

**CHAPTER**

**53**

**FUSELAGE**





**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 53**  
**FUSELAGE**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
53-EFFECTIVE PAGES			53-05-02			53-05-02 (cont)		
1 thru 9	Feb 15/2025		201	Oct 15/2023		237	Oct 15/2023	
10	BLANK		202	Oct 15/2023		238	Oct 15/2023	
53-CONTENTS			203	Oct 15/2023		239	Oct 15/2023	
1	Oct 15/2023		204	Oct 15/2023		240	Oct 15/2023	
2	Oct 15/2023		205	Oct 15/2023		241	Oct 15/2023	
3	Oct 15/2024		206	Oct 15/2023		242	Oct 15/2023	
4	Feb 15/2024		207	Oct 15/2023		243	Oct 15/2023	
5	Oct 15/2023		208	Oct 15/2023		244	Oct 15/2023	
6	Jun 15/2024		209	Oct 15/2023		245	Oct 15/2023	
7	Jun 15/2024		210	Oct 15/2023		246	Oct 15/2023	
8	Jun 15/2024		211	Oct 15/2023		247	Oct 15/2023	
9	Oct 15/2024		212	Oct 15/2023		248	Oct 15/2024	
10	Jun 15/2024		213	Oct 15/2023		249	Oct 15/2024	
11	Jun 15/2024		214	Oct 15/2023		250	Feb 15/2024	
12	Jun 15/2024		215	Oct 15/2023		251	Oct 15/2023	
13	Oct 15/2024		216	Oct 15/2023		252	Oct 15/2023	
14	Jun 15/2024		217	Oct 15/2023		253	Oct 15/2023	
15	Jun 15/2024		218	Oct 15/2023		254	Oct 15/2023	
16	Jun 15/2024		219	Oct 15/2023		255	Oct 15/2023	
17	Jun 15/2024		220	Oct 15/2023		256	Oct 15/2023	
18	Oct 15/2022		221	Oct 15/2023		257	Oct 15/2023	
O 19	Feb 15/2025		222	Oct 15/2023		258	Oct 15/2023	
O 20	Feb 15/2025		223	Oct 15/2023		259	Oct 15/2023	
O 21	Feb 15/2025		224	Oct 15/2023		260	Oct 15/2023	
O 22	Feb 15/2025		225	Oct 15/2023		261	Oct 15/2023	
23	Feb 15/2023		226	Oct 15/2023		262	Oct 15/2023	
24	Oct 15/2024		227	Oct 15/2023		263	Oct 15/2023	
25	Oct 15/2023		228	Oct 15/2023		264	Oct 15/2023	
26	Oct 15/2022		229	Oct 15/2023		265	Oct 15/2023	
27	Feb 15/2023		230	Oct 15/2023		266	Oct 15/2023	
28	Oct 15/2023		231	Oct 15/2023		267	Oct 15/2023	
53-00-00			232	Oct 15/2023		268	Oct 15/2023	
201	Oct 15/2015		233	Oct 15/2023		269	Oct 15/2023	
202	Jun 15/2019		234	Oct 15/2023		270	Oct 15/2023	
53-00-37			235	Oct 15/2023		271	Oct 15/2023	
201	Oct 15/2014		236	Oct 15/2023		272	Oct 15/2023	
202	BLANK							

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

**53-EFFECTIVE PAGES**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 53**  
**FUSELAGE**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
53-05-02 (cont)			53-05-02 (cont)			53-05-02 (cont)		
273	Oct 15/2023		298.11	Jun 15/2024		298.47	Jun 15/2024	
274	Oct 15/2023		298.12	Jun 15/2024		298.48	Jun 15/2024	
275	Oct 15/2023		298.13	Jun 15/2024		298.49	Jun 15/2024	
276	Oct 15/2023		298.14	Jun 15/2024		298.50	Jun 15/2024	
277	Oct 15/2023		298.15	Jun 15/2024		298.51	Jun 15/2024	
278	Oct 15/2023		298.16	Jun 15/2024		298.52	Jun 15/2024	
279	Oct 15/2023		298.17	Jun 15/2024		298.53	Jun 15/2024	
280	Feb 15/2024		298.18	Jun 15/2024		298.54	Jun 15/2024	
281	Oct 15/2023		298.19	Jun 15/2024		298.55	Jun 15/2024	
282	Oct 15/2023		298.20	Jun 15/2024		298.56	Jun 15/2024	
283	Feb 15/2024		298.21	Jun 15/2024		298.57	Jun 15/2024	
284	Oct 15/2023		298.22	Jun 15/2024		298.58	Jun 15/2024	
285	Oct 15/2023		298.23	Jun 15/2024		298.59	Jun 15/2024	
286	Oct 15/2023		298.24	Jun 15/2024		298.60	Jun 15/2024	
287	Oct 15/2023		298.25	Jun 15/2024		298.61	Jun 15/2024	
R 288	Feb 15/2025		298.26	Jun 15/2024		298.62	Jun 15/2024	
R 289	Feb 15/2025		298.27	Jun 15/2024		298.63	Jun 15/2024	
290	Jun 15/2024		298.28	Jun 15/2024		298.64	Jun 15/2024	
291	Jun 15/2024		298.29	Jun 15/2024		298.65	Jun 15/2024	
292	Jun 15/2024		298.30	Jun 15/2024		298.66	Jun 15/2024	
293	Jun 15/2024		298.31	Jun 15/2024		298.67	Jun 15/2024	
294	Jun 15/2024		298.32	Jun 15/2024		298.68	Jun 15/2024	
295	Jun 15/2024		298.33	Jun 15/2024		298.69	Jun 15/2024	
296	Jun 15/2024		298.34	Jun 15/2024		298.70	Jun 15/2024	
297	Jun 15/2024		298.35	Jun 15/2024		298.71	Jun 15/2024	
298	Jun 15/2024		298.36	Jun 15/2024		298.72	Jun 15/2024	
298.1	Jun 15/2024		298.37	Jun 15/2024		298.73	Jun 15/2024	
298.2	Jun 15/2024		298.38	Jun 15/2024		298.74	Jun 15/2024	
R 298.3	Feb 15/2025		298.39	Jun 15/2024		298.75	Jun 15/2024	
298.4	Jun 15/2024		298.40	Oct 15/2024		298.76	Jun 15/2024	
298.5	Jun 15/2024		298.41	Oct 15/2024		298.77	Jun 15/2024	
298.6	Jun 15/2024		298.42	Oct 15/2024		298.78	Jun 15/2024	
298.7	Jun 15/2024		298.43	Oct 15/2024		298.79	Jun 15/2024	
298.8	Jun 15/2024		298.44	Jun 15/2024		298.80	Jun 15/2024	
298.9	Jun 15/2024		298.45	Oct 15/2024		298.81	Jun 15/2024	
298.10	Jun 15/2024		298.46	Jun 15/2024		298.82	Jun 15/2024	

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**53-EFFECTIVE PAGES**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 53**  
**FUSELAGE**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
53-05-02 (cont)			53-05-02 (cont)			53-05-02 (cont)		
298.83	Jun 15/2024		298.119	Jun 15/2024		298.155	Jun 15/2024	
298.84	Jun 15/2024		298.120	Jun 15/2024		298.156	Jun 15/2024	
298.85	Jun 15/2024		298.121	Jun 15/2024		298.157	Jun 15/2024	
298.86	Jun 15/2024		298.122	Jun 15/2024		298.158	Jun 15/2024	
298.87	Jun 15/2024		298.123	Jun 15/2024		298.159	Jun 15/2024	
298.88	Jun 15/2024		298.124	Jun 15/2024		298.160	Jun 15/2024	
298.89	Jun 15/2024		298.125	Jun 15/2024		298.161	Jun 15/2024	
298.90	Jun 15/2024		298.126	Jun 15/2024		298.162	BLANK	
298.91	Oct 15/2024		298.127	Jun 15/2024		53-05-03		
298.92	Oct 15/2024		298.128	Jun 15/2024		201	Feb 15/2015	
298.93	Jun 15/2024		298.129	Jun 15/2024		202	Oct 15/2015	
298.94	Jun 15/2024		298.130	Jun 15/2024		203	Oct 15/2023	
298.95	Jun 15/2024		298.131	Jun 15/2024		204	Oct 15/2015	
298.96	Jun 15/2024		298.132	Jun 15/2024		205	Feb 15/2015	
298.97	Jun 15/2024		298.133	Jun 15/2024		206	Oct 15/2015	
298.98	Jun 15/2024		298.134	Jun 15/2024		207	Feb 15/2015	
298.99	Jun 15/2024		298.135	Jun 15/2024		208	Feb 15/2016	
298.100	Jun 15/2024		298.136	Jun 15/2024		209	Feb 15/2015	
298.101	Jun 15/2024		298.137	Jun 15/2024		210	Feb 15/2016	
298.102	Jun 15/2024		298.138	Jun 15/2024		211	Feb 15/2015	
298.103	Jun 15/2024		298.139	Jun 15/2024		212	Oct 15/2015	
298.104	Jun 15/2024		298.140	Jun 15/2024		213	Oct 15/2015	
298.105	Jun 15/2024		298.141	Jun 15/2024		214	Feb 15/2016	
298.106	Jun 15/2024		298.142	Jun 15/2024		215	Oct 15/2015	
298.107	Jun 15/2024		298.143	Jun 15/2024		216	Oct 15/2015	
298.108	Jun 15/2024		298.144	Jun 15/2024		217	Oct 15/2015	
298.109	Jun 15/2024		298.145	Jun 15/2024		218	Feb 15/2015	
298.110	Jun 15/2024		298.146	Jun 15/2024		219	Oct 15/2015	
298.111	Jun 15/2024		298.147	Jun 15/2024		220	Feb 15/2015	
298.112	Jun 15/2024		298.148	Jun 15/2024		221	Oct 15/2015	
298.113	Jun 15/2024		298.149	Jun 15/2024		222	Feb 15/2015	
298.114	Jun 15/2024		298.150	Jun 15/2024		223	Oct 15/2015	
298.115	Jun 15/2024		298.151	Jun 15/2024		224	Oct 15/2018	
298.116	Jun 15/2024		298.152	Jun 15/2024		225	Oct 15/2018	
298.117	Jun 15/2024		298.153	Jun 15/2024		226	Oct 15/2017	
298.118	Jun 15/2024		298.154	Jun 15/2024		227	Oct 15/2017	

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**53-EFFECTIVE PAGES**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 53**  
**FUSELAGE**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
53-05-03 (cont)			53-05-03 (cont)			53-05-03 (cont)		
228	Oct 15/2022		R 264	Feb 15/2025		O 298.2	Feb 15/2025	
229	Oct 15/2022		R 265	Feb 15/2025		O 298.3	Feb 15/2025	
230	Oct 15/2022		R 266	Feb 15/2025		O 298.4	Feb 15/2025	
231	Oct 15/2022		O 267	Feb 15/2025		O 298.5	Feb 15/2025	
232	Oct 15/2022		O 268	Feb 15/2025		O 298.6	Feb 15/2025	
233	Oct 15/2022		O 269	Feb 15/2025		O 298.7	Feb 15/2025	
234	Oct 15/2022		O 270	Feb 15/2025		O 298.8	Feb 15/2025	
235	Oct 15/2022		O 271	Feb 15/2025		O 298.9	Feb 15/2025	
236	Oct 15/2022		O 272	Feb 15/2025		O 298.10	Feb 15/2025	
237	Oct 15/2022		O 273	Feb 15/2025		O 298.11	Feb 15/2025	
238	Oct 15/2022		O 274	Feb 15/2025		O 298.12	Feb 15/2025	
239	Oct 15/2022		O 275	Feb 15/2025		O 298.13	Feb 15/2025	
240	Oct 15/2022		O 276	Feb 15/2025		O 298.14	Feb 15/2025	
241	Oct 15/2022		O 277	Feb 15/2025		O 298.15	Feb 15/2025	
242	Oct 15/2022		O 278	Feb 15/2025		O 298.16	Feb 15/2025	
243	Oct 15/2022		O 279	Feb 15/2025		O 298.17	Feb 15/2025	
244	Oct 15/2022		O 280	Feb 15/2025		O 298.18	Feb 15/2025	
245	Oct 15/2022		R 281	Feb 15/2025		O 298.19	Feb 15/2025	
246	Oct 15/2022		O 282	Feb 15/2025		O 298.20	Feb 15/2025	
247	Oct 15/2022		O 283	Feb 15/2025		O 298.21	Feb 15/2025	
248	Oct 15/2022		O 284	Feb 15/2025		O 298.22	Feb 15/2025	
249	Oct 15/2022		O 285	Feb 15/2025		O 298.23	Feb 15/2025	
250	Oct 15/2022		O 286	Feb 15/2025		O 298.24	Feb 15/2025	
251	Oct 15/2022		O 287	Feb 15/2025		O 298.25	Feb 15/2025	
252	Oct 15/2022		O 288	Feb 15/2025		O 298.26	Feb 15/2025	
253	Oct 15/2022		O 289	Feb 15/2025		O 298.27	Feb 15/2025	
254	Oct 15/2022		O 290	Feb 15/2025		O 298.28	Feb 15/2025	
255	Oct 15/2022		O 291	Feb 15/2025		O 298.29	Feb 15/2025	
R 256	Feb 15/2025		O 292	Feb 15/2025		O 298.30	Feb 15/2025	
257	Oct 15/2022		O 293	Feb 15/2025		O 298.31	Feb 15/2025	
258	Oct 15/2022		O 294	Feb 15/2025		O 298.32	Feb 15/2025	
259	Oct 15/2023		O 295	Feb 15/2025		O 298.33	Feb 15/2025	
260	Oct 15/2022		O 296	Feb 15/2025		O 298.34	Feb 15/2025	
261	Oct 15/2022		O 297	Feb 15/2025		O 298.35	Feb 15/2025	
R 262	Feb 15/2025		O 298	Feb 15/2025		O 298.36	Feb 15/2025	
R 263	Feb 15/2025		O 298.1	Feb 15/2025		O 298.37	Feb 15/2025	

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**53-EFFECTIVE PAGES**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 53**  
**FUSELAGE**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
53-05-03 (cont)			53-05-03 (cont)			53-11-01 (cont)		
O 298.38	Feb 15/2025		O 298.74	Feb 15/2025		405	Feb 15/2023	
O 298.39	Feb 15/2025		O 298.75	Feb 15/2025		406	Feb 15/2023	
O 298.40	Feb 15/2025		O 298.76	Feb 15/2025		407	Feb 15/2024	
O 298.41	Feb 15/2025		O 298.77	Feb 15/2025		408	Feb 15/2023	
O 298.42	Feb 15/2025		O 298.78	Feb 15/2025		409	Oct 15/2024	
O 298.43	Feb 15/2025		O 298.79	Feb 15/2025		410	Oct 15/2024	
O 298.44	Feb 15/2025		O 298.80	Feb 15/2025		411	Feb 15/2024	
O 298.45	Feb 15/2025		O 298.81	Feb 15/2025		412	BLANK	
O 298.46	Feb 15/2025		O 298.82	Feb 15/2025		53-11-02		
O 298.47	Feb 15/2025		O 298.83	Feb 15/2025		401	Oct 15/2021	
O 298.48	Feb 15/2025		O 298.84	Feb 15/2025		402	Oct 15/2024	
O 298.49	Feb 15/2025		O 298.85	Feb 15/2025		403	Oct 15/2024	
O 298.50	Feb 15/2025		O 298.86	Feb 15/2025		404	Oct 15/2024	
O 298.51	Feb 15/2025		O 298.87	Feb 15/2025		405	Oct 15/2021	
O 298.52	Feb 15/2025		O 298.88	Feb 15/2025		406	Oct 15/2024	
O 298.53	Feb 15/2025		O 298.89	Feb 15/2025		407	Oct 15/2021	
O 298.54	Feb 15/2025		O 298.90	Feb 15/2025		408	Oct 15/2024	
O 298.55	Feb 15/2025		O 298.91	Feb 15/2025		409	Oct 15/2021	
O 298.56	Feb 15/2025		O 298.92	Feb 15/2025		410	Oct 15/2024	
O 298.57	Feb 15/2025		O 298.93	Feb 15/2025		411	Oct 15/2024	
O 298.58	Feb 15/2025		O 298.94	Feb 15/2025		412	Oct 15/2024	
O 298.59	Feb 15/2025		O 298.95	Feb 15/2025		R 414	Feb 15/2025	
O 298.60	Feb 15/2025		O 298.96	Feb 15/2025		R 415	Feb 15/2025	
O 298.61	Feb 15/2025		O 298.97	Feb 15/2025		416	BLANK	
O 298.62	Feb 15/2025		O 298.98	Feb 15/2025		53-11-37		
O 298.63	Feb 15/2025		O 298.99	Feb 15/2025		201	Oct 15/2020	
O 298.64	Feb 15/2025		O 298.100	Feb 15/2025		202	Oct 15/2020	
O 298.65	Feb 15/2025		O 298.101	Feb 15/2025		203	Oct 15/2020	
O 298.66	Feb 15/2025		O 298.102	Feb 15/2025		204	Oct 15/2015	
O 298.67	Feb 15/2025		A 298.103	Feb 15/2025		205	Oct 15/2015	
O 298.68	Feb 15/2025		A 298.104	Feb 15/2025		206	Jun 15/2021	
O 298.69	Feb 15/2025	53-11-01				207	Oct 15/2020	
O 298.70	Feb 15/2025	401				208	Oct 15/2020	
O 298.71	Feb 15/2025	402				209	Oct 15/2020	
O 298.72	Feb 15/2025	403				210	Oct 15/2015	
O 298.73	Feb 15/2025	404				211	Oct 15/2015	

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**53-EFFECTIVE PAGES**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 53**  
**FUSELAGE**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
53-11-37 (cont)			53-12-12			53-21-00 (cont)		
212	Oct 15/2015		401	Oct 15/2021		418	Oct 15/2024	
213	Oct 15/2015		402	Oct 15/2021		419	Oct 15/2024	
214	Feb 15/2023		403	Oct 15/2019		420	Oct 15/2022	
215	Feb 15/2023		404	Oct 15/2019		421	Oct 15/2024	
216	Feb 15/2023		405	Jun 15/2022		422	Oct 15/2024	
217	Feb 15/2023		406	Oct 15/2021		423	Oct 15/2024	
218	Feb 15/2023	53-14-01				424	Oct 15/2024	
219	Feb 15/2023		401	Feb 15/2024		53-21-00		
220	Feb 15/2023		402	Jun 15/2021		801	Feb 15/2018	
221	Feb 15/2023		403	Feb 15/2019		802	Feb 15/2018	
222	Feb 15/2023		404	Oct 15/2019		803	Feb 15/2018	
223	Feb 15/2023		405	Feb 15/2019		804	Feb 15/2018	
224	Feb 15/2023		406	Feb 15/2019		805	Feb 15/2018	
225	Feb 15/2023		407	Oct 15/2021		806	Feb 15/2018	
226	Feb 15/2023		408	Oct 15/2021		807	Feb 15/2018	
227	Feb 15/2023		409	Oct 15/2021		808	Oct 15/2015	
228	Feb 15/2023		410	Feb 15/2024		809	Oct 15/2015	
229	Feb 15/2023		411	Feb 15/2024		810	Oct 15/2015	
230	Feb 15/2023	53-21-00	412	Feb 15/2024		811	Oct 15/2015	
231	Feb 15/2023		401	Feb 15/2023		812	Oct 15/2015	
232	Feb 15/2023		402	Feb 15/2023		813	Oct 15/2015	
233	Feb 15/2023		403	Jun 15/2023		814	Oct 15/2015	
234	Feb 15/2023		404	Oct 15/2024		53-21-11		
235	Feb 15/2023		405	Oct 15/2021		801	Oct 15/2018	
236	Feb 15/2023		406	Feb 15/2020		802	Jun 15/2022	
237	Feb 15/2023		407	Feb 15/2020		53-31-11		
238	Feb 15/2023		408	Feb 15/2020		R 401	Feb 15/2025	
239	Feb 15/2023		409	Feb 15/2020		402	Oct 15/2024	
240	Feb 15/2023		410	Oct 15/2024		403	Jun 15/2020	
241	Feb 15/2023		411	Oct 15/2024		404	Oct 15/2024	
242	Feb 15/2023		412	Oct 15/2024		405	Oct 15/2024	
243	Feb 15/2023		413	Oct 15/2024		406	Oct 15/2024	
244	Feb 15/2023		414	Oct 15/2024		53-31-21		
245	Feb 15/2023		415	Oct 15/2024		R 401	Feb 15/2025	
246	Feb 15/2023		416	Oct 15/2024		R 402	Feb 15/2025	
			417	Oct 15/2024		R 403	Feb 15/2025	
						O 404	Feb 15/2025	

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**53-EFFECTIVE PAGES**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 53**  
**FUSELAGE**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
53-31-21 (cont)			53-51-21			53-51-21 (cont)		
405	Oct 15/2015		401	Oct 15/2021		437	Jun 15/2022	
406	Oct 15/2015		402	Oct 15/2021		438	Jun 15/2023	
53-31-31 Config 2			403	Oct 15/2022		439	Oct 15/2024	C
R 401	Feb 15/2025		404	Oct 15/2024		440	BLANK	
R 402	Feb 15/2025		405	Oct 15/2024		53-51-21		
403	Oct 15/2023		406	Oct 15/2024		601	Oct 15/2019	
404	Oct 15/2023		407	Oct 15/2024		602	Jun 15/2023	
405	Oct 15/2023		408	Feb 15/2020		603	Jun 15/2023	
406	Oct 15/2023		409	Oct 15/2023		604	Jun 15/2023	
407	Oct 15/2023		410	Oct 15/2023		605	Oct 15/2015	
R 408	Feb 15/2025		411	Oct 15/2022		606	Oct 15/2022	
409	Feb 15/2024		412	Oct 15/2022		607	Feb 15/2018	
410	Feb 15/2024		413	Oct 15/2024		608	BLANK	
R 411	Feb 15/2025		414	Jun 15/2023		53-51-37		
R 412	Feb 15/2025		415	Oct 15/2022		201	Jun 15/2022	
R 413	Feb 15/2025		416	Oct 15/2022		202	Oct 15/2018	
R 414	Feb 15/2025		417	Oct 15/2022		203	Oct 15/2015	
R 415	Feb 15/2025		418	Jun 15/2023		204	BLANK	
O 416	Feb 15/2025		419	Feb 15/2024		53-52-00		
53-42-11			420	Oct 15/2021		201	Oct 15/2024	
701	Feb 15/2017		421	Jun 15/2022		202	Feb 15/2023	
702	Oct 15/2017		422	Oct 15/2023		203	Feb 15/2020	
53-51-00			423	Oct 15/2023		204	Feb 15/2020	
201	Oct 15/2015		424	Oct 15/2022		205	Feb 15/2020	
202	Oct 15/2014		425	Oct 15/2022		206	Feb 15/2020	
203	Oct 15/2015		426	Oct 15/2022		207	Jun 15/2022	
204	BLANK		427	Oct 15/2022		208	Feb 15/2020	
53-51-01			R 428	Feb 15/2025		209	Feb 15/2020	
601	Oct 15/2022		R 429	Feb 15/2025	C	53-52-00		
602	Oct 15/2022		R 430	Feb 15/2025		401	Jun 15/2023	
603	Oct 15/2022		R 431	Feb 15/2025		402	Jun 15/2023	
604	Oct 15/2022		432	Jun 15/2022		403	Jun 15/2023	
605	Oct 15/2015		433	Jun 15/2022		404	Jun 15/2023	
606	BLANK		434	Oct 15/2023		R 405	Feb 15/2025	
53-51-11			435	Oct 15/2023		406	Jun 15/2024	
401	Feb 15/2015		436	Oct 15/2023		407	Oct 15/2024	
402	Oct 15/2017							

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

**53-EFFECTIVE PAGES**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 53**  
**FUSELAGE**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
53-52-00 (cont)			53-52-03			53-53-00 (cont)		
408	Oct 15/2024		201	Jun 15/2023		412	Feb 15/2024	
409	Oct 15/2024		202	Jun 15/2023		413	Feb 15/2024	
410	Oct 15/2024		203	Feb 15/2018		414	Feb 15/2024	
53-52-00			204	Feb 15/2018		415	Feb 15/2024	
601	Jun 15/2023		205	Feb 15/2018		416	BLANK	
602	Jun 15/2023		206	Feb 15/2018		53-54-00		
603	Feb 15/2023		207	Feb 15/2018		R 401	Feb 15/2025	
604	Feb 15/2023		208	Jun 15/2023		O 402	Feb 15/2025	
605	Feb 15/2023		53-52-03			403	Jun 15/2018	
606	Feb 15/2023		401	Jun 15/2024		404	Jun 15/2018	
607	Feb 15/2023		402	Jun 15/2023		405	Oct 15/2023	
608	BLANK		403	Feb 15/2018		406	Oct 15/2023	
53-52-00			404	Feb 15/2018		R 407	Feb 15/2025	
701	Oct 15/2024		405	Oct 15/2024		O 408	Feb 15/2025	
702	Oct 15/2024		406	Oct 15/2024		O 409	Feb 15/2025	
703	Oct 15/2024		407	Jun 15/2024		R 410	Feb 15/2025	
704	Oct 15/2024		408	BLANK		O 411	Feb 15/2025	
705	Oct 15/2024		53-52-03			412	Oct 15/2023	
706	Oct 15/2024		801	Oct 15/2022		413	Oct 15/2023	
707	Oct 15/2024		802	Feb 15/2021		414	Oct 15/2023	
708	Oct 15/2024		53-52-31			415	Oct 15/2023	
709	Oct 15/2024		401	Oct 15/2017		416	Oct 15/2023	
710	Oct 15/2024		402	Oct 15/2020		417	Oct 15/2023	
711	Oct 15/2024		403	Oct 15/2015		418	BLANK	
712	Oct 15/2024		404	Oct 15/2015		53-54-00		
713	Oct 15/2024		53-53-00			601	Jun 15/2018	
714	Oct 15/2024		R 401	Feb 15/2025		602	Jun 15/2018	
715	Oct 15/2024		402	Jun 15/2024		603	Jun 15/2018	
716	Oct 15/2024		R 403	Feb 15/2025		604	Jun 15/2018	
717	Oct 15/2024		404	Jun 15/2024		605	Jun 15/2018	
718	Oct 15/2024		405	Feb 15/2024		606	BLANK	
719	Oct 15/2024		406	Feb 15/2024		53-54-00		
720	Oct 15/2024		407	Feb 15/2022		801	Jun 15/2018	
721	Oct 15/2024		408	Feb 15/2022		802	Jun 15/2022	
722	Oct 15/2024		409	Oct 15/2024		803	Feb 15/2022	
723	Oct 15/2024		410	Feb 15/2024		804	Feb 15/2022	
724	BLANK		411	Feb 15/2024		805	Jun 15/2022	

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

**53-EFFECTIVE PAGES**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 53**  
**FUSELAGE**

Subject/Page	Date	COC	Subject/Page	Date	COC	Subject/Page	Date	COC
53-54-00 (cont)								
806	Feb 15/2022							
807	Feb 15/2022							
808	Jun 15/2022							
809	Feb 15/2022							
810	Feb 15/2022							

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

**53-EFFECTIVE PAGES**

Page 9  
Feb 15/2025





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<u>SUBJECT</u>	<u>CHAPTER</u>	<u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
<u>FUSELAGE - MAINTENANCE PRACTICES</u>						
Airworthiness Limitation Precautions	53-00-00				201	LOM ALL
TASK 53-00-00-912-801					201	LOM ALL
<u>FUSELAGE - CORROSION PREVENTION</u>					201	LOM ALL
<u>FUSELAGE FATIGUE INSPECTIONS -</u>					201	LOM ALL
<u>MAINTENANCE PRACTICES</u>						
INTERNAL - DETAILED: KU BAND ANTENNA INSTALLATION					201	LOM 466-999
TASK 53-05-02-211-983						
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE					203	LOM ALL
TASK 53-05-02-250-801						
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE					203	LOM ALL
TASK 53-05-02-250-803						
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE					203	LOM ALL
TASK 53-05-02-250-805						
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE					204	LOM ALL
TASK 53-05-02-250-806						
INTERNAL - GENERAL VISUAL: LONGITUDINAL LAP SPLICE					204	LOM ALL
TASK 53-05-02-210-839						
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE					208	LOM ALL
TASK 53-05-02-250-807						
INTERNAL - SPECIAL DETAILED: CUTOUT - CREW CAB WINDOWS (LN 1389 & ON)					208	LOM ALL
TASK 53-05-02-250-809						
EXTERNAL - DETAILED: CUTOUT - CREW CAB WINDOWS (LN 1389 & ON)					208	LOM ALL
TASK 53-05-02-211-802						
EXTERNAL - DETAILED: CUTOUT - CREW CAB WINDOWS					211	LOM ALL
TASK 53-05-02-211-803						

53-CONTENTS



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<u>SUBJECT</u>	<u>CHAPTER</u>	<u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
EXTERNAL - SPECIAL DETAILED: CUTOUT - CREW CAB WINDOWS (LN 1389 & ON)					213	LOM ALL
TASK 53-05-02-250-811						
INTERNAL - SPECIAL DETAILED: CUTOUT - CREW CABIN WINDOWS					213	LOM ALL
TASK 53-05-02-250-812						
INTERNAL - SPECIAL DETAILED: CUTOUT - CREW CABIN WINDOWS					213	LOM ALL
TASK 53-05-02-250-813						
EXTERNAL - SPECIAL DETAILED: CROWN SKIN PANEL - FWD OF STA 259.5					214	LOM ALL
TASK 53-05-02-250-814						
EXTERNAL - DETAILED: CUTOUT - ELECTRONIC EQUIPMENT DOOR					214	LOM ALL
TASK 53-05-02-211-804						
EXTERNAL - SPECIAL DETAILED: CUTOUT - FORWARD ENTRY DOOR FRAME					217	LOM ALL
TASK 53-05-02-250-816						
EXTERNAL - SPECIAL DETAILED: CUTOUT - FORWARD ENTRY DOOR FRAME					217	LOM ALL
TASK 53-05-02-250-817						
INTERNAL - DETAILED: FWD ENTRY DOOR, FWD EDGE FRAME STOPS					217	LOM ALL
TASK 53-05-02-211-805						
INTERNAL - DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE					220	LOM ALL
TASK 53-05-02-211-806						
INTERNAL - SPECIAL DETAILED: FWD ENTRY DOOR FWD EDGE FRAME STOPS					223	LOM ALL
TASK 53-05-02-250-818						
INTERNAL - SPECIAL DETAILED: FWD ENTRY DOOR FWD EDGE FRAME STOPS					223	LOM ALL
TASK 53-05-02-250-819						
INTERNAL - DETAILED: FWD ENTRY DOOR AFT EDGE FRAME STOPS					223	LOM ALL
TASK 53-05-02-211-807						

53-CONTENTS



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<u>SUBJECT</u>	<u>CHAPTER</u> <u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
INTERNAL - DETAILED: FWD ENTRY DOOR AFT EDGE FRAME STOPS TASK 53-05-02-211-808				227	LOM ALL
INTERNAL - SPECIAL DETAILED: FWD ENTRY DOOR CUTOUT TASK 53-05-02-250-820				230	LOM ALL
INTERNAL - SPECIAL DETAILED: FORWARD GALLEY DOOR SURROUND STRUCTURE DOOR STOP BACKUP STRUCTURE TASK 53-05-02-250-821				230	LOM ALL
EXTERNAL - SPECIAL DETAILED: CUTOUT - FWD GALLEY DOOR TASK 53-05-02-250-822				230	LOM ALL
INTERNAL - SPECIAL DETAILED: BULKHEAD, STA 294.5 TASK 53-05-02-250-823				231	LOM ALL
INTERNAL - DETAILED: NOSE WHEEL WELL SIDE AND TOP PANELS TASK 53-05-02-211-809				232	LOM ALL
INTERNAL - DETAILED: NOSE LANDING GEAR SUPPORT FITTINGS TASK 53-05-02-211-810				236	LOM ALL
INTERNAL - DETAILED: NOSE LANDING GEAR TRUNNION SUPPORT FITTING TASK 53-05-02-211-811				240	LOM ALL
EXTERNAL - DETAILED: CROWN SKIN PANEL STA 360 TO 540 TASK 53-05-02-211-813				244	LOM ALL
INTERNAL - DETAILED: CROWN SKIN PANEL STA 360 TO 540 TASK 53-05-02-211-814				246	LOM ALL
INTERNAL - DETAILED: CROWN SKIN PANEL STA 360 TO 540 TASK 53-05-02-211-990				248	LOM ALL
INTERNAL - DETAILED: SATCOM AERO-H ANTENNA INSTALLATION TASK 53-05-02-211-815				248	LOM 404, 411, 412, 415, 416, 420, 422-434, 437-447, 450-457, 461-999

## 53-CONTENTS



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<u>SUBJECT</u>	<u>CHAPTER</u> <u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
EXTERNAL - GENERAL VISUAL: FUSELAGE SIDE SKIN PANELS TASK 53-05-02-210-801				250	LOM ALL
EXTERNAL - DETAILED: FUSELAGE SIDE SKIN PANELS UNDER THE WING-TO-BODY FAIRING TASK 53-05-02-211-816				252	LOM ALL
EXTERNAL - SPECIAL DETAILED: SKIN UNDER UPPER WING-TO-BODY DRAG ANGLE TASK 53-05-02-130-818				258	LOM 465-999
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE TASK 53-05-02-250-826				258	LOM ALL
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL SKIN SPLICE TASK 53-05-02-250-828				259	LOM ALL
INTERNAL - DETAILED: LONGITUDINAL LAP SPLICE TASK 53-05-02-211-817				259	LOM ALL
EXTERNAL - DETAILED: LONGITUDINAL LAP SPLICE TASK 53-05-02-211-819				262	LOM ALL
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE TASK 53-05-02-250-830				264	LOM ALL
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE TASK 53-05-02-250-832				264	LOM ALL
EXTERNAL - DETAILED: LONGITUDINAL LAP SPLICE TASK 53-05-02-211-821				265	LOM ALL
INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND TASK 53-05-02-250-833				267	LOM ALL
INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND TASK 53-05-02-130-801				267	LOM ALL

**53-CONTENTS**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<u>SUBJECT</u>	<u>CHAPTER</u> <u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND TASK 53-05-02-250-834				268	LOM ALL
INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE TASK 53-05-02-250-835				269	LOM ALL
INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE TASK 53-05-02-250-836				269	LOM ALL
INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE TASK 53-05-02-250-837				270	LOM ALL
INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE TASK 53-05-02-130-802				271	LOM ALL
INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE TASK 53-05-02-250-838				271	LOM ALL
INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE TASK 53-05-02-250-839				272	LOM ALL
INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE TASK 53-05-02-250-840				273	LOM ALL
INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR FITTINGS AND STOPS AT THE FORWARD AND AFT EDGE FRAMES TASK 53-05-02-250-841				273	LOM ALL
INTERNAL - SPECIAL DETAILED: WING TO BODY LOWER DRAG ANGLE TASK 53-05-02-250-842				274	LOM ALL
INTERNAL - SPECIAL DETAILED: WING TO BODY UPPER DRAG ANGLE TASK 53-05-02-250-843				275	LOM ALL
INTERNAL - SPECIAL DETAILED: WING TO BODY UPPER DRAG ANGLE TASK 53-05-02-250-844				277	LOM ALL

**53-CONTENTS**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<u>SUBJECT</u>	<u>CHAPTER</u> <u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
INTERNAL - SPECIAL DETAILED: WING TO BODY UPPER DRAG ANGLE TASK 53-05-02-250-845				278	LOM ALL
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL SKIN SPLICE TASK 53-05-02-250-847				279	LOM ALL
INTERNAL - DETAILED: WINDOW BELT, STA 540 TO 727 TASK 53-05-02-211-822				279	LOM ALL
EXTERNAL - DETAILED: WINDOW BELT, STA 540 TO 727 TASK 53-05-02-211-823				283	LOM ALL
INTERNAL - DETAILED: STRINGER SPLICE, STA 663 TASK 53-05-02-211-824				285	LOM ALL
INTERNAL - DETAILED: KEEL BEAM CHORDS, STIFFENERS AND SPLICE TASK 53-05-02-211-825				288	LOM ALL
INTERNAL - SPECIAL DETAILED: STIFFENER ATTACHMENT TO FLOOR BEAM, STA 727 TASK 53-05-02-250-848				292	LOM ALL
INTERNAL - SPECIAL DETAILED: STRINGER 18 STRAP SIDE OF BODY TASK 53-05-02-250-849				292	LOM ALL
INTERNAL - SPECIAL DETAILED: STRINGER 18A CHORD AND LINKS TASK 53-05-02-250-850				293	LOM ALL
INTERNAL - SPECIAL DETAILED: FRAME SPLICE AT STA 540 TASK 53-05-02-250-851				293	LOM ALL
EXTERNAL - DETAILED: BS 540 BULKHEAD TASK 53-05-02-211-826				294	LOM ALL
EXTERNAL - DETAILED: BS 663 BULKHEAD TASK 53-05-02-211-827				296	LOM ALL
INTERNAL - SPECIAL DETAILED: BS 663 BULKHEAD TASK 53-05-02-250-852				298	LOM ALL

**53-CONTENTS**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<u>SUBJECT</u>	<u>CHAPTER</u> <u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
INTERNAL - DETAILED: AFT CARGO DOOR SURROUND STRUCTURE				298	LOM ALL
TASK 53-05-02-211-828					
INTERNAL - SPECIAL DETAILED: WHEEL WELL AFT BULKHEAD AND PRESSURE WEB STA 727				298.3	LOM ALL
TASK 53-05-02-250-853					
INTERNAL - SPECIAL DETAILED: AFT WHEEL WELL BULKHEAD, STA 727				298.3	LOM ALL
TASK 53-05-02-250-854					
INTERNAL - SPECIAL DETAILED: WHEEL WELL AFT BULKHEAD				298.3	LOM ALL
TASK 53-05-02-130-804					
INTERNAL - DETAILED: WHEEL WELL AFT BULKHEAD AND PRESSURE WEB, STA 727				298.4	LOM ALL
TASK 53-05-02-211-830					
INTERNAL - DETAILED: AFT WHEEL WELL BULKHEAD AND PRESSURE WEB, STA 727				298.4	LOM ALL
TASK 53-05-02-211-832					
INTERNAL - SPECIAL DETAILED: AFT WHEEL WELL BULKHEAD FRAME, STA 727				298.7	LOM ALL
TASK 53-05-02-250-855					
INTERNAL - SPECIAL DETAILED: SIDE STRUT SUPPORT FRAME, STA 706				298.7	LOM ALL
TASK 53-05-02-250-856					
INTERNAL - GENERAL VISUAL: MAIN LANDING GEAR SUPPORT FRAME, STA 695				298.8	LOM ALL
TASK 53-05-02-210-802					
INTERNAL - SPECIAL DETAILED: MAIN LANDING GEAR SUPPORT FRAME, STA 716				298.11	LOM ALL
TASK 53-05-02-250-857					
INTERNAL - SPECIAL DETAILED: MAIN LANDING GEAR SUPPORT FRAME, STA 716				298.11	LOM ALL
TASK 53-05-02-250-858					
INTERNAL - SPECIAL DETAILED: MAIN LANDING GEAR SUPPORT FRAME, STA 716				298.12	LOM ALL
TASK 53-05-02-250-859					

53-CONTENTS



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

SUBJECT	CHAPTER SECTION	SUBJECT	CONF	PAGE	EFFECT
INTERNAL - SPECIAL DETAILED: MAIN LANDING GEAR SUPPORT FRAME, STA 716 TASK 53-05-02-250-860				298.12	LOM ALL
INTERNAL - DETAILED: WHEEL WELL FRAME, STA 685 TASK 53-05-02-211-833				298.13	LOM ALL
INTERNAL - SPECIAL DETAILED: WHEEL WELL FRAME, STA 685 TASK 53-05-02-250-861				298.16	LOM ALL
INTERNAL - SPECIAL DETAILED: WHEEL WELL FRAME AT STA 685 TASK 53-05-02-250-862				298.16	LOM ALL
EXTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT SKIN ASSEMBLY AND FRAME OUTER CHORD TASK 53-05-02-250-867				298.17	LOM ALL
EXTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT SKIN ASSEMBLY AND FRAME OUTER CHORD TASK 53-05-02-250-868				298.17	LOM ALL
INTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT SKIN ASSEMBLY AND FRAME OUTER CHORD TASK 53-05-02-250-869				298.18	LOM ALL
INTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT - DOOR CUTOUT CORNERS TASK 53-05-02-250-874				298.19	LOM ALL
INTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT - DOOR CUTOUT CORNERS TASK 53-05-02-250-875				298.20	LOM ALL
INTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT TASK 53-05-02-130-805				298.21	LOM ALL
INTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT TASK 53-05-02-250-878				298.22	LOM ALL

53-CONTENTS



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

SUBJECT	CHAPTER SECTION	SUBJECT	CONF	PAGE	EFFECT
EXTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT SKIN ASSY AND FRAME OUTER CHORD TASK 53-05-02-250-880				298.24	LOM ALL
INTERNAL - GENERAL VISUAL: OVERWING EMERGENCY EXIT CUTOUT TASK 53-05-02-210-803				298.25	LOM ALL
INTERNAL - DETAILED: OVERWING EMERGENCY EXIT DOOR STOPS AND FITTINGS TASK 53-05-02-211-835				298.30	LOM ALL
INTERNAL - DETAILED: OVERWING EMERGENCY EXIT DOOR STOPS AND FITTINGS TASK 53-05-02-211-836				298.34	LOM ALL
INTERNAL - SPECIAL DETAILED: OVERWING EXIT DOOR STOPS AND FITTINGS TASK 53-05-02-250-884				298.37	LOM ALL
INTERNAL - DETAILED: CROWN SKIN PANEL STA 727 TO 887 TASK 53-05-02-211-837				298.38	LOM ALL
INTERNAL - SPECIAL DETAILED: SATCOM ANTENNA INSTALLATION (CANADIAN MARCONI AND HONEYWELL) TASK 53-05-02-250-885			298.40	LOM 404, 411, 412, 415, 416, 420, 422-434, 437-447, 450-457, 461-999	
INTERNAL - DETAILED: SATCOM ANTENNA INSTALLATION (CANADIAN MARCONI AND HONEYWELL) TASK 53-05-02-211-838			298.40	LOM 404, 411, 412, 415, 416, 420, 422-434, 437-447, 450-457, 461-999	
INTERNAL - SPECIAL DETAILED: SATCOM ANTENNA INSTALLATION (ALL EXCEPT THOSE COVERED BY PSE 53-60-01-5) TASK 53-05-02-250-886			298.43	LOM 404, 411, 412, 415, 416, 420, 422-434, 437-447, 450-457, 461-999	
INTERNAL - DETAILED: SATCOM ANTENNA INSTALLATION (ALL EXCEPT THOSE COVERED BY PSE 53-60-01-5) TASK 53-05-02-211-839			298.43	LOM 404, 411, 412, 415, 416, 420, 422-434, 437-447, 450-457, 461-999	
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLIC TASK 53-05-02-250-887				298.46	LOM ALL

53-CONTENTS



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 53**  
**FUSELAGE**

<b>SUBJECT</b>	<b>CHAPTER SECTION</b>	<b>SUBJECT</b>	<b>CONF</b>	<b>PAGE</b>	<b>EFFECT</b>
INTERNAL - DETAILED: WINDOW BELT STA 727 TO STA 888				298.46	LOM ALL
TASK 53-05-02-211-840					
EXTERNAL - DETAILED: WINDOW BELT STA 727 TO STA 888				298.49	LOM ALL
TASK 53-05-02-211-841					
INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE				298.52	LOM ALL
TASK 53-05-02-250-888					
INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE				298.52	LOM ALL
TASK 53-05-02-250-889					
INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE				298.53	LOM ALL
TASK 53-05-02-250-890					
INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND FORWARD AND AFT EDGE FRAMES AT BS 794.37 AND BS 847				298.54	LOM ALL
TASK 53-05-02-250-891					
INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND FORWARD AND AFT EDGE FRAMES AT BS 794.37 AND BS 847				298.55	LOM ALL
TASK 53-05-02-130-806					
INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE				298.55	LOM ALL
TASK 53-05-02-250-892					
EXTERNAL - DETAILED: AFT CARGO DOOR SURROUND STRUCTURE				298.56	LOM ALL
TASK 53-05-02-211-842					
INTERNAL - GENERAL VISUAL: AFT CARGO DOOR SURROUND STRUCTURE				298.59	LOM ALL
TASK 53-05-02-210-804					
INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR FITTINGS AND STOPS AT THE FORWARD AND AFT EDGE FRAMES				298.61	LOM ALL
TASK 53-05-02-250-893					
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE				298.61	LOM ALL
TASK 53-05-02-250-894					

**53-CONTENTS**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<u>SUBJECT</u>	<u>CHAPTER</u> <u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
EXTERNAL - DETAILED: LONGITUDINAL LAP SPLICE				298.62	LOM ALL
TASK 53-05-02-211-845					
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE				298.64	LOM ALL
TASK 53-05-02-250-895					
INTERNAL - SPECIAL DETAILED: AFT ENTRY DOOR, FORWARD EDGE FRAME DOOR STOP BACKUP STRUCTURE				298.64	LOM ALL
TASK 53-05-02-250-896					
INTERNAL - SPECIAL DETAILED: AFT ENTRY DOOR, AFT EDGE FRAME DOOR STOP BACKUP INTERCOSTALS				298.64	LOM ALL
TASK 53-05-02-250-897					
INTERNAL - GENERAL VISUAL: AFT ENTRY DOOR, AFT EDGE FRAME DOOR STOP BACKUP INTERCOSTALS				298.65	LOM ALL
TASK 53-05-02-210-842					
EXTERNAL - DETAILED: CUTOUT, AFT ENTRY DOOR SURROUND STRUCTURE				298.68	LOM ALL
TASK 53-05-02-211-846					
EXTERNAL - DETAILED: AFT ENTRY DOOR SURROUND STRUCTURE				298.70	LOM ALL
TASK 53-05-02-211-847					
EXTERNAL - SPECIAL DETAILED: AFT ENTRY DOOR SURROUND STRUCTURE				298.72	LOM ALL
TASK 53-05-02-250-898					
INTERNAL - DETAILED: AFT ENTRY DOOR SURROUND STRUCTURE				298.72	LOM ALL
TASK 53-05-02-211-848					
INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR FORWARD EDGE FRAME DOOR STOP BACKUP STRUCTURE				298.75	LOM ALL
TASK 53-05-02-250-899					
INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR FORWARD EDGE FRAME DOOR STOP BACKUP STRUCTURE				298.75	LOM ALL
TASK 53-05-02-250-900					

**53-CONTENTS**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<u>SUBJECT</u>	<u>CHAPTER</u> <u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR AFT EDGE FRAME DOOR STOP BACKUP INTERCOSTALS TASK 53-05-02-250-901				298.76	LOM ALL
INTERNAL - GENERAL VISUAL: AFT GALLEY DOOR AFT EDGE FRAME DOOR STOP BACKUP INTERCOSTALS TASK 53-05-02-210-843				298.77	LOM ALL
EXTERNAL - DETAILED: CUTOUT, AFT GALLEY DOOR SURROUND STRUCTURE TASK 53-05-02-211-849				298.79	LOM ALL
INTERNAL - DETAILED: BULKHEAD STA 1016 TASK 53-05-02-211-850				298.81	LOM ALL
INTERNAL - DETAILED: BULKHEAD STA 1016 TASK 53-05-02-211-851				298.83	LOM ALL
INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016 TASK 53-05-02-250-902				298.86	LOM ALL
INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016 TASK 53-05-02-250-903				298.86	LOM ALL
INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016 TASK 53-05-02-250-904				298.87	LOM ALL
INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016 TASK 53-05-02-250-905				298.87	LOM ALL
INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016 TASK 53-05-02-250-906				298.88	LOM ALL
INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016 TASK 53-05-02-250-907				298.88	LOM ALL
INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016 TASK 53-05-02-250-908				298.89	LOM ALL

**53-CONTENTS**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<u>SUBJECT</u>	<u>CHAPTER</u> <u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016				298.89	LOM ALL
TASK 53-05-02-250-B08					
INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016				298.90	LOM ALL
TASK 53-05-02-250-909					
INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016				298.90	LOM ALL
TASK 53-05-02-250-910					
INTERNAL - DETAILED: BULKHEAD STA 1016				298.91	LOM 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-999
TASK 53-05-02-211-888					
INTERNAL - DETAILED: VERTICAL FIN FRONT SPAR FITTING BULKHEAD ATTACHMENT - STA 1016				298.93	LOM ALL
TASK 53-05-02-211-852					
INTERNAL - SPECIAL DETAILED: VERTICAL FIN FRONT SPAR FITTINGS - STA 1016				298.95	LOM ALL
TASK 53-05-02-250-912					
INTERNAL - SPECIAL DETAILED: STRINGER SPLICING FITTINGS				298.95	LOM ALL
TASK 53-05-02-250-913					
INTERNAL - SPECIAL DETAILED: JACKSCREW FITTING LUGS				298.96	LOM ALL
TASK 53-05-02-250-914					
INTERNAL - SPECIAL DETAILED: VERTICAL FIN REAR SPAR ATTACHMENT FITTINGS				298.97	LOM ALL
TASK 53-05-02-130-807					
INTERNAL - DETAILED: VERTICAL FIN REAR SPAR ATTACHMENT FITTINGS				298.98	LOM ALL
TASK 53-05-02-211-853					
INTERNAL - SPECIAL DETAILED: INTEGRATED BULKHEAD STA 1156				298.101	LOM ALL
TASK 53-05-02-250-916					
INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER PIVOT FITTING				298.101	LOM ALL
TASK 53-05-02-250-917					

53-CONTENTS



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<u>SUBJECT</u>	<u>CHAPTER</u> <u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER PIVOT PINS				298.102	LOM ALL
TASK 53-05-02-230-801					
EXTERNAL - DETAILED: SECTION 48 SKIN PANELS, STA 1088 TO STA 1156				298.102	LOM ALL
TASK 53-05-02-211-854					
EXTERNAL - DETAILED: CROWN SKIN PANEL STA 259.5 TO STA 360				298.104	LOM ALL
TASK 53-05-02-211-862					
INTERNAL - SPECIAL DETAILED: FWD GALLEY DOOR CUTOUT				298.106	LOM ALL
TASK 53-05-02-250-931					
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE				298.106	LOM ALL
TASK 53-05-02-250-932					
INTERNAL - DETAILED: WINDOW BELT STA 360 TO STA 540				298.106	LOM ALL
TASK 53-05-02-211-863					
EXTERNAL - DETAILED: WINDOW BELT STA 360 TO STA 540				298.110	LOM ALL
TASK 53-05-02-211-864					
INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE				298.112	LOM ALL
TASK 53-05-02-250-934					
EXTERNAL - DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE				298.112	LOM ALL
TASK 53-05-02-211-865					
INTERNAL - GENERAL VISUAL: FORWARD CARGO DOOR SURROUND STRUCTURE				298.115	LOM ALL
TASK 53-05-02-210-808					
EXTERNAL - DETAILED: CROWN SKIN PANEL STA 540 TO STA 727				298.117	LOM ALL
TASK 53-05-02-211-866					
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE				298.119	LOM ALL
TASK 53-05-02-250-935					

## 53-CONTENTS



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<u>SUBJECT</u>	<u>CHAPTER</u> <u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE TASK 53-05-02-250-937				298.119	LOM ALL
EXTERNAL - DETAILED: CROWN SKIN PANEL STA 727 TO STA 887 TASK 53-05-02-211-867				298.119	LOM ALL
EXTERNAL - GENERAL VISUAL: FUSELAGE SIDE SKIN PANELS TASK 53-05-02-210-805				298.122	LOM ALL
EXTERNAL - DETAILED: FUSELAGE SIDE SKIN PANELS UNDER THE WING-TO-BODY FAIRING TASK 53-05-02-211-868				298.124	LOM ALL
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE TASK 53-05-02-250-940				298.128	LOM ALL
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE TASK 53-05-02-250-942				298.128	LOM ALL
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE TASK 53-05-02-250-944				298.128	LOM ALL
INTERNAL - DETAILED: LONGITUDINAL LAP SPLICE TASK 53-05-02-211-869				298.129	LOM ALL
EXTERNAL - DETAILED: LONGITUDINAL LAP SPLICE TASK 53-05-02-211-871				298.132	LOM ALL
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE TASK 53-05-02-250-946				298.134	LOM ALL
INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE TASK 53-05-02-250-948				298.134	LOM ALL
INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE TASK 53-05-02-250-949				298.135	LOM ALL

**53-CONTENTS**



# **737-600/700/800/900**

## **AIRCRAFT MAINTENANCE MANUAL**

# **CHAPTER 53**

## **FUSELAGE**

<u>SUBJECT</u>	<u>CHAPTER</u>	<u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE TASK 53-05-02-250-974					298.135	LOM ALL
INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE TASK 53-05-02-250-950					298.136	LOM ALL
INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE TASK 53-05-02-130-809					298.137	LOM ALL
EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICETASK 53-05-02-250-951					298.137	LOM ALL
EXTERNAL - DETAILED: CROWN SKIN PANEL STA 887 TO STA 1016 TASK 53-05-02-211-873					298.138	LOM ALL
INTERNAL - DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE TASK 53-05-02-211-874					298.140	LOM ALL
EXTERNAL - DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE TASK 53-05-02-211-875					298.142	LOM ALL
INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE TASK 53-05-02-250-953					298.144	LOM ALL
INTERNAL - DETAILED: WINDOW BELT STA 888 to 927 TASK 53-05-02-211-876					298.144	LOM ALL
EXTERNAL - DETAILED: WINDOW BELT STA 888 to 927 TASK 53-05-02-211-877					298.147	LOM ALL
INTERNAL - SPECIAL DETAILED: AFT ENTRY DOOR SURROUND STRUCTURE TASK 53-05-02-250-997					298.150	LOM ALL
INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE TASK 53-05-02-250-A79					298.150	LOM ALL

## **53-CONTENTS**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<u>SUBJECT</u>	<u>CHAPTER</u> <u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
INTERNAL - GENERAL VISUAL: PRESSURE DECK ATTACHMENTS TO REAR SPAR EXTENSION TASK 53-05-02-210-837				298.151	LOM ALL
EXTERNAL - SPECIAL DETAILED: AFT WHEEL WELL BULKHEAD, STA 727 TASK 53-05-02-250-A98				298.154	LOM ALL
INTERNAL - DETAILED: AFT ENTRY DOOR SURROUND STRUCTURE TASK 53-05-02-211-981				298.154	LOM ALL
INTERNAL - DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE TASK 53-05-02-211-982				298.157	LOM ALL
EXTERNAL- DETAILED : CROWN SKIN PANEL - STA 540 TO 727 TASK 53-05-02-211-988				298.159	LOM ALL
INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016 TASK 53-05-02-250-B09				298.161	LOM ALL
<b>FUSELAGE - STRUCTURAL INSPECTIONS - MAINTENANCE PRACTICES</b>	53-05-03		201		LOM ALL
EXTERNAL - GENERAL VISUAL: FUSELAGE LOWER LOBE, FORWARD ACCESS DOOR CUTOUT TASK 53-05-03-210-801			201		LOM ALL
EXTERNAL - GENERAL VISUAL: FUSELAGE LOWER LOBE, EE COMPARTMENT DOOR CUTOUT TASK 53-05-03-210-802			203		LOM ALL
EXTERNAL - GENERAL VISUAL: NOSE WHEEL WELL TASK 53-05-03-210-804			205		LOM ALL
EXTERNAL - DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE, FITTINGS AND STOPS TASK 53-05-03-211-801			207		LOM ALL

## 53-CONTENTS



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 53**  
**FUSELAGE**

<b>SUBJECT</b>	<b>CHAPTER</b>	<b>SECTION</b>	<b>SUBJECT</b>	<b>CONF</b>	<b>PAGE</b>	<b>EFFECT</b>
EXTERNAL - DETAILED: AFT CARGO DOOR SURROUND STRUCTURE, FITTINGS AND STOPS					209	LOM ALL
TASK 53-05-03-211-802						
EXTERNAL - GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL					211	LOM ALL
TASK 53-05-03-210-805						
INTERNAL - GENERAL VISUAL: FORWARD PRESSURE BULKHEAD					218	LOM ALL
TASK 53-05-03-210-806						
INTERNAL - GENERAL VISUAL: AREA FORWARD OF NOSE WHEEL WELL					220	LOM ALL
TASK 53-05-03-210-807						
INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FLOOR STRUCTURE					222	LOM ALL
TASK 53-05-03-210-808						
INTERNAL - GENERAL VISUAL: AREA ABOVE AND OUTBOARD OF NOSE WHEEL WELL					224	LOM ALL
TASK 53-05-03-210-809						
INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - DRY AREA					228	LOM ALL
TASK 53-05-03-210-810						
INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - WET AREA					235	LOM ALL
TASK 53-05-03-210-811						
INTERNAL - GENERAL VISUAL: ELECTRICAL AND ELECTRONICS COMPARTMENT					241	LOM ALL
TASK 53-05-03-210-812						
INTERNAL - GENERAL VISUAL: FORWARD CARGO COMPARTMENT					248	LOM ALL
TASK 53-05-03-210-813						
INTERNAL - GENERAL VISUAL: FORWARD CARGO COMPARTMENT FLOOR STRUCTURE					253	LOM ALL
TASK 53-05-03-210-814						
INTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT FLOOR STRUCTURE					256	LOM ALL
TASK 53-05-03-210-815						

**53-CONTENTS**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<u>SUBJECT</u>	<u>CHAPTER</u> <u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
INTERNAL - DETAILED: FORWARD CARGO DOOR CUTOUT TASK 53-05-03-211-803				259	LOM ALL
INTERNAL - GENERAL VISUAL: FORWARD BILGE TASK 53-05-03-210-816				261	LOM ALL
INTERNAL - GENERAL VISUAL: AREA AFT OF FORWARD CARGO COMPARTMENT TASK 53-05-03-210-817				267	LOM ALL
INTERNAL - GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (Forward Of Wing Box) TASK 53-05-03-210-818				271	LOM ALL
INTERNAL - GENERAL VISUAL: AREA ABOVE WING BOX CENTER SECTION TASK 53-05-03-210-819				275	LOM ALL
INTERNAL - GENERAL VISUAL: AREA ABOVE MAIN LANDING GEAR WHEEL WELL TASK 53-05-03-210-820				278	LOM ALL
INTERNAL - GENERAL VISUAL: KEEL BEAM UNDER WING-TO-BODY FAIRING (under wing box) TASK 53-05-03-210-821				281	LOM ALL
INTERNAL - GENERAL VISUAL: KEEL BEAM IN WHEEL WELL TASK 53-05-03-210-823				286	LOM ALL
INTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT TASK 53-05-03-210-824				288	LOM ALL
INTERNAL - DETAILED: AFT CARGO DOOR CUTOUT TASK 53-05-03-211-804				292	LOM ALL
INTERNAL - GENERAL VISUAL: AFT BILGE TASK 53-05-03-210-825				294	LOM ALL
INTERNAL - GENERAL VISUAL: AREA AFT OF CARGO COMPARTMENT TASK 53-05-03-210-826				298.1	LOM ALL

## 53-CONTENTS



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<u>SUBJECT</u>	<u>CHAPTER</u>	<u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
INTERNAL - GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (aft of wheel well)					298.5	LOM ALL
TASK 53-05-03-210-827						
INTERNAL - GENERAL VISUAL: AREA UNDER WING-TO-BODY FAIRING (above wing)					298.9	LOM ALL
TASK 53-05-03-210-828						
EXTERNAL - GENERAL VISUAL: OVERWING EMERGENCY EXIT CUTOUT					298.12	LOM ALL
TASK 53-05-03-210-829						
EXTERNAL - DETAILED: FORWARD ENTRY DOOR FRAME, STOPS, LATCHES AND HINGES					298.17	LOM ALL
TASK 53-05-03-211-805						
EXTERNAL - DETAILED: FORWARD GALLEY SERVICE DOOR FRAME, STOPS, LATCHES AND HINGES					298.19	LOM ALL
TASK 53-05-03-211-806						
EXTERNAL - DETAILED: AFT ENTRY DOOR FRAME, STOPS, LATCHES AND HINGES					298.21	LOM ALL
TASK 53-05-03-211-807						
EXTERNAL - DETAILED: AFT GALLEY SERVICE DOOR FRAME, STOPS, LATCHES AND HINGES					298.23	LOM ALL
TASK 53-05-03-211-808						
INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FROM STA 178 TO 270					298.25	LOM ALL
TASK 53-05-03-210-830						
INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FLOOR STRUCTURE					298.28	LOM ALL
TASK 53-05-03-210-831						
INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FROM STA 270 to 360					298.30	LOM ALL
TASK 53-05-03-210-832						
INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS					298.33	LOM ALL
TASK 53-05-03-211-809						

## 53-CONTENTS



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

SUBJECT	CHAPTER SECTION	SUBJECT	CONF	PAGE	EFFECT
INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS TASK 53-05-03-211-810				298.35	LOM ALL
INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS TASK 53-05-03-211-811				298.37	LOM ALL
INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS TASK 53-05-03-211-812				298.39	LOM ALL
INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - DRY AREA TASK 53-05-03-210-833			298.41		LOM ALL; AIRPLANES WITH A CURVED AFT PRESSURE BULKHEAD
INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - WET AREA TASK 53-05-03-210-834			298.47		LOM ALL; AIRPLANES WITH A CURVED AFT PRESSURE BULKHEAD
INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - WET AREA TASK 53-05-03-210-835			298.52		LOM ALL
INTERNAL - GENERAL VISUAL: FORWARD PASSENGER COMPARTMENT, STA 360 to 663.75 TASK 53-05-03-210-836			298.56		LOM ALL
INTERNAL - GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 to 1016 TASK 53-05-03-210-837			298.61		LOM ALL
INTERNAL - GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD TASK 53-05-03-210-838			298.66		LOM ALL
INTERNAL - GENERAL VISUAL: STABILIZER TORSION BOX COMPARTMENT AND APU COMPARTMENT TASK 53-05-03-210-839			298.71		LOM ALL
INTERNAL - GENERAL VISUAL: STA 1156 BULKHEAD TASK 53-05-03-210-840			298.74		LOM ALL

53-CONTENTS



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<u>SUBJECT</u>	<u>CHAPTER</u> <u>SECTION</u>	<u>SUBJECT</u>	<u>CONF</u>	<u>PAGE</u>	<u>EFFECT</u>
INTERNAL - GENERAL VISUAL: FUSELAGE SKIN UNDER DORSAL FIN TASK 53-05-03-210-841				298.76	LOM ALL
INTERNAL - GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING TASK 53-05-03-210-842				298.78	LOM ALL
INTERNAL - GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING TASK 53-05-03-210-843				298.81	LOM ALL
INTERNAL - GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING TASK 53-05-03-210-844				298.87	LOM ALL
INTERNAL - GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING TASK 53-05-03-210-864				298.90	LOM ALL
INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FROM STA 178 TO 270 TASK 53-05-03-210-861				298.99	LOM ALL
INTERNAL - GENERAL VISUAL: CROWN SKIN PANEL TASK 53-05-03-210-862				298.103	LOM 466-999
<b>PASSENGER ENTRY DOOR SCUFF PLATE - REMOVAL/INSTALLATION</b>	53-11-01			401	LOM ALL
Scuff Plate Removal TASK 53-11-01-000-801				401	LOM ALL
Scuff Plate Installation TASK 53-11-01-420-801				409	LOM ALL
<b>CARGO DOOR SCUFF PLATE - REMOVAL/INSTALLATION</b>	53-11-02			401	LOM ALL
Cargo Door Scuff Plate Removal TASK 53-11-02-020-801				401	LOM ALL
Cargo Door Scuff Plate Installation TASK 53-11-02-420-801				410	LOM ALL

**53-CONTENTS**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 53**  
**FUSELAGE**

<b>SUBJECT</b>	<b>CHAPTER SECTION</b>	<b>SUBJECT</b>	<b>CONF</b>	<b>PAGE</b>	<b>EFFECT</b>
<b>FRAMES AND BULKHEADS CORROSION PREVENTION - MAINTENANCE PRACTICES</b>		53-11-37		201	LOM ALL
Crown Frames, Stringers and Skin - Corrosion Prevention				201	LOM ALL
TASK 53-11-37-600-811					
Lower Lobe Structure - Corrosion Prevention				206	LOM ALL
TASK 53-11-37-600-812					
Galley and Lavatory Areas - Corrosion Prevention				214	LOM ALL
TASK 53-11-37-600-804					
Main Gear Wheel Well and Keel Beam - Corrosion Prevention				221	LOM ALL
TASK 53-11-37-600-805					
Nose Gear Wheel Well - Corrosion Prevention				229	LOM ALL
TASK 53-11-37-600-806					
Door Openings - Corrosion Prevention				235	LOM ALL
TASK 53-11-37-600-808					
Upper Lobe Frames, Stringers and Skin - Corrosion Prevention				242	LOM ALL
TASK 53-11-37-600-810					
<b>STRINGER BEAM LINKS - REMOVAL/INSTALLATION</b>	53-12-12			401	LOM ALL
Stringer Beam Link Removal				401	LOM ALL
TASK 53-12-12-000-801					
Stringer Beam Link Installation				405	LOM ALL
TASK 53-12-12-400-801					
<b>NOSE WHEEL WELL ACCESS PANELS - REMOVAL/INSTALLATION</b>	53-14-01			401	LOM ALL
Nose Wheel Well Access Panels - Removal				401	LOM ALL
TASK 53-14-01-020-801					
Nose Wheel Well Access Panels - Installation				410	LOM ALL
TASK 53-14-01-420-801					
<b>PASSENGER CABIN FLOORS - REMOVAL/INSTALLATION</b>	53-21-00			401	LOM ALL
Passenger Cabin Floor Panel - Removal				401	LOM ALL
TASK 53-21-00-000-801					

**53-CONTENTS**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

SUBJECT	CHAPTER SECTION	SUBJECT	CONF	PAGE	EFFECT
Passenger Cabin Floor Panel - Installation TASK 53-21-00-400-801				419	LOM ALL
<b>POLYURETHANE WATERSEAL - REPAIRS</b>	53-21-00			801	LOM ALL
Repair the Polyurethane Waterseal TASK 53-21-00-300-801				801	LOM ALL
<b>WATER BARRIER - REPAIRS</b>	53-21-11			801	LOM ALL
Vinyl Water Barrier Repair TASK 53-21-11-300-801				801	LOM ALL
Mylar Water Barrier Repair TASK 53-21-11-300-802				801	LOM ALL
<b>NOSE VORTEX GENERATORS - REMOVAL/INSTALLATION</b>	53-31-11		401	LOM 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-999; LOM 402 POST SB 737-25-1543	
Remove the Nose Vortex Generators TASK 53-31-11-000-801			401	LOM 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-999; LOM 402 POST SB 737-25-1543	
Install the Nose Vortex Generators TASK 53-31-11-400-801			405	LOM 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-999; LOM 402 POST SB 737-25-1543	
<b>VORTEX GENERATOR ASSEMBLY - REMOVAL/INSTALLATION</b>	53-31-21		401	LOM ALL	
Vortex Generator Assembly Removal TASK 53-31-21-000-801			401	LOM ALL	
Vortex Generator Installation TASK 53-31-21-400-801			402	LOM ALL	
<b>STABILIZER TO BODY FRONT SPAR SLIDING SEAL - REMOVAL/INSTALLATION</b>	53-31-31	2	401	LOM ALL	
Stabilizer-to-Body Upper Front Spar Sliding Seal Removal TASK 53-31-31-000-802		2	401	LOM ALL	
Stabilizer-to-Body Upper Front Spar Sliding Seal Installation TASK 53-31-31-400-802		2	408	LOM ALL	

53-CONTENTS



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 53  
FUSELAGE

<b>SUBJECT</b>	<b>CHAPTER SECTION</b>	<b>SUBJECT</b>	<b>CONF</b>	<b>PAGE</b>	<b>EFFECT</b>
Stabilizer-to-Body Lower Front Spar Sliding Seal Removal		2	411		LOM ALL
TASK 53-31-31-000-803					
Stabilizer-to-Body Lower Front Spar Sliding Seal Installation		2	413		LOM ALL
TASK 53-31-31-400-803					
<b>PASSENGER CABIN AND CARGO COMPARTMENT</b>	<b>53-42-11</b>		701		LOM ALL
<b>TRACKS - CLEANING/PAINTING</b>					
Clean the Passenger Cabin and Cargo Compartment Track			701		LOM ALL
TASK 53-42-11-100-801					
<b>FRONT SPAR TO REAR SPAR UNDERWING PANEL - INSPECTION/REPAIR</b>	<b>53-51-00</b>		201		LOM ALL
Front Spar to Rear Spar Underwing Panel Inspection			201		LOM ALL
TASK 53-51-00-200-801					
Front Spar to Rear Spar Underwing Panel Repair			201		LOM ALL
TASK 53-51-00-300-801					
<b>WING-TO-BODY FAIRING - INSPECTION/CHECK</b>	<b>53-51-01</b>		601		LOM ALL
Wing-to-Body Fairing Electrical Resistance Check			601		LOM ALL
TASK 53-51-01-765-801					
<b>WING-TO-BODY FAIRING BLOWOUT PANEL - REMOVAL/INSTALLATION</b>	<b>53-51-11</b>		401		LOM ALL
Blowout Panel for the Wing-to-Body Fairing Removal			401		LOM ALL
TASK 53-51-11-000-801					
Blowout Panel for the Wing-to-Body Fairing Installation			401		LOM ALL
TASK 53-51-11-400-801					
<b>WING-TO-BODY FAIRING PANELS - REMOVAL/INSTALLATION</b>	<b>53-51-21</b>		401		LOM ALL
Forward Wing-To-Body Fairing Panel Removal			401		LOM ALL
TASK 53-51-21-000-803					
Forward Wing-To-Body Fairing Panel Installation			409		LOM ALL
TASK 53-51-21-400-803					

**53-CONTENTS**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 53**  
**FUSELAGE**

<b>SUBJECT</b>	<b>CHAPTER SECTION</b>	<b>SUBJECT</b>	<b>CONF</b>	<b>PAGE</b>	<b>EFFECT</b>
Center Wing-To-Body Fairing Panel Removal TASK 53-51-21-000-802				413	LOM ALL
Center Wing-To-Body Fairing Panel Installation TASK 53-51-21-400-802				421	LOM ALL
Aft Wing-To-Body Fairing Panel Removal TASK 53-51-21-000-801				428	LOM ALL
Aft Wing-To-Body Fairing Panel Installation TASK 53-51-21-400-801				434	LOM ALL
<b>WING-TO-BODY FAIRING PANELS - INSPECTION/CHECK</b>	53-51-21			601	LOM ALL
Wing-To-Body Fairing Panel Maximum Electrical Resistance Check TASK 53-51-21-760-801				601	LOM ALL
Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection TASK 53-51-21-211-801				606	LOM ALL
<b>FILLET FAIRINGS CORROSION - MAINTENANCE PRACTICES</b>	53-51-37			201	LOM ALL
Wing to Body Fairing Cavity - Corrosion Prevention TASK 53-51-37-600-801				201	LOM ALL
<b>NOSE RADOME - MAINTENANCE PRACTICES</b>	53-52-00			201	LOM ALL
Nose Radome - Open TASK 53-52-00-010-802				201	LOM ALL
Nose Radome - Close TASK 53-52-00-410-802				205	LOM ALL
Nose Radome Protective Boot Removal TASK 53-52-00-000-802				206	LOM ALL
Nose Radome Protective Boot Installation TASK 53-52-00-400-802				206	LOM ALL
<b>NOSE RADOME - REMOVAL/INSTALLATION</b>	53-52-00			401	LOM ALL
Nose Radome Removal TASK 53-52-00-000-801				401	LOM ALL
Nose Radome Installation TASK 53-52-00-400-801				406	LOM ALL

**53-CONTENTS**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 53**  
**FUSELAGE**

<b>SUBJECT</b>	<b>CHAPTER SECTION</b>	<b>SUBJECT</b>	<b>CONF</b>	<b>PAGE</b>	<b>EFFECT</b>
<b>NOSE RADOME - INSPECTION/CHECK</b>		53-52-00		601	LOM ALL
Nose Radome - Inspection TASK 53-52-00-200-801				601	LOM ALL
<b>NOSE RADOME - CLEANING/PAINTING</b>		53-52-00		701	LOM ALL
Nose Radome - Cleaning/Painting TASK 53-52-00-370-801				701	LOM ALL
<b>LIGHTNING DIVERTER STRIPS - MAINTENANCE PRACTICES</b>	53-52-03			201	LOM ALL
Remove the Lightning Diverter Strips TASK 53-52-03-000-801				201	LOM ALL
Install the Lightning Diverter Strip TASK 53-52-03-400-801				206	LOM ALL
Lightning Diverter Strips - Test TASK 53-52-03-820-801				207	LOM ALL
<b>LIGHTNING DIVERTER STRIPS - REPAIRS</b>	53-52-03			801	LOM ALL
Lightning Diverter Strip Temporary Repair TASK 53-52-03-300-801				801	LOM ALL
<b>CONDUCTOR STRAPS - REMOVAL/INSTALLATION</b>	53-52-03			401	LOM ALL
Remove the Conductor Straps TASK 53-52-03-000-802				401	LOM ALL
Install the Conductor Straps TASK 53-52-03-400-802				405	LOM ALL
<b>GLIDE SLOPE ANTENNA DIRECTOR BAR - REMOVAL/INSTALLATION</b>	53-52-31			401	LOM ALL
Glide Slope Director Bar Removal TASK 53-52-31-000-801				401	LOM ALL
Glide Slope Director Bar Installation TASK 53-52-31-400-801				401	LOM ALL
<b>TAILCONE - REMOVAL/INSTALLATION</b>	53-53-00			401	LOM ALL
Tailcone Removal TASK 53-53-00-000-801				401	LOM ALL
Tailcone Installation TASK 53-53-00-400-801				409	LOM ALL

**53-CONTENTS**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 53**  
**FUSELAGE**

<b>SUBJECT</b>	<b>CHAPTER SECTION</b>	<b>SUBJECT</b>	<b>CONF</b>	<b>PAGE</b>	<b>EFFECT</b>
<b>BROADBAND RADOME - REMOVAL/INSTALLATION</b>	53-54-00			401	LOM 466-999
Broadband Radome Removal				401	LOM 466-999
TASK 53-54-00-000-801					
Broadband Radome Installation				406	LOM 466-999
TASK 53-54-00-400-801					
Adapter Plate Assembly Removal				410	LOM 466-999
TASK 53-54-00-000-802					
Adapter Plate Assembly Installation				416	LOM 466-999
TASK 53-54-00-400-802					
<b>BROADBAND RADOME - INSPECTION/CHECK</b>	53-54-00			601	LOM 466-999
Broadband Radome Inspection				601	LOM 466-999
TASK 53-54-00-211-801					
<b>BROADBAND RADOME - REPAIRS</b>	53-54-00			801	LOM 466-999
Broadband Radome Blow-out Door Hinge Repair				801	LOM 466-999
TASK 53-54-00-300-801					
Broadband Radome Blow-out Door Latch Repair				801	LOM 466-999
TASK 53-54-00-300-802					
Broadband Radome Blow-out Door Opening				802	LOM 466-999
Edge Protector Repair					
TASK 53-54-00-300-803					
Broadband Radome Blow-out Door Seal Repair				803	LOM 466-999
TASK 53-54-00-300-804					
Broadband Radome Exterior Coating Repair				804	LOM 466-999
TASK 53-54-00-300-805					
Broadband Radome Hoist Point Nutplate Repair				806	LOM 466-999
TASK 53-54-00-300-806					
Broadband Radome Leading Edge Protector				807	LOM 466-999
Repair					
TASK 53-54-00-300-807					
Broadband Radome Lightning Diverter Strip				808	LOM 466-999
Repair					
TASK 53-54-00-300-808					

**53-CONTENTS**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

FUSELAGE - MAINTENANCE PRACTICES

**1. General**

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

**TASK 53-00-00-912-801**

**2. Airworthiness Limitation Precautions**

**A. General**

- (1) Critical Design Configuration Control Limitations (CDCCLs)
  - (a) All occurrences of CDCCLs found in this chapter of the AMM are identified by this note after each applicable CDCCL design feature:
    - 1) NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).
  - (b) Design features that are CDCCLs are defined and controlled by Special Federal Aviation Regulation (SFAR) 88, and can be found in Section 9 of the Maintenance Planning Data (MPD) document. CDCCLs are a means of identifying certain design configuration features intended to preclude a fuel tank ignition source for the operational life of the airplane. CDCCLs are mandatory and cannot be changed or deleted without the approval of the FAA Oversight Office that is responsible for the airplane model Type Certificate. A critical fuel tank ignition source prevention feature may exist in the fuel system and its related installation or in systems that, if a failure condition were to develop, could interact with the fuel system in such a way that an unsafe condition would develop without this limitation. Strict adherence to configuration, methods, techniques, and practices as prescribed is required to ensure the CDCCL is complied with. Any use of parts, methods, techniques or practices not contained in the applicable CDCCL must be approved by the FAA Oversight Office that is responsible for the airplane model Type Certificate.
- (2) Airworthiness Limitation Instructions (ALIs)
  - (a) All occurrences of fuel tank system ALIs found in this chapter of the AMM are identified by this note after each applicable ALI inspection feature:
    - 1) NOTE: ALI - Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important information on airworthiness limitation instructions (ALIs).
  - (b) Inspection features that are ALIs are defined and controlled by Special Federal Aviation Regulation (SFAR) 88, and can be found in Section 9 of the Maintenance Planning Data (MPD) document. These ALIs identify inspection features related to fuel tank ignition source prevention which must be done to maintain the design level of safety for the operational life of the airplane. These inspection features are mandatory and cannot be changed or deleted without the approval of the FAA Oversight Office that is responsible for the airplane model Type Certificate. Strict adherence to methods, techniques and practices as prescribed is required to ensure the ALI is complied with. Any use of methods, techniques or practices not contained in these ALIs must be approved by the FAA Oversight Office that is responsible for the airplane model Type Certificate.

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
100	Lower Half of Fuselage

EFFECTIVITY  
LOM ALL

**53-00-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

**Zone      Area**

200	Upper Half of Fuselage
500	Left Wing
600	Right Wing

**C. Critical Design Configuration Control Limitations (CDCCLs)**

SUBTASK 53-00-00-910-001



**WARNING**

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

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

**D. Airworthiness Limitation Instructions (ALIs)**

SUBTASK 53-00-00-910-002



**WARNING**

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

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

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-00-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**FUSELAGE - CORROSION PREVENTION**

**1. General**

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

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

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

EFFECTIVITY  
LOM ALL

**53-00-37**





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

FUSELAGE FATIGUE INSPECTIONS - MAINTENANCE PRACTICES

LOM 466-999

**TASK 53-05-02-211-983**

**1. INTERNAL - DETAILED: KU BAND ANTENNA INSTALLATION**

Figure 201

NOTE: This procedure is a scheduled maintenance task.

**A. References**

Reference	Title
53-54-00-000-801	Broadband Radome Removal (P/B 401)
53-54-00-400-801	Broadband Radome Installation (P/B 401)

**B. Location Zones**

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

**C. Inspection**

SUBTASK 53-05-02-211-184

- (1) Remove the Broadband Radome. Broadband Radome Removal, TASK 53-54-00-000-801
- (2) Remove the Adapter Plate.
- (3) Do a detailed inspection of the skin under the footprint of the antenna baseplate and the lugs common to the fuselage (PSE 53-60-01-9).  
See Doc. D626A001-DTR, DTR check form 53-60-01-9, for alternative inspections.
- (4) Install the Adapter Plate.
- (5) Install the Broadband Radome. Broadband Radome Installation, TASK 53-54-00-400-801

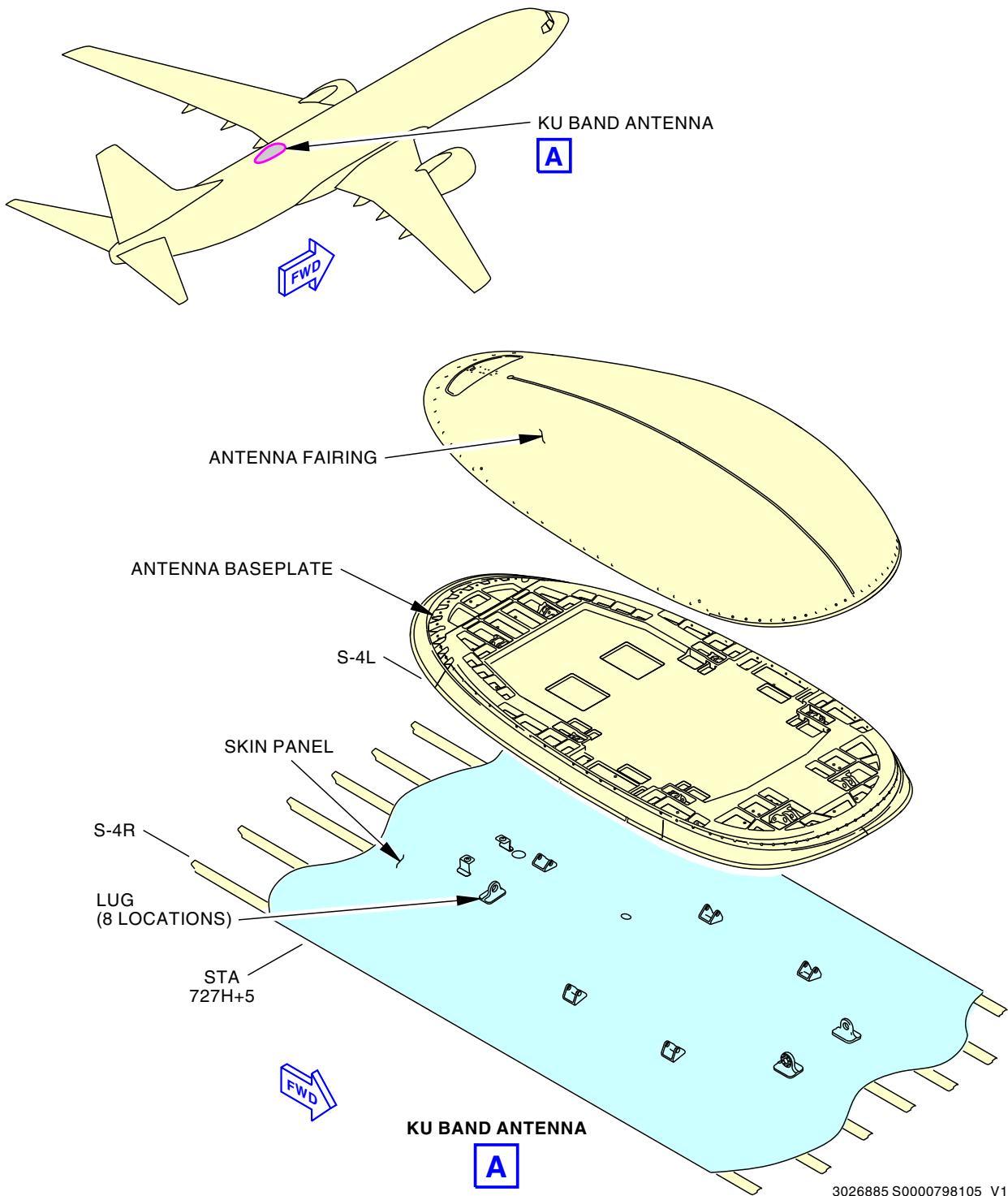
———— END OF TASK ————

EFFECTIVITY  
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**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



**KU Band Antenna Installation**  
Figure 201/53-05-02-990-866

EFFECTIVITY  
LOM 466-999

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

LOM ALL

**TASK 53-05-02-250-801**

**2. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLIC**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-001

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-4L and S-4R from STA 259.5 to STA 360.

See Doc. D626A001-DTR, DTR check form 53-10-03-1, for alternative inspections.

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 53-30-41.

———— END OF TASK ————

**TASK 53-05-02-250-803**

**3. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLIC**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-003

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringers S-4L and S-4R from STA 259.5 to STA 360.

See Doc. D626A001-DTR, DTR check form 53-10-03-2, for alternative inspections.

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 53-30-50.

———— END OF TASK ————

**TASK 53-05-02-250-805**

**4. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLIC**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

EFFECTIVITY  
LOM ALL

**53-05-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

(Continued)

<b>Zone</b>	<b>Area</b>
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

**B. Inspection**

SUBTASK 53-05-02-250-005

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringer S-14L (from STA 259.5 to STA 294.5, and from STA 350 to STA 360) and at stringer S-14R (from STA 259.5 to STA 277, and from STA 344 to STA 360).

See Doc D626A001-DTR, DTR check form 53-10-03-3 for alternative inspections.

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 53-30-41.

————— END OF TASK ————

**TASK 53-05-02-250-806**

**5. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-006

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringer S-14L (from STA 259.5 to STA 294.5 and from STA 350 to STA 360) and at stringer S-14R (from STA 259.5 to STA 277 and from STA 344 to STA 360).

See Doc D626A001-DTR, DTR check form 53-10-03-4 for alternative inspections.

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 53-30-50.

————— END OF TASK ————

**TASK 53-05-02-210-839**

**6. INTERNAL - GENERAL VISUAL: LONGITUDINAL LAP SPLICE**

Figure 202

Figure 203

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
220	Subzone - Passenger Compartment - Body Station 259.50 to 360.00
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left



**53-05-02**

Page 204  
Oct 15/2023



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**B. Inspection**

SUBTASK 53-05-02-210-038

NOTE: Remove or displace interiors and insulation as required to perform this inspection.

- (1) Do a General Visual inspection of the lower skin along the lower fastener row at stringer S-14L (from STA 259.5 to STA 294.5 and from STA 350 to STA 360) and at stringer S-14R (from STA 259.5 to STA 277 and from STA 344 to STA 360).

See Doc. D626A001-DTR, DTR check form 53-10-03-4 for alternative inspections.

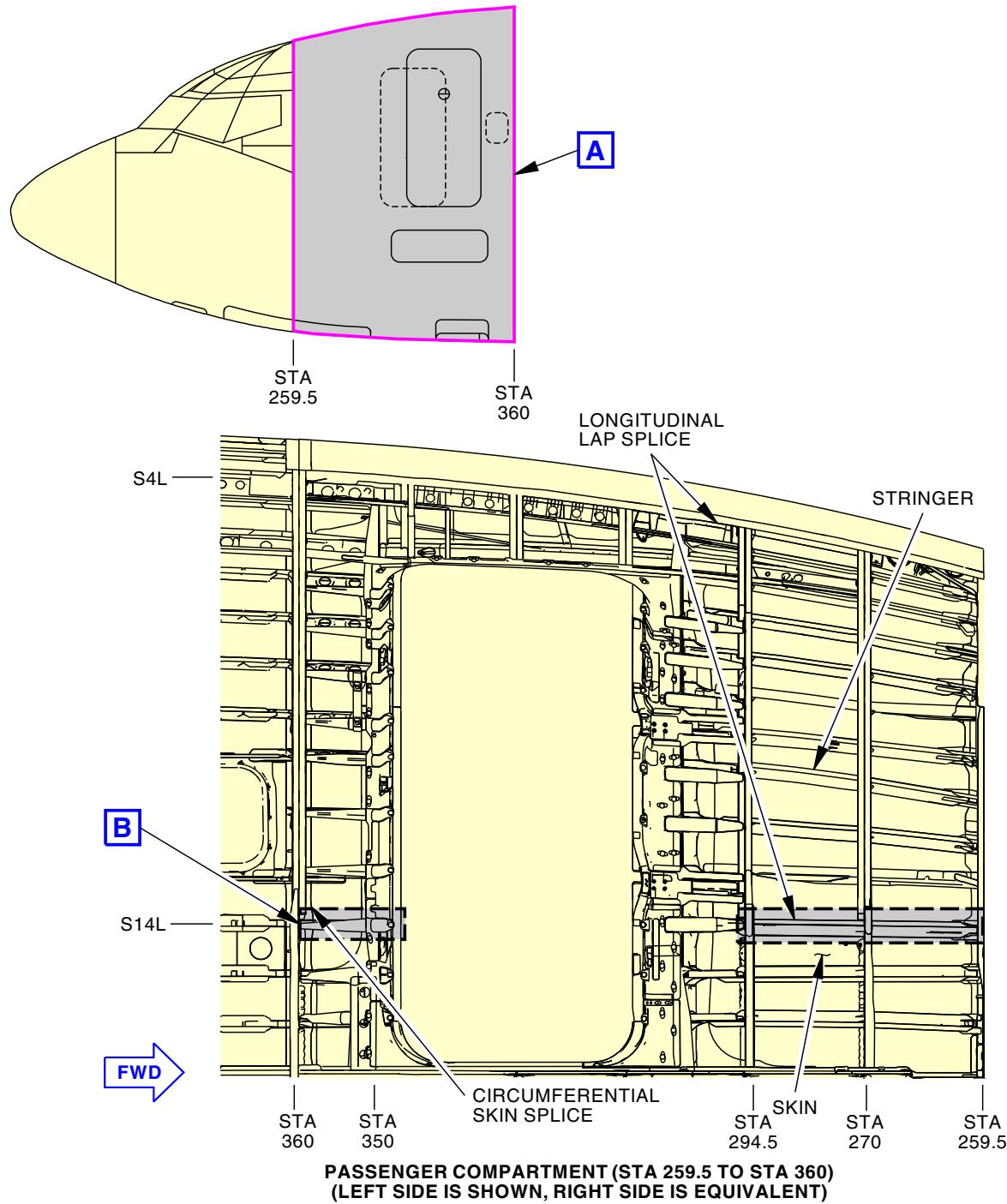
———— END OF TASK ————

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LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Longitudinal Lap Splice, S-14R and S-14L  
Figure 202/53-05-02-990-867

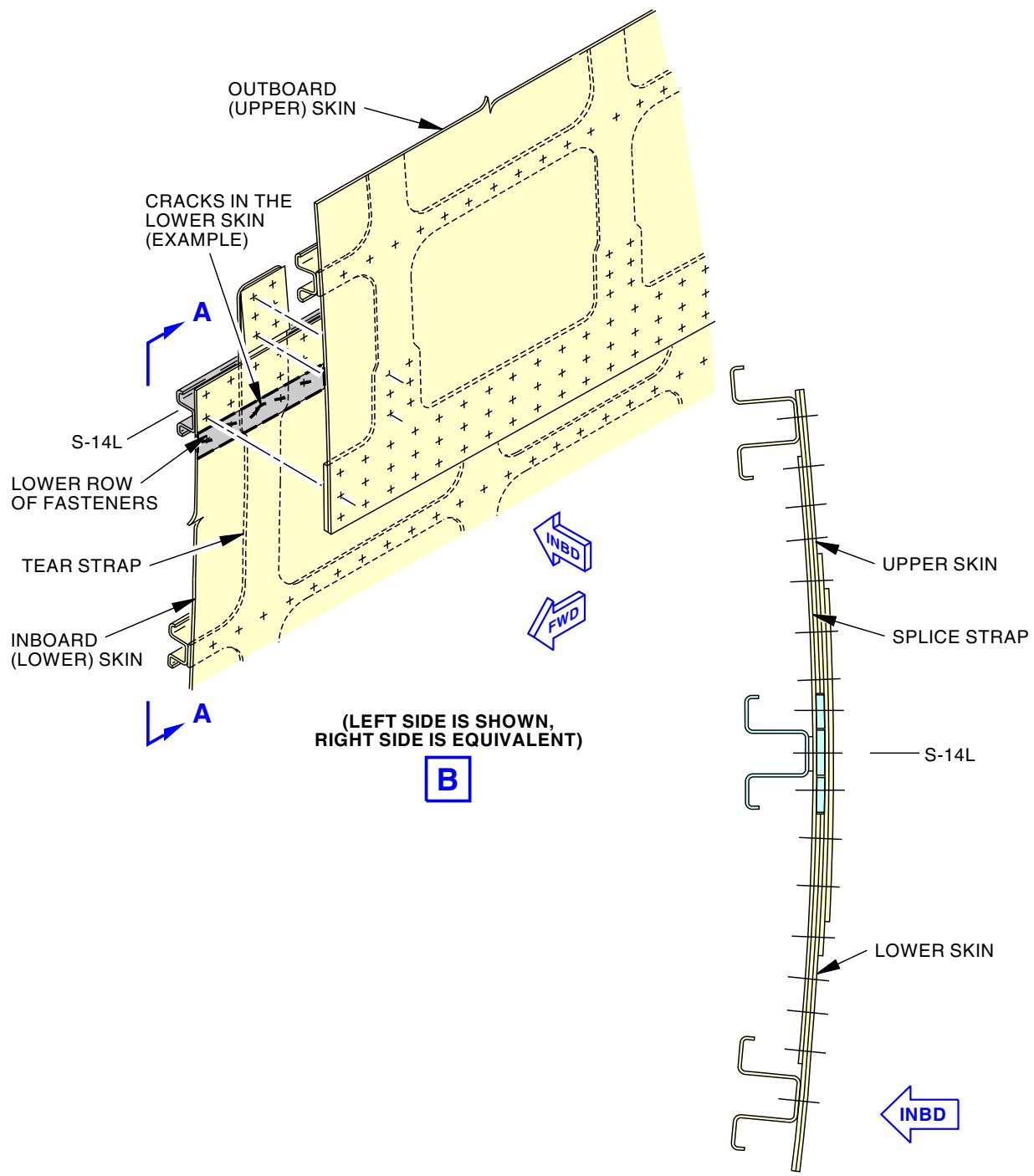


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ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-02**

Page 206  
Oct 15/2023



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**Longitudinal Lap Splice Lower Skin, S-14L and S-14R**  
**Figure 203/53-05-02-990-868**

EFFECTIVITY  
**LOM ALL**

**53-05-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-05-02-250-807**

**7. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLIC**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-007

- (1) Do a Low Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringer S-24L (from STA 259.5 to STA 334) and at stringer S-24R (from STA 259.5 to STA 360).

See Doc D626A001-DTR, DTR check form 53-10-03-5 for alternative inspections.

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 53-30-50.

———— END OF TASK ————

**TASK 53-05-02-250-809**

**8. INTERNAL - SPECIAL DETAILED: CUTOUT - CREW CAB WINDOWS (LN 1389 & ON)**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-009

- (1) Do a High Frequency Eddy Current inspection of the AB post structure, from inside the aircraft, from the upper to lower sills and the post flanges aft of fastener locations.

See Doc D626A001-DTR, DTR check form 53-10-04-1a for alternative inspections.

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 53-10-75.

———— END OF TASK ————

**TASK 53-05-02-211-802**

**9. EXTERNAL - DETAILED: CUTOUT - CREW CAB WINDOWS (LN 1389 & ON)**

Figure 204

NOTE: This procedure is a scheduled maintenance task.

———— EFFECTIVITY ————  
LOM ALL



737-600/700/800/900  
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**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-002

- (1) Do a Detailed inspection of the CD post, from outside the aircraft, along the entire post length on both the left and right sides.

See Doc D626A001-DTR, DTR check form 53-10-04-2a for alternative inspections.

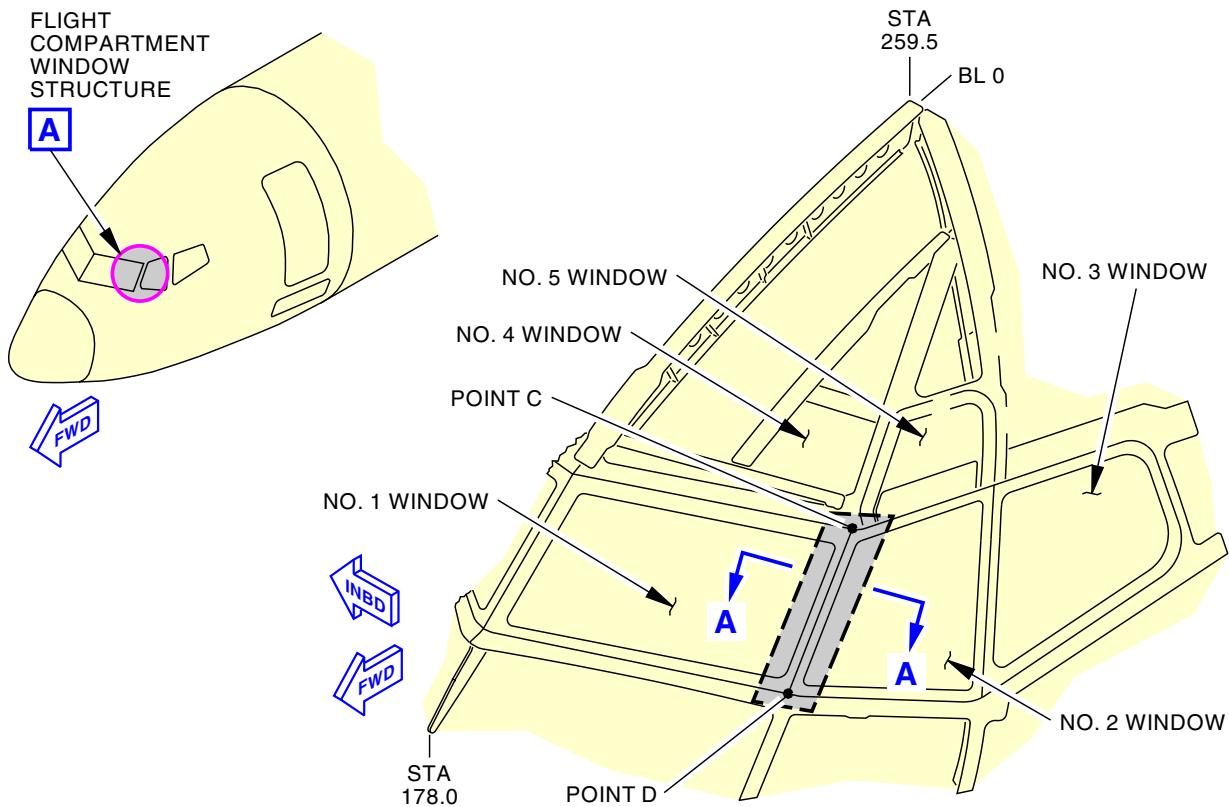
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

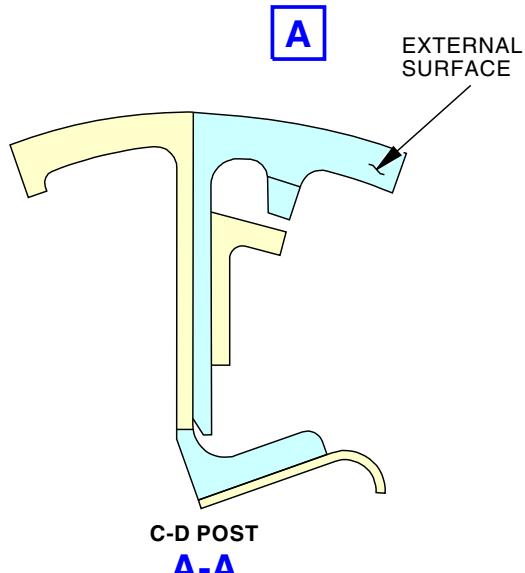
**53-05-02**



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FLIGHT COMPARTMENT WINDOW STRUCTURE  
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)



3026923 S0000797892\_V1

Cutout Crew Cab Windows  
Figure 204/53-05-02-990-869

EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-02**

Page 210  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-803**

**10. EXTERNAL - DETAILED: CUTOUT - CREW CAB WINDOWS**

Figure 205

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-003

- (1) Do a Detailed inspection of the EF post, from outside the aircraft, along the entire post length on both the left and right sides.

See Doc D626A001-DTR, DTR check form 53-10-04-3 for alternative inspections.

———— END OF TASK ————

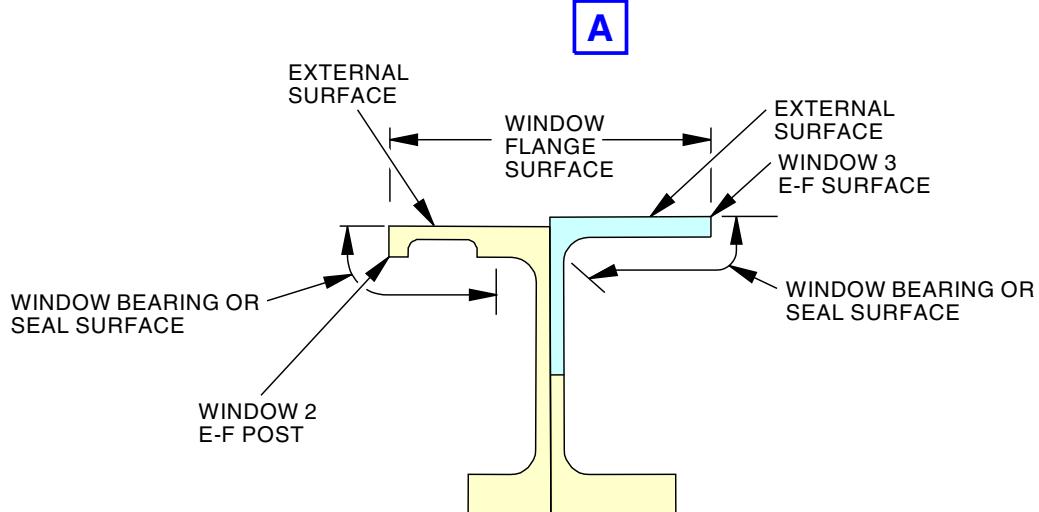
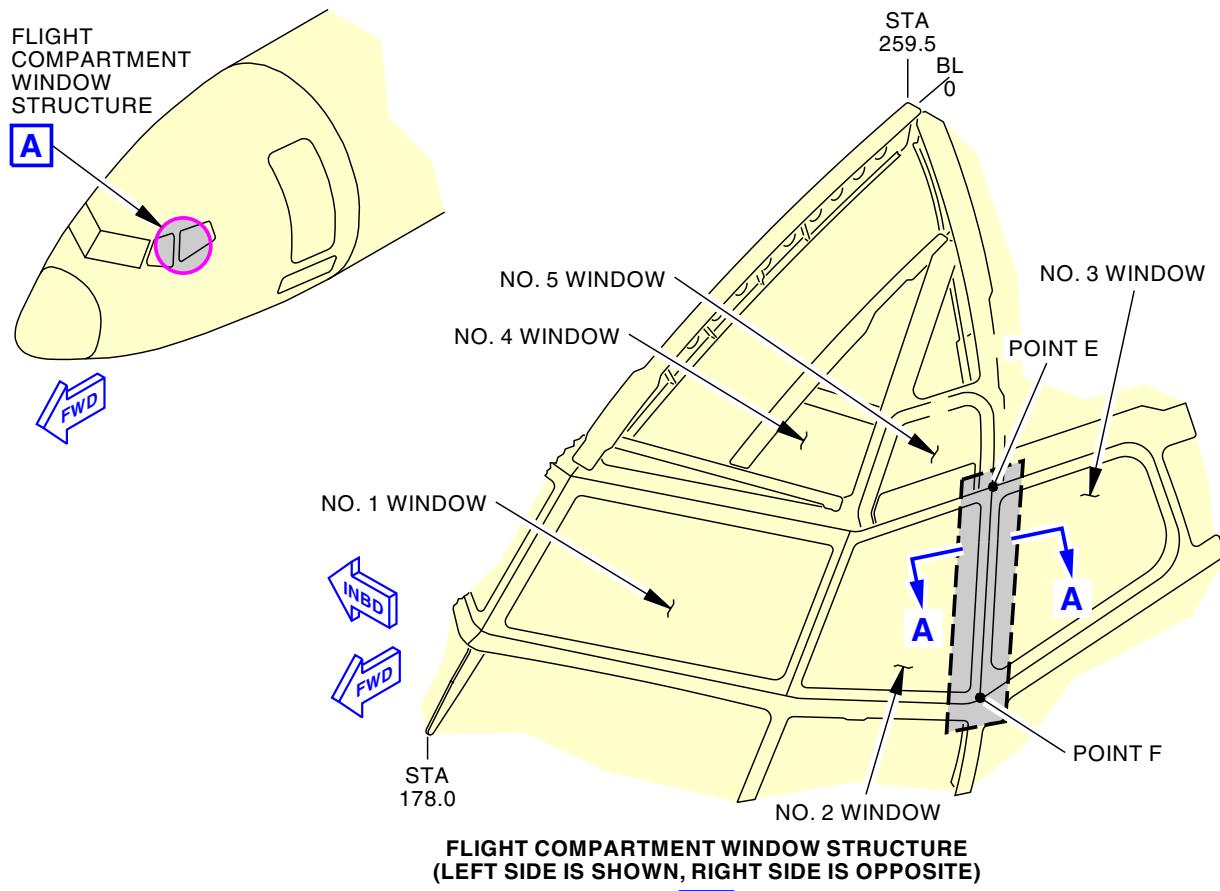
EFFECTIVITY  
LOM ALL

**53-05-02**

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737-600/700/800/900  
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A-A

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Cutout - Crew Cab Windows  
Figure 205/53-05-02-990-871

EFFECTIVITY  
LOM ALL

53-05-02

D633A101-LOM



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**TASK 53-05-02-250-811**

**11. EXTERNAL - SPECIAL DETAILED: CUTOUT - CREW CAB WINDOWS (LN 1389 & ON)**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-011

- (1) Do a Low Frequency Eddy Current inspection on both rows of fasteners attaching the skin to the BD Sill, from outside the aircraft, between LBL 8 and LBL 26.5. Repeat the process between RBL 8 and RBL 26.5.

See Doc D626A001-DTR, DTR check form 53-10-04-4a for alternative inspections.

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 53-10-76.

———— END OF TASK ————

**TASK 53-05-02-250-812**

**12. INTERNAL - SPECIAL DETAILED: CUTOUT - CREW CABIN WINDOWS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Remove glareshield as required to perform the inspection.

SUBTASK 53-05-02-250-012

- (1) Do a High Frequency Eddy Current inspection on the flanges of the Point D Fitting, from the CD post inboard to the second fastener common to the BD sill, on both the left and right sides.

See Doc D626A001-DTR, DTR check form 53-10-04-5 for alternative inspections.

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 53-10-72.

———— END OF TASK ————

**TASK 53-05-02-250-813**

**13. INTERNAL - SPECIAL DETAILED: CUTOUT - CREW CABIN WINDOWS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

EFFECTIVITY
LOM ALL

**53-05-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**B. Inspection**

NOTE: Remove glareshield if/as required to perform inspection.

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

There are four (4) fasteners that join the angle and the fitting.

SUBTASK 53-05-02-250-013

- (1) Do a High Frequency Eddy Current inspection of the Inconel angle around the (7) fasteners that join the angle to the B-D Sill Web and Point "D" Fitting.

See Doc D626A001-DTR, DTR check form 53-10-04-6 for alternative inspections.

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 53-10-71.

———— END OF TASK ————

**TASK 53-05-02-250-814**

**14. EXTERNAL - SPECIAL DETAILED: CROWN SKIN PANEL - FWD OF STA 259.5**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-014

- (1) Do a Low Frequency Eddy Current inspection of the subsurface of the first row of fasteners, on the left and right side, of BL 0.0 between the cab window cutout and STA 259.5 panel splice.

See Doc D626A001-DTR, DTR check form 53-10-05-1 for alternative inspections.

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 53-30-57.

———— END OF TASK ————

**TASK 53-05-02-211-804**

**15. EXTERNAL - DETAILED: CUTOUT - ELECTRONIC EQUIPMENT DOOR**

Figure 206

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-004

- (1) Do a Detailed inspection of the skin at the edge of the E/E door cutout and around the two rows of fasteners adjacent to the edge. Inspection is performed along the entire perimeter of the E/E door cutout and bounded by Sta 323.7 and Sta 351.2, and RBL 15.47 and LBL 6.74.

EFFECTIVITY LOM ALL
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**53-05-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

See Doc D626A001-DTR, DTR check form 53-10-13-1 for alternative inspections.

———— END OF TASK ——

— EFFECTIVITY —  
**LOM ALL**

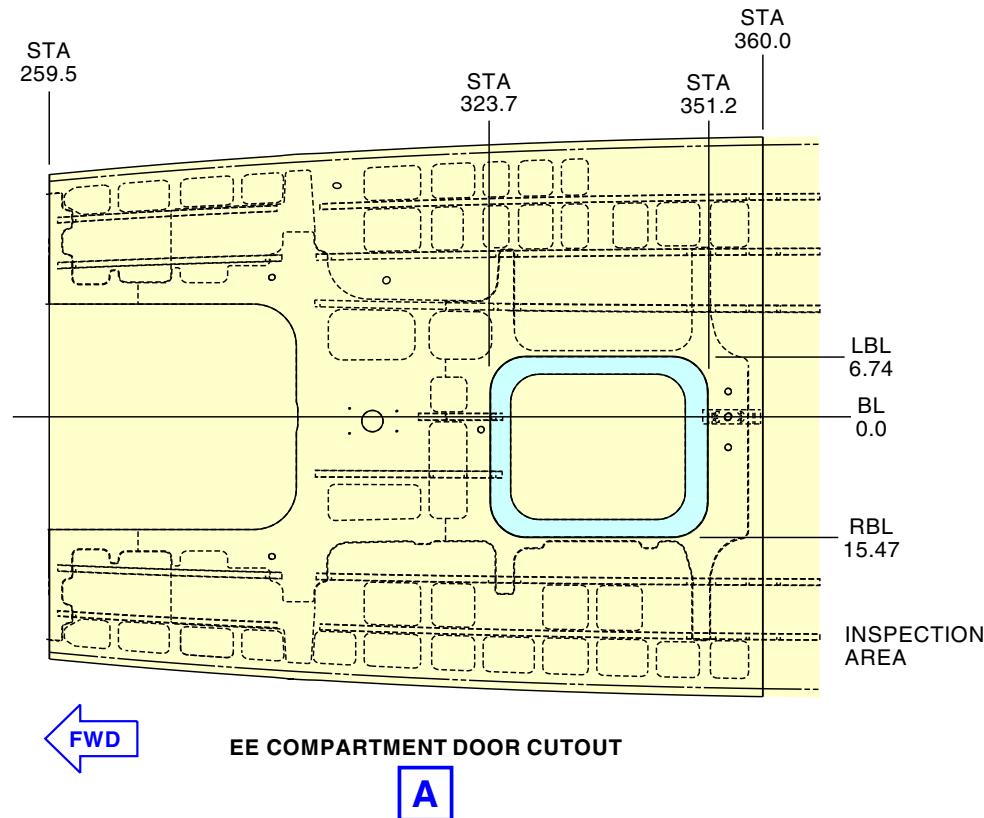
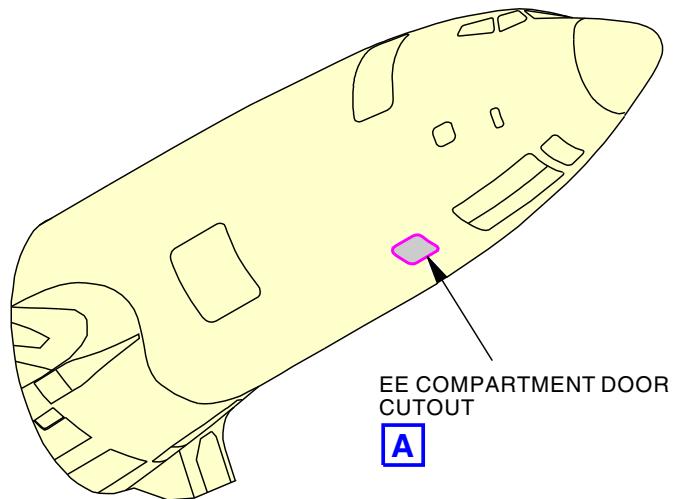
**53-05-02**

Page 215  
Oct 15/2023

D633A101-LOM



737-600/700/800/900  
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Cutout-Electronic Equipment Door  
Figure 206/53-05-02-990-873

EFFECTIVITY  
LOM ALL

**53-05-02**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-05-02-250-816**

**16. EXTERNAL - SPECIAL DETAILED: CUTOUT - FORWARD ENTRY DOOR FRAME**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-016

- (1) Do a High Frequency Eddy Current inspection on the two rows of fasteners common to the forward edge frame and skin at STA 303.9 from stringers S-11L and S-12L.

See Doc. D626A001-DTR, DTR check form 53-10-14-4 for alternative inspections.

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 53-10-89.

———— END OF TASK ————

**TASK 53-05-02-250-817**

**17. EXTERNAL - SPECIAL DETAILED: CUTOUT - FORWARD ENTRY DOOR FRAME**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-017

- (1) Do a High Frequency Eddy Current inspection around the two rows of fasteners common to the forward edge frame and skin at STA 303.9 from stringers S-7L to S-11L and stringers S-12L to S-13L.

See Doc. D626A001-DTR, DTR check form 53-10-14-5 for alternative inspections.

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 53-10-89.

———— END OF TASK ————

**TASK 53-05-02-211-805**

**18. INTERNAL - DETAILED: FWD ENTRY DOOR, FWD EDGE FRAME STOPS**

Figure 207

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Remove interior panels as required to perform inspection.



**53-05-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-05-02-211-005

- (1) Do a Detailed inspection around the fasteners in the inboard flange of the stop fittings from stringer S-7 thru S-16.

See Doc. D626A001-DTR, DTR check form 53-10-14-7 for alternative inspections.

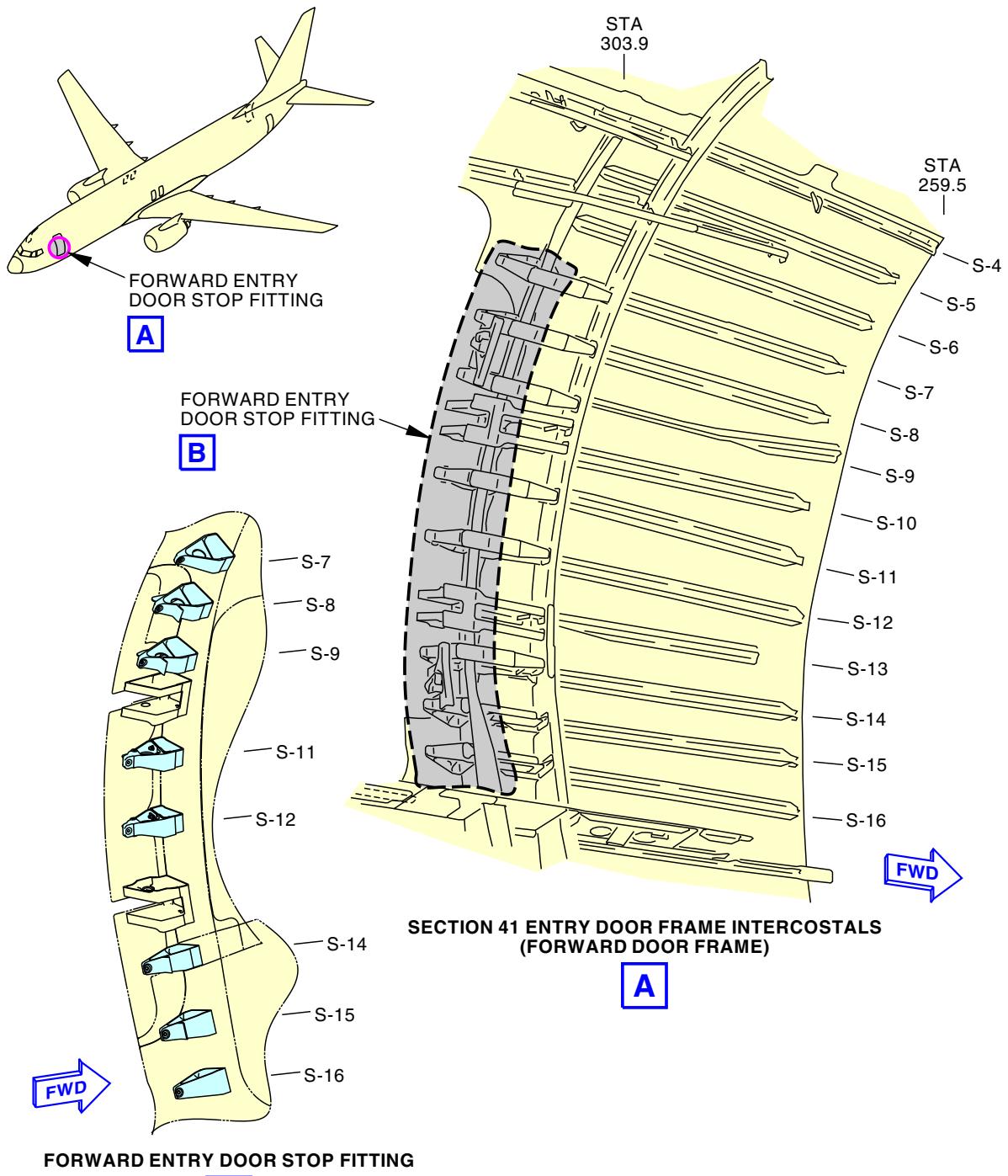
———— END OF TASK ————

— EFFECTIVITY —  
**LOM ALL**

**53-05-02**

Page 218  
Oct 15/2023

D633A101-LOM

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AIRCRAFT MAINTENANCE MANUAL**


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**FWD Entry Door, FWD Edge Frame Stops  
Figure 207/53-05-02-990-874**

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-806**

**19. INTERNAL - DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

Figure 208

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-120

- (1) Open this access panel:

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

SUBTASK 53-05-02-211-006

- (2) Do a Detailed inspection of the upper sill inner chord. (PSE 53-30-08-11).

See Doc. D626A001-DTR, DTR check form 53-60-08-11, for alternative inspections.

SUBTASK 53-05-02-410-118

- (3) Close this access panel:

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

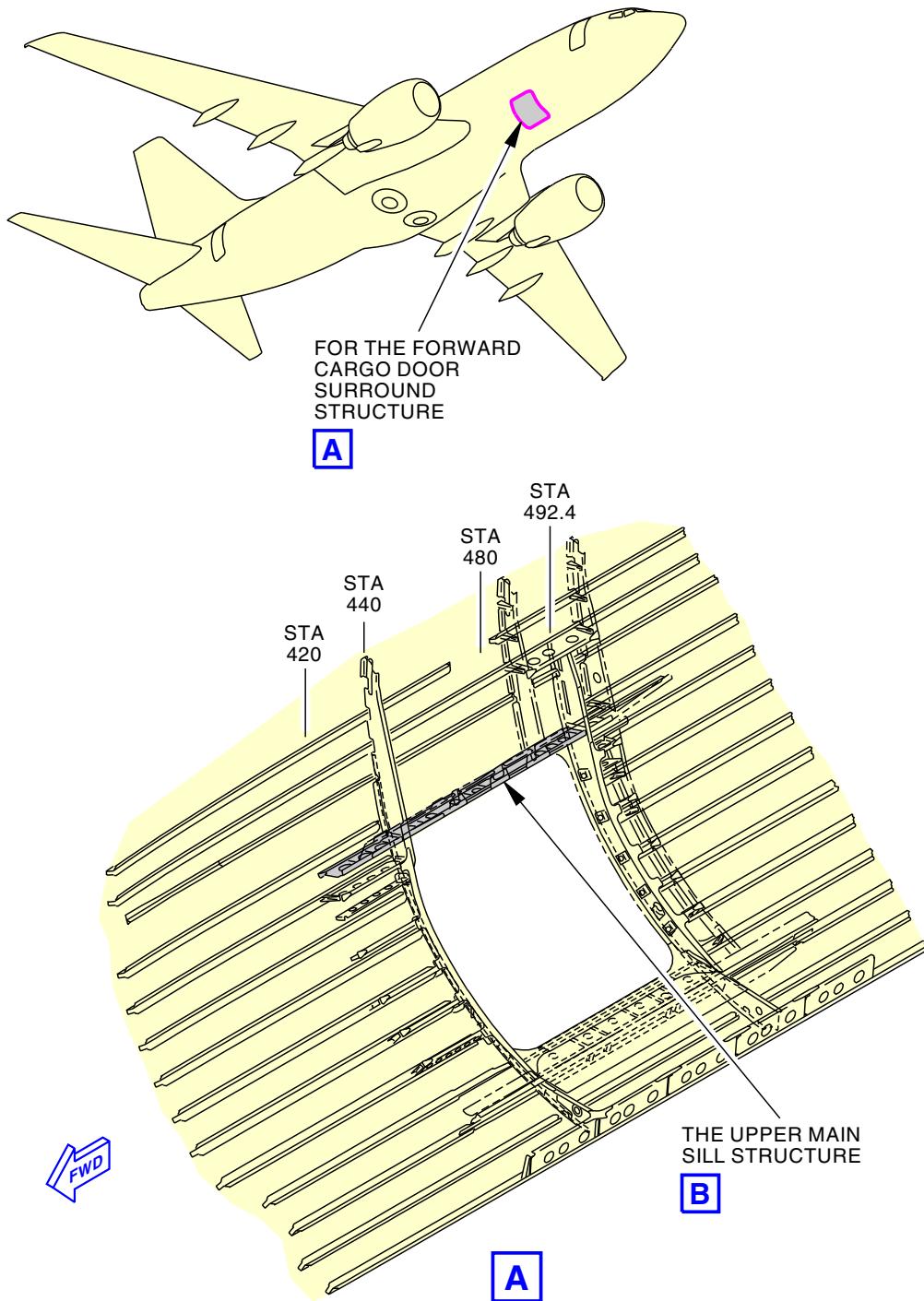
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3027989 S0000799260\_V1

**Forward Cargo Door Surround Structure (Upper Sill Inner Chord)**  
Figure 208/53-05-02-990-889 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

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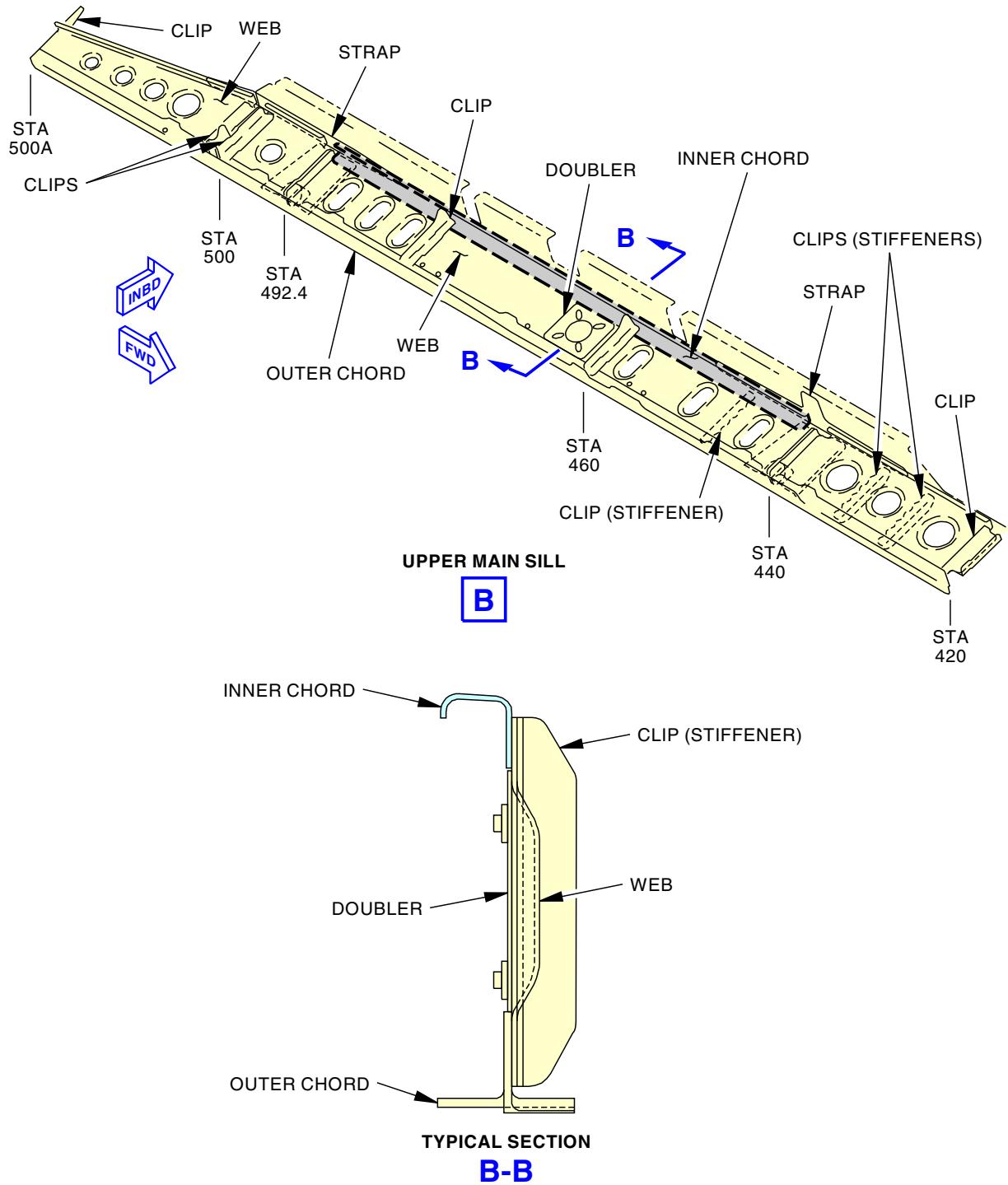
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-02**

Page 221  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3028021 S0000799462\_V1

Forward Cargo Door Surround Structure (Upper Sill Inner Chord)  
Figure 208/53-05-02-990-889 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

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**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-05-02-250-818**

**20. INTERNAL - SPECIAL DETAILED: FWD ENTRY DOOR FWD EDGE FRAME STOPS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Remove interior panels as required to perform inspection.

SUBTASK 53-05-02-250-018

- (1) Do a High Frequency Eddy Current inspection around the four fasteners on each stop strap at stringer S-7 thru S-14.

See Doc. D626A001-DTR, DTR check form 53-10-14-8 for alternative inspections.

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 53-11-01.

———— END OF TASK ————

**TASK 53-05-02-250-819**

**21. INTERNAL - SPECIAL DETAILED: FWD ENTRY DOOR FWD EDGE FRAME STOPS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Remove interior panels as required to perform inspection

SUBTASK 53-05-02-250-019

- (1) Do a High Frequency Eddy Current inspection around the first two (2) fasteners in the necked down section of the stop straps at S-15 and S-16.

See Doc. D626A001-DTR, DTR check form 53-10-14-9 for alternative inspections.

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 53-11-01.

———— END OF TASK ————

**TASK 53-05-02-211-807**

**22. INTERNAL - DETAILED: FWD ENTRY DOOR AFT EDGE FRAME STOPS**

Figure 209

Figure 210

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

EFFECTIVITY  
LOM ALL

**53-05-02**

Page 223  
Oct 15/2023



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**B. Inspection**

SUBTASK 53-05-02-211-007

**NOTE:** Open FWD Entry Door. Removal of interior panel is required to perform the inspection.

- (1) Do a Detailed inspection of the S-15 and S-16 tension straps at the fastener holes on either side of Sta 351.2 frame.

See Doc. D626A001-DTR, DTR check form 53-10-14-10 for alternative inspections.

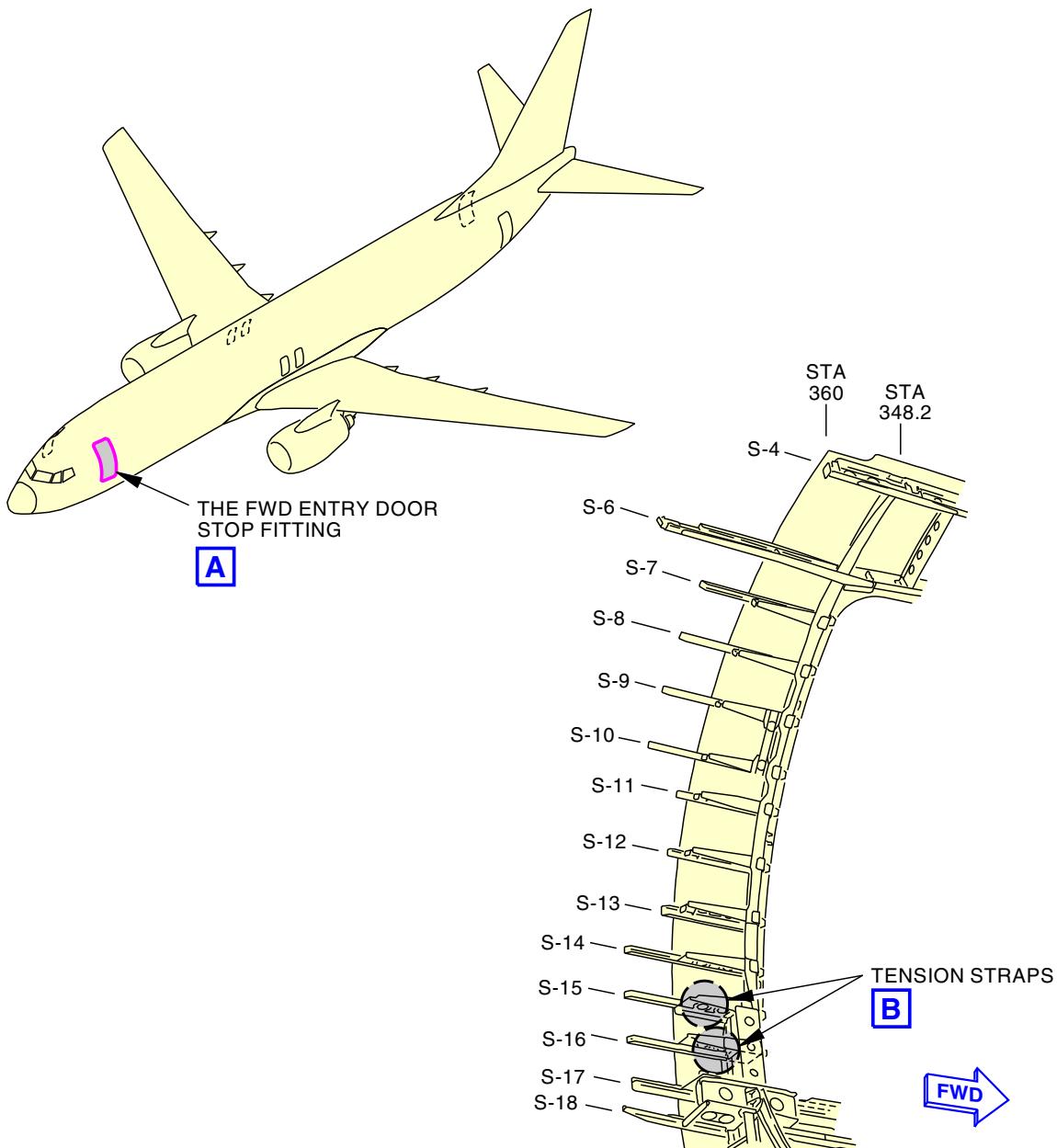
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



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AIRCRAFT MAINTENANCE MANUAL



SECTION 41 ENTRY DOOR FRAME INTERCOSTALS  
(AFT DOOR FRAME)

A

3026853 S0000797898\_V1

FWD Entry Door, AFT Edge Frame Stops  
Figure 209/53-05-02-990-875

EFFECTIVITY  
LOM ALL

**53-05-02**

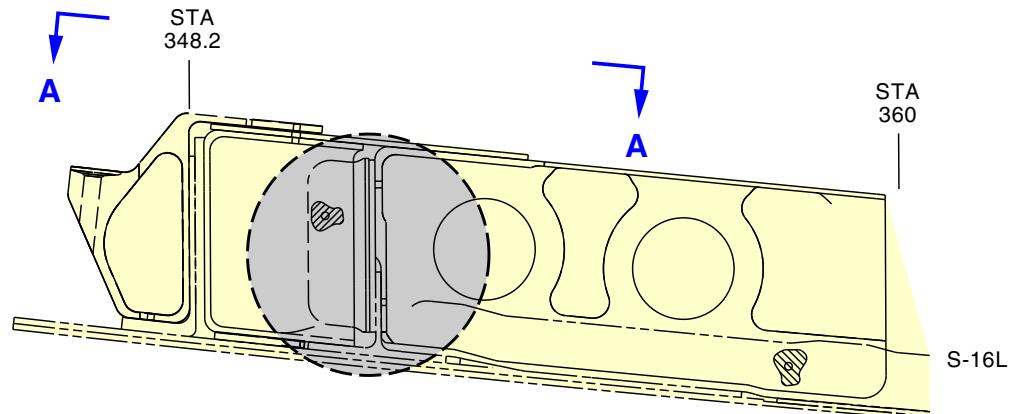
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

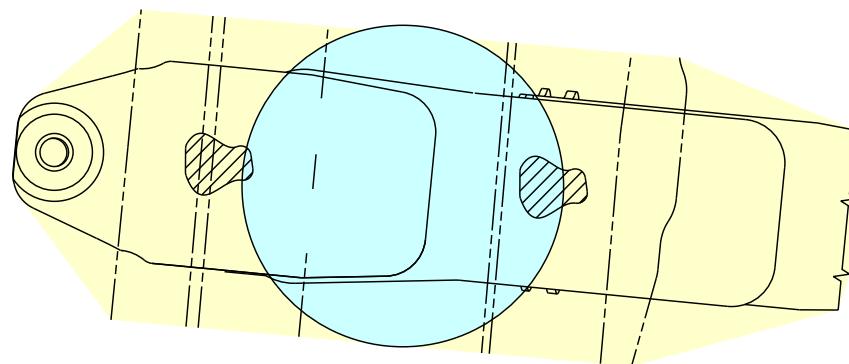
Page 225  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



TENSION STRAPS  
**B**



**A-A**

3026857 S0000798169\_V1

FWD Entry Door, AFT Edge Frame Stops Straps  
Figure 210/53-05-02-990-876

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 226  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-808**

**23. INTERNAL - DETAILED: FWD ENTRY DOOR AFT EDGE FRAME STOPS**

Figure 211

Figure 212

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Open FWD Entry Door. Removal of interior panel is required to perform the inspection.

SUBTASK 53-05-02-211-008

- (1) Do a Detailed inspection of the Aft frame stops at the inner flange holes near Sta 348.2 from stringer S-7 to S-14.

See Doc. D626A001-DTR, DTR check form 53-10-14-11 for alternative inspections.

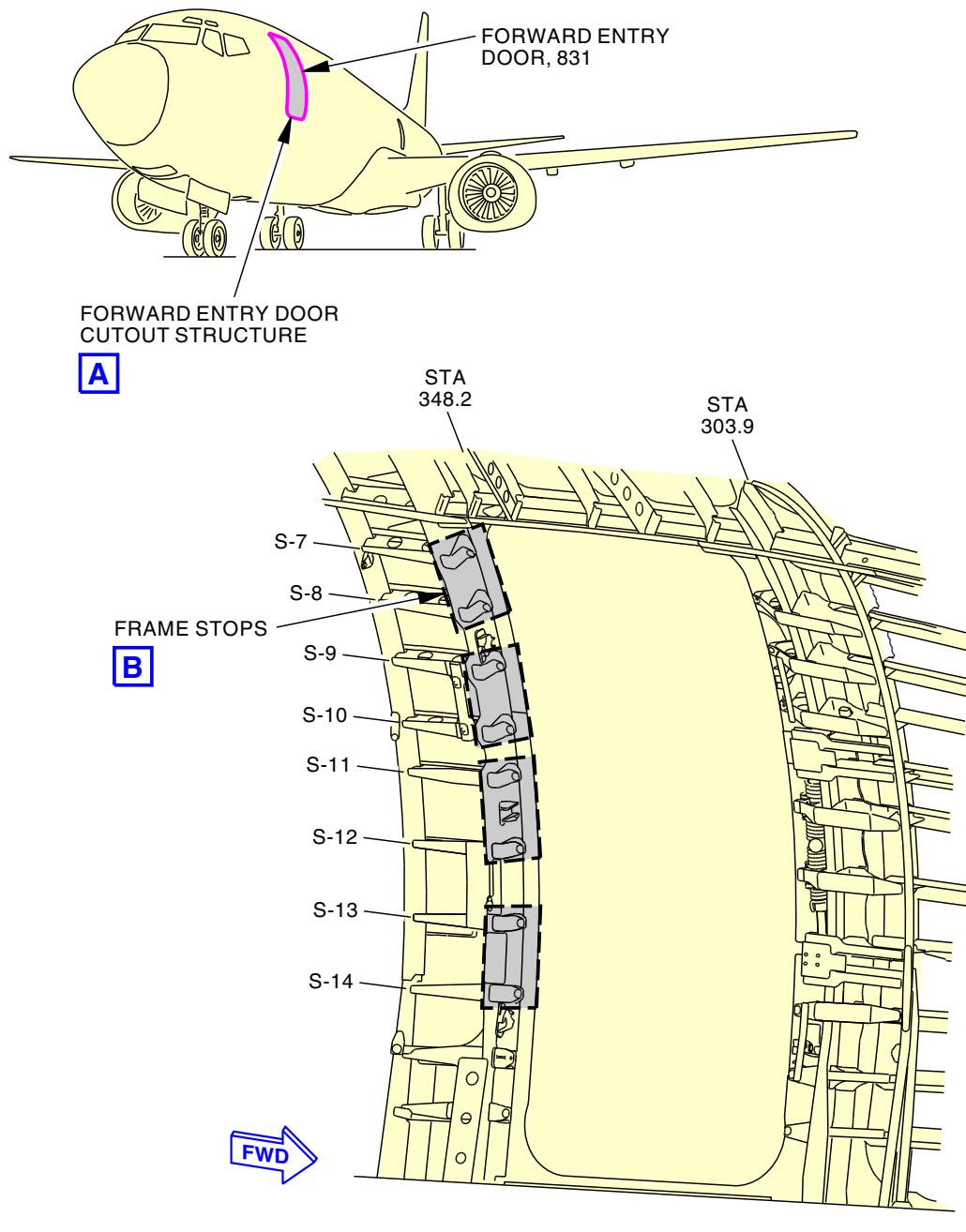
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



A

3027888 S0000799233\_V1

FWD Entry Door, AFT Edge Frame Stops  
Figure 211/53-05-02-990-877

EFFECTIVITY  
LOM ALL

**53-05-02**

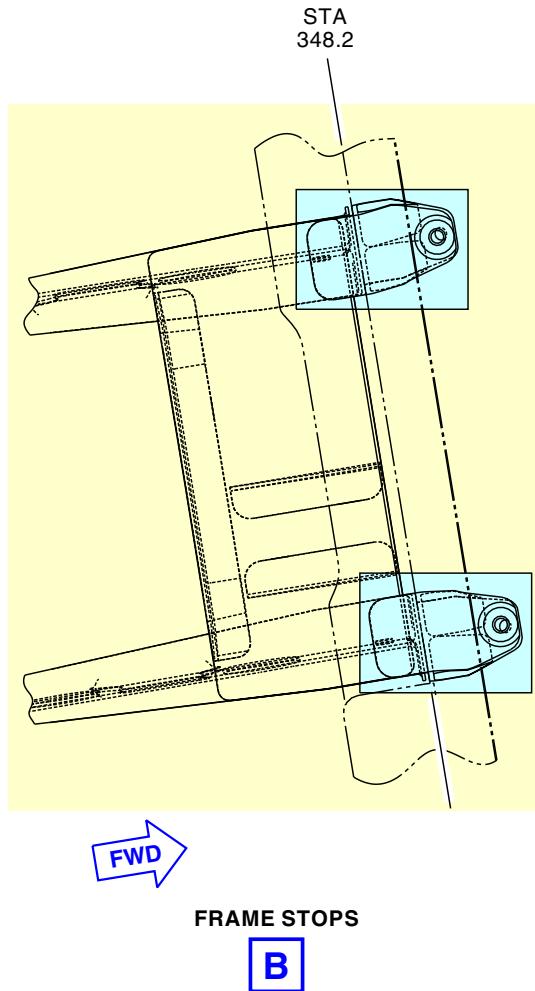
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Page 228  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3027970 S0000799234\_V1

**FWD Entry Door, Two AFT Edge Frame Stops**  
Figure 212/53-05-02-990-878

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 229  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-820**

**24. INTERNAL - SPECIAL DETAILED: FWD ENTRY DOOR CUTOUT**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
117	Electrical and Electronics Compartment - Left
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left

**B. Inspection**

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

SUBTASK 53-05-02-250-020

- (1) Do a High Frequency Eddy Current inspection of the skin around the fastener holes and along the edge of the cutout hidden by the scuff plates from STA 303 to STA 350.

See Doc. D626A001-DTR, DTR check form 53-10-14-12 for alternative inspections.

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 53-30-43.

———— END OF TASK ————

**TASK 53-05-02-250-821**

**25. INTERNAL - SPECIAL DETAILED: FORWARD GALLEY DOOR SURROUND STRUCTURE DOOR STOP BACKUP STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Remove interior panels as required to perform inspection. Door stops are numbered from the bottom up.

SUBTASK 53-05-02-250-021

- (1) Do a High Frequency Eddy Current inspection of the four (4) fastener at each stop location common to the intercostal tension strap at the forward edge frame at stops #1, #2, #5, #6.

See Doc. D626A001-DTR, DTR check form 53-10-15-2 for alternative inspections.

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 53-10-98.

———— END OF TASK ————

**TASK 53-05-02-250-822**

**26. EXTERNAL - SPECIAL DETAILED: CUTOUT - FWD GALLEY DOOR**

NOTE: This procedure is a scheduled maintenance task.



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-022

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

See Doc. D626A001-DTR, DTR check form 53-10-15-4 for alternative inspections.

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 53-30-55.

————— END OF TASK ————

**TASK 53-05-02-250-823**

**27. INTERNAL - SPECIAL DETAILED: BULKHEAD, STA 294.5**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

**B. Access Panels**

Number	Name/Location
117A	Electronic Equipment Access Door

**C. Inspection**

SUBTASK 53-05-02-010-046

- (1) Open this access panel:

Number    Name/Location

117A        Electronic Equipment Access Door

NOTE: Access through E/E Bay Aft of Nose Wheel Well.

SUBTASK 53-05-02-250-023

- (2) Do a High Frequency Eddy Current inspection around the fasteners in the WL 172 beam just outboard of LBL 17 and RBL 17 at the nose wheel well Aft bulkhead.

See Doc. D626A001-DTR, DTR check form 53-10-18-1 for alternative inspections.

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 53-10-99.

EFFECTIVITY
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-05-02-410-044

- (3) Close this access panel:

**Number      Name/Location**

117A      Electronic Equipment Access Door

———— END OF TASK ————

**TASK 53-05-02-211-809**

**28. INTERNAL - DETAILED: NOSE WHEEL WELL SIDE AND TOP PANELS**

Figure 213

Figure 214

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
53-14-01-020-801	Nose Wheel Well Access Panels - Removal (P/B 401)
53-14-01-420-801	Nose Wheel Well Access Panels - Installation (P/B 401)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right

**C. Access Panels**

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

**D. Inspection**

SUBTASK 53-05-02-010-014

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

**Number      Name/Location**

113BW      Forward Nose Wheel Well Panel

Open this access panel on the Right side:

**Number      Name/Location**

114BW      Forward Nose Wheel Well Panel

NOTE: Access through Left Aft Nose Wheel Well Panel.

Access through Right Aft Nose Wheel Well Panel.

- (a) Do this task: Nose Wheel Well Access Panels - Removal, TASK 53-14-01-020-801.

SUBTASK 53-05-02-211-009

- (2) Do a Detailed inspection of the Aft access cutout forward vertical beam at Sta 260, from WL 170 to WL 184.

See Doc. D626A001-DTR, DTR check form 53-10-19-4, for alternative inspections.

— EFFECTIVITY —  
**LOM ALL**

**53-05-02**

Page 232  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-05-02-410-012

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

**Number      Name/Location**

113BW      Forward Nose Wheel Well Panel

Close this access panel on the Right side:

**Number      Name/Location**

114BW      Forward Nose Wheel Well Panel

- (a) Do this task: Nose Wheel Well Access Panels - Installation, TASK 53-14-01-420-801.

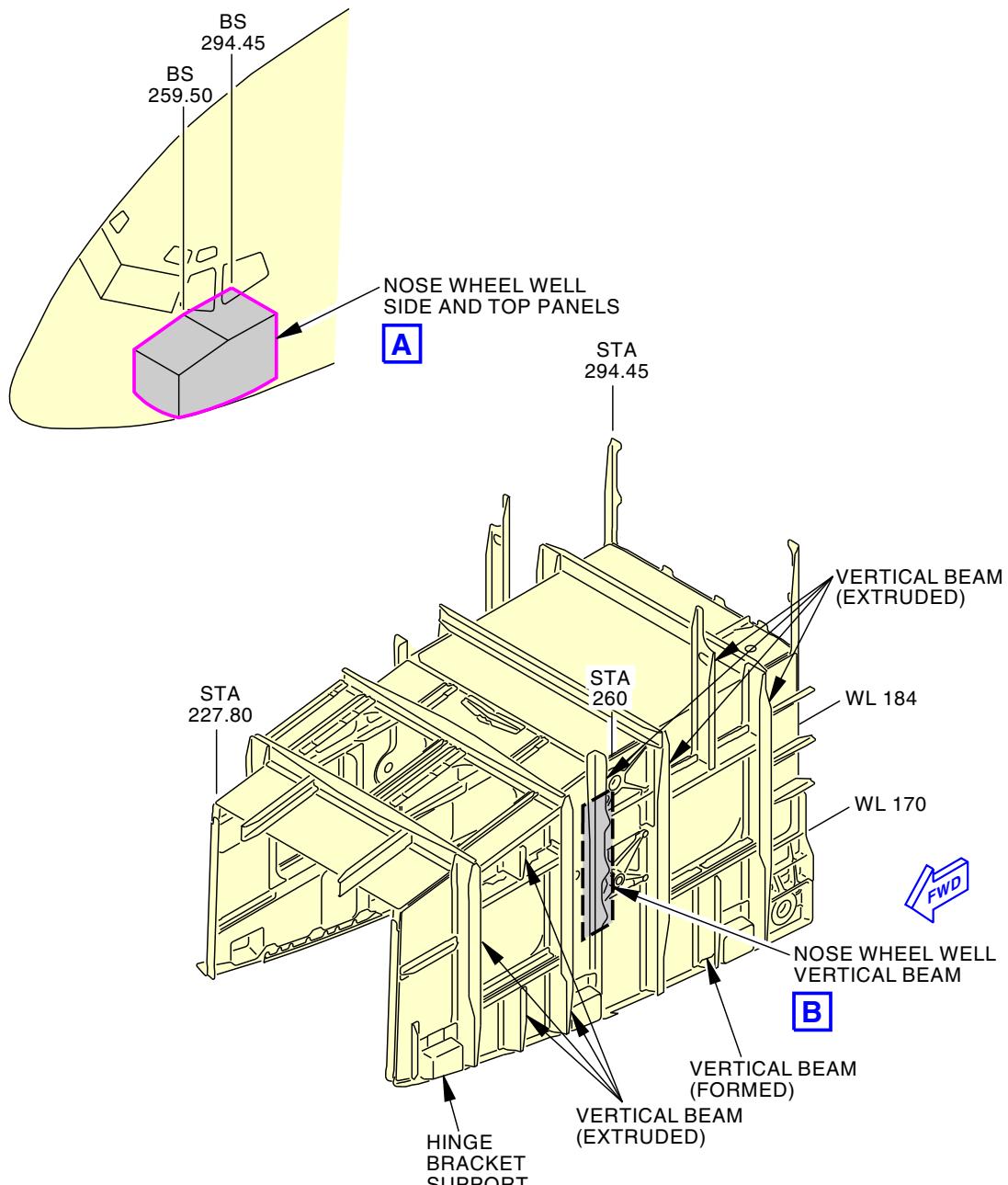
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**

Page 233  
Oct 15/2023

D633A101-LOM



LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE  
SIDE PANEL (PRESSURIZED SIDE)

**A**

3027962 S0000799239\_V1

**Nose Wheel Well Side and Top Panels**  
**Figure 213/53-05-02-990-879**

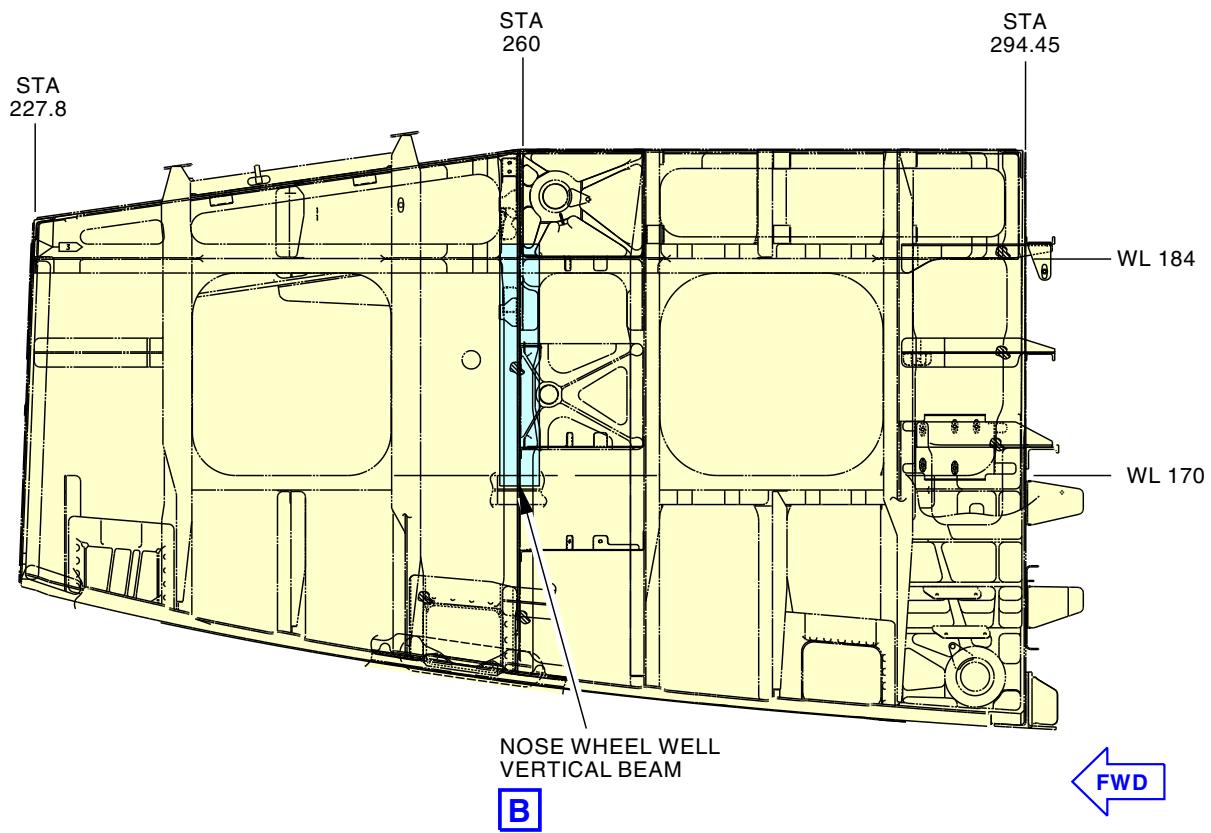
EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM



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3027983 S0000799240\_V1

Nose Wheel Well Side and Top Panels Vertical Beam  
Figure 214/53-05-02-990-880

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 235  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-810**

**29. INTERNAL - DETAILED: NOSE LANDING GEAR SUPPORT FITTINGS**

Figure 215

Figure 216

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

**A. References**

<b>Reference</b>	<b>Title</b>
53-14-01-020-801	Nose Wheel Well Access Panels - Removal (P/B 401)
53-14-01-420-801	Nose Wheel Well Access Panels - Installation (P/B 401)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

**D. Inspection**

SUBTASK 53-05-02-010-015

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

<b>Number</b>	<b>Name/Location</b>
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel

**NOTE:** For Direction 1, removal of Drag Brace is required. Sealant that extends beyond 0.40" around fastener heads or collars must be removed.

- (a) Do this task: Nose Wheel Well Access Panels - Removal, TASK 53-14-01-020-801.

SUBTASK 53-05-02-211-010

- (2) Do a Detailed inspection of the inboard and outboard drag brace fittings around the perimeter of the bushings at Sta 262, BL 16, WL 189.3.

See Doc. D626A001-DTR, DTR check form 53-10-20-2 for alternative inspections.

SUBTASK 53-05-02-410-013

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

<b>Number</b>	<b>Name/Location</b>
113AW	Forward Nose Wheel Well Panel

EFFECTIVITY  
LOM ALL

**53-05-02**

Page 236  
Oct 15/2023



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

(Continued)

**Number      Name/Location**

113BW      Forward Nose Wheel Well Panel

Close these access panels on the Right side:

**Number      Name/Location**

114AW      Forward Nose Wheel Well Panel

114BW      Forward Nose Wheel Well Panel

(a) Do this task: Nose Wheel Well Access Panels - Installation, TASK 53-14-01-420-801.

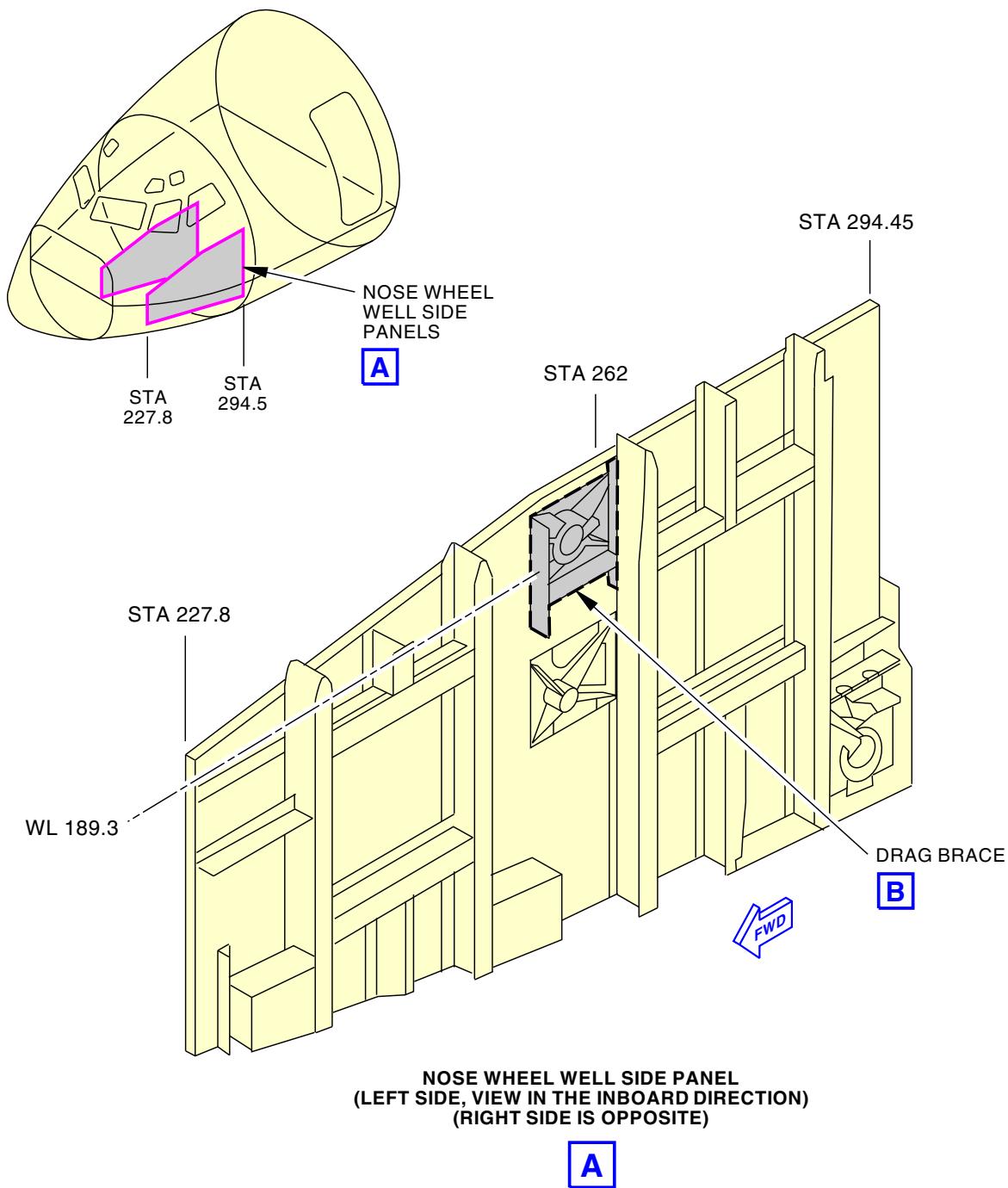
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



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AIRCRAFT MAINTENANCE MANUAL



3027905 S0000799250\_V1

**Nose Landing Gear Support Fittings**  
Figure 215/53-05-02-990-881

EFFECTIVITY  
LOM ALL

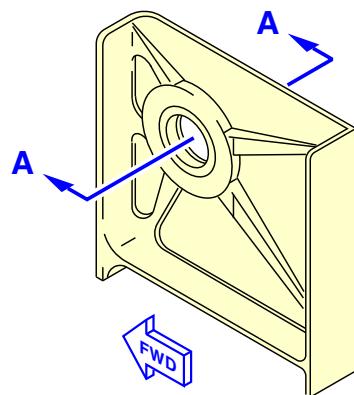
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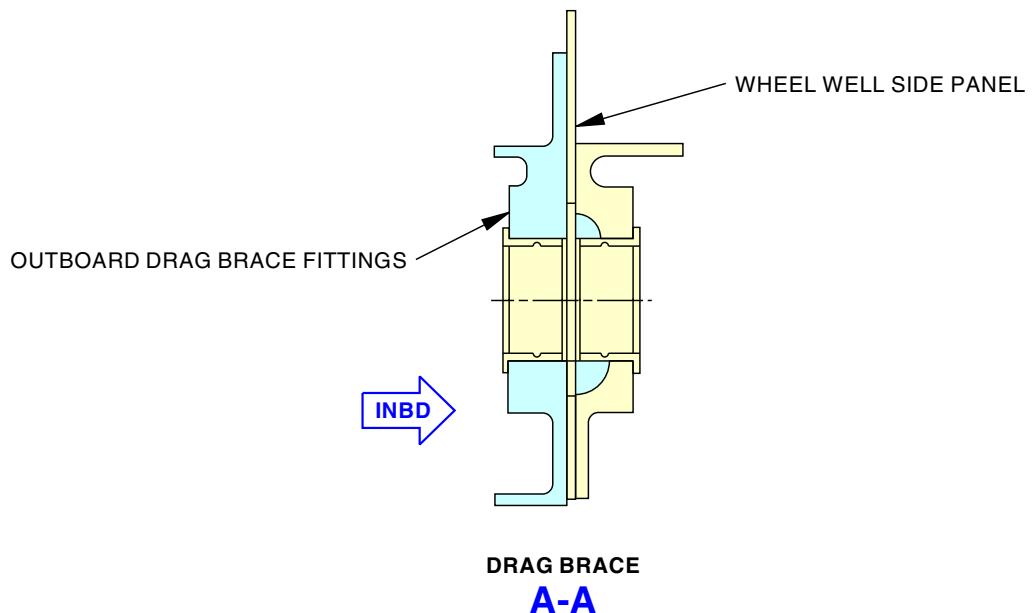
Page 238  
Oct 15/2023

**BOEING**  
737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



DRAG BRACE OUTBOARD SHOWN  
(OUTBOARD SHOWN, INBOARD IS EQUIVALENT)

**B**



DRAG BRACE  
**A-A**

3028121 S0000799251\_V1

Nose Landing Gear Support Fitting, Drag Brace Fitting  
Figure 216/53-05-02-990-882

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 239  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-811**

**30. INTERNAL - DETAILED: NOSE LANDING GEAR TRUNNION SUPPORT FITTING**

Figure 217

Figure 218

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

**A. References**

<b>Reference</b>	<b>Title</b>
53-14-01-020-801	Nose Wheel Well Access Panels - Removal (P/B 401)
53-14-01-420-801	Nose Wheel Well Access Panels - Installation (P/B 401)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
113BW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel
117A	Electronic Equipment Access Door

**D. Inspection**

SUBTASK 53-05-02-010-016

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

<b>Number</b>	<b>Name/Location</b>
113BW	Forward Nose Wheel Well Panel
117A	Electronic Equipment Access Door

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
114BW	Forward Nose Wheel Well Panel
117A	Electronic Equipment Access Door

- (a) Do this task: Nose Wheel Well Access Panels - Removal, TASK 53-14-01-020-801.

SUBTASK 53-05-02-211-011

- (2) Do a Detailed inspection of the inboard and outboard fitting segments of the Trunnion Support Fitting around the pin socket at BS 294.5, WL 156.1, and BL 16.

See Doc. D626A001-DTR, DTR check form 53-10-20-3 for alternative inspections.

SUBTASK 53-05-02-410-014

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

<b>Number</b>	<b>Name/Location</b>
113BW	Forward Nose Wheel Well Panel
117A	Electronic Equipment Access Door

EFFECTIVITY
LOM ALL

**53-05-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

Close these access panels on the Right Side:

**Number      Name/Location**

114BW      Forward Nose Wheel Well Panel  
117A      Electronic Equipment Access Door

- (a) Do this task: Nose Wheel Well Access Panels - Installation, TASK 53-14-01-420-801.

