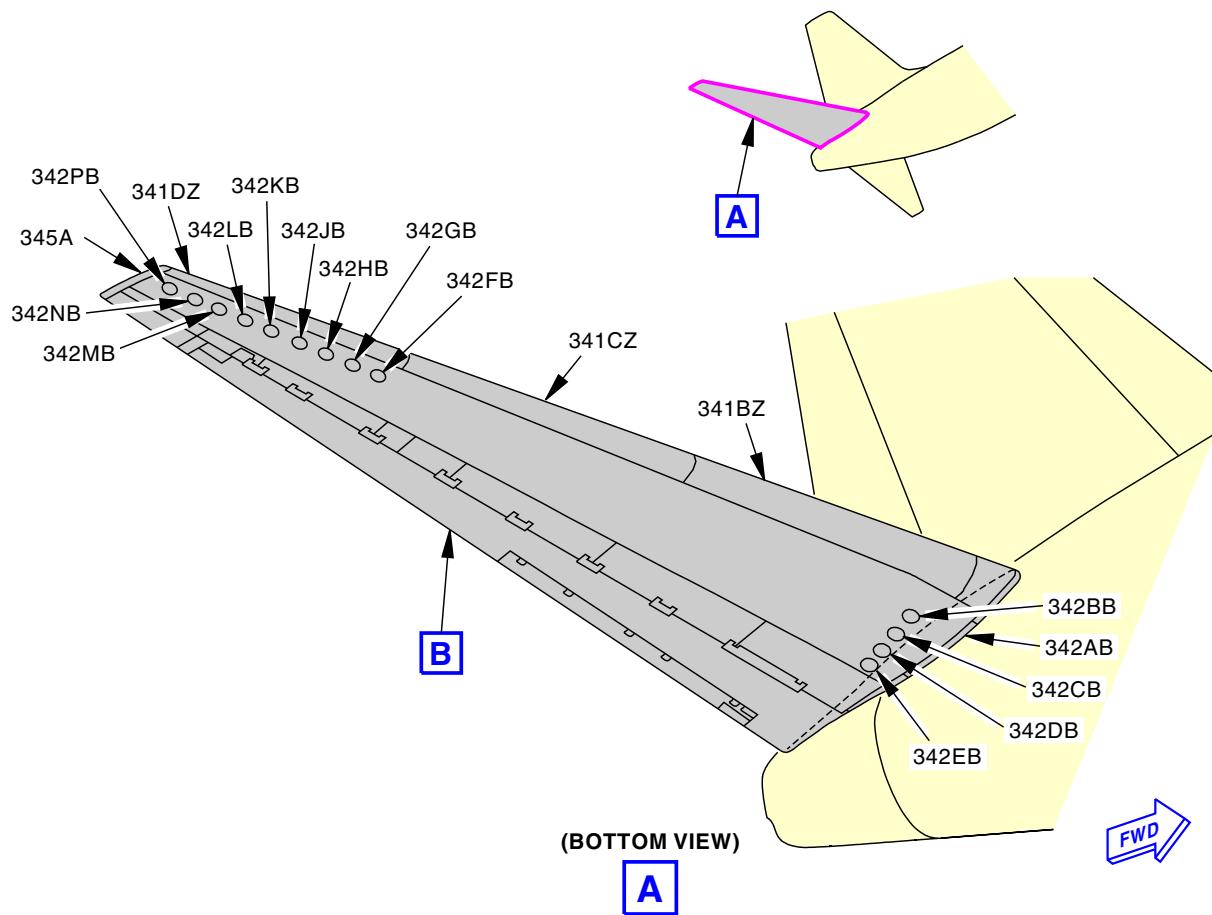
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**55-05-03**



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MPD ITEM  
55-100-02

2084315 S0000438553\_V2

INTERNAL-GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER  
Figure 211/55-05-03-990-823 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

D633A101-LOM

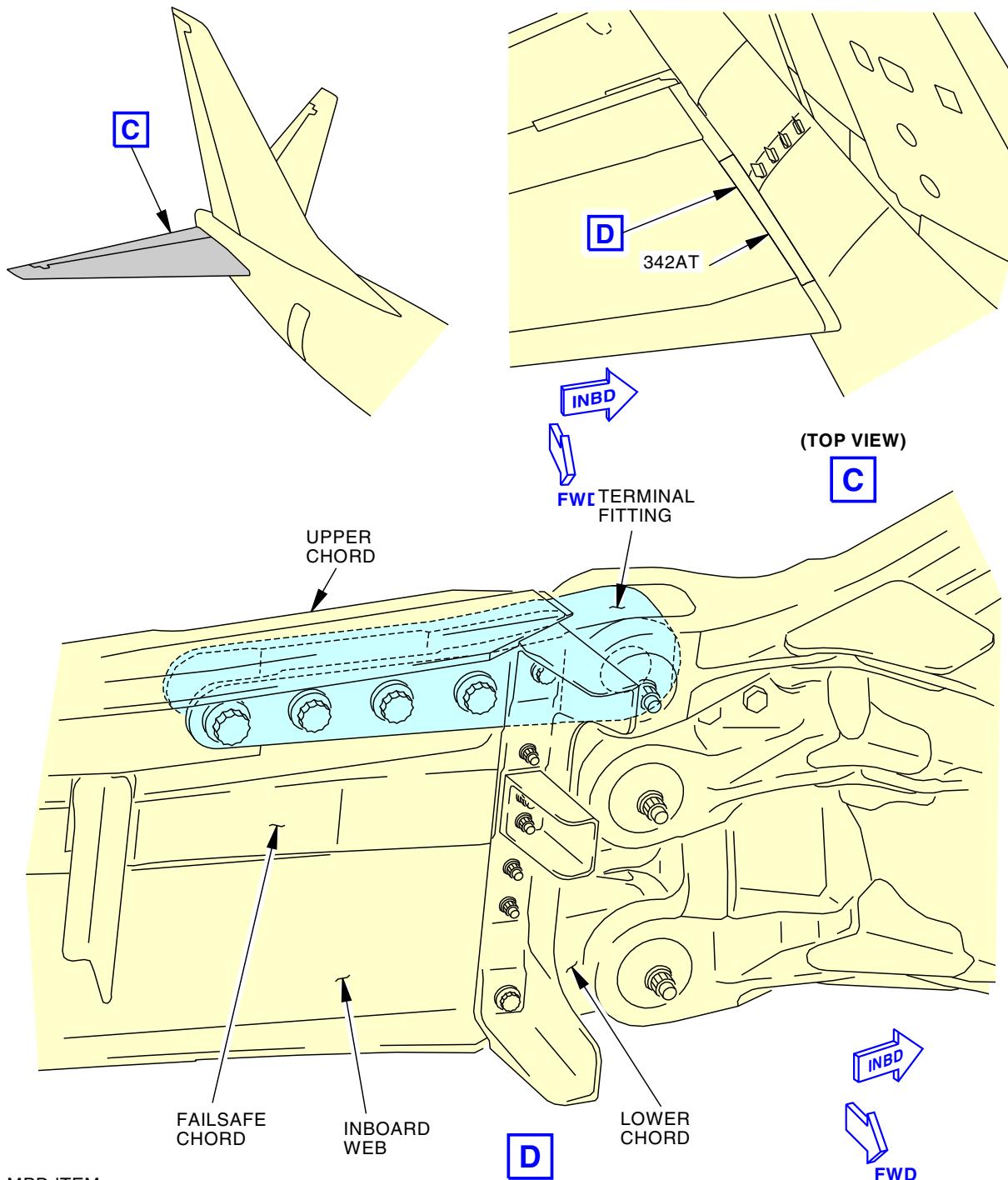
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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MPD ITEM  
55-100-02

2084319 S0000438554\_V2

**INTERNAL-GENERAL VISUAL: RIGHT HORIZONTAL STABILIZER**  
Figure 211/55-05-03-990-823 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**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	737-6789 Basic Task Description (P/B 201)
SOPM 20-30-03	General Cleaning Procedures
SRM 51-10-01	Structural Repair Manual

**B. Tools/Equipment**

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

Reference	Description
SPL-2035	Sling Equipment - Horizontal Stabilizer Part #: C55007-47 Supplier: 81205 Part #: C55007-48 (low clearance) 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

EFFECTIVITY  
LOM ALL

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(Continued)

<u>Number</u>	<u>Name/Location</u>
334FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
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 [1] and bolts [2] from the stabilizer top surface.



**WARNING** MAKE SURE YOU INSTALL THE HOISTING SLING CORRECTLY WHEN YOU REMOVE THE BOLTS. IF YOU DO NOT INSTALL THE HOISTING SLING CORRECTLY, YOU CAN CAUSE DAMAGE TO EQUIPMENT OR INJURY TO PERSONNEL.

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

**G. Inspection**

SUBTASK 55-05-03-010-011

- (1) Open 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

EFFECTIVITY  
LOM ALL

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(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

**SUBTASK 55-05-03-020-003**

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

**SUBTASK 55-05-03-010-019**

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

**SUBTASK 55-05-03-020-004**

- (4) At the horizontal stabilizer rear spar, do these steps:

(a) Remove the nuts [5] and washers [4] from the bolts [8].

(b) Remove the bolts [8], washers [7], and washers [3].

    1) If it is necessary, remove the seal support structure before you remove these bolts.

    2) Keep a record of each bolt length and location for the installation.

(c) Remove the washers [10], pins [6], and anti-rotation locks [15].

    1) If it is necessary, adjust the tension of the sling to help remove the pins.

(d) Remove and inspect each bolt or pin.

**NOTE:** If an existing bolt or pin has missing plating, cracked, or flaking, prior to further flight replace with new parts or repair in accordance with a method approved by an Authorized Representative for the BCA Organization Designation Authorization who has been authorized to make those findings.

- 1) If the bolts or pins show signs of damage: pitting, corrosion, no plating (pins only), galling (bolts only) or wear beyond drawing tolerances, replace them with the improved bolts or pins.
- 2) If the pins or bolts show no sign of damage, they can be reinstalled or replaced with an improved front spar bolts or rear spar pins designed to resist wear, galling, or corrosion.

**SUBTASK 55-05-03-100-009**

- (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 [6].

**SUBTASK 55-05-03-910-012**

- (7) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-804.

**SUBTASK 55-05-03-100-007**

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

EFFECTIVITY  
LOM ALL

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SUBTASK 55-05-03-420-006

- (9) At the rear spar of the horizontal stabilizer, do these steps:

- (a) Install the anti-rotation locks [15], pins [6], washers [10], washers [3], washers [7], bolts [8] with the bolt heads either forward or aft, washers [4] and nuts [5].
- (b) Measure the clearance between the bushing faces of the external and internal lugs (Figure 212).

NOTE: This clearance measurement is for the sum of the two clearances (A1 and A2) at each of the three rear spar clevises.

- 1) Make sure that the maximum allowable clearance for each clevis at the center (failsafe) and lower lugs (sum of the two clearances, A1 and A2, at each lug) is 0.032 in. (0.81 mm).
- 2) Make sure that the maximum allowable clearance for the upper clevis (sum of the two clearances, A1 and A2) is 0.046 in. (1.17 mm).
- (c) Tighten the nuts [5] to 500 in-lb (56 N·m) - 650 in-lb (73 N·m) but keep a clearance of 0.005 in. (0.13 mm) - 0.090 in. (2.29 mm) after the nut is tightened.

NOTE: The clearance of 0.005 in. (0.13 mm) - 0.090 in. (2.29 mm) after the nuts [5] are tightened, is taken between the Stabilizer Center Section Clevis and washer [4].

## H. Put the Airplane Back to Its Usual Condition

SUBTASK 55-05-03-420-002

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

SUBTASK 55-05-03-420-003

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

SUBTASK 55-05-03-410-021

- (3) Close this access panel:

Number      Name/Location

333AB      Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

- (a) Make sure that the blade seal is installed correctly into the forward track channel.

SUBTASK 55-05-03-410-011

- (4) Close these access panels:

Number      Name/Location

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

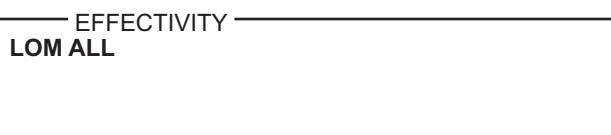
334CB      Horizontal Stabilizer, Seal, Trailing Edge to Elevator

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



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Special Access:

**Number      Name/Location**

S3331      Left Horizontal Stabilizer Trailing Edge Inspection

SUBTASK 55-05-03-390-003

- (5) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

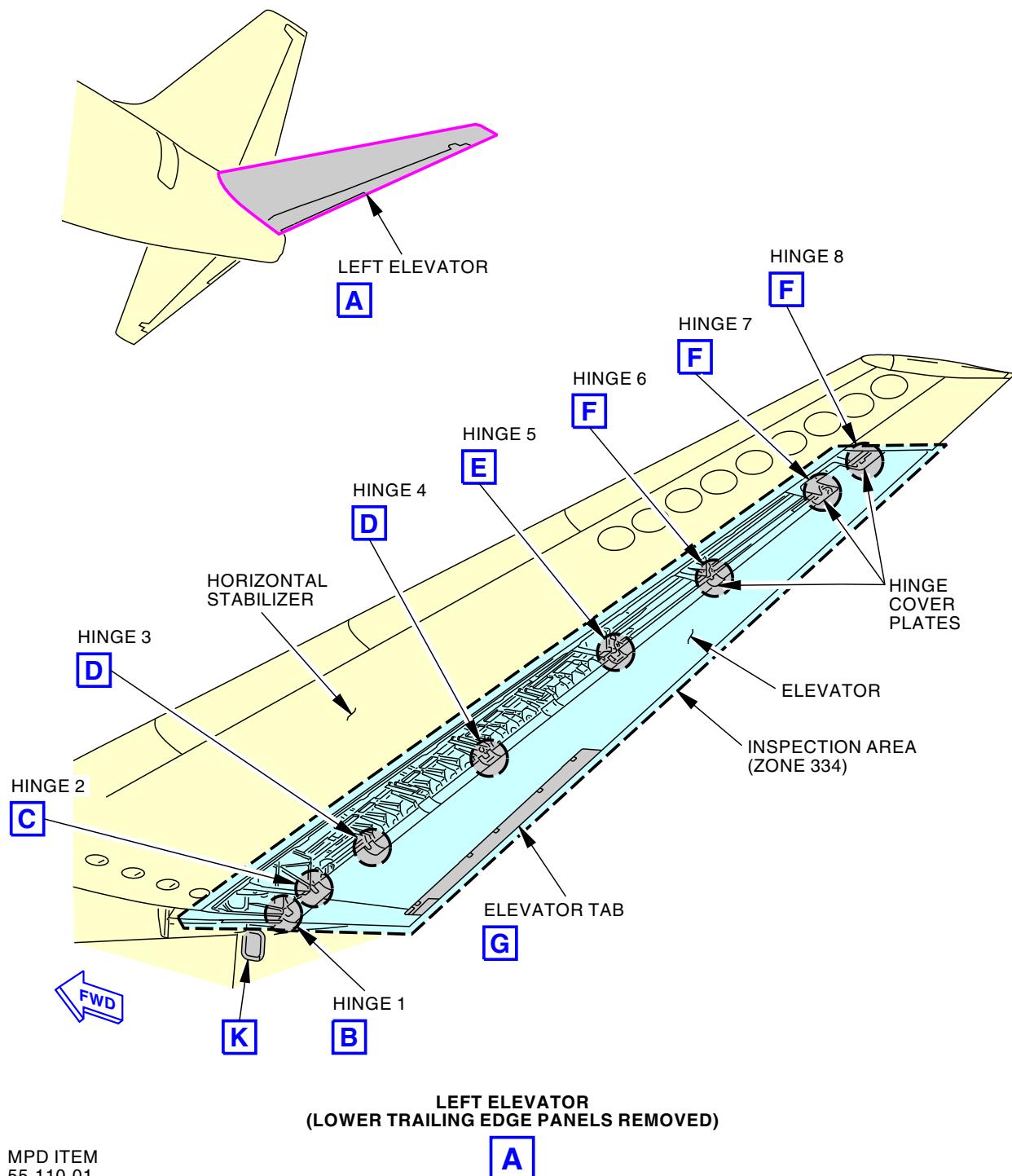
SUBTASK 55-05-03-080-003

- (6) Remove the sling equipment, SPL-2035.
- (a) Release tension applied to the sling equipment, SPL-2035.
  - (b) Remove the hoist to 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 stabilizer top surface.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

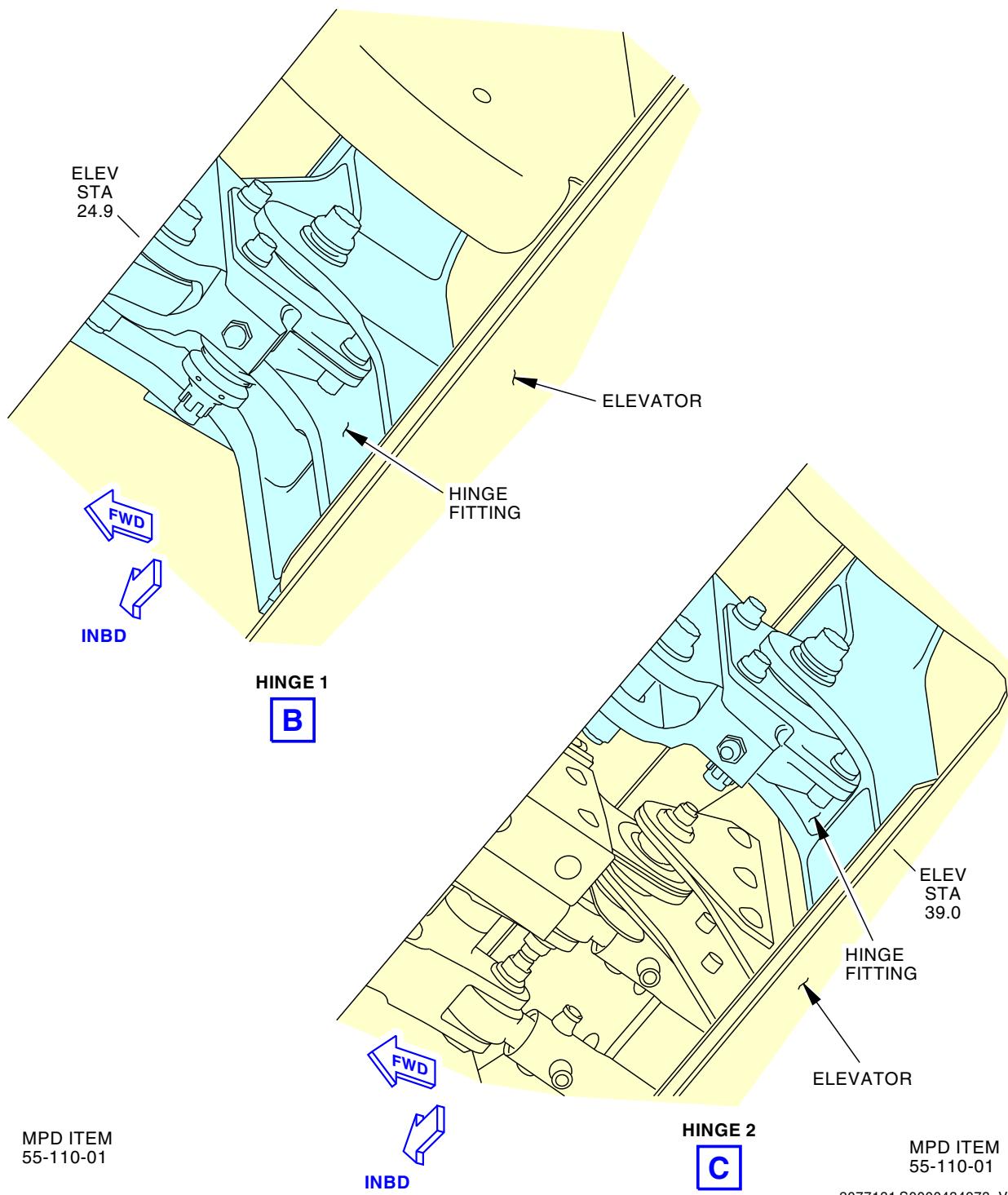
**55-05-03**



**Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual  
(Internal)**  
**Figure 212/55-05-03-990-818 (Sheet 1 of 10)**

EFFECTIVITY  
LOM ALL

**55-05-03**



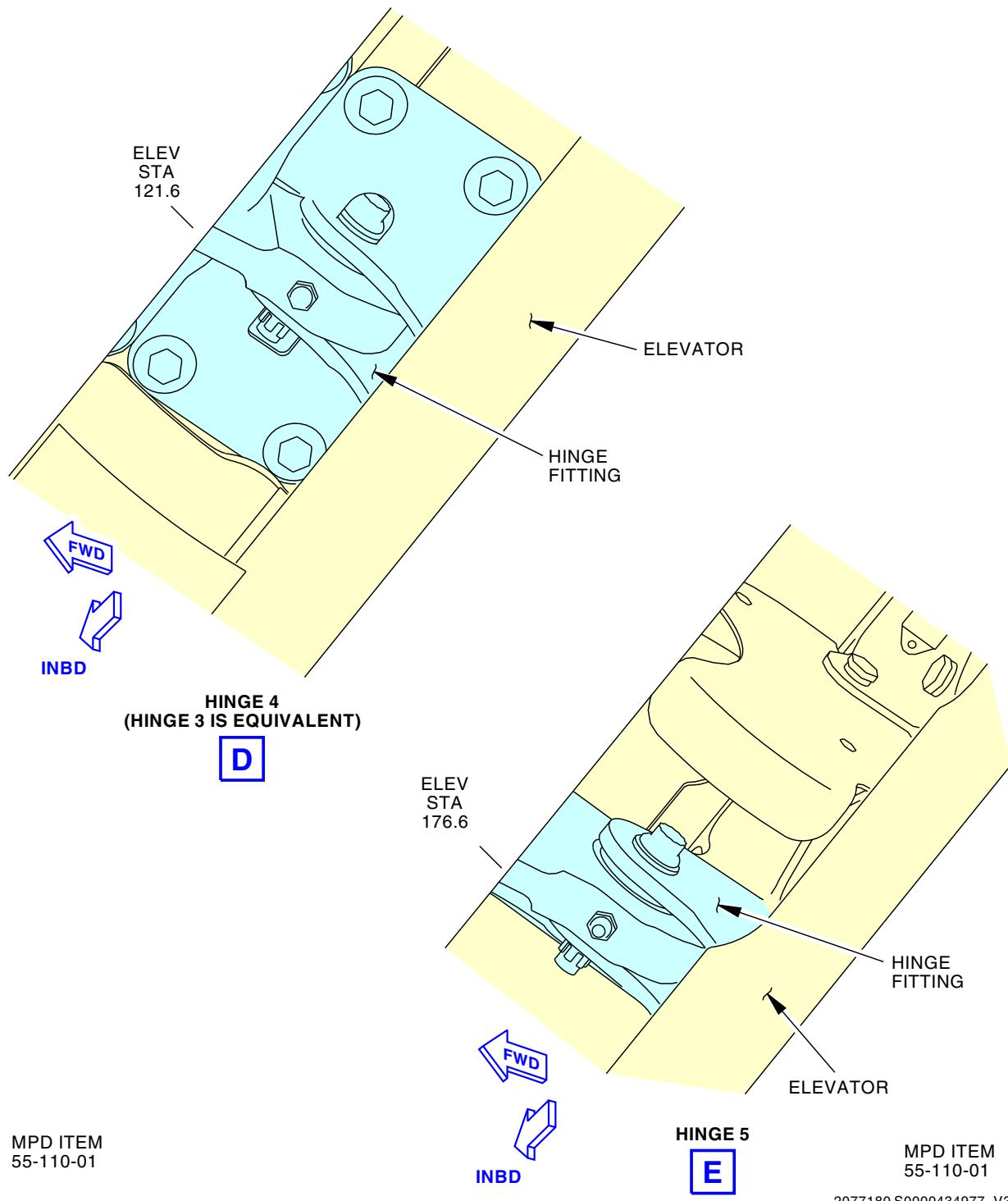
**Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)**  
**Figure 212/55-05-03-990-818 (Sheet 2 of 10)**

EFFECTIVITY  
LOM ALL

**55-05-03**

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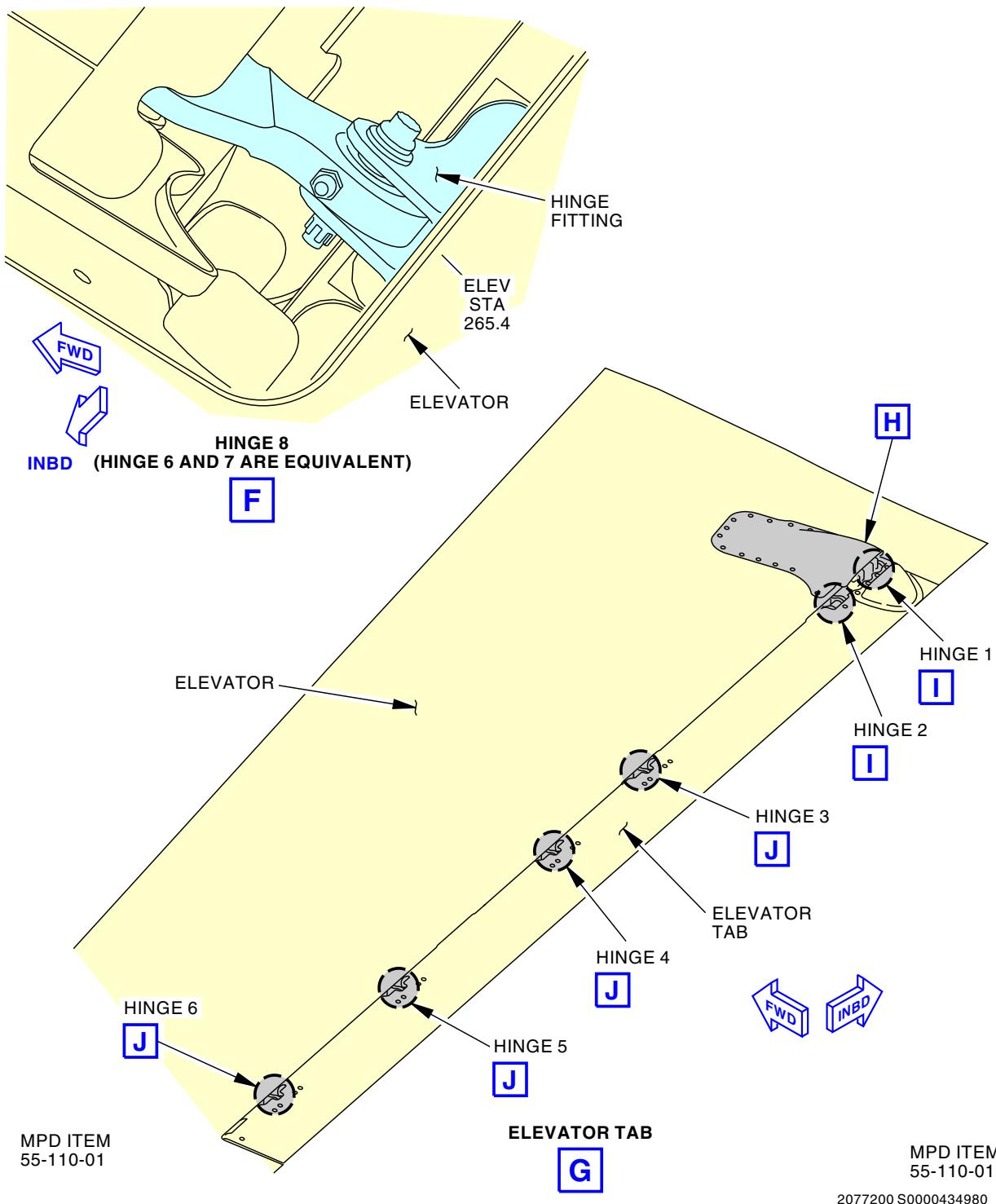
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**Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)**  
**Figure 212/55-05-03-990-818 (Sheet 3 of 10)**

EFFECTIVITY  
LOM ALL

**55-05-03**



**Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)**  
**Figure 212/55-05-03-990-818 (Sheet 4 of 10)**

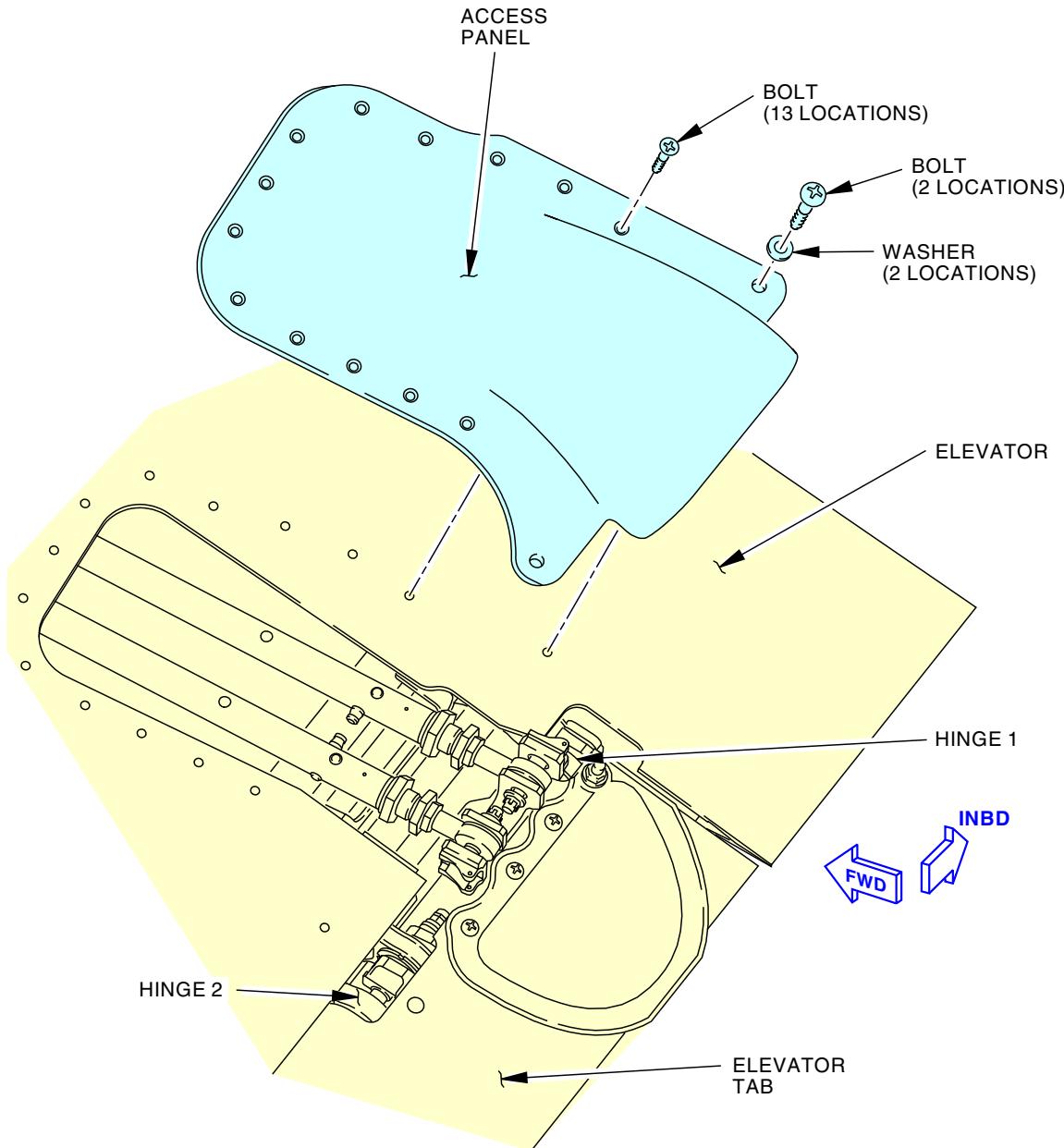
EFFECTIVITY	
LOM ALL	

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MPD ITEM  
55-110-01

H

MPD ITEM  
55-110-01

2077205 S0000434982\_V3

**Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)**  
**Figure 212/55-05-03-990-818 (Sheet 5 of 10)**

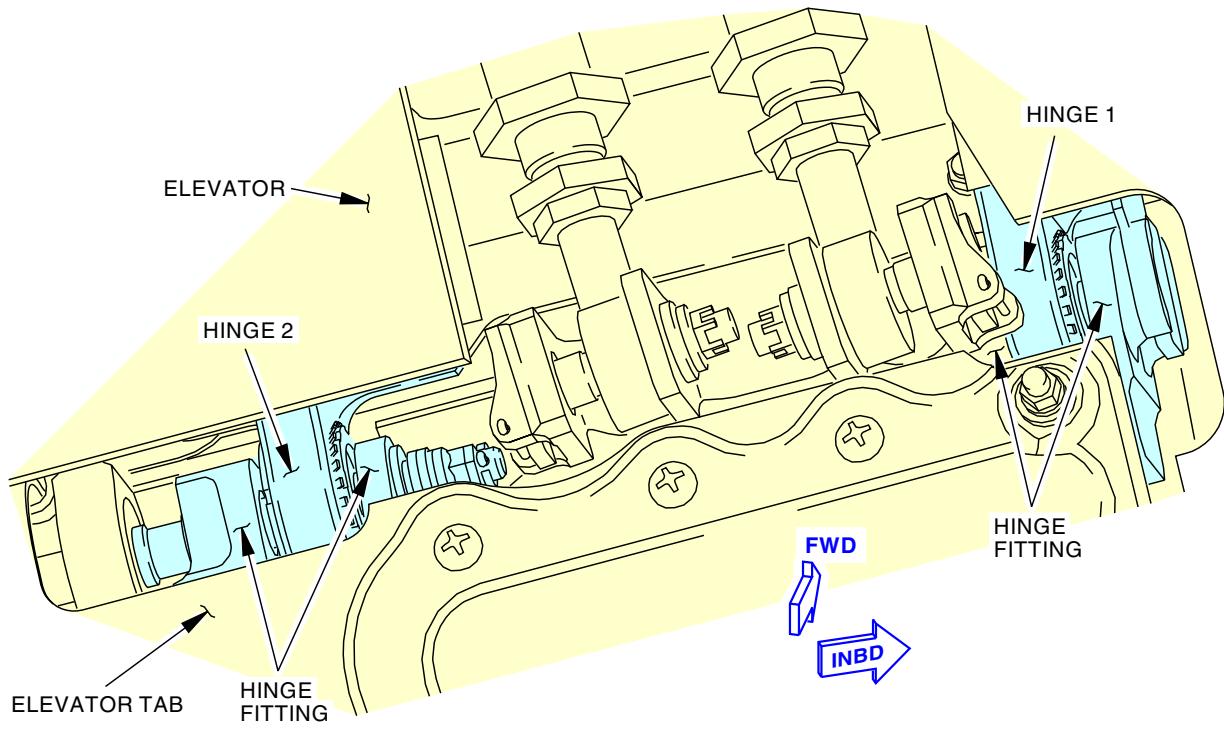
EFFECTIVITY  
LOM ALL

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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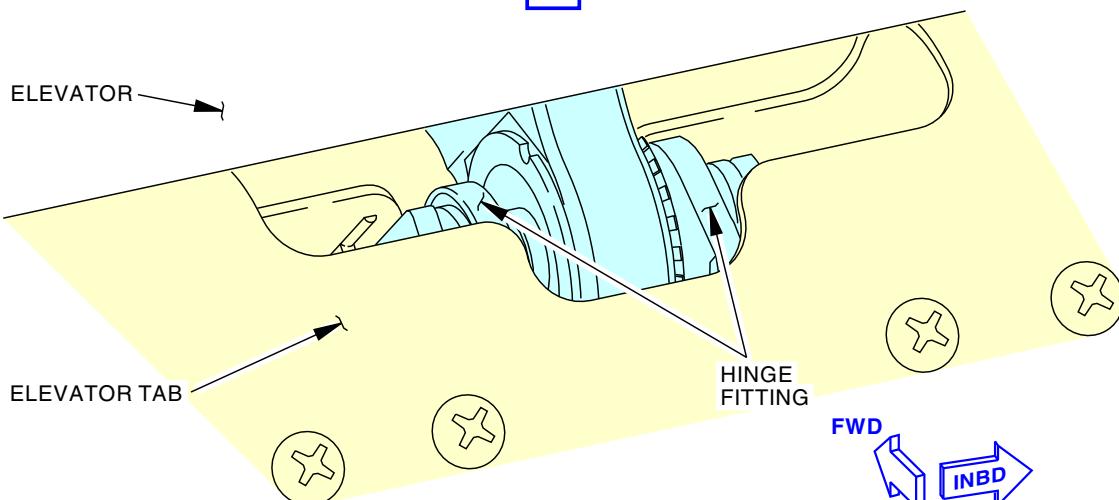
**55-05-03**

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**HINGE 1 AND 2  
(COVER REMOVED FOR CLARITY)**

I



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

J

MPD ITEM  
55-110-01

MPD ITEM  
55-110-01

2077208 S0000434983\_V3

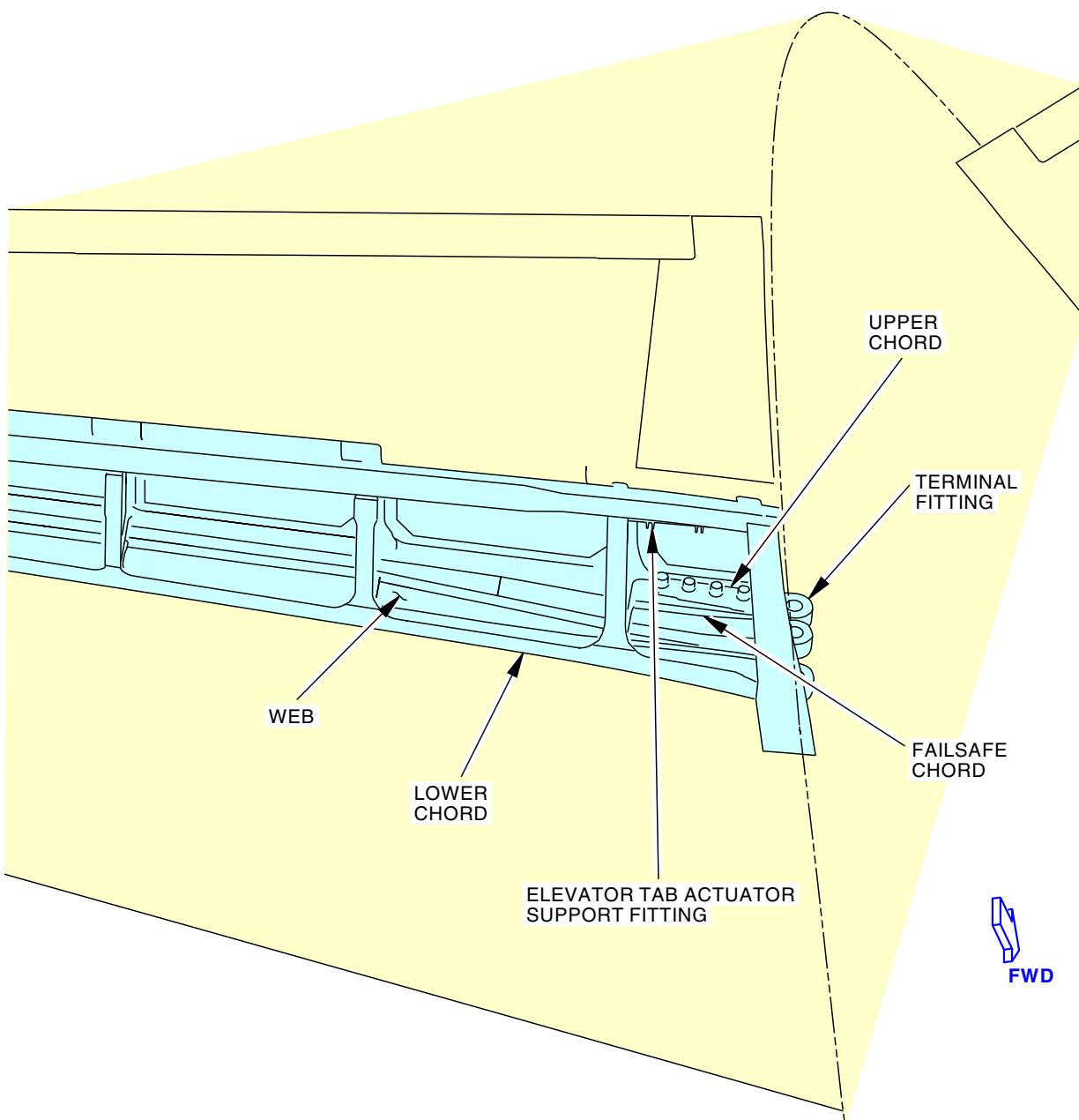
**Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual  
(Internal)**  
**Figure 212/55-05-03-990-818 (Sheet 6 of 10)**

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

MPD ITEM  
55-110-01

K

MPD ITEM  
55-110-01

2077326 S0000434985\_V3

Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual  
(Internal)  
Figure 212/55-05-03-990-818 (Sheet 7 of 10)

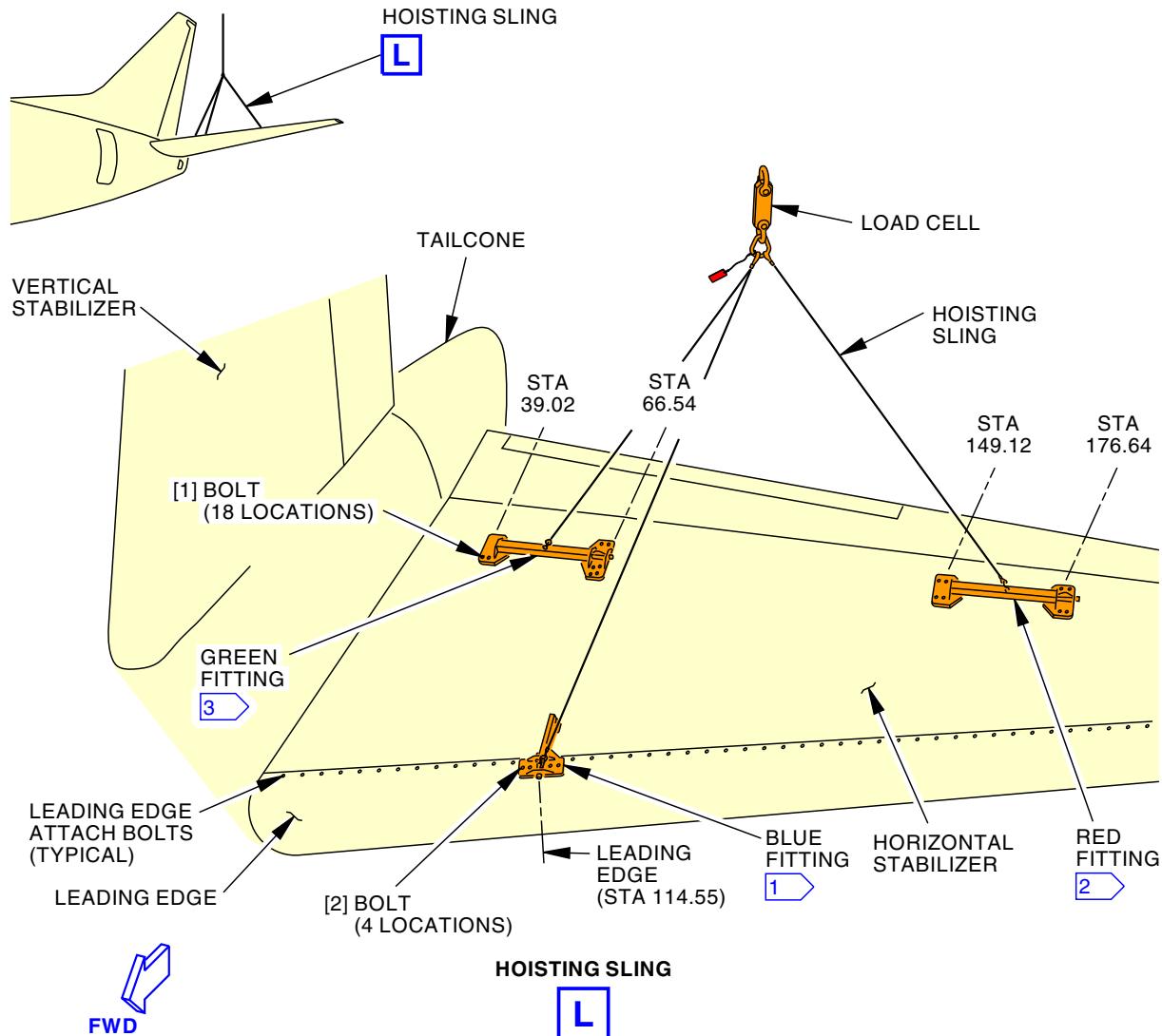
EFFECTIVITY  
LOM ALL

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**[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.

2438800 S0000565960\_V2

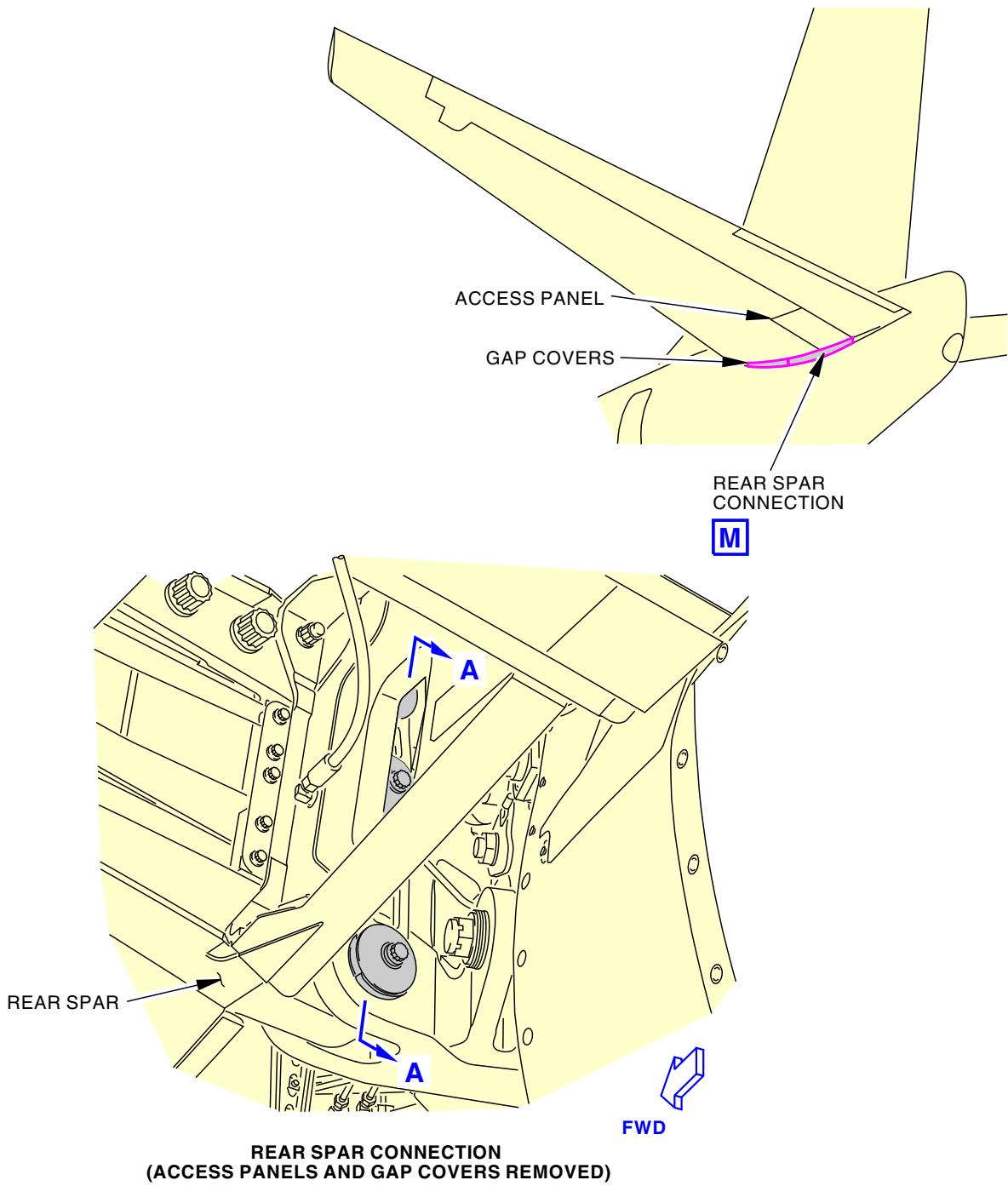
**Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)**

**Figure 212/55-05-03-990-818 (Sheet 8 of 10)**

EFFECTIVITY
LOM ALL

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**BOEING**  
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2438817 S0000565961\_V1

**Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual  
(Internal)**  
**Figure 212/55-05-03-990-818 (Sheet 9 of 10)**

EFFECTIVITY	LOM ALL
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**55-05-03**

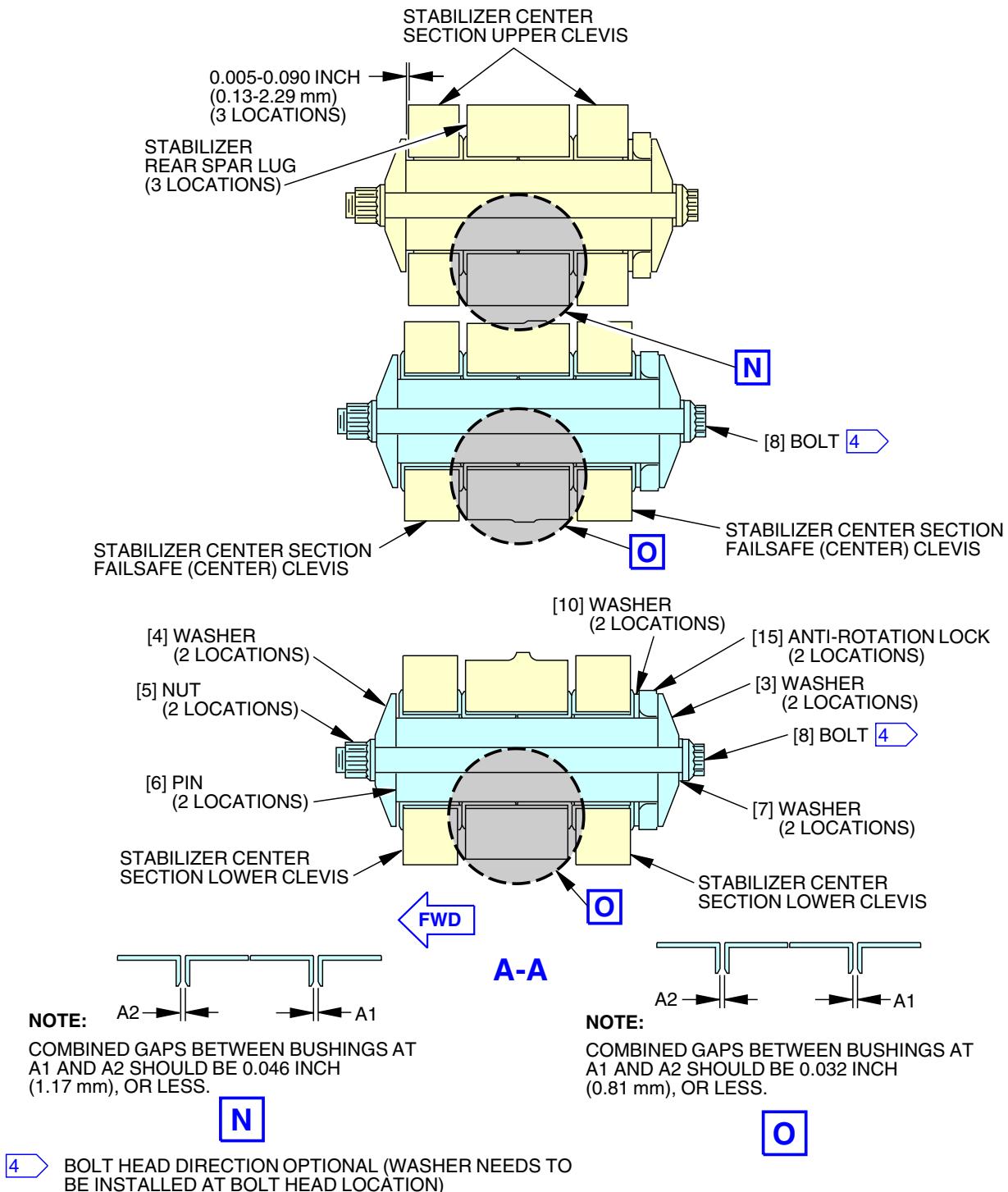
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2438844 S0000565962\_V5

**Left Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)**  
**Figure 212/55-05-03-990-818 (Sheet 10 of 10)**

EFFECTIVITY  
LOM ALL

**55-05-03**

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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**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	737-6789 Basic Task Description (P/B 201)
SOPM 20-30-03	General Cleaning Procedures
SRM 51-10-01	Structural Repair Manual

**B. Tools/Equipment**

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

Reference	Description
SPL-2035	Sling Equipment - Horizontal Stabilizer Part #: C55007-47 Supplier: 81205 Part #: C55007-48 (low clearance) 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

EFFECTIVITY  
LOM ALL

D633A101-LOM

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(Continued)

<u>Number</u>	<u>Name/Location</u>
344FB	Horizontal Stabilizer, Seal, Trailing Edge to Elevator
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 [1] and bolts [2] from the stabilizer top surface.



**WARNING** MAKE SURE YOU INSTALL THE HOISTING SLING CORRECTLY WHEN YOU REMOVE THE BOLTS. IF YOU DO NOT INSTALL THE HOISTING SLING CORRECTLY, YOU CAN CAUSE DAMAGE TO EQUIPMENT OR INJURY TO PERSONNEL.

- (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 a 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) (830 lb (376 kg) airplane part + 58 lb (26 kg) tool) with elevator attached
  - 688 lb (312 kg) (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:

<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

EFFECTIVITY  
LOM ALL

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(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

**SUBTASK 55-05-03-020-005**

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

**SUBTASK 55-05-03-010-020**

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

**SUBTASK 55-05-03-020-006**

- (4) At the horizontal stabilizer rear spar, do these steps:

- (a) Remove the nuts [5] and washers [4] from the bolts [8].
- (b) Remove the bolts [8], washers [7], and washers [3].
  - 1) If it is necessary, remove the seal support structure before you remove these bolts.
  - 2) Keep a record of each bolt length and location for the installation.
- (c) Remove the washers [10], pins [6], and anti-rotation locks [15].
  - 1) If it is necessary, adjust the tension of the sling to help remove the pins.
- (d) Remove and inspect each bolt or pin.

**NOTE:** If an existing bolt or pin has missing plating, cracked, or flaking, prior to further flight replace with new parts or repair in accordance with a method approved by an Authorized Representative for the BCA Organization Designation Authorization who has been authorized to make those findings.

- 1) If the bolts or pins show signs of damage: pitting, corrosion, no plating (pins only), galling (bolts only) or wear beyond drawing tolerances, replace them with the improved bolts or pins.
- 2) If the pins or bolts show no sign of damage, they can be reinstalled or replaced with an improved front spar bolts or rear spar pins designed to resist wear, galling, or corrosion.

**SUBTASK 55-05-03-100-003**

- (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 [6].

**SUBTASK 55-05-03-910-013**

- (7) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-804.

**SUBTASK 55-05-03-100-005**

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

EFFECTIVITY  
LOM ALL

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SUBTASK 55-05-03-400-005

- (9) At the rear spar of the horizontal stabilizer, do these steps:

- (a) Install the anti-rotation locks [15], pins [6], washers [10], washers [3], washers [7], bolts [8] with the bolt heads either forward or aft, washers [4] and nuts [5].
- (b) Measure the clearance between the bushing faces of the external and internal lugs (Views O and N, Figure 213).

NOTE: This clearance measurement is for the sum of the two clearances (A1 and A2) at each of the three rear spar clevises.

- 1) Make sure that the maximum allowable clearance for each clevis at the center (failsafe) and lower lugs (sum of the two clearances, A1 and A2, at each lug) is 0.032 in. (0.81 mm).
- 2) Make sure that the maximum allowable clearance for the upper clevis (sum of the two clearances, A1 and A2) is 0.046 in. (1.17 mm).
- (c) Tighten the nuts [5] to 500 in-lb (56 N·m) - 650 in-lb (73 N·m) but keep a clearance of 0.005 in. (0.13 mm) - 0.090 in. (2.29 mm) after the nut is tightened.

NOTE: The clearance of 0.005 in. (0.13 mm) - 0.090 in. (2.29 mm) after the nuts [5] are tightened, is taken between the Stabilizer Center Section Clevis and washer [4].

## H. Put the Airplane Back to Its Usual Condition

SUBTASK 55-05-03-420-004

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

SUBTASK 55-05-03-420-005

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

SUBTASK 55-05-03-410-022

- (3) Close this access panel:

Number      Name/Location

343AB      Horizontal Stabilizer, Gap Cover - H. Stab. to Body

- (a) Make sure that the blade seal is installed correctly into the forward track channel.