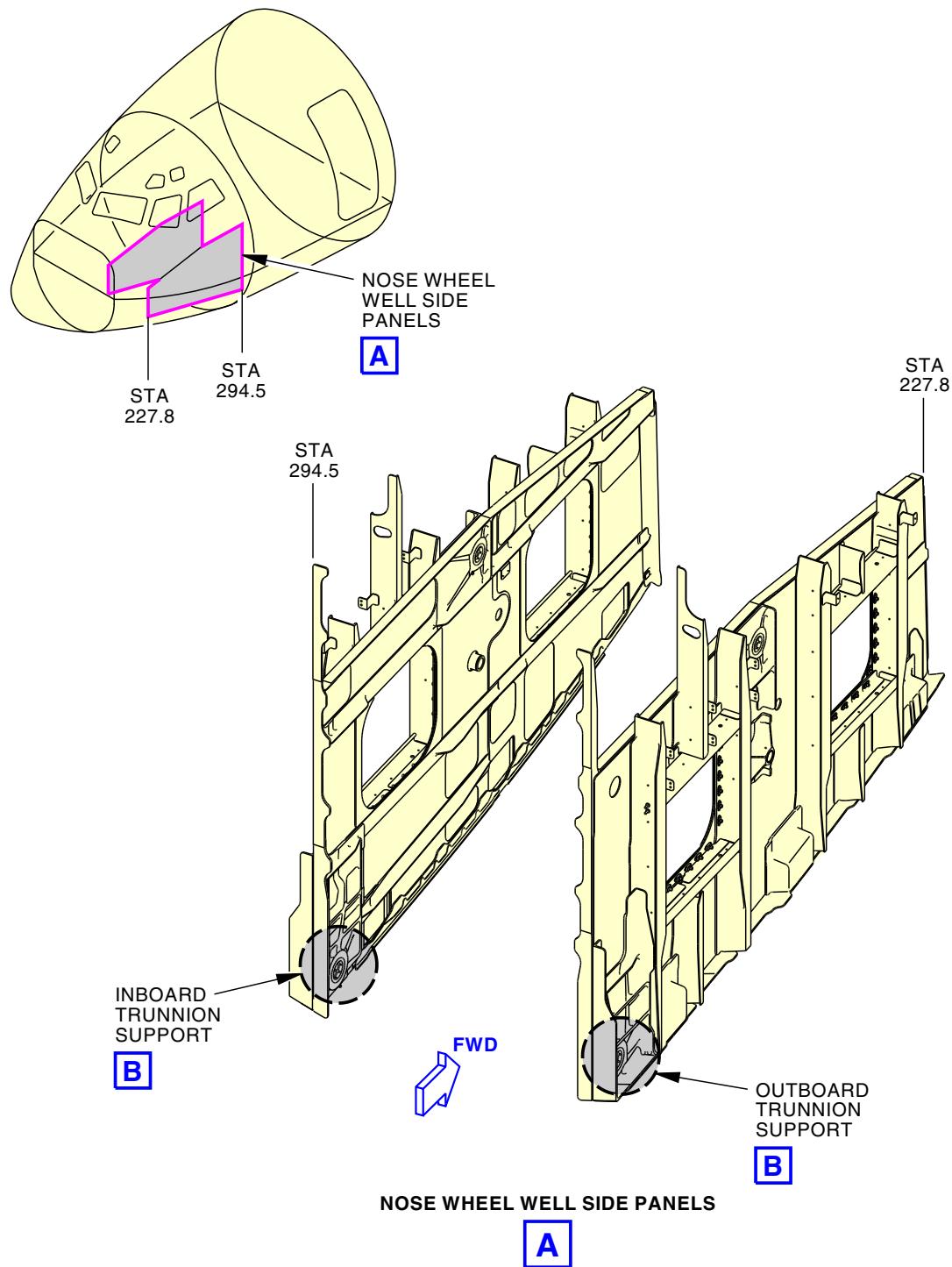
———— END OF TASK ————

EFFECTIVITY  
**LOM ALL**

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3027894 S0000799254\_V1

Nose Landing Gear Trunnion Support Fitting  
Figure 217/53-05-02-990-884

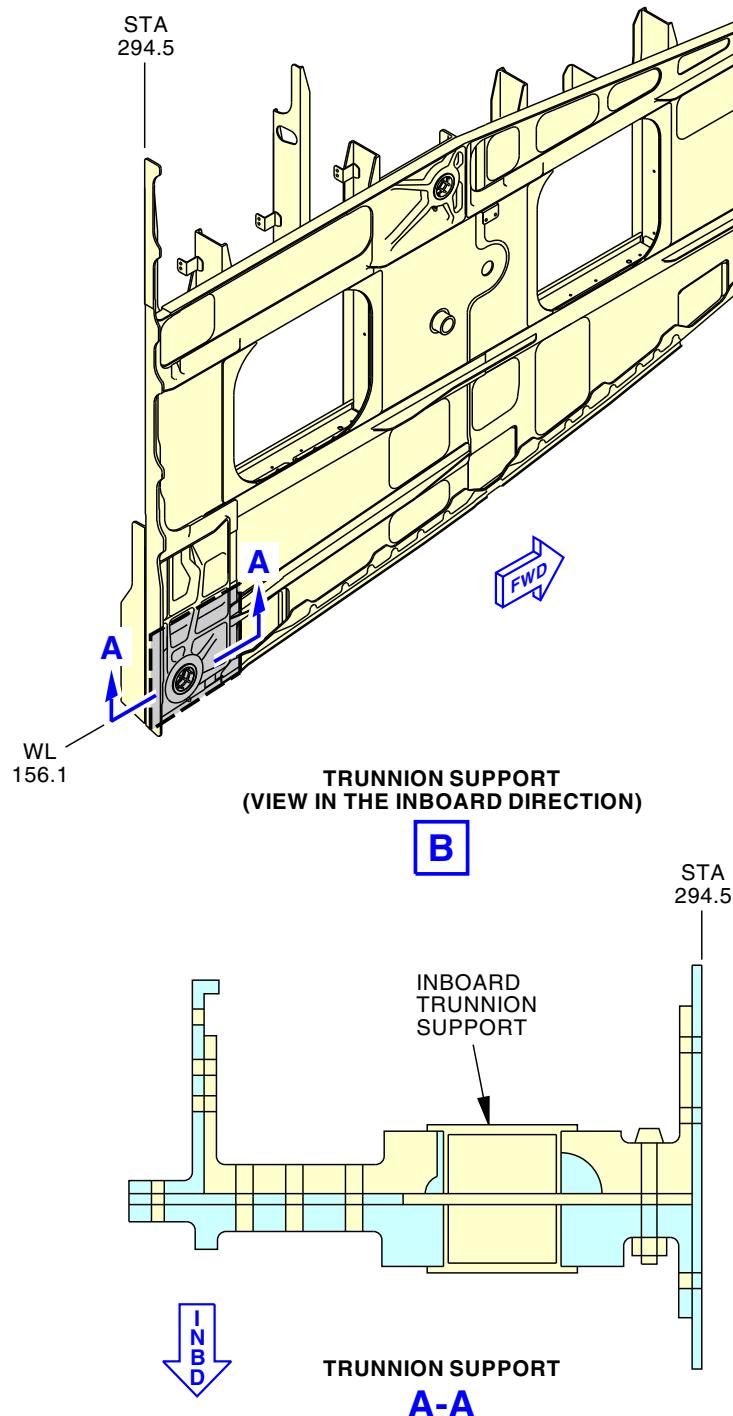
EFFECTIVITY	LOM ALL
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**53-05-02**

Page 242  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3027913 S0000799255\_V1

Nose Landing Gear Trunnion Support Fitting around pin socket  
Figure 218/53-05-02-990-885

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 243  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-813**

**31. EXTERNAL - DETAILED: CROWN SKIN PANEL STA 360 TO 540**

Figure 219

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-013

- (1) Do a Detailed inspection of the skin around all of the fastener locations from stringer S-10L to S-10R, from Sta 360 to Sta 540, except at the lap splices and antennas.

See Doc D626A001-DTR, DTR check form 53-30-01-2 for alternative inspections.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

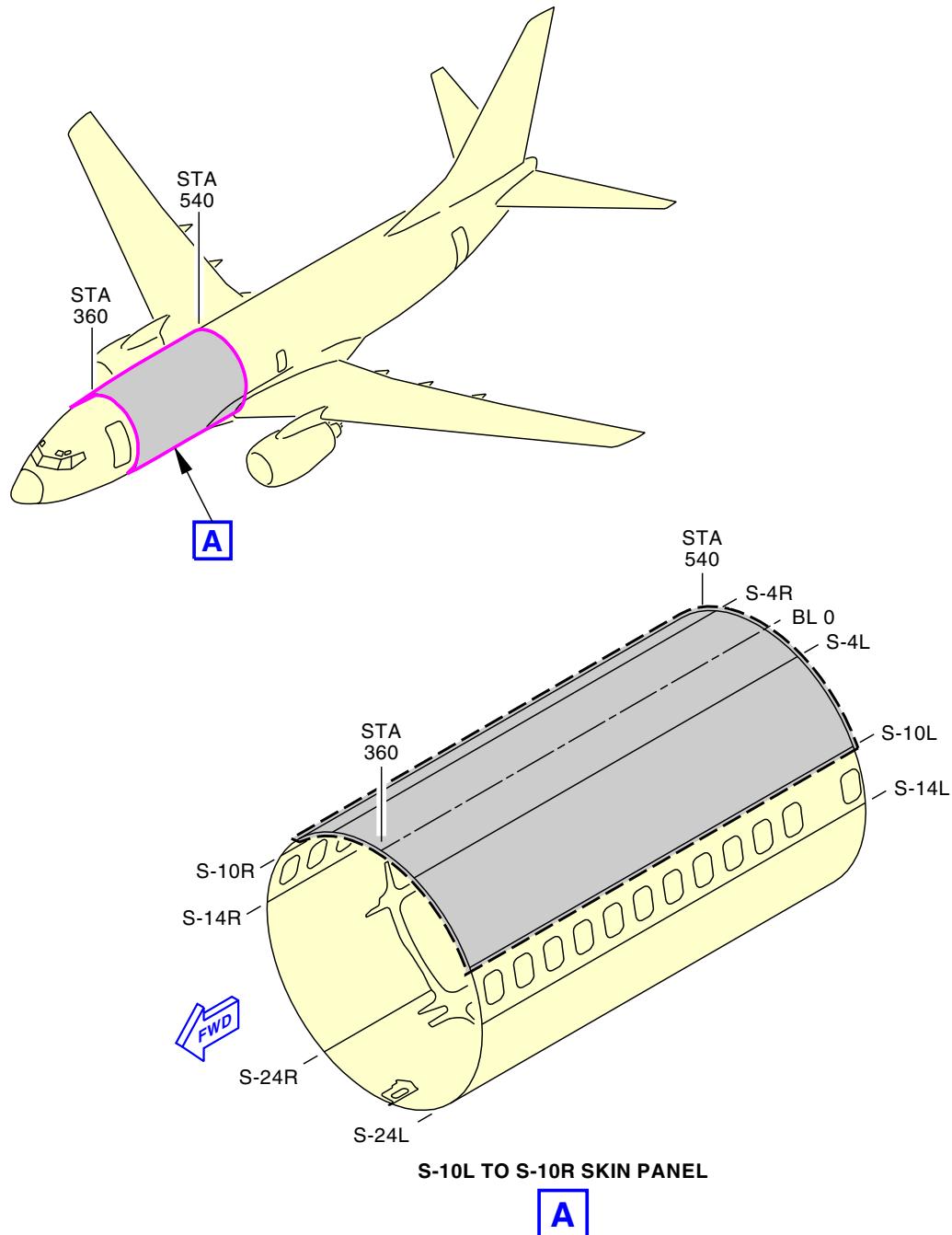
**53-05-02**

Page 244  
Oct 15/2023

D633A101-LOM



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3023952 S0000795798\_V1

Crown Skin Panel, STA 360 to 540  
Figure 219/53-05-02-990-872

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 245  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-814**

**32. INTERNAL - DETAILED: CROWN SKIN PANEL STA 360 TO 540**

Figure 220

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Removal of external antenna fairings and base plates are required.

SUBTASK 53-05-02-211-014

- (1) Do a Detailed inspection of the exterior surface of the skin under the ATC Antenna at STA 430, and the GPS Antenna at STA 500A.

See Doc D626A001-DTR, DTR check form 53-30-01-4 for alternative inspections.

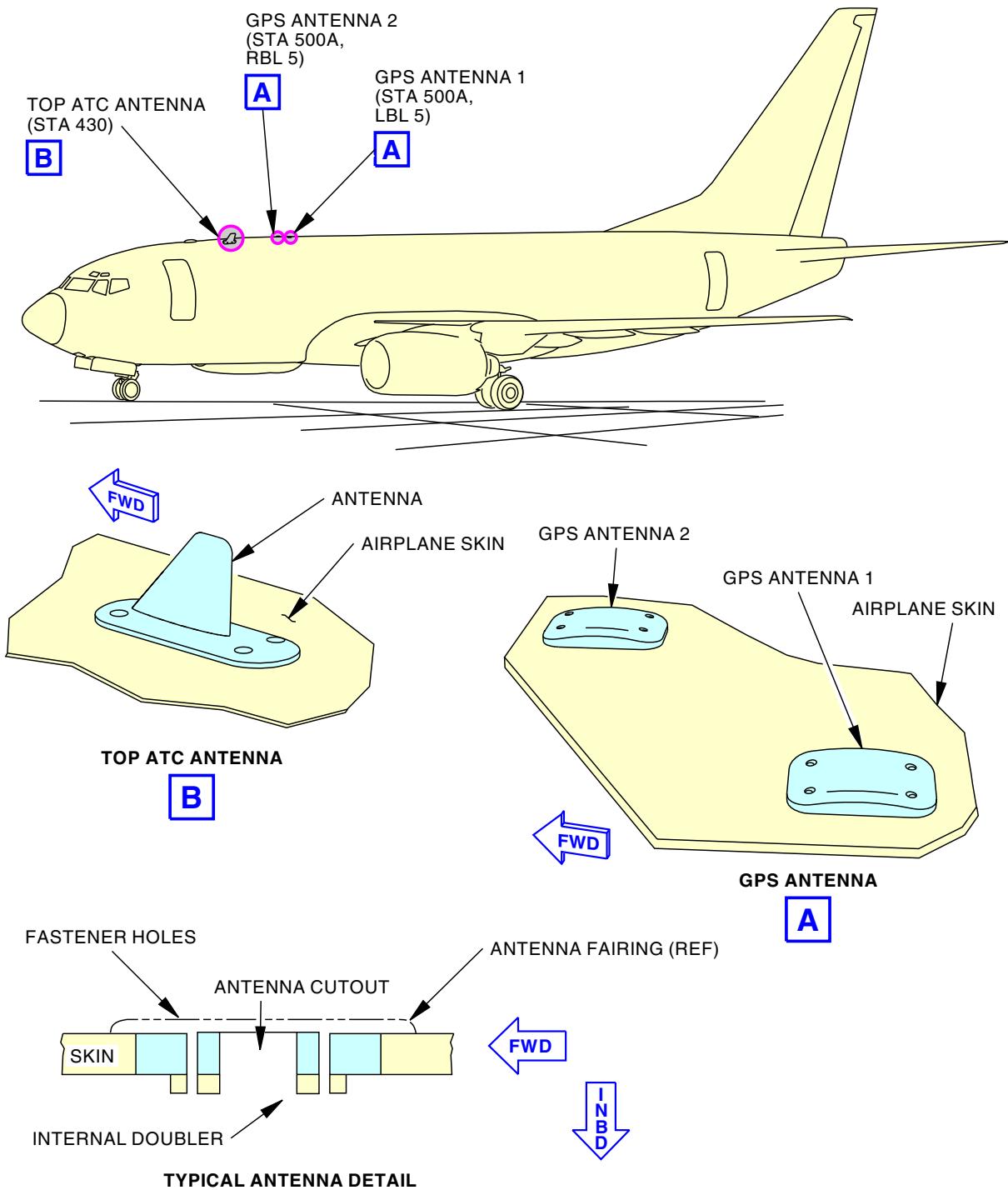
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



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3023954 S0000795799\_V1

Crown Skin Panel, STA 360 to 540  
Figure 220/53-05-02-990-905

EFFECTIVITY	LOM ALL
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D633A101-LOM

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**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-990**

**33. INTERNAL - DETAILED: CROWN SKIN PANEL STA 360 TO 540**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Removal of external antenna fairings are required.

SUBTASK 53-05-02-211-193

- (1) Do a High Frequency Eddy Current inspection of the edge of the skin at the antenna cutout under the TCAS Antenna at STA 385, RBL 5.

See Doc D626A001-DTR, DTR check form 53-30-01-4A for alternative inspections.

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 53-30-69.

———— END OF TASK ————

LOM 404, 411, 412, 415, 416, 420, 422-434, 437-447, 450-457, 461-999

**TASK 53-05-02-211-815**

**34. INTERNAL - DETAILED: SATCOM AERO-H ANTENNA INSTALLATION**

Figure 221

NOTE: This procedure is a scheduled maintenance task.

**A. General**

**B. Location Zones**

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

**C. Inspection**

NOTE: Removal of antenna is required.

SUBTASK 53-05-02-211-015

- (1) Do a Detailed inspection of the skin near the fastener locations around the antenna cutout, stringers, and antenna nutplates on both the left and right sides of the aircraft at Sta 500 between stringers S-6 and S-7.

See Doc D626A001-DTR, DTR check form 53-30-01-5 for alternative inspections.

———— END OF TASK ————

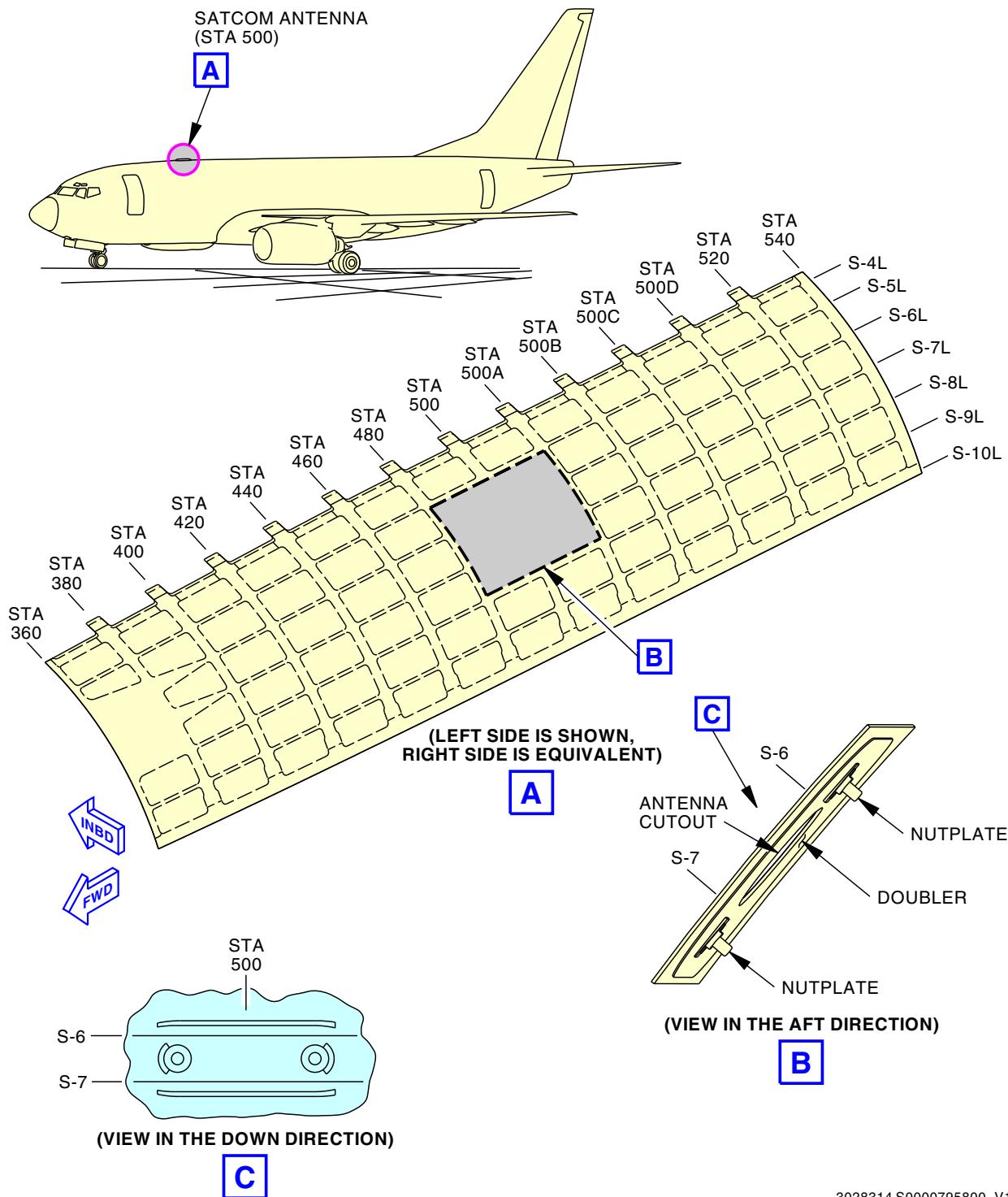


ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-02**

Page 248  
Oct 15/2024

**737-600/700/800/900  
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3028314 S0000795800\_V1

**SATCOM AERO - H Antenna Installation**  
**Figure 221/53-05-02-990-906**

EFFECTIVITY  
LOM 404, 411, 412, 415, 416, 420, 422-434, 437-447,  
450-457, 461-999

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

LOM ALL

**TASK 53-05-02-210-801**

**35. EXTERNAL - GENERAL VISUAL: FUSELAGE SIDE SKIN PANELS**

Figure 222

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
191	Lower Wing-To-Body Fairing - Forward of Wing Box
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right
231	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Right

**B. Inspection**

SUBTASK 53-05-02-210-001

- (1) Do a General Visual inspection of the skin from Sta 360 to Sta 540 between stringers S-14 to S-17.

See Doc D626A001-DTR, DTR check form 53-30-02-1 for alternative inspections.

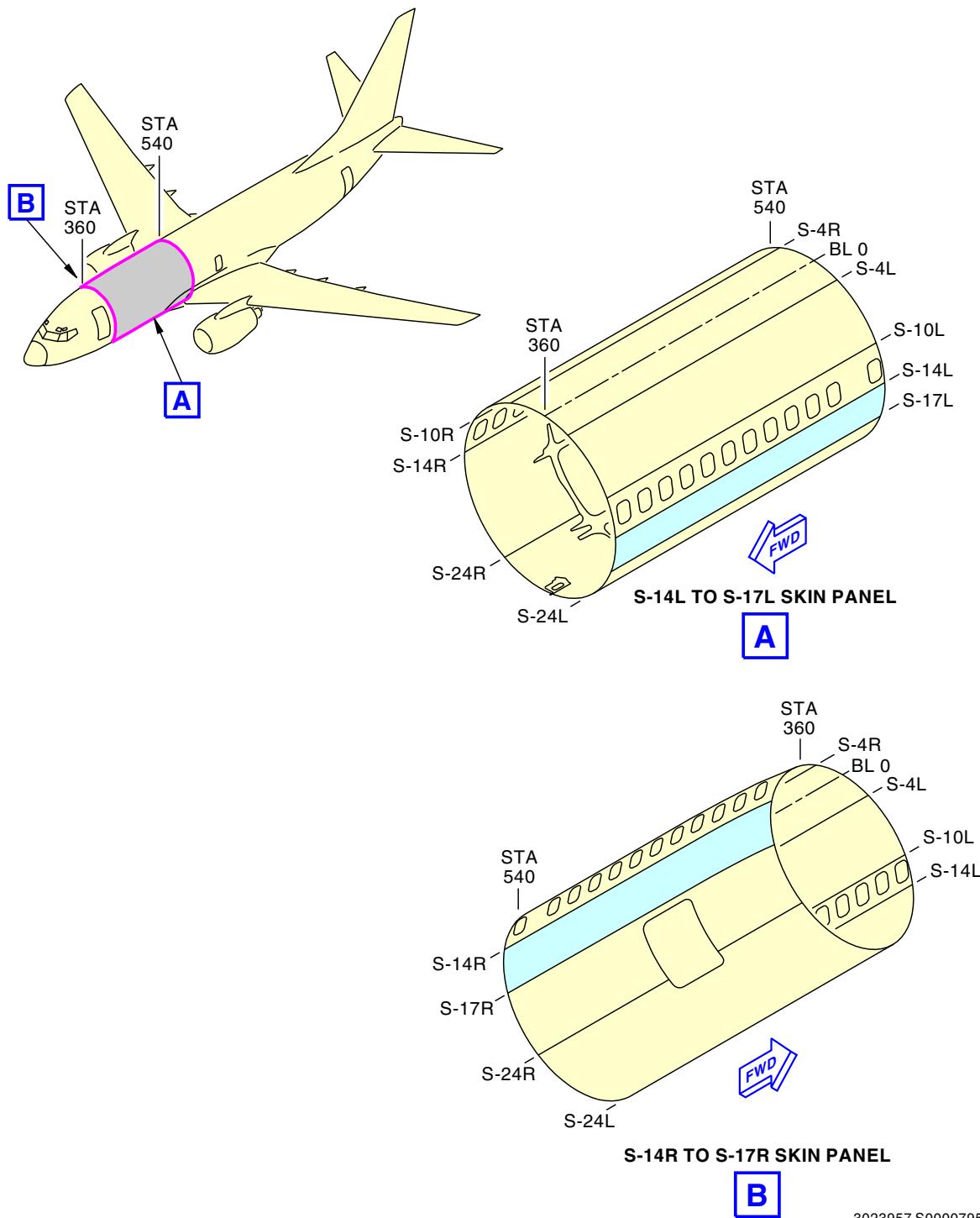
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



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3023957 S0000795801\_V1

Fuselage Side Skin Panels  
Figure 222/53-05-02-990-907

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-816**

**36. EXTERNAL - DETAILED: FUSELAGE SIDE SKIN PANELS UNDER THE WING-TO-BODY FAIRING**

Figure 223

Figure 224

Figure 225

Figure 226

Figure 227

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
191	Lower Wing-To-Body Fairing - Forward of Wing Box
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

**B. Access Panels**

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

**C. Inspection**

**SUBTASK 53-05-02-010-018**

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

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

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
191AR	Forward Wing To Body Fairing Panel - Upper
195AR	Wing To Body Fairing - Right Side

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

**SUBTASK 53-05-02-211-016**

- (2) Do a Detailed inspection of the fuselage skin panels under the Wing to Body Fairing from Sta 360 to Sta 540.

See Doc D626A001-DTR, DTR check form 53-30-02-4 for alternative inspections.

**SUBTASK 53-05-02-410-016**

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

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

Close these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
191AR	Forward Wing To Body Fairing Panel - Upper

EFFECTIVITY  
LOM ALL

**53-05-02**

Page 252  
Oct 15/2023



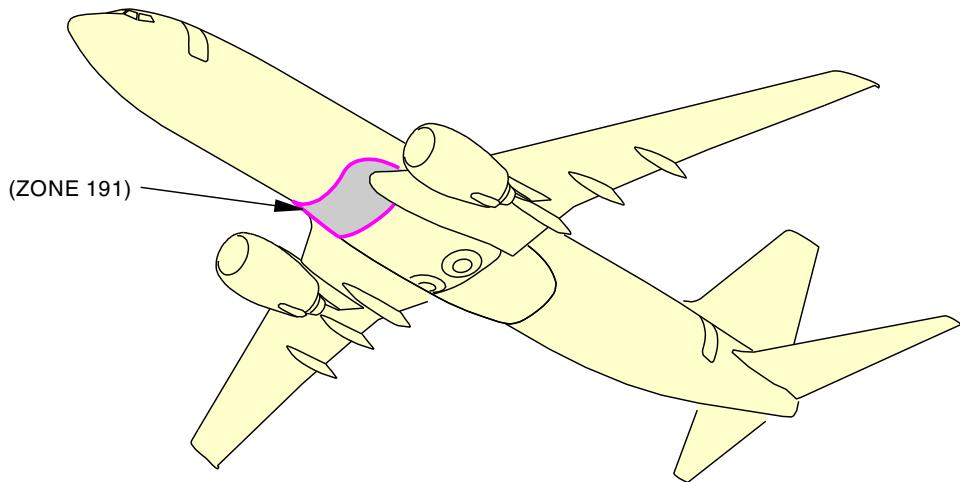
737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Number    Name/Location

195AR      Wing To Body Fairing - Right Side

———— END OF TASK ————



3026549 S0000796600\_V1

Fuselage Side Skin Panels Under the Wing-to-Body Fairing  
Figure 223/53-05-02-990-908

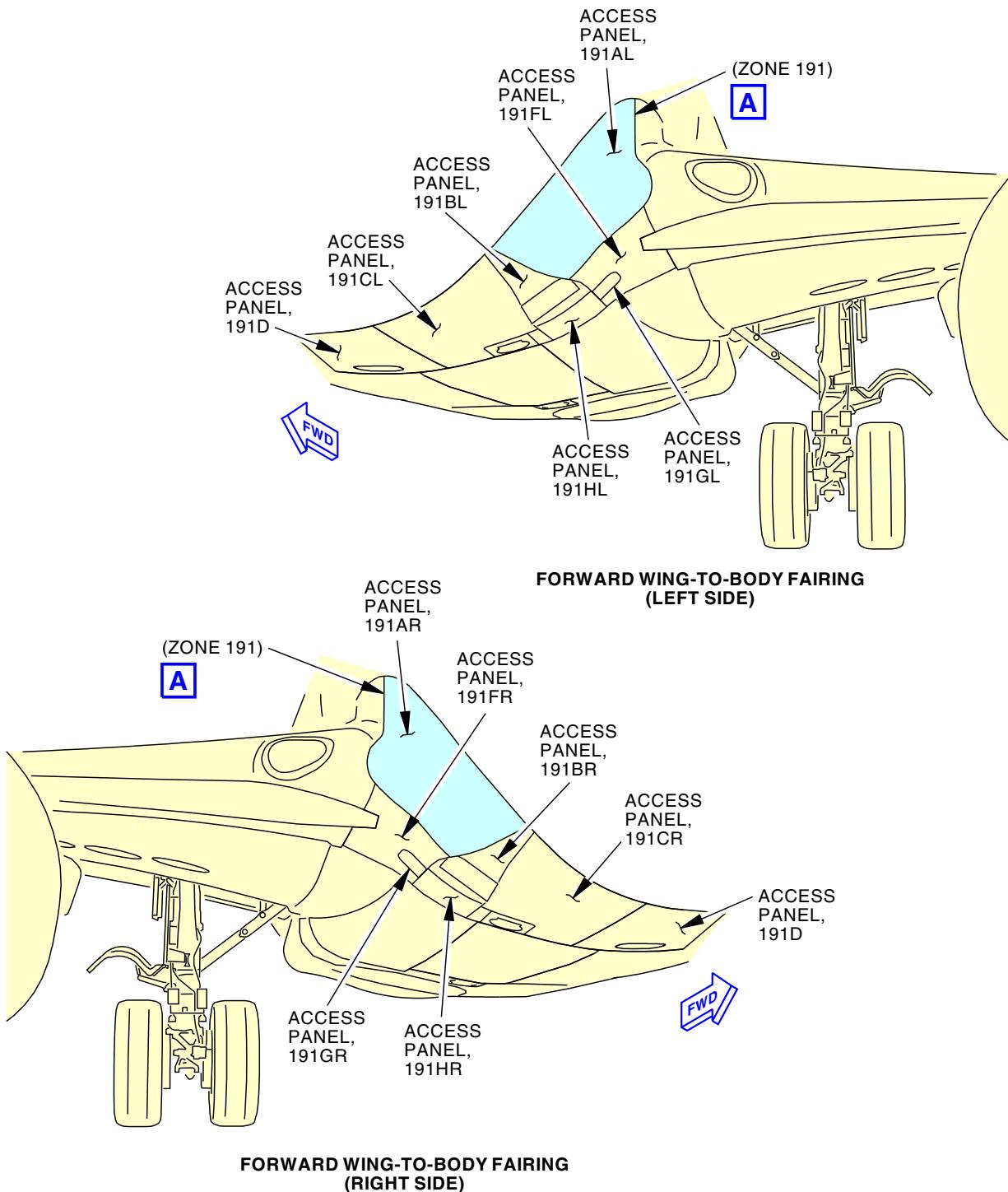
EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM



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AIRCRAFT MAINTENANCE MANUAL



3026551 S0000797867\_V1

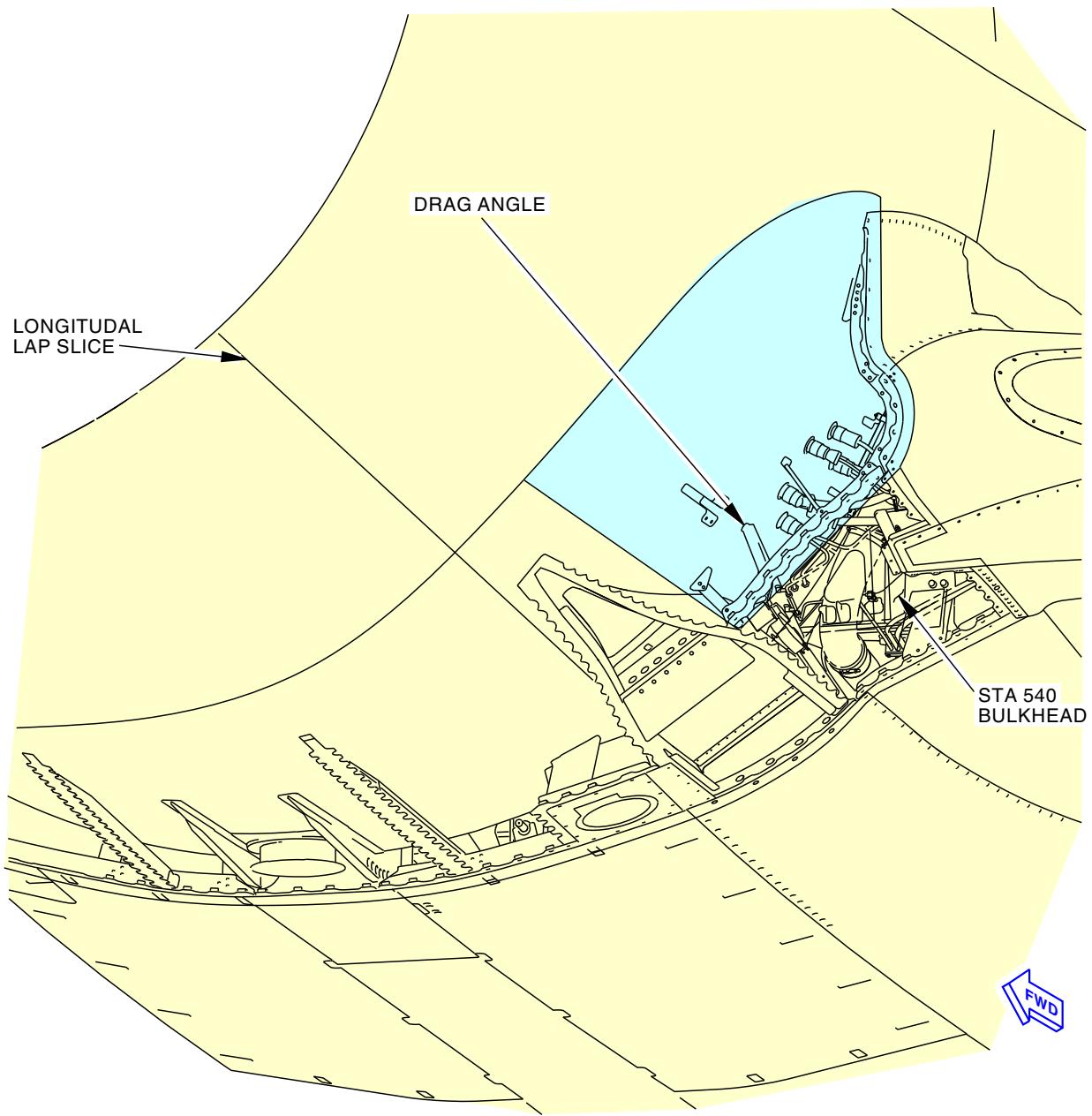
**Forward Wing-To-Body Fairing**  
Figure 224/53-05-02-990-909

EFFECTIVITY	LOM ALL
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**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



(LEFT SIDE OF FUSELAGE IS SHOWN, RIGHT SIDE  
OF FUSELAGE IS EQUIVALENT)

A

3026556 S0000797869\_V1

**Forward Wing-To-Body Fairing (Left Side)**  
Figure 225/53-05-02-990-910

EFFECTIVITY  
LOM ALL

**53-05-02**

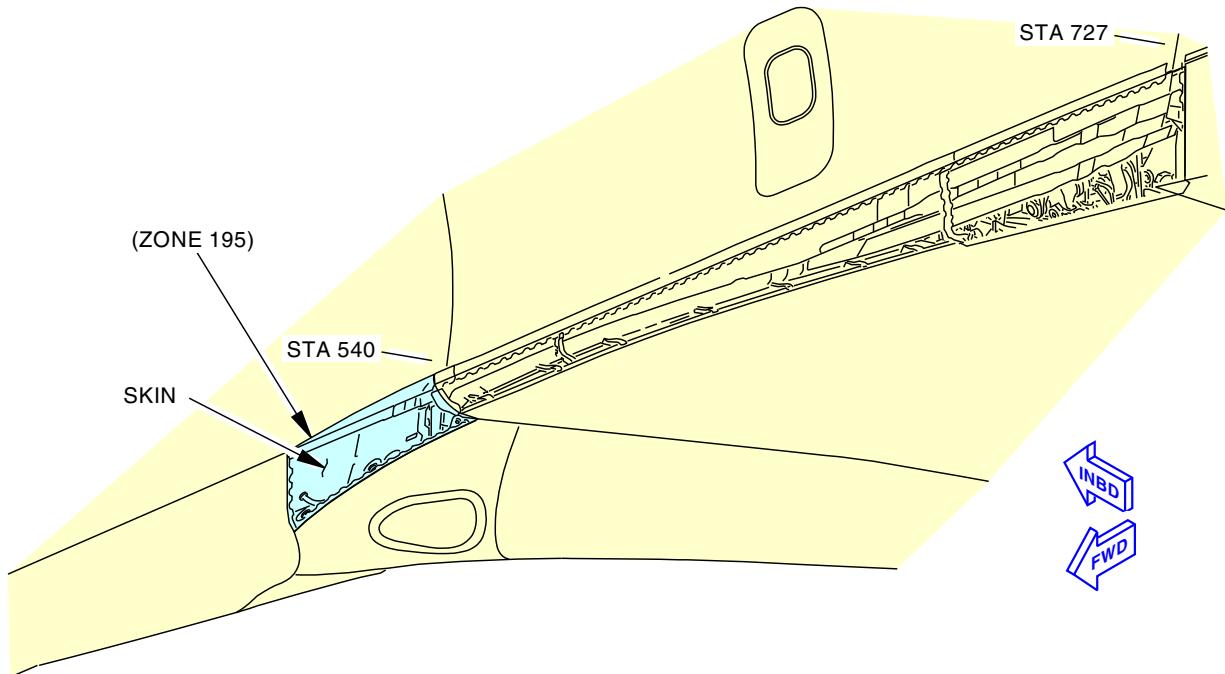
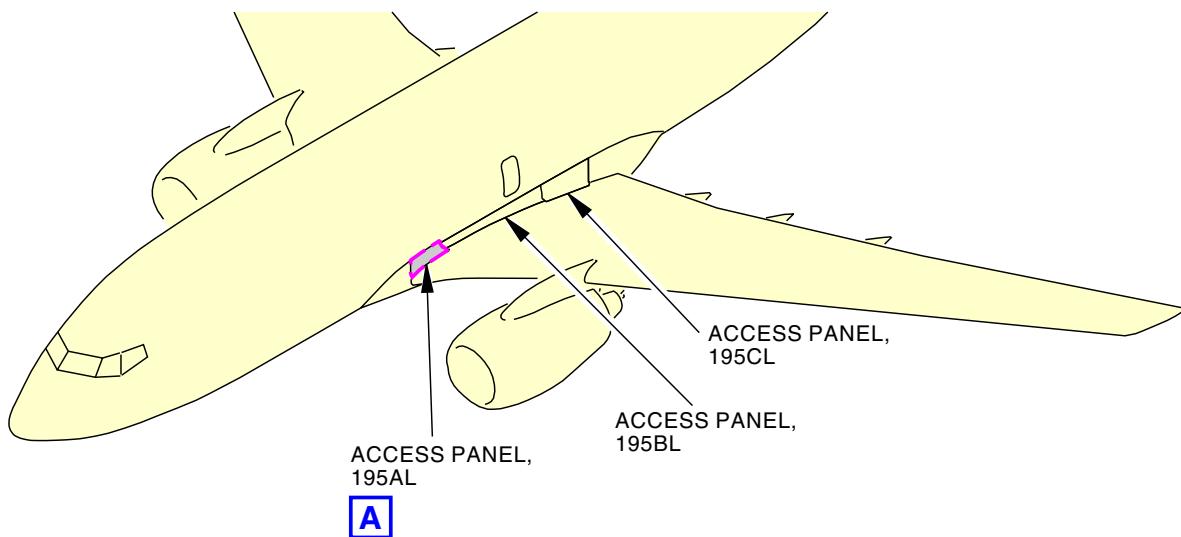
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 255  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



LEFT SIDE WING-TO-BODY FAIRING



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**Wing-To-Body Fairing (Left Side)**  
Figure 226/53-05-02-990-911

EFFECTIVITY  
LOM ALL

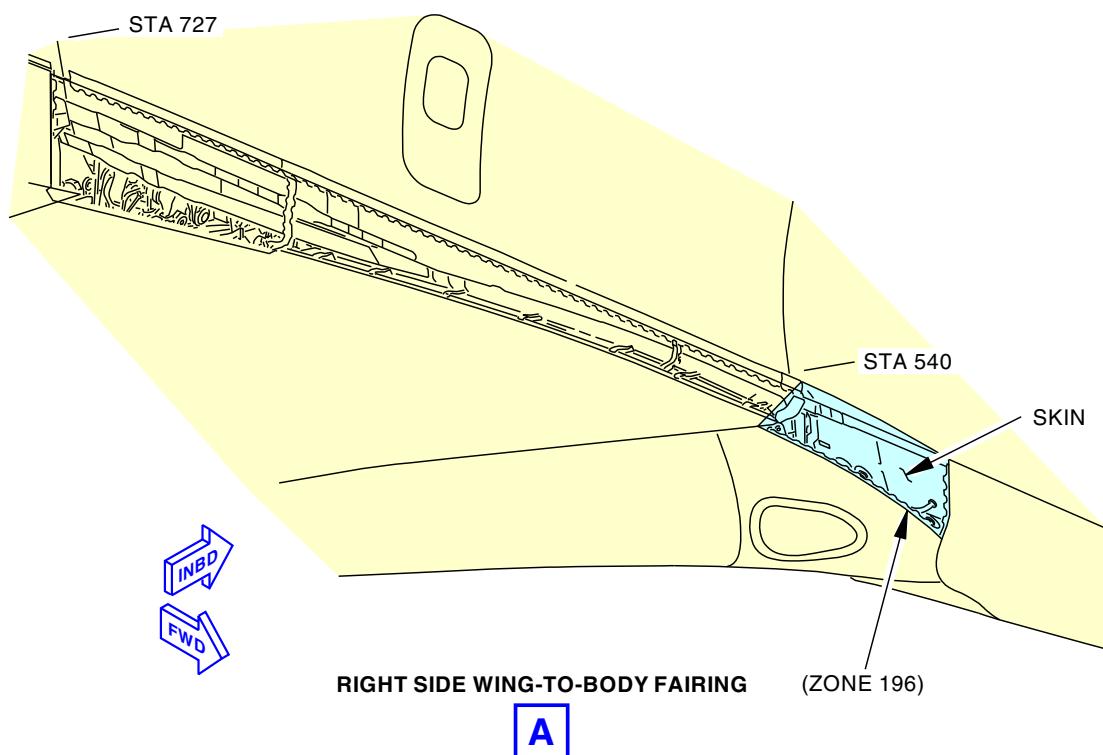
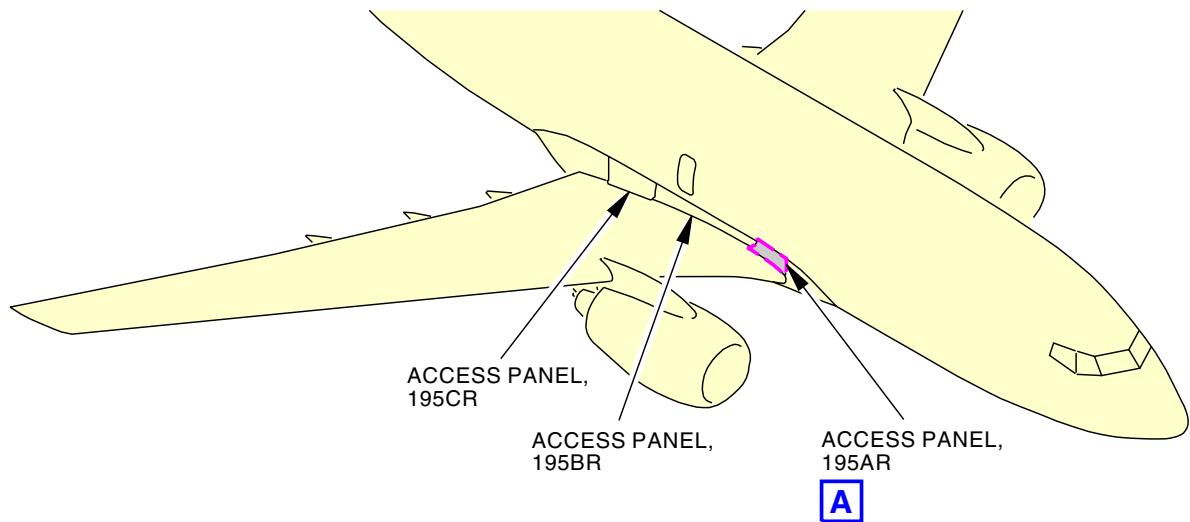
**53-05-02**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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**Wing-To-Body Fairing (Right Side)**  
Figure 227/53-05-02-990-912

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 257  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

LOM 465-999

**TASK 53-05-02-130-818**

**37. EXTERNAL - SPECIAL DETAILED: SKIN UNDER UPPER WING-TO-BODY DRAG ANGLE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
191	Lower Wing-To-Body Fairing - Forward of Wing Box

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper

**C. Inspection**

SUBTASK 53-05-02-010-216

- (1) Open these access panels:

<b>Number</b>	<b>Name/Location</b>
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper

SUBTASK 53-05-02-130-018

- (2) Do an Ultrasonic inspection of the skin under the upper wing-to-body drag angle along the upper drag angle forward of Station 536 between S-21 and S-22.

See Doc D626A001-DTR, DTR check form 53-30-02-5 for alternative inspections.

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, 53-20-02.

SUBTASK 53-05-02-410-212

- (3) Close these access panels:

<b>Number</b>	<b>Name/Location</b>
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper

— END OF TASK —

LOM ALL

**TASK 53-05-02-250-826**

**38. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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



**53-05-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**B. Inspection**

SUBTASK 53-05-02-250-026

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringers S-4L and S-4R from STA 360 to STA 540.

See Doc. D626A001-DTR, DTR check form 53-30-04-2, for alternative inspections.

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 53-30-50.

————— END OF TASK ————

**TASK 53-05-02-250-828**

**39. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL SKIN SPLICE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-028

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-10L and S-10R from STA 360 to STA 540.

See Doc. D626A001-DTR, DTR check form 53-30-04-3, for alternative inspections.

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 53-30-41.

————— END OF TASK ————

**TASK 53-05-02-211-817**

**40. INTERNAL - DETAILED: LONGITUDINAL LAP SPLICE**

Figure 228

Figure 229

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Removal or displacement of interior sidewall panels and insulation blankets are required.

SUBTASK 53-05-02-211-017

- (1) Do a Detailed inspection of the lower skin along the lower fastener row at stringers S-10L and S-10R from Sta 360 to Sta 540.

See Doc. D626A001-DTR, DTR check form 53-30-04-4, for alternative inspections.

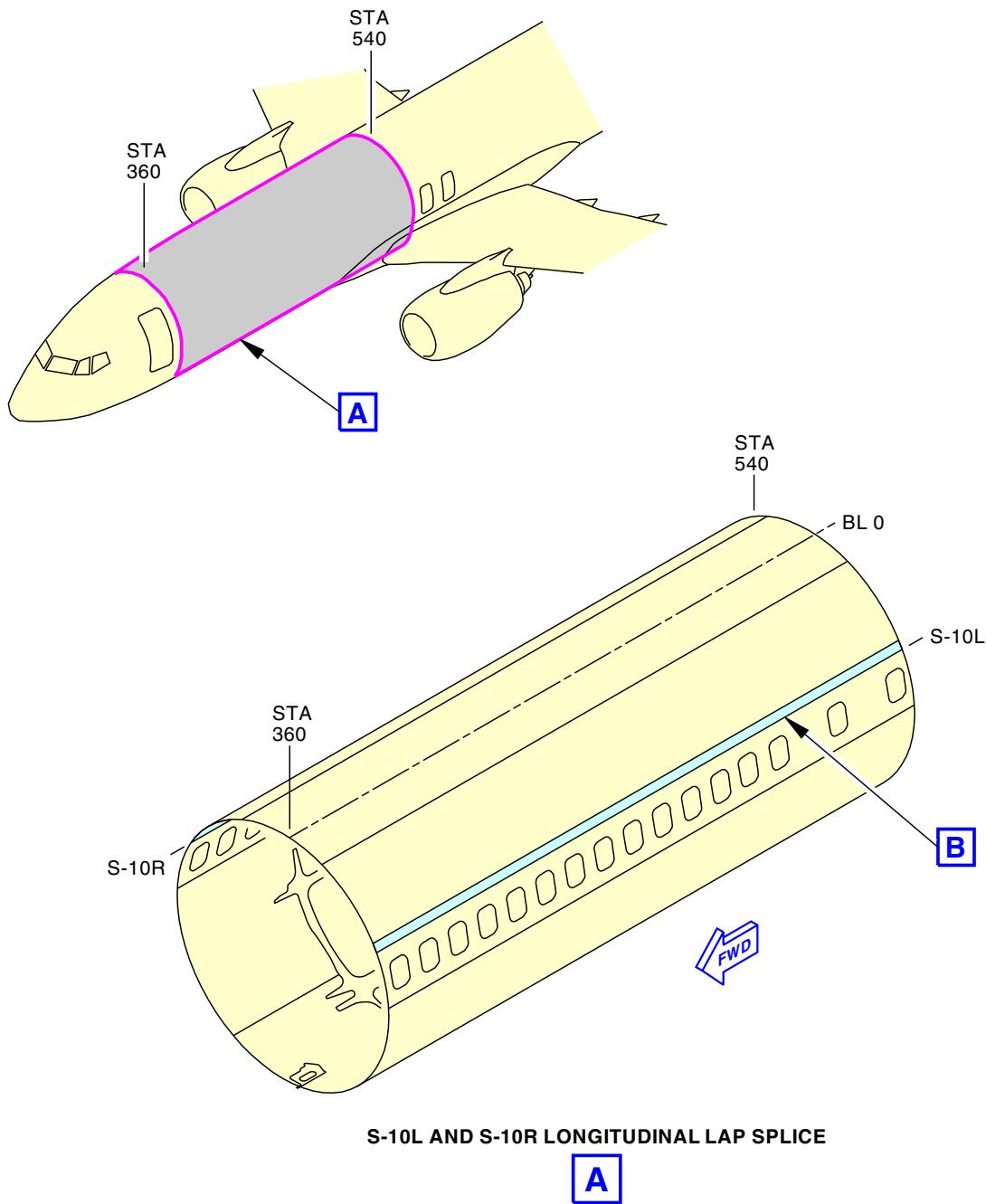
————— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

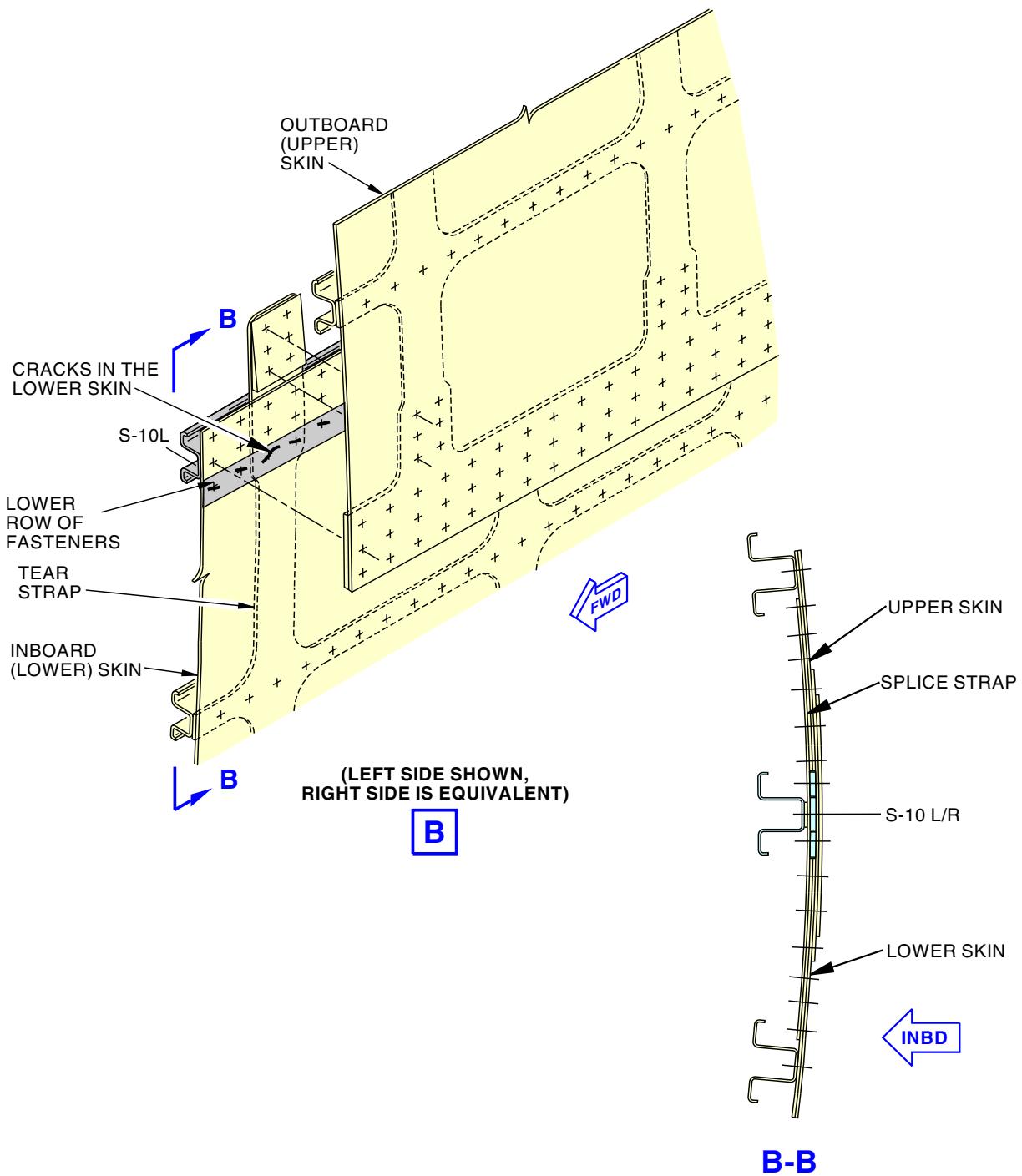


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**Longitudinal Lap Splice**  
Figure 228/53-05-02-990-913

EFFECTIVITY	LOM ALL
D633A101-LOM	

**53-05-02**



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**Longitudinal Lap Splice (S-10L and S-10R)**  
**Figure 229/53-05-02-990-914**

EFFECTIVITY  
**LOM ALL**

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-819**

**41. EXTERNAL - DETAILED: LONGITUDINAL LAP SPLIC**

Figure 230

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-019

- (1) Do a Detailed inspection of the upper skin along the upper fastener row at stringers S-14L and S-14R from Sta 360 to Sta 540.

See Doc. D626A001-DTR, DTR check form 53-30-04-5, for alternative inspections.

———— END OF TASK ————

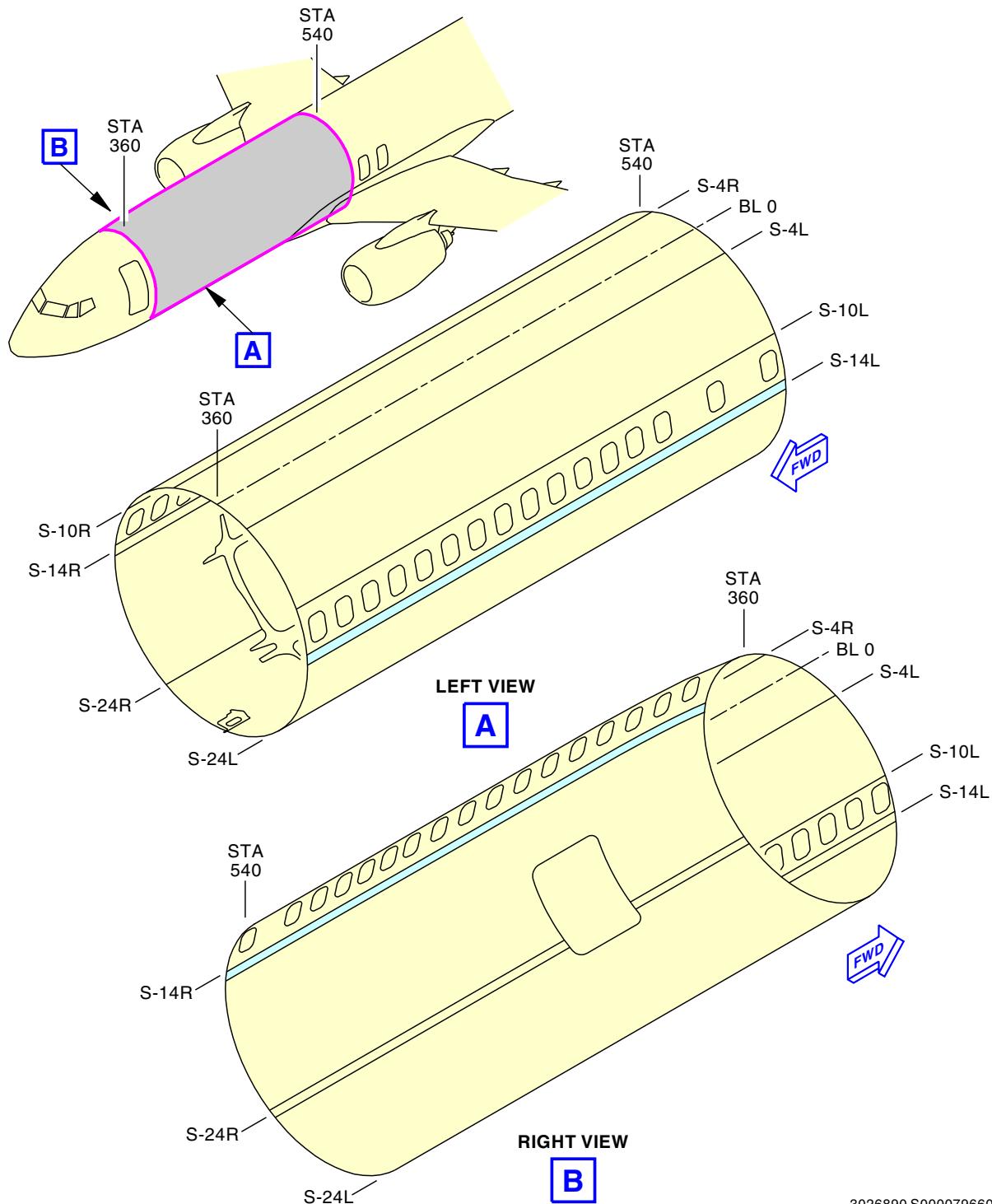
EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM



737-600/700/800/900  
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Longitudinal Lap Splice, S-14L and S-14R from STA 360 to STA 540.  
Figure 230/53-05-02-990-917

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 263  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-830**

**42. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-030

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringers S-14L and S-14R from STA 360 to STA 540.  
See Doc. D626A001-DTR, DTR check form 53-30-04-6, for alternative inspections.  
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 53-30-50.

———— END OF TASK ————

**TASK 53-05-02-250-832**

**43. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

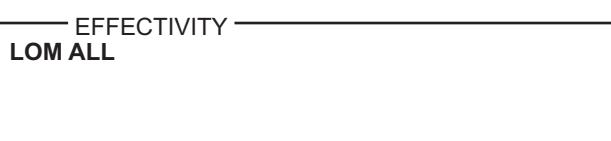
**B. Inspection**

NOTE: Remove Wing to Body Fairing as required to perform this inspection.

SUBTASK 53-05-02-250-032

- (1) Do a Low Frequency Eddy Current inspection of the upper (inner) skin along the upper fastener row at stringers S-24L and S-24R from STA 360 to STA 540, except at the cargo door cutout.  
See Doc. D626A001-DTR, DTR check form 53-30-04-7, for alternative inspections.  
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 53-30-50.

———— END OF TASK ————



**53-05-02**



737-600/700/800/900  
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**TASK 53-05-02-211-821**

**44. EXTERNAL - DETAILED: LONGITUDINAL LAP SPLIC**

Figure 231

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Remove Wing to Body Fairing as required to perform this inspection.

SUBTASK 53-05-02-211-021

- (1) Do a Detailed inspection of the lower (outer) skin along the lower fastener row at stringers S-24L and S-24R from Sta 360 to Sta 540, except at the cargo door cutout.

See Doc. D626A001-DTR, DTR check form 53-30-04-8, for alternative inspections.

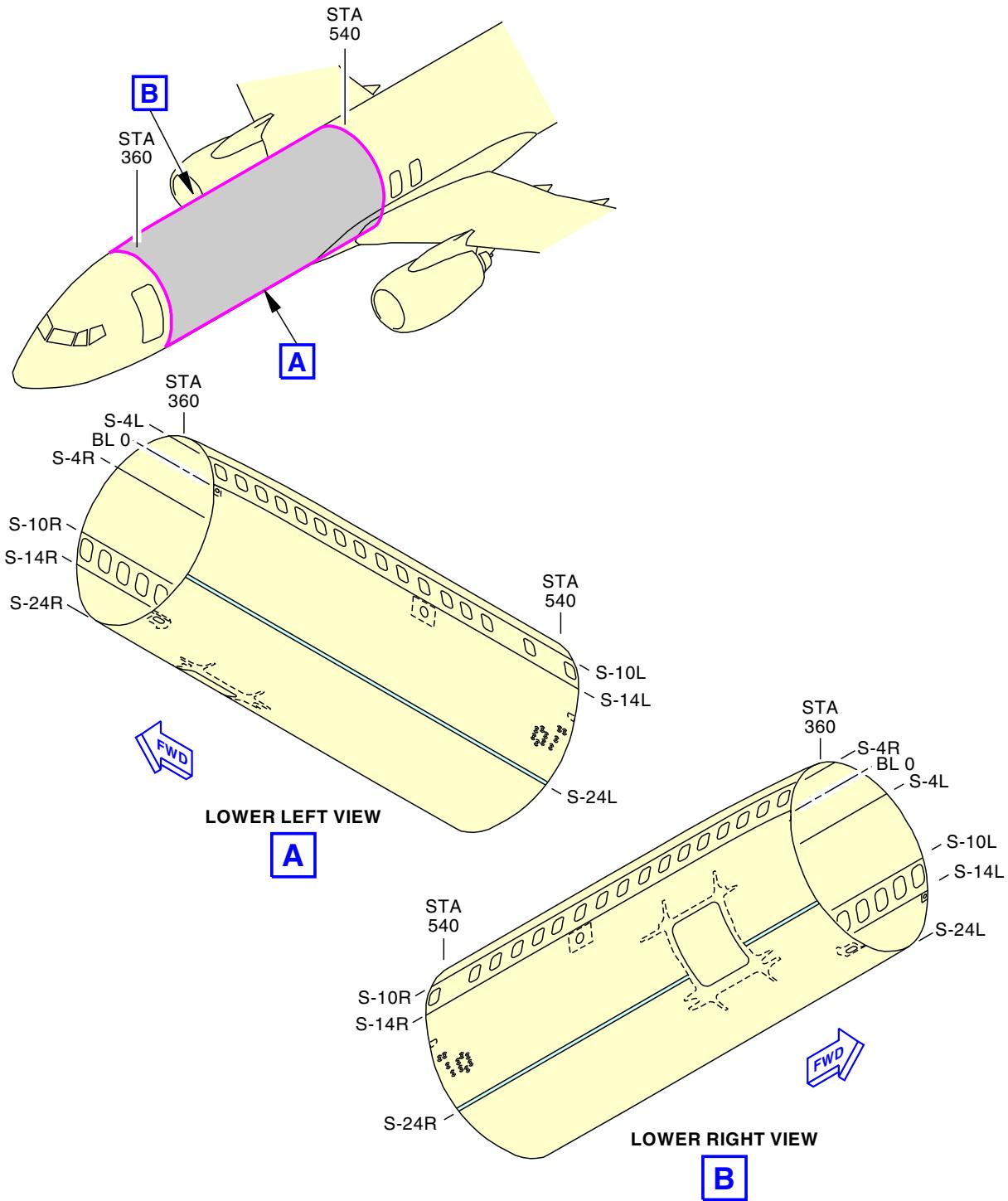
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**

Page 265  
Oct 15/2023

D633A101-LOM



**Longitudinal Lap Splice, S-24L and S-24R from STA 360 to STA 540**  
**Figure 231/53-05-02-990-883**

EFFECTIVITY  
LOM ALL

**53-05-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-05-02-250-833**

**45. INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-048

- (1) Open this access panel:

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

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

SUBTASK 53-05-02-250-033

- (2) Do a High Frequency Eddy Current inspection of the outboard portion of the frame web for damage between stringers S-17R and S-26R at the FWD and AFT edge frames at STA 440 and 492.4, except at the door stops and sill locations.

See Doc D626A001-DTR, DTR check form 53-30-08-1 for alternative inspections.

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 53-11-23.

SUBTASK 53-05-02-410-046

- (3) Close this access panel:

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

———— END OF TASK ————

**TASK 53-05-02-130-801**

**46. INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND**

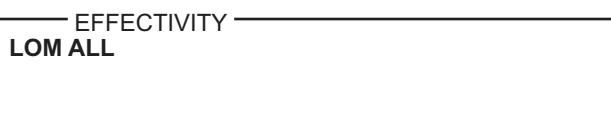
NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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



**53-05-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**C. Inspection**

SUBTASK 53-05-02-010-003

- (1) Open this access panel:

**Number      Name/Location**

821          Forward Cargo Door

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

SUBTASK 53-05-02-130-001

- (2) Do an Ultrasonic inspection of the outboard portion of the frame web for damage under all door stop fittings and sill clips at the FWD AND AFT edge frames at STA 440 AND 492.4.

See Doc D626A001-DTR, DTR check form 53-30-08-2 for alternative inspections.

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 53-10-06.

SUBTASK 53-05-02-410-001

- (3) Close this access panel:

**Number      Name/Location**

821          Forward Cargo Door

———— END OF TASK ————

**TASK 53-05-02-250-834**

**47. INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-049

- (1) Open this access panel:

**Number      Name/Location**

821          Forward Cargo Door

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

SUBTASK 53-05-02-250-034

- (2) Do a High Frequency Eddy Current inspection of the forward and aft edge frame inner chords between stringers S-18R and S-26R.

See Doc D626A001-DTR, DTR check form 53-30-08-3 for alternative inspections.

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 53-10-90.

— EFFECTIVITY —

LOM ALL

**53-05-02**

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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-05-02-410-047

- (3) Close this access panel:

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

———— END OF TASK ————

**TASK 53-05-02-250-835**

**48. INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-050

- (1) Open this access panel:

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

NOTE: Remove cargo liners as required to perform the inspection.

SUBTASK 53-05-02-250-035

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

See Doc D626A001-DTR, DTR check form 53-30-08-4 for alternative inspections.

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 53-10-87.

SUBTASK 53-05-02-410-048

- (3) Close this access panel:

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

———— END OF TASK ————

**TASK 53-05-02-250-836**

**49. INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-051

- (1) Open this access door:

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

NOTE: Remove cargo liners as required to perform the inspection.

SUBTASK 53-05-02-250-036

- (2) Do a High Frequency Eddy Current inspection of the forward and aft edge frame inner chords between S-17 and S-19.

See Doc D626A001-DTR, DTR check form 53-30-08-5 for alternative inspections.

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 53-11-57.

SUBTASK 53-05-02-410-049

- (3) Close this access door:

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

———— END OF TASK ————

**TASK 53-05-02-250-837**

**50. INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-052

- (1) Open this access door:

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

SUBTASK 53-05-02-250-037

- (2) Do a High Frequency Eddy Current inspection of the bearstrap for two inches on each side of stringer S-24R at STA 440 and STA 492.4.

See Doc D626A001-DTR, DTR check form 53-30-08-6 for alternative inspections.

EFFECTIVITY
LOM ALL

**53-05-02**



**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, Subject 53-10-91.

SUBTASK 53-05-02-410-050

- (3) Close this access door:

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

———— END OF TASK ————

**TASK 53-05-02-130-802**

**51. INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-004

- (1) Open this access panel:

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

SUBTASK 53-05-02-130-002

- (2) Do an Ultrasonic inspection of the bearstrap for hidden damage under the stop backup fitting at stringer S-24R at Sta 440 and Sta 492.4.

See Doc D626A001-DTR, DTR check form 53-30-08-6 for alternative inspections.

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 53-10-07.

SUBTASK 53-05-02-410-002

- (3) Close this access panel:

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

———— END OF TASK ————

**TASK 53-05-02-250-838**

**52. INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

EFFECTIVITY
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

**Zone      Area**

124      Forward Cargo Compartment - Right

**B. Access Panels**

**Number      Name/Location**

821      Forward Cargo Door

**C. Inspection**

SUBTASK 53-05-02-010-053

- (1) Open this access door:

**Number      Name/Location**

821      Forward Cargo Door

SUBTASK 53-05-02-250-038

- (2) Do a High Frequency Eddy Current inspection of the upper sill outer chord around the fasteners common to the chord and bearstrap.

See Doc. D626A001-DTR, DTR check form 53-30-08-10, for alternative inspections.

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 53-11-48.

SUBTASK 53-05-02-410-051

- (3) Close this access door:

**Number      Name/Location**

821      Forward Cargo Door

———— END OF TASK ————

**TASK 53-05-02-250-839**

**53. INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

**Zone      Area**

122      Forward Cargo Compartment - Right

124      Forward Cargo Compartment - Right

**B. Access Panels**

**Number      Name/Location**

821      Forward Cargo Door

**C. Inspection**

SUBTASK 53-05-02-010-054

- (1) Open this access door:

**Number      Name/Location**

821      Forward Cargo Door

SUBTASK 53-05-02-250-039

- (2) Do a High Frequency Eddy Current inspection of the bearstrap along the upper edge of the forward cargo door.

See Doc. D626A001-DTR, DTR check form 53-30-08-10, for alternative inspections.

EFFECTIVITY
LOM ALL

**53-05-02**



**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, Subject 53-11-48.

SUBTASK 53-05-02-410-052

- (3) Close this access door:

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

———— END OF TASK ————

**TASK 53-05-02-250-840**

**54. INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-055

- (1) Open this access panel:

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

NOTE: Removal of forward cargo door scuff plate is required to perform this inspection.

SUBTASK 53-05-02-250-040

- (2) Do a Low Frequency Eddy Current inspection around the fasteners common to the web at the lower main sill chords between STA 421 and 438 (for -600) and STA 461 and STA 478 (for -700/-800).

See Doc. D626A001-DTR, DTR check form 53-30-08-12, for alternative inspections.

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 53-30-33.

SUBTASK 53-05-02-410-053

- (3) Close this access panel:

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

———— END OF TASK ————

**TASK 53-05-02-250-841**

**55. INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR FITTINGS AND STOPS AT THE FORWARD AND AFT EDGE FRAMES**

NOTE: This procedure is a scheduled maintenance task.

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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
122	Forward Cargo Compartment - Right

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-056

- (1) Open this access panel:

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

NOTE: Remove cargo liners as required

SUBTASK 53-05-02-250-041

- (2) Do a High Frequency Eddy Current inspection of the intercostal web for cracks adjacent to rivets and fastener holes (five locations at the forward and aft edge frames) common to the backup fitting and intercostal.

See Doc D626A001-DTR, DTR check form 53-30-09-3 for alternative inspections.

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 53-11-02.

SUBTASK 53-05-02-410-054

- (3) Close this access panel:

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

— END OF TASK —

**TASK 53-05-02-250-842**

**56. INTERNAL - SPECIAL DETAILED: WING TO BODY LOWER DRAG ANGLE**

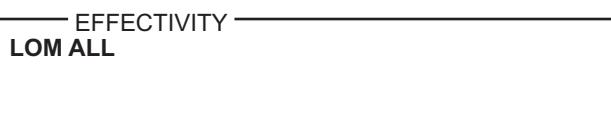
NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
132	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Right
191	Lower Wing-To-Body Fairing - Forward of Wing Box

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
191HL	Ram Air Inlet Lip Panel - Forward
191HR	Ram Air Inlet Lip Panel - Forward
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

C. Inspection

SUBTASK 53-05-02-010-057

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

Number    Name/Location

191HL	Ram Air Inlet Lip Panel - Forward
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward

SUBTASK 53-05-02-010-058

- (2) Open these access panels on the Right side:

Number    Name/Location

191HR	Ram Air Inlet Lip Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward

NOTE: Removal of wing to body fairings is required. Remove the ram air inlet assemblies and the air ducts that prevent access.

SUBTASK 53-05-02-250-042

- (3) Do a High Frequency Eddy Current inspection around all fasteners in the angle (9 inches forward and 12 inches aft) of the wing to body intersection (STA 536) between STA 518 to STA 555, above stringer 24.

See Doc D626A001-DTR, DTR check form 53-30-11-1 for alternative inspections.

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 53-30-47.

SUBTASK 53-05-02-410-055

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

Number    Name/Location

191HL	Ram Air Inlet Lip Panel - Forward
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward

SUBTASK 53-05-02-410-056

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

Number    Name/Location

191HR	Ram Air Inlet Lip Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward

———— END OF TASK ————

**TASK 53-05-02-250-843**

**57. INTERNAL - SPECIAL DETAILED: WING TO BODY UPPER DRAG ANGLE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
132	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Right



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

**Zone      Area**

191	Lower Wing-To-Body Fairing - Forward of Wing Box
-----	--

**B. Access Panels**

**Number      Name/Location**

191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192AL	Underwing Bolt Cover - Forward
192AR	Underwing Bolt Cover - Forward

**C. Inspection**

SUBTASK 53-05-02-010-059

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

**Number      Name/Location**

191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192AL	Underwing Bolt Cover - Forward

Open these access panels on the Right side:

**Number      Name/Location**

191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192AR	Underwing Bolt Cover - Forward

NOTE: Removal of wing to body fairings, duct located aft of STA 536 and sealant along edge of angle to body contour and lower wing skin is required.

SUBTASK 53-05-02-250-043

- (2) Do a High Frequency Eddy Current inspection, eight inches FWD and AFT of STA 536 along the edge of the inboard angle adjacent to the fuselage (FWD of STA 536) and the lower wing skin (AFT of STA 536), between S-21 and S-22.

See Doc D626A001-DTR, DTR check form 53-30-11-02 for alternative inspections.

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 53-30-47.

SUBTASK 53-05-02-410-058

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

**Number      Name/Location**

191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192AL	Underwing Bolt Cover - Forward

Close these access panels on the Right side:

**Number      Name/Location**

191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192AR	Underwing Bolt Cover - Forward

— END OF TASK —

EFFECTIVITY
LOM ALL

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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-844**

**58. INTERNAL - SPECIAL DETAILED: WING TO BODY UPPER DRAG ANGLE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
132	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Right
191	Lower Wing-To-Body Fairing - Forward of Wing Box

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192AL	Underwing Bolt Cover - Forward
192AR	Underwing Bolt Cover - Forward

**C. Inspection**

SUBTASK 53-05-02-010-061

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

<b>Number</b>	<b>Name/Location</b>
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192AL	Underwing Bolt Cover - Forward

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192AR	Underwing Bolt Cover - Forward

NOTE: Removal of wing to body fairings, duct located aft of STA 536 and sealant along edge of angle to body contour and lower wing skin is required.

SUBTASK 53-05-02-250-044

- (2) Do a High Frequency Eddy Current inspection, eight inches FWD and AFT of STA 536 along the inboard angle at the angle to fuselage interface (FWD of STA 536) and the angle to lower wing skin interface (AFT of STA 536), between S-21 and S-22.

See Doc D626A001-DTR, DTR check form 53-30-11-02 for alternative inspections.

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 53-30-47.

SUBTASK 53-05-02-410-059

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

<b>Number</b>	<b>Name/Location</b>
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

**Number      Name/Location**

192AL      Underwing Bolt Cover - Forward

Close these access panels on the Right side:

**Number      Name/Location**

191FR      Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

192AR      Underwing Bolt Cover - Forward

———— END OF TASK ————

**TASK 53-05-02-250-845**

**59. INTERNAL - SPECIAL DETAILED: WING TO BODY UPPER DRAG ANGLE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
132	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Right
191	Lower Wing-To-Body Fairing - Forward of Wing Box

**B. Access Panels**

Number	Name/Location
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192AL	Underwing Bolt Cover - Forward
192AR	Underwing Bolt Cover - Forward

**C. Inspection**

**SUBTASK 53-05-02-010-064**

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

**Number      Name/Location**

191FL      Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

192AL      Underwing Bolt Cover - Forward

Open these access panels on the Right side:

**Number      Name/Location**

191FR      Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

192AR      Underwing Bolt Cover - Forward

NOTE: Removal of wing to body fairings and duct located aft of STA 536 is required.

**SUBTASK 53-05-02-250-045**

- (2) Do a High Frequency Eddy Current inspection around the fasteners in the inboard and outboard angles eight inches forward and aft of STA 536, between S-21 and S-22.

See Doc. D626A001-DTR, DTR check form 53-30-11-03, for alternative inspections.

EFFECTIVITY  
LOM ALL

**53-05-02**



## 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, Subject 53-30-47.

### SUBTASK 53-05-02-410-061

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

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

191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192AL	Underwing Bolt Cover - Forward

### SUBTASK 53-05-02-410-062

- (4) Close these access panels on the Right side:

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

191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192AR	Underwing Bolt Cover - Forward

———— END OF TASK ————

### TASK 53-05-02-250-847

#### 60. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL SKIN SPLICE

NOTE: This procedure is a scheduled maintenance task.

##### A. Location Zones

<u>Zone</u>	<u>Area</u>
231	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

##### B. Inspection

### SUBTASK 53-05-02-250-047

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-10L and S-10R from STA 540 to STA 727.

See Doc. D626A001-DTR, DTR check form 53-40-03-3, for alternative inspections.

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 53-30-41.

———— END OF TASK ————

### TASK 53-05-02-211-822

#### 61. INTERNAL - DETAILED: WINDOW BELT, STA 540 TO 727

Figure 232

NOTE: This procedure is a scheduled maintenance task.

##### A. Location Zones

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

EFFECTIVITY
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**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

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

**B. Inspection**

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

SUBTASK 53-05-02-211-022

- (1) Do a Detailed inspection of the stringers S-11 and S-13 from STA 540 to 727.

See Doc. D626A001-DTR, DTR check form 53-40-04-1, for alternative inspections.

———— END OF TASK ————



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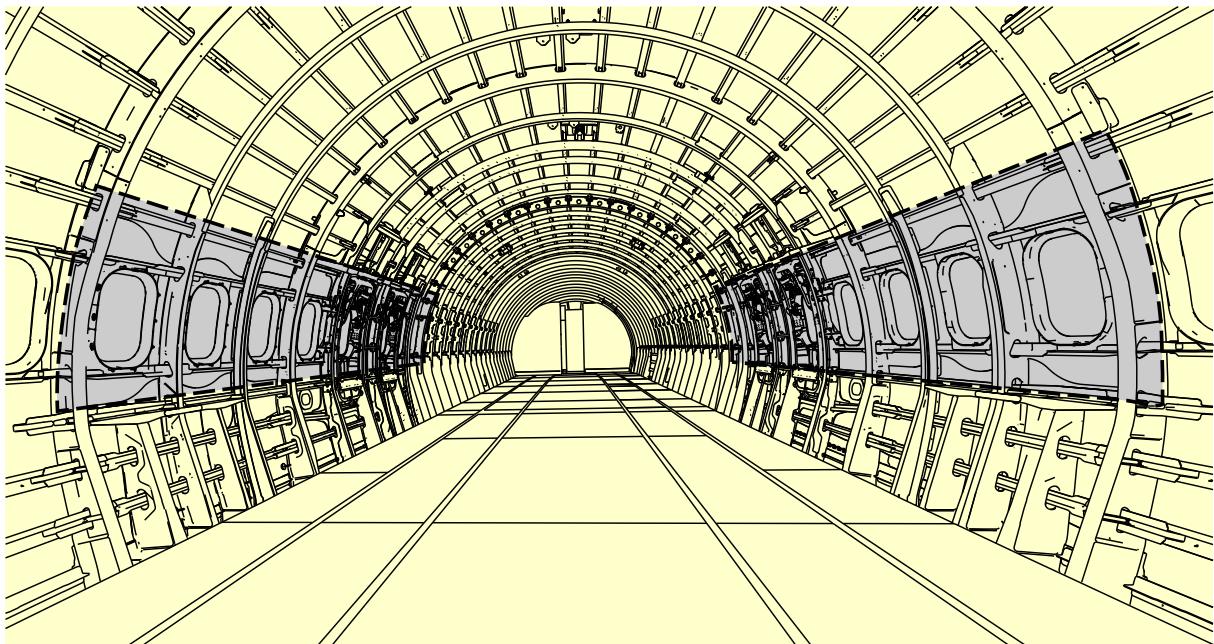
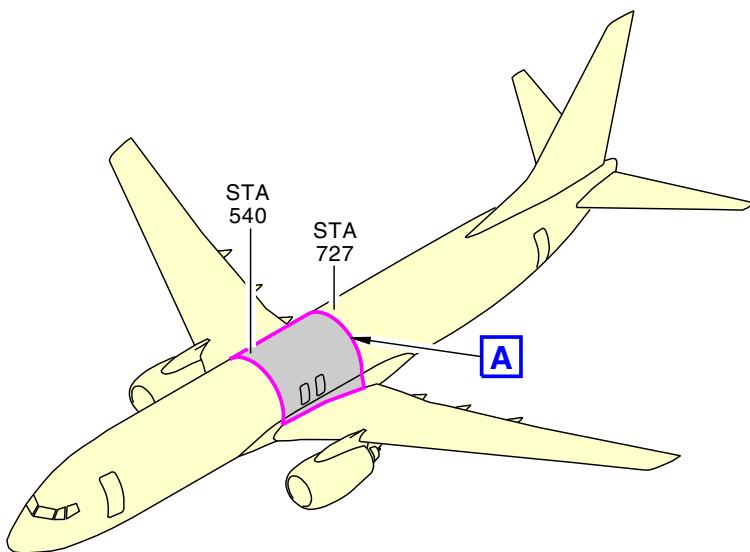
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Page 280  
Feb 15/2024

D633A101-LOM



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT



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Window Belt, STA 540 to STA 727  
Figure 232/53-05-02-990-891 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

**53-05-02**

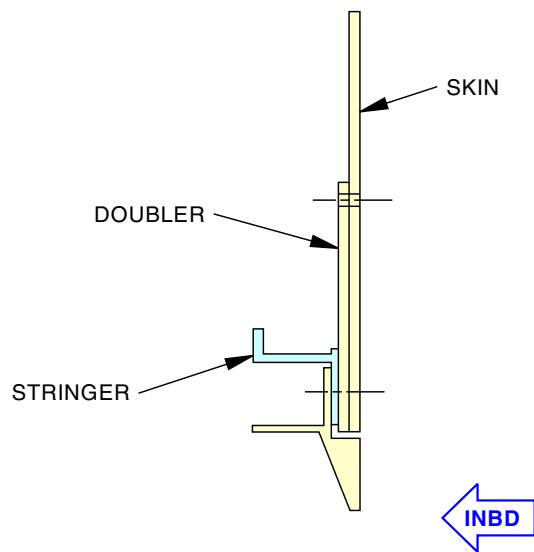
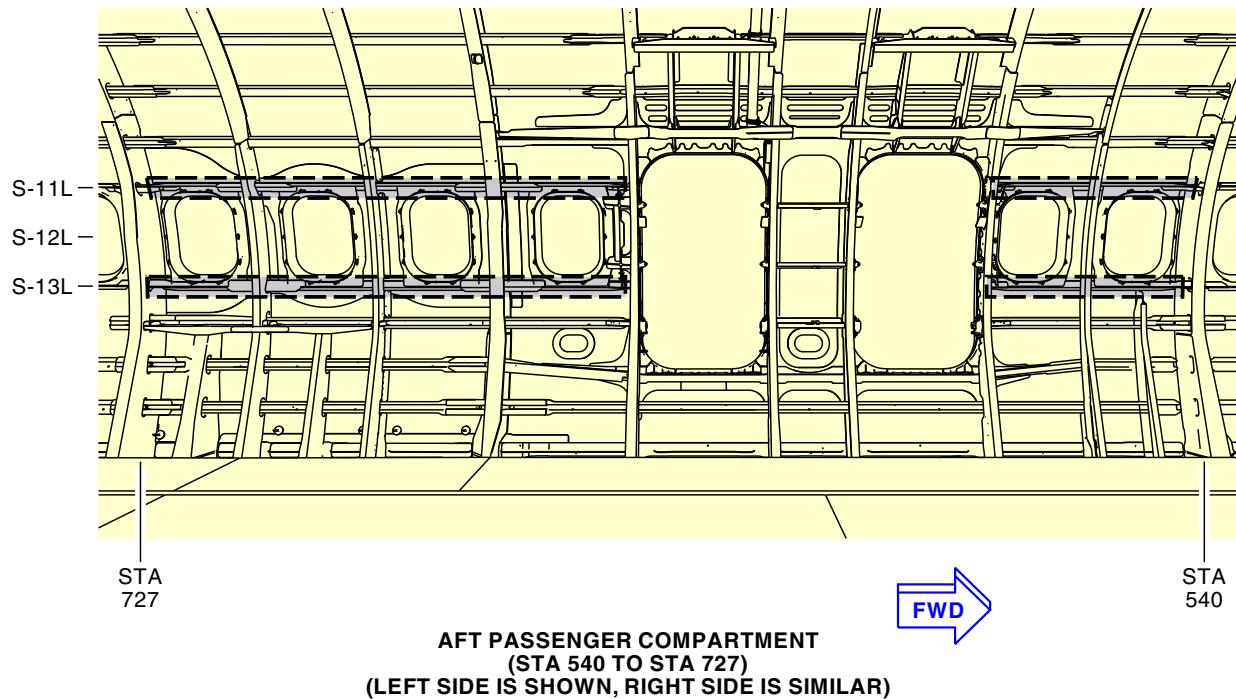
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Page 281  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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**Window Belt, STA 540 to STA 727**  
**Figure 232/53-05-02-990-891 (Sheet 2 of 2)**

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**53-05-02**

D633A101-LOM

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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-823**

**62. EXTERNAL - DETAILED: WINDOW BELT, STA 540 TO 727**

Figure 233

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-023

- (1) Do a Detailed inspection of the skin from stringers S-11 to S-13 between the windows from STA 540 to STA 727.

NOTE: Pay special attention to fastener locations common to the window frames.

See Doc. D626A001-DTR, DTR check form 53-40-04-2 for alternative inspections.

———— END OF TASK ——

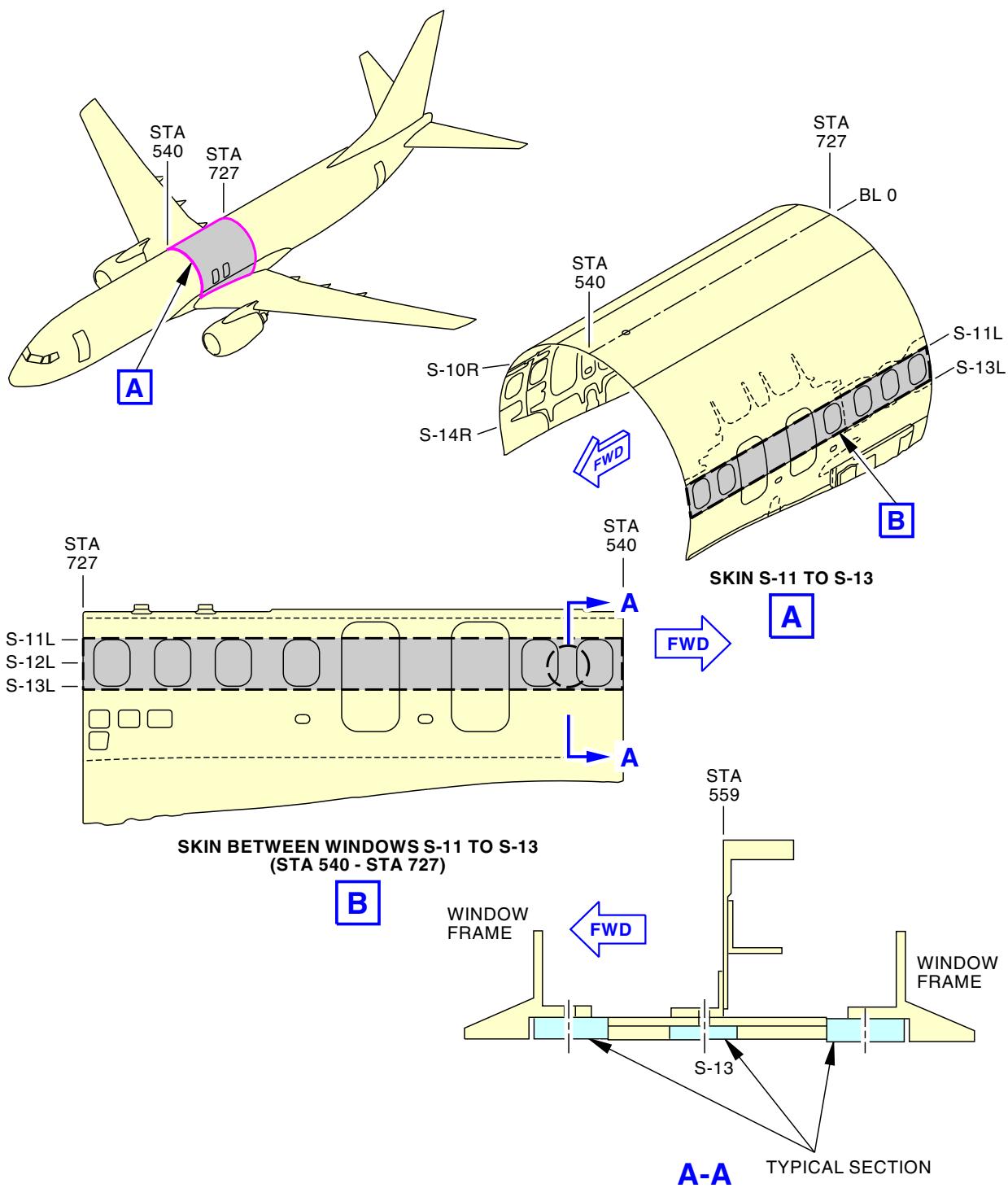
EFFECTIVITY  
LOM ALL

**53-05-02**

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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Window Belt, STA 540 to STA 727  
Figure 233/53-05-02-990-892

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-824**

**63. INTERNAL - DETAILED: STRINGER SPLICE, STA 663**

Figure 234

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Remove and/or displace passenger cabin sidewall panels and insulation blankets.

SUBTASK 53-05-02-211-024

- (1) Do a Detailed inspection of the stringers S-11 to S-13 at a distance of 10 inches forward and aft of STA 663.

See Doc. D626A001-DTR, DTR check form 53-40-07-2 for alternative inspections.

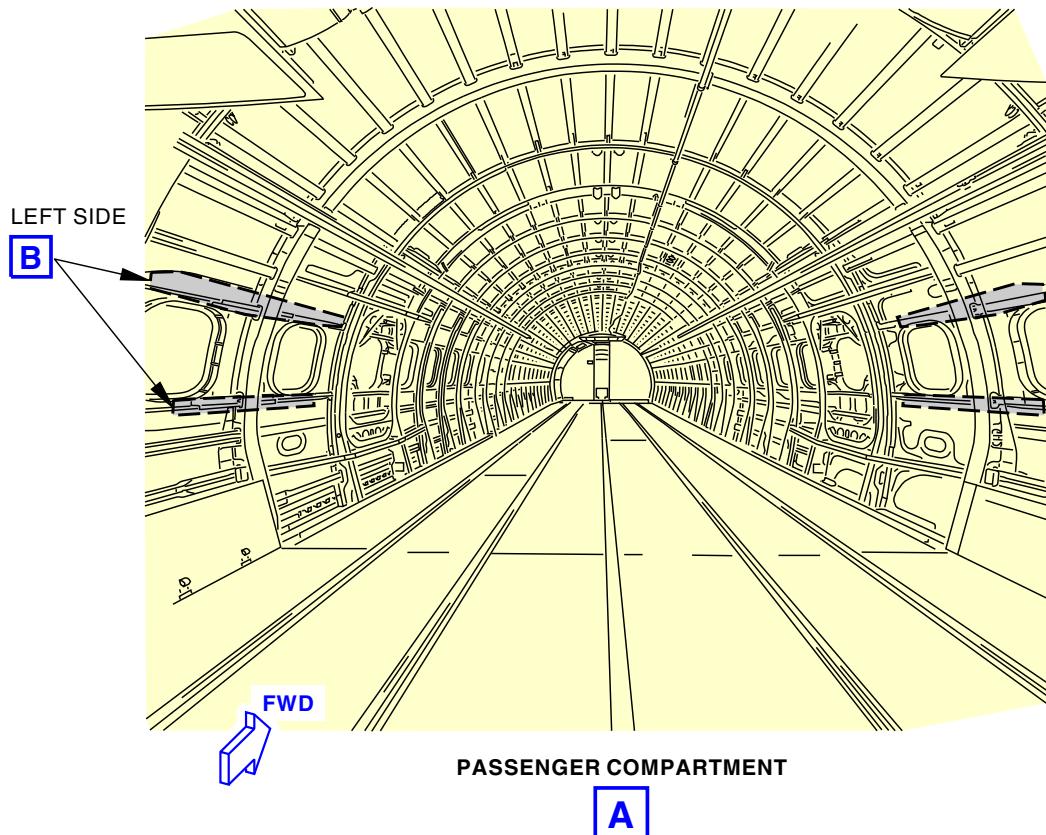
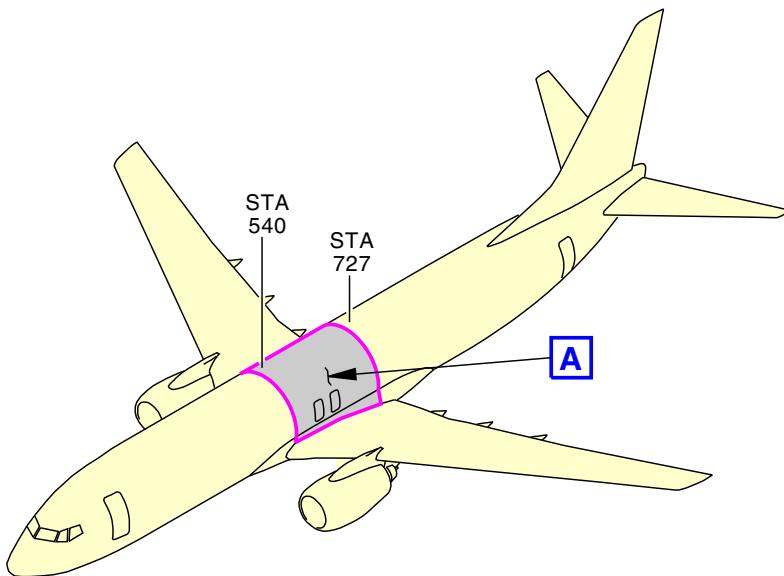
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EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Stringer Splice, STA 663  
Figure 234/53-05-02-990-893 (Sheet 1 of 2)

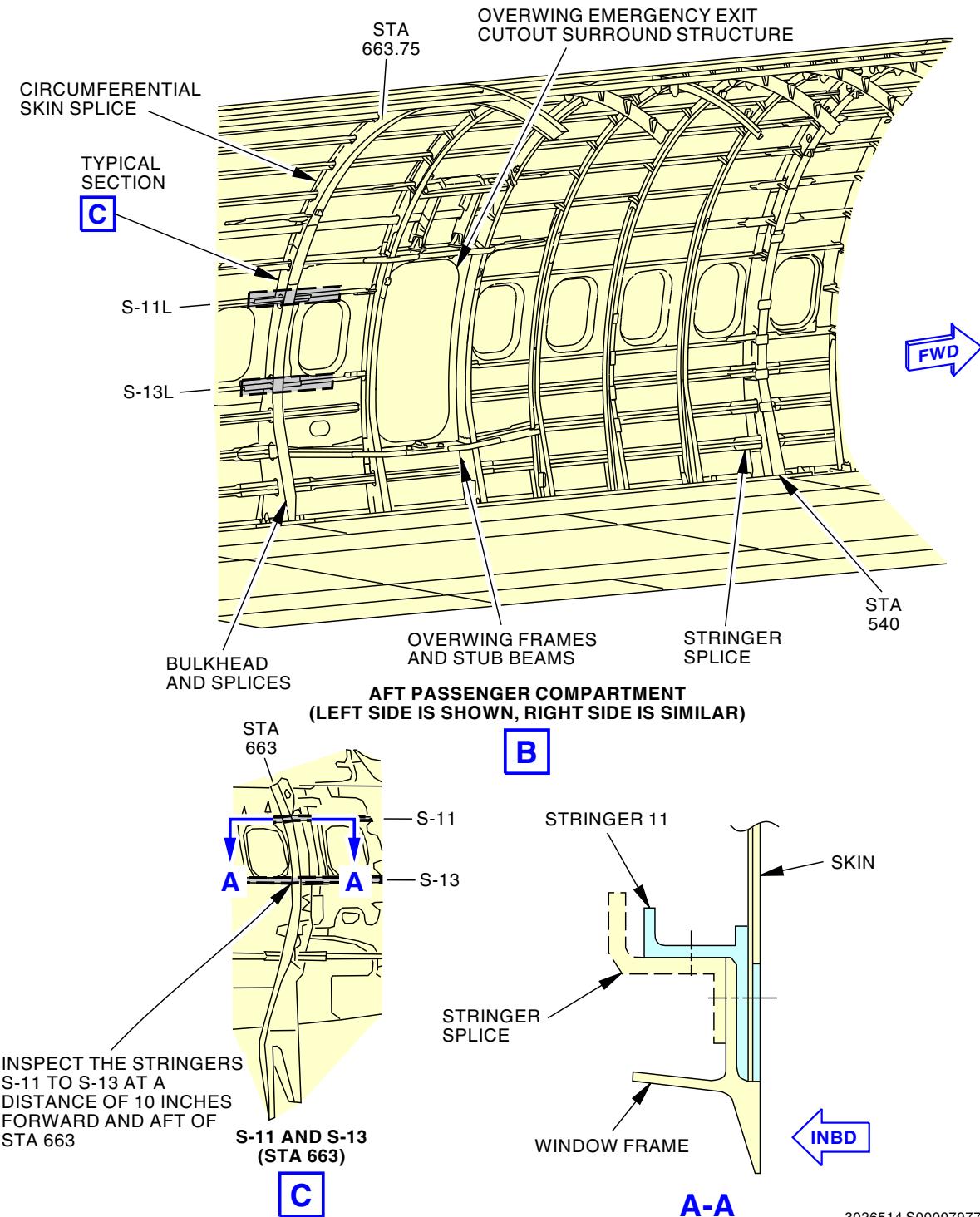
EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

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Page 286  
Oct 15/2023

**737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL**


**Stringer Splice, STA 663**  
**Figure 234/53-05-02-990-893 (Sheet 2 of 2)**

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-825**

**64. INTERNAL - DETAILED: KEEL BEAM CHORDS, STIFFENERS AND SPLICE**

(Figure 235)

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
06-41-00-010-801	Open Access Panel 192CR (P/B 201)
06-41-00-410-801	Close Access Panel 192CR (P/B 201)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
139	Keel Beam, (Part) Body Station 540.00 to Body Station 727.00
192	Lower Wing-To-Body Fairing - Under Wing Box
193	Lower Wing-To-Body Fairing - Wheel Well

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
192CL	ECS Access Door
192CR	ECS Access Door
192DR	ECS High Pressure Access Door

**D. Inspection**

SUBTASK 53-05-02-010-019

- (1) To open access panel 192CR, refer to: Open Access Panel 192CR, TASK 06-41-00-010-801  
Open this access panel on the Left side:

<b>Number</b>	<b>Name/Location</b>
192CL	ECS Access Door

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
192CR	ECS Access Door
192DR	ECS High Pressure Access Door

SUBTASK 53-05-02-211-025

- (2) Do a Detailed inspection of the keel beam side panel webs from STA 540 to STA 663.  
See Doc. D626A001-DTR, DTR check form 53-40-08-1 for alternative inspections.

SUBTASK 53-05-02-410-017

- (3) To close access panel 192CR, refer to: Close Access Panel 192CR, TASK 06-41-00-410-801  
Close this access panel on the Left side:

<b>Number</b>	<b>Name/Location</b>
192CL	ECS Access Door

Close these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
192CR	ECS Access Door
192DR	ECS High Pressure Access Door

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

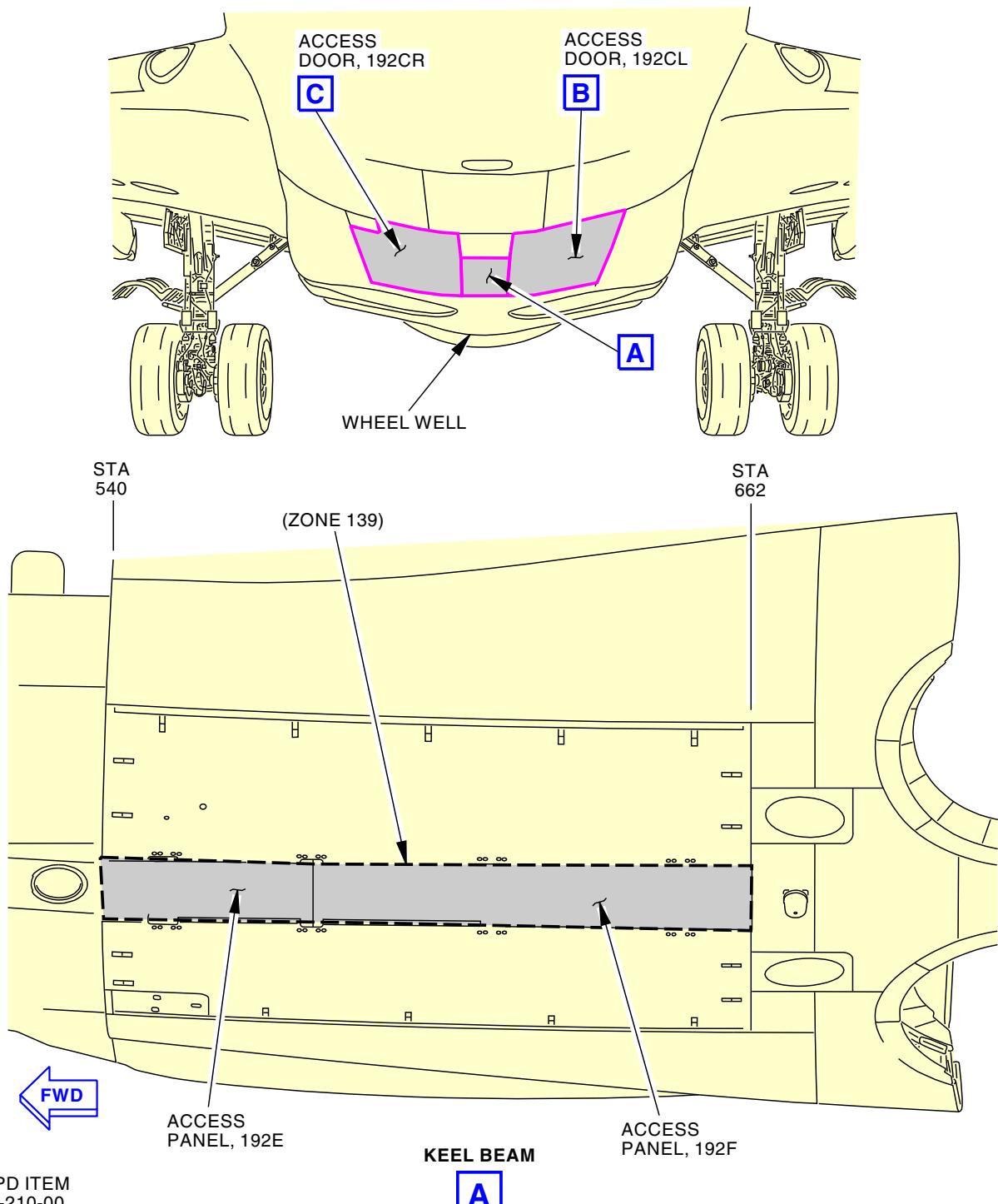
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———— EFFECTIVITY ————  
**LOM ALL**

**53-05-02**

Page 289  
Feb 15/2025

D633A101-LOM



**Keel Beam Chords, Stiffeners and Splice**  
**Figure 235/53-05-02-990-894 (Sheet 1 of 2)**

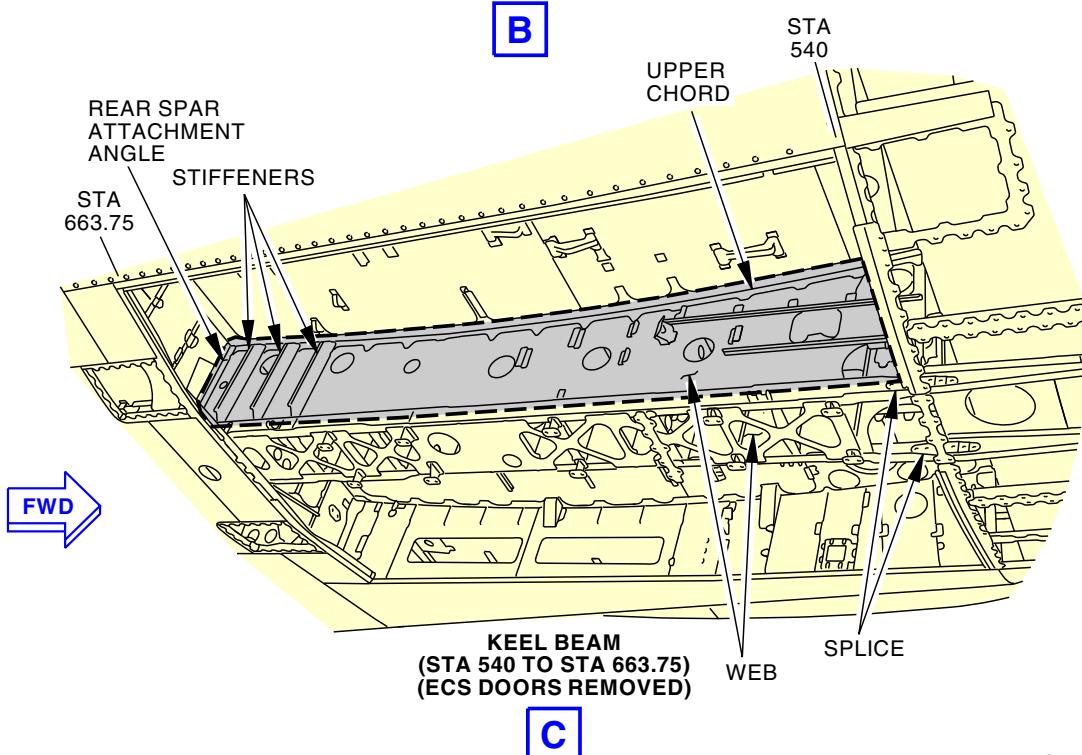
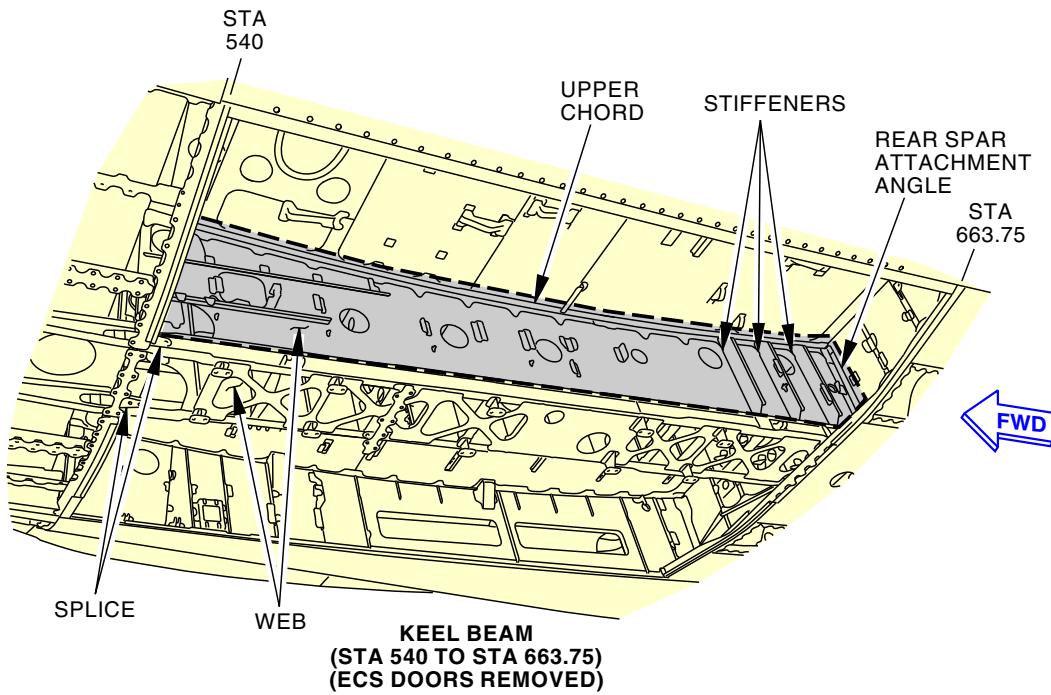
EFFECTIVITY  
LOM ALL

**53-05-02**

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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Keel Beam Chords, Stiffeners and Splice  
Figure 235/53-05-02-990-894 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

53-05-02

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 291  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-848**

**65. INTERNAL - SPECIAL DETAILED: STIFFENER ATTACHMENT TO FLOOR BEAM, STA 727**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right

**B. Inspection**

NOTE: Remove and/or displace aft cargo forward bulkhead, ceiling, sidewall panels and insulation blankets as required to perform the inspection.

SUBTASK 53-05-02-250-048

- (1) Do a High Frequency Eddy Current inspection of the fastener row connecting the pressure bulkhead stiffener to the stiffener attachment fitting that joins the stiffener to the floor beam (at five locations) around the fastener/collar on the outboard side at LBL and RBL 45 and WL 202.6.

See Doc. D626A001-DTR, DTR check form 53-40-10-1 for alternative inspections.

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 53-11-29.

————— END OF TASK ————

**TASK 53-05-02-250-849**

**66. INTERNAL - SPECIAL DETAILED: STRINGER 18 STRAP SIDE OF BODY**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

Number	Name/Location
195CL	Wing To Body Fairing - Left Side
195CR	Wing To Body Fairings - Right Side

**C. Inspection**

SUBTASK 53-05-02-010-137

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

**Number      Name/Location**  
195CL      Wing To Body Fairing - Left Side

Open this access panel on the Right side:

**Number      Name/Location**  
195CR      Wing To Body Fairings - Right Side

EFFECTIVITY  
LOM ALL

**53-05-02**

Page 292  
Jun 15/2024



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-05-02-250-049

- (2) Do a Low Frequency Eddy Current inspection of the skin under the strap at stringer S-18 between the fasteners common to the strap and skin from STA 717 to STA 727.

See Doc. D626A001-DTR, DTR check form 53-40-11-1 for alternative inspections.

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 53-30-49.

SUBTASK 53-05-02-410-127

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

**Number      Name/Location**

195CL      Wing To Body Fairing - Left Side

Close this access panel on the Right side:

**Number      Name/Location**

195CR      Wing To Body Fairings - Right Side

———— END OF TASK ————

**TASK 53-05-02-250-850**

**67. INTERNAL - SPECIAL DETAILED: STRINGER 18A CHORD AND LINKS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
142	Aft Cargo Compartment - Right

**B. Inspection**

SUBTASK 53-05-02-250-050

- (1) Do a High Frequency Eddy Current inspection around the bushings on each lug, three lugs per assembly, on the upper and lower surface at STA 663.

See Doc. D626A001-DTR, DTR check form 53-40-12-1 for alternative inspections.

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 53-11-30.

———— END OF TASK ————

**TASK 53-05-02-250-851**

**68. INTERNAL - SPECIAL DETAILED: FRAME SPLICE AT STA 540**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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



**53-05-02**

Page 293  
Jun 15/2024



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**B. Inspection**

NOTE: Remove and/or displace passenger cabin sidewalls and insulation blankets as required.

SUBTASK 53-05-02-250-051

- (1) Do a High Frequency Eddy Current inspection of the frame inner chord at all fasteners common to the inner chord and to the inner splice plate between stringers S-9 and S-10.

See Doc. D626A001-DTR, DTR check form 53-40-14-1 for alternative inspections.

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 53-11-49.

———— END OF TASK ————

**TASK 53-05-02-211-826**

**69. EXTERNAL - DETAILED: BS 540 BULKHEAD**

Figure 236

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-026

- (1) Do a Detailed inspection of the skin panels at the outer chord from stringers S-9L to S-9R, on each side of splice 540, for cracks at the frame to skin fastener holes.

See Doc. D626A001-DTR, DTR check form 53-40-14-4 for alternative inspections.

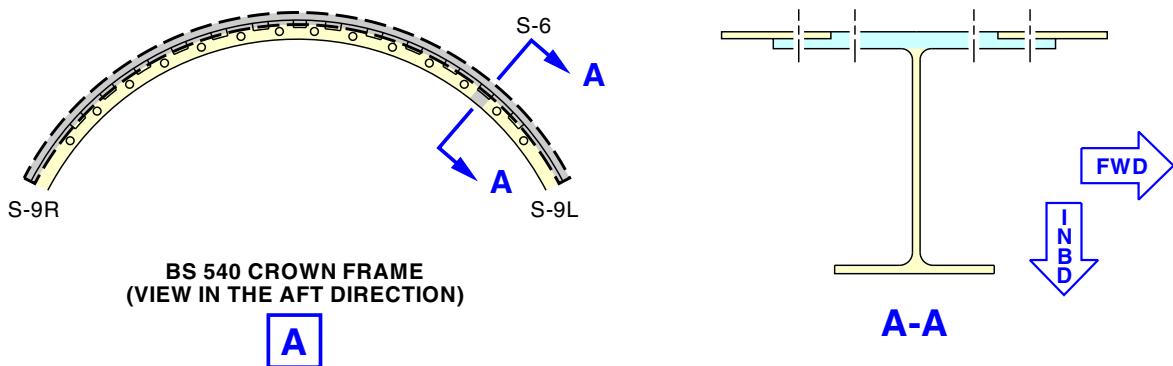
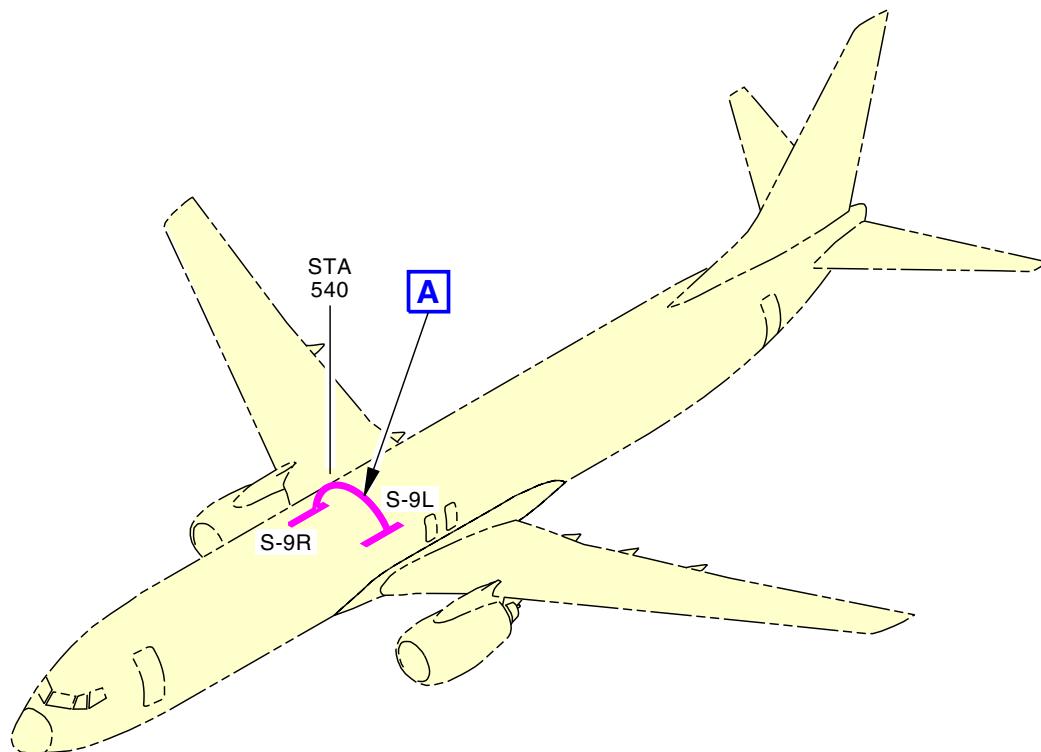
———— END OF TASK ————



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



BS 540 CROWN FRAME  
(VIEW IN THE AFT DIRECTION)

3024844 S0000796518\_V1

BS 540 Bulkhead  
Figure 236/53-05-02-990-895

EFFECTIVITY	LOM ALL
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D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-02**

Page 295  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-827**

**70. EXTERNAL - DETAILED: BS 663 BULKHEAD**

Figure 237

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-027

- (1) Do a Detailed inspection of the skin on each side of STA 663, from stringers S-8 to S-11, on both the left and right sides.

See Doc. D626A001-DTR, DTR check form 53-40-15-1 for alternative inspections.

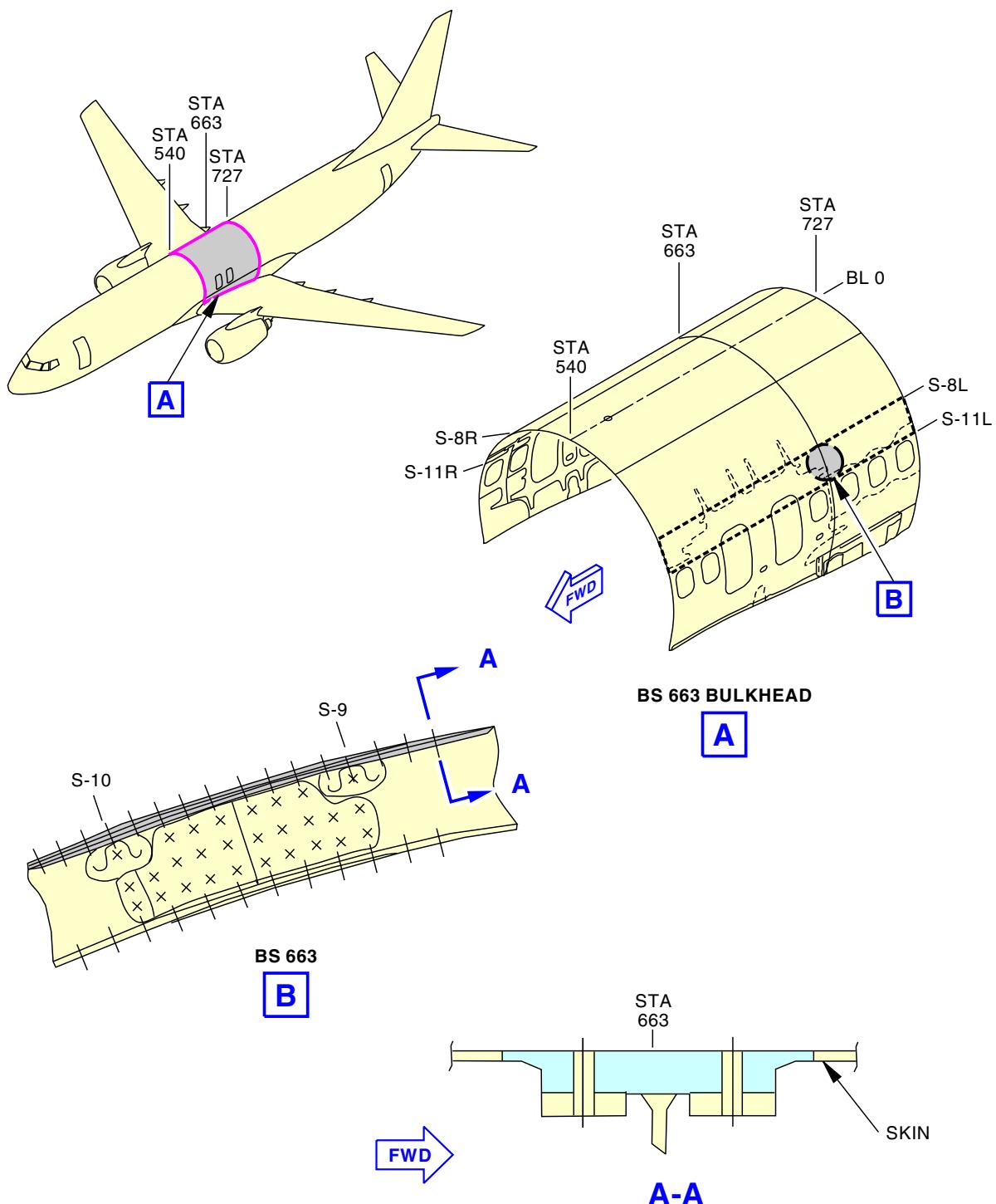
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3024823 S0000796735\_V1

**BS 663 Bulkhead**  
**Figure 237/53-05-02-990-896**

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-852**

**71. INTERNAL - SPECIAL DETAILED: BS 663 BULKHEAD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Remove and/or displace passenger cabin sidewalls and insulation blankets as required.

SUBTASK 53-05-02-250-052

- (1) Do a High Frequency Eddy Current inspection of the bulkhead inner chord from stringers S-10 and S-17 on both the left and right hand sides.

See Doc. D626A001-DTR, DTR check form 53-40-15-3 for alternative inspections.

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 53-11-50.

———— END OF TASK ————

**TASK 53-05-02-211-828**

**72. INTERNAL - DETAILED: AFT CARGO DOOR SURROUND STRUCTURE**

Figure 238

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

**B. Access Panels**

Number	Name/Location
822	Aft Cargo Door

**C. Inspection**

SUBTASK 53-05-02-010-142

- (1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

SUBTASK 53-05-02-211-028

- (2) Do a Detailed inspection of the upper sill inner chord.

See Doc. D626A001-DTR, DTR check form 53-60-08-11, for alternative inspections.

SUBTASK 53-05-02-410-134

- (3) Close this access panel:

Number	Name/Location
822	Aft Cargo Door

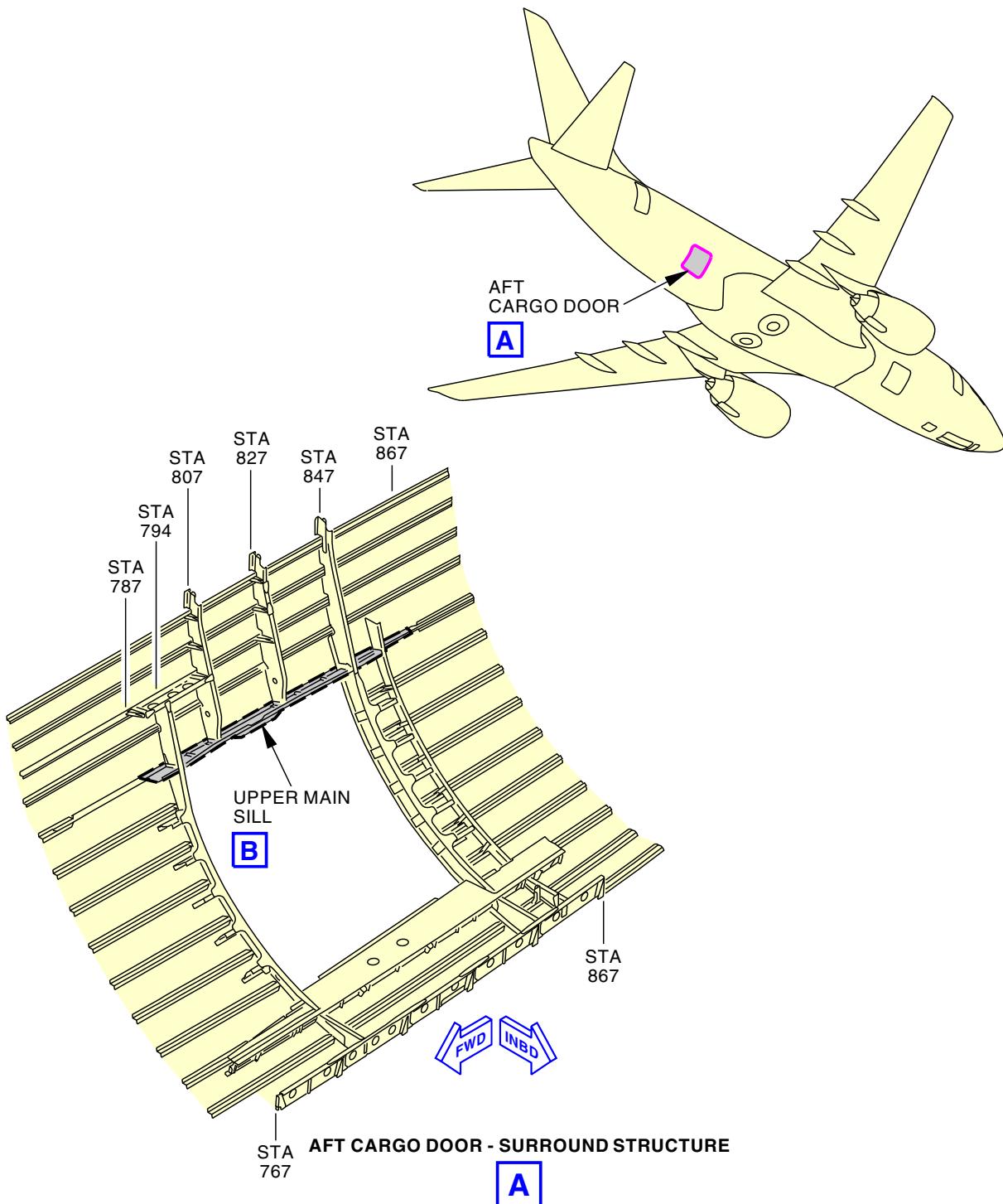
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3032703 S0000800054\_V1

Aft Cargo Door Surround Structure  
Figure 238/53-05-02-990-801 (Sheet 1 of 2)

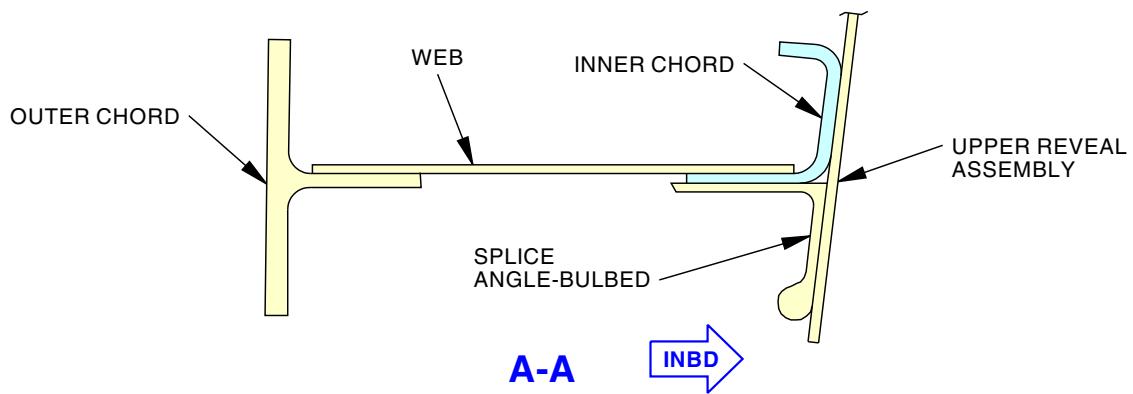
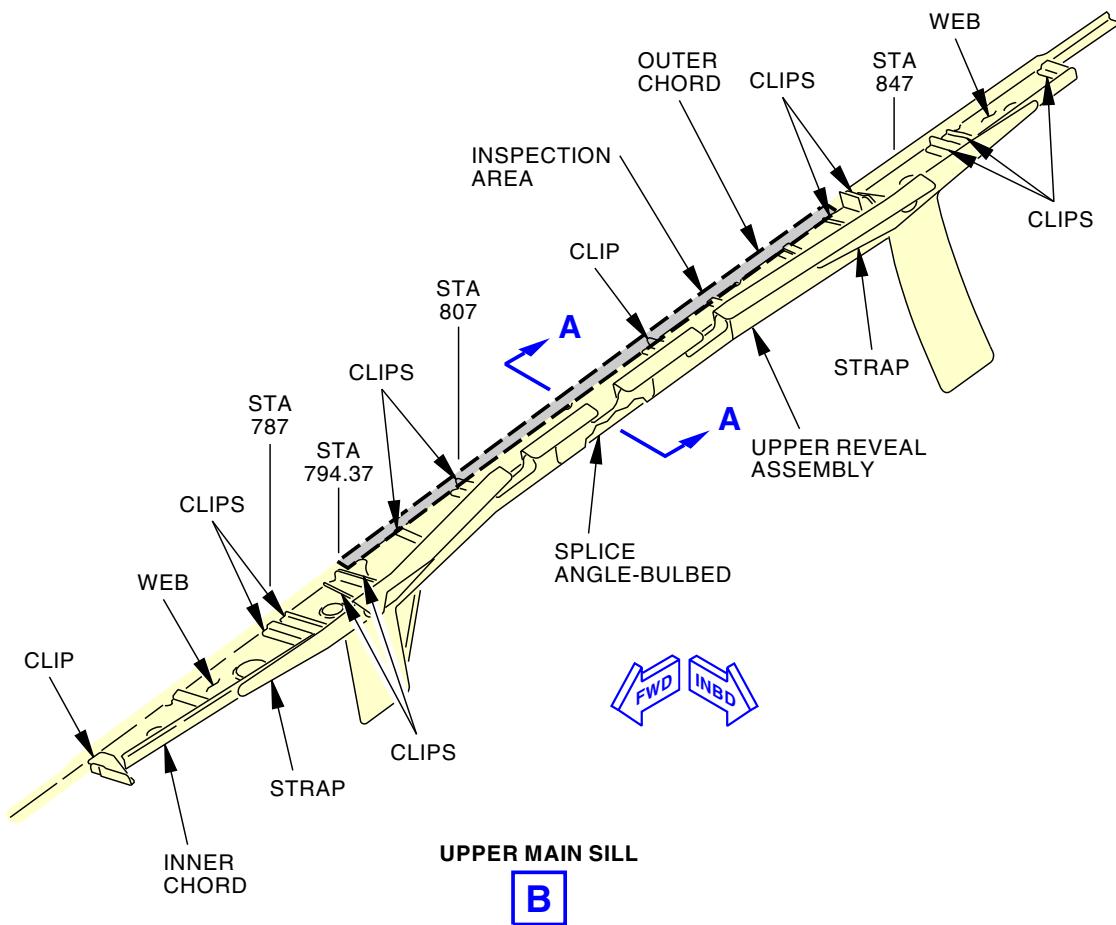
EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.1  
Jun 15/2024



3032704 S0000800055\_V1

**Aft Cargo Door Surround Structure**  
**Figure 238/53-05-02-990-801 (Sheet 2 of 2)**

EFFECTIVITY  
**LOM ALL**

**53-05-02**

D633A101-LOM



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-853**

**73. INTERNAL - SPECIAL DETAILED: WHEEL WELL AFT BULKHEAD AND PRESSURE WEB STA 727**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

**B. Inspection**

NOTE: Remove and/or displace aft cargo forward bulkhead, ceiling, sidewall panels and insulation blankets as required to perform the inspection.

SUBTASK 53-05-02-250-053

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

See Doc. D626A001-DTR, DTR check form 53-40-16-3 for alternative inspections.

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 53-11-25.

———— END OF TASK ————

**TASK 53-05-02-250-854**

**74. INTERNAL - SPECIAL DETAILED: AFT WHEEL WELL BULKHEAD, STA 727**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
143	Area Below Aft Cargo Compartment - Left
144	Area Below Aft Cargo Compartment - Right

**B. Inspection**

NOTE: Remove and/or displace aft cargo forward bulkhead, ceiling, sidewall panels and insulation blankets as required to perform the inspection.

SUBTASK 53-05-02-250-054

- (1) Do a High Frequency Eddy Current inspection of the fail safe angle from inside the aft cargo bay at frame 727, from stringers S-21L to S-27L and stringers S-21R to S-27R.

See Doc. D626A001-DTR, DTR check form 53-40-16-1a for alternative inspections.

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 53-10-93.

———— END OF TASK ————

**TASK 53-05-02-130-804**

**75. INTERNAL - SPECIAL DETAILED: WHEEL WELL AFT BULKHEAD**

NOTE: This procedure is a scheduled maintenance task.

EFFECTIVITY
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

A. Location Zones

Zone	Area
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

B. Inspection

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

SUBTASK 53-05-02-130-004

- (1) Do an Ultrasonic inspection of the six fasteners through the inner chord and web at STA 727 and WL 201.

See Doc. D626A001-DTR, DTR check form 53-40-16-2a for alternative inspections.

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 53-10-09.

———— END OF TASK ——

**TASK 53-05-02-211-830**

**76. INTERNAL - DETAILED: WHEEL WELL AFT BULKHEAD AND PRESSURE WEB, STA 727**

A. Inspection

SUBTASK 53-05-02-211-030

- (1) Do the inspection.

———— END OF TASK ——

**TASK 53-05-02-211-832**

**77. INTERNAL - DETAILED: AFT WHEEL WELL BULKHEAD AND PRESSURE WEB, STA 727**

Figure 239

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

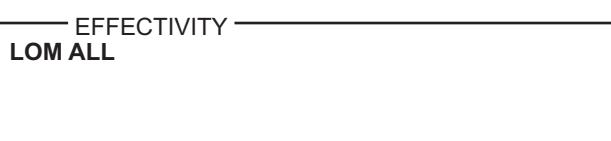
NOTE: Remove and/or displace passenger cabin ceiling panels and insulation as required to perform the inspection.

SUBTASK 53-05-02-211-032

- (1) Do a Detailed inspection of the frame inner chord and web between stringers S-9L and S-9R at STA 727.

See Doc. D626A001-DTR, DTR check form 53-40-16-5 for alternative inspections.

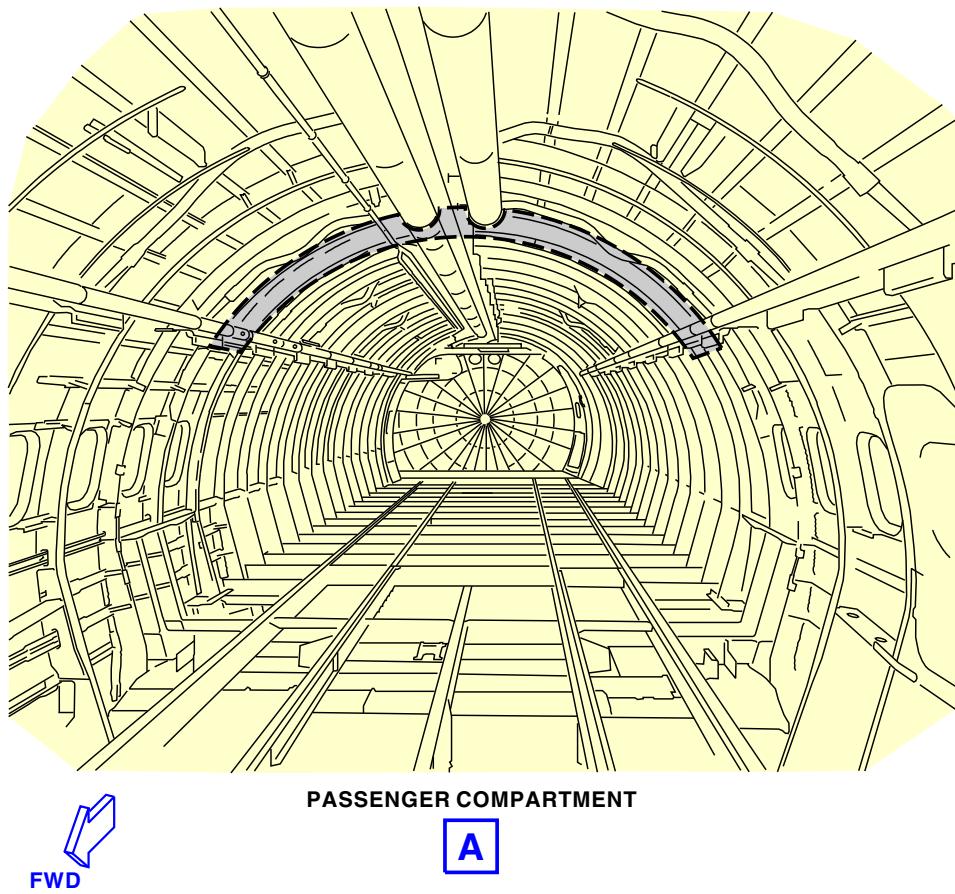
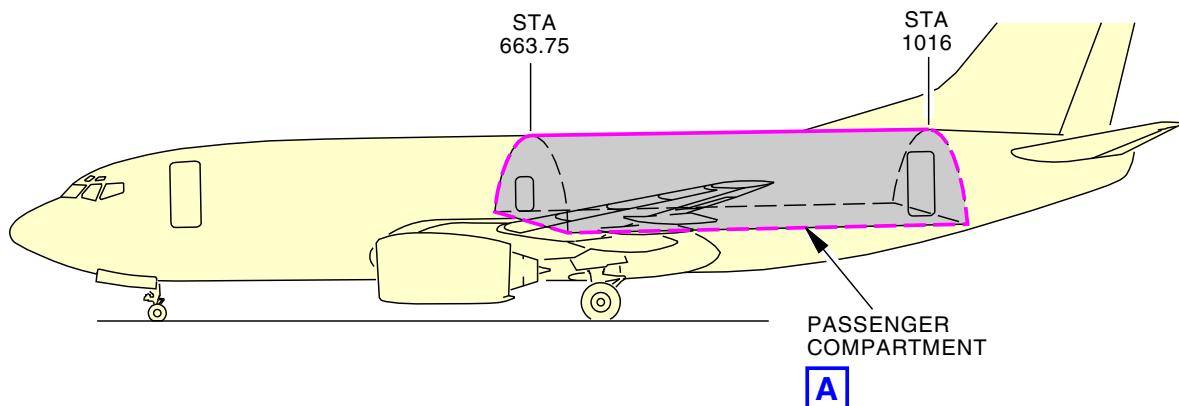
———— END OF TASK ——



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3026409 S0000796519\_V1

**Aft Wheel Well Bulkhead and Pressure Web, STA 727**  
Figure 239/53-05-02-990-897 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

**53-05-02**

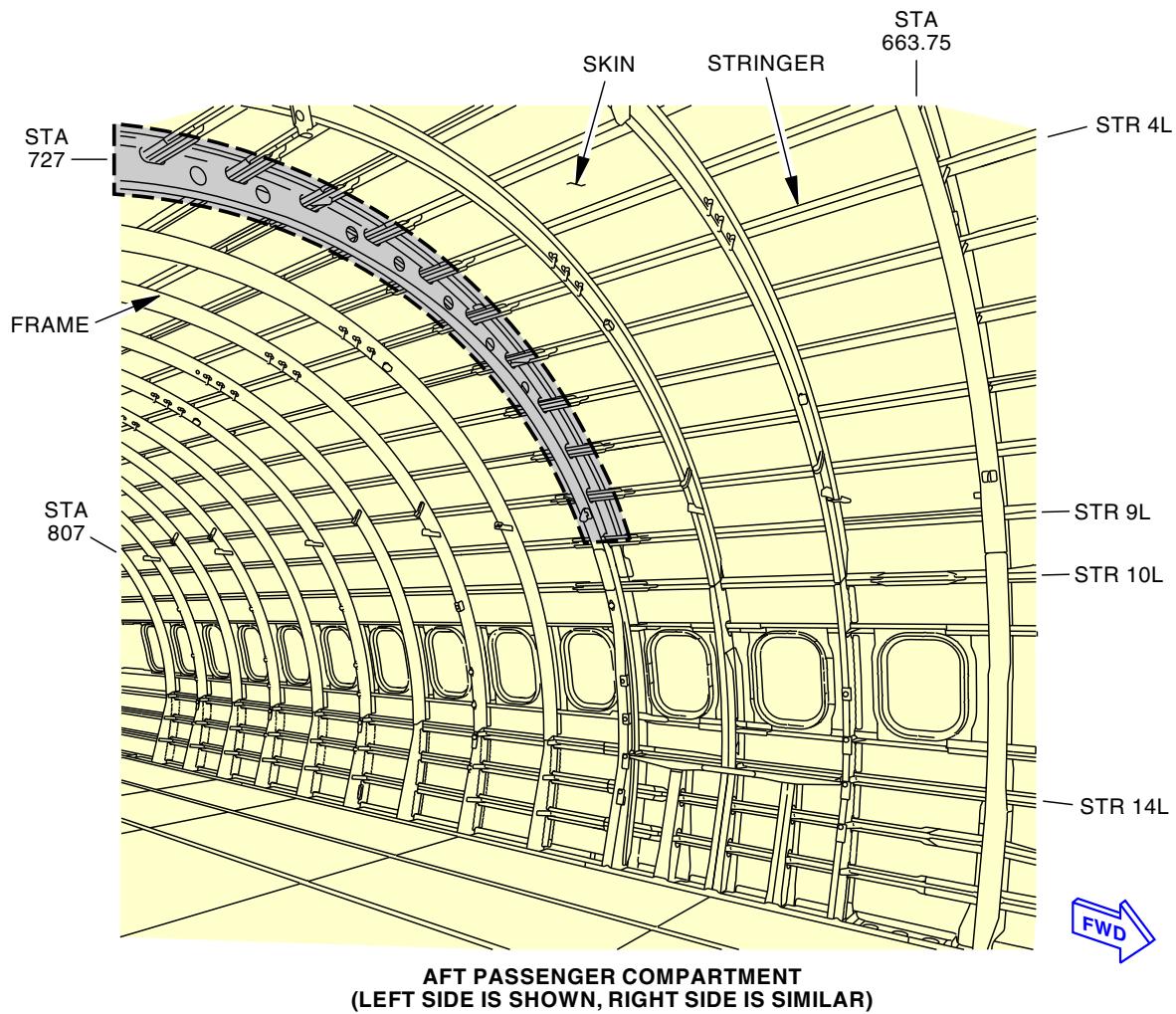
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

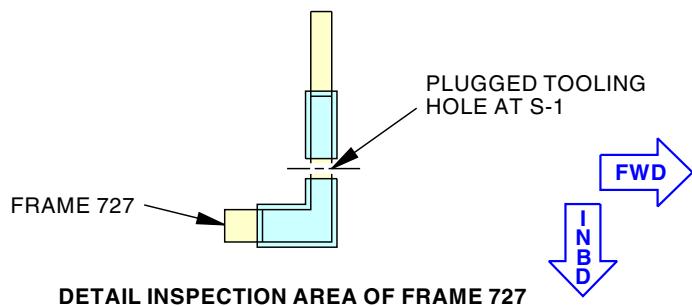
Page 298.5  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



AFT PASSENGER COMPARTMENT  
(LEFT SIDE IS SHOWN, RIGHT SIDE IS SIMILAR)



DETAIL INSPECTION AREA OF FRAME 727

3026418 S0000797751\_V1

Aft Wheel Well Bulkhead and Pressure Web, STA 727  
Figure 239/53-05-02-990-897 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.6  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-855**

**78. INTERNAL - SPECIAL DETAILED: AFT WHEEL WELL BULKHEAD FRAME, STA 727**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

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

SUBTASK 53-05-02-250-055

- (1) Do a High Frequency Eddy Current inspection of the visible portion of the frame web above the splice angle on the forward side of the frame between stringers S-9 and S-10 on both sides of the aircraft at STA 727.

See Doc. D626A001-DTR, DTR check form 53-40-16-6 for alternative inspections.

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 53-10-92.

————— END OF TASK ————

**TASK 53-05-02-250-856**

**79. INTERNAL - SPECIAL DETAILED: SIDE STRUT SUPPORT FRAME, STA 706**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

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

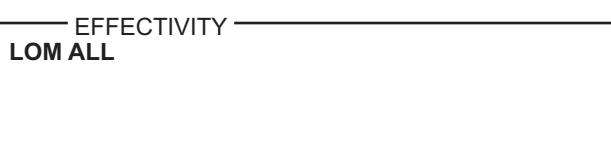
SUBTASK 53-05-02-250-056

- (1) Do a High Frequency Eddy Current inspection of the frame inner chord and fail-safe angle (around the fasteners common to the fail-safe angle), the forward frame web (around the fasteners common to the fail-safe angle), and the frame outer chord (around the fasteners common to the skin) between stringers S-10 and S-13.

See Doc. D626A001-DTR, DTR check form 53-40-17-1 for alternative inspections.

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 53-11-19.

————— END OF TASK ————



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-210-802**

**80. INTERNAL - GENERAL VISUAL: MAIN LANDING GEAR SUPPORT FRAME, STA 695**

Figure 240

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Inspection**

NOTE: Remove or displace passenger cabin sidewall air grilles, floor panels and insulation blankets as required.

SUBTASK 53-05-02-210-002

- (1) Do a General Visual inspection of the upper fastener through the web.

See Doc. D626A001-DTR, DTR check form 53-40-18-2 for alternative inspections.

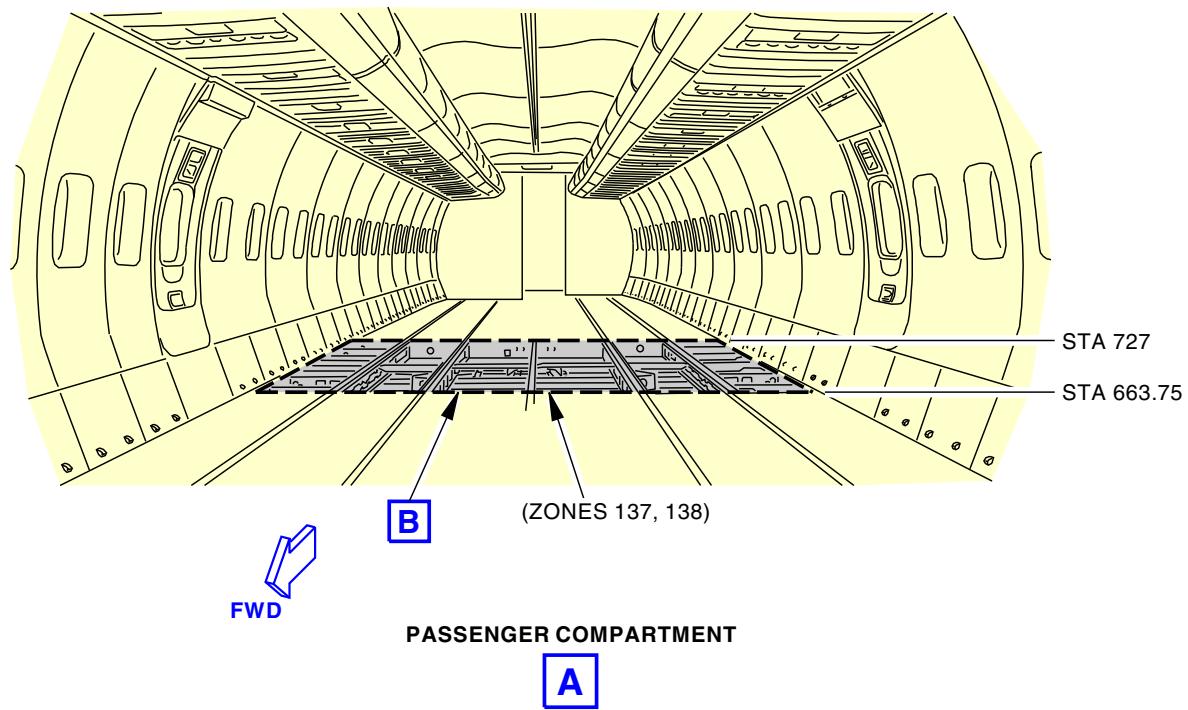
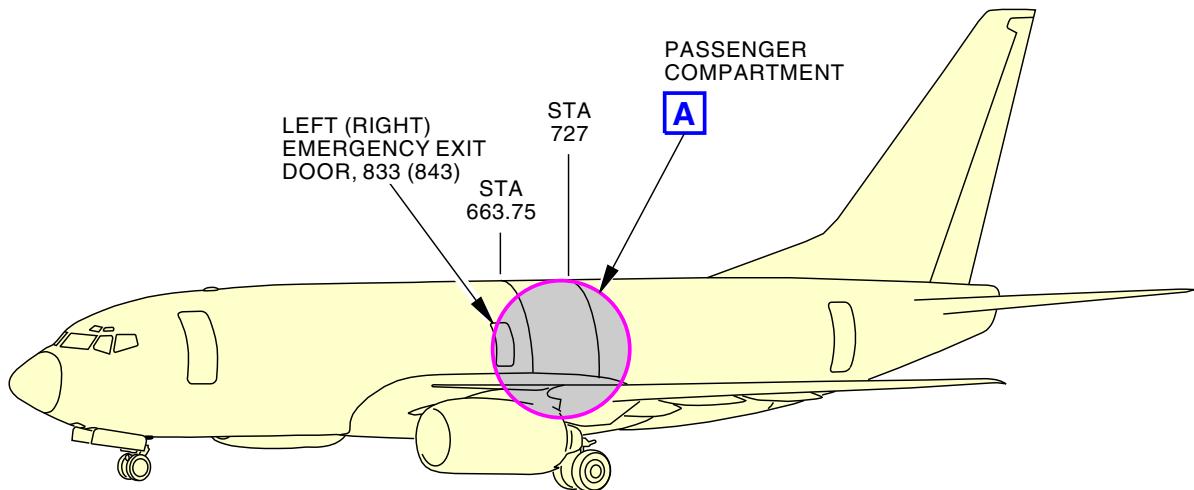
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-200-00

3026463 S0000796520\_V1

Main Landing Gear Support Frame, STA 695  
Figure 240/53-05-02-990-898 (Sheet 1 of 2)

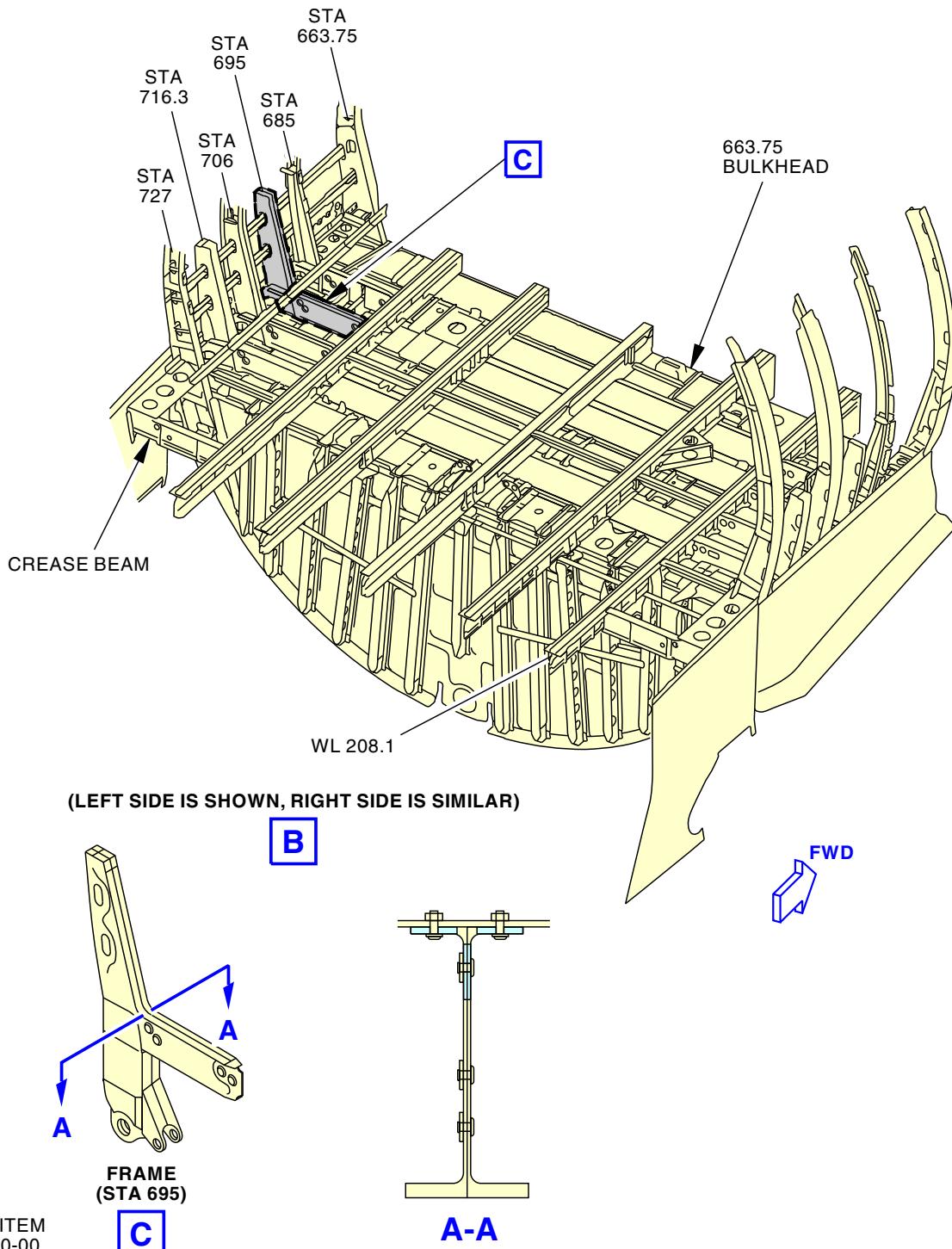
EFFECTIVITY  
LOM ALL

53-05-02

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.9  
Jun 15/2024



**Main Landing Gear Support Frame, STA 695**  
**Figure 240/53-05-02-990-898 (Sheet 2 of 2)**

EFFECTIVITY  
**LOM ALL**

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-857**

**81. INTERNAL - SPECIAL DETAILED: MAIN LANDING GEAR SUPPORT FRAME, STA 716**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Inspection**

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

SUBTASK 53-05-02-250-057

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

See Doc. D626A001-DTR, DTR check form 53-40-19-1 for alternative inspections.

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 53-40-05.

————— END OF TASK ————

**TASK 53-05-02-250-858**

**82. INTERNAL - SPECIAL DETAILED: MAIN LANDING GEAR SUPPORT FRAME, STA 716**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Inspection**

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

SUBTASK 53-05-02-250-058

- (1) Do a High Frequency Eddy Current inspection of the stub beam upper chord around the two fasteners common to the crease beam inner chord.

See Doc. D626A001-DTR, DTR check form 53-40-19-2 for alternative inspections.

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 53-11-14.

————— END OF TASK ————

————— EFFECTIVITY ————  
**LOM ALL**

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-859**

**83. INTERNAL - SPECIAL DETAILED: MAIN LANDING GEAR SUPPORT FRAME, STA 716**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Inspection**

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

SUBTASK 53-05-02-250-059

- (1) Do a High Frequency Eddy Current inspection on the web of the stub beam around the fasteners common to the floor clip.

See Doc. D626A001-DTR, DTR check form 53-40-19-3 for alternative inspections.

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 53-11-09.

———— END OF TASK ————

**TASK 53-05-02-250-860**

**84. INTERNAL - SPECIAL DETAILED: MAIN LANDING GEAR SUPPORT FRAME, STA 716**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Inspection**

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

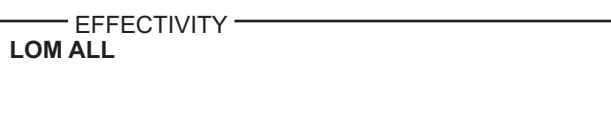
SUBTASK 53-05-02-250-060

- (1) Do a High Frequency Eddy Current inspection on the upper side of the upper flange on both the forward and aft sides from BL 45.5 to BL 64.6 on both the right and left sides.

See Doc. D626A001-DTR, DTR check form 53-40-19-3a for alternative inspections.

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 53-11-09.

———— END OF TASK ————



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-833**

**85. INTERNAL - DETAILED: WHEEL WELL FRAME, STA 685**

Figure 241Figure 242

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Inspection**

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

SUBTASK 53-05-02-211-033

- (1) Do a Detailed inspection of the frame inner chord from stringers S-13 to S-15.

See Doc. D626A001-DTR, DTR check form 53-40-21-2 for alternative inspections.

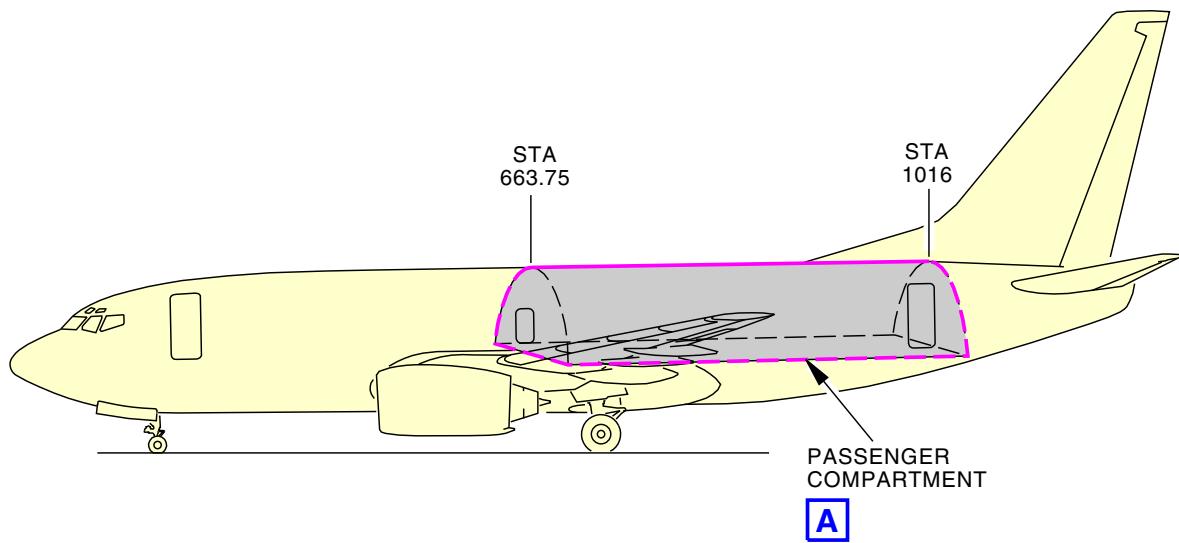
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Wheel Well Frame, STA 685  
Figure 241/53-05-02-990-802

EFFECTIVITY  
LOM ALL

**53-05-02**

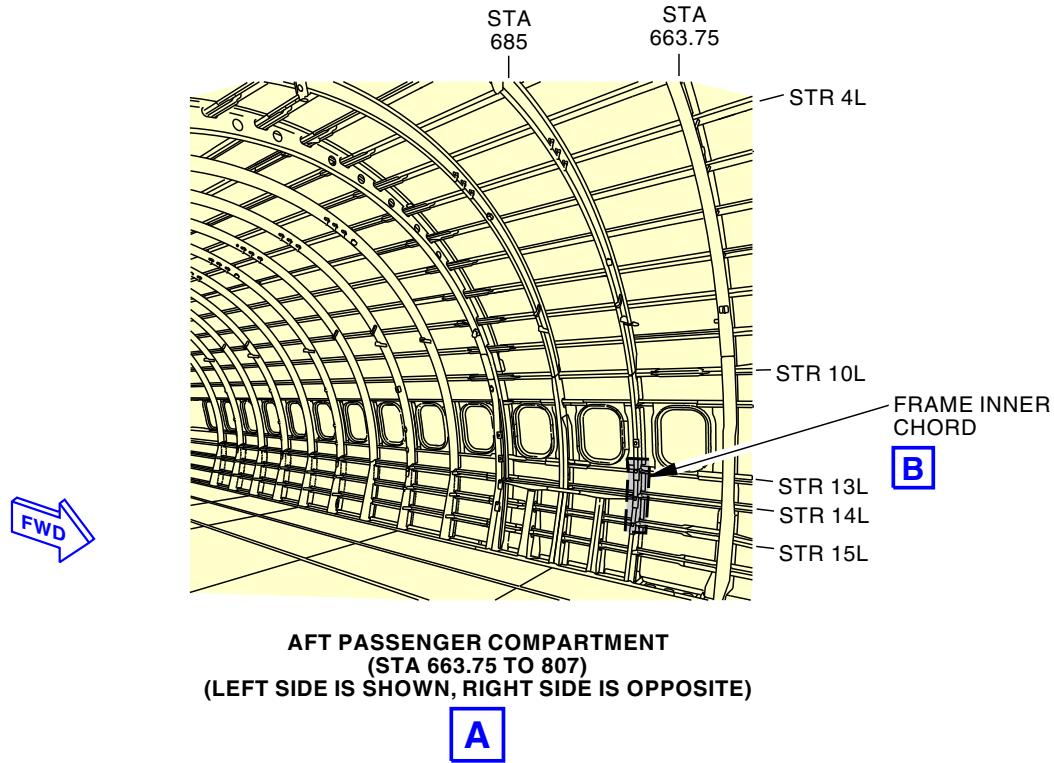
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

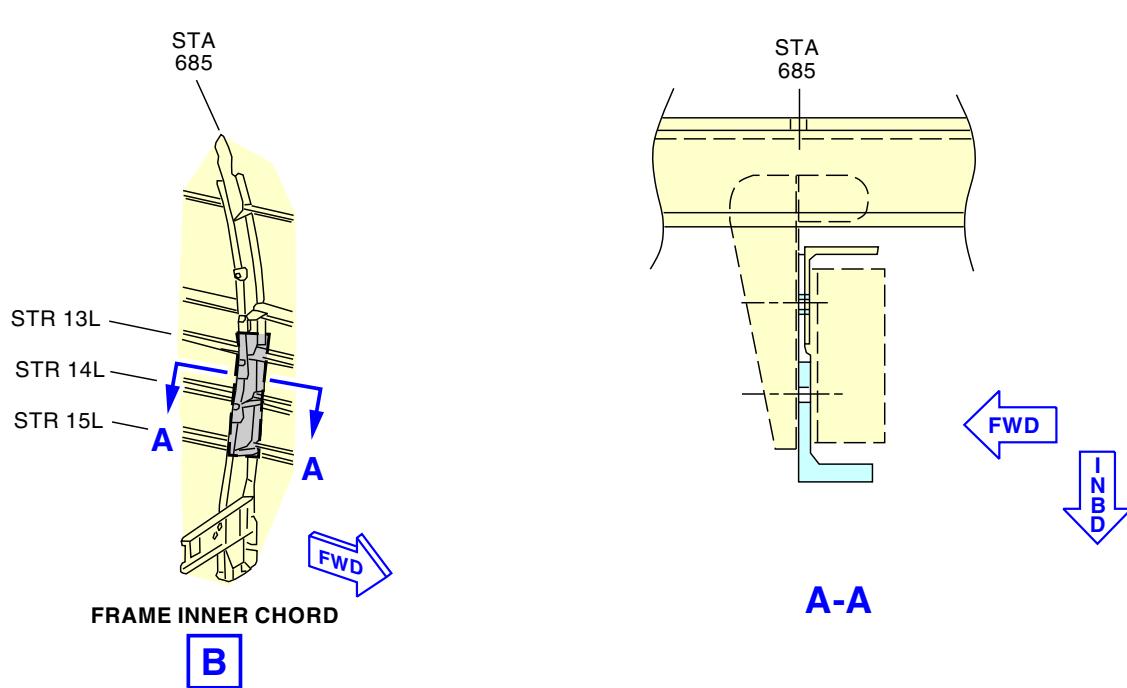
Page 298.14  
Jun 15/2024



737-600/700/800/900  
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AFT PASSENGER COMPARTMENT  
(STA 663.75 TO 807)  
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)



3026293 S0000797594\_V1

Wheel Well Frame, STA 685  
Figure 242/53-05-02-990-803

EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-02**

Page 298.15  
Jun 15/2024



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-05-02-250-861**

**86. INTERNAL - SPECIAL DETAILED: WHEEL WELL FRAME, STA 685**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Inspection**

SUBTASK 53-05-02-250-061

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

- (1) Do a High Frequency Eddy Current inspection of the frame inner chord flange and around accessible fasteners common to the inner chord and stringer clips from stringers S-17 to S-14. See Doc. D626A001-DTR, DTR check form 53-40-21-3 for alternative inspections.

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 53-11-17.