SUBTASK 55-05-03-410-012

- (4) Close these access panels:

Number      Name/Location

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



**55-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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**AIRCRAFT MAINTENANCE MANUAL**

Special Access:

**Number      Name/Location**

S3431      Right Horizontal Stabilizer Trailing Edge

SUBTASK 55-05-03-390-004

- (5) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

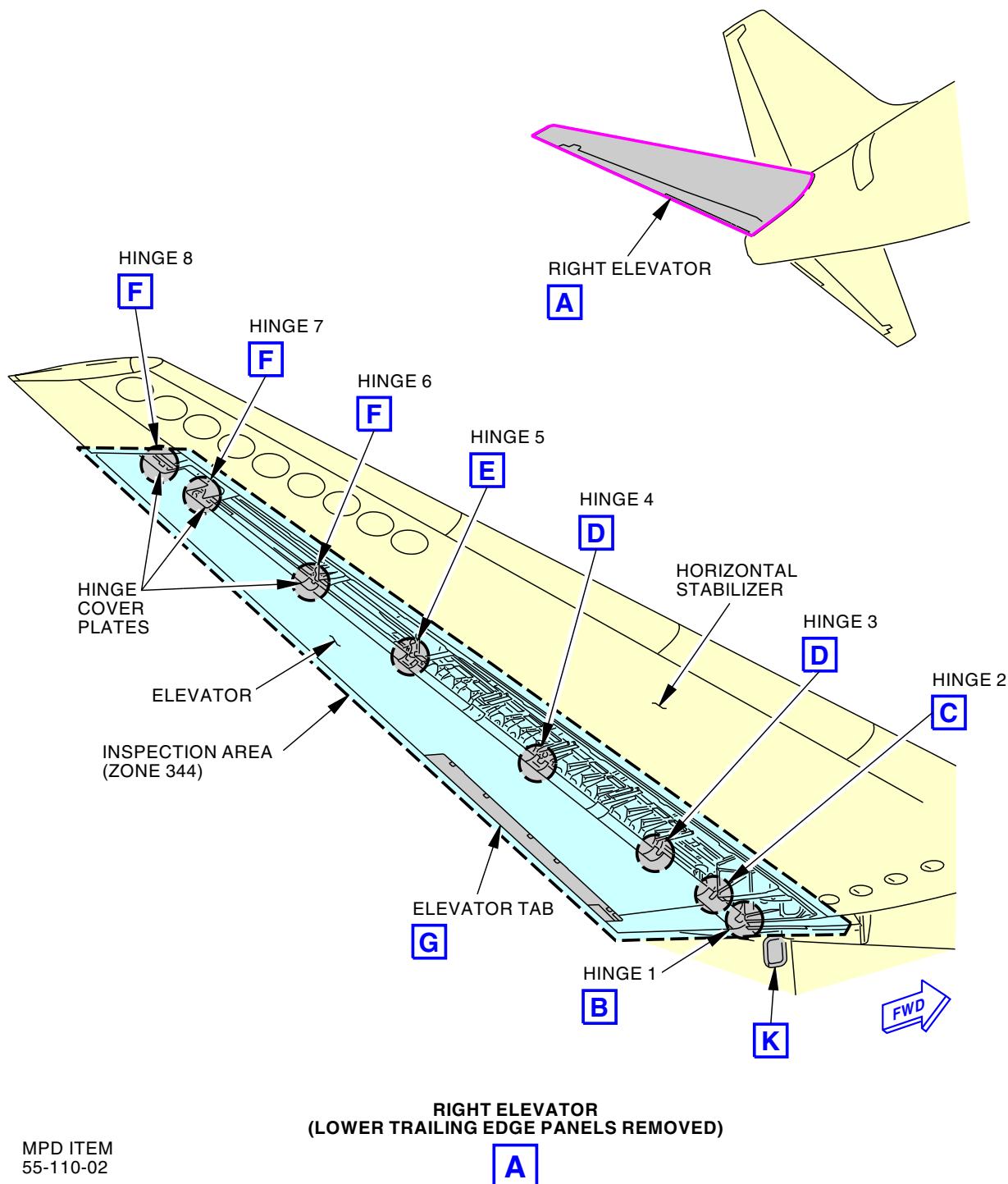
SUBTASK 55-05-03-080-004

- (6) Remove the sling equipment, SPL-2035.
- (a) Release tension applied to the sling equipment, SPL-2035.
  - (b) Remove the hoist to 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 stabilizer top surface.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**55-05-03**



**Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)**  
**Figure 213/55-05-03-990-819 (Sheet 1 of 10)**

EFFECTIVITY  
LOM ALL

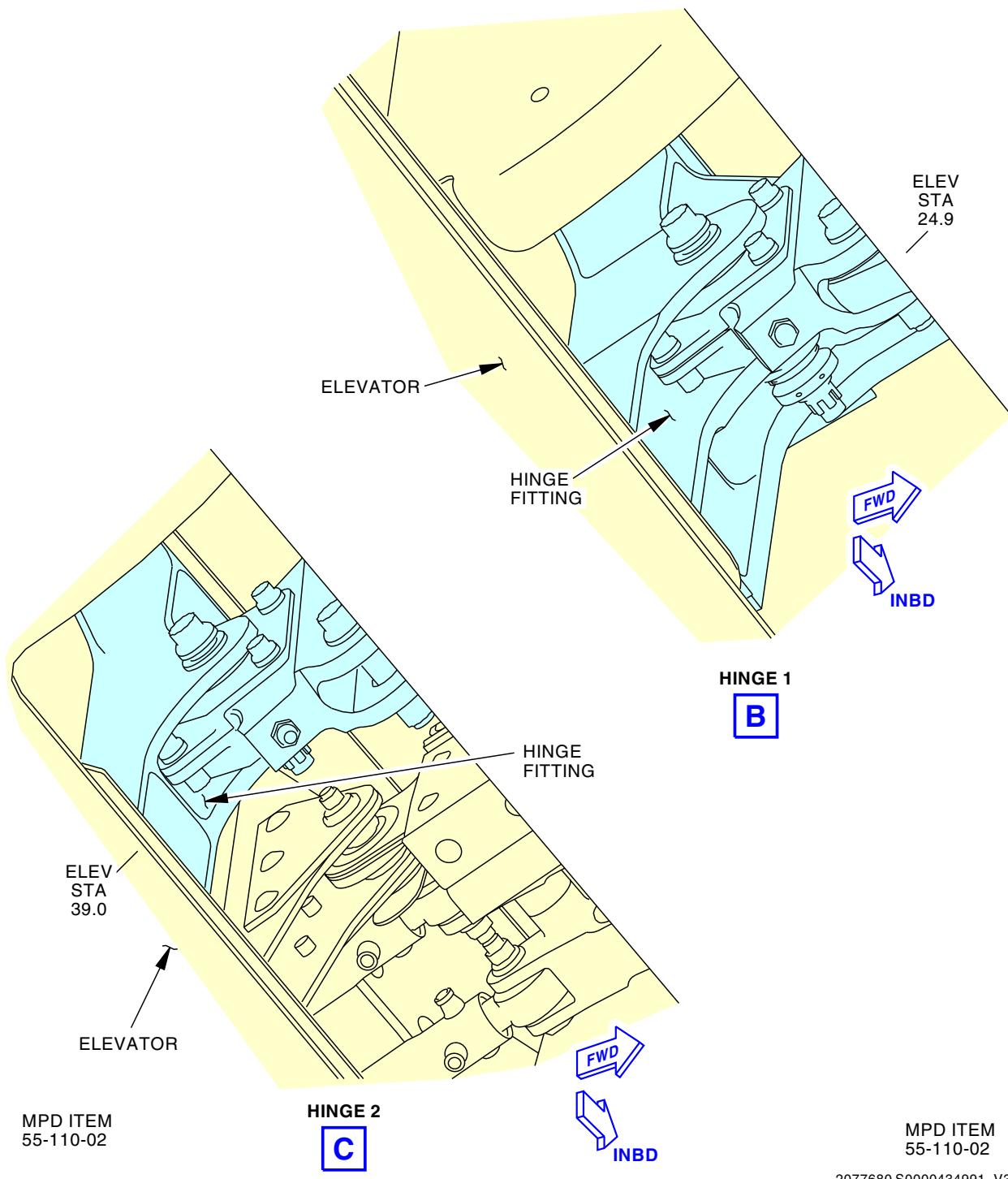
D633A101-LOM

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**Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)**  
**Figure 213/55-05-03-990-819 (Sheet 2 of 10)**

EFFECTIVITY  
LOM ALL

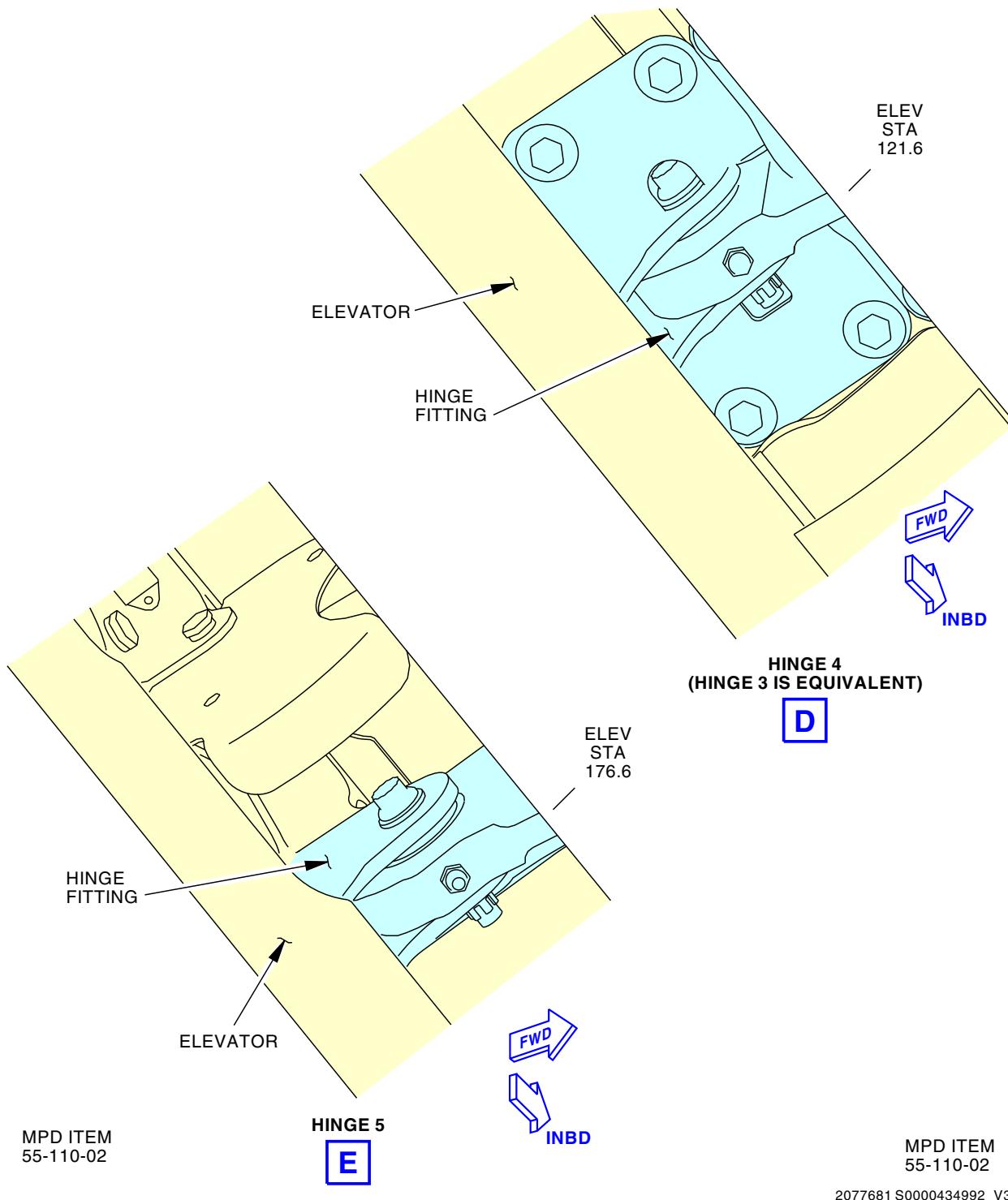
**55-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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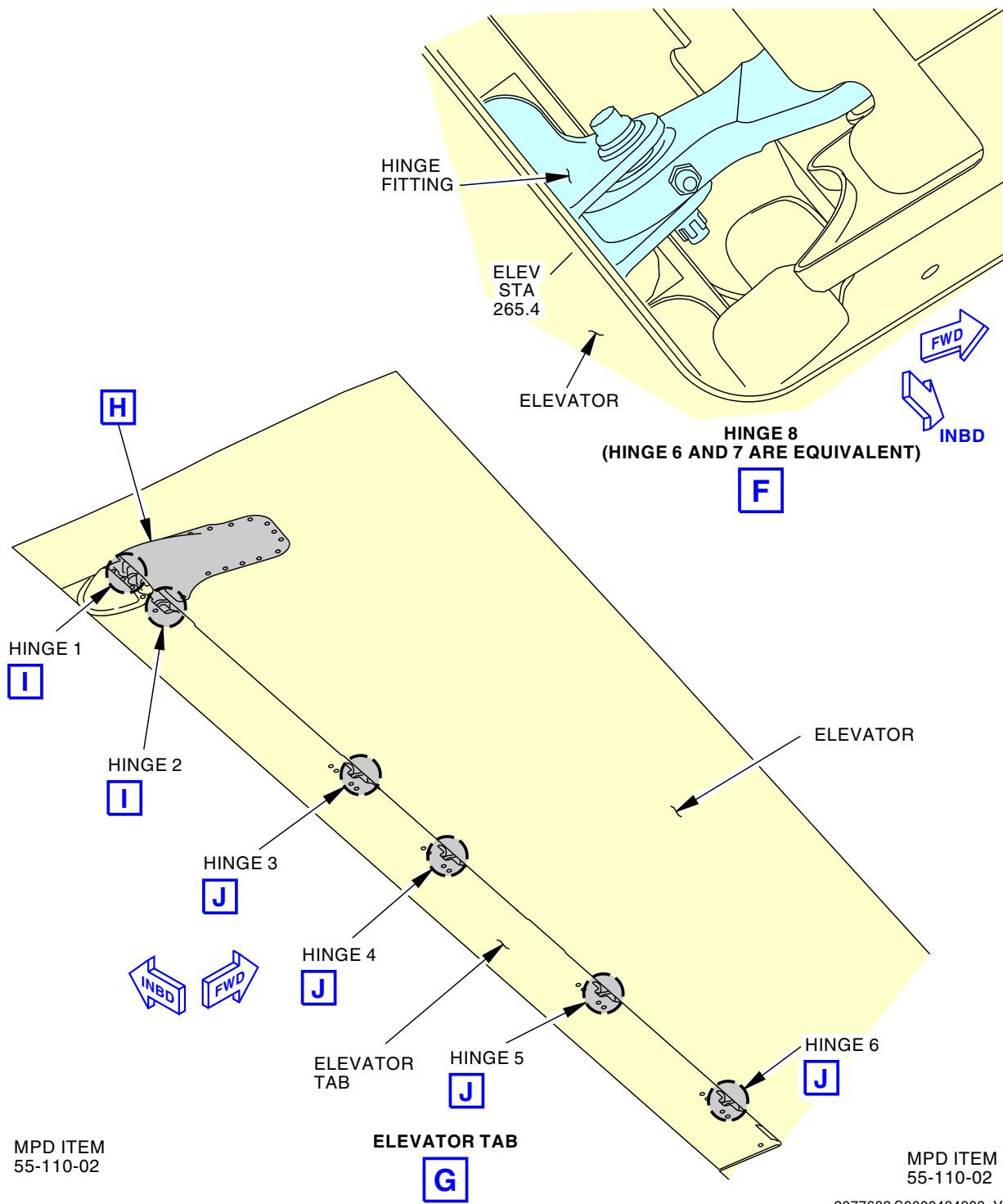
**Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)**  
Figure 213/55-05-03-990-819 (Sheet 3 of 10)

EFFECTIVITY  
LOM ALL

**55-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

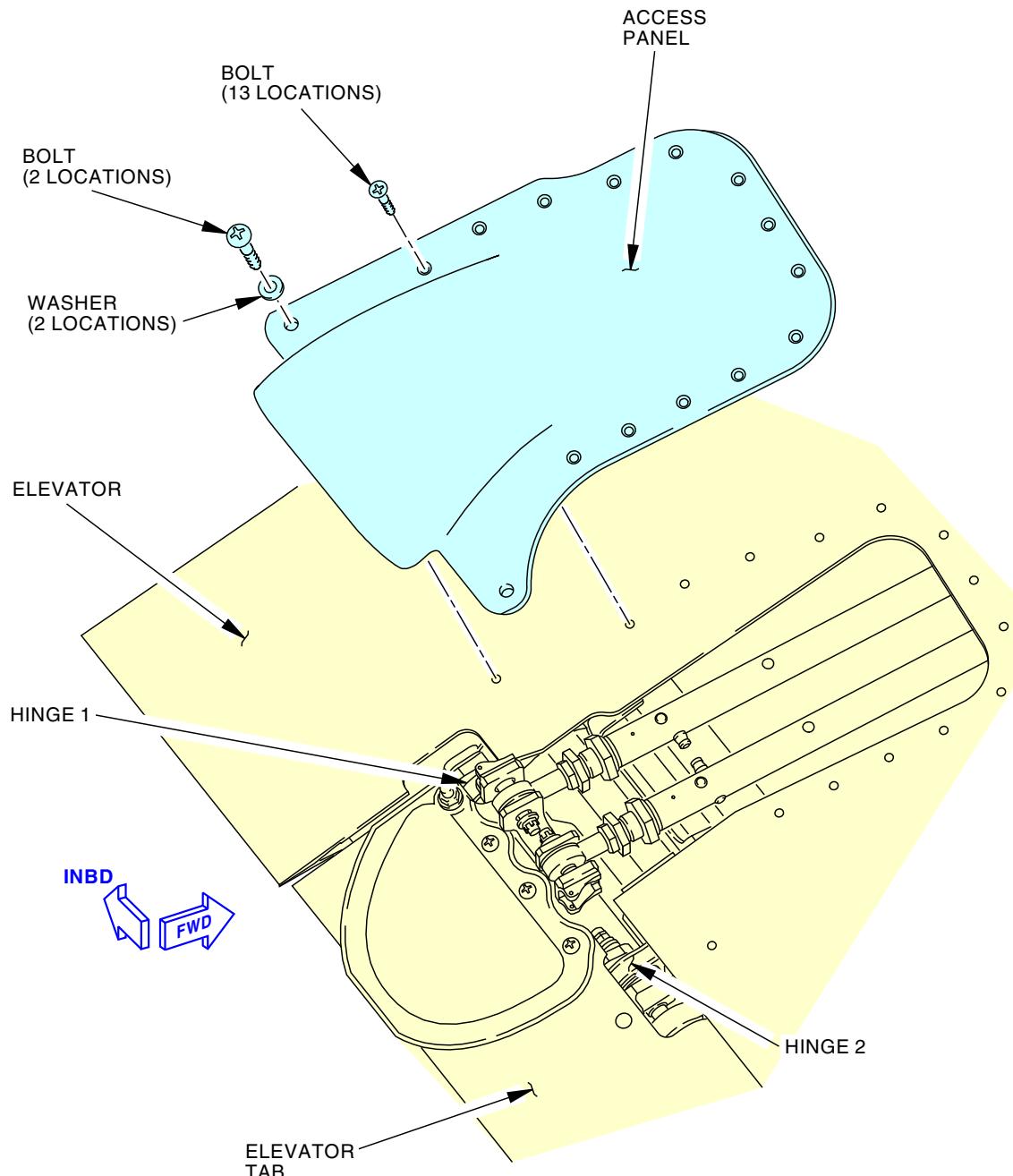


**Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)**  
**Figure 213/55-05-03-990-819 (Sheet 4 of 10)**

EFFECTIVITY  
LOM ALL

**55-05-03**

D633A101-LOM

MPD ITEM  
55-110-02**H**MPD ITEM  
55-110-02

2077684 S0000434994\_V3

**Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)**  
**Figure 213/55-05-03-990-819 (Sheet 5 of 10)**

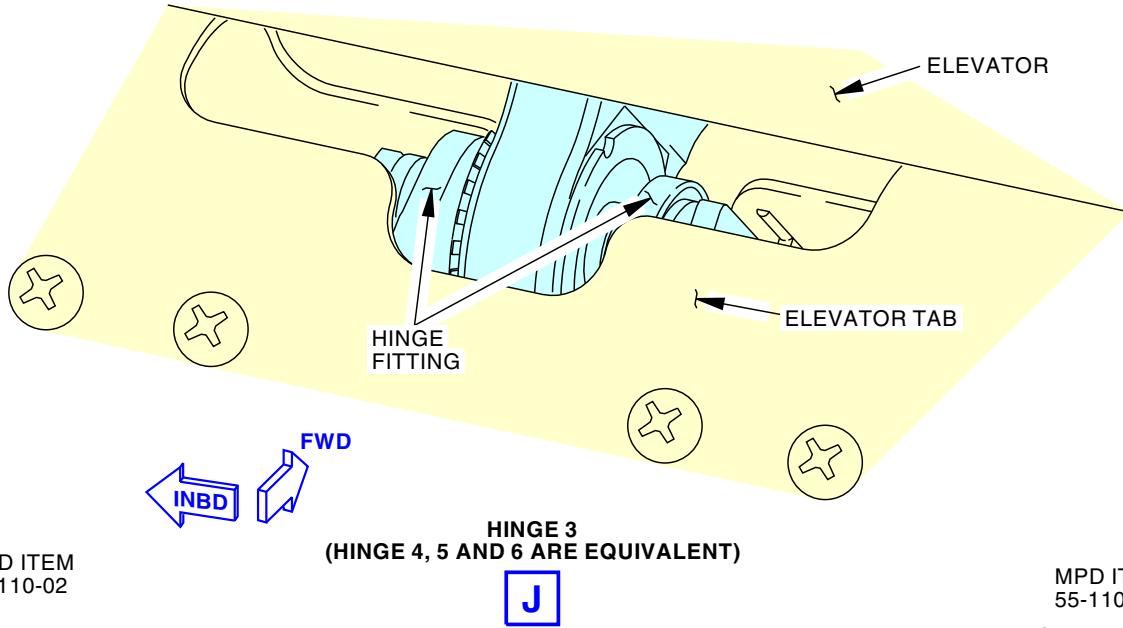
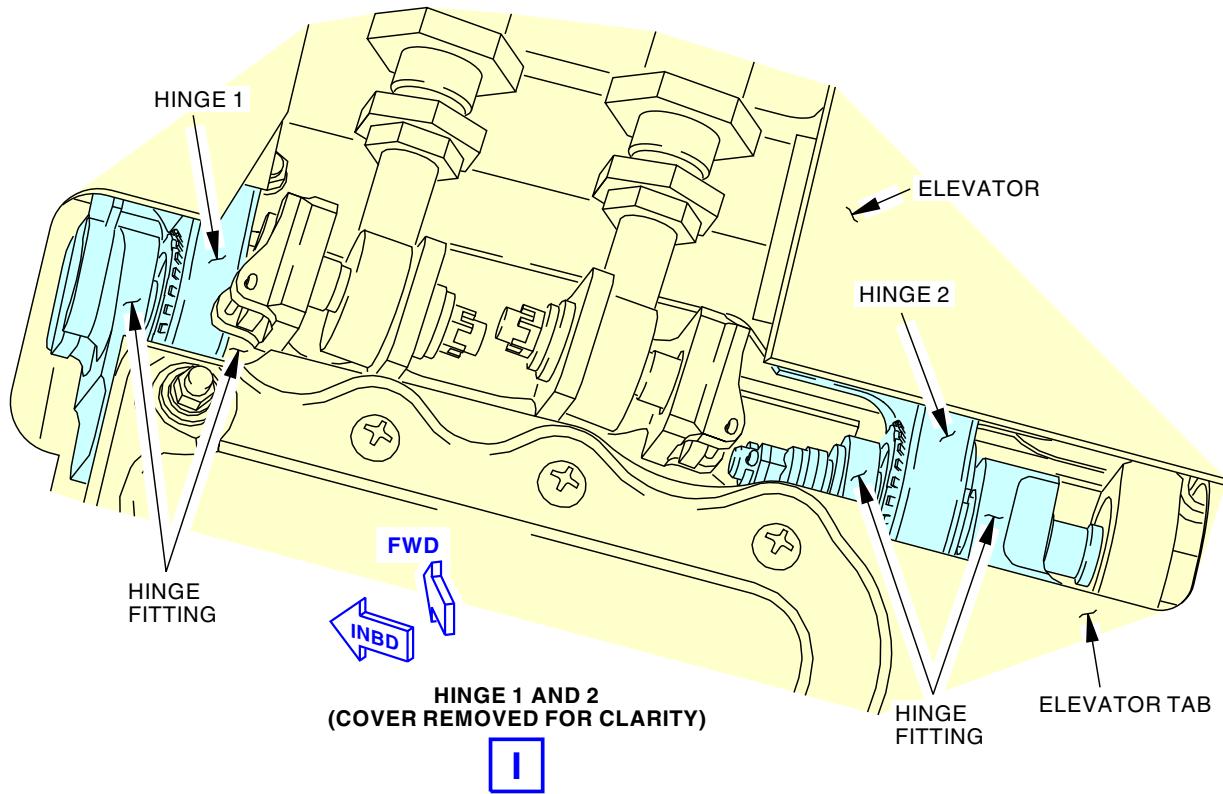
EFFECTIVITY
LOM ALL

D633A101-LOM

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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
55-110-02

MPD ITEM  
55-110-02

2077688 S0000434995\_V3

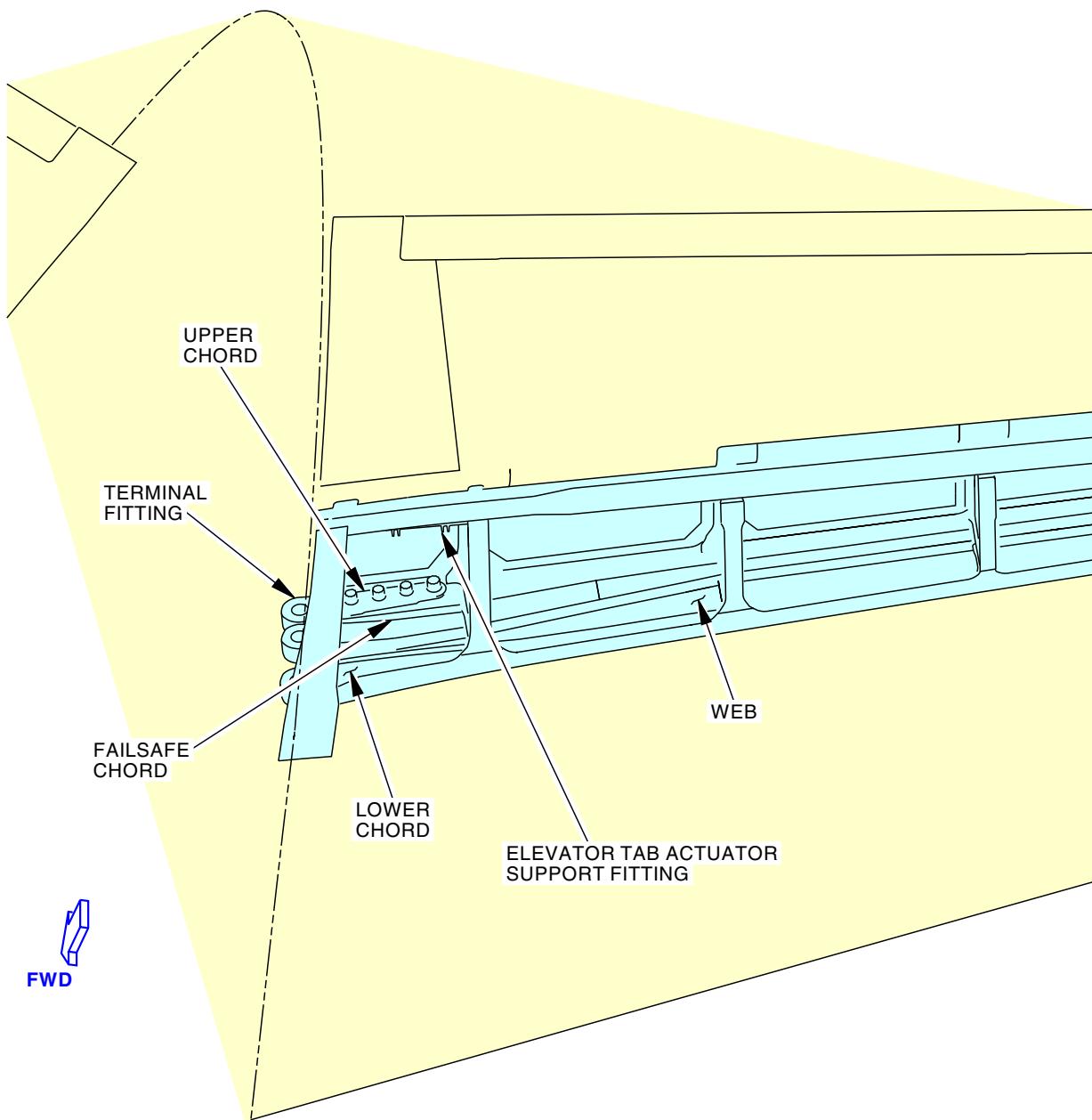
**Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)**  
**Figure 213/55-05-03-990-819 (Sheet 6 of 10)**



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MPD ITEM  
55-110-02**K**MPD ITEM  
55-110-02

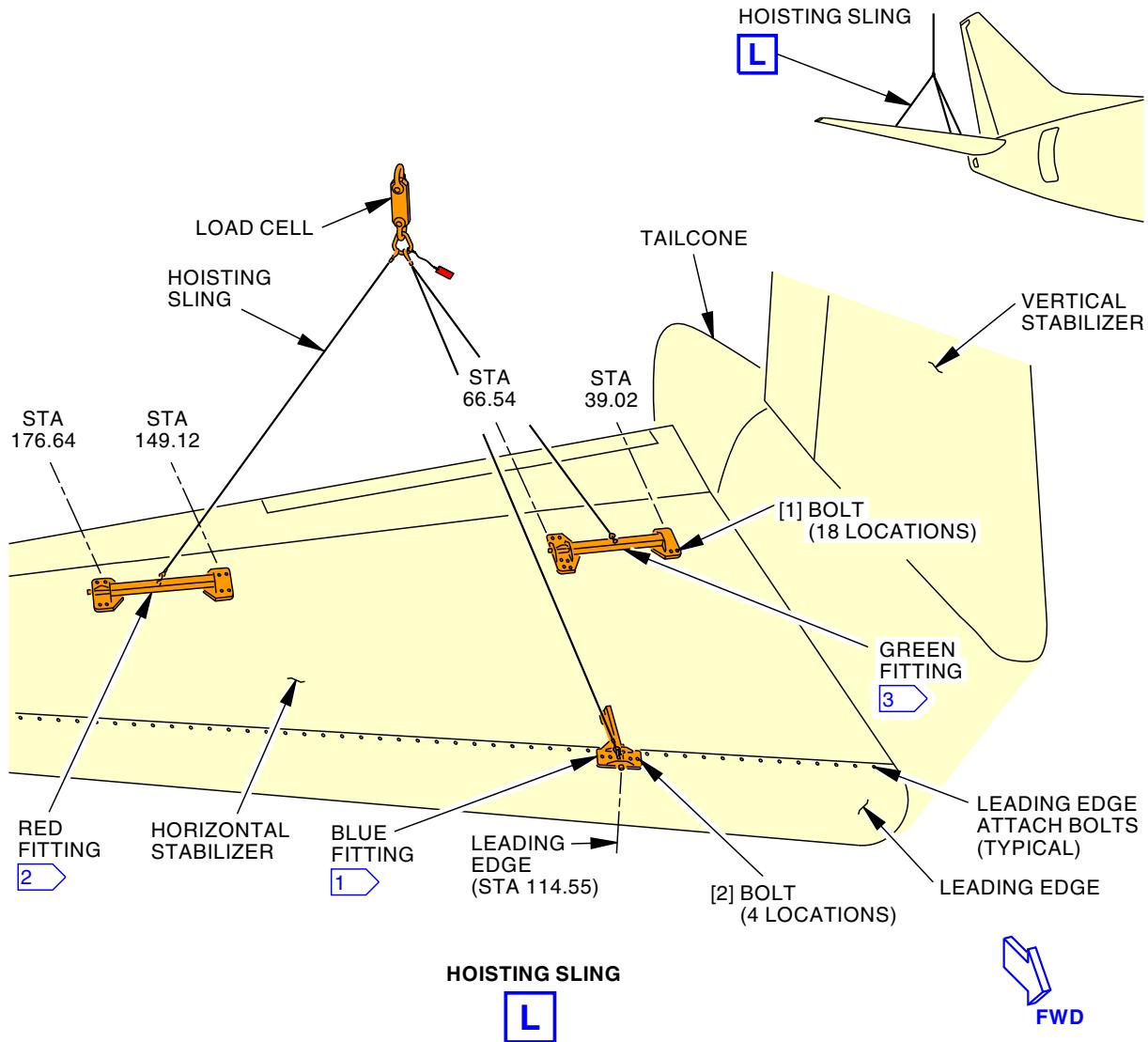
2077690 S0000434996\_V4

**Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General  
Visual (Internal)**  
**Figure 213/55-05-03-990-819 (Sheet 7 of 10)**

EFFECTIVITY  
LOM ALL

D633A101-LOM

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- 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.

2438883 S0000565930\_V2

**Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)**  
**Figure 213/55-05-03-990-819 (Sheet 8 of 10)**

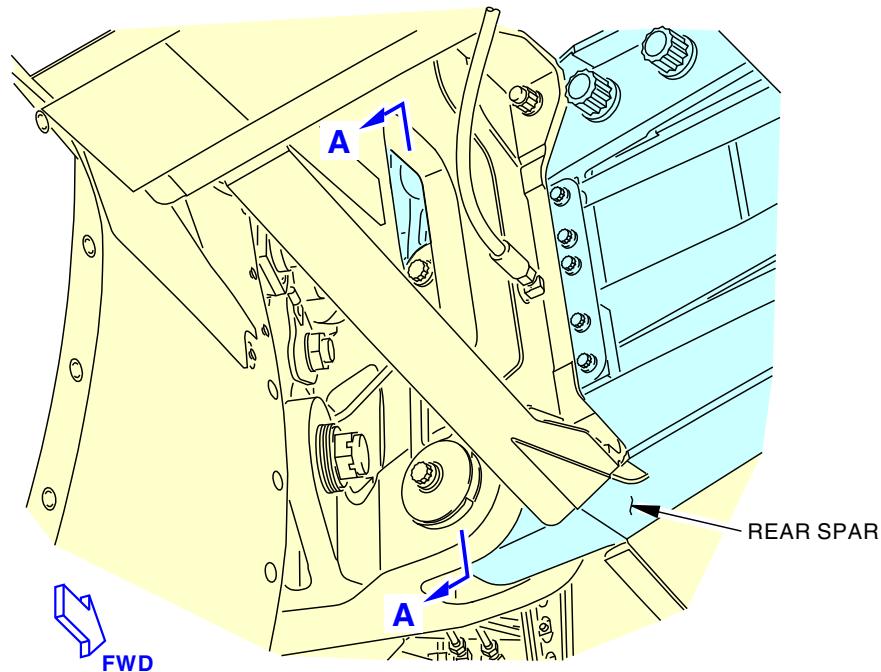
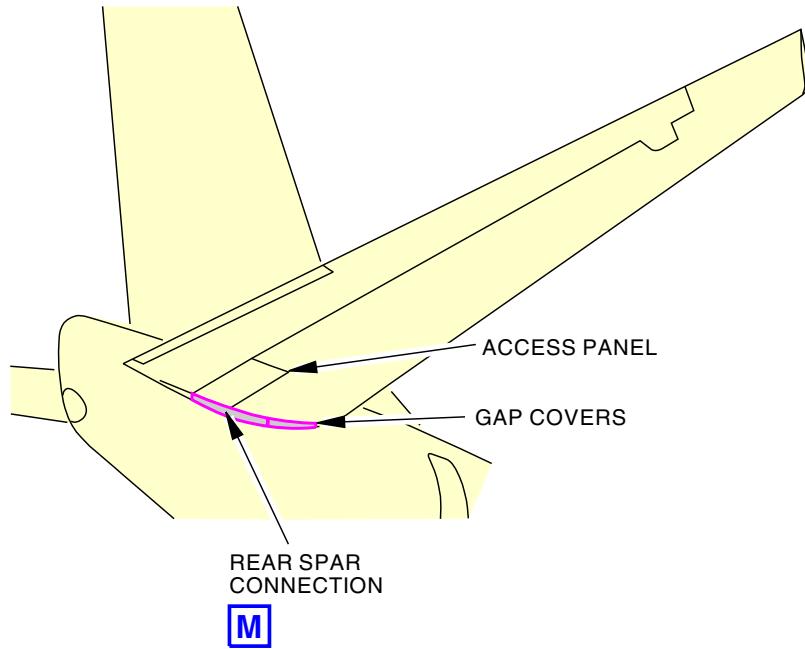
EFFECTIVITY
LOM ALL

D633A101-LOM

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REAR SPAR CONNECTION  
(ACCESS PANELS AND GAP COVERS REMOVED)



2438884 S0000565931\_V1

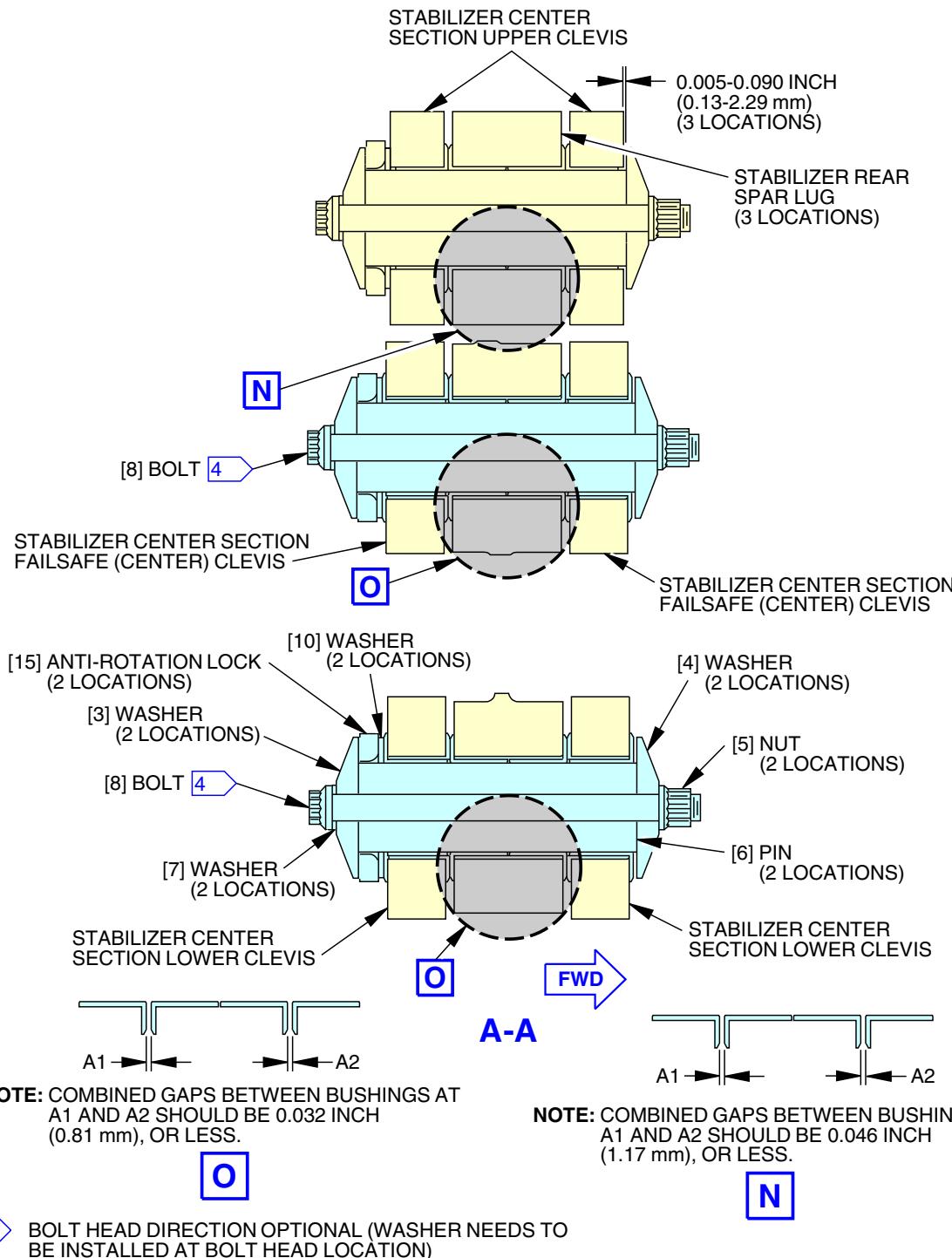
Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General  
Visual (Internal)  
Figure 213/55-05-03-990-819 (Sheet 9 of 10)

EFFECTIVITY  
LOM ALL

**55-05-03**

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2439034 S0000565932\_V6

**Right Elevator Hinge, Actuator, and Tab Mast Arm Fittings and Weight Support Structure - General Visual (Internal)**  
**Figure 213/55-05-03-990-819 (Sheet 10 of 10)**

EFFECTIVITY
LOM ALL

**55-05-03**



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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. Location Zones**

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

334	Left Horizontal Stabilizer - Elevator
-----	---------------------------------------

**B. Inspection**

**NOTE:** Remove upper or lower horizontal stabilizer trailing edge seal and elevator inboard hinge cover panel to inspect support fittings. If installed, 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.

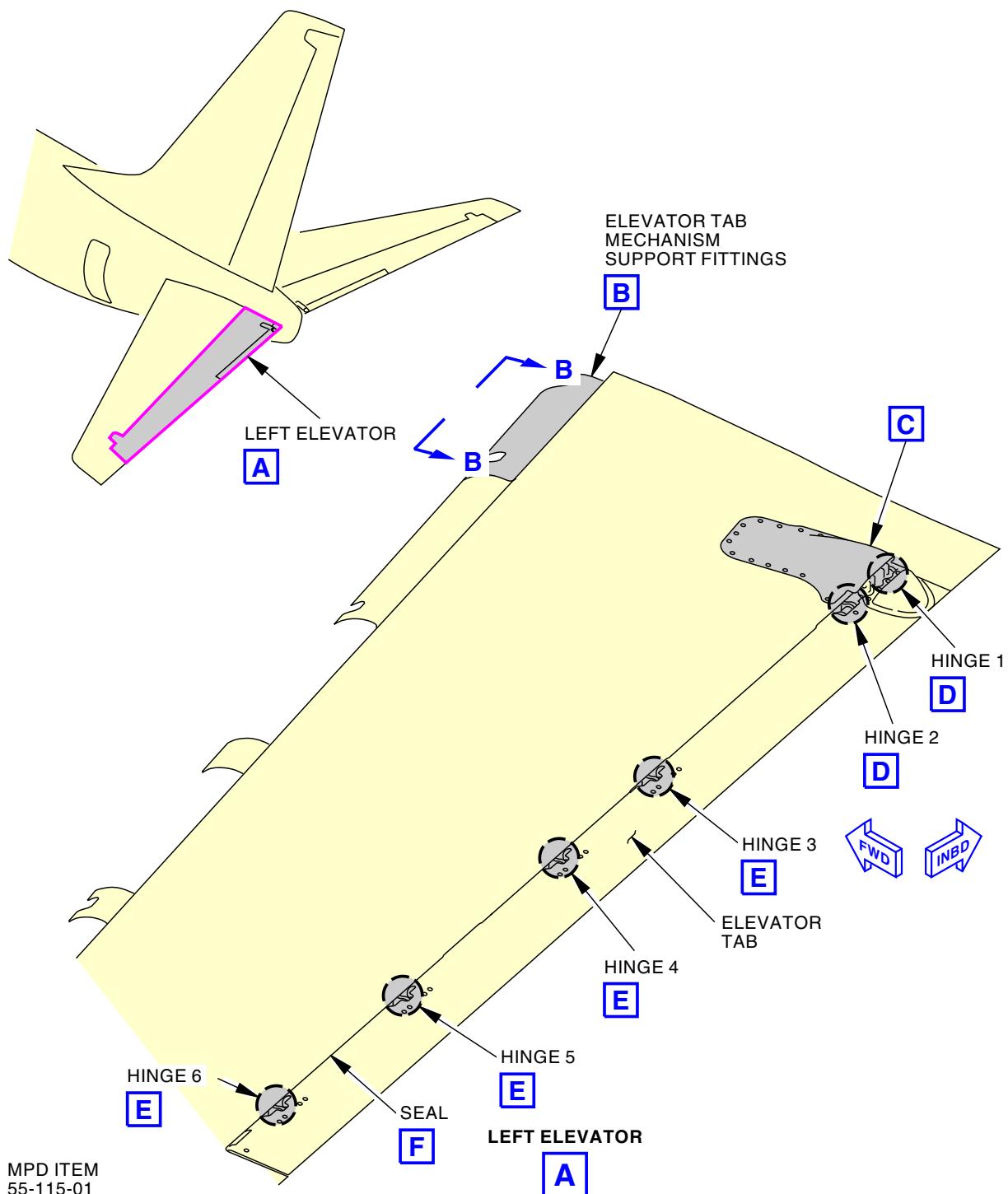
SUBTASK 55-05-03-910-014

- (2) 737-6789 Basic Task Description, AMM Task 51-05-01-210-804.

— END OF TASK —

EFFECTIVITY  
LOM ALL

**55-05-03**



2087570 S0000439782\_V3

**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 5)

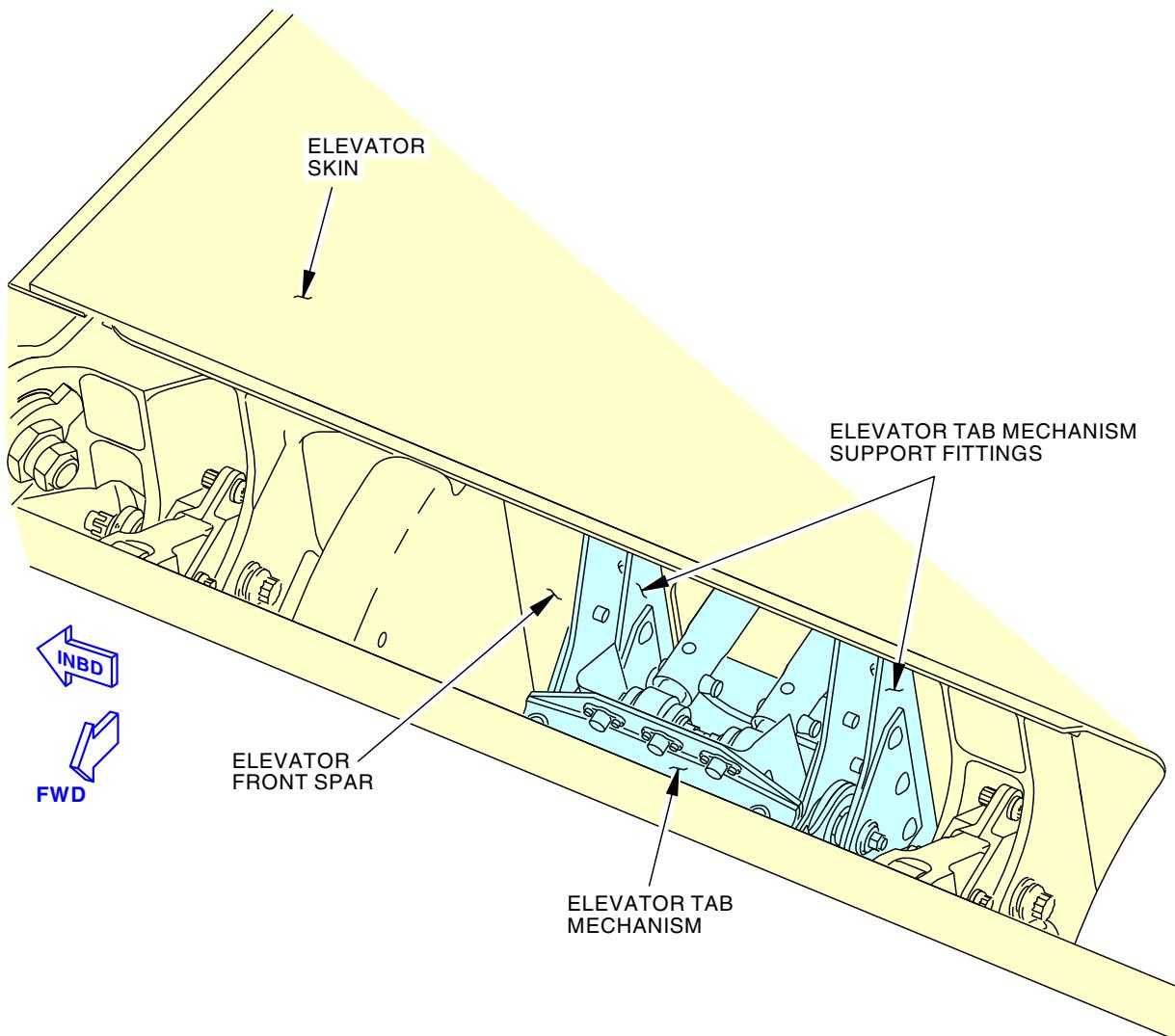
 EFFECTIVITY  
 LOM ALL

**55-05-03**

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ELEVATOR TAB MECHANISM SUPPORT FITTINGS

B

MPD ITEM  
55-115-01

2087556 S0000439787\_V2

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 5)

EFFECTIVITY  
LOM ALL

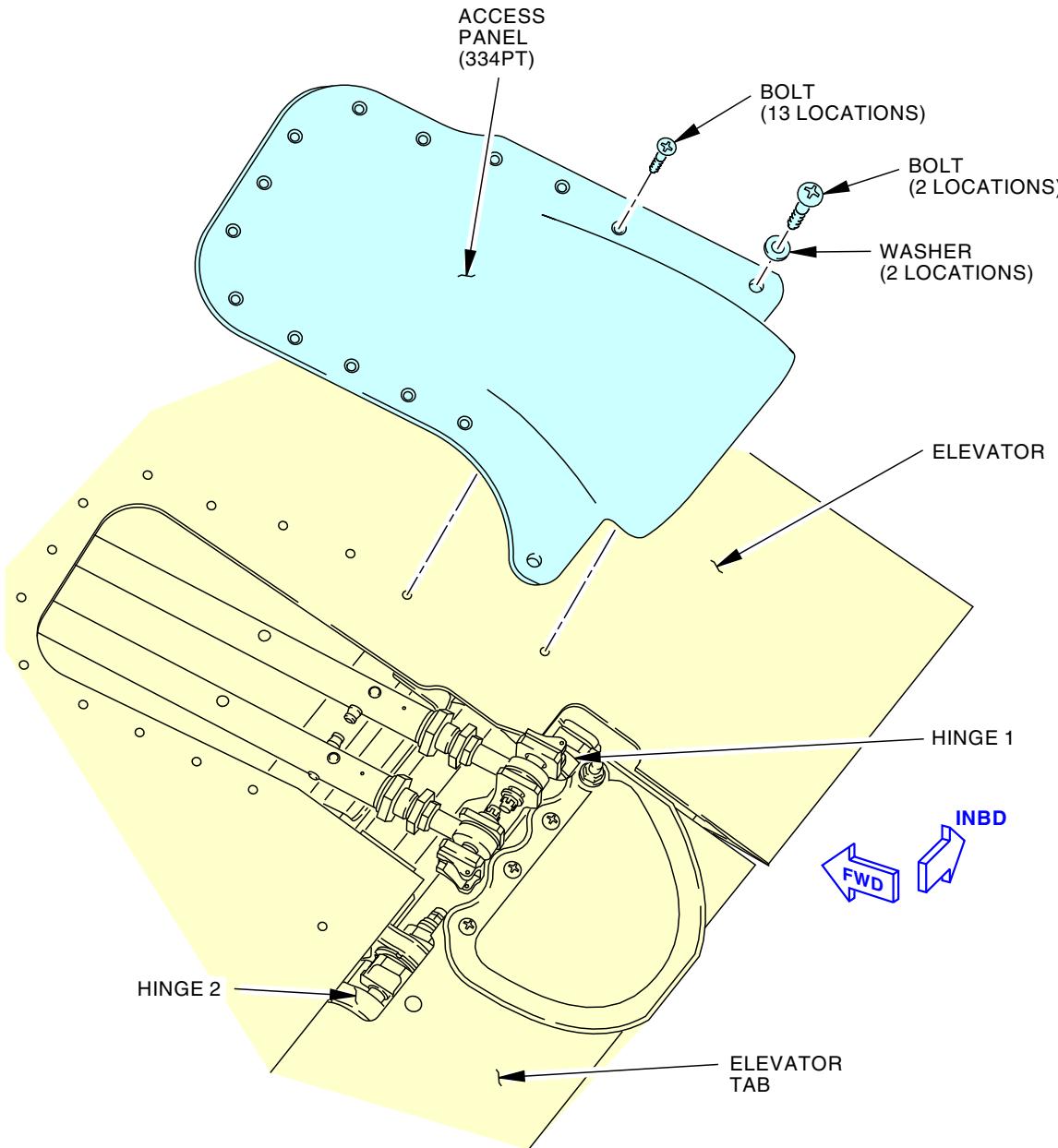
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**55-05-03**

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MPD ITEM  
55-115-01

C

2087561 S0000439789\_V2

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 5)

EFFECTIVITY  
LOM ALL

D633A101-LOM

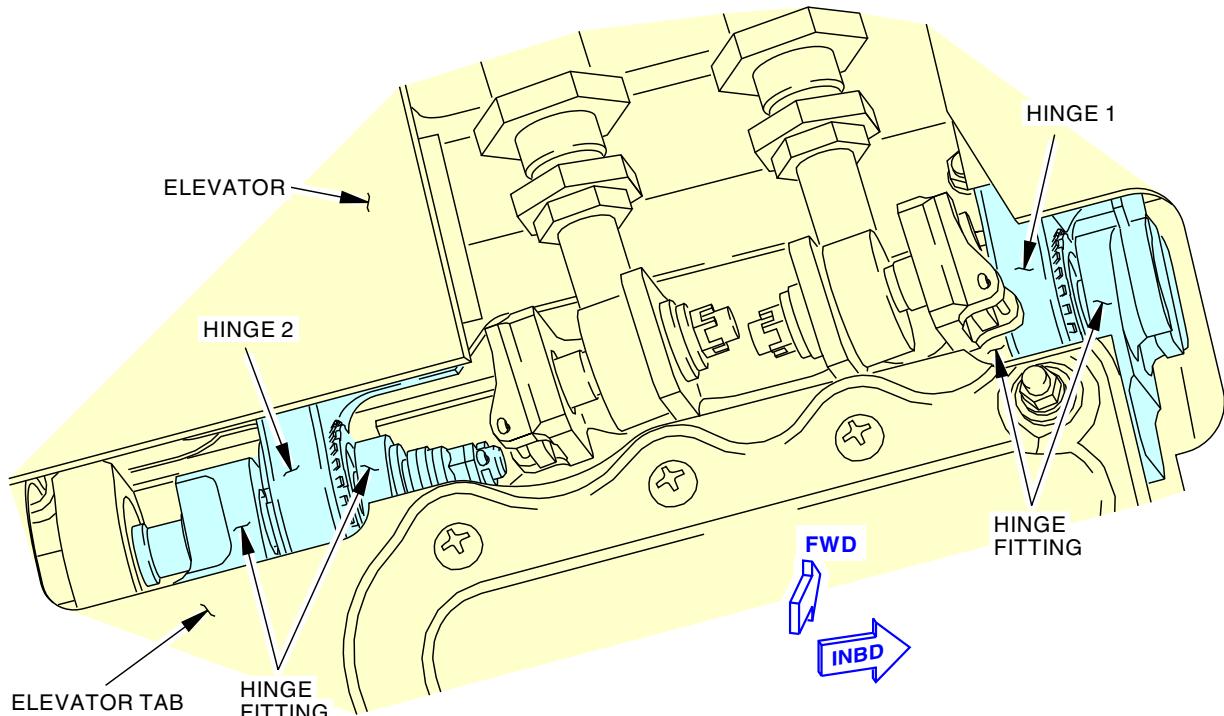
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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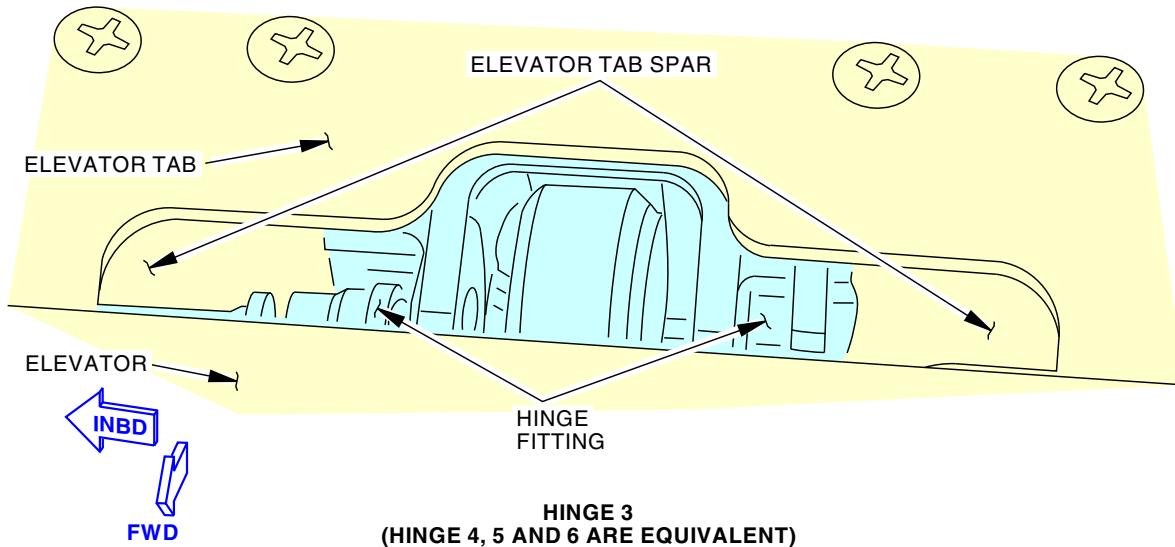


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HINGE 1 AND 2  
(COVER REMOVED FOR CLARITY)

D



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

E

MPD ITEM  
55-115-01

2087545 S0000439790\_V2

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 5)

EFFECTIVITY
LOM ALL

D633A101-LOM

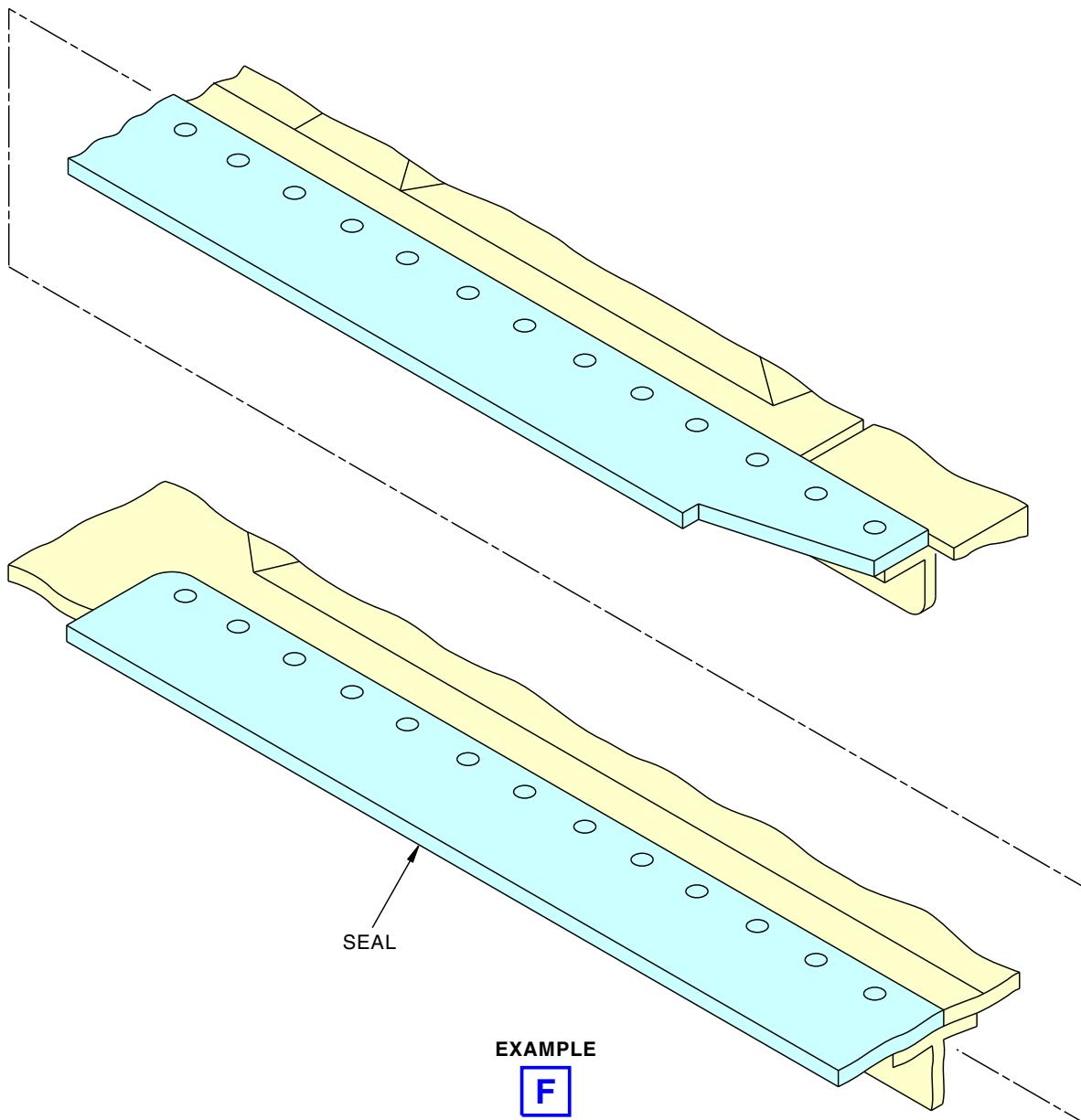
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2795525 S0000637116\_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 5 of 5)

EFFECTIVITY  
LOM ALL

**55-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**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. Location Zones**

Zone	Area
344	Right Horizontal Stabilizer - Elevator

**B. Inspection**

**NOTE:** Remove upper or lower horizontal stabilizer trailing edge seal and elevator inboard hinge cover panel to inspect support fittings. If installed, 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.

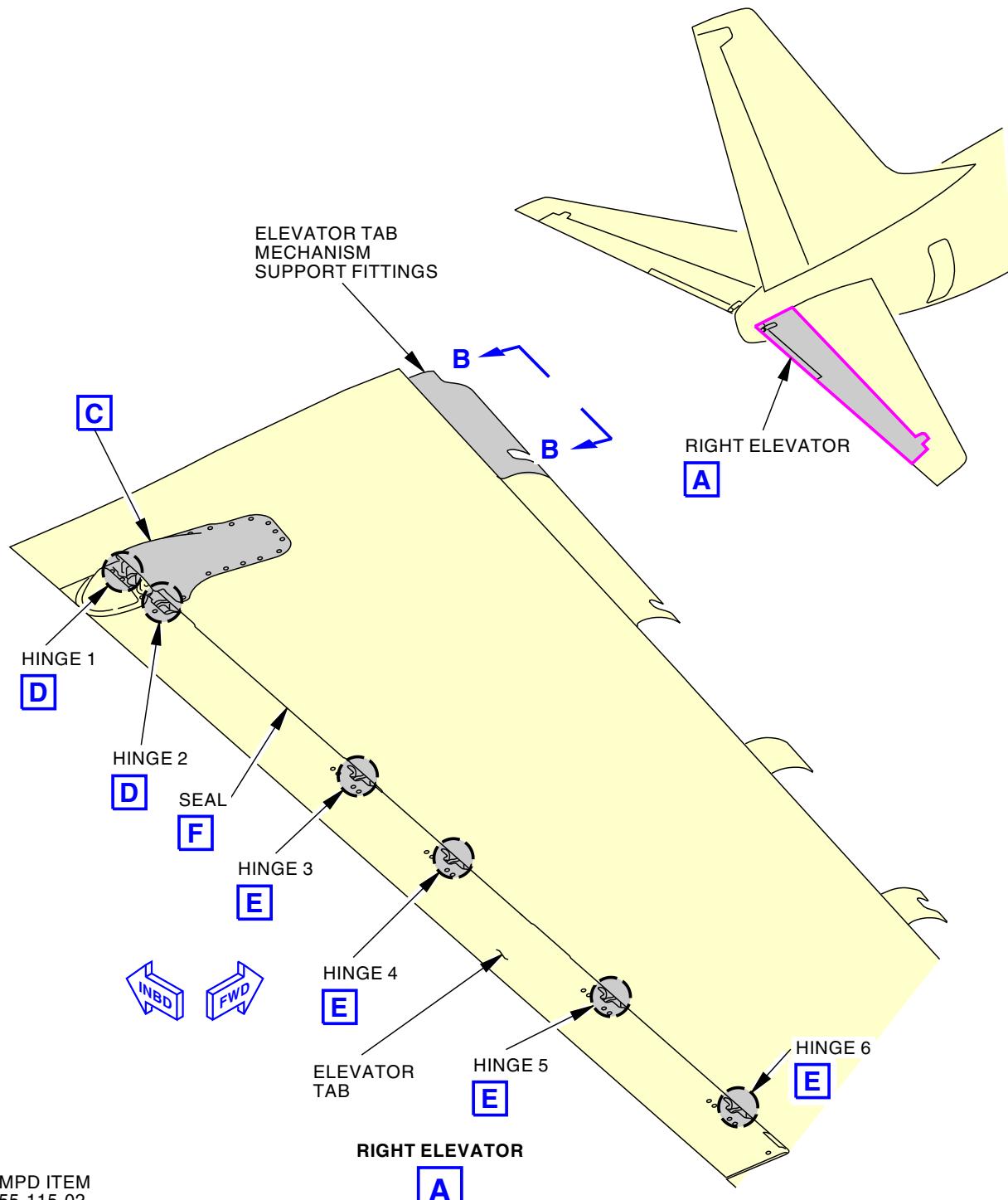
SUBTASK 55-05-03-910-015

- (2) 737-6789 Basic Task Description, AMM Task 51-05-01-210-804.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**55-05-03**

MPD ITEM  
55-115-02

2087928 S0000439792\_V3

**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 5)

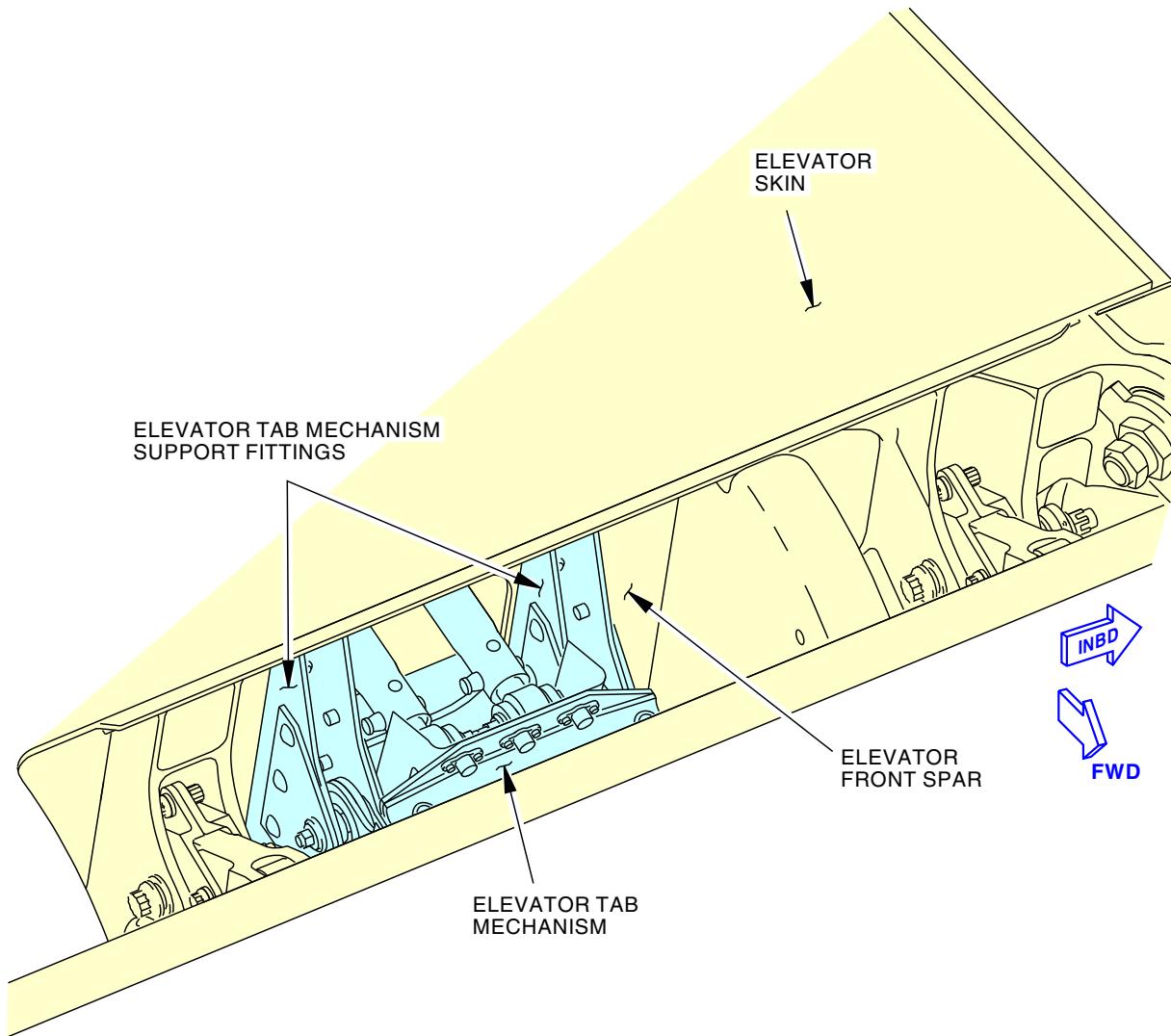
EFFECTIVITY	
LOM ALL	

**55-05-03**

D633A101-LOM



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AIRCRAFT MAINTENANCE MANUAL



ELEVATOR TAB MECHANISM SUPPORT FITTINGS

B

MPD ITEM  
55-115-02

2087903 S0000439793\_V2

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 5)

EFFECTIVITY  
LOM ALL

**55-05-03**

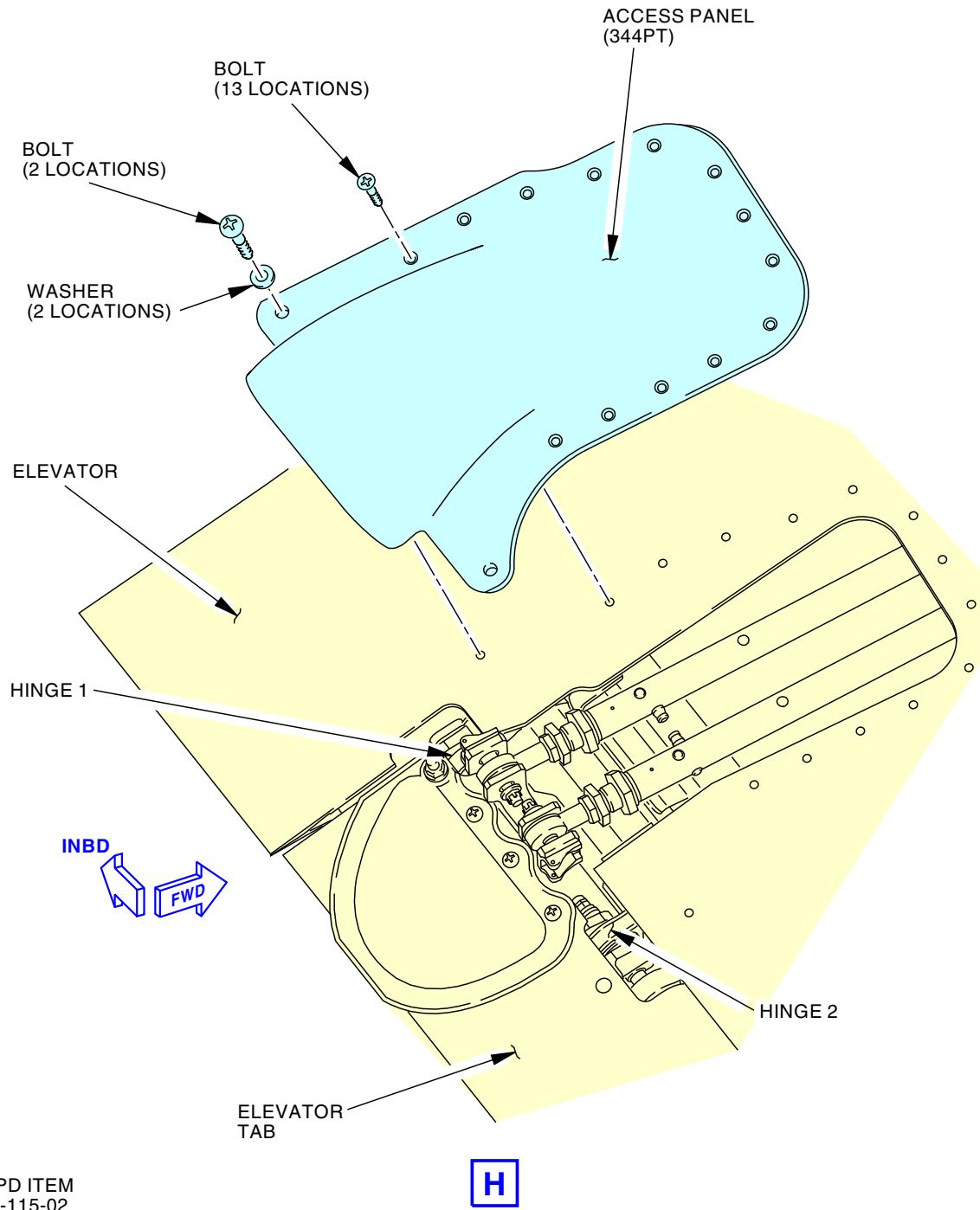
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2087944 S0000439794\_V2

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

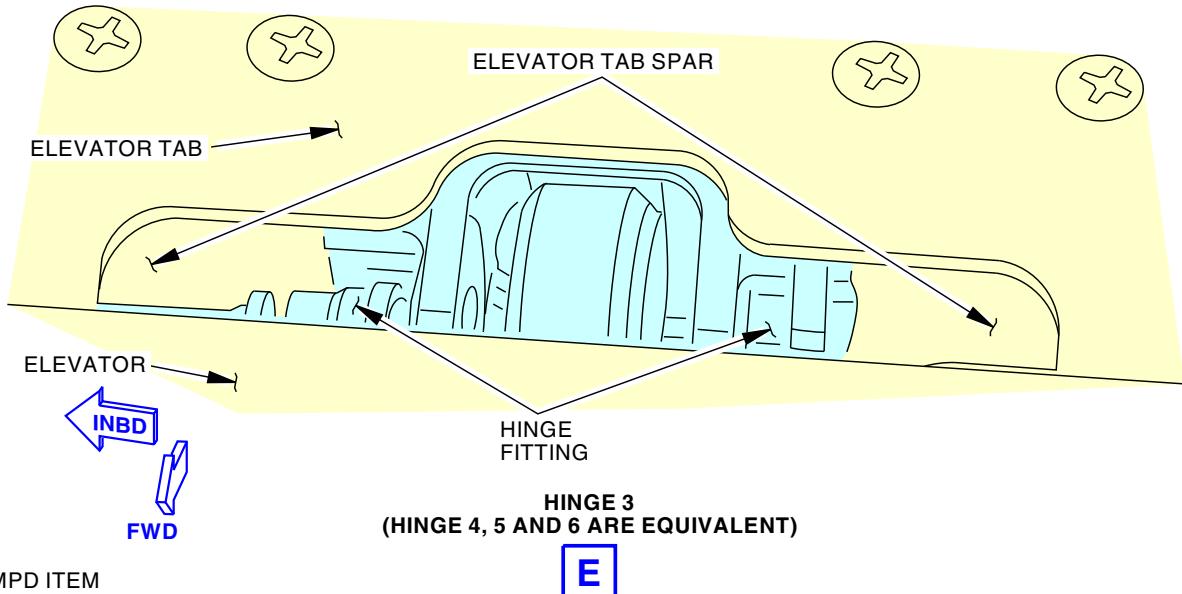
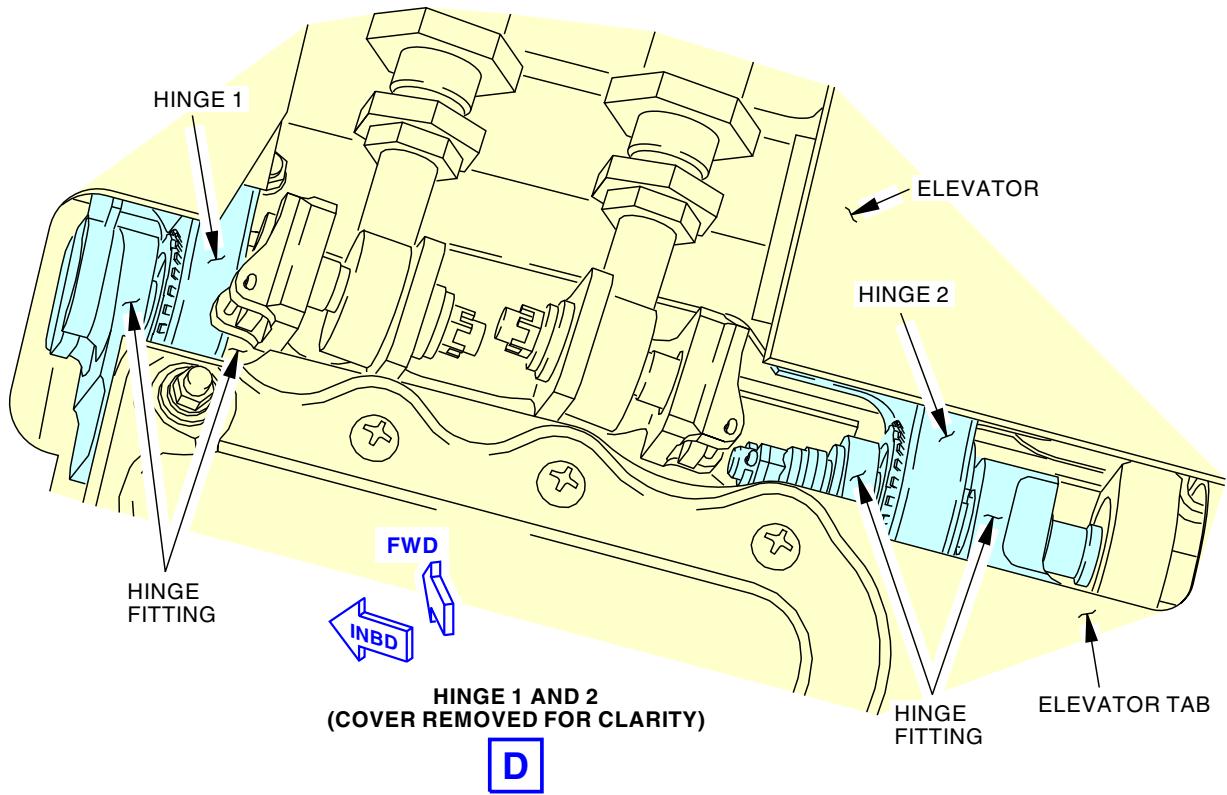
Figure 215/55-05-03-990-815 (Sheet 3 of 5)

EFFECTIVITY  
LOM ALL

D633A101-LOM

**55-05-03**

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MPD ITEM  
55-115-02

2087984 S0000439795\_V2

#### 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 5)

EFFECTIVITY
LOM ALL

D633A101-LOM

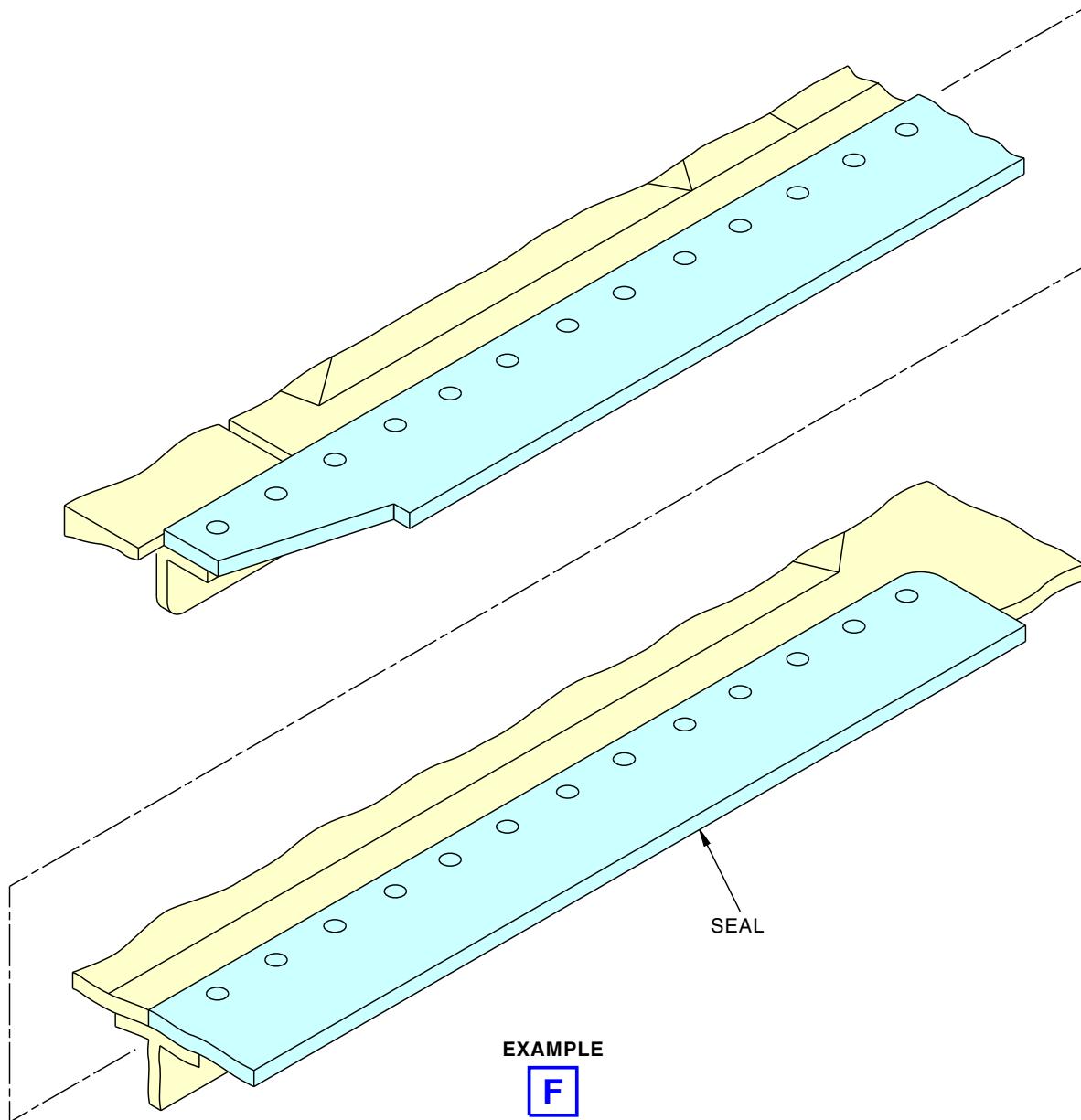
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2795771 S0000637117\_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 5 of 5)

EFFECTIVITY  
LOM ALL

**55-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**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**

<b>Reference</b>	<b>Title</b>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge

**D. Access Panels**

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

**E. Inspection**

SUBTASK 55-05-03-010-013

- (1) Open these access panels:

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

NOTE: Bolt removal is not required.

SUBTASK 55-05-03-210-014

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

SUBTASK 55-05-03-910-013

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-801.

SUBTASK 55-05-03-410-013

- (4) Close this access panel:

<b>Number</b>	<b>Name/Location</b>
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
(a)	Make sure that the blade seal is installed correctly into the forward track channel.

- (5) Close this access panel:

<b>Number</b>	<b>Name/Location</b>
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

SUBTASK 55-05-03-390-005

- (6) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

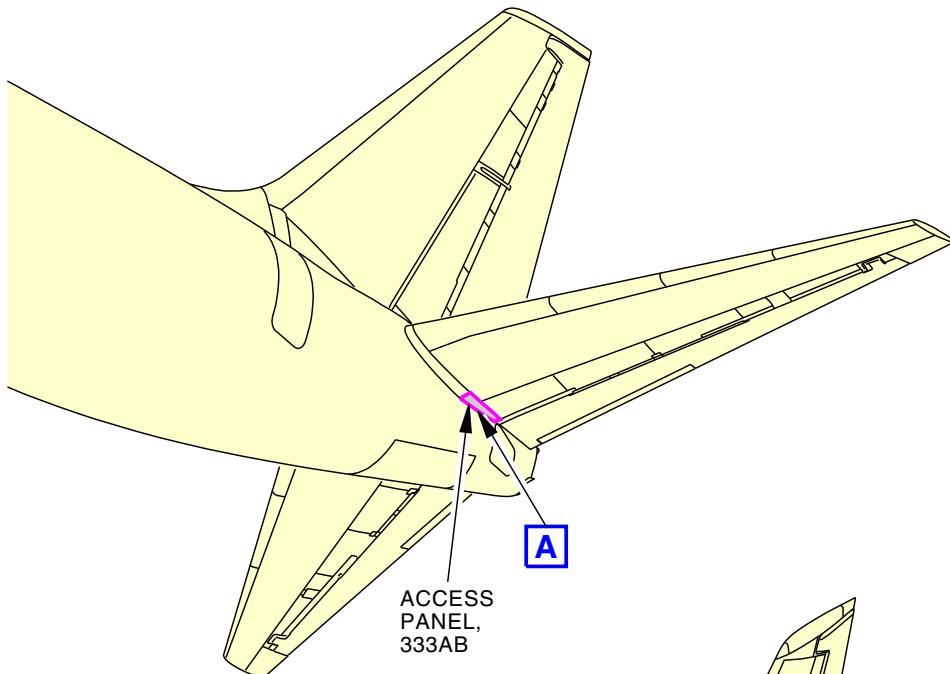
———— END OF TASK ————

— EFFECTIVITY —  
**LOM ALL**

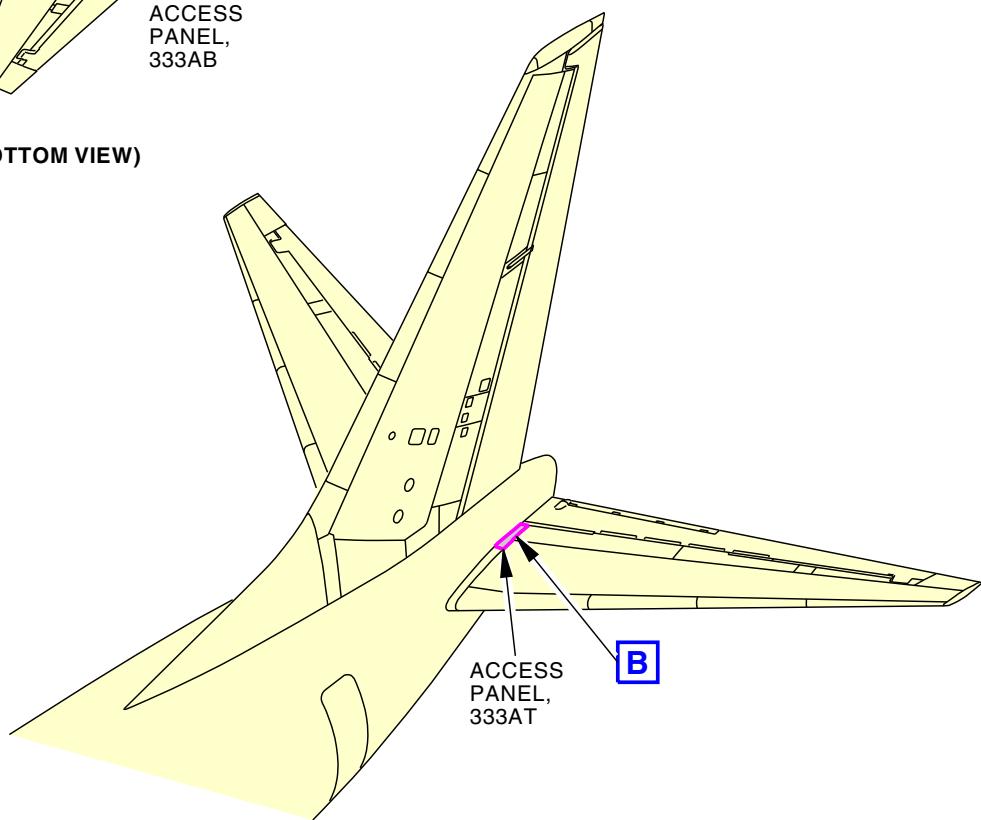
**55-05-03**



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AIRCRAFT MAINTENANCE MANUAL



(BOTTOM VIEW)



(TOP VIEW)

MPD ITEM  
55-120-01

487444 S0000146446\_V2

Left Horizontal Stabilizer Trailing Edge General Visual (Internal)  
Figure 216/55-05-03-990-805 (Sheet 1 of 2)

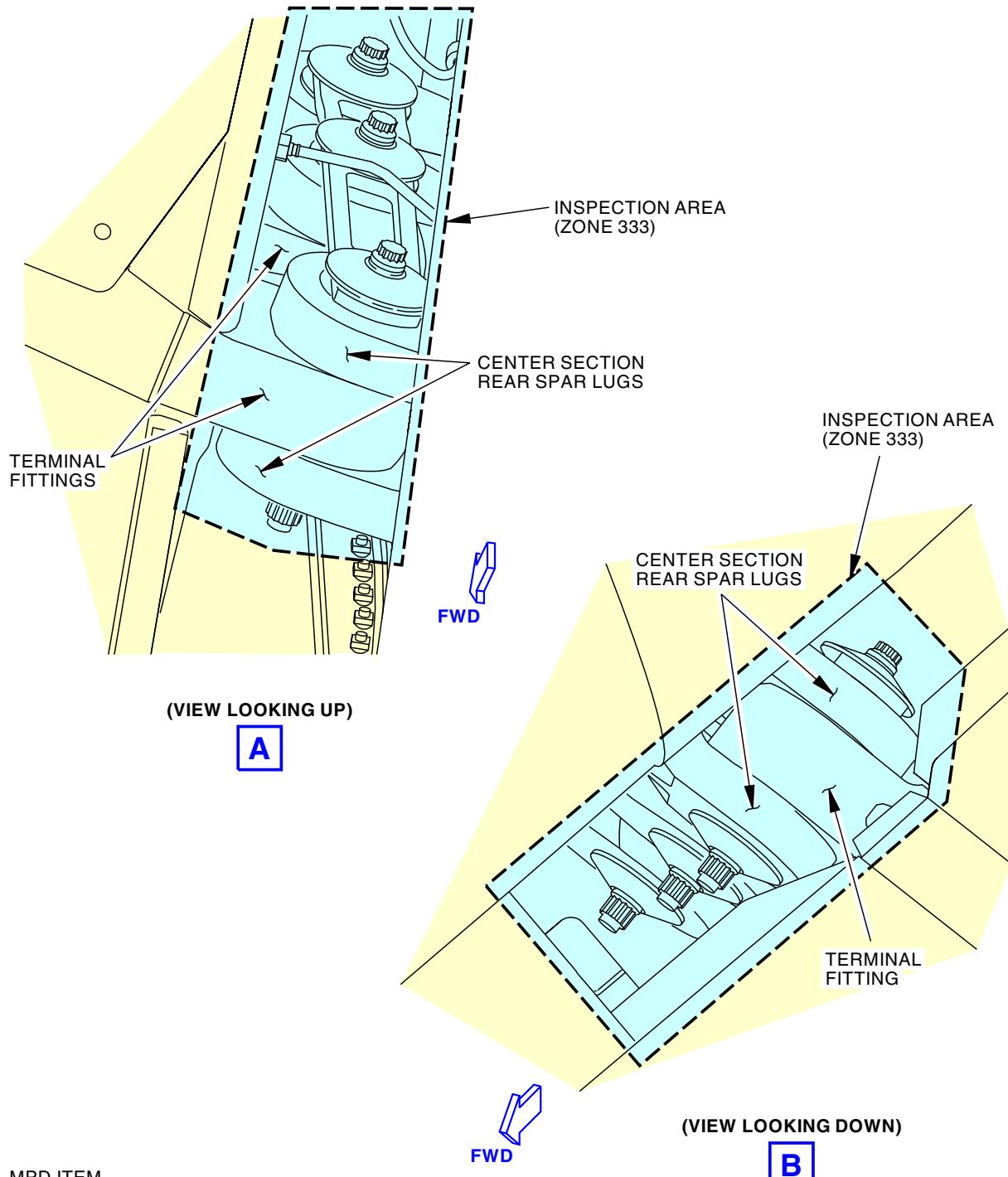
EFFECTIVITY  
LOM ALL

**55-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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MPD ITEM  
55-120-01

487843 S0000146449\_V2

**Left Horizontal Stabilizer Trailing Edge General Visual (Internal)**  
**Figure 216/55-05-03-990-805 (Sheet 2 of 2)**

EFFECTIVITY
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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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**

<b>Reference</b>	<b>Title</b>
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**D. Access Panels**

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

**E. Inspection**

SUBTASK 55-05-03-010-014

- (1) Open these access panels:

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

NOTE: Bolt removal is not required.

SUBTASK 55-05-03-210-015

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

SUBTASK 55-05-03-910-014

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-801.

SUBTASK 55-05-03-410-014

- (4) Close this access panel:

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

(a) Make sure that the blade seal is installed correctly into the forward track channel.

- (5) Close this access panel:

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

SUBTASK 55-05-03-390-006

- (6) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

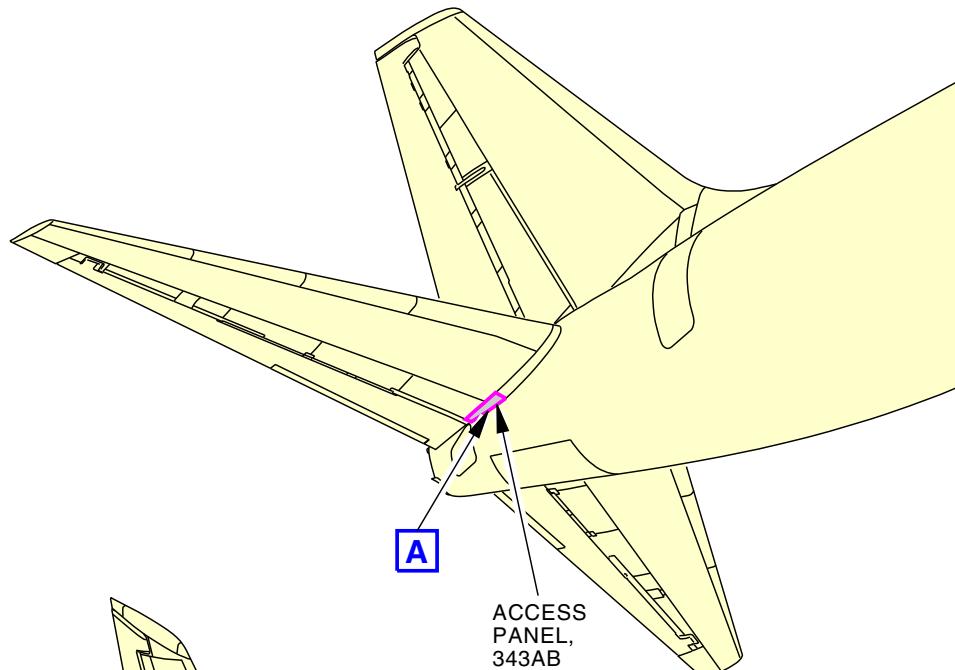
— END OF TASK —

— EFFECTIVITY —  
**LOM ALL**

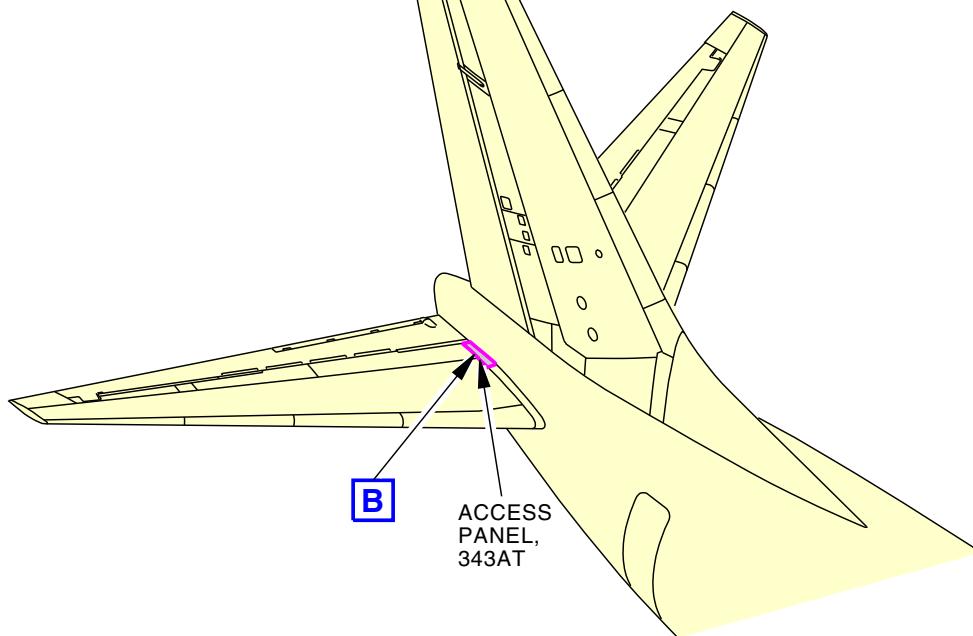
**55-05-03**



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(BOTTOM VIEW)



(TOP VIEW)

487445 S0000146452\_V2

Right Horizontal Stabilizer Trailing Edge General Visual (Internal)  
Figure 217/55-05-03-990-806 (Sheet 1 of 2)

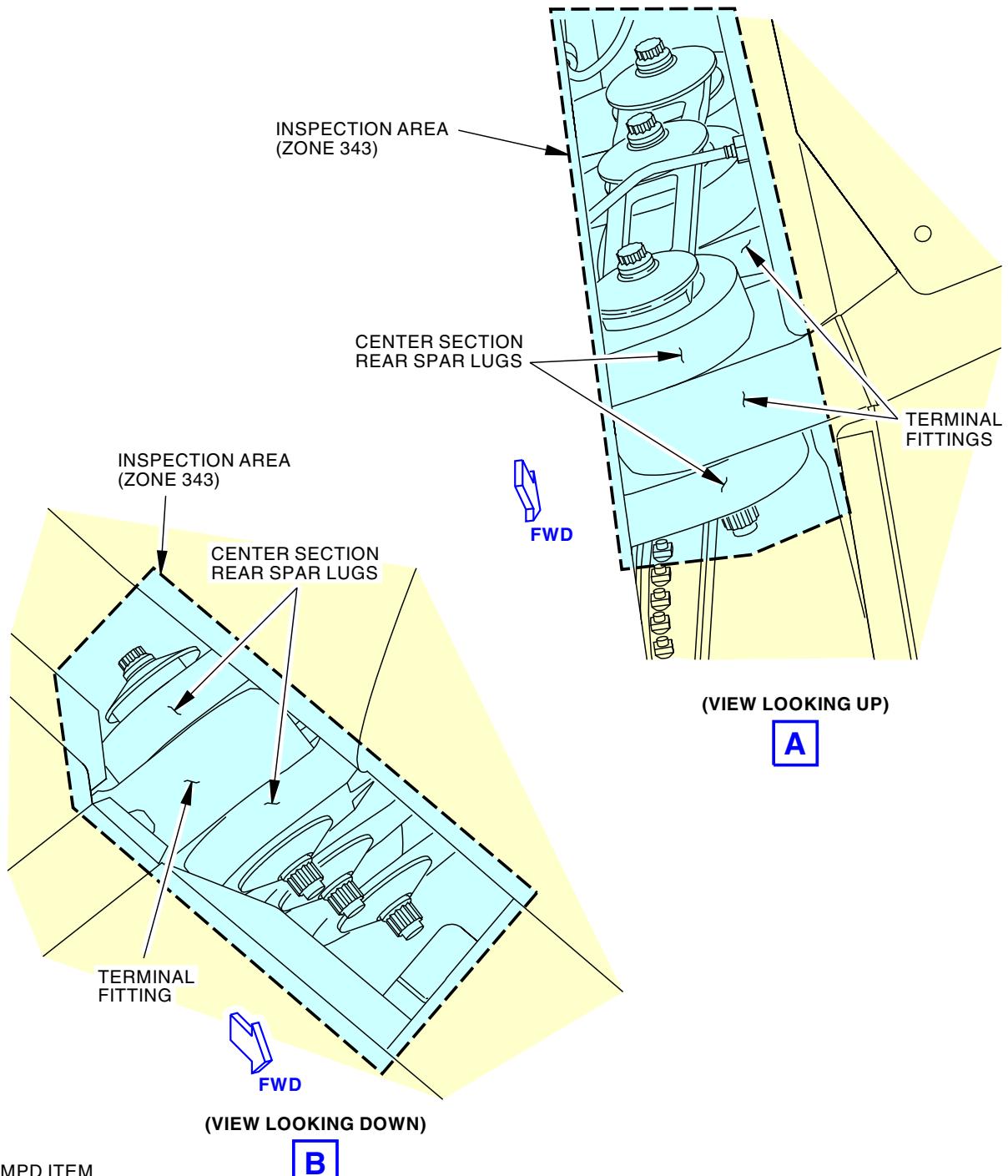
EFFECTIVITY  
LOM ALL

**55-05-03**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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MPD ITEM  
55-120-02

487844 S0000146453\_V3

**Right Horizontal Stabilizer Trailing Edge General Visual (Internal)**  
**Figure 217/55-05-03-990-806 (Sheet 2 of 2)**

EFFECTIVITY
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**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.

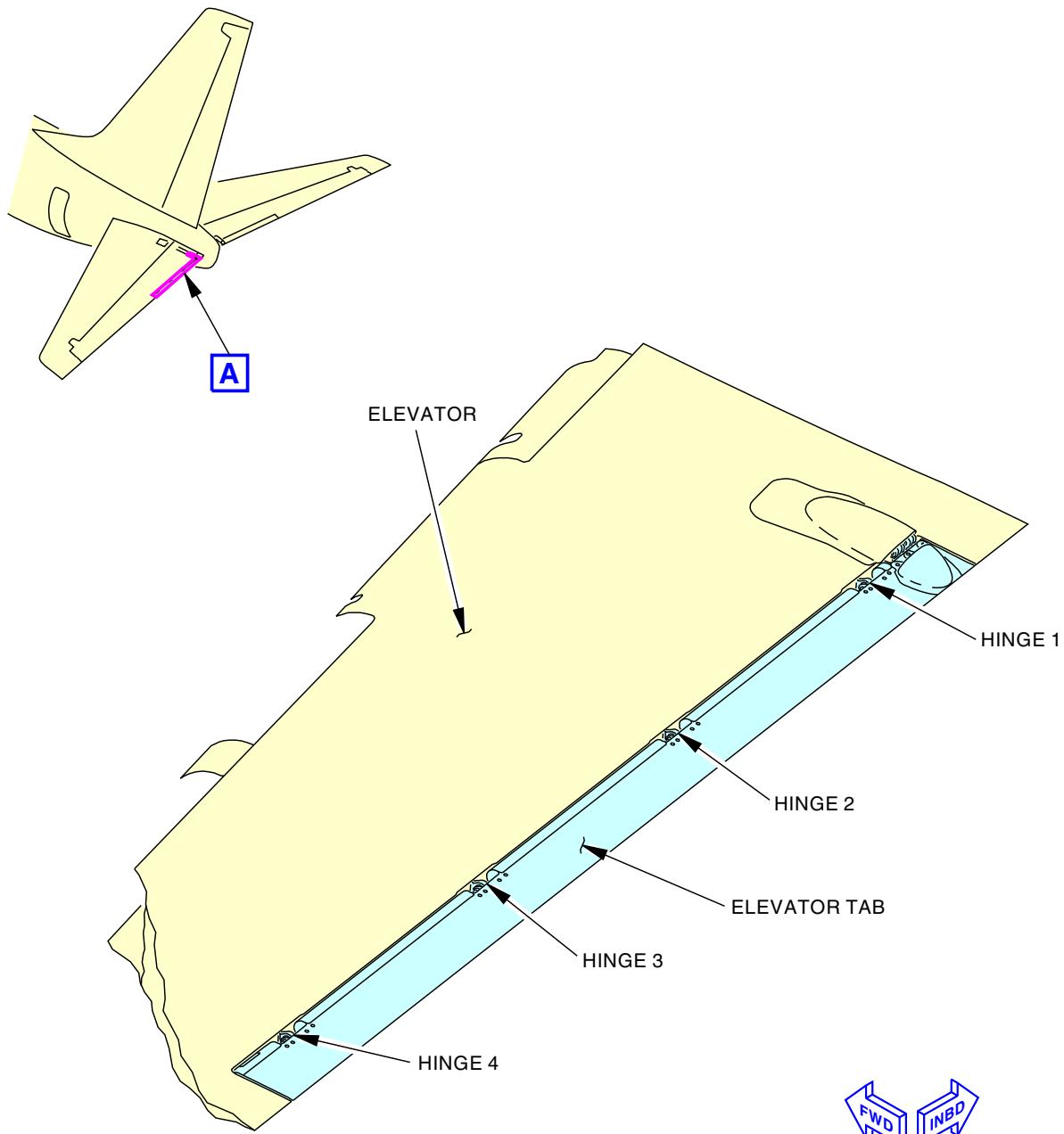
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**55-05-03**



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AIRCRAFT MAINTENANCE MANUAL



LEFT ELEVATOR TAB



M28792 S0006584725\_V2

Left Elevator Tab  
Figure 218/55-05-03-990-801

EFFECTIVITY  
LOM ALL

**55-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**TASK 55-05-03-211-806**

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

**A. Inspection**

SUBTASK 55-05-03-211-006

- (1) Do the inspection.

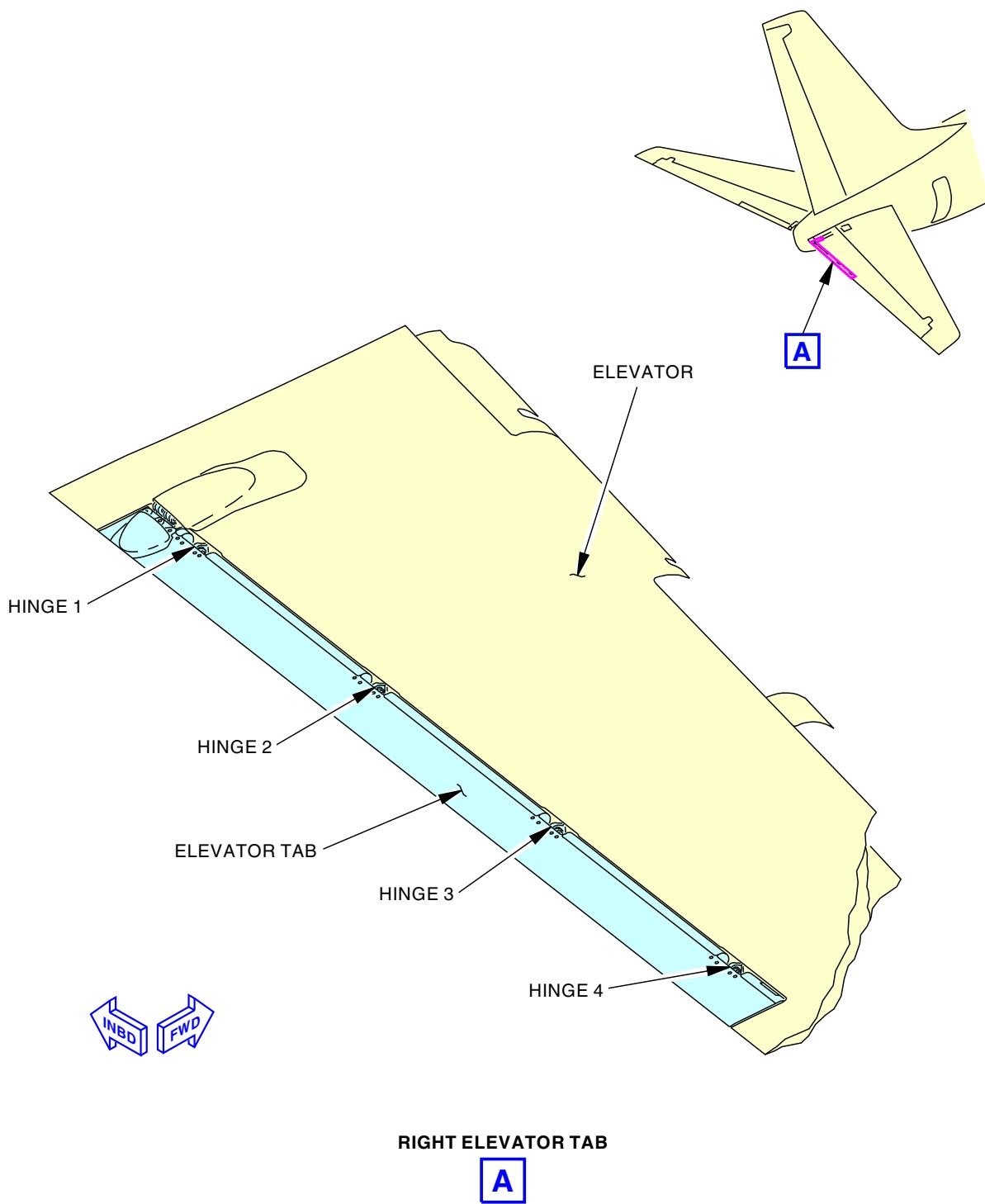
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**55-05-03**



737-600/700/800/900  
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RIGHT ELEVATOR TAB

A

M28795 S0006584729\_V2

Right Elevator Tab  
Figure 219/55-05-03-990-804

EFFECTIVITY  
LOM ALL

D633A101-LOM

**55-05-03**

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**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
SRM 51-10-01	Structural Repair Manual

**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
333CB	Horizontal Stabilizer, Access Panel, Trailing Edge
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge

EFFECTIVITY	LOM ALL
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**55-05-03**



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AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
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 55-05-03-010-015

- (1) Open 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
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
333DB	Horizontal Stabilizer, Access Panel, Trailing Edge
333EB	Horizontal Stabilizer, Access Panel, Trailing Edge

— EFFECTIVITY —  
**LOM ALL**

**55-05-03**



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AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
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) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 55-05-03-410-020

- (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 channel.	

SUBTASK 55-05-03-410-026

- (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 channel.	

SUBTASK 55-05-03-410-015

- (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
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

EFFECTIVITY  
LOM ALL

55-05-03



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AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
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, for each applicable panel (SRM 51-10-01).