———— END OF TASK ————

**TASK 53-05-02-250-862**

**87. INTERNAL - SPECIAL DETAILED: WHEEL WELL FRAME AT STA 685**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Inspection**

SUBTASK 53-05-02-250-062

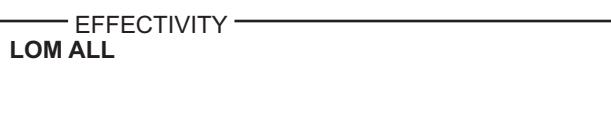
NOTE: Remove and/or displace passenger cabin floor panels as required to perform the inspection.

- (1) Do a High Frequency Eddy Current inspection of the stub beam upper chord from two inches inside the skin to a distance of twelve inches inboard and around any fasteners through the upper web and chord in this area.

See Doc. D626A001-DTR, DTR check form 53-40-21-4 for alternative inspections.

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 53-11-06.

———— END OF TASK ————



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-867**

**88. EXTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT SKIN ASSEMBLY AND FRAME OUTER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
832	Left Forward Emergency Exit
842	Right Forward Emergency Exit

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
842	Emergency Exit

**C. Inspection**

SUBTASK 53-05-02-010-080

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

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit

Open this access panel on the Right side:

<b>Number</b>	<b>Name/Location</b>
842	Emergency Exit

SUBTASK 53-05-02-250-067

- (2) Do a Low Frequency Eddy Current inspection of the doublers around the fasteners common to the STA 578 cutout forward edge frame outer chord from stringers S-11 to S-13.

See Doc. D626A001-DTR, DTR check form 53-40-22-3 for alternative inspections.

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 53-11-16.

NOTE: This inspection must be work in conjunction with either fatigue task 53-682-01 or 53-682-03 to meet DTR requirements.

SUBTASK 53-05-02-410-078

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

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit

Close this access panel on the Right side:

<b>Number</b>	<b>Name/Location</b>
842	Emergency Exit

— END OF TASK —

**TASK 53-05-02-250-868**

**89. EXTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT SKIN ASSEMBLY AND FRAME OUTER CHORD**

NOTE: This procedure is a scheduled maintenance task.

EFFECTIVITY
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**A. Location Zones**

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

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
842	Emergency Exit

**C. Inspection**

SUBTASK 53-05-02-010-081

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

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit

Open this access panel on the Right side:

<b>Number</b>	<b>Name/Location</b>
842	Emergency Exit

NOTE: Emergency Exit Door must be open to perform this inspection.

SUBTASK 53-05-02-250-068

- (2) Do a High Frequency Eddy Current inspection on the edges of the doublers from stringers S-11 to S-13.

See Doc. D626A001-DTR, DTR check form 53-40-22-3 for alternative inspections.

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 53-11-15.

NOTE: This inspection may be optional. See DTR 53-40-22-3 for inspection requirements.

SUBTASK 53-05-02-410-079

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

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit

Close this access panel on the Right side:

<b>Number</b>	<b>Name/Location</b>
842	Emergency Exit

———— END OF TASK ————

**TASK 53-05-02-250-869**

**90. INTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT SKIN ASSEMBLY AND FRAME OUTER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

B. Access Panels

Number	Name/Location
832	Emergency Exit
842	Emergency Exit

C. Inspection

SUBTASK 53-05-02-010-082

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

Number	Name/Location
832	Emergency Exit

Open this access panel on the Right side:

Number	Name/Location
842	Emergency Exit

NOTE: Emergency Exit Door must be open to perform this inspection. Seal removal or displacement is required to perform the inspection.

SUBTASK 53-05-02-250-069

- (2) Do a High Frequency Eddy Current inspection of the inner doubler from stringers S-11 to S-13.

See Doc. D626A001-DTR, DTR check form 53-40-22-3 for alternative inspections.

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 53-11-15.

NOTE: This inspection may be optional. See DTR 53-40-22-3 for inspection requirements.

SUBTASK 53-05-02-410-080

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

Number	Name/Location
832	Emergency Exit

Close this access panel on the Right side:

Number	Name/Location
842	Emergency Exit

————— END OF TASK ————

**TASK 53-05-02-250-874**

**91. INTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT - DOOR CUTOUT CORNERS**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
832	Emergency Exit
833	Emergency Exit



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

**Number      Name/Location**

842	Emergency Exit
843	Emergency Exit

**C. Inspection**

SUBTASK 53-05-02-010-085

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

**Number      Name/Location**

832	Emergency Exit
833	Emergency Exit

Open these access panels on the Right side:

**Number      Name/Location**

842	Emergency Exit
843	Emergency Exit

NOTE: Emergency Exit door must be open to perform the inspection.

SUBTASK 53-05-02-250-074

- (2) Do a High Frequency Eddy Current inspection on the edges of the doublers, on the upper edge, at stringer S-11( from STA 578 to STA 601 and from STA 616 to STA 639).

See Doc. D626A001-DTR, DTR check form 53-40-22-6 for alternative inspections.

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 53-11-15.

NOTE: Doors with external doublers at the upper forward corner refer to DTR 53-40-22-22 for area covered by the doubler.

SUBTASK 53-05-02-410-083

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

**Number      Name/Location**

832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

**Number      Name/Location**

842	Emergency Exit
843	Emergency Exit

————— END OF TASK ————

**TASK 53-05-02-250-875**

**92. INTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT - DOOR CUTOUT CORNERS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

**Zone      Area**

231	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Right

EFFECTIVITY
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

B. Access Panels

Number	Name/Location
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

C. Inspection

SUBTASK 53-05-02-010-087

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

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Open this access panel on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

NOTE: Emergency Exit door must be open to perform this inspection. Remove or displace passenger cabin sidewall lining if/as required to perform this inspection.

SUBTASK 53-05-02-250-075

- (2) Do a High Frequency Eddy Current inspection of the inner doubler between the seal retainer and the frames and sills, on the upper edge, at stringer S-11 ( from STA 578 to STA 601 and from STA 616 to STA 639).

See Doc. D626A001-DTR, DTR check form 53-40-22-6 for alternative inspections.

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 53-11-15.

NOTE: Doors with external doublers at the upper forward corner refer to DTR 53-40-22-22 for area covered by the doubler.

SUBTASK 53-05-02-410-085

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

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

———— END OF TASK ————

**TASK 53-05-02-130-805**

**93. INTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT**

NOTE: This procedure is a scheduled maintenance task.



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**A. Location Zones**

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

**B. Access Panels**

Number	Name/Location
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

**C. Inspection**

SUBTASK 53-05-02-010-005

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

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Open these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

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

SUBTASK 53-05-02-130-005

- (2) Do an Ultrasonic inspection of the edge frames outer chord under the stop backup fittings at stringers S-11 and S-12.

See Doc. D626A001-DTR, DTR check form 53-40-22-7 for alternative inspections.

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 53-10-10.

SUBTASK 53-05-02-410-003

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

Number	Name/Location
832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

Number	Name/Location
842	Emergency Exit
843	Emergency Exit

———— END OF TASK ————

**TASK 53-05-02-250-878**

**94. INTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT**

NOTE: This procedure is a scheduled maintenance task.

EFFECTIVITY
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**A. Location Zones**

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

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

**C. Inspection**

SUBTASK 53-05-02-010-089

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

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
842	Emergency Exit
843	Emergency Exit

NOTE: Emergency Exit door must be open to perform the inspection.

SUBTASK 53-05-02-250-078

- (2) Do a High Frequency Eddy Current inspection on the edges of the cutout doublers at all four lower corners (intersection of lower sill and edge frames) from stringer S-14 at STA 578 to S-14 at STA 601 and from S-14 at STA 616 to S-14 at STA 639.

See Doc. D626A001-DTR, DTR check form 53-40-22-9 for alternative inspections.

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 53-11-15.

NOTE: Doors with external doublers at the lower door corner refer to DTR 53-40-22-22 for area covered by the doubler.

SUBTASK 53-05-02-410-087

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

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
842	Emergency Exit
843	Emergency Exit

———— END OF TASK ————



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-880**

**95. EXTERNAL - SPECIAL DETAILED: OVERWING EMERGENCY EXIT CUTOUT SKIN ASSY AND FRAME OUTER CHORD**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

**C. Inspection**

SUBTASK 53-05-02-010-091

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

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
842	Emergency Exit
843	Emergency Exit

SUBTASK 53-05-02-250-080

- (2) Do a Low Frequency Eddy Current inspection of the doublers around the fasteners common to the edge frame at STA 578 (from stringers S-13 to S-15) and at STAs 601, 616 and 639 (from stringers S-10 to S-15).

See Doc. D626A001-DTR, DTR check form 53-40-22-11 for alternative inspections.

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 53-11-16.

NOTE: Doors with external doublers at the lower door corners refer to DTR 53-40-22-22 for area covered by doubler.

SUBTASK 53-05-02-410-089

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

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
842	Emergency Exit
843	Emergency Exit

EFFECTIVITY
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

———— END OF TASK ————

**TASK 53-05-02-210-803**

**96. INTERNAL - GENERAL VISUAL: OVERWING EMERGENCY EXIT CUTOUT**

Figure 243Figure 244Figure 245

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

**C. Inspection**

SUBTASK 53-05-02-010-010

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

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
842	Emergency Exit
843	Emergency Exit

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

SUBTASK 53-05-02-210-003

- (2) Do a General Visual inspection on the width and thickness of the lower sill inner splice strap and around the five fasteners at STAs 578, 601, 616 and 639.

NOTE: Fastener location is three FWD and two AFT at STAs 578/616 and two FWD and three AFT at STAs 601/639.

See Doc. D626A001-DTR, DTR check form 53-40-22-13 for alternative inspections.

SUBTASK 53-05-02-410-008

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

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
842	Emergency Exit
843	Emergency Exit

———— EFFECTIVITY ————  
**LOM ALL**

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

———— END OF TASK ————

———— EFFECTIVITY ————  
**LOM ALL**

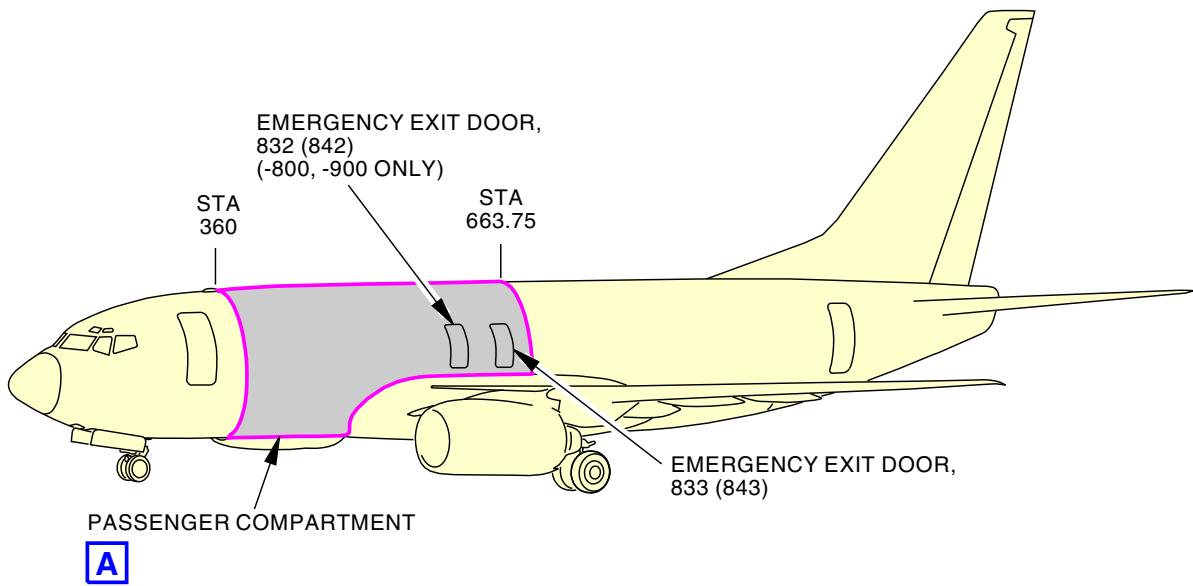
**53-05-02**

Page 298.26  
Jun 15/2024

D633A101-LOM



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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**Overwing Emergency Exit Cutout**  
**Figure 243/53-05-02-990-807**

EFFECTIVITY  
LOM ALL

**53-05-02**

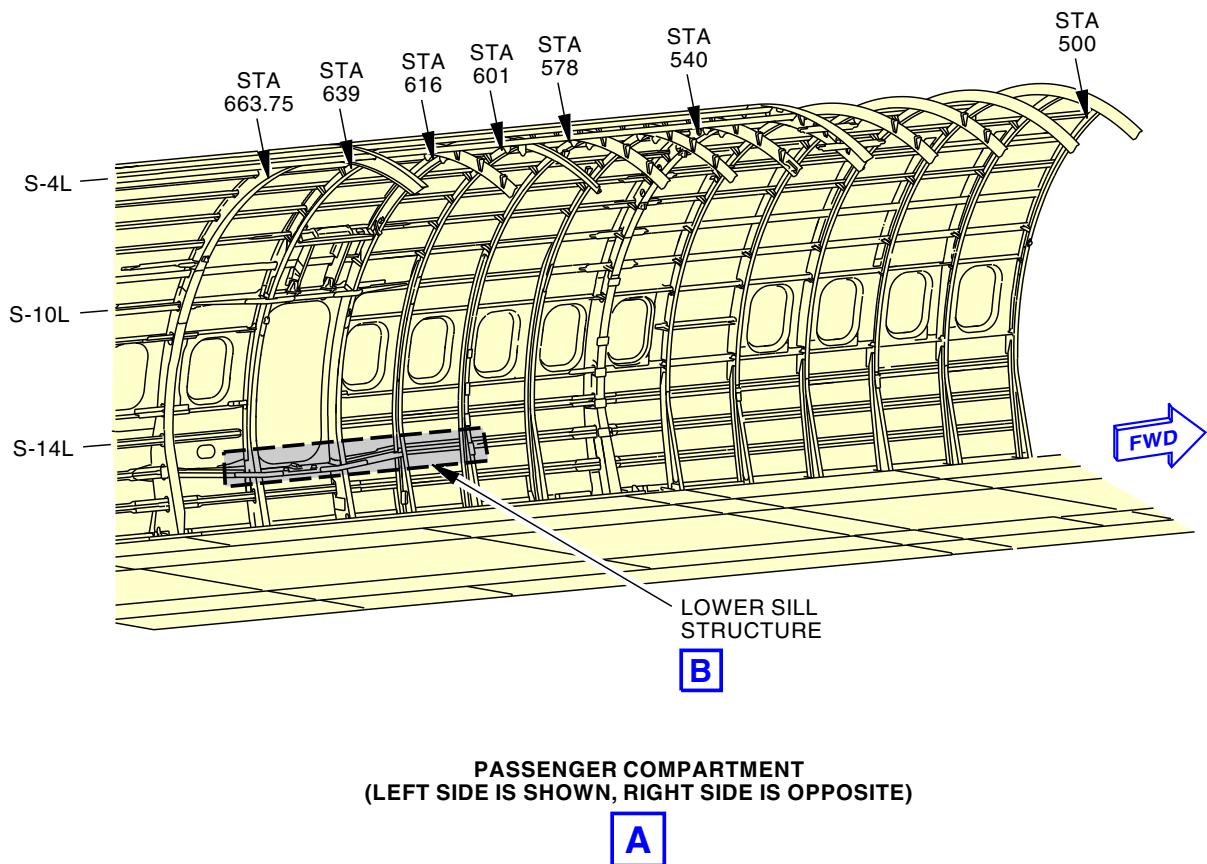
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Page 298.27  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT  
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

A

3026795 S0000797756\_V1

Overwing Emergency Exit Cutout  
Figure 244/53-05-02-990-808

EFFECTIVITY  
LOM ALL

**53-05-02**

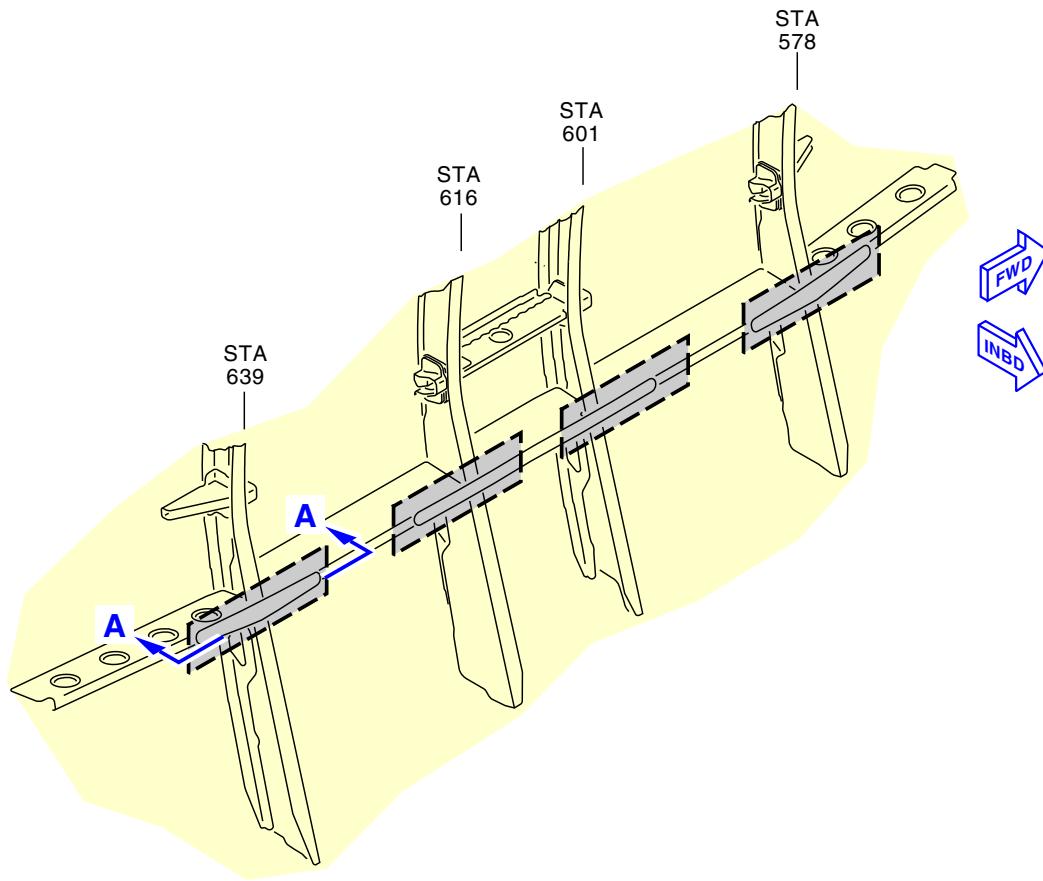
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.28  
Jun 15/2024

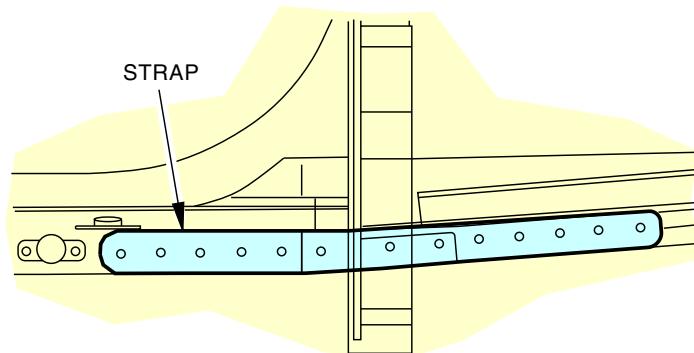


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LOWER SILL STRUCTURE  
(LEFT SIDE IS SHOWN, RIGHT SIDE IS EQUIVALENT)

B



INNER SPICE STRAP  
(TYPICAL)

A-A

3026793 S0000797757\_V1

Overwing Emergency Exit Cutout  
Figure 245/53-05-02-990-809

EFFECTIVITY  
LOM ALL

**53-05-02**

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Page 298.29  
Jun 15/2024



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**TASK 53-05-02-211-835**

**97. INTERNAL - DETAILED: OVERWING EMERGENCY EXIT DOOR STOPS AND FITTINGS**

Figure 246Figure 247Figure 248

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

**C. Inspection**

SUBTASK 53-05-02-010-021

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

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
842	Emergency Exit
843	Emergency Exit

NOTE: Emergency Exit Door must be open to perform the inspection.

SUBTASK 53-05-02-211-035

- (2) Do a Detailed inspection of the door stops attached to the forward and aft edge frames, six fittings per door.

See Doc. D626A001-DTR, DTR check form 53-40-23-1 for alternative inspections.

SUBTASK 53-05-02-410-019

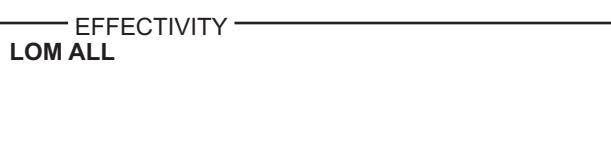
- (3) Close these access panels on the Left side:

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
842	Emergency Exit
843	Emergency Exit

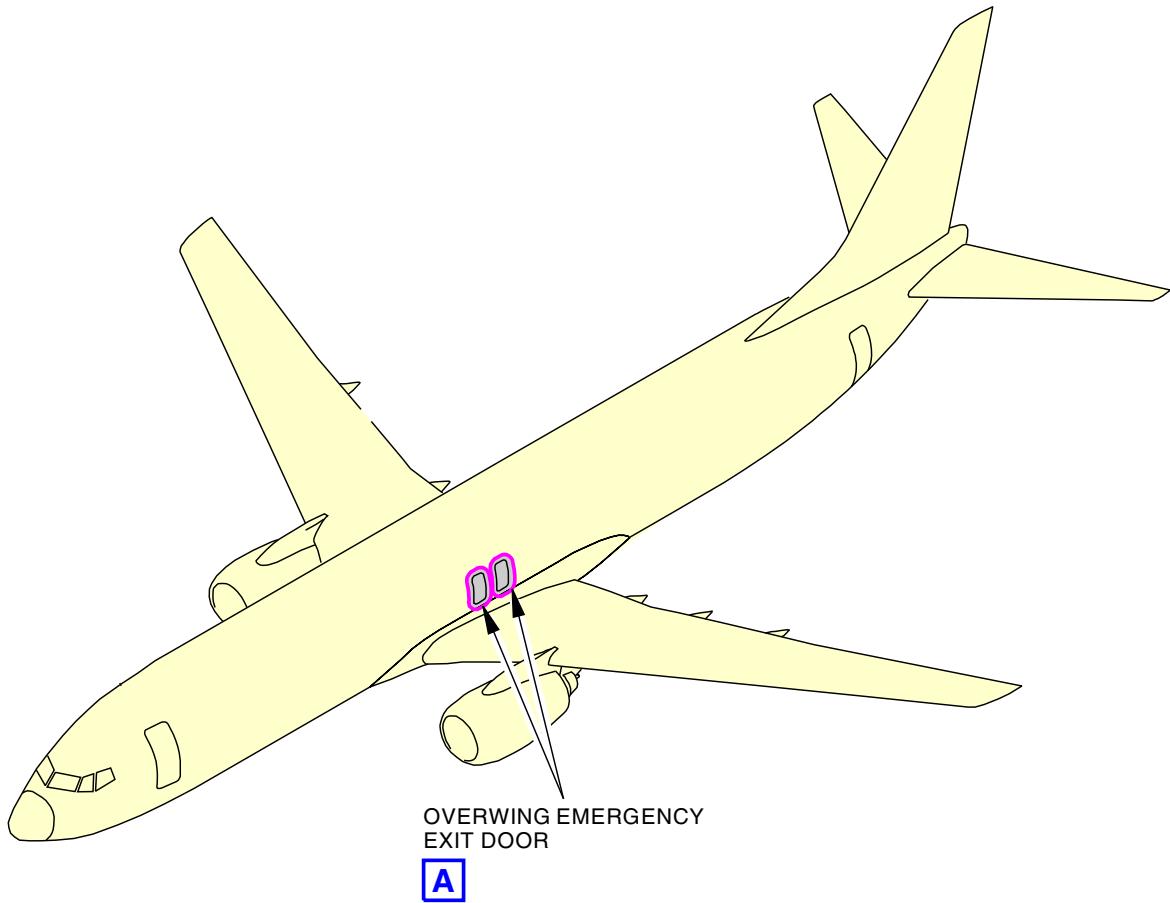
———— END OF TASK ————



**53-05-02**



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3026379 S0000797759\_V1

**Overwing Emergency Exit Door Stops and Fittings**  
**Figure 246/53-05-02-990-810**

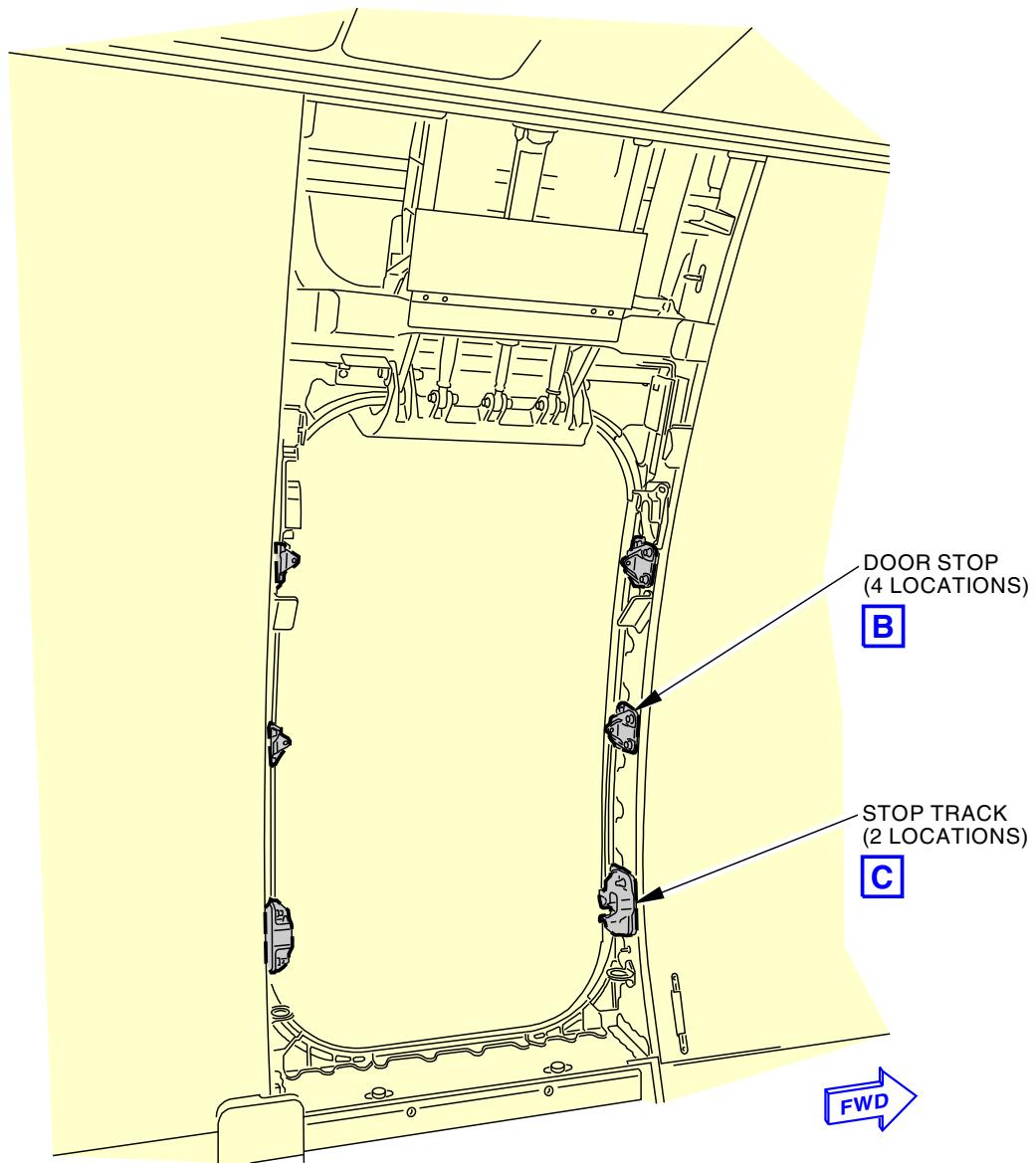
EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.31  
Jun 15/2024



LEFT OVERWING EMERGENCY EXIT CUTOUT STRUCTURE  
(LEFT SIDE IS SHOWN, RIGHT SIDE IS EQUIVALENT)  
(EXAMPLE)

**A**

3026382 S0000797760\_V1

**Overwing Emergency Exit Door Stops and Fittings**  
**Figure 247/53-05-02-990-811**

EFFECTIVITY  
LOM ALL

**53-05-02**

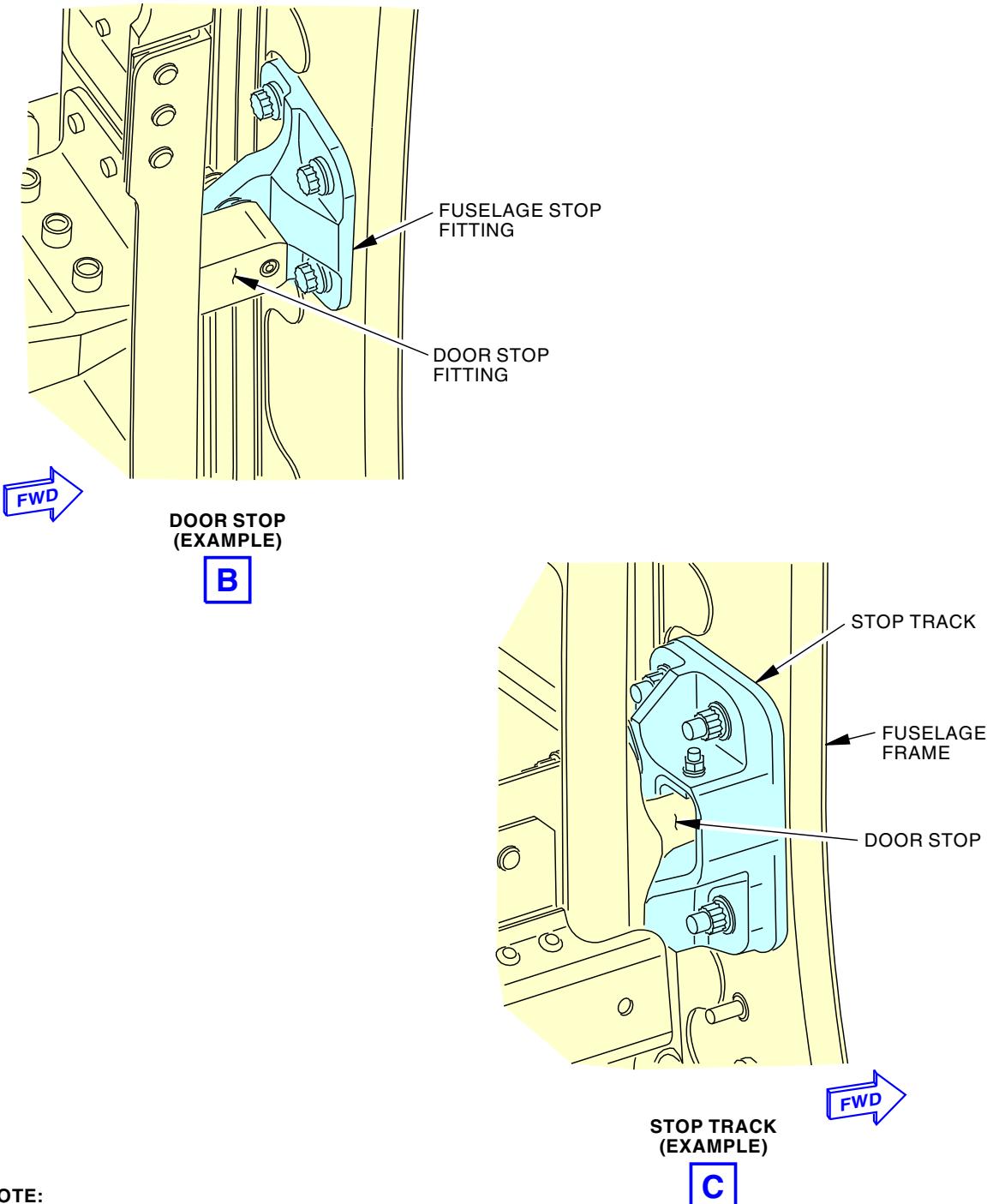
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.32  
Jun 15/2024



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**NOTE:**

LEFT SIDE IS SHOWN, RIGHT SIDE IS EQUIVALENT.

3026383 S0000797761\_V1

**Overwing Emergency Exit Door Stops and Fittings**  
**Figure 248/53-05-02-990-812**

EFFECTIVITY  
LOM ALL

**53-05-02**



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**TASK 53-05-02-211-836**

**98. INTERNAL - DETAILED: OVERWING EMERGENCY EXIT DOOR STOPS AND FITTINGS**

Figure 249Figure 250

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

**C. Inspection**

SUBTASK 53-05-02-010-022

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

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
842	Emergency Exit
843	Emergency Exit

NOTE: Emergency Exit Door must be open to perform this inspection. Removal of passenger cabin sidewall lining between Emergency Exit Doors is required to perform the inspection.

SUBTASK 53-05-02-211-036

- (2) Do a Detailed inspection of the door stop intercostals (three locations) between STA 601 to STA 616.

See Doc. D626A001-DTR, DTR check form 53-40-23-2 for alternative inspections.

SUBTASK 53-05-02-410-020

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

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
842	Emergency Exit
843	Emergency Exit

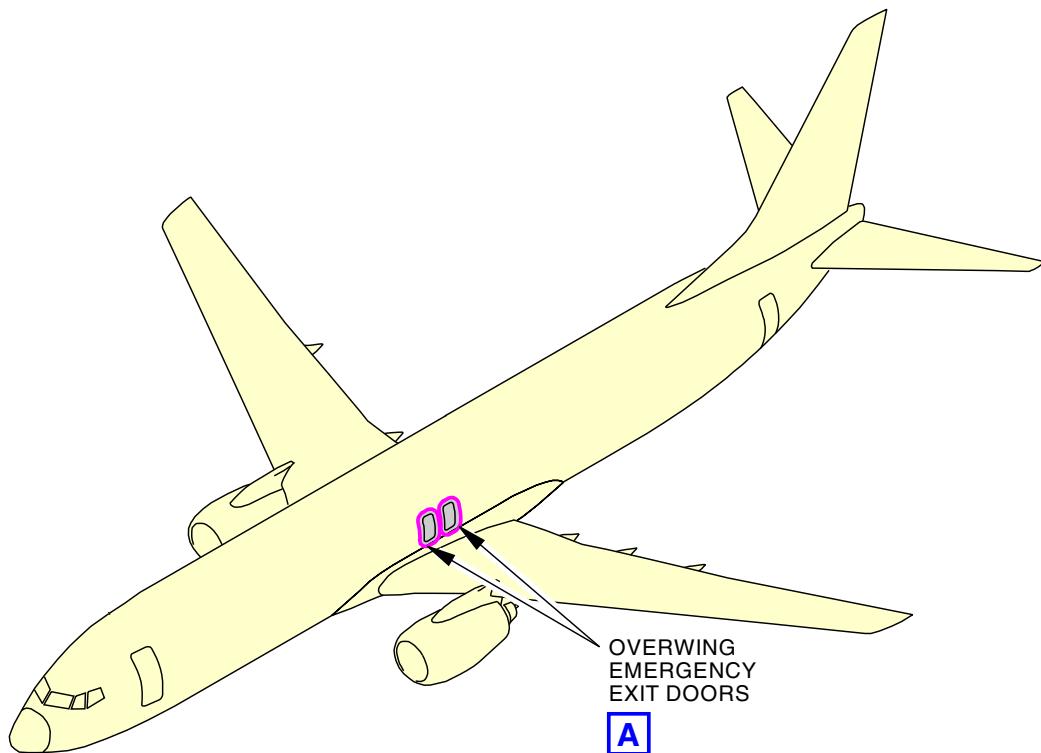
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



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3026548 S0000797768\_V1

**Overwing Emergency Exit Door Stops and Fittings**  
**Figure 249/53-05-02-990-813**

EFFECTIVITY  
LOM ALL

**53-05-02**

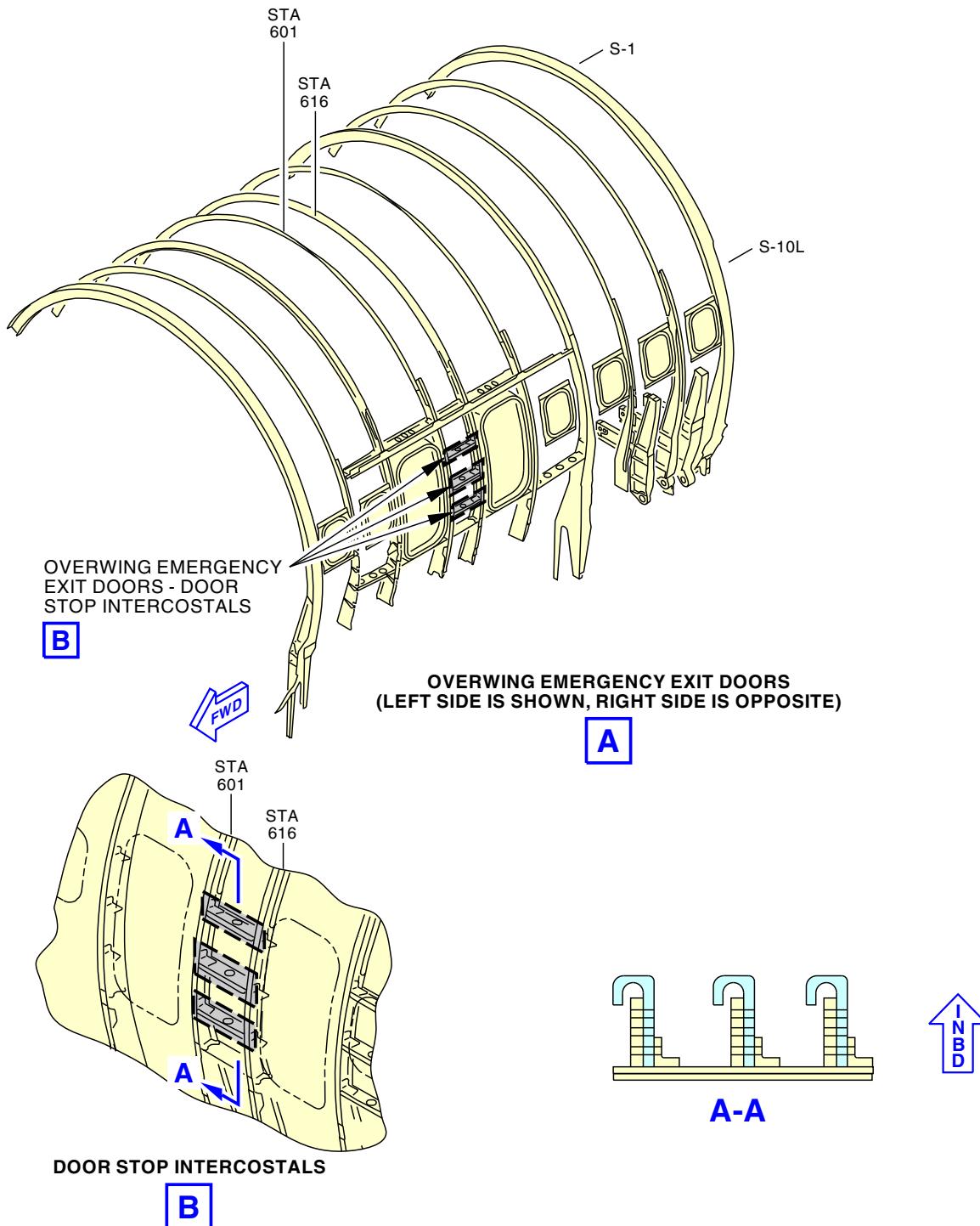
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Page 298.35  
Jun 15/2024



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3026553 S0000797770\_V1

Overwing Emergency Exit Door Stops and Fittings  
Figure 250/53-05-02-990-814



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**53-05-02**

Page 298.36  
Jun 15/2024



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**TASK 53-05-02-250-884**

**99. INTERNAL - SPECIAL DETAILED: OVERWING EXIT DOOR STOPS AND FITTINGS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

**C. Inspection**

SUBTASK 53-05-02-010-095

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

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
842	Emergency Exit
843	Emergency Exit

NOTE: Removal of passenger cabin sidewall lining between Emergency Exit Doors is required to perform the inspection.

SUBTASK 53-05-02-250-084

- (2) Do a High Frequency Eddy Current inspection of the window frame edge inboard of the fasteners common to the door stop backup fitting attachment at stringers S-11 and S-12.

See Doc. D626A001-DTR, DTR check form 53-40-23-3 for alternative inspections.

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 53-11-24.

SUBTASK 53-05-02-410-093

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

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit

Close these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
842	Emergency Exit
843	Emergency Exit

EFFECTIVITY  
LOM ALL

**53-05-02**



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———— END OF TASK ——

**TASK 53-05-02-211-837**

**100. INTERNAL - DETAILED: CROWN SKIN PANEL STA 727 TO 887**

Figure 251

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

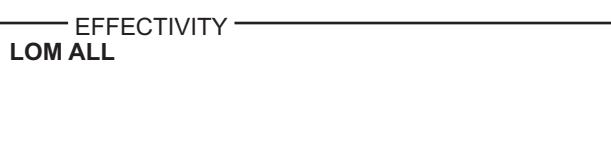
NOTE: Removal of ADT Antenna, fairing and base plate as required to expose the skin to perform the inspection.

SUBTASK 53-05-02-211-037

- (1) Do a Detailed inspection of the crown skin panel at the ADF Antenna cutout (STA 727+9, RBL 5) and the SATCOM Antenna cutout (STA 747 to Sta 787, centered on S-1 or between S-1 and S-2L).

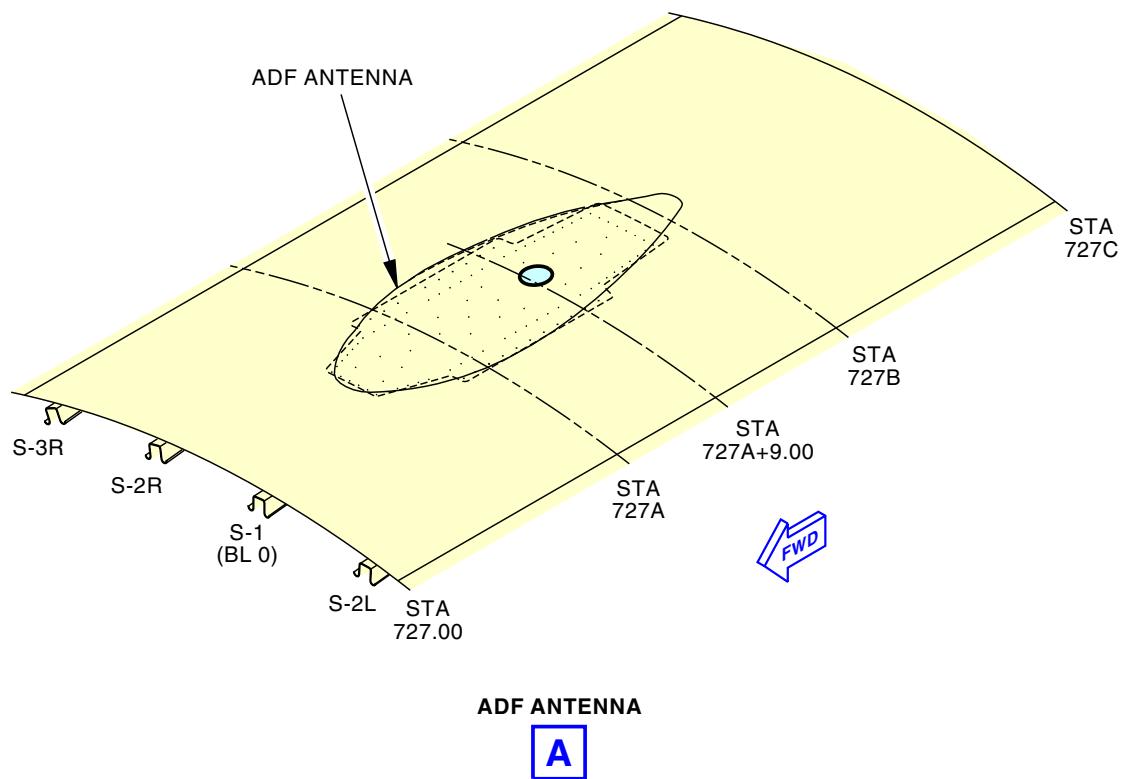
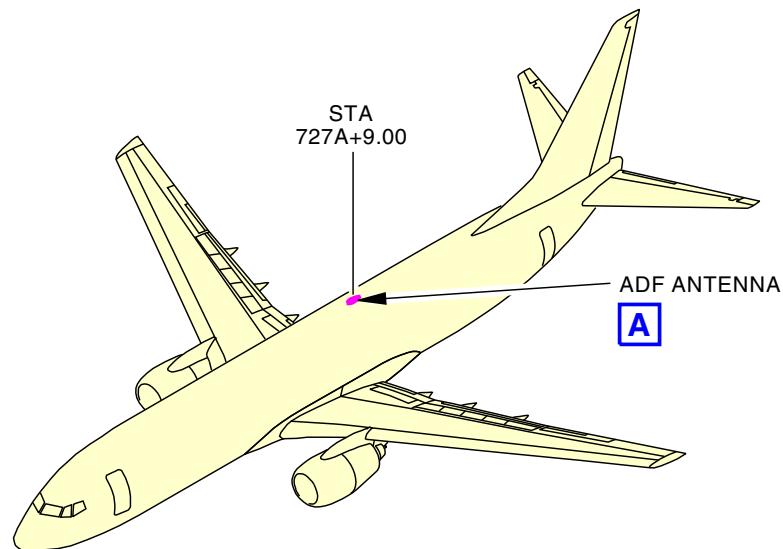
See Doc. D626A001-DTR, DTR check form 53-60-01-4 for alternative inspections.

———— END OF TASK ——





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3032368 S0000797164\_V1

**ADF Antenna STA 727A+9.0**  
**Figure 251/53-05-02-990-817**

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

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Page 298.39  
Jun 15/2024



**737-600/700/800/900**  
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**LOM 404, 411, 412, 415, 416, 420, 422-434, 437-447, 450-457, 461-999**

**TASK 53-05-02-250-885**

**101. INTERNAL - SPECIAL DETAILED: SATCOM ANTENNA INSTALLATION (CANADIAN MARCONI AND HONEYWELL)**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Remove or displace passenger cabin ceiling panels and air conditioning duct as required to perform the inspection.

SUBTASK 53-05-02-250-085

- (1) Do a Low Frequency Eddy Current inspection of the skin for hidden cracks between the adaptor plate and stringers S-1 and S-2L at STA 767.

See Doc. D626A001-DTR, DTR check form 53-60-01-5 for alternative inspections.

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 53-30-54.

———— END OF TASK ————

**TASK 53-05-02-211-838**

**102. INTERNAL - DETAILED: SATCOM ANTENNA INSTALLATION (CANADIAN MARCONI AND HONEYWELL)**

Figure 252

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Remove or displace passenger cabin ceiling panels and air conditioning duct as required to perform the inspection.

SUBTASK 53-05-02-211-038

- (1) Do a Detailed inspection of the skin under the antenna adaptor plate from stringers S-1 to S-2L at STA 767.

See Doc. D626A001-DTR, DTR check form 53-60-01-5 for alternative inspections.

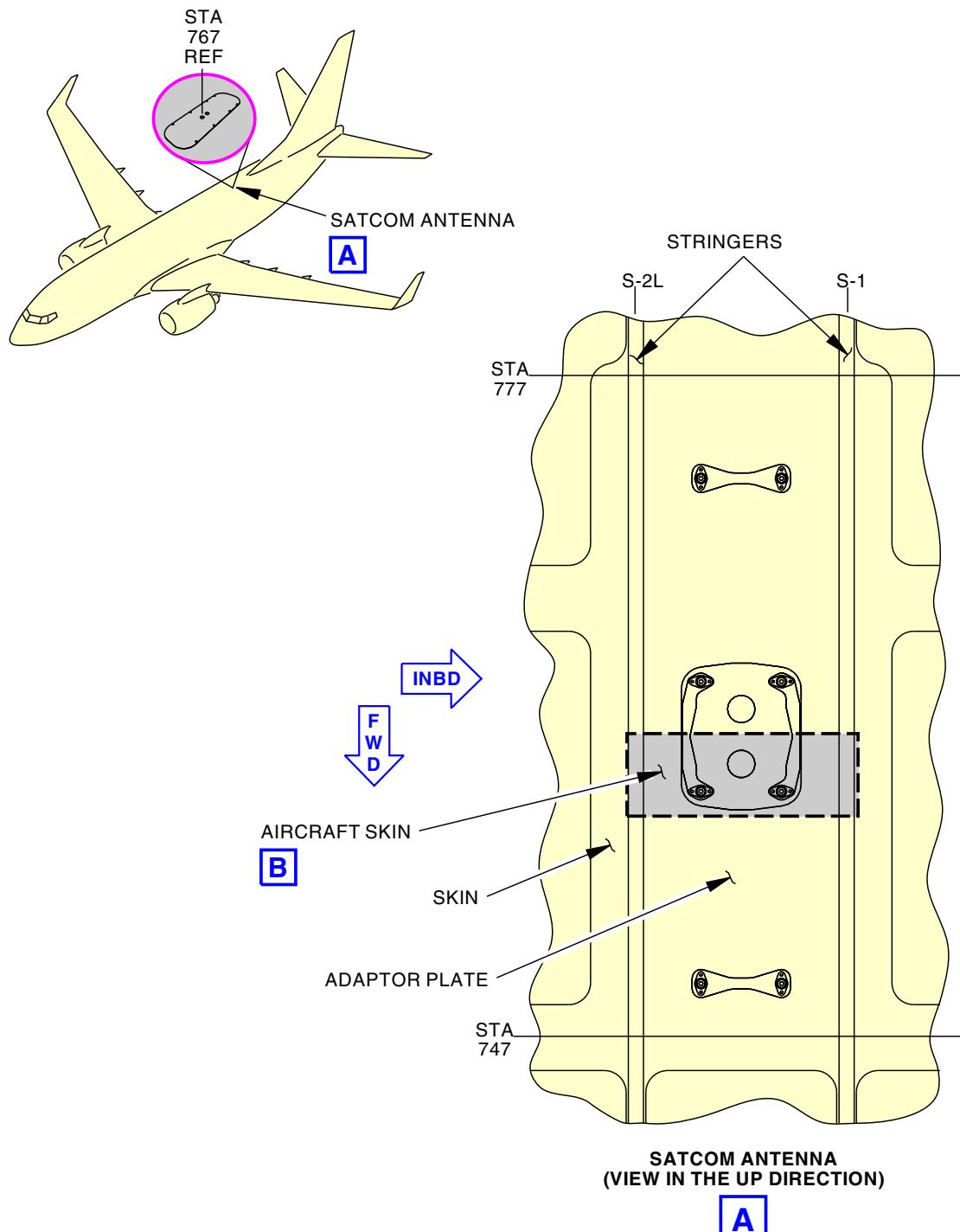
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



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3026629 S0000797830\_V1

STA 767 SATCOM Antenna  
Figure 252/53-05-02-990-819 (Sheet 1 of 2)

EFFECTIVITY  
LOM 404, 411, 412, 415, 416, 420, 422-434, 437-447,  
450-457, 461-999

**53-05-02**

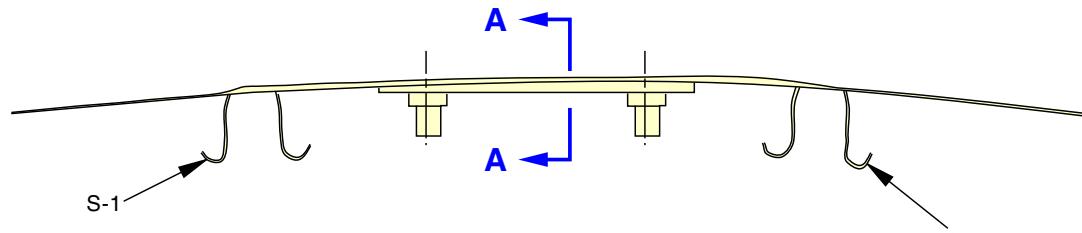
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

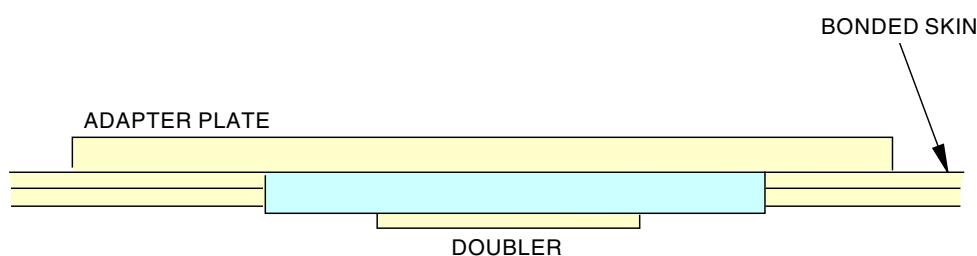
Page 298.41  
Oct 15/2024



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AIRCRAFT SKIN



**A-A**

3026630 S0000797831\_V1

STA 767 SATCOM Antenna  
Figure 252/53-05-02-990-819 (Sheet 2 of 2)

EFFECTIVITY  
LOM 404, 411, 412, 415, 416, 420, 422-434, 437-447,  
450-457, 461-999

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.42  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

LOM 404, 411, 412, 415, 416, 420, 422-434, 437-447, 450-457, 461-999 (Continued)

**TASK 53-05-02-250-886**

**103. INTERNAL - SPECIAL DETAILED: SATCOM ANTENNA INSTALLATION (ALL EXCEPT THOSE COVERED BY PSE 53-60-01-5)**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Remove or displace passenger cabin ceiling panels and air conditioning duct as required to perform the inspection

SUBTASK 53-05-02-250-086

- (1) Do a Low Frequency Eddy Current inspection of the skin for hidden cracks between the adaptor plate and stringers S-1 and S-2L at STA 747 to STA 787.

See Doc. D626A001-DTR, DTR check form 53-60-01-6 for alternative inspections.

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 53-30-53.

———— END OF TASK ————

**TASK 53-05-02-211-839**

**104. INTERNAL - DETAILED: SATCOM ANTENNA INSTALLATION (ALL EXCEPT THOSE COVERED BY PSE 53-60-01-5)**

Figure 253

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Remove or displace passenger cabin ceiling panels and air conditioning duct as required to perform the inspection.

SUBTASK 53-05-02-211-039

- (1) Do a Detailed inspection of the skin under the antenna adaptor plate from stringers S-1 to S-2L at STA 747 to STA 787.

See Doc. D626A001-DTR, DTR check form 53-60-01-6 for alternative inspections.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

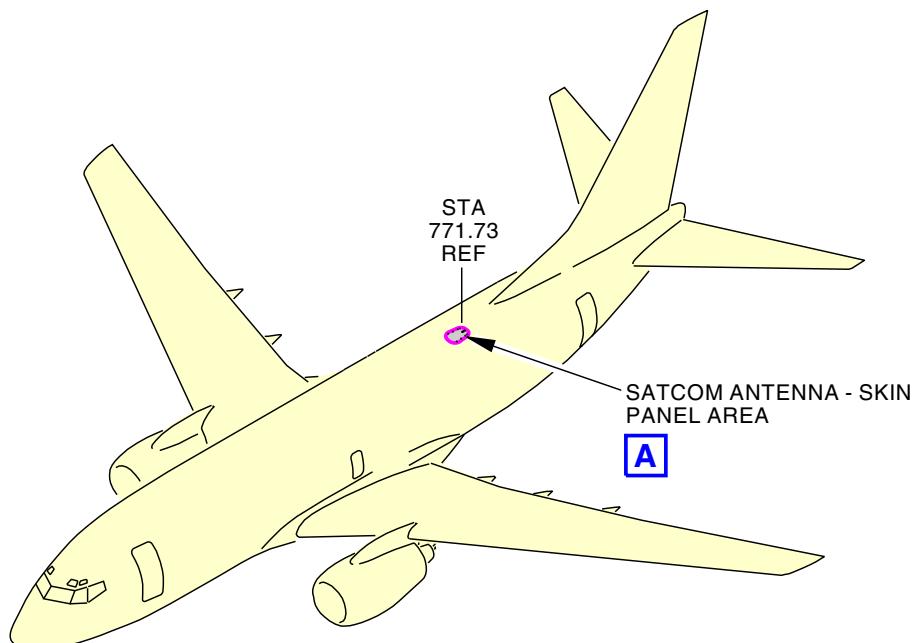
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.43  
Oct 15/2024



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3026816 S0000798224\_V1

**SATCOM Antenna**  
**Figure 253/53-05-02-990-820 (Sheet 1 of 2)**

EFFECTIVITY  
LOM ALL

**53-05-02**

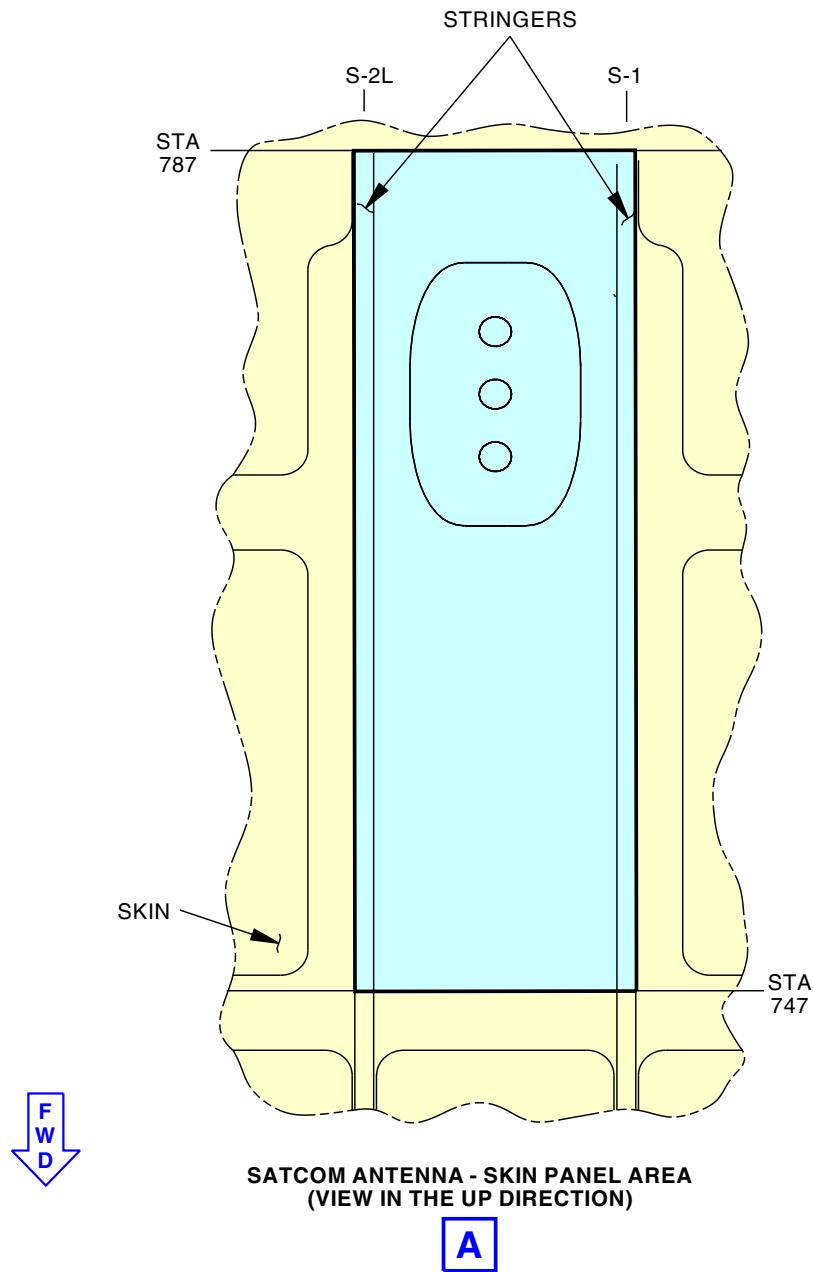
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Page 298.44  
Jun 15/2024



737-600/700/800/900  
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3026814 S0000798230\_V1

SATCOM Antenna  
Figure 253/53-05-02-990-820 (Sheet 2 of 2)

EFFECTIVITY  
LOM 404, 411, 412, 415, 416, 420, 422-434, 437-447,  
450-457, 461-999

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.45  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

LOM ALL

**TASK 53-05-02-250-887**

**105. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

**B. Inspection**

SUBTASK 53-05-02-250-087

- (1) Do a Low Frequency Eddy Current inspection of the upper (inner) skin along the upper fastener row at stringers S-23L and S-23R from STA 727 to STA 887, except at the cargo door cutout.

See Doc. D626A001-DTR, DTR check form 53-60-04-7, for alternative inspections.

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 53-30-50.

———— END OF TASK ————

**TASK 53-05-02-211-840**

**106. INTERNAL - DETAILED: WINDOW BELT STA 727 TO STA 888**

Figure 254

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

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

SUBTASK 53-05-02-211-040

- (1) Do a Detailed inspection of the window frames around each window from STA 727 to STA 888.

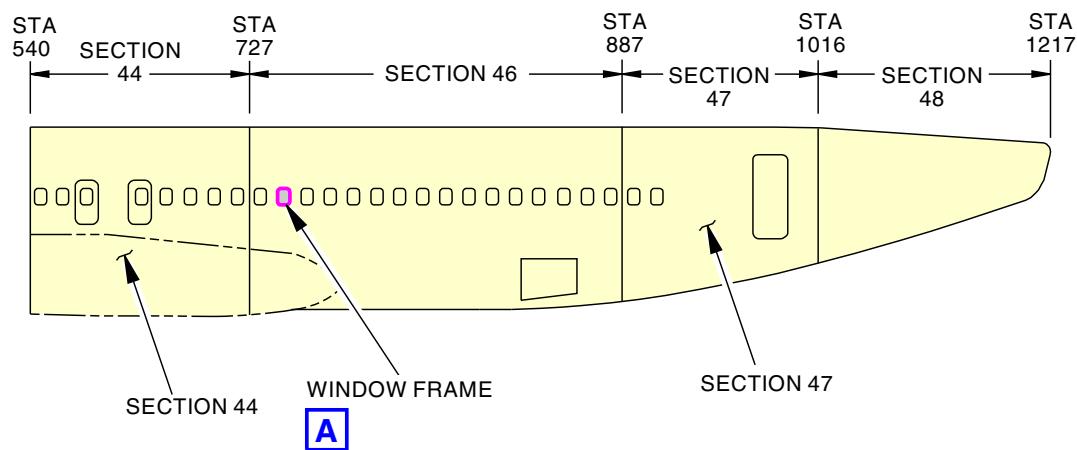
See Doc D626A001-DTR, DTR check form 53-60-05-2 for alternative inspections.

———— END OF TASK ————





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(LEFT SIDE IS SHOWN, RIGHT SIDE IS EQUIVALENT)

3026858 S0000798259\_V1

Window Belt STA 727 to STA 888  
Figure 254/53-05-02-990-821 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

D633A101-LOM

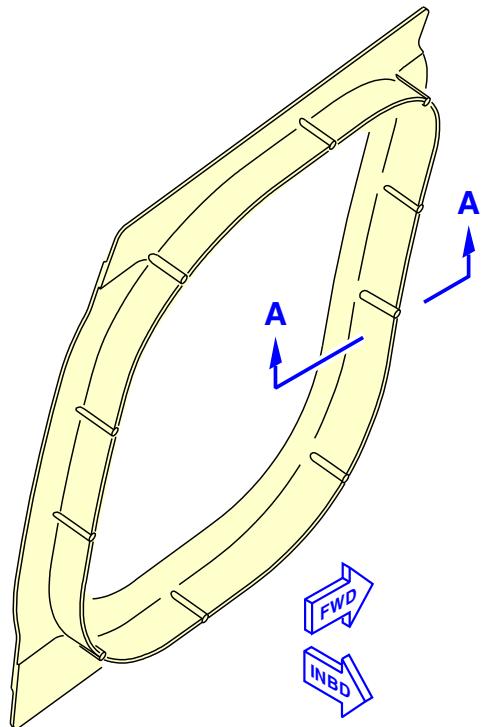
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-02**

Page 298.47  
Jun 15/2024

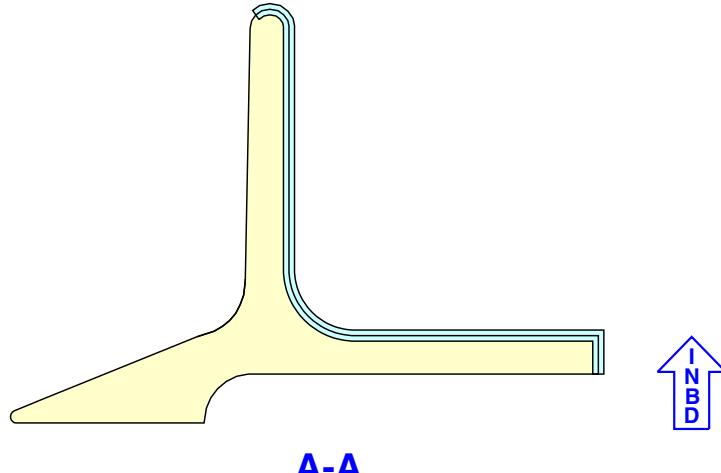


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WINDOW FRAME  
(TYPICAL)

A



Window Belt STA 727 to STA 888  
Figure 254/53-05-02-990-821 (Sheet 2 of 2)

3026861 S0000798260\_V1

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

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Page 298.48  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-841**

**107. EXTERNAL - DETAILED: WINDOW BELT STA 727 TO STA 888**

Figure 255

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-041

- (1) Do a Detailed inspection of the window frames around each window from STA 727 to STA 888.  
See Doc D626A001-DTR, DTR check form 53-60-05-2 for alternative inspections.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**

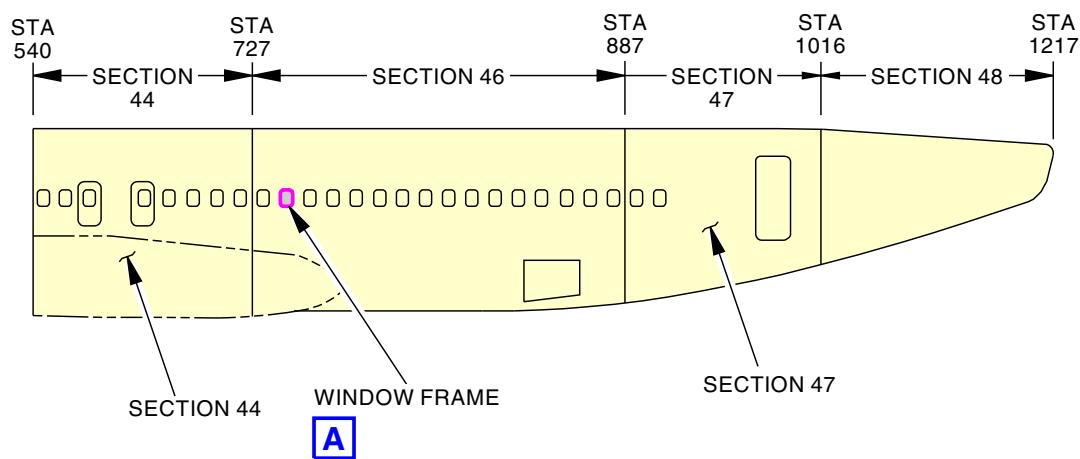
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.49  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



(LEFT SIDE IS SHOWN, RIGHT SIDE IS EQUIVALENT)

3028476 S0000799491\_V1

Window Belt STA 727 to STA 888  
Figure 255/53-05-02-990-822 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

**53-05-02**

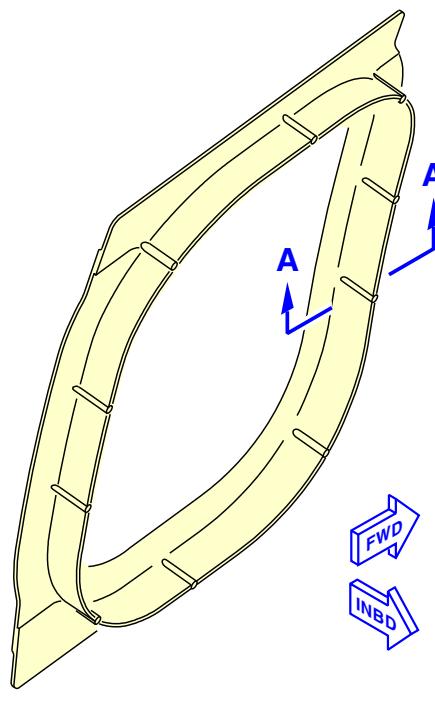
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.50  
Jun 15/2024

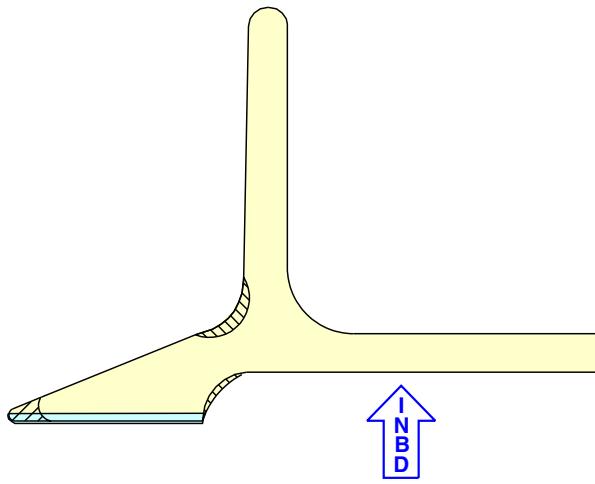


737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



WINDOW FRAME  
(TYPICAL)

A



A-A

3028479 S0000799492\_V1

Window Belt STA 727 to STA 888  
Figure 255/53-05-02-990-822 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.51  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-888**

**108. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
142	Aft Cargo Compartment - Right

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-096

- (1) Open this access panel:

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

NOTE: Cargo Door must be open to perform the inspection. Remove the shield panels between S-24R and S-26R as required. Remove sealer at door stops as required.

SUBTASK 53-05-02-250-088

- (2) Do a High Frequency Eddy Current inspection of the frame inner chord between the web and failsafe strap from stringers S-18R to S-26R at the forward and aft edge frame.

See Doc D626A001-DTR, DTR check form 53-60-08-1 for alternative inspections.

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 53-10-88.

SUBTASK 53-05-02-410-094

- (3) Close this access panel:

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

— END OF TASK —

**TASK 53-05-02-250-889**

**109. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
142	Aft Cargo Compartment - Right

**B. Access Panels**

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



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

C. Inspection

SUBTASK 53-05-02-010-097

- (1) Open this access panel:

Number    Name/Location

822           Aft Cargo Door

NOTE: Cargo Door must be open to perform the inspection. Remove or displace aft cargo sidewall and ceiling lining as required to perform the inspection.

SUBTASK 53-05-02-250-089

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

See Doc D626A001-DTR, DTR check form 53-60-08-2 for alternative inspections.

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 53-10-88.

SUBTASK 53-05-02-410-095

- (3) Close this access panel:

Number    Name/Location

822           Aft Cargo Door

————— END OF TASK ————

**TASK 53-05-02-250-890**

**110. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

B. Access Panels

Number	Name/Location
822	Aft Cargo Door

C. Inspection

SUBTASK 53-05-02-010-098

- (1) Open this access panel:

Number    Name/Location

822           Aft Cargo Door

NOTE: Remove or displace aft cargo sidewall and ceiling lining as required to perform the inspection.

SUBTASK 53-05-02-250-090

- (2) Do a High Frequency Eddy Current inspection of the forward and aft edge frame inner chords between S17 and S-19.

See Doc D626A001-DTR, DTR check form 53-60-08-3 for alternative inspections.



D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-02**

Page 298.53  
Jun 15/2024



**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, Subject 53-10-81.

SUBTASK 53-05-02-410-096

- (3) Close this access panel:

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

———— END OF TASK ————

**TASK 53-05-02-250-891**

**111. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND FORWARD AND AFT EDGE FRAMES AT BS 794.37 AND BS 847**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-099

- (1) Open this access panel:

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

NOTE: Aft cargo door must be open to perform the inspection.

SUBTASK 53-05-02-250-091

- (2) Do a High Frequency Eddy Current inspection of the outboard portion of the web on the outer chord between stringers S-16R and S-26R at STA 794.37 and STA 847 (except at door stops and sills location).

See Doc D626A001-DTR, DTR check form 53-60-08-4 for alternative inspections.

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 53-11-22.

SUBTASK 53-05-02-410-097

- (3) Close this access panel:

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

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-130-806**

**112. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND FORWARD AND AFT EDGE FRAMES AT BS 794.37 AND BS 847**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-006

- (1) Open this access panel:

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

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

SUBTASK 53-05-02-130-006

- (2) Do an Ultrasonic inspection of the outboard portion of the frame web under the door stop fittings and sill clips at STA 794.37 and STA 847.

See Doc D626A001-DTR, DTR check form 53-60-08-5 for alternative inspections.

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 53-10-08.

SUBTASK 53-05-02-410-004

- (3) Close this access panel:

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

— END OF TASK —

**TASK 53-05-02-250-892**

**113. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE**

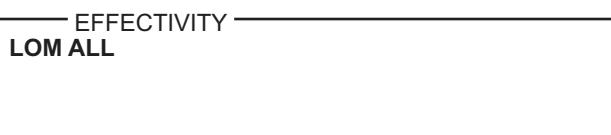
NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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



**53-05-02**



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AIRCRAFT MAINTENANCE MANUAL

C. Inspection

SUBTASK 53-05-02-010-100

- (1) Open this access panel:

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

SUBTASK 53-05-02-250-092

- (2) Do a High Frequency Eddy Current inspection of the exposed edge of the bearstrap at both the forward and aft edge of the door at STA 794.4 and STA 847 from stringers S-18R to S-25R. See Doc D626A001-DTR, DTR check form 53-60-08-8 for alternative inspections.

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 53-11-21.

SUBTASK 53-05-02-410-098

- (3) Close this access panel:

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

———— END OF TASK ————

**TASK 53-05-02-211-842**

**114. EXTERNAL - DETAILED: AFT CARGO DOOR SURROUND STRUCTURE**

Figure 256

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
142	Aft Cargo Compartment - Right

B. Access Panels

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

C. Inspection

SUBTASK 53-05-02-010-023

- (1) Open this access panel:

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

NOTE: Scuff plate removal required.

SUBTASK 53-05-02-211-042

- (2) Do a Detailed inspection of the skin at all four corners (upper/lower/FWD/AFT) of the cargo door cutout.

See Doc. D626A001-DTR, DTR check form 53-60-08-9, for alternative inspections.

SUBTASK 53-05-02-410-021

- (3) Close this access panel:

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

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

———— END OF TASK ————

———— EFFECTIVITY ————  
**LOM ALL**

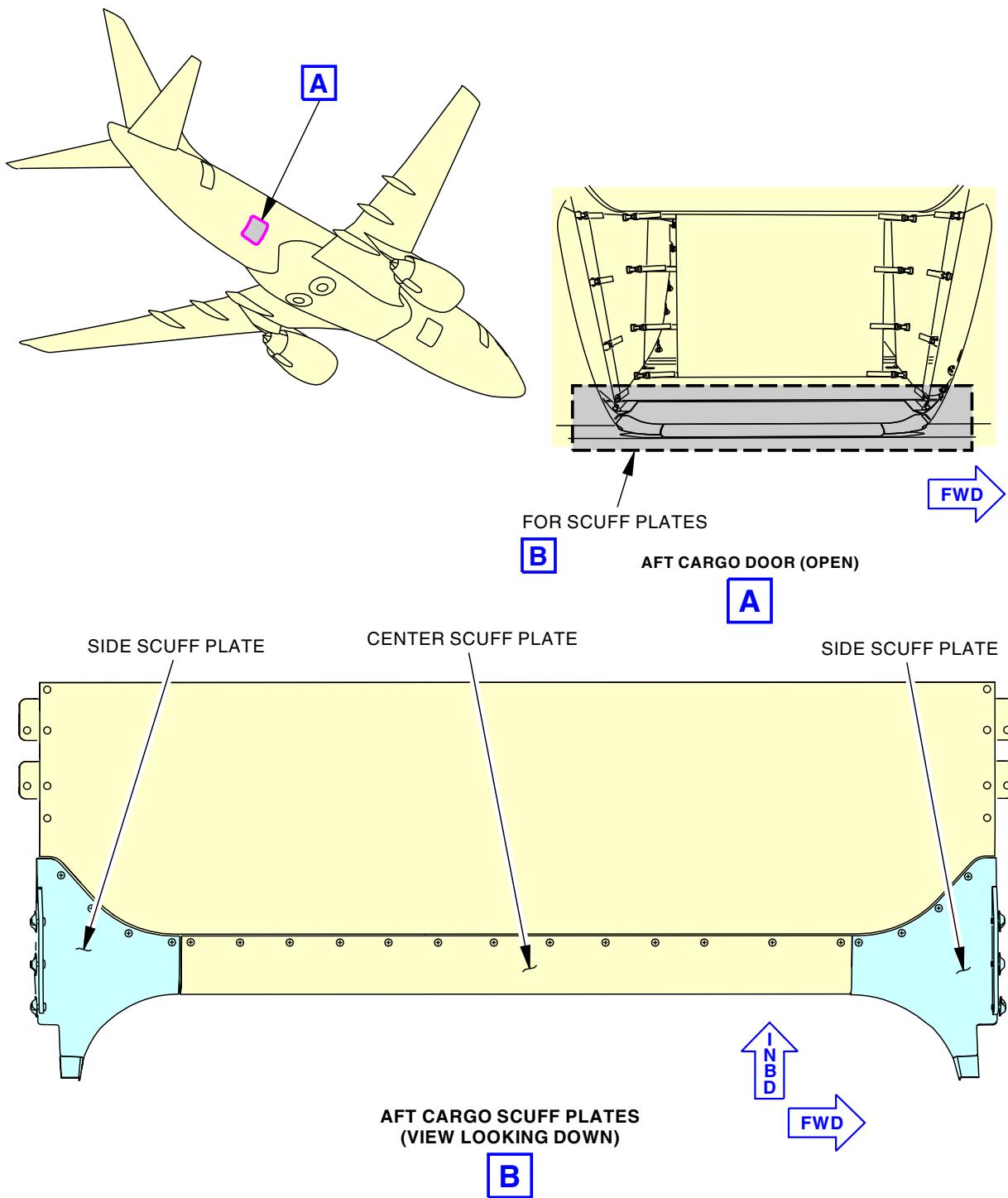
**53-05-02**

Page 298.57  
Jun 15/2024

D633A101-LOM



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AFT Cargo Door Surround Structure  
Figure 256/53-05-02-990-923

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-210-804**

**115. INTERNAL - GENERAL VISUAL: AFT CARGO DOOR SURROUND STRUCTURE**

Figure 257

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-011

- (1) Open this access panel:

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

NOTE: Corner casting removal is required.

SUBTASK 53-05-02-210-004

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

See Doc. D626A001-DTR, DTR check form 53-60-08-9, for alternative inspections.

SUBTASK 53-05-02-410-009

- (3) Close this access panel:

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

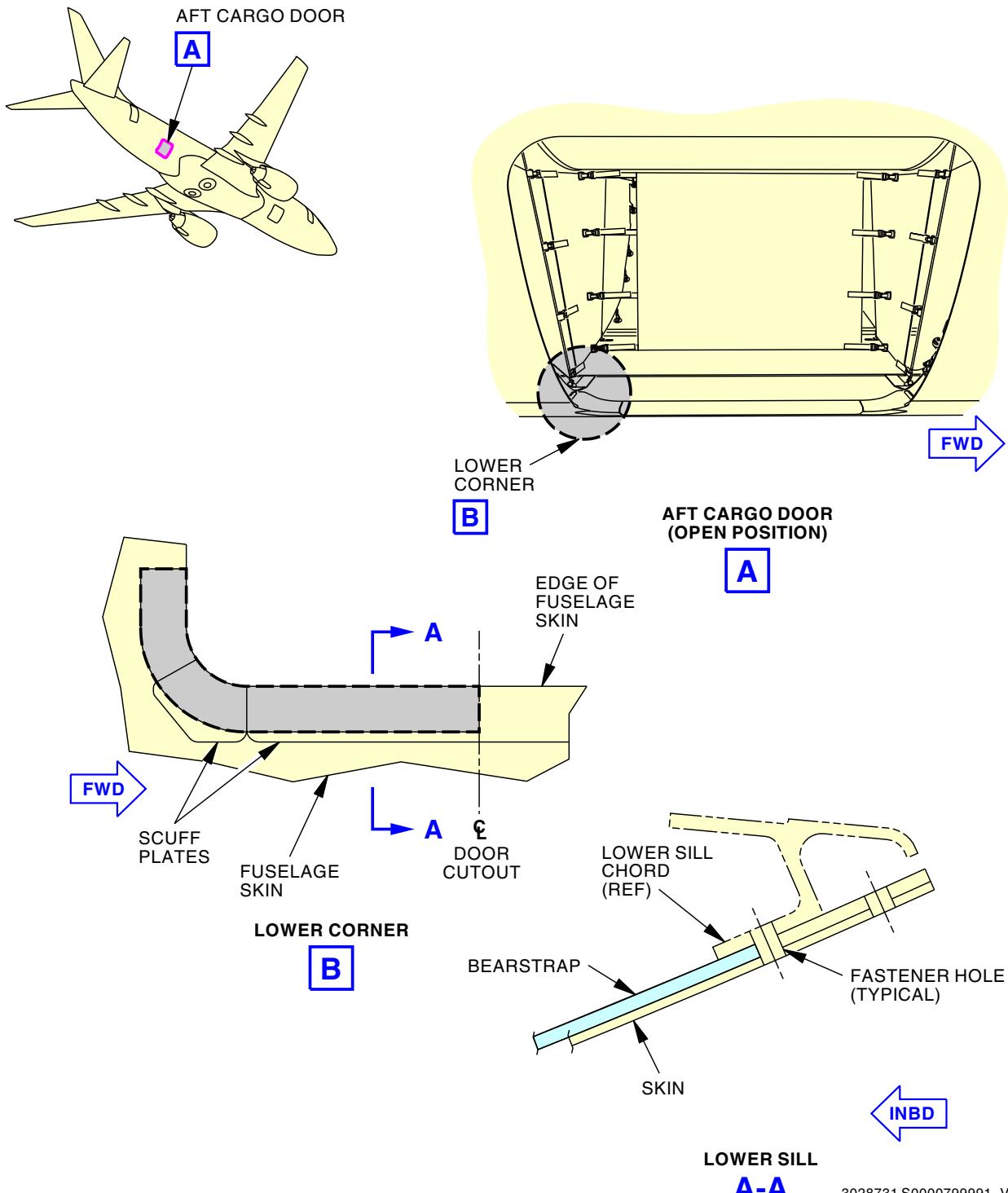
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



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AIRCRAFT MAINTENANCE MANUAL



AFT Cargo Door Surround Structure  
Figure 257/53-05-02-990-823

EFFECTIVITY  
LOM ALL

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**53-05-02**

Page 298.60  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-893**

**116. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR FITTINGS AND STOPS AT THE FORWARD AND AFT EDGE FRAMES**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
142	Aft Cargo Compartment - Right

**B. Access Panels**

Number	Name/Location
822	Aft Cargo Door

**C. Inspection**

SUBTASK 53-05-02-010-101

- (1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

NOTE: Aft cargo door must be open to perform the inspection. Remove or displace aft cargo sidewall lining as required to perform the inspection.

SUBTASK 53-05-02-250-093

- (2) Do a High Frequency Eddy Current inspection of the intercostal web for cracks adjacent to the rivet and fastener holes. Five door stops locations on both the forward and aft edge frames.

See Doc. D626A001-DTR, DTR check form 53-60-09-3, for alternative inspections.

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 53-10-82.

SUBTASK 53-05-02-410-099

- (3) Close this access panel:

Number	Name/Location
822	Aft Cargo Door

————— END OF TASK ————

**TASK 53-05-02-250-894**

**117. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

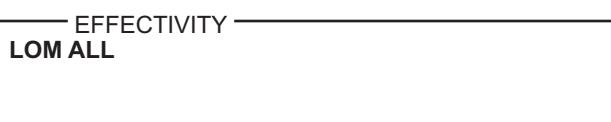
Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Inspection**

SUBTASK 53-05-02-250-094

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

See Doc. D626A001-DTR, DTR check form 53-70-03-2, for alternative inspections.



**53-05-02**



**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 53-30-50.

———— END OF TASK ——

**TASK 53-05-02-211-845**

**118. EXTERNAL - DETAILED: LONGITUDINAL LAP SPLIC**

Figure 258

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-045

- (1) Do a Detailed inspection of the upper skin along the upper fastener row at stringer S-14L (from STA 888 to STA 947, and from STA 1006 to STA 1016) and at stringer S-14R (from STA 888 to STA 947, and from STA 996 to STA 1016).

See Doc D626A001-DTR, DTR check form 53-70-03-3 for alternative inspections.

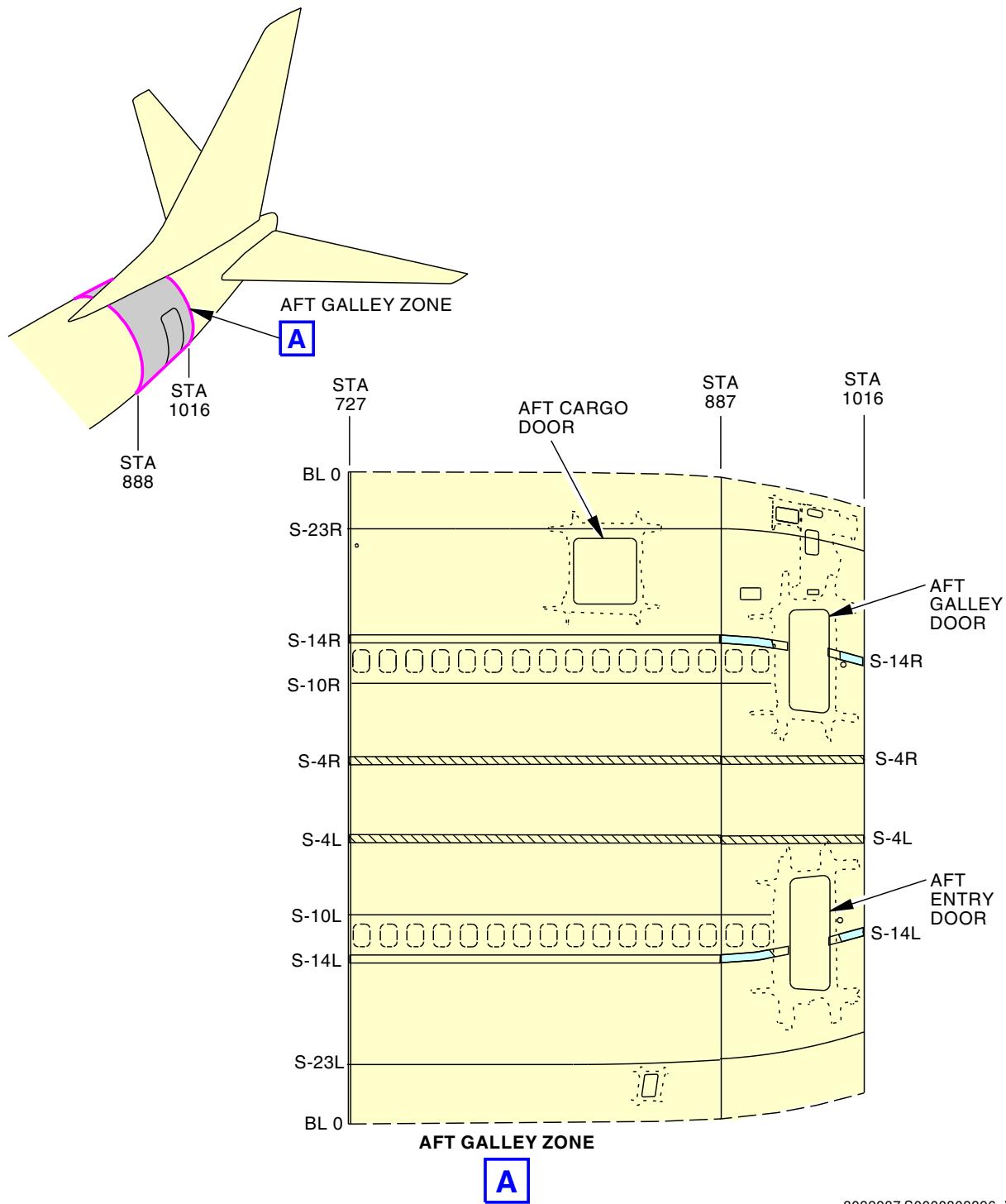
———— END OF TASK ——

———— EFFECTIVITY ——

**LOM ALL**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



Longitudinal Lap Splice  
Figure 258/53-05-02-990-824

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.63  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-895**

**119. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLIC**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-095

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringer S-14L (from STA 888 to STA 947 and from STA 1006 to STA 1016) and at stringer S-14R (from STA 888 to STA 947 and from STA 996 to STA 1016).

See Doc D626A001-DTR, DTR check form 53-70-03-4 for alternative inspections.

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 53-30-50.

———— END OF TASK ————

**TASK 53-05-02-250-896**

**120. INTERNAL - SPECIAL DETAILED: AFT ENTRY DOOR, FORWARD EDGE FRAME DOOR STOP BACKUP STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Remove or displace interior sidewall lining as required to perform the inspection.

SUBTASK 53-05-02-250-096

- (1) Do a High Frequency Eddy Current inspection of the four fastener locations at the #1, #2, #6 and #7 stop locations.

See Doc D626A001-DTR, DTR check form 53-70-07-3 for alternative inspections.

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 53-30-35.

———— END OF TASK ————

**TASK 53-05-02-250-897**

**121. INTERNAL - SPECIAL DETAILED: AFT ENTRY DOOR, AFT EDGE FRAME DOOR STOP BACKUP INTERCOSTALS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

EFFECTIVITY  
LOM ALL

**53-05-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**B. Inspection**

NOTE: Remove or displace interior sidewall and door lining as required to perform the inspection.

SUBTASK 53-05-02-250-097

- (1) Do a High Frequency Eddy Current inspection of the door stop intercostals along the inner chord and around fasteners common to the web and doublers at the #1, #2, #6 and #7 stop locations.

See Doc D626A001-DTR, DTR check form 53-70-07-4 for alternative inspections.

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 53-30-36.

———— END OF TASK ————

**TASK 53-05-02-210-842**

**122. INTERNAL - GENERAL VISUAL: AFT ENTRY DOOR, AFT EDGE FRAME DOOR STOP BACKUP  
INTERCOSTALS**

Figure 259Figure 260

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-210-042

NOTE: Remove or displace interior sidewall and door lining as required to perform the inspection.

- (1) Do a General Visual inspection of the door stop intercostals along the inner chord and around fasteners common to the web and doublers at the #1, #2, #6 and #7 stop locations.

See Doc D626A001-DTR, DTR check form 53-70-07-4 for alternative inspections.

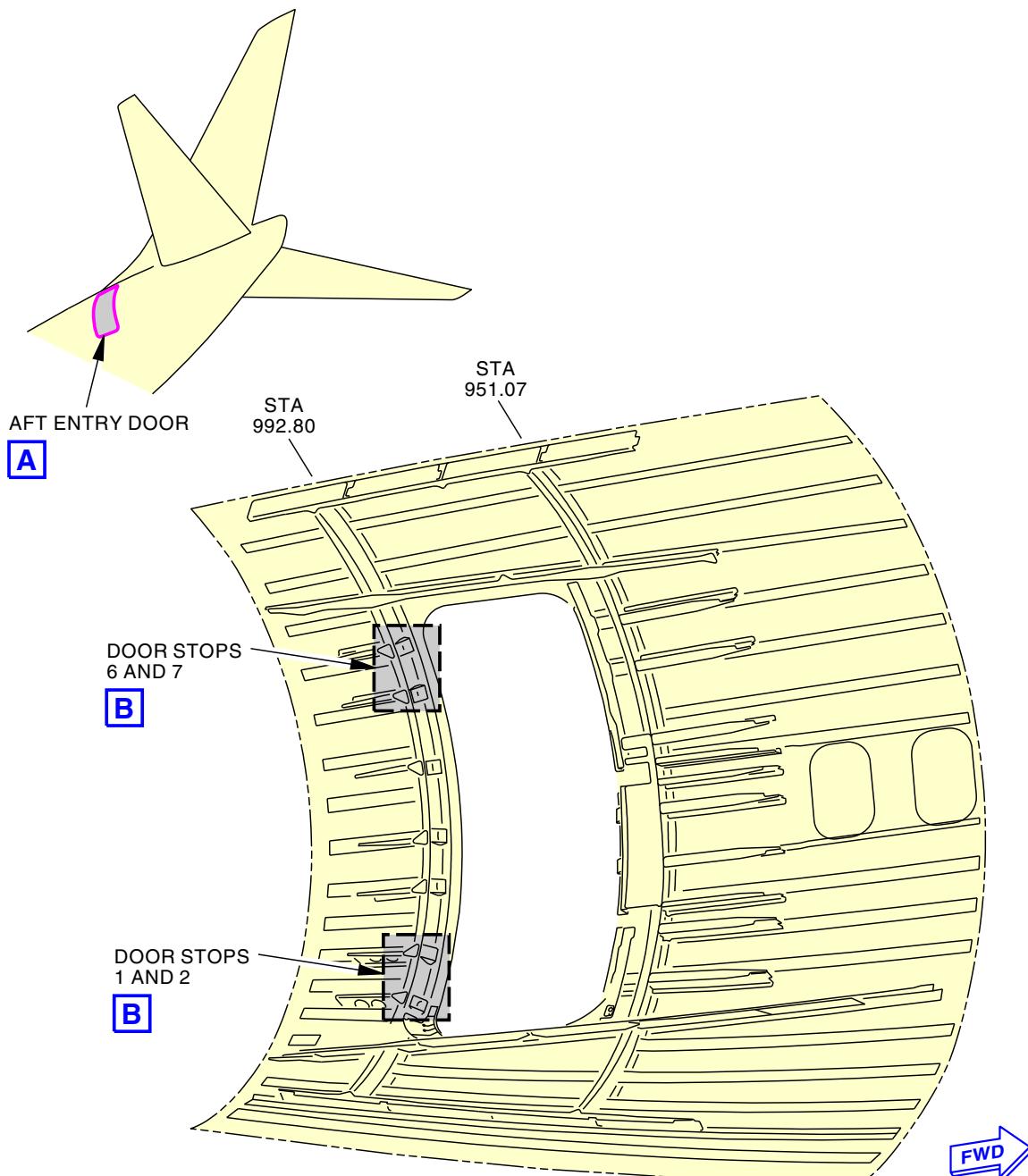
———— END OF TASK ————

———— EFFECTIVITY ————  
**LOM ALL**

**53-05-02**



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NOTE:

DOOR STOPS NUMBERED FROM  
BOTTOM TO TOP.

AFT ENTRY DOOR



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AFT Edge Frame Door Stop Backup Intercostals  
Figure 259/53-05-02-990-825



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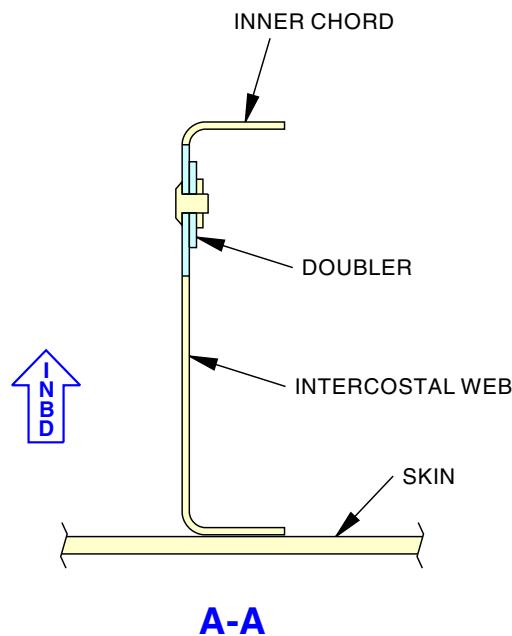
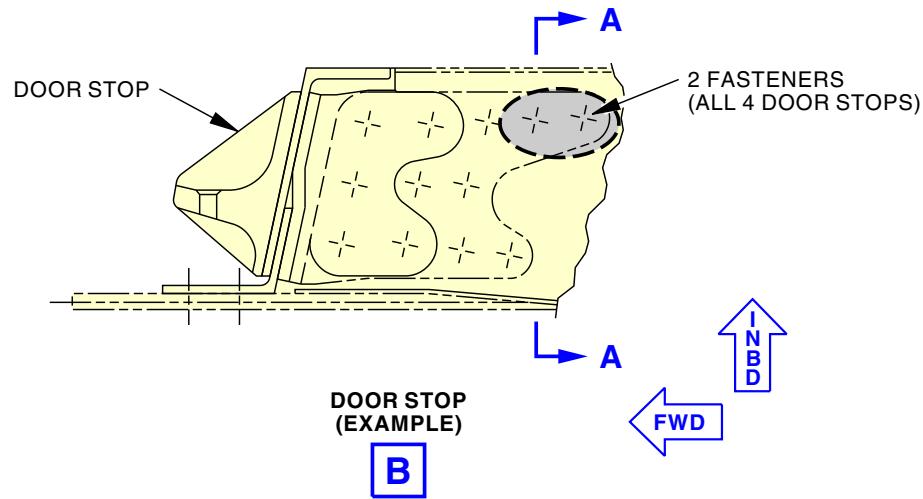
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**53-05-02**

Page 298.66  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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AFT Entry Door Stop Backup Intercostals  
Figure 260/53-05-02-990-826

EFFECTIVITY	LOM ALL
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**53-05-02**

Page 298.67  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-846**

**123. EXTERNAL - DETAILED: CUTOUT, AFT ENTRY DOOR SURROUND STRUCTURE**

Figure 261

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
834	Aft Entry Door

**C. Inspection**

SUBTASK 53-05-02-010-025

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
834	Aft Entry Door

NOTE: Remove or displace interior sidewall and door lining as required to do the inspection.

SUBTASK 53-05-02-211-046

- (2) Do a Detailed inspection on the perimeter of the cutout and around the fasteners common to the edge frames and upper sill outer chords.

See Doc D626A001-DTR, DTR check form 53-70-07-5 for alternative inspections.

SUBTASK 53-05-02-410-023

- (3) Close this access panel:

<b>Number</b>	<b>Name/Location</b>
834	Aft Entry Door

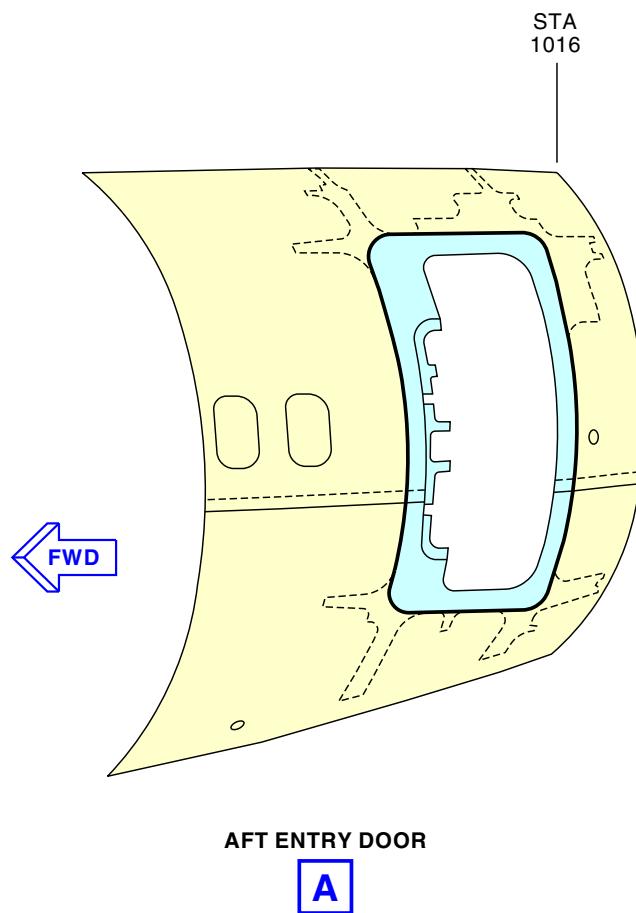
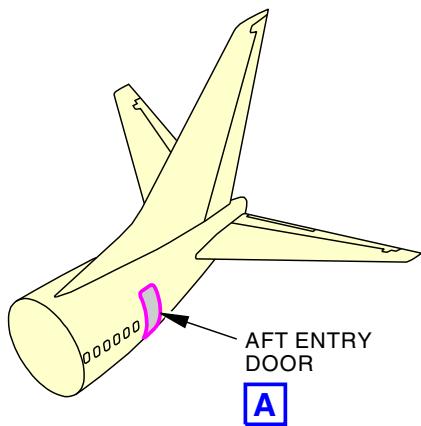
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



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AIRCRAFT MAINTENANCE MANUAL



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**Aft Entry Door Surround Structure - Cutout**  
**Figure 261/53-05-02-990-827**

EFFECTIVITY	LOM ALL
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**53-05-02**

Page 298.69  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-847**

**124. EXTERNAL - DETAILED: AFT ENTRY DOOR SURROUND STRUCTURE**

Figure 262

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
145	Aft Cargo Compartment Equipment Bay - Left
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
834	Aft Entry Door

**C. Inspection**

SUBTASK 53-05-02-010-026

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
834	Aft Entry Door

SUBTASK 53-05-02-211-047

- (2) Do a Detailed inspection of the skin around the edges of the scuff plates.

See Doc D626A001-DTR, DTR check form 53-70-07-6 for alternative inspections.

SUBTASK 53-05-02-410-024

- (3) Close this access panel:

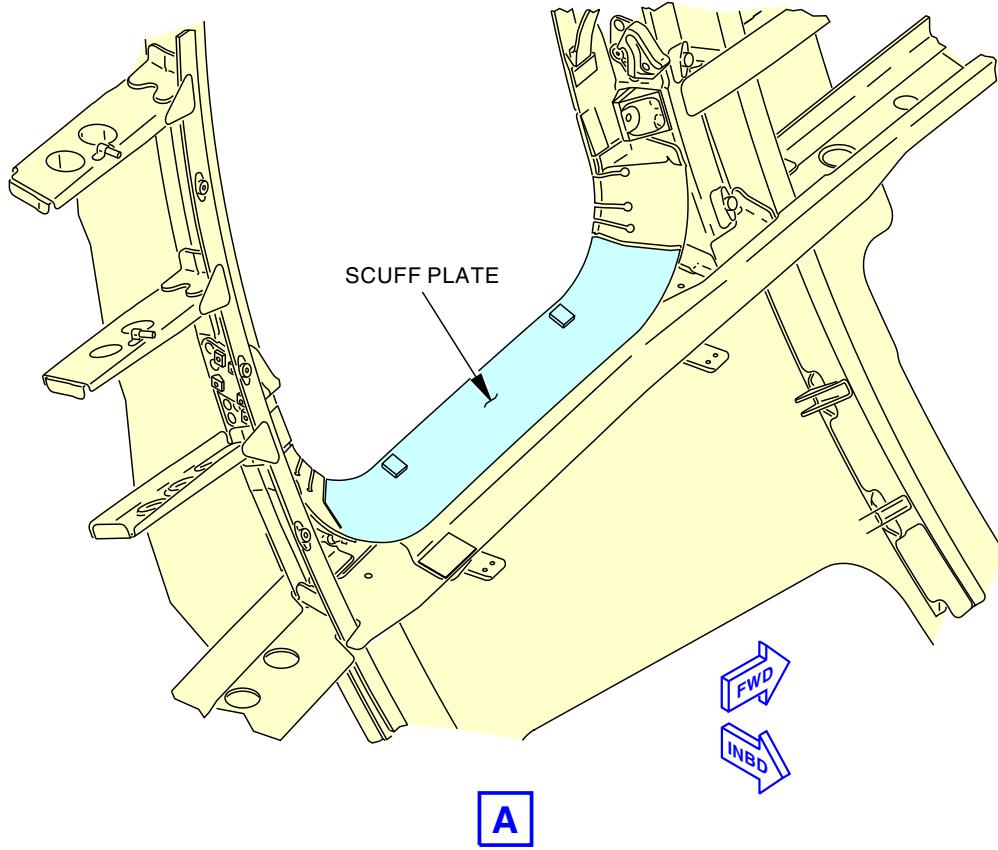
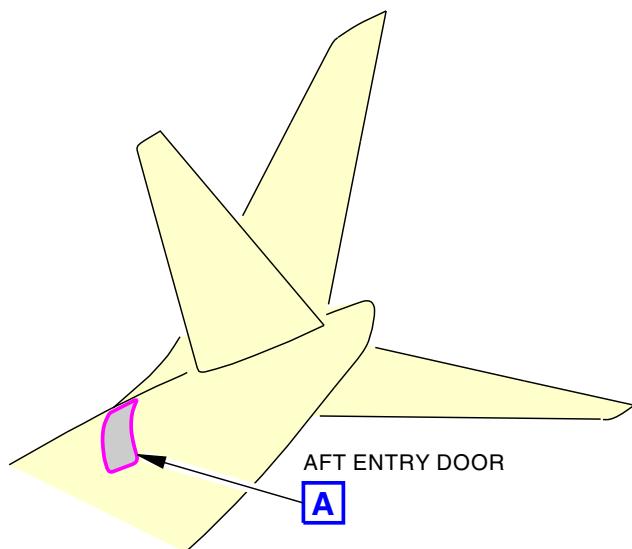
<b>Number</b>	<b>Name/Location</b>
834	Aft Entry Door

———— END OF TASK ————

— EFFECTIVITY —  
**LOM ALL**



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Aft Entry Door Surround Structure  
Figure 262/53-05-02-990-920

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

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Page 298.71  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-898**

**125. EXTERNAL - SPECIAL DETAILED: AFT ENTRY DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
145	Aft Cargo Compartment Equipment Bay - Left
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

**B. Access Panels**

<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door

**C. Inspection**

SUBTASK 53-05-02-010-103

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door

NOTE: Remove scuff plate.

SUBTASK 53-05-02-250-098

- (2) Do a High Frequency Eddy Current inspection of the skin around the fastener holes hidden by the scuff plate.

See Doc D626A001-DTR, DTR check form 53-70-07-6 for alternative inspections.

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 53-30-34.

SUBTASK 53-05-02-410-101

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door

NOTE: Re-attach scuff plate.

———— END OF TASK ————

**TASK 53-05-02-211-848**

**126. INTERNAL - DETAILED: AFT ENTRY DOOR SURROUND STRUCTURE**

Figure 263

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

**B. Access Panels**

<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door



**53-05-02**



737-600/700/800/900  
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C. Inspection

SUBTASK 53-05-02-010-027

- (1) Open this access panel:

Number    Name/Location

834           Aft Entry Door

NOTE: Remove or displace passenger cabin sidewall and ceiling lining as required to do the inspection.

SUBTASK 53-05-02-211-048

- (2) Do a Detailed inspection of the inner chord and web along the upper main sill from STA 951 to STA 1006.

See Doc D626A001-DTR, DTR check form 53-70-07-11 for alternative inspections.

SUBTASK 53-05-02-410-167

- (3) Close this access panel:

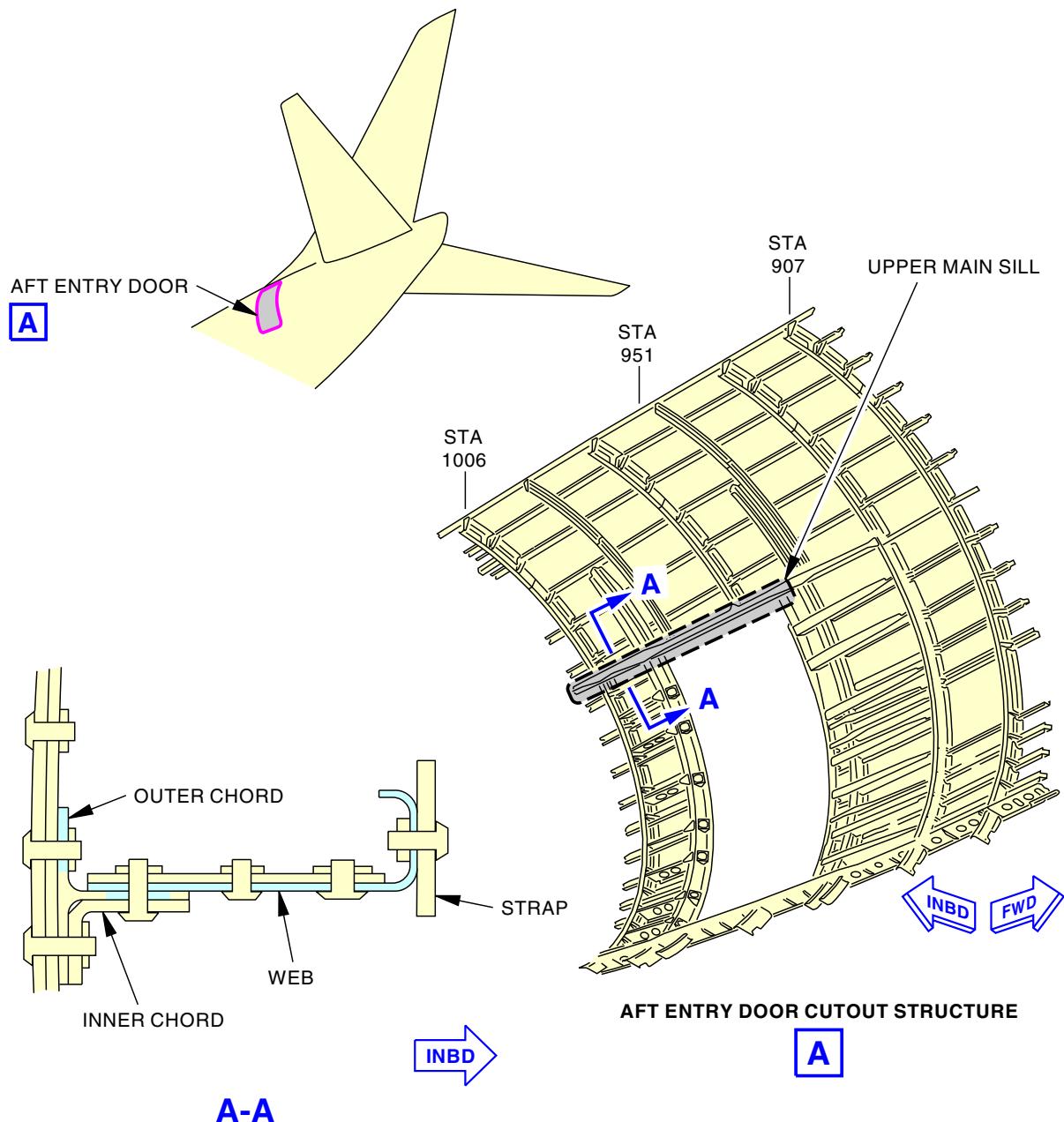
Number    Name/Location

834           Aft Entry Door

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



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**AFT Entry Door Surround Structure**  
**Figure 263/53-05-02-990-828**

 EFFECTIVITY  
 LOM ALL

**53-05-02**

D633A101-LOM

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 Page 298.74  
 Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-899**

**127. INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR FORWARD EDGE FRAME DOOR STOP  
BACKUP STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

Number	Name/Location
844	Aft Galley Service Door

**C. Inspection**

SUBTASK 53-05-02-010-102

- (1) Open this access panel:

Number	Name/Location
844	Aft Galley Service Door

NOTE: Remove or displace passenger cabin sidewall and ceiling lining as required to perform the inspection.

SUBTASK 53-05-02-250-099

- (2) Do a Low Frequency Eddy Current inspection on the four fastener locations at the #1, #2, #5 and #6 stop locations.

See Doc D626A001-DTR, DTR check form 53-70-08-3 for alternative inspections.

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 53-10-83.

SUBTASK 53-05-02-410-100

- (3) Close this access panel:

Number	Name/Location
844	Aft Galley Service Door

———— END OF TASK ————

**TASK 53-05-02-250-900**

**128. INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR FORWARD EDGE FRAME DOOR STOP  
BACKUP STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

Number	Name/Location
844	Aft Galley Service Door



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

C. Inspection

SUBTASK 53-05-02-010-104

- (1) Open this access panel:

Number    Name/Location

844              Aft Galley Service Door

NOTE: Remove or displace passenger cabin sidewall and ceiling lining as required to perform the inspection.

SUBTASK 53-05-02-250-100

- (2) Do a High Frequency Eddy Current inspection on the four fastener locations at the #1, #2, #5 and #6 stop locations. For door stop #5, there are two locations in the strap hidden by the bracket.

See Doc D626A001-DTR, DTR check form 53-70-08-3 for alternative inspections.

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 53-10-83.

SUBTASK 53-05-02-410-102

- (3) Close this access panel:

Number    Name/Location

844              Aft Galley Service Door

———— END OF TASK ————

**TASK 53-05-02-250-901**

**129. INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR AFT EDGE FRAME DOOR STOP BACKUP INTERCOSTALS**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone    Area

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

B. Access Panels

Number    Name/Location

844              Aft Galley Service Door

C. Inspection

SUBTASK 53-05-02-010-105

- (1) Open this access panel:

Number    Name/Location

844              Aft Galley Service Door

NOTE: Remove or displace passenger cabin sidewall and ceiling lining as required to perform the inspection.

SUBTASK 53-05-02-250-101

- (2) Do a High Frequency Eddy Current inspection of the door stop intercostals along the inner chord and around fasteners common to the web and doubler at the #1, #2, #5, and #6 stop locations.

See Doc D626A001-DTR, DTR check form 53-70-08-4 for alternative inspections.

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**53-05-02**



**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, Subject 53-10-84.

SUBTASK 53-05-02-410-103

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

———— END OF TASK ————

**TASK 53-05-02-210-843**

**130. INTERNAL - GENERAL VISUAL: AFT GALLEY DOOR AFT EDGE FRAME DOOR STOP BACKUP**

**INTERCOSTALS**

Figure 264

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Access Panels**

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

**C. Inspection**

SUBTASK 53-05-02-410-171

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

NOTE: Remove or displace passenger cabin sidewall and ceiling lining as required to perform the inspection.

SUBTASK 53-05-02-210-043

- (2) Do a General Visual inspection of the door stop intercostals along the inner chord and around fasteners common to the web and doubler at the #1, #2, #5, and #6 stop locations.

See Doc D626A001-DTR, DTR check form 53-70-08-4 for alternative inspections.

SUBTASK 53-05-02-410-172

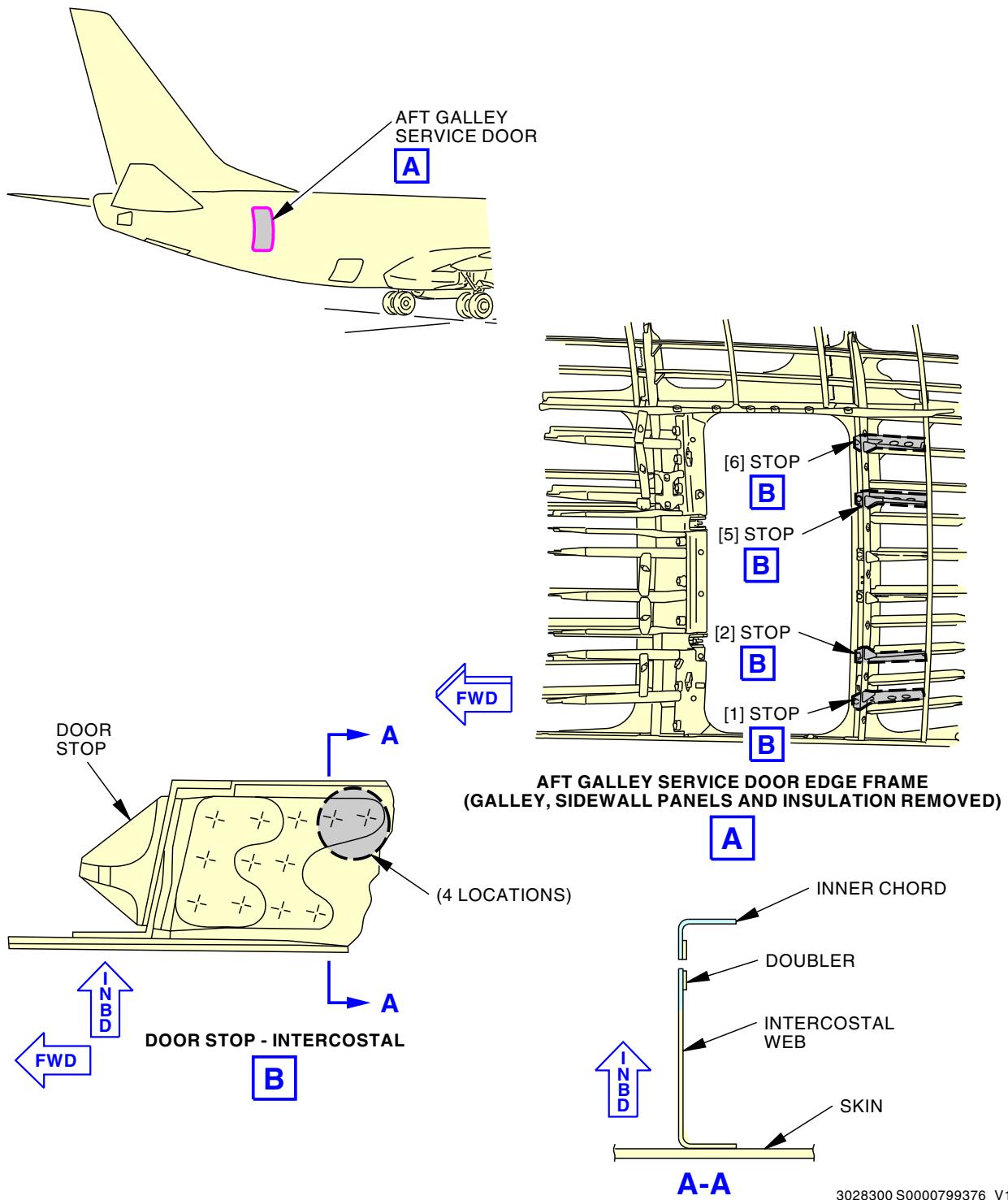
- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

———— END OF TASK ————

———— EFFECTIVITY ————  
LOM ALL

**53-05-02**



**Aft Galley Service Door Surround Structure - Door Stop Backup Intercostals**  
**Figure 264/53-05-02-990-848**

EFFECTIVITY  
LOM ALL

**53-05-02**



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AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-849**

**131. EXTERNAL - DETAILED: CUTOUT, AFT GALLEY DOOR SURROUND STRUCTURE**

Figure 265

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Access Panels**

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

**C. Inspection**

SUBTASK 53-05-02-010-028

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

SUBTASK 53-05-02-211-049

- (2) Do a Detailed inspection of the perimeter of the cutout and around the fasteners common to the edge frames and upper sill outer chords.

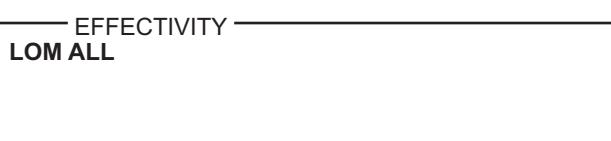
See Doc D626A001-DTR, DTR check form 53-70-08-5 for alternative inspections.

SUBTASK 53-05-02-410-026

- (3) Close this access panel:

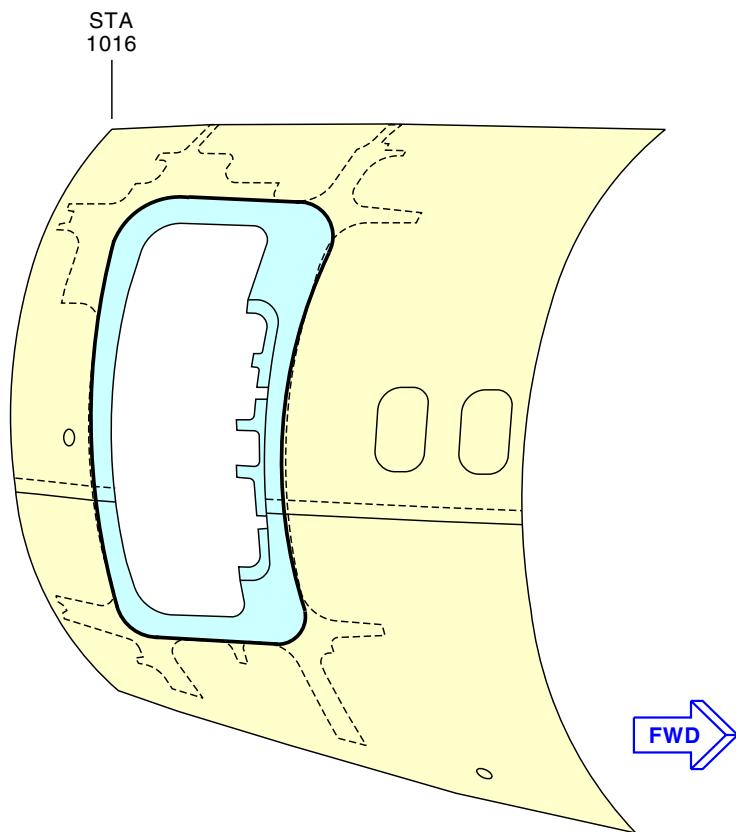
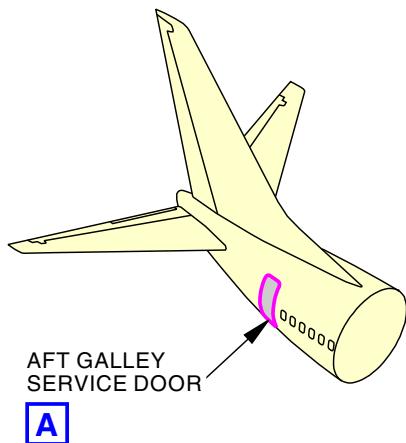
<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

———— END OF TASK ————





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**Aft Galley Service Door Surround Structure - Cutout**  
**Figure 265/53-05-02-990-829**

EFFECTIVITY  
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**53-05-02**

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Page 298.80  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-850**

**132. INTERNAL - DETAILED: BULKHEAD STA 1016**

Figure 266

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 53-05-02-010-029

- (1) Open this access panel:

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

SUBTASK 53-05-02-211-050

- (2) Do a Detailed inspection of the pressure dome webs between the stiffeners and tear straps.  
See Doc D626A001-DTR, DTR check form 53-80-01-2 for alternative inspections.

SUBTASK 53-05-02-410-027

- (3) Close this access panel:

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

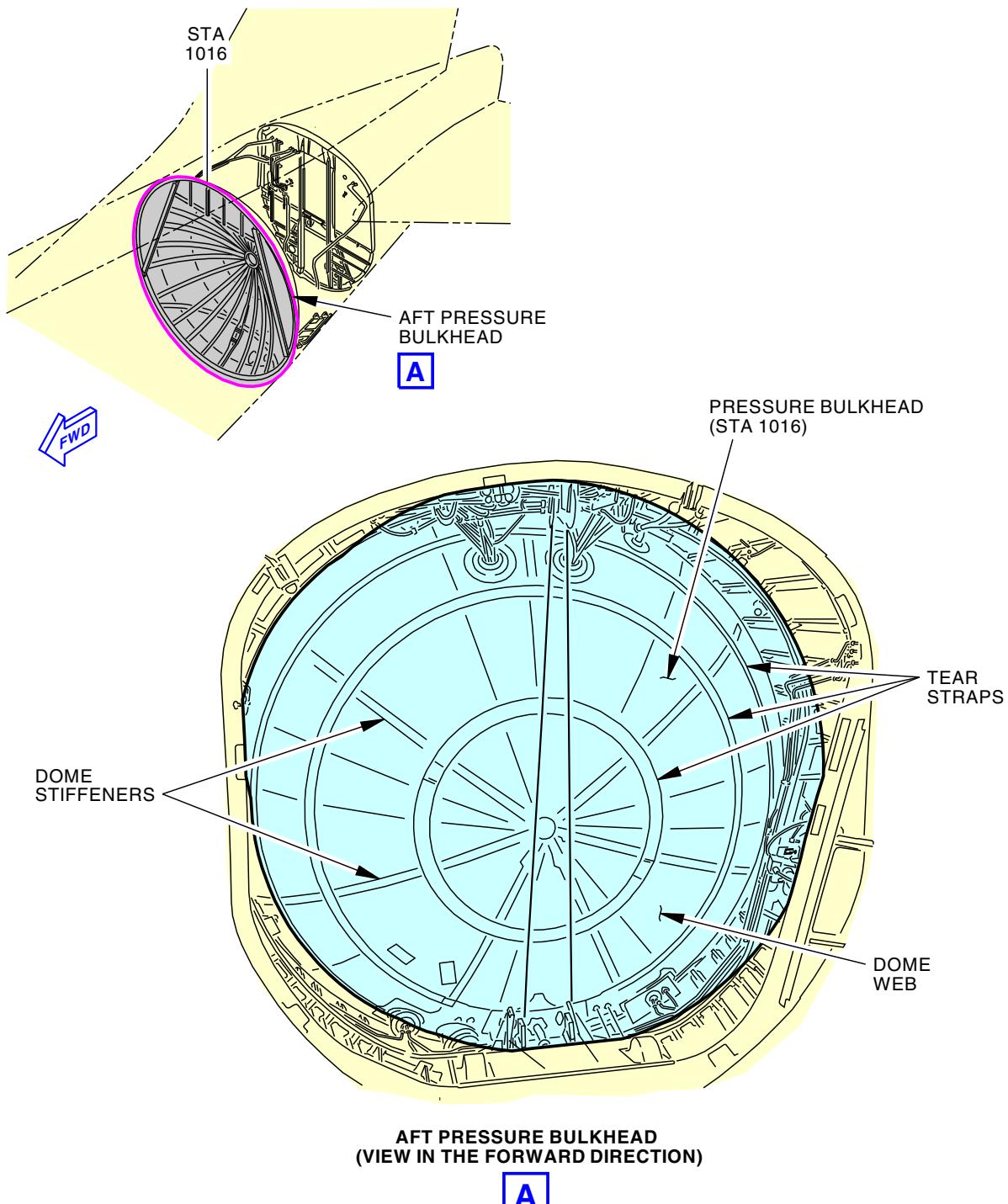
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



**737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL**



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**Bulkhead STA 1016**  
**Figure 266/53-05-02-990-830**

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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-851**

**133. INTERNAL - DETAILED: BULKHEAD STA 1016**

Figure 267Figure 268

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 53-05-02-010-030

- (1) Open this access panel:

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

SUBTASK 53-05-02-211-051

- (2) Do a Detailed inspection of the pressure dome web lap splices along the fastener rows adjacent to the radial stiffeners.

See Doc D626A001-DTR, DTR check form 53-80-01-3 for alternative inspections.

SUBTASK 53-05-02-410-028

- (3) Close this access panel:

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

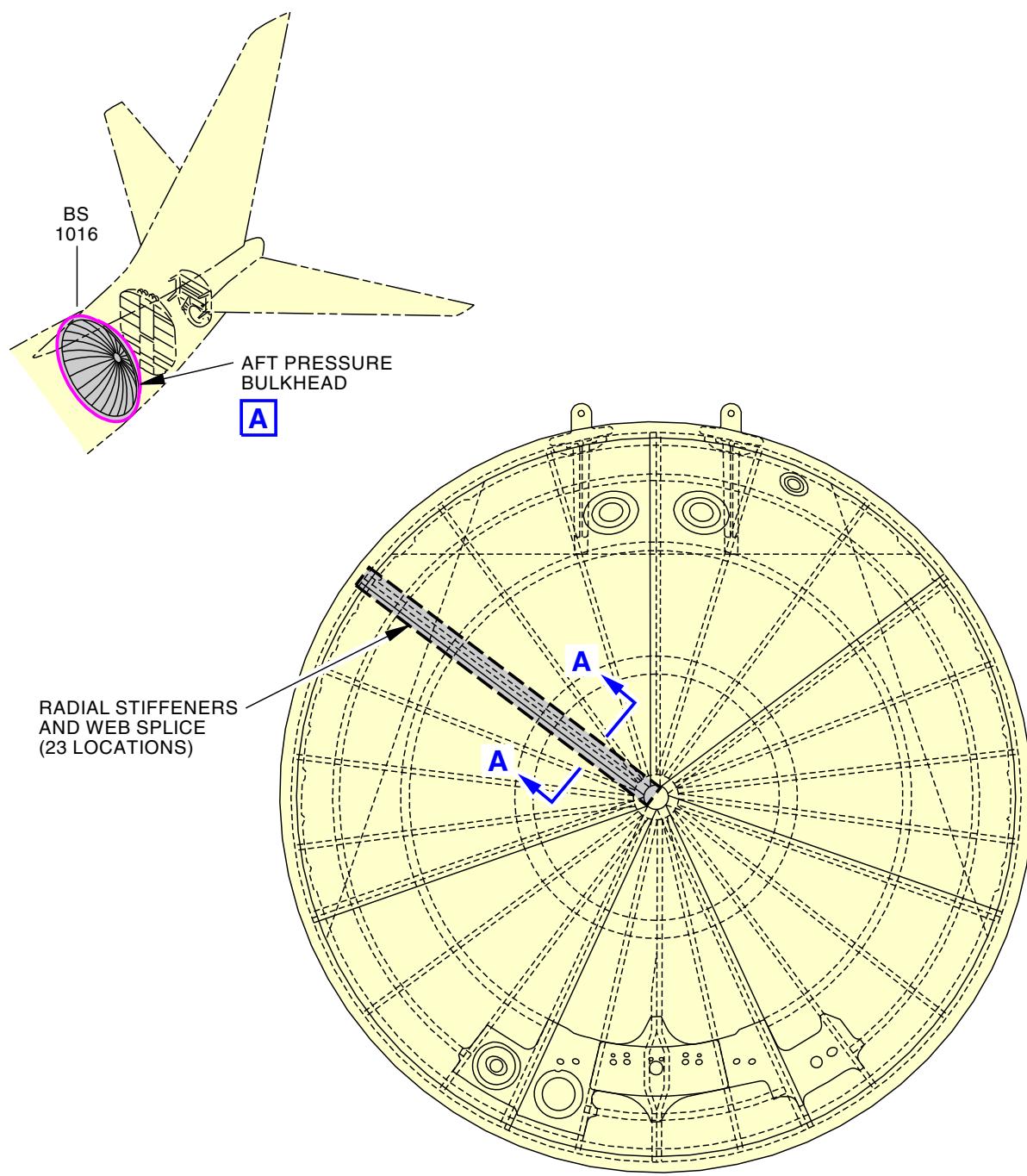
———— END OF TASK ————

EFFECTIVITY
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



AFT SIDE OF PRESSURE BULKHEAD

A

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Bulkhead STA 1016  
Figure 267/53-05-02-990-831

EFFECTIVITY  
LOM ALL

**53-05-02**

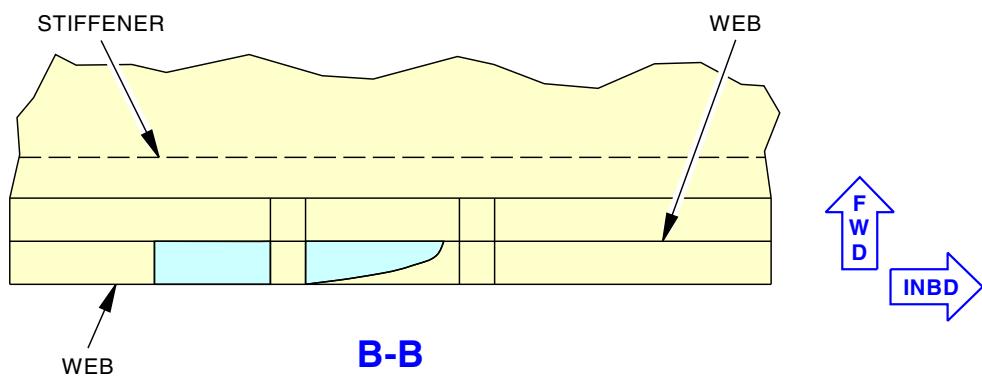
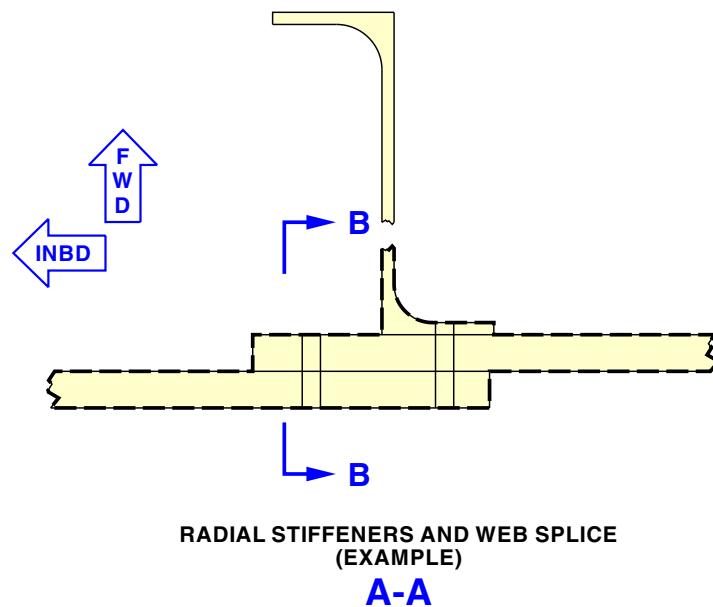
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Page 298.84  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Bulkhead STA 1016  
Figure 268/53-05-02-990-832

EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-02**

Page 298.85  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-902**

**134. INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

**B. Inspection**

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

SUBTASK 53-05-02-250-102

- (1) Do a High Frequency Eddy Current inspection of the forward side of the pressure dome web along the aft fastener row attaching the web to the pressure chord. Inspect at the edge of each stiffener/clip and around the two fasteners on each side of the stiffener.

See Doc D626A001-DTR, DTR check form 53-80-01-4 for alternative inspections.

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 53-11-11.

———— END OF TASK ——

**TASK 53-05-02-250-903**

**135. INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

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

SUBTASK 53-05-02-250-103

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

See Doc D626A001-DTR, DTR check form 53-80-01-5A for alternative inspections.

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 53-11-38.

———— END OF TASK ——

EFFECTIVITY
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-904**

**136. INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

**B. Inspection**

NOTE: Remove necessary passenger cabin interiors if/as required to perform this inspection.

SUBTASK 53-05-02-250-104

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

See Doc D626A001-DTR, DTR check form 53-80-01-5B for alternative inspections.

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 53-11-40.

————— END OF TASK ————

**TASK 53-05-02-250-905**

**137. INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

**B. Inspection**

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

SUBTASK 53-05-02-250-105

- (1) Do a Low Frequency Eddy Current inspection around the fasteners common to the pressure chord splices between stringers S-2 and S-3 and S-16 and S-17A.

See Doc D626A001-DTR, DTR check form 53-80-01-6 for alternative inspections.



D633A101-LOM

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**53-05-02**

Page 298.87  
Jun 15/2024



**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, Subject 53-11-42.

————— END OF TASK ————

**TASK 53-05-02-250-906**

**138. INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

**B. Inspection**

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

SUBTASK 53-05-02-250-106

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

See Doc D626A001-DTR, DTR check form 53-80-01-7 for alternative inspections. 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 53-11-39.

————— END OF TASK ————

**TASK 53-05-02-250-907**

**139. INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

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. Inspection**

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

SUBTASK 53-05-02-250-107

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

See Doc D626A001-DTR, DTR check form 53-80-01-8 for alternative inspections.

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 53-10-97.

————— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-908**

**140. INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-141

- (1) Open this access panel:

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

SUBTASK 53-05-02-250-108

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

See Doc D626A001-DTR, DTR check form 53-80-01-9A for alternative inspections.

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 53-11-08.

SUBTASK 53-05-02-410-132

- (3) Close this access panel:

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

— END OF TASK —

**TASK 53-05-02-250-B08**

**141. INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

**B. Access Panels**

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



**53-05-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**C. Inspection**

SUBTASK 53-05-02-010-215

- (1) Open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

SUBTASK 53-05-02-250-313

- (2) Do a Low Frequency Eddy Current inspection on the forward side of the pressure dome web at the intersection of the tear straps, lap splice, and doubler next to the stiffeners at S-23L/R.

See Doc D626A001-DTR, DTR check form 53-80-01-9B for alternative inspections.

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 53-11-39.

SUBTASK 53-05-02-410-211

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

———— END OF TASK ————

**TASK 53-05-02-250-909**

**142. INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

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. Inspection**

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

SUBTASK 53-05-02-250-109

- (1) Do a High Frequency Eddy Current inspection on the forward side of the pressure dome webs at the junction of the radial stiffeners/lap splices and the tear straps.

See Doc D626A001-DTR, DTR check form 53-80-01-11 for alternative inspections.

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 53-11-07.

———— END OF TASK ————

**TASK 53-05-02-250-910**

**143. INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

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

— EFFECTIVITY —

LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**B. Inspection**

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

SUBTASK 53-05-02-250-110

- (1) Do a Low Frequency Eddy Current inspection on the forward side of the pressure dome web around the fasteners common to the doubler, Y-Chord and the tear strap between stringers S-1 and S-3.

See Doc D626A001-DTR, DTR check form 53-80-01-13 for alternative inspections.

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 53-11-42.

———— END OF TASK ————

LOM 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-999

**TASK 53-05-02-211-888**

**144. INTERNAL - DETAILED: BULKHEAD STA 1016**

Figure 269

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-071

- (1) Open this access panel:

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

SUBTASK 53-05-02-211-088

- (2) Do a Detailed inspection of the aft side of STA 1016 bulkhead web for oil cans.

NOTE: Refer to Structural Repair Manual, Section 53-80-08, for definition of oil can.

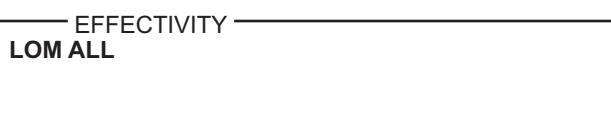
No DTR form available for PSE 53-80-01-14.

SUBTASK 53-05-02-410-069

- (3) Close this access panel:

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

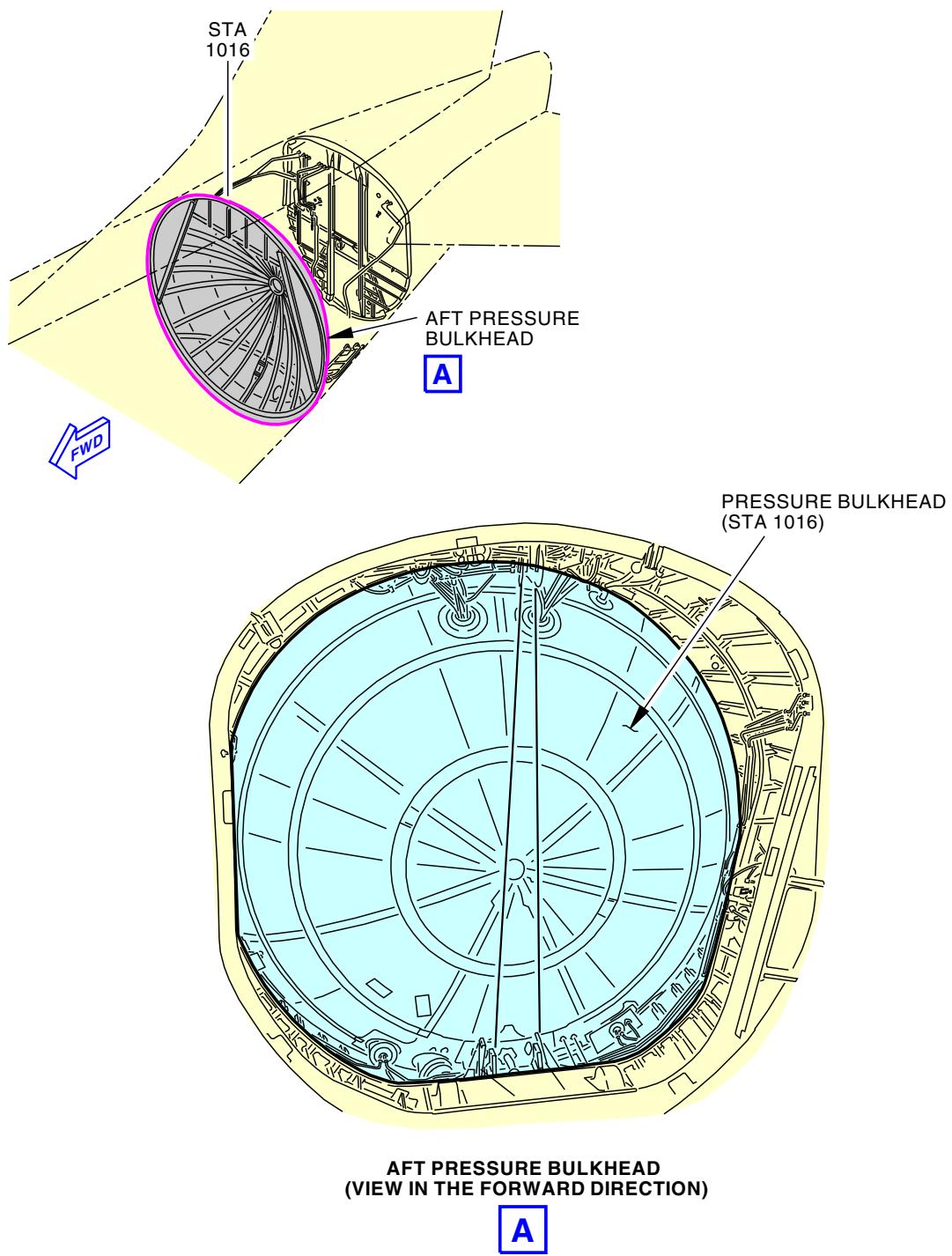
———— END OF TASK ————



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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**Aft Bulkhead STA 1016**  
Figure 269/53-05-02-990-833

EFFECTIVITY  
LOM 407, 411, 412, 415, 416, 420, 422-434, 437-447,  
450-999

**53-05-02**

D633A101-LOM

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Page 298.92  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

LOM ALL

**TASK 53-05-02-211-852**

**145. INTERNAL - DETAILED: VERTICAL FIN FRONT SPAR FITTING BULKHEAD ATTACHMENT - STA 1016**

Figure 270

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right
321	Vertical Fin - Dorsal Fin

**B. Inspection**

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

SUBTASK 53-05-02-211-052

- (1) Do a Detailed inspection of the fittings on both sides of the bulkhead at STA 1016.

See Doc D626A001-DTR, DTR check form 53-80-02-1 for alternative inspections.

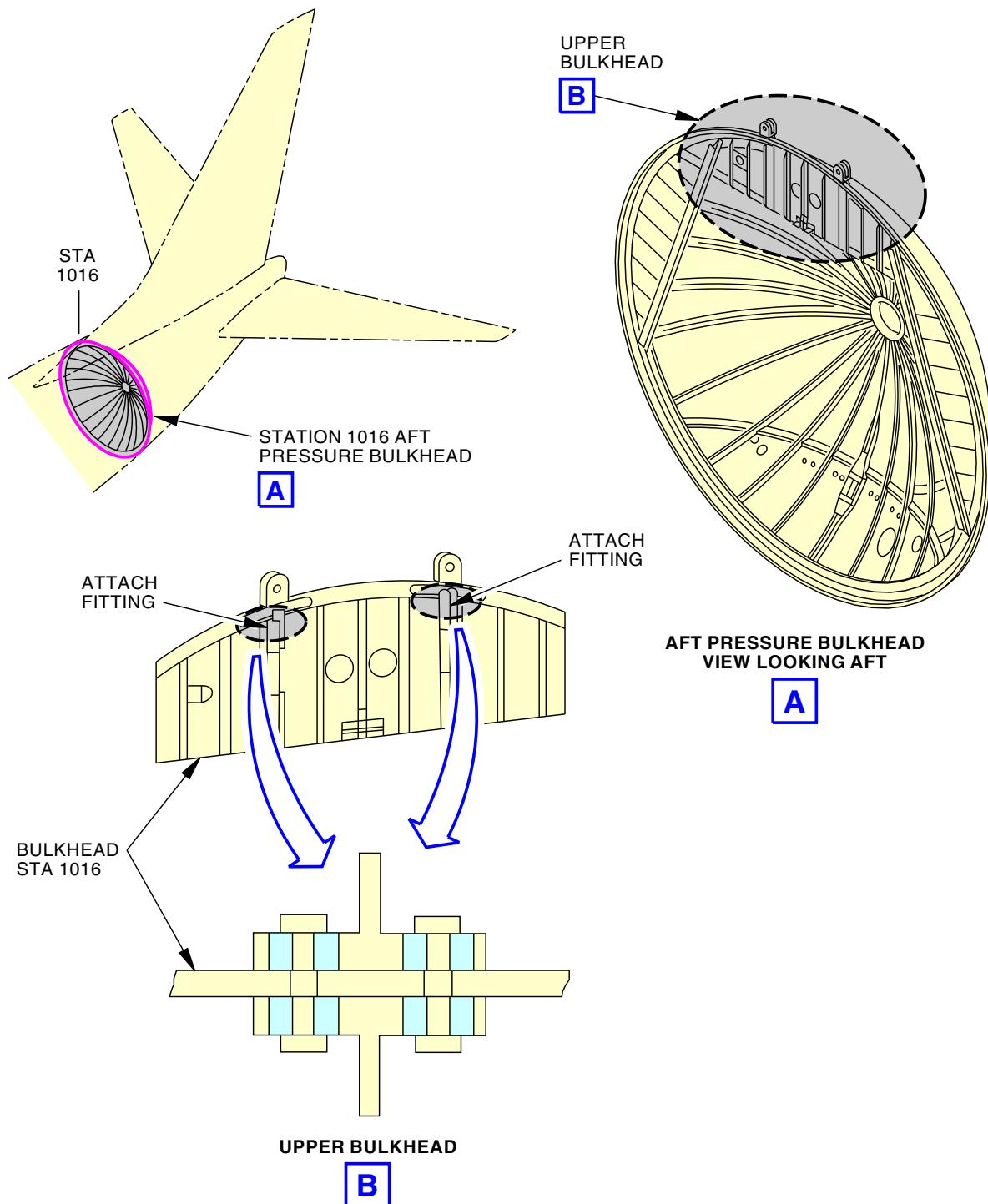
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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VERTICAL FIN FRONT SPAR FITTING BULKHEAD ATTACHMENT - STA 1016  
Figure 270/53-05-02-990-834

EFFECTIVITY  
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**53-05-02**

D633A101-LOM

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Page 298.94  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-912**

**146. INTERNAL - SPECIAL DETAILED: VERTICAL FIN FRONT SPAR FITTINGS - STA 1016**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right
322	Vertical Fin - Removable Fin Leading Edge

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-174

- (1) Open these access panels:

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

SUBTASK 53-05-02-250-112

- (2) Do a High Frequency Eddy Current inspection of the exposed forward and aft surfaces of the fitting lugs. Bolt removal is not required.

See Doc D626A001-DTR, DTR check form 53-80-02-2 for alternative inspections.

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 53-10-78.

SUBTASK 53-05-02-410-165

- (3) Close these access panels:

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

— END OF TASK —

**TASK 53-05-02-250-913**

**147. INTERNAL - SPECIAL DETAILED: STRINGER SPLICE FITTINGS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-144

- (1) Open this access panel:

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

NOTE: Remove or displace passenger cabin interior as required to perform the inspection.

SUBTASK 53-05-02-250-113

- (2) Do a High Frequency Eddy Current inspection of the stringer splice fittings from stringer S-9L to S-9R at the first two fastener locations forward and aft of the STA 1016 bulkhead.

See Doc D626A001-DTR, DTR check form 53-80-03-1 for alternative inspections.

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 53-10-79.

SUBTASK 53-05-02-410-135

- (3) Close this access panel:

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

— END OF TASK —

**TASK 53-05-02-250-914**

**148. INTERNAL - SPECIAL DETAILED: JACKSCREW FITTING LUGS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-106

- (1) Open this access panel:

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

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

SUBTASK 53-05-02-250-114

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

See Doc D626A001-DTR, DTR check form 53-80-05-1 for alternative inspections.

EFFECTIVITY
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**53-05-02**



**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, Subject 53-10-95.

SUBTASK 53-05-02-410-104

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

———— END OF TASK ————

**TASK 53-05-02-130-807**

**149. INTERNAL - SPECIAL DETAILED: VERTICAL FIN REAR SPAR ATTACHMENT FITTINGS**

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
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right
323	Vertical Fin - Front Spar To Rear Spar

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-007

- (1) Open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

NOTE: Access fittings inside the tailcone on the forward and aft side of the STA 1088 Bulkhead. The top of the fittings are sandwiched between the splice angles and the bulkhead.

SUBTASK 53-05-02-130-007

- (2) Do an Ultrasonic inspection of the top two fasteners in the outboard primary fittings common to the STA 1088 bulkhead.

See Doc D626A001-DTR, DTR check form 53-80-06-1 for alternative inspections.

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 53-80-01.

SUBTASK 53-05-02-410-005

- (3) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-853**

**150. INTERNAL - DETAILED: VERTICAL FIN REAR SPAR ATTACHMENT FITTINGS**

Figure 271

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
313	Stabilizer Torsion Box Compartment - Left
314	Stabilizer Torsion Box Compartment - Right
323	Vertical Fin - Front Spar To Rear Spar

**B. Inspection**

NOTE: Remove vertical fin including primary and fail-safe bolts.

SUBTASK 53-05-02-211-053

- (1) Do a Detailed inspection of the four primary fitting lugs, from the inside of the lugs, at STA 1088.

See Doc D626A001-DTR, DTR check form 53-80-06-2 for alternative inspections.

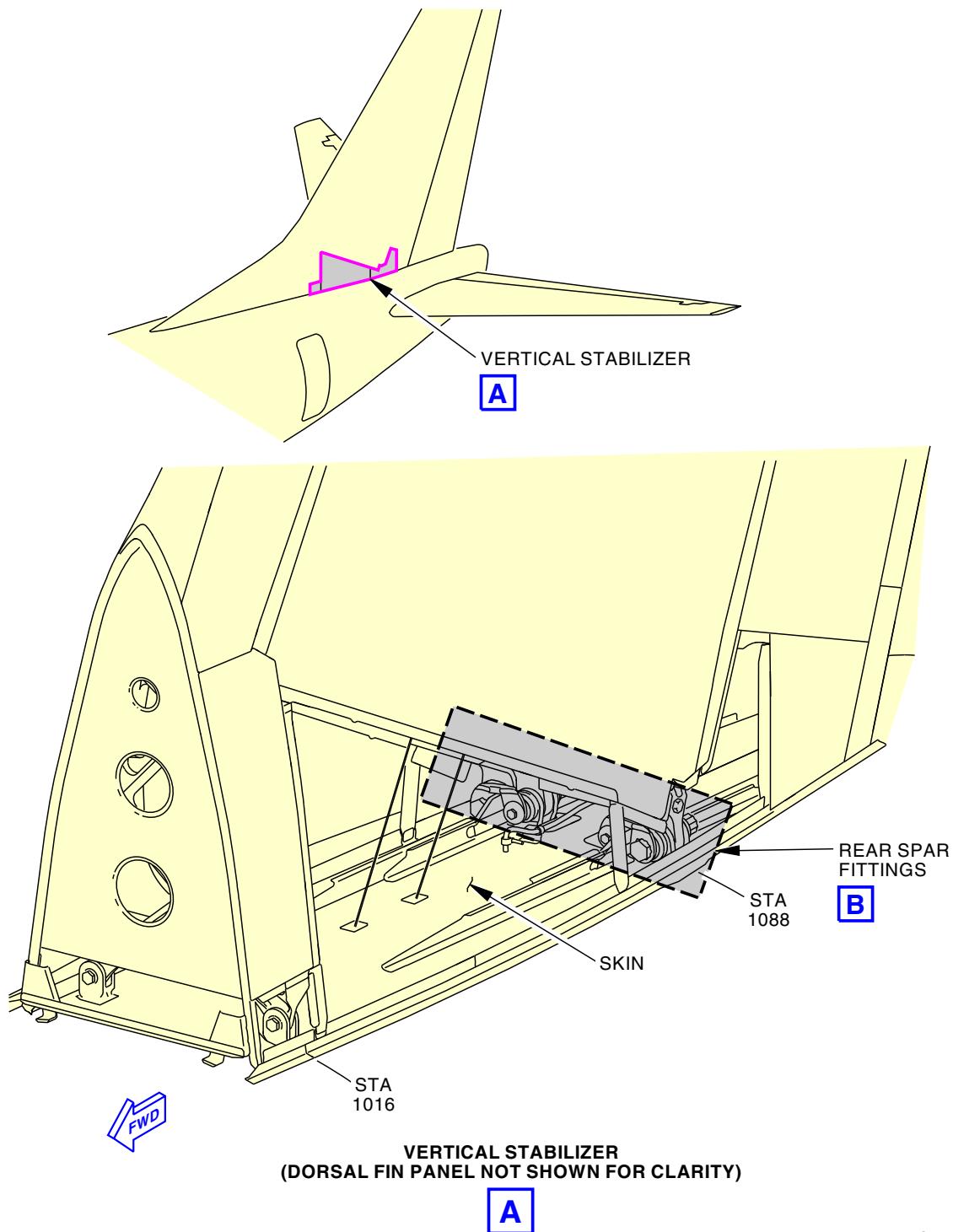
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Vertical Fin Rear Spar Attachment Fittings  
Figure 271/53-05-02-990-855 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

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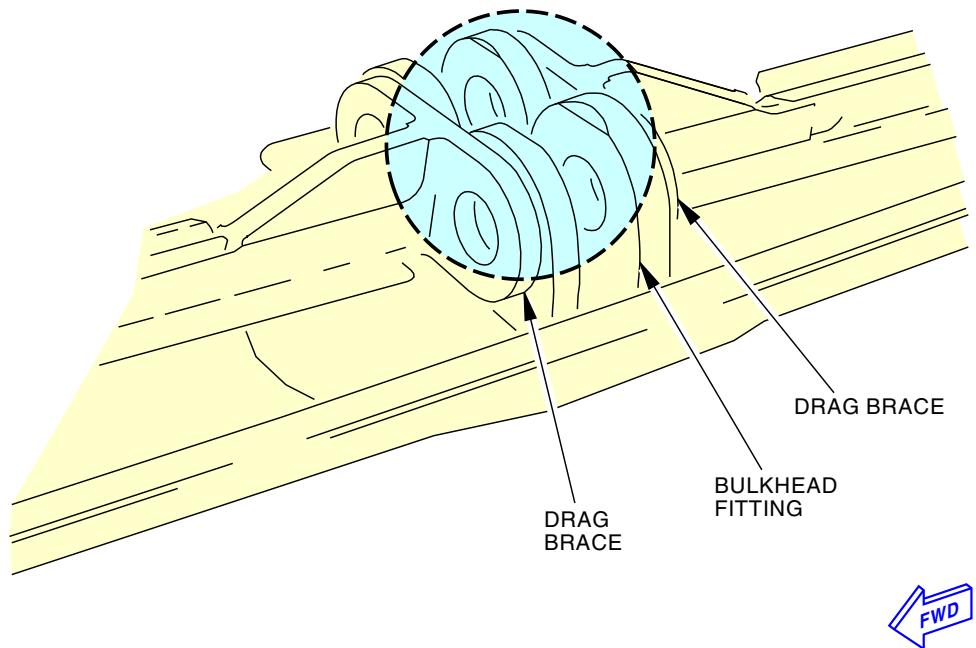
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**53-05-02**

Page 298.99  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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

B

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Vertical Fin Rear Spar Attachment Fittings  
Figure 271/53-05-02-990-855 (Sheet 2 of 2)

EFFECTIVITY  
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**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.100  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-916**

**151. INTERNAL - SPECIAL DETAILED: INTEGRATED BULKHEAD STA 1156**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

Number	Name/Location
318BR	Tailcone Access Door

**C. Inspection**

SUBTASK 53-05-02-010-108

- (1) Open this access panel:

Number	Name/Location
318BR	Tailcone Access Door

NOTE: Enter aircraft through the tail cone access panel.

SUBTASK 53-05-02-250-116

- (2) Do a High Frequency Eddy Current inspection of the web inboard along the failsafe strap from the top of the stabilizer attach fitting down 16 inches vertically.

See Doc D626A001-DTR, DTR check form 53-80-07-2 for alternative inspections.

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 53-11-33.

SUBTASK 53-05-02-410-106

- (3) Close this access panel:

Number	Name/Location
318BR	Tailcone Access Door

— END OF TASK —

**TASK 53-05-02-250-917**

**152. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER PIVOT FITTING**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Remove sliding seals for access.



**53-05-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-05-02-250-117

- (1) Do a High Frequency Eddy Current inspection of the pivot fitting beams around the pivot pins at the STA 1156 hinge beam.

See Doc D626A001-DTR, DTR check form 53-80-08-1 for alternative inspections.

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 53-10-86.

———— END OF TASK ————

**TASK 53-05-02-230-801**

**153. INTERNAL - SPECIAL DETAILED: HORIZONTAL STABILIZER PIVOT PINS**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

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

SUBTASK 53-05-02-230-001

- (1) Do a Dye Penetrant of both the inner and outer pivot pins at STA 1156.

See Doc D626A001-DTR, DTR check form 53-80-08-2 for alternative inspections.

———— END OF TASK ————

**TASK 53-05-02-211-854**

**154. EXTERNAL - DETAILED: SECTION 48 SKIN PANELS, STA 1088 TO STA 1156**

Figure 272

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-054

- (1) Do a Detailed inspection of the skin panels around the STA 1138 cutout.

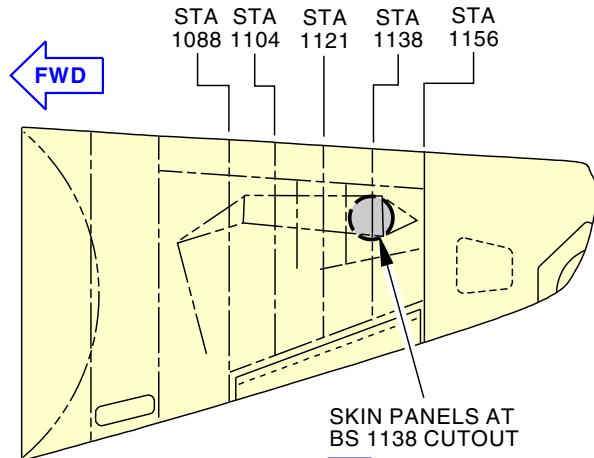
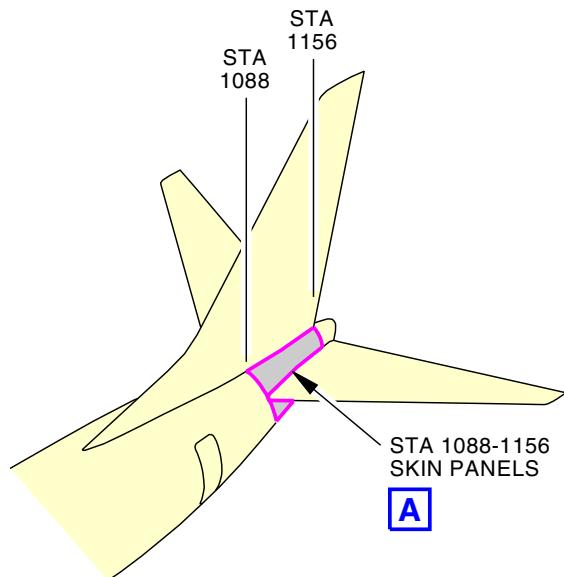
See Doc D626A001-DTR, DTR check form 53-80-10-1 for alternative inspections.

———— END OF TASK ————

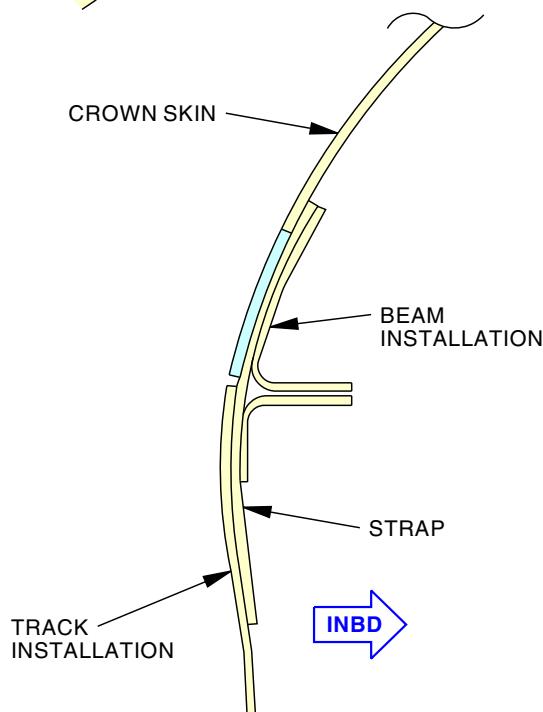




**737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL**

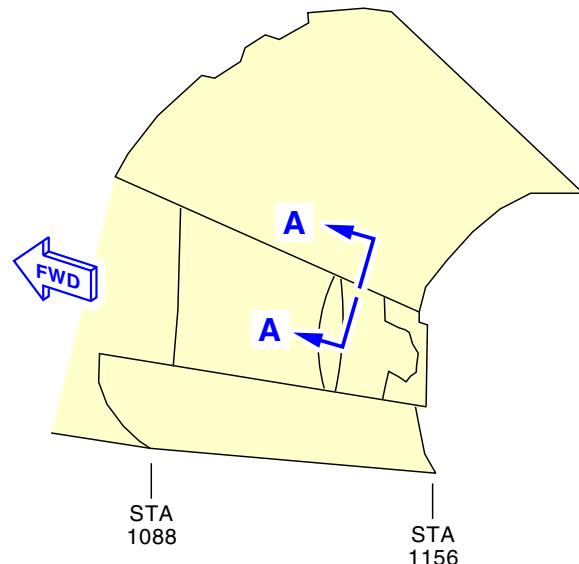


**STA 1088-1156 SKIN PANELS**



**SKIN PANEL INSPECTION AREA**

**A-A**



**SKIN PANELS AT BS 1138 CUTOUT**

**B**

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**Section 48 Skin Panels  
Figure 272/53-05-02-990-921**

EFFECTIVITY  
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**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-862**

**155. EXTERNAL - DETAILED: CROWN SKIN PANEL STA 259.5 TO STA 360**

Figure 273

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-062

- (1) Do a detailed inspection of the skin around all of the fastener locations from stringer S-10L to S-10R, from Sta 259.5 to Sta 360, except at the lap splices and antennas. (53-10-08-1).

See Doc D626A001-DTR, DTR check form 53-30-01-2 for alternative inspections.