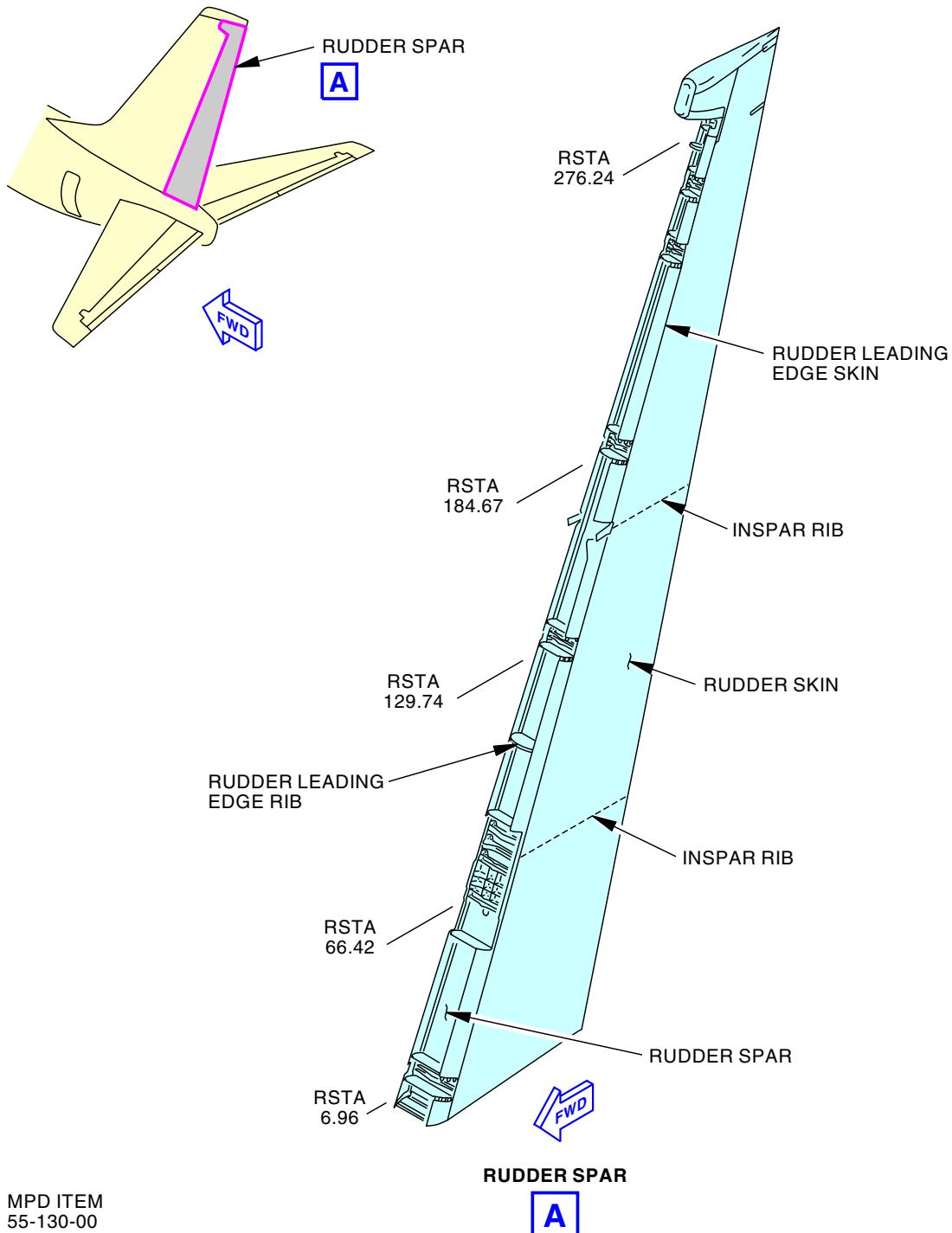
— END OF TASK —

EFFECTIVITY  
LOM ALL

**55-05-03**



737-600/700/800/900  
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MPD ITEM  
55-130-00

2085420 S0000439304\_V2

INTERNAL-GENERAL VISUAL: RUDDER, ELEVATOR & ELEVATOR TAB ATTACH FITTINGS  
Figure 220/55-05-03-990-816 (Sheet 1 of 4)

EFFECTIVITY  
LOM ALL

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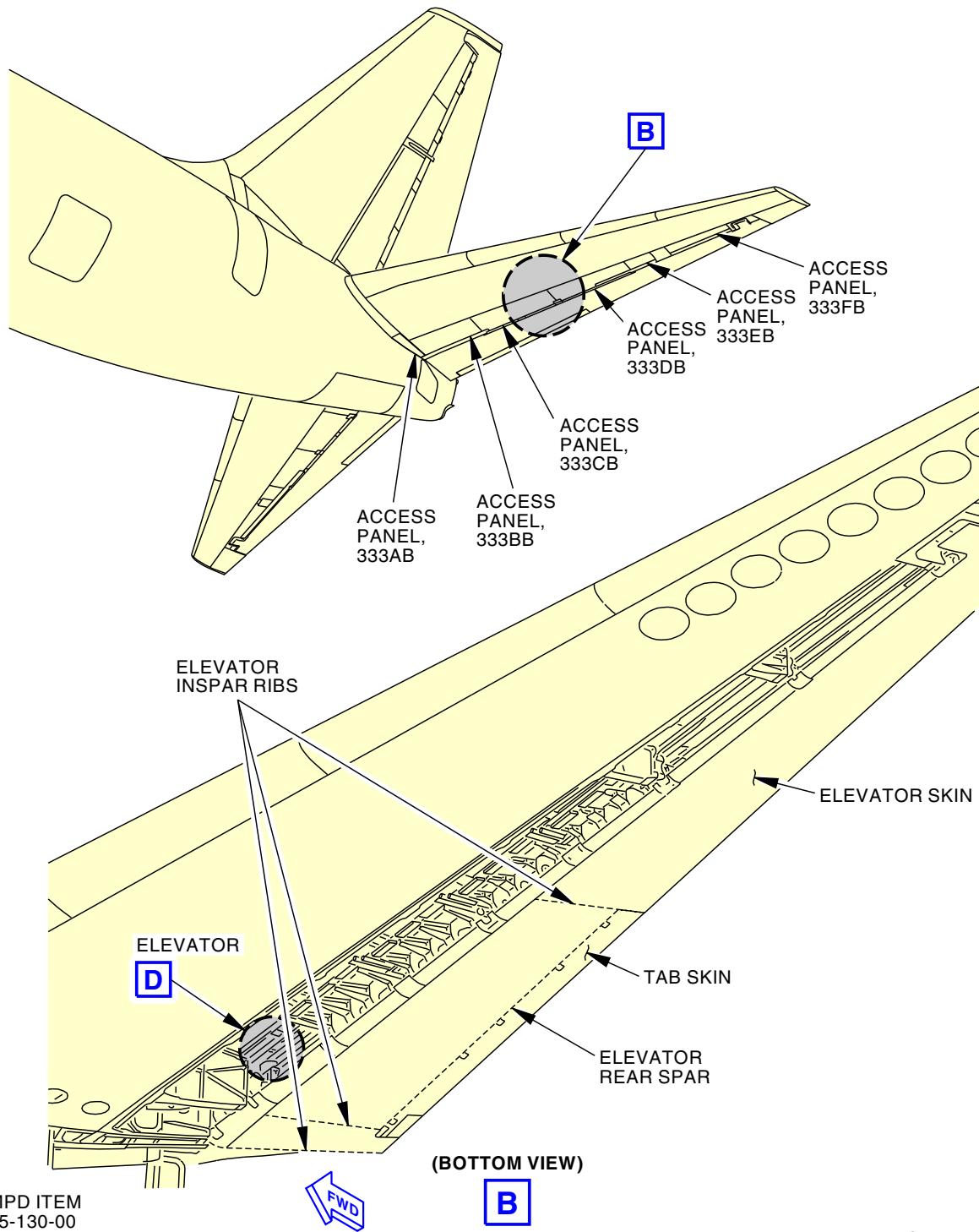
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**55-05-03**

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AIRCRAFT MAINTENANCE MANUAL



INTERNAL-GENERAL VISUAL: RUDDER, ELEVATOR & ELEVATOR TAB ATTACH FITTINGS  
Figure 220/55-05-03-990-816 (Sheet 2 of 4)

EFFECTIVITY  
LOM ALL

**55-05-03**

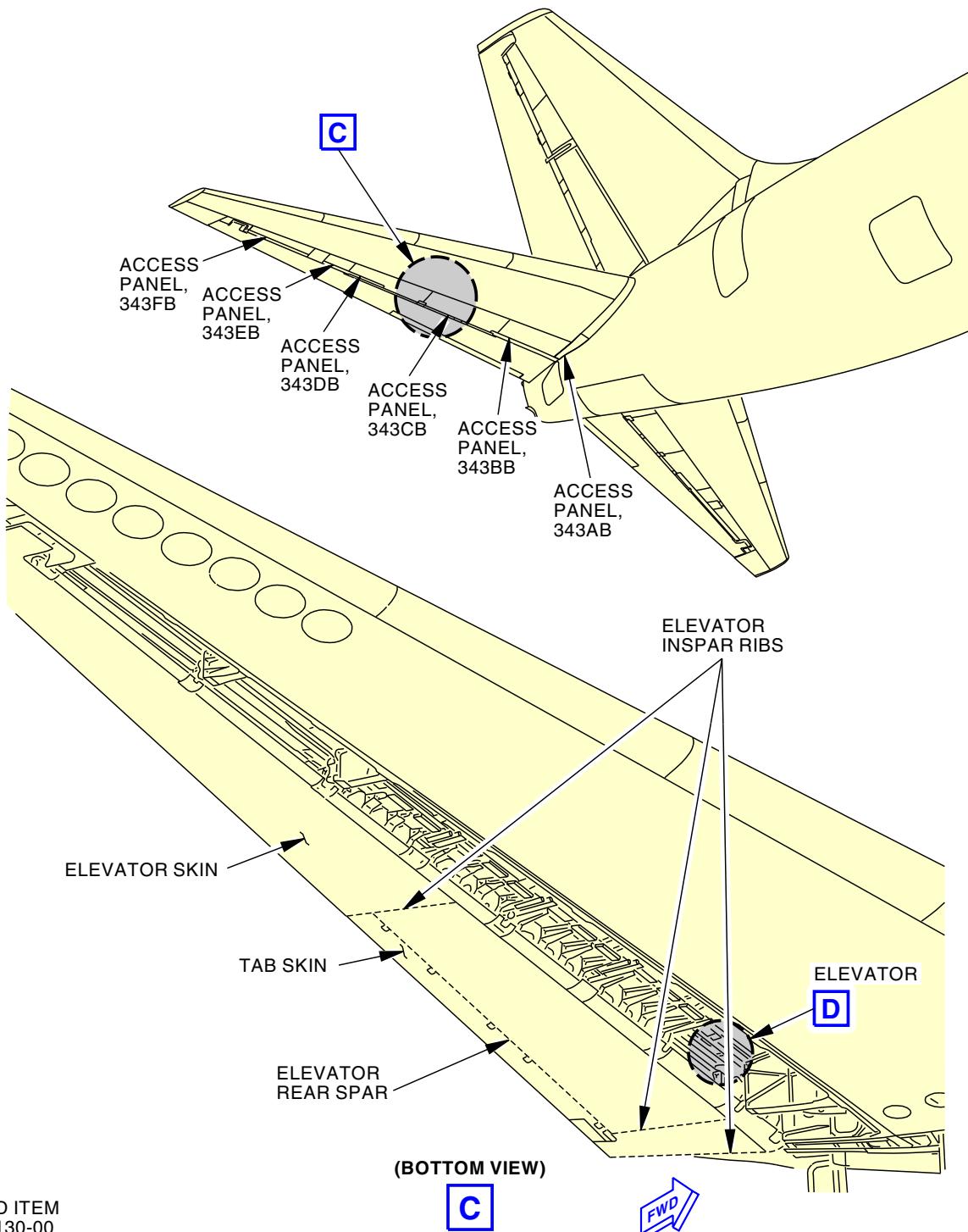
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AIRCRAFT MAINTENANCE MANUAL



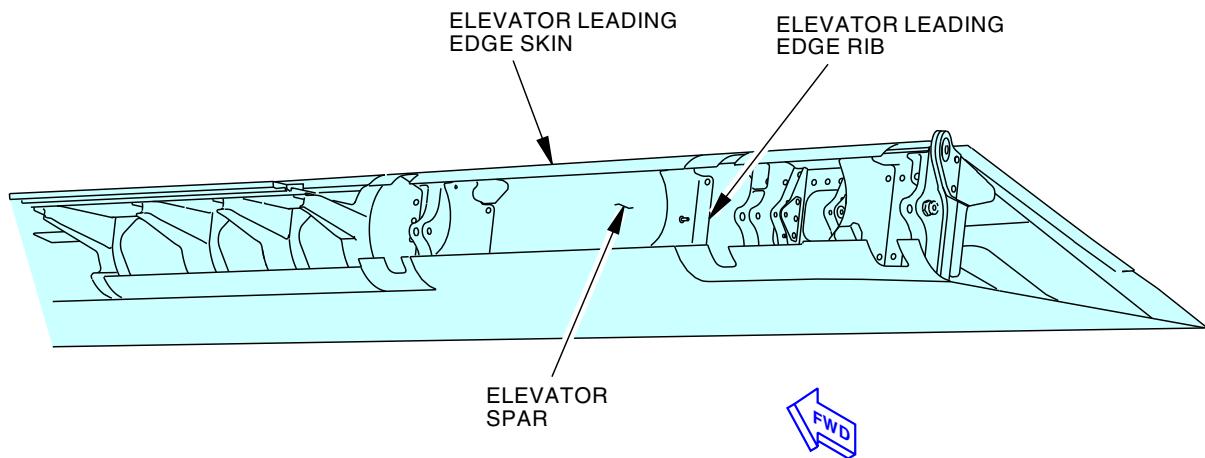
INTERNAL-GENERAL VISUAL: RUDDER, ELEVATOR & ELEVATOR TAB ATTACH FITTINGS  
Figure 220/55-05-03-990-816 (Sheet 3 of 4)

**55-05-03**

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

D

MPD ITEM  
55-130-00

2085530 S0000439307\_V2

INTERNAL-GENERAL VISUAL: RUDDER, ELEVATOR & ELEVATOR TAB ATTACH FITTINGS  
Figure 220/55-05-03-990-816 (Sheet 4 of 4)

EFFECTIVITY  
LOM ALL

**55-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**TASK 55-05-03-211-807**

**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**

<b>Reference</b>	<b>Title</b>
27-31-31-000-801	Elevator Tab - Removal (P/B 401)
27-31-31-400-801	Elevator Tab - Installation (P/B 401)
27-31-41-000-801	Elevator Balance Panel - Removal (P/B 401)
27-31-41-400-801	Elevator Balance Panel - Installation (P/B 401)
51-05-01-210-803	737-6789 Basic Task Description (P/B 201)
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
334	Left Horizontal Stabilizer - Elevator

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
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 55-05-03-010-016

- (1) Open these access panels:

<b>Number</b>	<b>Name/Location</b>
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

EFFECTIVITY
LOM ALL



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

(Continued)

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

NOTE: For elevator tab mast arm fittings, if it is necessary remove fairing on upper surface of elevator to gain access.

**SUBTASK 55-05-03-010-025**

- (2) Remove the elevator balance bay panels (TASK 27-31-41-000-801).
  - (a) (Alternative) Remove the elevator from the horizontal stabilizer (TASK 27-31-31-000-801).

**SUBTASK 55-05-03-211-007**

- (3) 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**

- (4) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-803.

**SUBTASK 55-05-03-410-029**

- (5) Install the elevator balance bay panels (TASK 27-31-41-400-801).
  - (a) (Alternative) Install the elevator to the horizontal stabilizer (TASK 27-31-31-400-801).

**SUBTASK 55-05-03-410-016**

- (6) 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

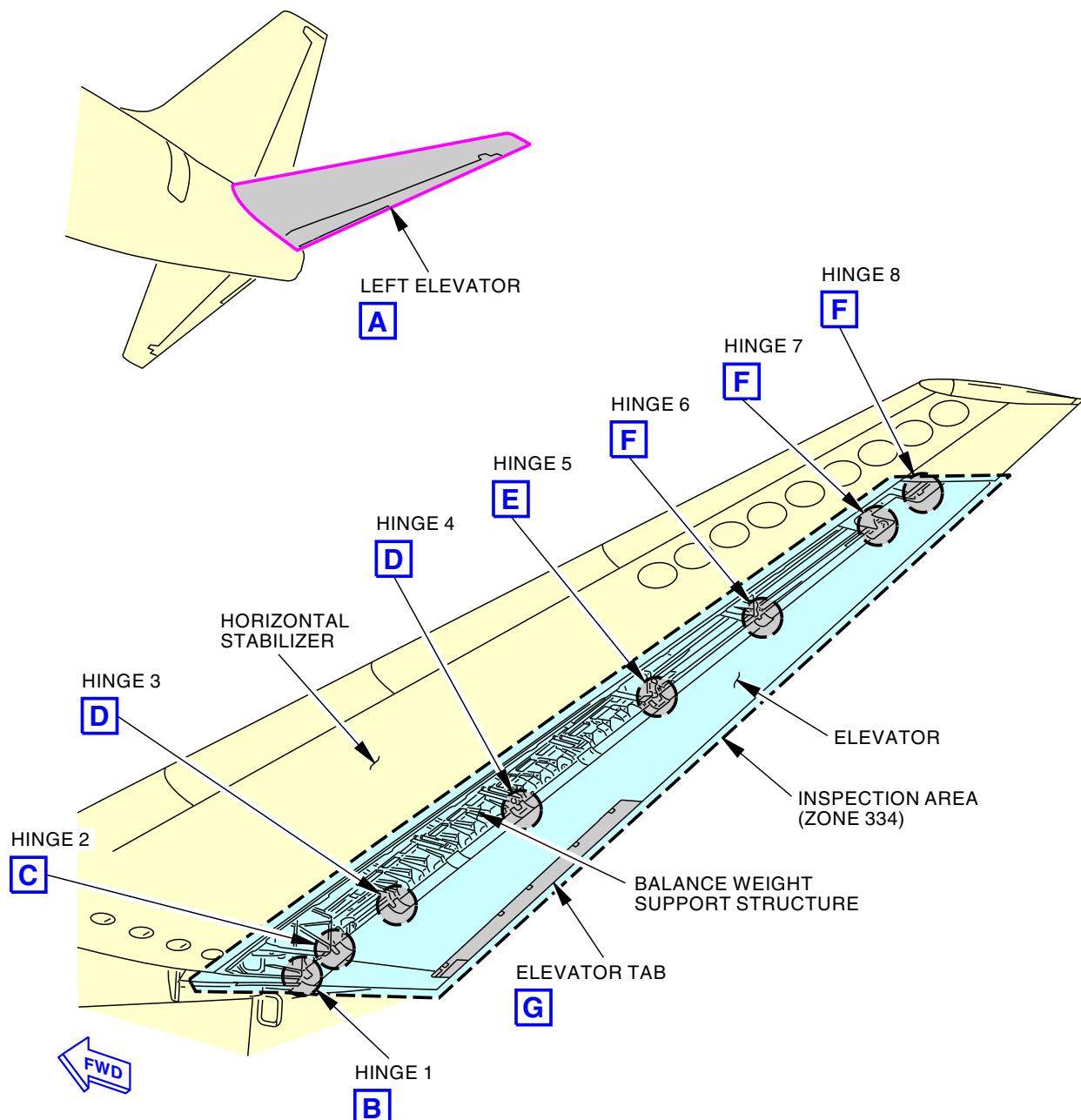
**SUBTASK 55-05-03-390-008**

- (7) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

— END OF TASK —

EFFECTIVITY
LOM ALL

**55-05-03**



**LEFT ELEVATOR  
(LOWER TRAILING EDGE PANELS REMOVED)**

**A**

MPD ITEM  
55-135-01

D46120 S0000158663\_V4

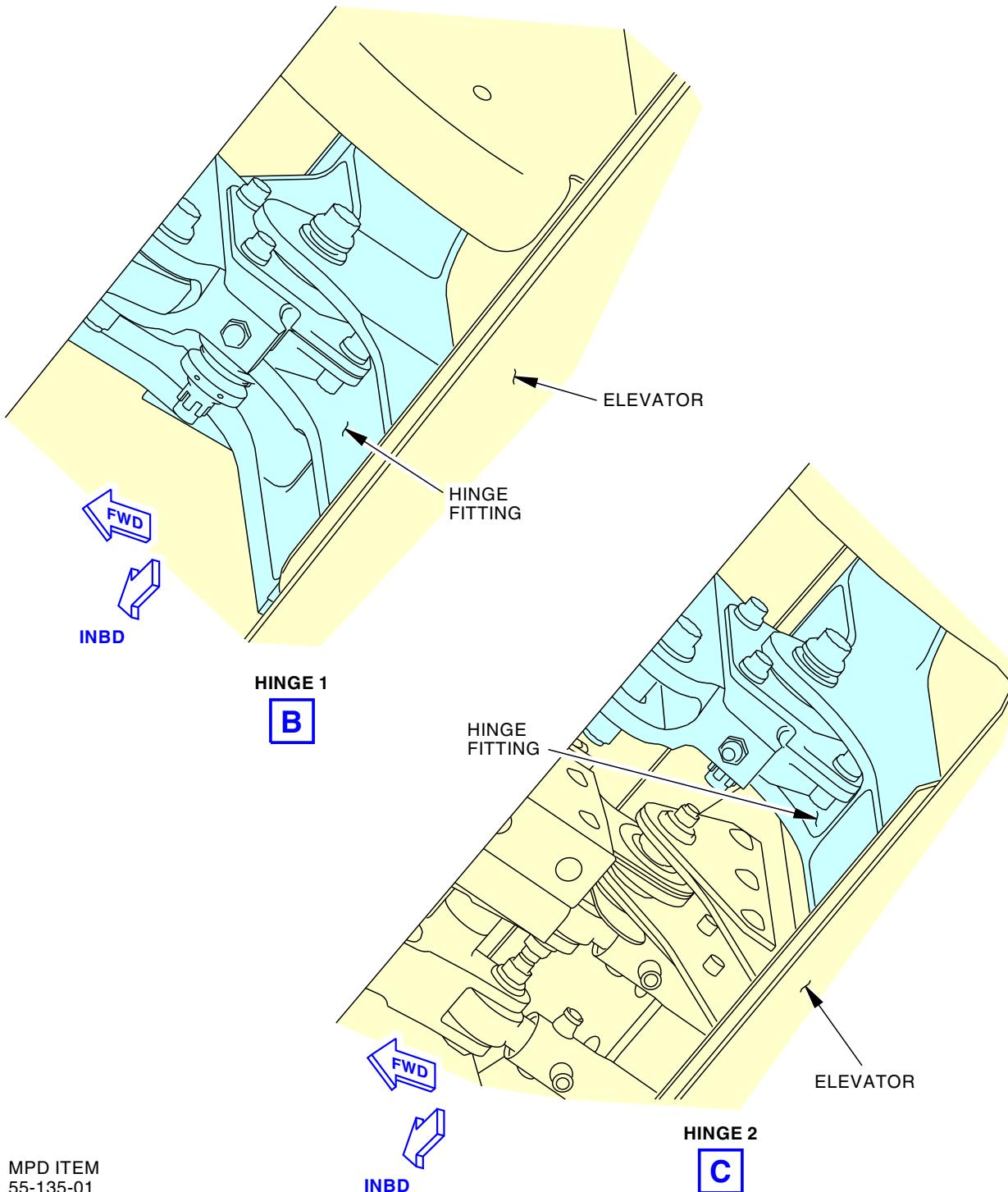
**Lft Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt**  
**Figure 221/55-05-03-990-809 (Sheet 1 of 6)**

EFFECTIVITY
LOM ALL

**55-05-03**



737-600/700/800/900  
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MPD ITEM  
55-135-01

D46122 S0000158664\_V3

Lft Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt  
Figure 221/55-05-03-990-809 (Sheet 2 of 6)

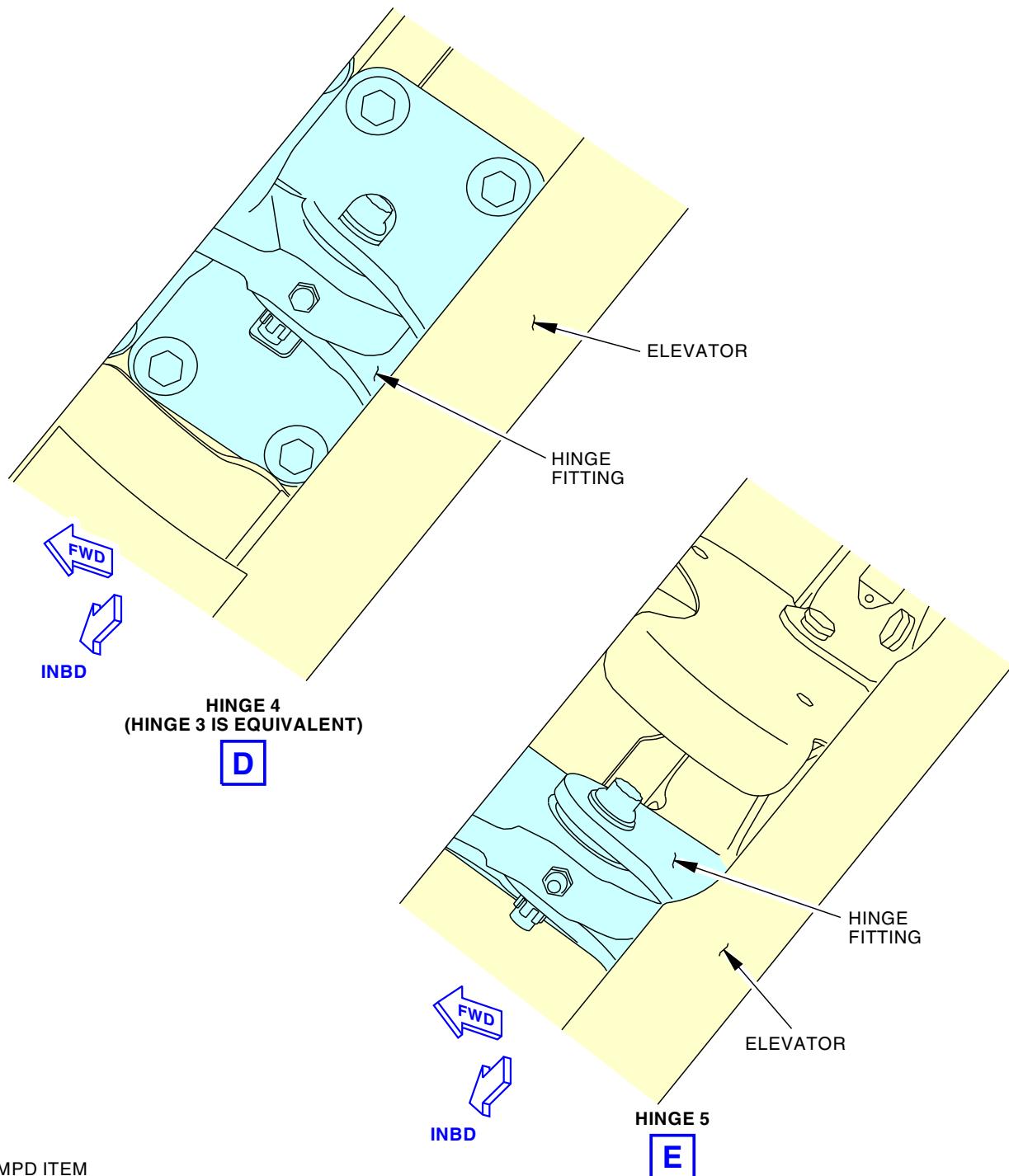
EFFECTIVITY  
LOM ALL

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**55-05-03**

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MPD ITEM  
55-135-01

D46124 S0000158665\_V3

Lft Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt  
Figure 221/55-05-03-990-809 (Sheet 3 of 6)

EFFECTIVITY  
LOM ALL

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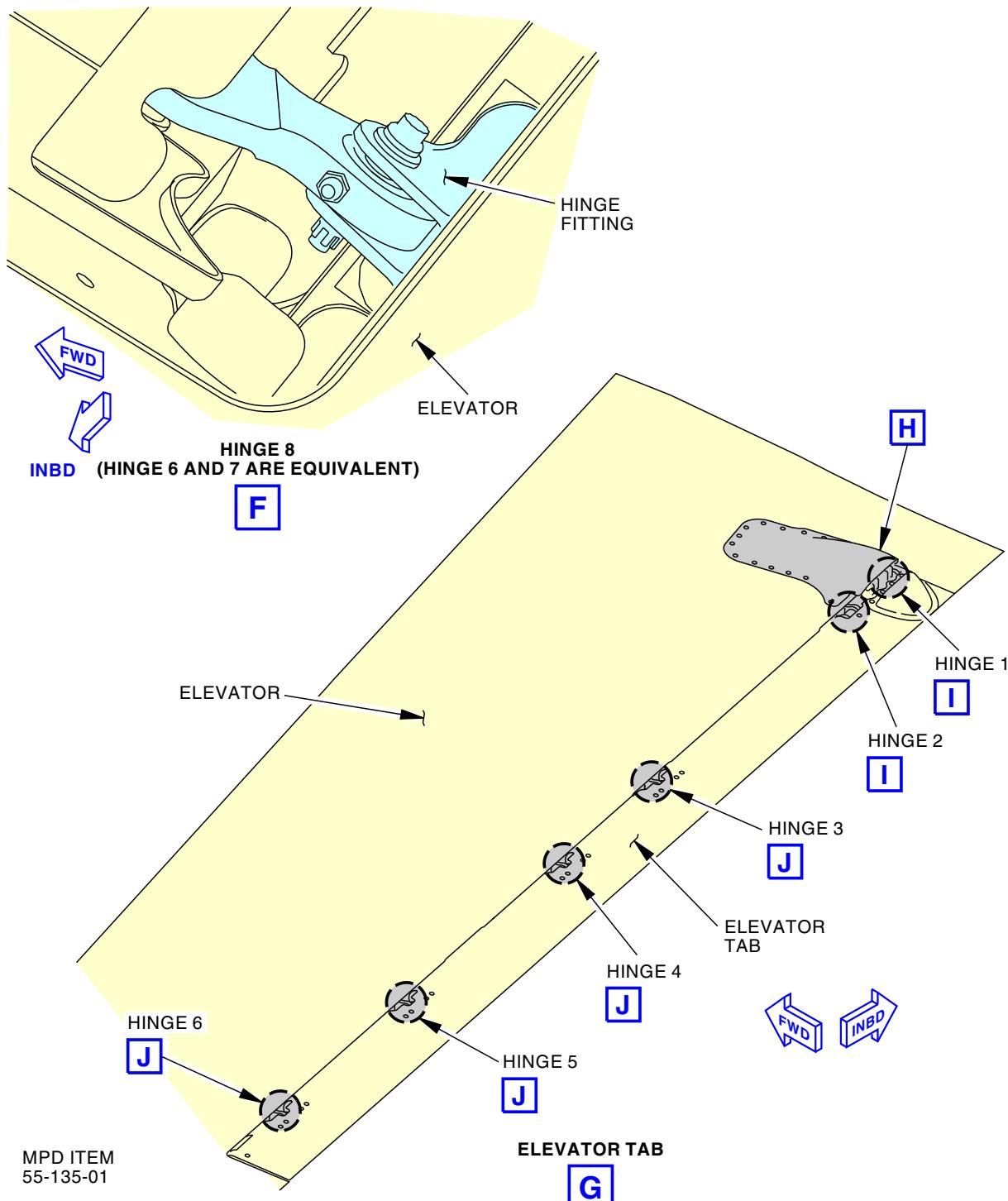
55-05-03

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# **737-600/700/800/900**

## **AIRCRAFT MAINTENANCE MANUAL**



D46125 S0000158666\_V4

**Lft Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt  
Figure 221/55-05-03-990-809 (Sheet 4 of 6)**

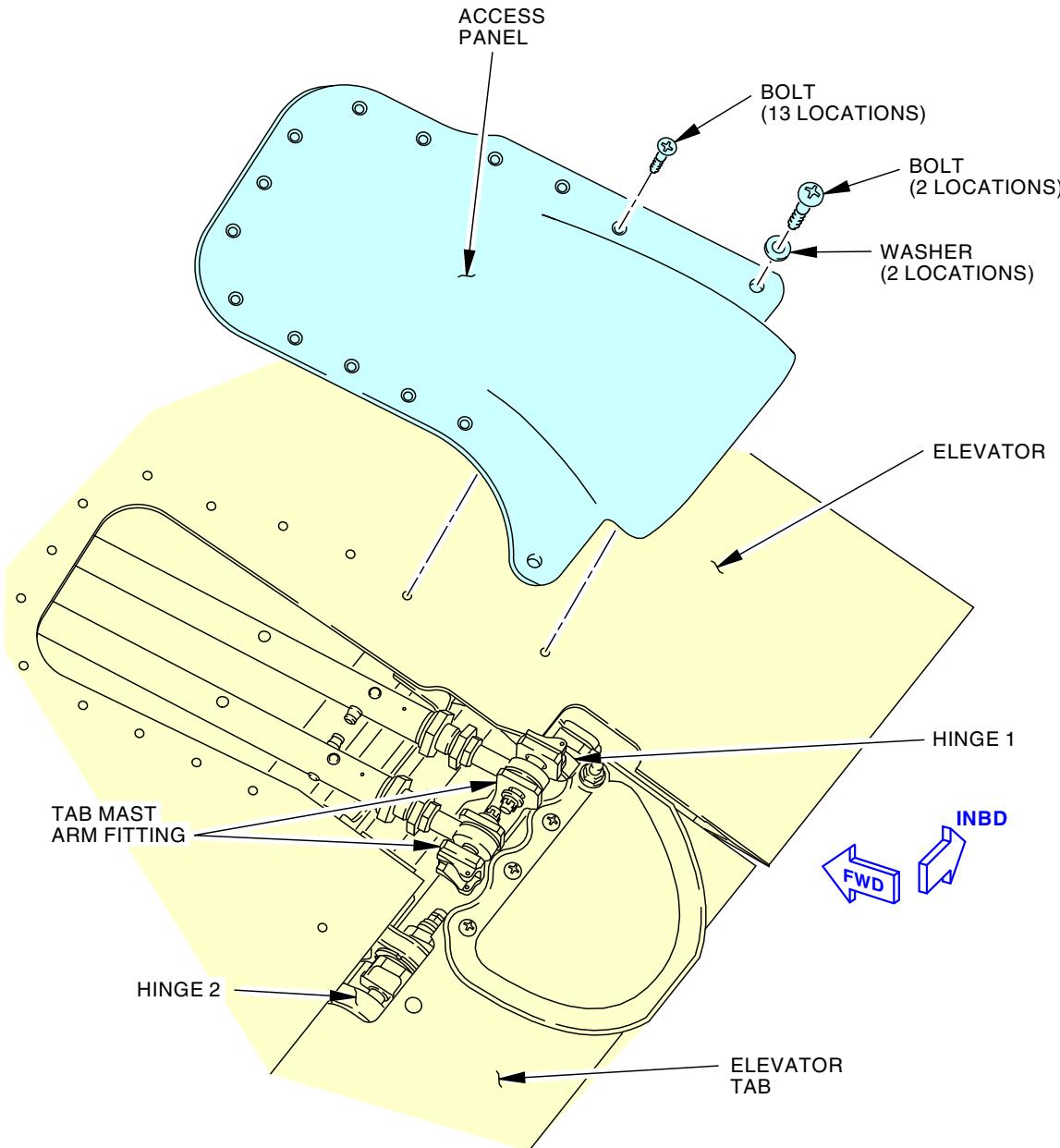
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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
55-135-01

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D46127 S0000158667\_V4

Lft Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt  
Figure 221/55-05-03-990-809 (Sheet 5 of 6)

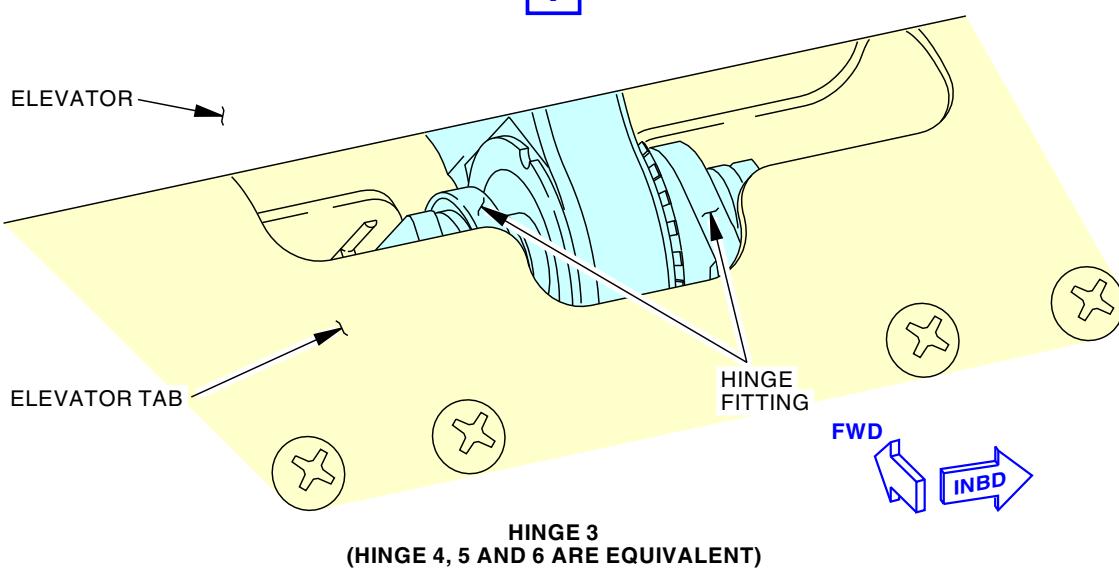
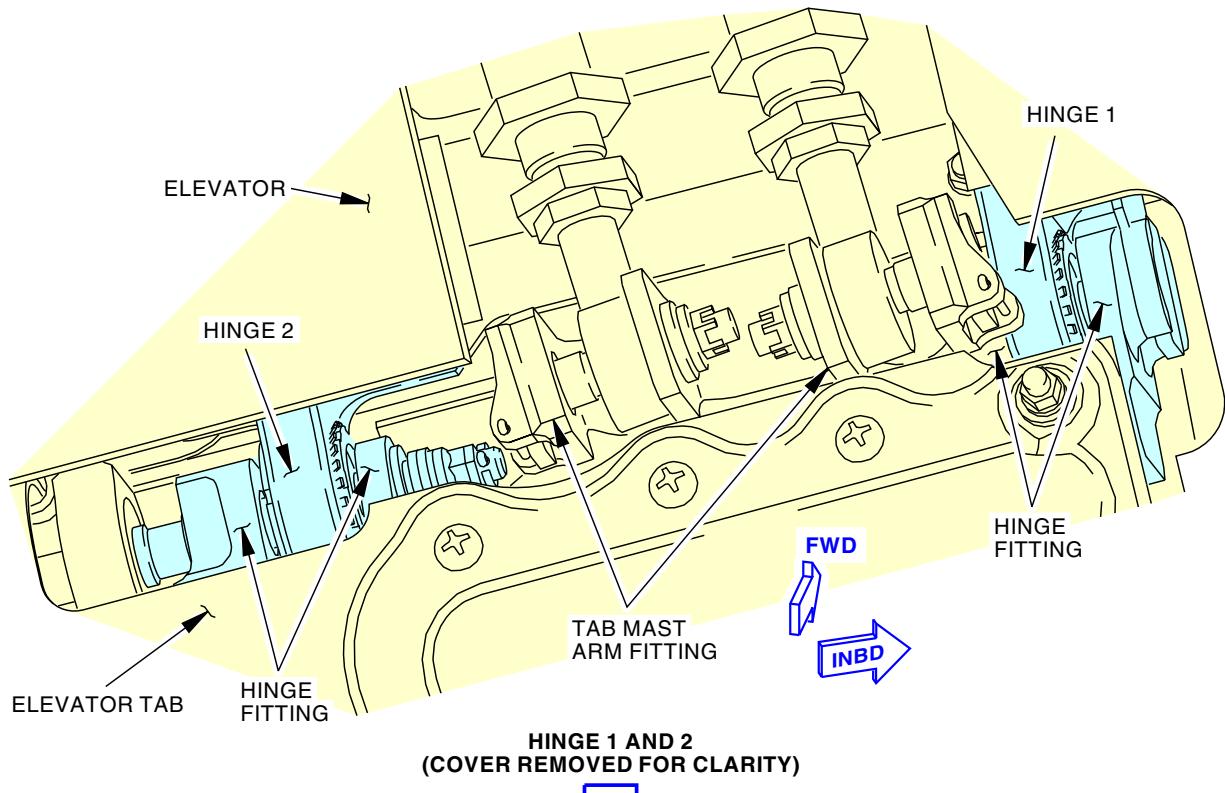
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**55-05-03**

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MPD ITEM  
55-135-01

D46129 S0000158668\_V4

**Lft Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt**  
**Figure 221/55-05-03-990-809 (Sheet 6 of 6)**

EFFECTIVITY  
LOM ALL

**55-05-03**



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AIRCRAFT MAINTENANCE MANUAL

**TASK 55-05-03-211-808**

**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**

<b>Reference</b>	<b>Title</b>
27-31-31-000-801	Elevator Tab - Removal (P/B 401)
27-31-31-400-801	Elevator Tab - Installation (P/B 401)
27-31-41-000-801	Elevator Balance Panel - Removal (P/B 401)
27-31-41-400-801	Elevator Balance Panel - Installation (P/B 401)
51-05-01-210-803	737-6789 Basic Task Description (P/B 201)
SRM 51-10-01	Structural Repair Manual

**B. Consumable Materials**

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

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
344	Right Horizontal Stabilizer - Elevator

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
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 55-05-03-010-017

- (1) Open these access panels:

<b>Number</b>	<b>Name/Location</b>
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

EFFECTIVITY
LOM ALL

**55-05-03**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

(Continued)

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

NOTE: For elevator tab mast arm fittings, if it is necessary remove fairing on upper surface of elevator to gain access.

**SUBTASK 55-05-03-010-026**

- (2) Remove the elevator balance bay panels (TASK 27-31-41-000-801).
  - (a) (Alternative) Remove the elevator from the horizontal stabilizer (TASK 27-31-31-000-801).

**SUBTASK 55-05-03-211-008**

- (3) 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**

- (4) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-803.

**SUBTASK 55-05-03-410-030**

- (5) Install the elevator balance bay panels (TASK 27-31-41-400-801).
  - (a) (Alternative) Install the elevator to the horizontal stabilizer (TASK 27-31-31-400-801).

**SUBTASK 55-05-03-410-017**

- (6) 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 55-05-03-390-009**

- (7) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

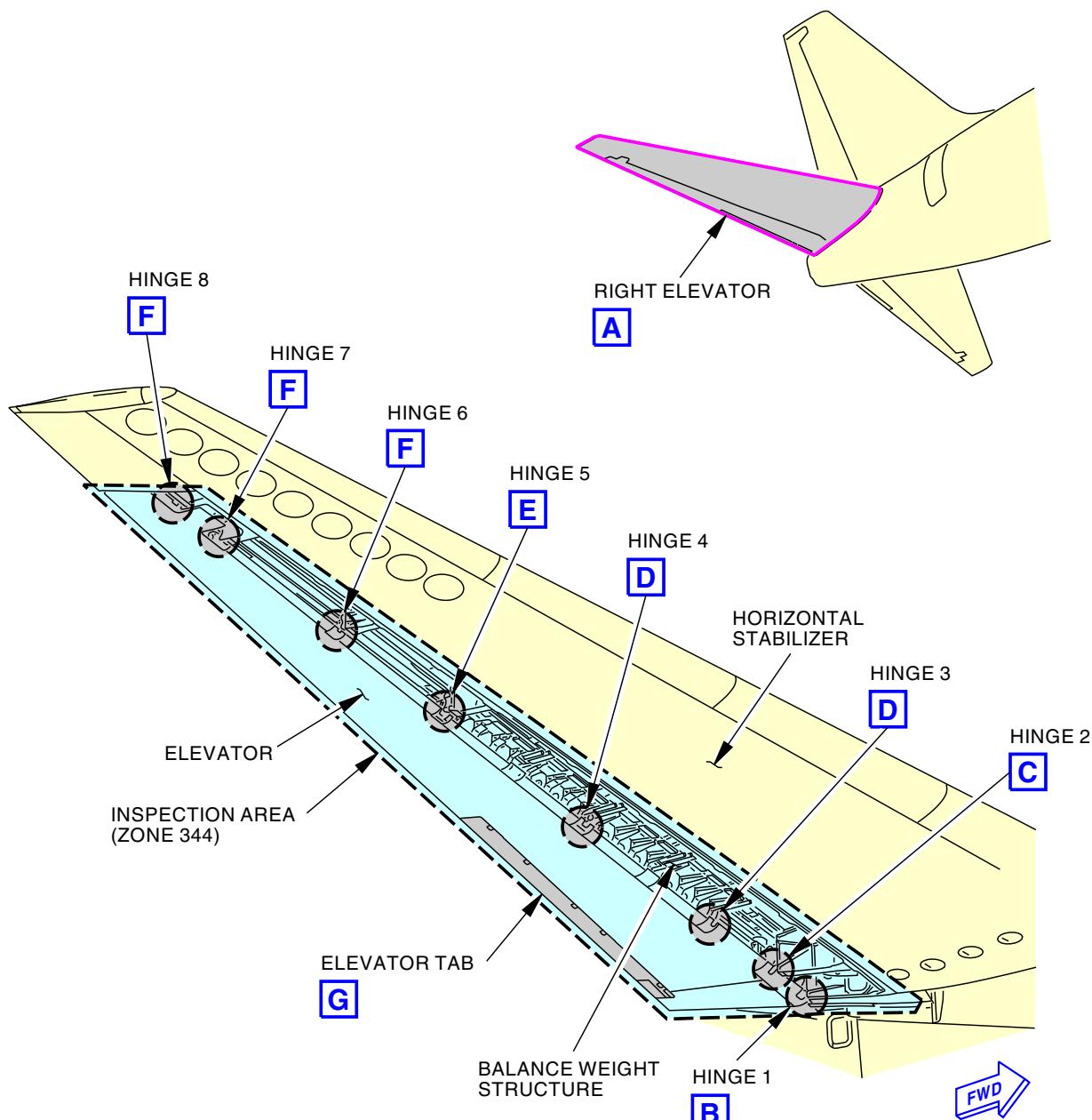
— END OF TASK —



**55-05-03**



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RIGHT ELEVATOR  
(LOWER TRAILING EDGE PANELS REMOVED)

A

MPD ITEM  
55-135-02

D46151 S0000158670\_V4

Rt. Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt  
Figure 222/55-05-03-990-810 (Sheet 1 of 6)

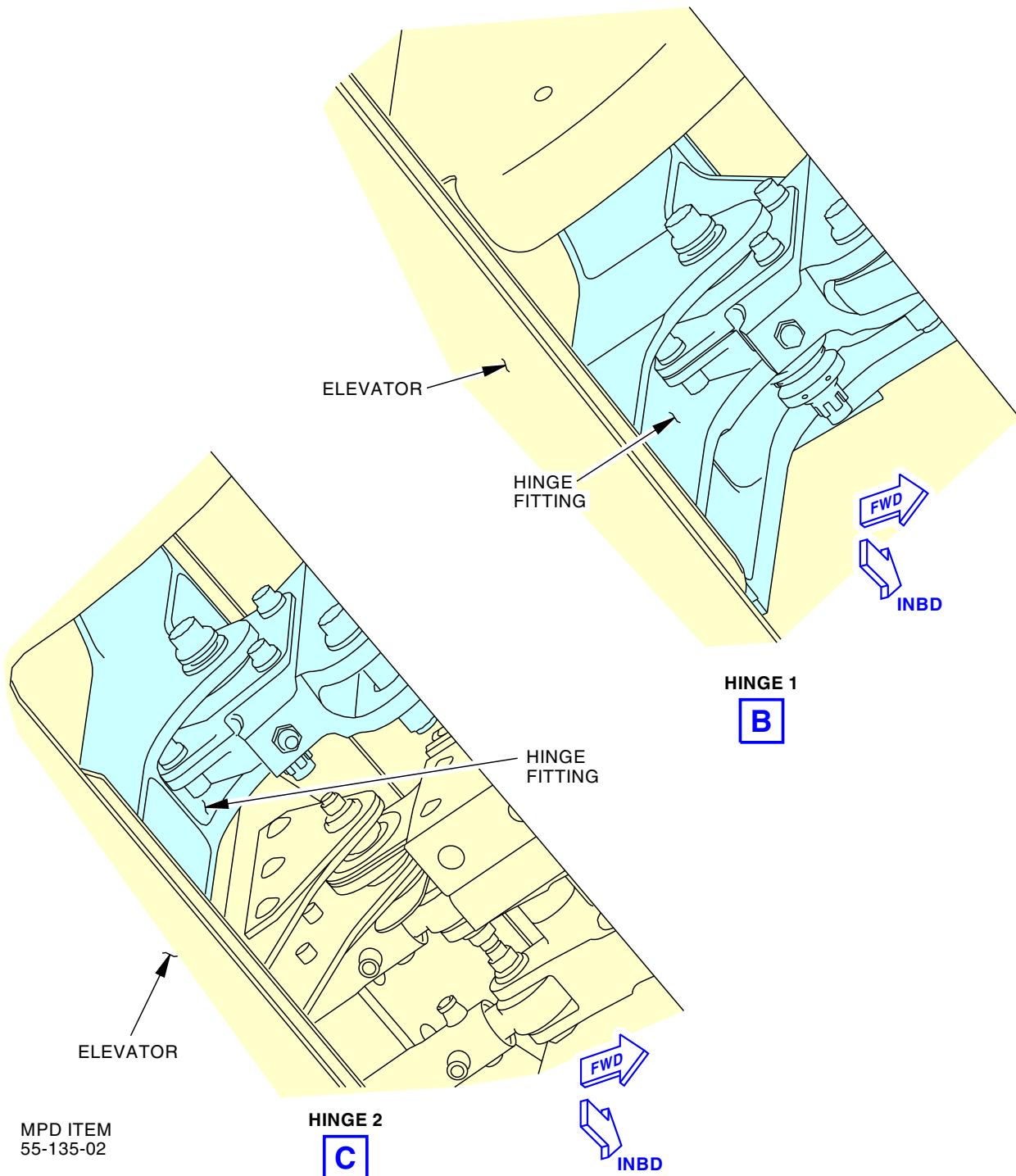
EFFECTIVITY  
LOM ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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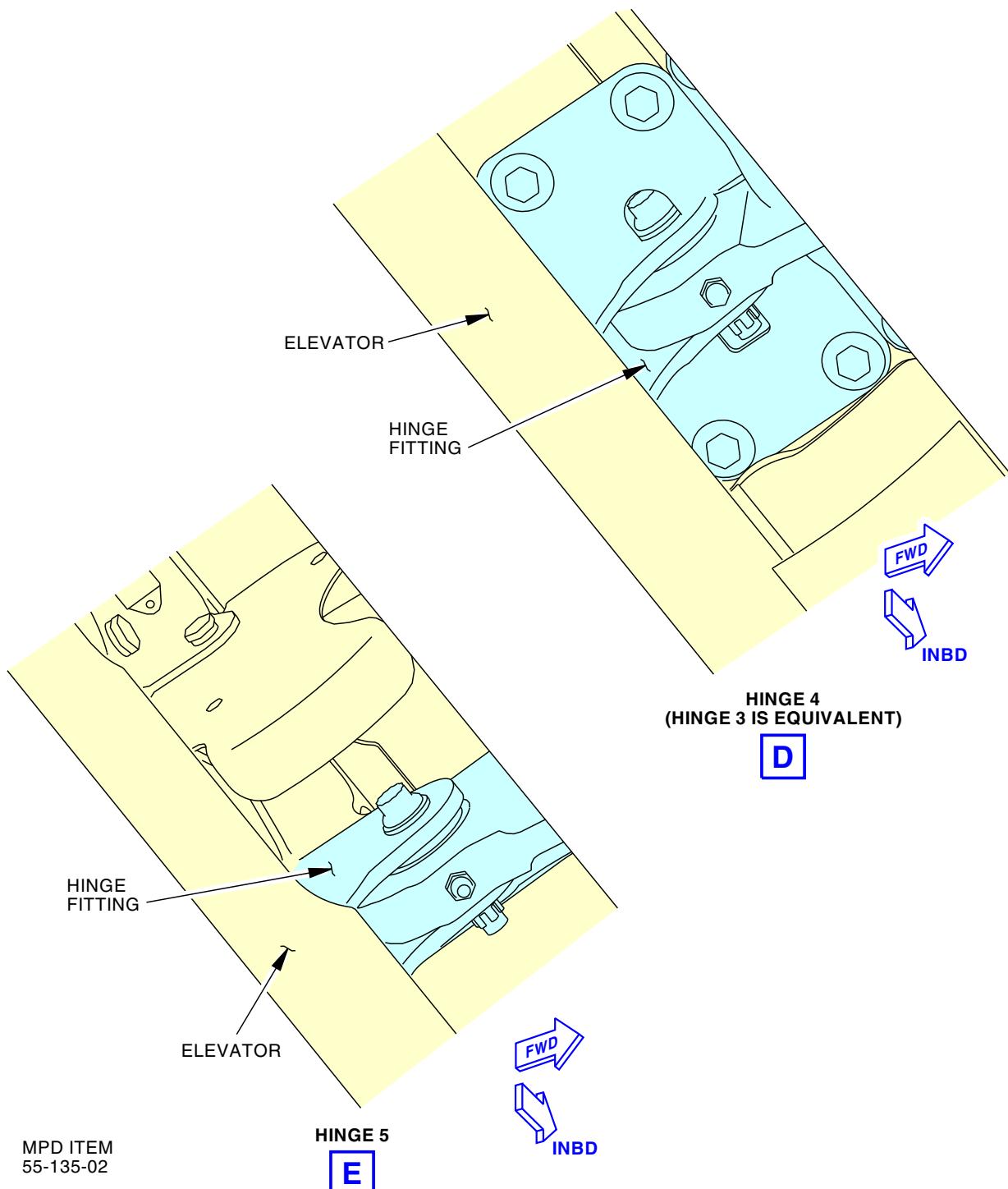
**Rt. Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt**  
**Figure 222/55-05-03-990-810 (Sheet 2 of 6)**

EFFECTIVITY  
LOM ALL

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D46207 S0000158672\_V3

Rt. Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt  
Figure 222/55-05-03-990-810 (Sheet 3 of 6)

EFFECTIVITY  
LOM ALL

**55-05-03**

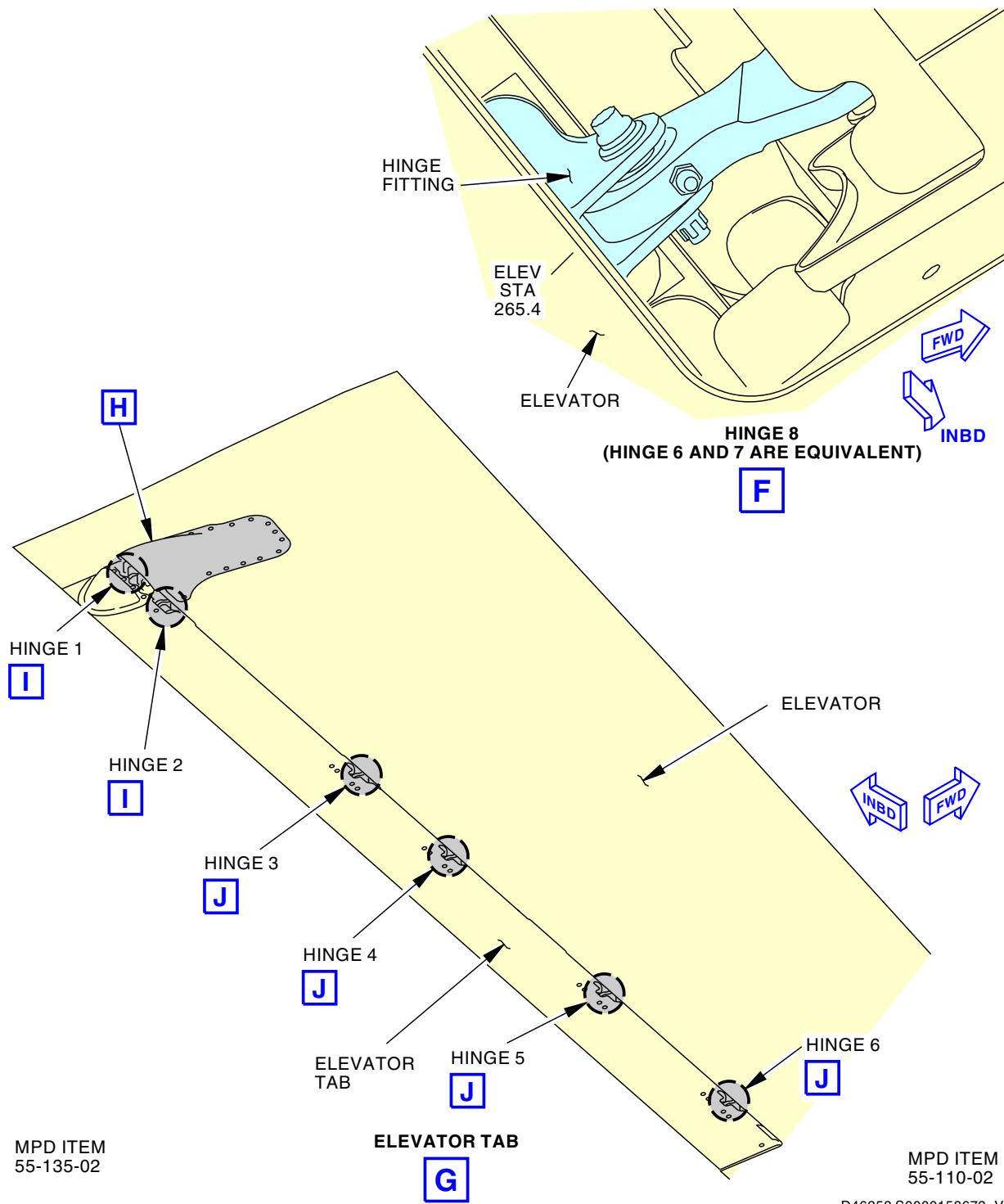
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Rt. Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt  
Figure 222/55-05-03-990-810 (Sheet 4 of 6)

EFFECTIVITY  
LOM ALL

**55-05-03**

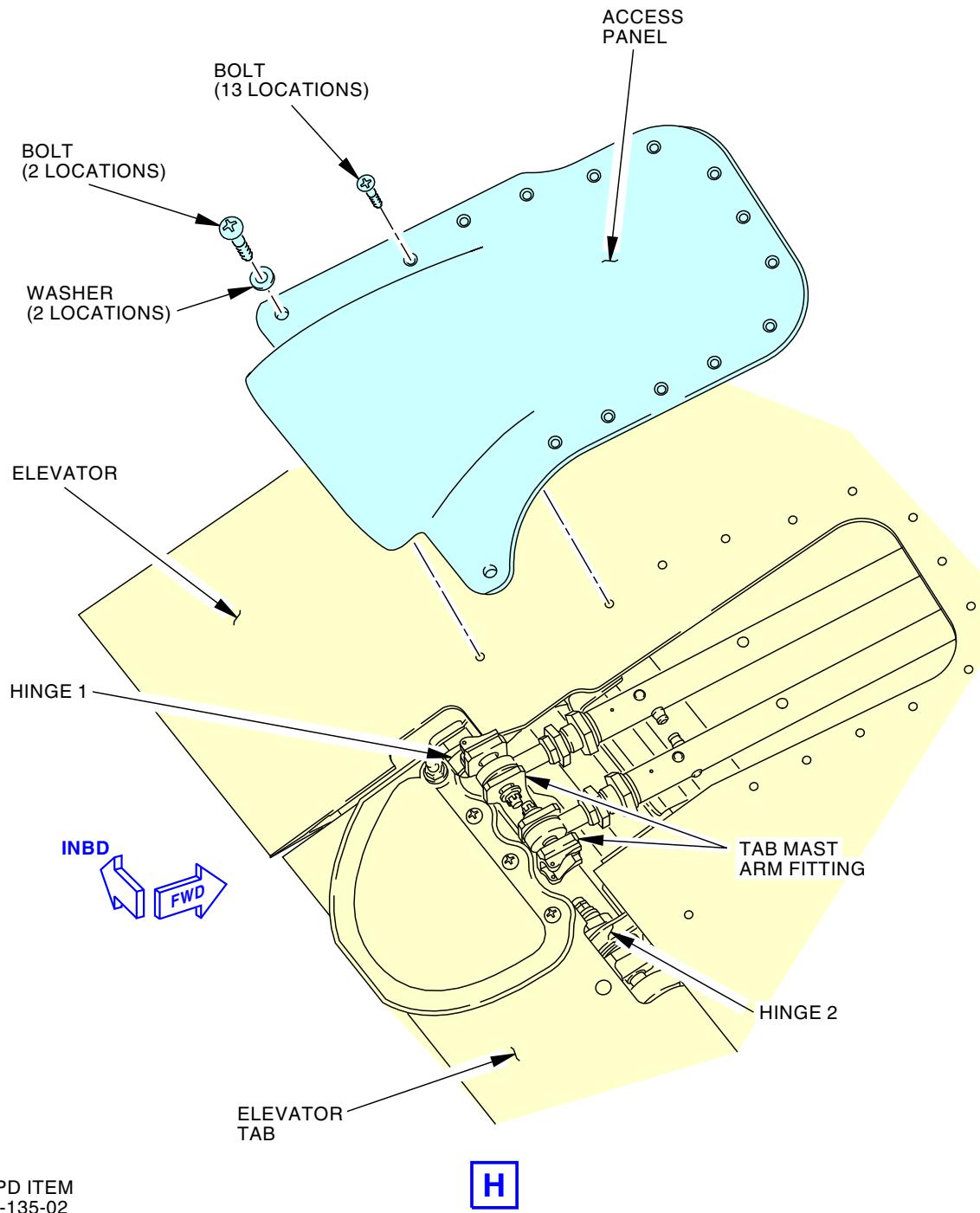
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Rt. Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt  
Figure 222/55-05-03-990-810 (Sheet 5 of 6)

EFFECTIVITY  
LOM ALL

**55-05-03**

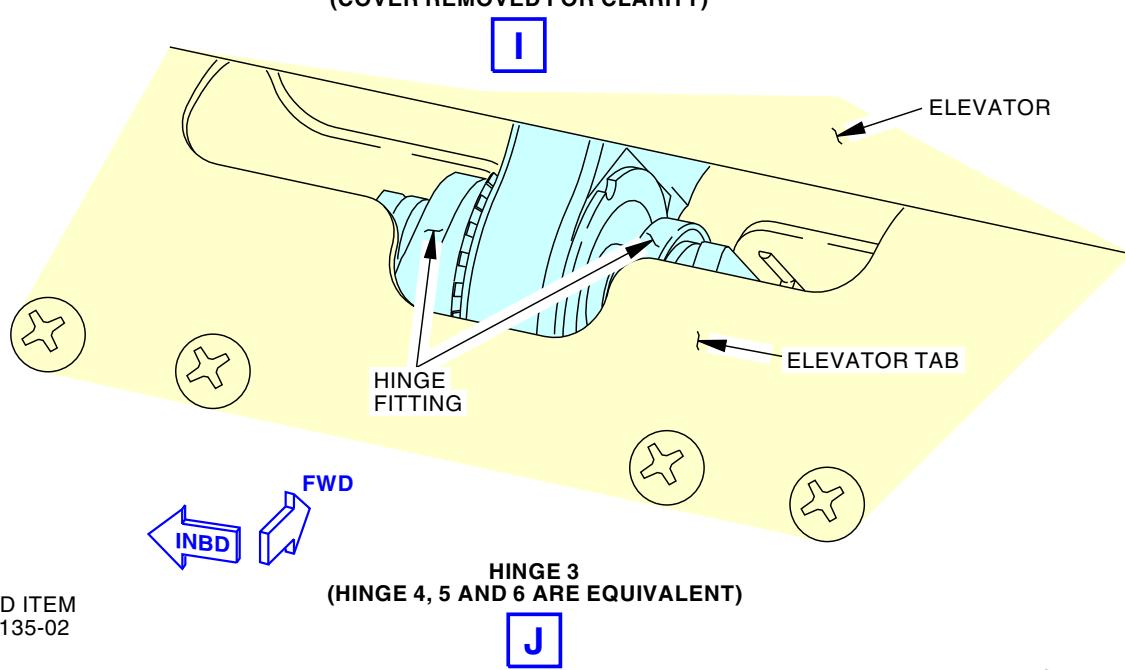
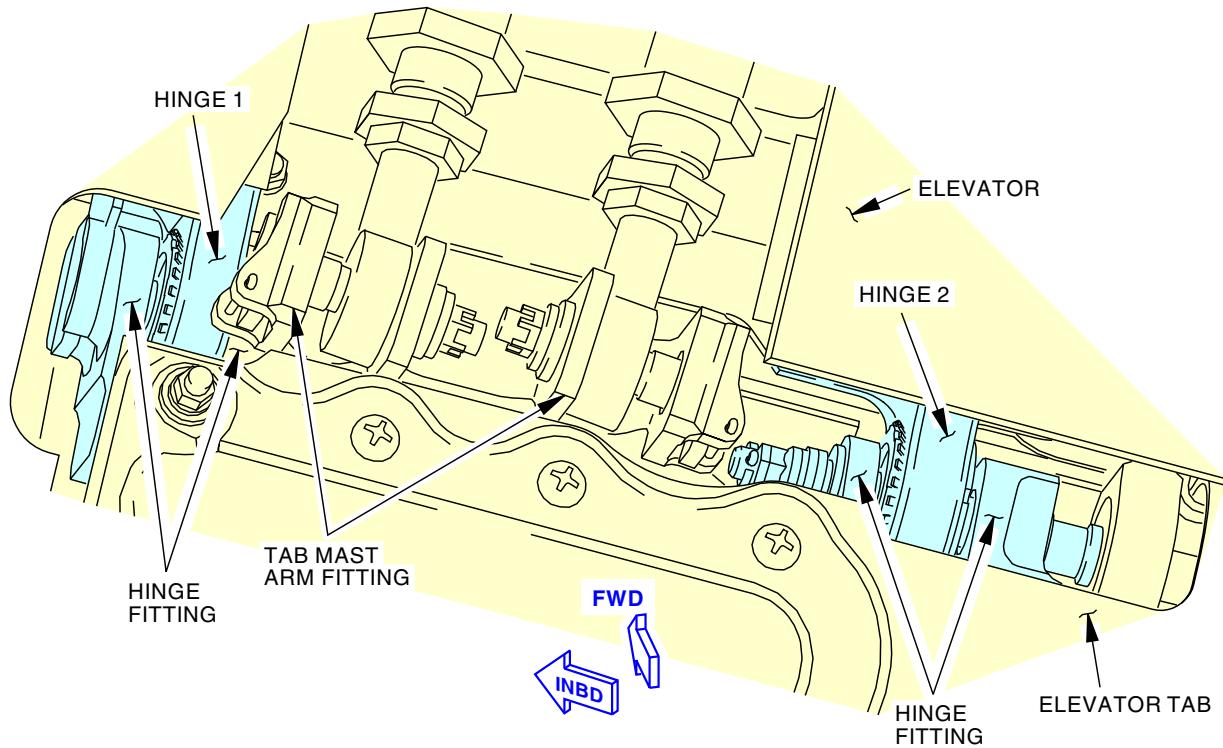
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MPD ITEM  
55-135-02

D46393 S0000158675\_V4

Rt. Ele. Hinge, Actuator, and Tab Mast Arm Ftgs and Balance WT Suppt  
Figure 222/55-05-03-990-810 (Sheet 6 of 6)

EFFECTIVITY  
LOM ALL

**55-05-03**



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**TASK 55-05-03-290-801**

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

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
51-05-01-210-804	737-6789 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**

<u>Zone</u>	<u>Area</u>
333	Left Horizontal Stabilizer - Rear Spar to Trailing Edge

**C. Access Panels**

<u>Number</u>	<u>Name/Location</u>
335A	Horizontal Stabilizer, Removable Stabilizer Tip

**D. Inspection**

SUBTASK 55-05-03-010-021

- (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: 737-6789 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

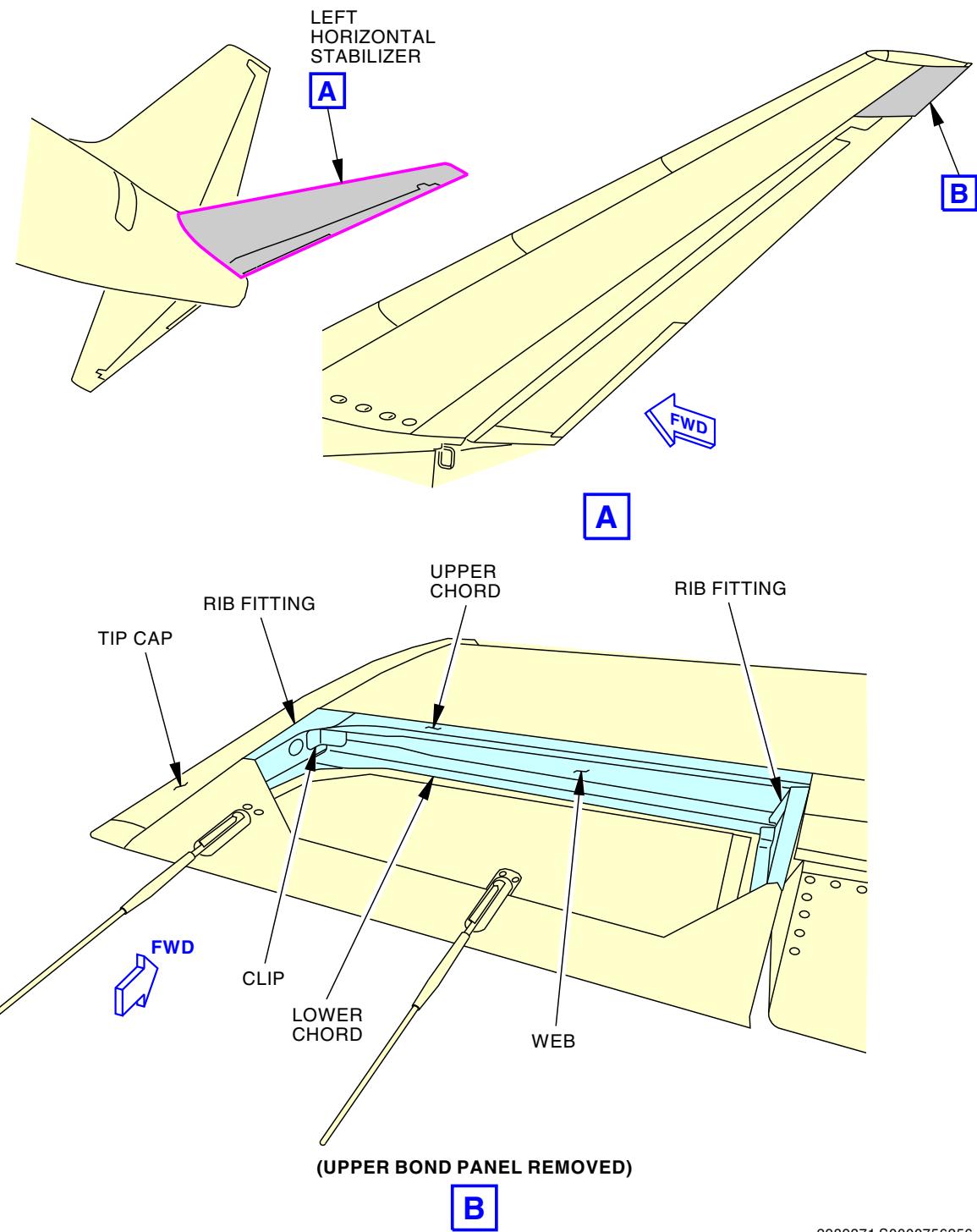
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EFFECTIVITY  
LOM ALL

**55-05-03**



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2989371 S0000756256\_V1

Left Horizontal Stabilizer Trailing Edge STAB BL 254.66 to STAB BL 281.81 - Special Detailed (Internal)  
Figure 223/55-05-03-990-828

EFFECTIVITY  
LOM ALL

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**55-05-03**

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**TASK 55-05-03-290-802**

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

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
51-05-01-210-804	737-6789 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**

<b>Zone</b>	<b>Area</b>
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge

**C. Access Panels**

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

**D. Inspection**

SUBTASK 55-05-03-010-022

- (1) Open this access panel:

**Number      Name/Location**

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: 737-6789 Basic Task Description, TASK 51-05-01-210-804

SUBTASK 55-05-03-410-024

- (4) Close this access panel:

**Number      Name/Location**

345A      Horizontal Stabilizer, Removable Stabilizer Tip

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

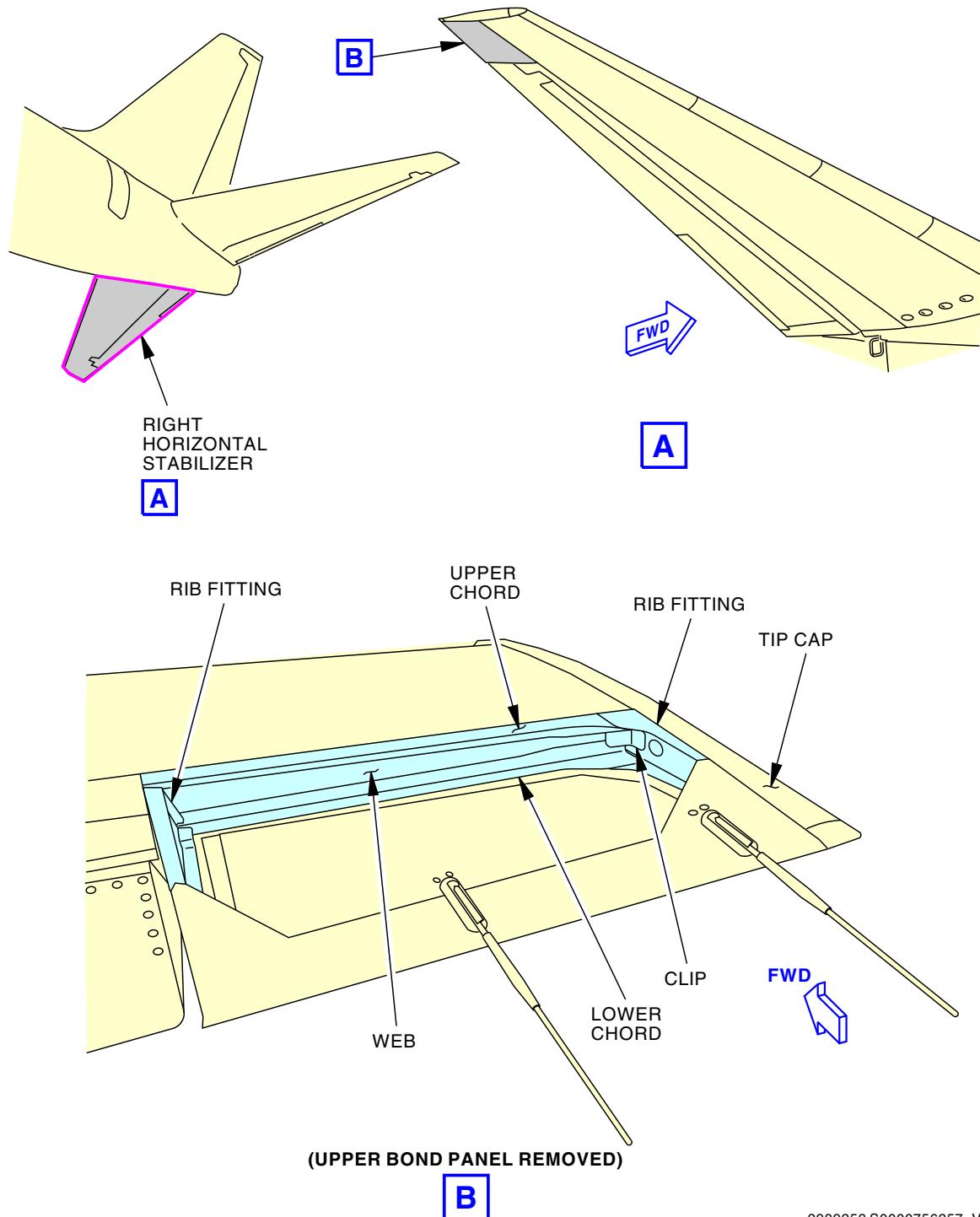
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EFFECTIVITY  
LOM ALL

**55-05-03**



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AIRCRAFT MAINTENANCE MANUAL



2989253 S0000756257\_V1

**Right Horizontal Stabilizer Trailing Edge STAB BL 254.66 to STAB BL 281.81 - Special Detailed (Internal)**  
**Figure 224/55-05-03-990-829**



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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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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**

<u>Zone</u>	<u>Area</u>
335	Left Horizontal Stabilizer - Tip
345	Right Horizontal Stabilizer - Tip

**B. Prepare for the Removal**

SUBTASK 55-10-00-860-003

- (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>
C	2	C00849	AFCS STABILIZER TRIM

**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].

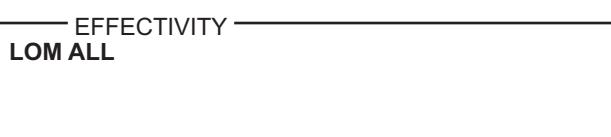
SUBTASK 55-10-00-010-001

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

SUBTASK 55-10-00-940-001

- (3) If the tip will be off for a long time, put a cover on the closure ribs.

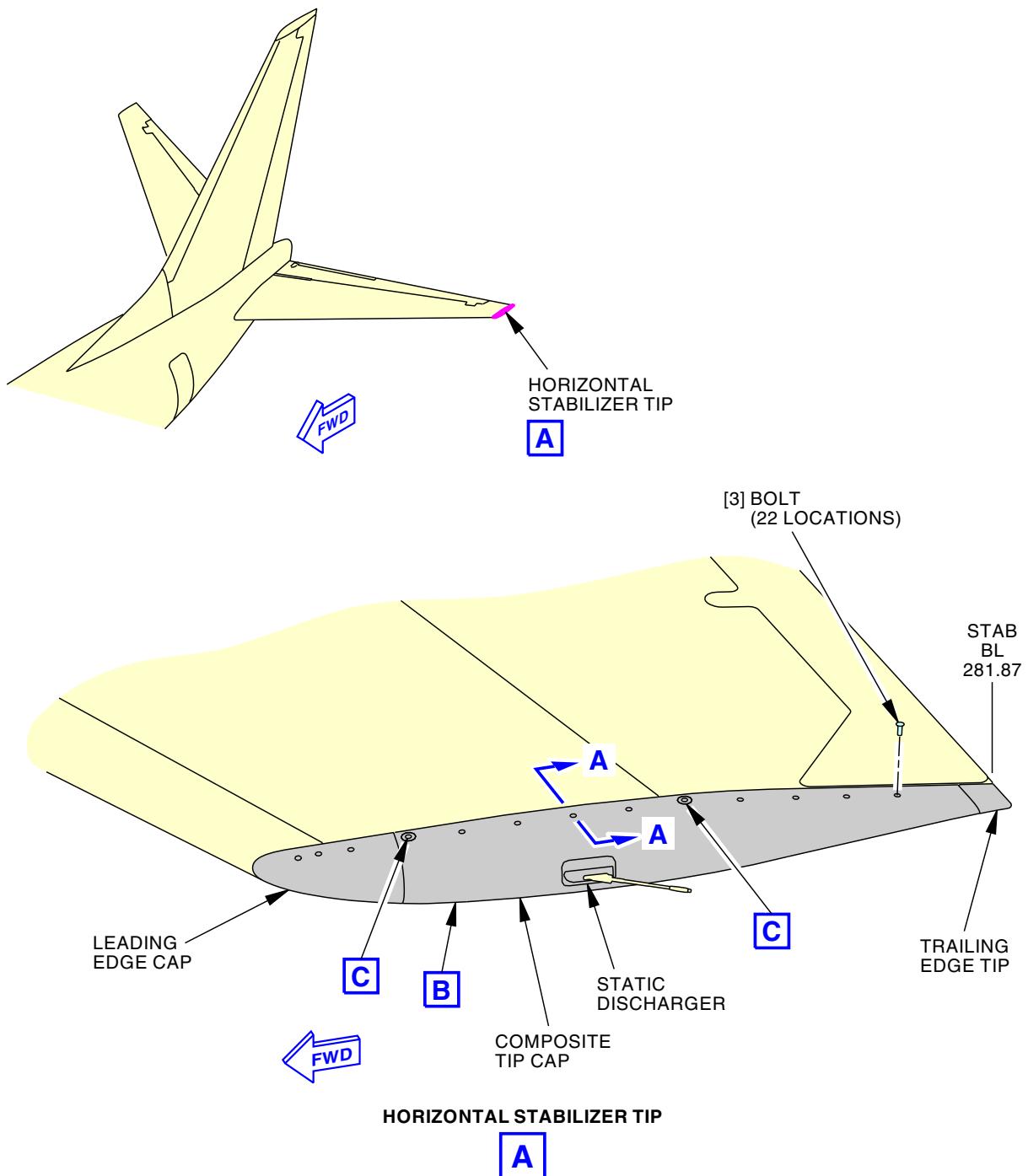
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**55-10-00**



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2927960 S0000706967\_V2

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

EFFECTIVITY  
LOM ALL

**55-10-00**

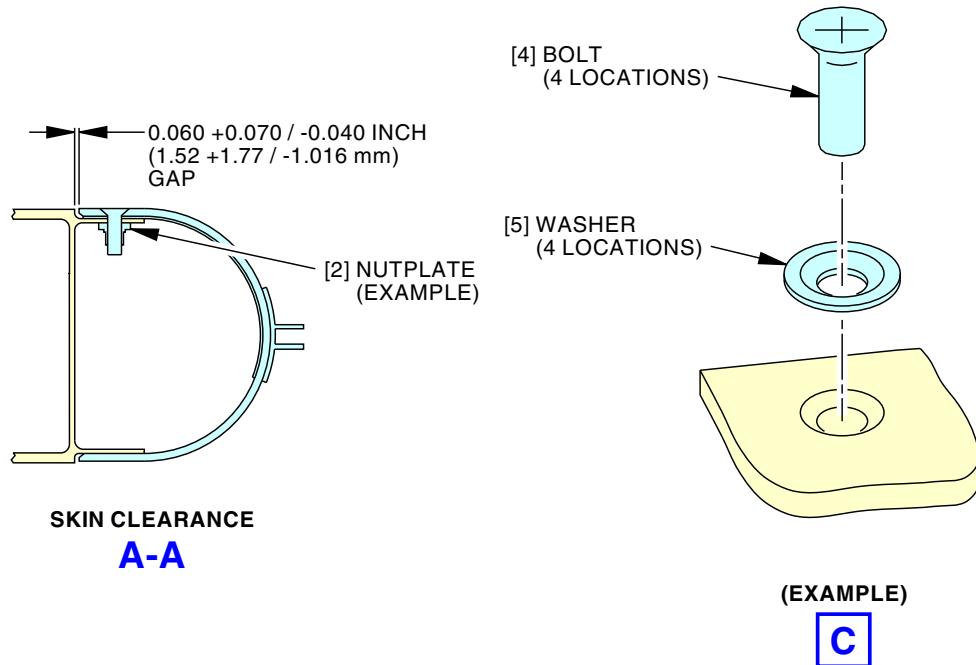
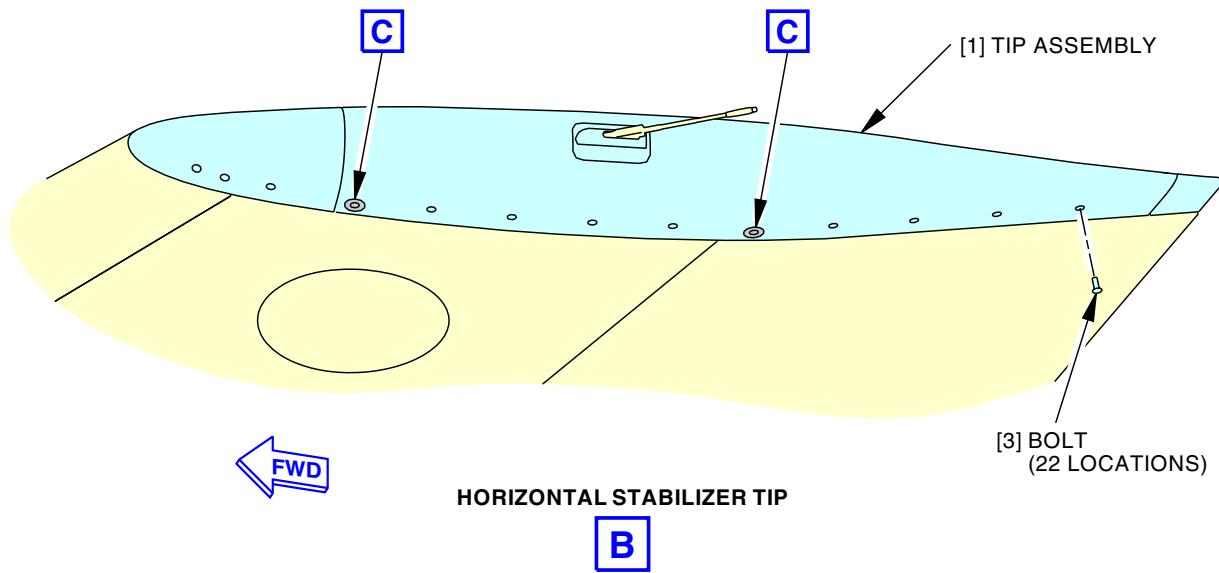
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2927964 S0000706968\_V1

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

EFFECTIVITY  
LOM ALL

**55-10-00**



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**TASK 55-10-00-400-801**

**3. Horizontal Stabilizer Tip - Installation**

(Figure 401)

**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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LOM ALL

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- (c) Tighten the bolts [3] and bolts [4] gradually, in a sequence that will not cause the skin to buckle.
- (d) Make sure that clearance between the tip skin and horizontal stabilizer is correct (View A-A, Figure 401).
- (e) Measure the electrical bonding resistance between the airplane structure and bolts [4] and washers [5] (SWPM 20-20-00).
  - 1) Use an intrinsically safe approved bonding meter, COM-1550.
  - 2) Make sure that the resistance is 0.001 ohm (1.0 milliohm) or less.

SUBTASK 55-10-00-390-001

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

**G. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-10-00-860-004

- (1) 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>
C	2	C00849	AFCS STABILIZER TRIM

**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 ————

EFFECTIVITY  
LOM ALL

**55-10-00**





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HORIZONTAL STABILIZER - CORROSION PREVENTION

**1. General**

- A. Corrosion has been found on the horizontal stabilizer rear spar, and filiform corrosion can occur on the inspar skin.
- B. Corrosion can occur on the jackscrew support truss.
- C. Corrosion has been found at the faying surfaces of the inspar skin and inspar rib chords.
- D. Corrosion has been reported on the rear spar attachment bolts which may result in chrome plating flaking.
- E. Corrosion has been found on the stabilizer and stabilizer center section clevises and lugs.
- F. Corrosion and plating deterioration can occur on hinge pins at the horizontal stabilizer center section.
- G. Corrosion has been found 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, were found at several locations along the beam between elevator stations 23 and 213. Corrosion is caused by water trapped in the unsealed seam.
- H. Corrosion has been found on the horizontal stabilizer pivot pins.
- I. Corrosion has been found on the horizontal stabilizer attachment lugs.
- J. Stress corrosion can cause broken lower attach bolt on the RH horizontal stabilizer. The attach bolts are made of a special alloy steel.
- K. Corrosion has been found in the stabilizer center section attach fittings. The deepest corrosion was found on gap between the two flanged bushings in the lug holes. Corrosion spots can also occur on the lug faces.
- L. 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.
- M. Corrosion can occur on the elevator balance panels and similar structure to the elevator front spar.
- N. Corrosion can occur between elevator nose skins and hinge fittings for elevator balance panels, and between hinge halves and adjacent faying structure.
- O. 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) 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.
- (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.
- (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.

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- (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.
- (5) If there is indication of 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) Inspect trailing edge skin panels for delamination and the moisture. Moisture accumulation could cause corrosion on the aluminum sub-structure and possible skin panel delamination. Accumulations of water may be detected radio-graphically.

**B. References**

<b>Reference</b>	<b>Title</b>
51-21-31 P/B 701	CORROSION REMOVAL AND CONTROL - CLEANING/PAINTING
51-21-91 P/B 701	CORROSION INHIBITING COMPOUND - CLEANING/PAINTING
51-31-00-390-806	Aerodynamic Smoother Application (P/B 201)

**C. Consumable Materials**

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

**D. Location Zones**

<b>Zone</b>	<b>Area</b>
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 first opportunity consistent with the scheduled maintenance activity, apply corrosion prevention treatment to the horizontal stabilizer.

SUBTASK 55-10-00-200-001

- (2) Periodically inspect the stabilizer for damaged finish and evidence of corrosion.

SUBTASK 55-10-00-200-002

- (3) Restore any damaged finish at the next maintenance opportunity.
  - (a) Apply water displacing corrosion inhibiting compound as the temporary corrosion protection meanwhile.
  - (b) On skin surfaces, apply corrosion inhibitor to rivet heads and panel edges where the paint has cracked or flaked and after 30 minutes wipe off the excess with a clean, dry rag.

SUBTASK 55-10-00-370-002

- (4) Apply water displacing corrosion inhibiting compound annually to the aft side of the rear spar cavity.
  - (a) Pay particular attention to attachment points and faying surfaces.

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SUBTASK 55-10-00-370-003

- (5) Apply water displacing corrosion inhibiting compound annually to the fastener heads and skin joint on the upper and lower surfaces at the rear spar.
- (a) Wipe off the excess with a clean, dry rag after a minimum of 30 minutes.

SUBTASK 55-10-00-370-004

- (6) Apply water displacing corrosion inhibiting compound annually to jackscrew support truss with particular attention to attachment points.
- (a) Do not apply the compound on the jackscrew.

SUBTASK 55-10-00-370-005

- (7) Every 2 years, 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) Pay particular attention 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) Apply water displacing corrosion inhibiting compound annually to exposed areas of the elevator spar, with particular attention to the 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) Apply water displacing corrosion inhibiting compound annually 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 sealant, A02315, fillet seal around the trailing edge panels (TASK 51-31-00-390-806).

SUBTASK 55-10-00-200-003

- (12) Frequency of Application:

- (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.

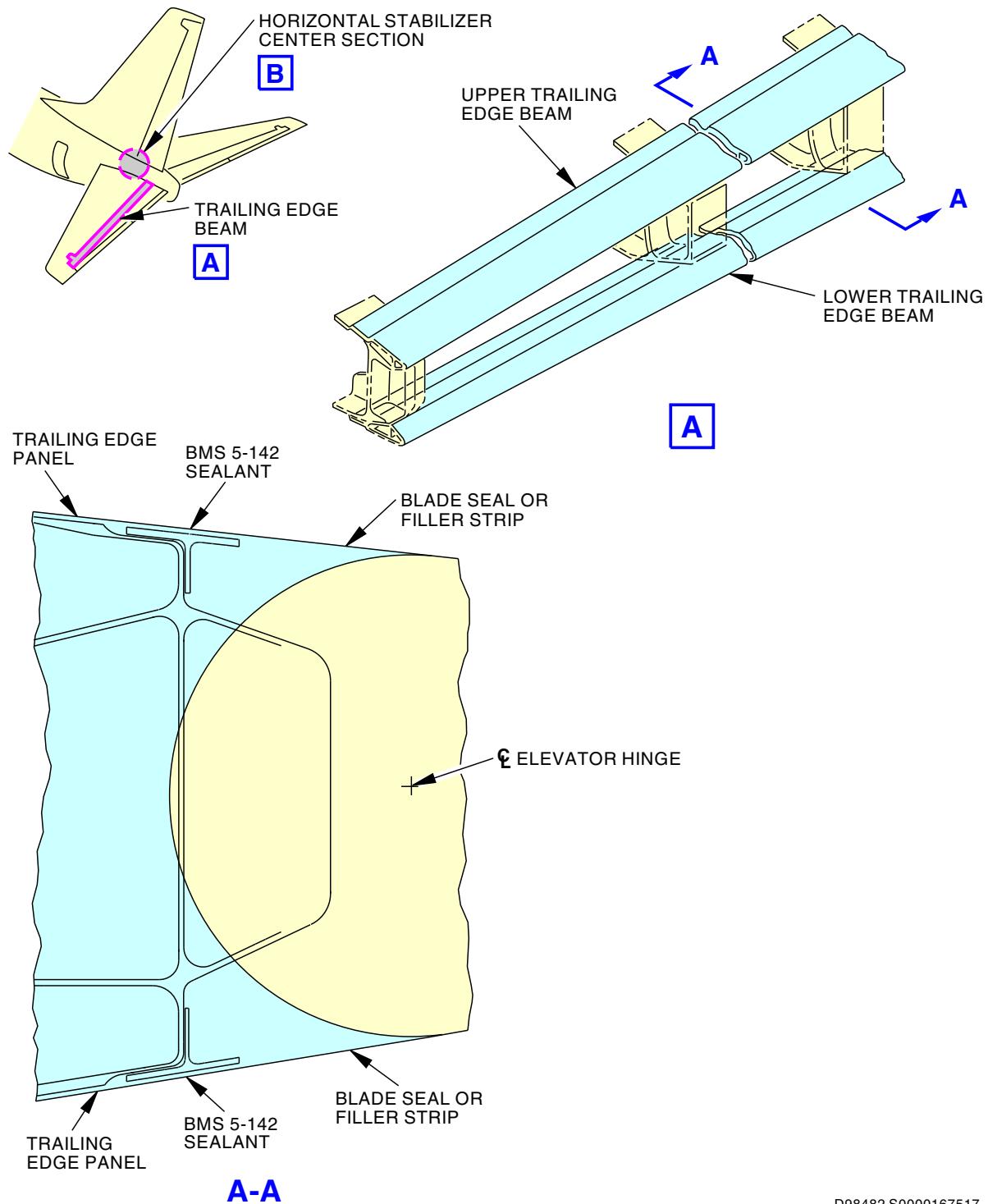
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Horizontal Stabilizer - Corrosion Prevention  
Figure 201/55-10-00-990-801 (Sheet 1 of 2)

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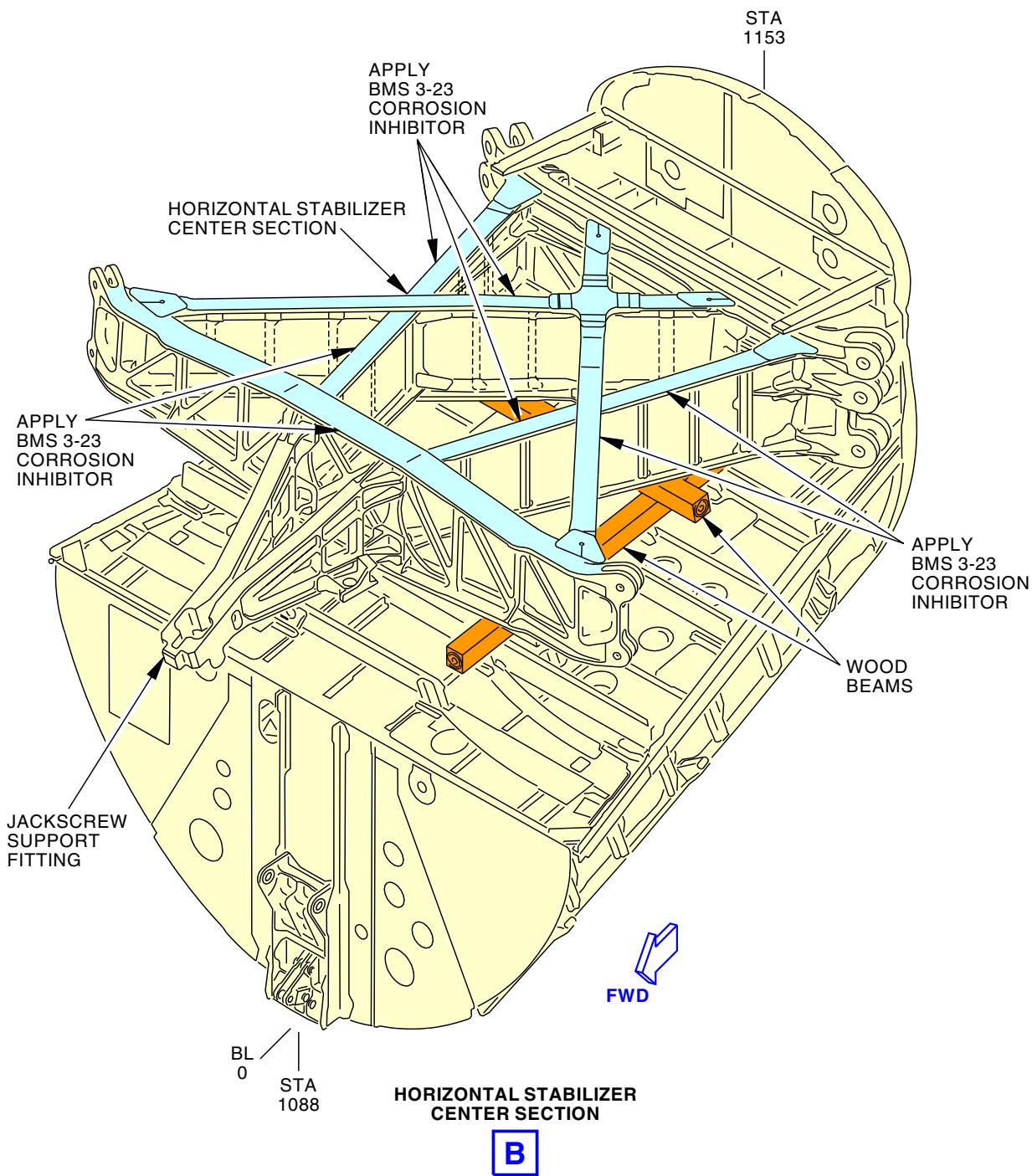
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Horizontal Stabilizer - Corrosion Prevention  
Figure 201/55-10-00-990-801 (Sheet 2 of 2)

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LEADING EDGE ACCESS PANELS - MAINTENANCE PRACTICES

**1. General**

- A. There are access panels aft of the leading edge which gives access to the wing forward spar.

**TASK 55-10-00-200-802**

**2. Guidelines for Missing Fasteners in the Horizontal Stabilizer Leading Edge Panels**

**A. General**

- (1) This procedure gives the task guidelines for missing fasteners from the Horizontal Stabilizer Leading Edge panels.

**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. Procedure**

SUBTASK 55-10-00-860-001

- (1) To find the applicable Horizontal Stabilizer Leading Edge panel, refer to Finding an Access Door or Panel in the Empennage, TASK 06-42-00-800-801.

SUBTASK 55-10-00-211-001

- (2) Make sure that the Horizontal Stabilizer Leading Edge panels meet these guidelines:
- One bolt can be missing from a panel if the panel has six to twelve bolts to keep the panel on the airplane.
  - Two bolts can be missing from a panel if the panel has more than twelve bolts to keep the panel on the airplane.
- 1) The two missing bolts must not be adjacent to each other.

SUBTASK 55-10-00-211-002

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

SUBTASK 55-10-00-420-001

- (4) To install the bolts with the applicable torques, refer to Standard Torque Values, TASK 20-50-11-910-801.

———— END OF TASK ————

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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	REPAIR 10 - Horizontal Stabilizer Trailing Edge Panel Conductive Strip

**B. Repair the Conductive Strip**

SUBTASK 55-10-01-300-001

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

———— END OF TASK ————

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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
24-22-00-860-812	Remove Electrical Power (P/B 201)
27-41-31-000-802	Horizontal Stabilizer Center Section Hinge Fitting Removal (P/B 401)
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	Lock Assembly - 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 CUTOUT position.

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

**SUBTASK 55-10-10-860-003**

- (3) Do this task: Remove Electrical Power, TASK 24-22-00-860-812.

**SUBTASK 55-10-10-860-004**

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

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SUBTASK 55-10-10-480-002

- (5) Install the lock assembly, SPL-1672 on the stabilizer trim wheel at the control stand (Horizontal Stabilizer Center Section Hinge Fitting Removal, TASK 27-41-31-000-802):
- Turn the trim wheel to put the handle at the top of the wheel.
  - Adjust the height of the trim lock to put the trim wheel handle correctly on the yoke.
  - Install the pin through the yoke.
  - Install the safety pin.

SUBTASK 55-10-10-010-001

- (6) Open this access panel:

(Figure 401)

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

SUBTASK 55-10-10-480-001

- (7) Install suitable wood beams to support the center section at approximately any horizontal position, (Figure 402).

**F. Remove the Thrust Brace Links**

SUBTASK 55-10-10-020-001

- (1) Disconnect the upper inboard end, (Figure 401).
- Remove the cotter pin [6] and nut [5].
  - Remove the two washers [7], the washer [4], and the bolt [3].
  - Discard the two washers [7].
  - Disconnect the thrust brace link [1] from the center section fitting.

SUBTASK 55-10-10-020-002

- (2) Disconnect the lower inboard end, (Figure 401).
- Remove the cotter pin [6] and nut [5].
  - Remove the two washers [7], the washer [4], and the bolt [8].
  - Discard the two washers [7].
  - Disconnect the thrust brace link [2] from the center section fitting.

SUBTASK 55-10-10-020-003

- (3) Disconnect the upper outboard end.
- Remove the cotter pin [6] and nut [5].
  - Remove the two washers [7], the washer [4], and the bolt [3].
  - Discard the two washers [7].
  - Remove thrust brace link [1] from the fitting.

SUBTASK 55-10-10-020-004

- (4) Disconnect the lower outboard end.
- Remove the cotter pin [6] and the nut [5].
  - Remove the two washers [7], the washers [4], and the bolt [3].
  - Discard the two washers [7].

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- (d) Remove thrust brace link [2] from the fitting.

———— END OF TASK ————

**TASK 55-10-10-400-801**

**3. Thrust Brace Link Installation**

(Figure 401, Figure 402, Figure 403)

**A. References**

Reference	Title
24-22-00-860-811	Supply Electrical Power (P/B 201)
27-41-31-400-802	Horizontal Stabilizer Center Section Hinge Fitting Installation (P/B 401)
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	Lock Assembly - Stabilizer Trim Part #: F71336-501 Supplier: 81205

**C. Consumable Materials**

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

**D. Location Zones**

Zone	Area
300	Empennage

**E. Access Panels**

Number	Name/Location
311BL	Stabilizer Trim Access Door

**F. Install the Thrust Brace Links**

**SUBTASK 55-10-10-420-005**

- (1) Connect the lower inboard end, (Figure 401).

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

- 1) Apply grease, D00633 to the shank and thread of bolt [8].
- 2) Install the two washers [7], the bolt [8] and the washer [4].

NOTE: The two washers [7] should be new washers.

- 3) Install the nut [5] and the cotter pin [6].

- a) Tighten the nut [5] to 440-540 pound-inches (49.7-61.0 Nm).

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 obtain cotter pin hole alignment, but do not exceed 650 pound-inches (73.4 Nm).

**SUBTASK 55-10-10-420-001**

- (2) Connect the upper inboard end.

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- (a) Install the thrust brace link [1] to the center section fitting.
- 1) Apply grease, D00633 to the shank and thread of bolt [3].
  - 2) Install the two washers [7], the bolt [3] and the washer [4].  
NOTE: The two washers [7] should be new washers.
  - 3) Install the nut [5] and the cotter pin [6].
    - a) Tighten nut [5] to 440-540 pound-inches (49.7-61.0 Nm).  
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 obtain cotter pin hole alignment, but do not exceed 650 pound-inches (73.4 Nm).

SUBTASK 55-10-10-420-006

- (3) Connect the lower outboard end.
- (a) Install the thrust brace link [2] to the fitting.
- 1) Apply grease, D00633 to the shank and thread of bolt [3].
  - 2) Install the two washers [7], the bolt [3], and the washer [4].  
NOTE: The two washers [7] should be new washers.
  - 3) Install the cotter pin [6] and the nut [5].
    - a) Tighten the nut [5] to 440-540 pound-inches (49.7-61.0 Nm).  
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 obtain cotter pin hole alignment, but do not exceed 650 pound-inches (73.4 Nm).

SUBTASK 55-10-10-420-003

- (4) Connect the upper outboard end.
- (a) Install the thrust brace link [1] to the fitting.
- 1) Apply grease, D00633 to the shank and thread of bolt [3].
  - 2) Install the two washers [7], the bolt [3], and the washer [4].  
NOTE: The two washers [7] should be new washers.
  - 3) Install the cotter pin [6] and the nut [5].
    - a) Tighten the nut [5] to 440-540 pound-inches (49.7-61.0 Nm).  
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 obtain cotter pin hole alignment, but do not exceed 650 pound-inches (73.4 Nm).

SUBTASK 55-10-10-080-002

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

SUBTASK 55-10-10-080-003

- | (6) Remove the lock assembly, SPL-1672 from the stabilizer trim wheel at the control stand, (Horizontal Stabilizer Center Section Hinge Fitting Installation, TASK 27-41-31-400-802).

SUBTASK 55-10-10-860-005

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

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SUBTASK 55-10-10-410-002

- (8) Close this access panel:

(Figure 401)

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

SUBTASK 55-10-10-860-006

- (9) Do this task: Supply Electrical Power, TASK 24-22-00-860-811.

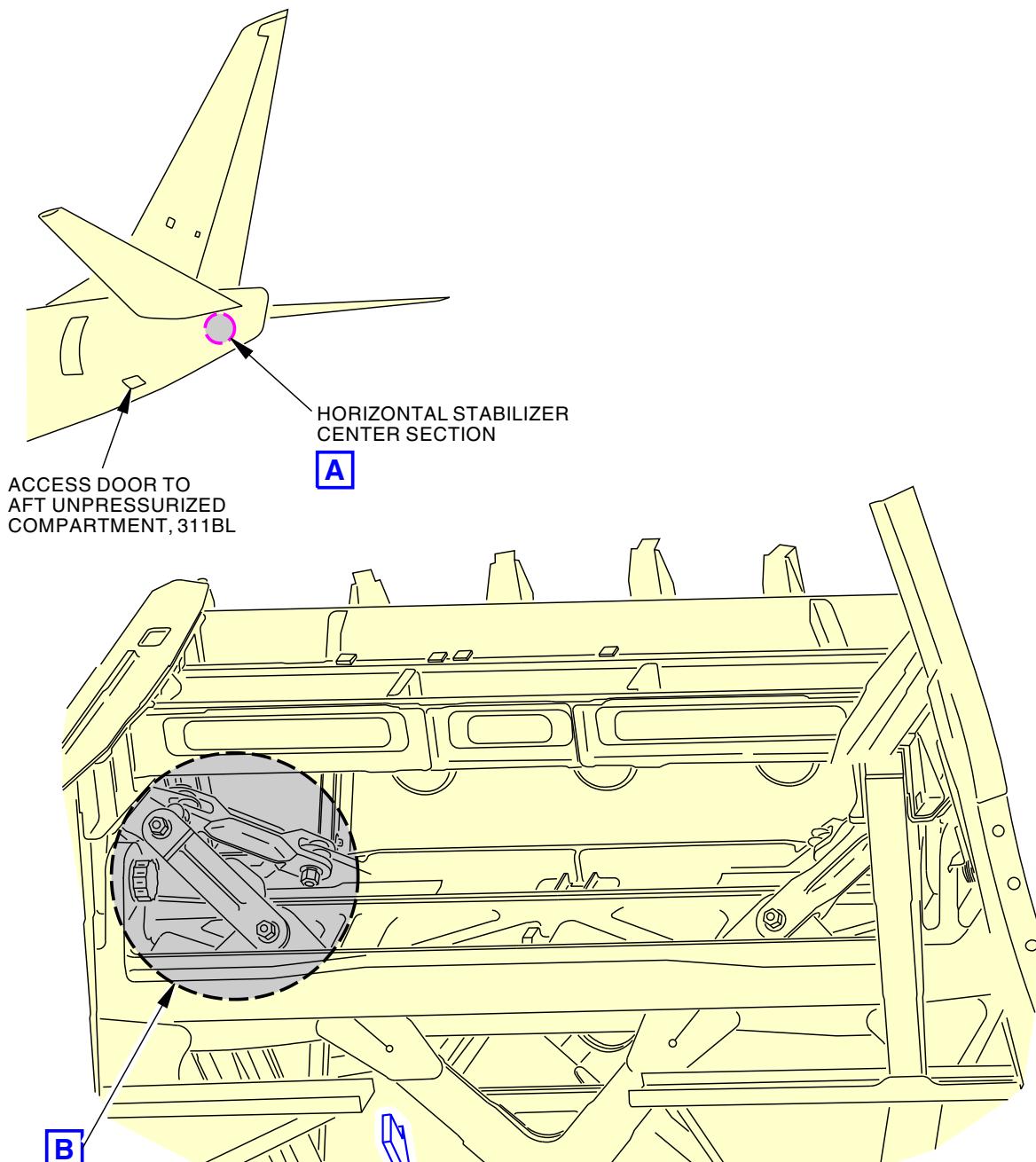
SUBTASK 55-10-10-860-007

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

———— END OF TASK ————

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HORIZONTAL STABILIZER CENTER SECTION

**A**

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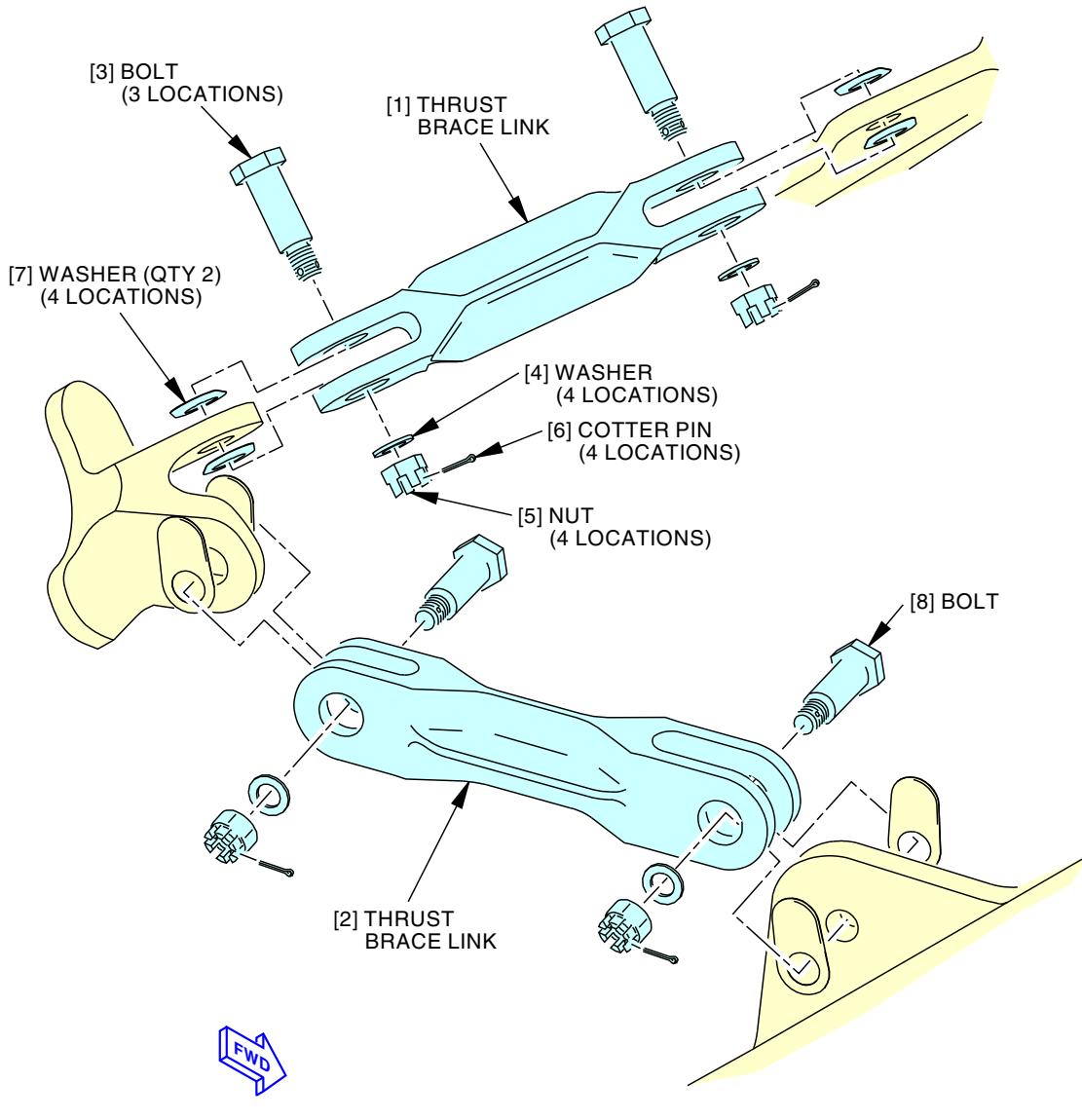
**Thrust Brace Links Installation**  
Figure 401/55-10-10-990-801 (Sheet 1 of 2)EFFECTIVITY  
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Thrust Brace Links Installation  
Figure 401/55-10-10-990-801 (Sheet 2 of 2)

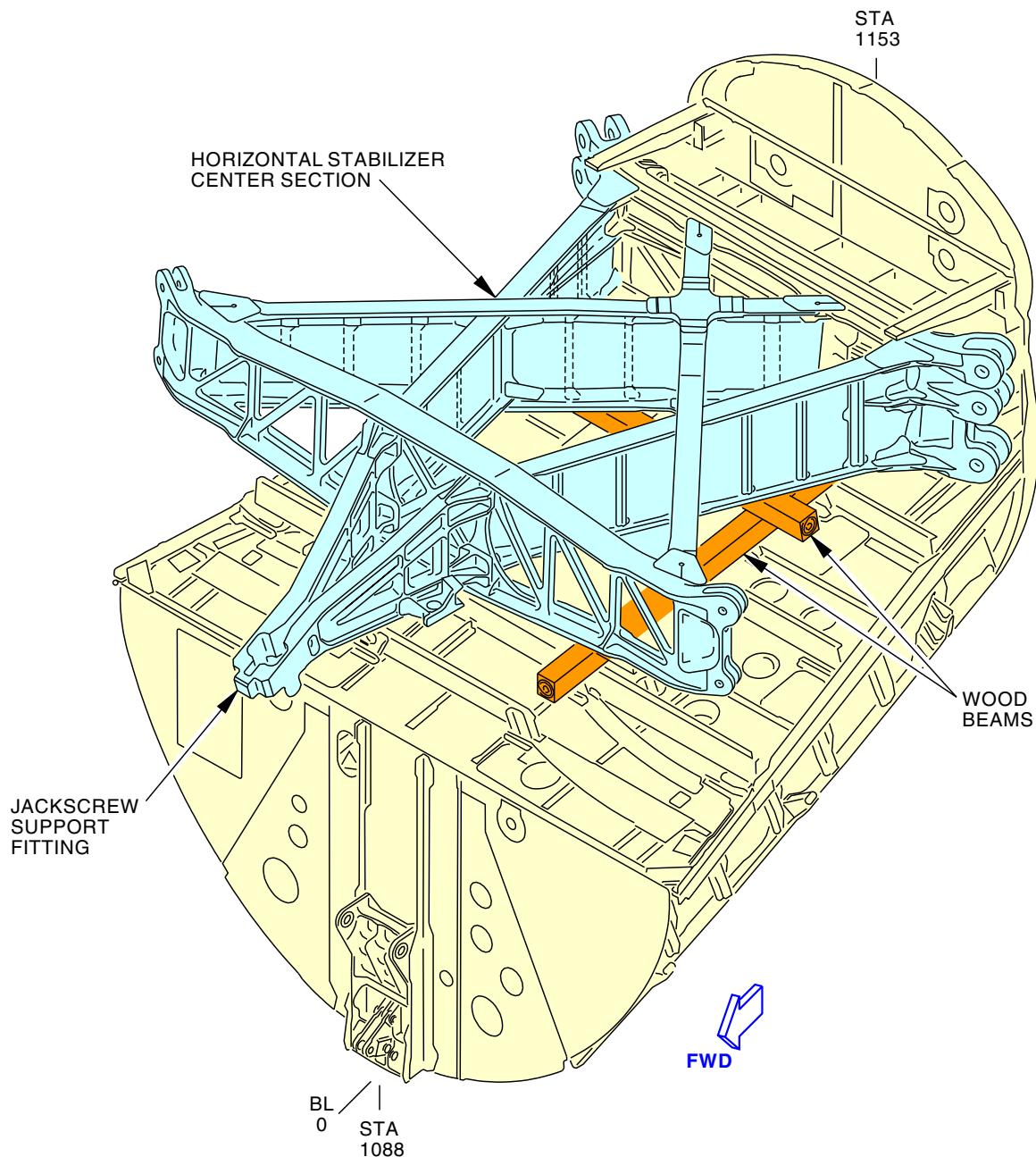
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**Horizontal Stabilizer Center Section Installation  
Figure 402/55-10-10-990-802**

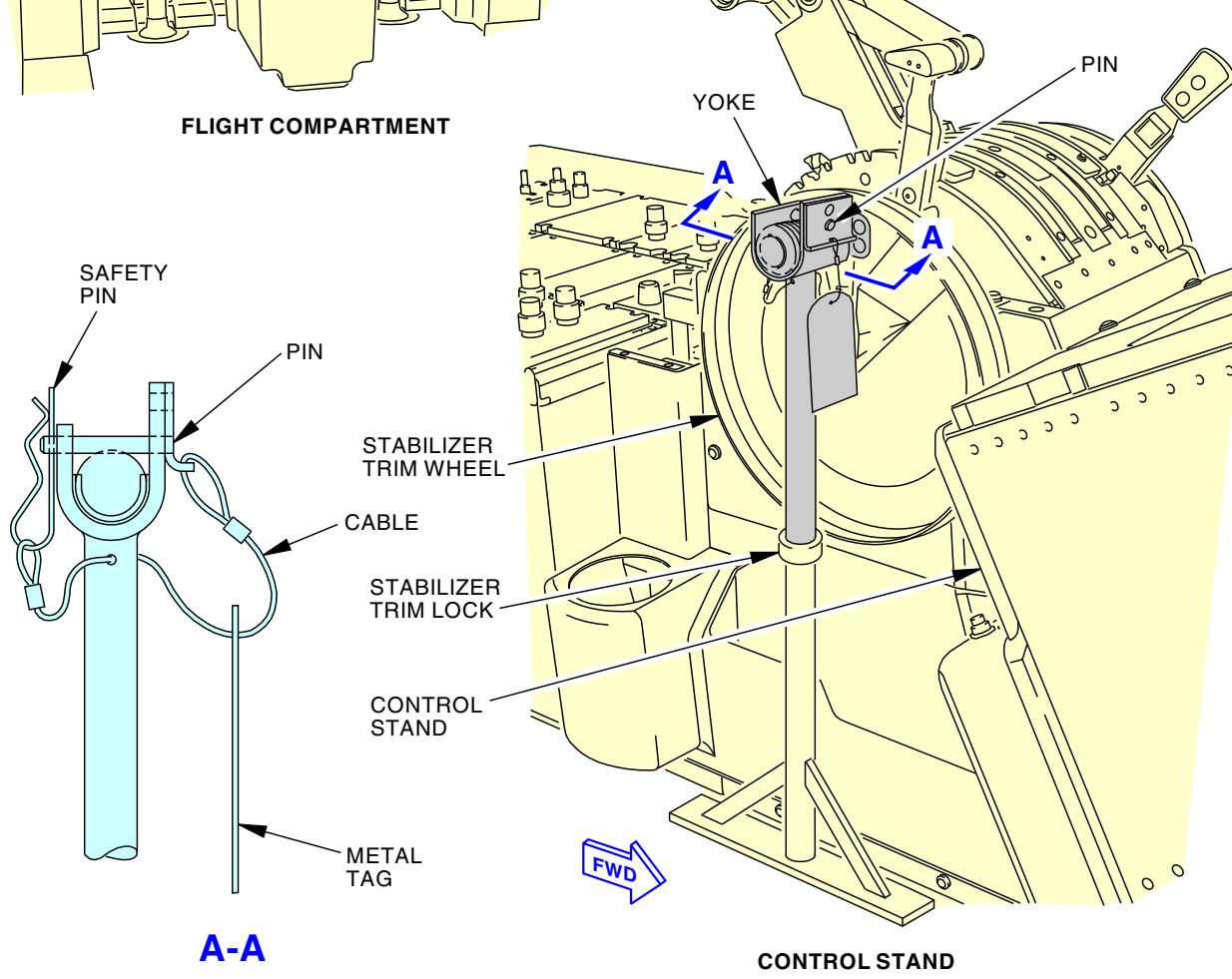
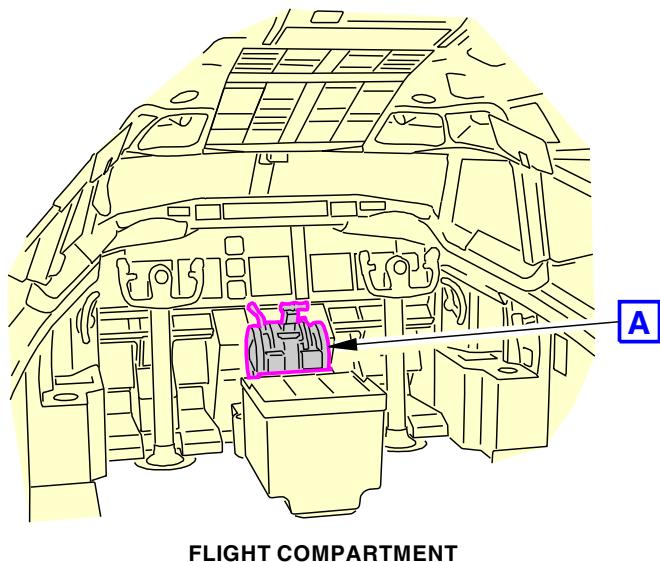
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**Stabilizer Trim Lock Installation  
Figure 403/55-10-10-990-803**

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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
51-31-00-160-801	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 Procedure**

**SUBTASK 55-10-11-020-002**

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

NOTE: You can remove a section of the fillet seal (TASK 51-31-00-160-801).