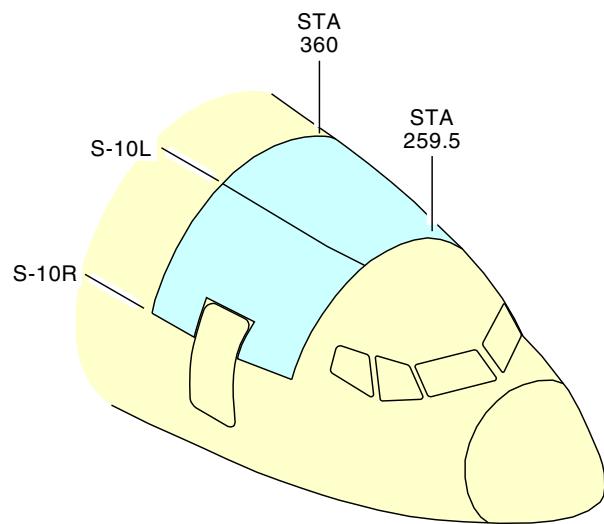
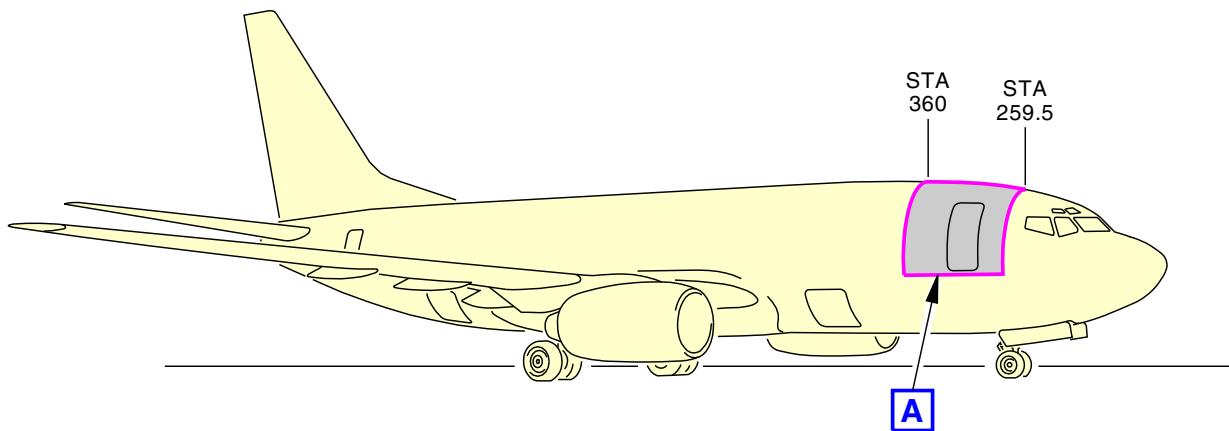
———— END OF TASK ——

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



CROWN SKIN PANEL

A

3026952 S0000797949\_V1

CROWN SKIN PANEL - STA 259.5 TO 360  
Figure 273/53-05-02-990-904

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

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Page 298.105  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-931**

**156. INTERNAL - SPECIAL DETAILED: FWD GALLEY DOOR CUTOUT**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
118	Electrical and Electronics Compartment - Right
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

**B. Inspection**

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

SUBTASK 53-05-02-250-131

- (1) Do a High Frequency Eddy Current inspection of the skin around the fastener holes and along the edge of the cutout hidden by the scuff plates from STA 303 to STA 350. (53-10-15-4).

See Doc. D626A001-DTR, DTR check form 53-10-14-12 for alternative inspections.

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 53-30-43.

———— END OF TASK ————

**TASK 53-05-02-250-932**

**157. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICING**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-132

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-4L and S-4R from STA 360 to STA 540 (PSE 53-30-04-1).

See Doc. D626A001-DTR, DTR check form 53-10-03-1, for alternative inspections.

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 53-30-41.

———— END OF TASK ————

**TASK 53-05-02-211-863**

**158. INTERNAL - DETAILED: WINDOW BELT STA 360 TO STA 540**

Figure 274

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Zone	Area
232	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Right

**B. Inspection**

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

SUBTASK 53-05-02-211-063

- (1) Do a Detailed inspection of the window frames around each window from Sta 360 to Sta 540.  
(PSE 53-30-05).

See Doc D626A001-DTR, DTR check form 53-60-05-2 for alternative inspections.

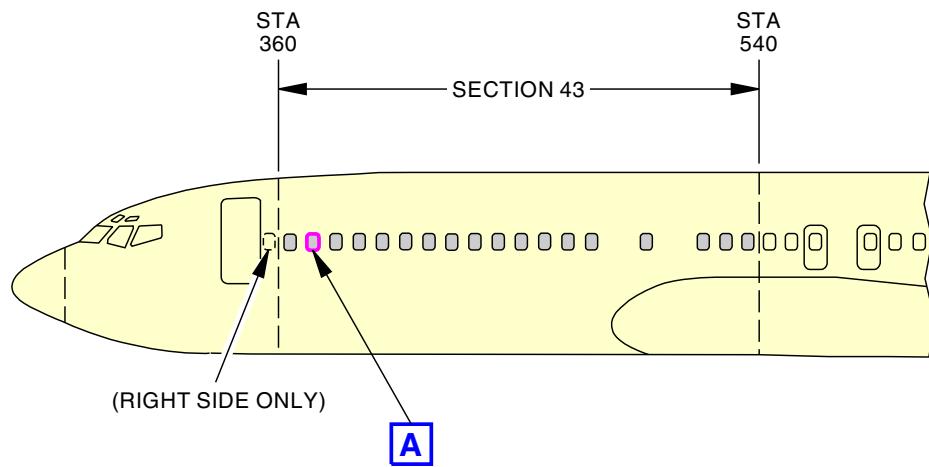
———— END OF TASK ——

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3027710 S0000799051\_V1

Window Belt STA 360 to STA 540  
Figure 274/53-05-02-990-886 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

D633A101-LOM

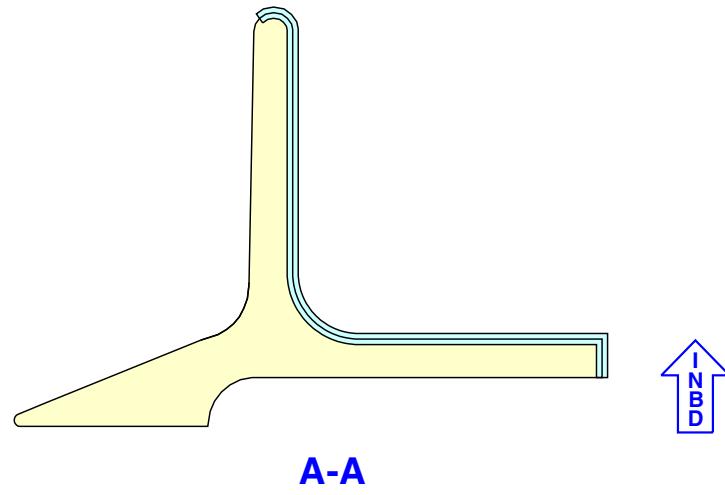
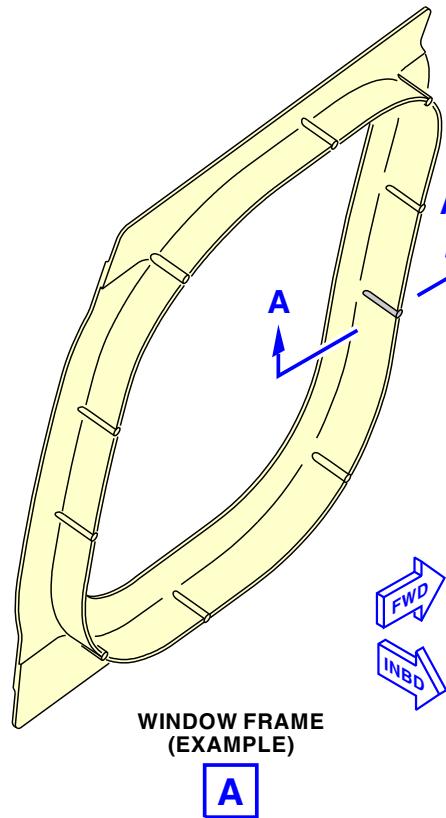
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-02**

Page 298.108  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3027711 S0000799052\_V1

Window Belt STA 360 to STA 540  
Figure 274/53-05-02-990-886 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

ECCN 9E991 BOEING PROPRIETARY - See title page for details

D633A101-LOM

**53-05-02**

Page 298.109  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-864**

**159. EXTERNAL - DETAILED: WINDOW BELT STA 360 TO STA 540**

Figure 275

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-064

- (1) Do a Detailed inspection of the window frames around each window from Sta 360 to Sta 540.  
(PSE 53-30-05).

See Doc D626A001-DTR, DTR check form 53-60-05-2 for alternative inspections.

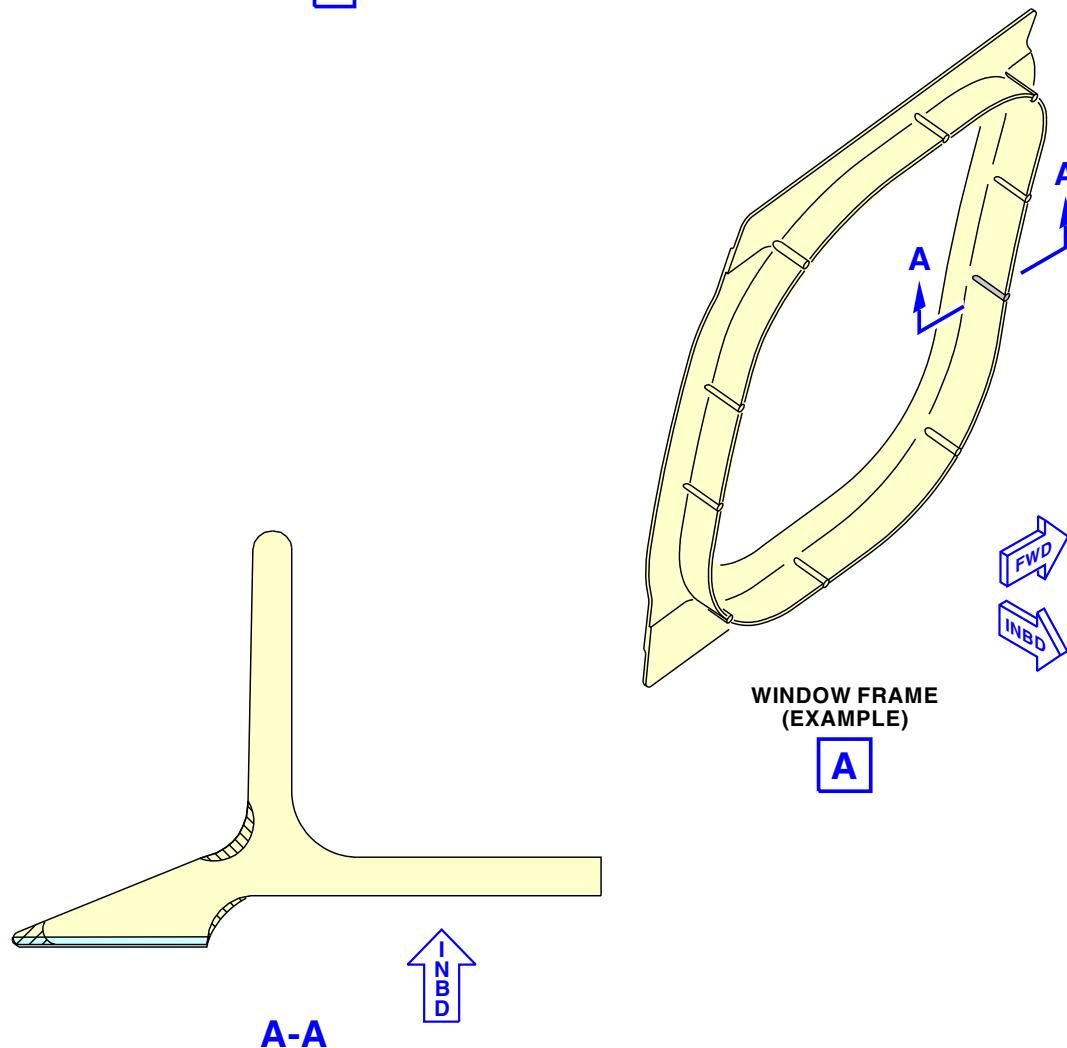
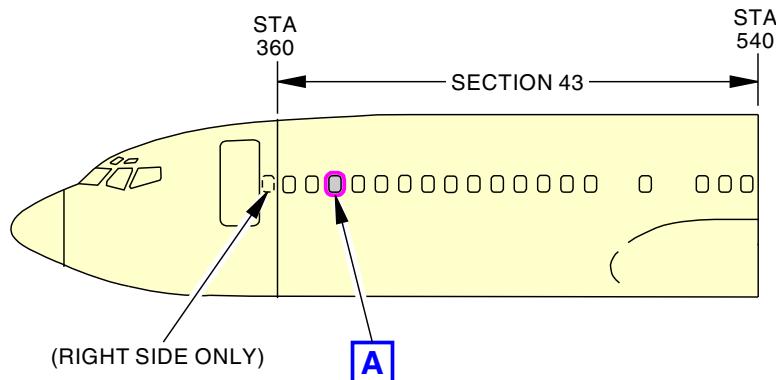
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3027787 S0000799053\_V1

Window Belt STA 360 to STA 540  
Figure 275/53-05-02-990-899

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

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Page 298.111  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-934**

**160. INTERNAL - SPECIAL DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-112

- (1) Open this access panel:

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

SUBTASK 53-05-02-250-134

- (2) Do a High Frequency Eddy Current inspection of the exposed edge of the bearstrap at both the forward and aft edge of the door at STA 440 and STA 492.4 from stringers S-18R to S-25R. (PSE 53-30-08).

See Doc D626A001-DTR, DTR check form 53-60-08-8 for alternative inspections.

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 53-11-21.

SUBTASK 53-05-02-410-110

- (3) Close this access panel:

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

— END OF TASK —

**TASK 53-05-02-211-865**

**161. EXTERNAL - DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE**

Figure 276

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

C. Inspection

SUBTASK 53-05-02-010-121

- (1) Open this access panel:

Number    Name/Location

821              Forward Cargo Door

NOTE: Forward cargo door must be open to perform this inspection. Scuff plate removal required.

SUBTASK 53-05-02-211-065

- (2) Do a Detailed inspection of the skin around the entire edge of the scuff plates at all four corners (upper/lower/fwd/aft) of the cargo door. (PSE 53-30-08-9).

See Doc. D626A001-DTR, DTR check form 53-60-08-9, for alternative inspections.

SUBTASK 53-05-02-410-119

- (3) Close this access panel:

Number    Name/Location

821              Forward Cargo Door

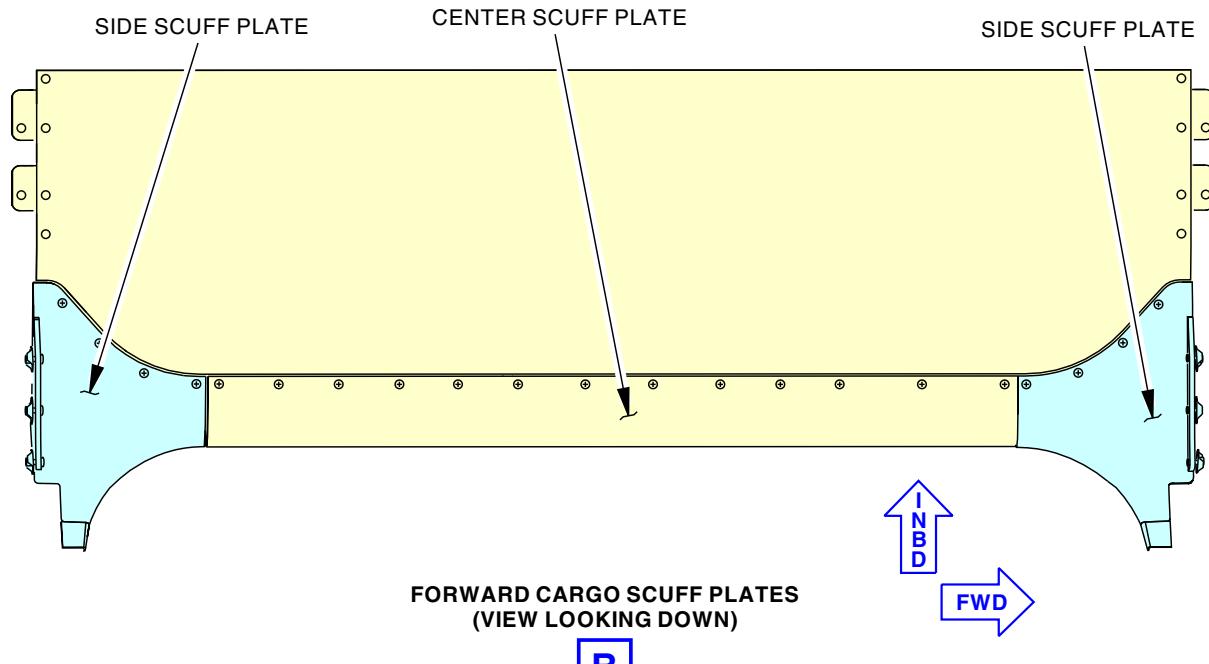
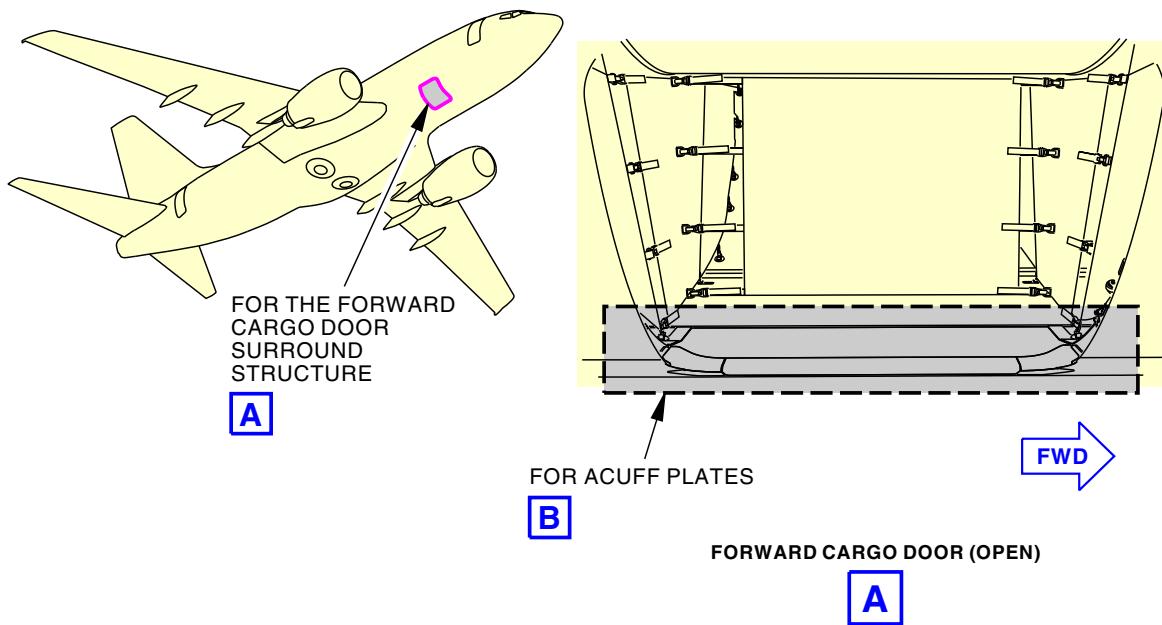
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3028020 S0000799252\_V1

Forward Cargo Door Surround Structure (Scuff Plate)  
Figure 276/53-05-02-990-887

EFFECTIVITY  
LOM ALL

D633A101-LOM

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**53-05-02**

Page 298.114  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-210-808**

**162. INTERNAL - GENERAL VISUAL: FORWARD CARGO DOOR SURROUND STRUCTURE**

Figure 277

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-013

- (1) Open this access panel:

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

NOTE: Corner casting removal is required.

SUBTASK 53-05-02-210-008

- (2) Do a General Visual inspection of the bearstrap at all four corners (upper/lower/fwd/aft) of the cargo door cutout. (PSE 53-30-08-9).

See Doc. D626A001-DTR, DTR check form 53-60-08-9, for alternative inspections.

SUBTASK 53-05-02-410-011

- (3) Close this access panel:

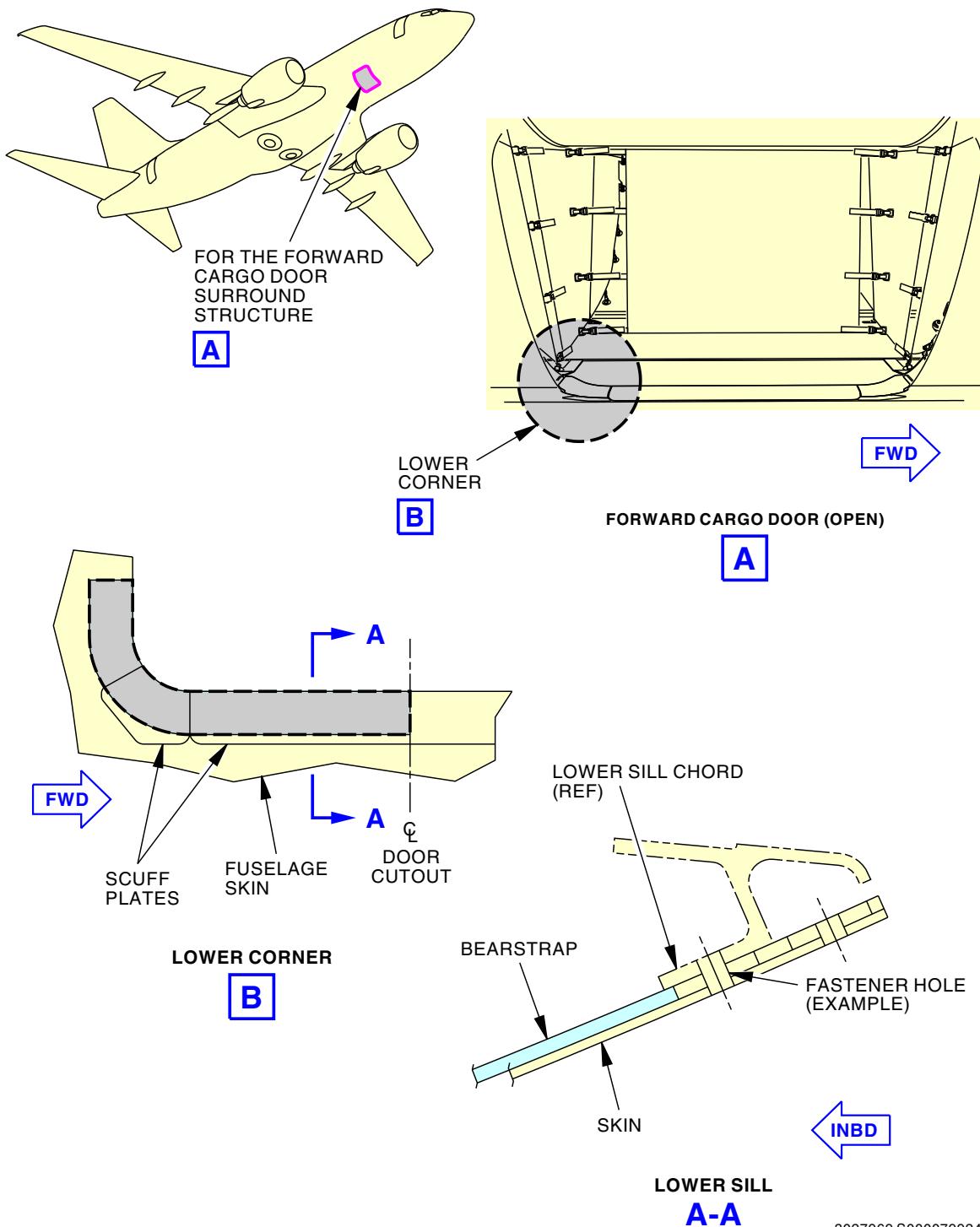
<b>Number</b>	<b>Name/Location</b>
821	Forward Cargo Door

———— END OF TASK ————



**53-05-02**

Page 298.115  
Jun 15/2024



3027969 S0000799249\_V1

**Forward Cargo Door Surround Structure (Bearstrap)**  
**Figure 277/53-05-02-990-888**

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-866**

**163. EXTERNAL - DETAILED: CROWN SKIN PANEL STA 540 TO STA 727**

Figure 278

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-066

- (1) Do a Detailed inspection of the skin around all of the fastener locations from stringer S-10L to S-10R, from STA 540 to STA 727, except at the lap splices and antennas. (53-40-01-1).

See Doc D626A001-DTR, DTR check form 53-30-01-2 for alternative inspections.

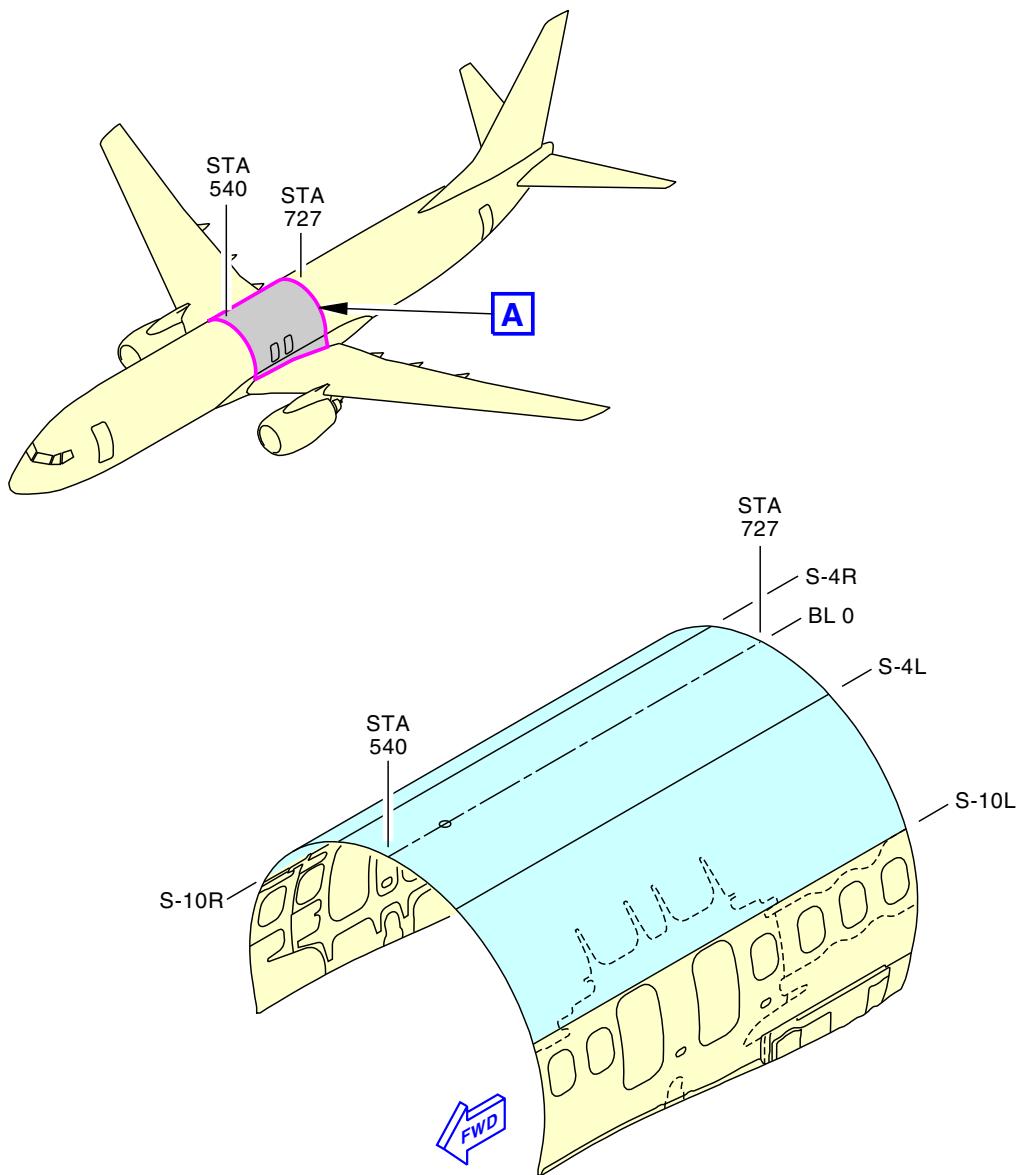
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



S-10L TO S-10R CROWN SKIN PANEL

A

3024758 S0000795612\_V1

Crown Skin Panel - STA 540 to 727  
Figure 278/53-05-02-990-890

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

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Page 298.118  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-935**

**164. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLIC**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-135

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-4L and S-4R from STA 540 to STA 727. (PSE 53-40-03-1).

See Doc. D626A001-DTR, DTR check form 53-10-03-1, for alternative inspections.

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 53-30-41.

———— END OF TASK ————

**TASK 53-05-02-250-937**

**165. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLIC**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-137

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringers S-4L and S-4R from STA 540 to STA 727. (53-40-03-2).

See Doc. D626A001-DTR, DTR check form 53-30-04-2, for alternative inspections.

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 53-30-50.

———— END OF TASK ————

**TASK 53-05-02-211-867**

**166. EXTERNAL - DETAILED: CROWN SKIN PANEL STA 727 TO STA 887**

Figure 279

NOTE: This procedure is a scheduled maintenance task.

— EFFECTIVITY —

LOM ALL

D633A101-LOM

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**A. Location Zones**

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

**B. Inspection**

NOTE: Remove Dorsal Fin as required to perform the inspection.

SUBTASK 53-05-02-211-067

- (1) Do a Detailed inspection of the skin around all of the fastener locations from stringer S-10L to S-10R, from STA 727 to STA 887, except at the lap splices and antennas. (PSE 53-60-01-2).

See Doc D626A001-DTR, DTR check form 53-30-01-2 for alternative inspections.

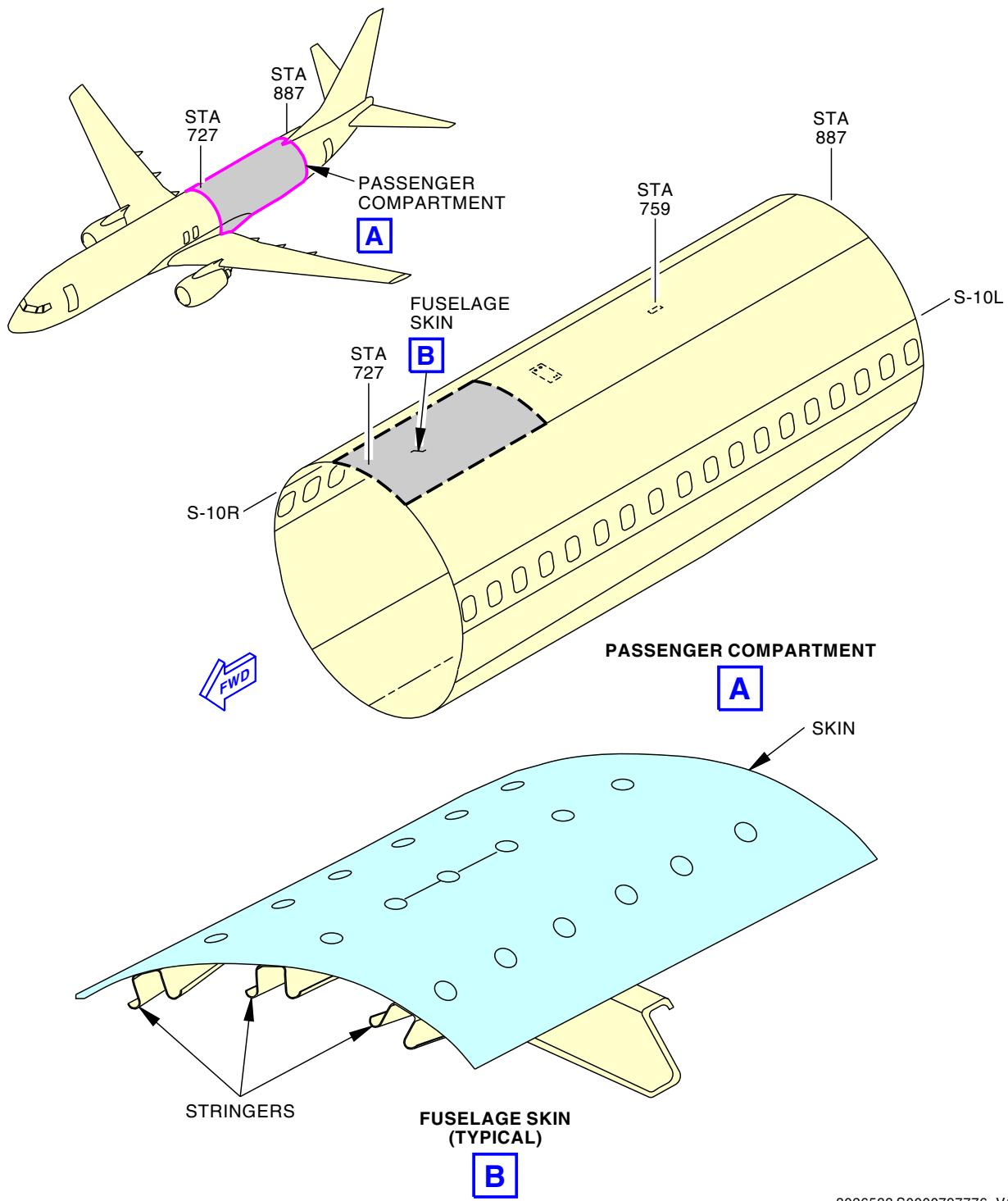
———— END OF TASK ————



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3026533 S0000797776\_V1

Crown Skin Panel - STA 727 to 887  
Figure 279/53-05-02-990-818

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.121  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-210-805**

**167. EXTERNAL - GENERAL VISUAL: FUSELAGE SIDE SKIN PANELS**

Figure 280

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
194	Lower Wing-To-Body Fairing - Aft of Wheel Well
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Inspection**

SUBTASK 53-05-02-210-005

- (1) Do a General Visual inspection of the skin from STA 727 to STA 887 between stringers S-14 to S-17. (PSE 53-60-02-1).

See Doc D626A001-DTR, DTR check form 53-30-02-1 for alternative inspections.

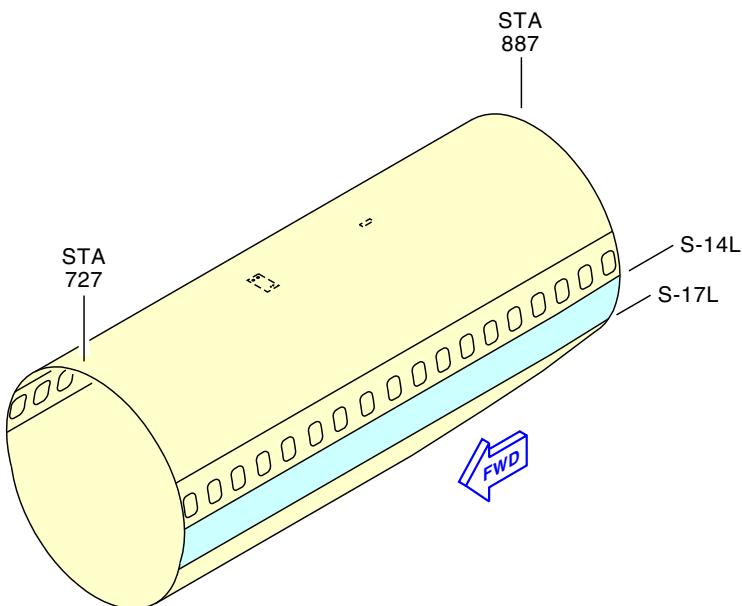
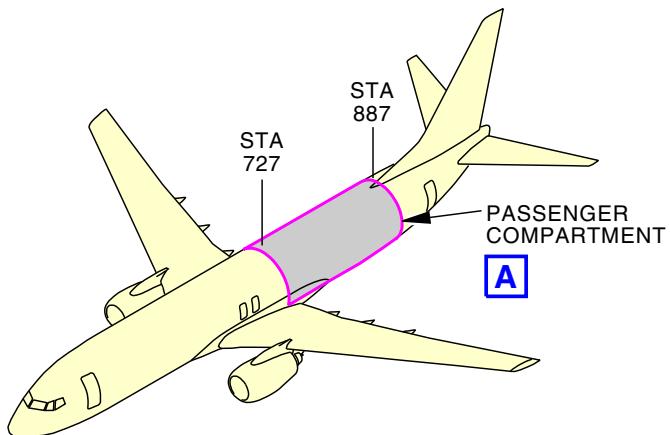
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT  
**A**

3026882 S0000798239\_V1

Fuselage Side Skin Panels  
Figure 280/53-05-02-990-835

EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-02**

Page 298.123  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-868**

**168. EXTERNAL - DETAILED: FUSELAGE SIDE SKIN PANELS UNDER THE WING-TO-BODY FAIRING**

Figure 281

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
194	Lower Wing-To-Body Fairing - Aft of Wheel Well

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel

**C. Inspection**

SUBTASK 53-05-02-010-037

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

<b>Number</b>	<b>Name/Location</b>
194AL	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel

Open these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
194AR	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel

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

SUBTASK 53-05-02-211-068

- (2) Do a Detailed inspection of the fuselage skin panels under the Wing to Body Fairing from STA 727 to STA 887. (53-60-02-4).

See Doc D626A001-DTR, DTR check form 53-30-02-4 for alternative inspections.

SUBTASK 53-05-02-410-035

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

<b>Number</b>	<b>Name/Location</b>
194AL	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel

Close these access panels on the Right side:

<b>Number</b>	<b>Name/Location</b>
194AR	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

———— END OF TASK ————

———— EFFECTIVITY ————  
**LOM ALL**

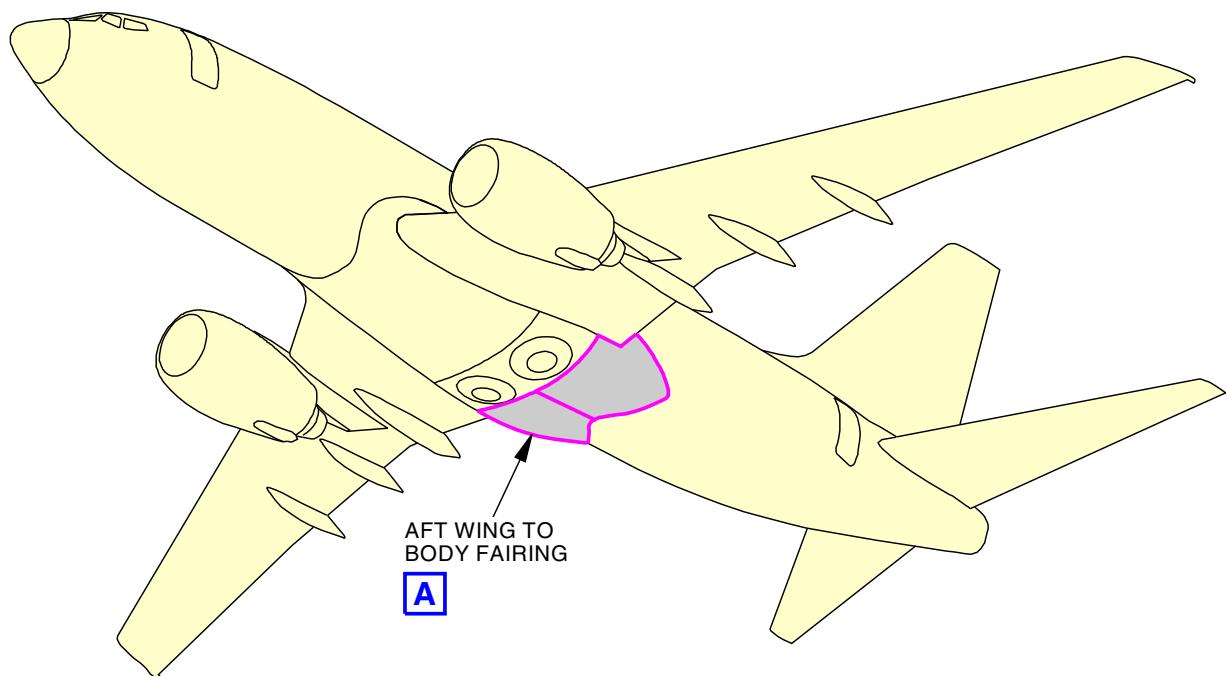
**53-05-02**

Page 298.125  
Jun 15/2024

D633A101-LOM



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3026839 S0000797861\_V1

**Wing to Body Fairing**  
**Figure 281/53-05-02-990-836 (Sheet 1 of 2)**

EFFECTIVITY  
LOM ALL

**53-05-02**

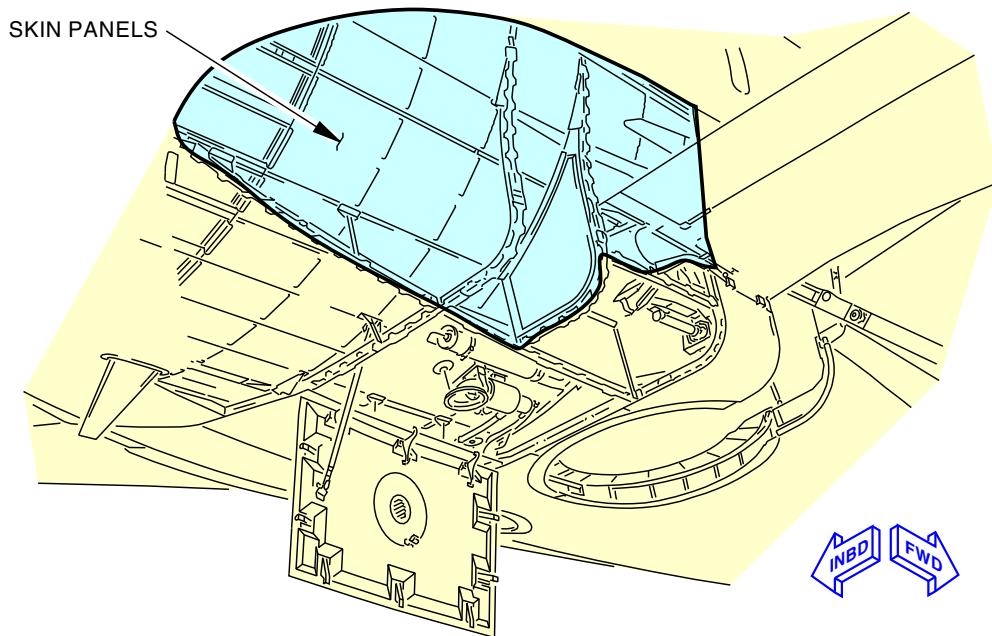
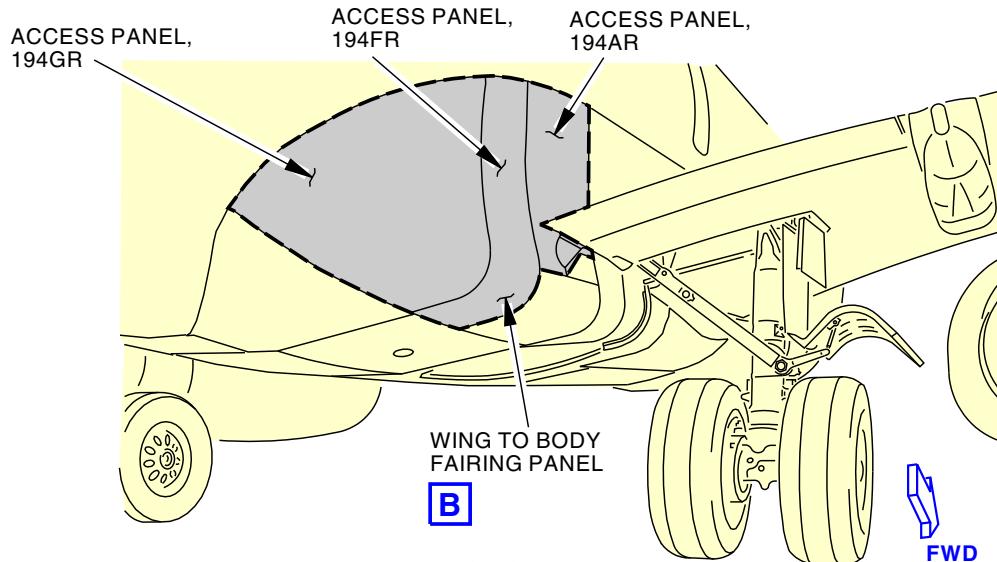
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Page 298.126  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



AREA UNDER LOWER WING-TO-BODY FAIRING PANEL  
(FAIRING REMOVED)  
(RIGHT SIDE IS SHOWN, LEFT SIDE IS OPPOSITE)

B

3026840 S0000797863\_V1

Wing to Body Fairing  
Figure 281/53-05-02-990-836 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.127  
Jun 15/2024



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-05-02-250-940**

**169. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Inspection**

SUBTASK 53-05-02-250-140

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

See Doc. D626A001-DTR, DTR check form 53-10-03-1, for alternative inspections.

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 53-30-41.

———— END OF TASK ————

**TASK 53-05-02-250-942**

**170. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Inspection**

SUBTASK 53-05-02-250-142

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringers S-4L and S-4R from STA 727 to STA 887. (PSE 53-60-04-2).

See Doc. D626A001-DTR, DTR check form 53-30-04-2, for alternative inspections.

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 53-30-50.

———— END OF TASK ————

**TASK 53-05-02-250-944**

**171. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right



**53-05-02**

Page 298.128  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**B. Inspection**

SUBTASK 53-05-02-250-144

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-10L and S-10R from STA 727 to STA 887. (PSE 53-60-04-3)

See Doc. D626A001-DTR, DTR check form 53-30-04-3, for alternative inspections.

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 53-30-41.

————— END OF TASK ————

**TASK 53-05-02-211-869**

**172. INTERNAL - DETAILED: LONGITUDINAL LAP SPLICE**

Figure 282

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

NOTE: Removal or displacement of interior sidewall panels and insulation blankets are required.

SUBTASK 53-05-02-211-069

- (1) Do a Detailed inspection of the lower skin along the lower fastener row at stringers S-10L and S-10R from STA 727 to STA 887. (PSE 53-60-04-4)

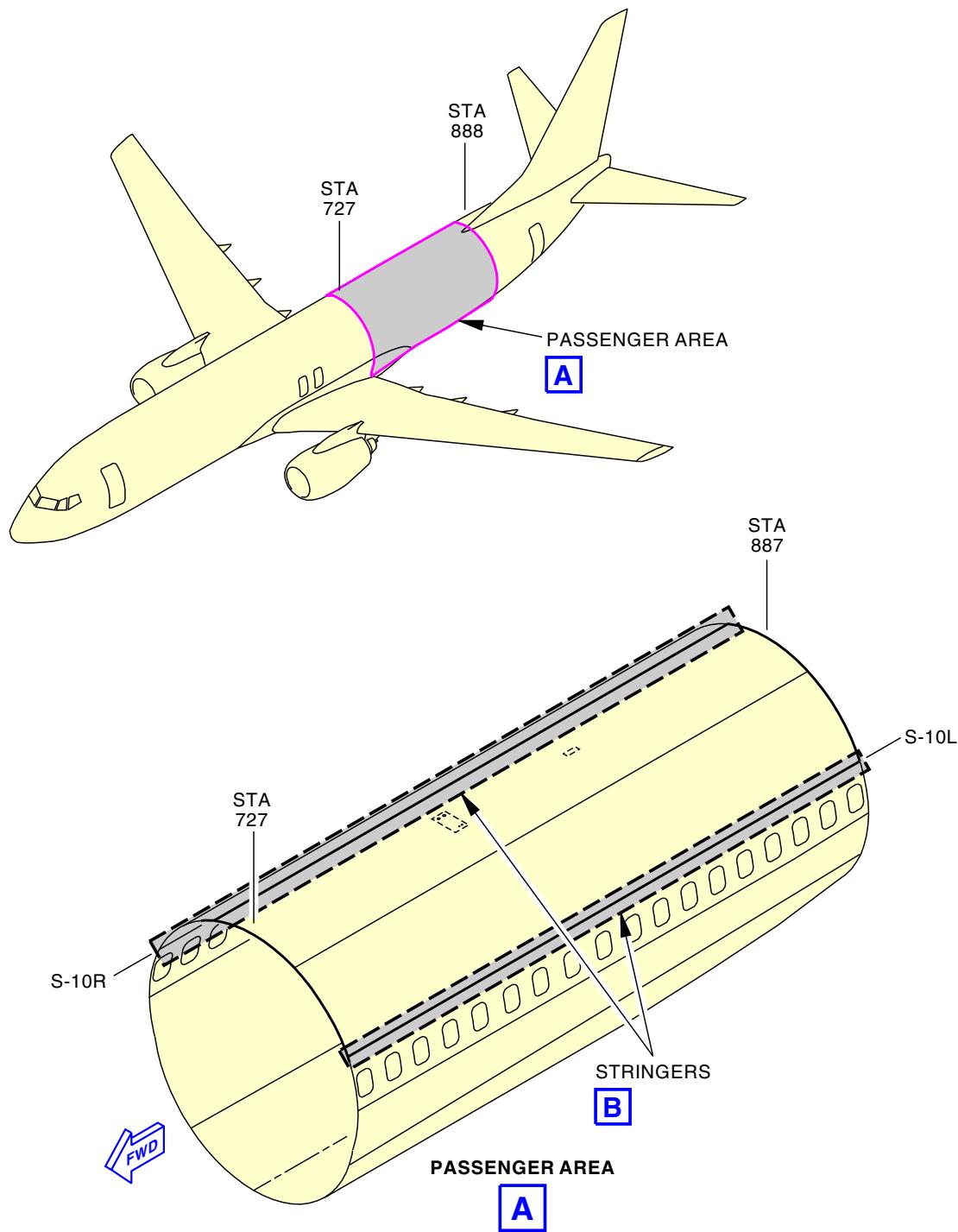
See Doc. D626A001-DTR, DTR check form 53-30-04-4, for alternative inspections.

————— END OF TASK ————





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3026851 S0000798243\_V1

Longitudinal Lap Splice STA 727 to STA 887  
Figure 282/53-05-02-990-837 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

**53-05-02**

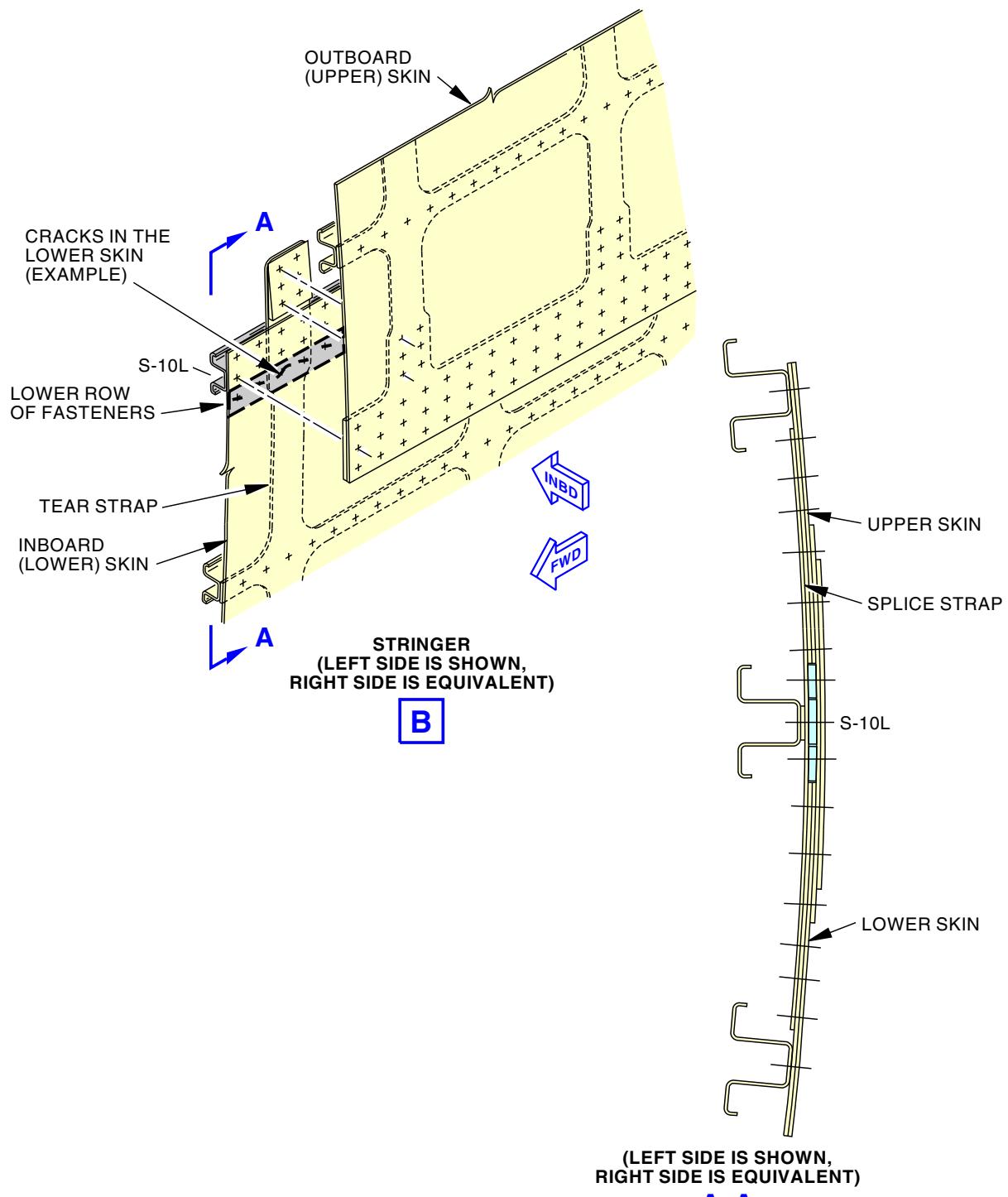
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.130  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



(LEFT SIDE IS SHOWN,  
RIGHT SIDE IS EQUIVALENT)

A-A

3026852 S0000798244\_V1

Longitudinal Lap Splice STA 727 to STA 887  
Figure 282/53-05-02-990-837 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

53-05-02



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-871**

**173. EXTERNAL - DETAILED: LONGITUDINAL LAP SPLIC**

Figure 283

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-071

- (1) Do a Detailed inspection of the upper skin along the upper fastener row at stringers S-14L and S-14R from STA 727 to STA 887. (PSE 53-60-04-5)

See Doc. D626A001-DTR, DTR check form 53-30-04-5, for alternative inspections.

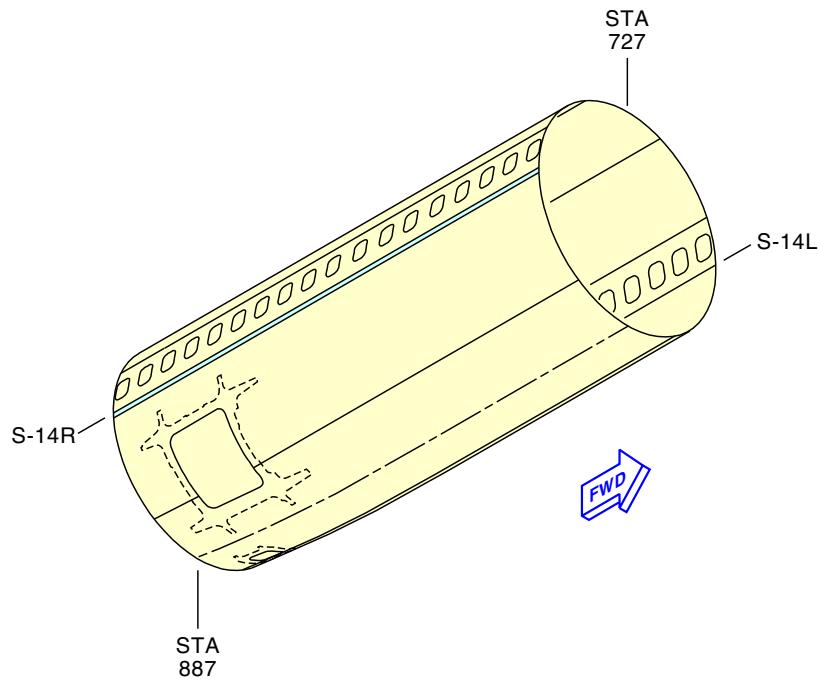
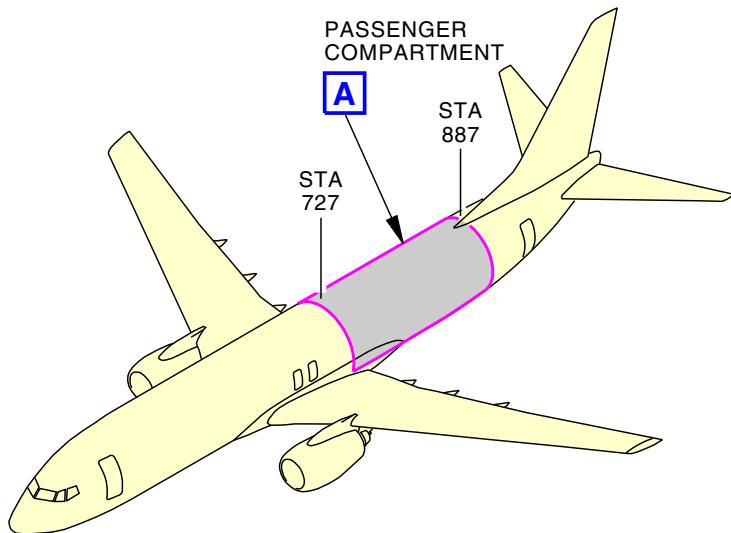
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT

A

3026876 S0000798249\_V1

Longitudinal Lap Splice STA 727 to STA 887  
Figure 283/53-05-02-990-839

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-946**

**174. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLIC**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-146

- (1) Do a Low Frequency Eddy Current inspection of the lower skin along the lower fastener row at stringers S-14L and S-14R from STA 727 to STA 887. (PSE 53-60-04-6).  
See Doc. D626A001-DTR, DTR check form 53-30-04-6, for alternative inspections.  
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 53-30-50.

————— END OF TASK ————

**TASK 53-05-02-250-948**

**175. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
142	Aft Cargo Compartment - Right
144	Area Below Aft Cargo Compartment - Right

**B. Access Panels**

Number	Name/Location
822	Aft Cargo Door

**C. Inspection**

SUBTASK 53-05-02-010-113

- (1) Open this access panel:

Number	Name/Location
822	Aft Cargo Door

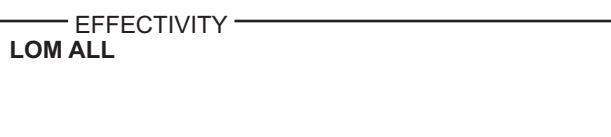
NOTE: Removal of aft cargo door scuff plate is required to perform the inspection.

SUBTASK 53-05-02-250-148

- (2) Do a Low Frequency Eddy Current inspection around the fasteners common to the web at the lower main sill chords between STA 807 and STA 827. (PSE 53-60-08).

See Doc. D626A001-DTR, DTR check form 53-30-08-12, for alternative inspections.

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 53-11-56.





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-05-02-410-111

- (3) Close this access panel:

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

———— END OF TASK ————

**TASK 53-05-02-250-949**

**176. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-115

- (1) Open this access panel:

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

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

SUBTASK 53-05-02-250-149

- (2) Do a High Frequency Eddy Current inspection of the upper sill outer chord around the fasteners common to the chord and bearstrap. (PSE 53-60-08-10).

See Doc. D626A001-DTR, DTR check form 53-30-08-10, for alternative inspections.

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 53-11-48.

SUBTASK 53-05-02-410-113

- (3) Close this access panel:

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

———— END OF TASK ————

**TASK 53-05-02-250-974**

**177. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-117

- (1) Open this access panel:

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

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

SUBTASK 53-05-02-250-174

- (2) Do a High Frequency Eddy Current inspection of the bearstrap along the upper edge of the aft cargo door. (53-60-08-10).

See Doc. D626A001-DTR, DTR check form 53-30-08-10, for alternative inspections.

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 53-11-48.

SUBTASK 53-05-02-410-115

- (3) Close this access panel:

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

———— END OF TASK ————

**TASK 53-05-02-250-950**

**178. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-114

- (1) Open this access panel:

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

SUBTASK 53-05-02-250-150

- (2) Do a High Frequency Eddy Current inspection of the bearstrap for two inches on each side of stringer S-24R at STA 794.4 and STA 847. (PSE 53-60-08-6)

EFFECTIVITY
LOM ALL

**53-05-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

See Doc D626A001-DTR, DTR check form 53-30-08-6 for alternative inspections. 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 53-10-91.

SUBTASK 53-05-02-410-112

- (3) Close this access panel:

Number    Name/Location

822              Aft Cargo Door

———— END OF TASK ————

**TASK 53-05-02-130-809**

**179. INTERNAL - SPECIAL DETAILED: AFT CARGO DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-02-010-008

- (1) Open this access panel:

Number    Name/Location

822              Aft Cargo Door

SUBTASK 53-05-02-130-009

- (2) Do an Ultrasonic inspection of the bearstrap for hidden damage under the stop backup fitting at stringer S-24R at STA 794.4 and STA 847. (PSE 53-60-08-6).

See Doc D626A001-DTR, DTR check form 53-30-08-6 for alternative inspections. 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 53-10-07.

SUBTASK 53-05-02-410-006

- (3) Close this access panel:

Number    Name/Location

822              Aft Cargo Door

———— END OF TASK ————

**TASK 53-05-02-250-951**

**180. EXTERNAL - SPECIAL DETAILED: LONGITUDINAL LAP SPLICE**

NOTE: This procedure is a scheduled maintenance task.

———— EFFECTIVITY ————  
LOM ALL

**53-05-02**

Page 298.137  
Jun 15/2024



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Inspection**

SUBTASK 53-05-02-250-151

- (1) Do a High Frequency Eddy Current inspection of the upper skin along the upper fastener row at stringers S-4L and S-4R from STA 887 to STA 1016. (PSE 53-70-03-1).

See Doc. D626A001-DTR, DTR check form 53-10-03-1, for alternative inspections.

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 53-30-41.

———— END OF TASK ————

**TASK 53-05-02-211-873**

**181. EXTERNAL - DETAILED: CROWN SKIN PANEL STA 887 TO STA 1016**

Figure 284

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Inspection**

NOTE: Remove Dorsal Fin as required to perform the inspection.

SUBTASK 53-05-02-211-073

- (1) Do a Detailed inspection of the skin around all of the fastener locations from stringer S-10L to S-10R, from STA 887 to STA 1016, except at the lap splices and antennas. (PSE 53-70-04-1).

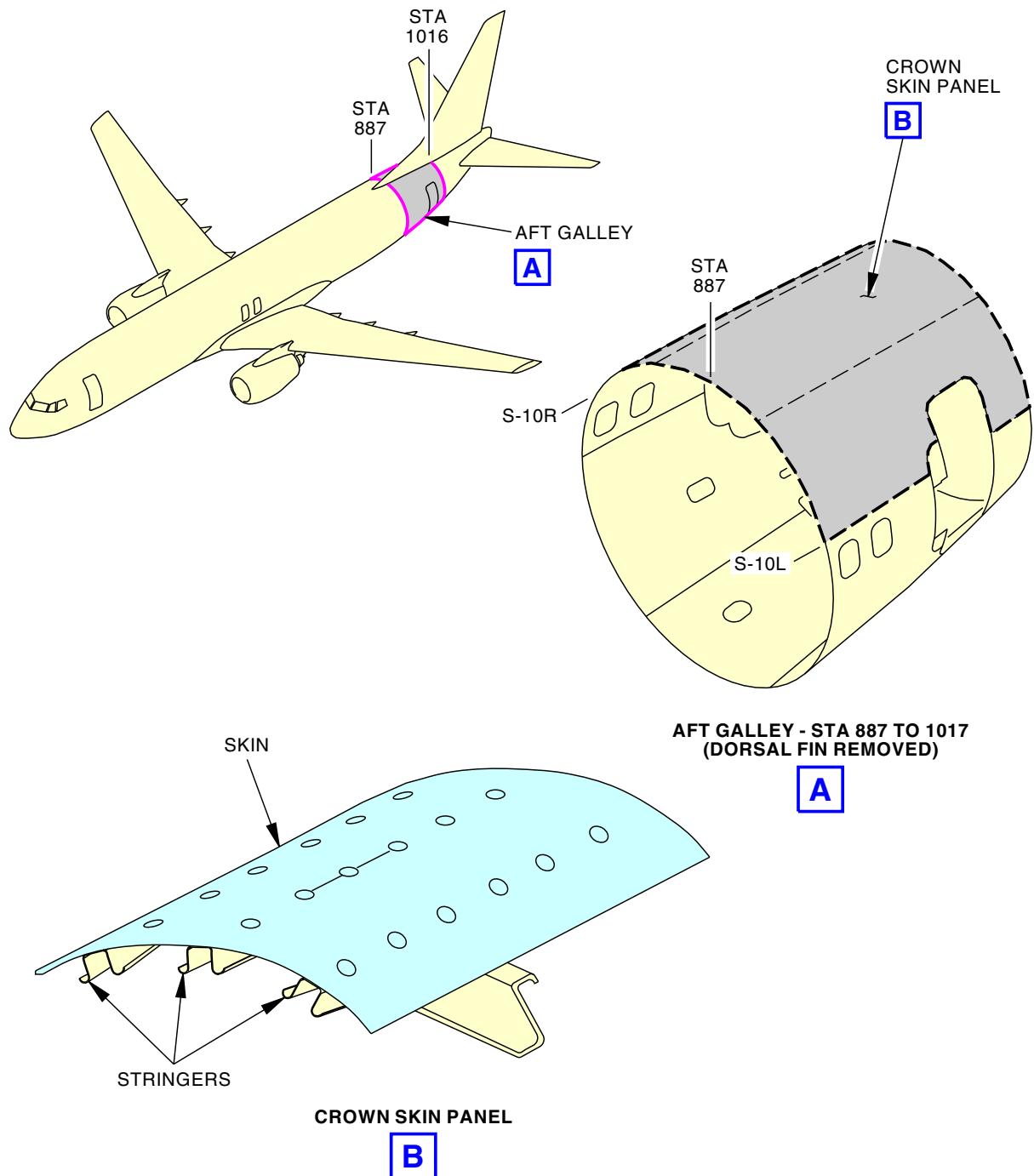
See Doc D626A001-DTR, DTR check form 53-30-01-2 for alternative inspections.

———— END OF TASK ————





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3033001 S0000803395\_V1

**Crown Skin Panel- STA 887 to 1016**  
Figure 284/53-05-02-990-841

EFFECTIVITY	LOM ALL
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D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-02**

Page 298.139  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-02-211-874

182. INTERNAL - DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE

Figure 285

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
844	Aft Galley Service Door

C. Inspection

SUBTASK 53-05-02-010-038

- (1) Open this access panel:

Number	Name/Location
844	Aft Galley Service Door

NOTE: Remove or displace passenger cabin sidewall and ceiling lining as required.

SUBTASK 53-05-02-211-074

- (2) Do a Detailed inspection of the inner chord and web along the upper main sill from STA 951 to STA 1006. (PSE 53-70-08-11).

See Doc D626A001-DTR, DTR check form 53-70-07-11 for alternative inspections.

SUBTASK 53-05-02-410-036

- (3) Close this access panel:

Number	Name/Location
844	Aft Galley Service Door

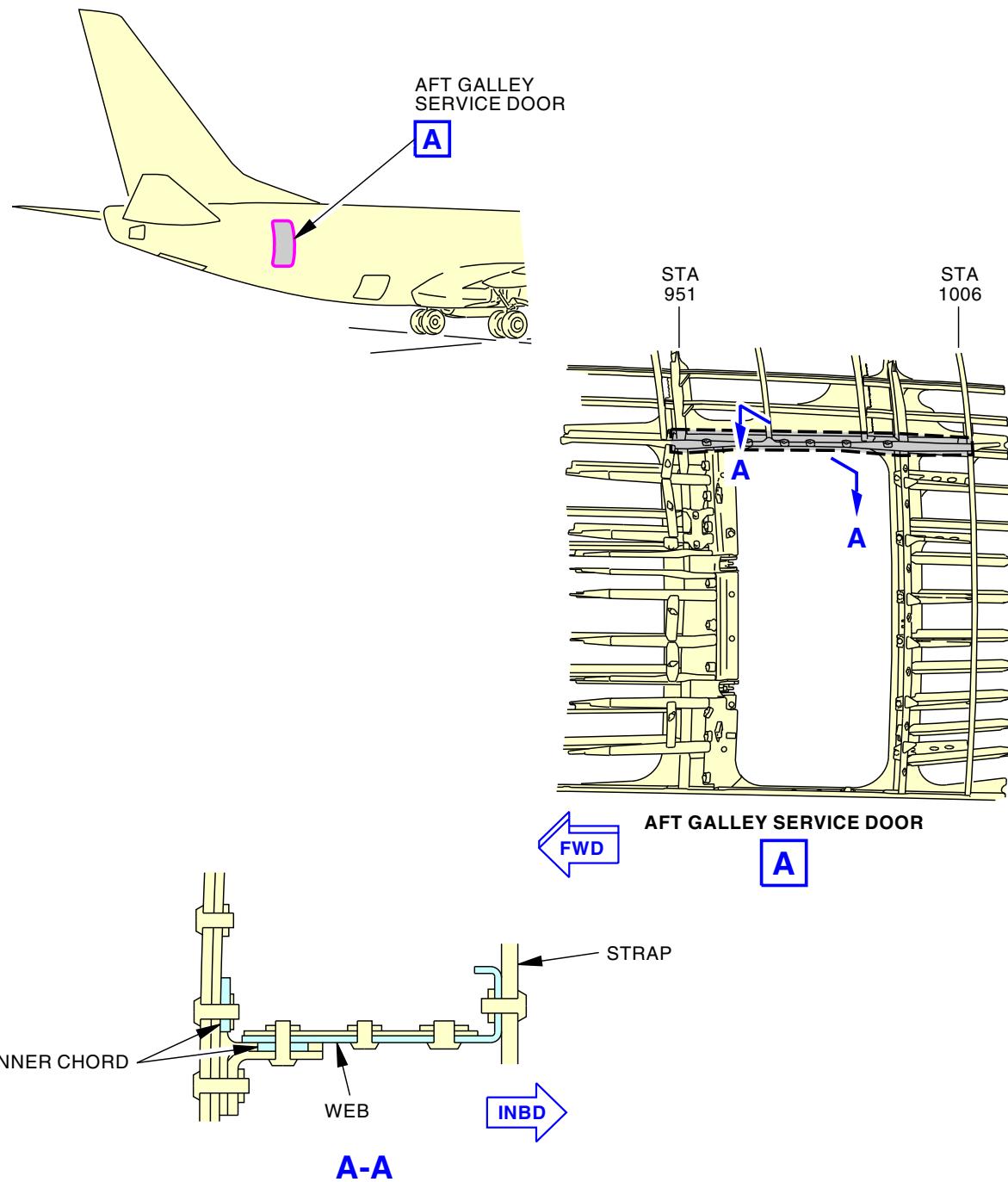
———— END OF TASK ————



**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3027159 S0000798528\_V1

Aft Entry Door Surround Structure  
Figure 285/53-05-02-990-842

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-875**

**183. EXTERNAL - DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE**

Figure 286

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
146	Aft Cargo Compartment Equipment Bay - Right
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
844	Aft Galley Service Door

**C. Inspection**

SUBTASK 53-05-02-010-039

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
844	Aft Galley Service Door

SUBTASK 53-05-02-211-075

- (2) Do a Detailed inspection of the skin around the edges of the scuff plates. (PSE 53-70-08-6).  
See Doc D626A001-DTR, DTR check form 53-70-07-6 for alternative inspections.

SUBTASK 53-05-02-410-037

- (3) Close this access panel:

<b>Number</b>	<b>Name/Location</b>
844	Aft Galley Service Door

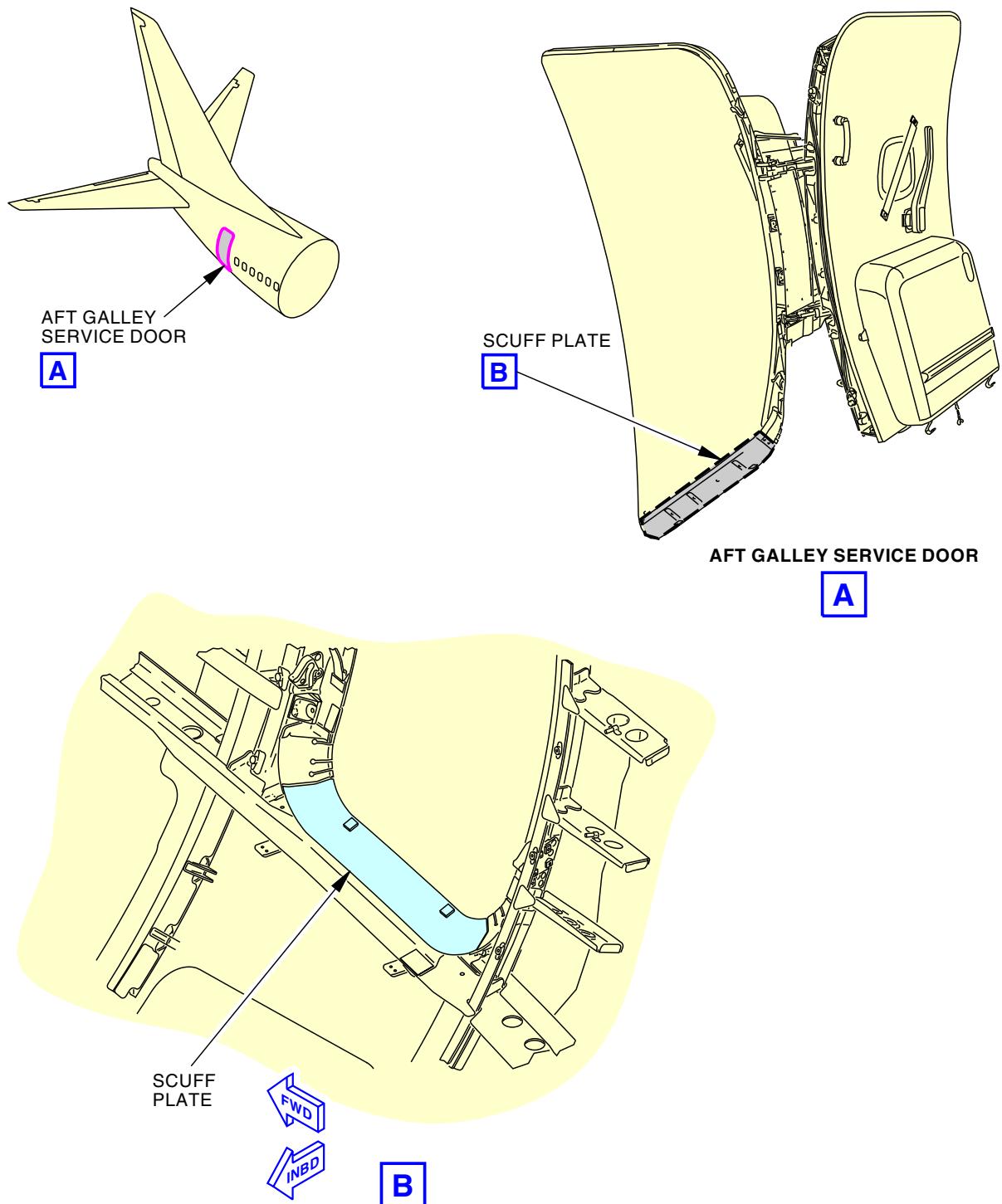
———— END OF TASK ————

— EFFECTIVITY —

LOM ALL



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3028131 S0000799378\_V1

Aft Galley Service Door Surround Structure - Scuff Plate  
Figure 286/53-05-02-990-922

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

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Page 298.143  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-953**

**184. INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
146	Aft Cargo Compartment Equipment Bay - Right
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Access Panels**

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

**C. Inspection**

SUBTASK 53-05-02-010-116

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

NOTE: Remove scuff plate.

SUBTASK 53-05-02-250-153

- (2) Do a High Frequency Eddy Current inspection on the skin around the fastener holes hidden by the scuff plate. (PSE 53-70-08-6).

See Doc D626A001-DTR, DTR check form 53-70-07-6 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 53-30-34.

SUBTASK 53-05-02-410-114

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door

NOTE: Re-attach scuff plate.

———— END OF TASK ————

**TASK 53-05-02-211-876**

**185. INTERNAL - DETAILED: WINDOW BELT STA 888 to 927**

Figure 287

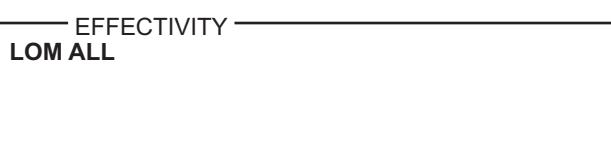
NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Inspection**

NOTE: Remove and/or displace passenger cabin sidewalls or sidewall window assemblies and insulation blankets as required.



**53-05-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-05-02-211-076

- (1) Do a Detailed inspection of the window frames around each window from STA 888 to STA 927.  
(PSE 53-70-09)

See Doc D626A001-DTR, DTR check form 53-60-05-2 for alternative inspections.

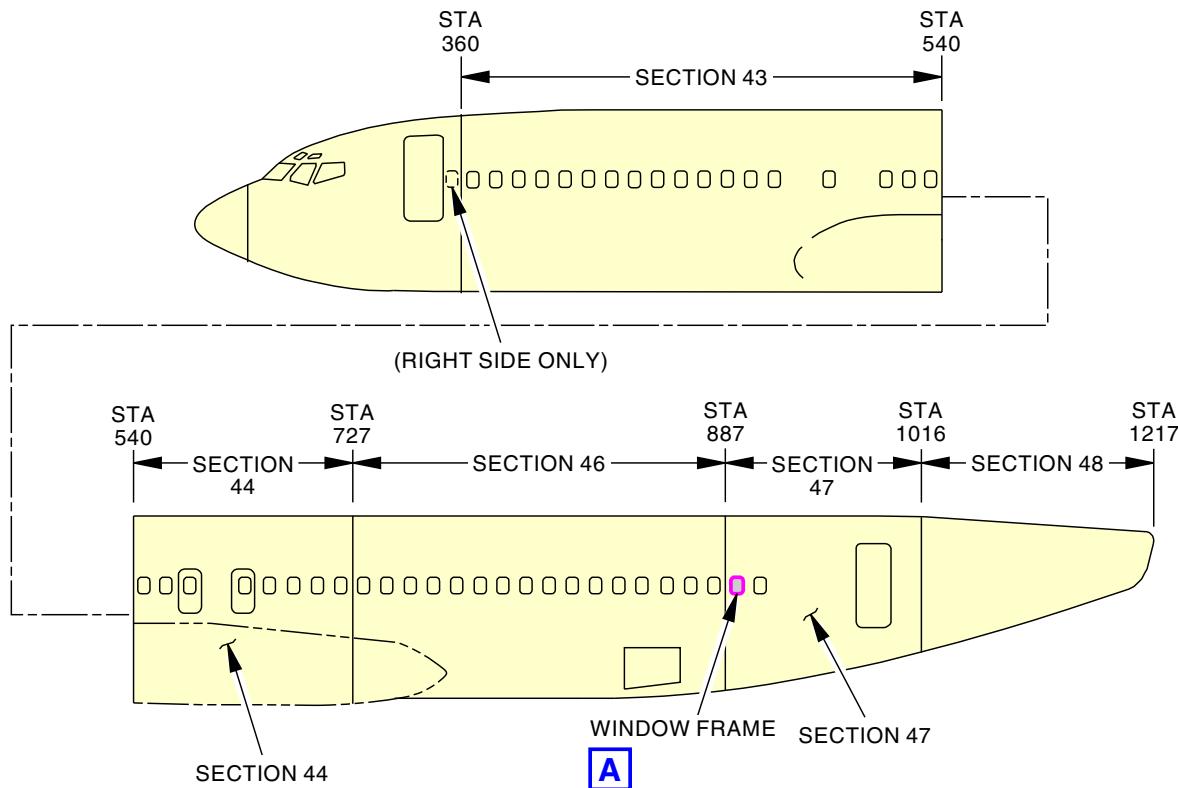
———— END OF TASK ————

— EFFECTIVITY —  
**LOM ALL**

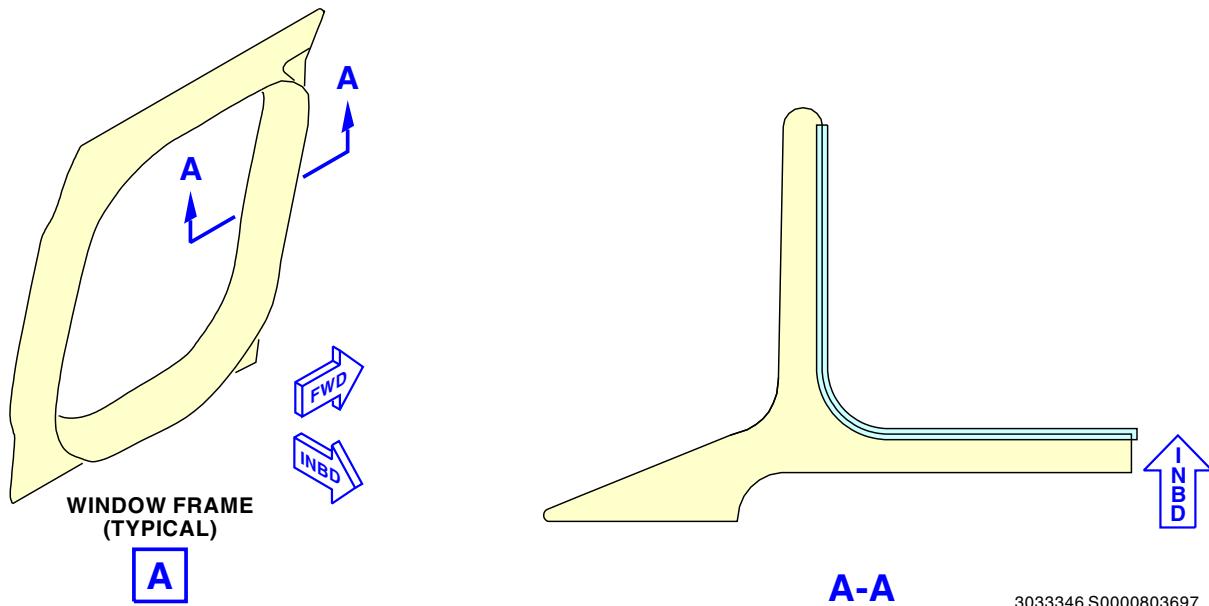
**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



(LEFT SIDE IS SHOWN, RIGHT SIDE IS EQUIVALENT)



3033346 S0000803697\_V1

Window Belt - STA 888 to 927  
Figure 287/53-05-02-990-843

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

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Page 298.146  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-877**

**186. EXTERNAL - DETAILED: WINDOW BELT STA 888 to 927**

Figure 288Figure 289

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-077

- (1) Do a Detailed inspection of the window frames around each window from STA 888 to STA 927.  
(PSE 53-70-09)

See Doc D626A001-DTR, DTR check form 53-60-05-2 for alternative inspections.

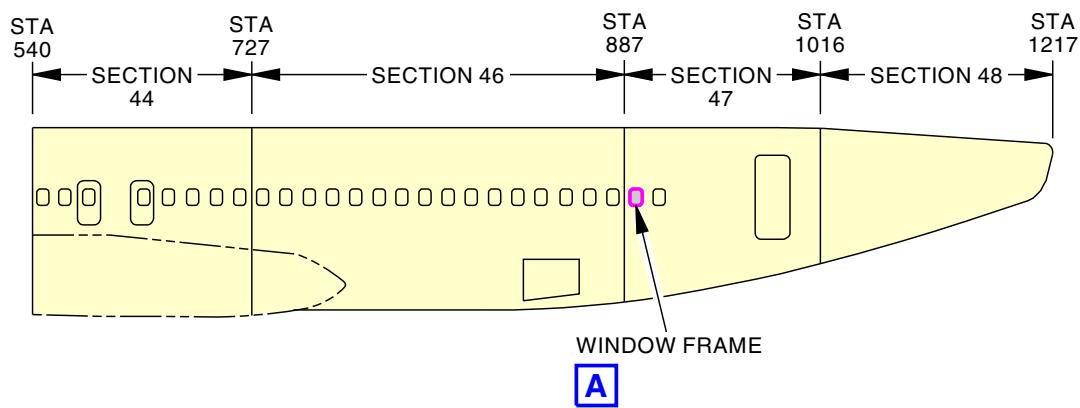
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



(LEFT SIDE IS SHOWN, RIGHT SIDE IS EQUIVALENT)

3034082 S0000804217\_V1

**Window Belt STA 888 to 927**  
**Figure 288/53-05-02-990-844**

EFFECTIVITY  
LOM ALL

**53-05-02**

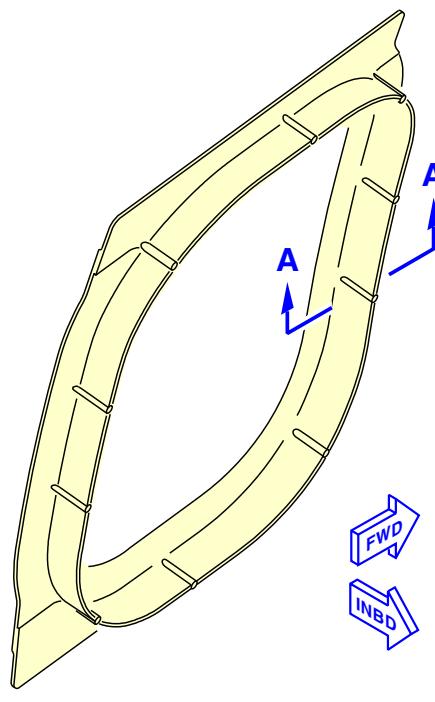
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.148  
Jun 15/2024

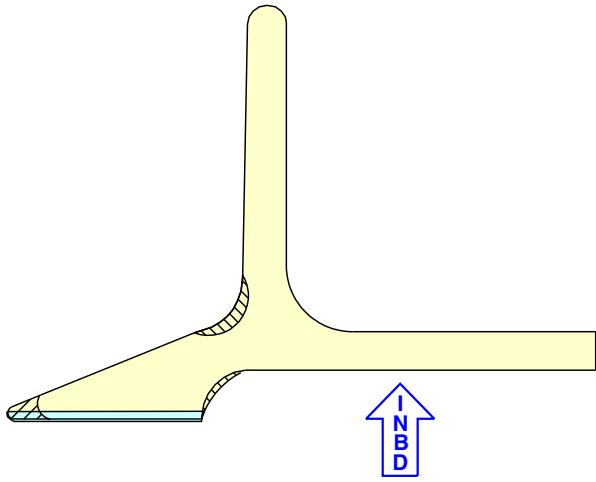


737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



WINDOW FRAME  
(TYPICAL)

A



A-A

3028479 S0000799492\_V1

Window Belt STA 888 to STA 927  
Figure 289/53-05-02-990-845

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.149  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-997**

**187. INTERNAL - SPECIAL DETAILED: AFT ENTRY DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Access Panels**

<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door

**C. Inspection**

SUBTASK 53-05-02-010-172

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door

NOTE: Remove scuff plates as required for access to the outer chord.

SUBTASK 53-05-02-250-197

- (2) Do a High Frequency Eddy Current inspection of the first five fasteners on the upper flange of the lower main sill outer chord, aft of the edge frame.

See Doc D626A001-DTR, DTR check form 53-70-07-12 for alternative inspections.

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 53-11-20.

SUBTASK 53-05-02-410-163

- (3) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door

NOTE: Re-attach scuff plates as required.

— END OF TASK —

**TASK 53-05-02-250-A79**

**188. INTERNAL - SPECIAL DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Access Panels**

<u>Number</u>	<u>Name/Location</u>
844	Aft Galley Service Door



**53-05-02**

Page 298.150  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

C. Inspection

SUBTASK 53-05-02-010-173

- (1) Open this access panel:

Number    Name/Location

844              Aft Galley Service Door

NOTE: Remove scuff plates as required for access to the outer chord.

SUBTASK 53-05-02-250-279

- (2) Do a High Frequency Eddy Current inspection on the first five fasteners on the upper flange of the lower main sill outer chord, aft of the edge frame. (53-70-08-12).

See Doc D626A001-DTR, DTR check form 53-70-07-12 for alternative inspections.

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 53-11-20.

SUBTASK 53-05-02-410-164

- (3) Close this access panel:

Number    Name/Location

844              Aft Galley Service Door

NOTE: Re-attach scuff plates as required.

———— END OF TASK ————

**TASK 53-05-02-210-837**

**189. INTERNAL - GENERAL VISUAL: PRESSURE DECK ATTACHMENTS TO REAR SPAR EXTENSION**

Figure 290Figure 291

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone    Area

133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right

B. Inspection

NOTE: Removal of the fillet seal is required.

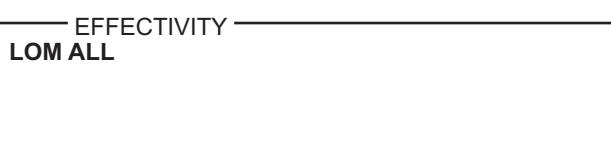
SUBTASK 53-05-02-210-037

- (1) Do a General Visual inspection of the angle between the rear spar extension and the pressure deck from the AFT or FWD side, including the bend radius at STA 663.

NOTE: Either the AFT or FWD side inspection may be performed.

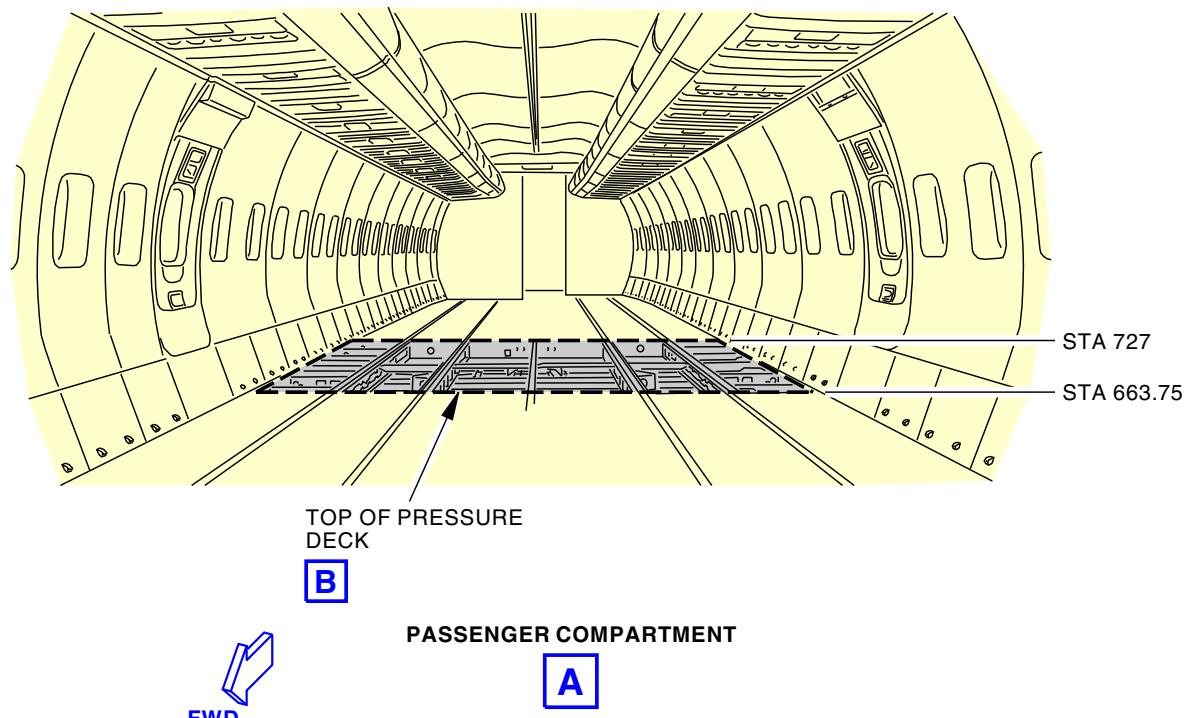
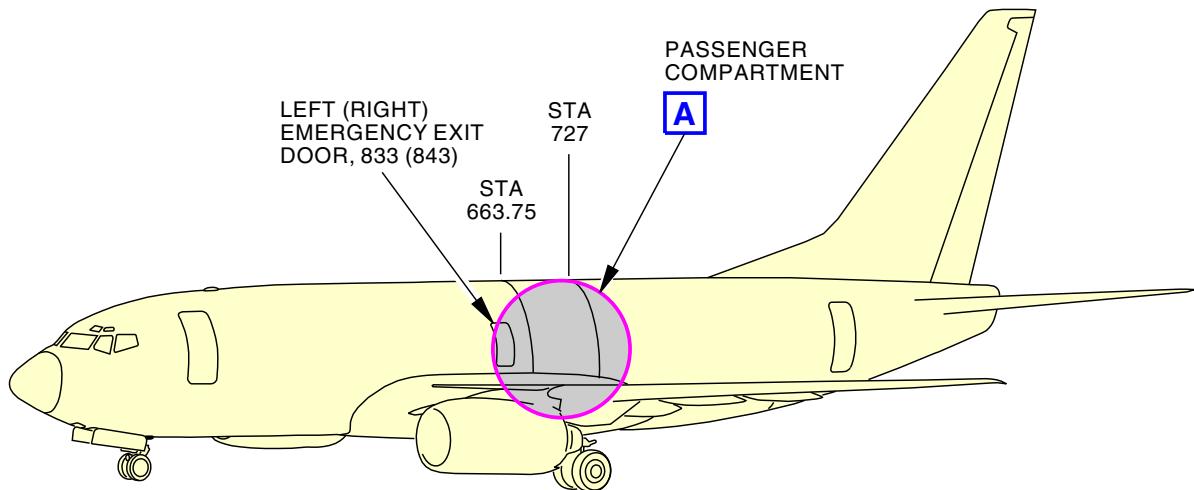
See Doc. D626A001-DTR, DTR check form 53-40-24-1 for alternative inspections.

———— END OF TASK ————





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-200-00

3026372 S0000797772\_V1

Pressure Deck Attachments to Rear Spar Extension  
Figure 290/53-05-02-990-815

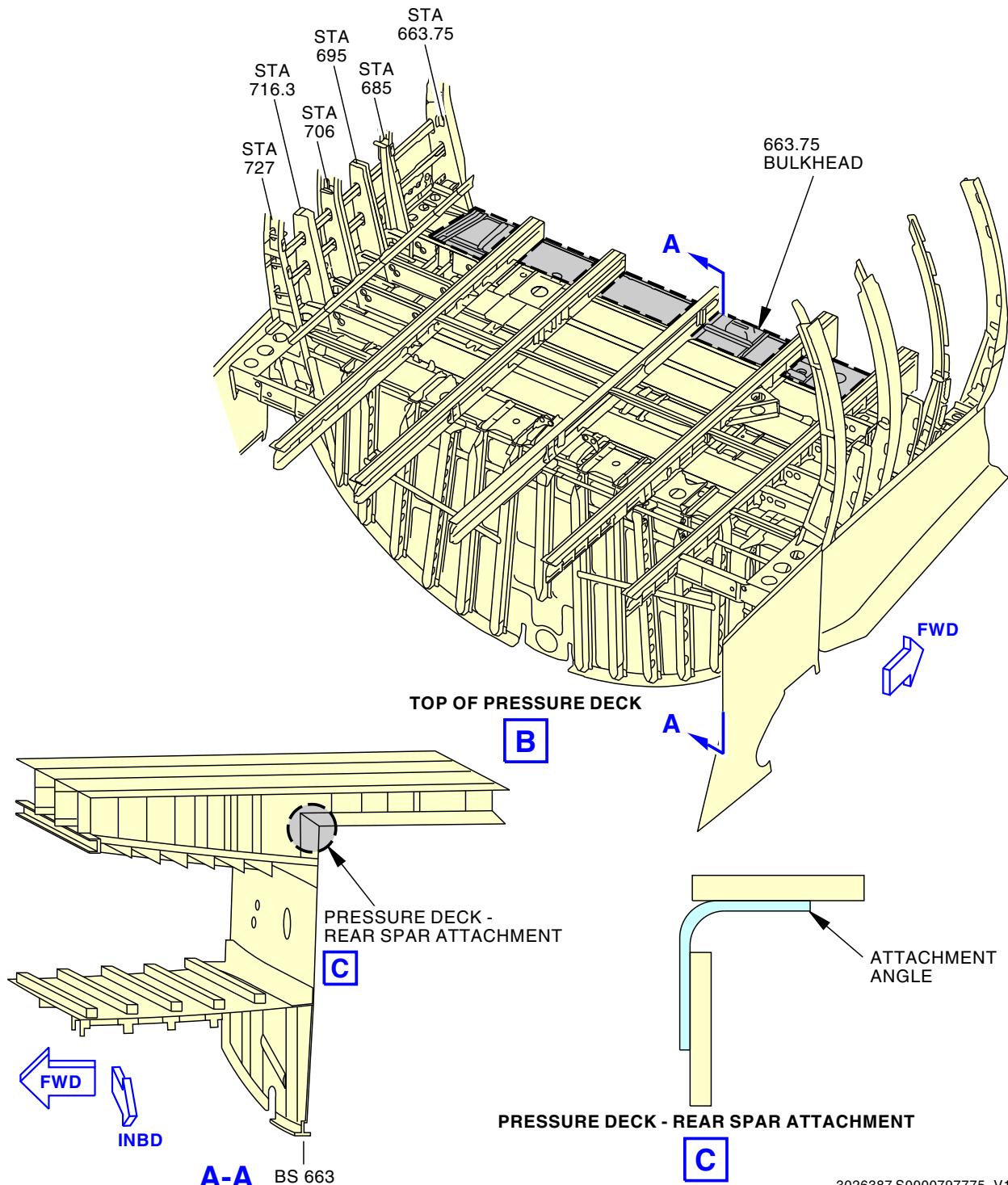
EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-02**

Page 298.152  
Jun 15/2024



3026387 S0000797775\_V1

**Pressure Deck Attachments to Rear Spar Extension**  
**Figure 291/53-05-02-990-816**

EFFECTIVITY  
 LOM ALL

D633A101-LOM

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**53-05-02**

 Page 298.153  
 Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-A98**

**190. EXTERNAL - SPECIAL DETAILED: AFT WHEEL WELL BULKHEAD, STA 727**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-250-303

- (1) Do a High Frequency Eddy Current inspection of the chord at frame 727 from stringers S-21L to S-27L and stringers S-21R to S-27R.

See Doc. D626A001-DTR, DTR check form 53-40-16-1b for alternative inspections.

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 53-10-93.

———— END OF TASK ————

**TASK 53-05-02-211-981**

**191. INTERNAL - DETAILED: AFT ENTRY DOOR SURROUND STRUCTURE**

Figure 292

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

Number	Name/Location
834	Aft Entry Door

**C. Inspection**

SUBTASK 53-05-02-010-176

- (1) Open this access panel:

Number	Name/Location
834	Aft Entry Door

NOTE: Remove or displace passenger cabin sidewall and ceiling lining as required to perform the inspection.

**D. Procedure**

SUBTASK 53-05-02-211-181

- (1) Do a Detailed inspection of the inner chord strap near the edge frames from STA 951 to STA 1006.





**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

See Doc D626A001-DTR, DTR check form 53-70-07-11 for alternative inspections.

SUBTASK 53-05-02-410-168

- (2) Close this access panel:

**Number      Name/Location**

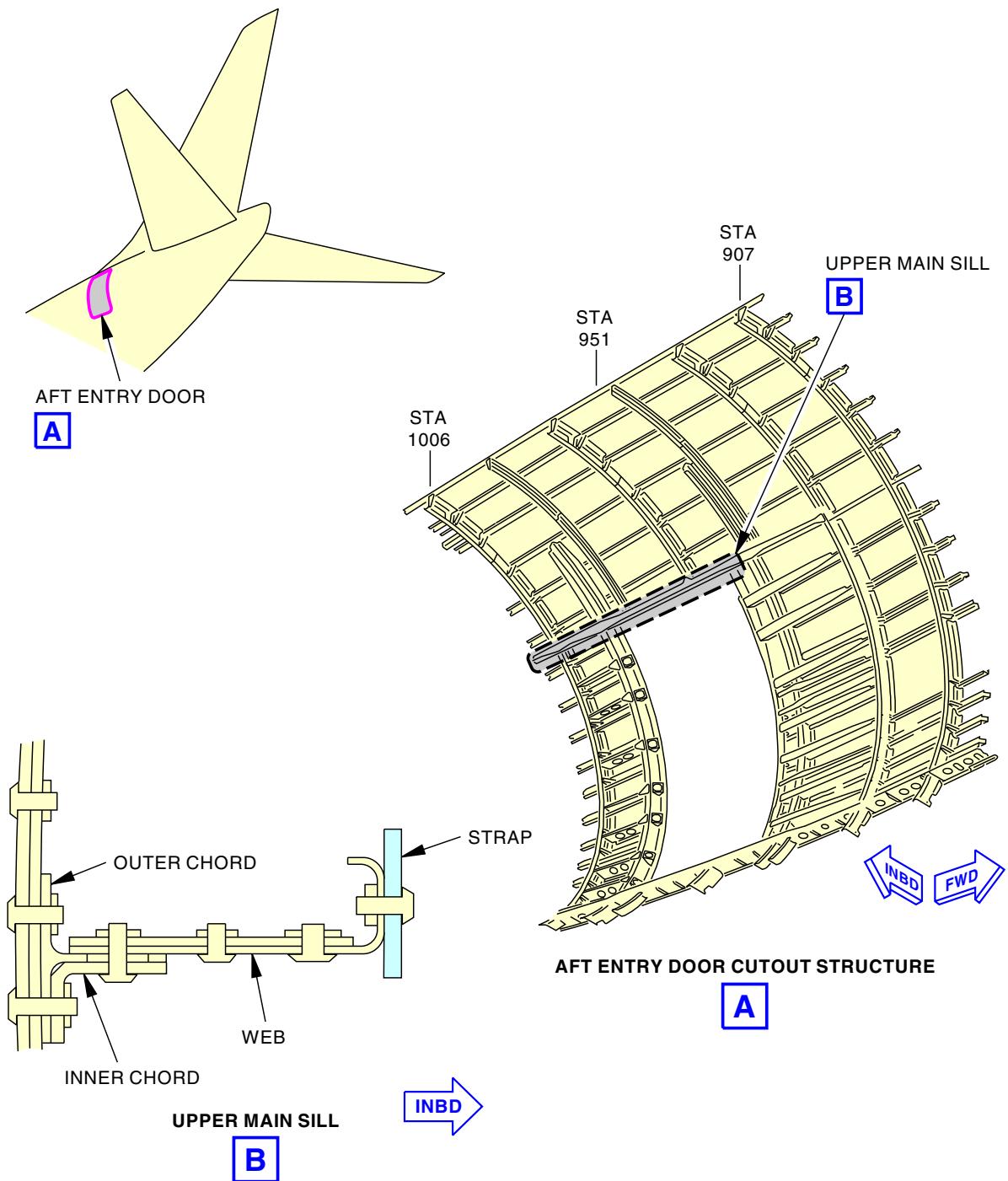
834            Aft Entry Door

NOTE: Re-attach passenger cabin sidewall and ceiling lining as required.

———— END OF TASK ————

— EFFECTIVITY —  
**LOM ALL**

**53-05-02**



3033004 S0000803500\_V1

**AFT Entry Door Upper Main Sill**  
**Figure 292/53-05-02-990-846**

 EFFECTIVITY  
 LOM ALL

**53-05-02**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

TASK 53-05-02-211-982

192. INTERNAL - DETAILED: AFT GALLEY DOOR SURROUND STRUCTURE

Figure 293

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
844	Aft Galley Service Door

C. Inspection

SUBTASK 53-05-02-010-177

- (1) Open this access panel:

Number	Name/Location
844	Aft Galley Service Door

NOTE: Remove or displace passenger cabin sidewall and ceiling lining as required to perform the inspection.

SUBTASK 53-05-02-211-183

- (2) Do a Detailed inspection of the inner chord strap near the edge frames from STA 951 to STA 1006. (PSE 53-70-08-11).

See Doc D626A001-DTR, DTR check form 53-70-07-11 for alternative inspections.

SUBTASK 53-05-02-410-170

- (3) Close this access panel:

Number	Name/Location
844	Aft Galley Service Door

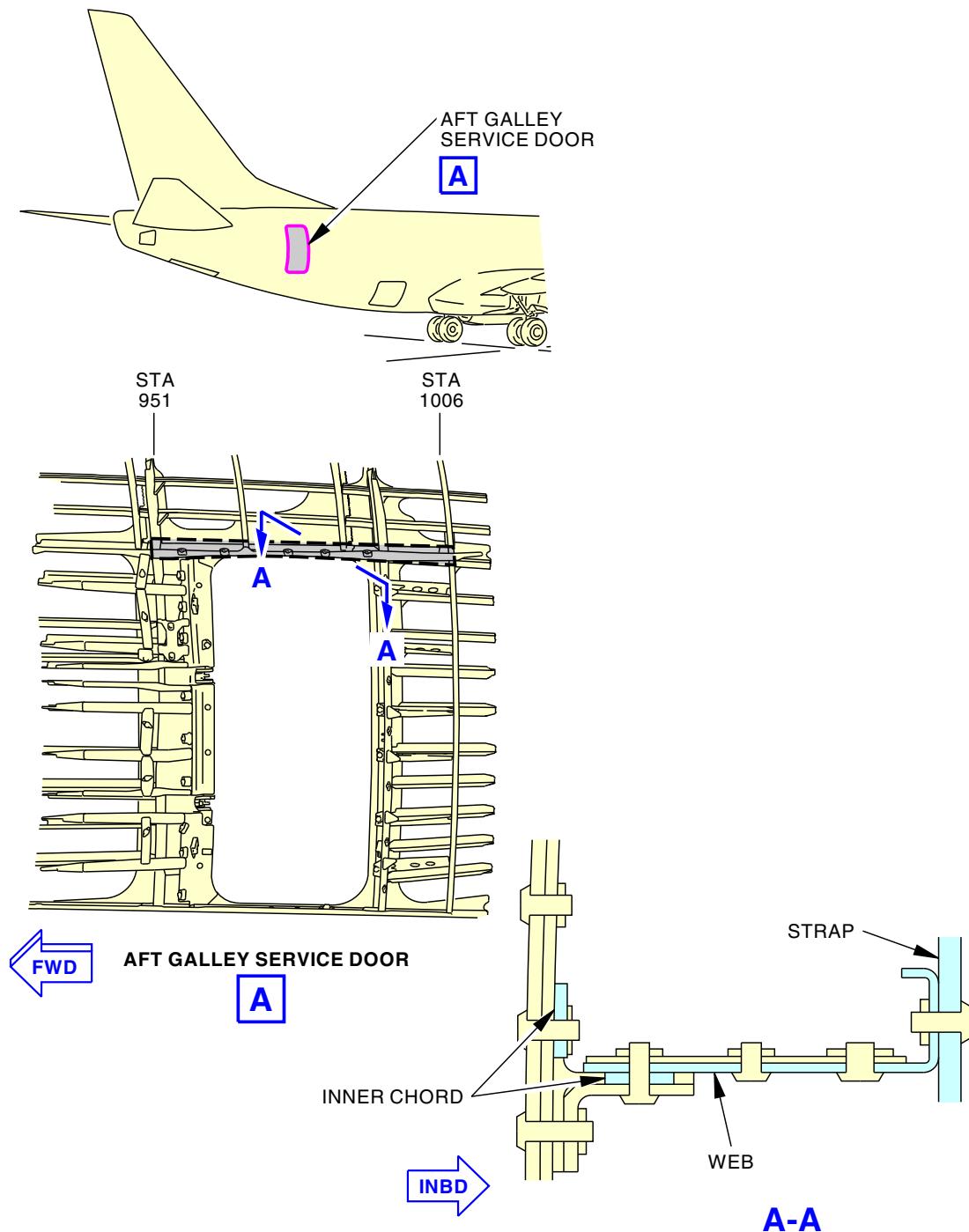
NOTE: Re-attach passenger cabin sidewall and ceiling lining as required.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL



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3027217 S0000798598\_V1

AFT Galley Door Surround Structure  
Figure 293/53-05-02-990-847

EFFECTIVITY  
LOM ALL

**53-05-02**

Page 298.158  
Jun 15/2024

D633A101-LOM



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-211-988**

**193. EXTERNAL- DETAILED : CROWN SKIN PANEL - STA 540 TO 727**

Figure 294

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Inspection**

SUBTASK 53-05-02-211-190

- (1) Remove antenna fairing, antenna and baseplate as required to expose skin.

SUBTASK 53-05-02-211-189

- (2) Inspect (Detailed) the skin around all of the structure locations from VHF Antenna Sta 630 between S-1 and S-2R, ADF Antenna Sta 694 between S-1 and S-2R (53-40-01-4).

See Doc D626A001-DTR, DTR check form 53-40-01-4 for alternative inspections.

SUBTASK 53-05-02-211-191

- (3) Install antenna fairing, antenna and baseplate as required.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

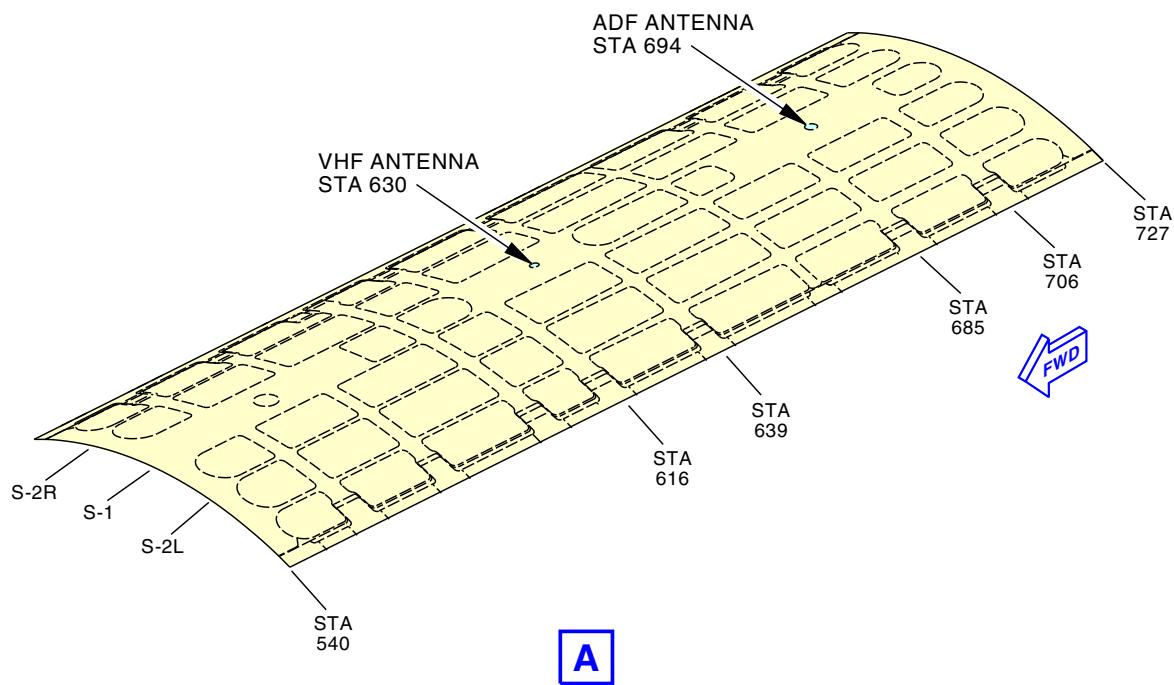
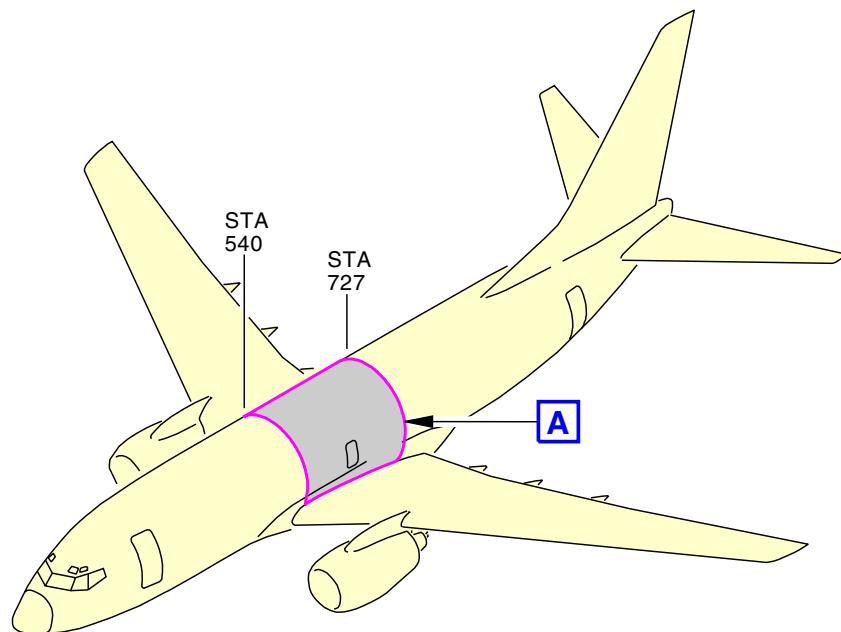
**53-05-02**

Page 298.159  
Jun 15/2024

D633A101-LOM



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3036952 S0000805484\_V1

CROWN SKIN PANEL - STA 540 to 727  
Figure 294/53-05-02-990-865

EFFECTIVITY  
LOM ALL

**53-05-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.160  
Jun 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-02-250-B09**

**194. INTERNAL - SPECIAL DETAILED: BULKHEAD STA 1016**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right
311	Area Aft of Pressure Bulkhead - Left
312	Area Aft of Pressure Bulkhead - Right

**B. Inspection**

NOTE: Remove necessary passenger cabin interiors if/as required to perform this inspection.

SUBTASK 53-05-02-250-315

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

See Doc D626A001-DTR, DTR check form 53-80-01-5B for alternative inspections.

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 53-11-11.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-02**

Page 298.161  
Jun 15/2024

D633A101-LOM





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

FUSELAGE - STRUCTURAL INSPECTIONS - MAINTENANCE PRACTICES

**TASK 53-05-03-210-801**

1. **EXTERNAL - GENERAL VISUAL: FUSELAGE LOWER LOBE, FORWARD ACCESS DOOR CUTOUT**  
(Figure 201)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
112	Area Forward of Nose Landing Gear Wheel Well

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
112A	Forward Access Door

**C. Inspection**

SUBTASK 53-05-03-010-001

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
112A	Forward Access Door

NOTE: Open forward access door.

SUBTASK 53-05-03-210-001

- (2) Do a General Visual inspection of the door cutout at forward access door.

SUBTASK 53-05-03-910-001

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-801.

SUBTASK 53-05-03-410-001

- (4) Close this access panel:

<b>Number</b>	<b>Name/Location</b>
112A	Forward Access Door

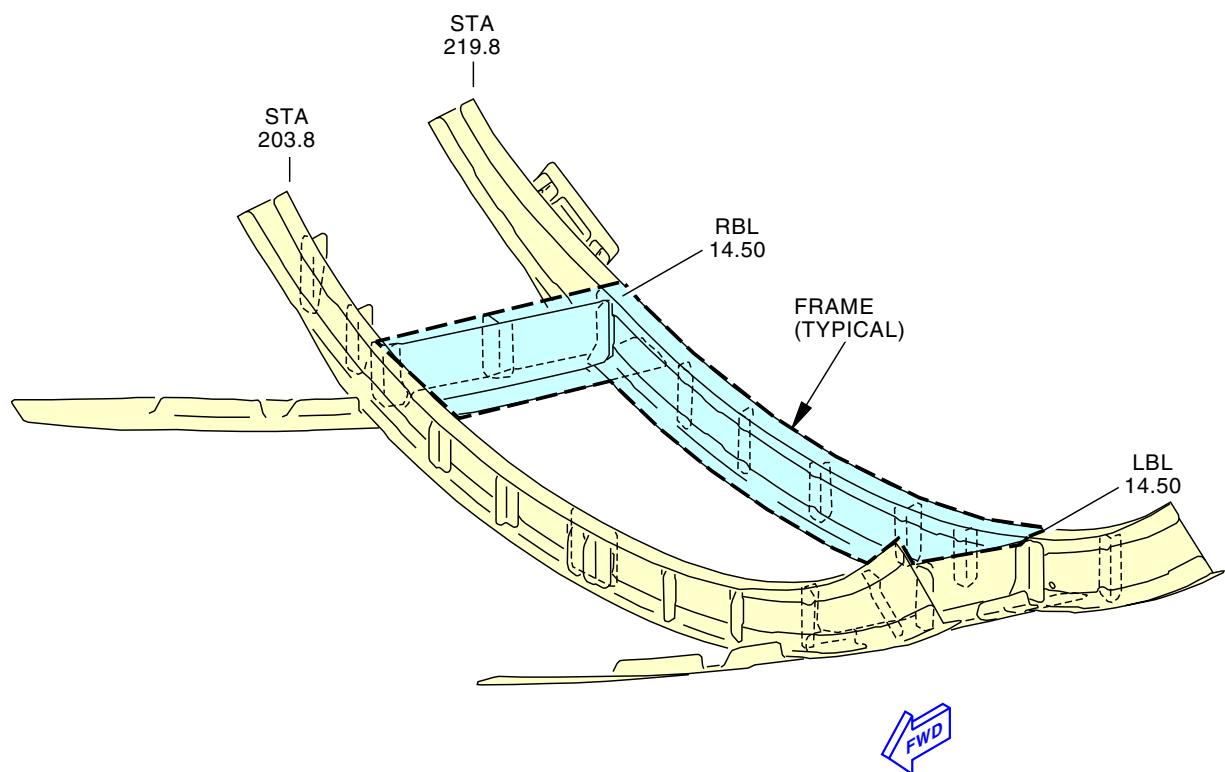
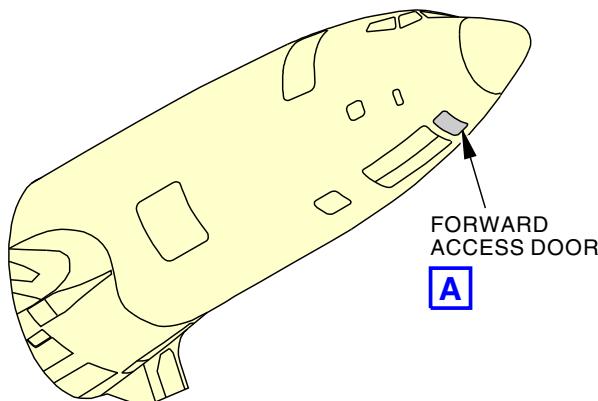
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



FORWARD ACCESS DOOR FRAME

A

H45940 S0006584592\_V2

External - Forward Access Door Cutout Frame  
Figure 201/53-05-03-990-801

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 202  
Oct 15/2015



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-802**

2. **EXTERNAL - GENERAL VISUAL: FUSELAGE LOWER LOBE, EE COMPARTMENT DOOR CUTOUT**  
(Figure 202)

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
51-05-01-210-801	737-6789 Basic Task Description (P/B 201)

**B. Location Zones**

<u>Zone</u>	<u>Area</u>
117	Electrical and Electronics Compartment - Left

**C. Access Panels**

<u>Number</u>	<u>Name/Location</u>
117A	Electronic Equipment Access Door

**D. Inspection**

SUBTASK 53-05-03-010-002

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
117A	Electronic Equipment Access Door

SUBTASK 53-05-03-210-002

- (2) Do a General Visual inspection of the door cutout at Electronic Equipment (EE) Compartment door.

SUBTASK 53-05-03-910-002

- (3) 737-6789 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 53-05-03-410-002

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
117A	Electronic Equipment Access Door

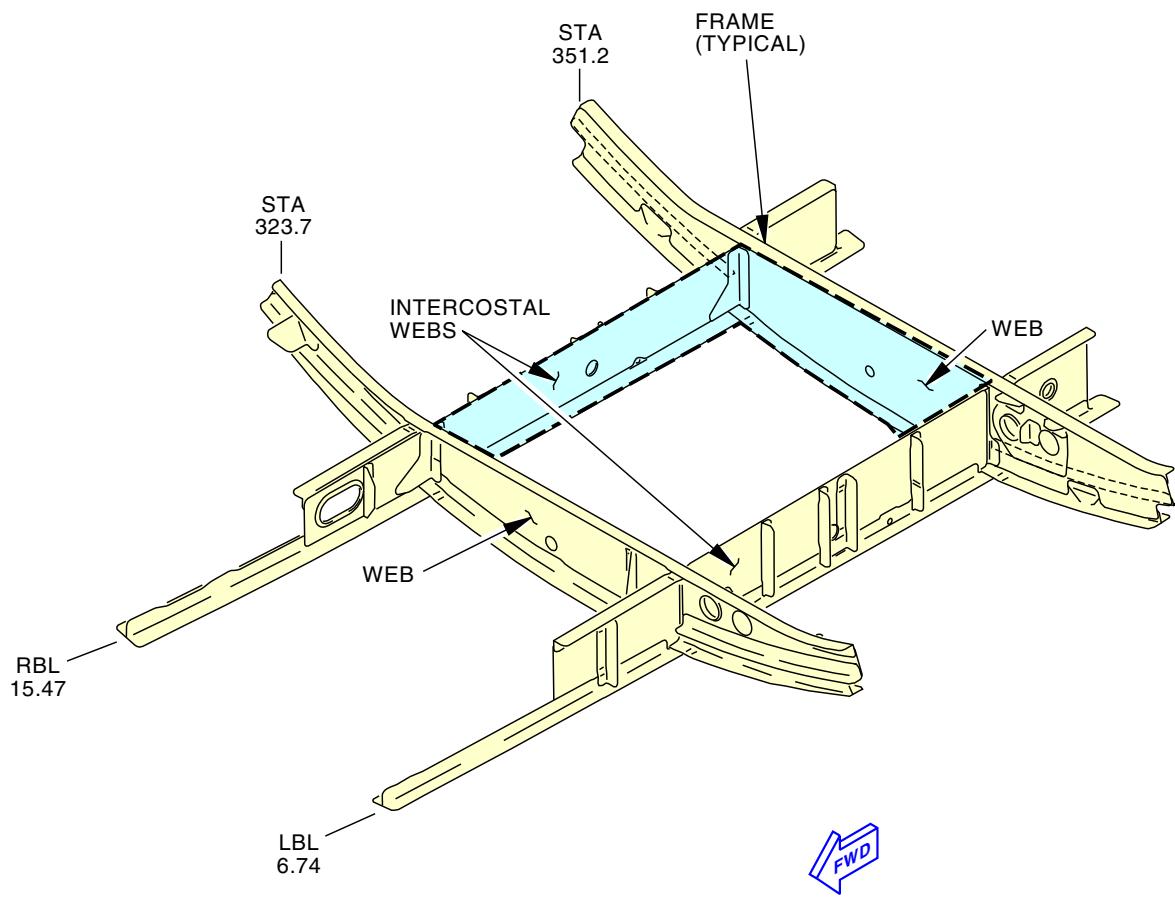
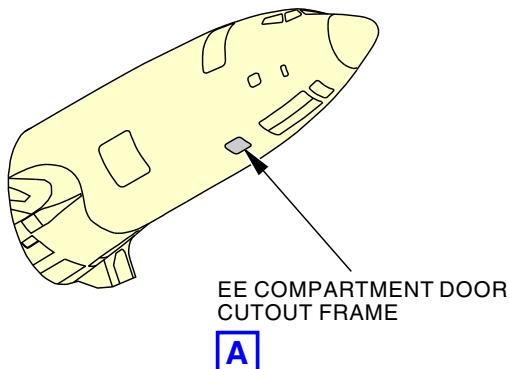
———— END OF TASK ————



**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



H45755 S0006584595\_V2

External - EE Compartment Door Cutout Frame  
Figure 202/53-05-03-990-802

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 204  
Oct 15/2015



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-804**

**3. EXTERNAL - GENERAL VISUAL: NOSE WHEEL WELL**

(Figure 203)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right

**B. Inspection**

SUBTASK 53-05-03-210-004

- (1) Do a General Visual inspection of the nose landing gear wheel well, including canted bulkhead (Sta 224.8 to 227.8), Sta 294.5 bulkhead, side and top panels, trunnion support fitting, actuator support fitting, and drag brace fitting.

SUBTASK 53-05-03-910-004

- (2) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

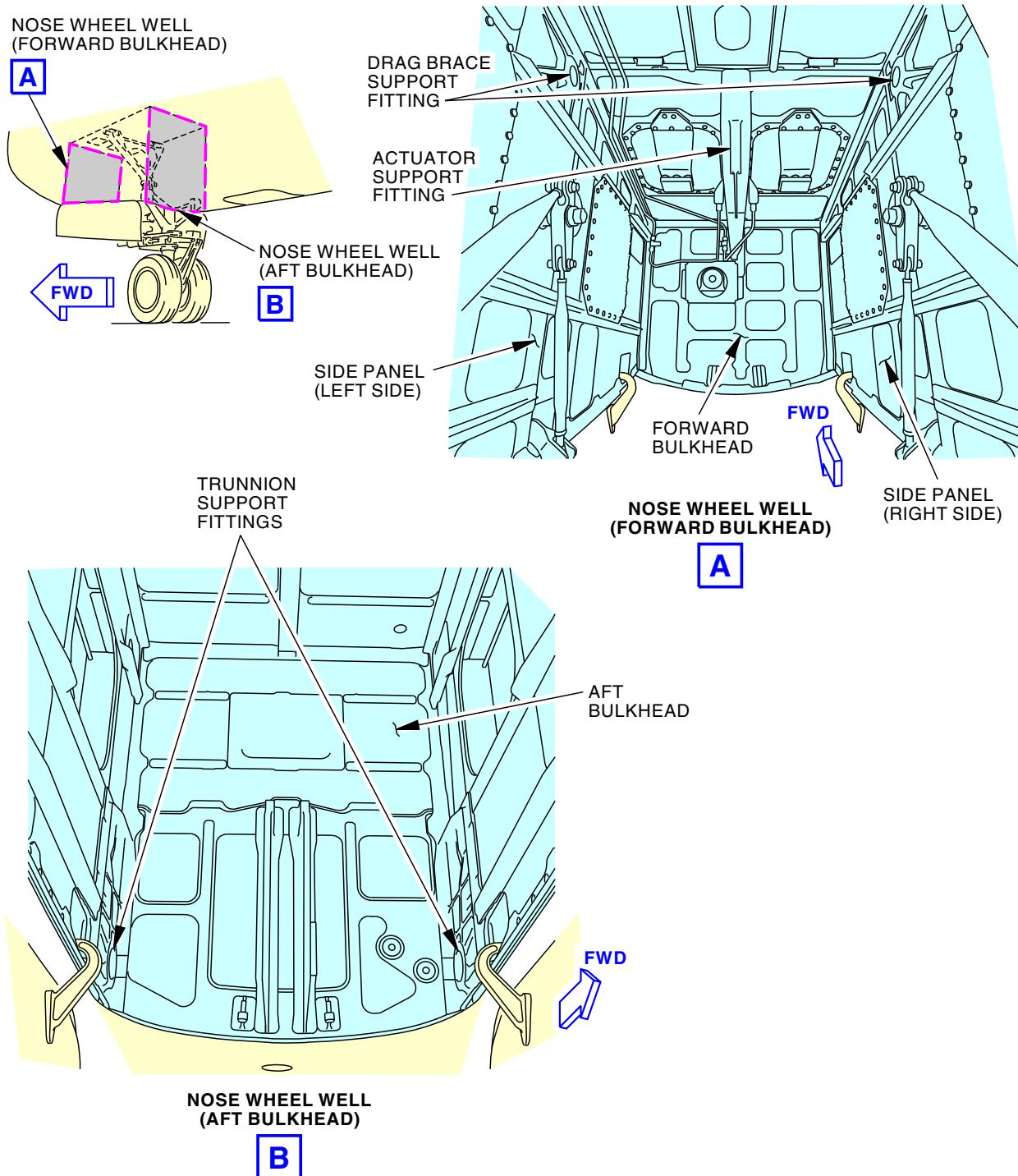
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**

Page 205  
Feb 15/2015

D633A101-LOM



D63215 S0000162566\_V2

**Nose Landing Gear Wheel Well**  
**Figure 203/53-05-03-990-831**

EFFECTIVITY  
**LOM ALL**
**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-211-801**

**4. EXTERNAL - DETAILED: FORWARD CARGO DOOR SURROUND STRUCTURE, FITTINGS AND STOPS**

(Figure 204)

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

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
122	Forward Cargo Compartment - Right

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-03-010-055

- (1) Open this access panel:

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

SUBTASK 53-05-03-211-001

- (2) Do a Detailed inspection of the forward cargo door surround structure, fittings and stops.

SUBTASK 53-05-03-910-005

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-809.

SUBTASK 53-05-03-410-055

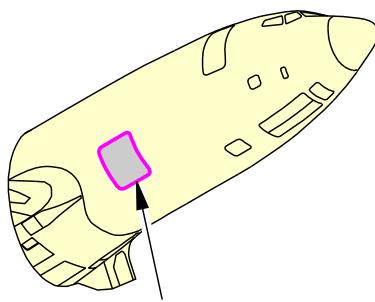
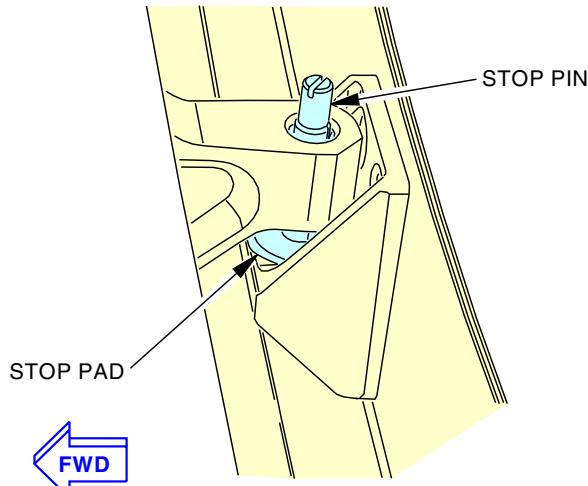
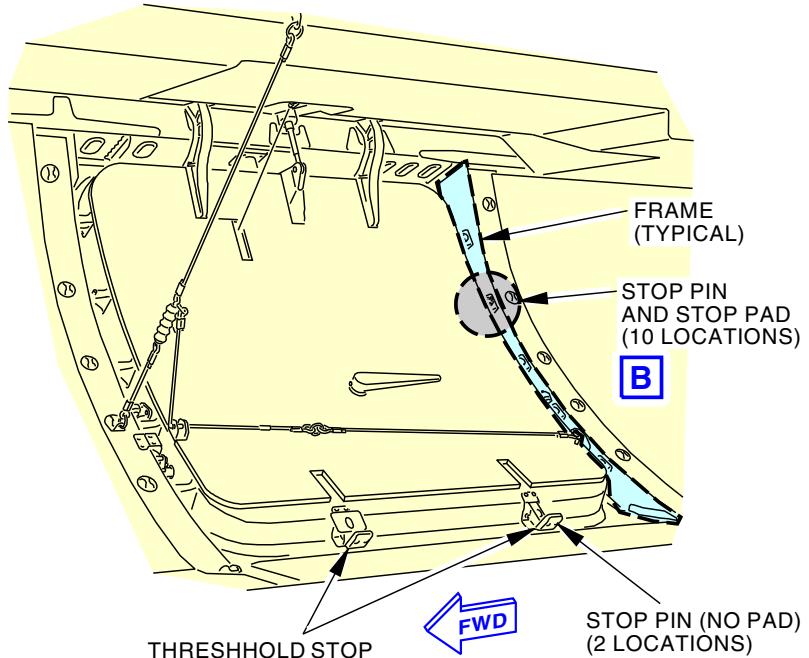
- (4) Close this access panel:

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

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**


**FORWARD CARGO COMPARTMENT DOOR**
**A**

**STOP PIN AND STOP PAD (EXAMPLE)**
**B**

H45965 S0006584602\_V4

**External - Forward Cargo Door Surround Structure Fitting and Stops**  
**Figure 204/53-05-03-990-804**

EFFECTIVITY	
LOM ALL	

**53-05-03**

 Page 208  
 Feb 15/2016



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-211-802**

5. **EXTERNAL - DETAILED: AFT CARGO DOOR SURROUND STRUCTURE, FITTINGS AND STOPS**  
(Figure 205)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
142	Aft Cargo Compartment - Right

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-03-010-056

- (1) Open this access panel:

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

SUBTASK 53-05-03-211-002

- (2) Do a Detailed inspection of the aft cargo door surround structure, fittings and stops.

SUBTASK 53-05-03-910-006

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-809.

SUBTASK 53-05-03-410-056

- (4) Close this access panel:

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

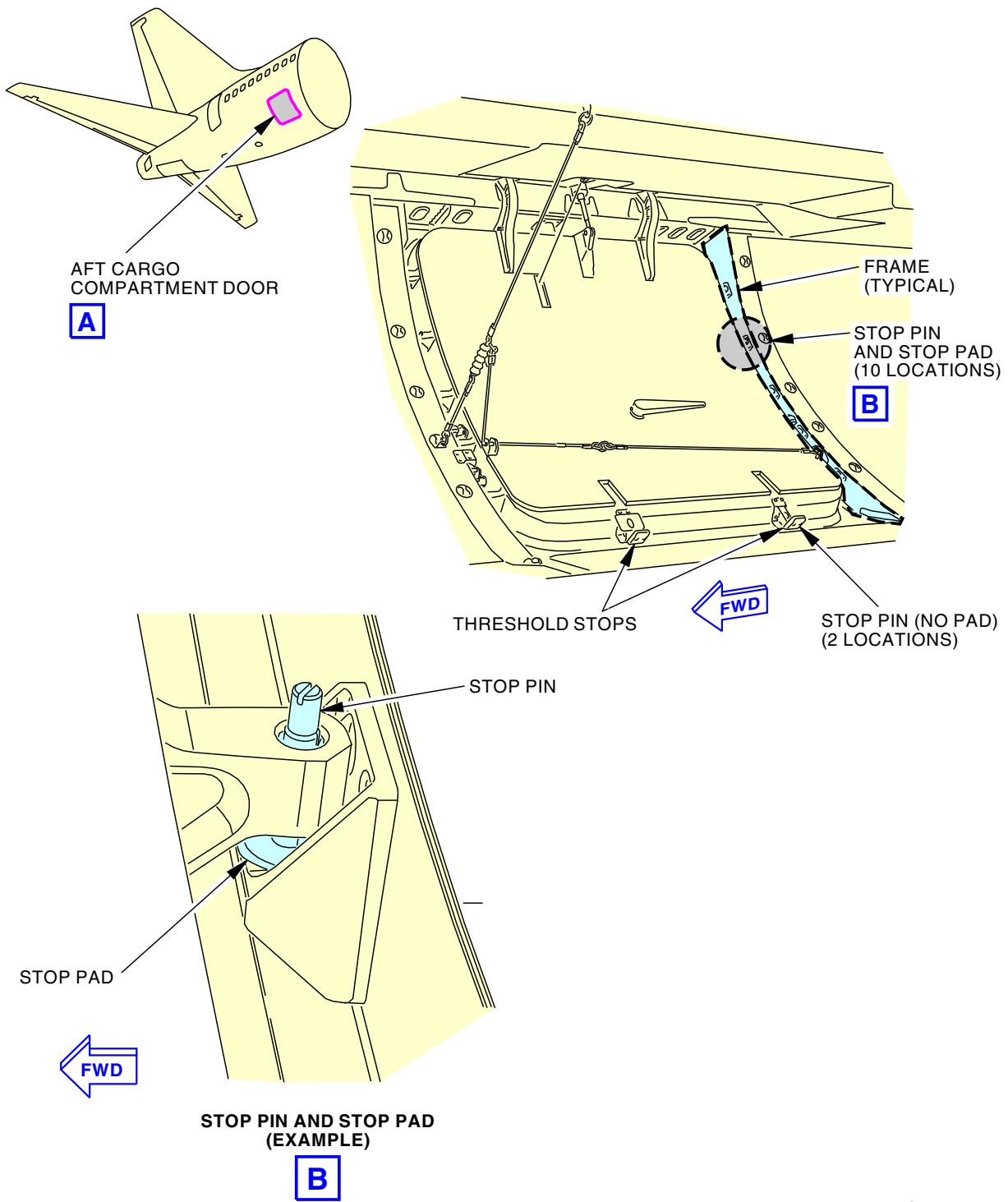
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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External - Aft Cargo Door Surround Structure Fittings and Stops  
Figure 205/53-05-03-990-805

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 210  
Feb 15/2016



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-05-03-210-805**

**6. EXTERNAL - GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL**

(Figure 206,Figure 207,Figure 208)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
139	Keel Beam, (Part) Body Station 540.00 to Body Station 727.00
193	Lower Wing-To-Body Fairing - Wheel Well

**B. Inspection**

**SUBTASK 53-05-03-210-005**

- (1) Do a General Visual inspection of the main landing gear wheel well, including:
  1. Pressure deck web and stiffeners, including attachment to wing center section rear spar at Sta 663.
  2. Bulkhead at STA 663.
  3. Bulkhead and pressure web at STA 727.
  4. Keel beam chords, webs, stiffeners and splice, keel beam/rear spar attachment angles.
  5. Stringer 18A web, chord and links.
  6. Side strut support frame at STA 706.
  7. Main landing gear support frame at STA 695 and 716.
  8. Wheel well frame at STA 685.
  9. Flap track support fittings.

**SUBTASK 53-05-03-910-007**

- (2) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

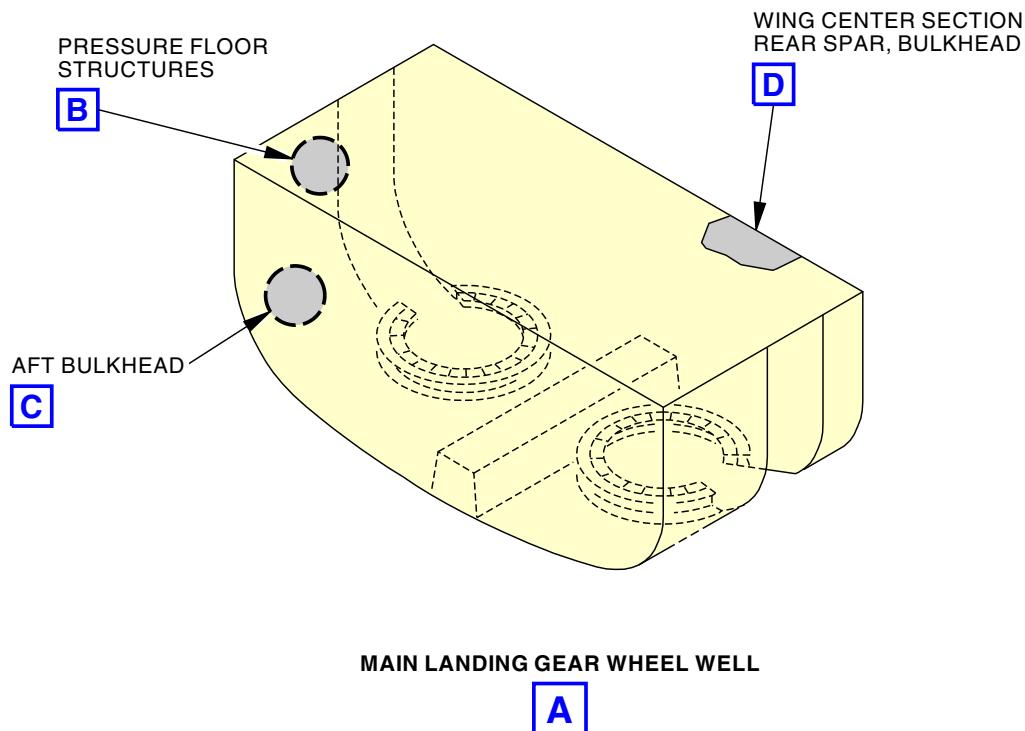
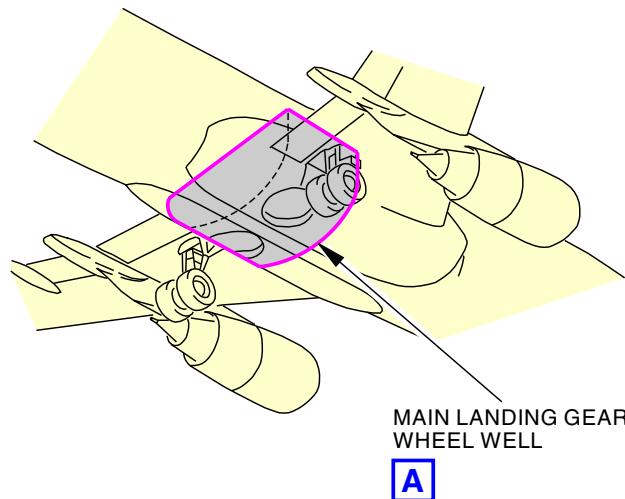
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



D79088 S0000164330\_V2

EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL  
Figure 206/53-05-03-990-835 (Sheet 1 of 4)

EFFECTIVITY  
LOM ALL

**53-05-03**

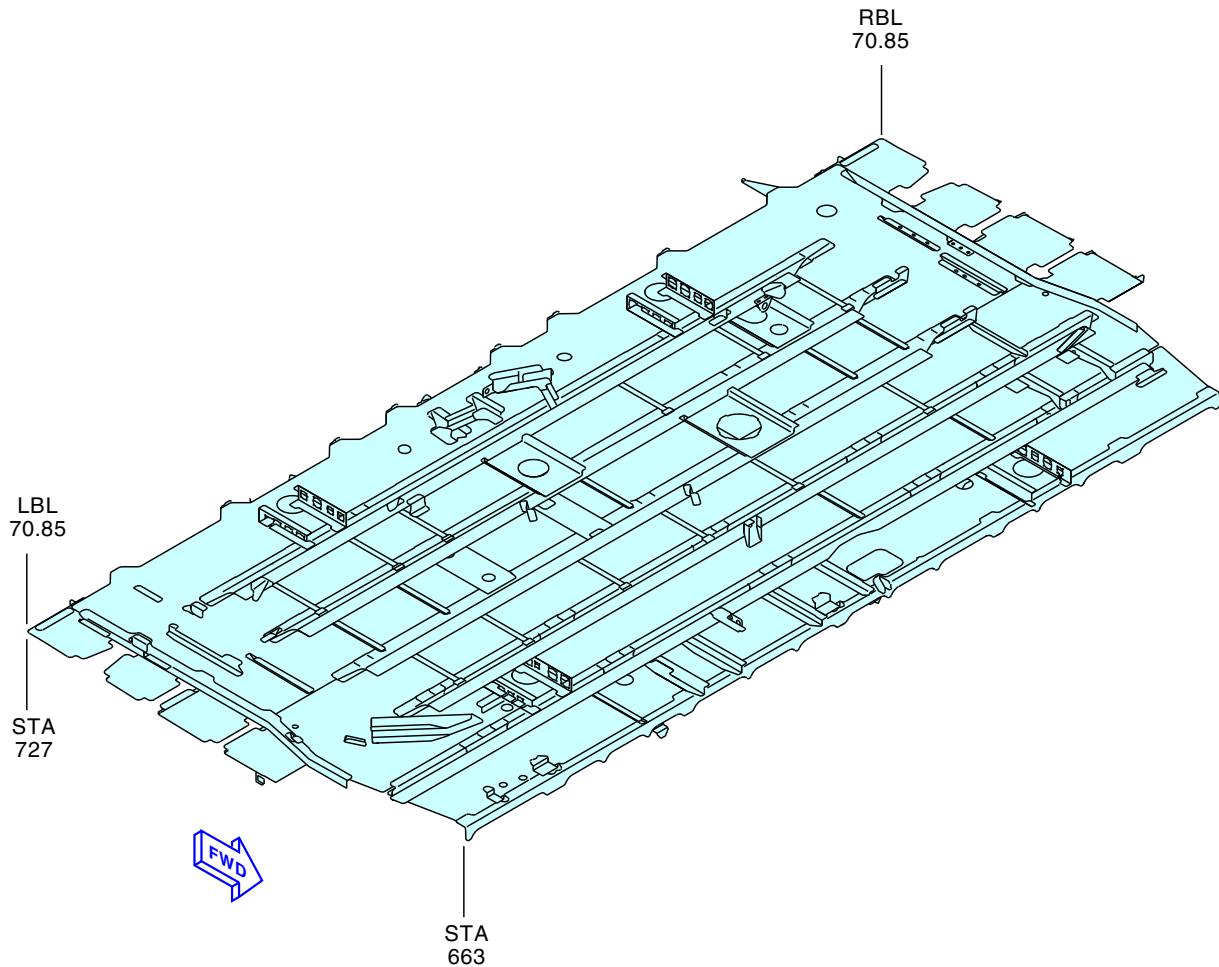
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 212  
Oct 15/2015



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PRESSURE FLOOR STRUCTURES  
(BOTTOM VIEW LOOKING UP)

B

D79097 S0000164679\_V2

EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL  
Figure 206/53-05-03-990-835 (Sheet 2 of 4)

EFFECTIVITY  
LOM ALL

**53-05-03**

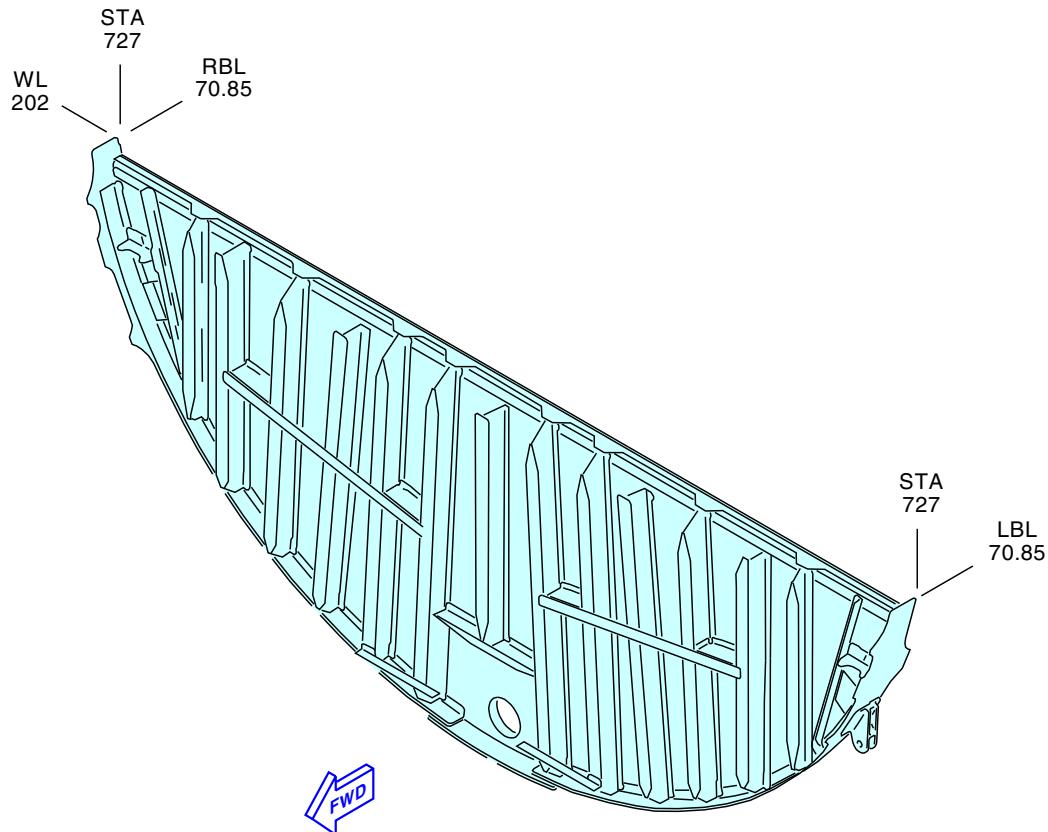
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 213  
Oct 15/2015



737-600/700/800/900  
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AFT BULKHEAD  
(STA 727)

C

D79170 S0000164681\_V3

EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL  
Figure 206/53-05-03-990-835 (Sheet 3 of 4)

EFFECTIVITY  
LOM ALL

**53-05-03**

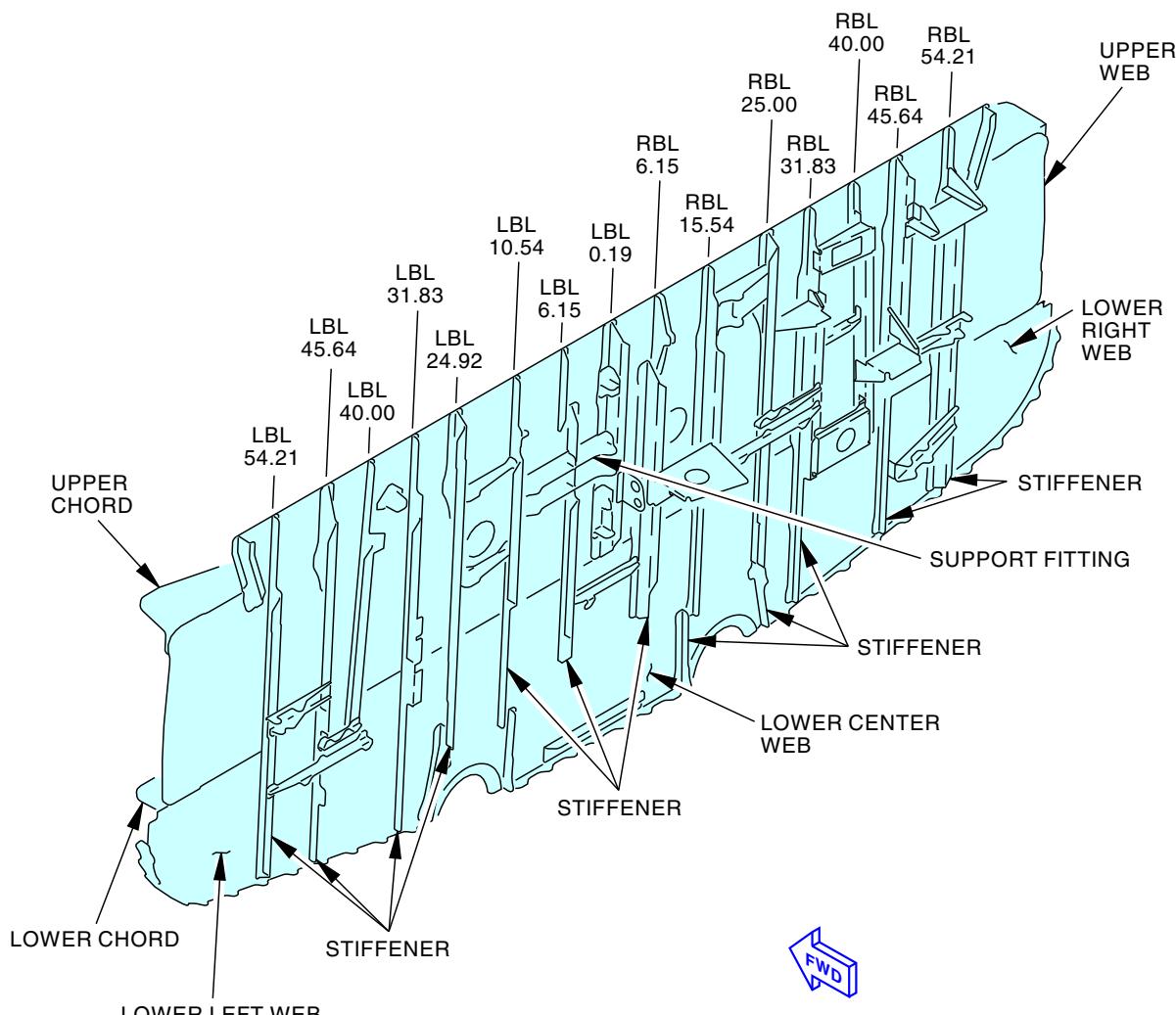
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Page 214  
Feb 15/2016



737-600/700/800/900  
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WING CENTER SECTION  
REAR SPAR, BULKHEAD  
(STA 663)

D

D79184 S0000164682\_V2

EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL  
Figure 206/53-05-03-990-835 (Sheet 4 of 4)

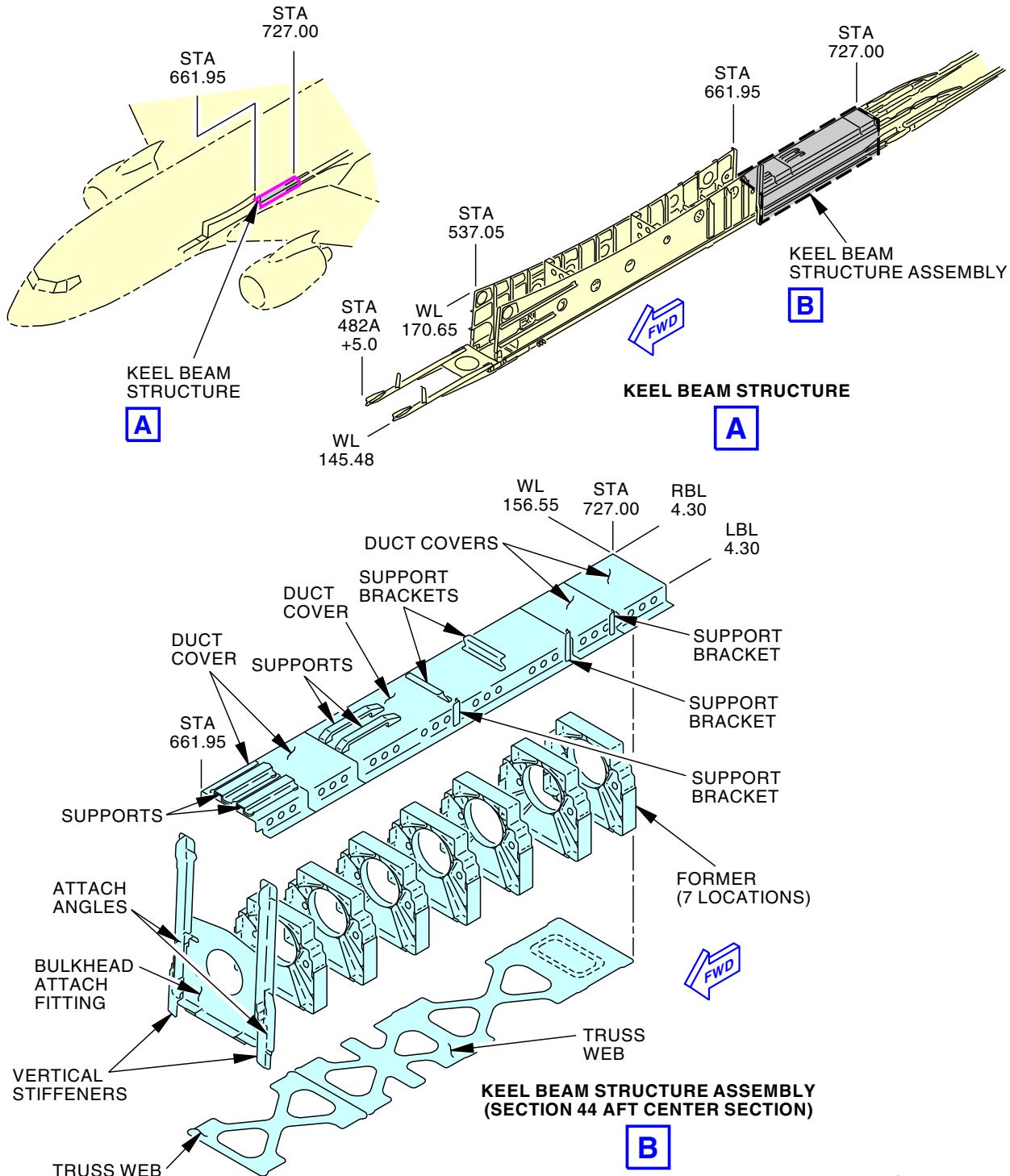
EFFECTIVITY  
LOM ALL

53-05-03

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

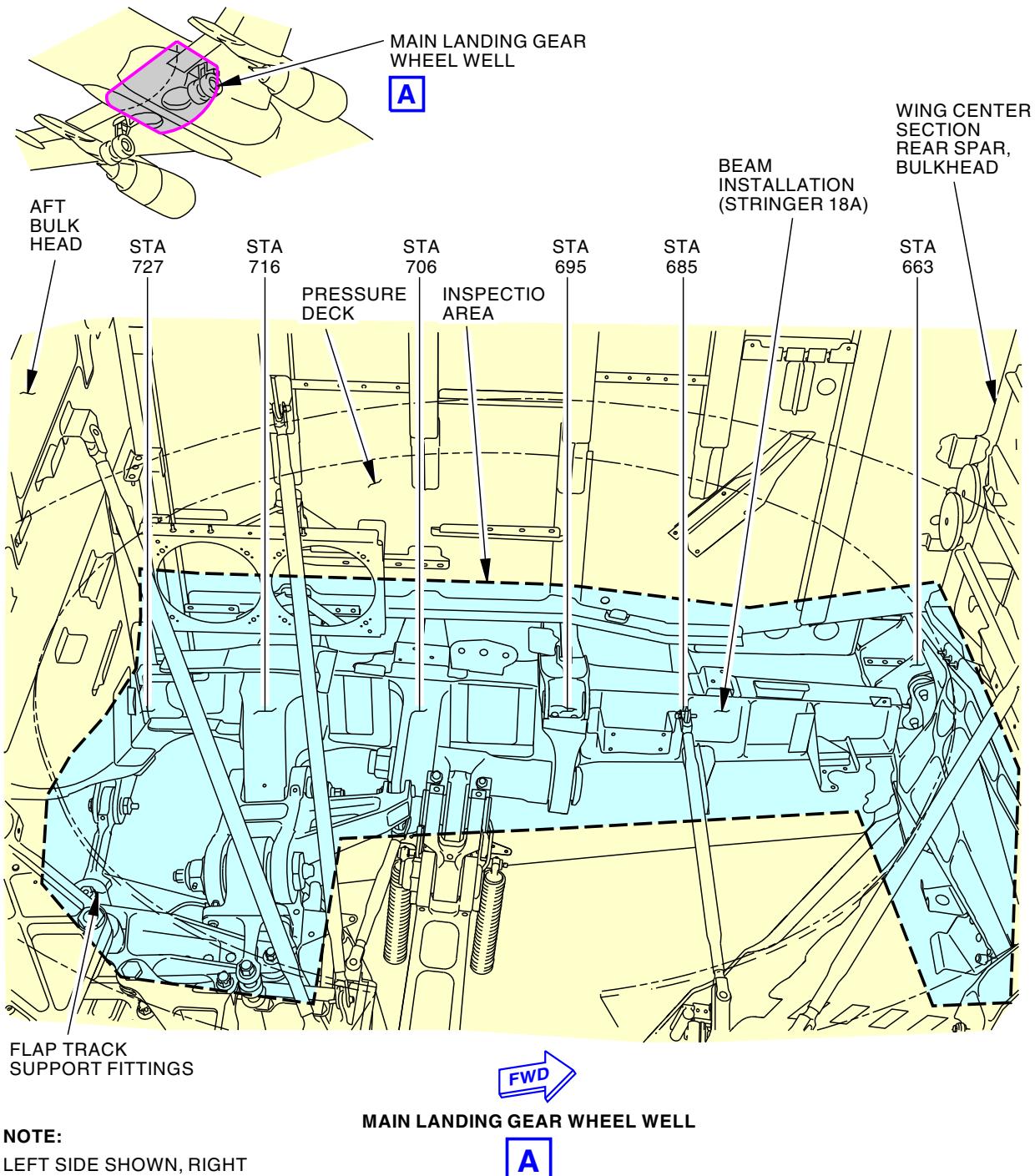
Page 215  
Oct 15/2015

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AIRCRAFT MAINTENANCE MANUAL**


D79276 S0000164948\_V2

**EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL**  
Figure 207/53-05-03-990-836

**53-05-03**



D80805 S0000164953\_V2

**EXTERNAL-GENERAL VISUAL: MAIN LANDING GEAR WHEEL WELL**  
Figure 208/53-05-03-990-837

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM



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**TASK 53-05-03-210-806**

**7. INTERNAL - GENERAL VISUAL: FORWARD PRESSURE BULKHEAD**

(Figure 209)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
111	Radome

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
111	Radome

**C. Inspection**

SUBTASK 53-05-03-010-004

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
111	Radome

NOTE: Open nose radome.

SUBTASK 53-05-03-210-006

- (2) Do a General Visual inspection of the forward side of STA 178 bulkhead.

SUBTASK 53-05-03-910-008

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-004

- (4) Close this access panel:

<b>Number</b>	<b>Name/Location</b>
111	Radome

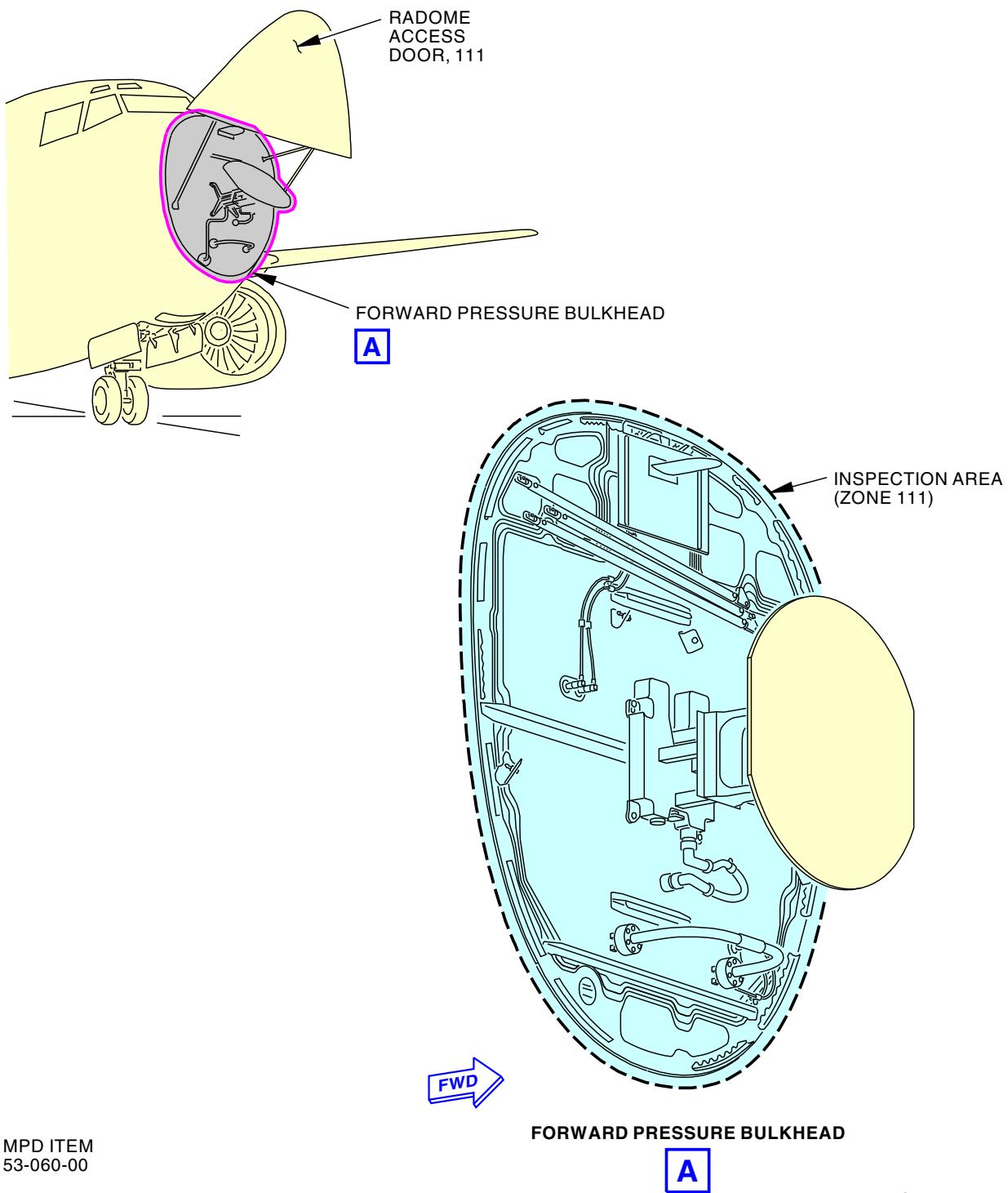
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



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**Forward Pressure Bulkhead, Sta. 178**  
Figure 209/53-05-03-990-894

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 219  
Oct 15/2015



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-807**

**8. INTERNAL - GENERAL VISUAL: AREA FORWARD OF NOSE WHEEL WELL**

(Figure 210)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
112	Area Forward of Nose Landing Gear Wheel Well

**B. Access Panels**

<u>Number</u>	<u>Name/Location</u>
112A	Forward Access Door
S1122	Area Forward Of Nose Wheel Well Inspection

**C. Inspection**

SUBTASK 53-05-03-010-005

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
112A	Forward Access Door
S1122	Area Forward Of Nose Wheel Well Inspection

NOTE: Remove weather radar RT mount. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-007

- (2) Do a General Visual inspection of the fuselage lower lobe from STA 178 bulkhead to canted bulkhead (STA 224.8 to 227.8), including bulkheads, skin panels (skins, frames, stringers), longitudinal lap splices, forward access door cutout, and nose wheel well cutout.