**SUBTASK 55-10-11-020-001**

- (2) Do these steps to remove the applicable panels:

NOTE: Hold the panel until all the fasteners have been removed.

- (a) Tag the fasteners with their location for later installation.
- (b) Left side panels:

- 1) Remove the fasteners for these 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

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(Continued)

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

(c) Right side panels:

- 1) Remove the fasteners for these panels:

<b>Number</b>	<b>Name/Location</b>
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.

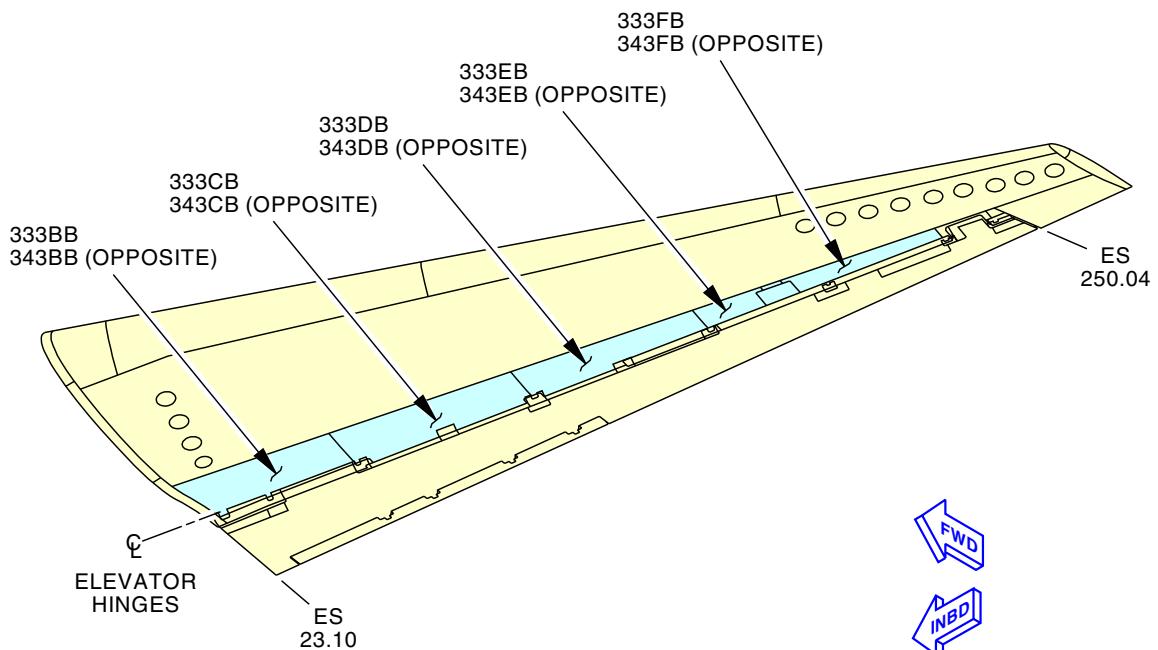
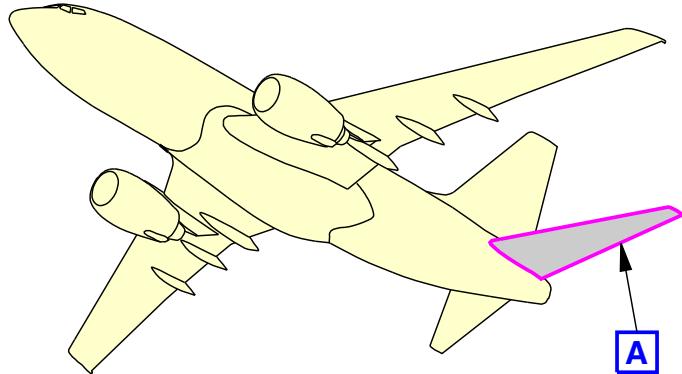
———— END OF TASK ————

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LEFT SIDE SHOWN  
(RIGHT SIDE IS OPPOSITE)



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

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**TASK 55-10-11-400-801**

**3. Balance Bay Panels Installation**

(Figure 401)

**A. References**

Reference	Title
51-31-00-390-806	Aerodynamic Smoother Application (P/B 201)
51-31-00-390-810	Removable Faying (Mated) Surface Seal Application (P/B 201)
SRM 51-20-01	Structural Repair Manual
SWPM 20-20-00 Paragraph 19	Electrical Bonding of Fasteners to Conductive Finishes on Composites

**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
C50413	Coating - Chemical And Solvent Resistant Finish - (BAC 452 Green)	BMS 10-11 Type I Class A
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 - BAC5000 Frekote 710-NC Mold Release)	
G50335	Agent - Non-Peelable Parting (Henkel Loctite - BAC5000 Frekote 44-NC Mold Release).	
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

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Reference	Description	Specification
G50636	Lubricant - PTFE Release Agent - Miller-Stephenson MS-122RA (use until stock depleted)	
G50711	Agent - Non-Peelable Parting (Henkel Loctite - BAC5000 Frekote 48-NC Mold Release).	
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 (SRM 51-20-01).

SUBTASK 55-10-11-370-002

- (2) For the removable fasteners except at the grounding fastener locations, do these steps:
  - (a) Apply coating, G50961, or coating, C50413, (as applicable) 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 Removable Faying (Mated) Surface Seal Application, TASK 51-31-00-390-810.

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- 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
  - <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 damage to the sealant, remove the sealant or if the sealant does not exist.
  - a) Install the panel and apply sealant, A00247, (Removable Faying (Mated) Surface Seal Application, TASK 51-31-00-390-810).
  - b) Make sure each fastener is installed in the correct location.
  - c) Install and do an electrical bonding check (SWPM 20-20-00 Paragraph 19) for each applicable fastener.
- 3) 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
- 4) 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
- 5) Apply sealant, A02315, after installation as necessary (Aerodynamic Smoother Application, TASK 51-31-00-390-806).

———— END OF TASK ————

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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

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- (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 ——

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**VERTICAL STABILIZER (FIN) - REMOVAL/INSTALLATION**

**1. General**

- A. There are two tasks in this procedure. There is one task for the removal and one task for the installation of the vertical stabilizer. You must do these tasks in a hangar.
- (1) The removal procedure has these parts:
- (a) The removal of the access panels
  - (b) The installation of the lock-rudder, PCU removed
  - (c) The removal of the rudder control cables
  - (d) The installation of the sling assembly
  - (e) The removal of the vertical fin.
- (2) The installation procedure has these parts:
- (a) The installation of the vertical fin
  - (b) The removal of the sling assembly
  - (c) The installation of the rudder control cables
  - (d) The removal of the lock-rudder, PCU removed
  - (e) An adjustment of the rudder
  - (f) The installation of the access panels.

**TASK 55-30-00-000-801**

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

(Figure 401, Figure 402)

**A. References**

Reference	Title
06-42-00-800-801	Finding an Access Door or Panel in the Empennage (P/B 201)
23-11-61-000-801	HF Antenna Coupler - Removal (P/B 401)
27-21-00-800-802	Pressure from the Rudder Hydraulic Systems A, B, and Standby - Deactivation (P/B 201)
27-21-91-000-803-002	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	Structural Repair Manual

**B. Tools/Equipment**

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

Reference	Description
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
SPL-24233	Thread Protector - Attach Bolt, Vertical Stabilizer Part #: C55017-1 Supplier: 81205

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**C. Location Zones**

<b>Zone</b>	<b>Area</b>
300	Empennage

**D. Access Panels**

<b>Number</b>	<b>Name/Location</b>
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

**E. Prepare for the Removal.**

SUBTASK 55-30-00-860-001

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

**CAPT Electrical System Panel, P18-1**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
A	1	C01374	RADIO NAVIGATION VOR/MKR BCN 1

**CAPT Electrical System Panel, P18-2**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-431, 433, 434, 437-447, 450-999			
E	11	C00839	COMMUNICATIONS HF 1

**F/O Electrical System Panel, P6-1**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
LOM ALL			
A	12	C01375	RADIO NAVIGATION VOR 2
LOM 404, 412, 415, 416, 422-426, 433, 434, 439-445, 451-454, 457, 464-999			
D	2	C00857	COMMUNICATIONS HF 2

**LOM ALL**

These circuit breakers are inoperative and should remain open:

**CAPT Electrical System Panel, P18-2**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
LOM 432			
E	11	C00839	COMMUNICATIONS HF 1 (INOP)

**F/O Electrical System Panel, P6-1**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
LOM 402, 406, 407, 411, 420, 427-432, 437, 438, 446, 447, 450, 455, 456, 458-463			
D	2	C00857	COMMUNICATIONS HF 2 (INOP)

**LOM ALL**

SUBTASK 55-30-00-020-001

- (2) Do this task: HF Antenna Coupler - Removal, TASK 23-11-61-000-801.



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SUBTASK 55-30-00-860-002



## WARNING

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.

- (3) 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

- (4) To open the vertical fin access door, do this task: Finding an Access Door or Panel in the Empennage, TASK 06-42-00-800-801.

- (a) Open these access panels:

<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

- (5) Do this task: Main Rudder Power Control Unit Removal, TASK 27-21-91-000-803-002  
(6) Install a lock-rudder, PCU removed lock, SPL-1727 with a warning streamer.

## F. Remove the Vertical Fin.

SUBTASK 55-30-00-020-002

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

SUBTASK 55-30-00-020-003

- (2) Disconnect the electrical wires.

- (a) Disconnect the VOR and HF cables, as applicable, 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.

NOTE: Install tags on lines and port fittings to clearly show the correct connection location. See Elevator Feel Computer - Removal, TASK 27-31-37-000-801 for instructions on correct tubing removal.

SUBTASK 55-30-00-020-004

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

SUBTASK 55-30-00-020-005

- (5) Disconnect the rudder control cables.

- (a) Move the rudder trim indicator in the control cabin to NEUTRAL.  
(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 55-30-00-480-003

- (6) Install the sling equipment, SPL-2032, by the following steps:

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- (a) Install the three sling attach fittings to the applicable sides of the vertical fin, (Figure 401).
- NOTE: Determine on which side you will put down the vertical fin. This will show which side of the vertical fin 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 skin at the three applicable lift fitting locations.
  - 2) Install the lift fittings with the accompanying bolts.
    - a) Add washers to lift fitting bolts, if bolts are too long.
    - b) Tighten fasteners to 25 in-lb (2.8 N·m).
- (b) Attach the sling assembly to the crane.
- (c) At lift fitting #1 on both sides of the vertical fin, connect 50 ft (15 m) length of 3/8 to 1/2 inch (9.5 to 12 mm) braided nylon rope.
- NOTE: This rope will be a tether line.
- (d) Put the sling assembly in its position.
- (e) Connect the sling to the lift fittings on the vertical fin.
- (f) Tighten the sling assembly to decrease the load on the fin attachment bolts.

SUBTASK 55-30-00-020-006

- (7) Remove the vertical fin, (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 to inspect them, remove one bolt at a time to keep the fin aligned.
  - 2) Remove the cotter pin [22], self-locking nut [21], bolt [16], washer [20], washers [18], and washer [17] 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], washers [19], and washers [28] from the outboard rear spar fitting.

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

NOTE: If you remove the bolts to inspect them, remove one bolt at a time to keep the fin aligned.
- (b) Remove the bolts and the fasteners of the front spar fittings:
- 1) Remove the cotter pins [5] from the front spar attach fittings.
  - 2) Remove the nuts [4], washers [2], washers [3], washers [6], and bolts [1] from the front spar attach fittings.
- NOTE: If you remove the bolts to inspect them, remove one bolt at a time to keep the fin aligned.
- a) If necessary, use a thread protector, SPL-24233 to remove bolts [1].

NOTE: The use of thread protectors, SPL-24233 are optional.
- (c) Lift the vertical fin from the airplane. Make sure that there are no side loads on the sling lift fittings.

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- (d) Lower the crane hook #1 to lay the vertical fin down in a horizontal position.

NOTE: Use the tether lines to position the fin horizontally.

SUBTASK 55-30-00-950-001

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

SUBTASK 55-30-00-210-001

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

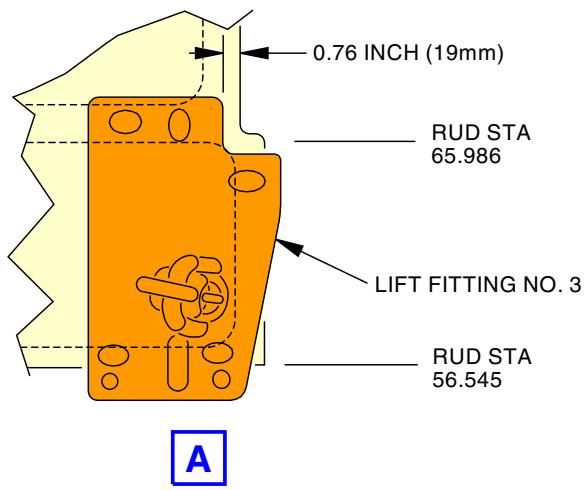
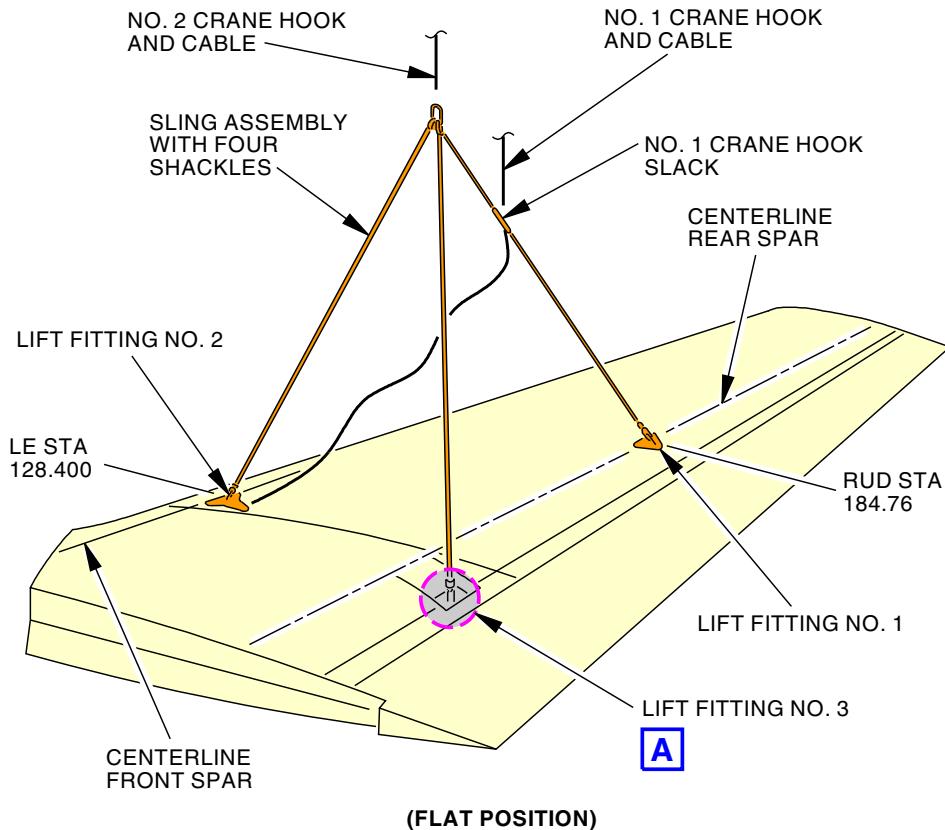
———— END OF TASK ————

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**Vertical Fin Sling Installation**  
**Figure 401/55-30-00-990-806 (Sheet 1 of 2)**

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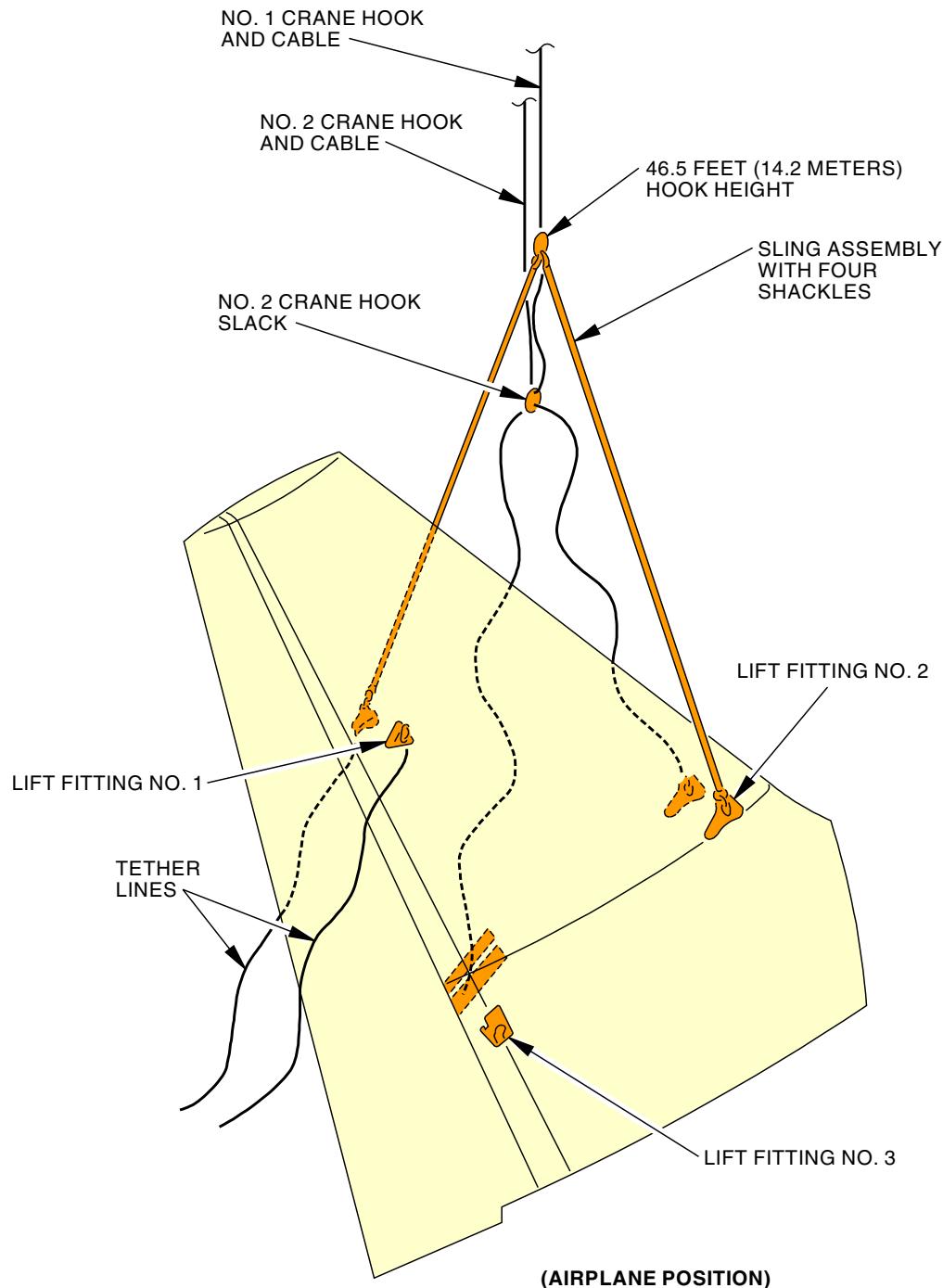
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Vertical Fin Sling Installation  
Figure 401/55-30-00-990-806 (Sheet 2 of 2)

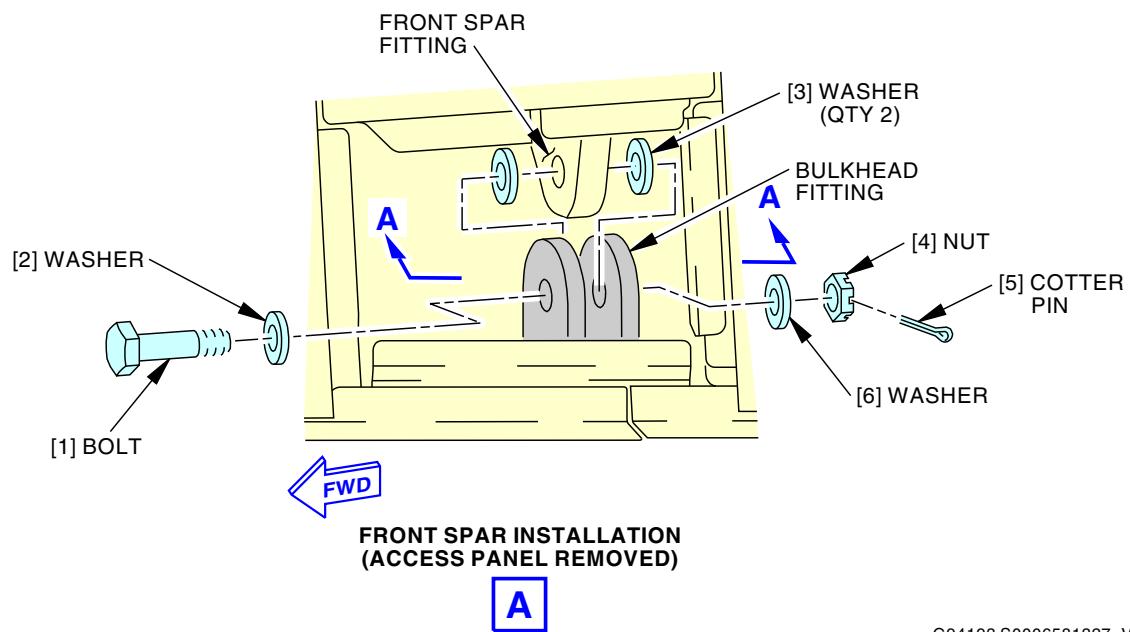
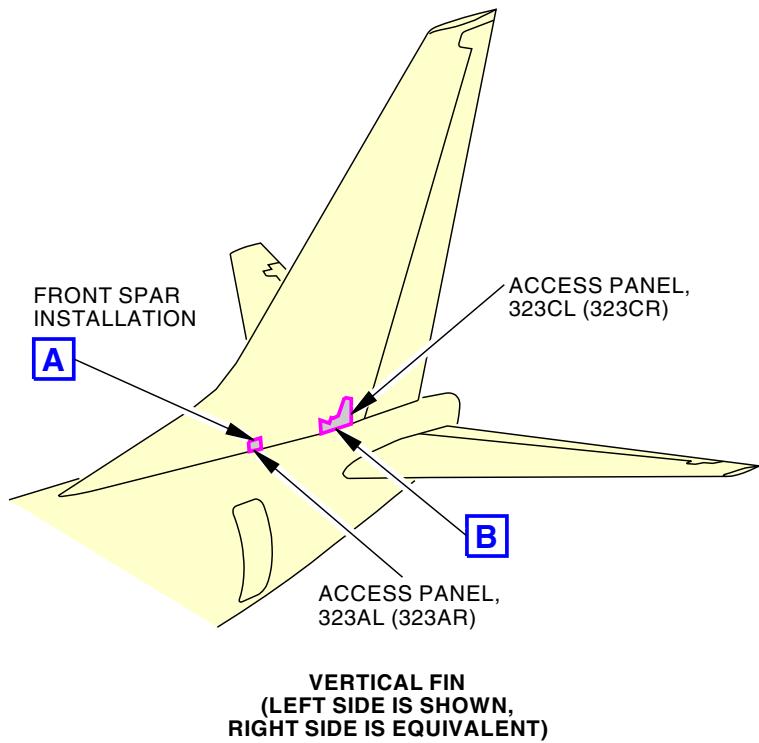
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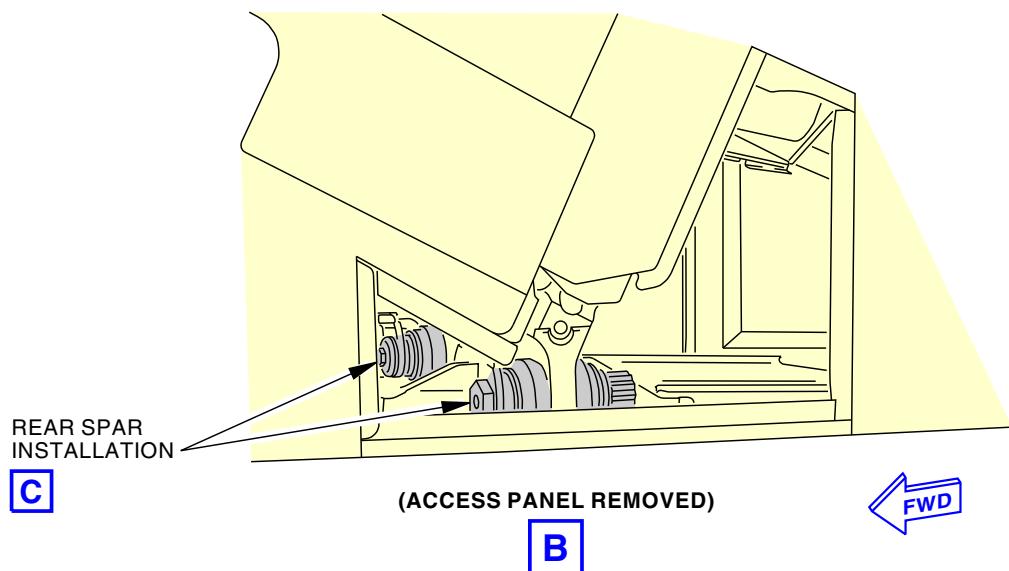
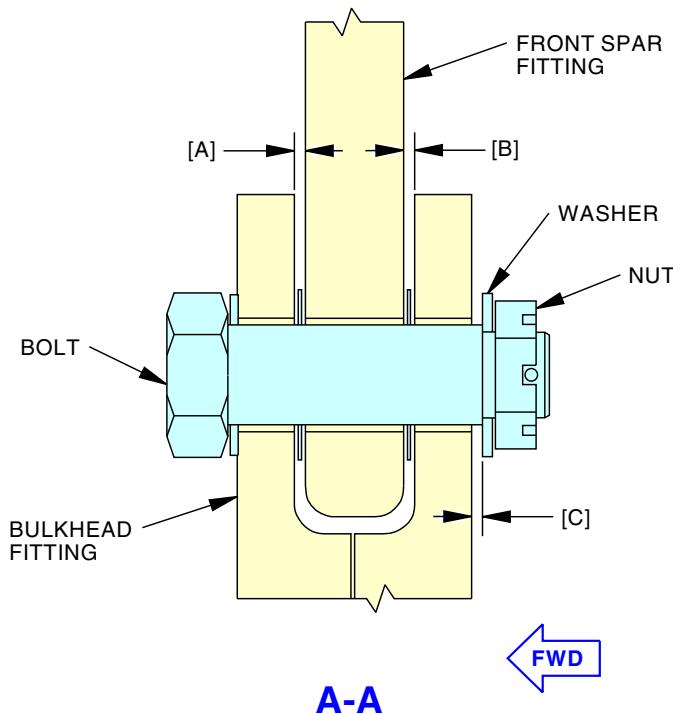
**Vertical Stabilizer (Fin) Installation**  
**Figure 402/55-30-00-990-807 (Sheet 1 of 4)**

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Vertical Stabilizer (Fin) Installation  
Figure 402/55-30-00-990-807 (Sheet 2 of 4)

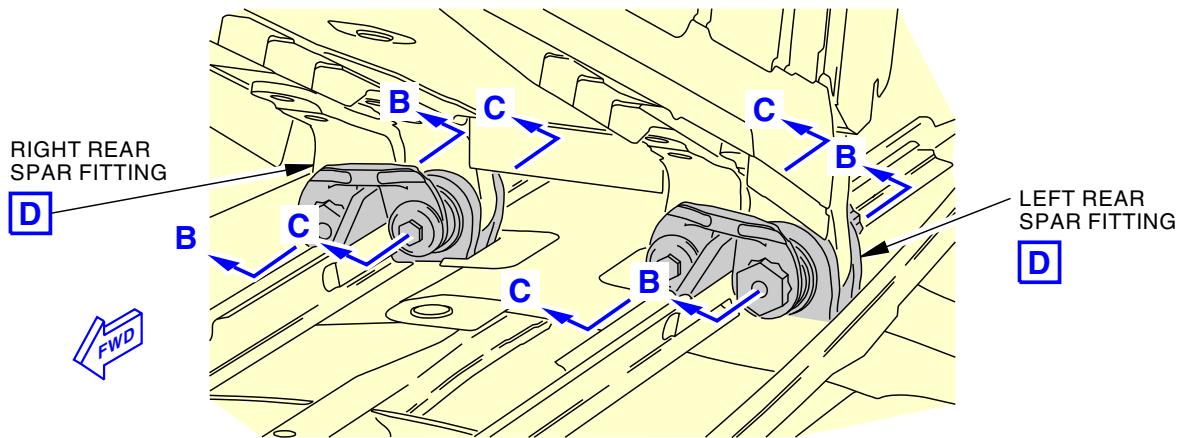
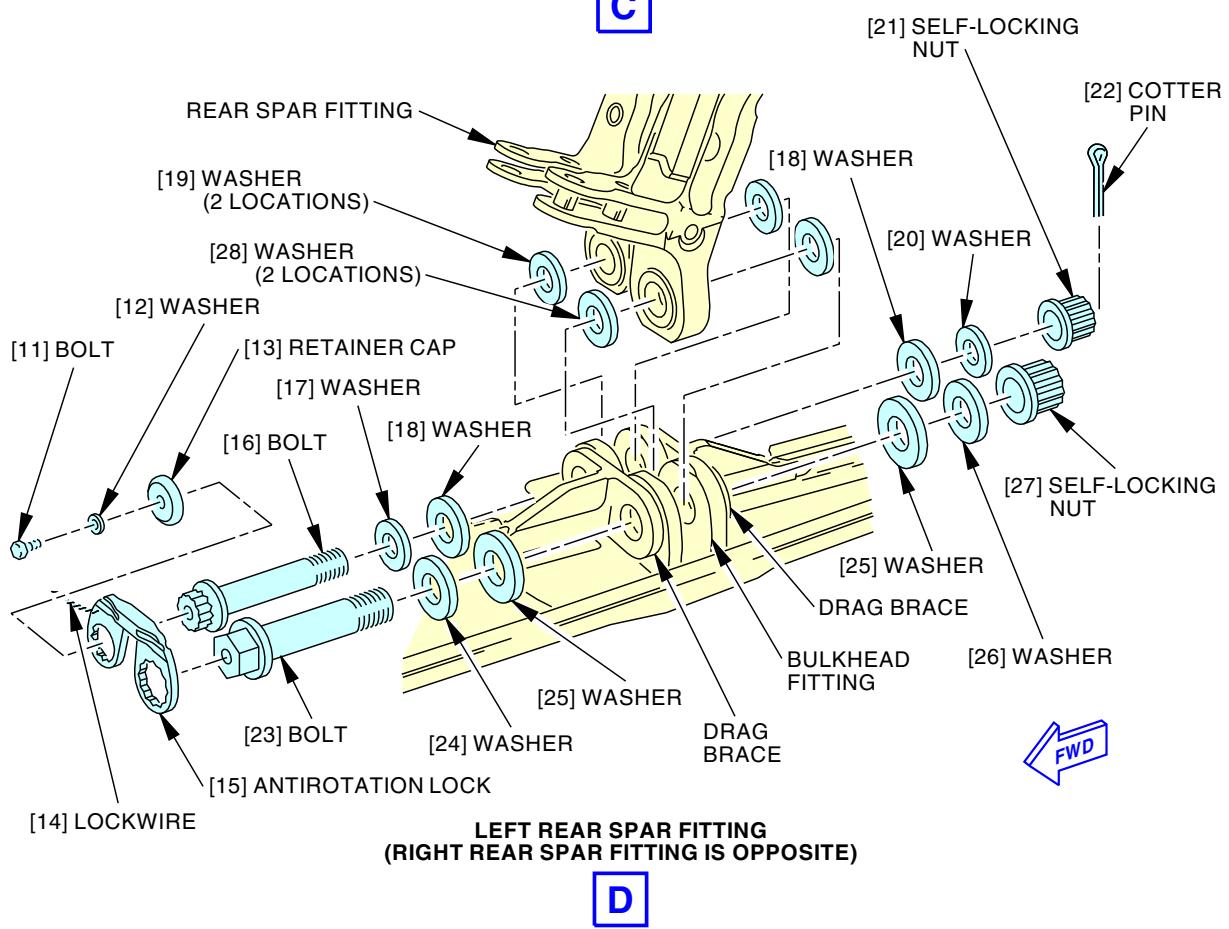
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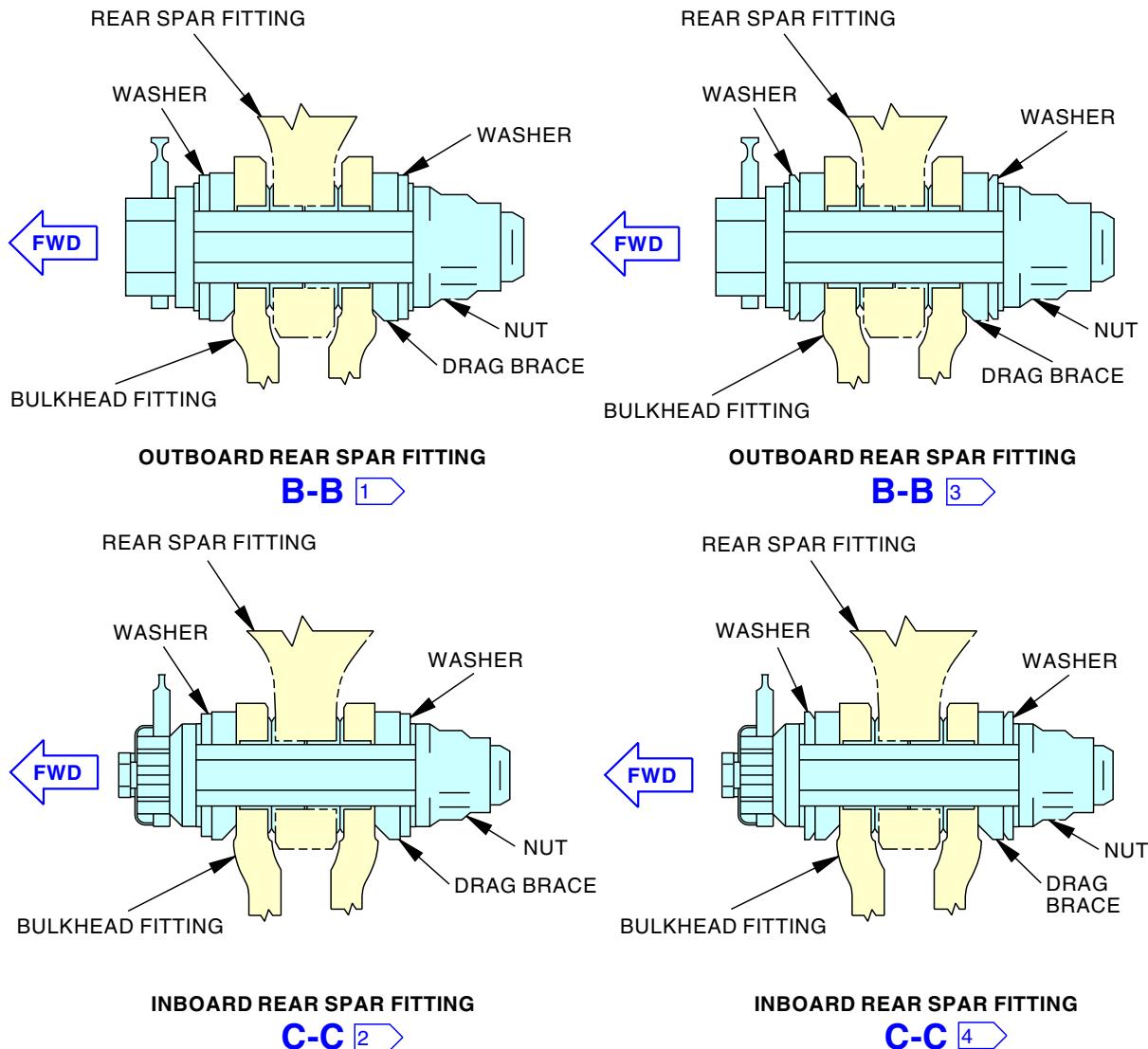

**REAR SPAR INSTALLATION**
**C**

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

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**Vertical Stabilizer (Fin) Installation**  
**Figure 402/55-30-00-990-807 (Sheet 3 of 4)**

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- 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.

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**Vertical Stabilizer (Fin) Installation**  
**Figure 402/55-30-00-990-807 (Sheet 4 of 4)**

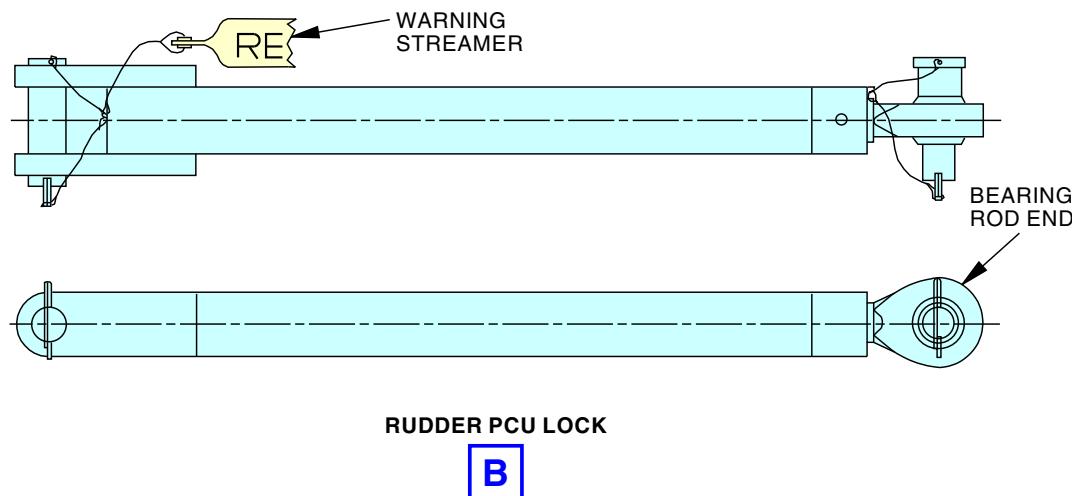
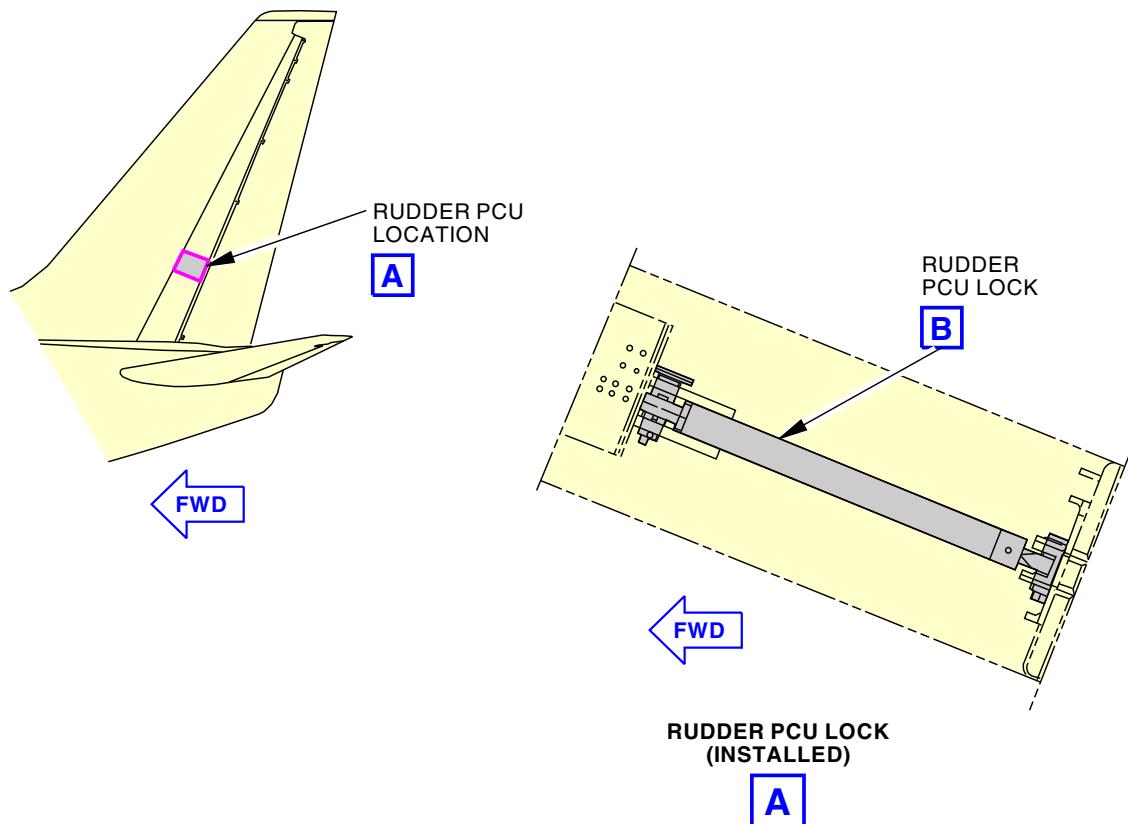
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LOCK-RUDDER PCU  
Figure 403/55-30-00-990-808

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**TASK 55-30-00-400-801**

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

(Figure 401, Figure 402)

**A. References**

Reference	Title
06-42-00-800-801	Finding an Access Door or Panel in the Empennage (P/B 201)
23-11-00-730-801	HF Communication System - System Test (P/B 501)
23-11-61-400-801	HF Antenna Coupler - Installation (P/B 401)
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)
27-21-00-820-808-002	Rudder Control Cables RA and RB Adjustment (P/B 501)
27-21-91-400-803-002	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)
SRM 51-10-01	Structural Repair Manual

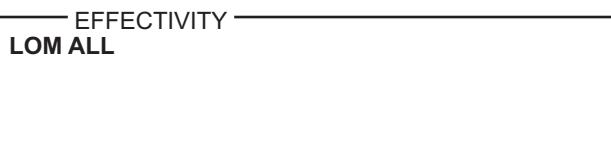
**B. Tools/Equipment**

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

Reference	Description
SPL-1727	Lock - Ground, Rudder, PCU Removed Part #: C27057-1 Supplier: 81205
SPL-2031	Alignment Tool - 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
SPL-24233	Thread Protector - Attach Bolt, Vertical Stabilizer Part #: C55017-1 Supplier: 81205

**C. Consumable Materials**

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
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
G50347	Lockwire - MS20995NC32, Monel - 0.032 Inch (0.8128 mm) Diameter	NASM20995



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D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
5	Cotter pin	55-30-00-26-005	LOM ALL
22	Cotter pin	55-30-00-26-055	LOM ALL

E. Location Zones

Zone	Area
300	Empennage

F. 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

G. 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 the vertical fin access doors (Figure 402).
  - (a) Open these 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

SUBTASK 55-30-00-160-001

- (3) Clean the bolts and bolt holes that attach the fin with solvent, B00083.

SUBTASK 55-30-00-480-004

- (4) Make sure that the lock-rudder, PCU removed lock, SPL-1727, with the warning streamer is installed.

H. Vertical Stabilizer (Fin) Installation

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 (Figure 401).

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- (a) Lift the fin into its position with the sling equipment, SPL-2032.

NOTE: Use the tether lines to control the position of the fin while moving it.

- 1) Rotate vertical fin from a horizontal position to a vertical position by lifting crane hook #1.

- (b) Use the alignment pin alignment tool, SPL-2031, to align the holes in the attachment fittings.

- (c) Install the bolts, washers, and nuts that attach the left and right hand sides of the vertical fin 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, only on the shank of bolt [16] and bolt [23].

- 3) Loosely install the bolt [16], bolt [23], self-locking nut [21], self-locking nut [27], washer [17], washers [18], washers [19], washer [20], washer [24], washers [25], washer [26], and washers [28].

NOTE: There may be one more washer [20] or washer [26] for grip length adjustment.

**LOM 442-447, 450-999**

- a) 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:

- <1> 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.

- <2> Apply anti-seize compound, D50004, to the washer [19] or washer [28] before installation.

**LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-441**

- b) If the clearance on one of the sides of the rear spar fitting is more than 0.007 in. (0.178 mm), add or remove shims from the washers [19] or washers [28].

NOTE: Only one washer is permitted on each side of the rear spar fitting.

**LOM ALL**

- c) Apply sealant, A00247, between the washers [18] and drag brace (Figure 402).

- d) Apply sealant, A00247, between the washers [25] and drag brace (Figure 402).

- 4) Tighten the rear spar bolts:

- a) On the inboard fitting (Figure 402), tighten the bolt [16] to 6500 in-lb (734.4 N·m) - 7500 in-lb (847.4 N·m).

- b) On the outboard fitting (Figure 402), tighten the bolt [23] to 7500 in-lb (847.4 N·m) - 8500 in-lb (960.4 N·m).

- 5) Install the cotter pin [22] in the inboard bolt [16] attach fitting.

- 6) Install the antirotation lock [15], retainer cap [13], washer [12], lockwire [14] (MS20995NC32 lockwire, G50347), and bolt [11].

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- a) Apply anti-seize compound, D50004, to the threads of the bolt [11] and threads on the bolt [16] head.
- b) Tighten bolt [11] to 660 in-lb (74.6 N·m) - 980 in-lb (110.7 N·m).
- (d) Apply a layer of the grease, D00633, only on the shank of the bolts [1] that attach the vertical fin at the front spar.  
NOTE: Apply grease only to the shank of the bolts.
- (e) Apply anti-seize compound, D50004, to the bolt threads and nut threads.
- (f) Install the two bolts [1], washers [2], washers [3], washers [6], and nuts [4] that attach the vertical fin to the fuselage at the front spar fittings.
  - 1) If it is necessary, use a thread protector, SPL-24233, to align holes and install bolts [1].  
NOTE: The use of thread protectors, SPL-24233, are optional.
  - 2) 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 401/55-30-00-993-802 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
[C]	A-A	0.015 in. (0.38 mm) minimum

NOTE: Align the nut with the cotter pin in the bolt.

- 3) Install the cotter pins [5].

**SUBTASK 55-30-00-420-002**

- (2) Attach the rudder flight control cables.
  - (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 55-30-00-020-007**

- (3) Do this task: HF Antenna Coupler - Installation, TASK 23-11-61-400-801.

**SUBTASK 55-30-00-410-003**

- (4) Connect the electrical cables.
  - (a) Connect the VOR cables, when it is necessary, in the jackscrew compartment above and aft of the pressure bulkhead.

**SUBTASK 55-30-00-420-005**

- (5) Connect the pitot lines to the elevator feel computer assembly.

NOTE: See Elevator Feel Computer - Installation, TASK 27-31-37-400-801 for instructions on correct tubing installation.

**SUBTASK 55-30-00-420-003**

- (6) Connect the rudder control cables at the rudder control power unit.

**SUBTASK 55-30-00-420-004**

- (7) Connect the hydraulic lines.



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SUBTASK 55-30-00-080-002

- (8) Remove the sling and lift fittings.  
(a) Install the bolts on the vertical fin skin at the three applicable lift fitting locations.

SUBTASK 55-30-00-080-003

- (9) Do this task: Main Rudder Power Control Unit Installation, TASK 27-21-91-400-803-002  
(Figure 403).  
(10) Remove the lock-rudder, PCU removed lock, SPL-1727, and warning streamer.

SUBTASK 55-30-00-860-004

- (11) Check 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

- (12) 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

- (13) Do this task: Rudder Control Cables RA and RB Adjustment, TASK 27-21-00-820-808-002.

SUBTASK 55-30-00-730-001

- (14) Do this task: VOR System - System Test, TASK 34-51-00-730-801.

**I. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-30-00-860-006

- (1) Close these circuit breakers:

**CAPT Electrical System Panel, P18-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
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>
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-431, 433, 434, 437-447, 450-999			
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>
LOM ALL			
A	12	C01375	RADIO NAVIGATION VOR 2
LOM 404, 412, 415, 416, 422-426, 433, 434, 439-445, 451-454, 457, 464-999			
D	2	C00857	COMMUNICATIONS HF 2

**LOM ALL**

These circuit breakers are inoperative and should remain open:

**CAPT Electrical System Panel, P18-2**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
LOM 432			
E	11	C00839	COMMUNICATIONS HF 1 (INOP)

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LOM 432 (Continued)

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
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LOM 402, 406, 407, 411, 420, 427-432, 437, 438, 446, 447, 450, 455, 456, 458-463	D	2	C00857 COMMUNICATIONS HF 2 (INOP)
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LOM ALL

SUBTASK 55-30-00-730-002

- (2) Do this task: HF Communication System - System Test, TASK 23-11-00-730-801.

SUBTASK 55-30-00-410-004

- (3) Close the vertical fin access doors, do this task: Finding an Access Door or Panel in the Empennage, TASK 06-42-00-800-801.  
(a) Close these access panels:

<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 55-30-00-390-001

- (4) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

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VERTICAL STABILIZER (FIN) - INSPECTION/CHECK

**1. General**

- A. There is one task in this procedure, an inspection and a check of the vertical stabilizer (fin). To do the inspection, you measure the inner and outer diameters of the bolts and bushings which attach the fin to the fuselage.
- B. If you do the inspection with the fin installed on the airplane, remove one bolt at a time. The alignment of the fin will not be changed.

**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 dimensions you measured, with the permitted dimensions shown in (Figure 601).
- (c) Repair or replace the parts which are not in the tolerance.

SUBTASK 55-30-00-410-005

- (3) Do this task: Vertical Stabilizer (Fin) Installation, TASK 55-30-00-400-801.

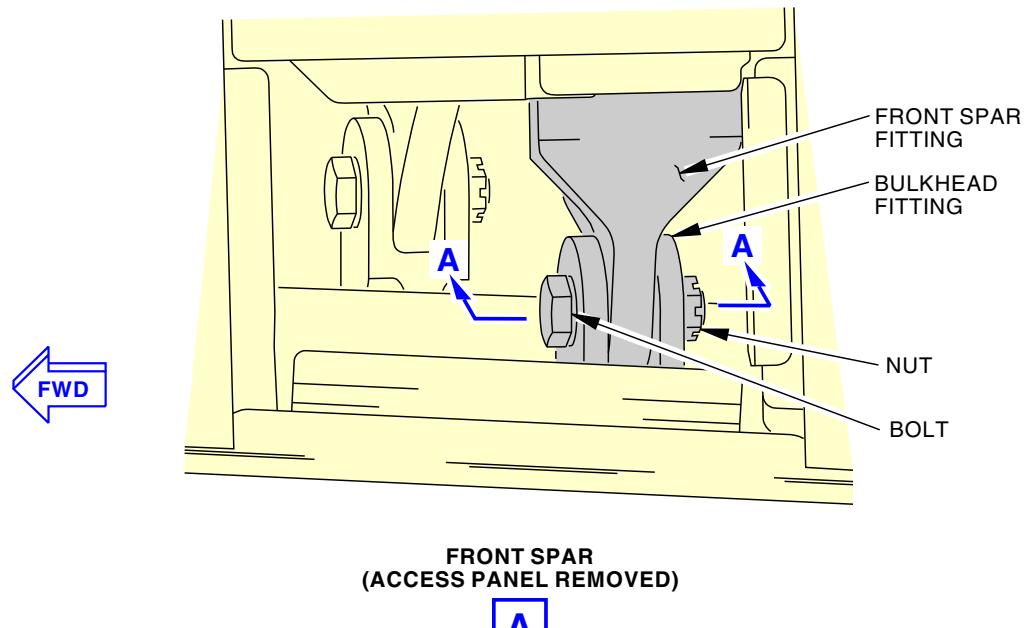
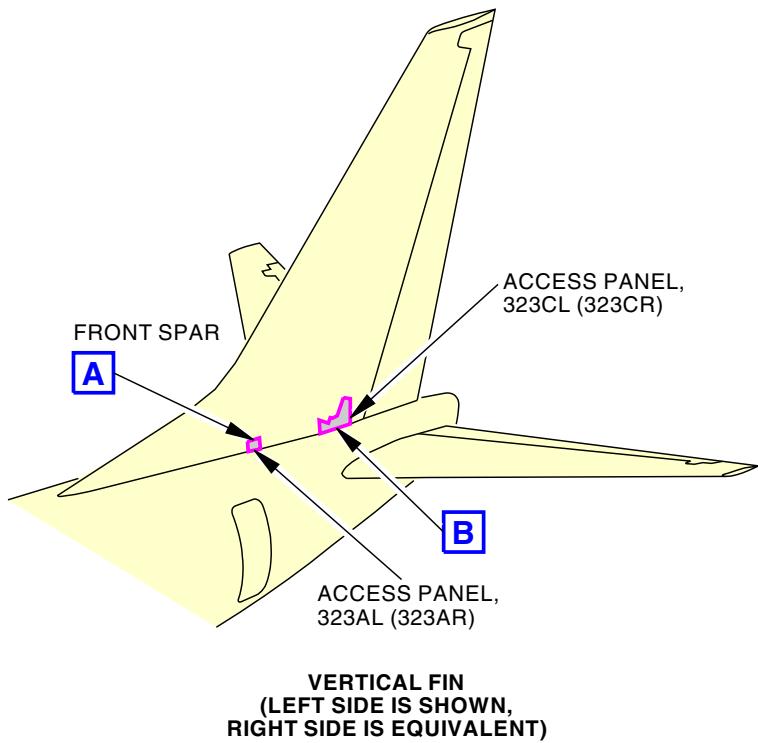
———— END OF TASK ————

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**Vertical Stabilizer (Fin) Inspection**  
Figure 601/55-30-00-990-801 (Sheet 1 of 4)

EFFECTIVITY  
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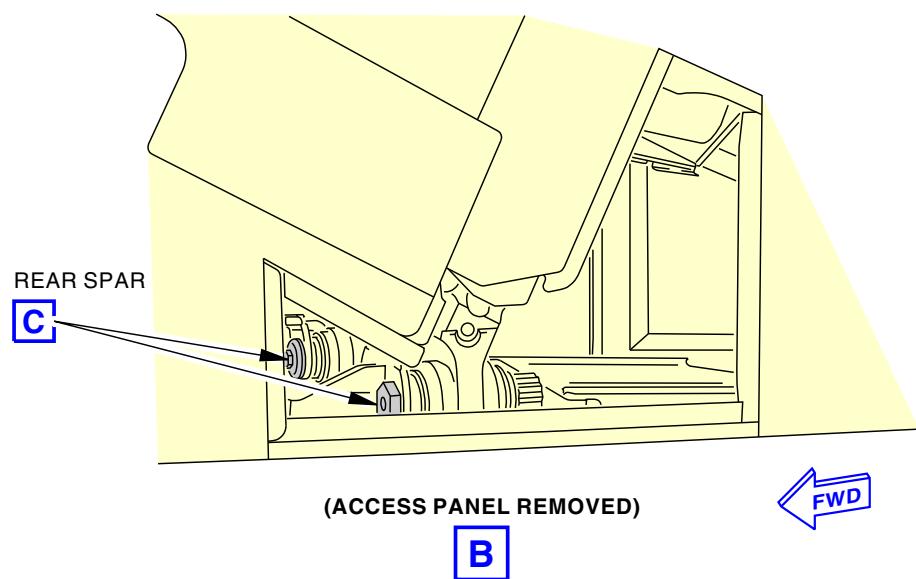
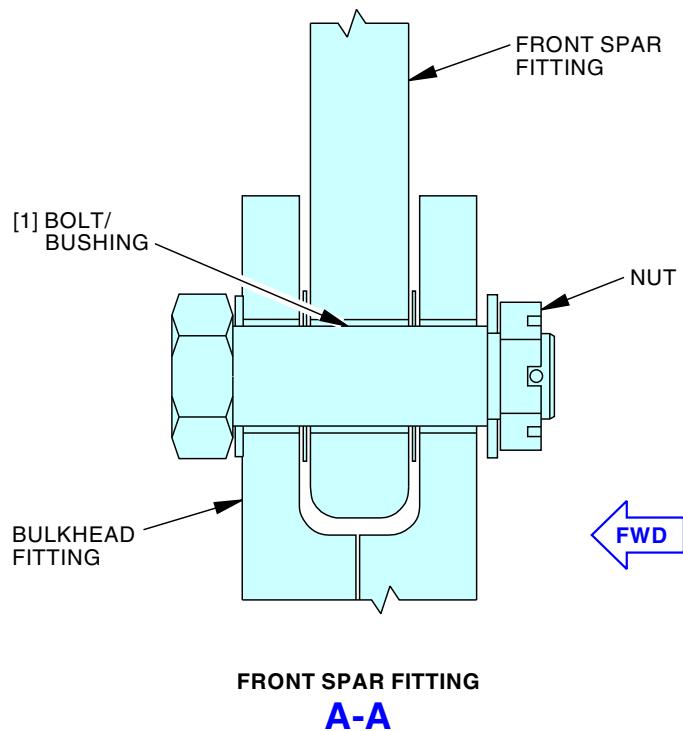
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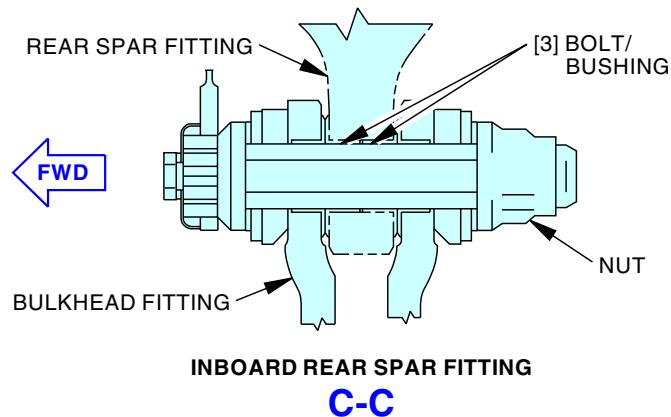
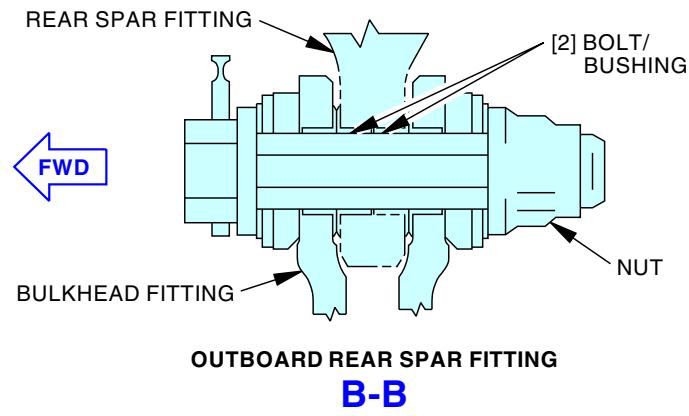
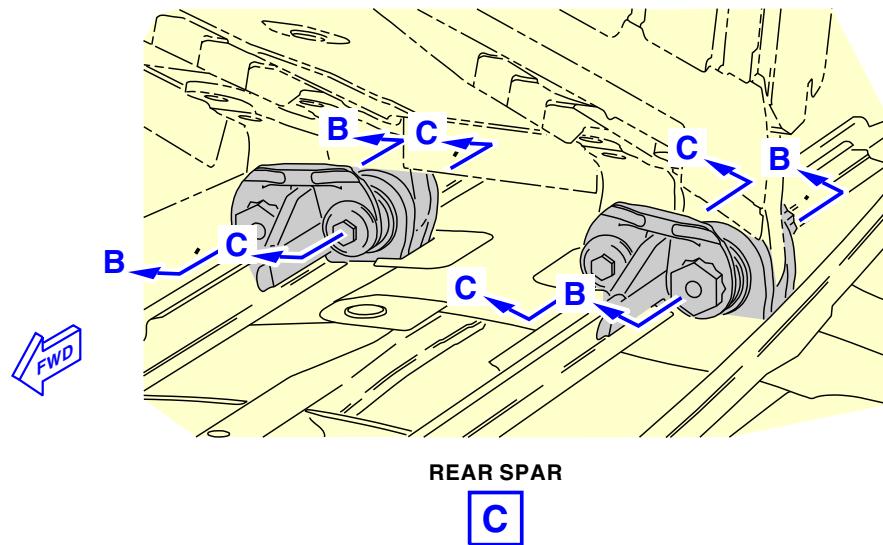
**Vertical Stabilizer (Fin) Inspection**  
**Figure 601/55-30-00-990-801 (Sheet 2 of 4)**

EFFECTIVITY  
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Vertical Stabilizer (Fin) Inspection  
Figure 601/55-30-00-990-801 (Sheet 3 of 4)

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INDEX NO.	PART 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	172A0161-1	BUSHING (FRONT SPAR)	ID	0.8780 (22.301)	0.8790 (22.327)	0.8835 (22.441)	0.0100 (0.254)	X			
	170A1611-3	BOLT (FRONT SPAR)	OD	0.8730 (22.174)	0.8740 (22.200)	0.8685 (22.060)		X	X		
2	172A0161-2	BUSHING (REAR SPAR)	ID	1.7530 (44.526)	1.7540 (44.552)	1.7600 (44.704)	0.0100 (0.254)	X			
	170A1611-1	BOLT (REAR SPAR)	OD	1.7480 (44.399)	1.7490 (44.425)	1.7420 (44.247)		X	X		
3	172A0161-3	BUSHING (REAR SPAR)	ID	1.5030 (38.176)	1.5040 (38.202)	1.5095 (38.341)	0.0100 (0.254)	X			
	170A1611-2	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.

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Vertical Stabilizer (Fin) Inspection  
Figure 601/55-30-00-990-801 (Sheet 4 of 4)

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VERTICAL FIN LUG SEALING - INSPECTION/CHECK

**1. General**

- A. There is one task in this procedure. An inspection of the vertical fin lug sealing.

NOTE: Obey all warnings and cautions given in the specified manual sections.

**TASK 55-30-01-200-801**

**2. Vertical Fin Sealing Inspection**

**A. References**

Reference	Title
24-22-00-860-812	Remove Electrical Power (P/B 201)
SRM 51-10-01	Structural Repair Manual

**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
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 55-30-01-860-001

- (1) Remove electrical power from the aircraft, do this task: Remove Electrical Power, TASK 24-22-00-860-812

SUBTASK 55-30-01-010-001

- (2) Get access to the vertical fin lugs.

- (a) Open these access panels:

Number	Name/Location
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

- (3) Examine all areas for water ingress, corrosion damage and missing, insufficient, or cracked sealant (Figure 601).

NOTE: If no missing sealant is found, no further action is required.

SUBTASK 55-30-01-010-002

- (4) Get access to the Stabilizer Trim

- (a) Open the Stabilizer Trim Access panel 311BL

- 1) Examine the skin edges for any gaps

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- 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, ballnut, and gimbal pins for corrosion.

SUBTASK 55-30-01-410-001

- (5) Return the airplane back to it's original condition

Close these access panels:

<b>Number</b>	<b>Name/Location</b>
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

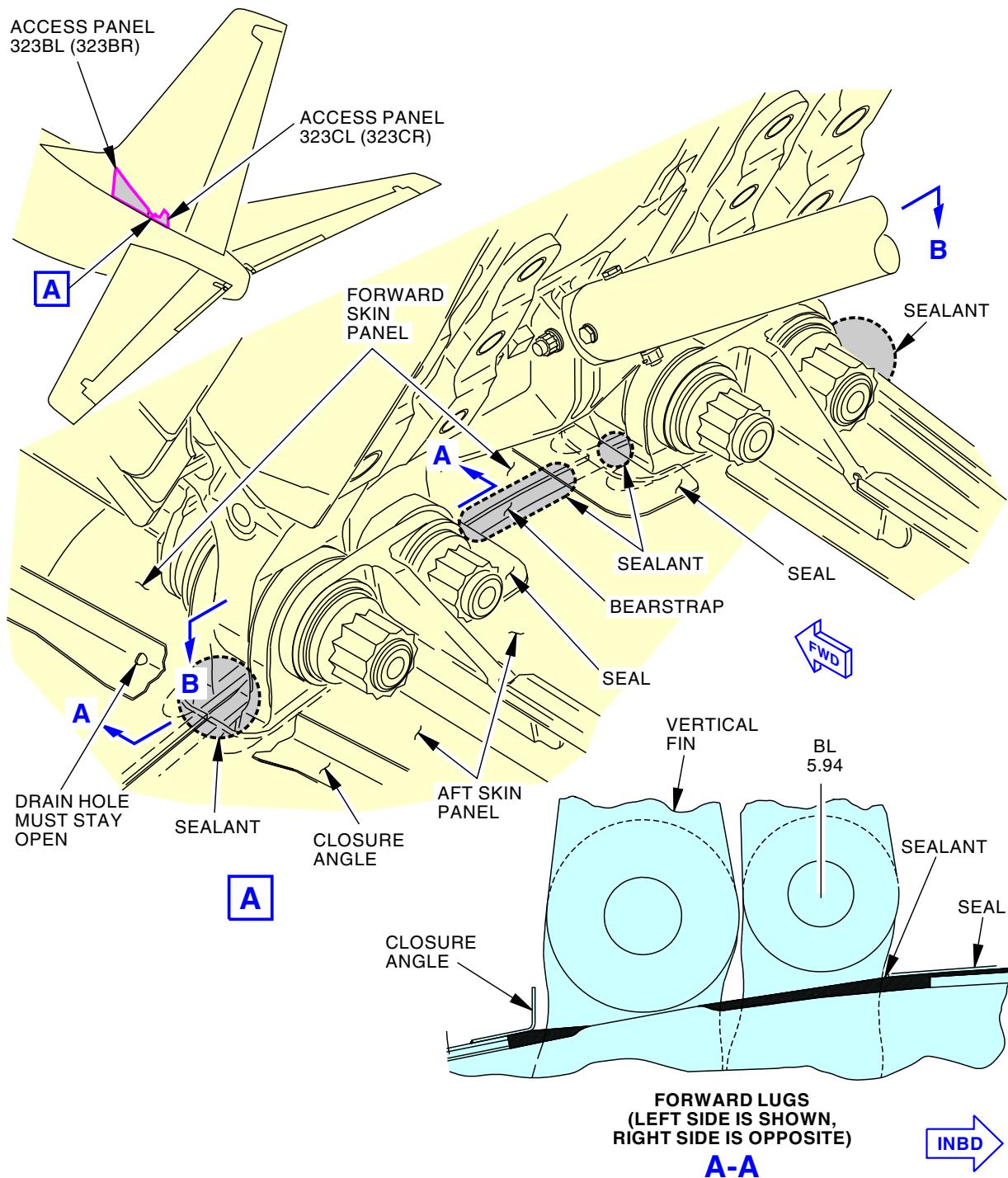
SUBTASK 55-30-01-390-001

- (6) Apply an aerodynamic smoother sealant, A02315, for each applicable panel (SRM 51-10-01).

———— END OF TASK ————

EFFECTIVITY  
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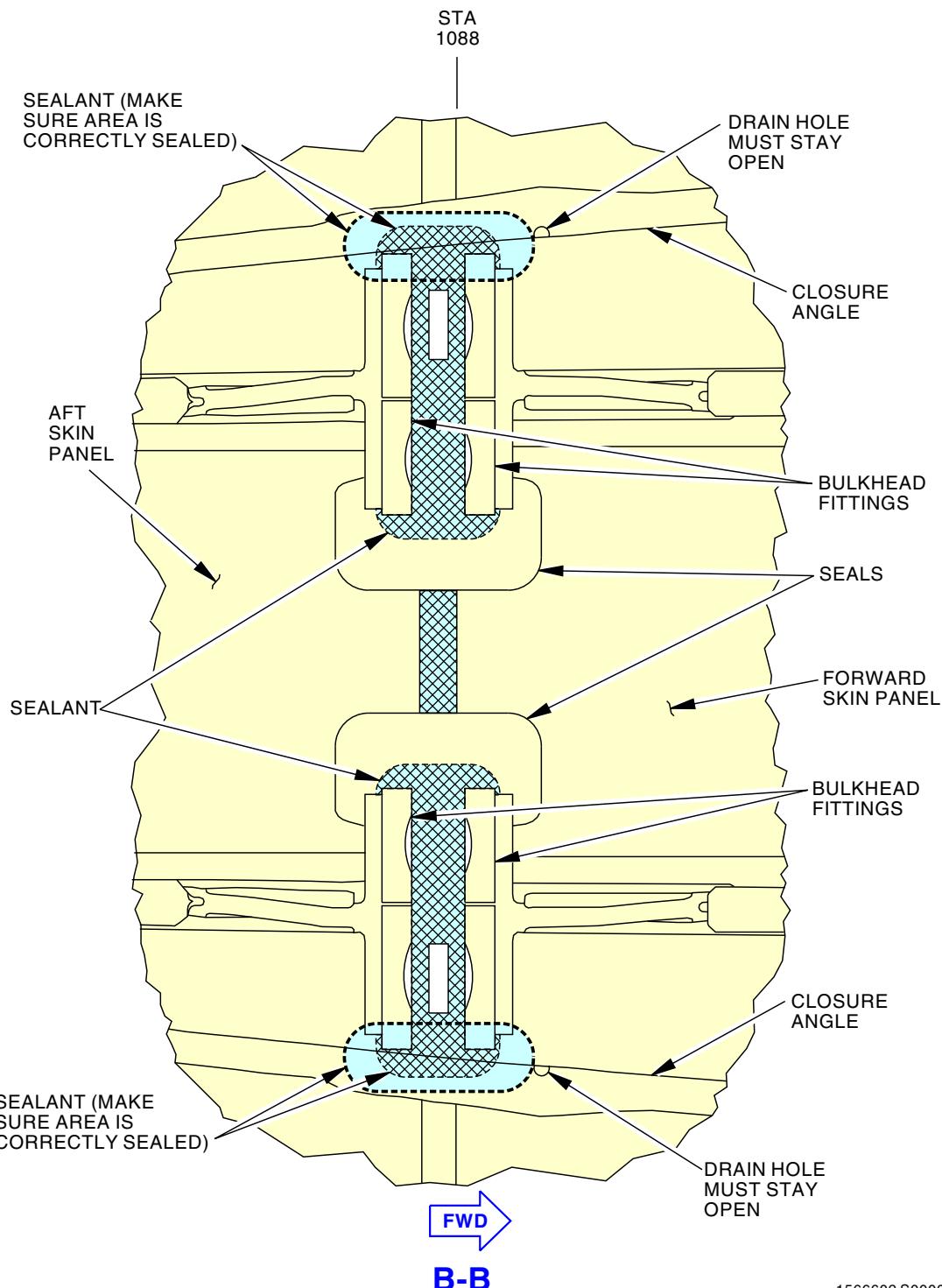
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**Vertical Fin Lugs - Inspection/Check**  
Figure 601/55-30-01-990-801 (Sheet 1 of 2)

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**Vertical Fin Lugs - Inspection/Check**  
**Figure 601/55-30-01-990-801 (Sheet 2 of 2)**

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LOM ALL

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DORSAL FIN - REMOVAL/INSTALLATION

**1. General**

- A. This procedure contains these tasks:
- (1) A removal of the dorsal fin.
  - (2) An installation of the dorsal fin.

**TASK 55-32-11-000-801**

**2. Dorsal Fin Removal**

(Figure 401)

**A. References**

Reference	Title
21-23-01-000-801	Overhead Distribution Duct Removal (P/B 201)
25-21-71-000-807	Entry Panel Removal (P/B 401)
25-21-71-000-821	Aft Entry Ceiling Panel Removal (P/B 401)
25-80-00-000-801	Insulation Blanket Removal (P/B 401)

**B. Location Zones**

Zone	Area
321	Vertical Fin - Dorsal Fin

**C. Dorsal Fin Removal**

**LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426**

SUBTASK 55-32-11-010-001

- (1) Do this task: Entry Panel Removal, TASK 25-21-71-000-807.

**LOM 427-434, 437-447, 450-999**

SUBTASK 55-32-11-010-007

- (2) Do this task: Aft Entry Ceiling Panel Removal, TASK 25-21-71-000-821.

**LOM ALL**

SUBTASK 55-32-11-010-002

- (3) 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

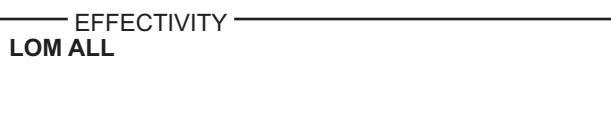
- (4) Do this task: Overhead Distribution Duct Removal, TASK 21-23-01-000-801.

**LOM 402, 404, 406**

SUBTASK 55-32-11-010-004

- (5) Move the insulation blankets sufficiently to get access to the bolts [2], bolts [4], bolts [6], bolts [7], and bolt [8] of the dorsal fin [1].

(a) When necessary, remove the insulation blankets to get access to the bolts [2], bolts [4], bolts [6], bolts [7], and bolt [8] (TASK 25-80-00-000-801).



**55-32-11**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**LOM 407**

SUBTASK 55-32-11-010-005

- (6) Move the insulation blankets sufficiently to get access to the bolts [2], bolts [8], bolts [6], and bolts [7] of the dorsal fin [1].
  - (a) When necessary, remove the insulation blankets to get access to the bolts [2], bolts [8], bolts [6], and bolts [7] (TASK 25-80-00-000-801).

**LOM 411, 412, 415, 416, 420, 422-434, 437-447, 450-999**

SUBTASK 55-32-11-010-006

- (7) Move the insulation blankets sufficiently to get access to the bolts [9], bolts [10], bolts [11], and bolts [12] of the dorsal fin [1].
  - (a) When necessary, remove the insulation blankets to get access to the bolts [9], bolts [10], bolts [11], and bolts [12] (TASK 25-80-00-000-801).

**LOM 402, 404, 406**

SUBTASK 55-32-11-020-001

- (8) Remove the dorsal fin [1].
  - (a) Remove sealant from the bolts [2], bolts [4], bolts [6], bolts [7], and bolt [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 [13], washers [3], washers [5], bolts [2], bolts [4], bolts [6], bolts [7], and bolt [8] that attach the dorsal fin [1] to the body structure.
- (c) Lift the dorsal fin [1] from the fuselage.

**LOM 407**

SUBTASK 55-32-11-020-002

- (9) Remove the dorsal fin [1].
  - (a) Remove sealant from the bolts [2], bolts [8], bolts [6], and bolts [7].



**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 [13], washers [3], washers [5], bolts [2], bolts [8], bolts [6], and bolts [7] that attach the dorsal fin [1] to the body structure.
- (c) Lift the dorsal fin [1] from the fuselage.

**LOM 411, 412, 415, 416, 420, 422-434, 437-447, 450-999**

SUBTASK 55-32-11-020-003

- (10) Remove the dorsal fin [1].
  - (a) Remove sealant from the bolts [9], bolts [10], bolts [11], and bolts [12].

EFFECTIVITY  
LOM ALL

**55-32-11**



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AIRCRAFT MAINTENANCE MANUAL

LOM 411, 412, 415, 416, 420, 422-434, 437-447, 450-999 (Continued)



**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.

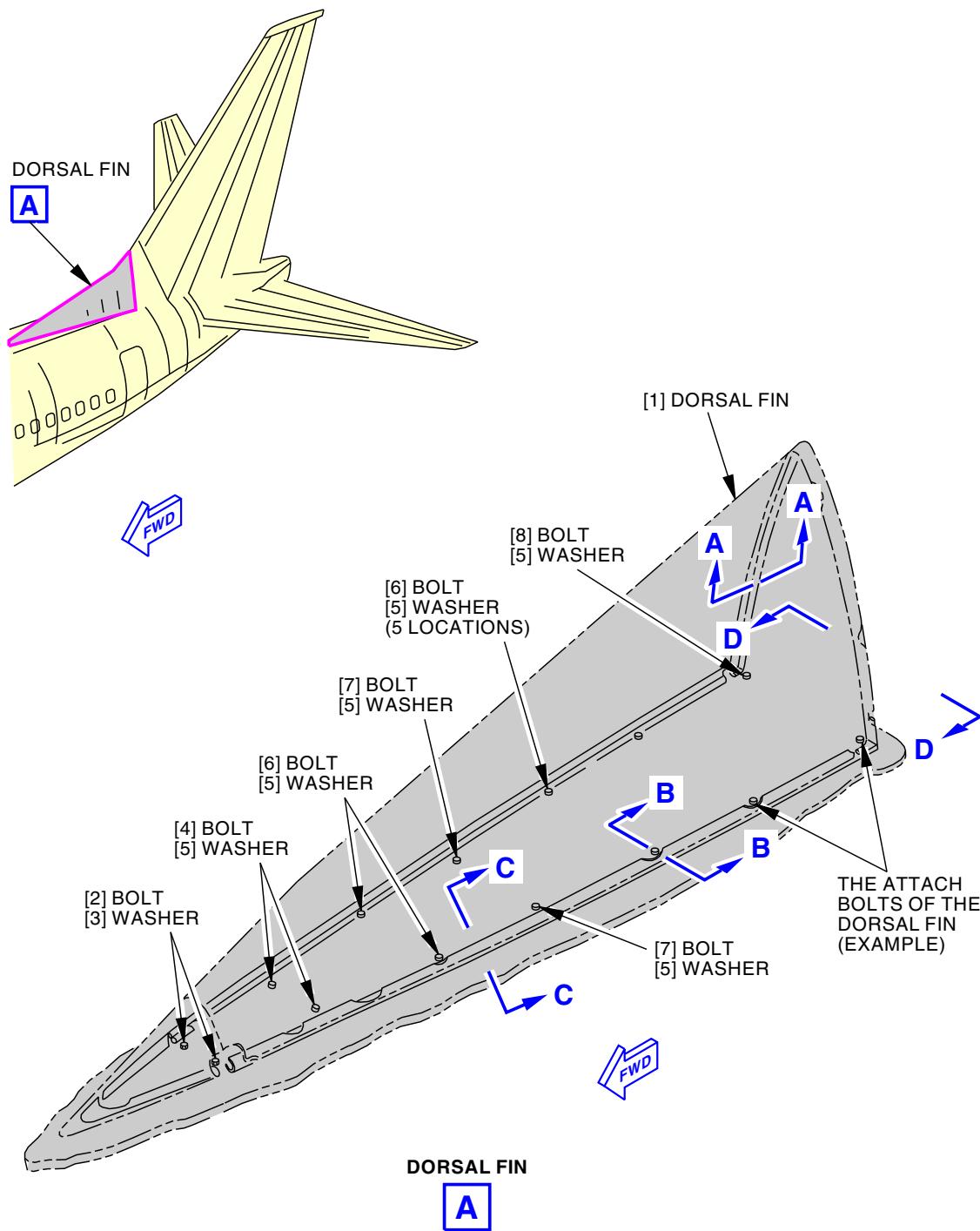
- (b) Remove the shims [13], washers [3], washers [5], bolts [9], bolts [10], bolts [11], and bolts [12] that attach the dorsal fin [1] to the body structure.
- (c) Lift the dorsal fin [1] from the fuselage.

LOM ALL

———— END OF TASK ————

———— EFFECTIVITY ————  
**LOM ALL**

**55-32-11**

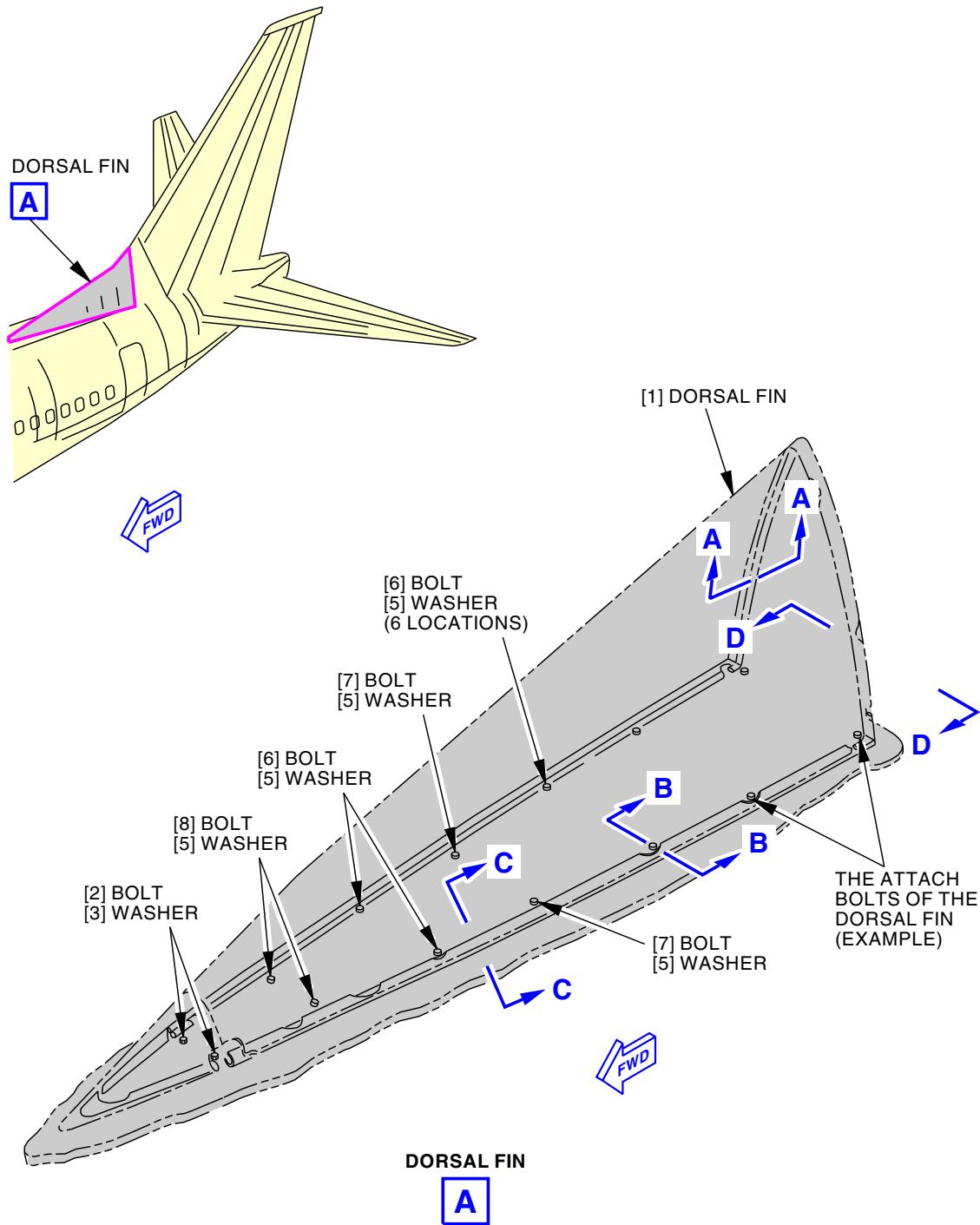


G24641 S0006581346\_V5

**Dorsal Fin Installation**  
**Figure 401/55-32-11-990-803 (Sheet 1 of 7)**

EFFECTIVITY  
 LOM 402, 404, 406

**55-32-11**



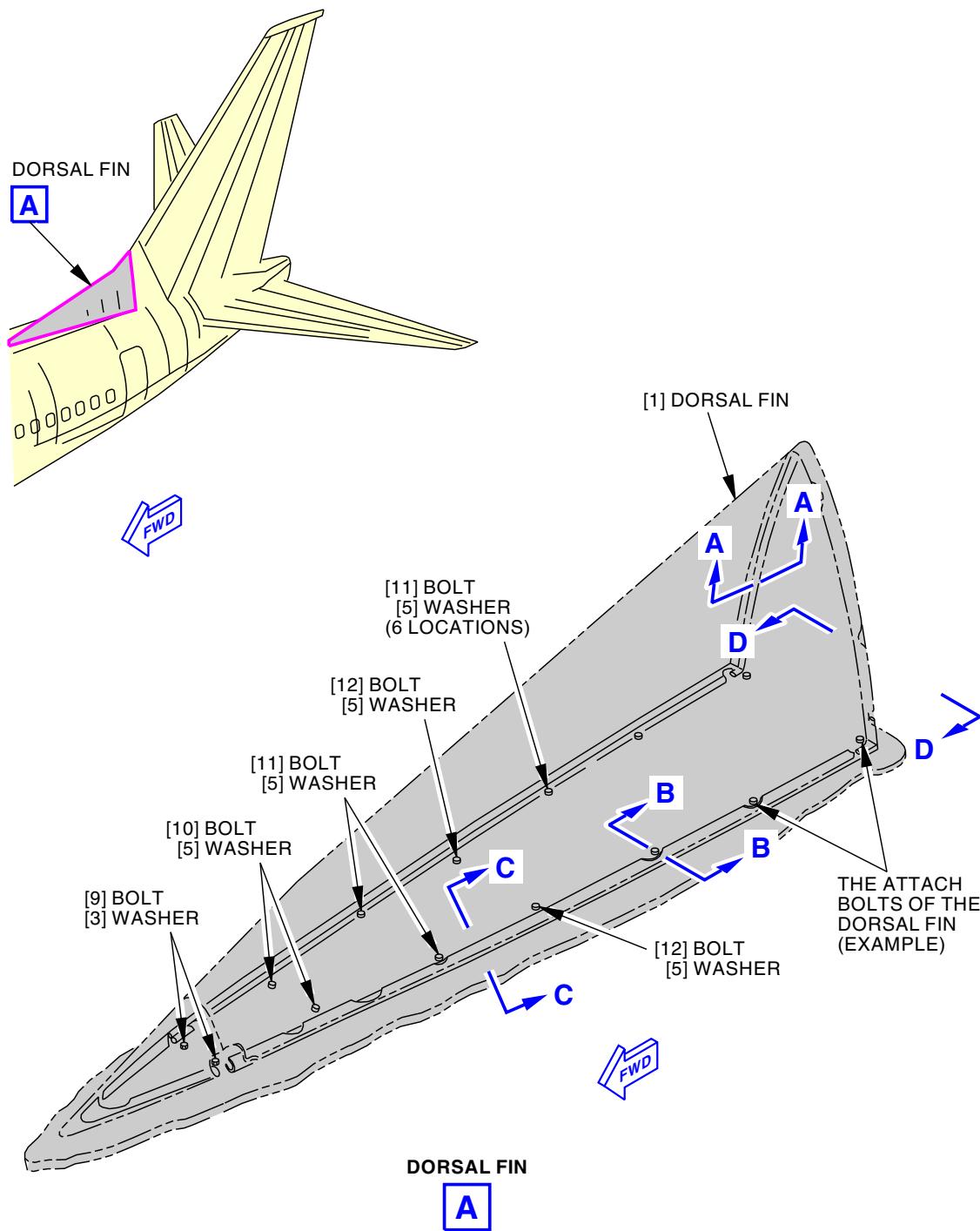
2944745 S0000720964\_V1

**Dorsal Fin Installation**  
**Figure 401/55-32-11-990-803 (Sheet 2 of 7)**

EFFECTIVITY	LOM 407
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**55-32-11**

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 Feb 15/2021



2946499 S0000723386\_V1

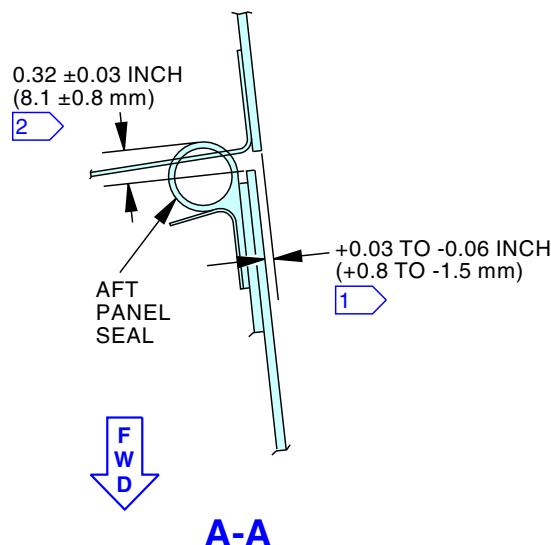
**Dorsal Fin Installation**  
Figure 401/55-32-11-990-803 (Sheet 3 of 7)

EFFECTIVITY  
LOM 411, 412, 415, 416, 420, 422-434, 437-447,  
450-999

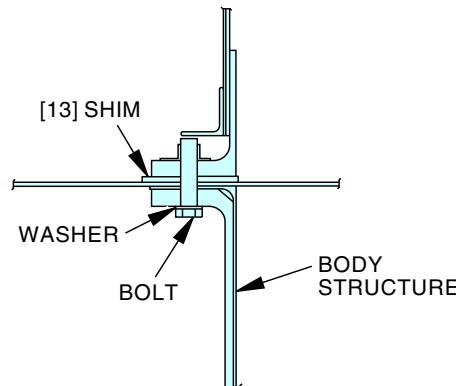
**55-32-11**



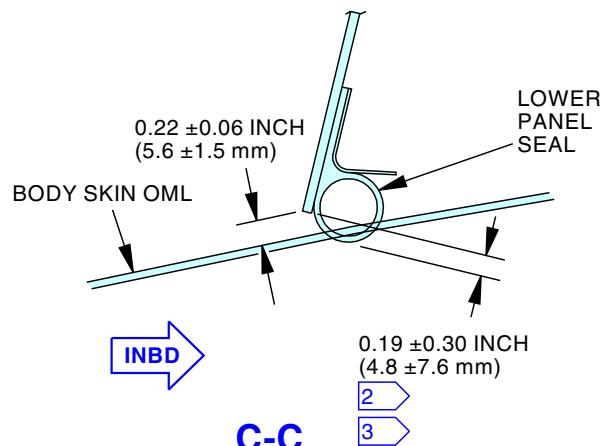
737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



A-A



ATTACHMENT FITTING  
(TYPICAL, 14 LOCATIONS)  
B-B



C-C

[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.

G33734 S0006581347\_V5

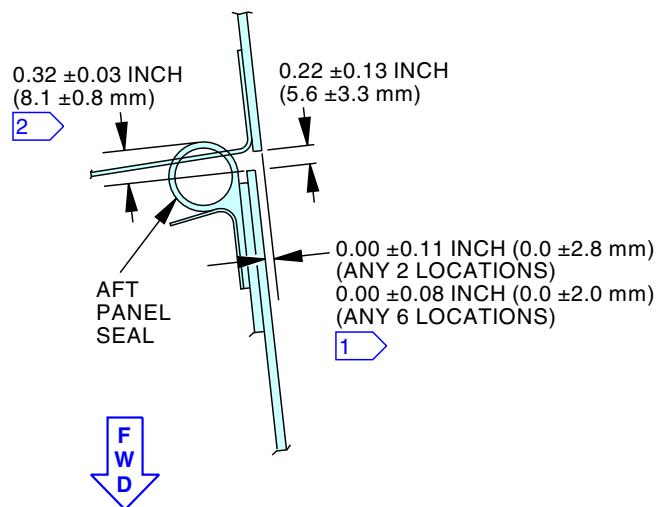
Dorsal Fin Installation  
Figure 401/55-32-11-990-803 (Sheet 4 of 7)

EFFECTIVITY  
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,  
422-431

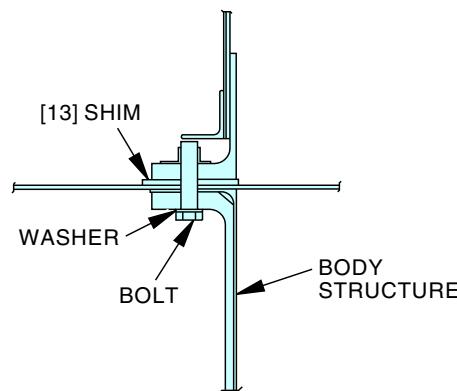
55-32-11



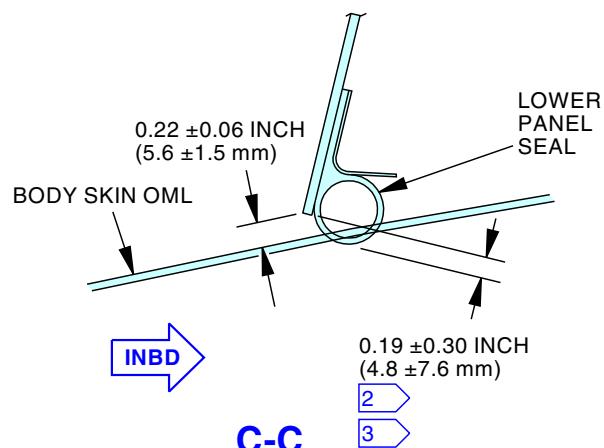
737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



(EXAMPLE)  
**A-A**



ATTACHMENT FITTING  
(TYPICAL, 14 LOCATIONS)  
**B-B**



**C-C**

**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.

2944767 S0000721123\_V2

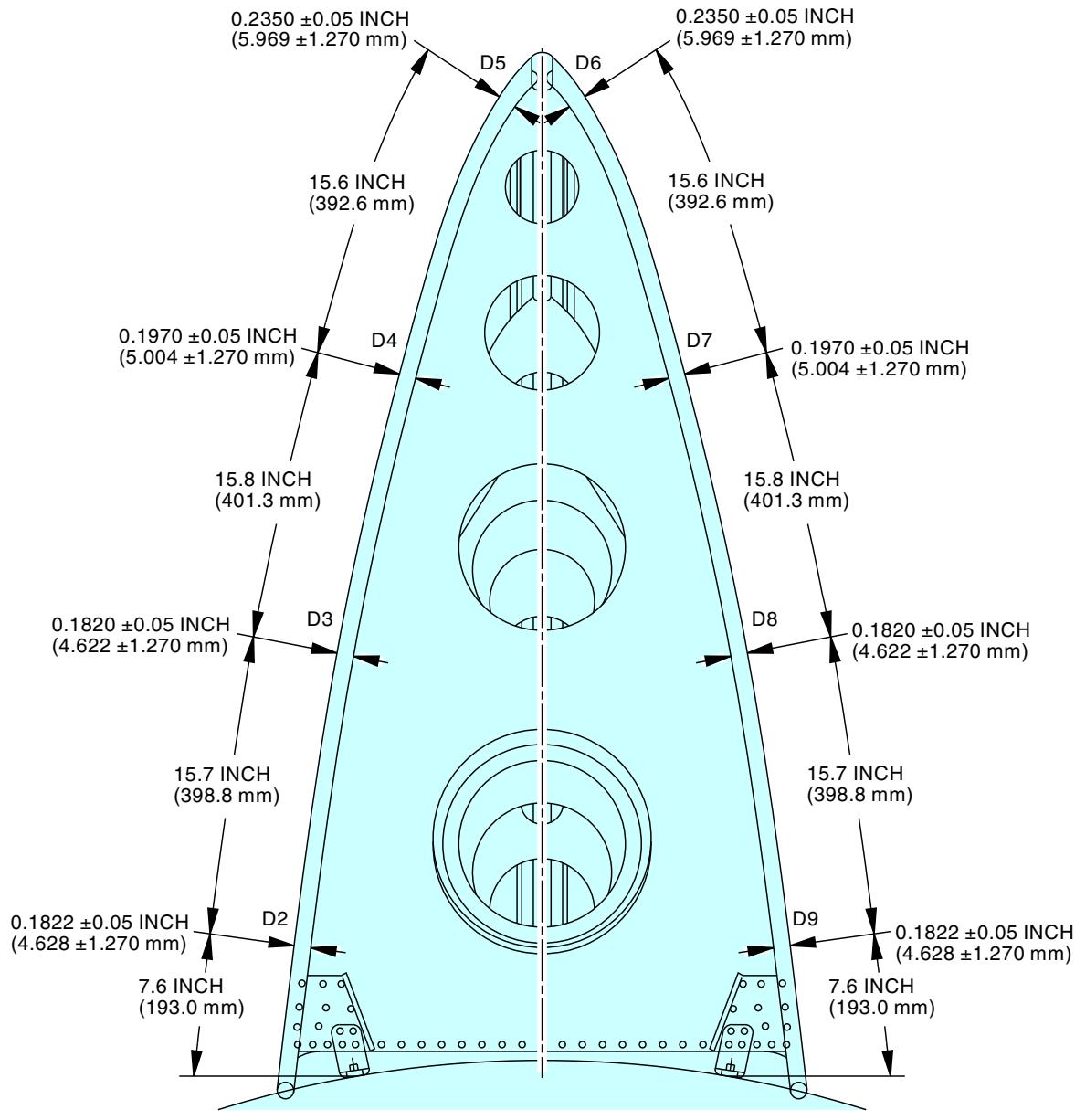
Dorsal Fin Installation  
Figure 401/55-32-11-990-803 (Sheet 5 of 7)

EFFECTIVITY  
LOM 432-434, 437-447, 450-999

**55-32-11**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



VIEW IN THE FORWARD DIRECTION

**D-D**

1305649 S0000216827\_V4

**Dorsal Fin Installation**  
**Figure 401/55-32-11-990-803 (Sheet 6 of 7)**

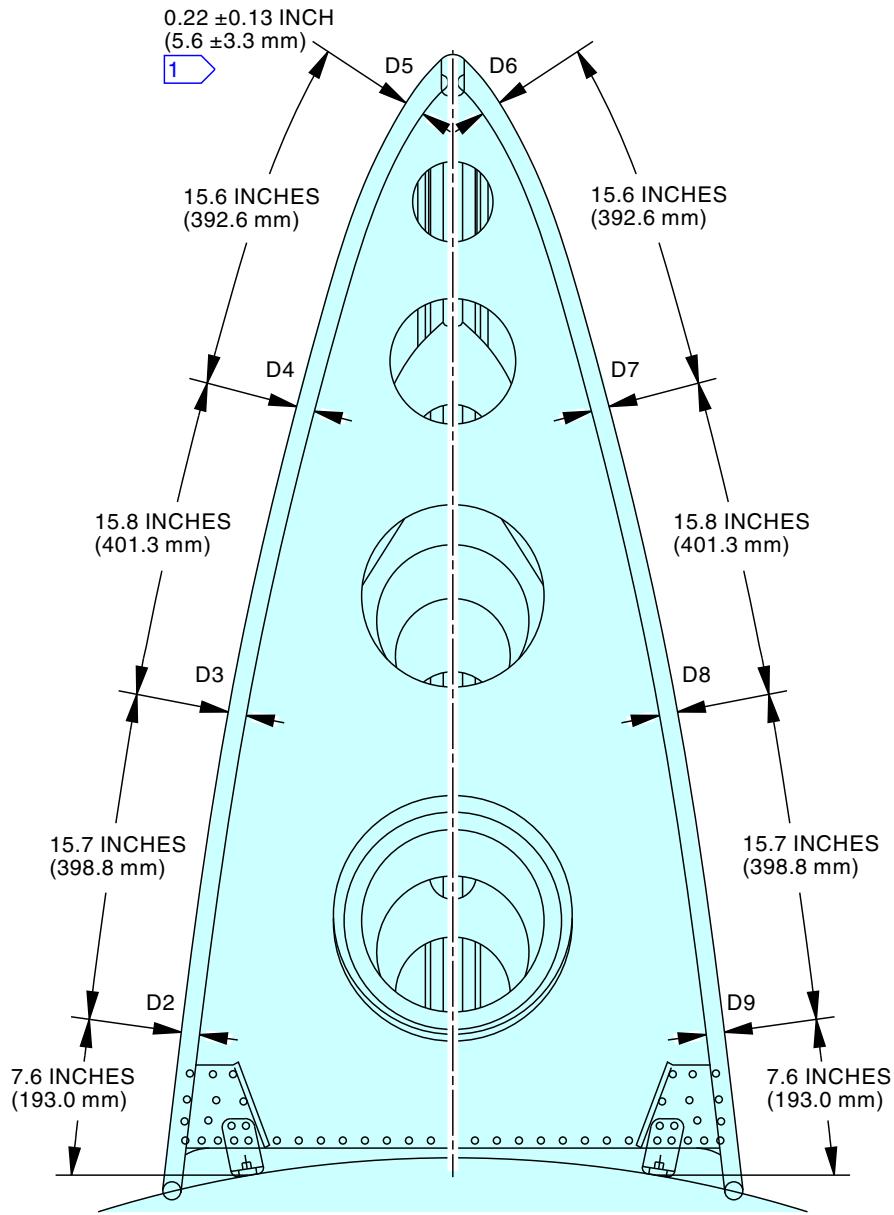
EFFECTIVITY  
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,  
422-431

**55-32-11**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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(VIEW IN THE FORWARD DIRECTION)

**D-D**

**1** CLEARANCE VALUE IS COMMON FOR ALL  
D2-D9 LOCATIONS

2947094 S0000723963\_V2

**Dorsal Fin Installation**  
Figure 401/55-32-11-990-803 (Sheet 7 of 7)

EFFECTIVITY  
LOM 432-434, 437-447, 450-999

**55-32-11**



737-600/700/800/900  
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**TASK 55-32-11-400-801**

**3. Dorsal Fin Installation**

(Figure 401)

**A. References**

Reference	Title
21-23-01-400-801	Overhead Distribution Duct Installation (P/B 201)
25-21-71-400-807	Entry Panel Installation (P/B 401)
25-21-71-400-821	Aft Entry Ceiling Panel Installation (P/B 401)
25-80-00-400-801	Insulation Blanket Installation (P/B 401)
51-31-00-390-804	Fillet Seal Application (P/B 201)
SRM 51-10-01	Structural Repair Manual
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES
SWPM 20-20-00, Paragraph 2.A.	Cleaning Procedure 1

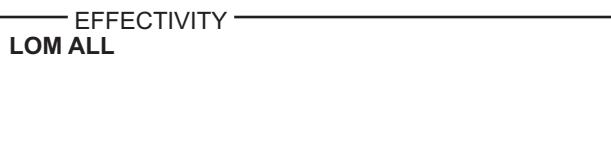
**B. Tools/Equipment**

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

Reference	Description
COM-614	Bonding Meters - Non-Intrinsically Safe (For use in outside Class I, Divisions I & II non-hazardous locations. For hazardous locations, use COM-1550). Part #: 247000 Supplier: 00426 Part #: 620LK Supplier: 1CRL2 Part #: BLR-0003-XX Supplier: KC432 Part #: BT51 Supplier: 00426 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659 Opt Part #: 247001 Supplier: 00426

**C. Consumable Materials**

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
A50231	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class B
A50337	Sealant - Fuel Tank	BMS5-45 Class B
A50359	Sealant - Low Density, Non-Chromate Type	BMS5-142 Type II Class B
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CLA)



**55-32-11**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Dorsal fin	55-32-11-01A-045	LOM ALL

E. Location Zones

Zone	Area
321	Vertical Fin - Dorsal Fin

F. Dorsal Fin Installation

**LOM 402, 404, 406**

SUBTASK 55-32-11-420-001

- (1) Install the dorsal fin [1] (Figure 401).



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.

- (d) Install the shims [13], washers [3], and bolts [2] that attach the dorsal fin [1] to the body structure.

- 1) Tighten the bolts [2] 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.

- (e) Install the shims [13], washers [5], bolts [4], bolts [6], bolts [7], and bolt [8] that attach the dorsal fin [1] to the body structure.

- 1) Tighten the bolts [4], bolts [6], bolts [7], and bolt [8] to  $150 +5 / -4$  in-lb ( $17 +1 / -0$  N·m).

**LOM 407**

SUBTASK 55-32-11-420-002

- (2) Install the dorsal fin [1] (Figure 401).

- (a) Clean the mating surface of the dorsal fin [1] (SWPM 20-20-00, Paragraph 2.A.).
- (b) Use cotton wiper, G00034, moist in solvent, B00184, to clean the mating surfaces of the washers [3], washers [5], bolts [2], bolts [6], bolts [7], and bolts [8].
- (c) Put the dorsal fin [1] in its position on the airplane.

EFFECTIVITY  
LOM ALL

**55-32-11**



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AIRCRAFT MAINTENANCE MANUAL

LOM 407 (Continued)



**CAUTION**

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.

- (d) Install the shims [13], washers [3], and bolts [2] that attach the dorsal fin [1] to the body structure.
- 1) Tighten the bolts [2] to  $80 \pm 2$  in-lb ( $9 \pm 0$  N·m).



**CAUTION**

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.

- (e) Install the shims [13], washers [5], bolts [8], bolts [6], and bolts [7] that attach the dorsal fin [1] to the body structure.
- 1) Tighten the bolts [8], bolts [6], and bolts [7] to  $150 +5 / -4$  in-lb ( $17 +1 / -0$  N·m).

**LOM 411, 412, 415, 416, 420, 422-434, 437-447, 450-999**

SUBTASK 55-32-11-420-003

- (3) Install the dorsal fin [1] (Figure 401).

- (a) Clean the mating surface of the dorsal fin [1] (SWPM 20-20-00, Paragraph 2.A.).
- (b) Use cotton wiper, G00034, moist in solvent, B00184, to clean the mating surfaces of the washers [3], washers [5], bolts [9], bolts [10], bolts [11], and bolts [12].
- (c) Put the dorsal fin [1] in its position on the airplane.



**CAUTION**

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.

- (d) Install the shims [13], washers [3], and bolts [9] that attach the dorsal fin [1] to the body structure.
- 1) Tighten the bolts [9] to  $80 \pm 2$  in-lb ( $9 \pm 0$  N·m).



**CAUTION**

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.

- (e) Install the shims [13], washers [5], bolts [10], bolts [11], and bolts [12] that attach the dorsal fin [1] to the body structure.
- 1) Tighten the bolts [10], bolts [11], and bolts [12] to  $150 +5 / -4$  in-lb ( $17 +1 / -0$  N·m).

**LOM ALL**

SUBTASK 55-32-11-220-001

- (4) Make sure that the clearances are in the tolerance (Figure 401).

- (a) Make sure that the full length of the lower panel seal touches the body.

EFFECTIVITY  
**LOM ALL**

**55-32-11**



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SUBTASK 55-32-11-220-004

- (5) Make sure that the dorsal fin [1] is in aerodynamic smoothness limits (SRM 51-10-01).

**LOM 402, 404, 406, 407, 411, 412, 415, 416, 420**

SUBTASK 55-32-11-760-001

- (6) Measure the electrical bonding resistance between the washer [3]/washer [5] and body structure (SWPM 20-20-00).
- (a) Use a non-intrinsically safe bonding meter, COM-614.
  - (b) Make sure that the electrical bonding resistance is 0.0005 ohm (0.5 milliohm) or less.
  - (c) Check the electrical bonding resistance for all washers [3]/washers [5].

**LOM 422-434, 437-447, 450-999**

SUBTASK 55-32-11-760-002

- (7) Measure the electrical bonding resistance between the outside dorsal fin rivet and outside skin rivet.
- (a) Use a non-intrinsically safe bonding meter, COM-614.
  - (b) Make sure that the electrical bonding resistance is 0.005 ohm (5.0 milliohm) or less.
  - (c) Measure two locations on each side of the dorsal fin [1].

**LOM 402, 404, 406**

SUBTASK 55-32-11-390-001

- (8) Apply sealant, A02315, to the bolts [2], bolts [4], bolts [6], bolts [7], and bolt [8].
- (a) To apply the sealant, do this task: Fillet Seal Application, TASK 51-31-00-390-804.

**LOM 407**

SUBTASK 55-32-11-390-002

- (9) Apply sealant, A02315, to the bolts [2], bolts [8], bolts [6], and bolts [7].
- (a) To apply the sealant, do this task: Fillet Seal Application, TASK 51-31-00-390-804.

**LOM 411, 412, 415, 416, 420**

SUBTASK 55-32-11-390-003

- (10) Apply sealant, A02315, to the bolts [9], bolts [10], bolts [11], and bolts [12].
- (a) To apply the sealant, do this task: Fillet Seal Application, TASK 51-31-00-390-804.

**LOM 422-434, 437-447, 450-999**

SUBTASK 55-32-11-390-004

- (11) Apply sealant, A50337, or sealant, A50231, or sealant, A50359, to the bolts [9], bolts [10], bolts [11], and bolts [12].
- (a) To apply the sealant, do this task: Fillet Seal Application, TASK 51-31-00-390-804.

**LOM 402, 404, 406**

SUBTASK 55-32-11-410-002

- (12) If were removed, install the insulation blankets to get access to the bolts [2], bolts [4], bolts [6], bolts [7], and bolt [8].
- (a) To install the blankets, do this task: Insulation Blanket Installation, TASK 25-80-00-400-801.

EFFECTIVITY  
LOM ALL

**55-32-11**



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**LOM 407**

SUBTASK 55-32-11-410-007

- (13) If were removed, Install the insulation blankets to get access to the bolts [2], bolts [8], bolts [6], and bolts [7].
  - (a) To install the blankets, do this task: Insulation Blanket Installation, TASK 25-80-00-400-801.

**LOM 411, 412, 415, 416, 420, 422-434, 437-447, 450-999**

SUBTASK 55-32-11-410-008

- (14) If were removed, Install the insulation blankets to get access to the bolts [9], bolts [10], bolts [11], and bolts [12].
  - (a) To install the blankets, do this task: Insulation Blanket Installation, TASK 25-80-00-400-801.

**LOM ALL**

SUBTASK 55-32-11-410-003

- (15) Do this task: Overhead Distribution Duct Installation, TASK 21-23-01-400-801.