SUBTASK 53-05-03-910-009

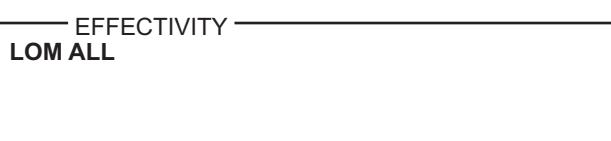
- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

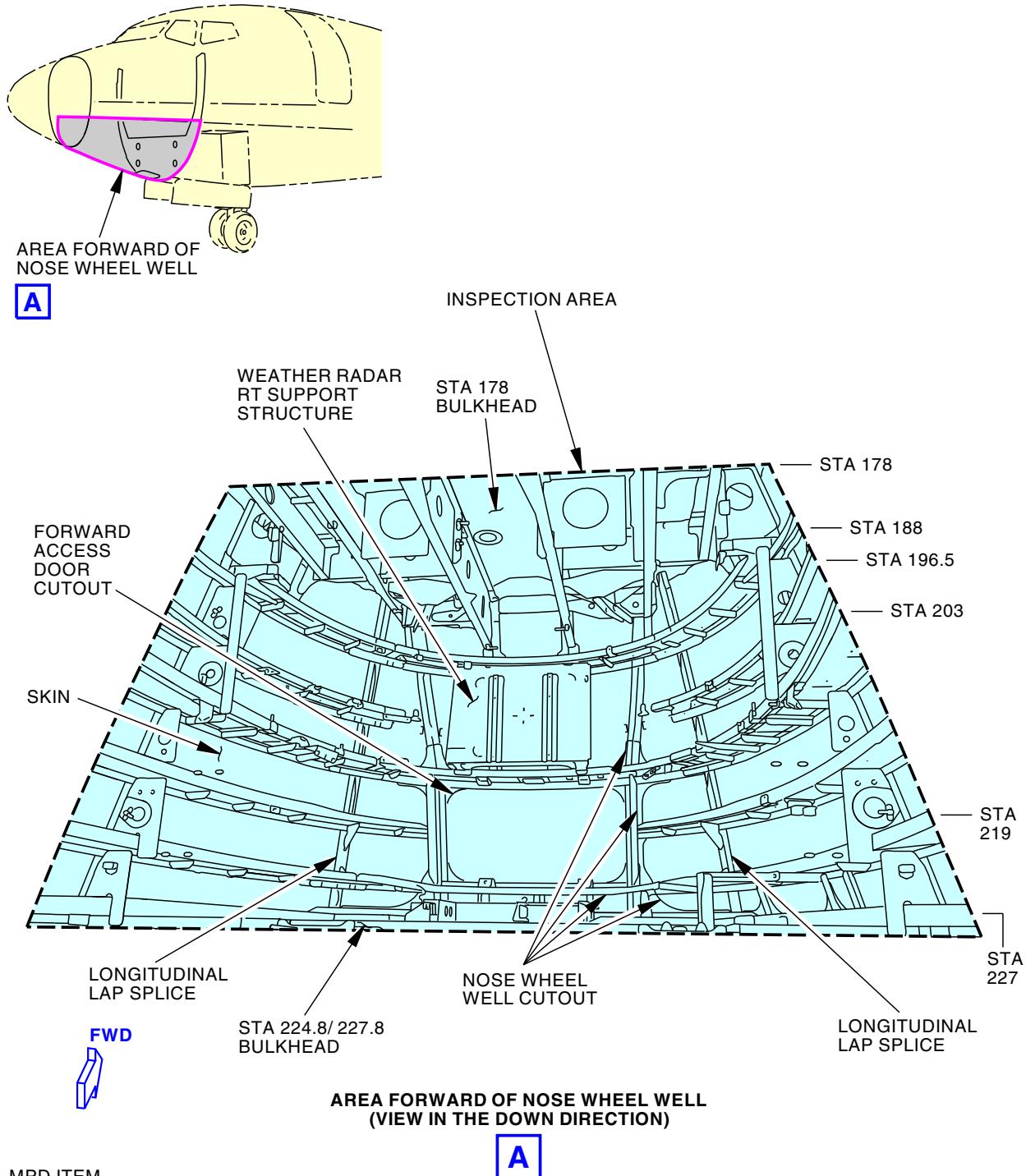
SUBTASK 53-05-03-410-005

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
112A	Forward Access Door
S1122	Area Forward Of Nose Wheel Well Inspection

— END OF TASK —



MPD ITEM  
53-070-00

2069529 S0000429375\_V2

**Forward of Nose Landing Gear Wheel Well General Visual (Internal)**  
**Figure 210/53-05-03-990-845**

EFFECTIVITY  
LOM ALL

D633A101-LOM

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**53-05-03**Page 221  
Oct 15/2015



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**TASK 53-05-03-210-808**

**9. INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FLOOR STRUCTURE**

(Figure 211)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
112	Area Forward of Nose Landing Gear Wheel Well

**B. Access Panels**

<u>Number</u>	<u>Name/Location</u>
112A	Forward Access Door

**C. Inspection**

SUBTASK 53-05-03-010-006

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
112A	Forward Access Door

NOTE: Access through forward access door.

SUBTASK 53-05-03-210-008

- (2) Do a General Visual inspection of the flight compartment floor structure from lower lobe.

SUBTASK 53-05-03-910-010

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-006

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
112A	Forward Access Door

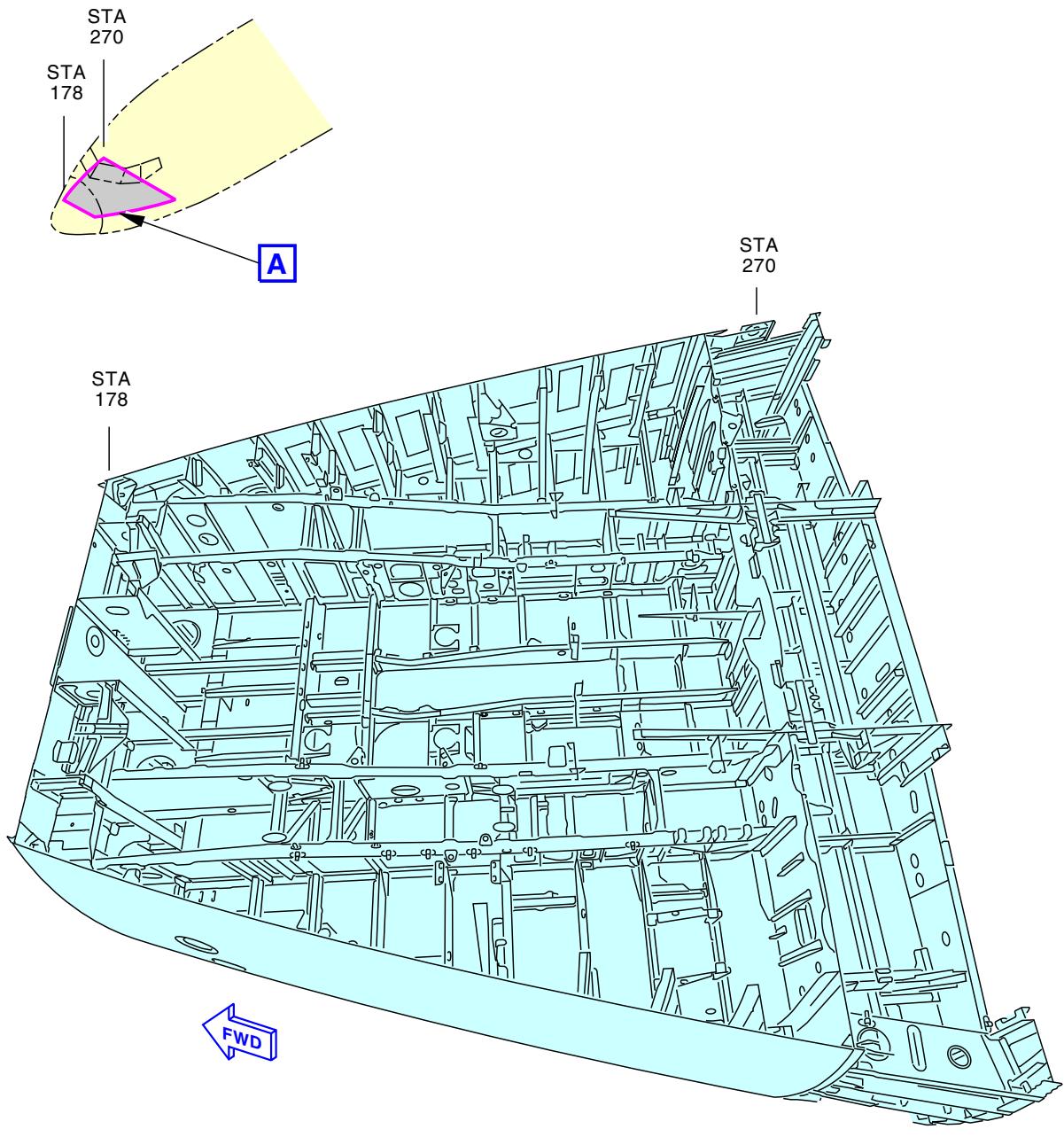
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



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(VIEW IN THE UP DIRECTION)

A

MPD ITEM  
53-080-00

D63217 S0000162565\_V3

Flight Deck Floor Structure  
Figure 211/53-05-03-990-830

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 223  
Oct 15/2015



737-600/700/800/900  
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**TASK 53-05-03-210-809**

**10. INTERNAL - GENERAL VISUAL: AREA ABOVE AND OUTBOARD OF NOSE WHEEL WELL**

(Figure 212)

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
53-14-01-020-801	Nose Wheel Well Access Panels - Removal (P/B 401)
53-14-01-420-801	Nose Wheel Well Access Panels - Installation (P/B 401)

**B. Location Zones**

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

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
113AC	Fwd Nose Wheel Well Upper Access Panel
113AW	Forward Nose Wheel Well Panel
113BW	Forward Nose Wheel Well Panel
114AC	Fwd Nose Wheel Well Upper Access Panel
114AW	Forward Nose Wheel Well Panel
114BW	Forward Nose Wheel Well Panel
S1101	Area Above And Outboard of Nose Wheel Well Inspection

**D. Inspection**

**SUBTASK 53-05-03-010-007**

- (1) Open these access panels:

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

NOTE: Access through nose wheel well side and top access panels, and through access panel in crew floor. Remove/displace insulation blankets as required.

- (a) Do this task: Nose Wheel Well Access Panels - Removal, TASK 53-14-01-020-801.

**SUBTASK 53-05-03-010-081**

- (2) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
S1101	Area Above And Outboard of Nose Wheel Well Inspection

NOTE: Access through nose wheel well side and top access panels, and through access panel in crew floor. Remove/displace insulation blankets as required.

**SUBTASK 53-05-03-210-009**

- (3) Do a General Visual inspection of the fuselage lower lobe from canted bulkhead (Sta 224.8 to 227.8) to Sta 294, including:

EFFECTIVITY  
LOM ALL

**53-05-03**



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1. Skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices, bulkhead at Sta 259.5.
2. Nose wheel well cutout surround structure, nose wheel well side and top panels.
3. Trunnion support fitting, actuator support fitting and drag brace fitting.

SUBTASK 53-05-03-910-011

- (4) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-007

- (5) Close these access panels:

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

- (a) Do this task: Nose Wheel Well Access Panels - Installation, TASK 53-14-01-420-801.

SUBTASK 53-05-03-410-076

- (6) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
S1101	Area Above And Outboard of Nose Wheel Well Inspection

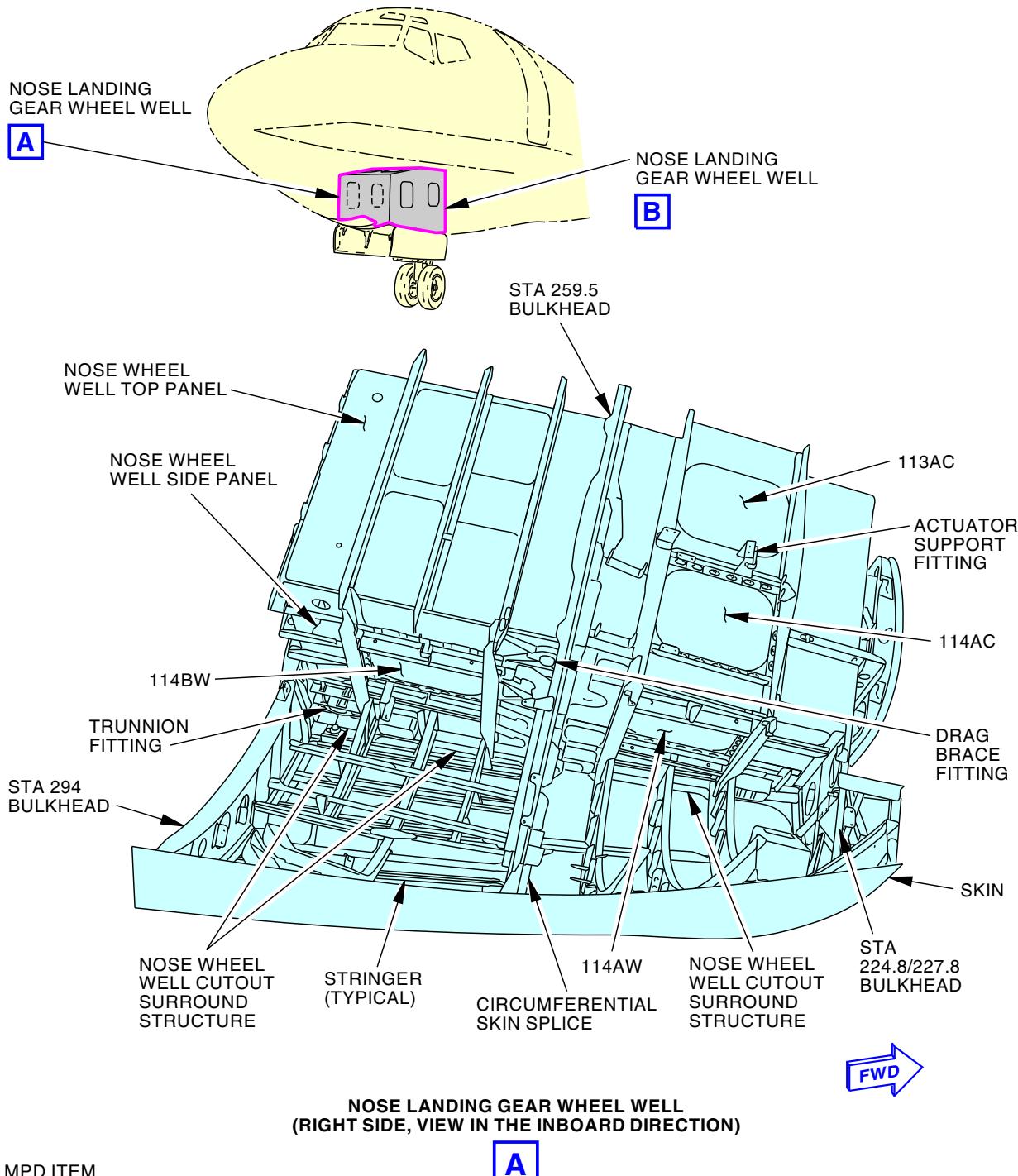
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



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NOSE LANDING GEAR WHEEL WELL  
(RIGHT SIDE, VIEW IN THE INBOARD DIRECTION)

A

MPD ITEM  
53-090-00

2069612 S0000429415\_V3

Above and Outboard of the Nose Landing Gear Wheel Well General Visual (Internal)  
Figure 212/53-05-03-990-844 (Sheet 1 of 2)

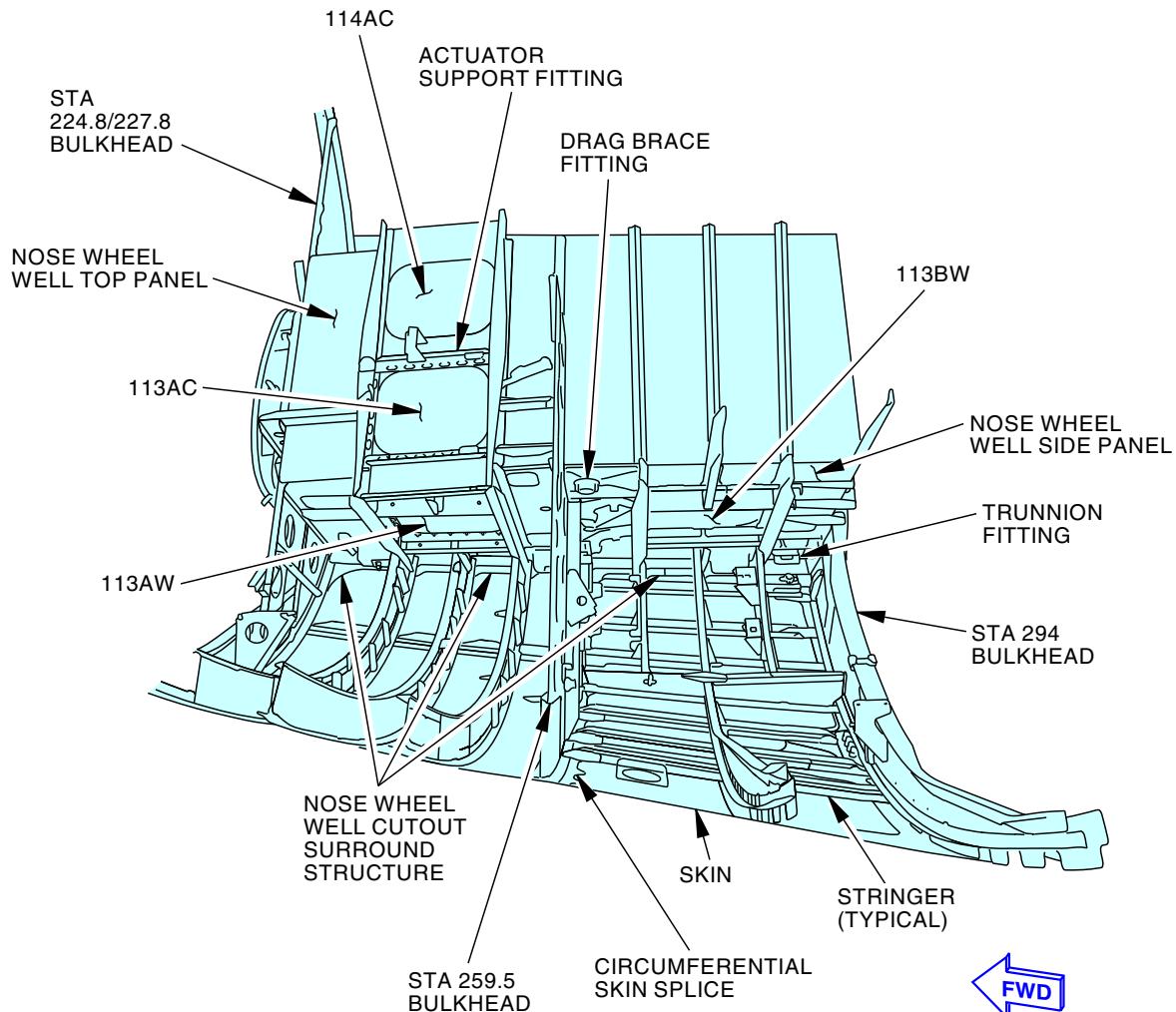
EFFECTIVITY  
LOM ALL

**53-05-03**

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Page 226  
Oct 15/2017



**NOSE LANDING GEAR WHEEL WELL  
(LEFT SIDE, VIEW IN THE DOWN DIRECTION)**

**B**

MPD ITEM  
53-090-00

2070792 S0000429416\_V3

**Above and Outboard of the Nose Landing Gear Wheel Well General Visual (Internal)  
Figure 212/53-05-03-990-844 (Sheet 2 of 2)**

EFFECTIVITY  
LOM ALL

D633A101-LOM

**53-05-03**

Page 227  
Oct 15/2017



737-600/700/800/900  
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**TASK 53-05-03-210-810**

11. **INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - DRY AREA**  
(Figure 213)

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
25-52-06-000-801	Cargo Compartment Sidewall Lining - Removal (P/B 401)
25-52-06-400-801	Cargo Compartment Sidewall Lining - Installation (P/B 401)
25-52-09-000-801	Cargo Compartment Ceiling Liner - Removal (P/B 401)
25-52-09-400-801	Cargo Compartment Ceiling Liner - Installation (P/B 401)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - Right

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
117BL	Forward Airstair Door
S1101	Area Above And Outboard of Nose Wheel Well Inspection

**D. Inspection**

**SUBTASK 53-05-03-010-008**

- (1) Open these access panels:

<b>Number</b>	<b>Name/Location</b>
117BL	Forward Airstair Door
S1101	Area Above And Outboard of Nose Wheel Well Inspection

NOTE: Remove or displace auxiliary fuel tank as required (business jet only). Remove forward airstairs and airstairs compartment (if installed).

**SUBTASK 53-05-03-010-084**

- (2) If it is necessary, then do the following tasks:

- Cargo Compartment Sidewall Lining - Removal, TASK 25-52-06-000-801
- Cargo Compartment Ceiling Liner - Removal, TASK 25-52-09-000-801

NOTE: Remove ceiling and sidewall panels as required. Remove/displace insulation blankets as required.

EFFECTIVITY
LOM ALL

**53-05-03**



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SUBTASK 53-05-03-210-010

- (3) Do a General Visual inspection of the passenger compartment floor structure in dry areas (away from doors, galleys and lavs) from lower lobe.

SUBTASK 53-05-03-910-012

- (4) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-081

- (5) If the ceiling or sidewall panels were removed, then do the following applicable tasks:
- (a) Cargo Compartment Sidewall Lining - Installation, TASK 25-52-06-400-801
  - (b) Cargo Compartment Ceiling Liner - Installation, TASK 25-52-09-400-801

SUBTASK 53-05-03-410-008

- (6) Close these access panels:

**Number**    **Name/Location**

117BL      Forward Airstair Door

S1101      Area Above And Outboard of Nose Wheel Well Inspection

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

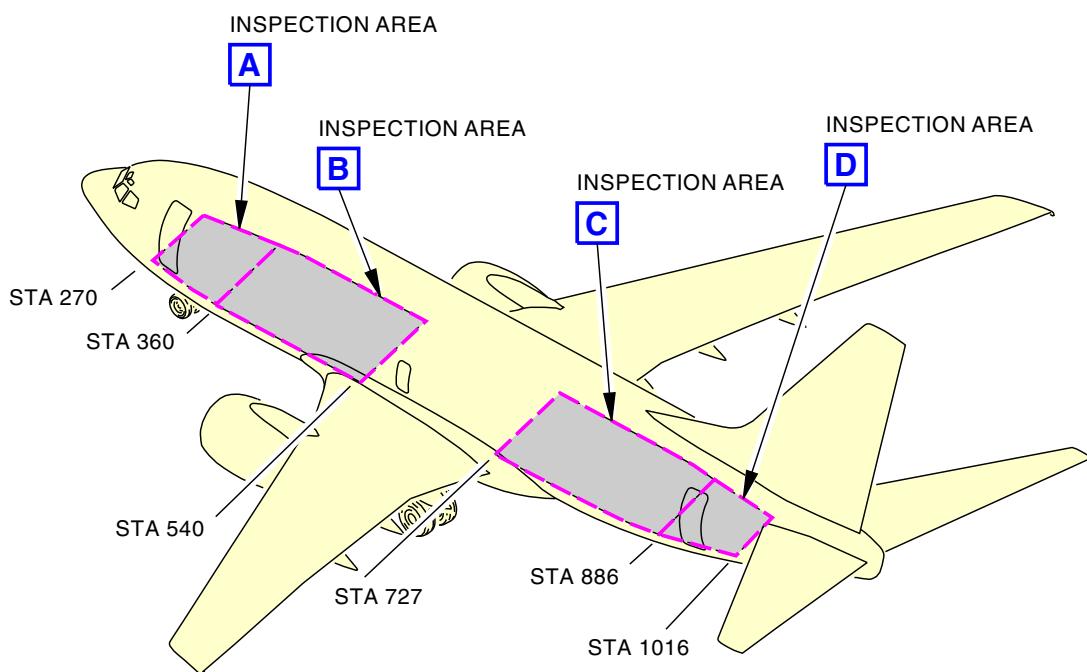
**53-05-03**

Page 229  
Oct 15/2022

D633A101-LOM



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MPD ITEM  
53-100-00

2089311 S0000440307\_V2

**INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE**  
**Figure 213/53-05-03-990-849 (Sheet 1 of 5)**

EFFECTIVITY  
LOM ALL

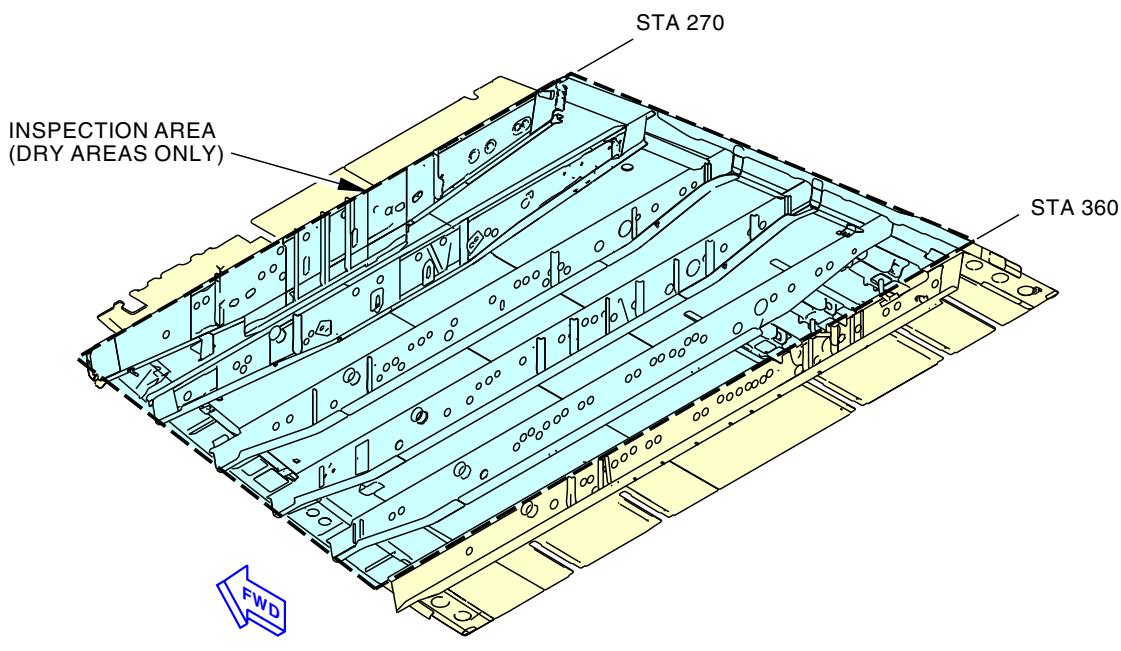
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**53-05-03**

Page 230  
Oct 15/2022



737-600/700/800/900  
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PASSENGER COMPARTMENT FLOOR STRUCTURE  
(BOTTOM VIEW)

A

MPD ITEM  
53-100-00

2089843 S0000440308\_V3

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE  
Figure 213/53-05-03-990-849 (Sheet 2 of 5)

EFFECTIVITY  
LOM ALL

D633A101-LOM

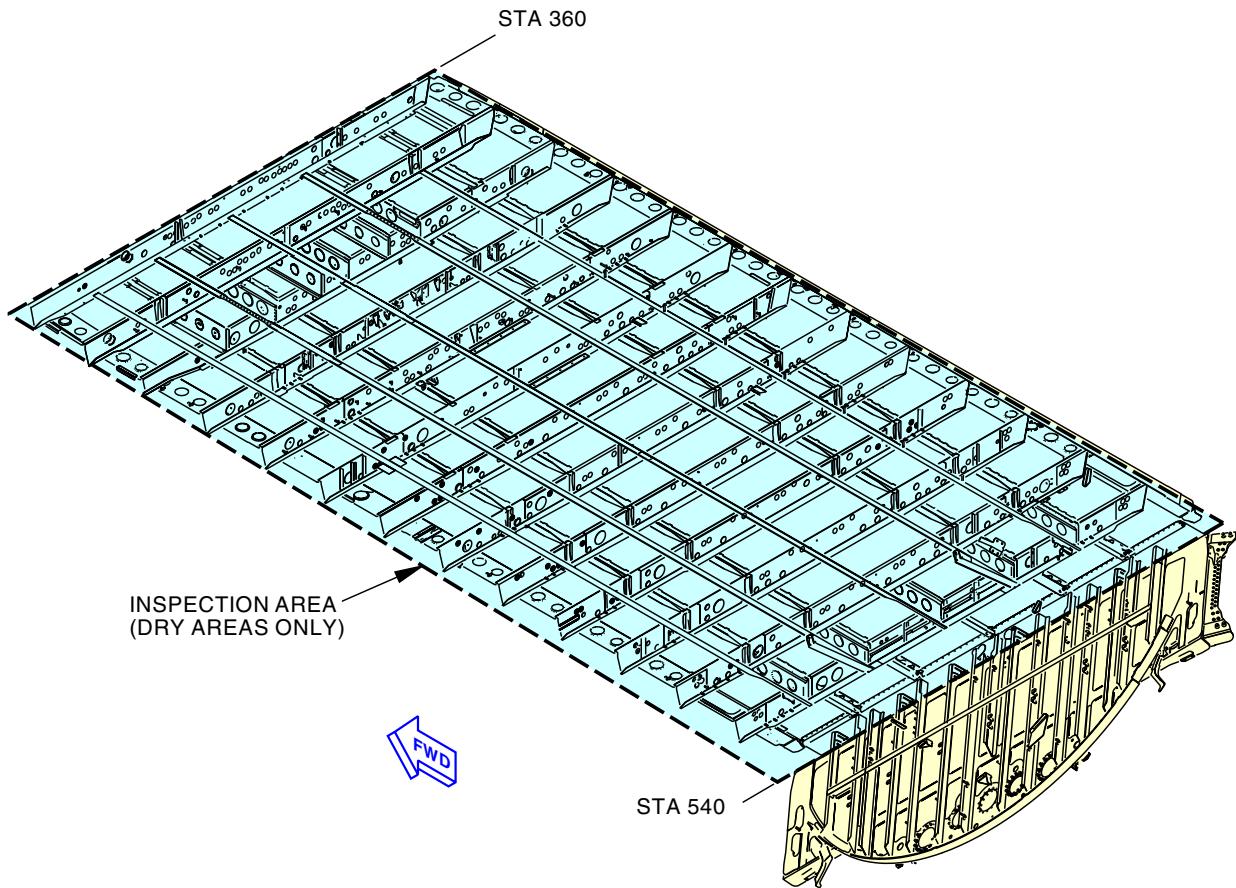
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**53-05-03**

Page 231  
Oct 15/2022



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AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT FLOOR STRUCTURE  
(BOTTOM VIEW)

B

MPD ITEM  
53-100-00

2089847 S0000440309\_V3

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE  
Figure 213/53-05-03-990-849 (Sheet 3 of 5)

EFFECTIVITY  
LOM ALL

**53-05-03**

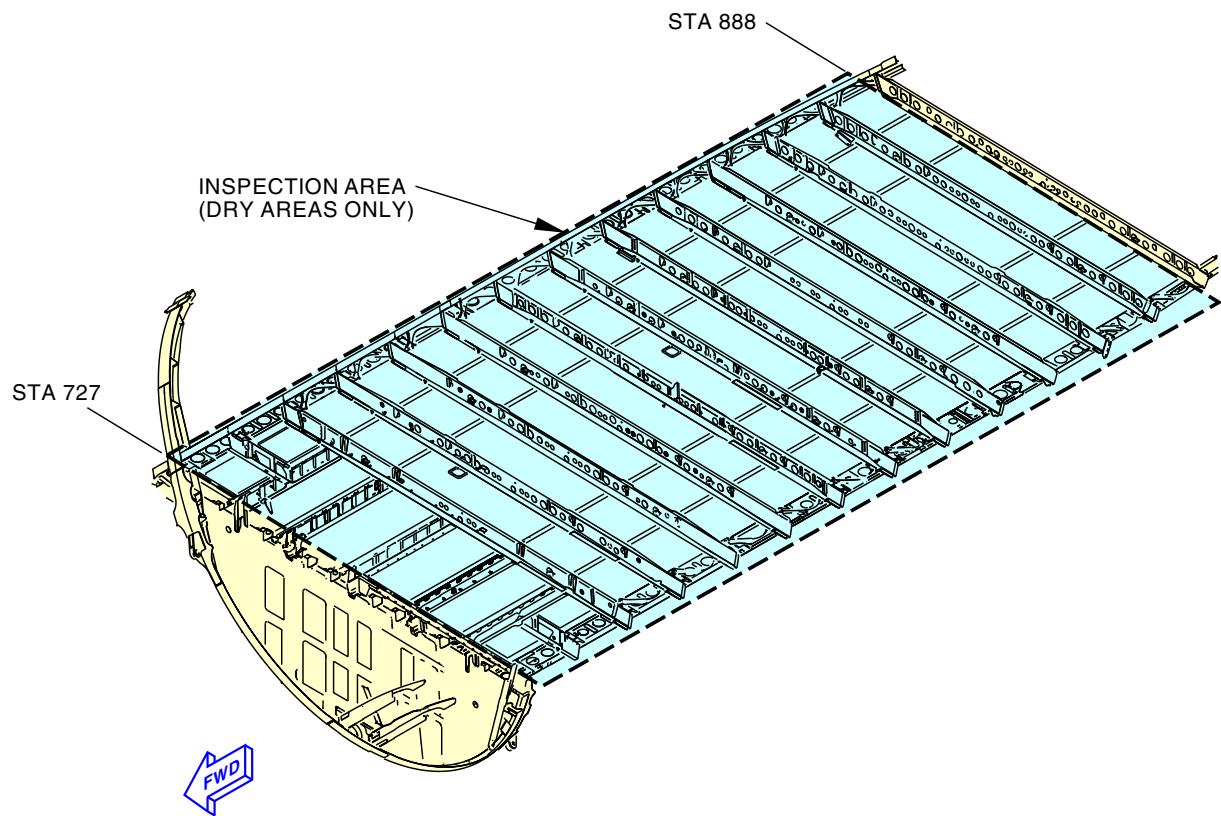
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 232  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT FLOOR STRUCTURE  
(BOTTOM VIEW)

C

MPD ITEM  
53-100-00

2089855 S0000440310\_V3

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE  
Figure 213/53-05-03-990-849 (Sheet 4 of 5)

EFFECTIVITY  
LOM ALL

**53-05-03**

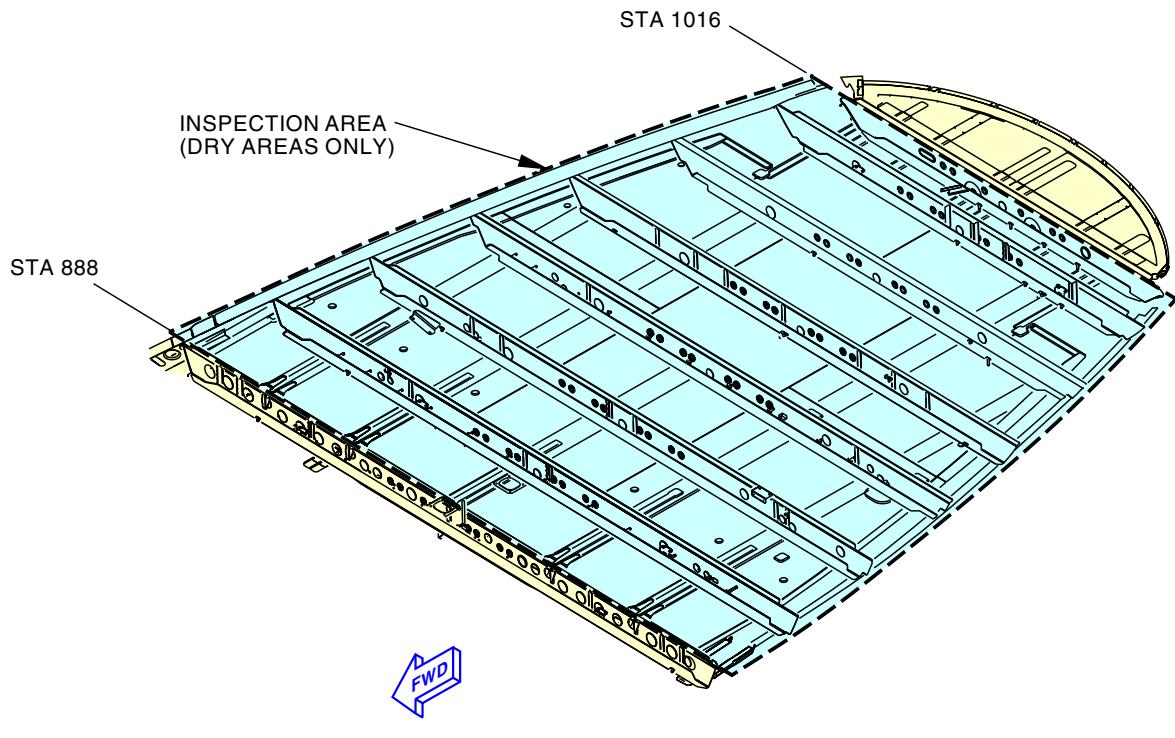
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Page 233  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT FLOOR STRUCTURE  
(BOTTOM VIEW)

D

MPD ITEM  
53-100-00

2089863 S0000440311\_V3

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE  
Figure 213/53-05-03-990-849 (Sheet 5 of 5)

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 234  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-811**

- 12. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - WET AREA**  
(Figure 214)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
113	Area Above and Outboard of Nose Landing Gear Wheel Well - Left
114	Area Above and Outboard of Nose Landing Gear Wheel Well - Right
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
117BL	Forward Airstair Door
S1002	Passenger Compartment Floor Structure - Wet Area Inspection

**C. Inspection**

SUBTASK 53-05-03-010-009

- (1) Open these access panels:

<b>Number</b>	<b>Name/Location</b>
117BL	Forward Airstair Door
S1002	Passenger Compartment Floor Structure - Wet Area Inspection

NOTE: Remove ceiling and sidewall panels as required. Remove/displace insulation blankets as required. Remove or displace auxiliary fuel tank as required (business jet only). Remove forward airstairs and airstair compartment (if installed. 117BL).

SUBTASK 53-05-03-210-011

- (2) Do a General Visual inspection of the passenger compartment floor structure in wet areas (within approximately 20 inches from doors, galleys and lavs) from lower lobe.

SUBTASK 53-05-03-910-013

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-009

- (4) Close these access panels:

<b>Number</b>	<b>Name/Location</b>
117BL	Forward Airstair Door
S1002	Passenger Compartment Floor Structure - Wet Area Inspection

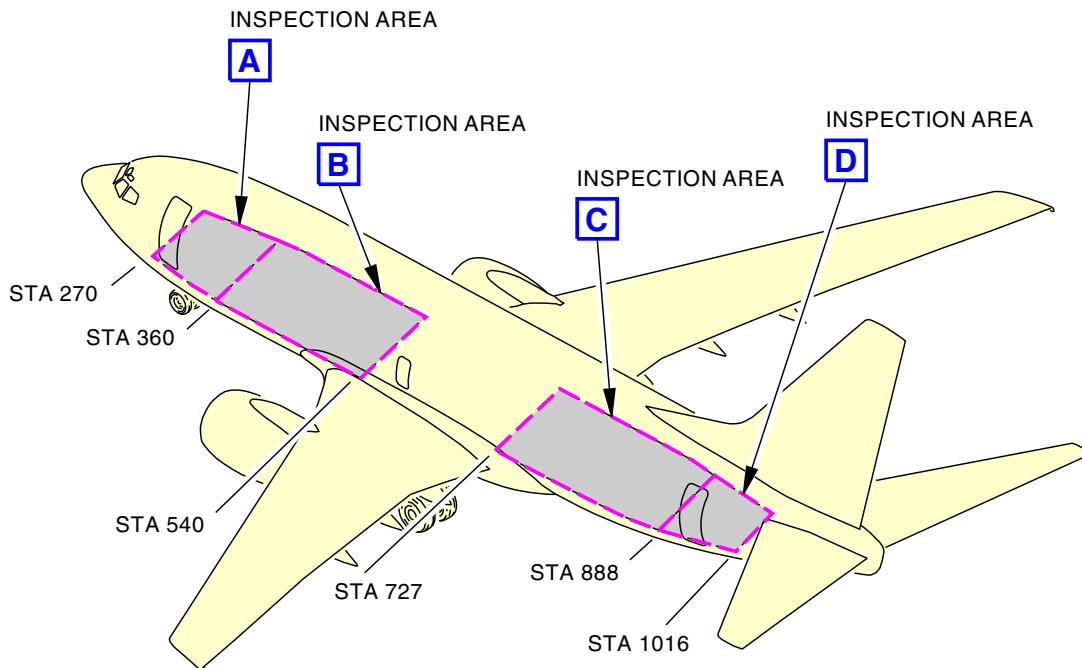
— END OF TASK —

EFFECTIVITY  
LOM ALL

**53-05-03**



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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-110-00

2123126 S0000457776\_V2

Passenger Compartment Structure-Wet Area General Visual (Internal)  
Figure 214/53-05-03-990-869 (Sheet 1 of 5)

EFFECTIVITY  
LOM ALL

**53-05-03**

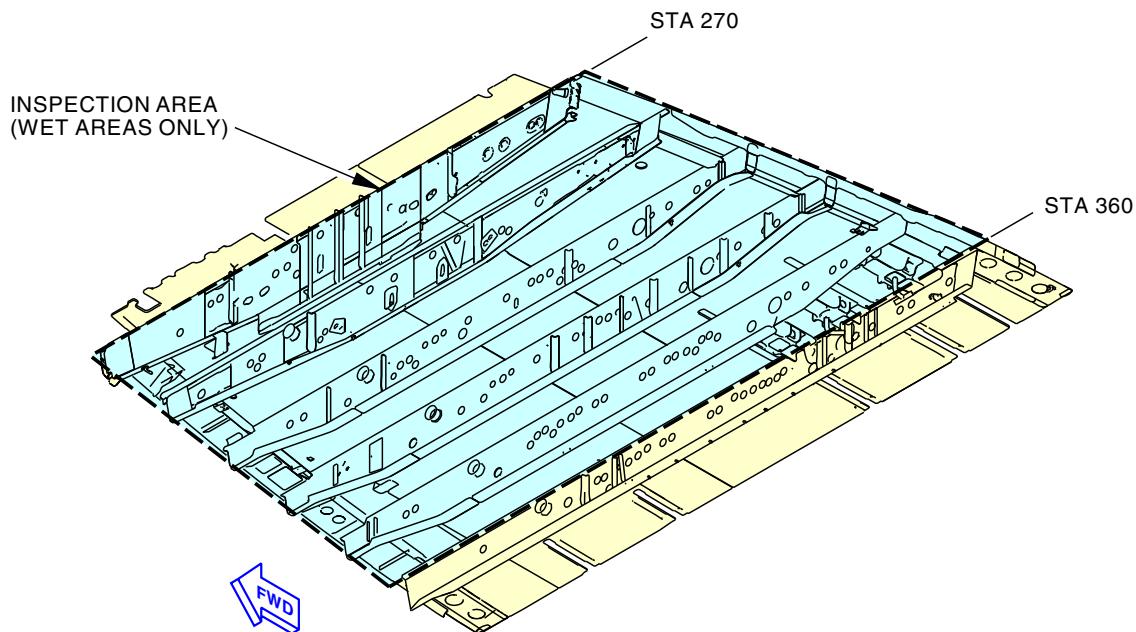
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 236  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT FLOOR STRUCTURE  
(BOTTOM VIEW)

A

MPD ITEM  
53-110-00

2123135 S0000457777\_V2

Passenger Compartment Structure-Wet Area General Visual (Internal)  
Figure 214/53-05-03-990-869 (Sheet 2 of 5)

EFFECTIVITY  
LOM ALL

D633A101-LOM

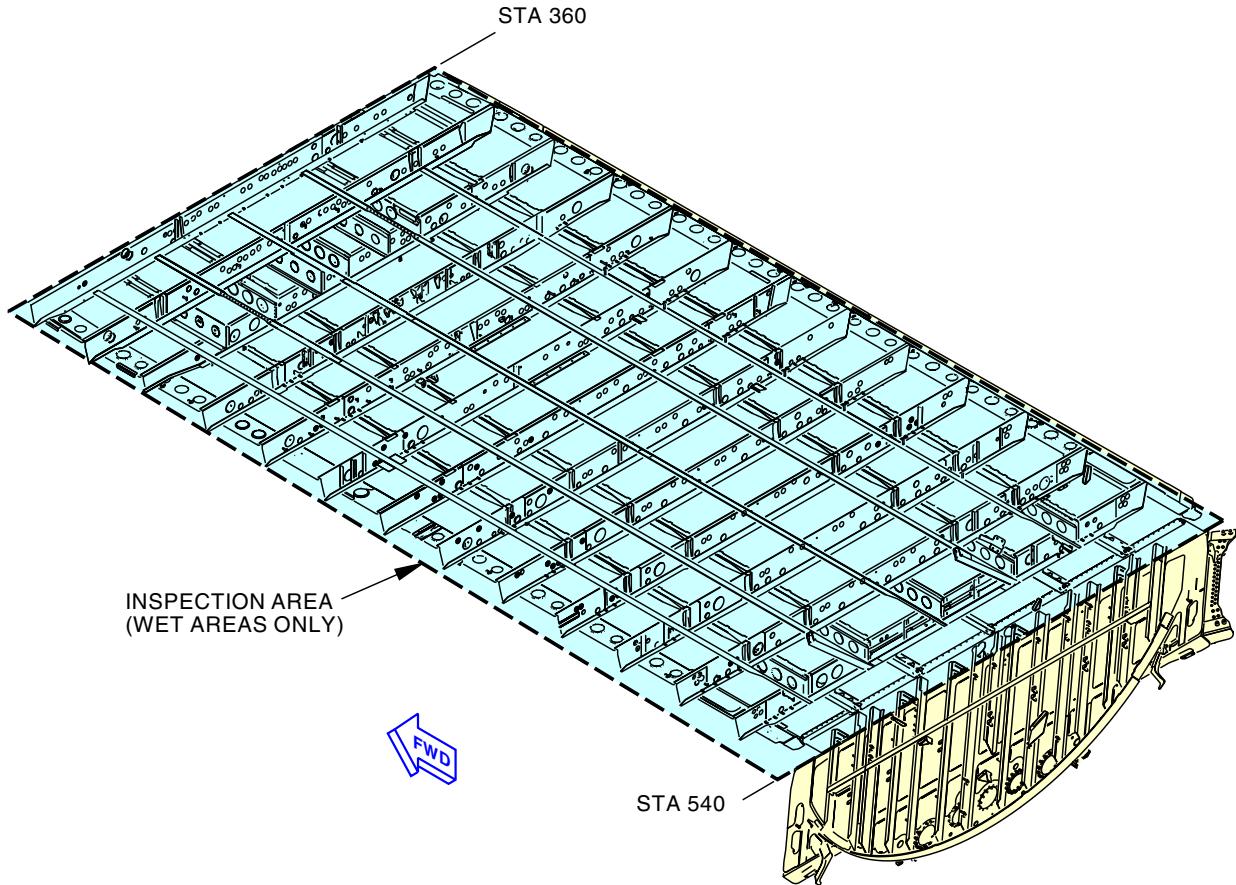
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 237  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT FLOOR STRUCTURE  
(BOTTOM VIEW)

B

MPD ITEM  
53-110-00

2123138 S0000457778\_V2

Passenger Compartment Structure-Wet Area General Visual (Internal)  
Figure 214/53-05-03-990-869 (Sheet 3 of 5)

EFFECTIVITY  
LOM ALL

**53-05-03**

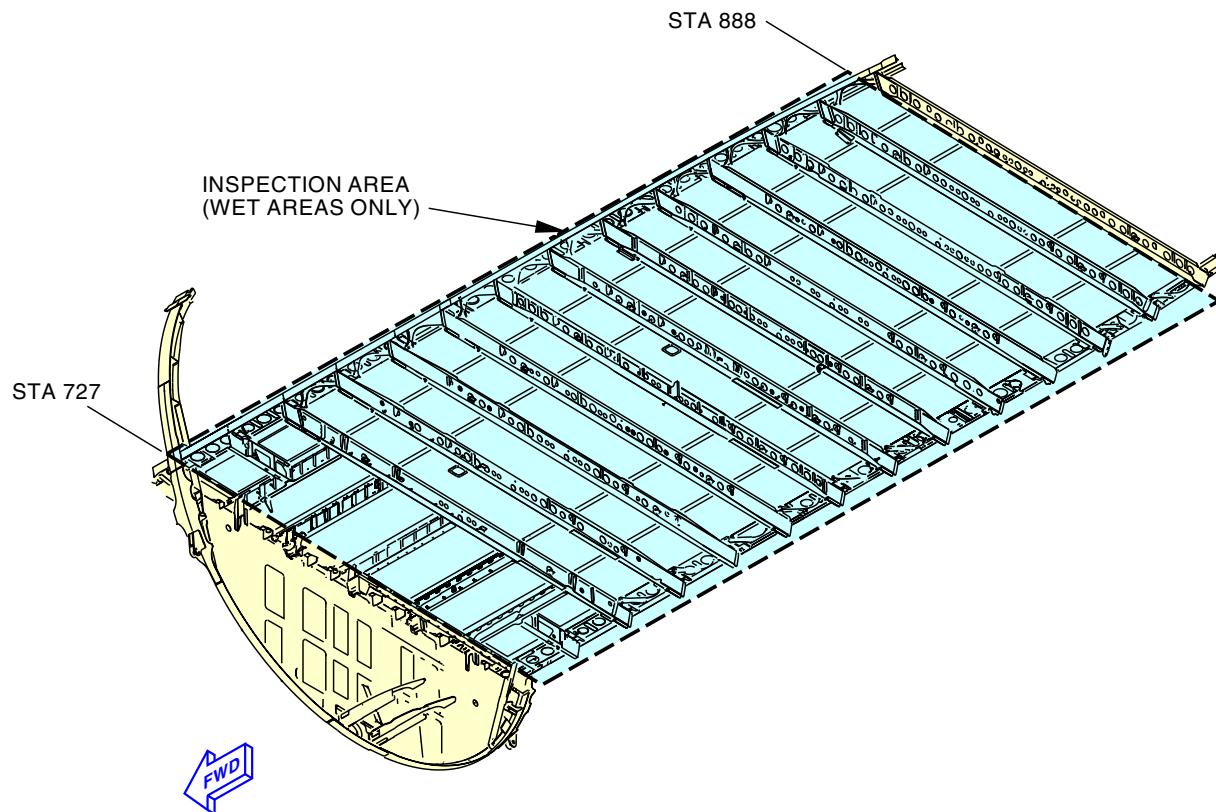
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 238  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT FLOOR STRUCTURE  
(BOTTOM VIEW)

C

MPD ITEM  
53-110-00

2123141 S0000457779\_V2

Passenger Compartment Structure-Wet Area General Visual (Internal)  
Figure 214/53-05-03-990-869 (Sheet 4 of 5)

EFFECTIVITY  
LOM ALL

**53-05-03**

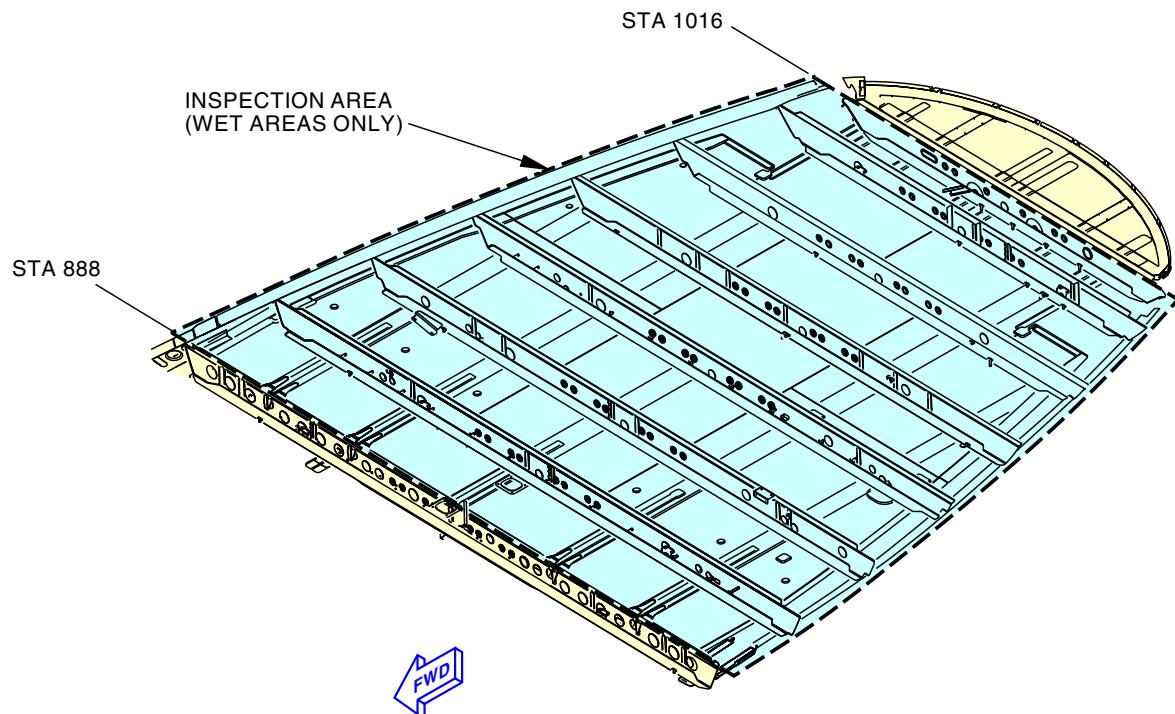
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 239  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT FLOOR STRUCTURE  
(BOTTOM VIEW)

D

MPD ITEM  
53-110-00

2123145 S0000457780\_V2

Passenger Compartment Structure-Wet Area General Visual (Internal)  
Figure 214/53-05-03-990-869 (Sheet 5 of 5)

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 240  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-812**

**13. INTERNAL - GENERAL VISUAL: ELECTRICAL AND ELECTRONICS COMPARTMENT**

(Figure 215)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
117	Electrical and Electronics Compartment - Left
118	Electrical and Electronics Compartment - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
117A	Electronic Equipment Access Door
S1102	Electrical And Electronics Compartment Inspection

**C. Inspection**

SUBTASK 53-05-03-010-010

- (1) Open these access panels:

<b>Number</b>	<b>Name/Location</b>
117A	Electronic Equipment Access Door
S1102	Electrical And Electronics Compartment Inspection

NOTE: Remove LRUs and racks, do not remove permanently installed structure.  
Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-012

- (2) Do a General Visual inspection of the EE compartment (STA 294.5 to 396 (STA 400 for 737-700C and 737-800BCF)), including:
1. Skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices, bulkhead at STA 294.5.
  2. EE compartment door and airstairs door cutout surround structure.
  3. Forward entry and galley door cutout surround structure (portion in lower lobe).

SUBTASK 53-05-03-910-014

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-010

- (4) Close these access panels:

<b>Number</b>	<b>Name/Location</b>
117A	Electronic Equipment Access Door
S1102	Electrical And Electronics Compartment Inspection

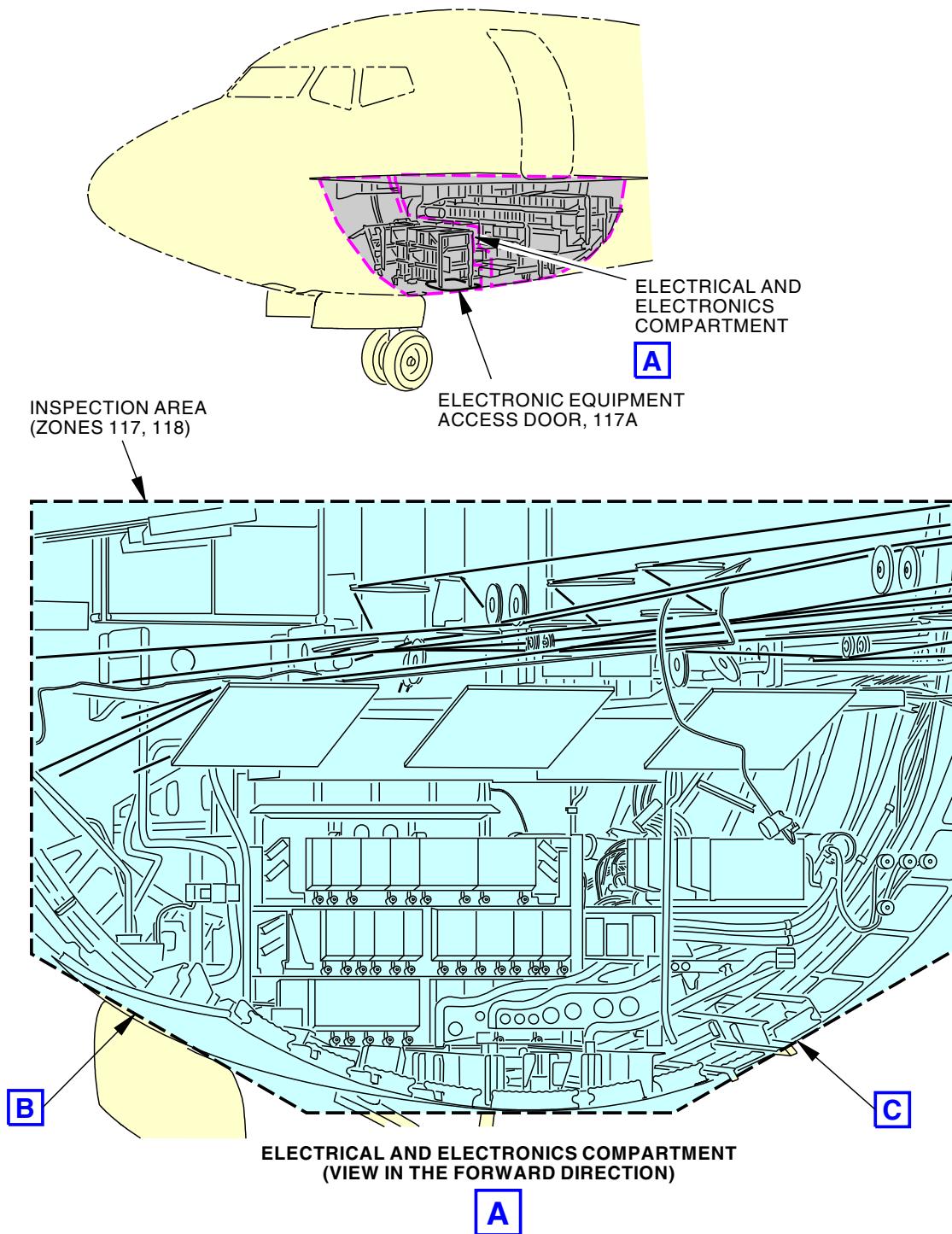
— END OF TASK —

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



2084073 S0000437120\_V3

Electrical Equipment Access Door General Visual (Internal)  
Figure 215/53-05-03-990-843 (Sheet 1 of 6)

EFFECTIVITY  
LOM ALL

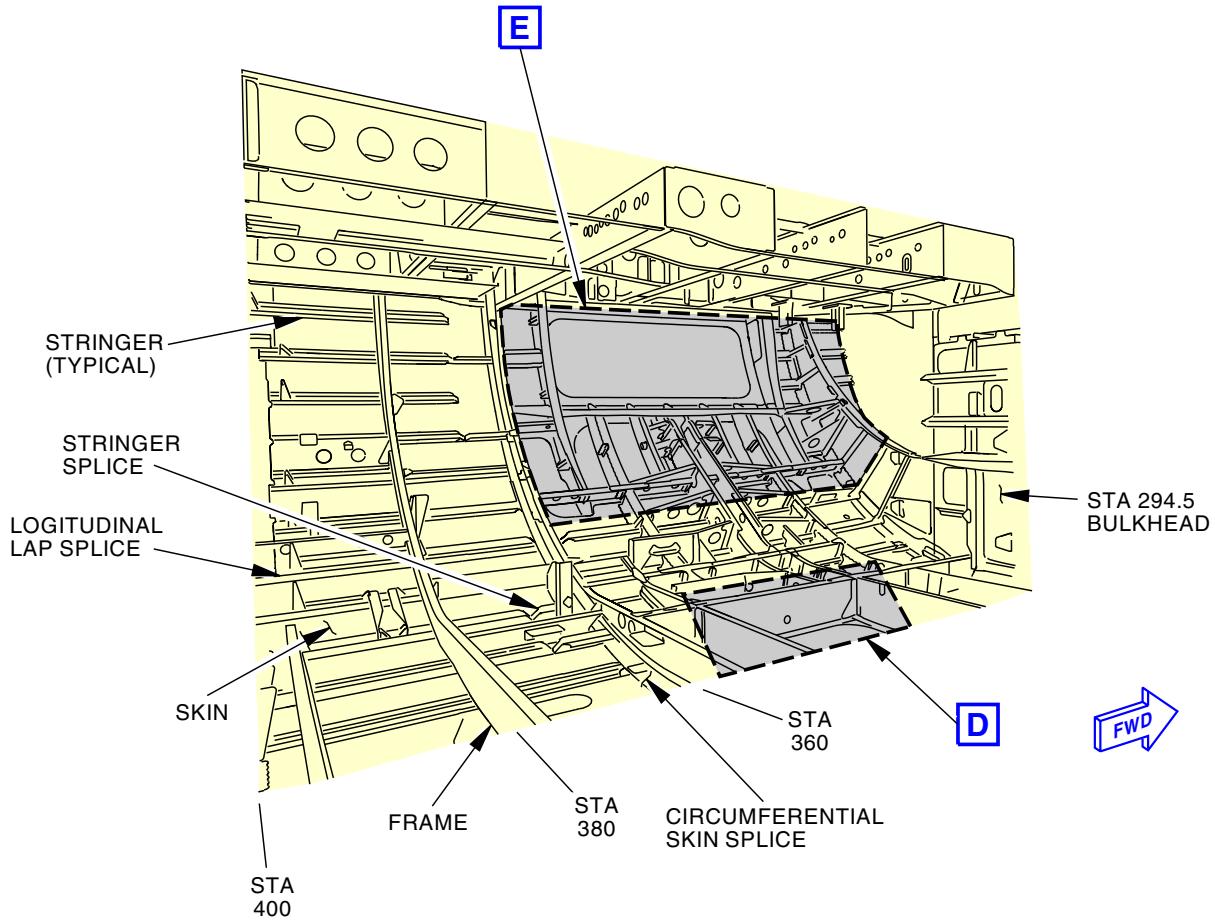
**53-05-03**

D633A101-LOM

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737-600/700/800/900  
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ELECTRICAL AND ELECTRONIC COMPARTMENT  
(LEFT SIDE)

B

MPD ITEM  
53-120-00

2083911 S0000437121\_V3

Electrical Equipment Access Door General Visual (Internal)  
Figure 215/53-05-03-990-843 (Sheet 2 of 6)

EFFECTIVITY  
LOM ALL

53-05-03

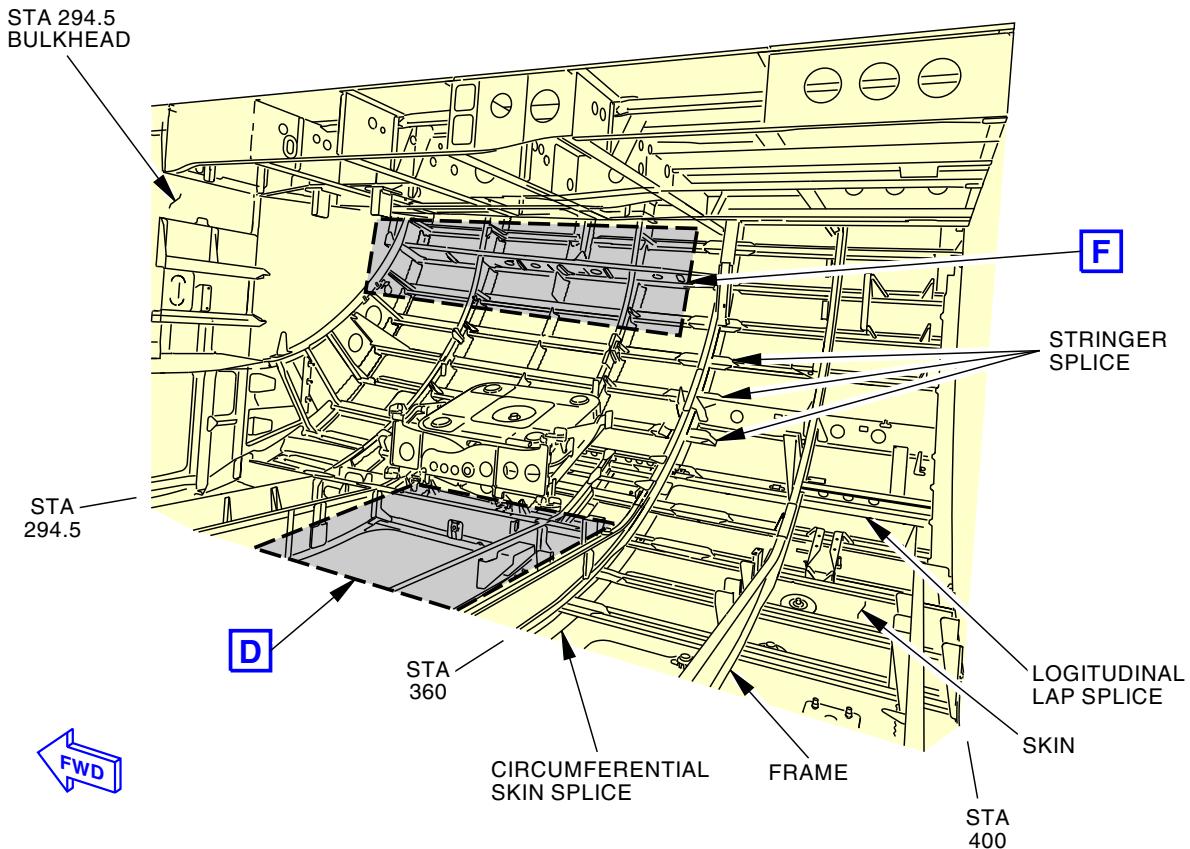
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 243  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



ELECTRICAL AND ELECTRONIC COMPARTMENT  
(RIGHT SIDE)

C

MPD ITEM  
53-120-00

2081267 S0000437122\_V3

Electrical Equipment Access Door General Visual (Internal)  
Figure 215/53-05-03-990-843 (Sheet 3 of 6)

EFFECTIVITY  
LOM ALL

53-05-03

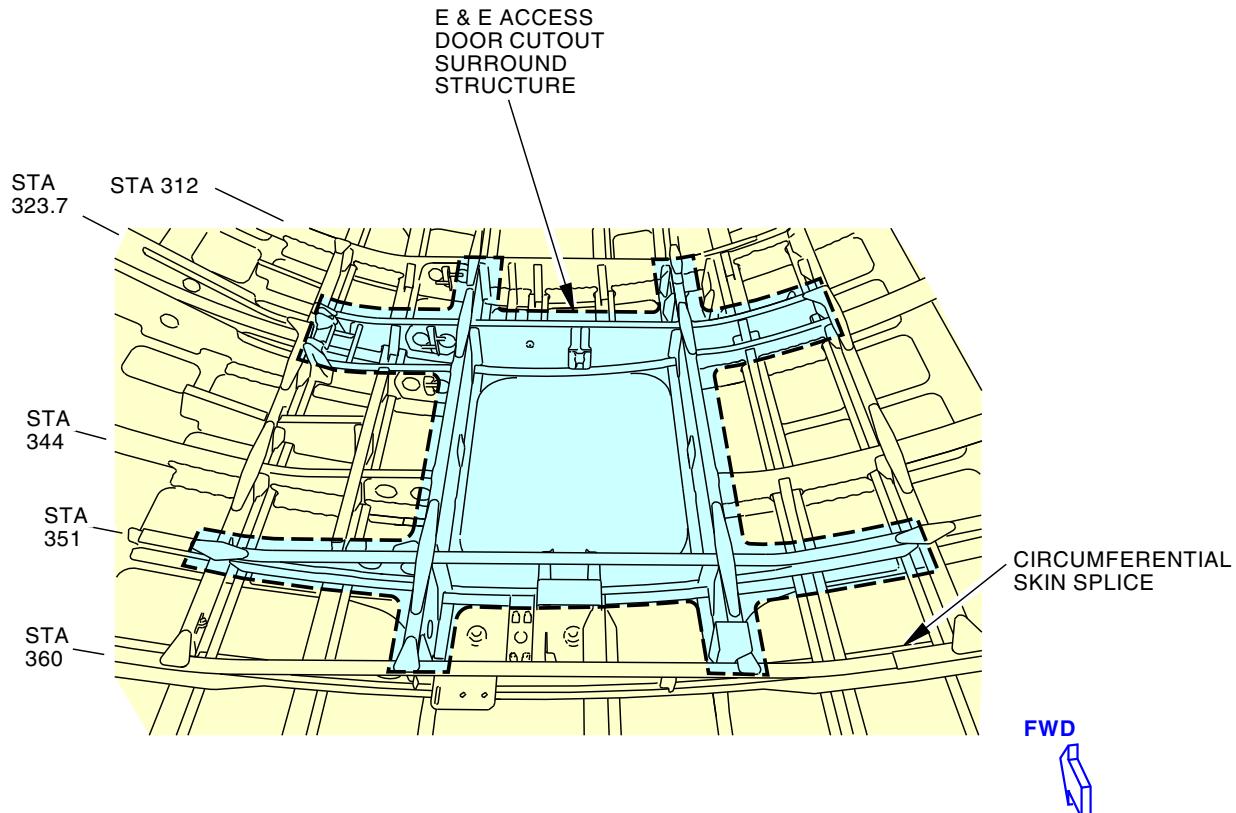
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 244  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



ELECTRICAL AND ELECTRONIC COMPARTMENT  
ACCESS DOOR CUTOUT SURROUND STRUCTURE

D

MPD ITEM  
53-120-00

2084481 S0000437123\_V3

Electrical Equipment Access Door General Visual (Internal)  
Figure 215/53-05-03-990-843 (Sheet 4 of 6)

EFFECTIVITY  
LOM ALL

**53-05-03**

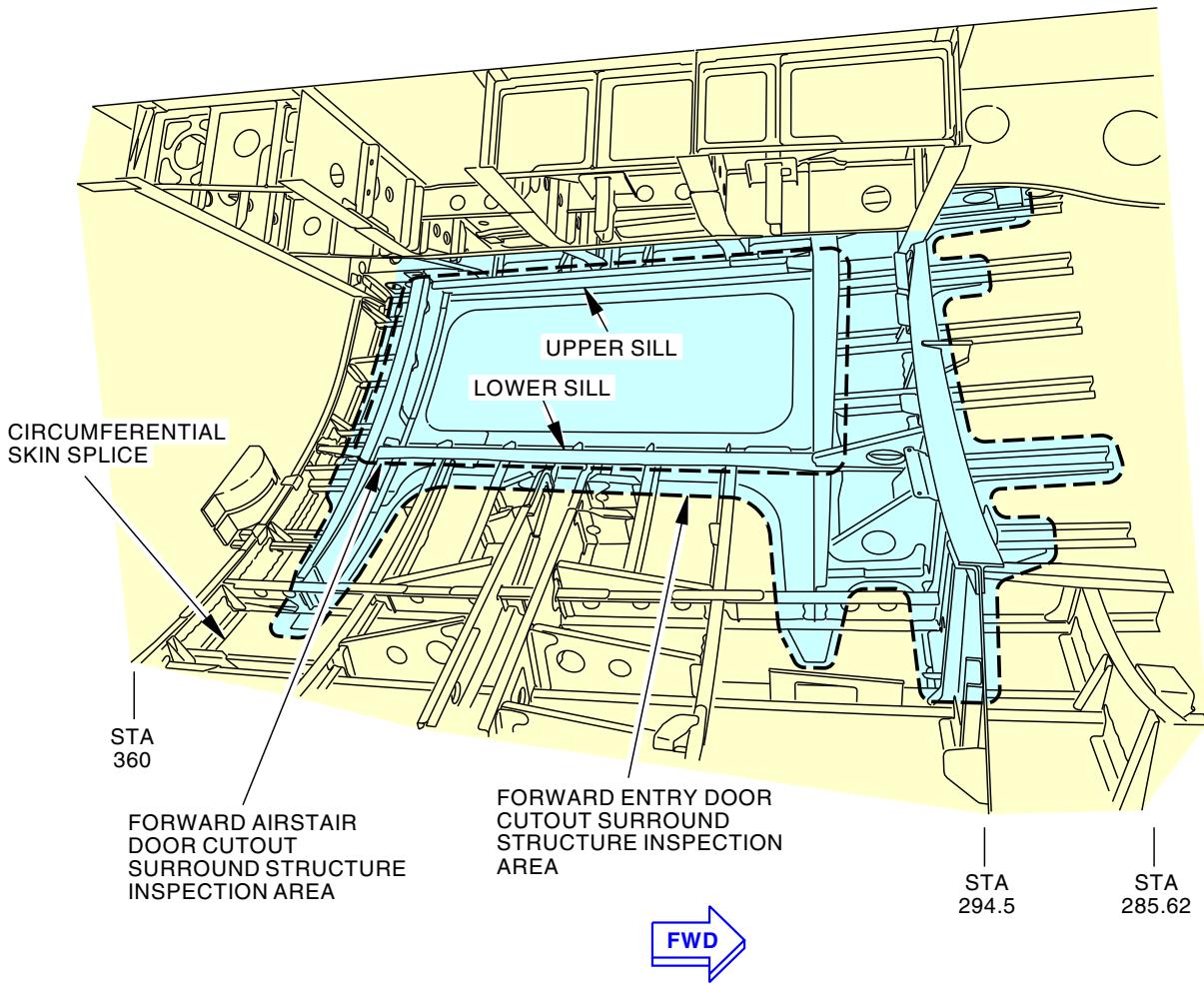
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Page 245  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



FORWARD AIRSTAIR DOOR AND FORWARD ENTRY DOOR CUTOUT  
AND SURROUND STRUCTURE

E

MPD ITEM  
53-120-00

2088473 S0000437124\_V5

Electrical Equipment Access Door General Visual (Internal)  
Figure 215/53-05-03-990-843 (Sheet 5 of 6)

EFFECTIVITY  
LOM ALL

53-05-03

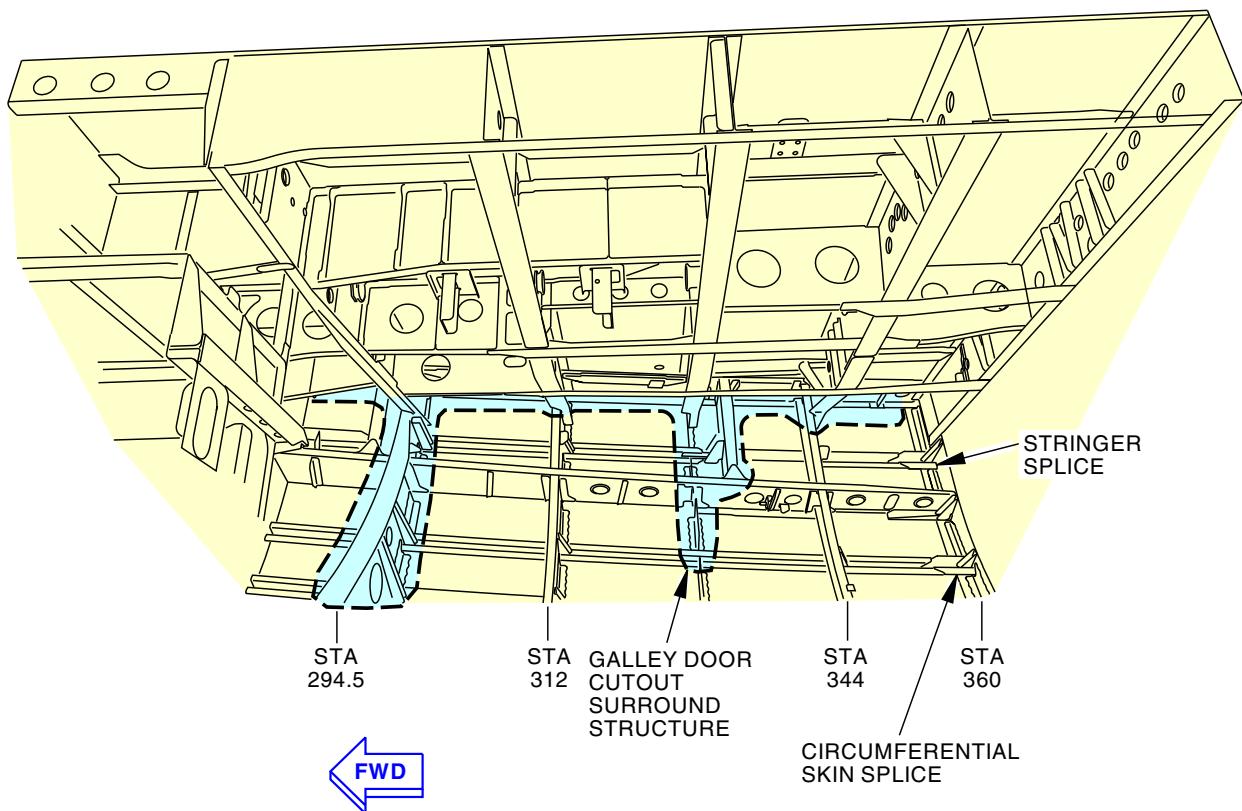
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 246  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



GALLEY DOOR CUTOUT SURROUND STRUCTURE

F

MPD ITEM  
53-120-00

2086454 S0000437125\_V3

Electrical Equipment Access Door General Visual (Internal)  
Figure 215/53-05-03-990-843 (Sheet 6 of 6)

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 247  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-813**

**14. INTERNAL - GENERAL VISUAL: FORWARD CARGO COMPARTMENT**

(Figure 216)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
S1201	Forward Cargo Compartment Inspection

**C. Inspection**

SUBTASK 53-05-03-010-011

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
S1201	Forward Cargo Compartment Inspection

NOTE: Remove sidewalls and ceiling panels. Remove/displace insulation blankets as required. Remove/displace auxiliary fuel tank as required (business jet only).

SUBTASK 53-05-03-210-013

- (2) Do a General Visual inspection of the forward cargo compartment skin panels including skins, frames, and stringers (note: inspection includes the circumferential skin and stringer splice at STA 500E for the -900 models and the circumferential splice at STA 500H for the -800BCF).

SUBTASK 53-05-03-910-015

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-011

- (4) Close this access panel:

<b>Number</b>	<b>Name/Location</b>
S1201	Forward Cargo Compartment Inspection

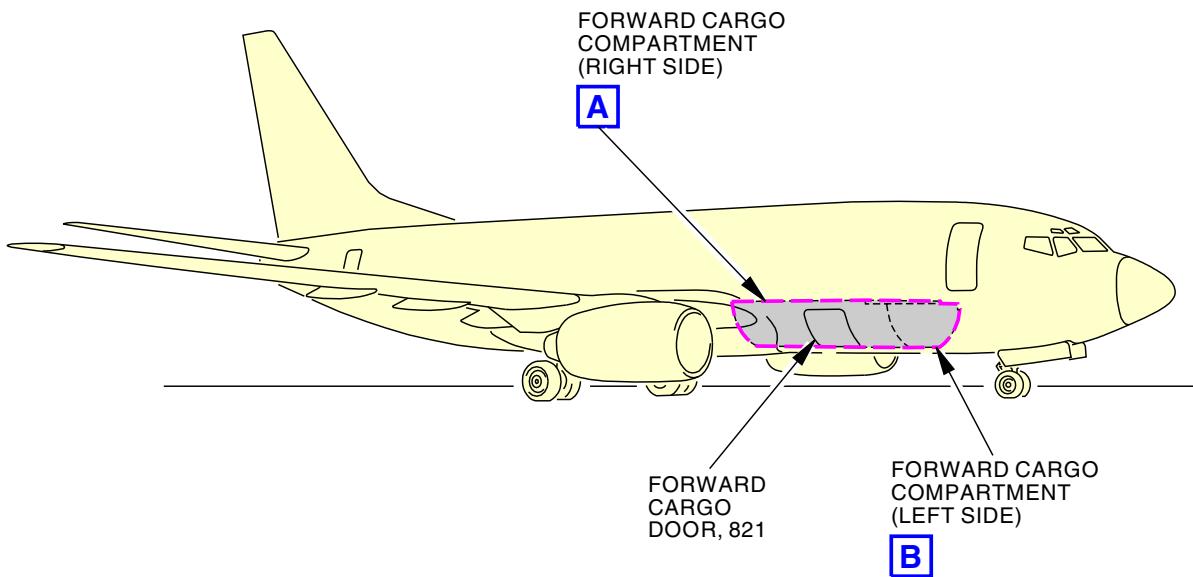
— END OF TASK —

EFFECTIVITY  
LOM ALL

**53-05-03**



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MPD ITEM  
53-130-00

2080203 S0000436833\_V3

**Forward Cargo Compartment General Visual (Internal) (Sidewall Liners and Insulation Removed)**  
**Figure 216/53-05-03-990-846 (Sheet 1 of 4)**

EFFECTIVITY  
LOM ALL

D633A101-LOM

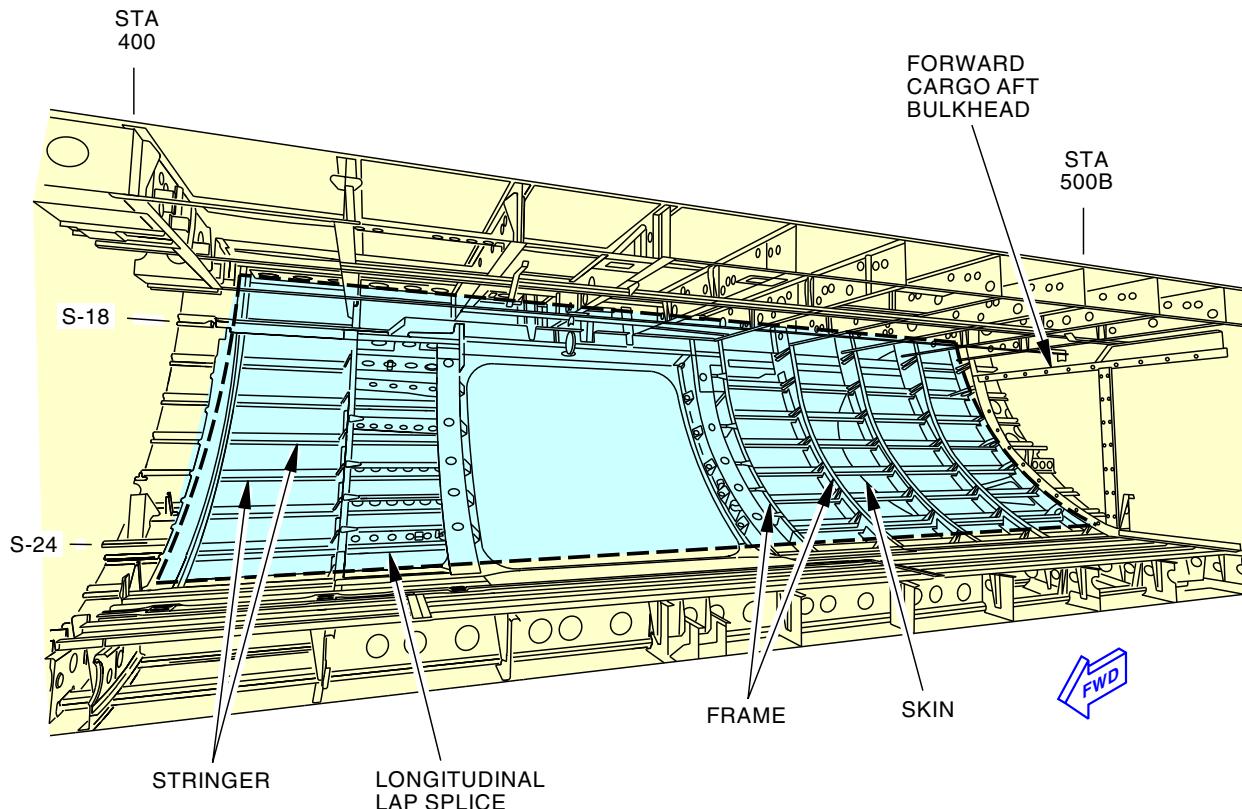
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**53-05-03**

Page 249  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



FORWARD CARGO COMPARTMENT (STA 400 TO AFT BULKHEAD)  
(RIGHT SIDE VIEW)

A

MPD ITEM  
53-130-00

2080217 S0000436834\_V3

Forward Cargo Compartment General Visual (Internal) (Sidewall Liners and Insulation Removed)  
Figure 216/53-05-03-990-846 (Sheet 2 of 4)

EFFECTIVITY  
LOM ALL

D633A101-LOM

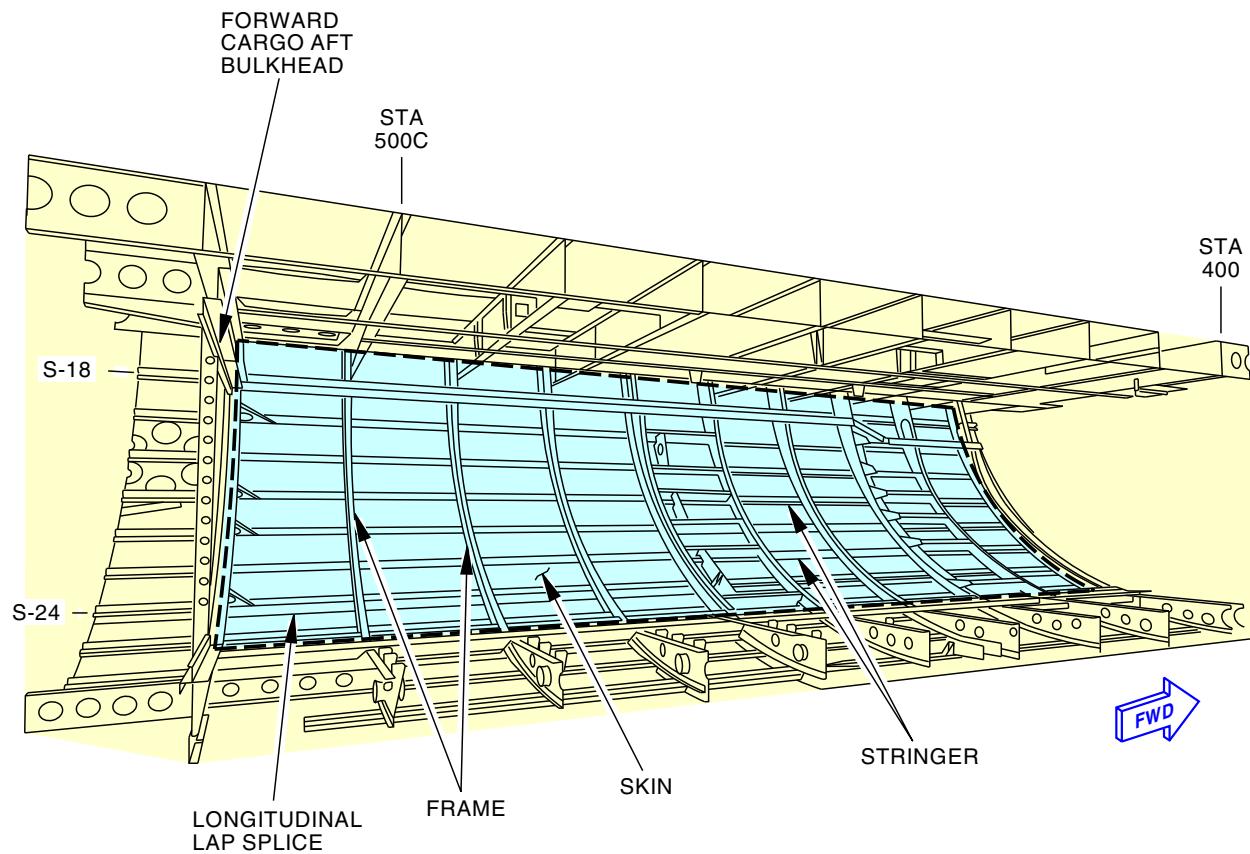
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**53-05-03**

Page 250  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



FORWARD CARGO COMPARTMENT (STA 400 TO AFT BULKHEAD)  
(LEFT SIDE VIEW)

B

MPD ITEM  
53-130-00

2082663 S0000436835\_V3

Forward Cargo Compartment General Visual (Internal) (Sidewall Liners and Insulation Removed)  
Figure 216/53-05-03-990-846 (Sheet 3 of 4)

EFFECTIVITY  
LOM ALL

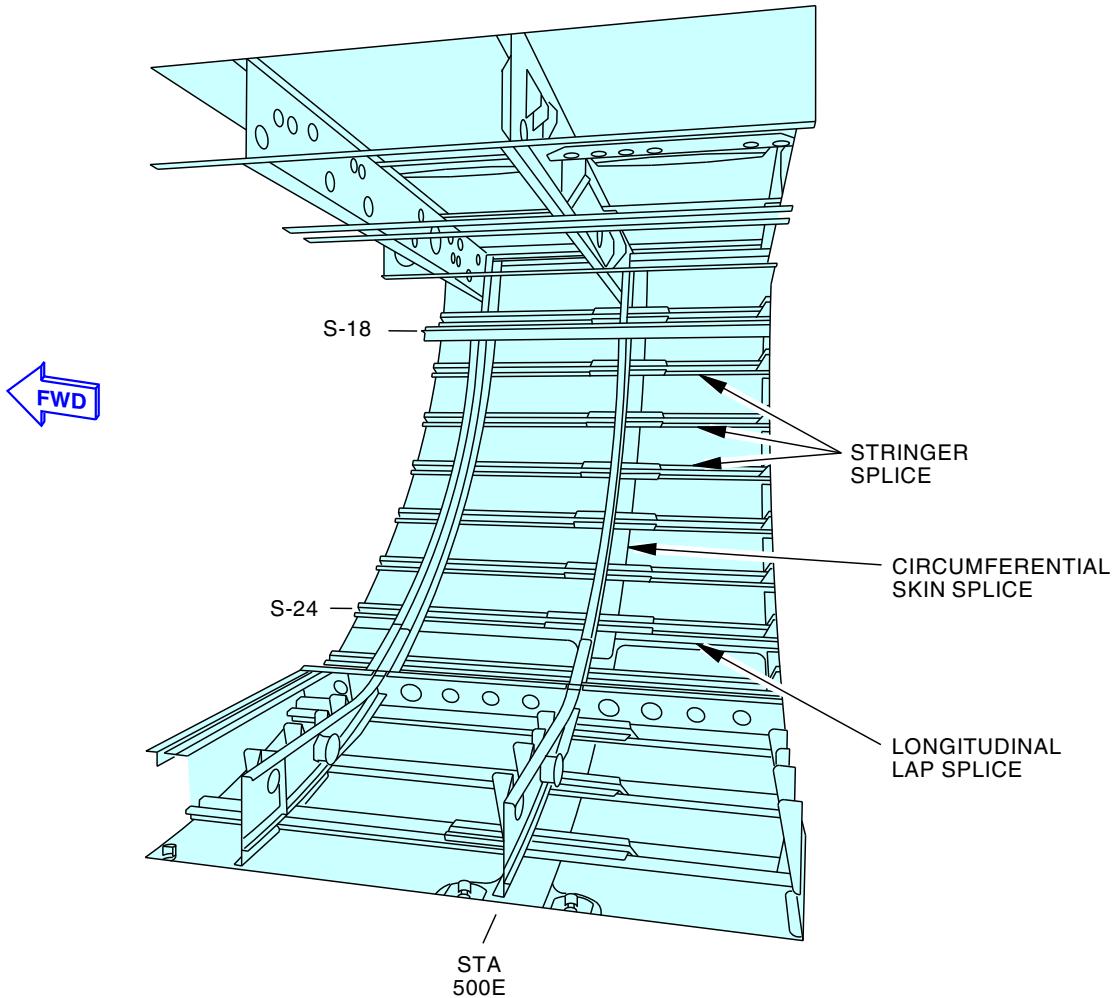
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**53-05-03**

Page 251  
Oct 15/2022


**BOEING**  
 737-600/700/800/900  
 AIRCRAFT MAINTENANCE MANUAL



**CIRCUMFERENTIAL SKIN AND STRINGER SPLICE -900 MODEL  
(RIGHT SIDE VIEW, LEFT SIDE OPPOSITE)**

MPD ITEM  
53-130-00

2082409 S0000436836\_V3

**Forward Cargo Compartment General Visual (Internal) (Sidewall Liners and Insulation Removed)  
Figure 216/53-05-03-990-846 (Sheet 4 of 4)**

EFFECTIVITY	
LOM ALL	

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-814**

- 15. INTERNAL - GENERAL VISUAL: FORWARD CARGO COMPARTMENT FLOOR STRUCTURE**  
(Figure 217)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
121	Forward Cargo Compartment - Left
122	Forward Cargo Compartment - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
S1003	Forward and Aft Cargo Compartment Floor Structure Inspection

**C. Inspection**

SUBTASK 53-05-03-010-012

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
S1003	Forward and Aft Cargo Compartment Floor Structure Inspection

NOTE: Remove cargo floor panels.

SUBTASK 53-05-03-210-014

- (2) Do a General Visual inspection of the forward cargo compartment floor structure.

SUBTASK 53-05-03-910-016

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-012

- (4) Close this access panel:

<b>Number</b>	<b>Name/Location</b>
S1003	Forward and Aft Cargo Compartment Floor Structure Inspection

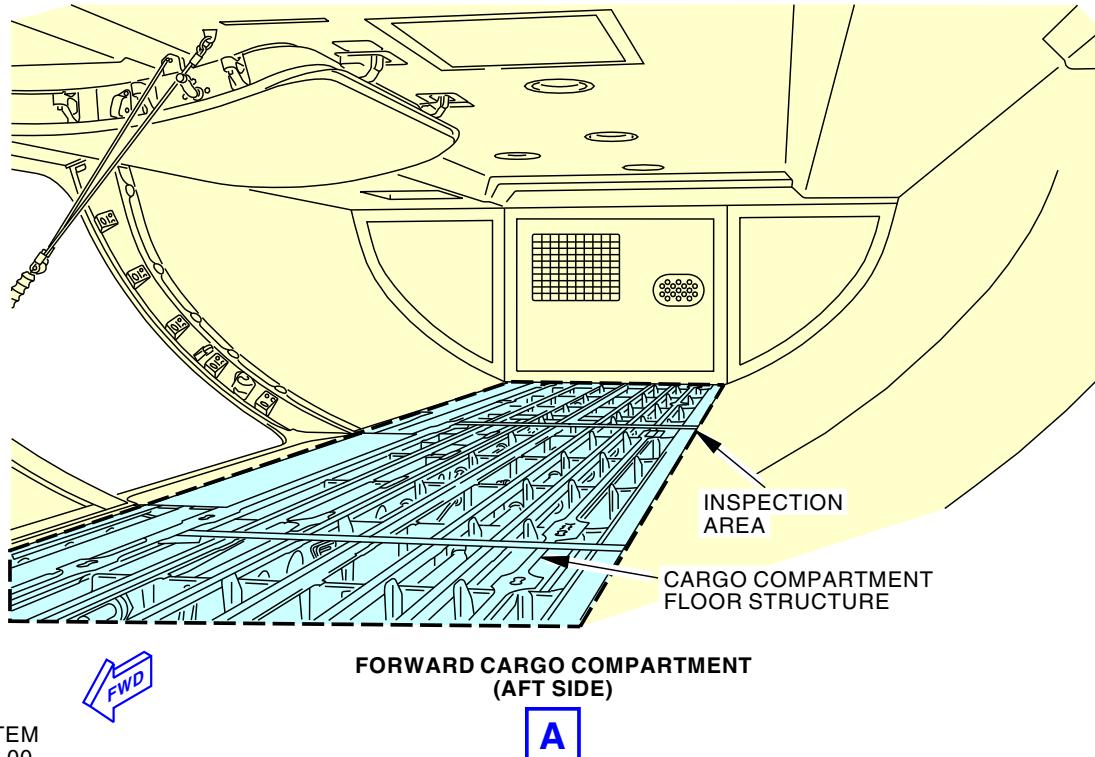
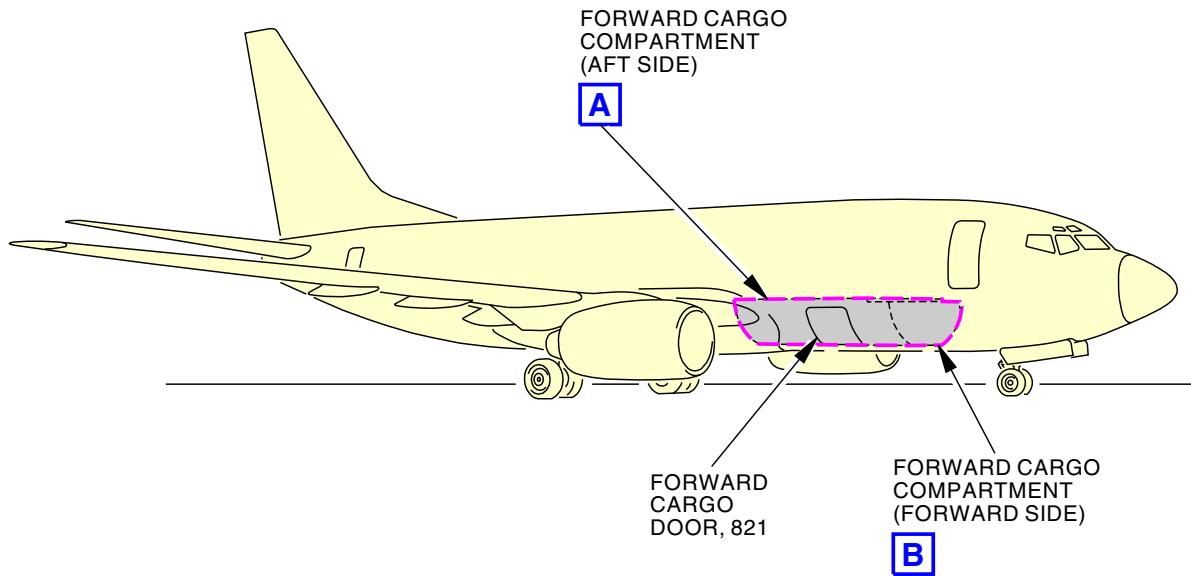
———— END OF TASK ————



**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-140-00

485945 S0000145825\_V3

Forward Cargo Compartment Floor Structure General Visual (Internal)  
Figure 217/53-05-03-990-819 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

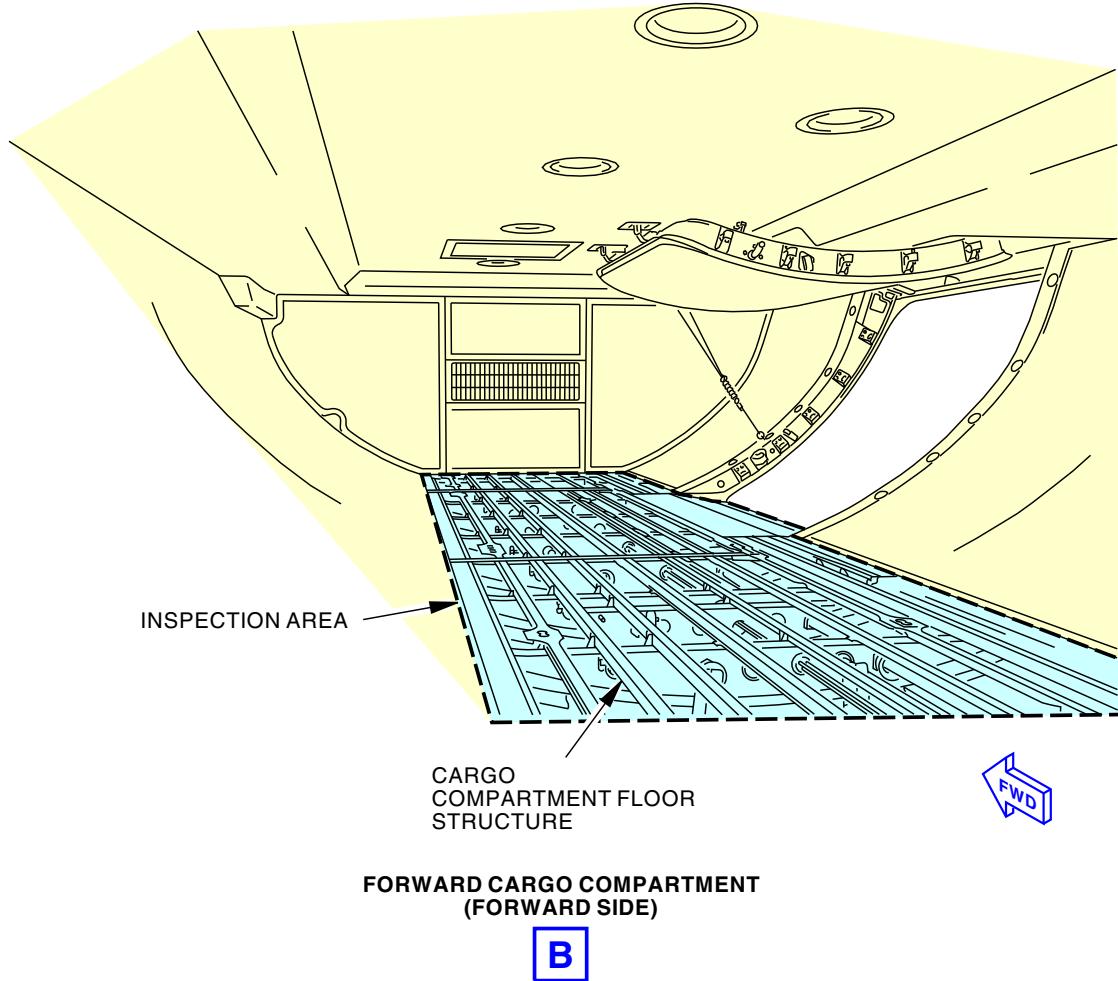
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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-140-00

485946 S0000145826\_V3

Forward Cargo Compartment Floor Structure General Visual (Internal)  
Figure 217/53-05-03-990-819 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 255  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-815**

**16. INTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT FLOOR STRUCTURE**

(Figure 218)

**A. Location Zones**

Zone	Area
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

**B. Access Panels**

Number	Name/Location
S1003	Forward and Aft Cargo Compartment Floor Structure Inspection

**C. Inspection**

SUBTASK 53-05-03-010-013

- (1) Open this access panel:

**Number      Name/Location**

S1003      Forward and Aft Cargo Compartment Floor Structure Inspection

NOTE: Remove cargo floor panels.

SUBTASK 53-05-03-210-015

- (2) Do a General Visual inspection of the aft cargo compartment floor structure.

SUBTASK 53-05-03-910-017

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-013

- (4) Close this access panel:

**Number      Name/Location**

S1003      Forward and Aft Cargo Compartment Floor Structure Inspection

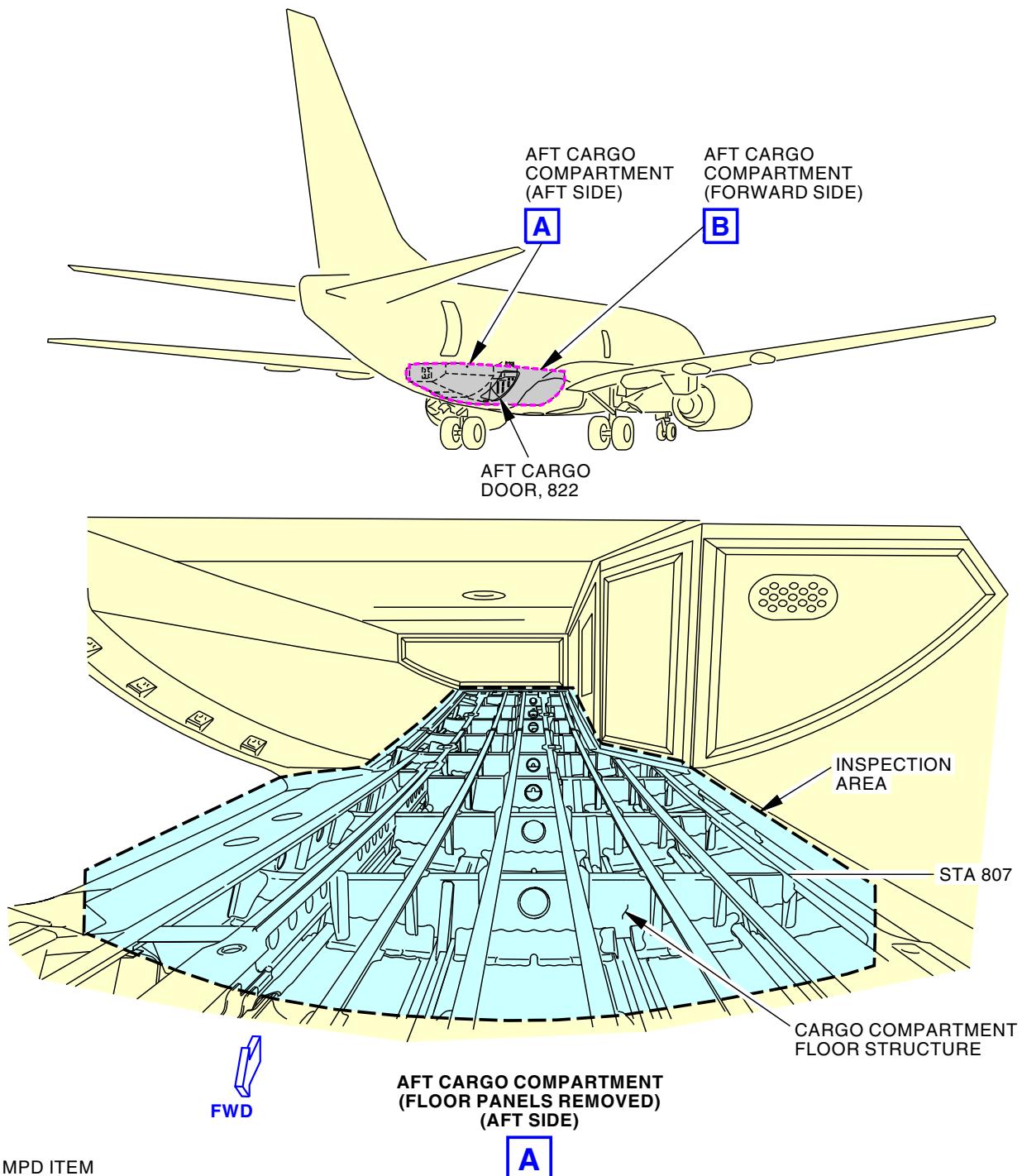
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EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-140-00

D64162 S0000161692\_V2

INTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT FLOOR STRUCTURE  
Figure 218/53-05-03-990-828 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

D633A101-LOM

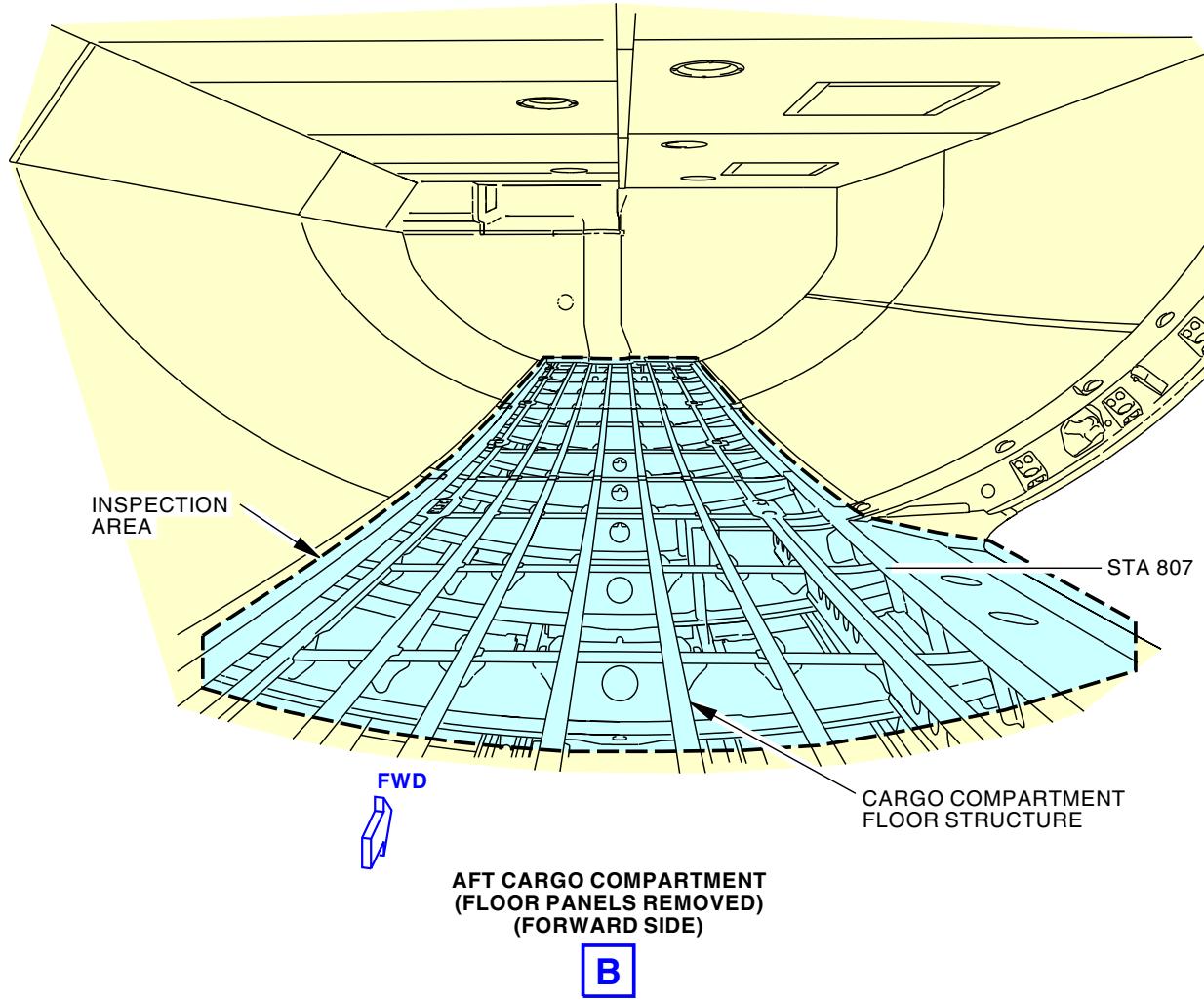
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**53-05-03**

Page 257  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-140-00

D64168 S0000161694\_V2

INTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT FLOOR STRUCTURE  
Figure 218/53-05-03-990-828 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 258  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-211-803**

**17. INTERNAL - DETAILED: FORWARD CARGO DOOR CUTOUT**

(Figure 219)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
122	Forward Cargo Compartment - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
S1221	Forward Cargo Door Cutout Inspection

**C. Inspection**

SUBTASK 53-05-03-010-057

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
S1221	Forward Cargo Door Cutout Inspection

NOTE: Remove door reveals and scuff plates. Remove sidewalls as required.  
Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-003

- (2) Do a Detailed inspection of the forward cargo door cutout surround structure.

SUBTASK 53-05-03-910-018

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-057

- (4) Close this access panel:

<b>Number</b>	<b>Name/Location</b>
S1221	Forward Cargo Door Cutout Inspection

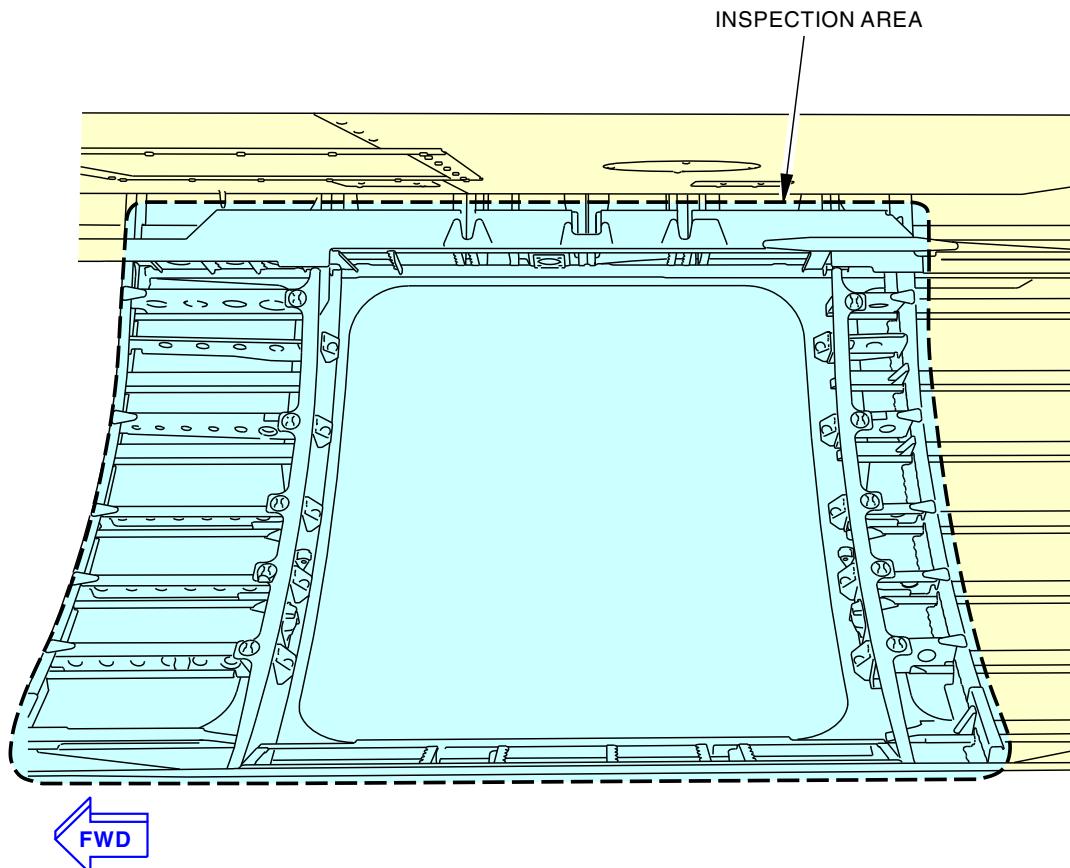
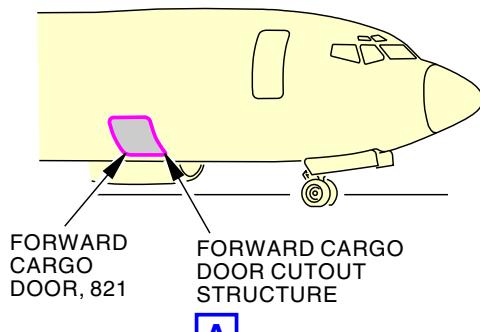
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-150-00

485944 S0000145836\_V2

Forward Cargo Door Cutout Detailed (Internal)  
Figure 219/53-05-03-990-821

EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 260  
Oct 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-816**

**18. INTERNAL - GENERAL VISUAL: FORWARD BILGE**

(Figure 220)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
123	Forward Cargo Compartment - Left
124	Forward Cargo Compartment - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
S1202	Forward Bilge Inspection

**C. Inspection**

SUBTASK 53-05-03-010-014

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
S1202	Forward Bilge Inspection

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

SUBTASK 53-05-03-210-016

- (2) Do a General Visual inspection of the forward bilge skin panels including skins, frames, stringers, longitudinal lap splices, and cargo door cutout surround structure in bilge (note: inspection includes the circumferential skin and stringer splice at STA 500E for the -900 models).

SUBTASK 53-05-03-910-019

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-014

- (4) Close this access panel:

<b>Number</b>	<b>Name/Location</b>
S1202	Forward Bilge Inspection

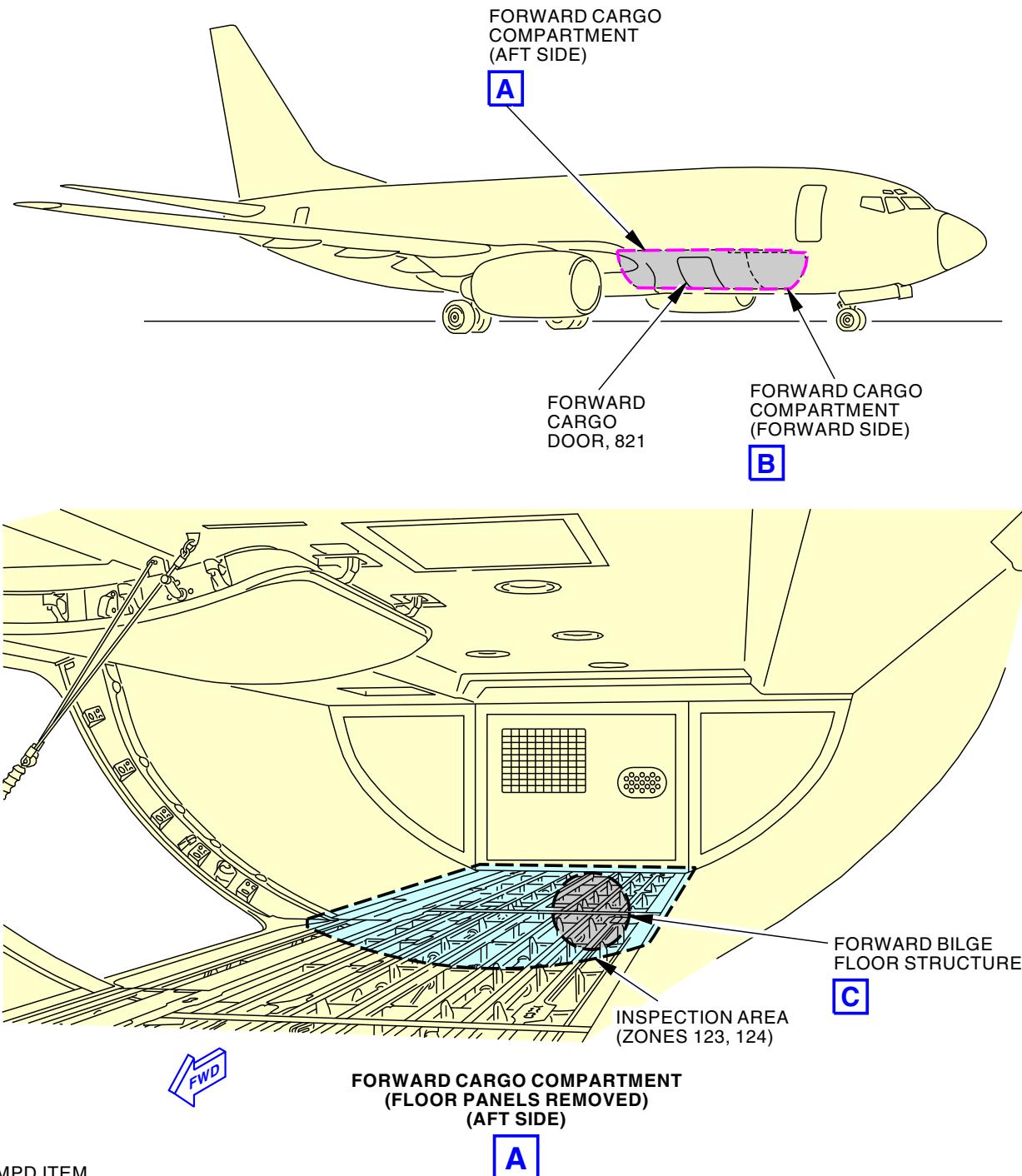
— END OF TASK —

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-160-00

D46438 S0000158657\_V2

|  
Below the Forward Cargo Comp - Forward Bilge General Visual (Int)  
Figure 220/53-05-03-990-825 (Sheet 1 of 5)

EFFECTIVITY  
LOM ALL

D633A101-LOM

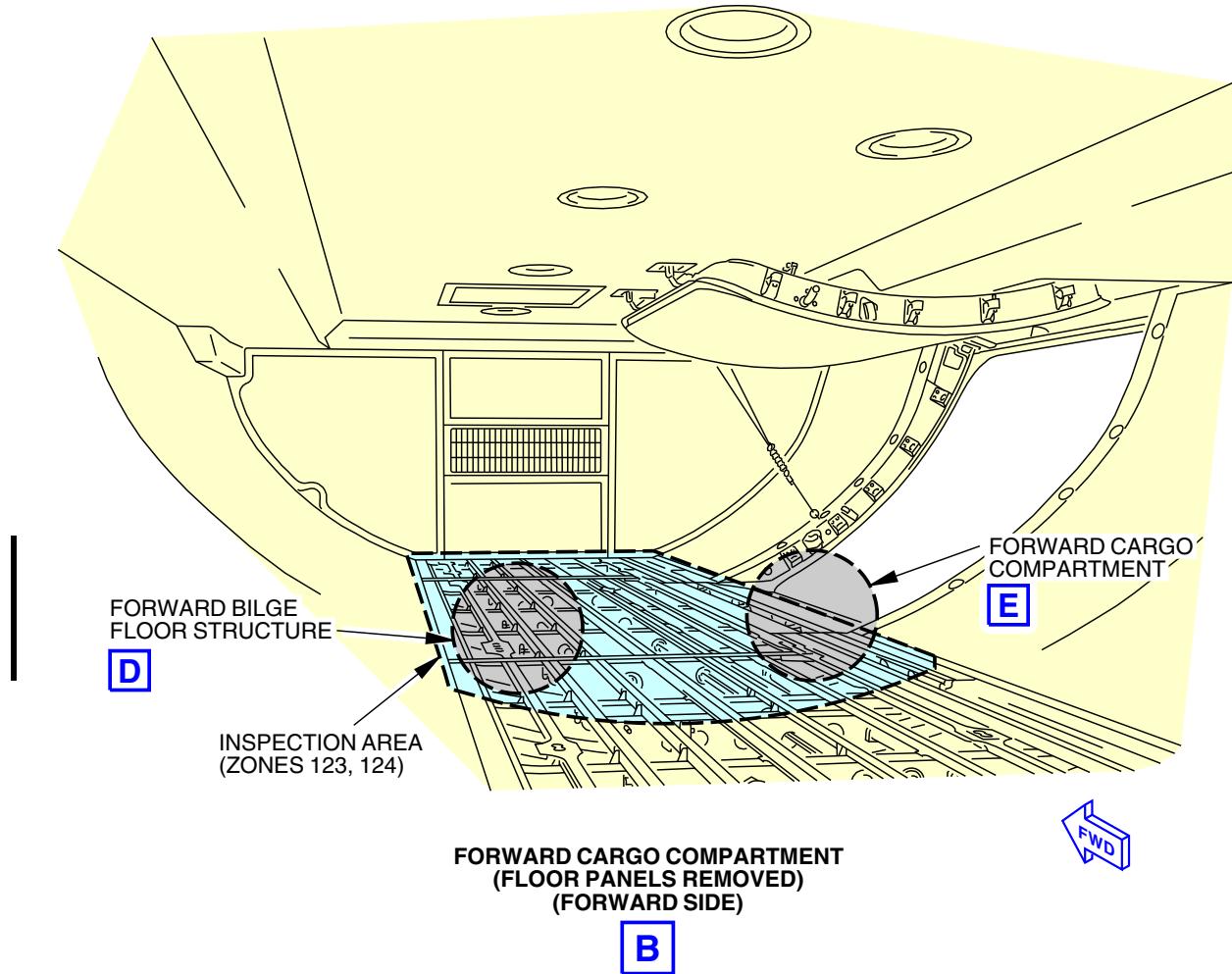
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**53-05-03**

Page 262  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-160-00

D46441 S0000158658\_V3

| Below the Forward Cargo Comp - Forward Bilge General Visual (Int)  
Figure 220/53-05-03-990-825 (Sheet 2 of 5)

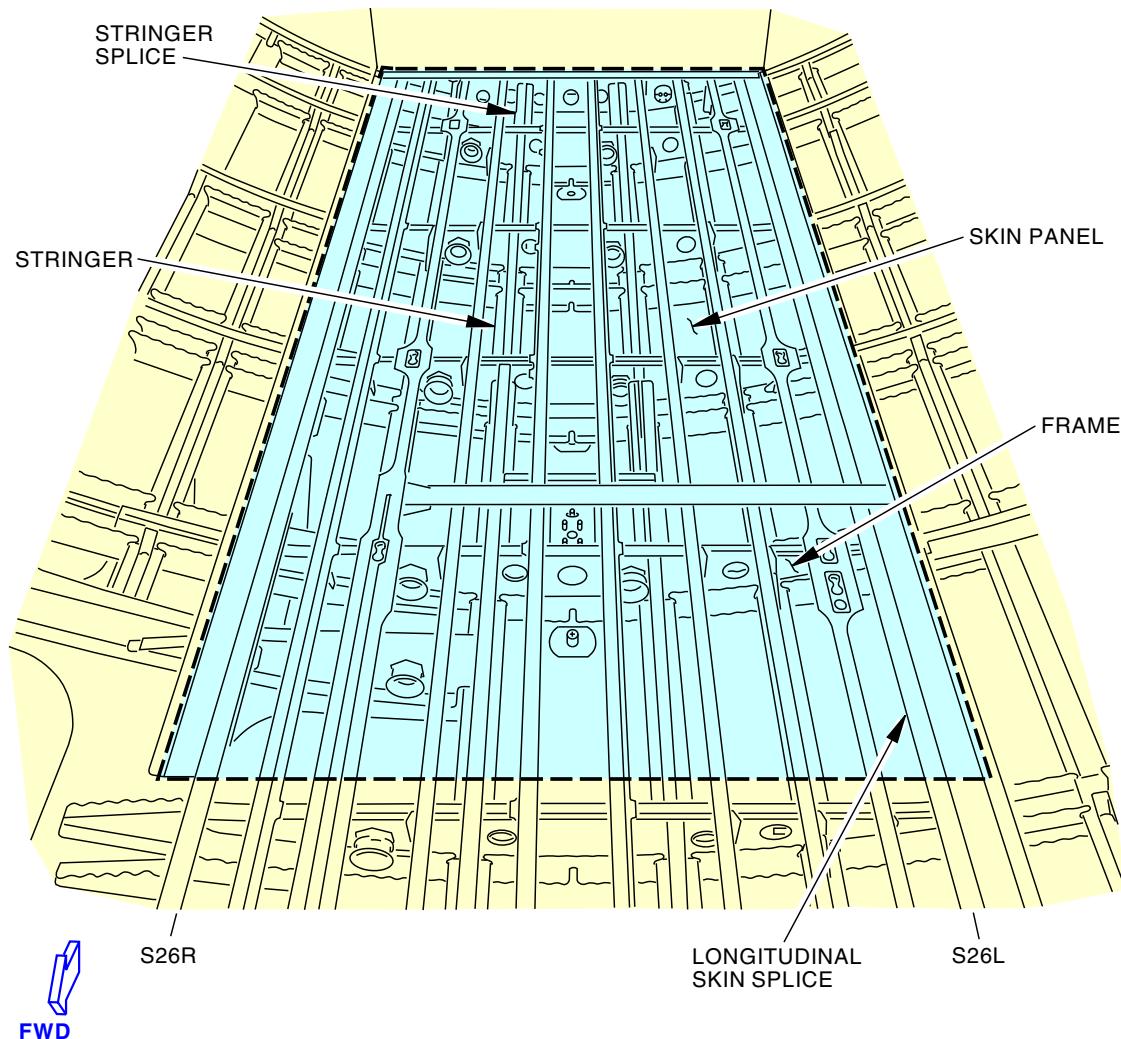
EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 263  
Feb 15/2025



**FORWARD BILGE FLOOR STRUCTURE  
(FLOOR PANELS AND INSULATION REMOVED)  
(FORWARD SIDE)**

**C**

MPD ITEM  
53-160-00

2164768 S0000465828\_V2

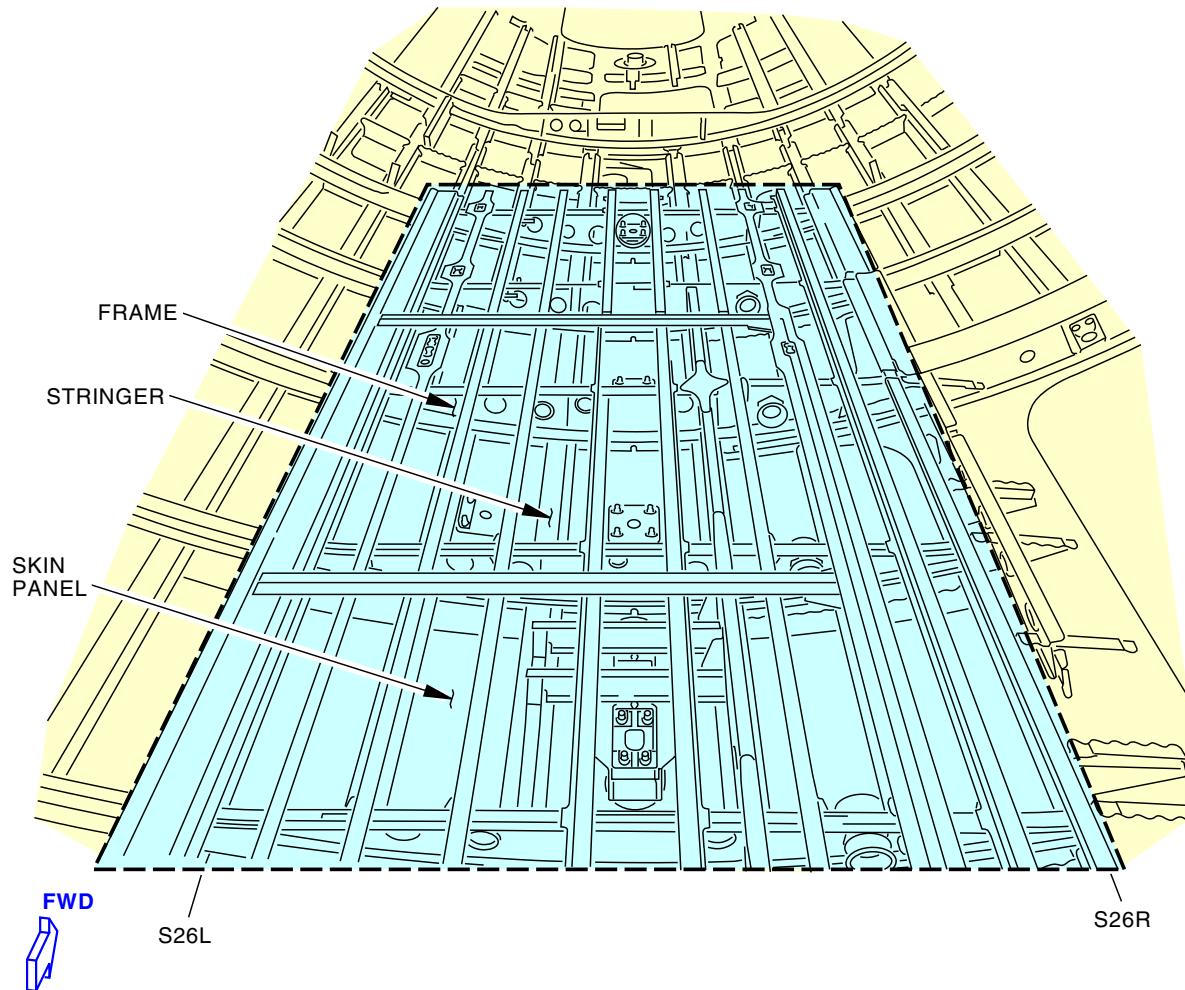
**Below the Forward Cargo Comp - Forward Bilge General Visual (Int)  
Figure 220/53-05-03-990-825 (Sheet 3 of 5)**

EFFECTIVITY
LOM ALL

**53-05-03**



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MPD ITEM  
53-160-00

2164769 S0000465860\_V2

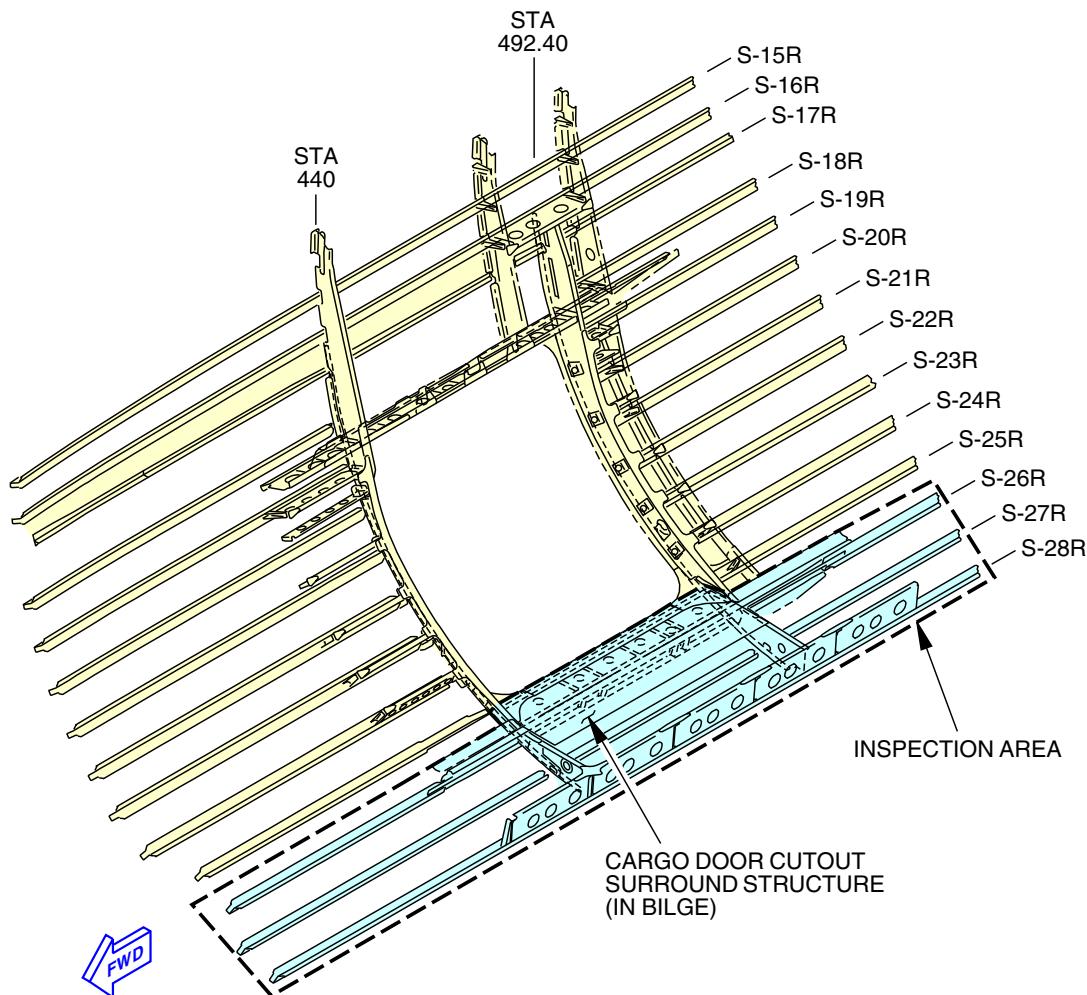
|  
Below the Forward Cargo Comp - Forward Bilge General Visual (Int)  
Figure 220/53-05-03-990-825 (Sheet 4 of 5)

EFFECTIVITY  
LOM ALL

D633A101-LOM

**53-05-03**

Page 265  
Feb 15/2025

FORWARD CARGO COMPARTMENT  
(DOOR REVEALS AND SIDEWALL PANELS REMOVED)

E

MPD ITEM  
53-160-00

3083344 S0000838359\_V1

Below the Forward Cargo Comp - Forward Bilge General Visual (Int)  
Figure 220/53-05-03-990-825 (Sheet 5 of 5)EFFECTIVITY  
LOM ALL

53-05-03



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**TASK 53-05-03-210-817**

**19. INTERNAL - GENERAL VISUAL: AREA AFT OF FORWARD CARGO COMPARTMENT**

(Figure 221)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
S1203	Area Aft Of Forward Cargo Compartment Inspection

**C. Inspection**

SUBTASK 53-05-03-010-015

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
S1203	Area Aft Of Forward Cargo Compartment Inspection

NOTE: Remove forward cargo compartment aft bulkhead panels. Remove/displace insulation blankets as required. Remove ducting as required.

SUBTASK 53-05-03-210-017

- (2) Do a General Visual inspection of the area aft of forward cargo compartment, including skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices, and forward side of Sta 540 bulkhead and bulkhead splices.

SUBTASK 53-05-03-910-020

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-015

- (4) Close this access panel:

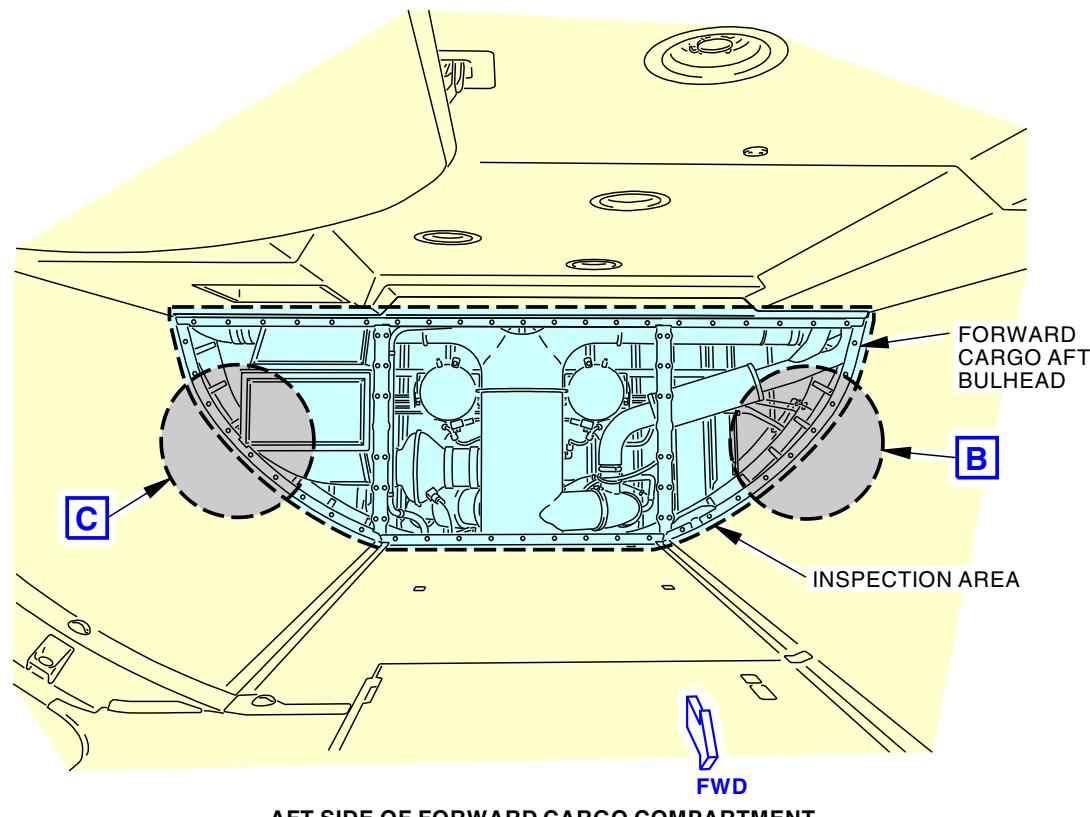
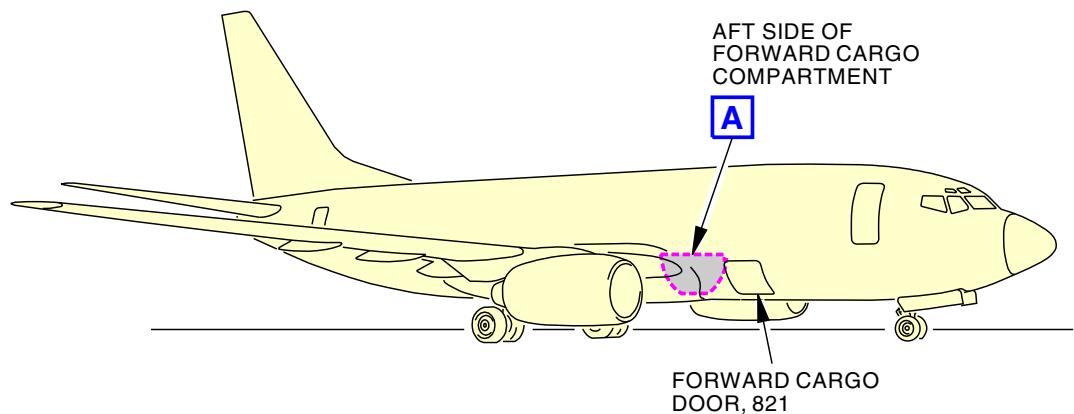
<b>Number</b>	<b>Name/Location</b>
S1203	Area Aft Of Forward Cargo Compartment Inspection

— END OF TASK —

EFFECTIVITY  
LOM ALL

**53-05-03**

**BOEING**  
**737-600/700/800/900**  
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MPD ITEM  
53-170-00

**A**

2079477 S0000435859\_V2

**INTERNAL-GENERAL VISUAL: AREA AFT OF FORWARD CARGO COMPARTMENT**  
**Figure 221/53-05-03-990-847 (Sheet 1 of 3)**

EFFECTIVITY
LOM ALL

D633A101-LOM

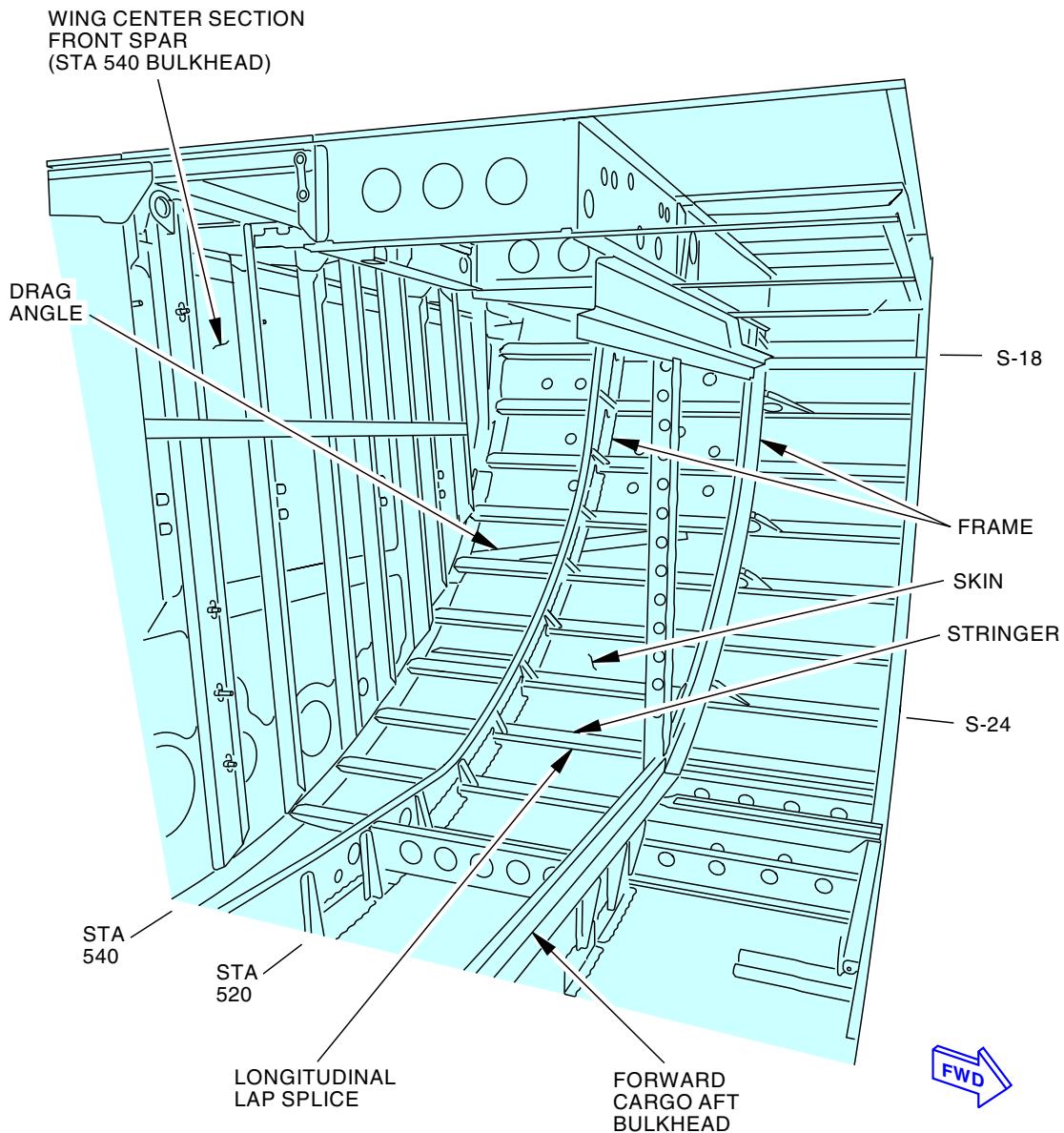
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 268  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



AREA AFT OF FORWARD CARGO  
(LEFT SIDE VIEW)

B

MPD ITEM  
53-170-00

2079756 S0000435862\_V3

INTERNAL-GENERAL VISUAL: AREA AFT OF FORWARD CARGO COMPARTMENT  
Figure 221/53-05-03-990-847 (Sheet 2 of 3)

EFFECTIVITY  
LOM ALL

**53-05-03**

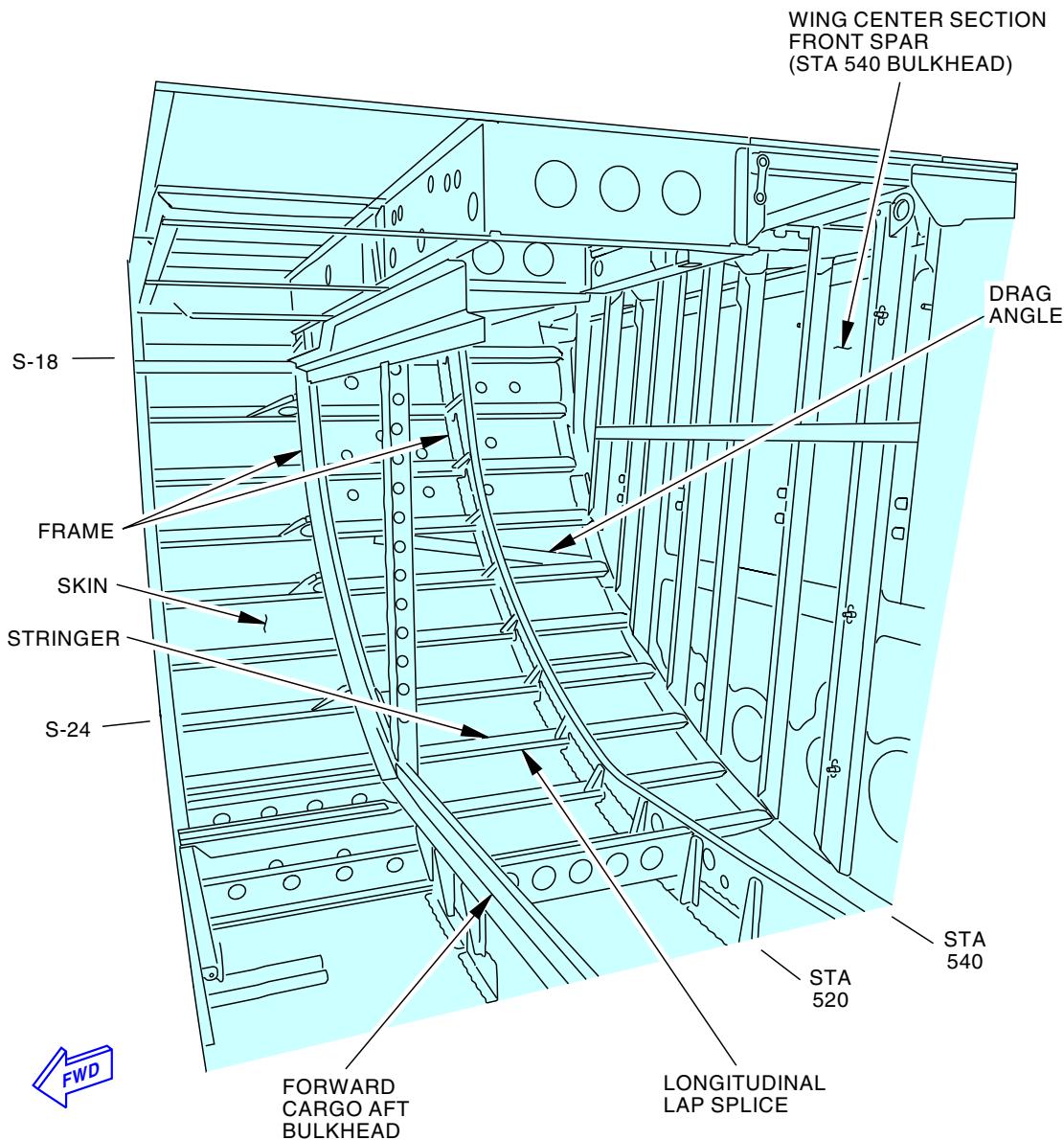
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 269  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



AREA AFT OF FORWARD CARGO  
(RIGHT SIDE VIEW)

C

MPD ITEM  
53-170-00

2080303 S0000435861\_V3

INTERNAL-GENERAL VISUAL: AREA AFT OF FORWARD CARGO COMPARTMENT  
Figure 221/53-05-03-990-847 (Sheet 3 of 3)

EFFECTIVITY  
LOM ALL

D633A101-LOM

**53-05-03**

Page 270  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-818**

20. **INTERNAL - GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (Forward Of Wing Box)**  
(Figure 222)

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

**A. References**

Reference	Title
21-51-23-000-801	Ram Air Inlet Modulation Panels - Removal (P/B 401)
21-51-23-400-801	Ram Air Inlet Modulation Panels - Installation (P/B 401)

**B. Location Zones**

Zone	Area
129	Keel Beam (Part) Body Station 501.70 to Body Station 540.00
191	Lower Wing-To-Body Fairing - Forward of Wing Box

**C. Access Panels**

Number	Name/Location
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper
191BL	Forward Wing To Body Fairing Panel, Ram Air Inlet
191BR	Forward Wing To Body Fairing Panel, Ram Air Inlet
191CL	Forward Wing To Body Fairing Panel - Middle
191CR	Forward Wing To Body Fairing Panel - Middle
191D	Forward Wing To Body Fairing Panel - Lower
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191GL	Ram Air Actuator Panel - Forward
191GR	Ram Air Actuator Panel - Forward
191HL	Ram Air Inlet Lip Panel - Forward
191HR	Ram Air Inlet Lip Panel - Forward

**D. Inspection**

**SUBTASK 53-05-03-010-016**

- (1) Open these access panels:

Number	Name/Location
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper
191BL	Forward Wing To Body Fairing Panel, Ram Air Inlet
191BR	Forward Wing To Body Fairing Panel, Ram Air Inlet
191CL	Forward Wing To Body Fairing Panel - Middle
191CR	Forward Wing To Body Fairing Panel - Middle
191D	Forward Wing To Body Fairing Panel - Lower
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191GL	Ram Air Actuator Panel - Forward

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Number    Name/Location

191GR	Ram Air Actuator Panel - Forward
191HL	Ram Air Inlet Lip Panel - Forward
191HR	Ram Air Inlet Lip Panel - Forward

SUBTASK 53-05-03-010-080

- (2) Open the forward ram air modulation panel. To open the panel, do this task: Ram Air Inlet Modulation Panels - Removal, TASK 21-51-23-000-801.

SUBTASK 53-05-03-210-018

- (3) Do a General Visual inspection of the area under lower wing-to-body fairing (forward of wing box), including skin panels, longitudinal lap splices, keel beam extension, wing-to-body drag angles, and Sta 540 bulkhead (note: inspection includes the circumferential splice at STA 500H for the -800BCF).

SUBTASK 53-05-03-910-021

- (4) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-016

- (5) Close these access panels:

Number    Name/Location

191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper
191BL	Forward Wing To Body Fairing Panel, Ram Air Inlet
191BR	Forward Wing To Body Fairing Panel, Ram Air Inlet
191CL	Forward Wing To Body Fairing Panel - Middle
191CR	Forward Wing To Body Fairing Panel - Middle
191D	Forward Wing To Body Fairing Panel - Lower
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191GL	Ram Air Actuator Panel - Forward
191GR	Ram Air Actuator Panel - Forward
191HL	Ram Air Inlet Lip Panel - Forward
191HR	Ram Air Inlet Lip Panel - Forward

SUBTASK 53-05-03-410-073

- (6) Close the forward ram air modulation panel. To close the panel, do this task: Ram Air Inlet Modulation Panels - Installation, TASK 21-51-23-400-801.

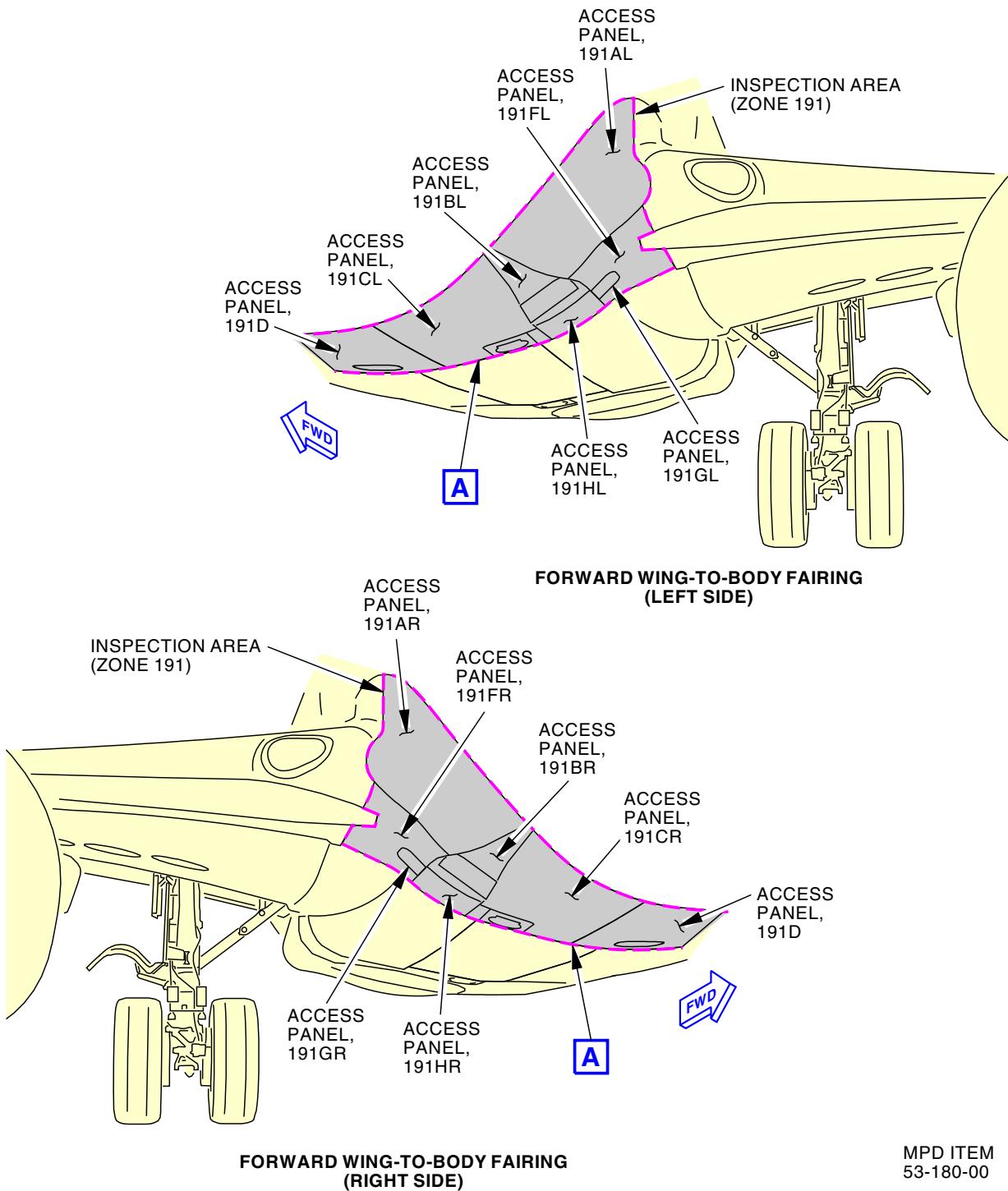
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



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MPD ITEM  
53-180-00

2077124 S0000435772\_V2

INTERNAL-GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (Forward Of Wing Box)  
Figure 222/53-05-03-990-850 (Sheet 1 of 2)

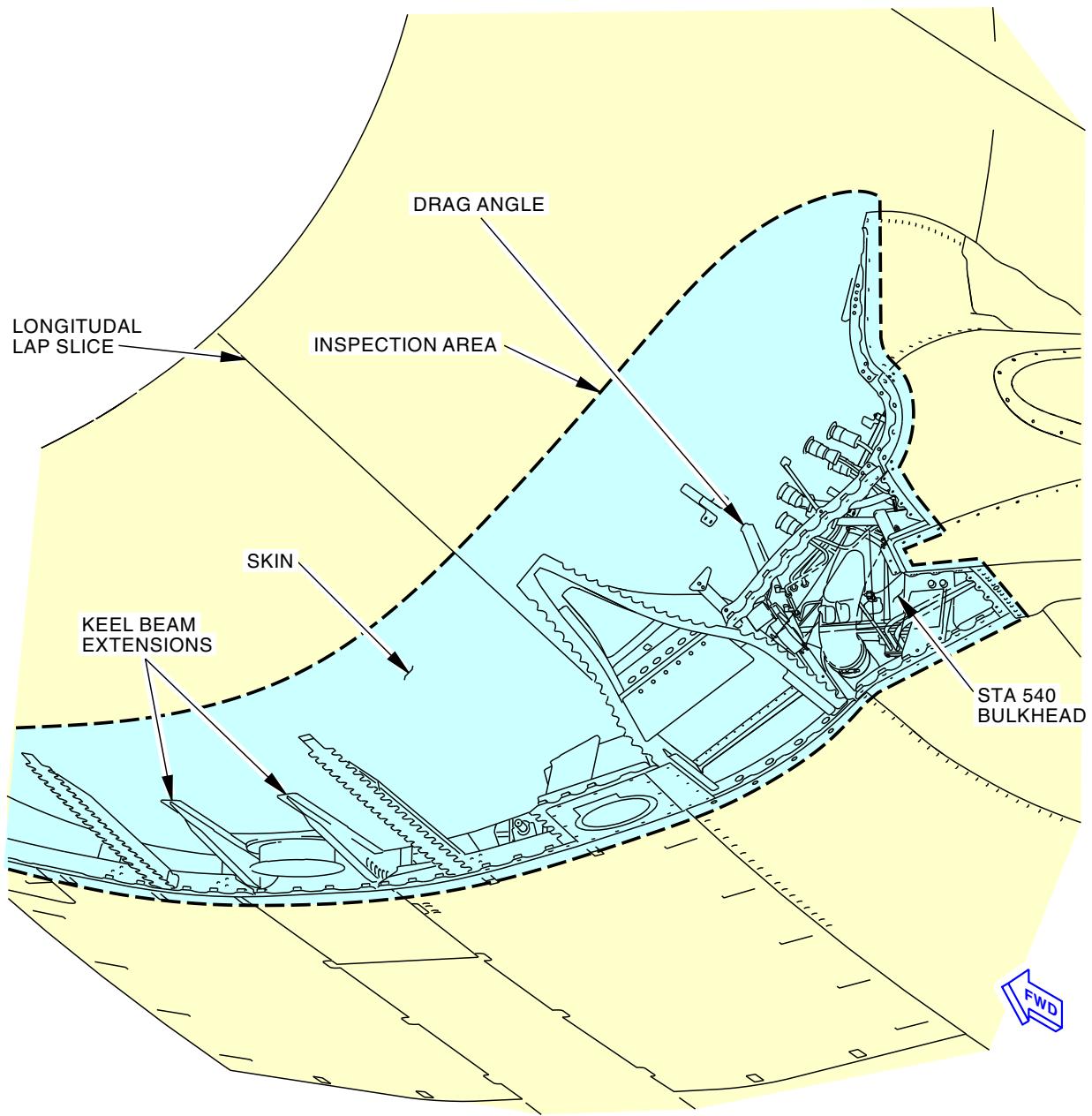
EFFECTIVITY	LOM ALL
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D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 273  
Feb 15/2025

(LEFT SIDE OF FUSELAGE SHOWN, RIGHT SIDE  
OF FUSELAGE IS EQUIVALENT)**A**MPD ITEM  
53-180-00

2078266 S0000435773\_V2

**INTERNAL-GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (Forward Of Wing Box)**  
 Figure 222/53-05-03-990-850 (Sheet 2 of 2)
EFFECTIVITY  
LOM ALL**53-05-03**

D633A101-LOM



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**TASK 53-05-03-210-819**

**21. INTERNAL - GENERAL VISUAL: AREA ABOVE WING BOX CENTER SECTION**

(Figure 223)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
135	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Left
136	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Right

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-03-010-076

- (1) Special Access:

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

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

SUBTASK 53-05-03-210-019

- (2) Do a General Visual inspection of the fuselage lower lobe above wing box center section upper panel, including side skin panels (skins, frames and stringers), Sta 540 bulkhead, and overwing frames and stub beams.