SUBTASK 55-32-11-410-004

- (16) Install the entry light fixture.

**LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426**

SUBTASK 55-32-11-410-005

- (17) Do this task: Entry Panel Installation, TASK 25-21-71-400-807.

**LOM 427-434, 437-447, 450-999**

SUBTASK 55-32-11-410-009

- (18) Do this task: Aft Entry Ceiling Panel Installation, TASK 25-21-71-400-821.

———— END OF TASK ————

EFFECTIVITY  
**LOM ALL**

**55-32-11**





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VERTICAL STABILIZER (FIN) LEADING EDGE - REMOVAL/INSTALLATION

1. **General**

- A. There are two tasks in this procedure:
  - (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. References**

Reference	Title
55-33-21-000-801	Vertical Stabilizer (Fin) Tip Removal (P/B 401)
SRM 51-10-01	Structural Repair Manual

**B. Tools/Equipment**

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

Reference	Description
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
322	Vertical Fin - Removable Fin Leading Edge

**D. Access Panels**

Number	Name/Location
322A	Vertical Fin, Fixed Leading Edge
322AL	Vertical Fin, Fixed Leading Edge
322AR	Vertical Fin, Fixed Leading Edge
322B	Vertical Fin, Removable Leading Edge
322C	Vertical Fin, Removable Leading Edge

**E. Prepare for the Removal**

SUBTASK 55-33-11-040-001



REMOVE THE ELECTRICAL POWER FROM EACH HIGH-FREQUENCY (HF) COMMUNICATION SYSTEM, BEFORE YOU REMOVE THE LEADING SECTIONS. IF YOU DO NOT OBEY, HF SIGNALS CAN CAUSE AN ELECTRICAL SHOCK INJURY TO PERSONS.

- (1) Make sure that these circuit breakers are open and have safety tags:

**CAPT Electrical System Panel, P18-2**

Row   Col   Number   Name

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-431, 433, 434, 437-447, 450-999

EFFECTIVITY  
LOM ALL

**55-33-11**



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**LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-431, 433, 434, 437-447, 450-999 (Continued)**

(Continued)

**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

**LOM ALL**

These circuit breakers are inoperative and should remain open:

**CAPT Electrical System Panel, P18-2**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
LOM 432	E	11	C00839 COMMUNICATIONS HF 1 (INOP)

**F/O Electrical System Panel, P6-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
LOM 402, 406, 407, 411, 420, 427-432, 437, 438, 446, 447, 450, 455, 456, 458-463	D	2	C00857 COMMUNICATIONS HF 2 (INOP)

**LOM ALL**

**F. Vertical Stabilizer (Fin) Leading Edge Removal**

SUBTASK 55-33-11-010-002



**CAUTION**

WHEN YOU INSTALL FASTENERS, MAKE SURE THAT THE DRIVER BIT IS IN LINE WITH A FASTENER. THIS WILL PREVENT DRIVER BIT WOBBLE WHICH CAN CAUSE DAMAGE TO THE FASTENER RECESSES AND THREADS.

- (1) Use a leverage access panel adapter, SPL-1558, or a 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



**CAUTION**

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 55-33-11-020-001



**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.

EFFECTIVITY  
**LOM ALL**

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(WARNING PRECEDES)



**CAUTION**

BE CAREFUL WHEN YOU REMOVE THE LEADING EDGE. YOU CAN EASILY CAUSE DAMAGE TO THE LEADING EDGE FINISH.

- (3) These access panels are required to be removed in this procedure (follow the steps in the procedure to remove the applicable access panels):

**Number      Name/Location**

322A	Vertical Fin, Fixed Leading Edge
322AL	Vertical Fin, Fixed Leading Edge
322AR	Vertical Fin, Fixed Leading Edge
322B	Vertical Fin, Removable Leading Edge
322C	Vertical Fin, Removable Leading Edge

SUBTASK 55-33-11-030-001

- (4) Disconnect the upper end of the feedline tube [6], as follows:
- Remove the removable leading edge panel, 322C [5].
  - Remove the screw [10] and washer [11].

SUBTASK 55-33-11-020-002

- (5) Remove the sleeve [8], as follows:
- Remove the fixed leading edge panel, 322AL [2].
  - Remove the hose clamps [7] from the feedline tube assembly.
  - Slide the sleeve [8] back.

SUBTASK 55-33-11-010-004

- (6) Disconnect the lower end of the feedline tube [6], as follows:
- Remove the fixed leading edge panel, 322A [1].
  - Remove the coupler tray assembly cover [9].
  - Remove the screw [12], washer [13], and nut [14].
  - Remove the feedline tube [6].

SUBTASK 55-33-11-010-005

- (7) Remove the fasteners from the removable leading edge panel, 322B [4].

SUBTASK 55-33-11-010-006

- (8) Remove the fasteners from vertical stabilizer tip forward fairing (TASK 55-33-21-000-801).

SUBTASK 55-33-11-010-007

- (9) Move the removable leading edge panel, 322B [4] slightly up and remove it.

SUBTASK 55-33-11-210-003

- (10) Examine the leading edge for aerodynamic smoothness (SRM 51-10-01).

SUBTASK 55-33-11-210-004

- (11) Install the protective cover on the leading edge area.

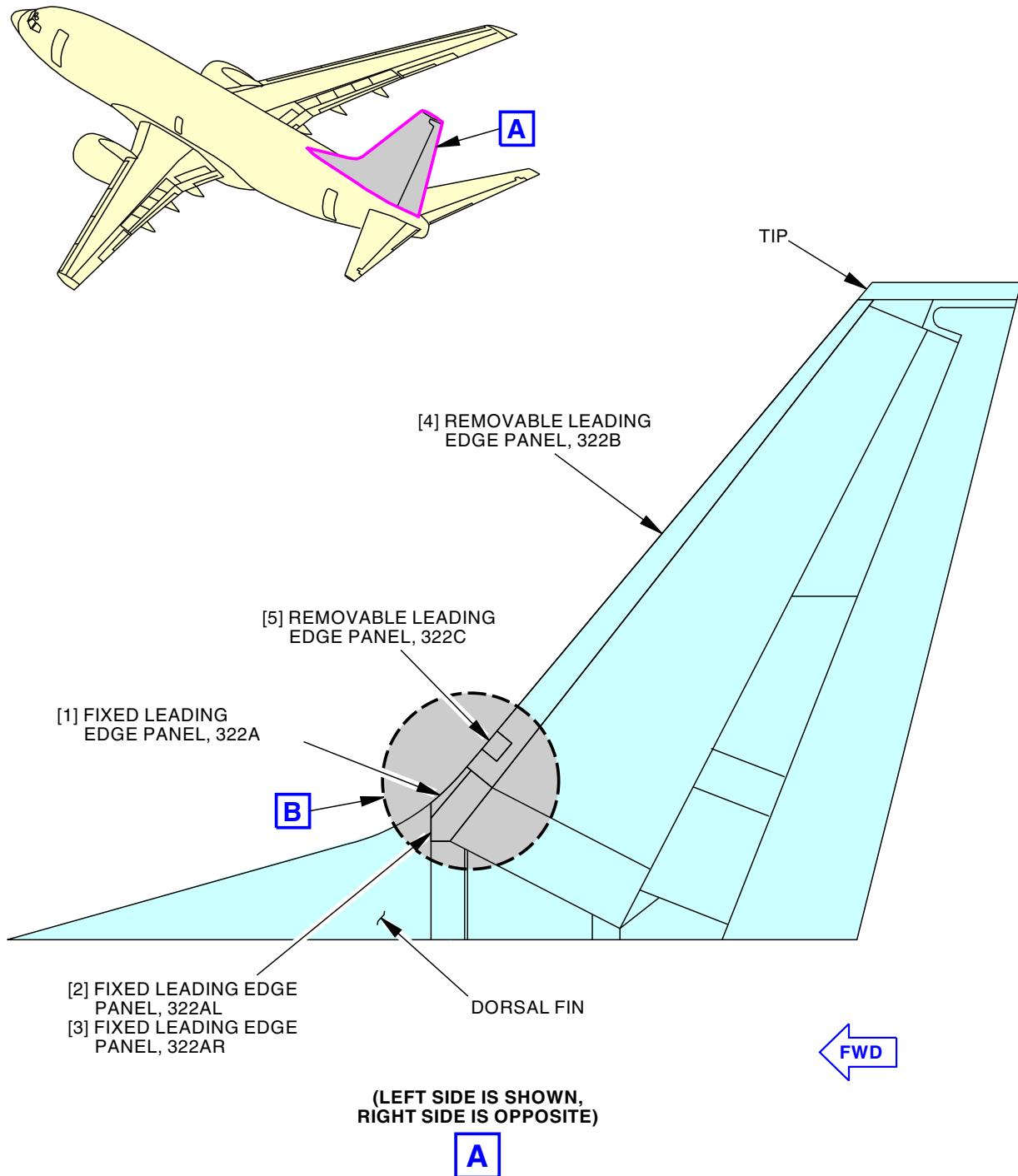
— END OF TASK —

EFFECTIVITY  
LOM ALL

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Vertical Stabilizer (Fin) Leading Edge Panels Installation  
Figure 401/55-33-11-990-802 (Sheet 1 of 2)

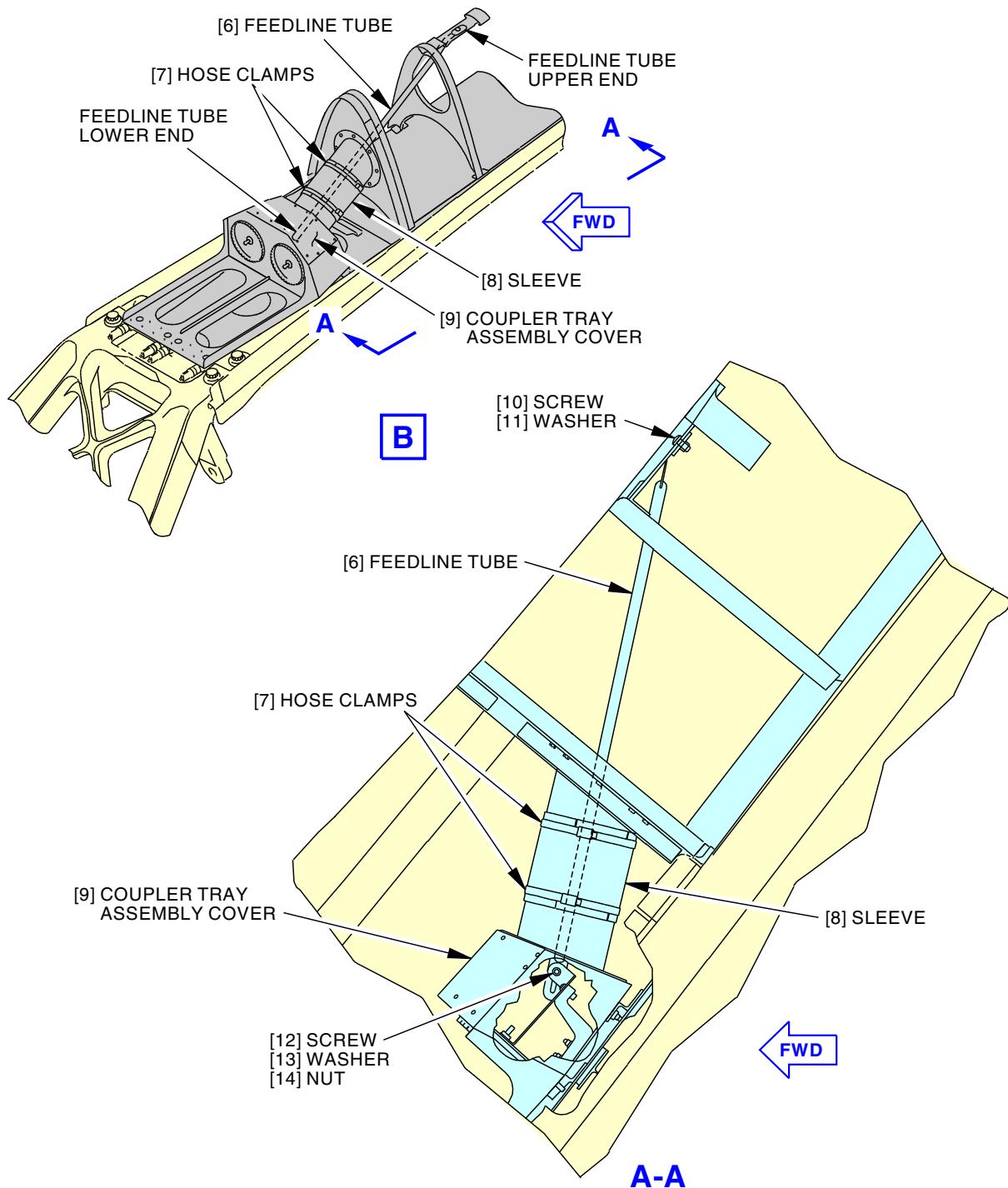
EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**Vertical Stabilizer (Fin) Leading Edge Panels Installation**  
**Figure 401/55-33-11-990-802 (Sheet 2 of 2)**

EFFECTIVITY  
LOM ALL

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**TASK 55-33-11-400-801**

**3. Vertical Stabilizer (Fin) Leading Edge Installation**

(Figure 401)

**A. 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	Bonderite M-CR 1001 Aero Application Process (P/B 701)
55-33-21-400-801	Vertical Stabilizer (Fin) Tip Installation (P/B 401)
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
SPL-1558	Adapter - Access Panel, Leverage Part #: 3008-550 Supplier: 55856 Part #: B20004-42 Supplier: 81205 Opt Part #: B20004-21 Supplier: 81205

**C. 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
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
C50153	Coating - Chemical Conversion - Bonderite M-CR 1001 Aero (Formerly Alodine 1001)	BAC5719 Class B, MIL-DTL-81706 Type I Class 3
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CLA)
G50381	Abrasive - Aluminum Oxide Paper, 180 Grit	
G50961	Coating - Corrosion Inhibiting Epoxy Primer - (BAC 377 Yellow Color)	BMS10-11 Type I

EFFECTIVITY	LOM ALL
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**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
322B	Vertical Fin, Removable Leading Edge
322C	Vertical Fin, Removable Leading Edge

**F. Vertical Stabilizer (Fin) Leading Edge Installation**

SUBTASK 55-33-11-010-003

- (1) Remove the protective cover from the leading edge area.

SUBTASK 55-33-11-410-003

- (2) Attach the lower end of the feedline tube [6].
  - (a) Install the screw [12], washer [13], and nut [14].
  - (b) Tighten the screw [12] to 25 in-lb (2.8 N·m).

**LOM 422-434, 437-447, 450-999**

- (c) Apply a fillet seal with sealant, A50231, to cover the screw [12], washer [13], and nut [14].

**LOM ALL**

- (d) Install the coupler tray assembly cover [9].

SUBTASK 55-33-11-410-004

- (3) Install the sleeve [8] to the feedline tube assembly.
  - (a) Attach the hose clamps [7].
  - (b) Tighten the hose clamps [7] to 16 in-lb (1.8 N·m) - 18 in-lb (2.0 N·m).

SUBTASK 55-33-11-420-001



**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.



**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:

EFFECTIVITY  
**LOM ALL**

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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 you check the alignment of the leading edge assembly along the full length prior to installing the fasteners.

NOTE: If the leading edge assembly is not aligned or forced into position during installation, then the induced strains can cause tension cracks in the rib chords.

Install these access panels:

**Number      Name/Location**

322A	Vertical Fin, Fixed Leading Edge
322AL	Vertical Fin, Fixed Leading Edge
322AR	Vertical Fin, Fixed Leading Edge
322B	Vertical Fin, Removable Leading Edge
322C	Vertical Fin, Removable Leading Edge

SUBTASK 55-33-11-420-003

- (5) Put the applicable vertical stabilizer tip forward fairing in its position on the stabilizer (TASK 55-33-21-400-801).

SUBTASK 55-33-11-420-002

- (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 any fasteners need to be replaced, it is recommended that K-coated titanium bolts with cadmium plated Cres nut-plates be installed where applicable.

- (b) Remove the unwanted paint on the fastener recesses.



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 countersink.



WHEN YOU INSTALL FASTENERS, MAKE SURE THAT THE DRIVER BIT IS IN LINE WITH A FASTENER. THIS WILL PREVENT DRIVER BIT WOBBLE WHICH CAN CAUSE 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 (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 should have a hardness of 56-58 RC.

SUBTASK 55-33-11-400-001

- (7) Do these steps to install the part of the leading edge that contains the HF antenna:

- (a) Clean the mating surfaces between the attach plates and antenna feedlines with 180 grit abrasive paper, G50381.

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LOM ALL

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**AIRCRAFT MAINTENANCE MANUAL**

- (b) Clean the surfaces with a clean cotton wiper, G00034, moist with alcohol, B00130.
- (c) Apply Bonderite M-CR 1001 Aero coating, C50153, to the cleaned surfaces, do this task: Bonderite M-CR 1001 Aero Application Process, TASK 51-21-41-370-801.
- (d) Put the part of the leading edge that contains the HF antenna in the correct position.
  - 1) Make sure that the attach plate is below the feedline tube [6].
- (e) Connect the feedline tube [6] to the attach plates.
  - 1) Install the screw [10] and washer [11].
- (f) Measure the electrical bonding resistance between the feedline tube [6] and structure (PAGEBLOCK 20-10-37/601, SWPM 20-20-00).
  - 1) Use an intrinsically safe approved bonding meter, COM-1550.
  - 2) Make sure that the bonding resistance is 0.001 ohm (1 milliohm) or less.
- (g) If the resistance between the feedline tube [6] and structure is more than 0.001 ohm (1 milliohm), clean the feedline tube [6] again.
- (h) Apply coating, G50961, to the mating surfaces of the installed parts.
- (i) Tighten the screw [10] to 80 in-lb (9.0 N·m).

**LOM 422-434, 437-447, 450-999**

- (j) Apply sealant, A50231 to make a fillet seal around the screw [10], washer [11] and the nutplate on the feedline tube [6].

**LOM ALL**

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 panel:
    - 1) Make sure that the clearance for the fixed leading edge panel, 322A [1], fixed leading edge panel, 322AL [2], fixed leading edge panel, 322AR [3], and removable leading edge panel, 322B [4] is 0.08 +0.06 / -0.04 in. (2.03 +1.52 / -1.02 mm).
    - 2) Make sure that the clearance for the removable leading edge panel, 322C [5] is 0.08 +0.06 / -0.04 in. (2.03 +1.52 / -1.02 mm) on the upper edge and 0.14 +0.06 / -0.04 in. (3.56 +1.52 / -1.02 mm) on the bottom edge.
  - (b) Make sure that the misfair is less than or equal to 0.010 in. (0.254 mm).
  - (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 55-33-11-410-002

- (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 fasteners with aerodynamic sealant, A00247.

EFFECTIVITY  
**LOM ALL**

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**G. Put the Airplane Back to Its Usual Condition**

SUBTASK 55-33-11-860-002

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

**CAPT Electrical System Panel, P18-2**

Row    Col    Number    Name

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-431, 433, 434, 437-447, 450-999  
E        11      C00839     COMMUNICATIONS HF 1

**F/O Electrical System Panel, P6-1**

Row    Col    Number    Name

LOM 404, 412, 415, 416, 422-426, 433, 434, 439-445, 451-454, 457, 464-999  
D        2        C00857     COMMUNICATIONS HF 2

**LOM ALL**

These circuit breakers are inoperative and should remain open:

**CAPT Electrical System Panel, P18-2**

Row    Col    Number    Name

**LOM 432**  
E        11      C00839     COMMUNICATIONS HF 1 (INOP)

**F/O Electrical System Panel, P6-1**

Row    Col    Number    Name

LOM 402, 406, 407, 411, 420, 427-432, 437, 438, 446, 447, 450, 455, 456, 458-463  
D        2        C00857     COMMUNICATIONS HF 2 (INOP)

**LOM ALL**

**H. 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 ————



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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.
- B. The (fin) tip includes a forward, a middle and an aft fairing. You can remove the forward and the aft fairings independently. You must remove the forward fairing before you remove the middle fairing.

**TASK 55-33-21-000-801**

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

(Figure 401)

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
326	Vertical Fin - Fin Tip

**B. 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>
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>
E	2	C00412	INSTR XFR

**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

SUBTASK 55-33-21-020-001



**WARNING**

MAKE SURE THAT PERSONNEL STAY A MINIMUM OF 10 FT (3 M) AWAY FROM THE VERTICAL STABILIZER WHEN THE HF SYSTEM TRANSMITS. RF ENERGY FROM THE HF ANTENNA CAN CAUSE INJURIES TO PERSONNEL.

- (2) Remove the fairings on the (fin) tip.
  - (a) Remove the fasteners from the forward fairing.
  - (b) Remove the forward fairing.
  - (c) Disconnect the wires from the VOR antenna.
  - (d) Remove the fasteners from the middle fairing.
  - (e) Remove the middle fairing.
  - (f) Remove the fasteners from the aft fairing.
  - (g) Remove the aft fairing.

— END OF TASK —

EFFECTIVITY  
LOM ALL

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**TASK 55-33-21-400-801**

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

(Figure 401)

**A. 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)

**B. 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

**C. Location Zones**

Zone	Area
326	Vertical Fin - Fin Tip

**D. Vertical Stabilizer (Fin) Tip Installation**

SUBTASK 55-33-21-420-001



**WARNING** MAKE SURE THAT PERSONNEL STAY A MINIMUM OF 10 FT (3 M) AWAY

FROM THE VERTICAL STABILIZER WHEN THE HF SYSTEM TRANSMITS. RF ENERGY FROM THE HF ANTENNA CAN CAUSE INJURIES TO PERSONNEL.

- (1) Install the fairings on the (fin) tip.

- (a) Put the aft fairing in its position on the fin.
- (b) Install the fasteners in the aft fairing.
- (c) Put the middle fairing in its position.
- (d) Install the fasteners on the middle fairing.
- (e) Connect the VOR antenna wires.
- (f) Put the forward fairing in its position.
- (g) Install the fasteners on the forward fairing.

NOTE: Make sure 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 55-33-21-390-001

- (2) Apply sealant, A00247 or sealant, A50359, between the forward fairing [1] and middle fairing [2] to make an aerodynamic seal.

SUBTASK 55-33-21-390-002

- (3) Apply sealant, A00247 or sealant, A50359, between the middle fairing [2] and aft fairing [4] to make an aerodynamic seal.

EFFECTIVITY  
LOM ALL

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SUBTASK 55-33-21-860-001

- (4) 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>
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>
E	2	C00412	INSTR XFR

**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

SUBTASK 55-33-21-730-001

- (5) Do this task: Instrument Landing System - Operational Test, TASK 34-31-00-710-801.

SUBTASK 55-33-21-710-001

- (6) Do this task: VOR System - Operational Test, TASK 34-51-00-710-801.

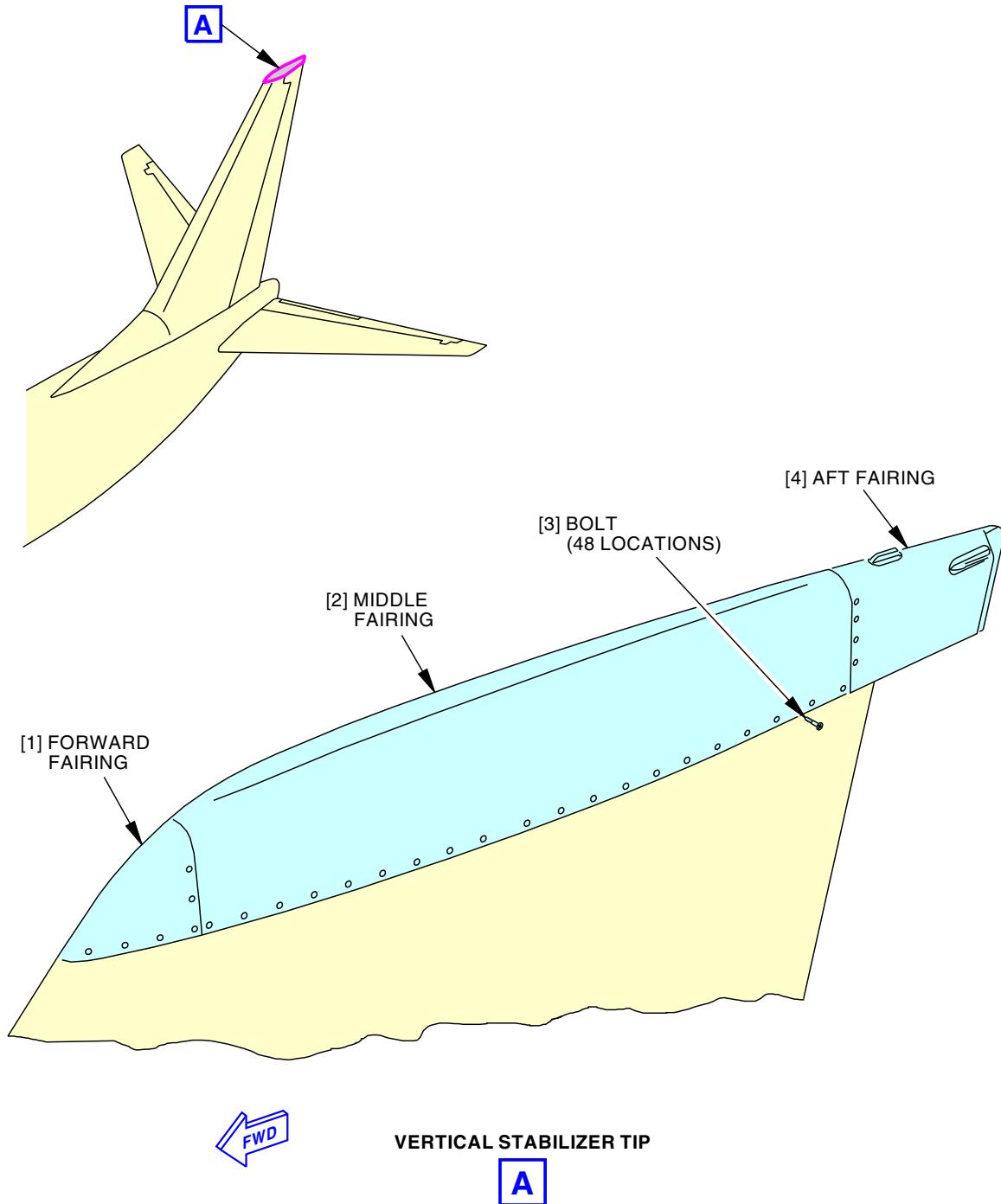
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**55-33-21**



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**Vertical Stabilizer Tip Installation**  
**Figure 401/55-33-21-990-801**

EFFECTIVITY  
LOM ALL

**55-33-21**

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VERTICAL STABILIZER (FIN) TRAILING EDGE PANELS - REMOVAL/INSTALLATION

**1. General**

- A. There are two tasks in this procedure:
  - (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**

**A. Tools/Equipment**

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

Reference	Description
SPL-1558	Adapter - Access Panel, Leverage
	Part #: 3008-550 Supplier: 55856
	Part #: B20004-42 Supplier: 81205
	Opt Part #: B20004-21 Supplier: 81205

**B. Location Zones**

Zone	Area
324	Vertical Fin - Rear Spar To Trailing Edge

**C. Access Panels**

Number	Name/Location
324AL	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

**D. Removal**

**SUBTASK 55-33-31-010-001**



**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) Select the trailing edge panel that you will remove and do this step:

Open these access panels:

**Number      Name/Location**

324AL      Vertical Fin, Aft Fin Access Door

EFFECTIVITY  
LOM ALL

**55-33-31**



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(Continued)

<u>Number</u>	<u>Name/Location</u>
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 55-33-31-010-002

- (2) Remove the fasteners from the applicable vertical fin trailing edge access panels.
  - (a) The following can help remove the fasteners:
    - 1) A leverage access panel adapter, SPL-1558.
- (3) Remove the panel.

— END OF TASK —

**TASK 55-33-31-400-801**

**3. Vertical Stabilizer (Fin) Trailing Edge Panels Installation**

**A. Consumable Materials**

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

**B. Location Zones**

<u>Zone</u>	<u>Area</u>
324	Vertical Fin - Rear Spar To Trailing Edge

**C. Access 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

**D. 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) Select the trailing edge panel that you will install and do this step:

EFFECTIVITY  
LOM ALL

**55-33-31**



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**AIRCRAFT MAINTENANCE MANUAL**

Close these access 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.

**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 outside contour.

NOTE: Largest gap should be less than 0.15 in. (3.81 mm).

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

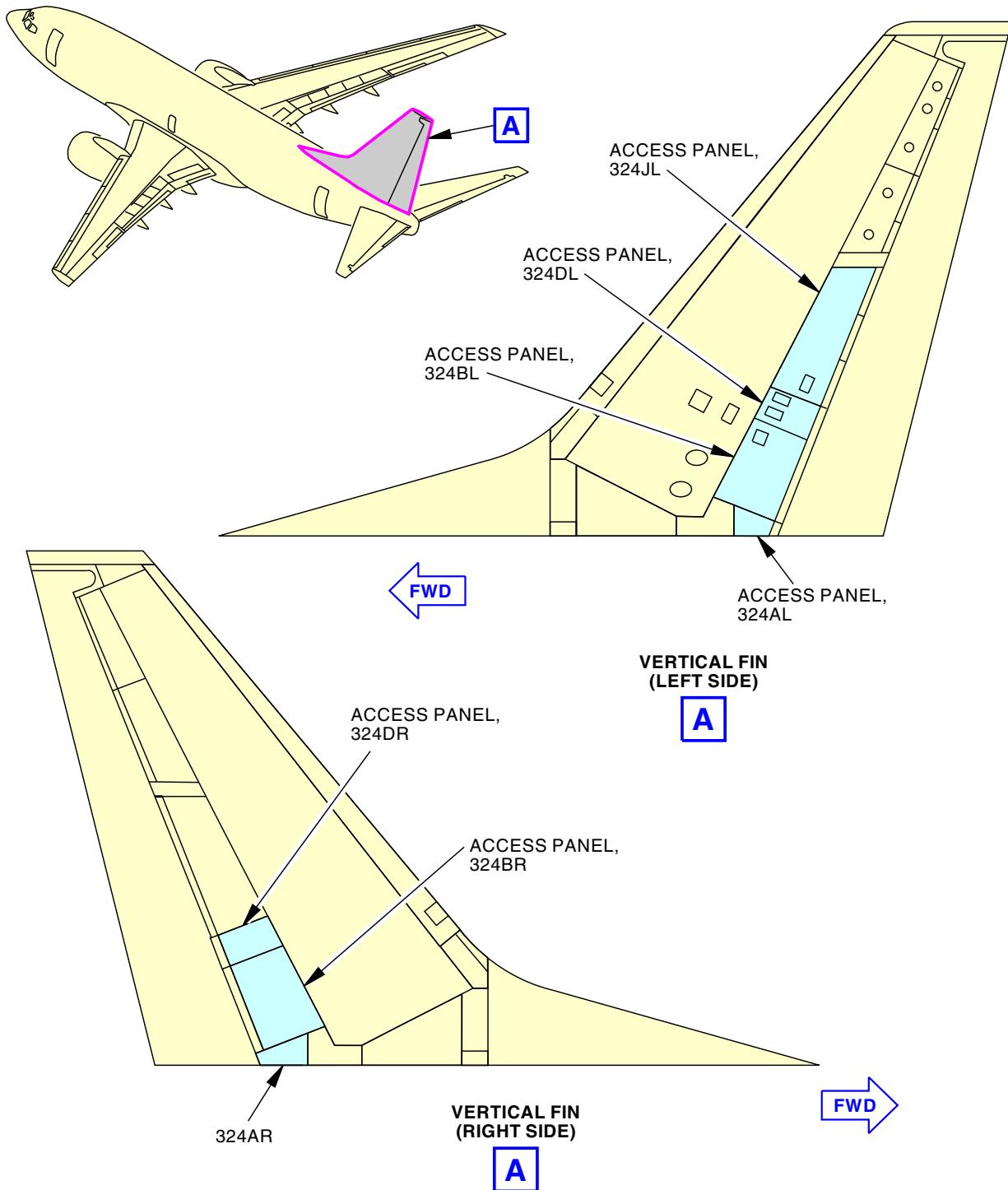
**55-33-31**

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1696272 S0000308488\_V2

**Vertical Stabilizer (Fin) Trailing Edge Panels Installation**  
**Figure 401/55-33-31-990-801**

EFFECTIVITY  
LOM ALL

**55-33-31**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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VERTICAL STABILIZER HF ANTENNA LEADING EDGE PANEL - REPAIRS

**1. General**

- A. This procedure contains these tasks:
- (1) Inspection of the HF Antenna Fiberglass Panel Leading Edge Panel No. 4 for damage to the erosion coating and the underlying anti-static coating.
  - (2) Replacement of the original finish.
  - (3) Application of Polyurethane Protective Tape (PPT) on the HF Antenna Fiberglass Panel Leading Edge Panel No. 4 as a temporary repair or as a preventative measure.
    - (a) When installing the PPT it is not required to edge seal the tape. Edge sealing increases durability and longevity of the PPT patch.
    - (b) If you do not edge seal the PPT patch, the PPT patch is considered cured 2 hours after the installation if the ambient temperature is 70°F (21°C).
    - (c) Not applying an edge seal to the PPT patch increases the risk of patch peeling or damage.

**TASK 55-35-01-200-801**

**2. HF Antenna Fiberglass Panel Leading Edge Panel No. 4 - Inspection**  
(Figure 801)

**A. Visually inspect the HF antenna fiberglass panel leading edge panel number 4.**

SUBTASK 55-35-01-860-001



**WARNING**

REMOVE ELECTRICAL POWER FOR THE HF COMMUNICATION SYSTEM BEFORE YOU PERFORM VERTICAL-STABILIZER HF-ANTENNA LEADING-EDGE-PANEL REPAIRS. HF SIGNALS CAN CAUSE ELECTRICAL SHOCKS AND INJURIES TO PERSONS.

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

**CAPT Electrical System Panel, P18-2**

Row   Col   Number   Name

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-431, 433, 434, 437-447, 450-999  
E        11      C00839     COMMUNICATIONS HF 1

**F/O Electrical System Panel, P6-1**

Row   Col   Number   Name

LOM 404, 412, 415, 416, 422-426, 433, 434, 439-445, 451-454, 457, 464-999

D        2      C00857     COMMUNICATIONS HF 2

LOM ALL

These circuit breakers are inoperative and should remain open:

**CAPT Electrical System Panel, P18-2**

Row   Col   Number   Name

LOM 432

E        11      C00839     COMMUNICATIONS HF 1 (INOP)

EFFECTIVITY  
LOM ALL

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LOM 432 (Continued)

F/O Electrical System Panel, P6-1

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
------------	------------	---------------	-------------

LOM 402, 406, 407, 411, 420, 427-432, 437, 438, 446, 447, 450, 455, 456, 458-463	D	2	C00857 COMMUNICATIONS HF 2 (INOP)
--	---	---	-----------------------------------

LOM ALL

SUBTASK 55-35-01-211-005

- (2) Look for the conditions that follow.
  - (a) Damaged structure.
  - (b) Missing Caapcoat FP-200 erosion coating.
  - (c) Missing BMS 10-21 Type II or Type IV anti-static coating.

SUBTASK 55-35-01-211-001

- (3) Look for the conditions that follow.

NOTE: There must be no evidence 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 55-35-01-211-002

- (4) If there is no peeling of the erosion coating, do one of the steps that follow.
  - (a) No further action is necessary.
  - (b) Do the steps in Polyurethane Protective Tape (PPT) - Installation, TASK 55-35-01-400-801 to install the Polyurethane Protective Tape (PPT) for added protection.

NOTE: Installing PPT is not required but it can increase the durability and longevity of the HF antenna fiberglass panel leading edge panel installation.

SUBTASK 55-35-01-211-003

- (5) If there is peeling of the erosion coating and/or anti-static coating but no damage to the fiberglass composite structure, do one of the steps that follow.
  - (a) Temporarily repair the area, do this task: Polyurethane Protective Tape (PPT) - Installation, TASK 55-35-01-400-801.
  - (b) Repair the original finish by re-applying the finish per Leading Edge Finish - Installation, TASK 55-35-01-400-802.
  - (c) Repair the HF antenna fiberglass panel leading edge panel number 4, do this task: SRM 55-30-01.

SUBTASK 55-35-01-200-003

- (6) If you installed PPT as a temporary repair when the erosion coating is damaged, do this step.
  - (a) Do a visual inspection and tap test for damage each 500 flight cycles:
    - 1) If any discrepancies are found, do a temporary or permanent repair.
    - 2) If no discrepancies are found, do a permanent repair at the next major check.

SUBTASK 55-35-01-211-004

- (7) If there is damage to the composite structure, do the steps that follow.

EFFECTIVITY
LOM ALL

**55-35-01**



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- (a) See SRM 55-30-01 to determine if the panel can be repaired.
- 1) If the panel can be repaired, do the repair.
    - a) After the repair, re-apply the coatings per Leading Edge Finish - Installation, TASK 55-35-01-400-802.  
<1> For added protection after you re-apply the coatings, add the polyurethane protective tape (optional, Polyurethane Protective Tape (PPT) - Installation, TASK 55-35-01-400-801).
  - 2) If the panel cannot be repaired, replace the panel.

SUBTASK 55-35-01-860-002

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

**CAPT Electrical System Panel, P18-2**

Row   Col   Number   Name

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-431, 433, 434, 437-447, 450-999  
E      11    C00839    COMMUNICATIONS HF 1

**F/O Electrical System Panel, P6-1**

Row   Col   Number   Name

LOM 404, 412, 415, 416, 422-426, 433, 434, 439-445, 451-454, 457, 464-999  
D      2      C00857    COMMUNICATIONS HF 2

**LOM ALL**

These circuit breakers are inoperative and should remain open:

**CAPT Electrical System Panel, P18-2**

Row   Col   Number   Name

LOM 432  
E      11    C00839    COMMUNICATIONS HF 1 (INOP)

**F/O Electrical System Panel, P6-1**

Row   Col   Number   Name

LOM 402, 406, 407, 411, 420, 427-432, 437, 438, 446, 447, 450, 455, 456, 458-463  
D      2      C00857    COMMUNICATIONS HF 2 (INOP)

**LOM ALL**

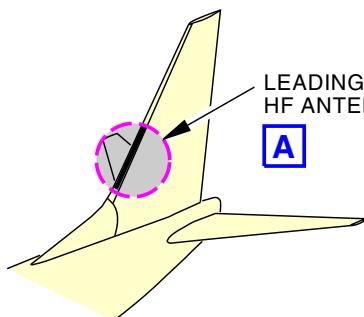
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

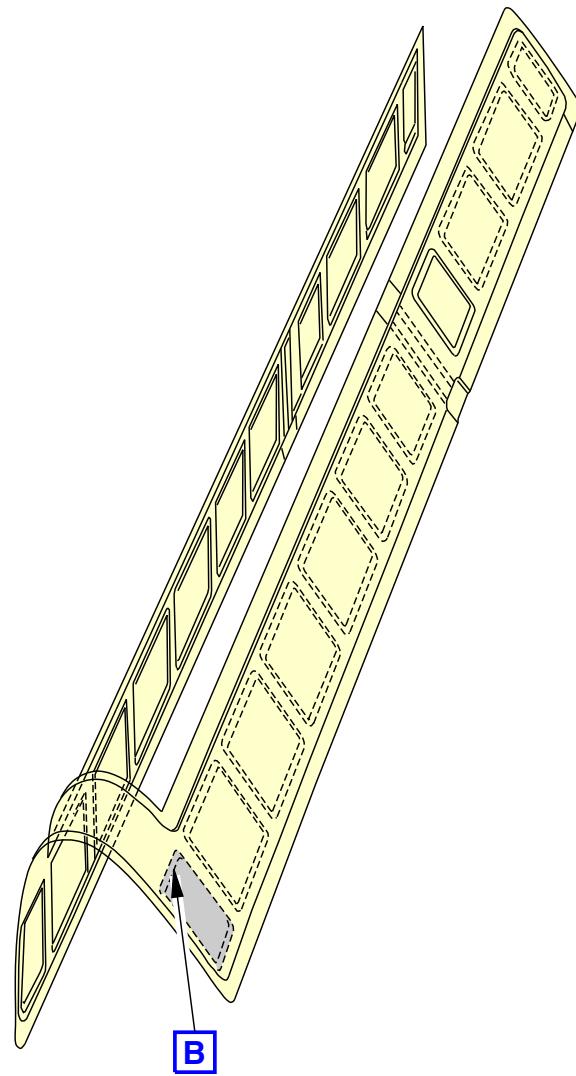
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VERTICAL  
STABILIZER



LEADING EDGE PANEL NO. 4, HF ANTENNA  
FIBERGLASS PANEL



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HF Antenna Fiberglass Panel Leading Edge Panel No. 4  
Figure 801/55-35-01-990-801 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

**55-35-01**

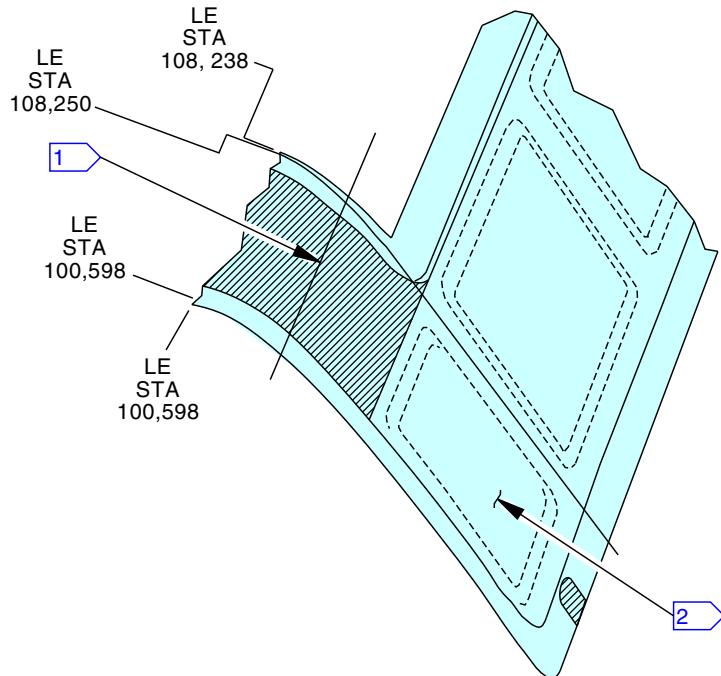
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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(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)

EFFECTIVITY  
LOM ALL

55-35-01

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**TASK 55-35-01-400-802**

**3. Leading Edge Finish - Installation**

**A. General**

- (1) This procedure gives instructions on how to replace the manufacturer painted leading edge finish.
- (2) Erosion of the finish on the leading edge of the HF antenna's fiberglass panel erosion area are shown in Figure 801.
  - (a) You can apply decorative paint over the erosion finish, but the decorative finish is not required and does not need to be replaced.
  - (b) Decorative paint applied over the erosion coat may affect the performance of the erosion finish.
- (3) Handle the panel with cotton, lint-free gloves, G01306.

**B. References**

<b>Reference</b>	<b>Title</b>
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)

**C. Consumable Materials**

<b>Reference</b>	<b>Description</b>	<b>Specification</b>
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)
G01306	Gloves - Lint-free	
G02428	Abrasive - Aluminum Oxide Paper, 150 grit	A-A-1048





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D. Prepare to Re-apply the Leading Edge Primer

SUBTASK 55-35-01-860-003



**WARNING**

REMOVE ELECTRICAL POWER FOR THE HF COMMUNICATION SYSTEM BEFORE YOU PERFORM VERTICAL-STABILIZER HF-ANTENNA LEADING-EDGE-PANEL REPAIRS. HF SIGNALS CAN CAUSE ELECTRICAL SHOCKS AND INJURIES TO PERSONS.

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

**CAPT Electrical System Panel, P18-2**

Row   Col   Number   Name

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-431, 433, 434, 437-447, 450-999

E      11      C00839      COMMUNICATIONS HF 1

**F/O Electrical System Panel, P6-1**

Row   Col   Number   Name

LOM 404, 412, 415, 416, 422-426, 433, 434, 439-445, 451-454, 457, 464-999

D      2      C00857      COMMUNICATIONS HF 2

**LOM ALL**

These circuit breakers are inoperative and should remain open:

**CAPT Electrical System Panel, P18-2**

Row   Col   Number   Name

**LOM 432**

E      11      C00839      COMMUNICATIONS HF 1 (INOP)

**F/O Electrical System Panel, P6-1**

Row   Col   Number   Name

LOM 402, 406, 407, 411, 420, 427-432, 437, 438, 446, 447, 450, 455, 456, 458-463

D      2      C00857      COMMUNICATIONS HF 2 (INOP)

**LOM ALL**

SUBTASK 55-35-01-150-001

- (2) Remove the remaining erosion coating if necessary (TASK 51-21-11-150-801).

SUBTASK 55-35-01-160-001

- (3) Prepare the surface for the application of the finish (TASK 51-21-21-100-802).

SUBTASK 55-35-01-160-002

- (4) Prepare the area that you will apply the primer on.

(a) Solvent clean the area.

(b) Abrade the side of the panel to be painted with 150 grit abrasive paper, G02428.

(c) Remove the residue 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  
**LOM ALL**

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- (a) Spray the primer, C00766, in a uniform 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 55-35-01-800-003

- (1) Prepare the Caapcoat FP-200 coating, C50006 (Figure 801).

- (a) Mix the Caapcoat FP-200 coating, C50006.

NOTE: Use thinner if necessary to achieve 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 a uniform 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	MIX RATION (PARTS BY VOLUME)	VISCOSITY, SECONDS ZAHN #2	MINIMUM RELATIVE HUMIDITY	DRY FILM THICKNESS, mils (mm)		CURE TIMES, HOURS		
				PER COAT	TOTAL	TO RECOAT	TO OVERCOAT	FINAL
LOM ALL								



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Table 801/55-35-01-993-801 (Continued)

MATERIAL	MIX RATION (PARTS BY VOLUME)	VISCOSITY, SECONDS ZAHN #2	MINIMUM RELATIVE HUMIDITY	DRY FILM THICKNESS, mils (mm)	CURE TIMES, HOURS		
					MAXIMUM: 1ST: 1.500 mils (0.038 mm) 2ND AND ON: 2.000 mils (0.051 mm)	10 mils (0 mm) TO 14 mils (0 mm)	MINIMUM: 1/3 HOUR MAXIMUM: 2 HOURS
FP-200 VEHICLE CURING AGENT ACCELERATOR	64 3 4 (RECOMMENDED)	22-28 AT 70°F (21°C) TO 80°F (27°C)	30				

\*[1] Cure can be made faster by 24 hours at room temperature followed by oven cure at 150°F (66°C) for 3 hours.

SUBTASK 55-35-01-370-001

- (3) Re-apply the enamel coating, C00033, or decorative exterior 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.

#### H. Put the Airplane Back to Its Usual Condition

SUBTASK 55-35-01-860-004

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

**CAPT Electrical System Panel, P18-2**

Row   Col   Number   Name

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-431, 433, 434, 437-447, 450-999  
 E        11      C00839     COMMUNICATIONS HF 1

**F/O Electrical System Panel, P6-1**

Row   Col   Number   Name

LOM 404, 412, 415, 416, 422-426, 433, 434, 439-445, 451-454, 457, 464-999  
 D        2       C00857     COMMUNICATIONS HF 2

LOM ALL

These circuit breakers are inoperative and should remain open:

**CAPT Electrical System Panel, P18-2**

Row   Col   Number   Name

LOM 432  
 E        11      C00839     COMMUNICATIONS HF 1 (INOP)

**F/O Electrical System Panel, P6-1**

Row   Col   Number   Name

LOM 402, 406, 407, 411, 420, 427-432, 437, 438, 446, 447, 450, 455, 456, 458-463  
 D        2       C00857     COMMUNICATIONS HF 2 (INOP)

LOM ALL

———— END OF TASK ————

EFFECTIVITY  
 LOM ALL



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TASK 55-35-01-400-801

4. Polyurethane Protective Tape (PPT) - Installation

A. Tools/Equipment

Reference	Description
STD-821	Squeegee - Plastic

B. Consumable Materials

Reference	Description	Specification
A50476	Adhesive - 3M Scotch-Weld DP190 Gray Epoxy	
B00130	Alcohol - Isopropyl	TT-I-735
C50006	Coating - Gloss Polyurethane - Caapcoat FP-200	BAC5880 TYPE I CLASS 5
C50020	Kit - Edge Seal With Activator (Desothane) - CA8000/B900B with CA8000B	BAC5312
C50328	Sealer - Two-Part, Polyurethane, Edge Sealer, Erosion Resistant (ES2000)	
G50078	Abrasive - Aluminum Oxide Paper, 320 grit or finer	
G50632	Towel - Paper, Wypall X80 (Packaged in Brag-Box, 1\4 Fold, Pop-Up Box and Jumbo Rolls)	
G51114	Tape - 3M 8673 Polyurethane Protective Tape	

C. Prepare to Install the Polyurethane Protective Tape (PPT)

SUBTASK 55-35-01-860-005



**WARNING**

REMOVE ELECTRICAL POWER FOR THE HF COMMUNICATION SYSTEM BEFORE YOU PERFORM VERTICAL-STABILIZER HF-ANTENNA LEADING-EDGE-PANEL REPAIRS. HF SIGNALS CAN CAUSE ELECTRICAL SHOCKS AND INJURIES TO PERSONS.

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

**CAPT Electrical System Panel, P18-2**

Row   Col   Number   Name

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-431, 433, 434, 437-447, 450-999  
E        11      C00839     COMMUNICATIONS HF 1

**F/O Electrical System Panel, P6-1**

Row   Col   Number   Name

LOM 404, 412, 415, 416, 422-426, 433, 434, 439-445, 451-454, 457, 464-999  
D        2       C00857     COMMUNICATIONS HF 2

LOM ALL

These circuit breakers are inoperative and should remain open:

**CAPT Electrical System Panel, P18-2**

Row   Col   Number   Name

LOM 432

EFFECTIVITY  
LOM ALL

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**LOM 432 (Continued)**

(Continued)

**CAPT Electrical System Panel, P18-2**

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

**F/O Electrical System Panel, P6-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
LOM 402, 406, 407, 411, 420, 427-432, 437, 438, 446, 447, 450, 455, 456, 458-463	D	2	COMMUNICATIONS HF 2 (INOP)

**LOM ALL**

SUBTASK 55-35-01-010-001

- (2) If you are installing the 3M 8673 tape, G51114 (or equivalent) as a temporary repair, do the steps that follow.
  - (a) If the existing 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 of removal is to peel off the Caapcoat FP-200 coating, C50006.
    - 2) If you cannot peel off the Caapcoat FP-200 coating, C50006, trim any loose material.
      - a) Make sure 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.

**D. Install the Polyurethane Protective Tape (PPT)**

(Figure 802)

SUBTASK 55-35-01-800-001

- (1) Cut the 3M 8673 tape, G51114 (or equivalent) to a size that overlaps the surface adjacent to the undamaged 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 liner from the 3M 8673 tape, G51114 (or equivalent).

SUBTASK 55-35-01-400-002

- (3) Do one of these two procedures to install the 3M 8673 tape, G51114 (or equivalent) to the area to cover:
  - (a) Install the 3M 8673 tape, G51114 (or equivalent) dry (Preferred Method).
    - 1) Put one end of the 3M 8673 tape, G51114 (or equivalent) onto the surface and use a plastic squeegee, STD-821 to make sure there is no air between the tape and the HF leading edge as you apply the tape.



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- (b) Install the 3M 8673 tape, G51114 (or equivalent) wet (Alternative Method).
- 1) Apply a solution of one part detergent to 50 parts water to the HF leading edge.
  - 2) Put one end of the 3M 8673 tape, G51114 (or equivalent) onto the surface and use a plastic squeegee, STD-821 to make sure there is no air or detergent between the tape and the HF leading edge as you apply the tape.
  - 3) Rub the tape down satisfactorily with a clean cheesecloth (G60070).

**SUBTASK 55-35-01-400-003**

- (4) Apply sealer, C50328 (Preferred), or Scotch-Weld DP190 epoxy adhesive, A50476 (Alternative), or CA8000/B900B with CA8000B kit, C50020 (Alternative) 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 (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 is cured.
- (a) Rub your fingernail perpendicular to the edge seal.
  - 1) Start at the adjacent substrate and continue onto the marker.

**SUBTASK 55-35-01-800-002**

- (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 be cured.

**SUBTASK 55-35-01-860-006**

- (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>
------------	------------	---------------	-------------

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-431, 433, 434, 437-447, 450-999  
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>
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LOM 404, 412, 415, 416, 422-426, 433, 434, 439-445, 451-454, 457, 464-999  
D 2 C00857 COMMUNICATIONS HF 2

**LOM ALL**

These circuit breakers are inoperative and should remain open:

**CAPT Electrical System Panel, P18-2**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
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**LOM 432**  
E 11 C00839 COMMUNICATIONS HF 1 (INOP)

**F/O Electrical System Panel, P6-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
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**LOM 402, 406, 407, 411, 420, 427-432, 437, 438, 446, 447, 450, 455, 456, 458-463**  
D 2 C00857 COMMUNICATIONS HF 2 (INOP)

EFFECTIVITY  
**LOM ALL**

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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

LOM ALL

———— END OF TASK ————

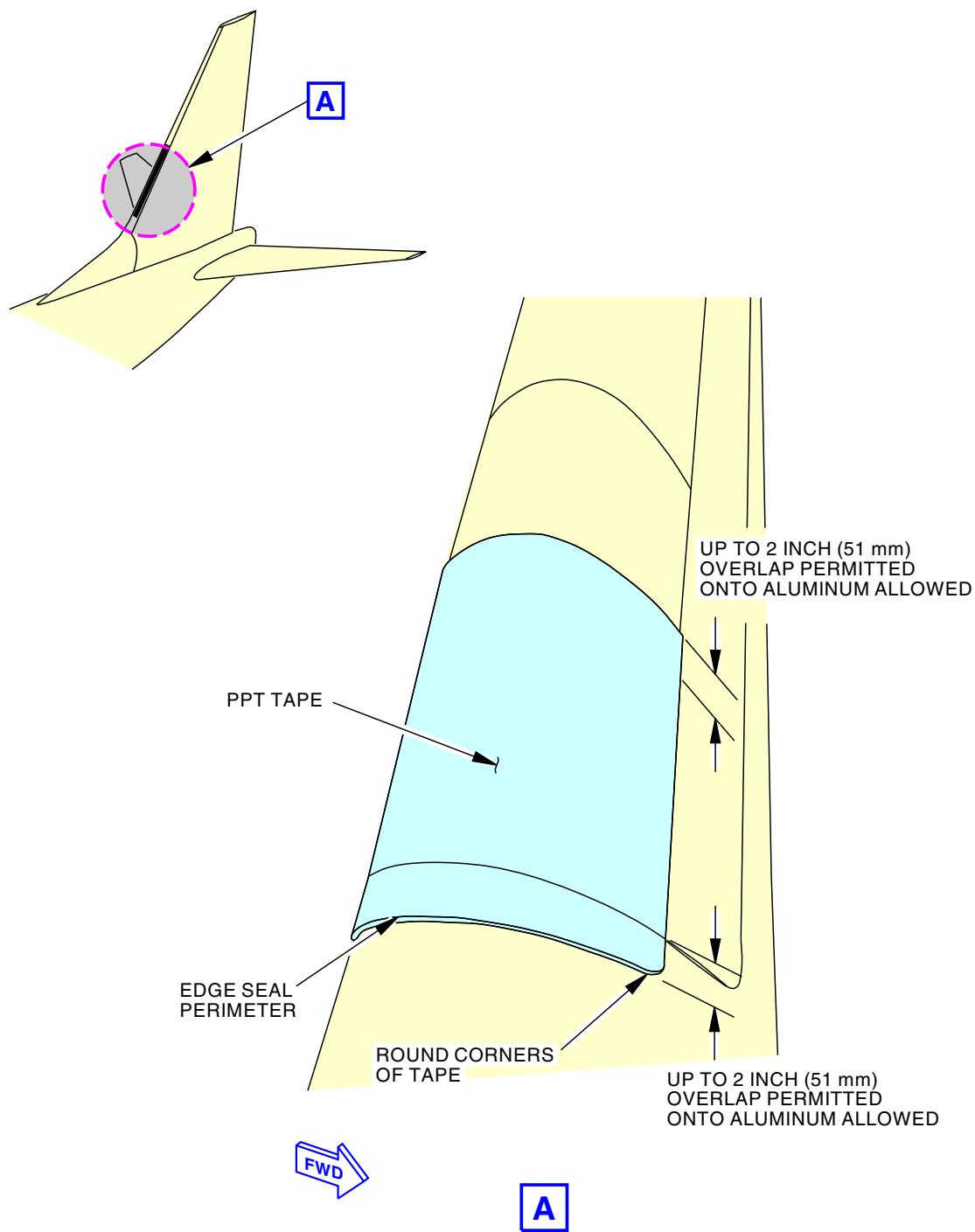
EFFECTIVITY  
LOM ALL

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**BOEING**  
 737-600/700/800/900  
 AIRCRAFT MAINTENANCE MANUAL



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**Polyurethane Protective Tape (PPT) - Installation**  
**Figure 802/55-35-01-990-802**

EFFECTIVITY  
 LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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