SUBTASK 53-05-03-910-022

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

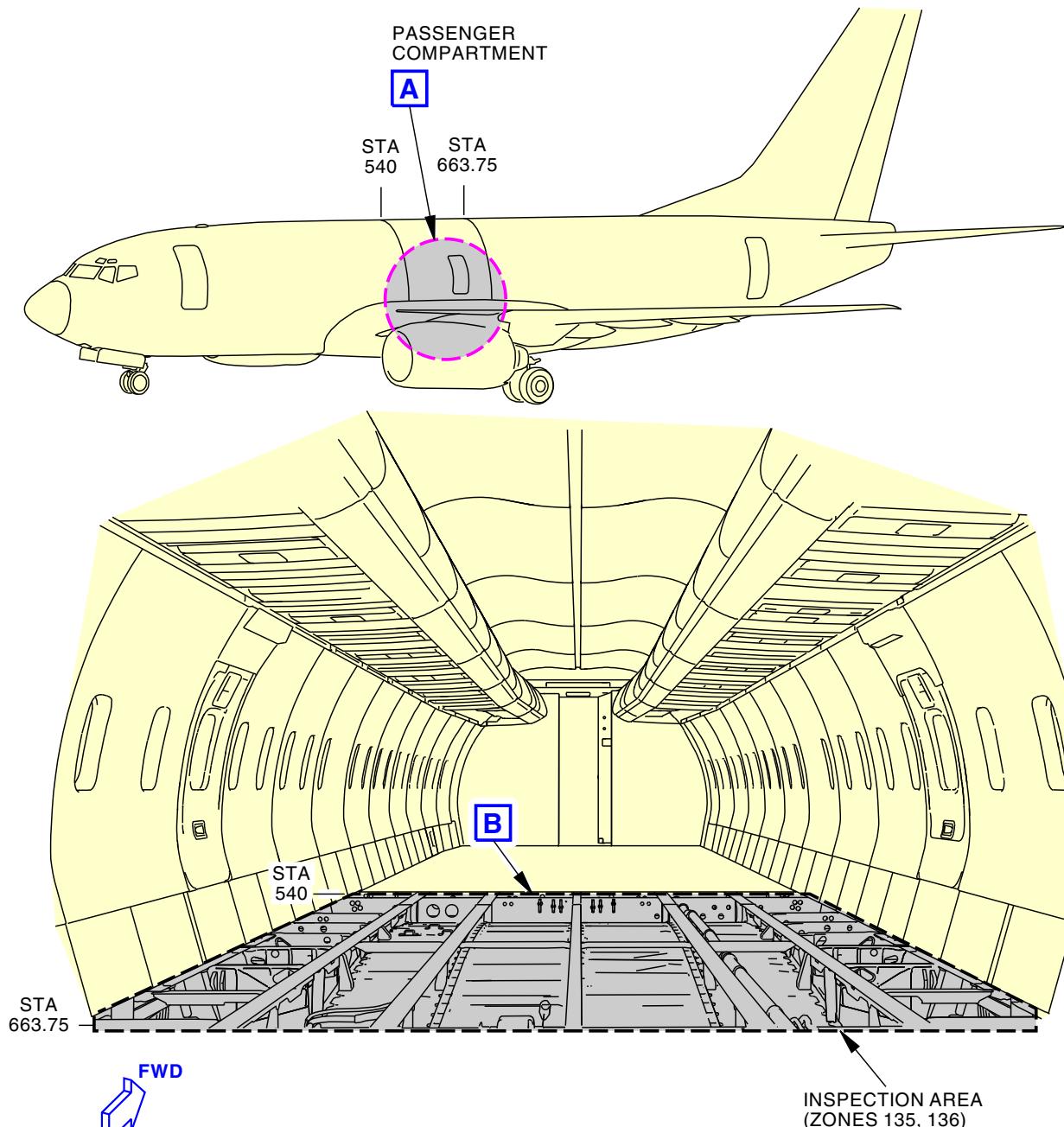
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



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PASSENGER COMPARTMENT  
(AREA ABOVE WING BOX CENTER SECTION)

A

MPD ITEM  
53-190-00

2077193 S0000435832\_V2

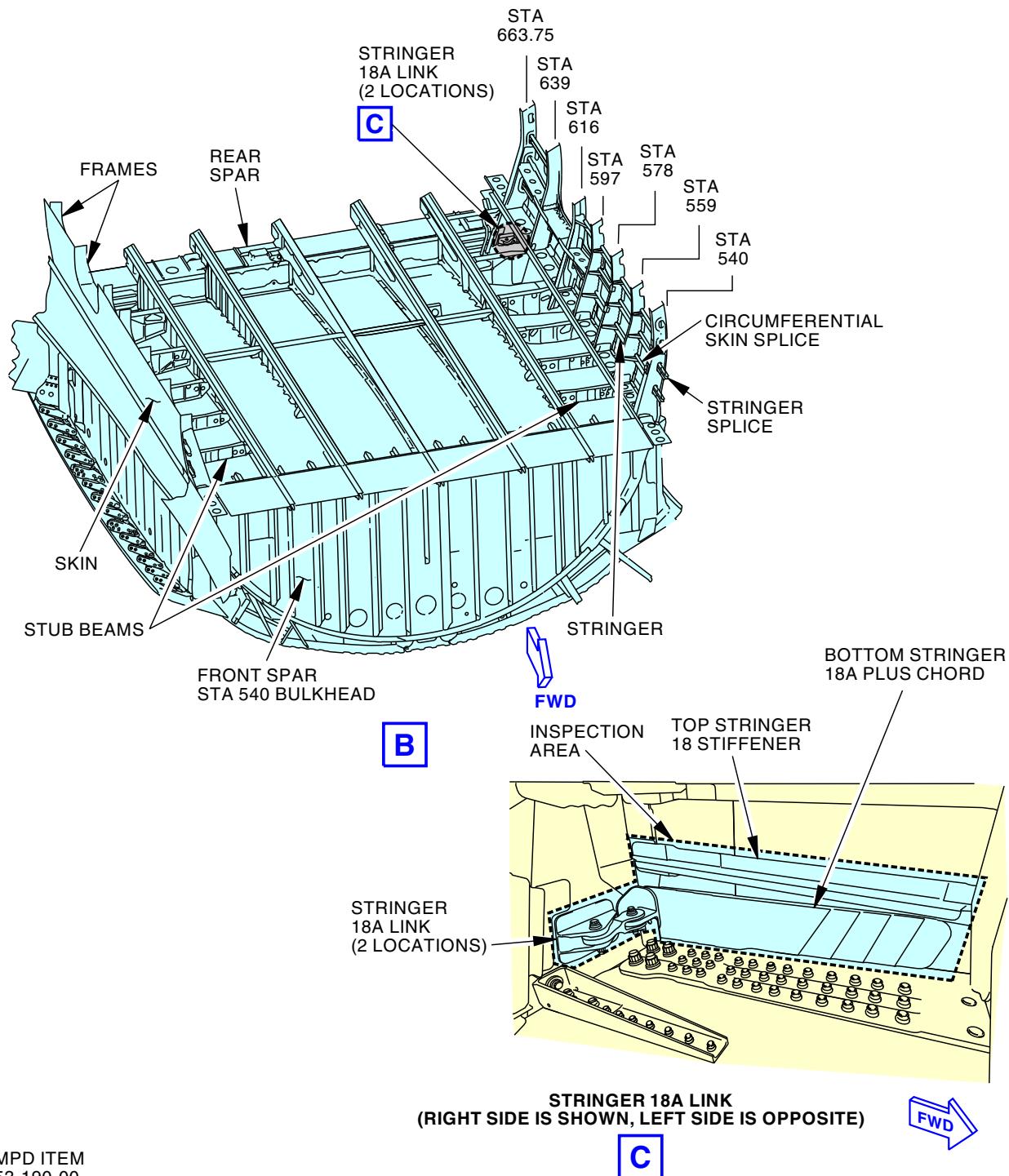
INTERNAL-GENERAL VISUAL: AREA ABOVE WING BOX CENTER SECTION  
Figure 223/53-05-03-990-848 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

D633A101-LOM

**53-05-03**

Page 276  
Feb 15/2025

**737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL**


**INTERNAL-GENERAL VISUAL: AREA ABOVE WING BOX CENTER SECTION**  
**Figure 223/53-05-03-990-848 (Sheet 2 of 2)**

EFFECTIVITY  
LOM ALL

**53-05-03**



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**TASK 53-05-03-210-820**

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

(Figure 224)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
S1302	Area Above Main Landing Gear Wheel Well Inspection

**C. Inspection**

SUBTASK 53-05-03-010-018

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
S1302	Area Above Main Landing Gear Wheel Well Inspection

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

SUBTASK 53-05-03-210-020

- (2) Do a General Visual inspection of the fuselage lower lobe above main landing gear wheel well, including:

1. Pressure deck web to stiffeners, stiffener attachment to floor beam at STA 727.
2. Side skin panels, circumferential skin and stringer splice.
3. Bulkheads at STA 663 and 727.
4. Side strut support frame at STA 706.
5. Main landing gear support frame at STA 695 and 716.
6. Wheel well frame at STA 685.

SUBTASK 53-05-03-910-023

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-018

- (4) Close this access panel:

<b>Number</b>	<b>Name/Location</b>
S1302	Area Above Main Landing Gear Wheel Well Inspection

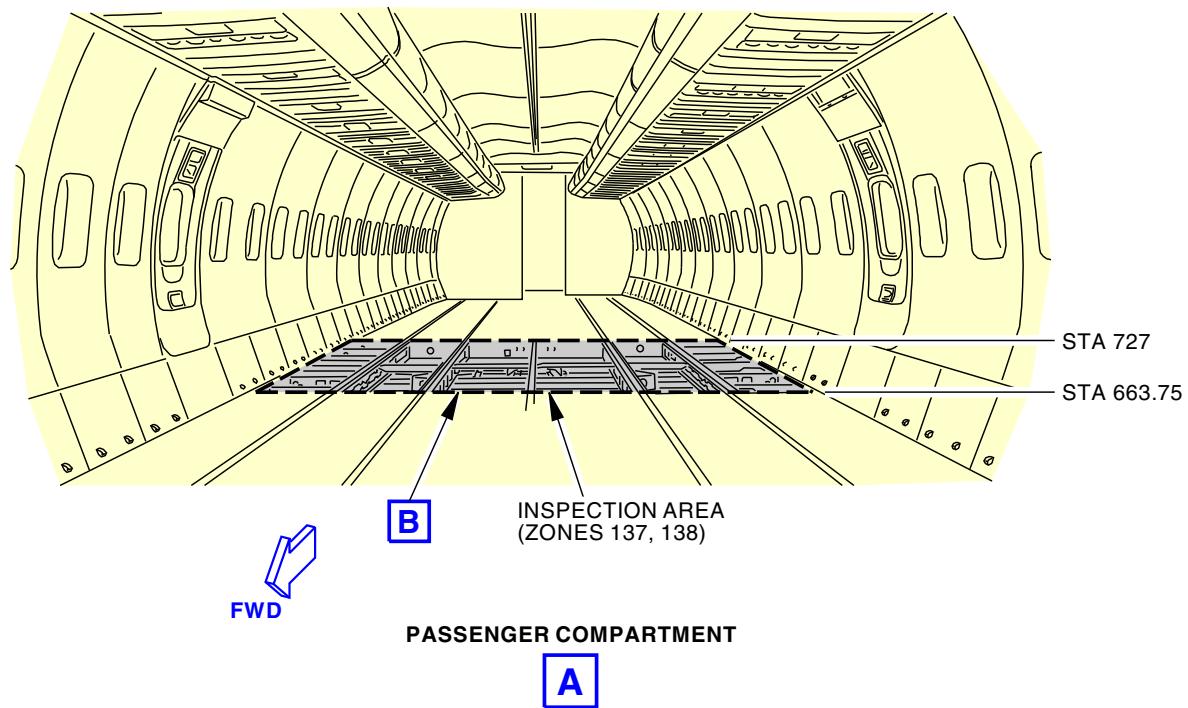
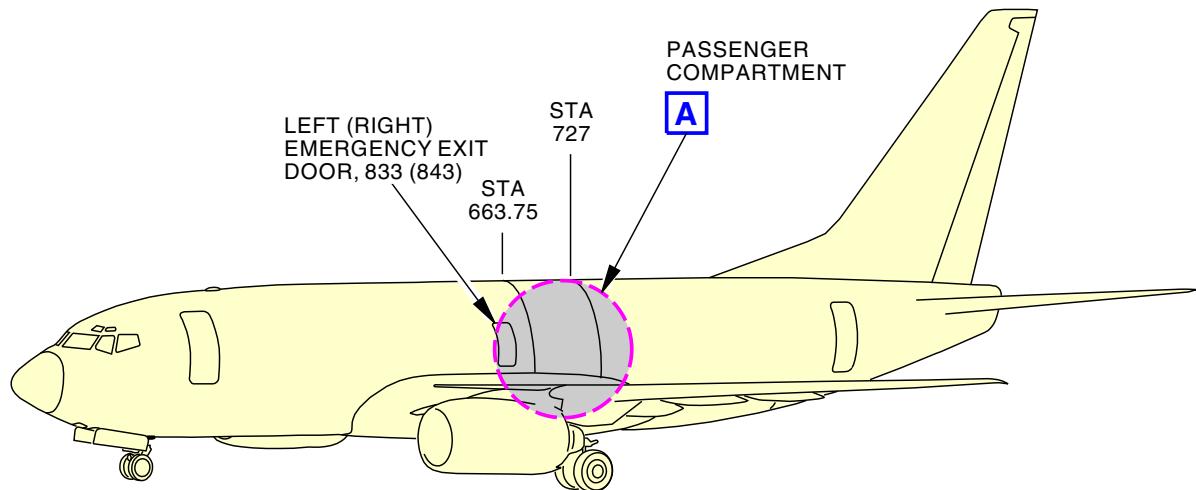
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
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MPD ITEM  
53-200-00

2068994 S0000429080\_V3

Above and Outboard of the Main Landing Gear Wheel Well General Visual (Internal)  
Figure 224/53-05-03-990-842 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

D633A101-LOM

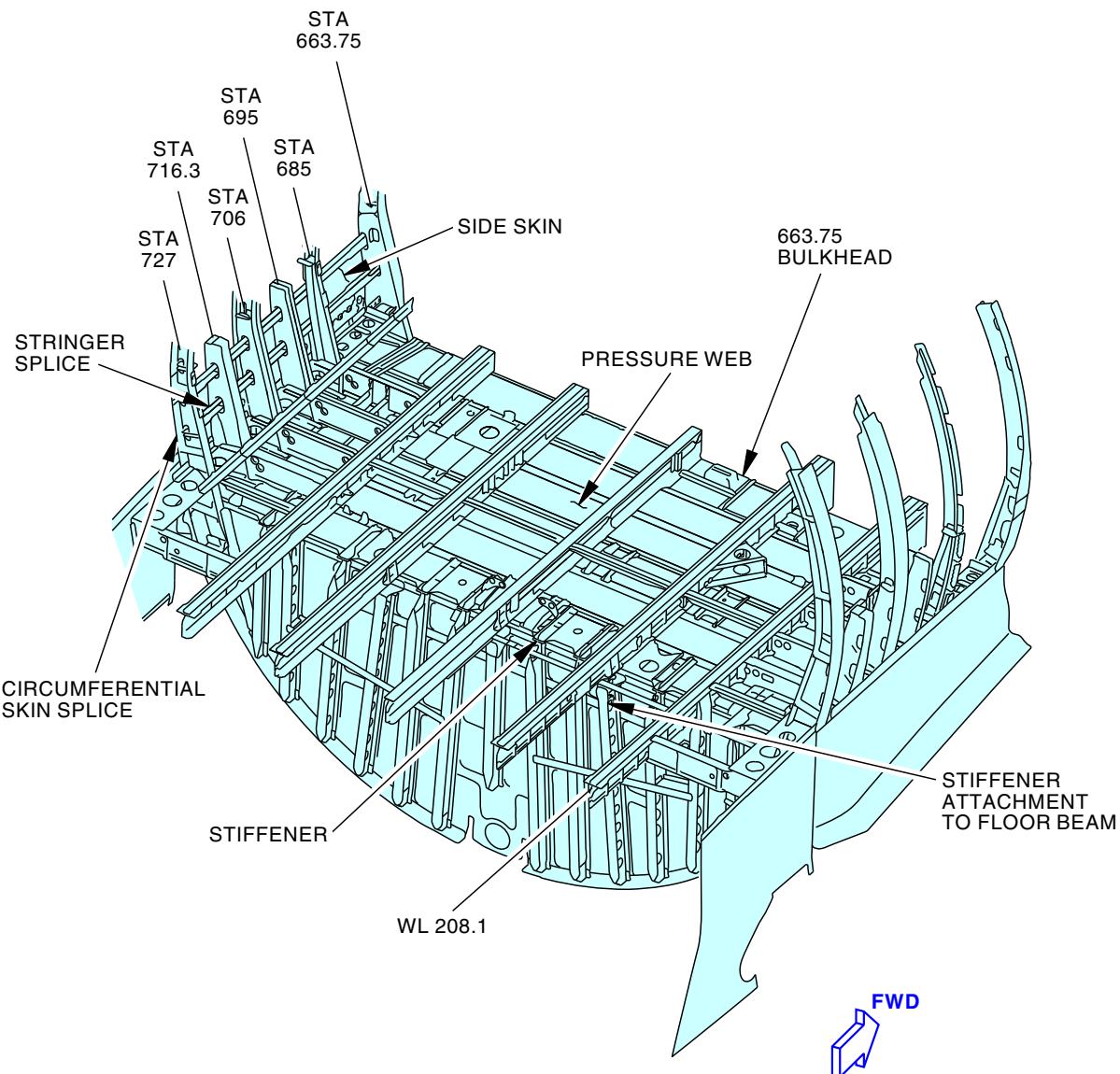
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**53-05-03**

Page 279  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-200-00

2070775 S0000429084\_V2

Above and Outboard of the Main Landing Gear Wheel Well General Visual (Internal)  
Figure 224/53-05-03-990-842 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-821**

23. **INTERNAL - GENERAL VISUAL: KEEL BEAM UNDER WING-TO-BODY FAIRING (under wing box)**  
(Figure 225)

NOTE: This procedure is a scheduled maintenance task.

**A. References**

Reference	Title
06-41-00-010-801	Open Access Panel 192CR (P/B 201)
06-41-00-410-801	Close Access Panel 192CR (P/B 201)
51-05-01-210-804	737-6789 Basic Task Description (P/B 201)

**B. Location Zones**

Zone	Area
139	Keel Beam, (Part) Body Station 540.00 to Body Station 727.00
192	Lower Wing-To-Body Fairing - Under Wing Box

**C. Access Panels**

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
S1004	Keel Beam Under Wing-to-Body Fairing (Under Wing Box) Inspection

**D. Inspection**

**SUBTASK 53-05-03-010-071**

- (1) To open access panel 192CR, refer to: Open Access Panel 192CR, TASK 06-41-00-010-801  
Open these access panels:

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
S1004	Keel Beam Under Wing-to-Body Fairing (Under Wing Box) Inspection

NOTE: Remove ECS Under Keel Panels (192E and 192F). Remove / displace AC pack components are required.

**SUBTASK 53-05-03-210-021**

- (2) Do a General Visual inspection of the keel beam under wing-to-body fairing (under wing box, Sta 540 to 663.75), including keel beam chords, webs, stiffeners, splice, keel beam/rear spar attachment angles.

**SUBTASK 53-05-03-910-026**

- (3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-804.

**SUBTASK 53-05-03-410-071**

- (4) To close access panel 192CR, refer to: Close Access Panel 192CR, TASK 06-41-00-410-801

EFFECTIVITY  
LOM ALL

**53-05-03**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

Close these access panels:

<u>Number</u>	<u>Name/Location</u>
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
S1004	Keel Beam Under Wing-to-Body Fairing (Under Wing Box) Inspection

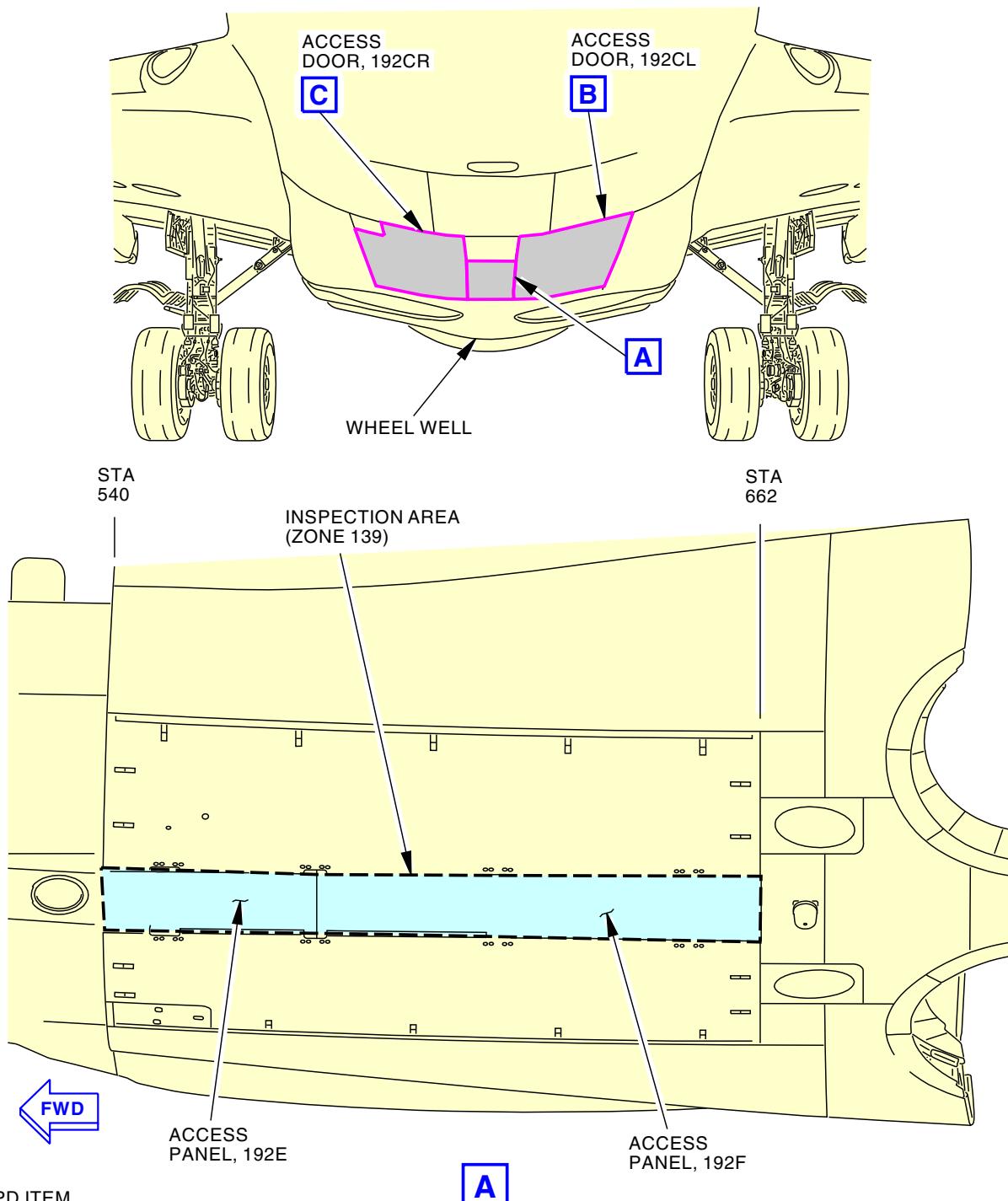
———— END OF TASK ————

— EFFECTIVITY —  
**LOM ALL**

**53-05-03**



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MPD ITEM  
53-210-00

2084307 S0000436344\_V2

**Keel Beam**  
Figure 225/53-05-03-990-806 (Sheet 1 of 3)

EFFECTIVITY  
LOM ALL

D633A101-LOM

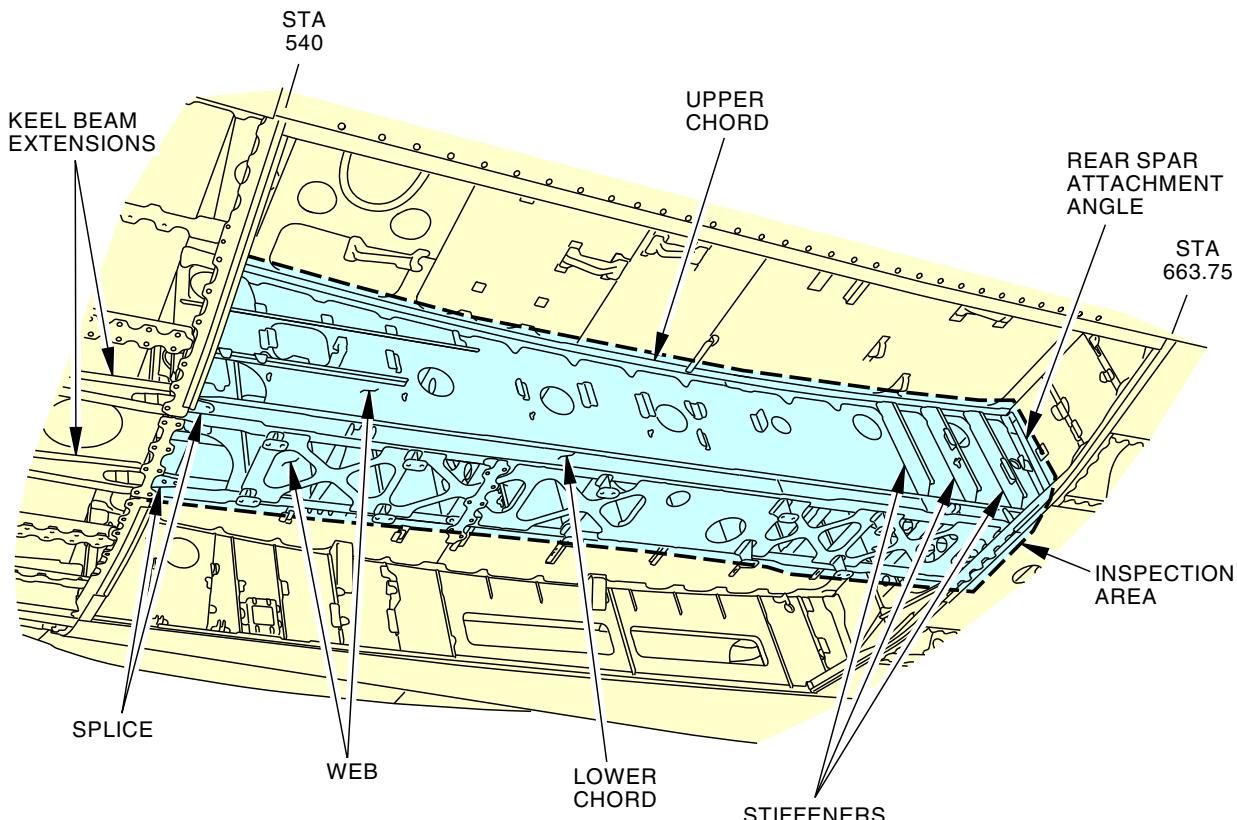
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**53-05-03**

Page 283  
Feb 15/2025



737-600/700/800/900  
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KEEL BEAM  
(STA 540 TO STA 663.75)  
(ECS DOORS REMOVED)

B

MPD ITEM  
53-210-00

2085210 S0000436345\_V3

Keel Beam  
Figure 225/53-05-03-990-806 (Sheet 2 of 3)

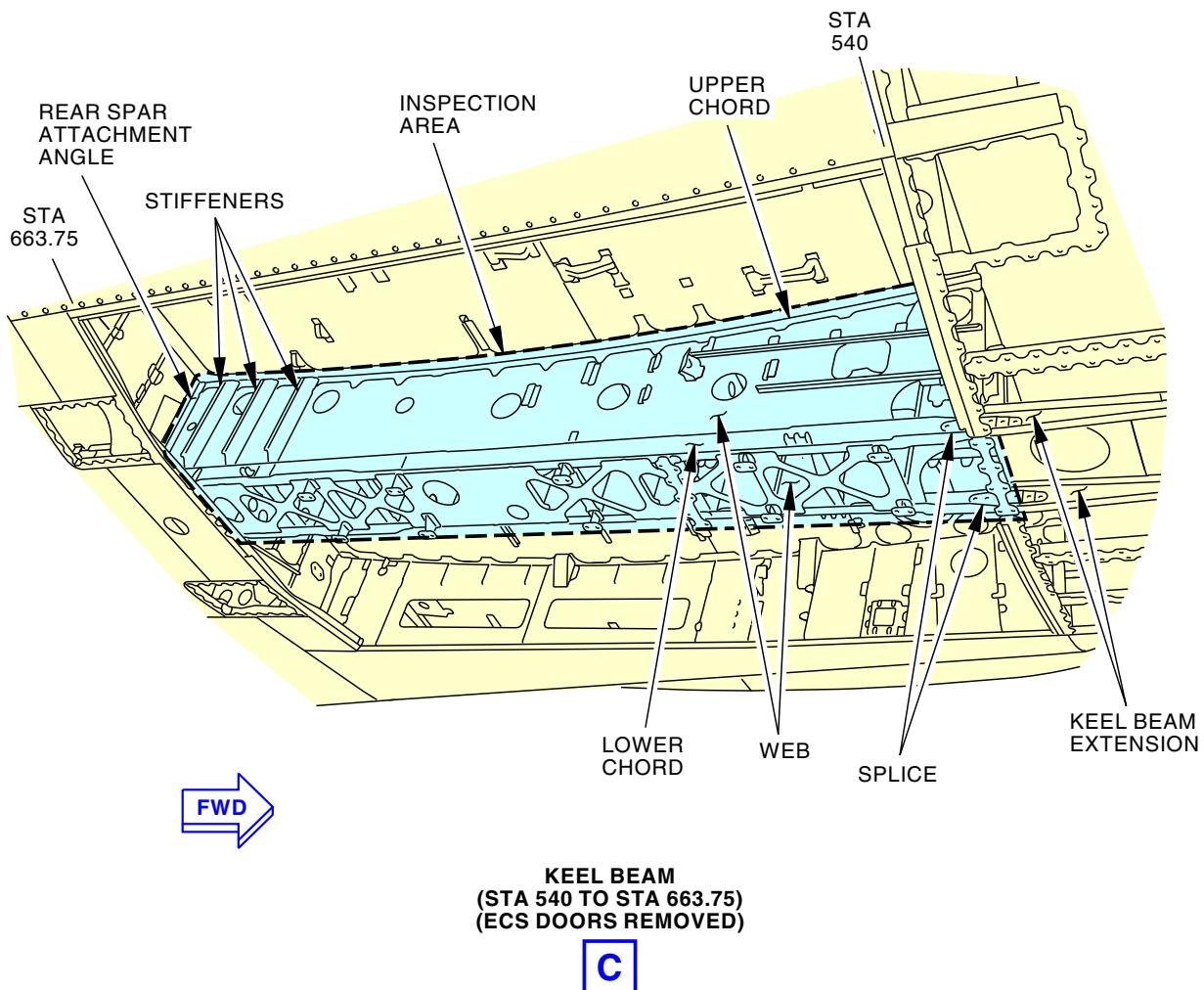
EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-210-00

2084810 S0000436346\_V4

Keel Beam  
Figure 225/53-05-03-990-806 (Sheet 3 of 3)

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 285  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-823**

**24. INTERNAL - GENERAL VISUAL: KEEL BEAM IN WHEEL WELL**

(Figure 226)

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)
53-51-21-000-802	Center Wing-To-Body Fairing Panel Removal (P/B 401)
53-51-21-400-802	Center Wing-To-Body Fairing Panel Installation (P/B 401)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
139	Keel Beam, (Part) Body Station 540.00 to Body Station 727.00
193	Lower Wing-To-Body Fairing - Wheel Well

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
193B	Wheel Well Panel - Forward Inboard
193D	Wheel Well Panel - Aft Inboard

**D. Inspection**

SUBTASK 53-05-03-010-020

- (1) Open these access panels:  
(TASK 53-51-21-000-802)

<b>Number</b>	<b>Name/Location</b>
193B	Wheel Well Panel - Forward Inboard
193D	Wheel Well Panel - Aft Inboard

NOTE: Remove aerodynamic anti-collision light assembly if installed.

SUBTASK 53-05-03-210-023

- (2) Do a General Visual inspection of the keel beam in wheel well (Sta 663.75 to 727), including keel beam chords, webs, stiffeners, splice, keel beam/rear spar attachment angles.

SUBTASK 53-05-03-910-024

- (3) 737-6789 Basic Task Description, TASK 51-05-01-210-806.

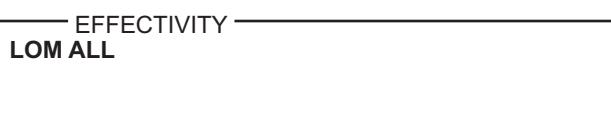
SUBTASK 53-05-03-410-020

- (4) Close these access panels:

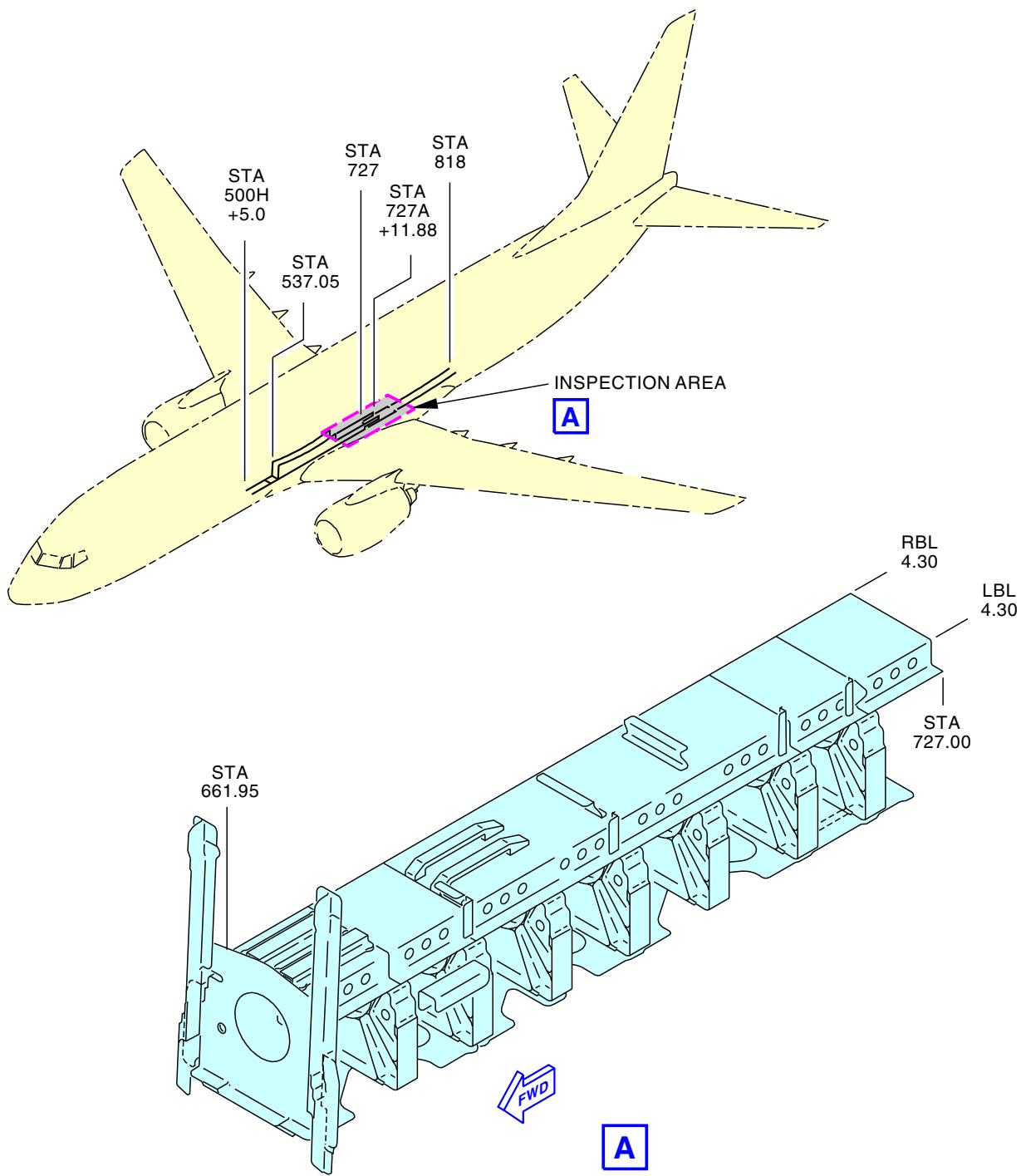
(TASK 53-51-21-400-802)

<b>Number</b>	<b>Name/Location</b>
193B	Wheel Well Panel - Forward Inboard
193D	Wheel Well Panel - Aft Inboard

———— END OF TASK ————



**53-05-03**



D65252 S0000161683\_V2

**INTERNAL - GENERAL VISUAL: KEEL BEAM IN WHEEL WELL**  
**Figure 226/53-05-03-990-827**

EFFECTIVITY  
**LOM ALL**

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-824**

**25. INTERNAL - GENERAL VISUAL: AFT CARGO COMPARTMENT**

(Figure 227)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
141	Aft Cargo Compartment - Left
142	Aft Cargo Compartment - Right

**B. Access Panels**

<u>Number</u>	<u>Name/Location</u>
S1401	AFT Cargo Compartment Inspection

**C. Inspection**

SUBTASK 53-05-03-010-021

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
S1401	AFT Cargo Compartment Inspection

NOTE: Remove sidewall and ceiling panels, E6 LRU, access panels around vacuum lav tank. Remove/displace insulation blankets as required. Remove/displace vacuum lav components as required. Remove/displace auxiliary fuel tank as required (business jet only).

SUBTASK 53-05-03-210-024

- (2) Do a General Visual inspection of the aft cargo compartment, including:

1. Side skin panels (skin, frames, stringers), circumferential skin and stringer splices, (note: located at Sta 727I for -900 and 727L for -900ER models).
2. Stringer 18 strap at side of body.
3. Stringer 18A web, chord and links.
4. Aft side of STA 727 bulkhead and pressure web.
5. For the -800BCF, frame reinforcements at STA 727B to STA 867 at S-17 to S-21 (Note: frame reinforcements on LH side only at STA 807 to STA 847), STA 747 shear ties at S-18R/L to S-20R/L, STA 847 shear tie at S-18L to S-19L, STA 887 frame reinforcements at S-17 to S-21 and floor beam reinforcements, and frame fitting and rail support at STA 907 at S-15 to S-17.

SUBTASK 53-05-03-910-025

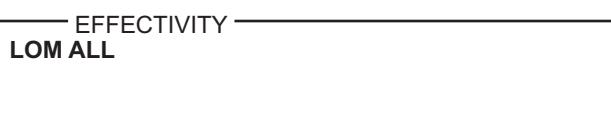
- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-021

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
S1401	AFT Cargo Compartment Inspection

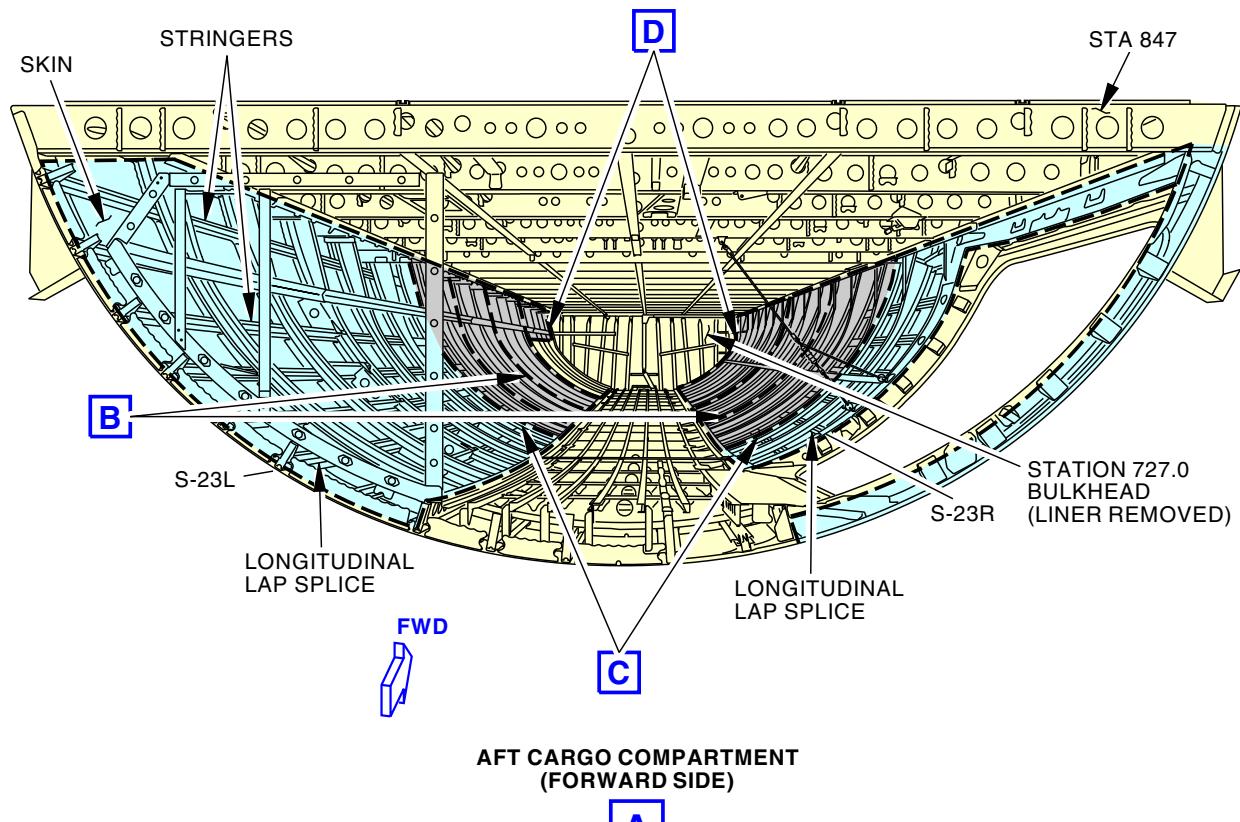
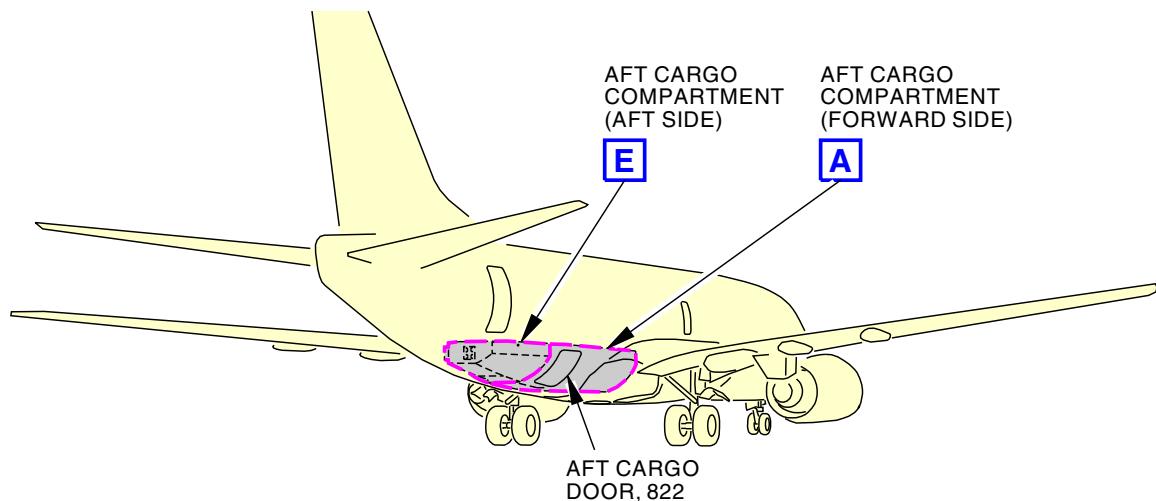
— END OF TASK —



**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-230-00

2094308 S0000439209\_V2

INTERNAL-GENERAL VISUAL: AFT CARGO COMPARTMENT  
Figure 227/53-05-03-990-859 (Sheet 1 of 3)

EFFECTIVITY  
LOM ALL

D633A101-LOM

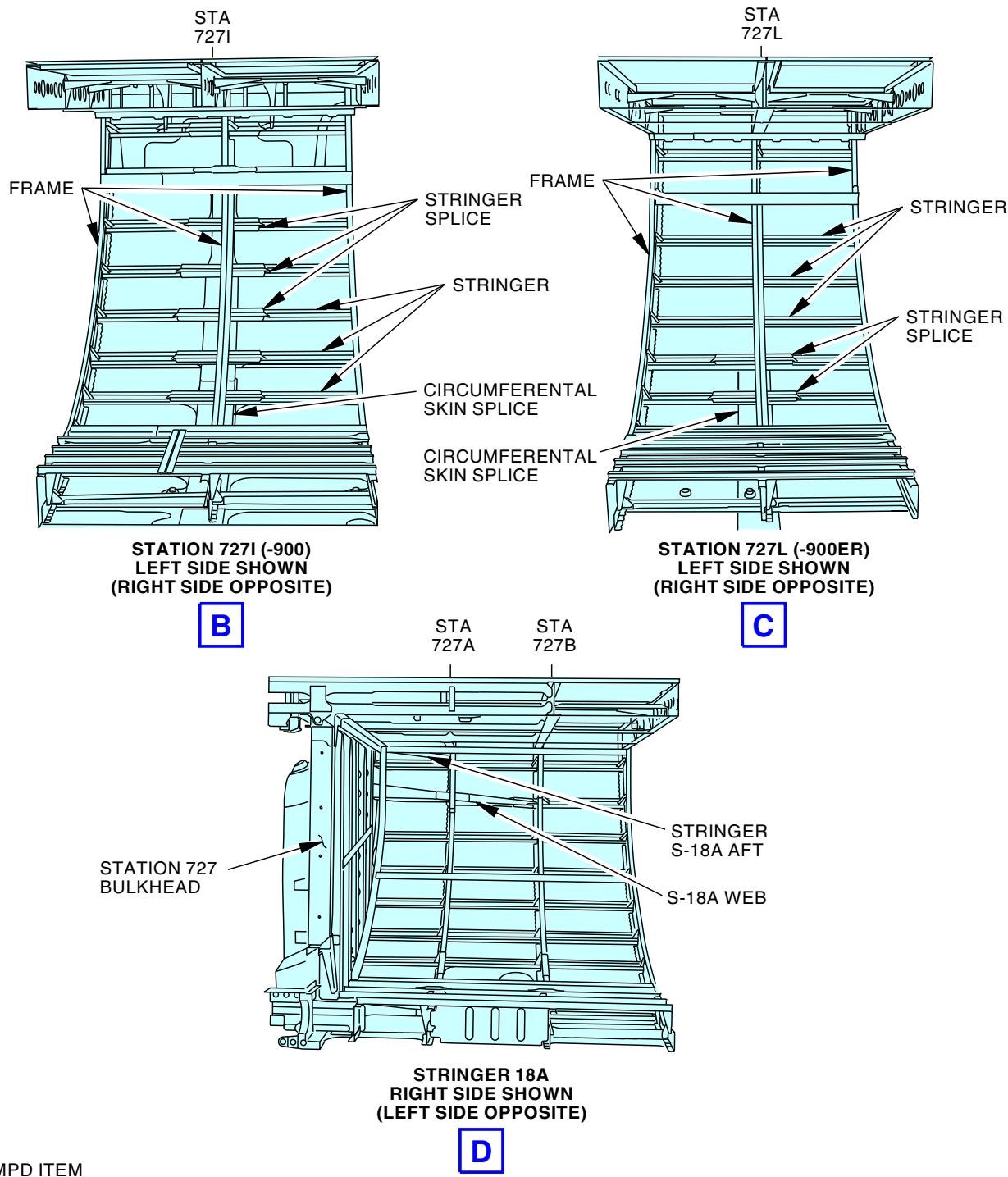
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 289  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-230-00

2094379 S0000439211\_V2

INTERNAL-GENERAL VISUAL: AFT CARGO COMPARTMENT  
Figure 227/53-05-03-990-859 (Sheet 2 of 3)

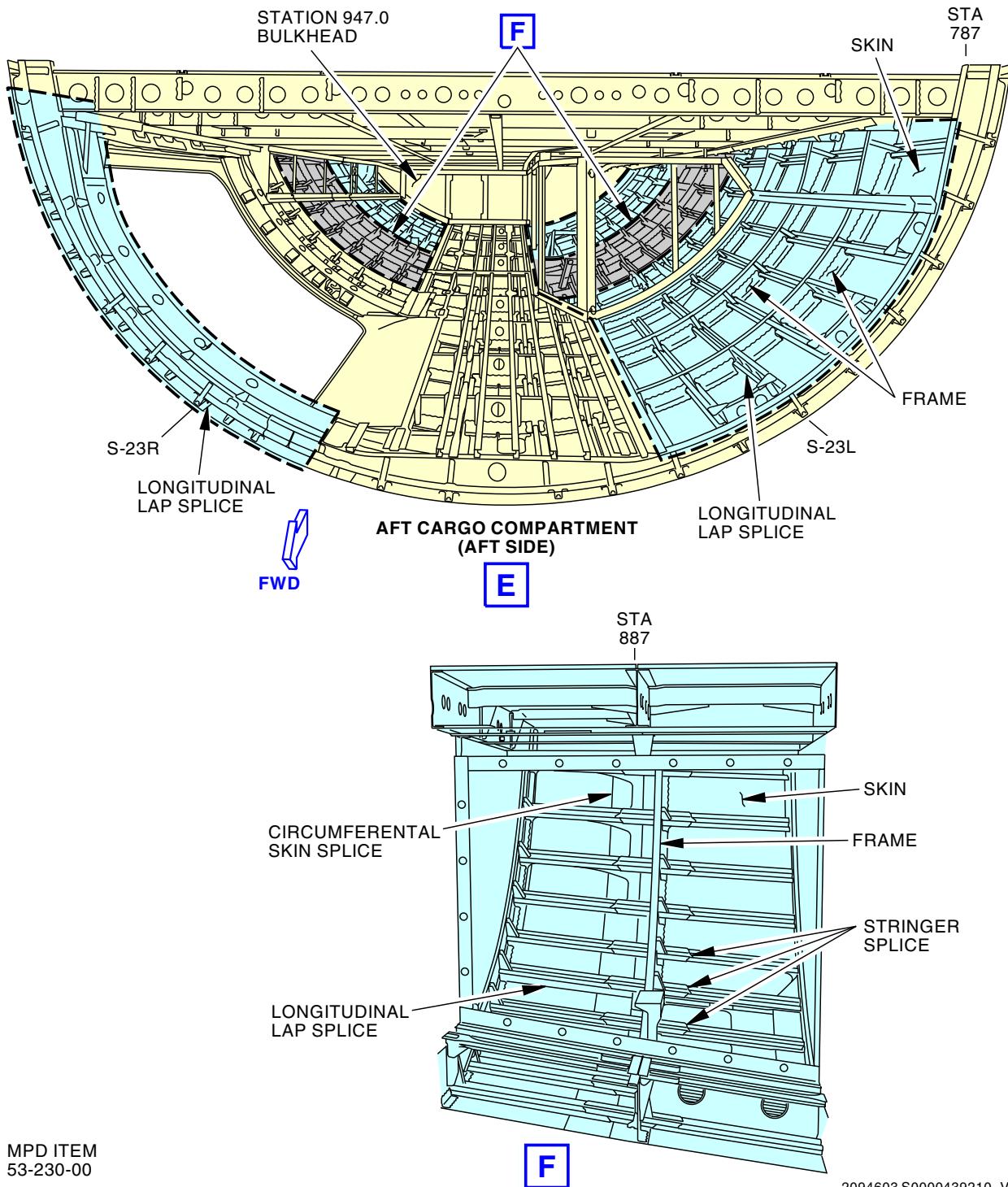
EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 290  
Feb 15/2025

**737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL**


MPD ITEM  
53-230-00

2094603 S0000439210\_V3

**INTERNAL-GENERAL VISUAL: AFT CARGO COMPARTMENT**  
**Figure 227/53-05-03-990-859 (Sheet 3 of 3)**

EFFECTIVITY
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 291  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-211-804**

**26. INTERNAL - DETAILED: AFT CARGO DOOR CUTOUT**

(Figure 228)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
142	Aft Cargo Compartment - Right

**B. Access Panels**

<u>Number</u>	<u>Name/Location</u>
S1421	Aft Cargo Door Cutout Inspection

**C. Inspection**

SUBTASK 53-05-03-010-058

- (1) Special Access:

<u>Number</u>	<u>Name/Location</u>
S1421	Aft Cargo Door Cutout Inspection

NOTE: Remove door reveals and scuff plates. Remove sidewalls as required.  
Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-004

- (2) Do a Detailed inspection of the aft cargo door cutout surround structure.

SUBTASK 53-05-03-910-029

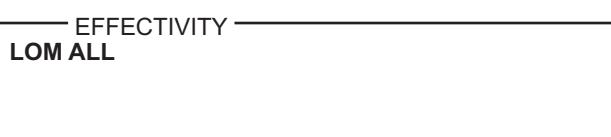
- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-058

- (4) Close this access panel:

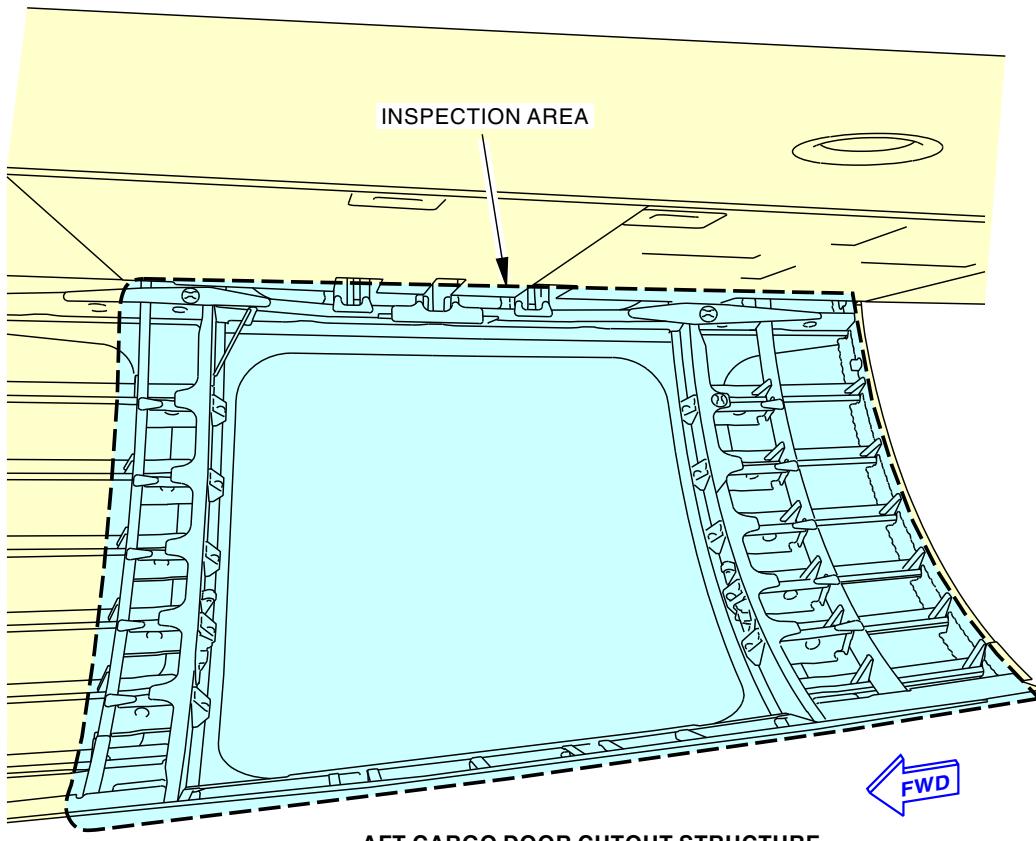
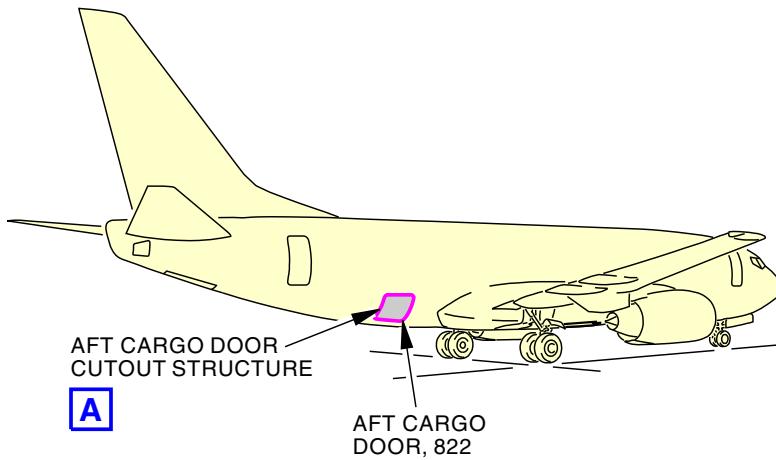
<u>Number</u>	<u>Name/Location</u>
S1421	Aft Cargo Door Cutout Inspection

— END OF TASK —





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AFT CARGO DOOR CUTOUT STRUCTURE  
(DOOR REVEALS AND SIDEWALL PANELS REMOVED)

MPD ITEM  
53-240-00

A

485948 S0000145833\_V3

Aft Cargo Door Cutout Detailed (Internal)  
Figure 228/53-05-03-990-820

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 293  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-825**

**27. INTERNAL - GENERAL VISUAL: AFT BILGE**

(Figure 229,Figure 230)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
143	Area Below Aft Cargo Compartment - Left
144	Area Below Aft Cargo Compartment - Right

**B. Access Panels**

<u>Number</u>	<u>Name/Location</u>
S1402	Aft Bilge Inspection

**C. Inspection**

SUBTASK 53-05-03-010-022

- (1) Special Access:

<u>Number</u>	<u>Name/Location</u>
S1402	Aft Bilge Inspection

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

SUBTASK 53-05-03-210-025

- (2) Do a General Visual inspection of the aft bilge skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices, (note: located at Sta 727I for -900 and 727L for -900ER models); Sta 727 bulkhead and pressure web, and cargo door cutout surround structure in bilge.

SUBTASK 53-05-03-910-030

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-079

- (4) Restore Special Access:

<u>Number</u>	<u>Name/Location</u>
S1402	Aft Bilge Inspection

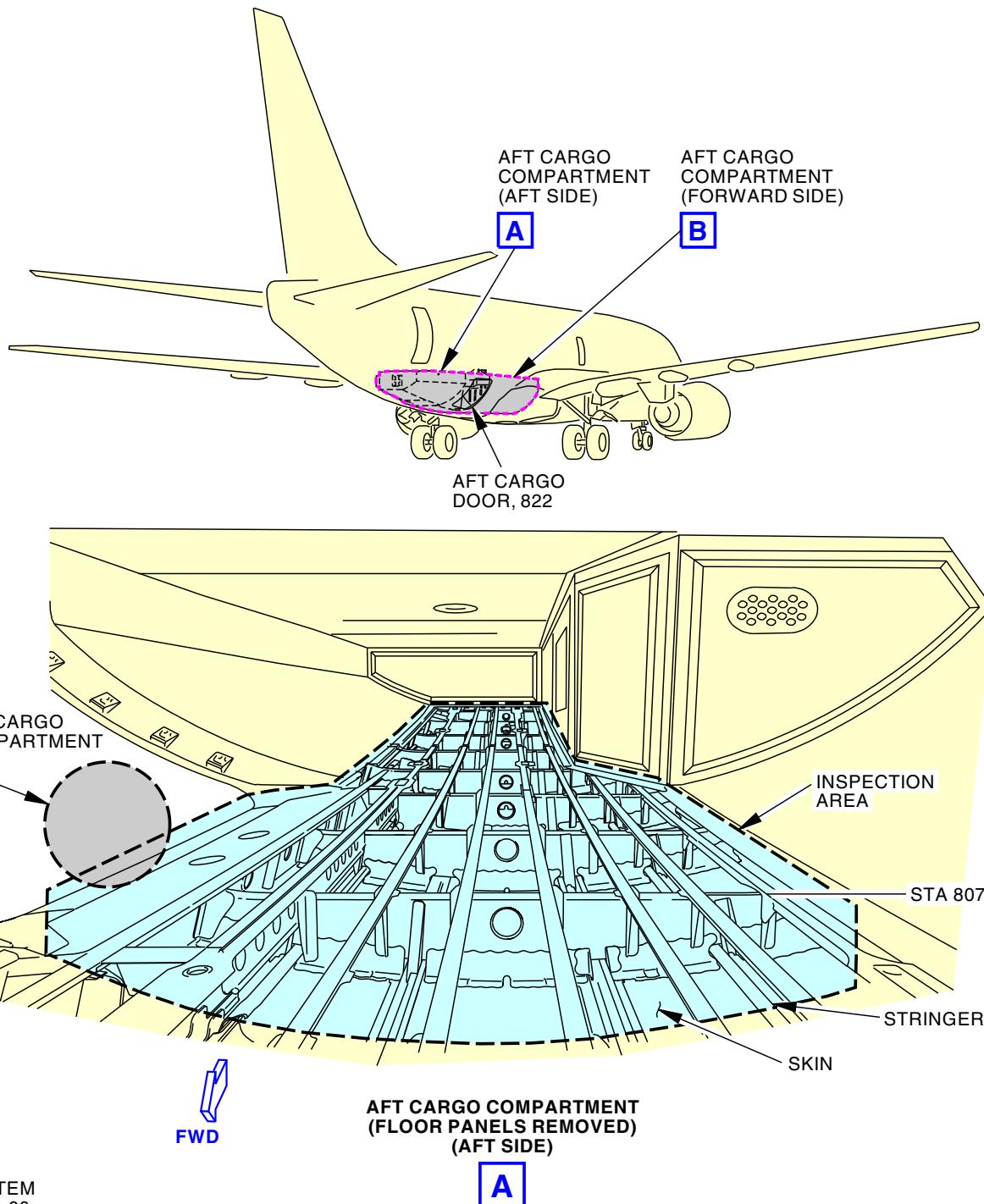
— END OF TASK —

EFFECTIVITY  
LOM ALL

**53-05-03**



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MPD ITEM  
53-250-00

D46462 S0000158660\_V3

Below the Aft Cargo Comp. - Aft Bilge General Visual (Int)  
Figure 229/53-05-03-990-826 (Sheet 1 of 3)

EFFECTIVITY  
LOM ALL

**53-05-03**

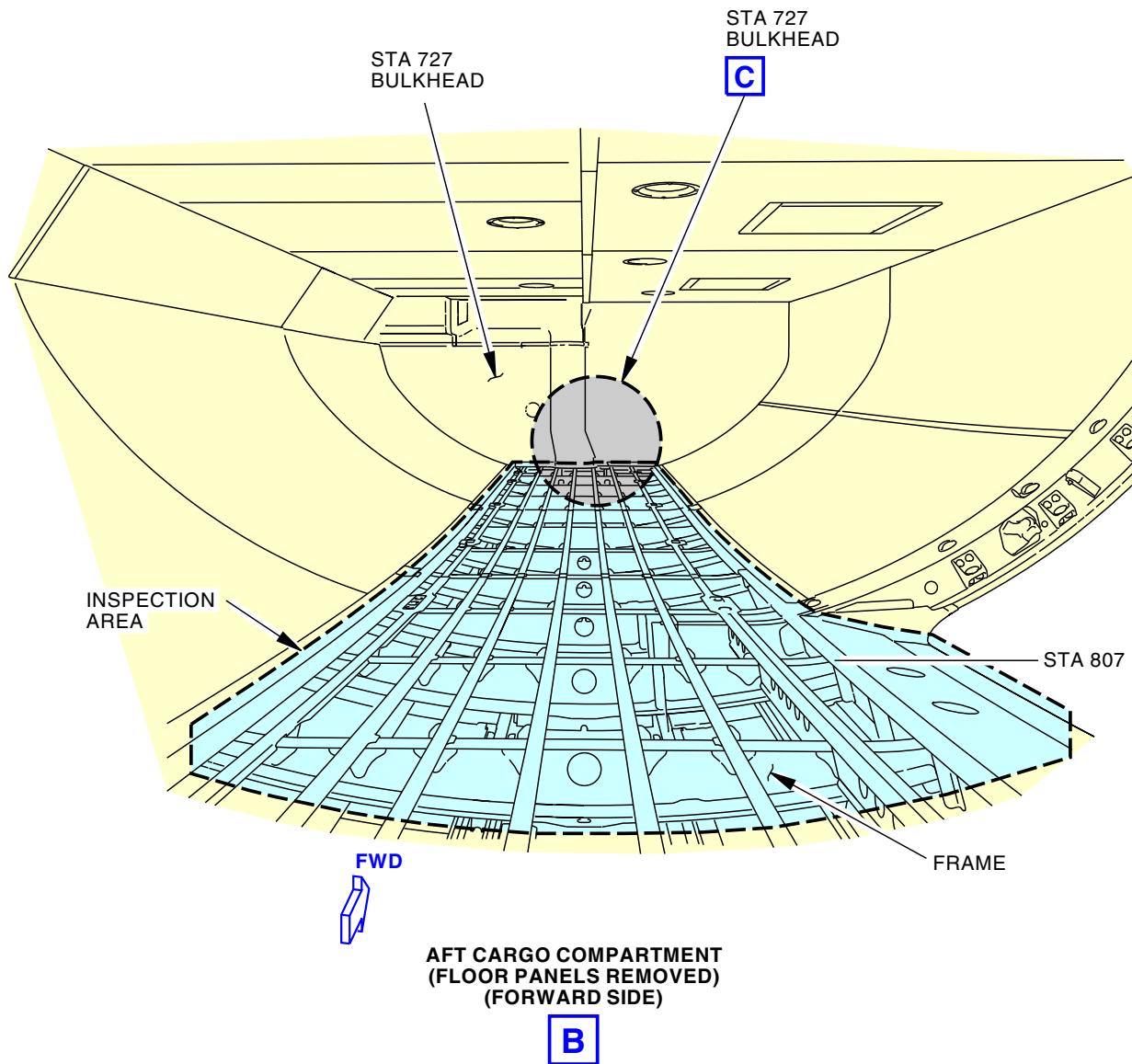
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 295  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-250-00

D46463 S0000158661\_V3

Below the Aft Cargo Comp. - Aft Bilge General Visual (Int)  
Figure 229/53-05-03-990-826 (Sheet 2 of 3)

EFFECTIVITY  
LOM ALL

D633A101-LOM

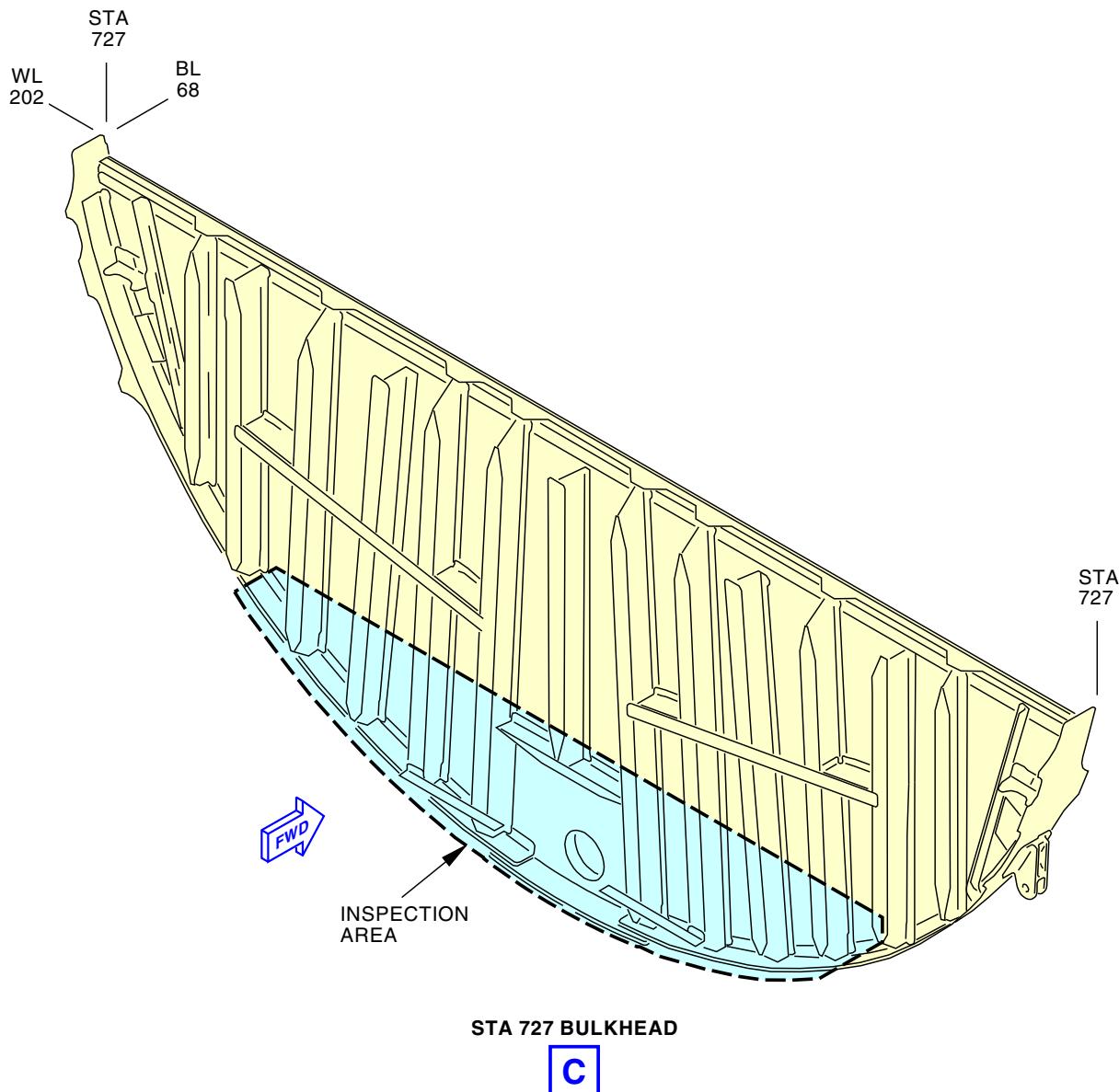
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 296  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-250-00

D65280 S0000161690\_V2

Below the Aft Cargo Comp. - Aft Bilge General Visual (Int)  
Figure 229/53-05-03-990-826 (Sheet 3 of 3)

EFFECTIVITY  
LOM ALL

**53-05-03**

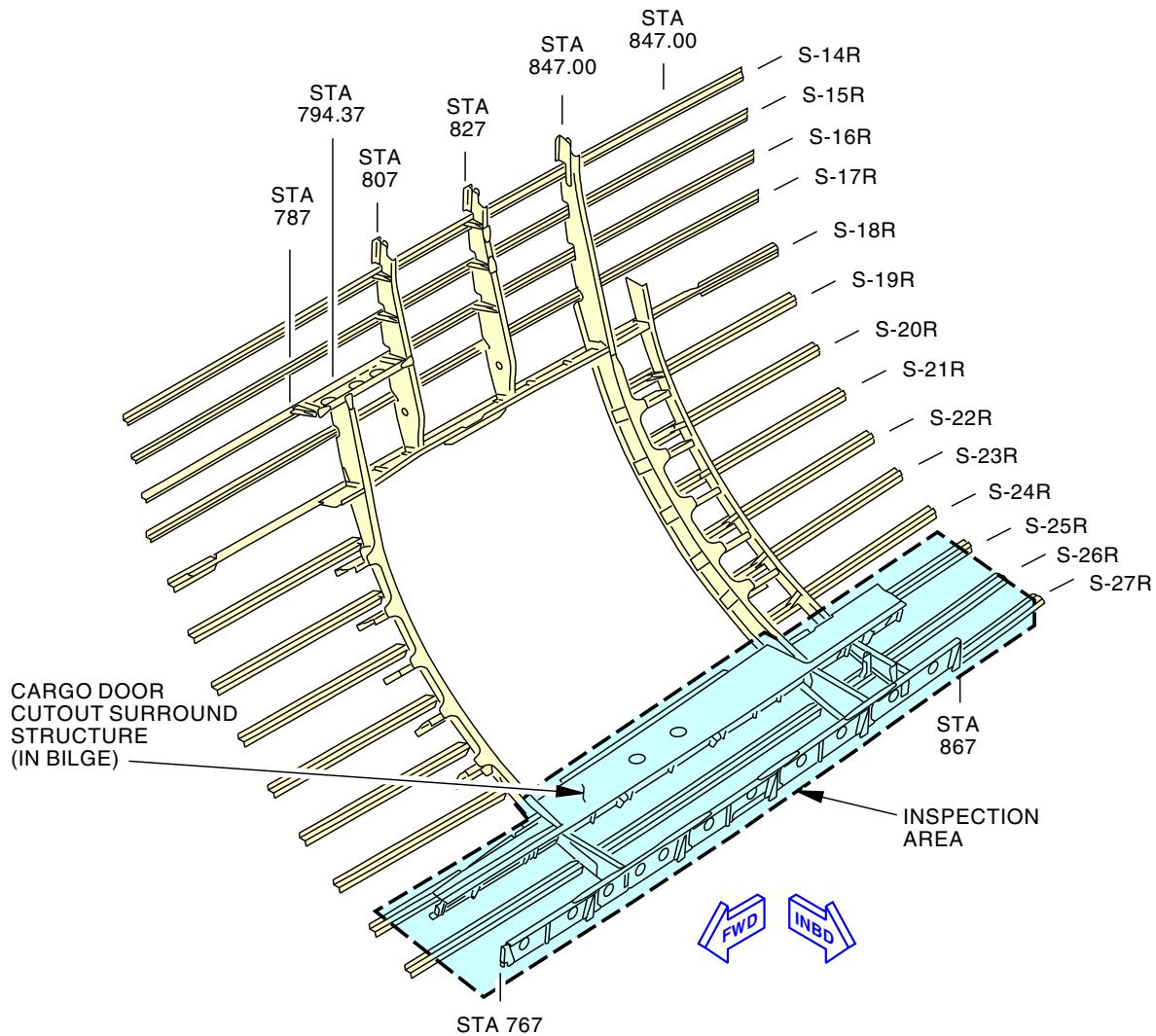
D633A101-LOM

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Page 297  
Feb 15/2025



737-600/700/800/900  
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AFT CARGO COMPARTMENT  
(DOOR REVEALS AND SIDEWALL PANELS REMOVED)

D

MPD ITEM  
53-250-00

D64287 S0000161689\_V2

Section 46 Aft Cargo Door Surround Structure Locations - General Visual (Internal)  
Figure 230/53-05-03-990-832

EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-826**

**28. INTERNAL - GENERAL VISUAL: AREA AFT OF CARGO COMPARTMENT**

(Figure 231)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
145	Aft Cargo Compartment Equipment Bay - Left
146	Aft Cargo Compartment Equipment Bay - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
S1403	Area Aft of Cargo Compartment Inspection

**C. Inspection**

**SUBTASK 53-05-03-010-023**

- (1) Special Access:

<b>Number</b>	<b>Name/Location</b>
S1403	Area Aft of Cargo Compartment Inspection

NOTE: Remove aft cargo compartment aft bulkhead panel. Remove potable water tank or aft outflow valve. Remove/displace insulation blankets as required.

**SUBTASK 53-05-03-210-026**

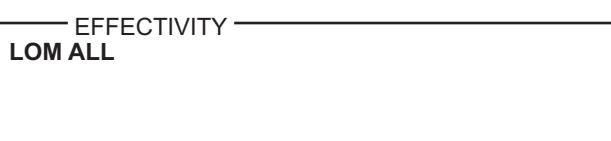
- (2) Do a General Visual inspection of the area aft of cargo compartment, including:

1. Skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices.
2. Aft entry and galley door cutout surround structure in lower lobe.
3. STA 1016 bulkhead, including chords, pressure web, stiffeners, chord/web attachments.
4. Stringer splice fittings and tension bolts at STA 1016.
5. For the -800BCF, frame reinforcement at STA 967 at S-18 to S-21, at STA 986.5 inspect floor beam to frame clip reinforcement and frame reinforcement at S-18 to S-22.

**SUBTASK 53-05-03-910-031**

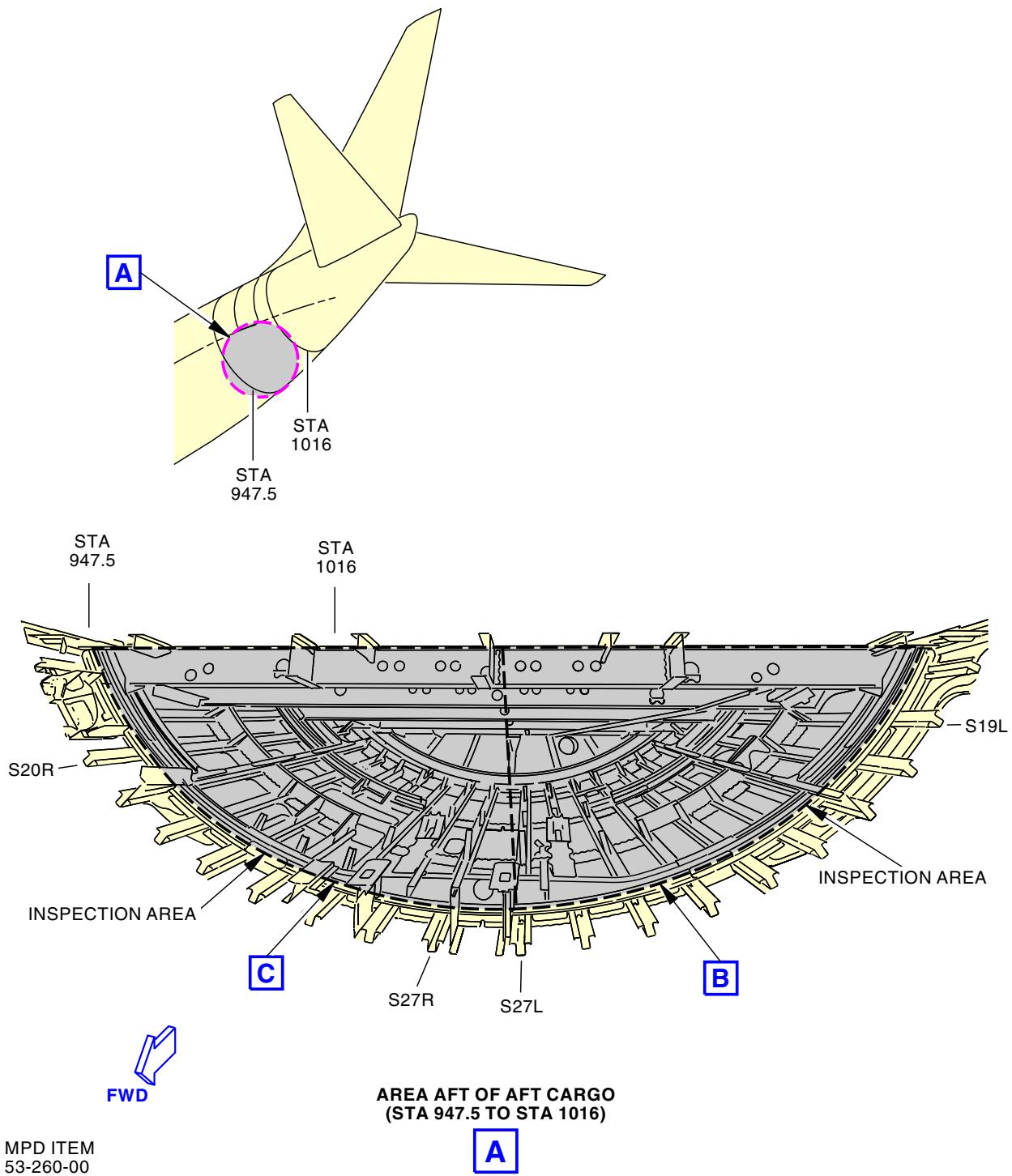
- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

———— END OF TASK ————





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MPD ITEM  
53-260-00

2094363 S0000442104\_V2

Internal-General Visual: Internal-Area Aft Of Cargo Compartment  
Figure 231/53-05-03-990-866 (Sheet 1 of 3)

EFFECTIVITY  
LOM ALL

**53-05-03**

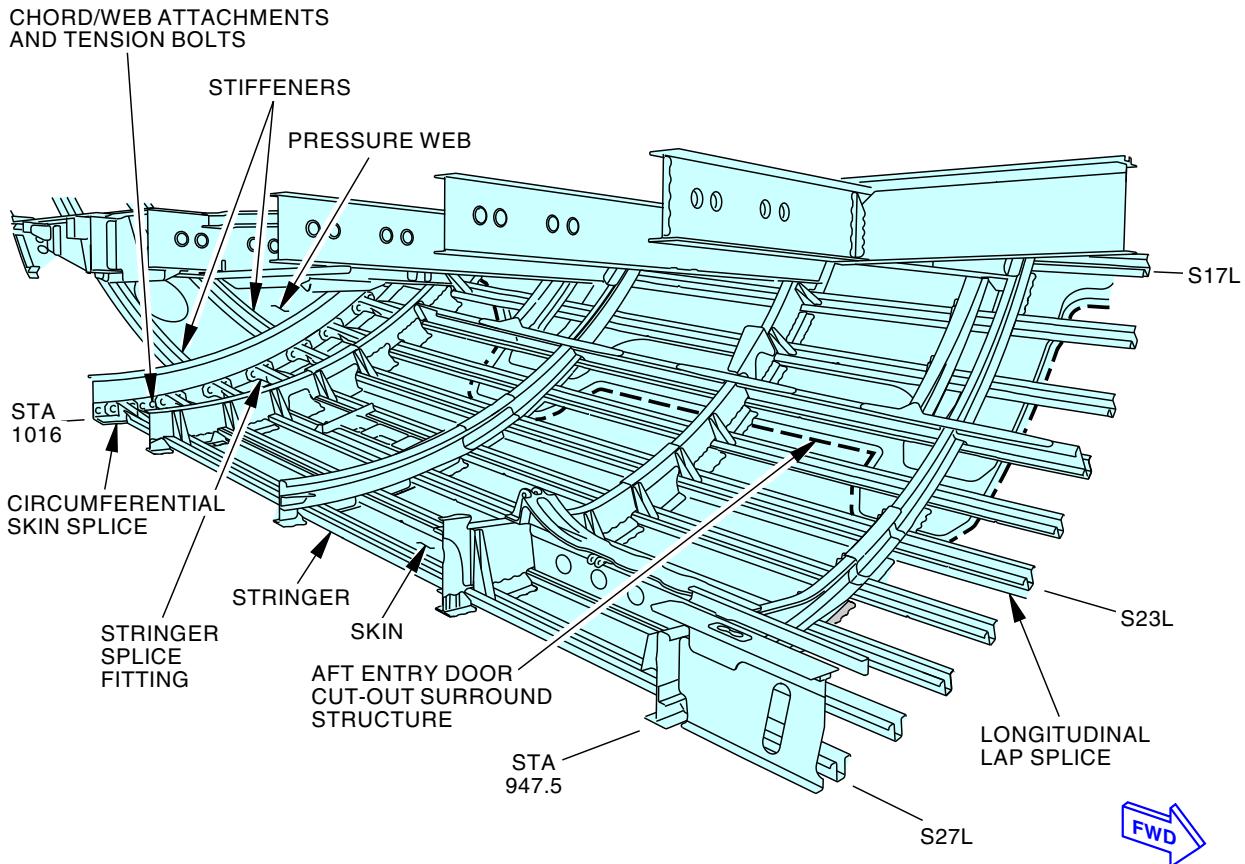
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.2  
Feb 15/2025



737-600/700/800/900  
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AREA AFT OF AFT CARGO  
(STA 947.5 TO STA 1016)  
(LEFT SIDE)

B

MPD ITEM  
53-260-00

2094973 S0000442106\_V2

Internal-General Visual: Internal-Area Aft Of Cargo Compartment  
Figure 231/53-05-03-990-866 (Sheet 2 of 3)

EFFECTIVITY  
LOM ALL

D633A101-LOM

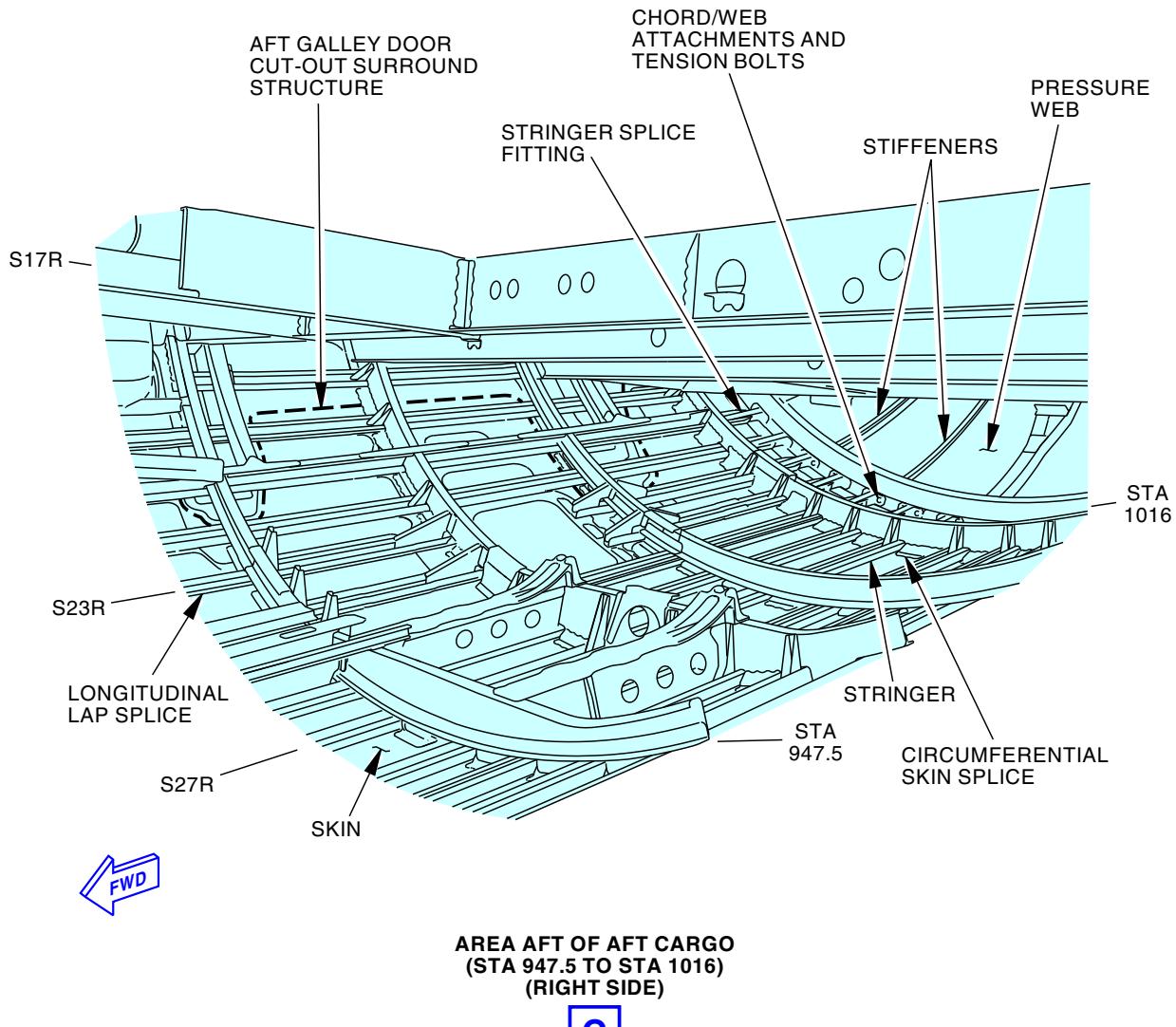
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.3  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-260-00

2095515 S0000442107\_V2

Internal-General Visual: Internal-Area Aft Of Cargo Compartment  
Figure 231/53-05-03-990-866 (Sheet 3 of 3)

EFFECTIVITY  
LOM ALL

D633A101-LOM

**53-05-03**

Page 298.4  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-827**

29. **INTERNAL - GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (aft of wheel well)**  
(Figure 232)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
149	Keel Beam (Part) Body Station 727.00 to Body Station 743.95
194	Lower Wing-To-Body Fairing - Aft of Wheel Well

**B. Access Panels**

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft
194CL	Aft Wing To Body Fairing Panel
194CR	Aft Wing To Body Fairing Panel
194DL	Aft Wing To Body Fairing Panel
194DR	Aft Wing To Body Fairing Panel
194E	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel
194HL	Aft Wing To Body Fairing Panel
194HR	Aft Wing To Body Fairing Panel

**C. Inspection**

**SUBTASK 53-05-03-010-024**

- (1) Open these access panels:

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft
194CL	Aft Wing To Body Fairing Panel
194CR	Aft Wing To Body Fairing Panel
194DL	Aft Wing To Body Fairing Panel
194DR	Aft Wing To Body Fairing Panel
194E	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel
194HL	Aft Wing To Body Fairing Panel
194HR	Aft Wing To Body Fairing Panel

EFFECTIVITY  
LOM ALL

**53-05-03**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-05-03-210-027

- (2) Do a General Visual inspection of the area under lower wing-to-body fairing (aft of wheel well), including skin panels, longitudinal lap splices, circumferential skin splice, stringer 18 strap at side of body, stringer 18A (web, chords and links), and keel beam extension.

SUBTASK 53-05-03-910-032

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-024

- (4) Close these access panels:

<b>Number</b>	<b>Name/Location</b>
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft
194CL	Aft Wing To Body Fairing Panel
194CR	Aft Wing To Body Fairing Panel
194DL	Aft Wing To Body Fairing Panel
194DR	Aft Wing To Body Fairing Panel
194E	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel
194HL	Aft Wing To Body Fairing Panel
194HR	Aft Wing To Body Fairing Panel

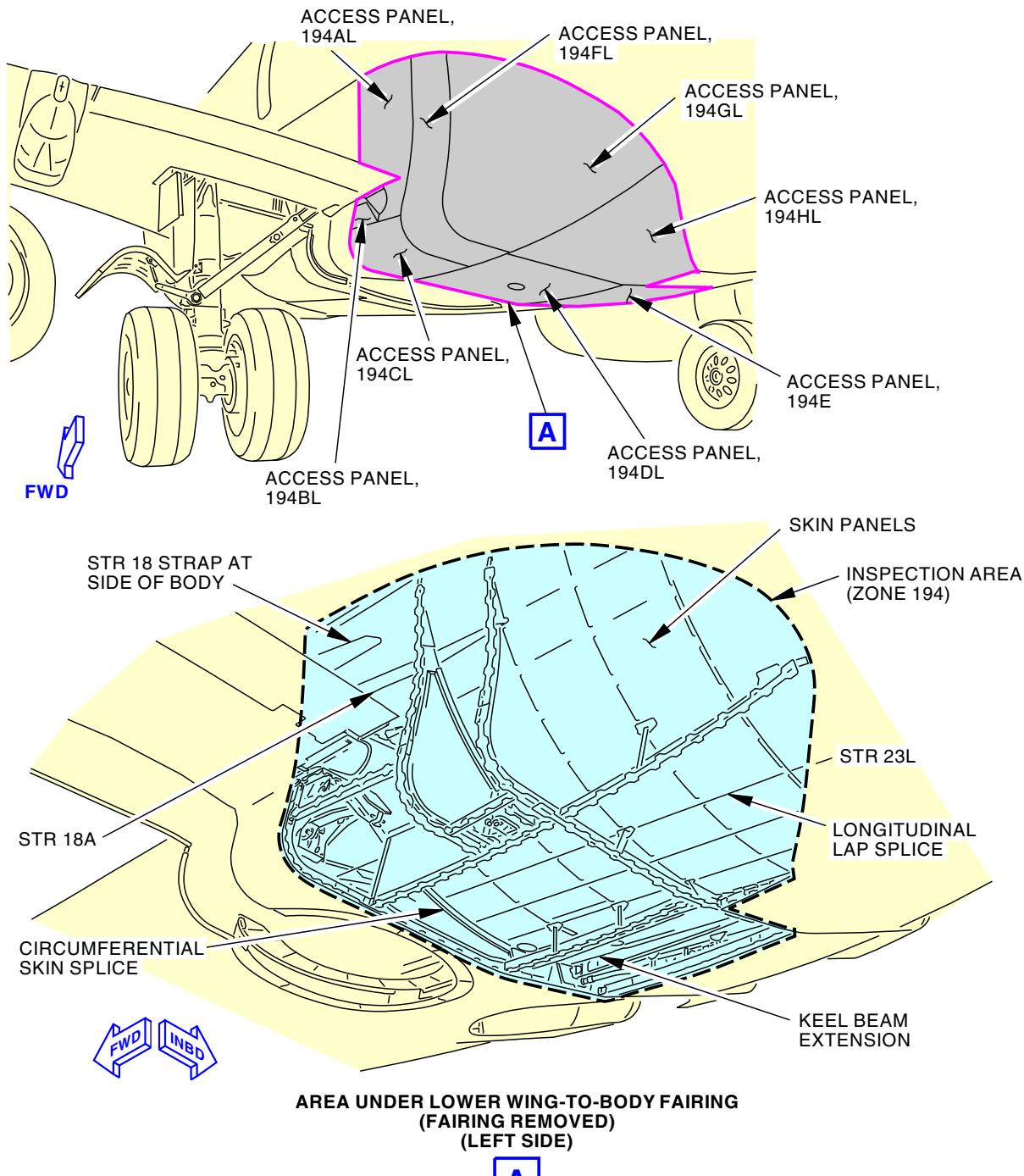
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



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MPD ITEM  
53-270-00

2089485 S0000441011\_V2

INTERNAL-GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (aft of wheel well)  
Figure 232/53-05-03-990-855 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

D633A101-LOM

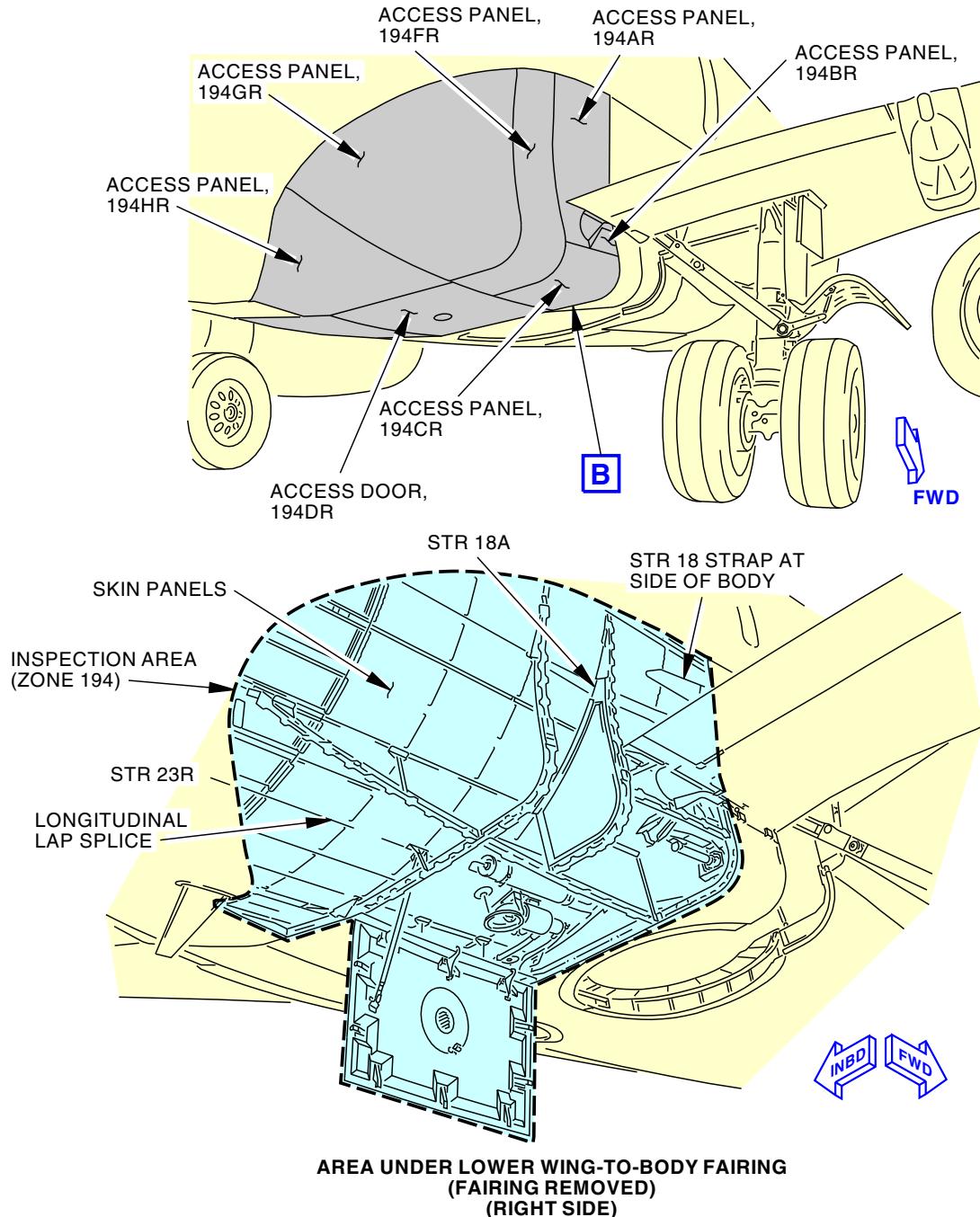
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.7  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
57-270-00

2089514 S0000441012\_V2

INTERNAL-GENERAL VISUAL: AREA UNDER LOWER WING-TO-BODY FAIRING (aft of wheel well)  
Figure 232/53-05-03-990-855 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.8  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-828**

**30. INTERNAL - GENERAL VISUAL: AREA UNDER WING-TO-BODY FAIRING (above wing)**

(Figure 233,Figure 234)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

**B. Access Panels**

Number	Name/Location
195AL	Wing To Body Fairing - Left Side
195AR	Wing To Body Fairing - Right Side
195BL	Wing To Body Fairing - Left Side
195BR	Wing To Body Fairing - Right Side
195CL	Wing To Body Fairing - Left Side
195CR	Wing To Body Fairings - Right Side

**C. Inspection**

SUBTASK 53-05-03-010-025

- (1) Open these access panels:

Number	Name/Location
195AL	Wing To Body Fairing - Left Side
195AR	Wing To Body Fairing - Right Side
195BL	Wing To Body Fairing - Left Side
195BR	Wing To Body Fairing - Right Side
195CL	Wing To Body Fairing - Left Side
195CR	Wing To Body Fairings - Right Side

SUBTASK 53-05-03-210-028

- (2) Do a General Visual inspection of the area under above-wing wing-to-body fairing, including skin panels, circumferential skin splices, and stringer 18 strap at side of body.

SUBTASK 53-05-03-910-035

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-025

- (4) Close these access panels:

Number	Name/Location
195AL	Wing To Body Fairing - Left Side
195AR	Wing To Body Fairing - Right Side
195BL	Wing To Body Fairing - Left Side
195BR	Wing To Body Fairing - Right Side
195CL	Wing To Body Fairing - Left Side
195CR	Wing To Body Fairings - Right Side

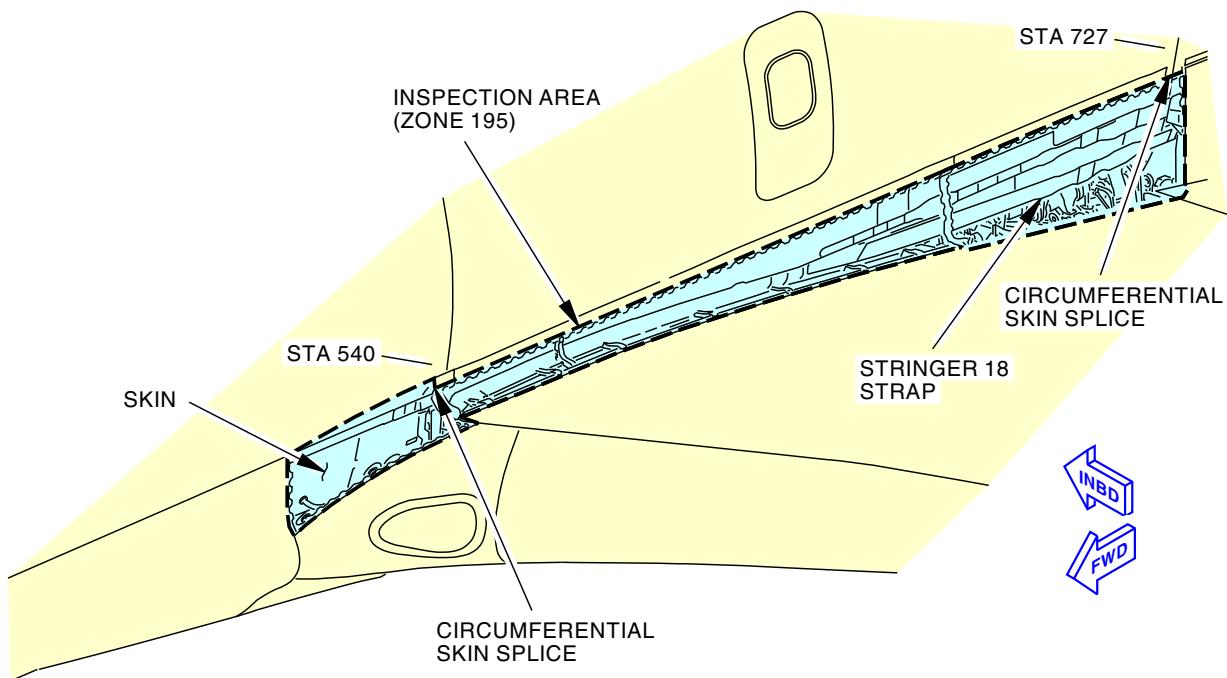
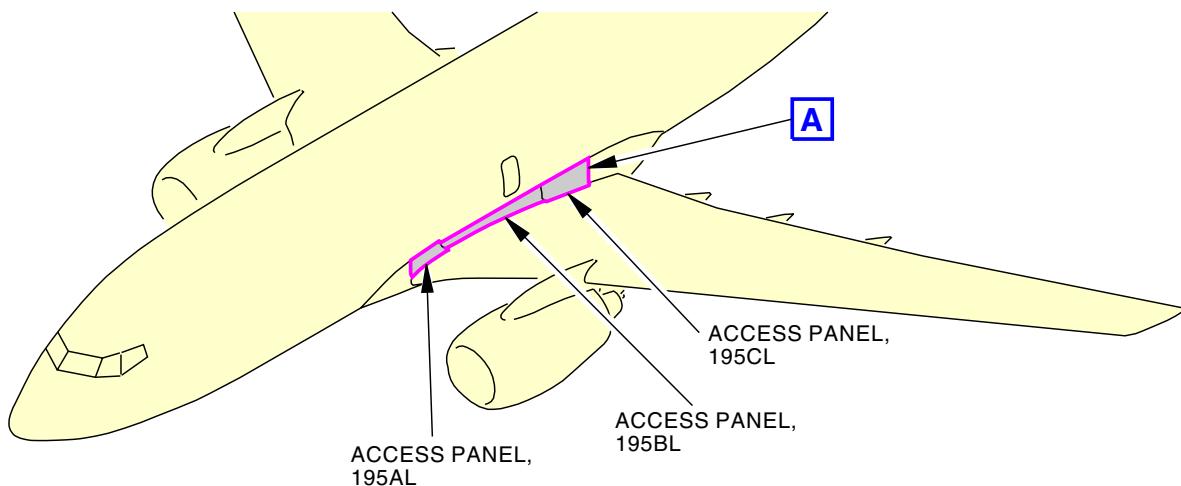
— END OF TASK —



**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-280-00

A

2083283 S0000437150\_V2

Internal - General Visual: Area Under Left Wing-to-Body Fairing  
Figure 233/53-05-03-990-856

EFFECTIVITY  
LOM ALL

**53-05-03**

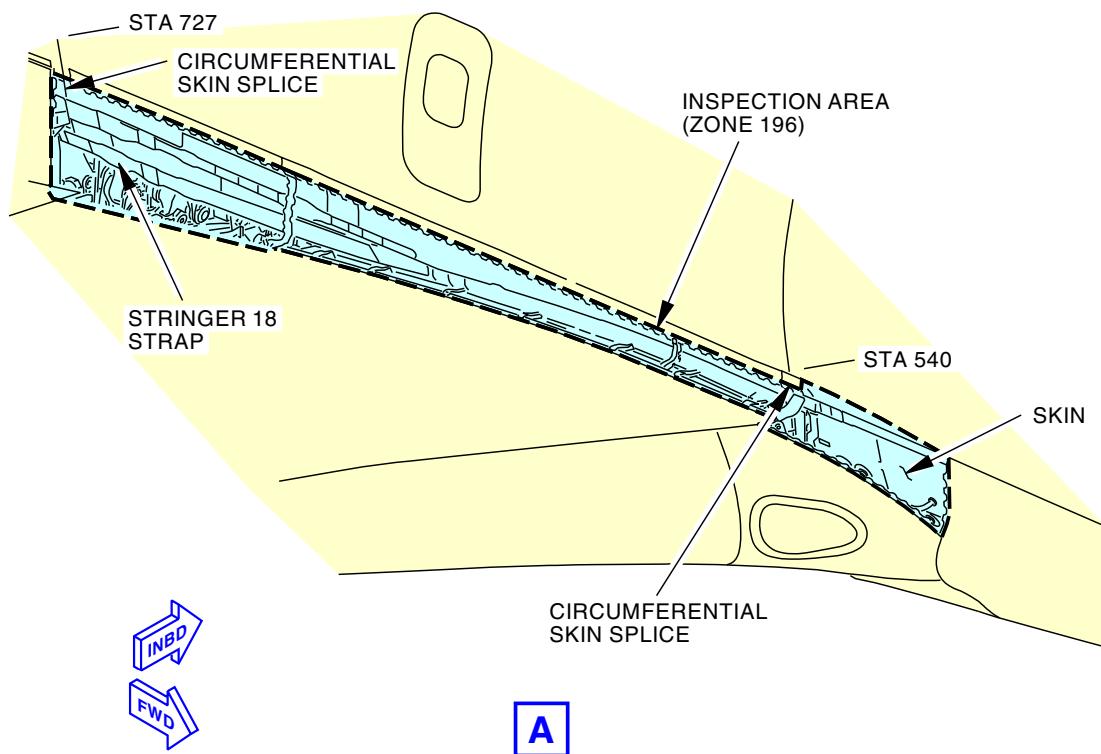
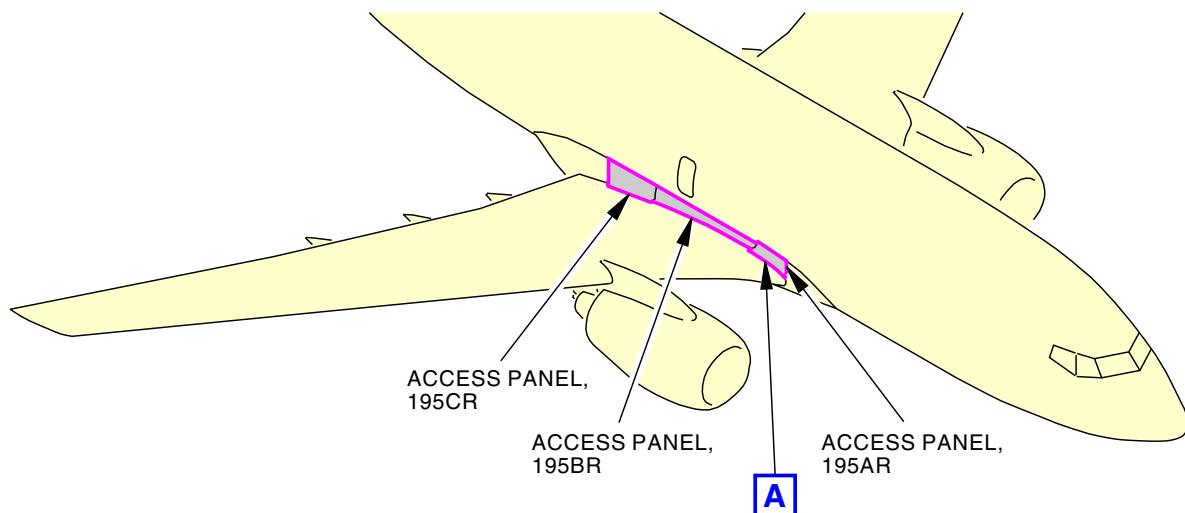
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.10  
Feb 15/2025



737-600/700/800/900  
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MPD ITEM  
53-280-00

2083297 S0000437151\_V3

Internal - General Visual: Area Under Right Wing-to-Body Fairing  
Figure 234/53-05-03-990-899

EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.11  
Feb 15/2025



737-600/700/800/900  
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**TASK 53-05-03-210-829**

**31. EXTERNAL - GENERAL VISUAL: OVERWING EMERGENCY EXIT CUTOUT**

(Figure 235,Figure 236)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

**C. Inspection**

SUBTASK 53-05-03-010-026

- (1) Open these access panels:

<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

NOTE: Open automatic overwing exits.

SUBTASK 53-05-03-210-029

- (2) Do a General Visual inspection of the automatic overwing exit cutout structure, fittings and stops.

SUBTASK 53-05-03-910-034

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-809.

SUBTASK 53-05-03-410-026

- (4) Close these access panels:

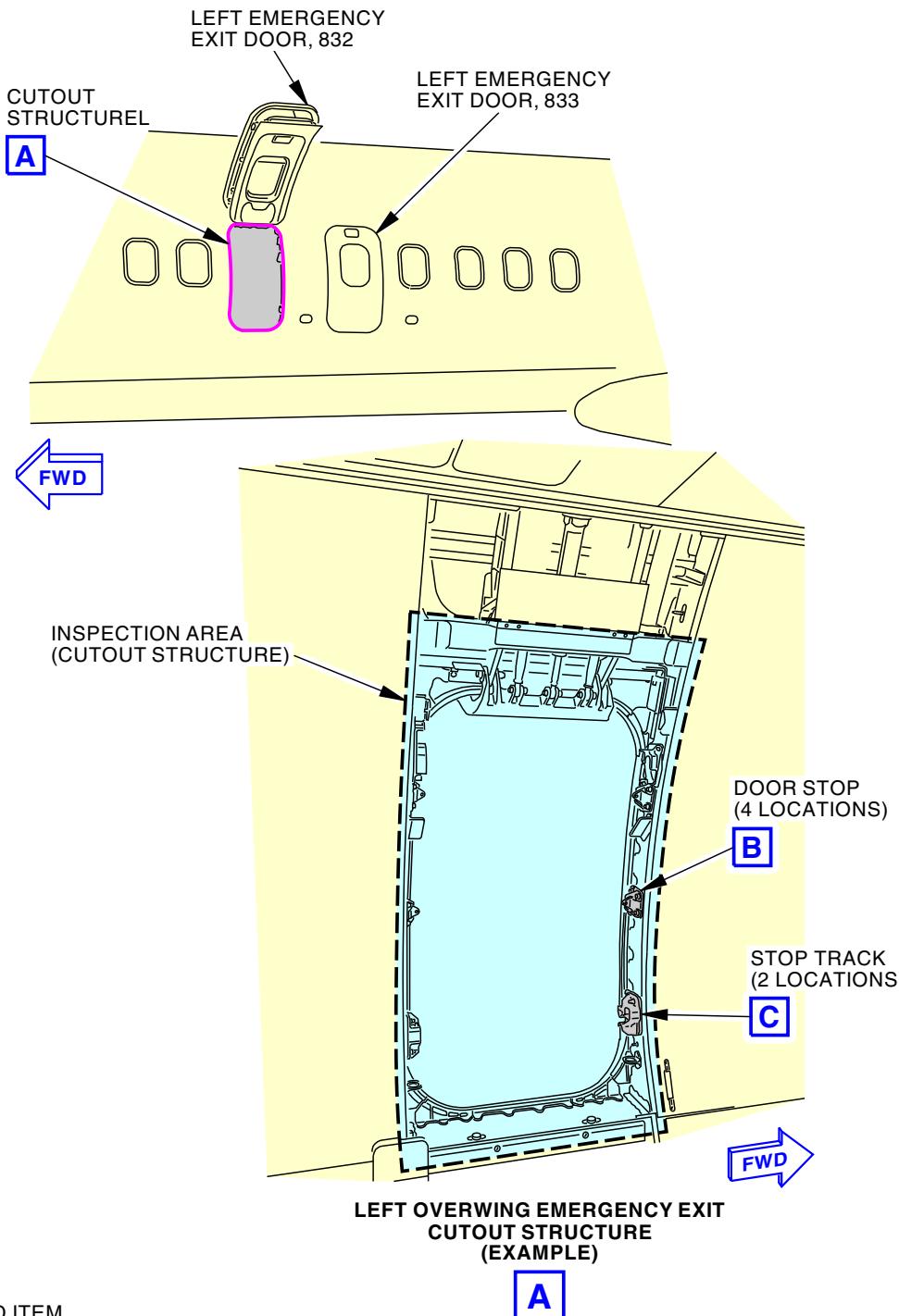
<b>Number</b>	<b>Name/Location</b>
832	Emergency Exit
833	Emergency Exit
842	Emergency Exit
843	Emergency Exit

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**

**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**



MPD ITEM  
53-290-00

484671 S0000143823\_V2

**Left Overwing Emergency Exit Cutout**  
**Figure 235/53-05-03-990-814 (Sheet 1 of 2)**

EFFECTIVITY	LOM ALL
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D633A101-LOM

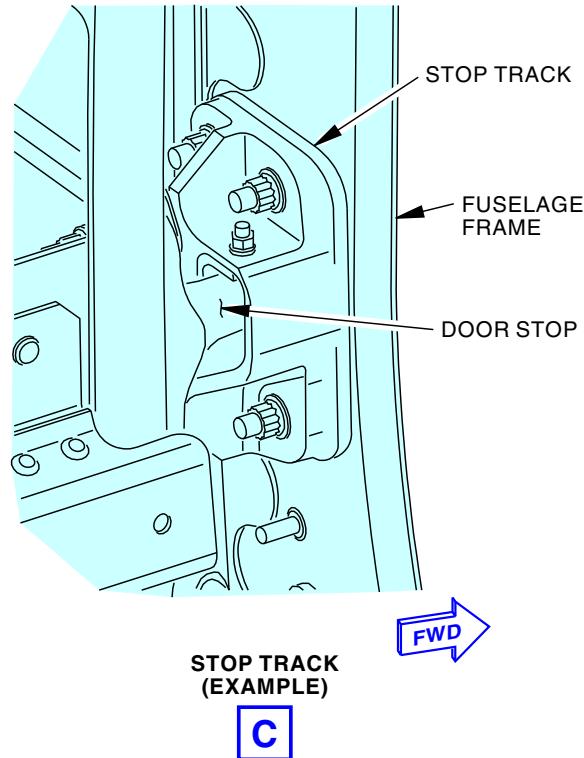
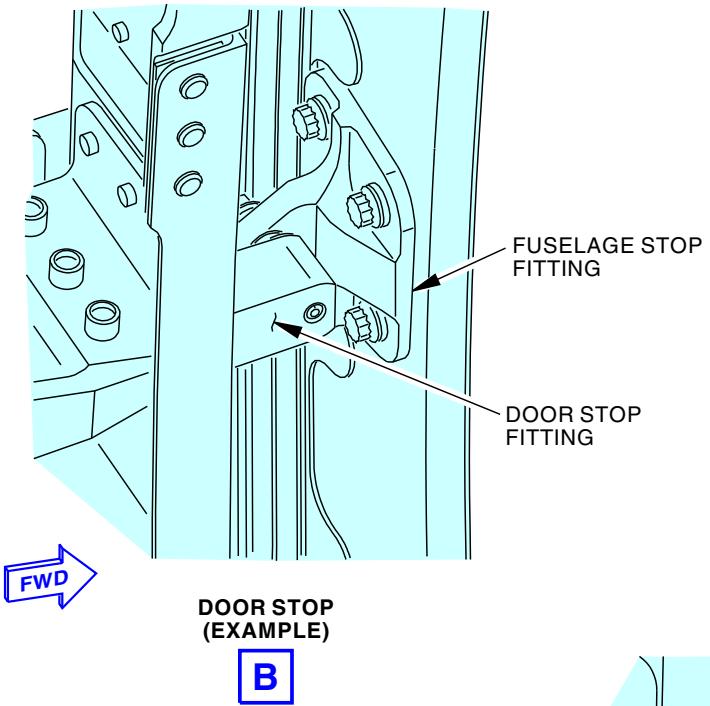
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.13  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-290-00

484672 S0000143827\_V3

Left Overwing Emergency Exit Cutout  
Figure 235/53-05-03-990-814 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

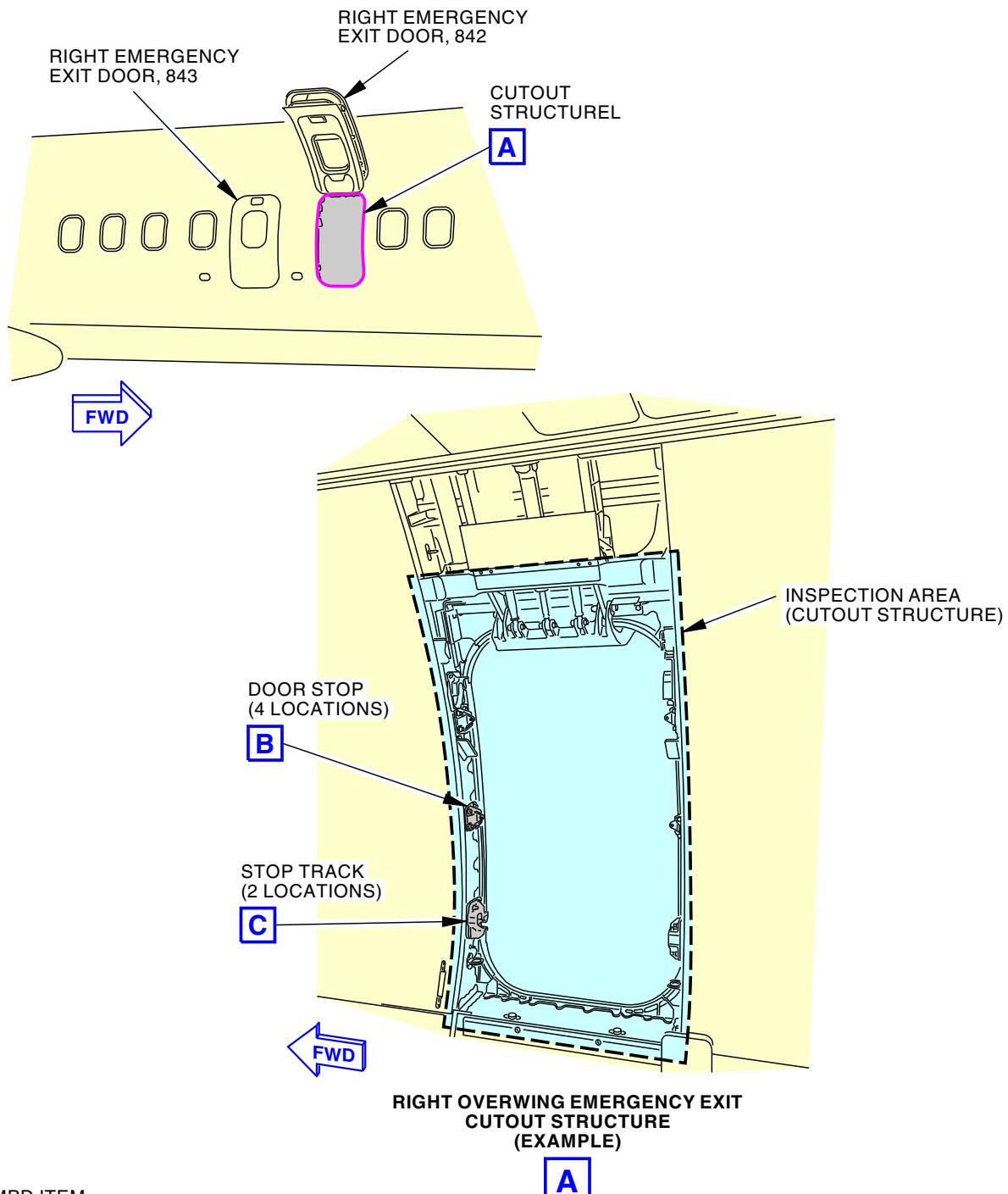
**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.14  
Feb 15/2025

**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**



MPD ITEM  
53-290-00

484697 S0000143836\_V2

**Right Overwing Emergency Exit Cutout**  
**Figure 236/53-05-03-990-815 (Sheet 1 of 2)**

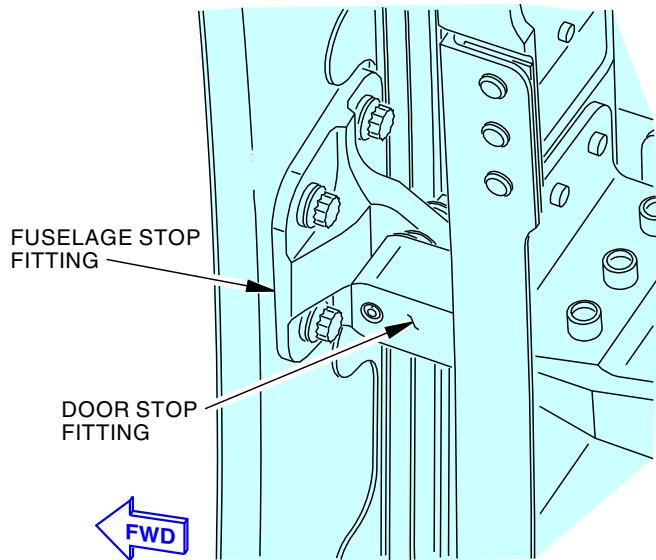
EFFECTIVITY	LOM ALL
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D633A101-LOM

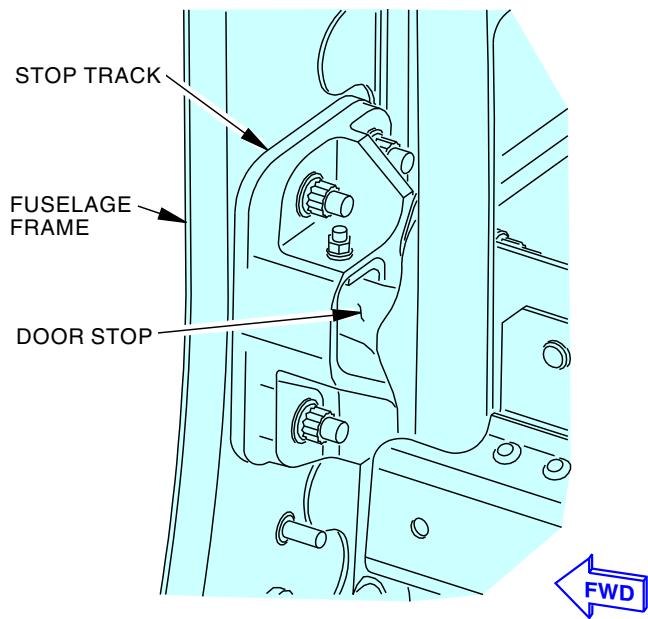
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.15  
Feb 15/2025



DOOR STOP (EXAMPLE)

**B**

STOP TRACK (EXAMPLE)

**C**MPD ITEM  
53-290-00

484701 S0000143840\_V3

**Right Overwing Emergency Exit Cutout**  
Figure 236/53-05-03-990-815 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.16  
Feb 15/2025



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**TASK 53-05-03-211-805**

32. **EXTERNAL - DETAILED: FORWARD ENTRY DOOR FRAME, STOPS, LATCHES AND HINGES**  
(Figure 237)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

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

**C. Inspection**

SUBTASK 53-05-03-010-059

- (1) Open this access panel:

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

NOTE: Open forward entry door.

SUBTASK 53-05-03-211-005

- (2) Do a Detailed inspection of the door frames, stops, latches and hinges on the forward door cutout surround structure.

SUBTASK 53-05-03-910-036

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-809.

SUBTASK 53-05-03-410-059

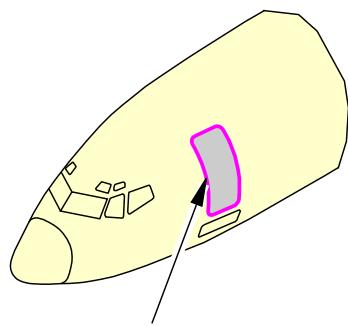
- (4) Close this access panel:

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

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

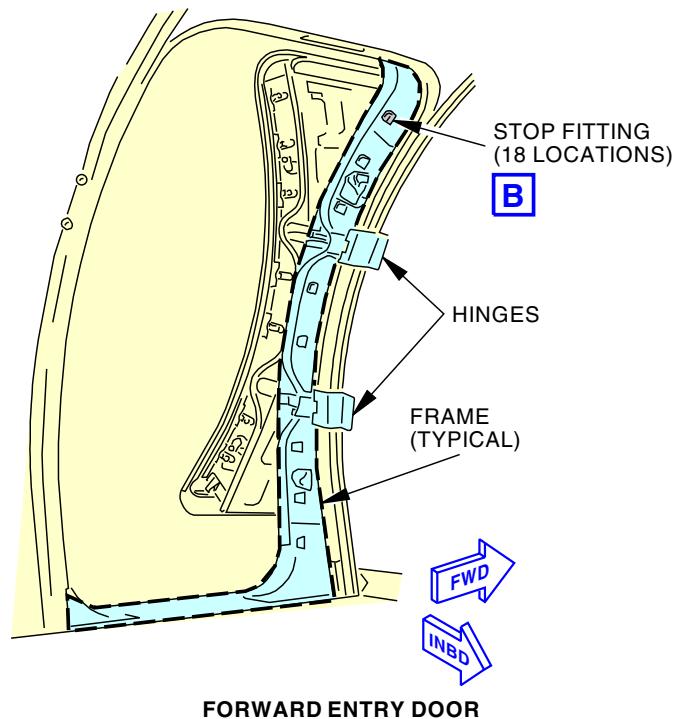
**53-05-03**



FORWARD  
ENTRY  
DOOR

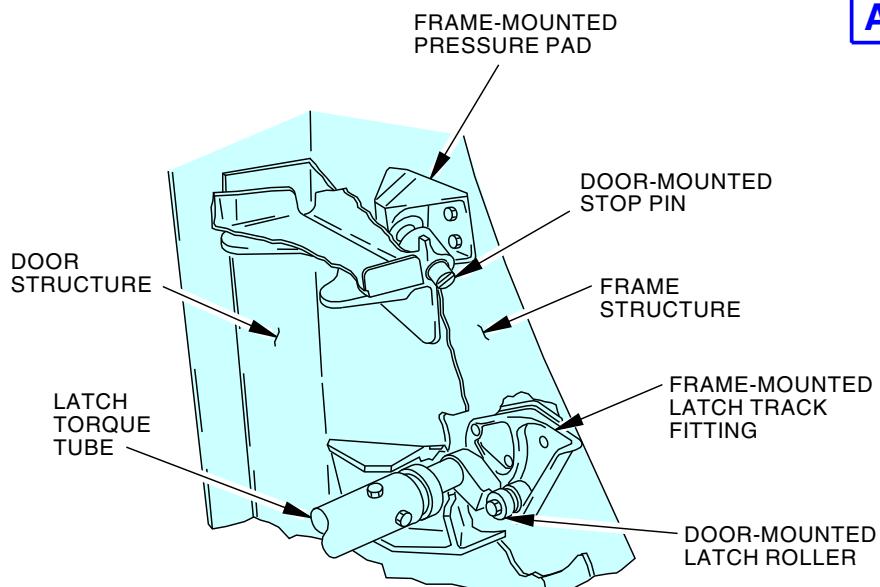
**A**

(EXAMPLE)



FORWARD ENTRY DOOR

**A**



LATCH AND STOP ASSEMBLY DETAIL

**B**

H45979 S0006584636\_V3

**External - Forward Entry Door Frame, Stop, Latches and Hinges**  
**Figure 237/53-05-03-990-808**

EFFECTIVITY  
LOM ALL

**53-05-03**



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AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-211-806**

**33. EXTERNAL - DETAILED: FORWARD GALLEY SERVICE DOOR FRAME, STOPS, LATCHES AND HINGES**

(Figure 238)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

<u>Number</u>	<u>Name/Location</u>
841	Forward Galley Service Door

**C. Inspection**

SUBTASK 53-05-03-010-060

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
841	Forward Galley Service Door

NOTE: Open forward galley service door.

SUBTASK 53-05-03-211-006

- (2) Do a Detailed inspection of the door frames, stops, latches and hinges on forward galley door cutout surround structure.

SUBTASK 53-05-03-910-037

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-809.

SUBTASK 53-05-03-410-060

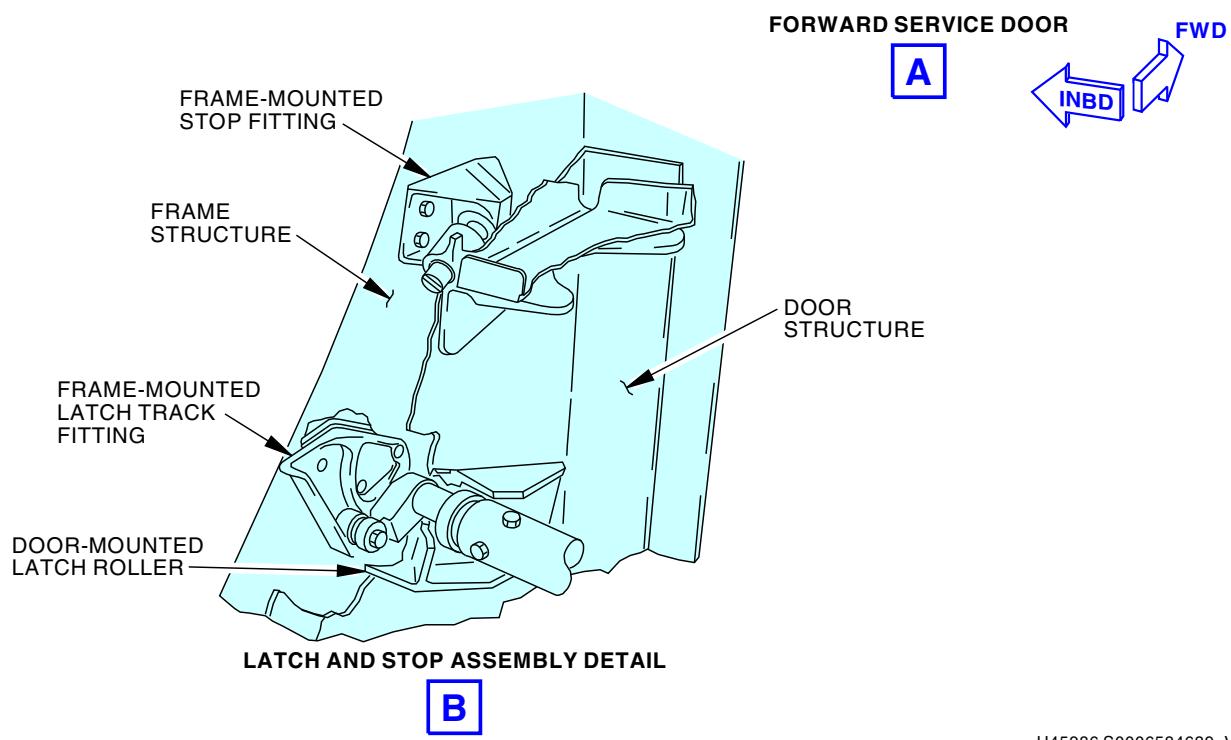
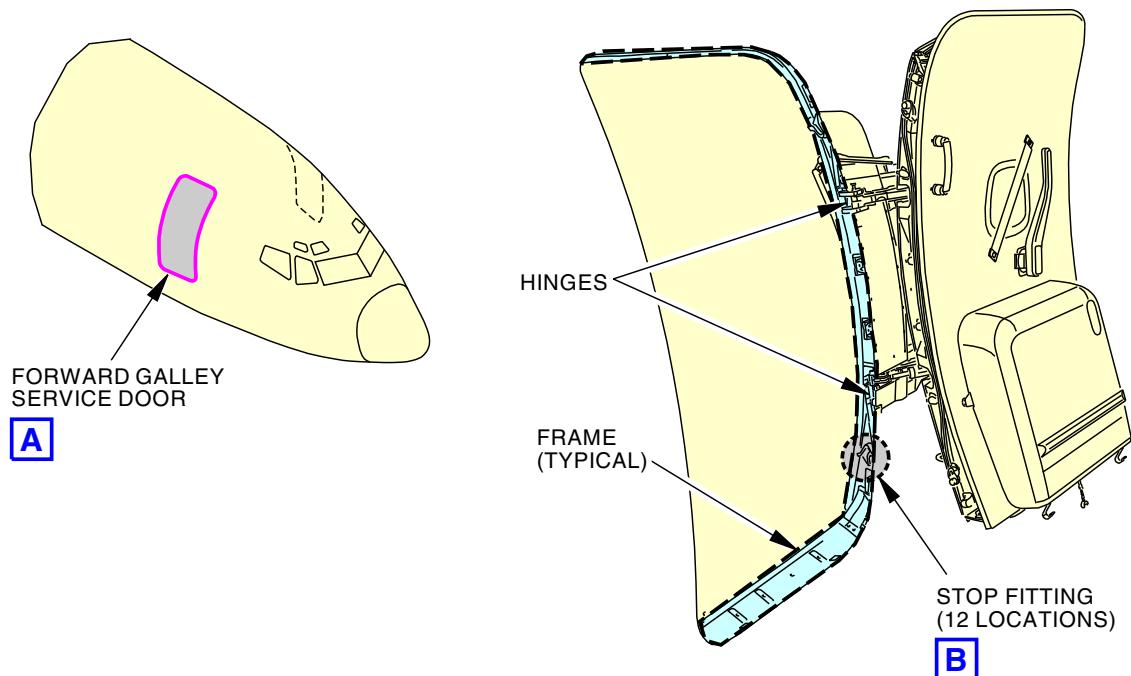
- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
841	Forward Galley Service Door

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



H45986 S0006584639\_V2

**External - Forward Galley Service Door Frame, Stops, Latches and Hinges**  
**Figure 238/53-05-03-990-809**

EFFECTIVITY  
**LOM ALL**

**53-05-03**



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**TASK 53-05-03-211-807**

**34. EXTERNAL - DETAILED: AFT ENTRY DOOR FRAME, STOPS, LATCHES AND HINGES**

(Figure 239)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

**B. Access Panels**

<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door

**C. Inspection**

SUBTASK 53-05-03-010-061

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door

NOTE: Open aft entry door.

SUBTASK 53-05-03-211-007

- (2) Do a Detailed inspection of the door frames, stops, latches and hinges on aft entry cutout surround structure.

SUBTASK 53-05-03-910-038

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-809.

SUBTASK 53-05-03-410-061

- (4) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
834	Aft Entry Door

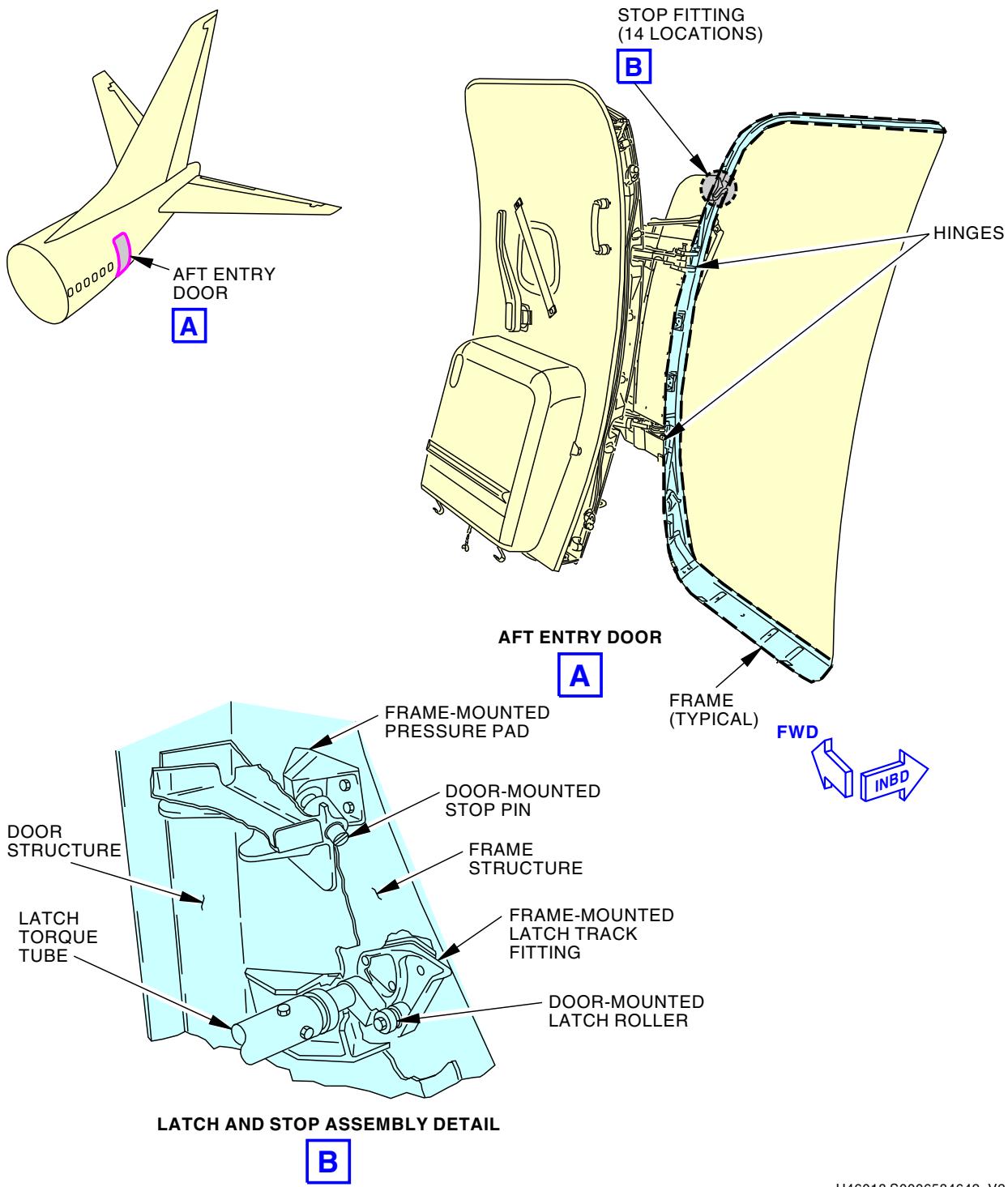
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



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H46018 S0006584642\_V2

**AFT Entry Door Frame, Stops, Latches and Hinges**  
Figure 239/53-05-03-990-810

EFFECTIVITY  
LOM ALL

**53-05-03**



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AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-211-808**

35. **EXTERNAL - DETAILED: AFT GALLEY SERVICE DOOR FRAME, STOPS, LATCHES AND HINGES**  
(Figure 240)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
844	Aft Galley Service Door

**C. Inspection**

SUBTASK 53-05-03-010-062

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
844	Aft Galley Service Door

NOTE: Open aft galley door.

SUBTASK 53-05-03-211-008

- (2) Do a Detailed inspection of the door frames, stops, latches and hinges on aft galley door cutout surround structure.

SUBTASK 53-05-03-910-039

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-809.

SUBTASK 53-05-03-410-062

- (4) Close this access panel:

<b>Number</b>	<b>Name/Location</b>
844	Aft Galley Service Door

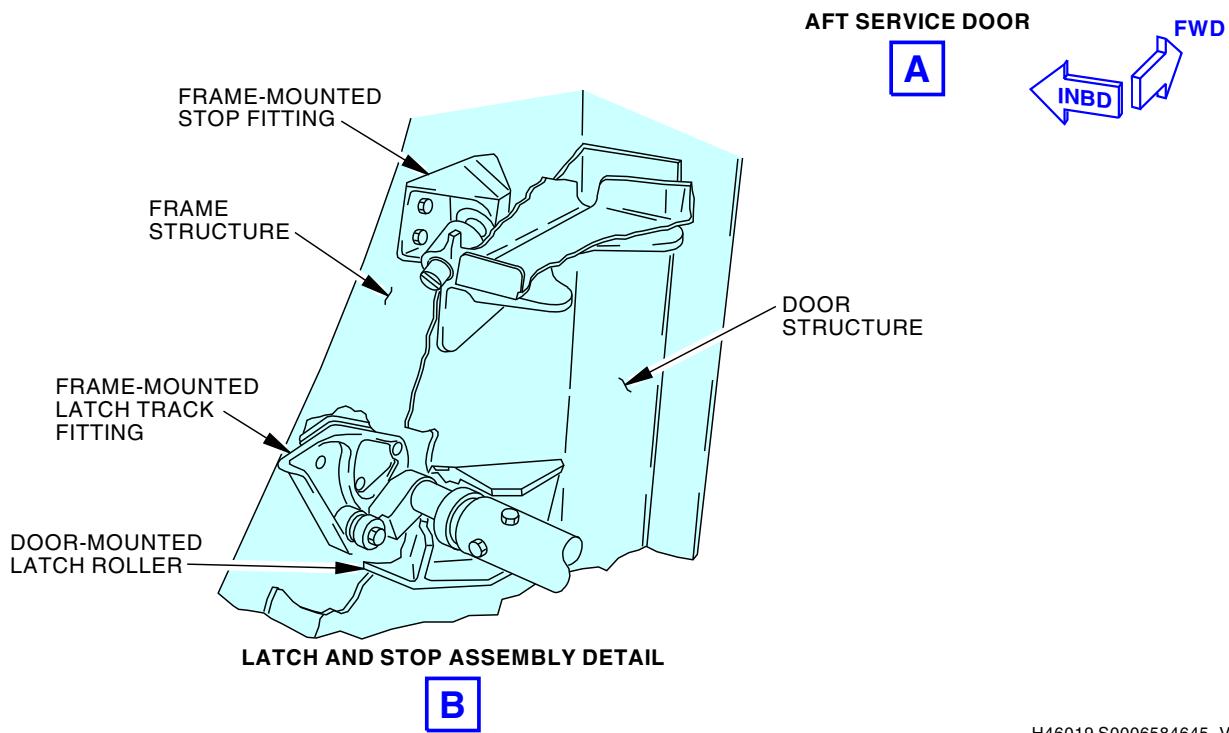
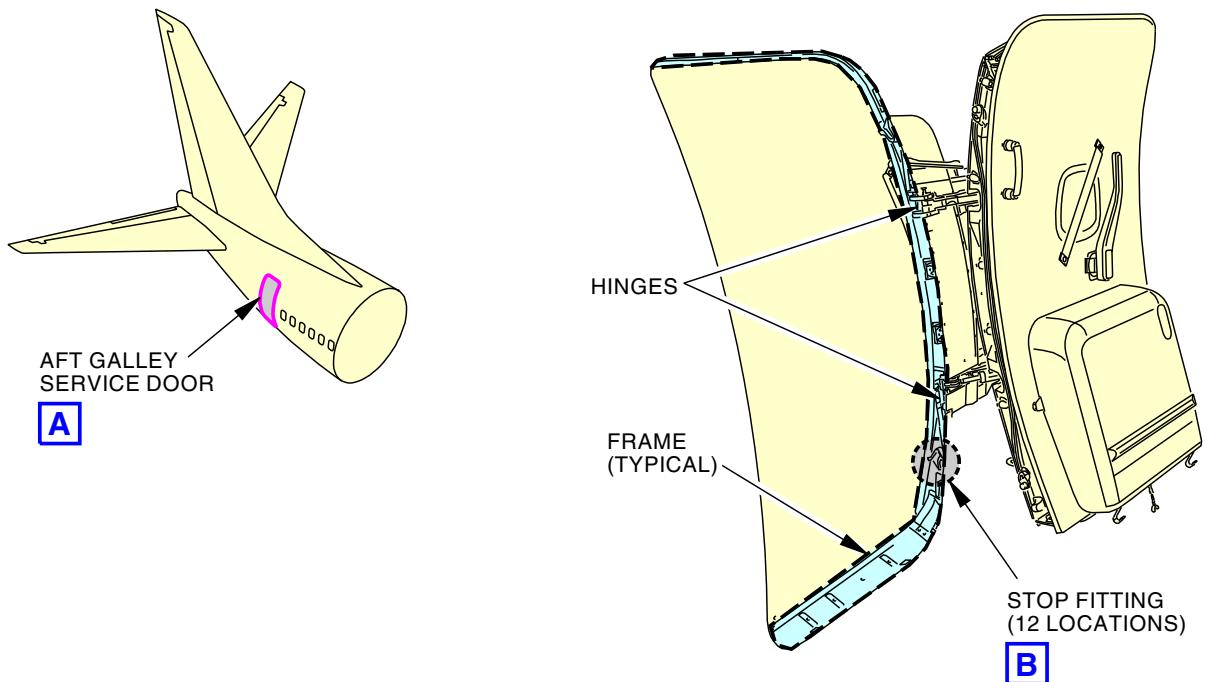
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



H46019 S0006584645\_V2

Aft Galley Door Frame, Stop, Latches and Hinges  
Figure 240/53-05-03-990-811

EFFECTIVITY  
LOM ALL

**53-05-03**



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AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-830**

**36. INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FROM STA 178 TO 270**

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
211	Flight Compartment - Left
212	Flight Compartment - Right
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
S2101	Flight Compartment Inspection

**C. Inspection**

SUBTASK 53-05-03-010-078

- (1) Special Access:

<b>Number</b>	<b>Name/Location</b>
S2101	Flight Compartment Inspection

NOTE: Remove glare shield, liners, overhead units and panels as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-030

- (2) Do a General Visual inspection of the flight compartment from Sta 178 to 270, including skin panels (skins, frames, stringers), circumferential skin and stringer splice, crew cabin window cutout structure, and structure adjacent to ground block behind rudder pedal. Inspection area does not include: Forward side of frame at STA 259.5 and structure 3 inches forward of STA 259.5; BL 0 + 4 inches (Left and Right); Forward and aft side of Frame 259.5 and structure from STA 249 to STA 263 between floor and S-5L (excluding window and window frame structure); Forward side of Frame 259.5 and structure 3 inches forward of STA 259.5 between floor and S-3R; Structure forward of STA 203.8 to STA 178 and from floor up to window frame (except structure adjacent to ground block behind rudder pedal); skin, frames and stringers above P5 panel.

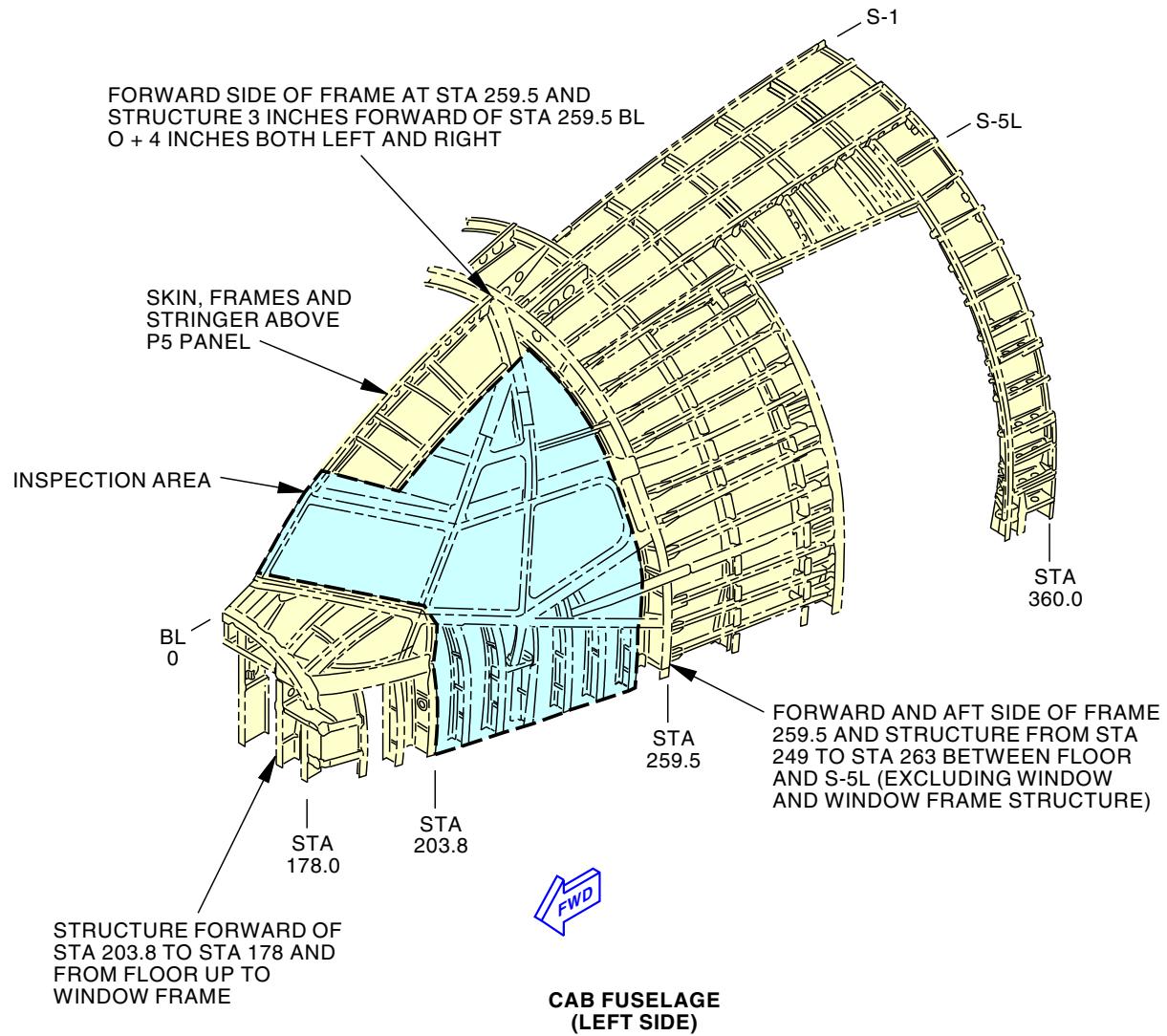
SUBTASK 53-05-03-910-040

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

———— END OF TASK ————

EFFECTIVITY
LOM ALL

**53-05-03**



MPD ITEM 53-330-00

2293027 S0000519158\_V3

**FLIGHT COMPARTMENT FROM STA 178 TO 270**  
**Figure 241/53-05-03-990-900 (Sheet 1 of 2)**

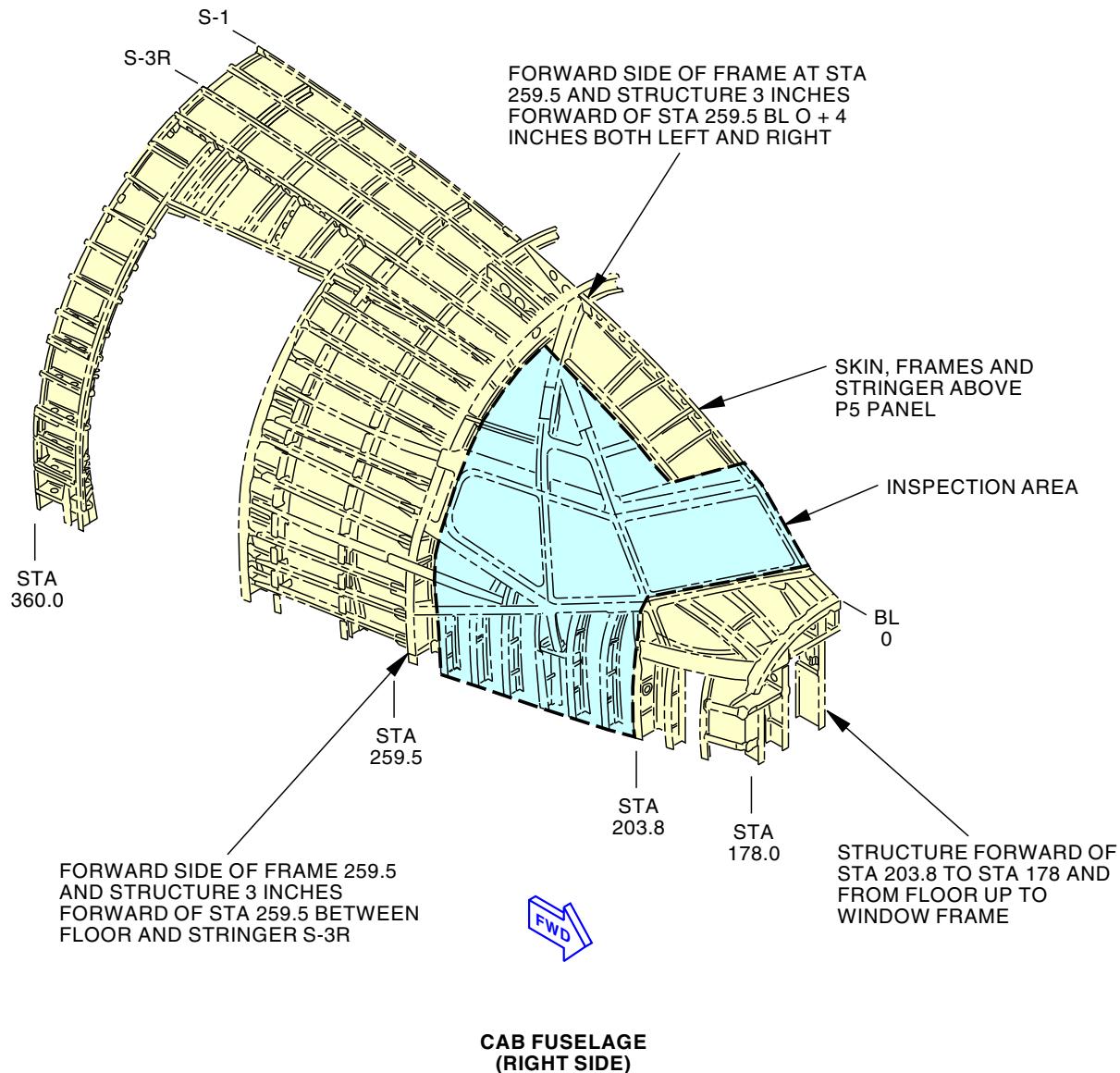
EFFECTIVITY  
**LOM ALL**

**53-05-03**

D633A101-LOM



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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM 53-330-00

2293019 S0000519160\_V4

FLIGHT COMPARTMENT FROM STA 178 TO 270  
Figure 241/53-05-03-990-900 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.27  
Feb 15/2025



737-600/700/800/900  
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**TASK 53-05-03-210-831**

**37. INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FLOOR STRUCTURE**

(Figure 242)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
211	Flight Compartment - Left
212	Flight Compartment - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
S2102	Flight Compartment Floor Structure

**C. Inspection**

SUBTASK 53-05-03-010-028

- (1) Special Access:

<b>Number</b>	<b>Name/Location</b>
S2102	Flight Compartment Floor Structure

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

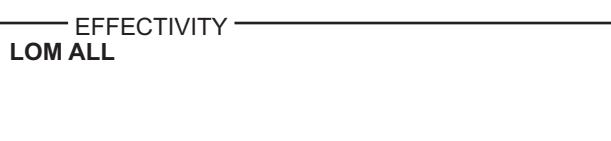
SUBTASK 53-05-03-210-031

- (2) Do a General Visual inspection of the flight compartment floor structure.

SUBTASK 53-05-03-910-041

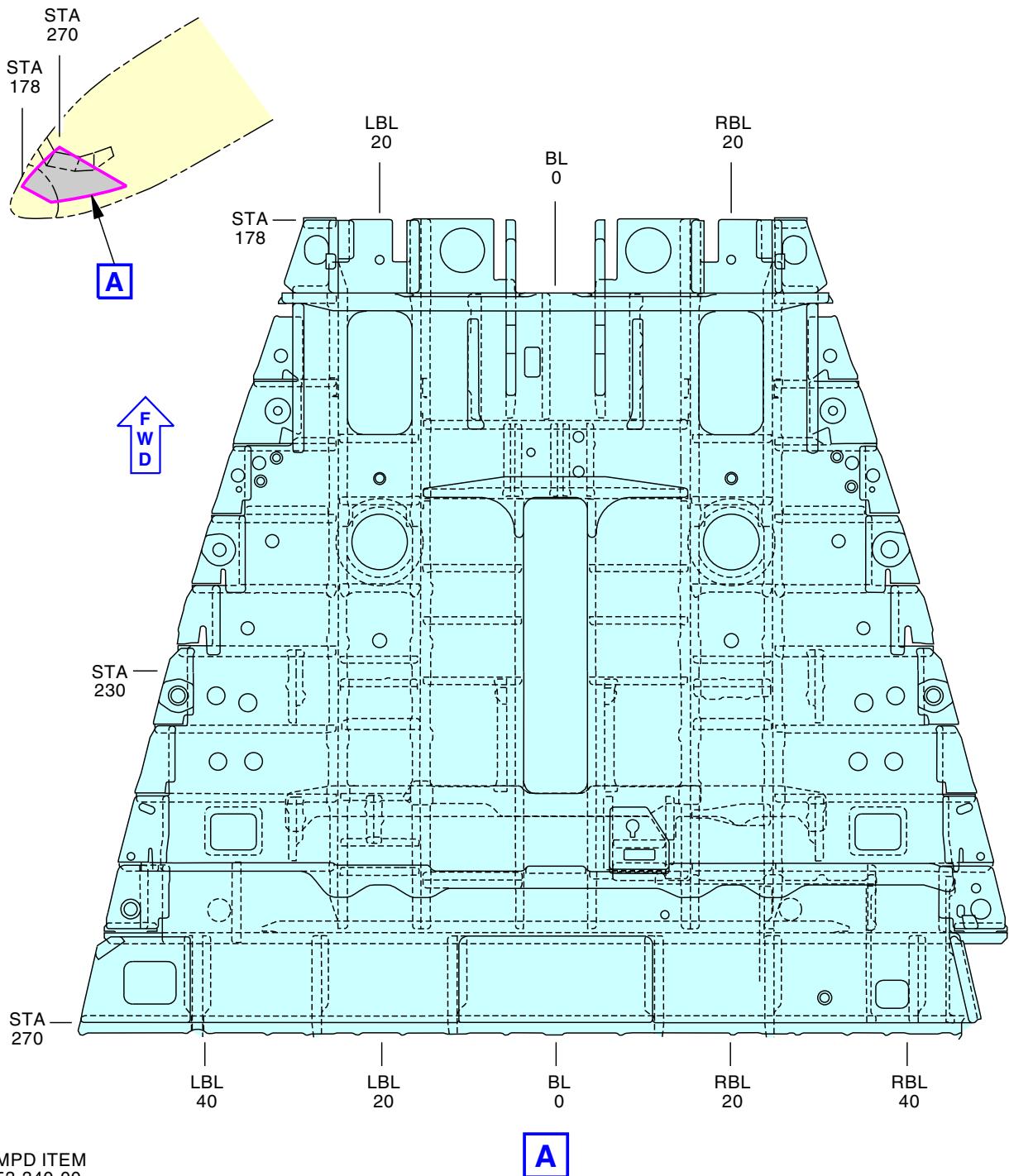
- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

———— END OF TASK ————





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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-340-00

A

2102637 S0000447408\_V2

Flight Deck Floor Structure  
Figure 242/53-05-03-990-829

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
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**TASK 53-05-03-210-832**

38. **INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FROM STA 270 to 360**  
(Figure 243)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

Number	Name/Location
S2201	Passenger Compartment From STA 259.5 to 360

**C. Inspection**

SUBTASK 53-05-03-010-029

- (1) Special Access:

Number	Name/Location
S2201	Passenger Compartment From STA 259.5 to 360

NOTE: Remove galleys/lavs. Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-032

- (2) Do a General Visual inspection of the passenger compartment from Sta 270 to 360 (except areas around door cutouts), including skin panels (skins, frames, stringers), longitudinal lap splices, circumferential skin and stringer splices.

SUBTASK 53-05-03-910-042

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

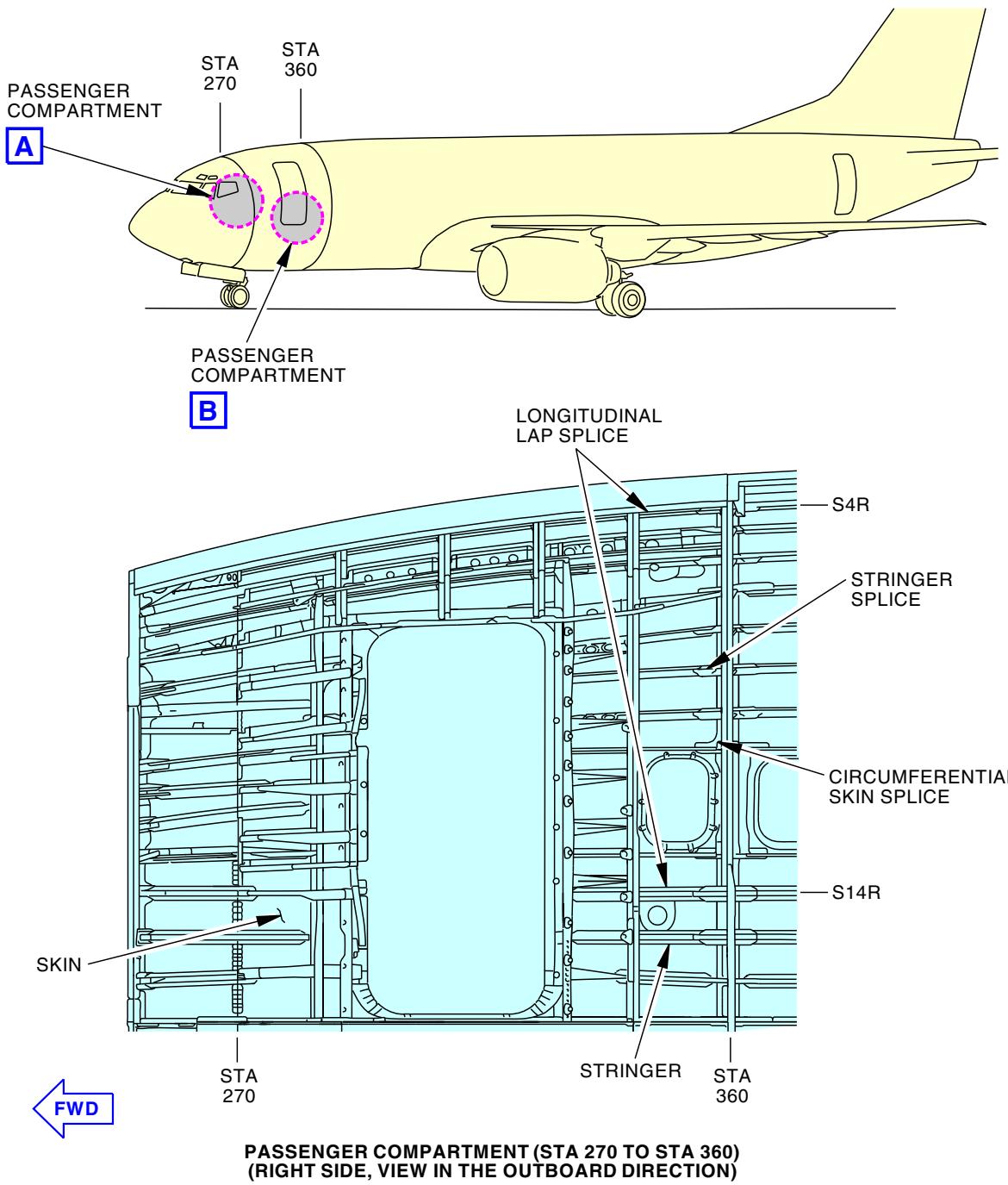
— END OF TASK —

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-350-00

2071151 S0000430778\_V2

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FROM STA 270 TO STA 360  
Figure 243/53-05-03-990-860 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

D633A101-LOM

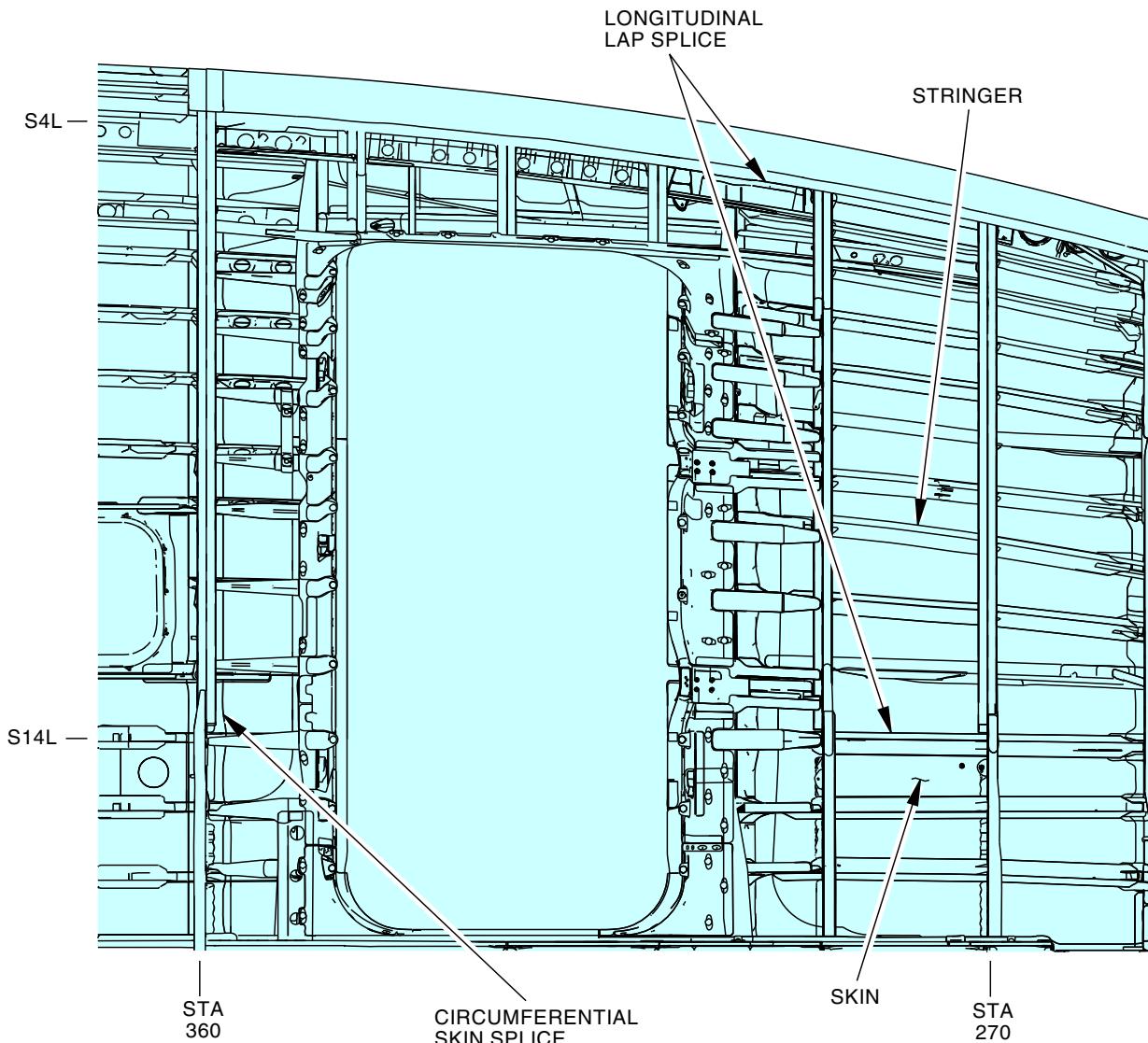
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**53-05-03**

Page 298.31  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



PASSENGER COMPARTMENT (STA 270 TO STA 360)  
(LEFT SIDE, VIEW IN THE OUTBOARD DIRECTION)



B

MPD ITEM  
53-350-00

2071155 S0000430781\_V2

INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FROM STA 270 TO STA 360  
Figure 243/53-05-03-990-860 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.32  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-211-809**

**39. INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS**

(Figure 244)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

Number	Name/Location
S2001	Passenger Compartment Door Cutouts Inspection

**C. Inspection**

SUBTASK 53-05-03-010-063

- (1) Special Access:

Number	Name/Location
S2001	Passenger Compartment Door Cutouts Inspection

NOTE: Remove galleys/lavs. Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-009

- (2) Do a Detailed inspection of the forward entry door cutout surround structure (the door cutout to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-043

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

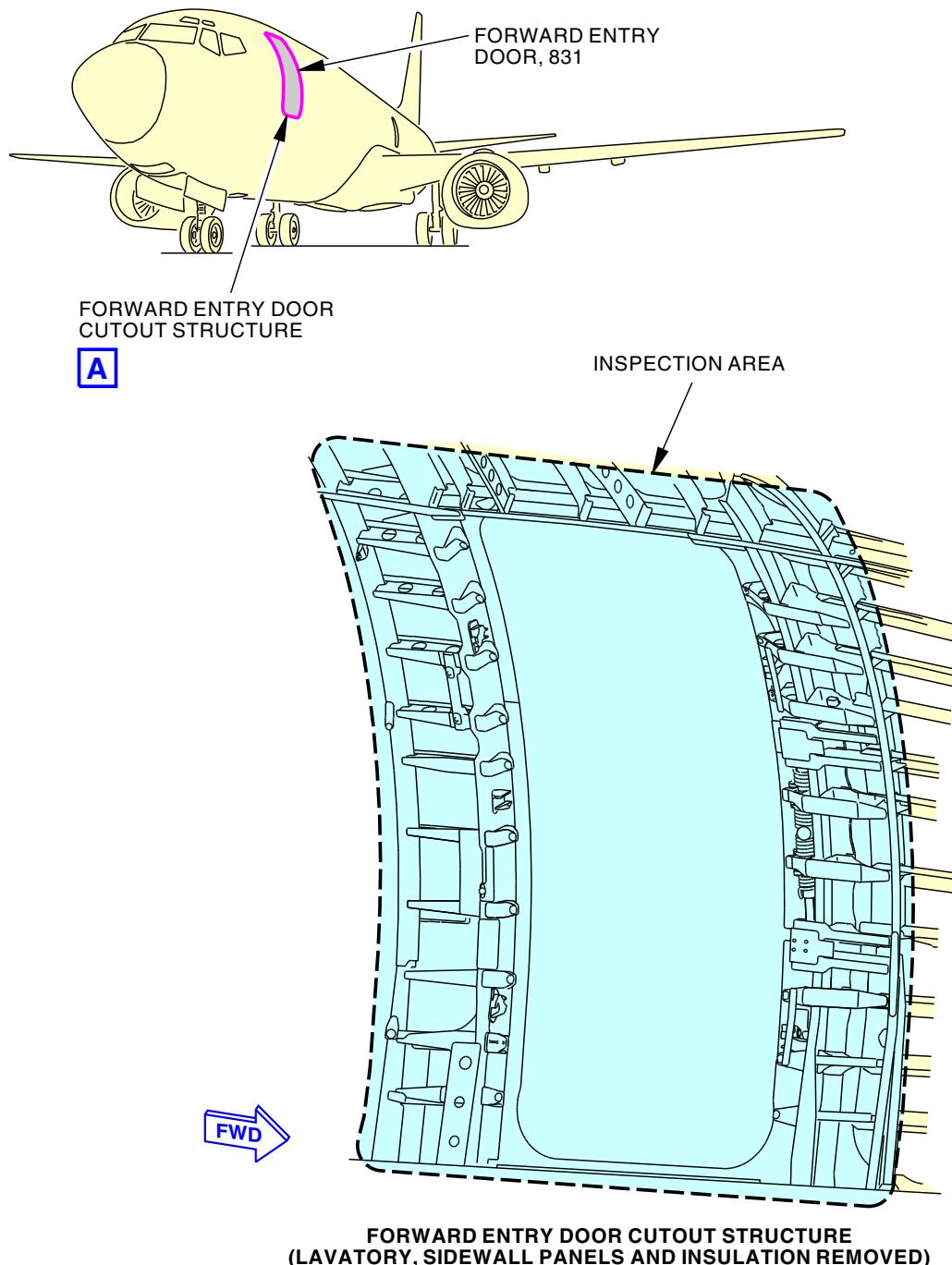
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-360-00

A

484830 S0000144947\_V2

**Forward Entry Door Cutout Surround Structure (Lavatory, Sidewall Panels And Insulation Removed)**  
Figure 244/53-05-03-990-816

EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.34  
Feb 15/2025



737-600/700/800/900  
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**TASK 53-05-03-211-810**

**40. INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS**

Figure 245

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
222AR	Forward Galley Service Door Hinge and Torque Tube Access Panel
S2001	Passenger Compartment Door Cutouts Inspection

**C. Inspection**

SUBTASK 53-05-03-010-064

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
222AR	Forward Galley Service Door Hinge and Torque Tube Access Panel

Special Access:

<b>Number</b>	<b>Name/Location</b>
S2001	Passenger Compartment Door Cutouts Inspection

NOTE: Remove galleys/lav's. Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-010

- (2) Do a Detailed inspection of the forward galley door cutout surround structure (the door cutout to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-044

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

SUBTASK 53-05-03-410-064

- (4) Close this access panel:

<b>Number</b>	<b>Name/Location</b>
222AR	Forward Galley Service Door Hinge and Torque Tube Access Panel

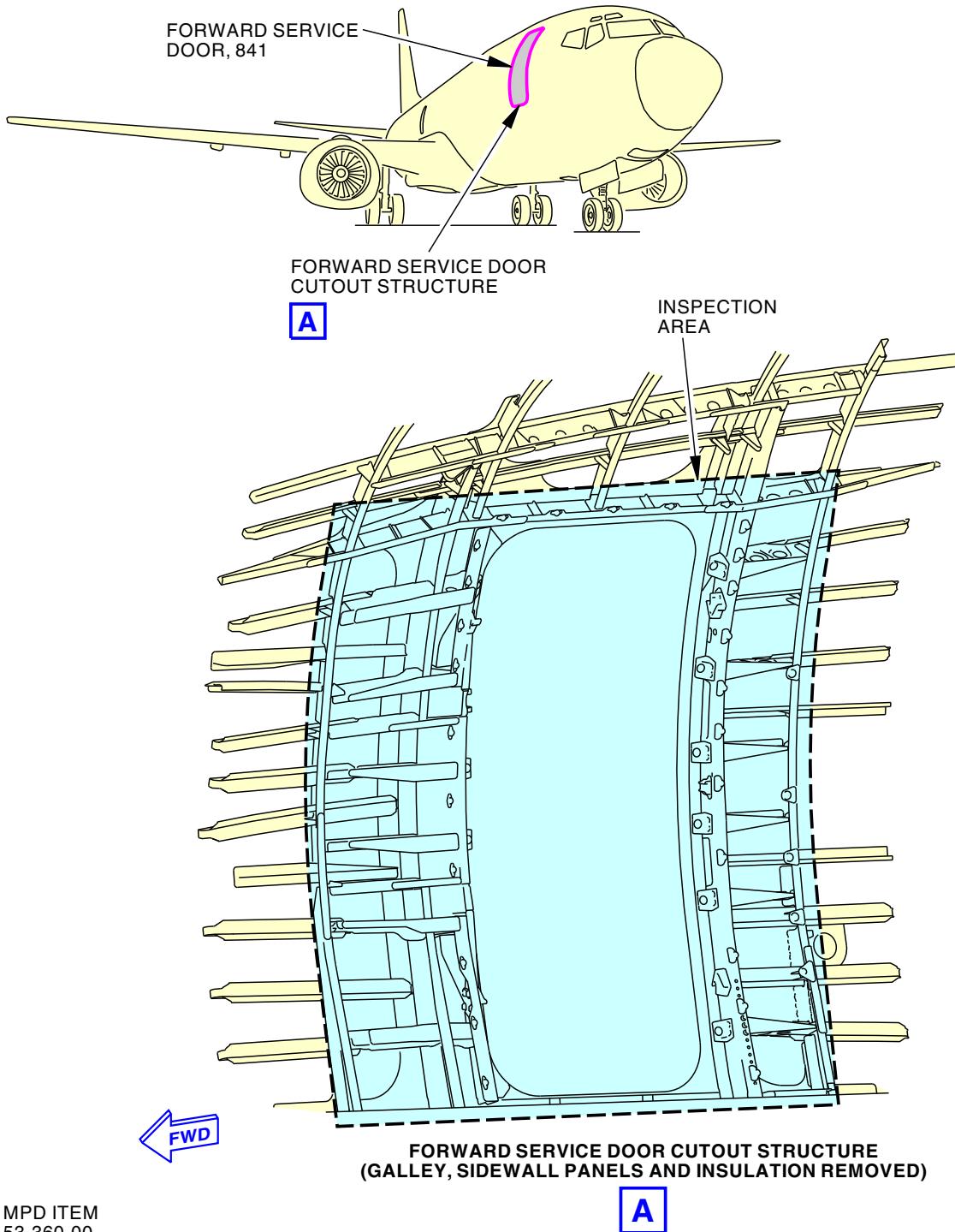
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**

 BOEING

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AIRCRAFT MAINTENANCE MANUAL



484862 S0000143855\_V2

**Forward Galley Service Door Cutout Surround Structure (Galley, Sidewall Panels and Insulation Removed)**  
**Figure 245/53-05-03-990-813**

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.36  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-211-811**

**41. INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS**

(Figure 246)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
S2001	Passenger Compartment Door Cutouts Inspection

**C. Inspection**

SUBTASK 53-05-03-010-065

- (1) Special Access:

<b>Number</b>	<b>Name/Location</b>
S2001	Passenger Compartment Door Cutouts Inspection

NOTE: Remove galleys/lavs. Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-011

- (2) Do a Detailed inspection of the aft entry door cutout surround structure (the door cutout to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-045

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

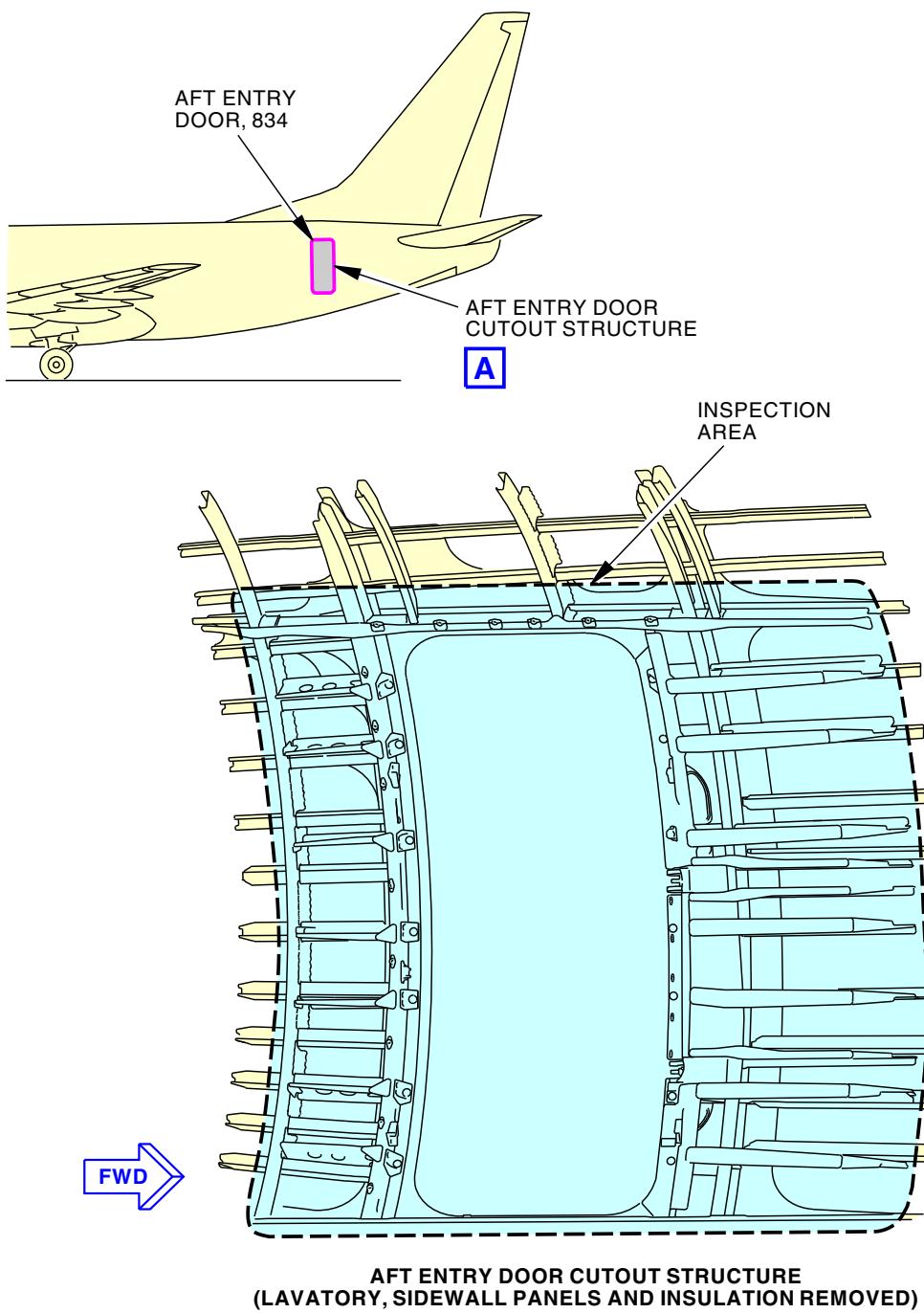
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-360-00

485858 S0000145331\_V2

**Passenger Compartment Door Cutouts**  
Figure 246/53-05-03-990-817

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.38  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-211-812**

**42. INTERNAL - DETAILED: PASSENGER COMPARTMENT DOOR CUTOUTS**

(Figure 247)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
S2001	Passenger Compartment Door Cutouts Inspection

**C. Inspection**

SUBTASK 53-05-03-010-066

- (1) Special Access:

<b>Number</b>	<b>Name/Location</b>
S2001	Passenger Compartment Door Cutouts Inspection

NOTE: Remove galleys/lavs. Remove cabin interior as required. Remove/displace insulation blankets as required.

SUBTASK 53-05-03-211-012

- (2) Do a Detailed inspection of the aft galley door cutout surround structure (the door cutout to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-046

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

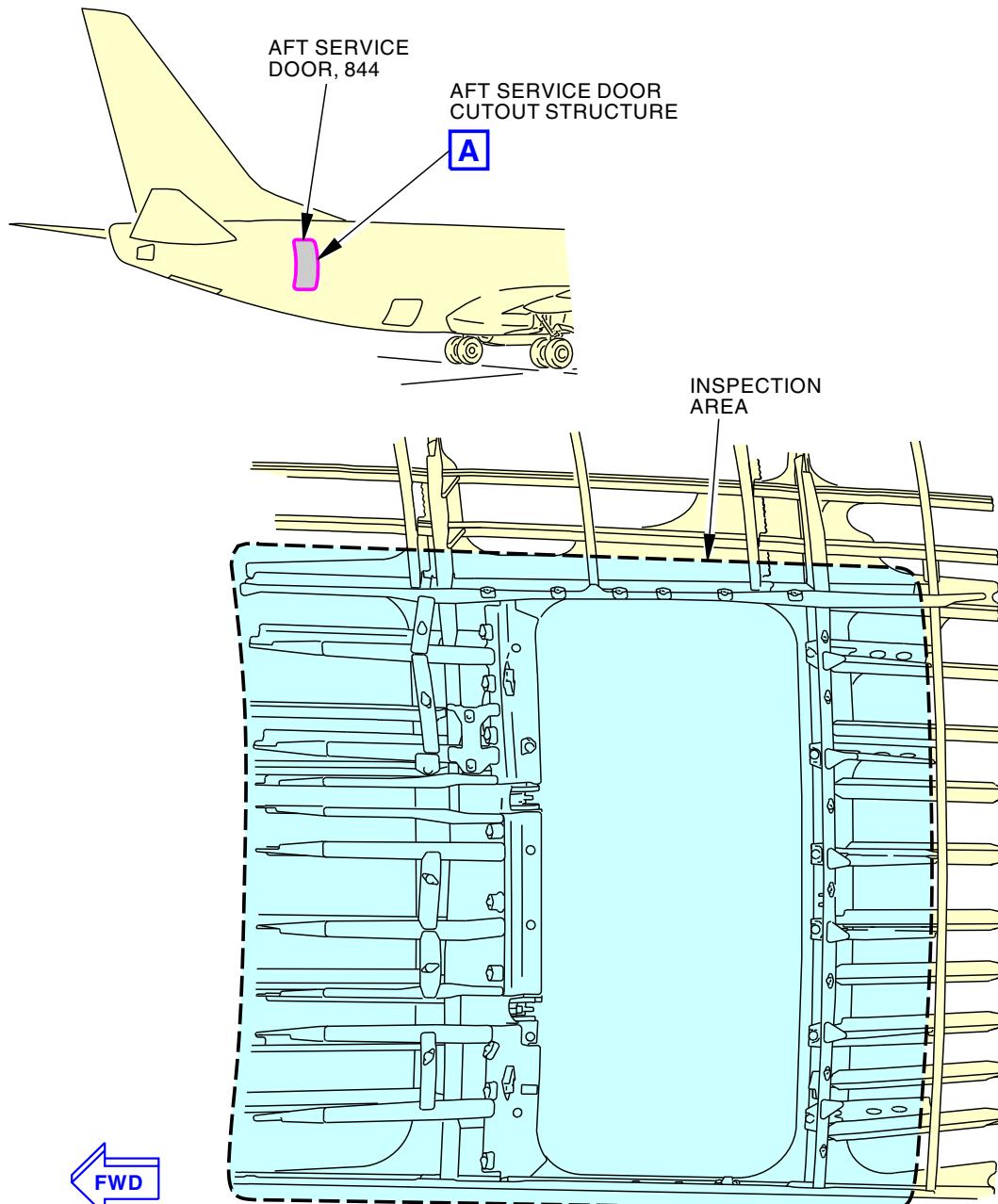
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



AFT SERVICE DOOR CUTOUT STRUCTURE  
(GALLEY, SIDEWALL PANELS AND INSULATION REMOVED)

MPD ITEM  
53-360-00

A

485895 S0000145333\_V2

**Passenger Compartment Door Cutouts**  
Figure 247/53-05-03-990-818

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.40  
Feb 15/2025



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**LOM ALL; AIRPLANES WITH A CURVED AFT PRESSURE BULKHEAD**

**TASK 53-05-03-210-833**

- 43. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - DRY AREA**  
(Figure 248)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right
231	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
S2002	Passenger Compartment Floor Structure - Dry Area Inspection

**C. Inspection**

**SUBTASK 53-05-03-010-030**

- (1) Special Access:

<b>Number</b>	<b>Name/Location</b>
S2002	Passenger Compartment Floor Structure - Dry Area Inspection

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

**SUBTASK 53-05-03-210-033**

- (2) Do a General Visual inspection of the passenger compartment floor structure in dry area (away from doors, galleys and lavs). Exclude floor structure from Sta 540 to 727.

**SUBTASK 53-05-03-910-047**

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

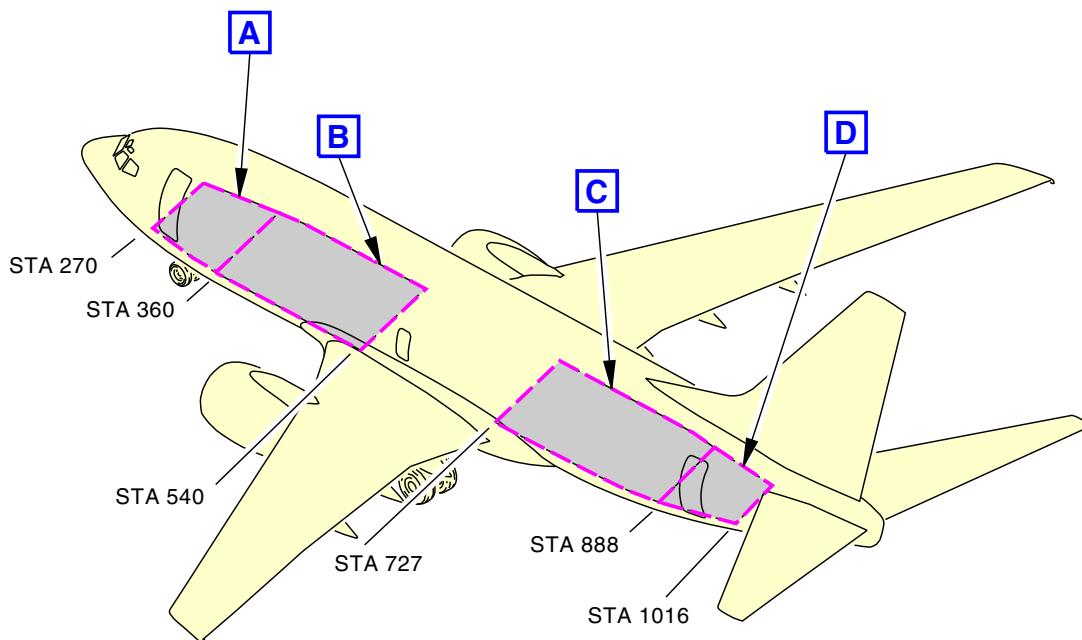
———— END OF TASK ————

EFFECTIVITY  
**LOM ALL**

**53-05-03**



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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-370-00

2099246 S0000444460\_V2

**INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE-DRY AREA**  
**Figure 248/53-05-03-990-861 (Sheet 1 of 5)**

EFFECTIVITY  
LOM ALL; AIRPLANES WITH A CURVED AFT  
PRESSURE BULKHEAD

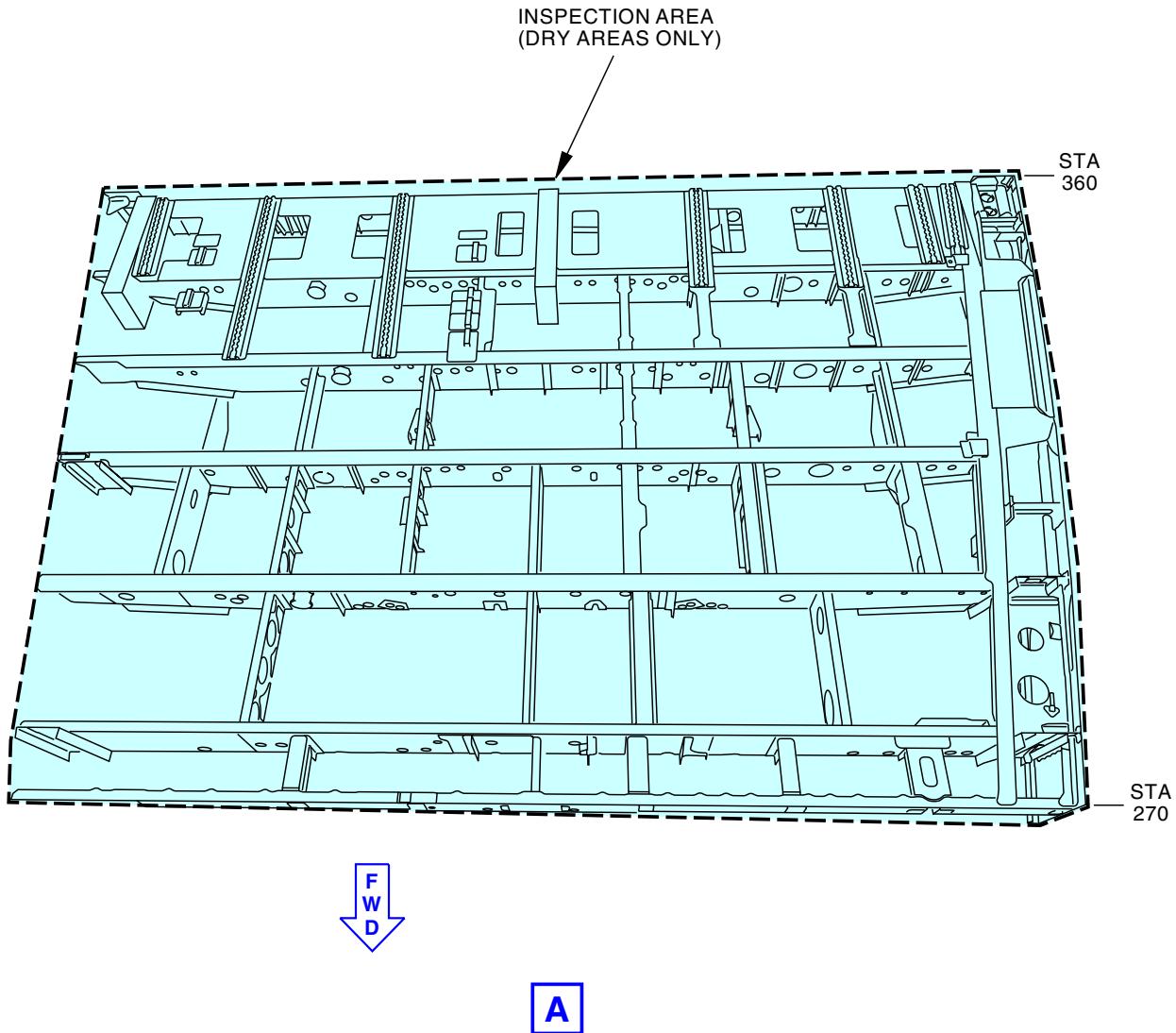
D633A101-LOM

**53-05-03**

Page 298.42  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-370-00

2099970 S0000444461\_V3

**INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE-DRY AREA**  
**Figure 248/53-05-03-990-861 (Sheet 2 of 5)**

EFFECTIVITY  
LOM ALL; AIRPLANES WITH A CURVED AFT  
PRESSURE BULKHEAD

**53-05-03**

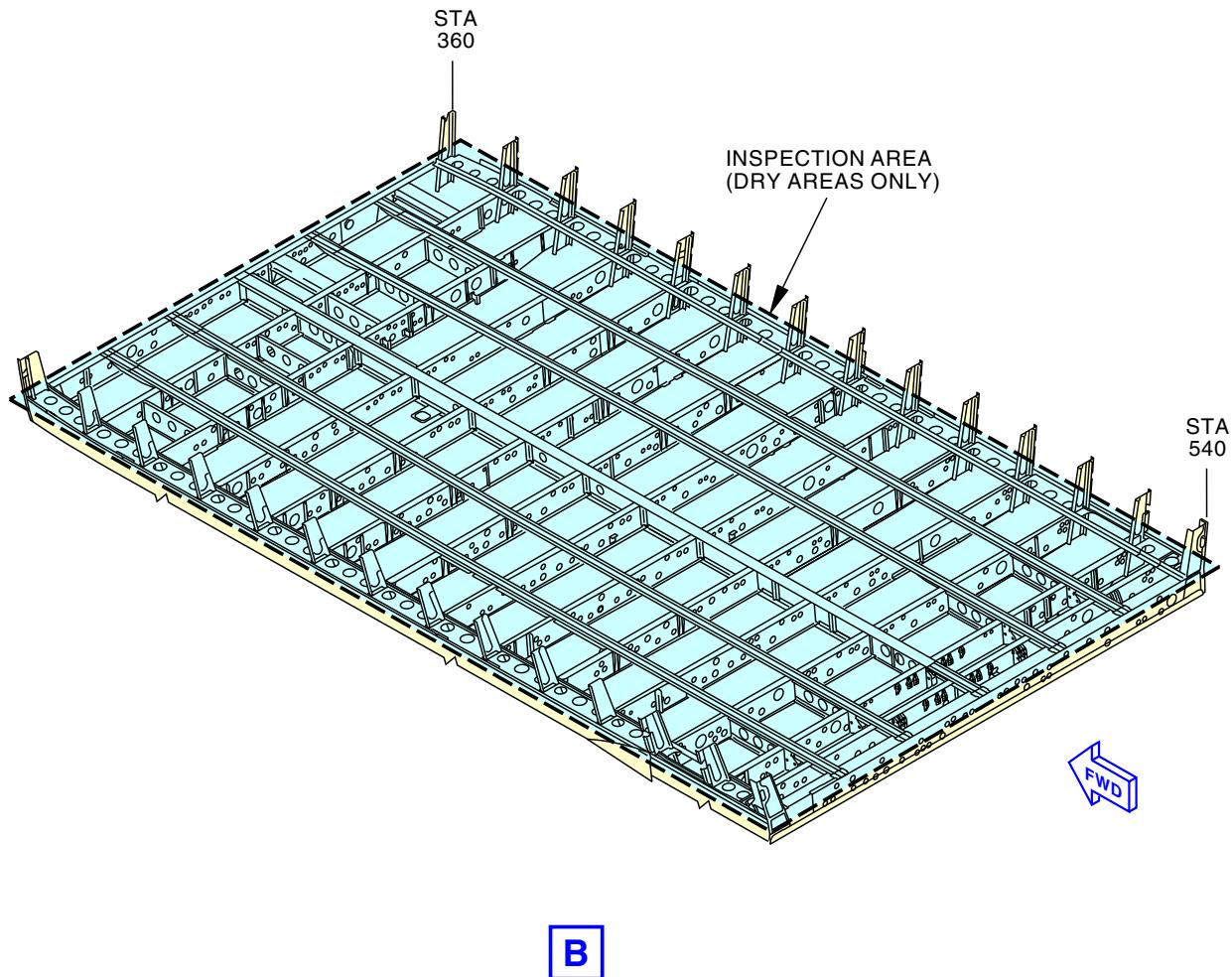
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.43  
Feb 15/2025



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MPD ITEM  
53-370-00

2102696 S0000444462\_V3

**INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE-DRY AREA**  
**Figure 248/53-05-03-990-861 (Sheet 3 of 5)**

EFFECTIVITY  
LOM ALL; AIRPLANES WITH A CURVED AFT  
PRESSURE BULKHEAD

D633A101-LOM

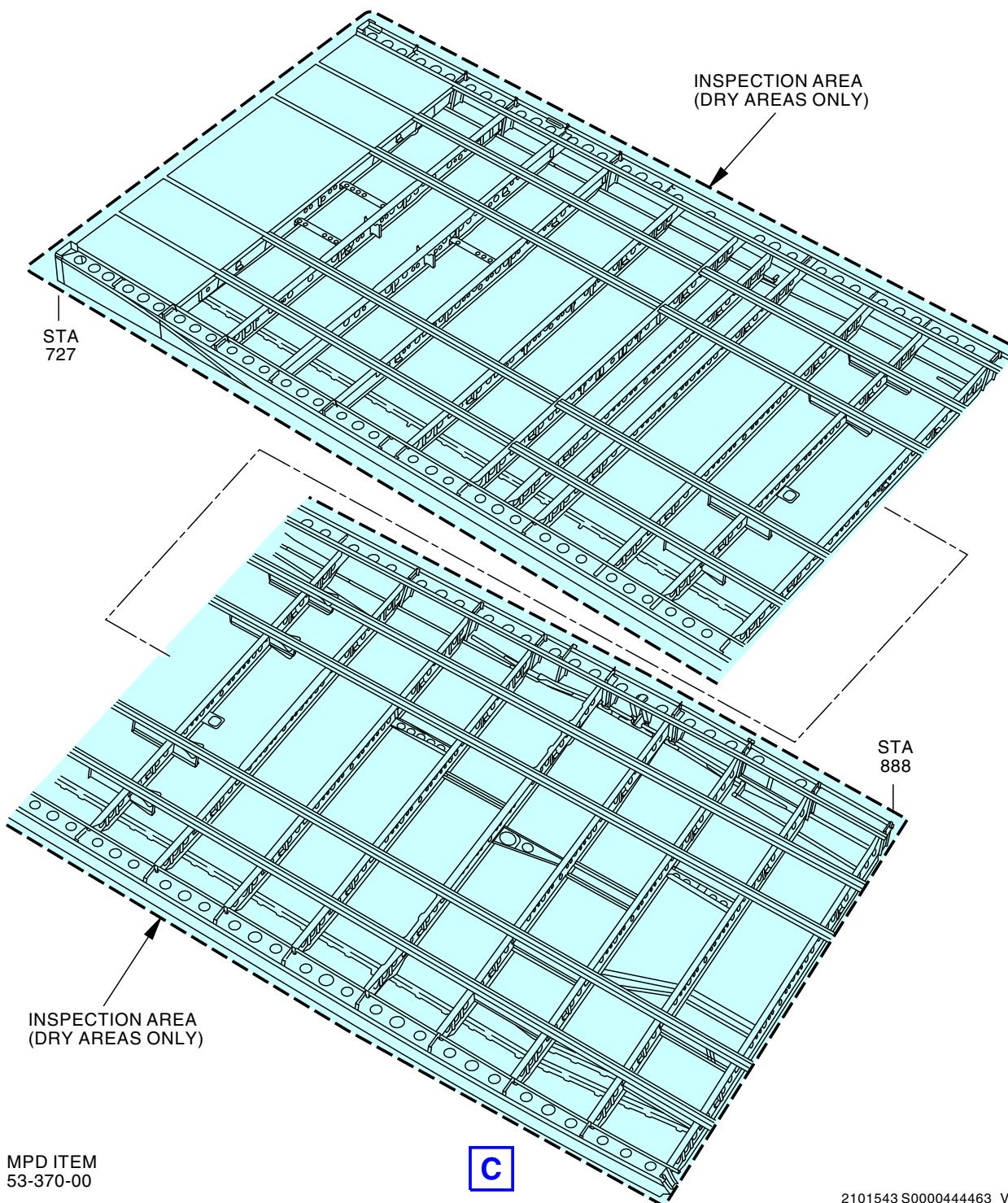
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.44  
Feb 15/2025



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AIRCRAFT MAINTENANCE MANUAL



**INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE-DRY AREA**  
Figure 248/53-05-03-990-861 (Sheet 4 of 5)

EFFECTIVITY  
LOM ALL; AIRPLANES WITH A CURVED AFT  
PRESSURE BULKHEAD

**53-05-03**

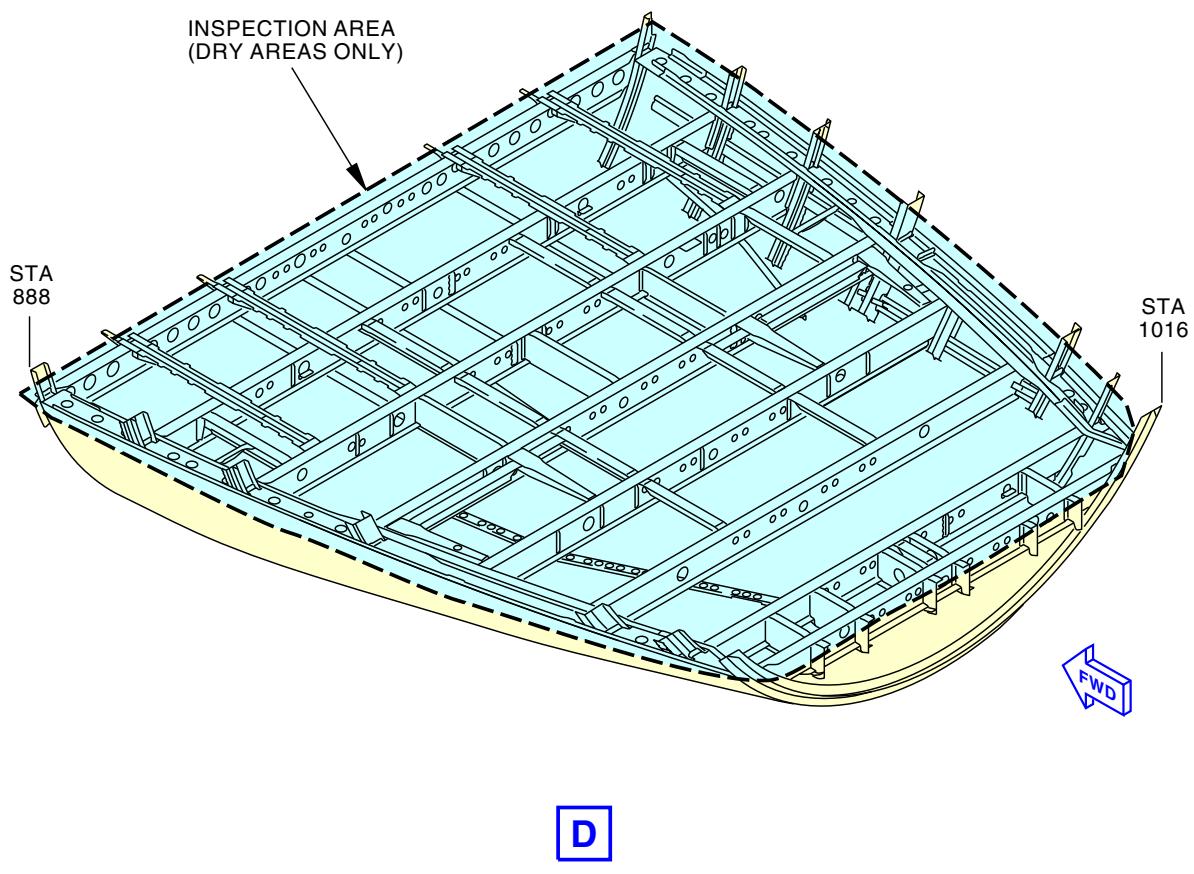
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.45  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-370-00

2102072 S0000444464\_V3

**INTERNAL-GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE-DRY AREA**  
Figure 248/53-05-03-990-861 (Sheet 5 of 5)

EFFECTIVITY  
LOM ALL; AIRPLANES WITH A CURVED AFT  
PRESSURE BULKHEAD

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.46  
Feb 15/2025



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AIRCRAFT MAINTENANCE MANUAL

LOM ALL; AIRPLANES WITH A CURVED AFT PRESSURE BULKHEAD (Continued)

**TASK 53-05-03-210-834**

**44. INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - WET AREA**  
(Figure 249,Figure 250)

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<b>Reference</b>	<b>Title</b>
51-05-01-210-808	737-6789 Basic Task Description (P/B 201)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right
231	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
S2003	Passenger Compartment Floor Structure - Wet Area Inspection

**D. Inspection**

SUBTASK 53-05-03-010-031

(1) Special Access:

<b>Number</b>	<b>Name/Location</b>
S2003	Passenger Compartment Floor Structure - Wet Area Inspection

NOTE: Remove galleys and lavs. Remove floor panels and sidewalls as required.  
Remove/displace insulation blankets as required.

SUBTASK 53-05-03-210-034

- (2) Do a general visual inspection of the passenger compartment floor structure in wet area (within approximately 20 inches from doors, galleys and lavs, and the floor structure below the door to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-048

- (3) 737-6789 Basic Task Description, TASK 51-05-01-210-808.

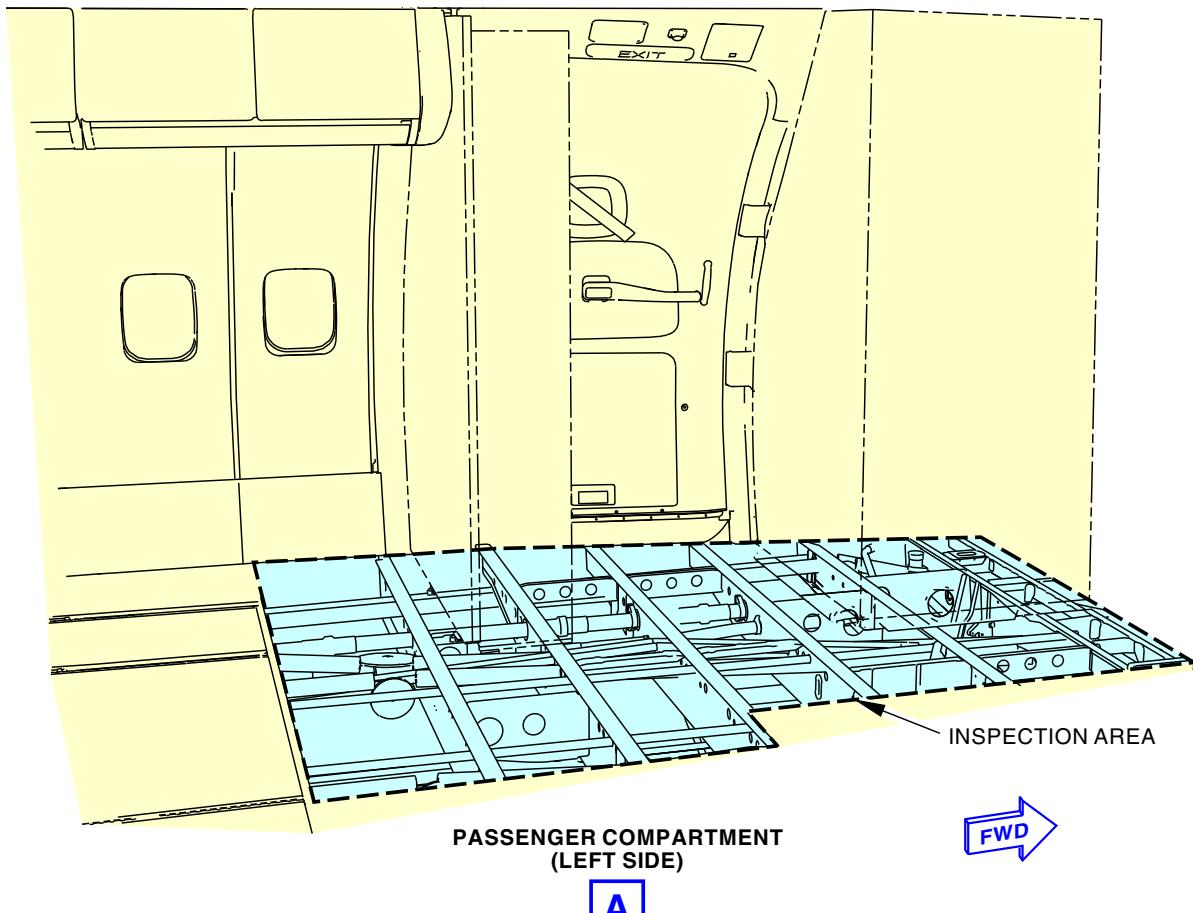
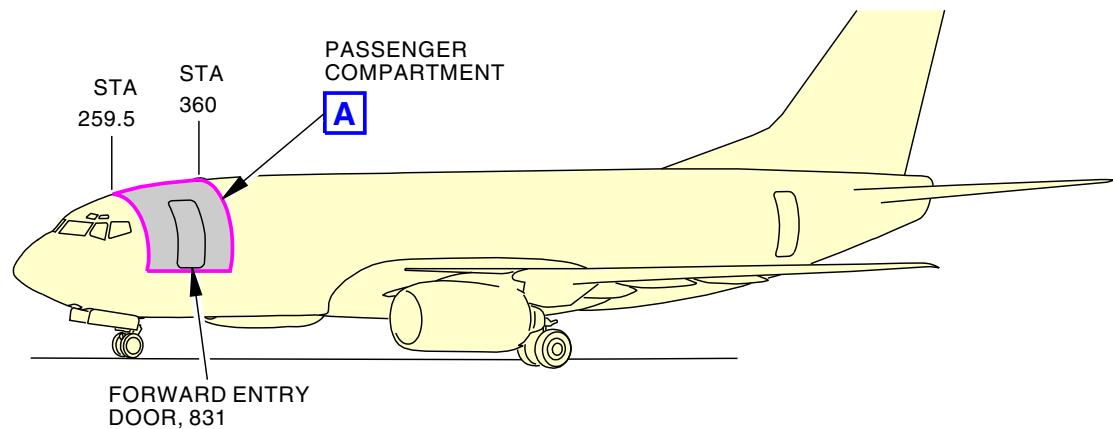
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-380-00

1363524 S0000246348\_V4

Passenger Compartment Structure - Wet Area General Visual (Internal)  
Figure 249/53-05-03-990-871 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL; AIRPLANES WITH A CURVED AFT  
PRESSURE BULKHEAD

**53-05-03**

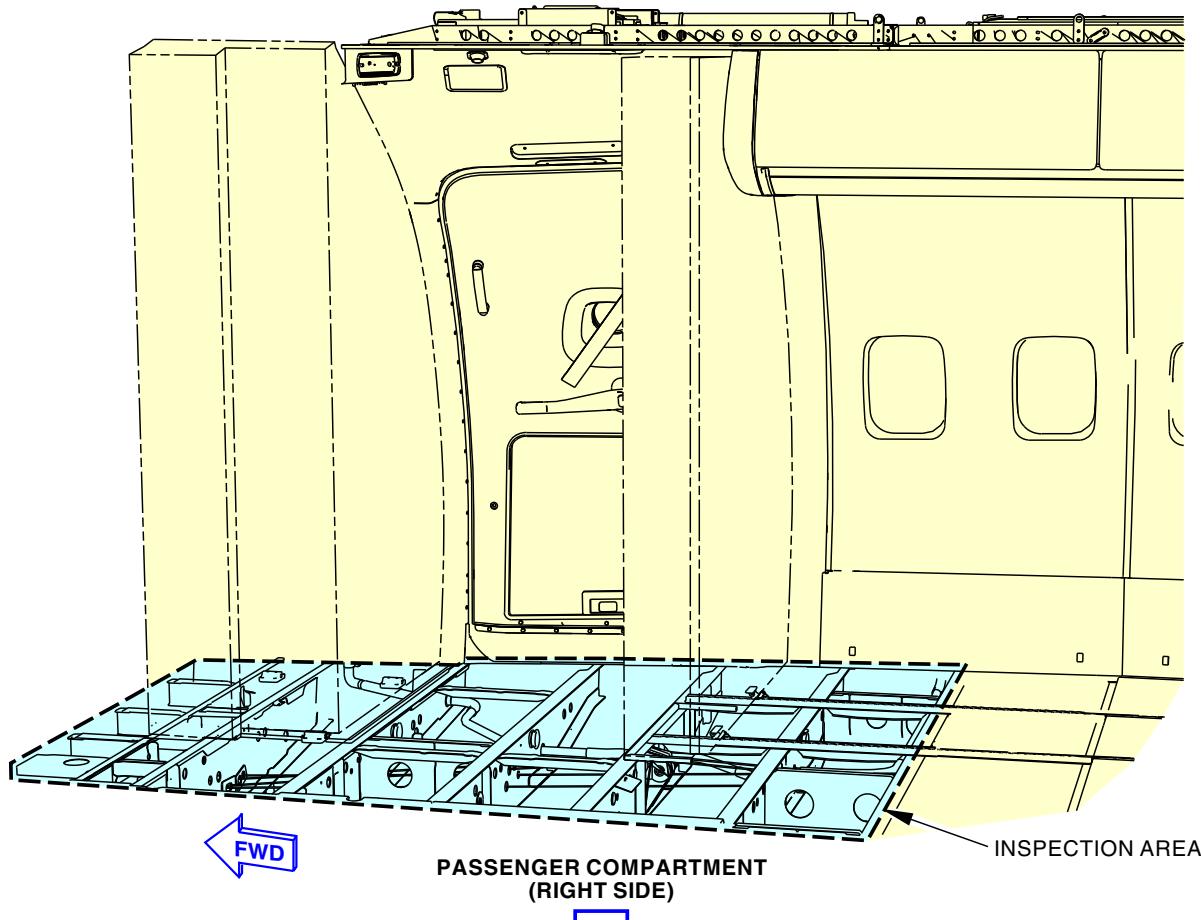
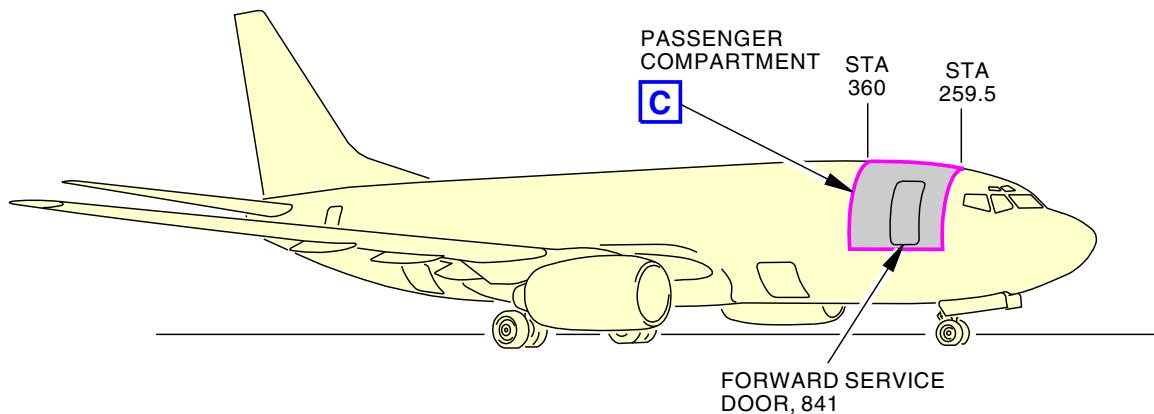
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.48  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-380-00

1363522 S0000246349\_V4

Passenger Compartment Structure - Wet Area General Visual (Internal)  
Figure 249/53-05-03-990-871 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL; AIRPLANES WITH A CURVED AFT  
PRESSURE BULKHEAD

D633A101-LOM

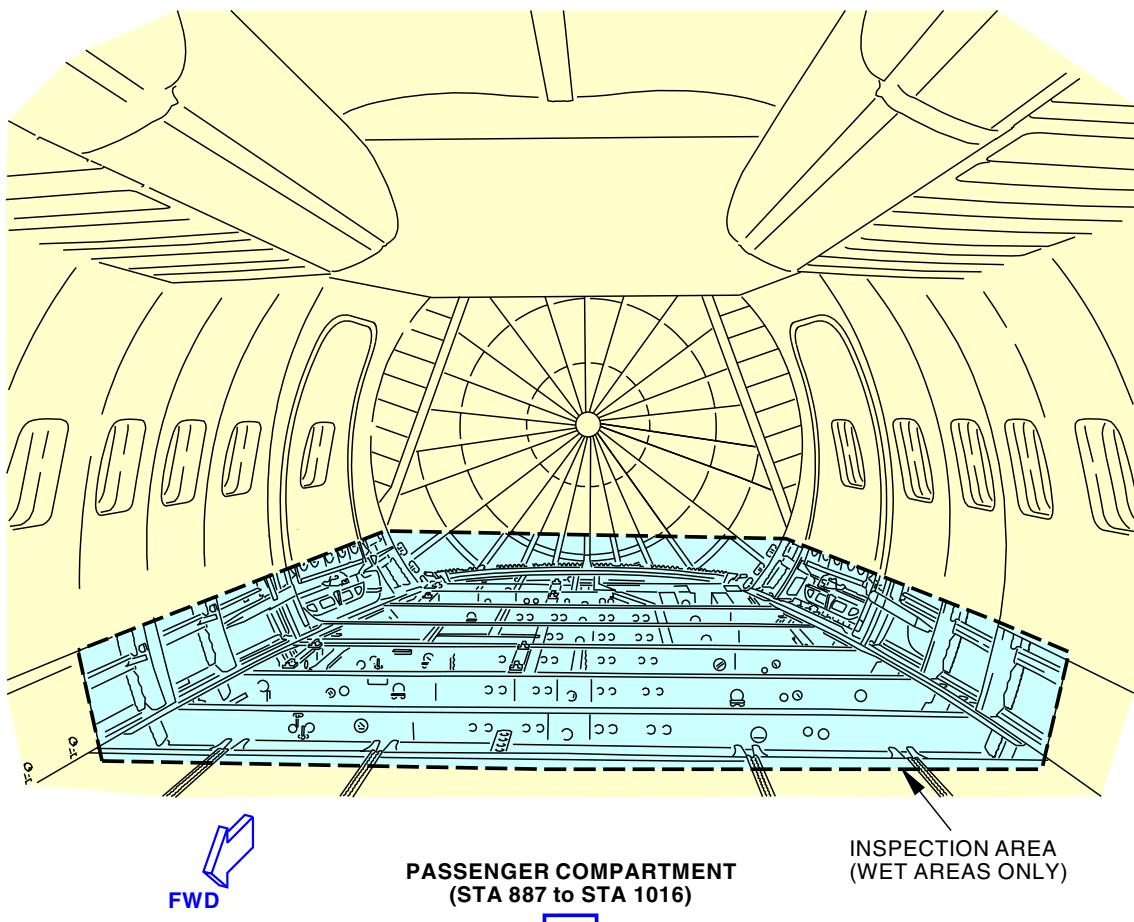
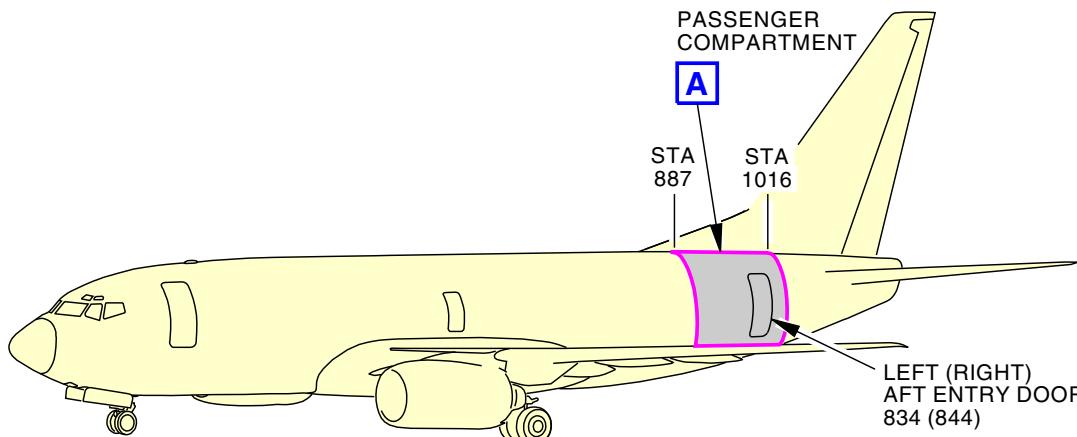
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.49  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-380-00

A

J76715 S0000179157\_V4

Passenger Compartment Structure - Wet Area General Visual (Internal)  
Figure 250/53-05-03-990-872 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL; AIRPLANES WITH A CURVED AFT  
PRESSURE BULKHEAD

D633A101-LOM

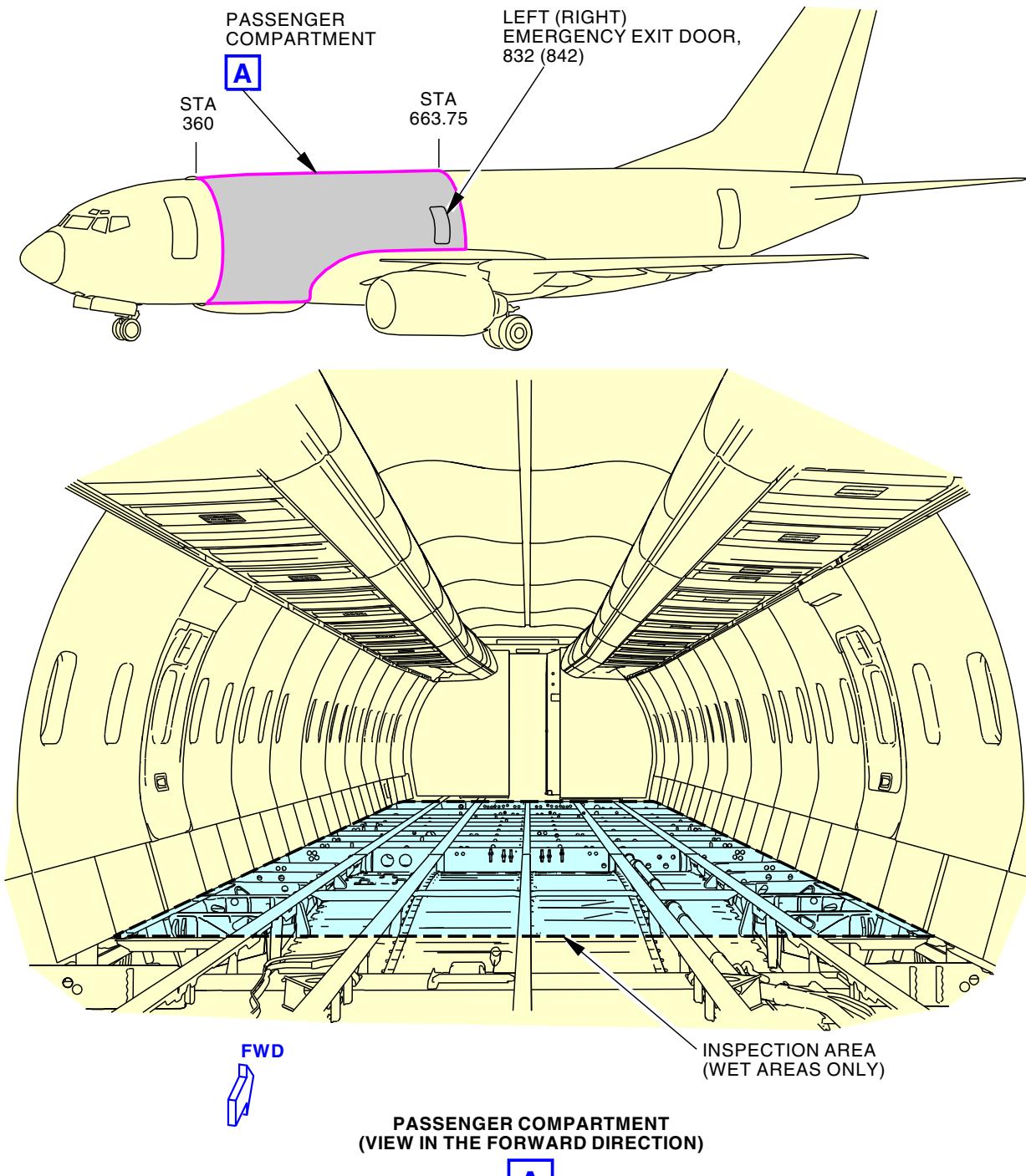
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.50  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-380-00

D37065 S0000154098\_V4

Passenger Compartment Structure - Wet Area General Visual (Internal)  
Figure 250/53-05-03-990-872 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL; AIRPLANES WITH A CURVED AFT  
PRESSURE BULKHEAD

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.51  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

LOM ALL

**TASK 53-05-03-210-835**

45. **INTERNAL - GENERAL VISUAL: PASSENGER COMPARTMENT FLOOR STRUCTURE - WET AREA**  
(Figure 251)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

Zone	Area
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right
231	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to Sta 663.75 - Right
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

**B. Access Panels**

Number	Name/Location
S2004	Passenger Compartment Floor Structure - Wet Area Inspection

**C. Inspection**

SUBTASK 53-05-03-010-032

- (1) Special Access:

**Number      Name/Location**

S2004	Passenger Compartment Floor Structure - Wet Area Inspection
-------	---

NOTE: Galleys and lavs removal is not required. Remove galley kick-plates and any other easily removable panels that may help inspect areas under galleys and lavs.

SUBTASK 53-05-03-210-035

- (2) Do a General Visual inspection of the galley and lav attach fittings and any other easily visible portions of the floor structure in wet area (within approximately 20 inches from galleys and lavs, and the floor structure below the door to, and including, the door side of the first frame from the door in both the forward and aft directions).

SUBTASK 53-05-03-910-049

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-804.

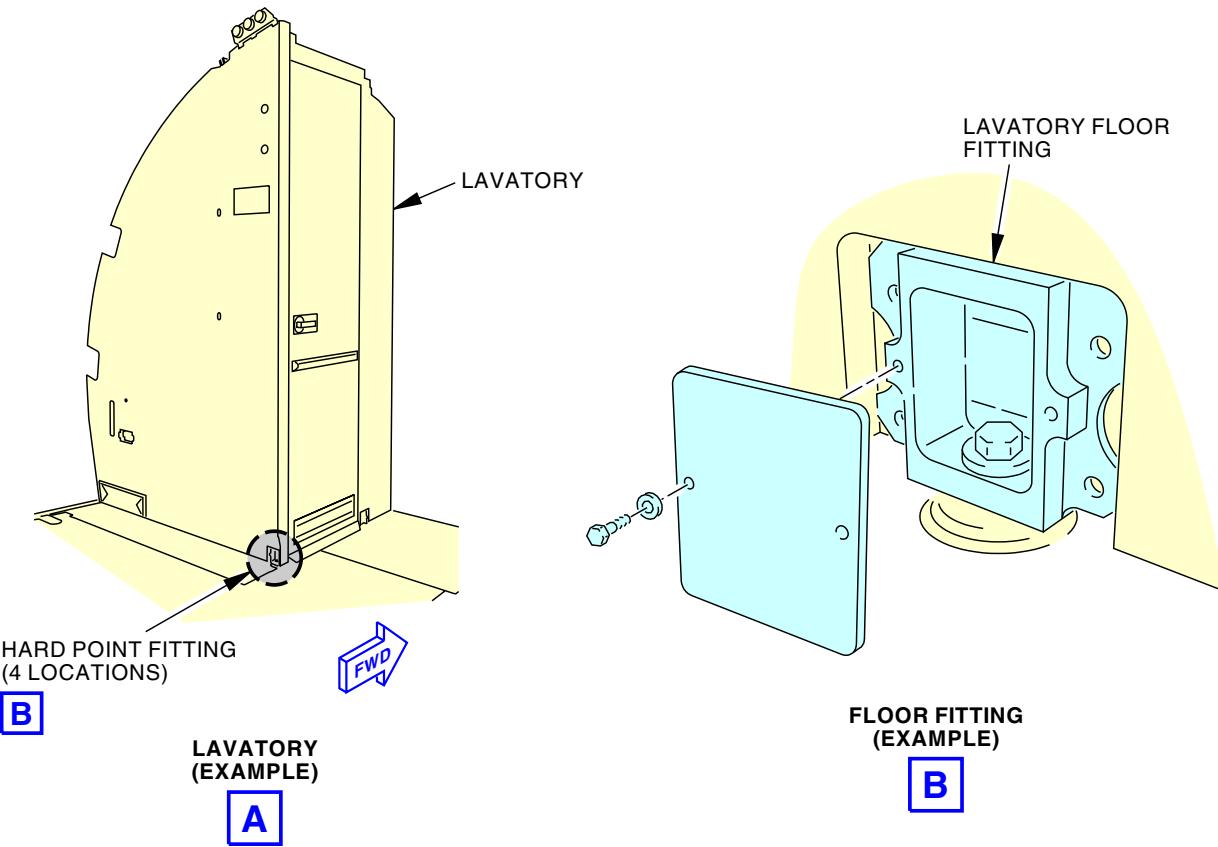
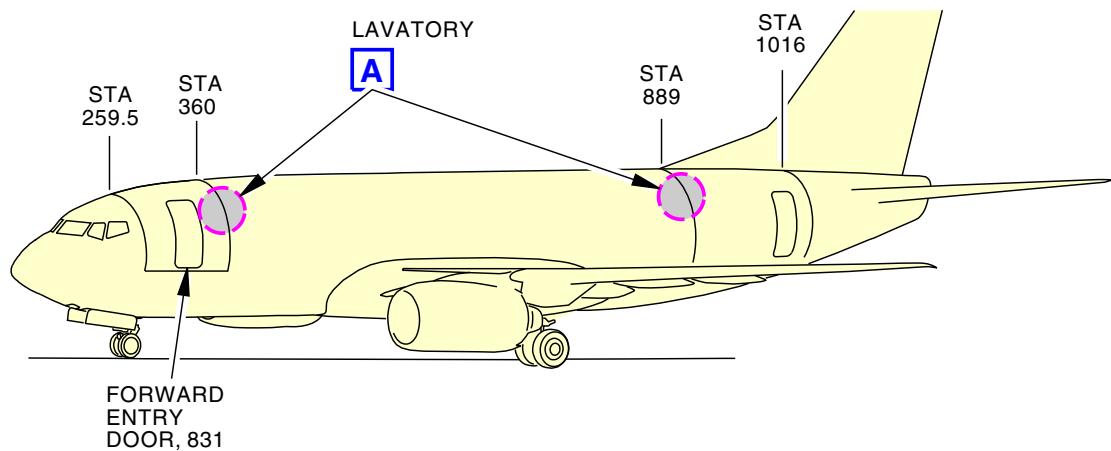
———— END OF TASK ————



**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-390-00

2341697 S0000533813\_V2

Passenger Compartment Floor Structure - Wet Area  
Figure 251/53-05-03-990-822 (Sheet 1 of 3)

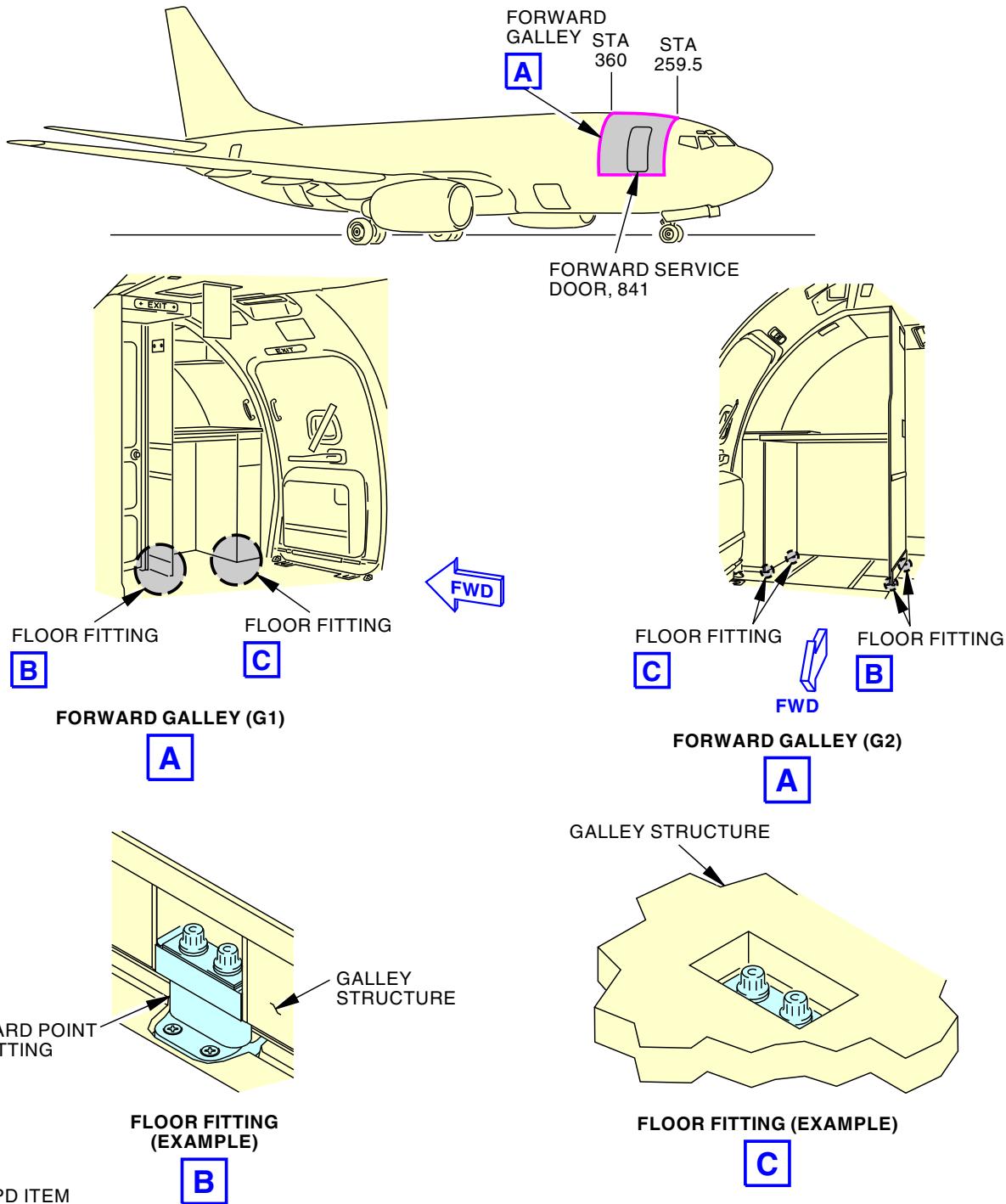
EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.53  
Feb 15/2025

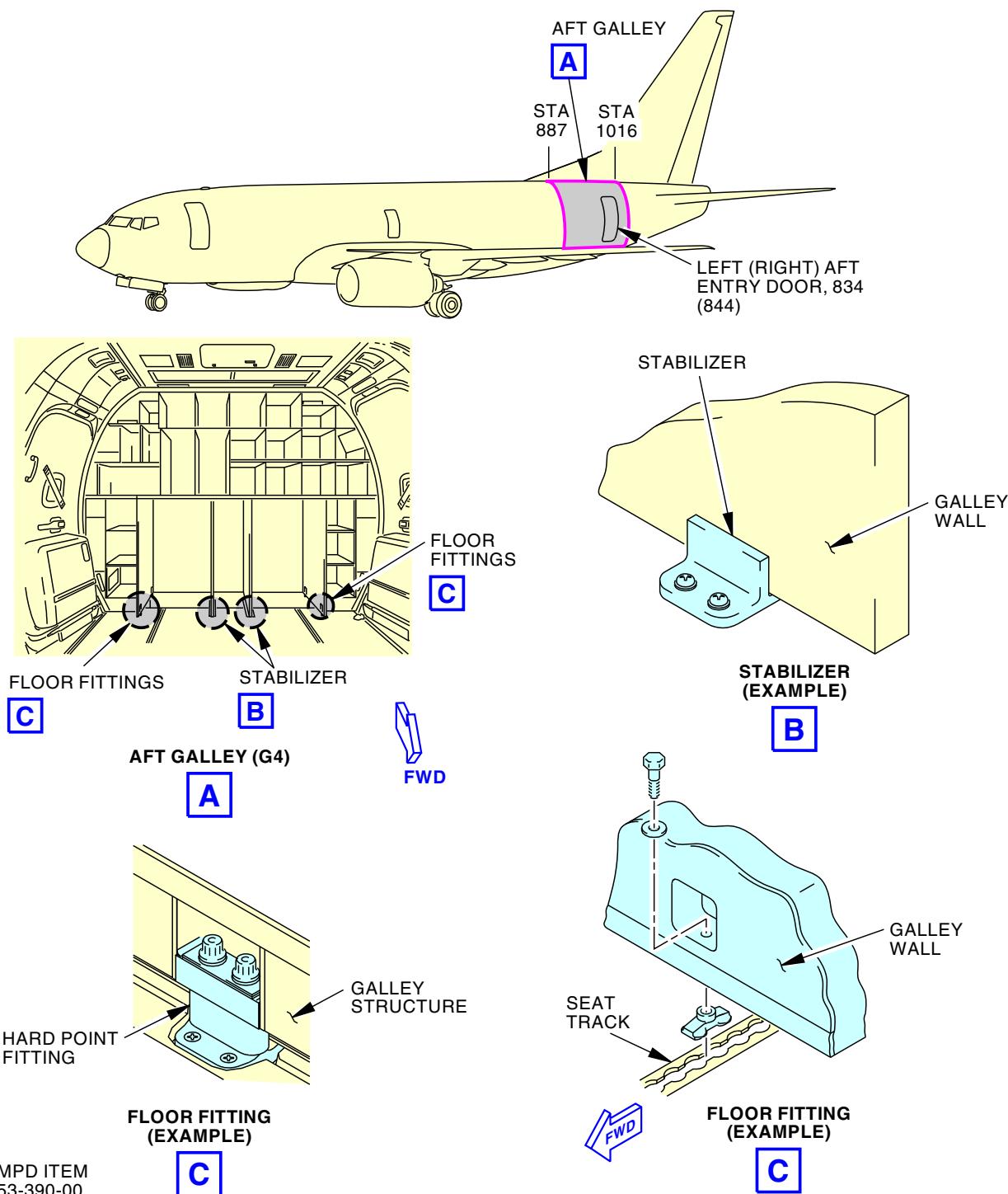
**737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL**

MPD ITEM  
53-390-00

2341761 S0000533816\_V2

**Passenger Compartment Floor Structure - Wet Area  
Figure 251/53-05-03-990-822 (Sheet 2 of 3)**

EFFECTIVITY  
LOM ALL

**53-05-03**



2341784 S0000533818\_V2

**Passenger Compartment Floor Structure - Wet Area**  
**Figure 251/53-05-03-990-822 (Sheet 3 of 3)**

EFFECTIVITY  
 LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-836**

- 46. INTERNAL - GENERAL VISUAL: FORWARD PASSENGER COMPARTMENT, STA 360 to 663.75**  
(Figure 252)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
833	Emergency Exit
843	Emergency Exit
S2301	Forward Passenger Compartment STA 360 to 663.75

**C. Inspection**

**SUBTASK 53-05-03-010-033**

- (1) Open these access panels:

<b>Number</b>	<b>Name/Location</b>
833	Emergency Exit
843	Emergency Exit

Special Access:

<b>Number</b>	<b>Name/Location</b>
S2301	Forward Passenger Compartment STA 360 to 663.75

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

**SUBTASK 53-05-03-210-036**

- (2) Do a General Visual inspection of the passenger compartment from STA 360 to 663.75, including:

1. Skin panels (skins, frames and stringers), longitudinal lap splices, (note: inspection includes the longitudinal lap splice at S-7L, and S-14L for the -800BCF), circumferential skin and stringer splices (note: inspection includes the circumferential splice at STA 500H for the -800BCF).
2. Window belt structure.
3. Overwing emergency exit cutout structure.
4. Forward cargo door cutout surround structure (portion in upper lobe).
5. STA 540 and 663 bulkheads and splices.
6. Overwing frames and stub beams.
7. Inspection area does not include the crown panel (skin, frames, shear ties, and stringers) at STA 360 to STA 500H between S-4R and S-7L for the -800BCF.

**SUBTASK 53-05-03-910-050**

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.



**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-05-03-410-033

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
833	Emergency Exit
843	Emergency Exit

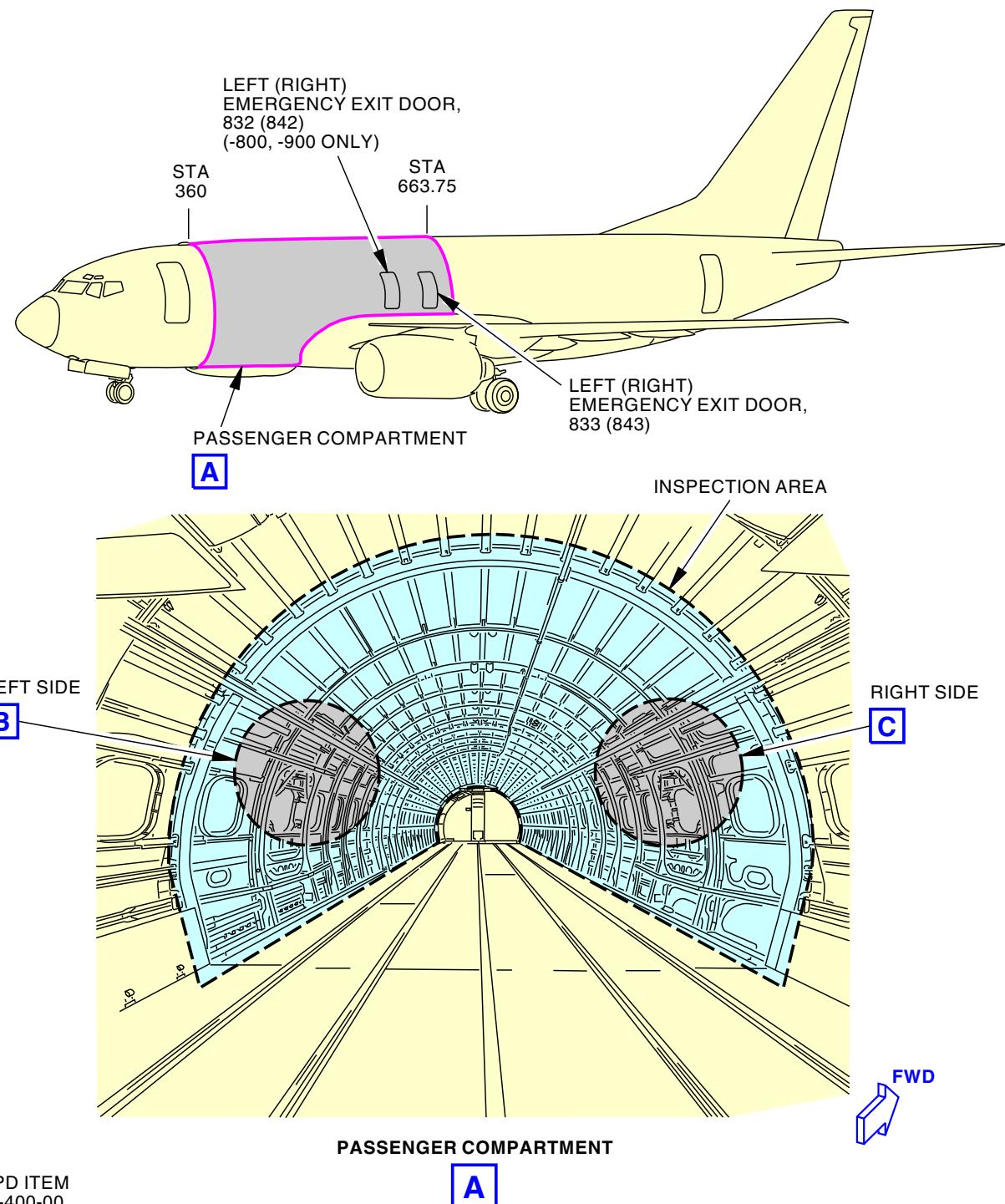
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-400-00

2089687 S0000441136\_V3

INTERNAL-GENERAL VISUAL: FORWARD PASSENGER COMPARTMENT, STA 360 TO STA 663.75  
Figure 252/53-05-03-990-862 (Sheet 1 of 3)

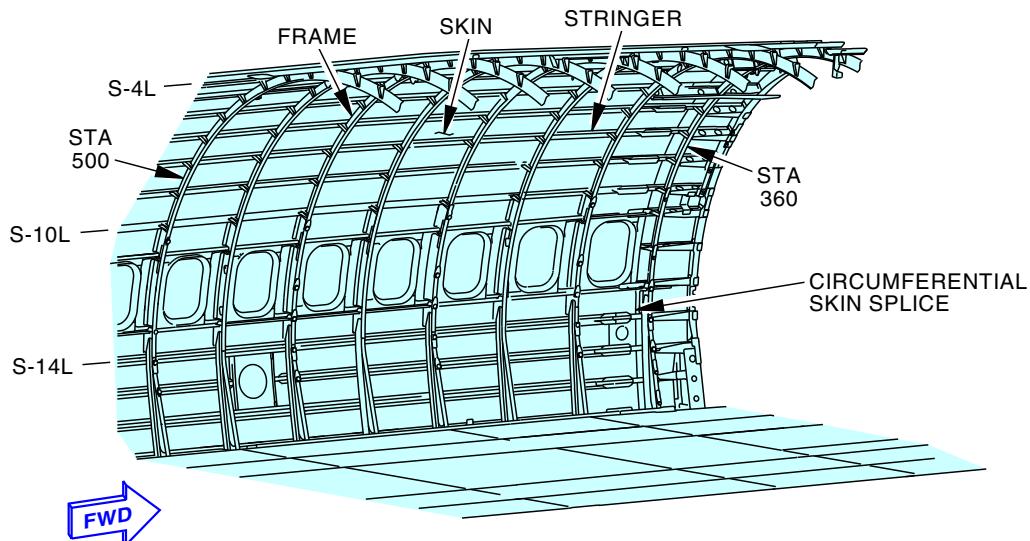
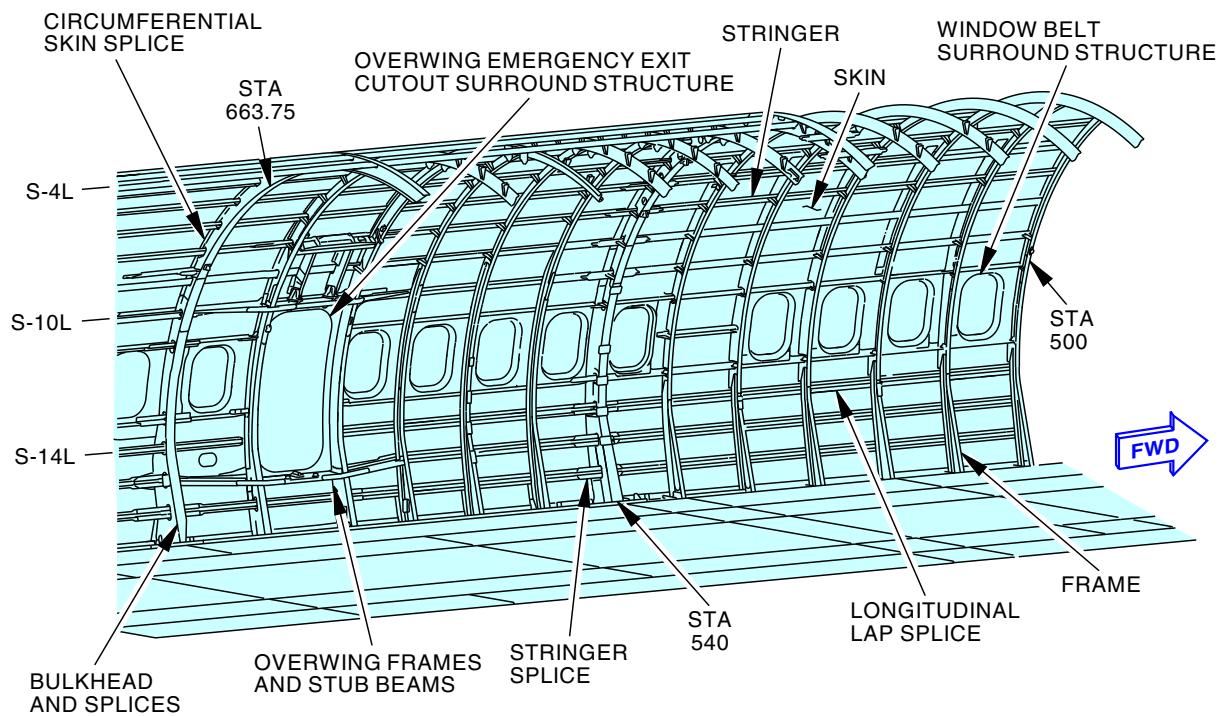
EFFECTIVITY  
LOM ALL

D633A101-LOM

**53-05-03**



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AIRCRAFT MAINTENANCE MANUAL



LEFT SIDE - PASSENGER COMPARTMENT

B

2093204 S0000441137\_V2

INTERNAL-GENERAL VISUAL: FORWARD PASSENGER COMPARTMENT, STA 360 TO STA 663.75  
Figure 252/53-05-03-990-862 (Sheet 2 of 3)

EFFECTIVITY  
LOM ALL

53-05-03

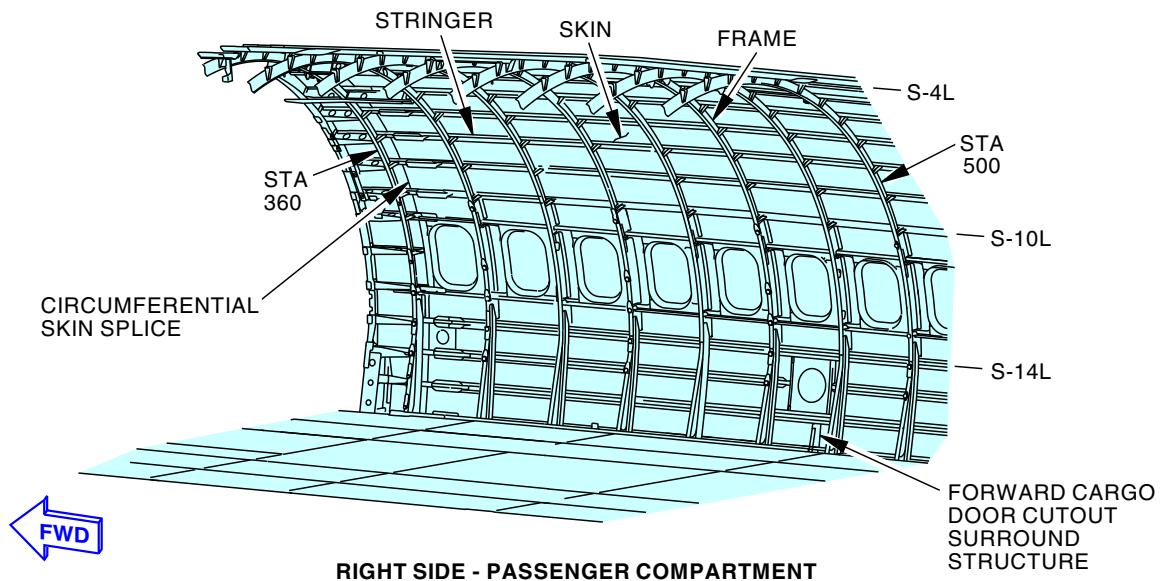
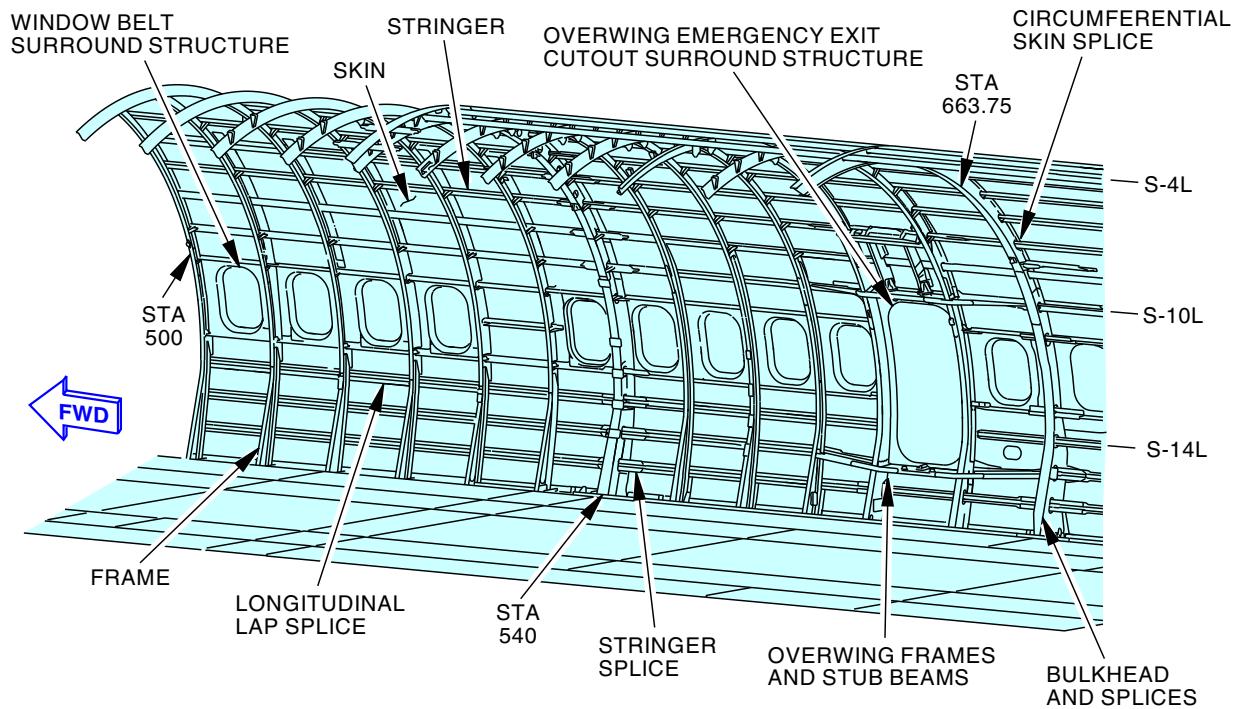
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.59  
Feb 15/2025



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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-400-00

C

2094904 S0000441138\_V2

INTERNAL-GENERAL VISUAL: FORWARD PASSENGER COMPARTMENT, STA 360 TO STA 663.75  
Figure 252/53-05-03-990-862 (Sheet 3 of 3)

EFFECTIVITY  
LOM ALL

**53-05-03**



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AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-837**

47. **INTERNAL - GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 to 1016**  
(Figure 253)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

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

**B. Access Panels**

Number	Name/Location
S2401	AFT Passenger Compartment STA 663.75 to 1016

**C. Inspection**

SUBTASK 53-05-03-010-034

- (1) Special Access:

Number	Name/Location
S2401	AFT Passenger Compartment STA 663.75 to 1016

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

SUBTASK 53-05-03-210-037

- (2) Do a General Visual inspection of the passenger compartment from STA 663.75 to 1016 (except areas around door cutouts), including:

1. Skin panels (skins, frames and stringers), longitudinal lap splices, circumferential skin and stringer splices (note: inspection includes the circumferential skin and stringer splice at Sta 727I for the -900 models).
2. Window belt structure.
3. STA 663 bulkhead and splices.
4. STA 727 bulkhead.
5. Side strut support frame at STA 706.
6. Main landing gear support frames at STA 695 and 716.
7. Wheel well frame at STA 685.
8. Aft cargo door cutout surround structure (portion in upper lobe).
9. Forward side of STA 1016 bulkhead (chords, pressure web, stiffeners, chord/web attachments), including vertical fin front spar fittings.
10. Stringer splice fittings and tension bolts at STA 1016.
11. For the -800BCF, frame reinforcements at STA 727B to STA 867 at S-16 to S-17 (Note: frame reinforcements on LH side only at STA 807 to STA 847), STA 887 frame reinforcements at S-16 to S-17, and frame fitting and rail support at STA 907 between S-15 and S-17.

SUBTASK 53-05-03-910-051

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

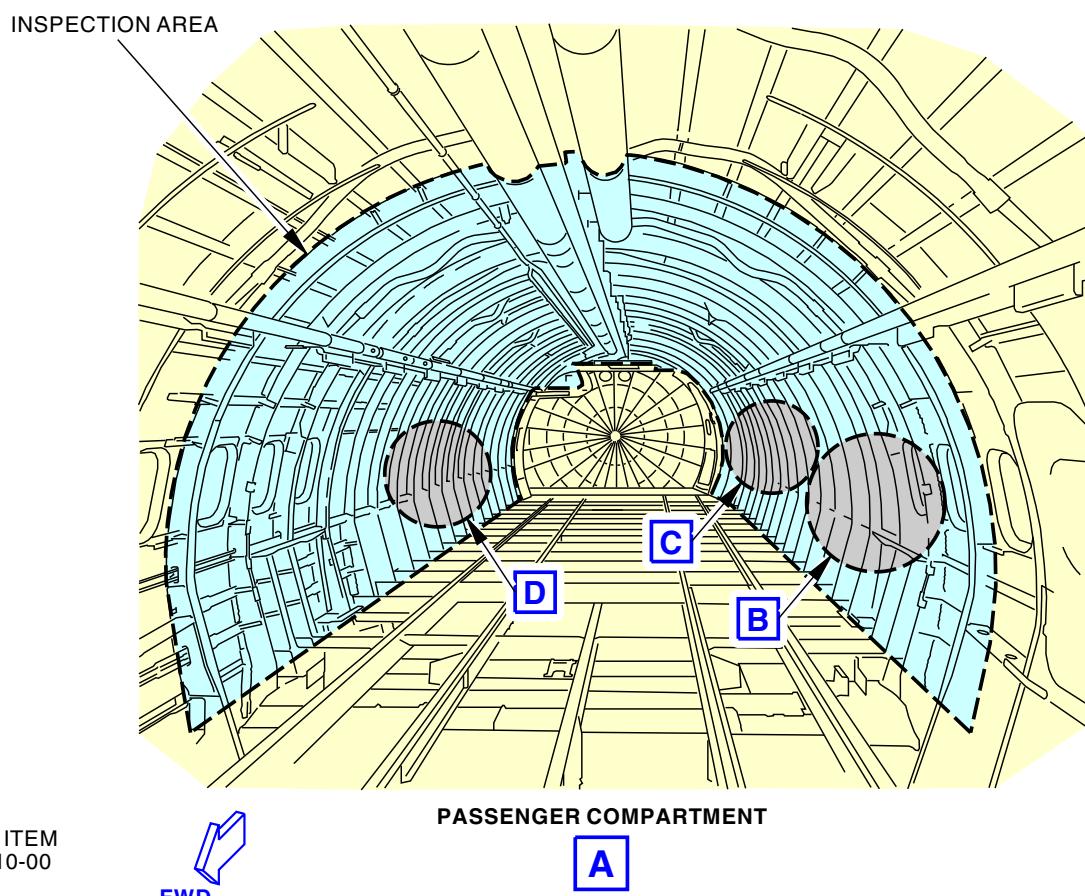
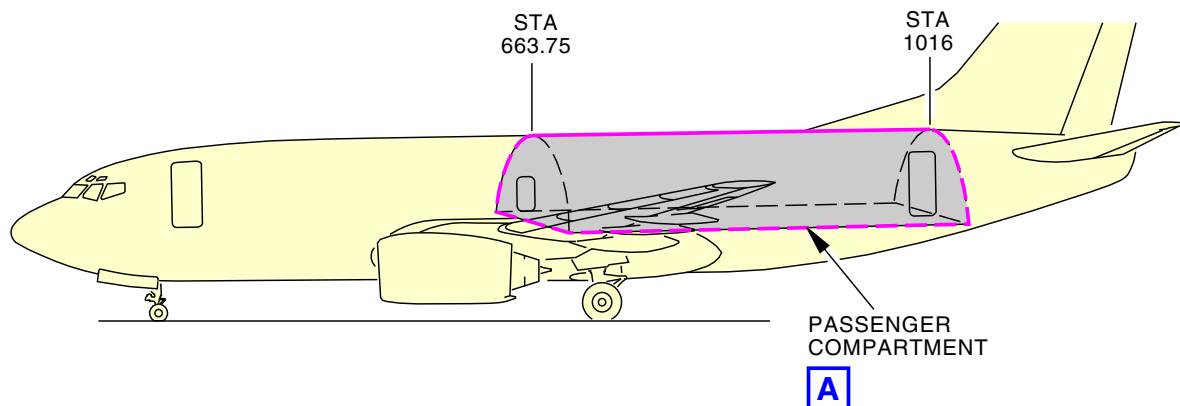
— END OF TASK —

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-410-00

2101150 S0000442502\_V2

INTERNAL-GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 TO STA 1016  
Figure 253/53-05-03-990-863 (Sheet 1 of 4)

EFFECTIVITY  
LOM ALL

D633A101-LOM

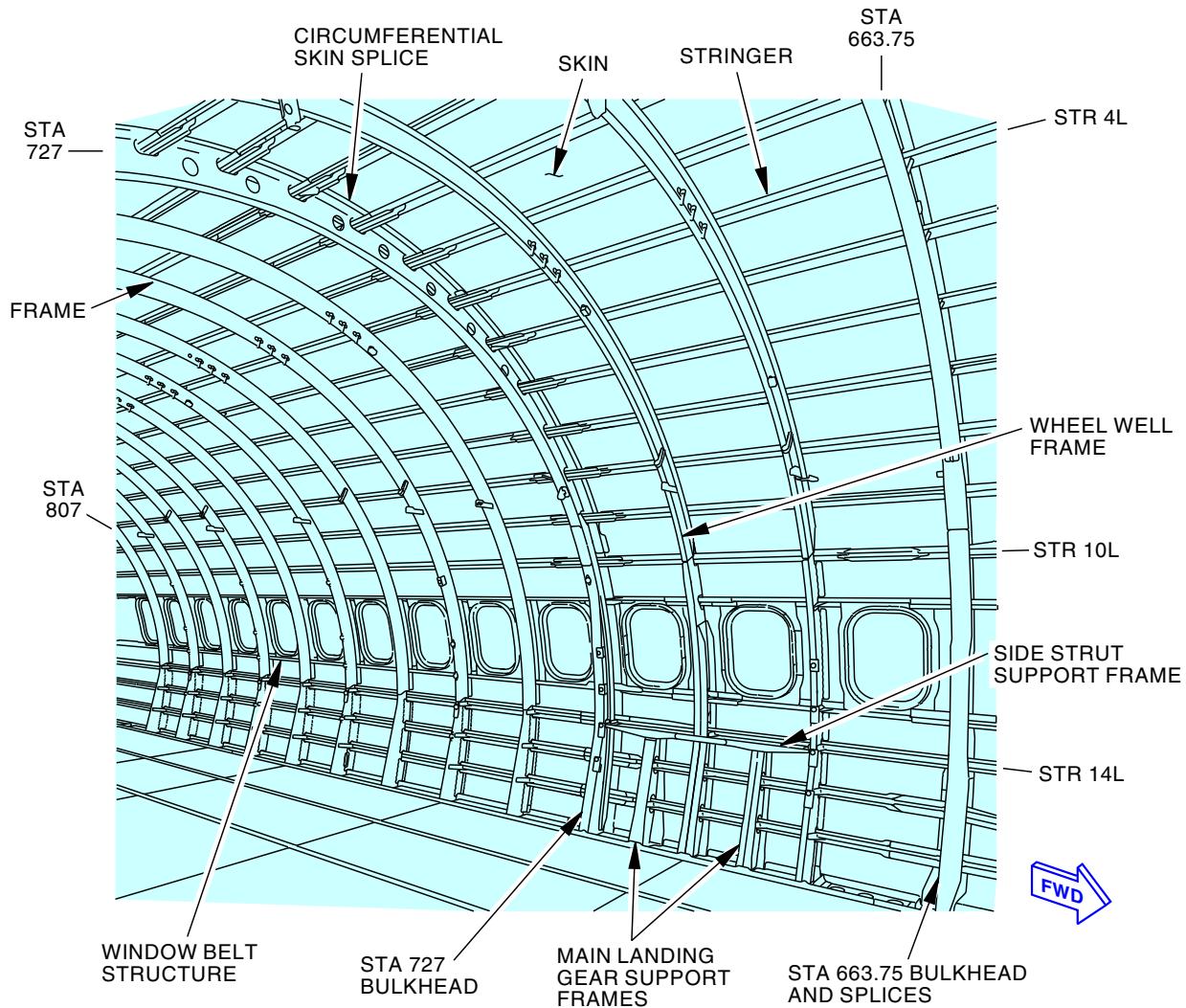
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.62  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



AFT PASSENGER COMPARTMENT  
(STA 663.75 TO 807)  
(LEFT SIDE IS SHOWN, RIGHT SIDE IS ALMOST THE SAME)

B

MPD ITEM  
53-410-00

2101205 S0000442500\_V2

INTERNAL-GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 TO STA 1016  
Figure 253/53-05-03-990-863 (Sheet 2 of 4)

EFFECTIVITY  
LOM ALL

53-05-03

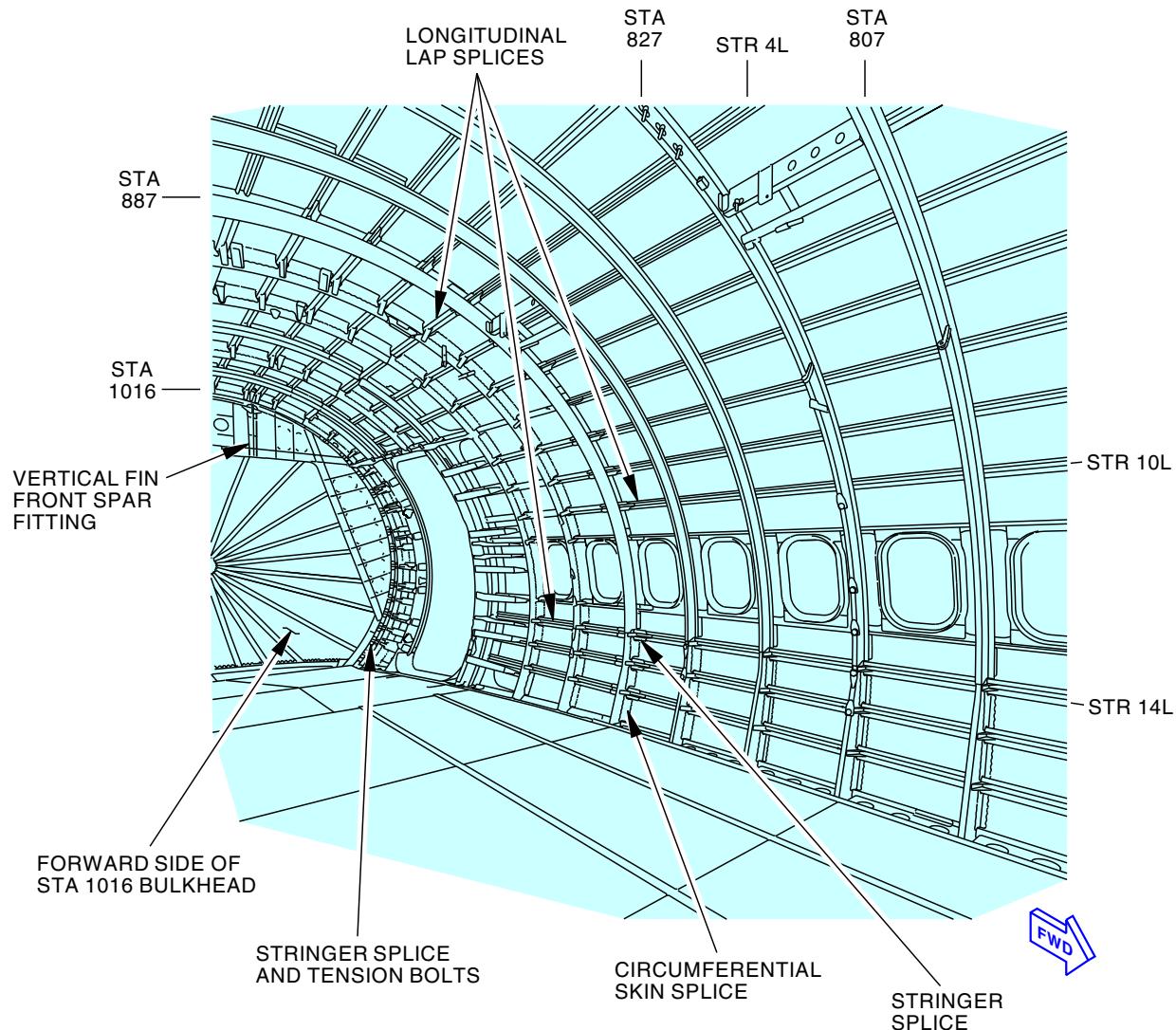
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.63  
Feb 15/2025



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AIRCRAFT MAINTENANCE MANUAL



AFT PASSENGER COMPARTMENT  
(STA 807 TO 1016)  
(LEFT SIDE IS SHOWN, RIGHT SIDE IS ALMOST THE SAME)

C

MPD ITEM  
53-410-00

2101274 S0000442503\_V2

INTERNAL-GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 TO STA 1016  
Figure 253/53-05-03-990-863 (Sheet 3 of 4)

EFFECTIVITY  
LOM ALL

53-05-03

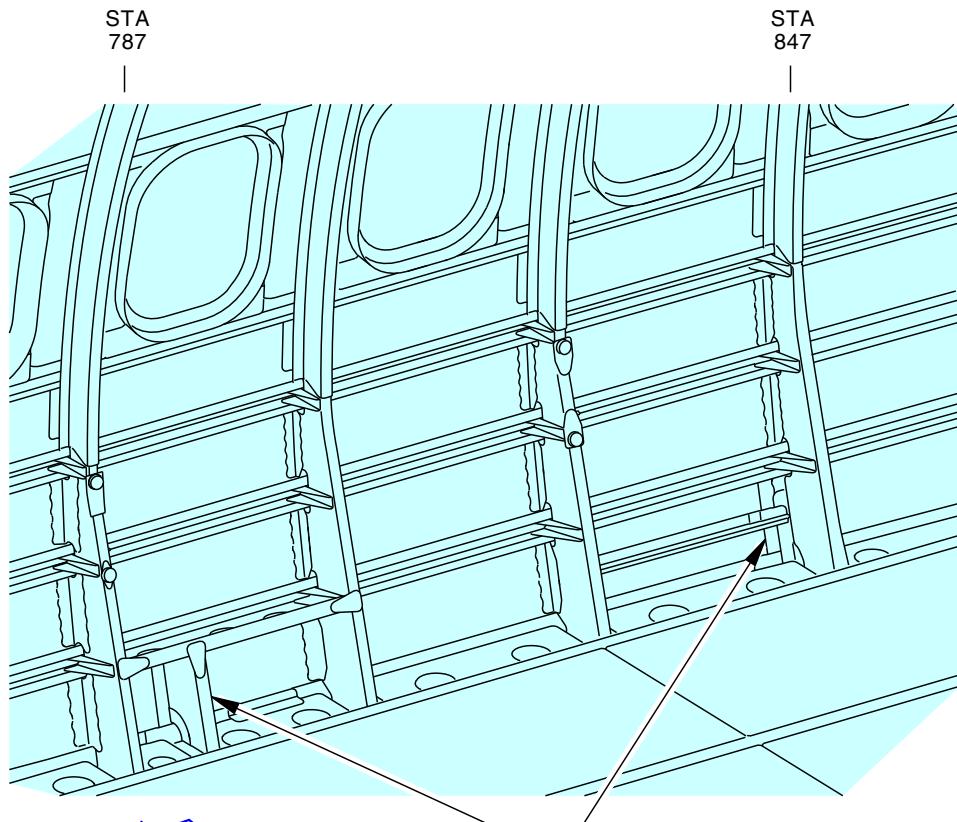
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.64  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



AFT PASSENGER COMPARTMENT  
(STA 787 TO 847)  
(RIGHT SIDE ONLY)

D

MPD ITEM  
53-410-00

2101287 S0000442504\_V2

INTERNAL-GENERAL VISUAL: AFT PASSENGER COMPARTMENT, STA 663.75 TO STA 1016  
Figure 253/53-05-03-990-863 (Sheet 4 of 4)

EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.65  
Feb 15/2025



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AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-838**

**48. INTERNAL - GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD**

(Figure 254)

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 53-05-03-010-035

- (1) Open this access panel:

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

SUBTASK 53-05-03-210-038

- (2) Do a General Visual inspection of the area aft of STA 1016 pressure bulkhead to STA 1088, including:

1. Skin panels (skins, frames and stringers), longitudinal lap splices, circumferential skin and stringer splices.
2. Aft side of STA 1016 bulkhead (chords, pressure web, stiffeners, chord/web attachments).
3. Stringer splice fittings and tension bolts at STA 1016.
4. STA 1088 bulkhead, including vertical fin rear spar fittings and horizontal stabilizer center section jackscrew fitting lugs and bolts.

SUBTASK 53-05-03-910-067

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-035

- (4) Close this access panel:

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

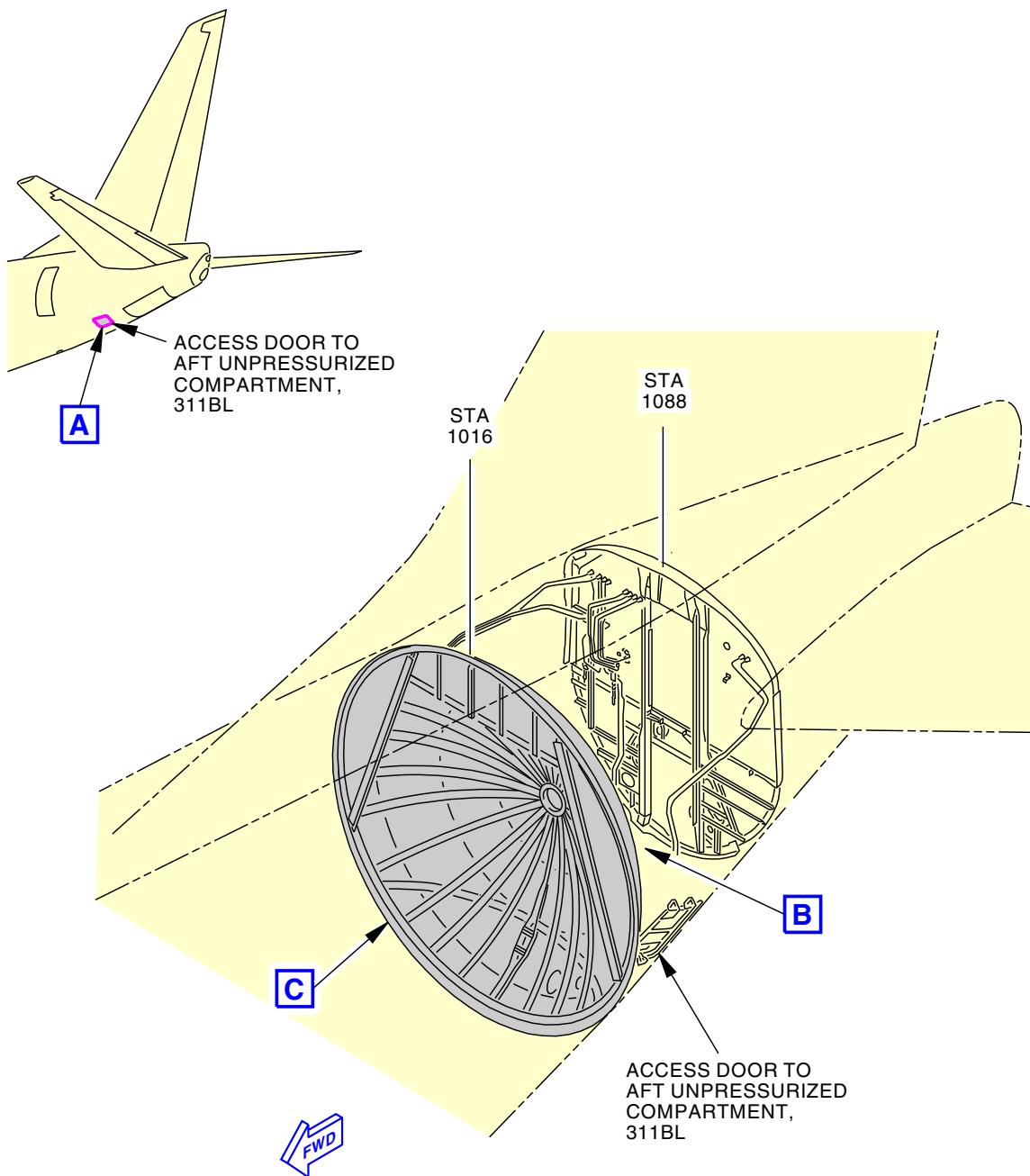
— END OF TASK —

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-420-00

A

2100609 S0000445724\_V2

INTERNAL-GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD  
Figure 254/53-05-03-990-851 (Sheet 1 of 4)

EFFECTIVITY  
LOM ALL

**53-05-03**

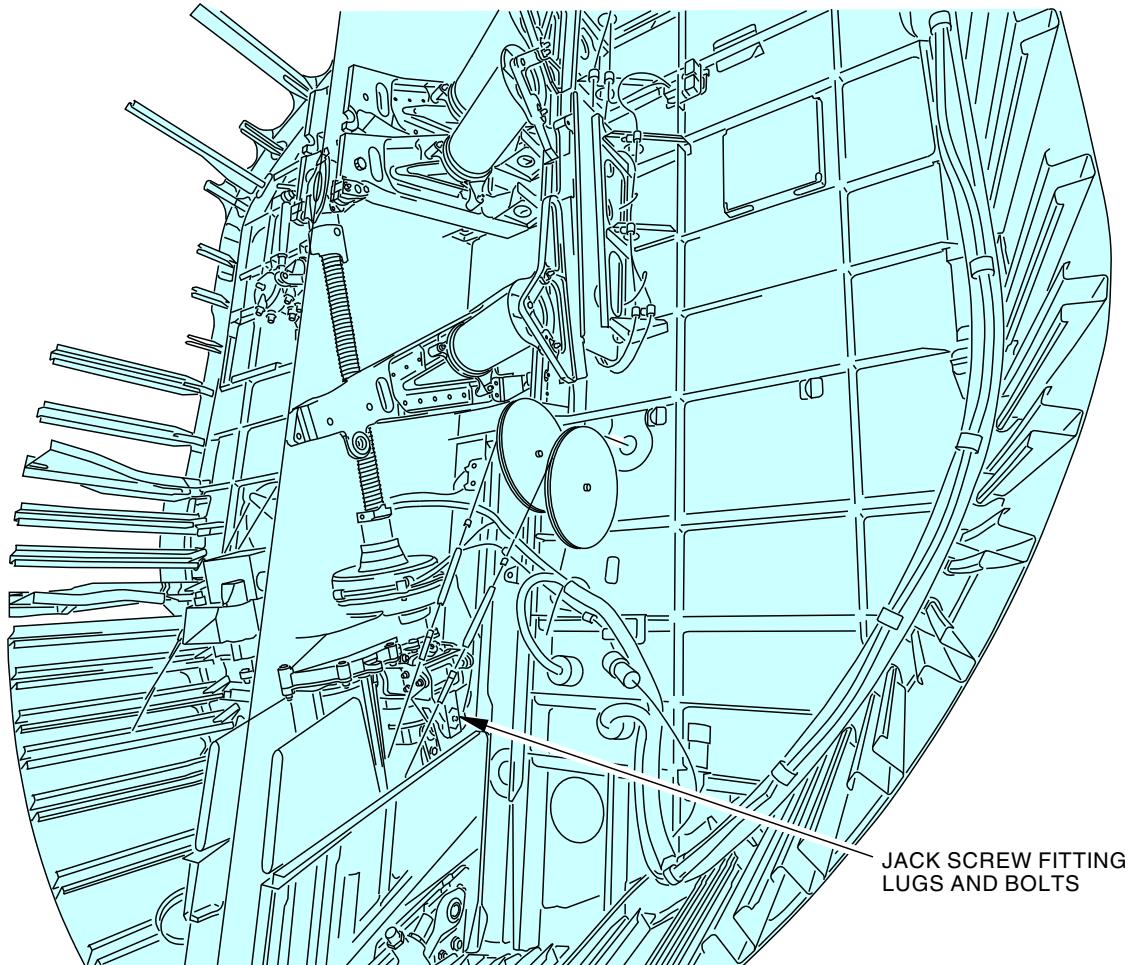
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.67  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



FWD

VIEW FROM BACK

B

MPD ITEM  
53-420-00

2093789 S0000441634\_V2

INTERNAL-GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD  
Figure 254/53-05-03-990-851 (Sheet 2 of 4)

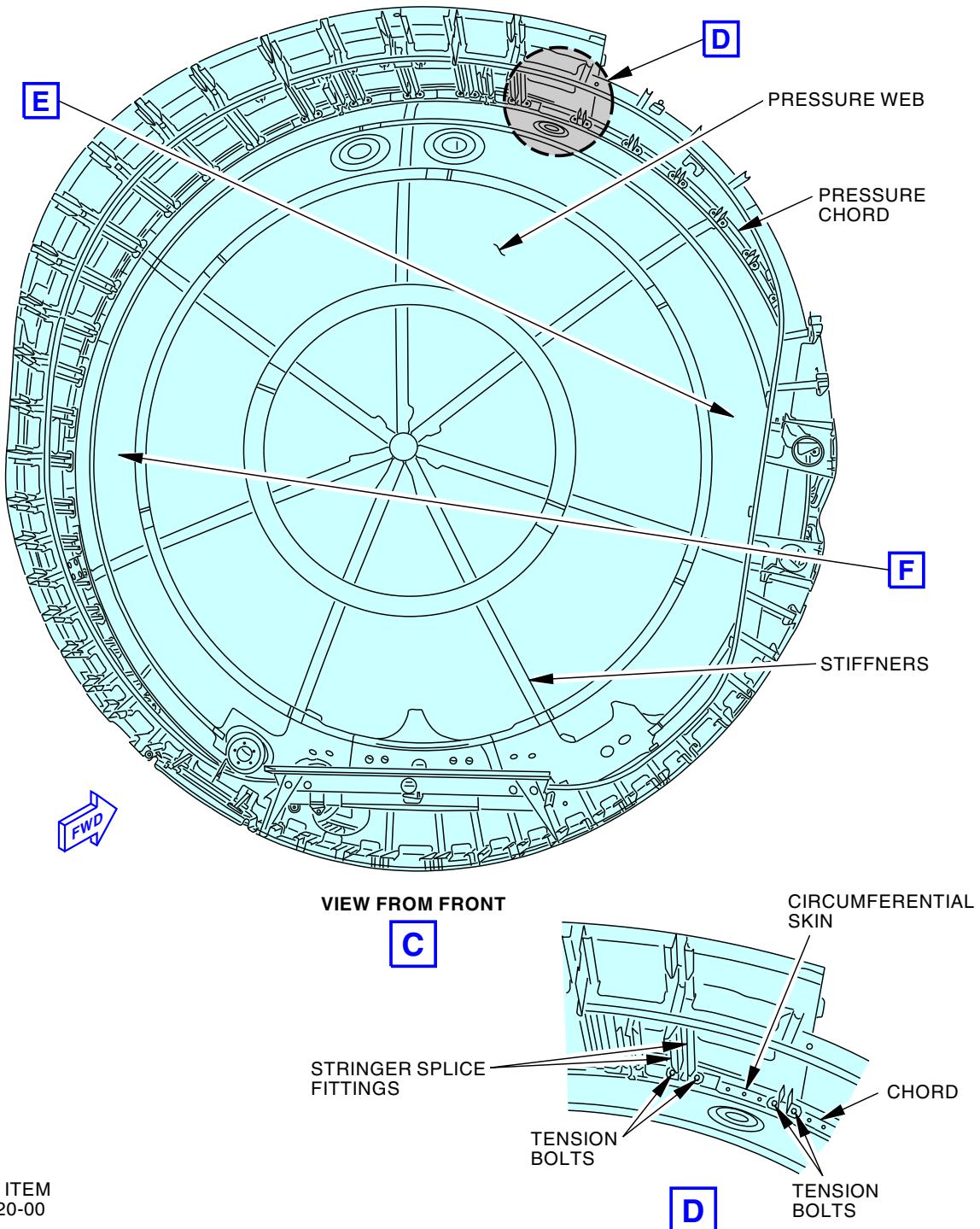
EFFECTIVITY  
LOM ALL

**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

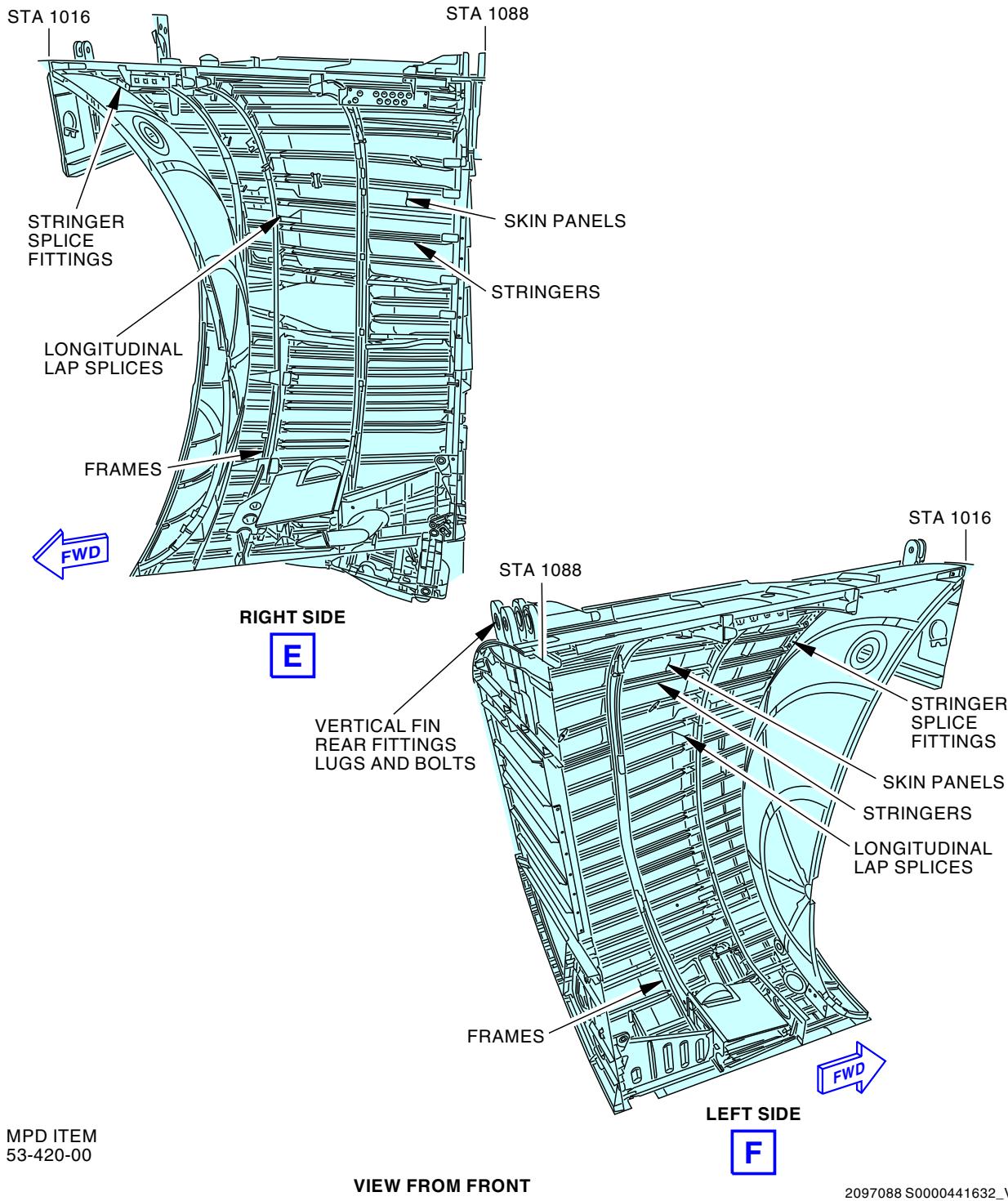
Page 298.68  
Feb 15/2025



**INTERNAL-GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD**  
Figure 254/53-05-03-990-851 (Sheet 3 of 4)

EFFECTIVITY  
LOM ALL

**53-05-03**

**737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL**


**INTERNAL-GENERAL VISUAL: AREA AFT OF STA 1016 BULKHEAD**  
**Figure 254/53-05-03-990-851 (Sheet 4 of 4)**

EFFECTIVITY  
LOM ALL

**53-05-03**



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AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-839**

**49. INTERNAL - GENERAL VISUAL: STABILIZER TORSION BOX COMPARTMENT AND APU COMPARTMENT**

(Figure 255)

**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
315	APU Compartment - Left
316	APU Compartment - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
311BL	Stabilizer Trim Access Door
315A	APU Cowl Door
331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342AT	Gap Cover, Horizontal Stabilizer
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
S3101	Stabilizer Torsion Box Compartment and APU Compartment Inspection

**C. Inspection**

**SUBTASK 53-05-03-010-036**

- (1) Open these access panels:

<b>Number</b>	<b>Name/Location</b>
311BL	Stabilizer Trim Access Door
315A	APU Cowl Door
331A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
332AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
332AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
341A	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body
342AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
342AT	Gap Cover, Horizontal Stabilizer
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body

Special Access:

<b>Number</b>	<b>Name/Location</b>
S3101	Stabilizer Torsion Box Compartment and APU Compartment Inspection



**53-05-03**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**NOTE:** For area below stringer 12, remove APU and firewalls; remove APU plenum as required. For area above stringer 12, adjust stabilizer trim as required. For access to Sta 1156 horizontal stabilizer hinge fitting lugs and bolts, remove gap seal and horizontal stabilizer rear spar sliding seal as required.

**SUBTASK 53-05-03-210-039**

- (2) Do a General Visual inspection of the stabilizer torsion box compartment and APU compartment, including:
  1. Skin panels (skins, frames and stringers), longitudinal lap splices.
  2. STA 1088 bulkhead, including vertical fin rear spar fittings.
  3. Forward side of STA 1156 bulkhead, including horizontal stabilizer hinge fittings and bolts.
  4. Upper horizontal deck (at stringer 6) and lower horizontal deck (at stringer 12).

**SUBTASK 53-05-03-910-068**

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-804.

**SUBTASK 53-05-03-410-072**

- (4) 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 53-05-03-410-036**

- (5) Close these access panels:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

315A      APU Cowl Door

331A      Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body

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

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

341A      Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer To Body

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

342AT      Gap Cover, Horizontal Stabilizer

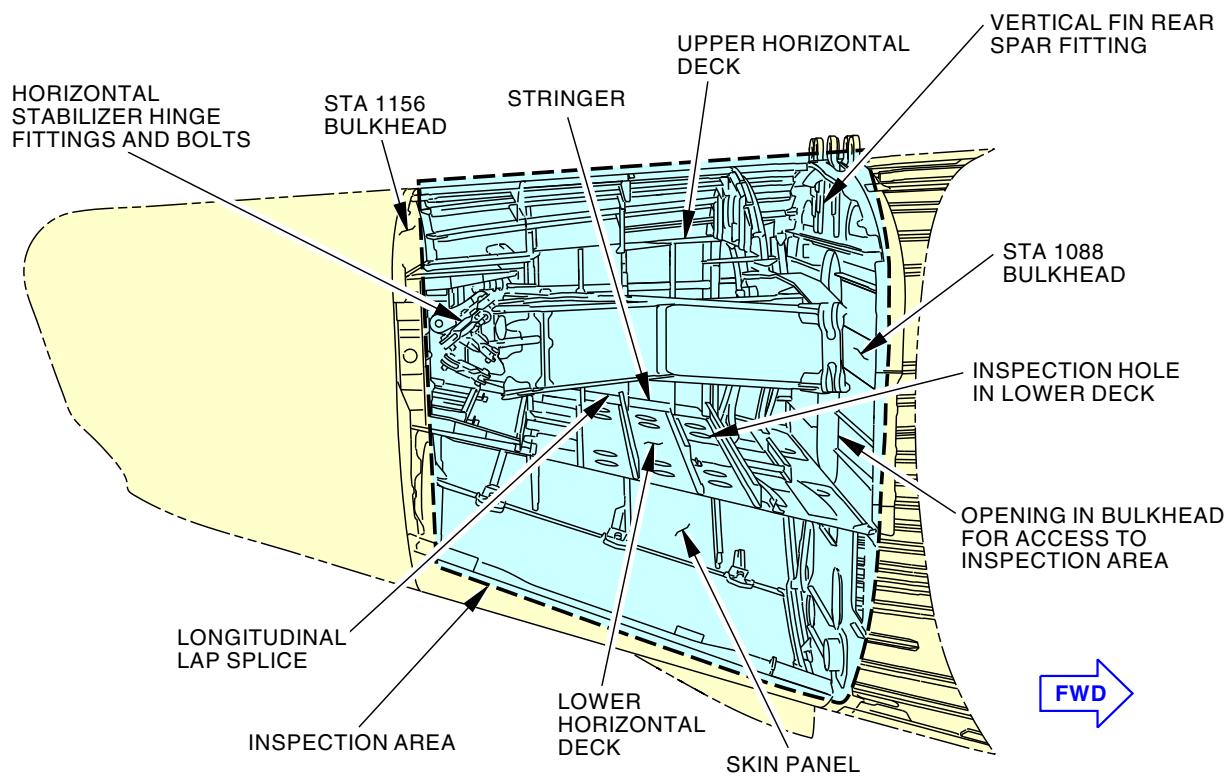
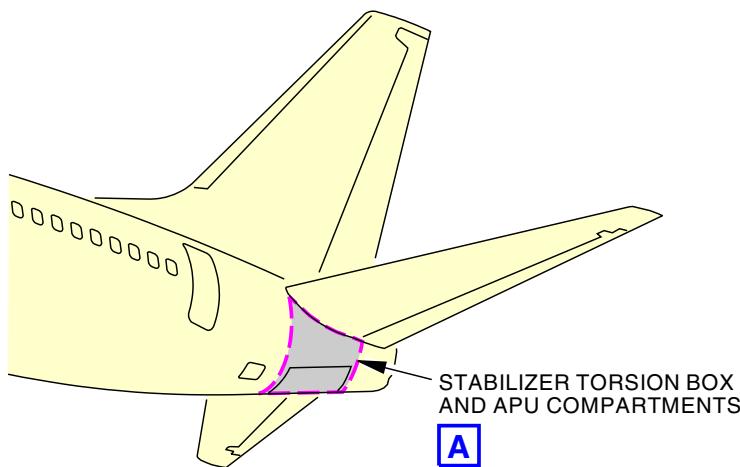
343AT      Horizontal Stabilizer, Gap Cover - H. Stab. to Body

———— END OF TASK ———





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



STABILIZER TORSION BOX AND APU COMPARTMENTS  
(LEFT SIDE SHOWN, RIGHT SIDE OPPOSITE)  
(APU PLENUM, APU, AND FIREWALLS REMOVED)

**A**

MPD ITEM  
53-430-00

2097200 S0000441491\_V2

INTERNAL-GENERAL VISUAL: STABILIZER TORSION BOX COMPARTMENT AND APU COMPARTMENT  
Figure 255/53-05-03-990-857

EFFECTIVITY
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.73  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-840**

**50. INTERNAL - GENERAL VISUAL: STA 1156 BULKHEAD**

(Figure 256)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
317	Tail Cone Compartment - Left
318	Tail Cone Compartment - Right

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
318BR	Tailcone Access Door

**C. Inspection**

SUBTASK 53-05-03-010-037

- (1) Open this access panel:

<b>Number</b>	<b>Name/Location</b>
318BR	Tailcone Access Door

SUBTASK 53-05-03-210-040

- (2) Do a General Visual inspection of the aft side of STA 1156 bulkhead.

SUBTASK 53-05-03-910-069

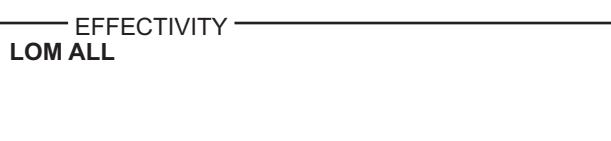
- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-037

- (4) Close this access panel:

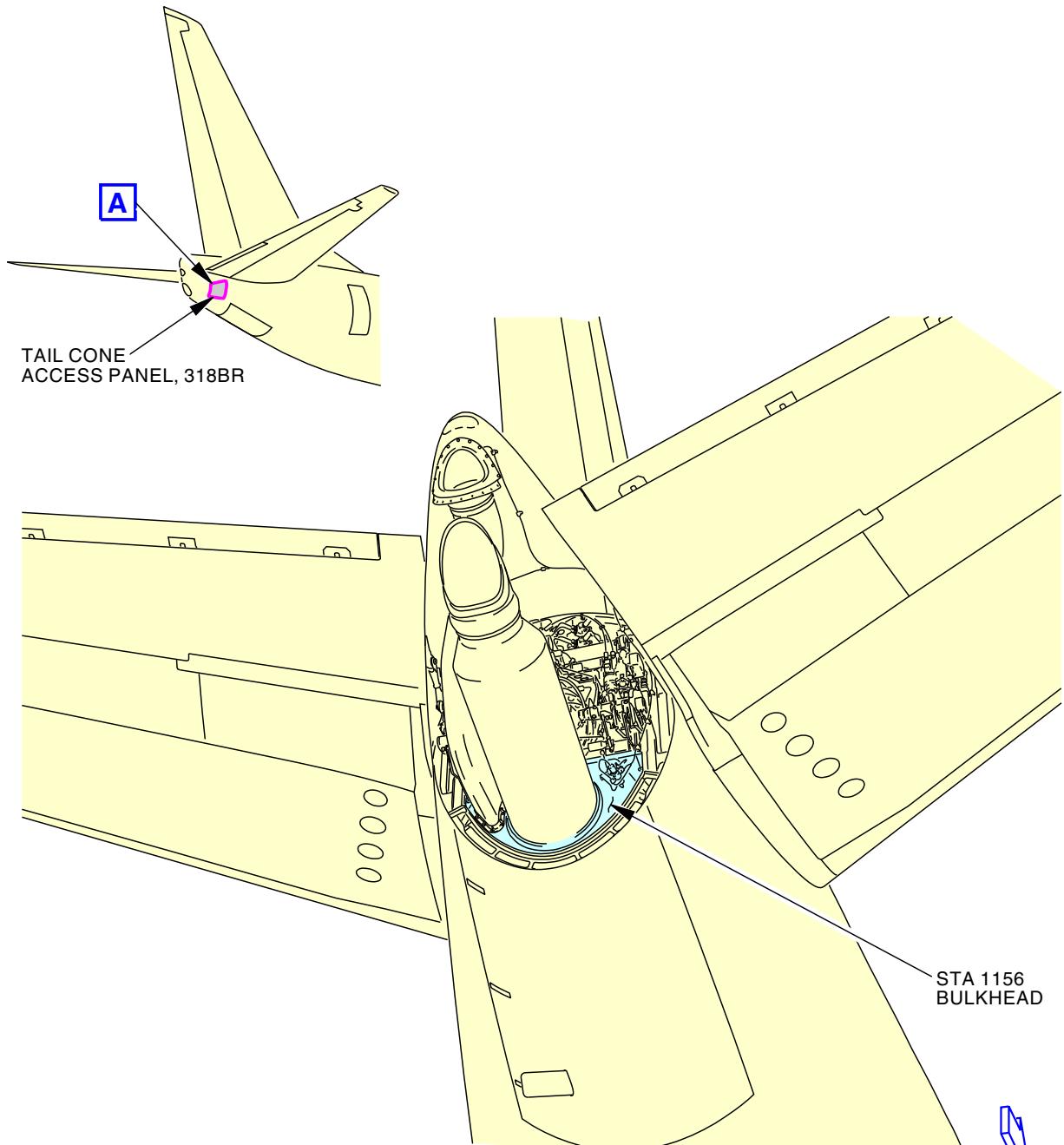
<b>Number</b>	<b>Name/Location</b>
318BR	Tailcone Access Door

———— END OF TASK ————





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-440-00

STA 1156 BULKHEAD  
(TAIL CONE REMOVED FOR CLARITY)



2081370 S0000437527\_V3

INTERNAL-GENERAL VISUAL: STA 1156 BULKHEAD  
Figure 256/53-05-03-990-852

EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.75  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-841**

**51. INTERNAL - GENERAL VISUAL: FUSELAGE SKIN UNDER DORSAL FIN**

(Figure 257)

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)
55-32-11-000-801	Dorsal Fin Removal (P/B 401)
55-32-11-400-801	Dorsal Fin Installation (P/B 401)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
321	Vertical Fin - Dorsal Fin

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
321A	Vertical Fin, Dorsal Fin

**D. Inspection**

SUBTASK 53-05-03-010-038

- (1) To remove the dorsal fin assembly, do this task: Dorsal Fin Removal, TASK 55-32-11-000-801.
  - (a) Remove this access panel:

<b>Number</b>	<b>Name/Location</b>
321A	Vertical Fin, Dorsal Fin

SUBTASK 53-05-03-210-041

- (2) Do a general visual inspection of the fuselage skin under dorsal fin and aft to STA 1016, including circumferential splice.

SUBTASK 53-05-03-910-079

- (3) 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 53-05-03-410-038

- (4) To install the dorsal fin assembly, do this task: Dorsal Fin Installation, TASK 55-32-11-400-801.
  - (a) Install this access panel:

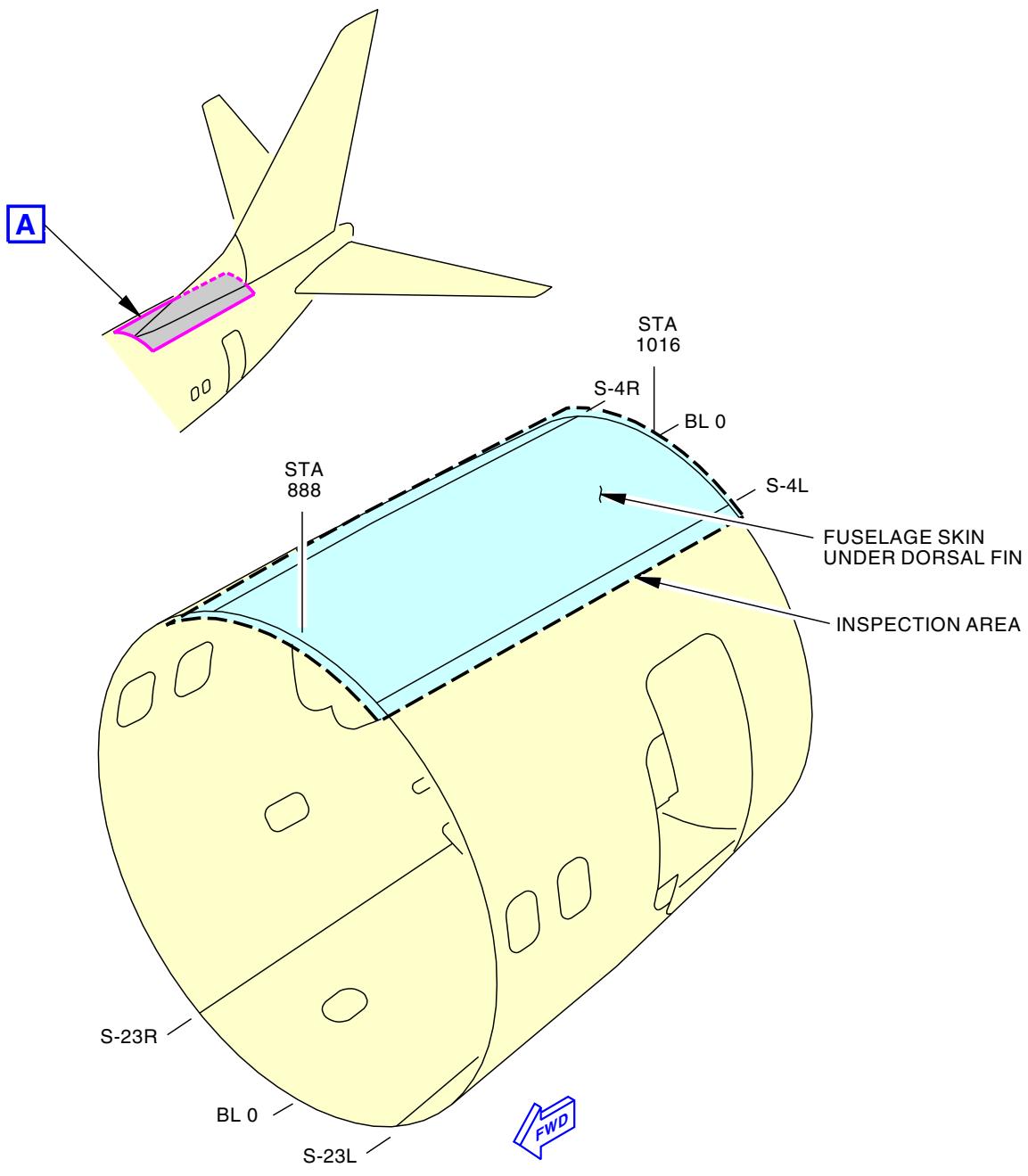
<b>Number</b>	<b>Name/Location</b>
321A	Vertical Fin, Dorsal Fin

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**

**BOEING**  
**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**



MPD ITEM  
53-450-00

D68723 S0000163388\_V2

**Internal-General Visual: Fuselage Skin Under Dorsal Fin**  
**Figure 257/53-05-03-990-834**

EFFECTIVITY	LOM ALL
D633A101-LOM	

**53-05-03**



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AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-842**

**52. INTERNAL - GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING**

(Figure 258)

NOTE: This procedure is a scheduled maintenance task.

**A. Location Zones**

<b>Zone</b>	<b>Area</b>
322	Vertical Fin - Removable Fin Leading Edge

**B. Access Panels**

<b>Number</b>	<b>Name/Location</b>
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

**C. Inspection**

SUBTASK 53-05-03-010-039

- (1) Open these access panels:

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

NOTE: Bolt removal is not required.

SUBTASK 53-05-03-210-042

- (2) Do a General Visual inspection of the vertical fin front spar fitting lugs and bolts (Sta 1016).

SUBTASK 53-05-03-910-071

- (3) 737-6789 Basic Task Description, AMM Task 51-05-01-210-806.

SUBTASK 53-05-03-410-039

- (4) Close these access panels:

<b>Number</b>	<b>Name/Location</b>
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

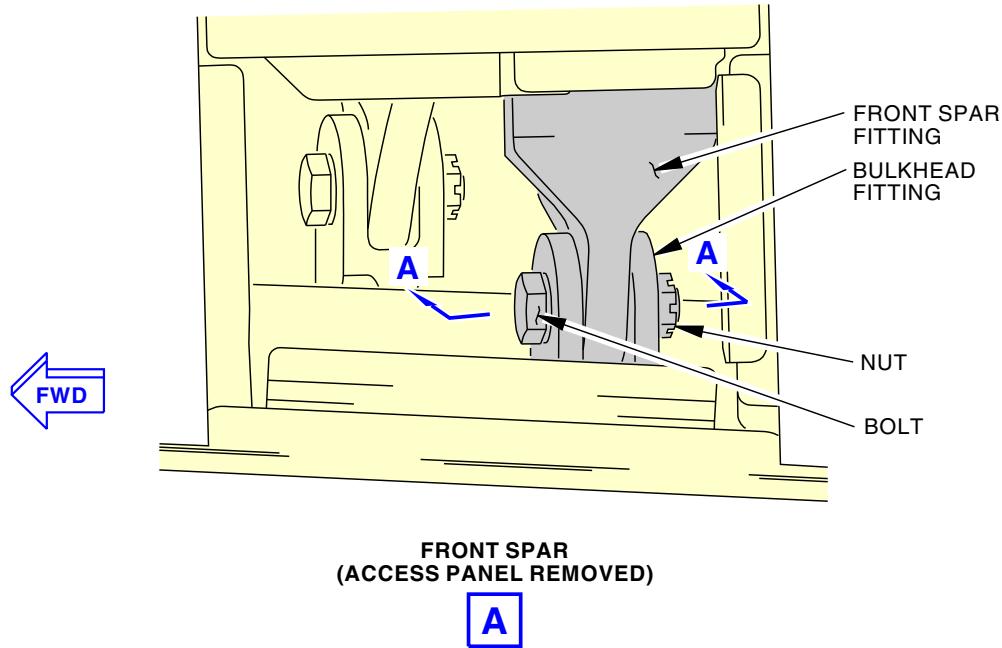
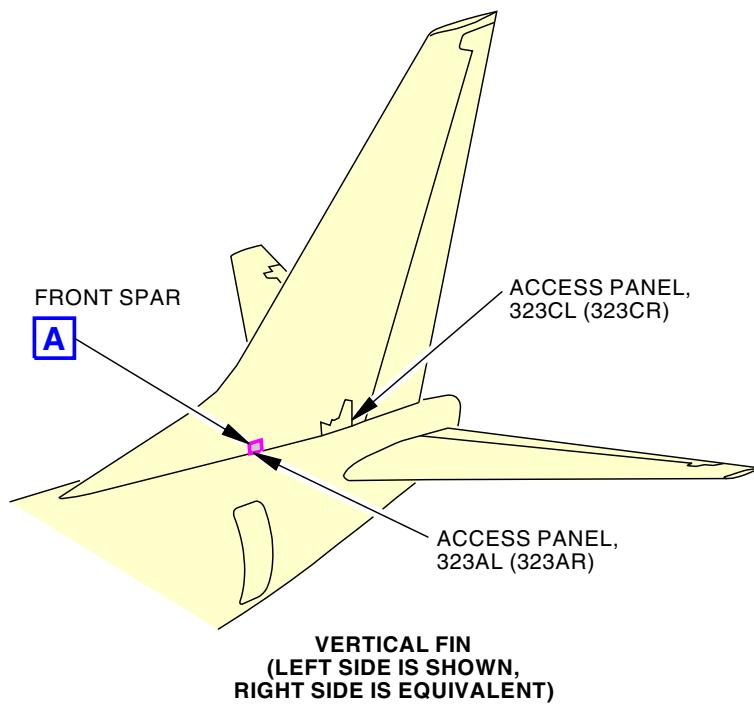
— END OF TASK —

EFFECTIVITY  
LOM ALL

**53-05-03**



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MPD ITEM  
53-460-00

2072432 S0000432636\_V3

Vertical Fin Front Spar Fitting General Visual Inspection (Internal)  
Figure 258/53-05-03-990-903 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

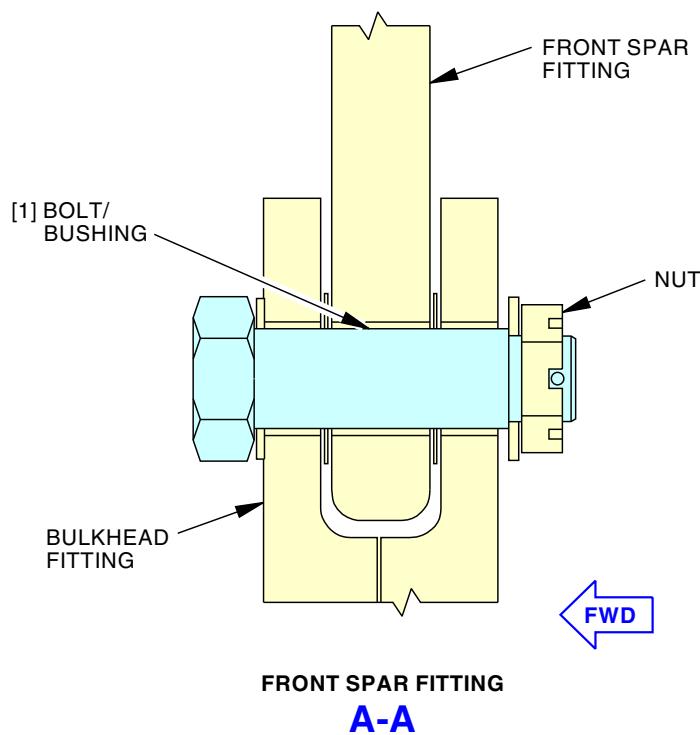
**53-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.79  
Feb 15/2025

**BOEING**  
737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-460-00

2072440 S0000432646\_V3

Vertical Fin Front Spar Fitting General Visual Inspection (Internal)  
Figure 258/53-05-03-990-903 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-05-03**

Page 298.80  
Feb 15/2025



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AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-843**

**53. INTERNAL - GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING**

(Figure 259)

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)

**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.

<b>Reference</b>	<b>Description</b>
SPL-2032	Sling Equipment - Vertical Fin
	Part #: C55010-33 Supplier: 81205
	Opt Part #: C55010-1 Supplier: 81205

**C. Consumable Materials**

<b>Reference</b>	<b>Description</b>	<b>Specification</b>
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
D00633	Grease - Aircraft General Purpose	BMS3-33
D50004	Compound - Antiseize	BMS3-28

**D. Expendables/Parts**

<b>AMM Item</b>	<b>Description</b>	<b>AIPC Reference</b>	<b>AIPC Effectivity</b>
5	Cotter pin	55-30-00-26-005	LOM ALL

**E. Location Zones**

<b>Zone</b>	<b>Area</b>
322	Vertical Fin - Removable Fin Leading Edge

**F. Access Panels**

<b>Number</b>	<b>Name/Location</b>
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

**G. Inspection**

SUBTASK 53-05-03-480-001

- (1) Install the sling equipment, SPL-2032.

SUBTASK 53-05-03-010-040

- (2) Open these access panels:

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

EFFECTIVITY	LOM ALL
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**53-05-03**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-05-03-020-003

- (3) Remove the cotter pins [5], nuts [4], washers [2], washers [3], washers [6] and bolts [1] from the front spar attach fittings.

NOTE: There is a bolt on the left side and the right side. Only remove one bolt at a time to keep the fin aligned.

SUBTASK 53-05-03-210-043

- (4) Do a General Visual inspection of the vertical fin front spar fitting lugs and bolts [1] (STA 1016).

SUBTASK 53-05-03-910-072

- (5) 737-6789 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 53-05-03-110-001

- (6) Clean the bolts [1] and bolt holes with solvent, B00083.

SUBTASK 53-05-03-420-001

- (7) Install the fasteners of the front spar fitting:

- (a) Apply a layer of grease, D00633 on the shank of the bolts [1].

NOTE: Apply grease only to the shank of the bolts.

- (b) Apply anti-seize compound, D50004 to the bolt [1] threads and the nut [4] threads.

- (c) Install the bolts [1], washers [2], washers [3], washers [6] and nuts [4].

- 1) Torque the nuts [4] to 50 in-lb (5.6 N·m) - 1500 in-lb (169.5 N·m).

NOTE: Maintain the required gaps shown in View A-A.

NOTE: Align nut with the cotter pin hole in the bolt.

- 2) Install new cotter pins [5] in to the nuts [4].

SUBTASK 53-05-03-410-040

- (8) Close these access panels:

**Number      Name/Location**

323AL      Vertical Fin, Front Spar Access Door

323AR      Vertical Fin, Front Spar Access Door

323BL      Vertical Fin, Forward Fin Access Door

323BR      Vertical Fin, Forward Fin Access Door

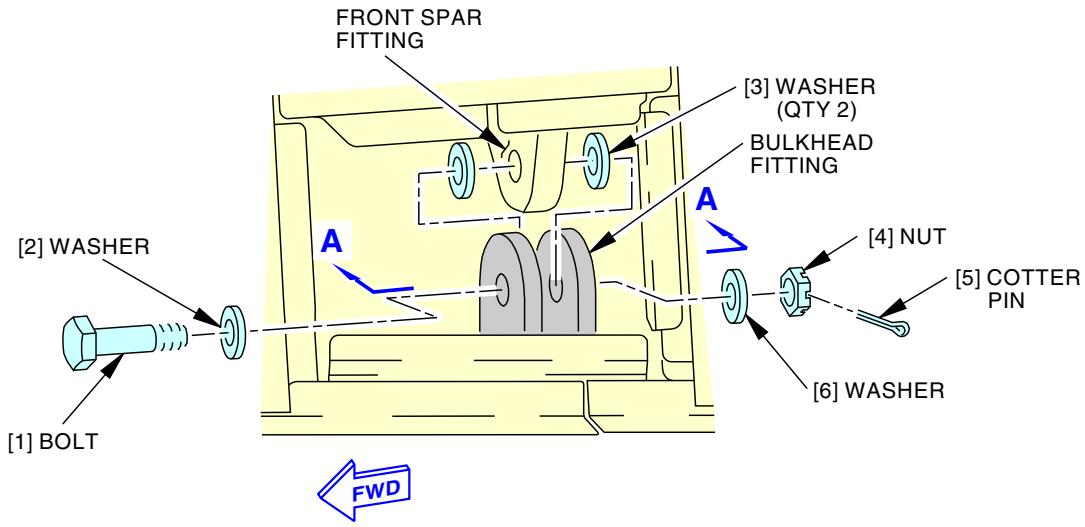
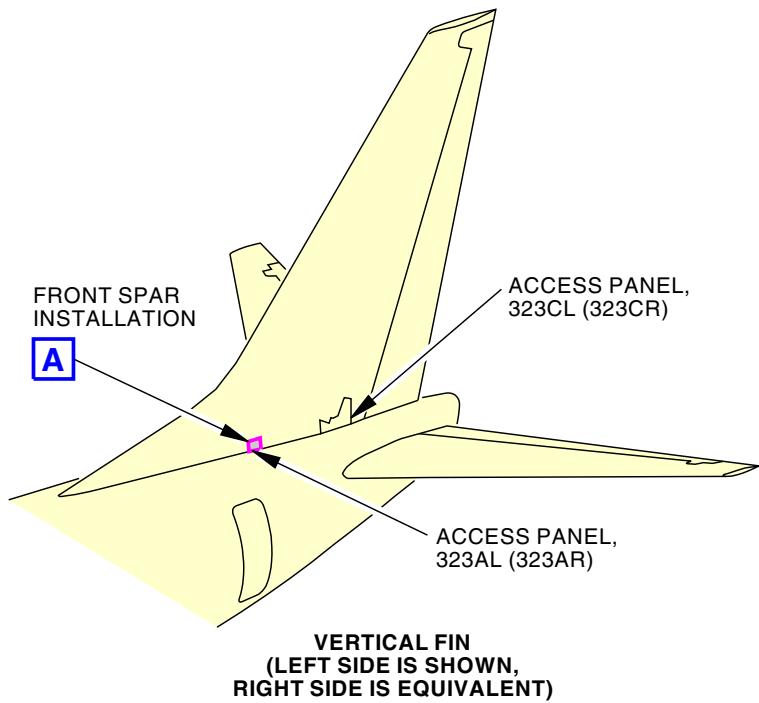
SUBTASK 53-05-03-080-001

- (9) Remove the sling equipment, SPL-2032.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



**FRONT SPAR INSTALLATION**  
(ACCESS PANEL REMOVED)

**A**

MPD ITEM  
53-470-00

2087670 S0000439339\_V3

**INTERNAL-GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING**  
Figure 259/53-05-03-990-904 (Sheet 1 of 4)

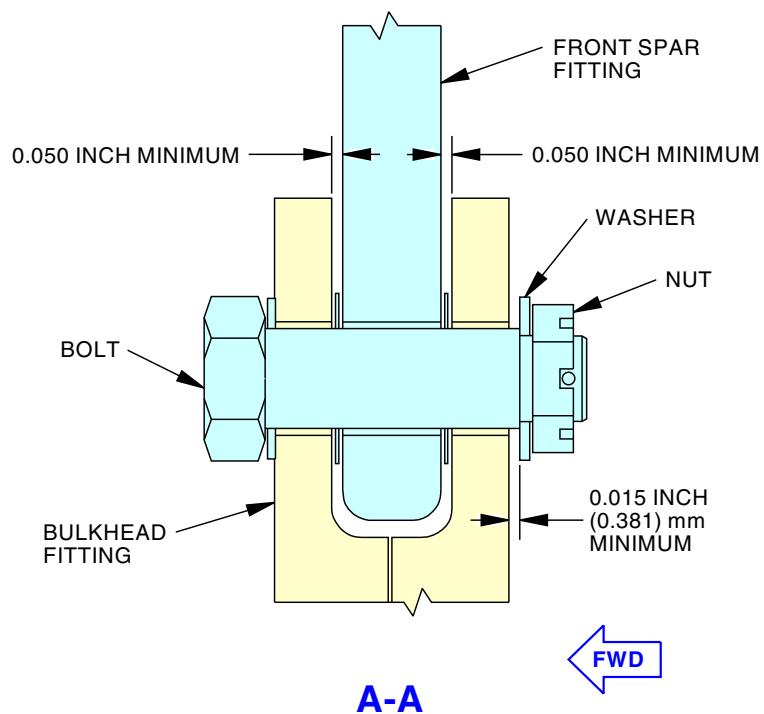
EFFECTIVITY	LOM ALL
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**53-05-03**



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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-470-00

2087696 S0000439340\_V4

**INTERNAL-GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING**  
Figure 259/53-05-03-990-904 (Sheet 2 of 4)

EFFECTIVITY  
LOM ALL

**53-05-03**

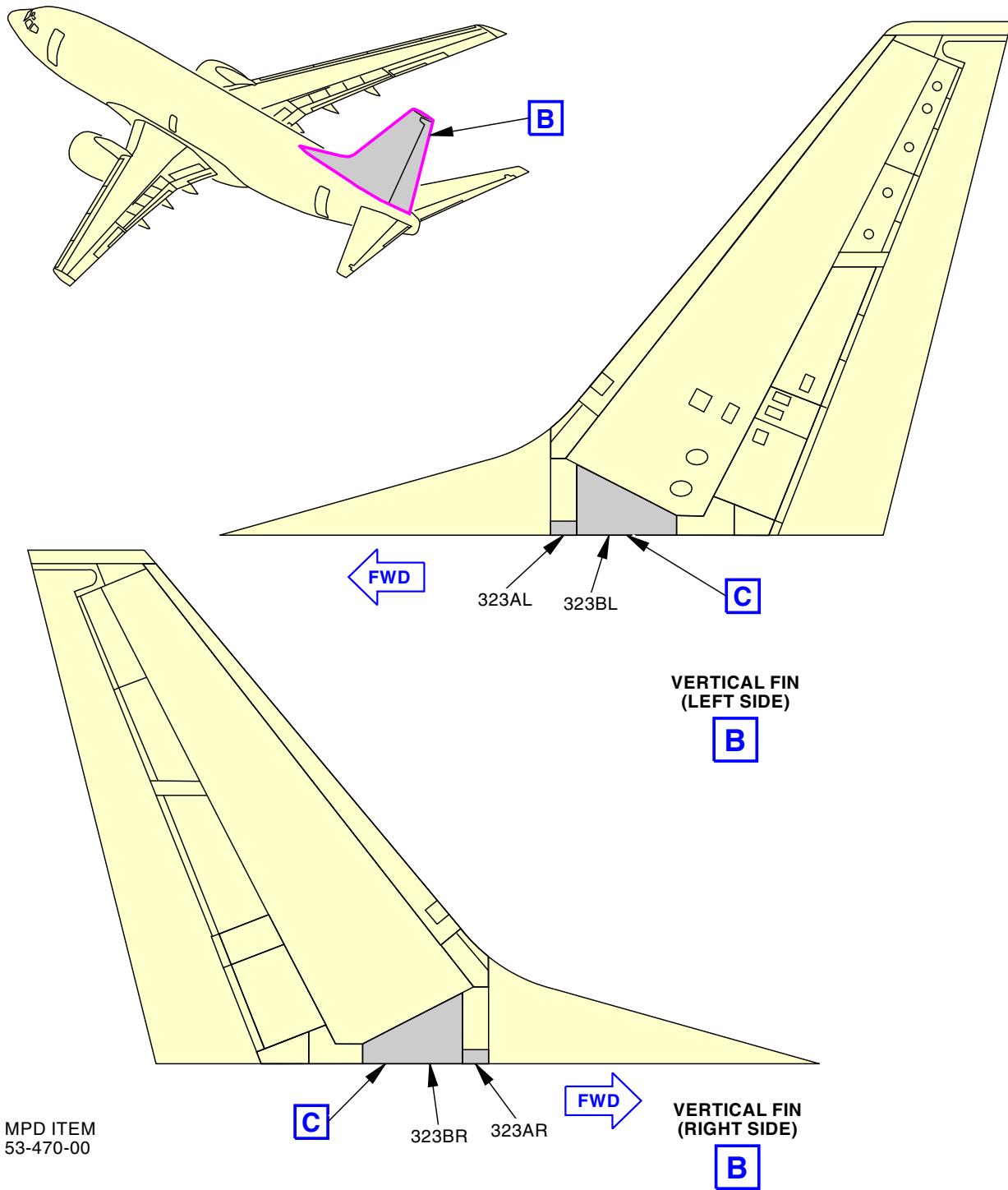
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Page 298.84  
Feb 15/2025



737-600/700/800/900  
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INTERNAL-GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING  
Figure 259/53-05-03-990-904 (Sheet 3 of 4)

EFFECTIVITY  
LOM ALL

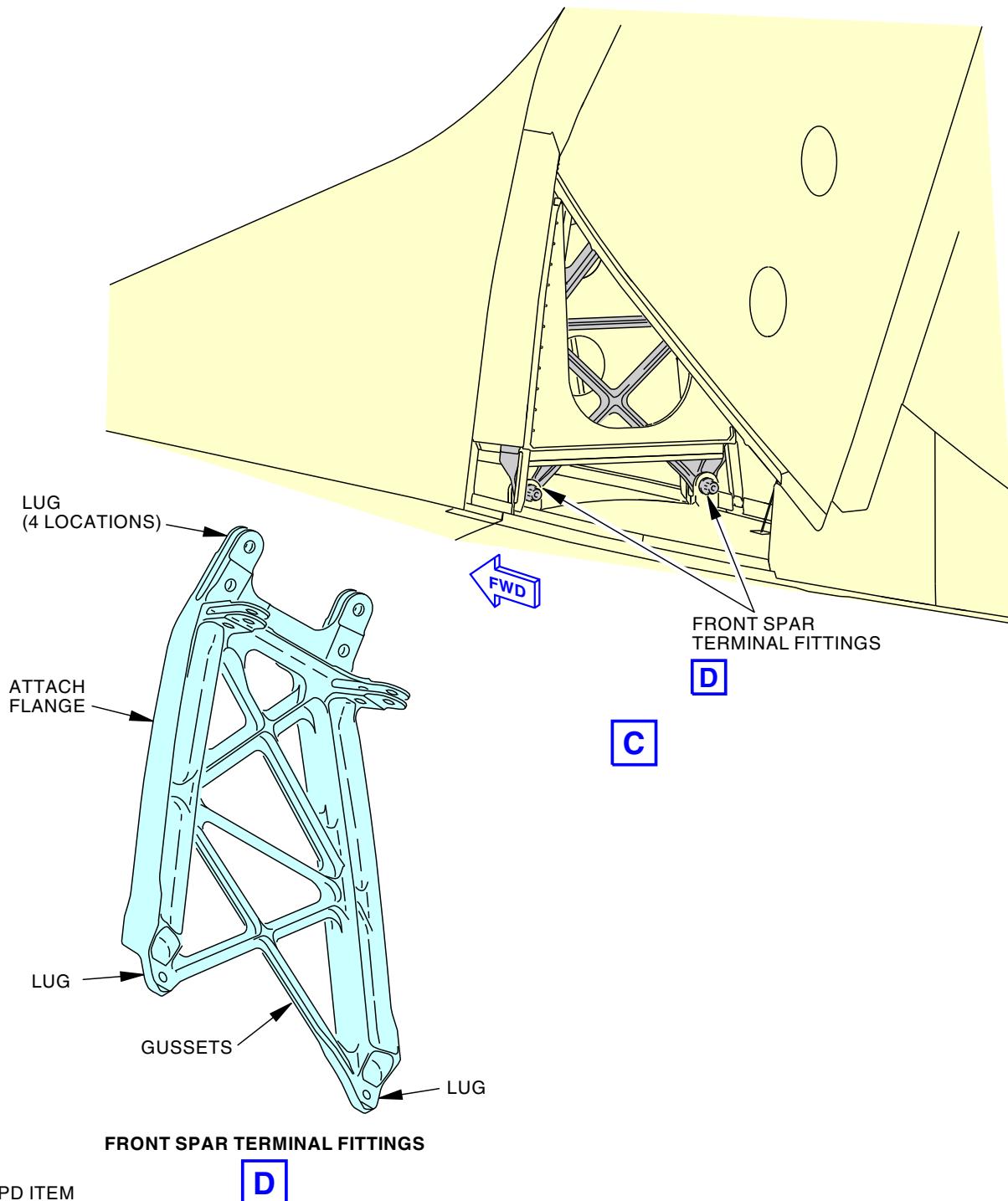
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**53-05-03**

Page 298.85  
Feb 15/2025



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INTERNAL-GENERAL VISUAL: VERTICAL FIN FRONT SPAR FITTING  
Figure 259/53-05-03-990-904 (Sheet 4 of 4)

EFFECTIVITY  
LOM ALL

**53-05-03**

Page 298.86  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-844**

**54. INTERNAL - GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING**

(Figure 260)

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)

**B. Location Zones**

<b>Zone</b>	<b>Area</b>
323	Vertical Fin - Front Spar To Rear Spar

**C. Access Panels**

<b>Number</b>	<b>Name/Location</b>
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

**D. Inspection**

**SUBTASK 53-05-03-010-041**

- (1) Open these access panels:

<b>Number</b>	<b>Name/Location</b>
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

**SUBTASK 53-05-03-210-044**

- (2) Do a General Visual inspection of the vertical fin rear spar fitting lugs and bolts at Sta 1088.  
Inspect fuselage skin under vertical fin from Sta 1016 to 1088.

**SUBTASK 53-05-03-910-073**

- (3) 737-6789 Basic Task Description, TASK 51-05-01-210-806.

**SUBTASK 53-05-03-410-041**

- (4) Close these access panels:

<b>Number</b>	<b>Name/Location</b>
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

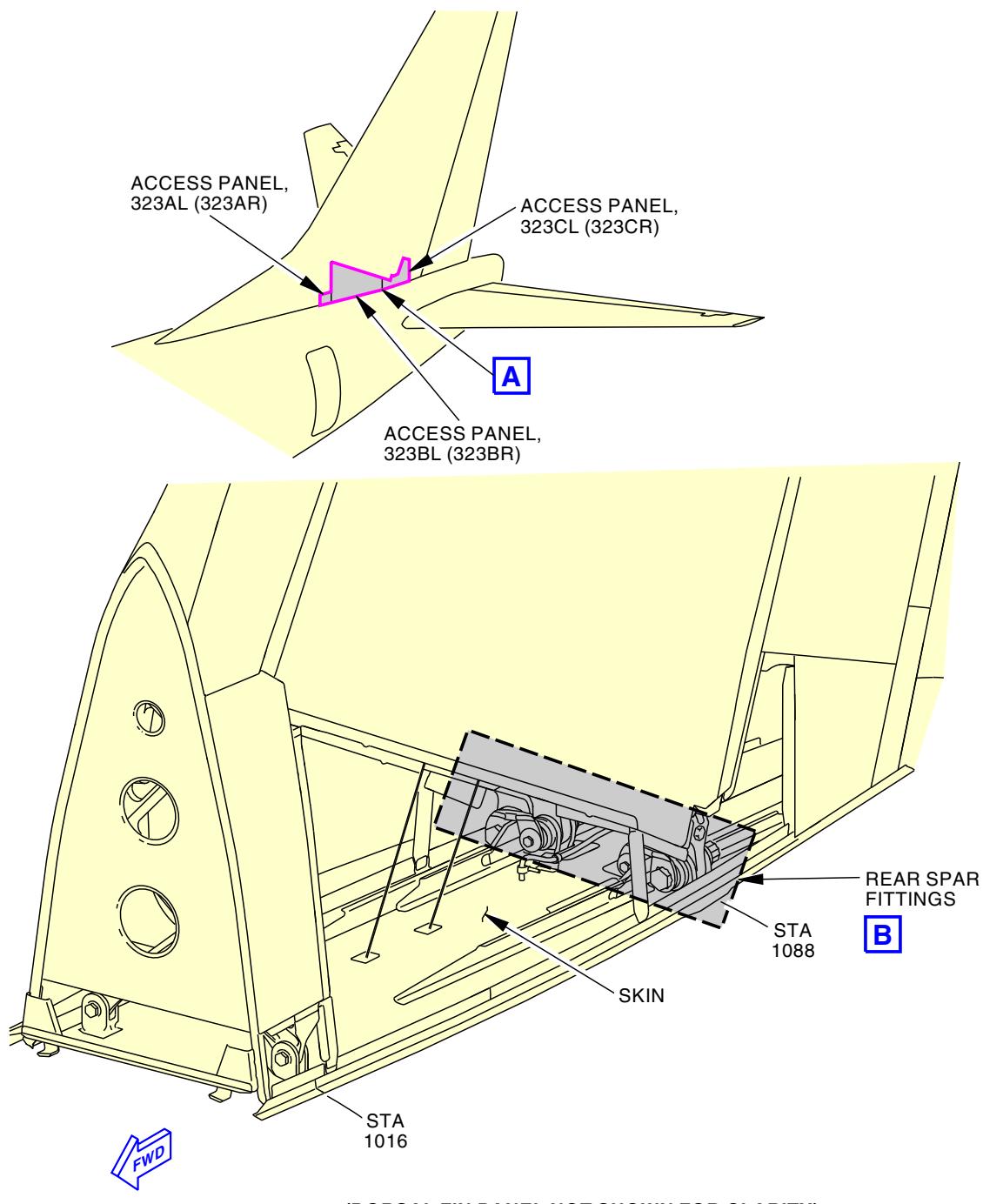
— END OF TASK —

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-480-00

2084332 S0000438778\_V2

INTERNAL-GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING  
Figure 260/53-05-03-990-854 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

**53-05-03**

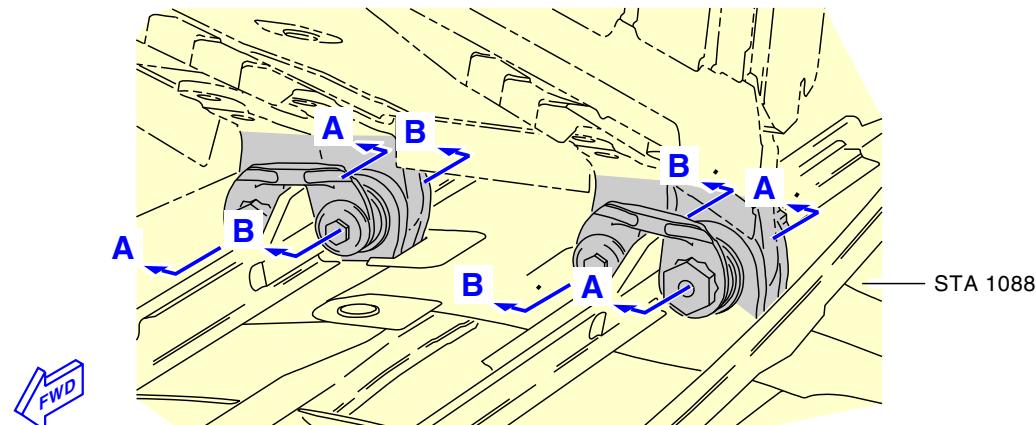
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 298.88  
Feb 15/2025



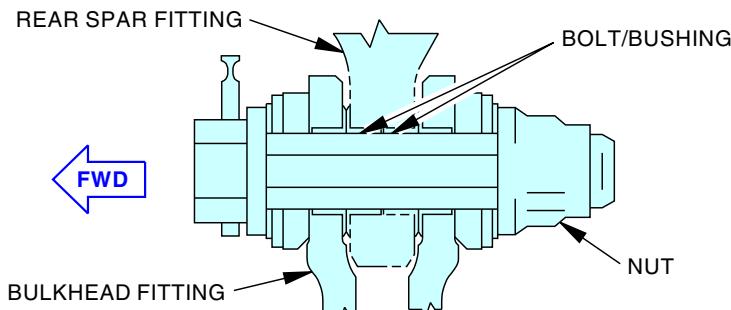
737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



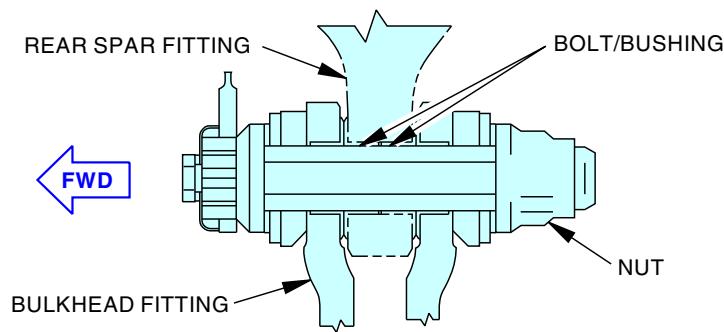
REAR SPAR FITTINGS



STA 1088



OUTBOARD SPAR FITTING



INBOARD SPAR FITTING



MPD ITEM  
53-480-00

2084337 S0000438779\_V2

INTERNAL-GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING  
Figure 260/53-05-03-990-854 (Sheet 2 of 2)

EFFECTIVITY	LOM ALL
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D633A101-LOM

**53-05-03**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-05-03-210-864**

**55. INTERNAL - GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING**

(Figure 261, Figure 262)

**A. References**

<b>Reference</b>	<b>Title</b>
51-05-01-210-806	737-6789 Basic Task Description (P/B 201)

**B. Tools/Equipment**

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

<b>Reference</b>	<b>Description</b>
SPL-2032	Sling Equipment - Vertical Fin Part #: C55010-33 Supplier: 81205 Opt Part #: C55010-1 Supplier: 81205

**C. Consumable Materials**

<b>Reference</b>	<b>Description</b>	<b>Specification</b>
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
D00633	Grease - Aircraft General Purpose	BMS3-33
D50004	Compound - Antiseize	BMS3-28
G50347	Lockwire - MS20995NC32, Monel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

**D. Location Zones**

<b>Zone</b>	<b>Area</b>
323	Vertical Fin - Front Spar To Rear Spar

**E. Access Panels**

<b>Number</b>	<b>Name/Location</b>
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

**F. Inspection**

**SUBTASK 53-05-03-420-004**

- (1) Install the sling equipment, SPL-2032.

- (a) Attach the sling equipment, SPL-2032, to the Lift Fitting and Lift Fitting 2.

NOTE: It is not necessary to attach the Lift Fitting 3. The sling relieves the weight of the vertical fin at the attach fitting joint to allow the removal of an attached bolt.

**SUBTASK 53-05-03-010-082**

- (2) Open these access panels:

<b>Number</b>	<b>Name/Location</b>
323AL	Vertical Fin, Front Spar Access Door

EFFECTIVITY
LOM ALL

**53-05-03**

Page 298.90  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

SUBTASK 53-05-03-420-005



MAKE SURE THAT THE FORCE WITHOUT THE TOOL WEIGHT IS NO MORE THAN THE SPECIFIED FORCE. A FORCE THAT IS MORE THAN THE SPECIFIED FORCE CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (3) Increase the lift force gradually until you can remove the bolt for inspection.

- Make sure that the lift force is not more than 1700 lbf (7562 N).
- Remove only one bolt at a time.

NOTE: For an inspection, remove one bolt at a time. The alignment of the fin will not be changed.

SUBTASK 53-05-03-210-052

- (4) Do a General Visual Inspection (GVI) of the vertical fin rear spar fitting lugs and bolts at Sta 1088. Inspect fuselage skin under vertical fin from Sta 1016 to 1088.

SUBTASK 53-05-03-910-078

- (5) 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 53-05-03-020-005

- (6) Re-install the bolt(s) removed for inspection.

NOTE: Only do the steps for the bolt [16] or bolt [23] that was removed for inspection.

- If bolt [16] was removed for inspection, do these steps:
  - Apply anti-seize compound, D50004 to the threads of bolt [16].
  - Apply grease, D00633 only on the shank of bolt [16].
  - Loosely install bolt [16], self-locking nut [21], washer [17], washer [18], washer [19], and washer [20].

NOTE: One more washer [20] can be added if needed to maintain the grip length adjustment.

**LOM 442-447, 450-999**

- 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:
  - Select the necessary washer [19] 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.
  - Apply anti-seize compound, D50004 to the washer [19] before installation.

EFFECTIVITY  
LOM ALL

**53-05-03**



**737-600/700/800/900**  
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**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 washer [19] as necessary.

NOTE: Only one washer is permitted on each side of the rear spar fitting.

**LOM ALL**

- c) Apply sealant, A00247 between the washer [18] and the drag brace, (Figure 262).
  - 4) On the inboard fitting (Figure 262), tighten the bolt [16] to 6500 in-lb (734.4 N·m) - 7500 in-lb (847.4 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].
    - 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).
- (b) If bolt [23] was removed for inspection, do these steps:
- 1) Apply anti-seize compound, D50004 to the threads of bolt [23].
  - 2) Apply grease, D00633 only on the shank of bolt [23].
  - 3) Loosely install bolt [23], self-locking nut [27], washer [24], washer [25], washer [26], and washer [28].

NOTE: One more washer [26] can be added if needed to maintain the 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 [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 [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 washer [28] as necessary.

NOTE: Only one washer is permitted on each side of the rear spar fitting.

**LOM ALL**

- c) Apply sealant, A00247 between the washer [25] and the drag brace, (Figure 262).
- 4) On the outboard fitting (Figure 262), tighten the bolt [23] to 7500 in-lb (847.4 N·m) - 8500 in-lb (960.4 N·m).

EFFECTIVITY  
LOM ALL

**53-05-03**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 5) Install the antirotation lock [15], retainer cap [13], washer [12], lockwire [14] (MS20995NC32 lockwire, G50347), and bolt [11].
  - 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).

SUBTASK 53-05-03-410-077

- (7) Close these access panels:

<b>Number</b>	<b>Name/Location</b>
323AL	Vertical Fin, Front Spar Access Door
323AR	Vertical Fin, Front Spar Access Door
323BL	Vertical Fin, Forward Fin Access Door
323BR	Vertical Fin, Forward Fin Access Door
323CL	Vertical Fin, Rear Spar Access Door
323CR	Vertical Fin, Rear Spar Access Door

SUBTASK 53-05-03-410-078

- (8) Remove the sling equipment, SPL-2032.

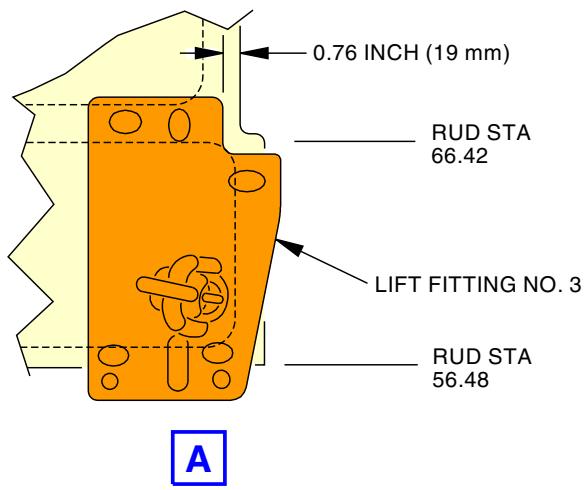
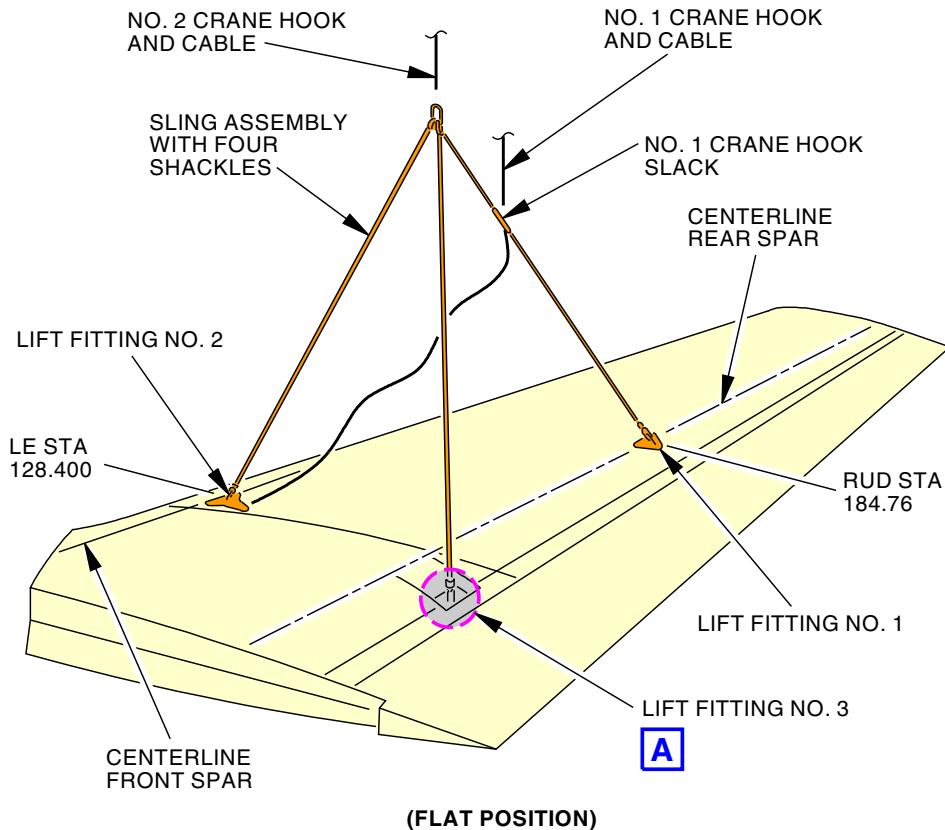
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EFFECTIVITY  
LOM ALL

**53-05-03**



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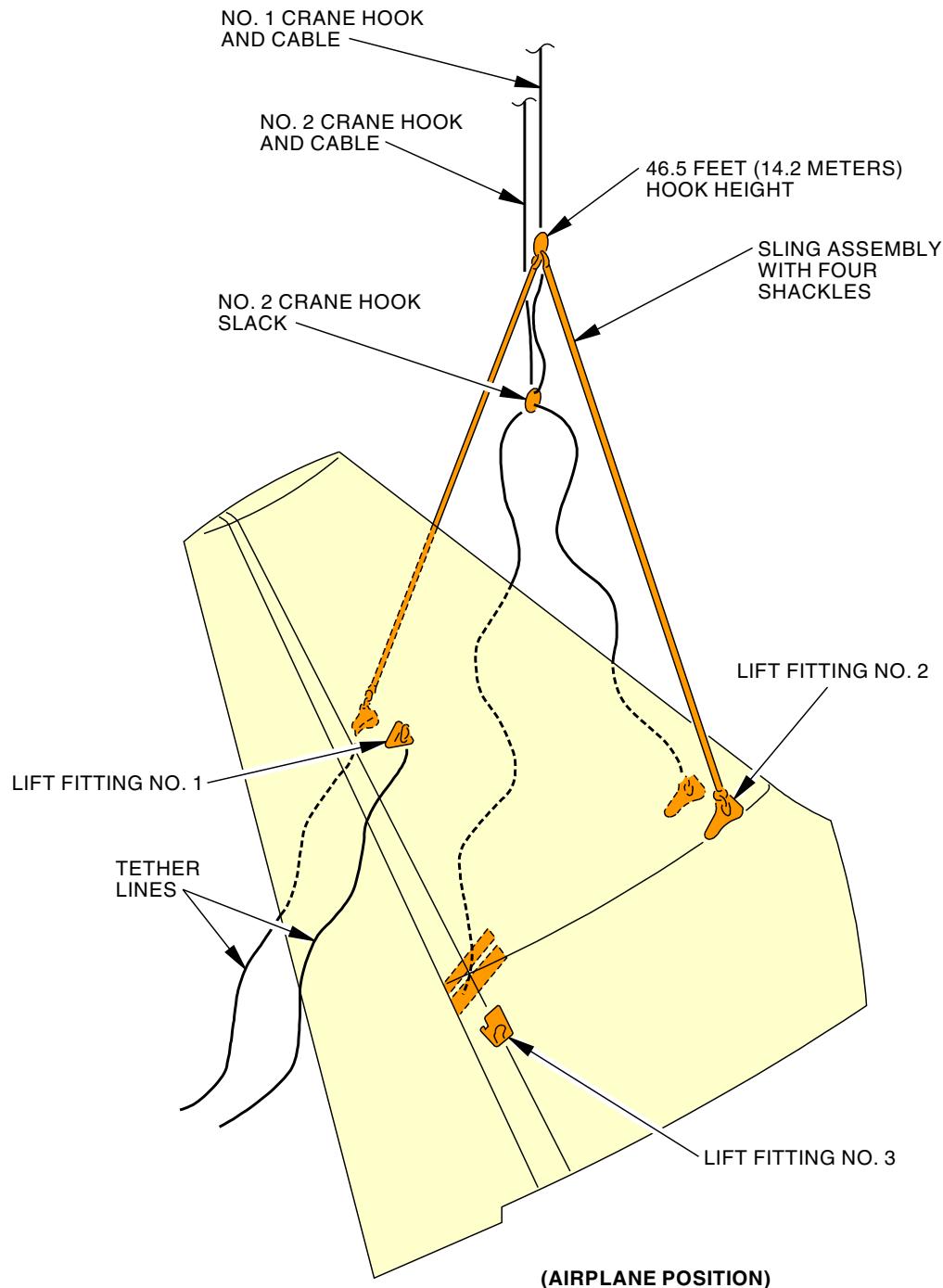
INTERNAL-GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING  
Figure 261/53-05-03-990-907 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
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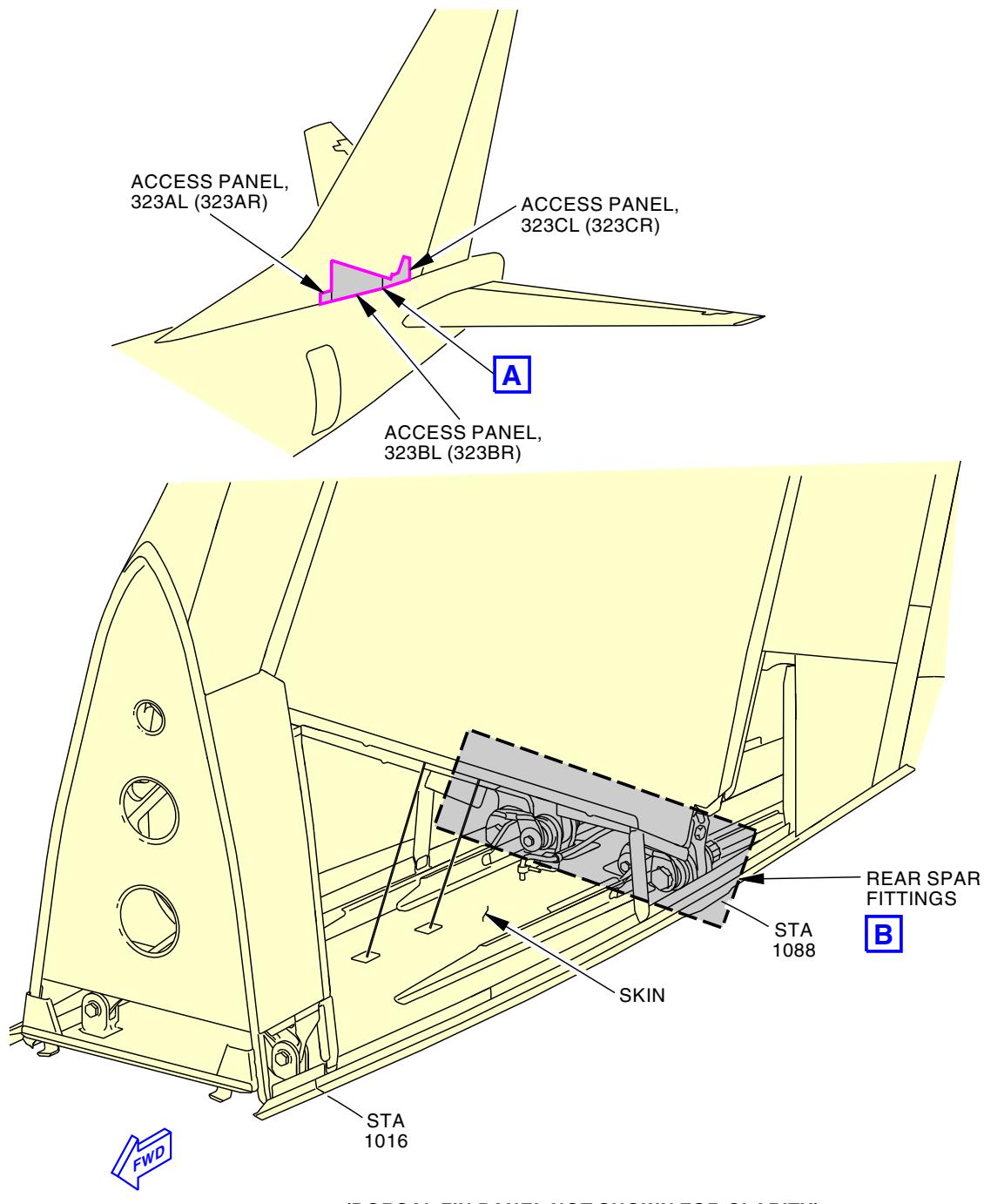
INTERNAL-GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING  
Figure 261/53-05-03-990-907 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM  
53-480-00

2084332 S0000438778\_V2

INTERNAL-GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING  
Figure 262/53-05-03-990-906 (Sheet 1 of 3)

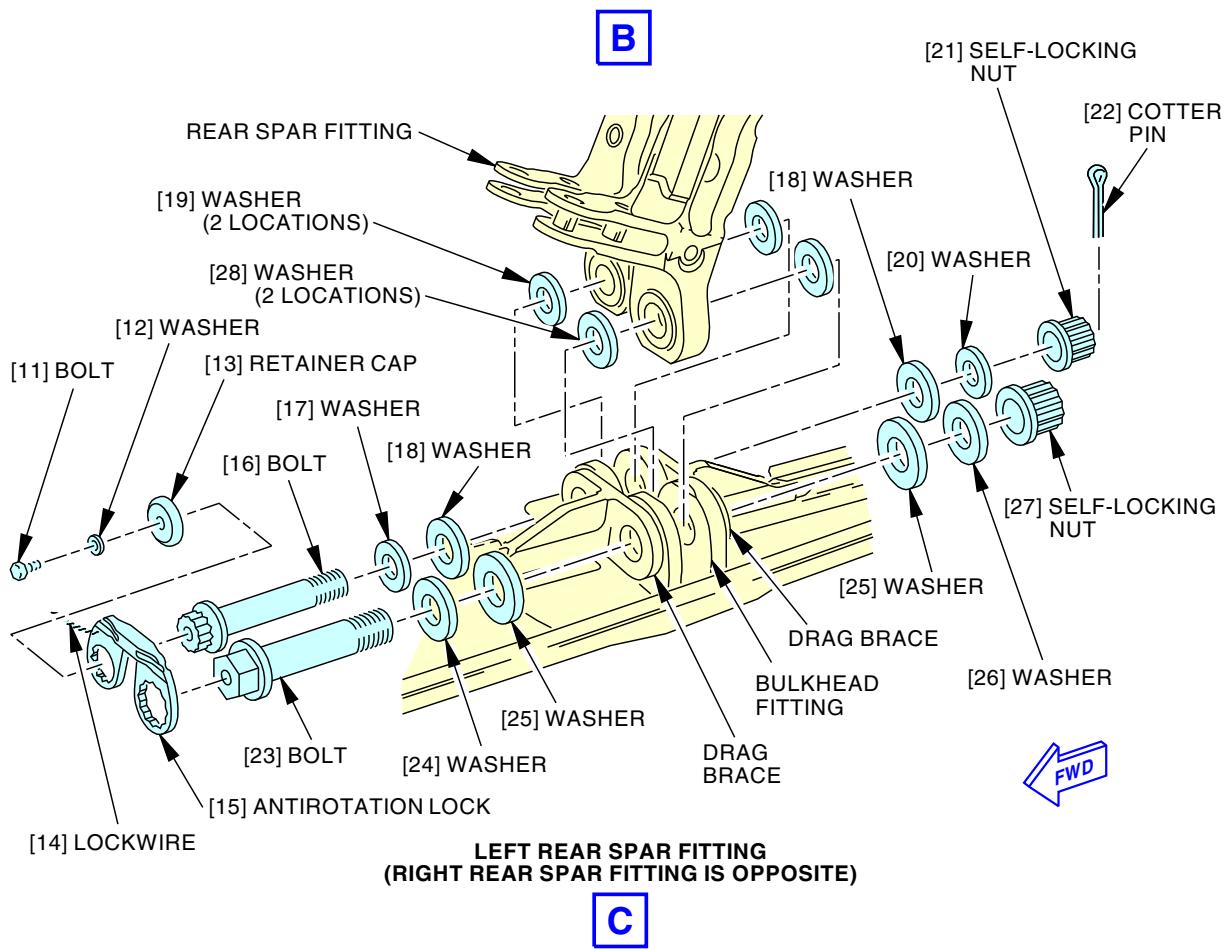
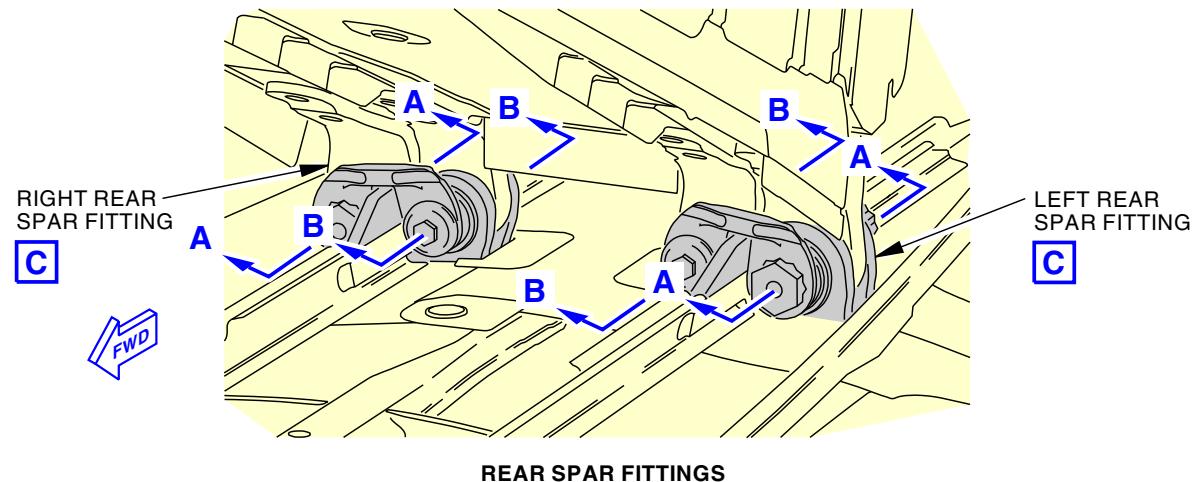
EFFECTIVITY  
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**53-05-03**

Page 298.96  
Feb 15/2025

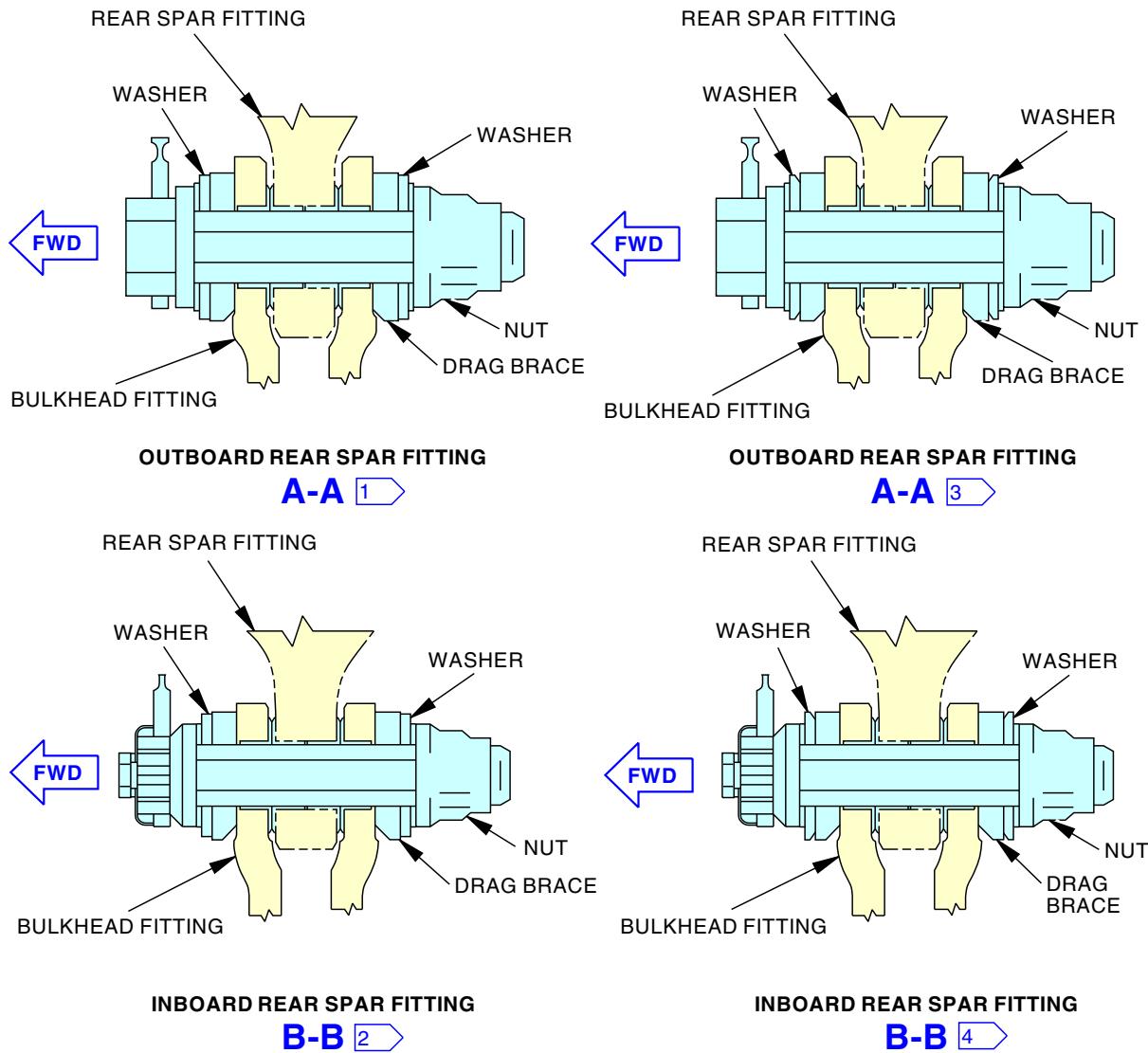


2928038 S0000707588\_V2

**INTERNAL-GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING**  
 Figure 262/53-05-03-990-906 (Sheet 2 of 3)

 EFFECTIVITY  
 LOM ALL

**53-05-03**


**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.

- 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

2928048 S0000707589\_V1

**INTERNAL-GENERAL VISUAL: VERTICAL FIN REAR SPAR FITTING**  
**Figure 262/53-05-03-990-906 (Sheet 3 of 3)**

 EFFECTIVITY  
 LOM ALL

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-05-03-210-861**

**56. INTERNAL - GENERAL VISUAL: FLIGHT COMPARTMENT FROM STA 178 TO 270**

NOTE: This procedure is a scheduled maintenance task.

**A. References**

<u>Reference</u>	<u>Title</u>
25-11-21-210-801	Inspection Access - P18 Panel (P/B 601)
25-11-21-210-802	Inspection Access - P5 Panel (P/B 601)

**B. Location Zones**

<u>Zone</u>	<u>Area</u>
211	Flight Compartment - Left
212	Flight Compartment - Right
221	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Left
222	Passenger Compartment - Aft of Control Compartment to Forward Entry Door - Right

**C. Access Panels**

<u>Number</u>	<u>Name/Location</u>
S2101	Flight Compartment Inspection

**D. Inspection**

SUBTASK 53-05-03-010-079

- (1) Special Access:

<u>Number</u>	<u>Name/Location</u>
S2101	Flight Compartment Inspection

NOTE: Removal of the glare shields, liners, overhead units, panels, rudder pedals and covers, forward galley, and forward lavatory is recommended to obtain maximum access to the area of inspection. Remove/displace insulation blankets as required. Removal of structure attached with permanent fasteners is not required to accomplish the intent of this inspection.

SUBTASK 53-05-03-020-001

- (2) To access inspection area behind P18 panel, do this task: Inspection Access - P18 Panel, TASK 25-11-21-210-801 up to Step 2. H.

SUBTASK 53-05-03-020-002

- (3) To access inspection area behind P5 panel, do this task: Inspection Access - P5 Panel, TASK 25-11-21-210-802 up to Step 3. H.

SUBTASK 53-05-03-210-049

- (4) Do a General Visual inspection of the flight compartment, including skin panels (skins, frames, stringers), circumferential skin and stringer splice, crew cabin window cutout structure, and forward pressure bulkhead within the following areas: Forward side of frame at STA 259.5 and structure 3 inches forward of STA 259.5; BL 0 + 4 inches (Left and Right); Forward and aft side of Frame 259.5 and structure from STA 249 to STA 263 between floor and S-5L (excluding window and window frame structure); Forward side of Frame 259.5 and structure 3 inches forward of STA 259.5 between floor and S-3R; Structure forward of STA 203.8 to STA 178 and from floor up to window frame; and skin, frames and stringers above P5 panel.

SUBTASK 53-05-03-910-077

- (5) 737-6789 Basic Task Description, AMM Task 51-05-01-210-808.

EFFECTIVITY  
LOM ALL

**53-05-03**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-05-03-410-074

- (6) To install the P18 panel, do this task: Inspection Access - P18 Panel, TASK 25-11-21-210-801, Step 2. H.

SUBTASK 53-05-03-410-075

- (7) To install the P5 panel, do this task: Inspection Access - P5 Panel, TASK 25-11-21-210-802, Step 3. H.

———— END OF TASK ————

— EFFECTIVITY —  
LOM ALL

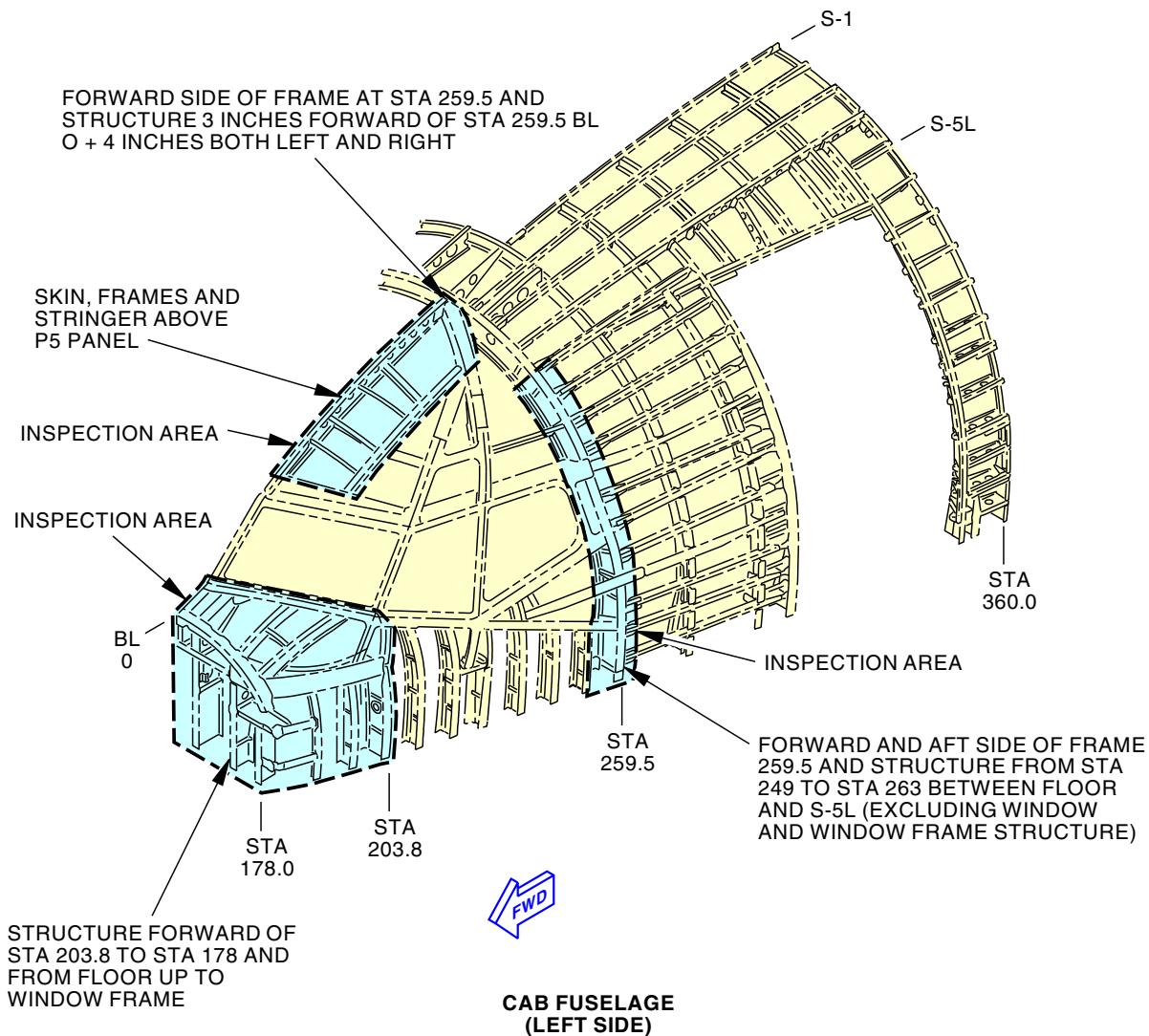
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Page 298.100  
Feb 15/2025

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737-600/700/800/900  
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MPD ITEM 53-335-00

2293154 S0000519282\_V2

**FLIGHT COMPARTMENT FROM STA 178 TO 270**  
**Figure 263/53-05-03-990-901 (Sheet 1 of 2)**

EFFECTIVITY  
LOM ALL

D633A101-LOM

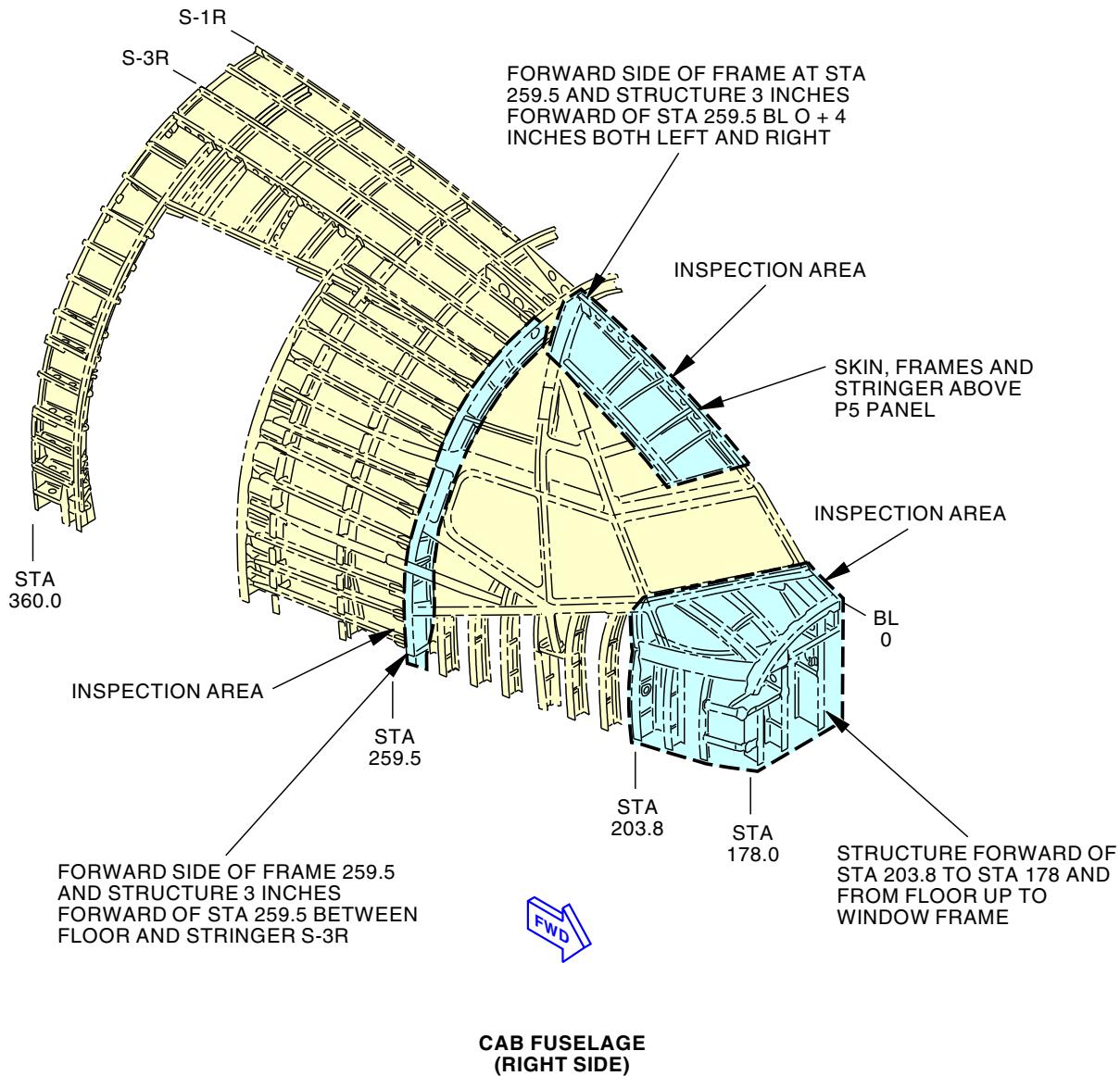
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**53-05-03**

Page 298.101  
Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM 53-335-00

2293157 S0000519280\_V3

**FLIGHT COMPARTMENT FROM STA 178 TO 270**  
**Figure 263/53-05-03-990-901 (Sheet 2 of 2)**

EFFECTIVITY  
LOM ALL

**53-05-03**

Page 298.102  
Feb 15/2025

D633A101-LOM



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

LOM 466-999

**TASK 53-05-03-210-862**

**57. INTERNAL - GENERAL VISUAL: CROWN SKIN PANEL**

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

**A. Inspect the skin and lug under the antenna base plate STA 727D to 727H+5, S-4L to S-4R.**

- (1) Remove the Broadband Radome. Broadband Radome Removal, TASK 53-54-00-000-801
- (2) Remove the Adapter Plate.
- (3) Do a General Visual inspection of the crown skin and lugs under the Ku antenna base plate.
- (4) 737-6789 Basic Task Description, AMM 737-6789 Basic Task Description, TASK 51-05-01-210-806.
- (5) Install the Adapter Plate.
- (6) Install the Broadband Radome. Broadband Radome Installation, TASK 53-54-00-400-801
- (7) Operation check of Ku band antenna system.

**B. References**

<b>Reference</b>	<b>Title</b>
51-05-01-210-806	737-6789 Basic Task Description (P/B 201)
53-54-00-000-801	Broadband Radome Removal (P/B 401)
53-54-00-400-801	Broadband Radome Installation (P/B 401)

**C. Location Zones**

<b>Zone</b>	<b>Area</b>
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-05-03**



737-600/700/800/900  
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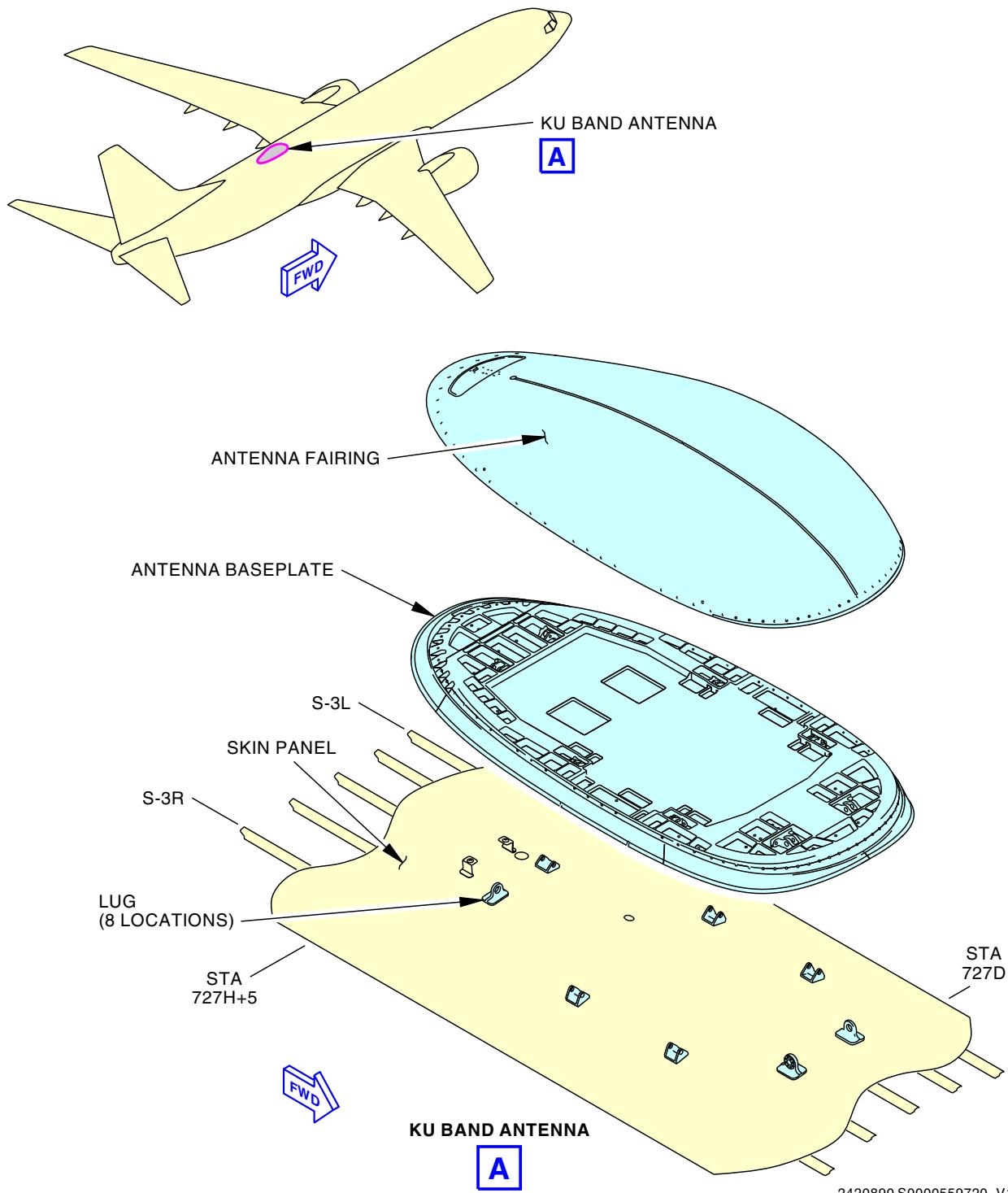


Figure 264/53-05-03-990-902

EFFECTIVITY  
LOM 466-999

**53-05-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

PASSENGER ENTRY DOOR SCUFF PLATE - REMOVAL/INSTALLATION

**1. General**

- A. This procedure contains these tasks:
- (1) The removal of the passenger entry door scuff plates.
  - (2) The installation of the passenger entry door scuff plates.

**TASK 53-11-01-000-801**

**2. Scuff Plate Removal**

(Figure 401, Figure 402, Figure 403, Figure 404)

**A. Tools/Equipment**

Reference	Description
STD-1064	Scraper - Phenolic, Hard Resin

**B. Consumable Materials**

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

**C. Location Zones**

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

**D. Scuff Plate Removal**

SUBTASK 53-11-01-020-001

- (1) Remove the scuff plate:

- (a) Remove the fasteners that attach the scuff plate to structure.
- (b) Use a hard resin phenolic scraper, STD-1064, to release the scuff plate from structure.
- (c) Remove the scuff plate.

**NOTE:** The door lining attached to the scuff plate is installed with a parting agent on the scuff plate for separation and removal of the scuff plate. It is possible to remove the door lining attached to the scuff plate with the scuff plate.



DO NOT GET SOLVENTS IN YOUR MOUTH, EYES, OR SKIN. DO NOT BREATHE FUMES FROM SOLVENTS. REFER TO PRODUCT MATERIAL SAFETY DATA SHEETS (MSDS) AND LOCAL REQUIREMENTS FOR PROPER HANDLING. SOLVENTS ARE HAZARDOUS MATERIALS AND MAY BE FLAMMABLE OR HARMFUL TO THE ENVIRONMENT. IF YOU DO NOT OBEY, INJURY TO PERSONNEL AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (d) Remove sealant and parting agent from faying surfaces with solvent, B00148, and hard resin phenolic scraper, STD-1064.
- (e) Do a visual inspection of the nut plates to determine if they are in acceptable condition.
  - 1) If it is necessary, replace them.

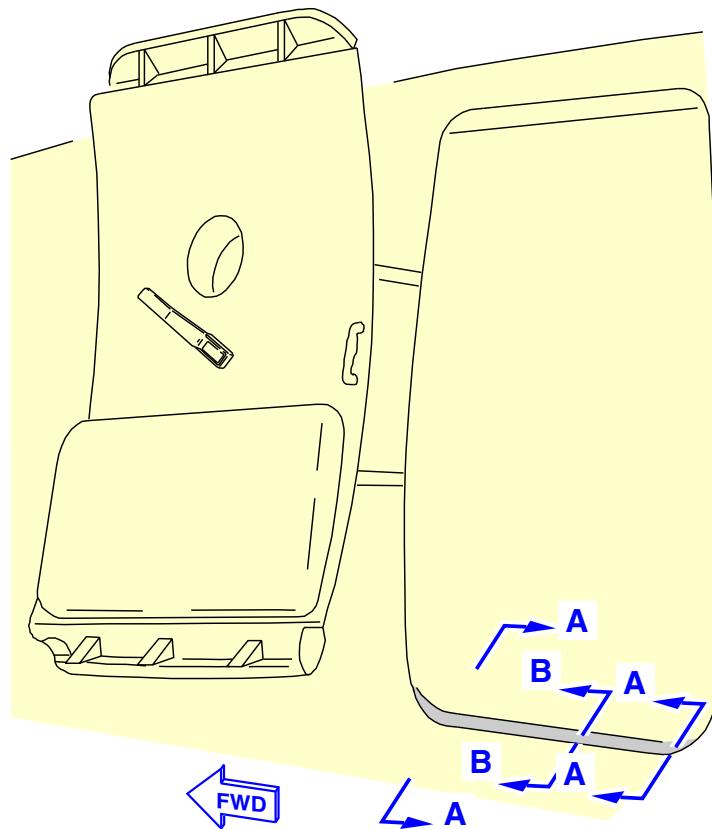
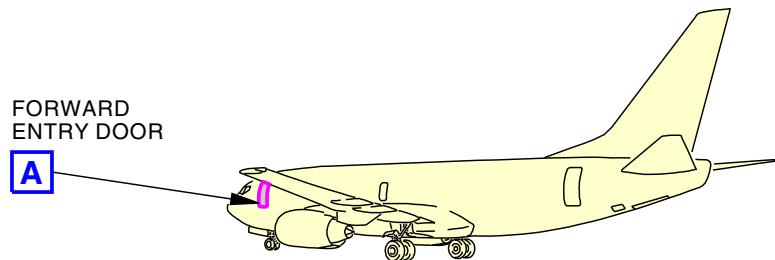
— END OF TASK —

EFFECTIVITY  
LOM ALL

**53-11-01**



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FORWARD ENTRY DOOR



M27503 S0006581002\_V2

**Forward Entry Door Scuff Plate Installation**  
**Figure 401/53-11-01-990-805 (Sheet 1 of 2)**

EFFECTIVITY  
LOM ALL

**53-11-01**

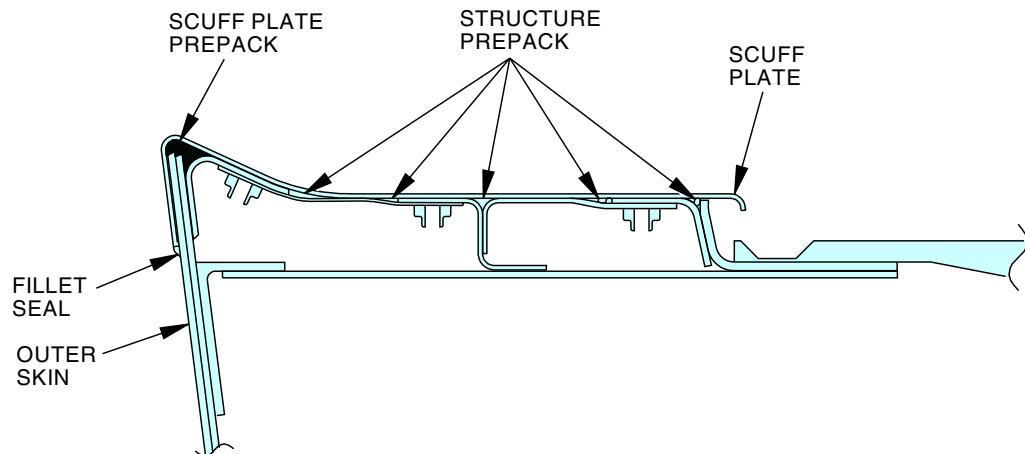
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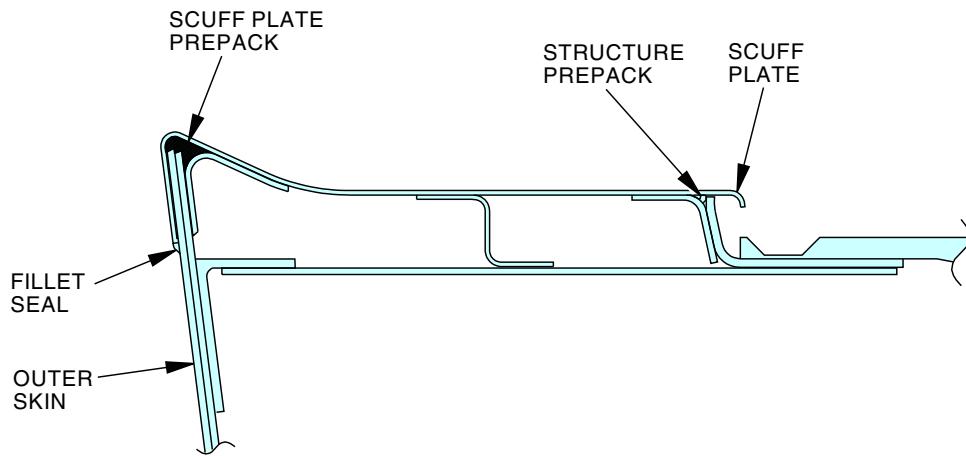
Page 402  
Feb 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



A-A



B-B

M27782 S0006581003\_V3

Forward Entry Door Scuff Plate Installation  
Figure 401/53-11-01-990-805 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

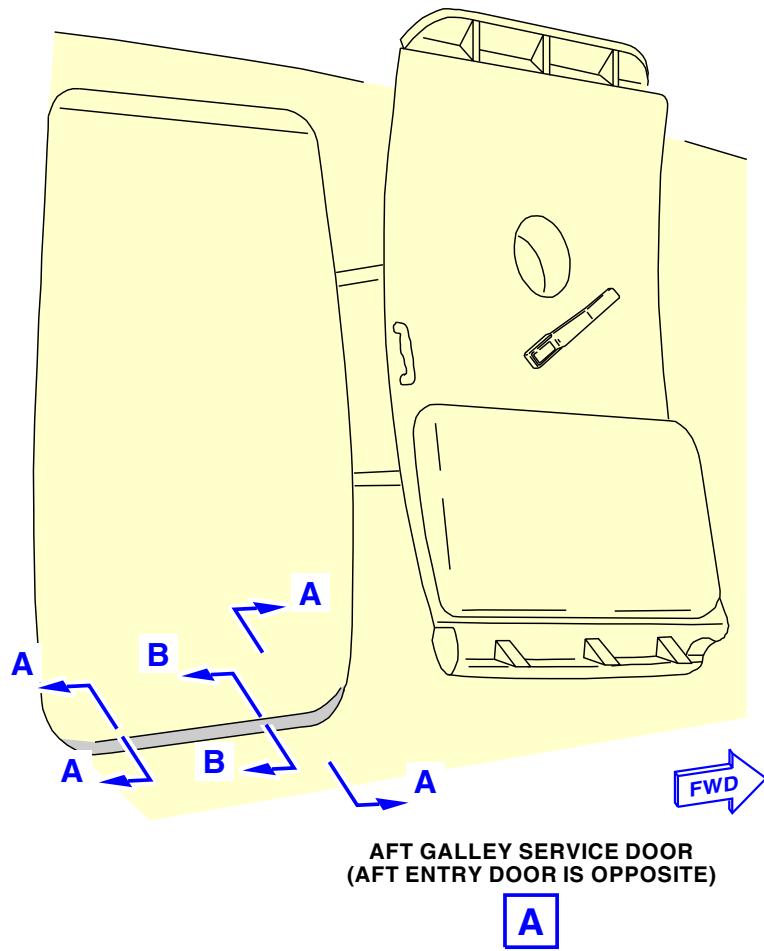
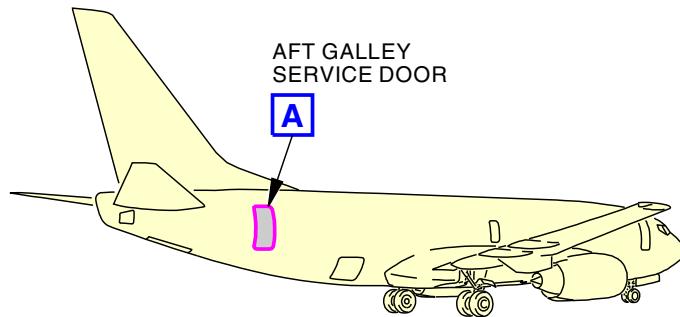
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 403  
Feb 15/2024

**BOEING**  
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AIRCRAFT MAINTENANCE MANUAL



AFT GALLEY SERVICE DOOR  
(AFT ENTRY DOOR IS OPPOSITE)

**A**

M27802 S0006581004\_V2

**Aft Galley Service Door and Aft Entry Door Scuff Plate Installation**  
**Figure 402/53-11-01-990-809 (Sheet 1 of 2)**

EFFECTIVITY  
LOM ALL

**53-11-01**

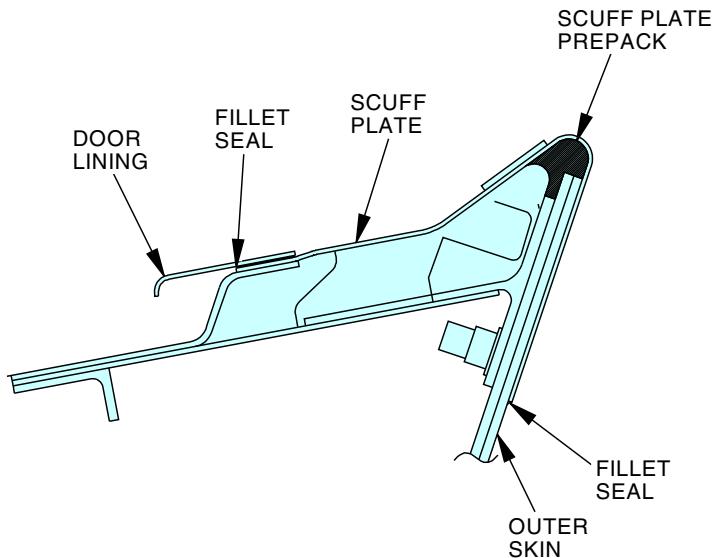
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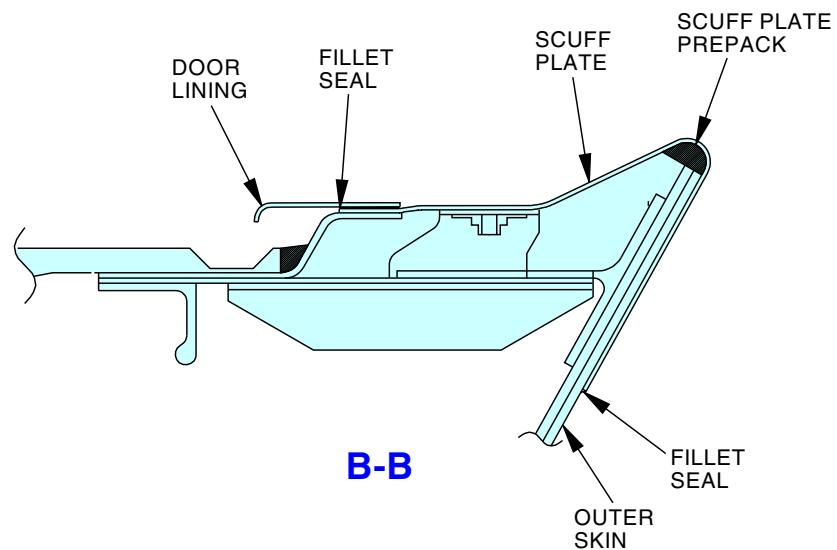
Page 404  
Feb 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



A-A



B-B

M27801 S0006581005\_V2

**Aft Galley Service Door and Aft Entry Door Scuff Plate Installation**  
**Figure 402/53-11-01-990-809 (Sheet 2 of 2)**

EFFECTIVITY  
LOM ALL

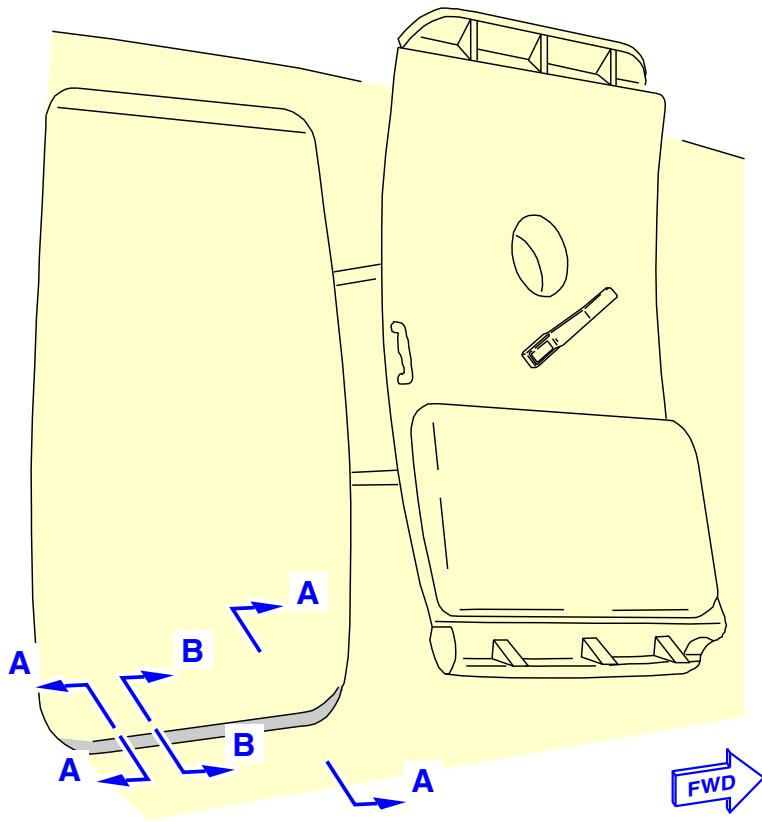
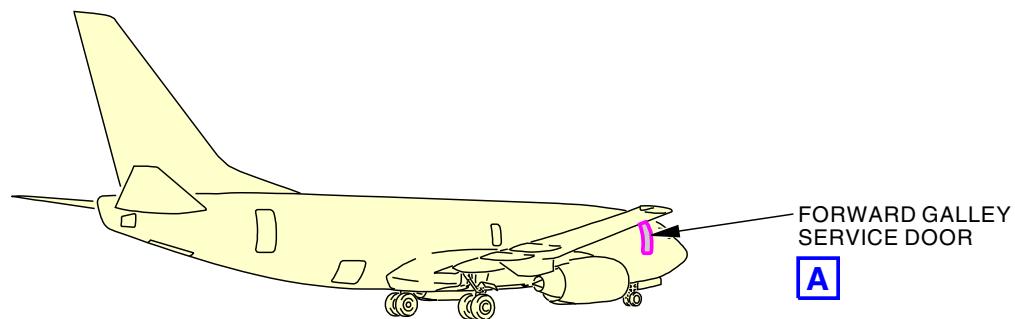
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Page 405  
Feb 15/2023

**BOEING**  
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AIRCRAFT MAINTENANCE MANUAL



M27808 S0006581006\_V2

**Forward Galley Service Door Scuff Plate Installation**  
**Figure 403/53-11-01-990-810 (Sheet 1 of 2)**

EFFECTIVITY  
LOM ALL

**53-11-01**

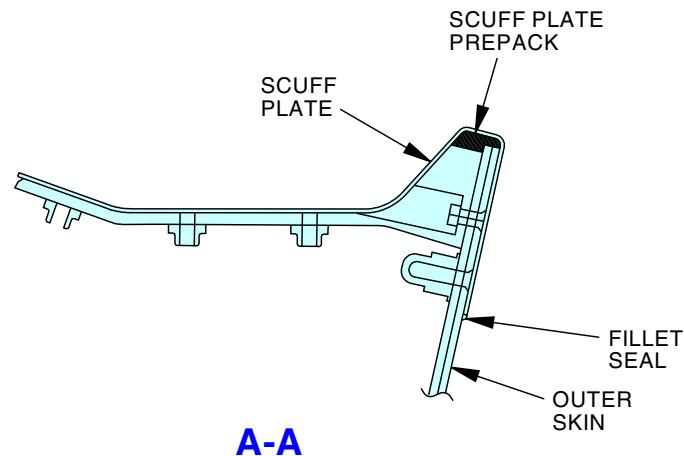
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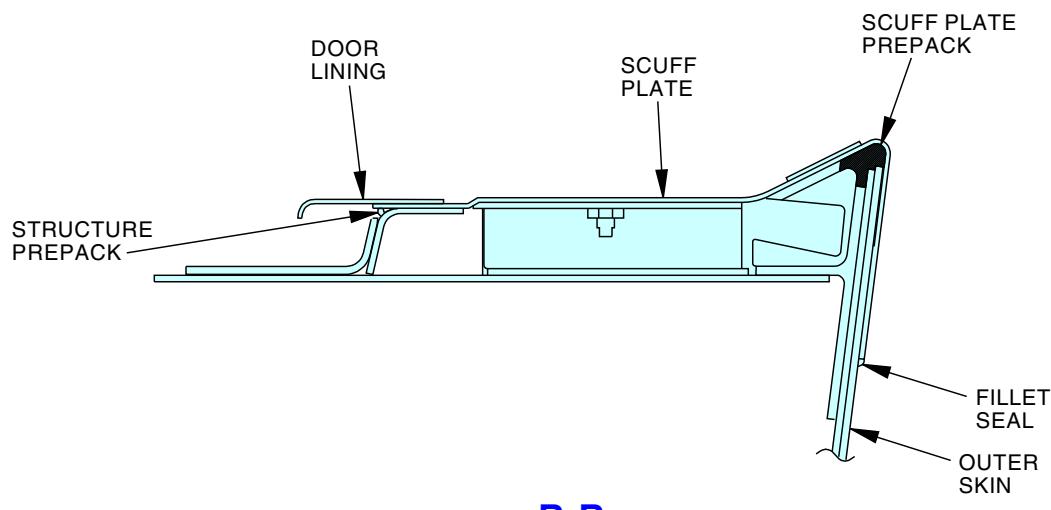
Page 406  
Feb 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



A-A



B-B

M27780 S0006581007\_V3

**Forward Galley Service Door Scuff Plate Installation**  
**Figure 403/53-11-01-990-810 (Sheet 2 of 2)**

EFFECTIVITY  
LOM ALL

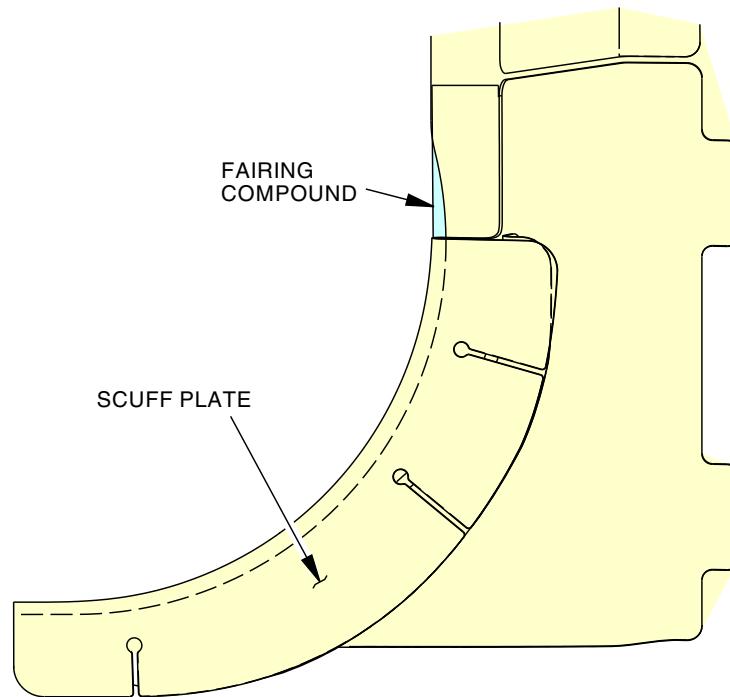
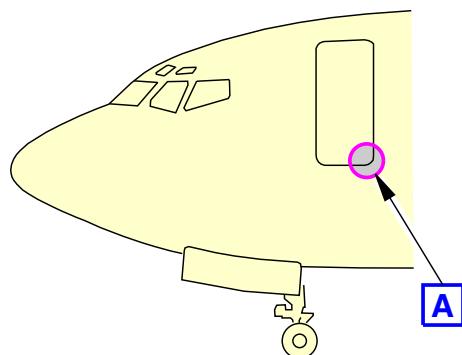
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Page 407  
Feb 15/2024

**BOEING**  
737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3018100 S0000790735\_V1

**Entry Door Scuff Plate Installation - Fairing Compound**  
Figure 404/53-11-01-990-811

EFFECTIVITY  
LOM ALL

D633A101-LOM

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**53-11-01**

Page 408  
Feb 15/2023



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-11-01-420-801**

**3. Scuff Plate Installation**

(Figure 401, Figure 402, Figure 403, Figure 404)

**A. References**

Reference	Title
51-21-41-370-802	Bonderite M-CR 600 Aero, Bonderite M-CR Alcrm 1200 Aero or Bonderite M-CR 1200S Aero Application Process (P/B 701)

**B. Consumable Materials**

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A01024	Compound - Fairing - 3M EC-3587B	BAC5530
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
D00504	Grease - Petrolatum	VV-P-236
G02185	Agent - Peelable Parting (Valspar - 4A-183 Green Strippable Coating)Manufacturing discontinued, use stock until depleted	
G02497	Agent - Non-Peelable Parting (Henkel Loctite - Frekote 700-NC Mold Release)	BAC5000
G50313	Agent - Non-Peelable Parting (Henkel Loctite - Frekote 710-NC Mold Release)	BAC5000
G50365	Agent - Peelable Parting (AC Products - AC962-73C) Production discontinued, use stock until depleted.	BAC5000
G50366	Agent - Parting, Peelable, AZ 534-2B (0A3C8 - Aztec Chemical, Inc., El Monte, CA)	BAC5000, PSD 6-187
G50367	Agent - Peelable Parting (Aztec Chemical AZ 634-2)	MIL-PRF-6799, BAC5000
G50368	Agent - Peelable Parting (Rexco Chemical Company - Partall Coverall Film)	BAC5000
G50369	Coating - Alkaline Removable, Water Resistant	BMS15-12 Type I Class 1

**C. Location Zones**

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

**D. Scuff Plate Installation**

SUBTASK 53-11-01-110-001

- (1) Install the scuff plate:

EFFECTIVITY
LOM ALL

**53-11-01**



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- (a) If it is necessary, clean all faying surfaces with a solvent, B00148.
- (b) Apply MIL-C-81706, class 1A, form II chemical conversion coating, and two coats of primer, C00259, to exposed metal surfaces of the outer skin that will be under the scuff plate (TASK 51-21-41-370-802).
- (c) Apply a coat of parting agent to the bottom side of the scuff plate and the outer skin.
- (d) Preferred peelable AC962-73C peelable parting agent, G50365.
  - 1) Alternate Valspar 4A-183 green strippable coating, G02185
  - 2) Alternate peelable parting agent, G50366
  - 3) Alternate AZ 634-2 peelable parting agent, G50367
  - 4) Alternate Rexco Partall Coverall Film peelable parting agent, G50368
  - 5) Alternate temporary coating, G50369
  - 6) Alternate Frekote 710-NC non-peelable parting agent, G50313
  - 7) Alternate grease, D00504.
- (e) Prepack the scuff plate in the area shown with sealant, A00247, minimum 0.35 in. (8.9 mm) thick.
- (f) Prepack the structure in the areas shown with sealant, A00247.
- (g) Apply sealant, A00247, to the structure surface that will touch the scuff plate.
- (h) Install the scuff plate.
- (i) If a new door lining will be installed on the scuff plate, do these steps:
  - 1) Apply sealant, A00247, to the area of the door lining that will touch the scuff plate.
  - 2) Apply Frekote 700-NC non-peelable parting agent, G02497, or grease, D00504, to the area of the scuff plate that will touch the door lining.
  - 3) Install the door lining on the scuff plate.
- (j) Apply primer, C00259, to the fastener holes.
- (k) Make sure that the primer, C00259, is dry before the fasteners are installed.
- (l) Install the fasteners wet with compound, C00528.
- (m) Remove excess sealant from the edges of the scuff plate.
- (n) FOR FORWARD ENTRY DOOR;  
Fill gaps and fastener recesses with sealant, A00247, and fair flush with adjacent surfaces.
- (o) FOR AFT ENTRY DOOR AND GALLEY SERVICE DOORS;  
Fill gaps and fastener recesses with 3M EC-3587B compound, A01024, and fair flush with the adjacent surfaces.
- (p) FOR FORWARD ENTRY DOOR AND FORWARD GALLEY SERVICE DOOR;

EFFECTIVITY  
LOM ALL

53-11-01



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

Fill forward and aft edges of the scuff plate with 3M EC-3587B compound, A01024, and fair flush with adjacent surfaces.

NOTE: This will provide a smooth surface for the door seal.

- (q) FOR AFT ENTRY DOOR AND AFT GALLEY SERVICE DOOR;

Fill forward and aft edges of the scuff plate with sealant, A00247, and fair flush with adjacent surfaces.

NOTE: This will provide a smooth surface for the door seal.

- (r) FOR FORWARD ENTRY DOOR;

Apply sealant, A00247, (aero-smoother), around scuff plate.

- (s) FOR FORWARD GALLEY SERVICE DOOR;

Apply sealant, A00247, (aero-smoother), around scuff plate at a 6 to 1 taper ratio.

- (t) FOR AFT ENTRY AND AFT GALLEY SERVICE DOORS;

Apply sealant, A02315, fillet seal around the scuff plate.

- (u) FOR AFT ENTRY AND AFT GALLEY SERVICE DOORS;

Fill slots at forward area of the scuff plate with sealant, A00247, and fair flush with adjacent surfaces.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-11-01**





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CARGO DOOR SCUFF PLATE - REMOVAL/INSTALLATION

**1. General**

- A. This procedure has these tasks:
  - (1) A removal of the cargo door scuff plate
  - (2) An installation of the cargo door scuff plate.
- B. All the installations of the scuff plates are almost the same.
- C. The clearances between the scuff plates and airplane structure are sealed for aerodynamic smoothness.

**TASK 53-11-02-020-801**

**2. Cargo Door Scuff Plate Removal**

(Figure 401)

**A. References**

Reference	Title
51-31-00 P/B 201	SEALS AND SEALING - MAINTENANCE PRACTICES

**B. Tools/Equipment**

Reference	Description
STD-1064	Scraper - Phenolic, Hard Resin

**C. Consumable Materials**

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

**D. Location Zones**

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

**E. Cargo Door Scuff Plate Removal**

SUBTASK 53-11-02-020-003

- (1) Remove the filler scuff plate [1].



DO NOT USE METAL TOOLS TO REMOVE THE SEALANT. AN APPROVED TOOL WILL PREVENT DAMAGE TO THE SKIN OF THE AIRCRAFT.

- (a) Use a hard resin phenolic scraper, STD-1064, to release the filler scuff plate [1] from the structure.
- (b) Remove the filler scuff plate [1] away from the plane.

EFFECTIVITY  
LOM ALL

**53-11-02**



737-600/700/800/900  
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SUBTASK 53-11-02-020-001



**WARNING**

DO NOT GET SOLVENTS IN YOUR MOUTH, YOUR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. SOLVENTS ARE DANGEROUS MATERIALS. SOLVENTS CAN BE FLAMMABLE. OBEY THE MATERIAL SAFETY DATA SHEETS (MSDS) FOR SOLVENTS. OBEY LOCAL REGULATIONS FOR THE CORRECT PROCEDURES TO USE OR DISCARD SOLVENTS. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (2) Remove the scuff plate [4].

- (a) Remove the screws [5] that attach the scuff plate [4] to the structure.



**CAUTION**

DO NOT USE METAL TOOLS TO REMOVE THE SEALANT. AN APPROVED TOOL WILL PREVENT DAMAGE TO THE SKIN OF THE AIRCRAFT.

- (b) Use a hard resin phenolic scraper, STD-1064, to release the scuff plate [4] from the structure.  
(c) Remove the scuff plate [4] away from the airplane.  
(d) Remove the filler scuff plate [6] from the structure.  
(e) Use a hard resin phenolic scraper, STD-1064, to release the filler scuff plate [6] from structure.

**LOM 411, 412, 415, 416, 420, 422-434, 437-447, 450-999; LOM 402, 404, 406, 407 POST SB  
737-53-1276**

- (e) Remove the gasket [9] from the structure.

**LOM ALL**



**WARNING**

DO NOT GET SOLVENTS IN YOUR MOUTH, YOUR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. SOLVENTS ARE DANGEROUS MATERIALS. SOLVENTS CAN BE FLAMMABLE. OBEY THE MATERIAL SAFETY DATA SHEETS (MSDS) FOR SOLVENTS. OBEY LOCAL REGULATIONS FOR THE CORRECT PROCEDURES TO USE OR DISCARD SOLVENTS. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.



**CAUTION**

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

- (3) Remove the sealant and parting agent from mating surfaces with solvent, B00148, and a hard resin phenolic scraper, STD-1064 (PAGEBLOCK 51-31-00/201).  
(4) Do a visual inspection of the nut plates [11] to find if they are in a satisfactory condition.  
(a) If it is necessary, replace the nut plates [11].

SUBTASK 53-11-02-020-004

- (5) Remove the forward and aft scuff plates [2].

- (a) Remove the screws [3] that attach the scuff plate [2] to the structure.

EFFECTIVITY  
**LOM ALL**

**53-11-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**



**CAUTION**  
DO NOT USE METAL TOOLS TO REMOVE THE SEALANT. AN APPROVED TOOL WILL PREVENT DAMAGE TO THE SKIN OF THE AIRCRAFT.

- (b) Use a hard resin phenolic scraper, STD-1064, to release the scuff plate [2] from the structure.
- (c) Remove the scuff plate [2] away from the plane.

SUBTASK 53-11-02-020-005

- (6) Remove the scuff plate [7].
  - (a) Remove the screws [8] that attach the scuff plate [7] to the structure.



**CAUTION**  
DO NOT USE METAL TOOLS TO REMOVE THE SEALANT. AN APPROVED TOOL WILL PREVENT DAMAGE TO THE SKIN OF THE AIRCRAFT.

- (b) Use a hard resin phenolic scraper, STD-1064, to release the scuff plate [7] from the structure.
- (c) Remove the scuff plate [7] from the structure.

**LOM 411, 412, 415, 416, 420, 422-434, 437-447, 450-999; LOM 402, 404, 406, 407 POST SB  
737-53-1276**

- (d) Remove the gasket [12] and gel tape [10] from the structure.

**LOM ALL**

———— END OF TASK ————

———— EFFECTIVITY ————  
**LOM ALL**

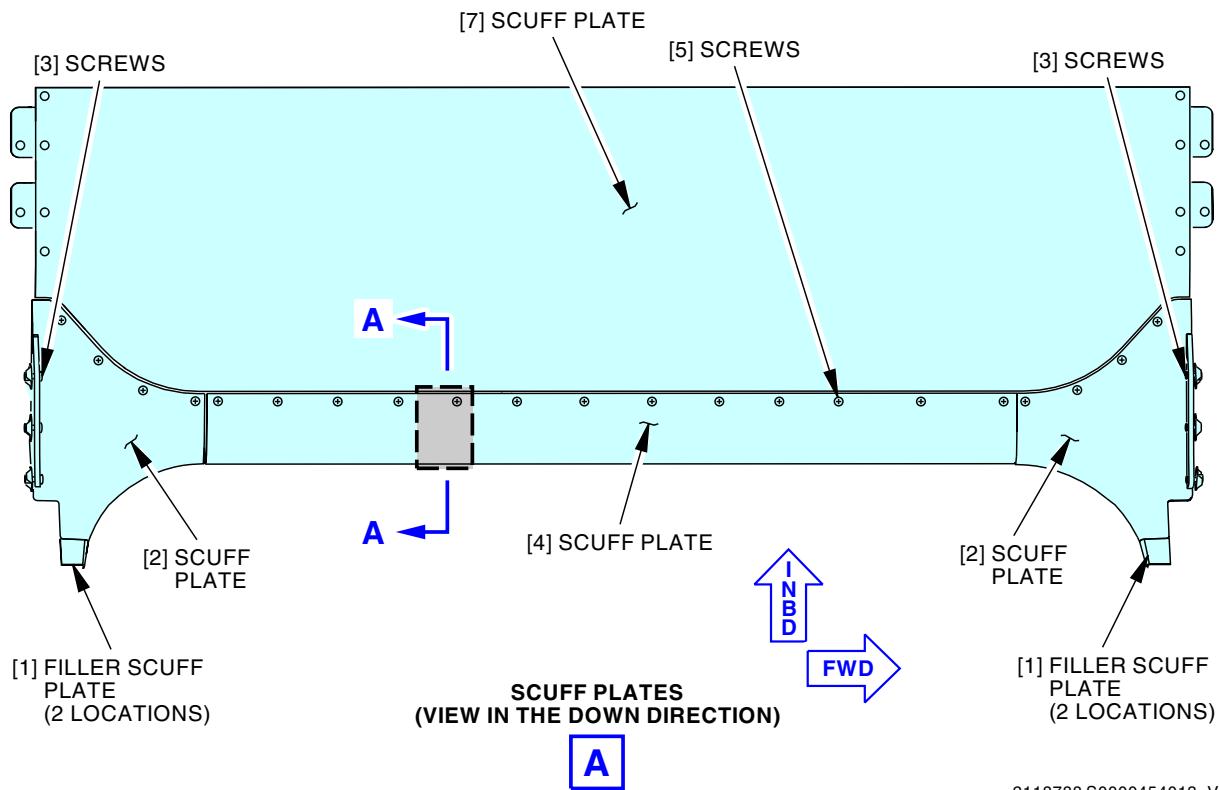
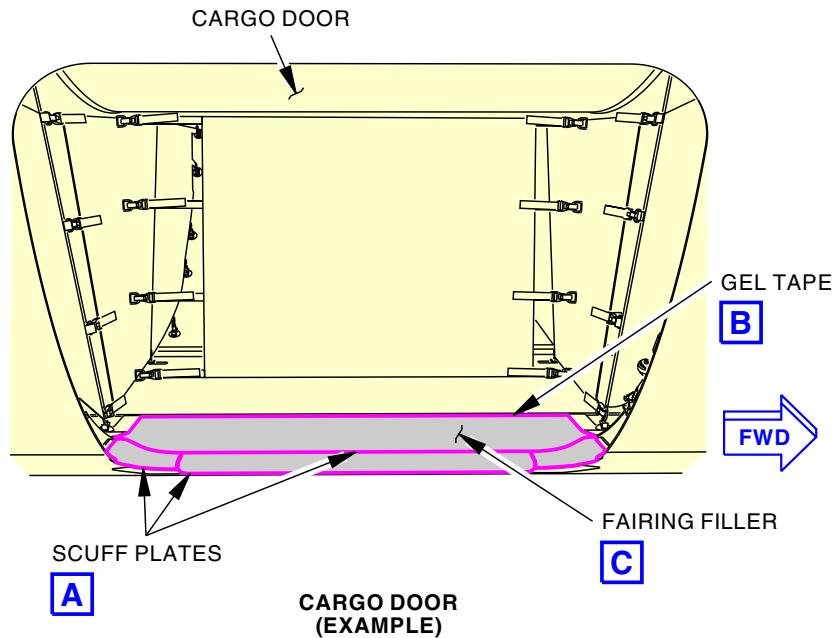
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Page 403  
Oct 15/2024

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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



2118788 S0000454013\_V3

Cargo Door Scuff Plate Installation  
Figure 401/53-11-02-990-802 (Sheet 1 of 6)

EFFECTIVITY  
LOM 411, 412, 415, 416, 420, 422-434, 437-447,  
450-999; LOM 402, 404, 406, 407 POST SB  
737-53-1276

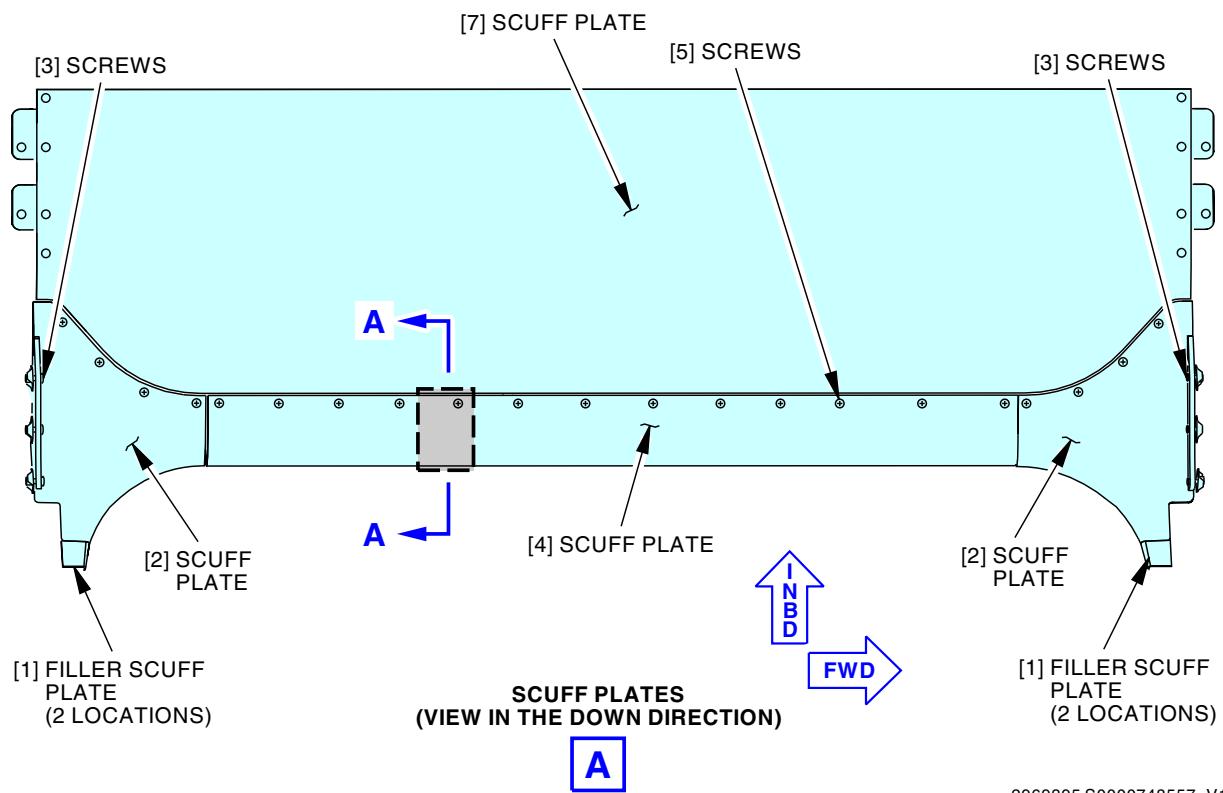
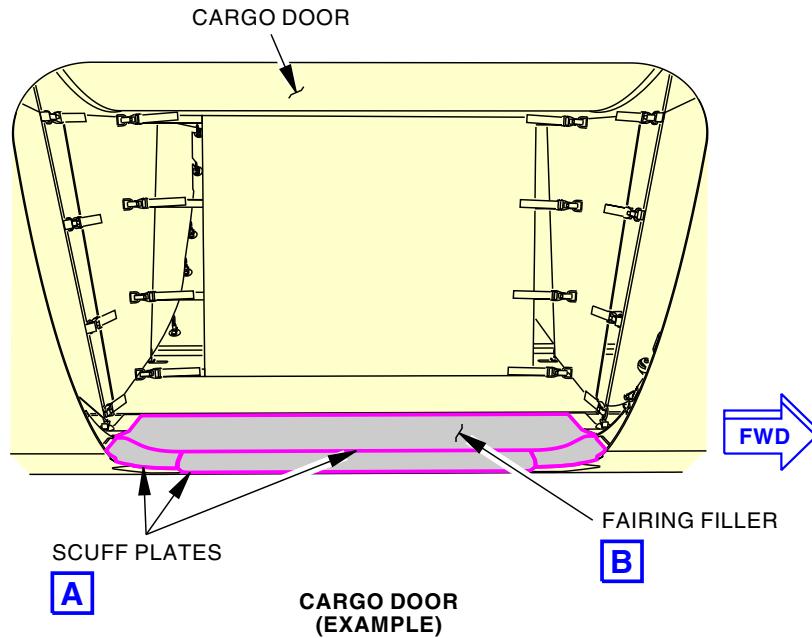
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2969395 S0000748557\_V1

Cargo Door Scuff Plate Installation  
Figure 401/53-11-02-990-802 (Sheet 2 of 6)

EFFECTIVITY  
LOM 402, 404, 406, 407 PRE SB 737-53-1276

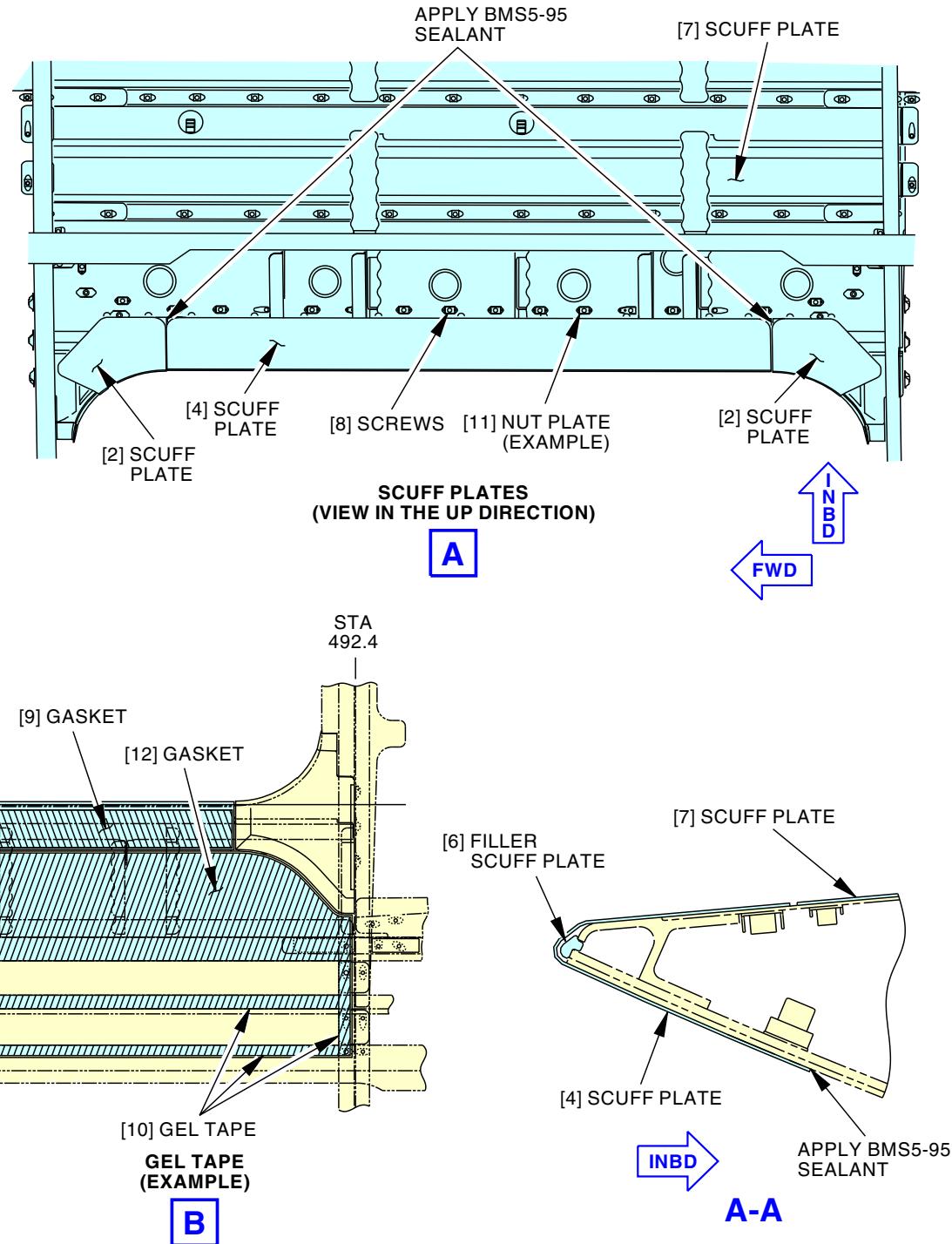
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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



2120999 S0000454014\_V4

Cargo Door Scuff Plate Installation  
Figure 401/53-11-02-990-802 (Sheet 3 of 6)

EFFECTIVITY  
LOM 411, 412, 415, 416, 420, 422-434, 437-447,  
450-999; LOM 402, 404, 406, 407 POST SB  
737-53-1276

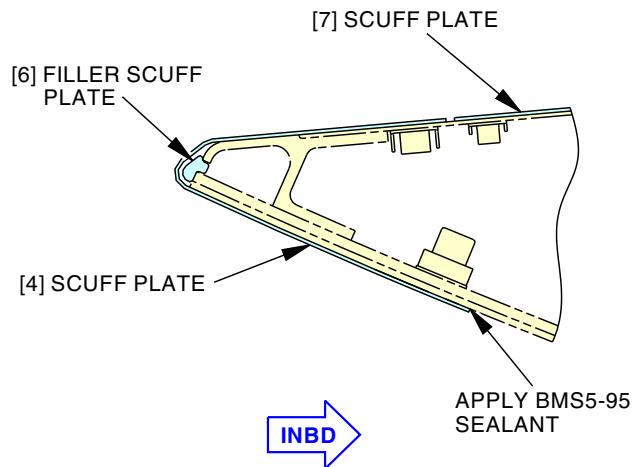
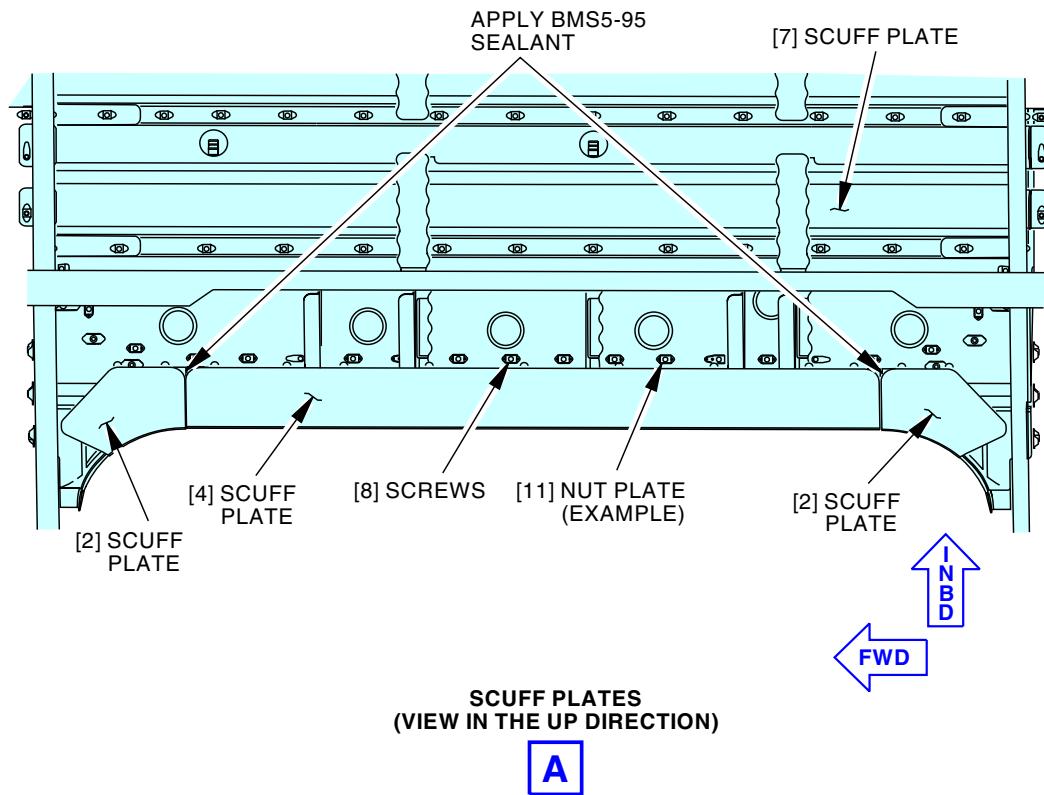
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ECCN 9E991 BOEING PROPRIETARY - See title page for details



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AIRCRAFT MAINTENANCE MANUAL



A-A

2470912 S0000578432\_V2

Cargo Door Scuff Plate Installation  
Figure 401/53-11-02-990-802 (Sheet 4 of 6)

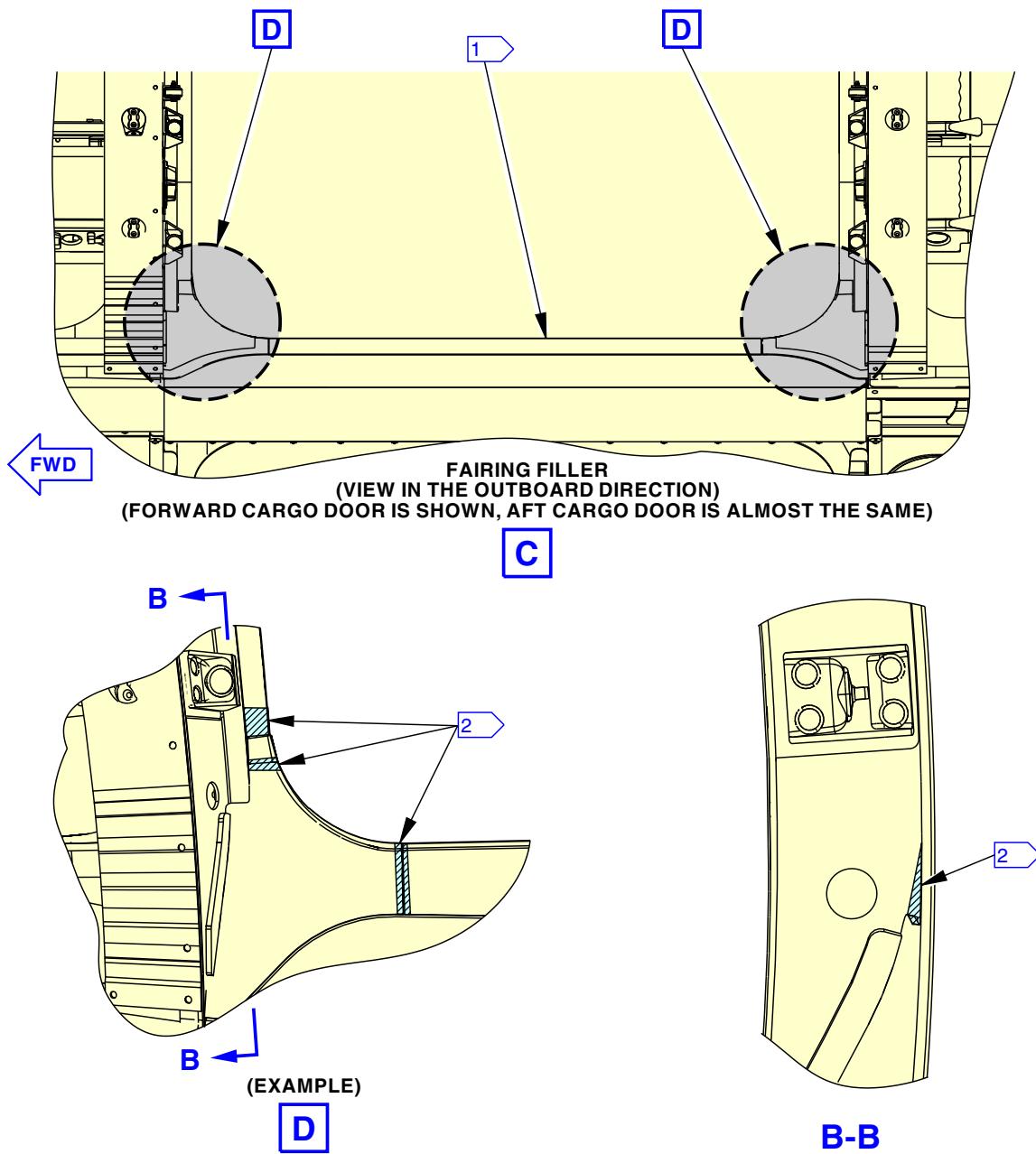
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**53-11-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 407  
Oct 15/2021



FAIRING COMPOUND

1 FILL FLUSH FASTENER RECESS FOR OUTBOARD FASTENER ROW COMMON TO THE DOOR SEAL PLANE/INTERFACE ONLY.

2 FILL THE GAPS AND MISMATCHES.

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**Cargo Door Scuff Plate Installation**  
**Figure 401/53-11-02-990-802 (Sheet 5 of 6)**

EFFECTIVITY  
LOM 411, 412, 415, 416, 420, 422-434, 437-447,  
450-999; LOM 402, 404, 406, 407 POST SB  
737-53-1276

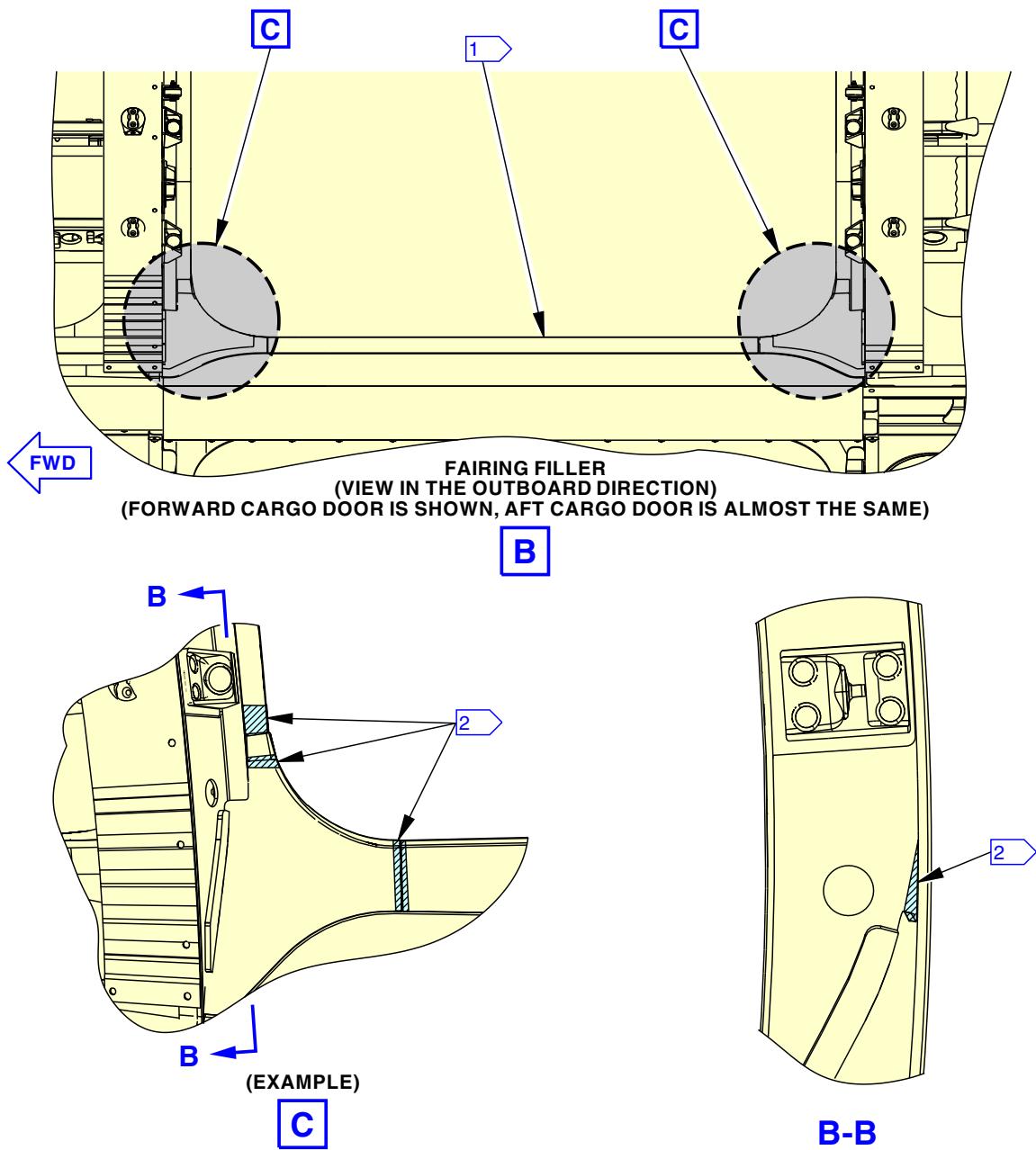
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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



FAIRING COMPOUND

1 FILL FLUSH FASTENER RECESS FOR OUTBOARD FASTENER ROW COMMON TO THE DOOR SEAL PLANE/INTERFACE ONLY.

2 FILL THE GAPS AND MISMATCHES.

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Cargo Door Scuff Plate Installation  
Figure 401/53-11-02-990-802 (Sheet 6 of 6)

EFFECTIVITY  
LOM 402, 404, 406, 407 PRE SB 737-53-1276

**53-11-02**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 409  
Oct 15/2021



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-11-02-420-801**

**3. Cargo Door Scuff Plate Installation**

(Figure 401)

**A. General**

- (1) This task gives the instructions to install the cargo door scuff plate.

**B. References**

Reference	Title
20-30-88-910-801	Final Cleaning of Metal Prior to Non-structural Bonding (Series 88) (P/B 201)
51-31-00 P/B 201	SEALS AND SEALING - MAINTENANCE PRACTICES

**C. Consumable Materials**

Reference	Description	Specification
A01024	Compound - Fairing - 3M EC-3587B	BAC5530
A50250	Sealant - P/S 870 Class B-1/2 Corrosion Inhibitive Sealant	BMS5-95 Class B-1/2
A50343	Sealant - PPG Aerospace PR-1772 Class B Low Weight Fuselage Sealant	BMS5-142 Type II Class B
A50479	Sealant - P/S 870 Class B-2 Corrosion Inhibitive Sealant	BMS5-95 Class B-2
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
B00666	Solvent - Methyl Propyl Ketone	BMS11-9
D00504	Grease - Petrolatum	VV-P-236
G00009	Compound - Organic Corrosion Inhibiting Agent - Peelable Parting (Valspar - 4A-183 Green Strippable Coating)Manufacturing discontinued, use stock until depleted	BMS3-23
G02185	Agent - Non-Peelable Parting (Henkel Loctite - Frekote 710-NC Mold Release)	BAC5000
G50313	Agent - Peelable Parting (AC Products - AC962-73C) Production discontinued, use stock until depleted.	BAC5000
G50365	Agent - Parting, Peelable, AZ 534-2B (0A3C8 - Aztec Chemical, Inc., El Monte, CA)	BAC5000, PSD 6-187
G50367	Agent - Peelable Parting (Aztec Chemical AZ 634-2)	MIL-PRF-6799, BAC5000
G50368	Agent - Peelable Parting (Rexco Chemical Company - Partall Coverall Film)	BAC5000
G50369	Coating - Alkaline Removable, Water Resistant	BMS15-12 Type I Class 1
G50734	Tape - Flame Retardant Hi-Tak (Av-DEC - HI-TAK HT3935-7FR-XXX)	

EFFECTIVITY  
LOM ALL

**53-11-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**D. Expendables/Parts**

AMM Item	Description	AIPC Reference	AIPC Effectivity
9	Gasket	53-13-00-05A-120	LOM 402, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-999
12	Gasket	53-13-00-08-220 53-13-00-05A-125	LOM ALL LOM 402, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-999
		53-13-00-08-225	LOM ALL

**E. Location Zones**

Zone	Area
821	Forward Cargo Door
822	Aft Cargo Door

**F. Cargo Door Scuff Plate Installation**

SUBTASK 53-11-02-420-001

- (1) Install the scuff plate [7].



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- (a) Clean all mating surfaces with solvent, B00184, or solvent, B00666 (TASK 20-30-88-910-801).
- (b) Apply one layer of corrosion inhibiting compound, G00009, to the surface of the structure.
- (c) Install the new gasket [12] as follows:
 

NOTE: For the new gasket (143A8335-2) use one piece of the HI-TAK Tape, G50734, 8 in. (20 cm) x 52 in. (132 cm).

NOTE: For the new gasket (146A8335-2) use one piece of the HI-TAK Tape, G50734, 8 in. (20 cm) x 52.5 in. (133 cm).

  - 1) Install the gasket [12] that its outboard edge aligns with the outboard edge of the holes used to attach the scuff plate [7].
- (d) Install the gel tape [10] (HI-TAK Tape, G50734) as follows:
  - 1) Install the forward edge of the gel tape [10] (HI-TAK Tape, G50734) to align with the forward edge of the scuff plate [7] attach holes.
  - 2) Install the inboard edge of the gel tape [10] (HI-TAK Tape, G50734) to align with the inboard edge of the scuff plate [7] attach holes.

EFFECTIVITY
LOM ALL

**53-11-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**LOM 411, 412, 415, 416, 420, 422-434, 437-447, 450-999; LOM 402, 404, 406, 407 POST SB 737-53-1276  
(Continued)**

- 3) Install the aft edge of the gel tape [10] (HI-TAK Tape, G50734) to align with the aft edge of the scuff plate [7] attach holes.
- 4) Install the middle strip of the gel tape [10] (HI-TAK Tape, G50734) on the center of the rail.

NOTE: The gel tape (HI-TAK Tape, G50734) can overhang toward the center of the scuff plate.

**LOM ALL**

- (e) Install the scuff plate [7] in its position.
- (f) Install the screws [8] that attach the scuff plate [7] to the structure.
  - 1) Apply P/S 870 Class B-1/2 sealant, A50250, or P/S 870 Class B-2 sealant, A50479, to the screws [8].
  - 2) Tighten the screws [8] to 18 in-lb (2 N·m) to 22 in-lb (2 N·m).

SUBTASK 53-11-02-420-003

- (2) Install the forward and aft scuff plates [2].



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- (a) Clean all mating surfaces with solvent, B00148, or solvent, B00666 (TASK 20-30-88-910-801).
- (b) Apply one layer of corrosion inhibiting compound, G00009, to the structure and the skin area.
- (c) Apply two layers of parting agent to the scuff plates in all areas of a mating surface (PAGEBLOCK 51-31-00/201).
  - 1) Use AC962-73C peelable parting agent, G50365 (preferred), or one of these parting agents:
    - a) Optional Valspar 4A-183 green strippable coating, G02185
    - b) Optional peelable parting agent, G50366
    - c) Optional AZ 634-2 peelable parting agent, G50367
    - d) Optional Rexco Partall Coverall Film peelable parting agent, G50368
    - e) Optional temporary coating, G50369
    - f) Optional Frekote 710-NC non-peelable parting agent, G50313
    - g) Optional grease, D00504.
- (d) Apply a fay surface seal between the skin and the forward and aft scuff plate [2] with P/S 870 Class B-1/2 sealant, A50250, or P/S 870 Class B-2 sealant, A50479.
- (e) Install the forward and aft scuff plate [2] in its position.
- (f) Install the screws [3] that attach the scuff plate [2] to the structure.

EFFECTIVITY  
**LOM ALL**

**53-11-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 1) Apply P/S 870 Class B-1/2 sealant, A50250, or P/S 870 Class B-2 sealant, A50479, to the screws [3].
  - 2) Tighten the screws [3] to 18 in-lb (2 N·m) to 22 in-lb (2 N·m).
- (g) Install the filler scuff plates [1].



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- (h) Clean all mating surfaces with solvent, B00148, or solvent, B00666 (TASK 20-30-88-910-801).
- (i) Bond the filler scuff plate [1] to the structure with P/S 870 Class B-1/2 sealant, A50250, or P/S 870 Class B-2 sealant, A50479.

SUBTASK 53-11-02-420-002

- (3) Install the scuff plate [4].



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- (a) Clean all mating surfaces with solvent, B00148, or solvent, B00666 (TASK 20-30-88-910-801).
- (b) Apply one layer of corrosion inhibiting compound, G00009, to the structure and the skin area.

**LOM 411, 412, 415, 416, 420, 422-434, 437-447, 450-999; LOM 402, 404, 406, 407 POST SB  
737-53-1276**

- (c) Install the inboard edge of the new gasket [9] to align with the inboard edge of the scuff plate [4] attach holes.

NOTE: For the new gasket (143A8335-1) use one piece of the HI-TAK Tape, G50734, 3 in. (8 cm) x 36.5 in. (93 cm).

NOTE: For the new gasket (146A8335-1) use one piece of the HI-TAK Tape, G50734, 3 in. (8 cm) x 36 in. (91 cm).

**LOM ALL**

- (d) Install the filler scuff plate [6].
  - 1) Bond the rubber filler to the structure with P/S 870 Class B-1/2 sealant, A50250, or P/S 870 Class B-2 sealant, A50479.
- (e) Apply two layers of parting agent to the scuff plates in all areas of a mating surface (PAGEBLOCK 51-31-00/201).
  - 1) Use AC962-73C peelable parting agent, G50365 (preferred), or one of these parting agents:

EFFECTIVITY  
**LOM ALL**

**53-11-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- a) Optional Valspar 4A-183 green strippable coating, G02185
- b) Optional peelable parting agent, G50366
- c) Optional AZ 634-2 peelable parting agent, G50367
- d) Optional Rexco Partall Coverall Film peelable parting agent, G50368
- e) Optional temporary coating, G50369
- f) Optional Frekote 710-NC non-peelable parting agent, G50313
- g) Optional grease, D00504.
- (f) Apply P/S 870 Class B-1/2 sealant, A50250, or P/S 870 Class B-2 sealant, A50479, to the scuff plate [4] around the rubber filler scuff plate [6].
- (g) Apply a fay surface seal between the skin and the scuff plate [4] with P/S 870 Class B-1/2 sealant, A50250, or P/S 870 Class B-2 sealant, A50479.
- (h) Install the scuff plate [4] in its position.
- (i) Install the screws [5] that attach the scuff plate [4] to the structure.
  - 1) Apply P/S 870 Class B-1/2 sealant, A50250, or P/S 870 Class B-2 sealant, A50479, to the screws [5].
  - 2) Tighten the screws [5] to 18 in-lb (2 N·m) to 22 in-lb (2 N·m).

SUBTASK 53-11-02-390-001

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

SUBTASK 53-11-02-390-003

- (5) Fill the gaps flush with P/S 870 Class B-1/2 sealant, A50250, or P/S 870 Class B-2 sealant, A50479, around the forward and aft scuff plate [2], scuff plate [4], scuff plate [7], and the bull nose.

SUBTASK 53-11-02-390-002

- (6) Apply 3M EC-3587B compound, A01024, or PR-1772 Class B Sealant, A50343 (as alternative), to the gaps and fastener recesses common to the door seal as follows:
  - (a) Clean areas to be filled with solvent, B00148, or solvent, B00666.

**LOM 411, 412, 415, 416, 420, 422-434, 437-447, 450-999; LOM 402, 404, 406, 407 POST SB  
737-53-1276**

- (b) Fill flush fastener recesses for outboard fastener row that are common to the door seal plane/interface only (View C, Figure 401).

**LOM 402, 404, 406, 407 PRE SB 737-53-1276**

- (c) Fill flush fastener recesses for outboard fastener row that are common to the door seal plane/interface only (View B, Figure 401).

**LOM ALL**

- (d) Sand smooth to a visually equivalent Roughness Height Rating (RHR) 125 finish that is flush with adjacent surfaces.

**LOM 411, 412, 415, 416, 420, 422-434, 437-447, 450-999; LOM 402, 404, 406, 407 POST SB  
737-53-1276**

- (e) Fill the gaps and mismatches (View D, Figure 401).

**LOM 402, 404, 406, 407 PRE SB 737-53-1276**

- (f) Fill the gaps and mismatches (View C, Figure 401).

**LOM ALL**

EFFECTIVITY  
**LOM ALL**

**53-11-02**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (g) To obtain a smooth continual surface around the corner of the body opening, smooth and blend phenolic filler (if it is necessary) and fairing compound in indicated areas.
  - 1) Make a smooth fair ramp at a minimum ratio of 10 to 1.
- (h) Sand smooth with no abrupt transition to a visually equivalent RHR 125 finish.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-11-02**





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

FRAMES AND BULKHEADS CORROSION PREVENTION - MAINTENANCE PRACTICES

**1. General**

- A. This procedure contains the following tasks:
  - (1) Corrosion Prevention of the Crown Frames, Stringers and Skin
  - (2) Corrosion Prevention of the Lower Lobe Structure
  - (3) Corrosion Prevention of the Galley and Lavatory Areas
  - (4) Corrosion Prevention of the Main Gear Wheel Well and Keel Beam
  - (5) Corrosion Prevention of the Nose Gear Wheel Well
  - (6) Corrosion Prevention of the Door Openings
  - (7) Corrosion Prevention of the Upper Lobe Frames, Stringers and Skin.

**TASK 53-11-37-600-811**

**2. Crown Frames, Stringers and Skin - Corrosion Prevention**

(Figure 201)

**A. General**

- (1) The fuselage is of semi-monocoque construction utilizing aluminum skins, circumferential frames and longitudinal hat section stringers. The fuselage skin is installed with circumferential butt joints and longitudinal lap joints that are usually flush riveted. Skins should be treated concurrently with fuselage structure.
- (2) The stringers, frames and skins have been found susceptible to corrosion due to moisture entrapment between the skin and insulation blankets. Added to this moisture spillage, condensation or moisture through open doors running along frames or stringers collecting at some dammed location contribute to corrosion. Corrosion can readily start where protective finishes have been broken or deteriorated.
- (3) Treatment of the interior structure should be accomplished at the same time as longitudinal lap splices are treated or whenever access is gained to expose the frame/stringer/skin structure. For lap splices, refer to INSPECTION AND DETECTION, SUBJECT 51-00-51.
- (4) Insulation blankets are provided on cabin interiors for passenger comfort and to minimize the condensation of warm cabin air on cold skins and stringers. Corrosion has been experienced in areas where the blankets are not installed taut and wrap around stringers or lay on the skins. Reports of water soaked blankets have been common in these instances.
- (5) Delamination of the waffle doublers on the crown and side skin panels has been reported. If left untreated, delaminated doublers may promote corrosion and cracking of the skin interior and doublers.
- (6) Stress corrosion has been attributed to reported three cracks in the right side BS540 bulkhead forging refer to Figure 201 (Sheet 1).
- (7) Refer to CORROSION PREVENTION, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

**B. References**

Reference	Title
51-00	CORROSION PREVENTION
51-00-51	INSPECTION AND DETECTION

EFFECTIVITY  
LOM ALL



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Title
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
SRM 737-678	Structural Repair Manual

**C. Consumable Materials**

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

**D. Location Zones**

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

**E. Corrosion Prevention**

SUBTASK 53-11-37-610-061

- (1) Make the periodic inspection described in INSPECTION AND DETECTION, SUBJECT 51-00-51 to preclude or detect the early stages of corrosion. Missing fasteners, white powdery or any discolored deposits are evidences of the existence of corrosion which should alert operators that some corrective action is required. A corrosion prevention program should be initiated to prevent the accumulation of corrosive products in order to minimize the occurrence of corrosion.

SUBTASK 53-11-37-610-009

- (2) Corrosion inspection/removal.
  - (a) Following cleaning of suspected areas, a visual inspection utilizing bright lighting and mirror is effective for identifying the existence of corrosion. In specific localized areas where inspection by visual means is impossible or where extent of corrosion has to be determined after visual detection, INSPECTION AND DETECTION, SUBJECT 51-00-51 for applicable method.
  - (b) Where corrosion exists (noticeable bulges of the skin or white deposits of corrosion products at fastener heads or joint edges), refer to SRM 737-678 for details of corrosion removal.
  - (c) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by an application of a corrosion inhibiting compound into the affected area to retard the corrosion process. The finish system should be restored at the next maintenance opportunity (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59).

SUBTASK 53-11-37-610-010

- (3) Application of corrosion inhibitors.
  - (a) For details of application of water displacing corrosion inhibiting compound, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-11-37-610-011

- (4) Prevention treatment.
  - (a) Maintenance prevention.

EFFECTIVITY  
LOM ALL

**53-11-37**

Page 202  
Oct 15/2020

D633A101-LOM



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 1) At first opportunity when scheduled maintenance work allows access to the structure, corrosion prevention treatment should be accomplished.
  - 2) Remove insulation blankets to expose frame, stringer and skin. Dry blankets thoroughly if found wet.
  - 3) Open plugged drains.
  - 4) Replace broken or damaged finishes. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems.
  - 5) In all areas, except where indicated, apply a coat of epoxy primer, C00259, primer to inboard flanges of stringers and allow to dry thoroughly.
  - 6) Allow solvent to evaporate before reinstalling insulation blankets.
  - 7) Reinstall blankets so they are taut and so that the outboard surfaces of the upper blanket overlap the lower blanket.
- (b) Improved corrosion protection.
- 1) On airplanes with sealant applied to inboard flanges of stringers, apply a coat of sealant, A00247, class F, by spray, brush or roller coat to inboard face of stringer flanges and edges of frames where contacted by the insulation blanket, in areas above the window belt, between stations 259.5 and 1015. On other airplanes stringers may have either sealant or an additional coat of Type 1 (yellow) primer, C00259.
  - 2) Apply corrosion inhibiting compound, G00009, to all exposed structure. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for methods of application of corrosion inhibiting compound, G00009.
  - 3) On some airplanes operators may wish to rework insulation blankets by removing the sewn cap strip from the lower edge of the blanket and continuously penetrate the stitch sealing. The blankets to be reworked must be fabricated with water-repellent fillers. All 737 airplanes are known to be delivered utilizing water-repellent fillers.
  - 4) Some airplane have had the tightly sealed covers replaced with unsealed covers to permit water to enter the blanket and drain. The blankets serve as drain paths into the lower lobe drain masts. Water repellent blanket filler is used.
  - 5) The sealant, A00247, class F, is applied by spray, brush or roller coating to the inner flanges of stringers and edges of frames where contacted by the insulation blankets above the window belt, between stations 259.5 and 1015. Airplane stringers may have sealant, A00247, or an additional coat of yellow primer, C00259.

SUBTASK 53-11-37-610-012

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

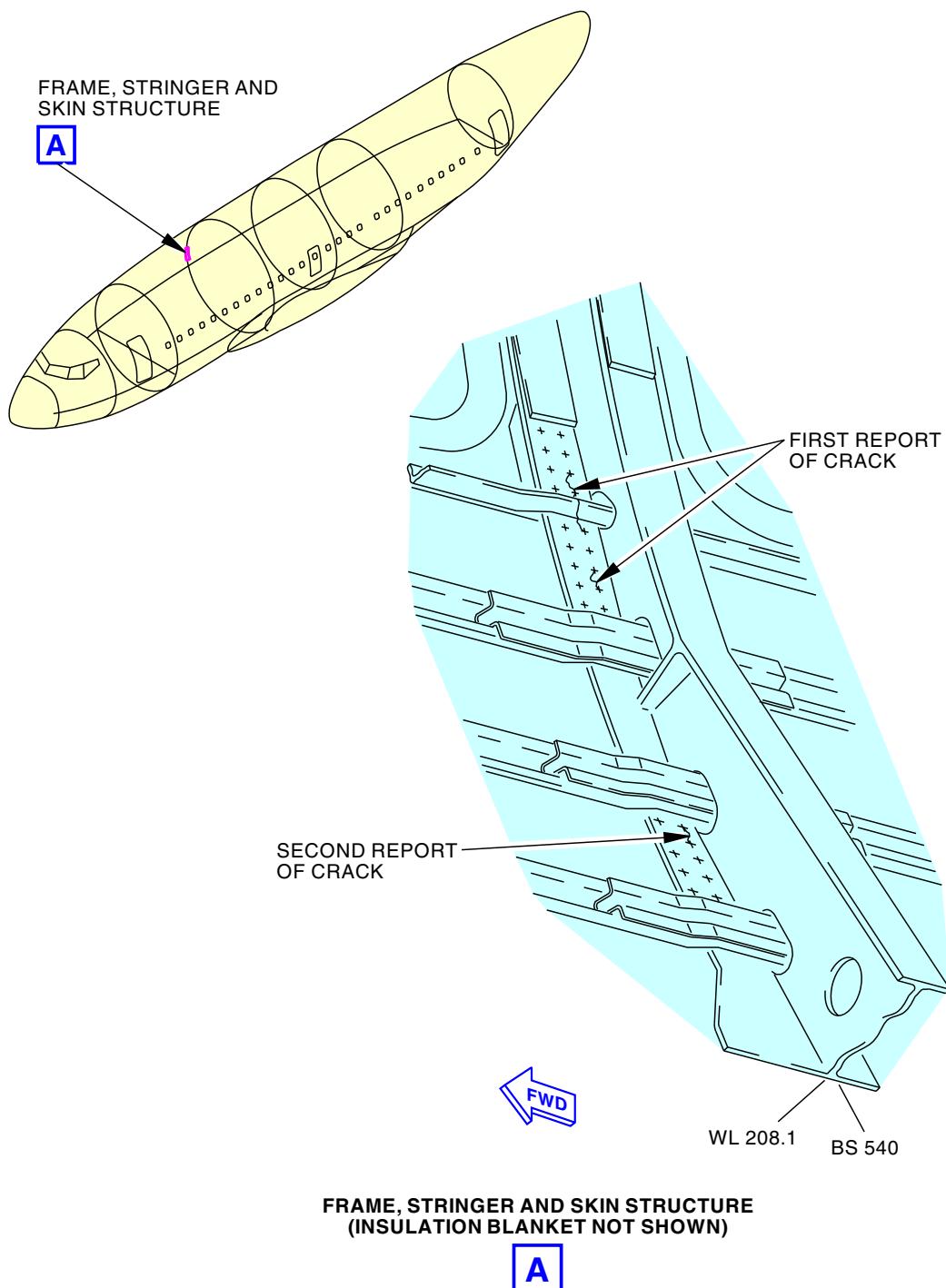
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LOM ALL

**53-11-37**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Crown Frames, Stringers and Skin  
Figure 201/53-11-37-990-811 (Sheet 1 of 2)

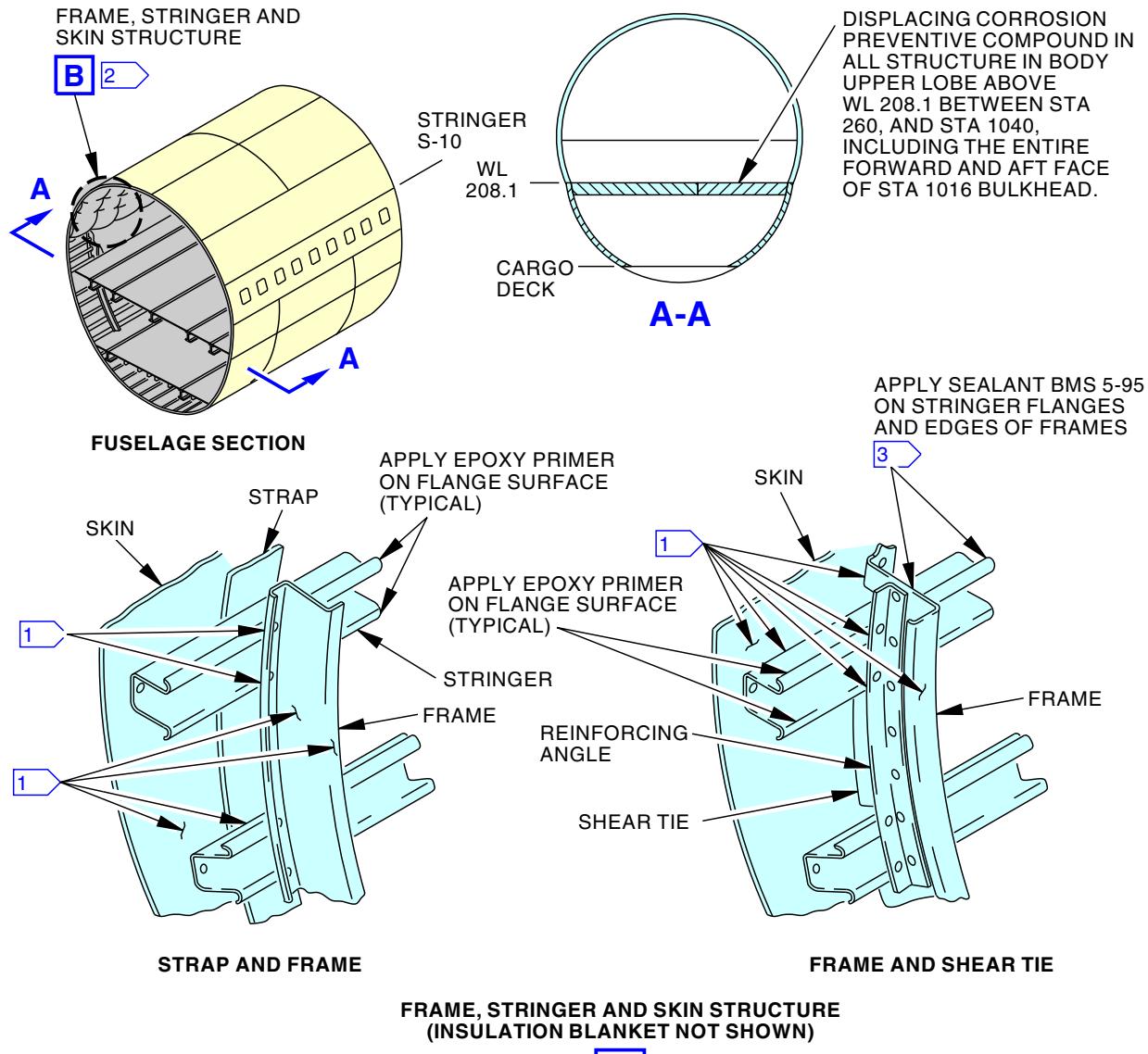
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**53-11-37**

Page 204  
Oct 15/2015

**737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL**


- 1** **APPLY BMS 3-23 TO ALL EXPOSED STRUCTURE**
- 2** **WHEN INSULATION BLANKETS ARE REINSTALLED, ENSURE THAT OUTBOARD SURFACE OF UPPER BLANKET OVERLAPS LOWER BLANKET.**
- 3** **IN AREAS ABOVE THE WINDOW BELT BETWEEN STA 259.5 AND STA 1015 WHERE BLANKETS CONTACT STRINGER FLANGES AND EDGES OF FRAMES. BETWEEN BODY STATIONS 540 AND 1016 WHERE STRINGER SOUND DAMPING CAPS ARE USED, SEALANT IS NOT REQUIRED.**

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**Crown Frames, Stringers and Skin**  
**Figure 201/53-11-37-990-811 (Sheet 2 of 2)**

EFFECTIVITY	LOM ALL
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D633A101-LOM

**53-11-37**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-11-37-600-812**

**3. Lower Lobe Structure - Corrosion Prevention**

(Figure 202)

**A. General**

- (1) The fuselage is of semi-monocoque construction utilizing aluminum skins, circumferential frames and longitudinal stringers. The fuselage skin is installed with circumferential butt joints and longitudinal lap joints. The floor beams act as tension ties across the frames. In the lower lobe area, shear ties from the skin to the frame are used between stringers with an inner angle on the frame.
- (2) The lower lobe structure including stringers, frames, shear ties, faying surfaces at doublers and straps, etc., are susceptible to corrosion due to moisture accumulation, moisture laden insulation blankets, cargo spillage, toilet effluent leakage and environmental contaminants. The lower lobe areas described herein include the cargo compartments, bilge areas and the electronic compartment.
- (3) To help clean out contamination in the lower lobe, dams divide the bilge into compartments for optional hose out operations (Figure 202 (Sheet 3)). However on some airplanes, these dams have foam blocks which can become soaked with moisture and cause corrosion.
- (4) Some lower lobe doublers came apart from the skin, and corrosion and cracks occurred on airplanes with 1400 flight hours or more. The damaged areas were between Stringers 26L and 26R under the forward cargo compartment, BS 360-540 and between Stringers 25L and 25R under the aft cargo compartment, BS 727-1016.
- (5) At the nose wheel well, the three hinge bracket supports for the wheel well doors on the left and right side have pockets that can catch moisture.
- (6) Insulation blankets are provided on cabin interiors for passenger comfort and to minimize the condensation of warm cabin air on cold skins and stringers. Corrosion has been experienced in areas where the blankets are not installed taut and wrap around stringers or lay on the skins. Reports of water soaked blankets have been common in these instances.
- (7) Treatment of the areas under galleys and lavatories is described in Figure 203.
- (8) Much corrosion and separation of doublers has been reported in the lower lobe. Areas where corrosion is of particular concern is from BS 260 to BS 360, stringers S-19 left to S-19 right.
- (9) Refer to CORROSION PREVENTION, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

**B. References**

<b>Reference</b>	<b>Title</b>
51-00	CORROSION PREVENTION
51-00-51	INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
51-41-11-350-801	Area Around the Aircraft Drains (Leveling with Compound) Repair (P/B 801)
SRM 737-678	Structural Repair Manual

**C. Consumable Materials**

<b>Reference</b>	<b>Description</b>	<b>Specification</b>
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

EFFECTIVITY  
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**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

(Continued)

Reference	Description	Specification
C00032	Coating - Protective Enamel, General Use	BMS10-60 Type I
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00260	Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel	BMS10-11 Type II
D00633	Grease - Aircraft General Purpose	BMS3-33
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

**D. Location Zones**

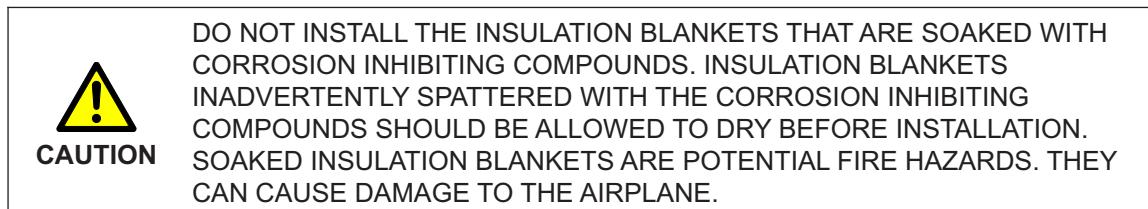
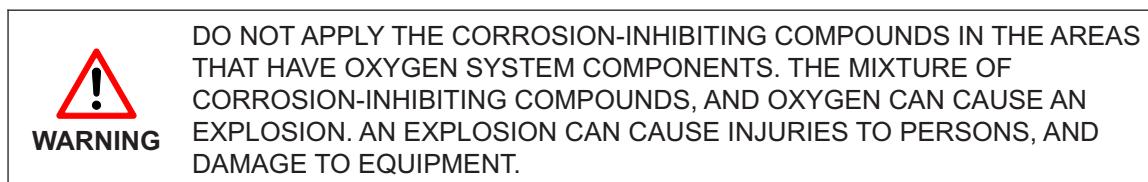
Zone	Area
100	Lower Half of Fuselage

**E. Corrosion Prevention**

SUBTASK 53-11-37-610-013

- (1) Make the regular inspections of INSPECTION AND DETECTION, SUBJECT 51-00-51 to stop of find the start of corrosion. Inspect the areas beneath the forward and aft cargo floors. Skin bulges, missing fasteners, or white powdery deposits are signs of corrosion.

SUBTASK 53-11-37-610-014



- (2) If you find corrosion (skin bulges, missing fasteners or large amounts of white deposits at the fastener heads or faying surfaces), refer to SRM 737-678 for details of corrosion removal.

SUBTASK 53-11-37-610-015

- (3) For details of application of water displacing corrosion inhibiting compound, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-11-37-610-016

- (4) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by an application of a corrosion inhibiting compound into the affected area to retard the corrosion process. The finish system should be restored at the next maintenance opportunity.

**NOTE:** The treatment of internal structure described above should be made at first opportunity the area is exposed. Location of the area should be noted and monitored from the outside every 3 months for visual indication of corrosion progression. Any noticeable skin bulges would require scheduling corrosion removal outlined in SRM 737-678.



**53-11-37**

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 207  
Oct 15/2020



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-11-37-610-017

- (5) The corrosion inhibiting compound, G00009, should not be used in the vicinity of oxygen system components. The suggested protection system for areas near oxygen system components is as follows:
- (a) Clean corrosion and repair affected area per the SRM 737-678.
  - (b) Chemical treat bare aluminum surfaces.
  - (c) Apply one coat of green primer, C00259 Type 1.
  - (d) Apply one coat of yellow primer, C00259 type 1.
  - (e) Apply coating, C00260, type 2 epoxy or coating, C00032, polyurethane enamel top coat.

SUBTASK 53-11-37-610-018

- (6) Prevention treatment.
- (a) At first opportunity when scheduled maintenance work allows access to the structure, corrosion prevention treatment should be accomplished.
  - (b) Remove sidewall lining and insulation blankets in the cargo compartment and beneath the upper lobe entry and cargo doors to expose frame, stringer, doublers and skin.
  - (c) Remove floor panels to gain access to bilge areas, if required.
  - (d) Remove ceiling lining for access to main deck floor beams and intercostals.
  - (e) Open plugged drains.
  - (f) Make sure that all drain paths are clear at the frames and stringers in the airframe lower lobe and stringer ends at station bulkhead.
  - (g) Replace broken or damaged finishes. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems.
  - (h) Apply a coat of primer, C00259, primer to the inboard flange surfaces of stringers and allow to dry thoroughly.
  - (i) Replace or repair broken or damaged leveling compounds used for drainage (TASK 51-41-11-350-801).
  - (j) The chromate-loaded sealant, A00247, class F, is applied to the inboard flanges and to portions of the frames that come in contact with insulation blankets. Allow to cure for 48 hours. Note condition of the sealant and reapply as necessary.
  - (k) Apply corrosion inhibiting compound to all exposed structure under the cargo floor and to the sidewalls beneath the upper lobe entry and cargo doors. The use of spray equipment with nozzle directed into faying surfaces is recommended. Do not apply excessively.

NOTE: To reduce the possibility of moisture entrapment between insulation blankets and airplane skins in the bilge area, supports for the insulation blankets were provided. These supports consist of nylon twine and brackets. Earlier installations utilizing silicone rubber loops may deteriorate because of exposure to hydrocarbons such as corrosion inhibitors and should be replaced with the nylon twine.

- (l) Allow solvent to evaporate before reinstalling insulation blankets.
- (m) Install blankets so they are taut and so that the outboard surfaces of the upper blanket overlap the lower blanket.
- (n) Install liners and floor panels. Install the floor panel fasteners with grease, D00633.

SUBTASK 53-11-37-610-019

- (7) Frequency of application.

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**53-11-37**

Page 208  
Oct 15/2020

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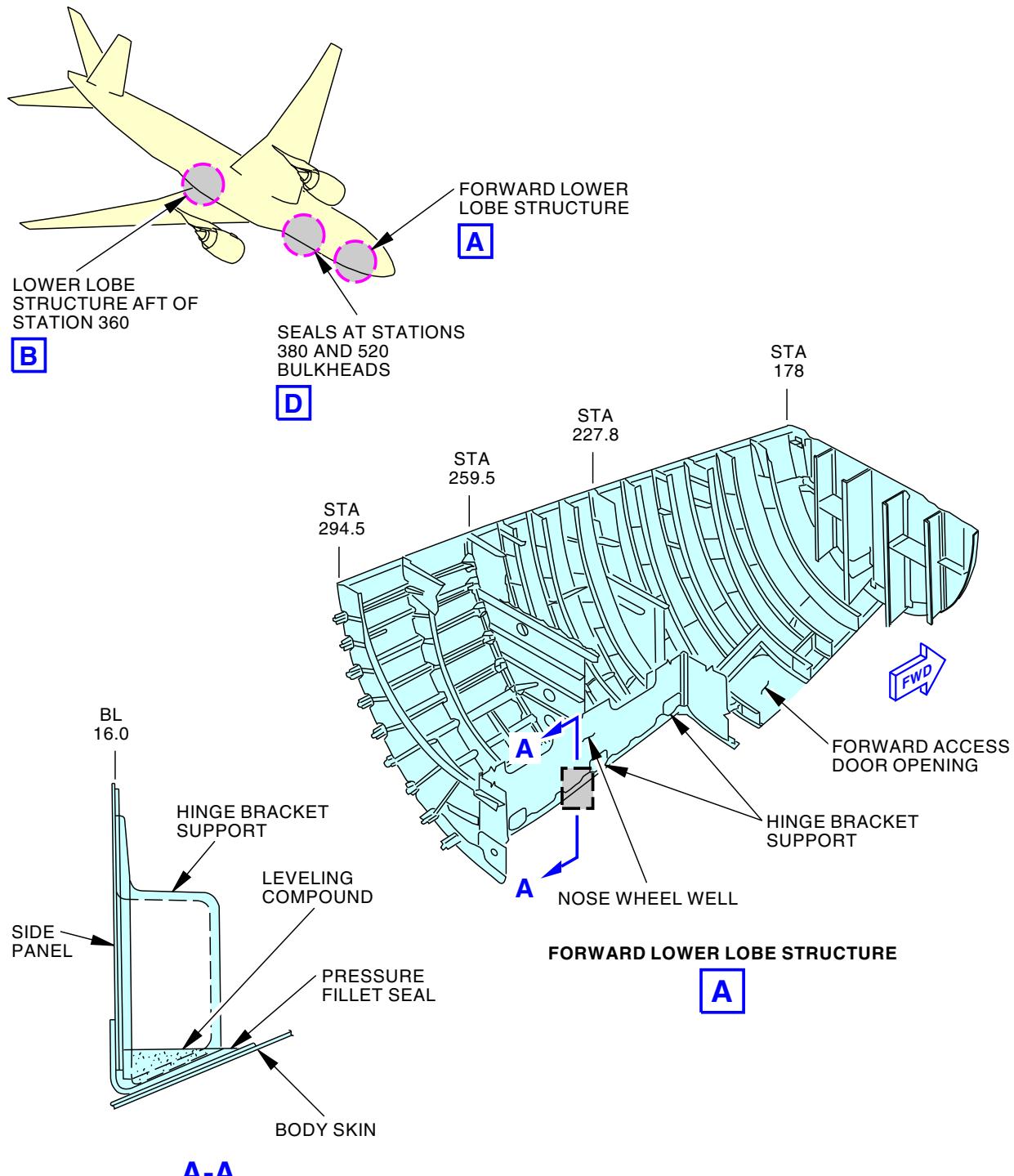
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**AIRCRAFT MAINTENANCE MANUAL**

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

———— END OF TASK ——

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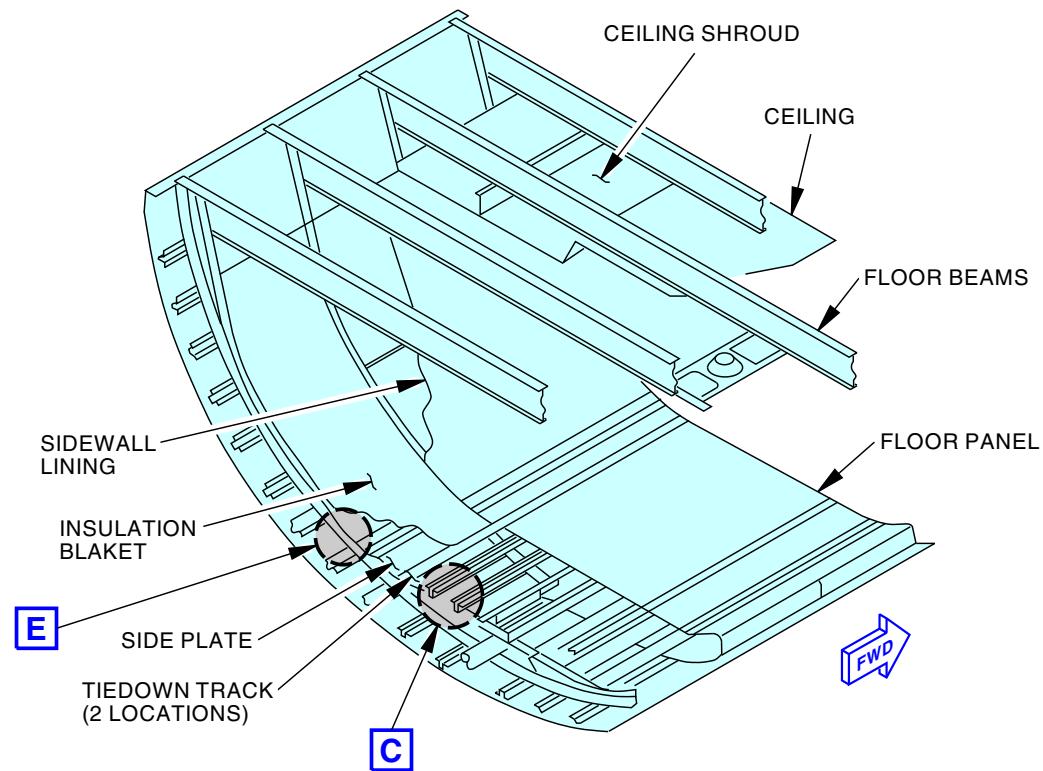
**Lower Lobe Structure**  
Figure 202/53-11-37-990-803 (Sheet 1 of 4)

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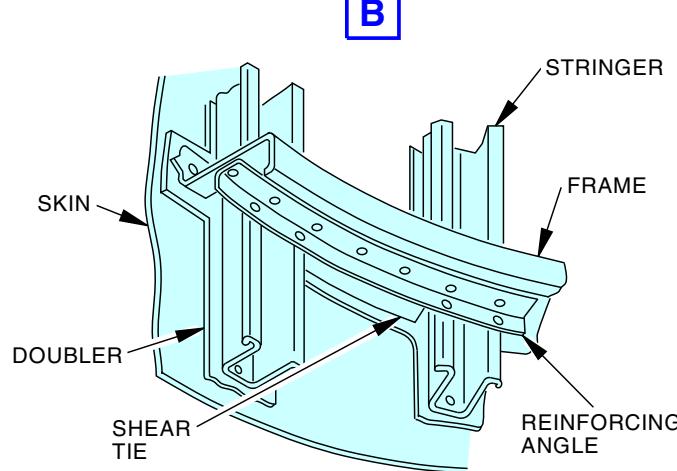
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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



LOWER LOBE STRUCTURE AFT



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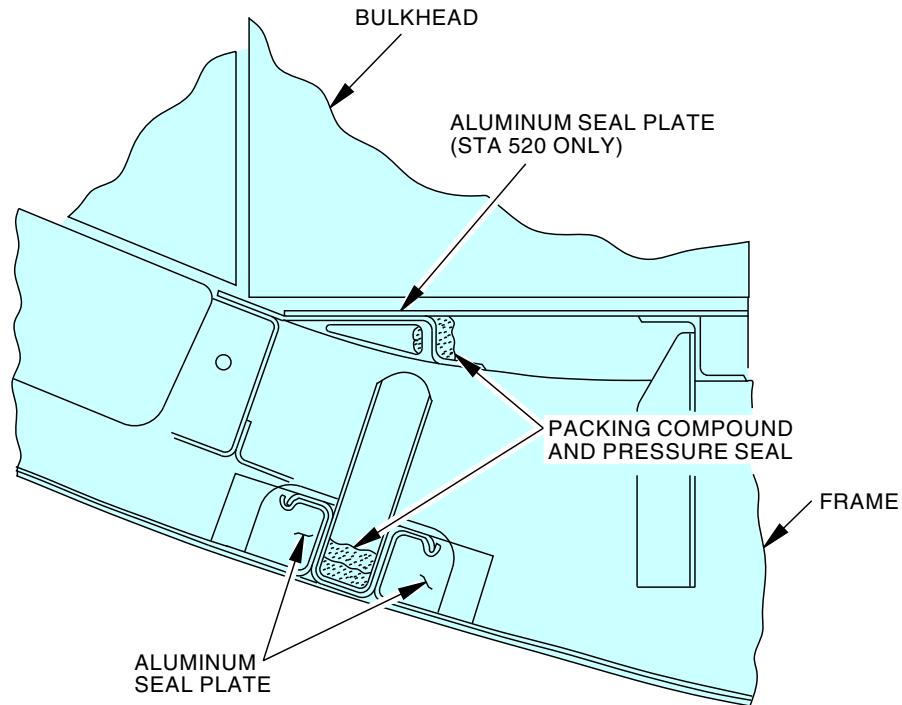
Lower Lobe Structure  
Figure 202/53-11-37-990-803 (Sheet 2 of 4)

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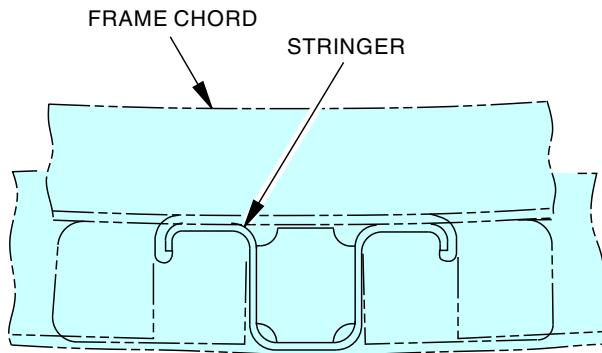


737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



SEALS AT STATIONS 380 AND 520 BULKHEAD

D



DAMS FOR HOSE-OUT OPTION

E

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Lower Lobe Structure  
Figure 202/53-11-37-990-803 (Sheet 3 of 4)

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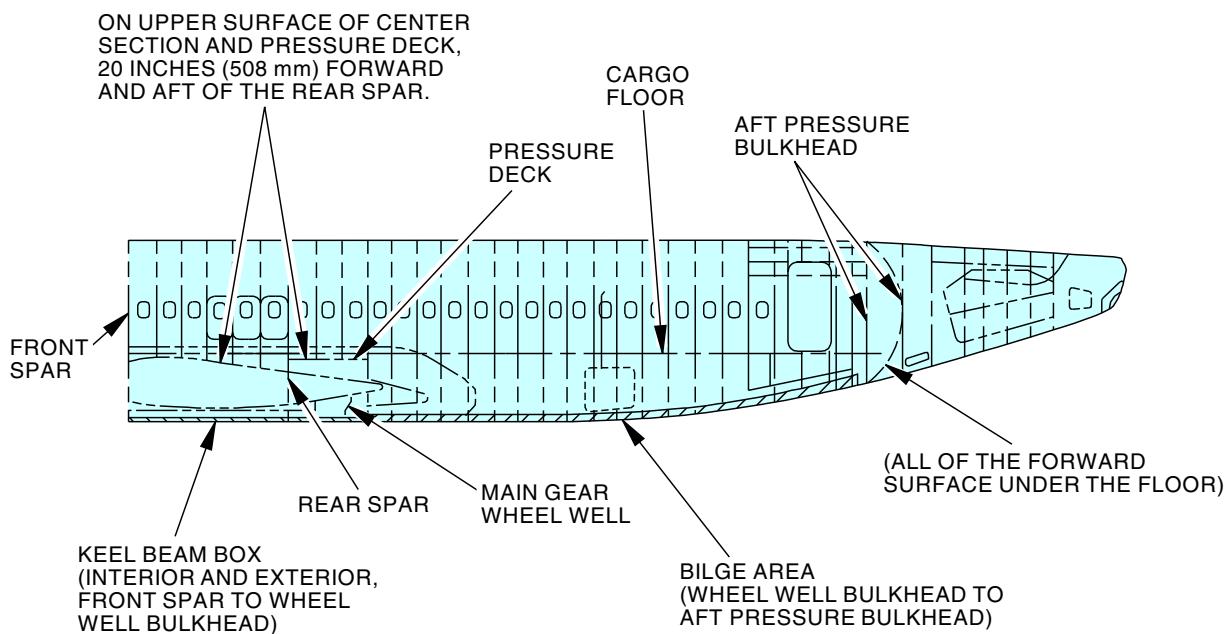
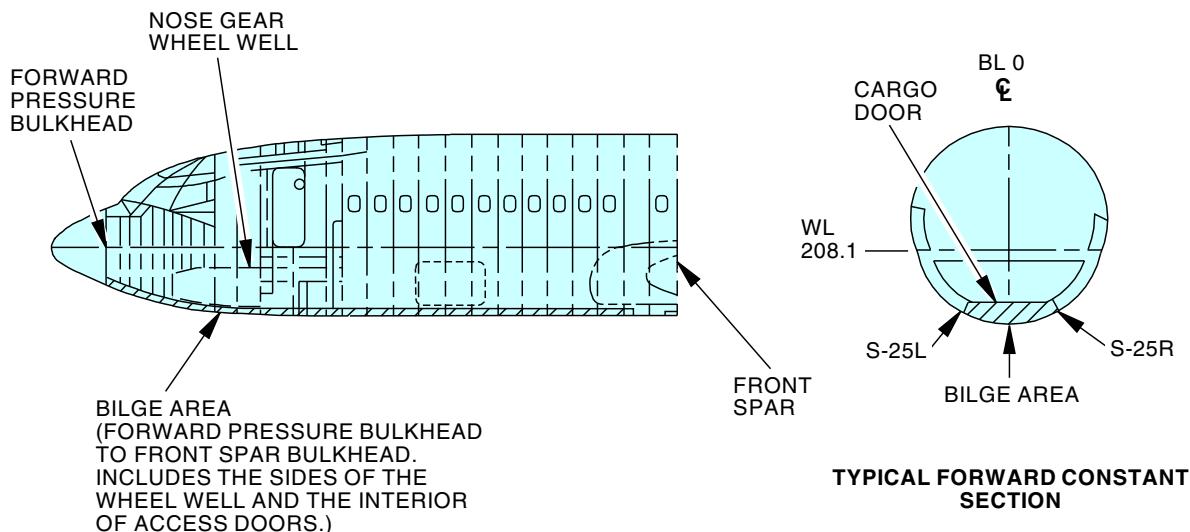
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Page 212  
Oct 15/2015



**737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL**



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**Lower Lobe Structure**  
**Figure 202/53-11-37-990-803 (Sheet 4 of 4)**

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D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-11-37**

Page 213  
Oct 15/2015



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-11-37-600-804**

**4. Galley and Lavatory Areas - Corrosion Prevention**

(Figure 203)

**A. General**

- (1) Areas under galleys and lavatories are susceptible to corrosion because of spillage of fluids or food. Leakage from plumbing lines also contributes to corrosion. Seat tracks in galley or lavatory areas are particularly susceptible because of exposure to traffic debris and spillage which collect inside the track. Corrosion has also been reported on the forward lavatory bulkhead-to-floor area and door post, aft of the lavatory door.
- (2) Corrosion of the aluminum faced floor panels under galleys and lavatories has been alleviated by using fiberglass faced balsa panels.
- (3) Insulation blankets are provided on cabin interiors for passenger comfort and to minimize the condensation of warm cabin air on cold skins and stringers. Corrosion has been experienced in areas where the blankets are not installed taut and wrap around stringers or lie on the skins. Reports of water soaked blankets have been common in these instances.
- (4) Unsealed covers permit water to enter the blanket and drain. The blankets serve as drain paths into the lower lobe drain masts. Water repellent blanket filler is used.
- (5) A water dam and seal has been added to the outboard side of the forward lavatory floor, and between the aft lavatories. Floor drains have been added to the aft lavatories and a drain installation to the forward lavatory.
- (6) For improved corrosion protection, a production change has been made to apply sealant, A00247, class F, to inboard flanges of stringers and to portions of frames that contact insulation blankets.
- (7) Severe corrosion and corrosion cracking have been reported on the lower ten inches of the bulkhead forward face. Corrosion of the bulkhead web can result in severe cracks and rapid cabin depressurization. The corrosion, has been attributed to fluids from galleys and lavatories. A plugged drain hole in the station 1016 frame chord assembly can trap these fluids and thereby accelerate the corrosion process. See Figure 203 for aft pressure bulkhead.
- (8) Apply corrosion inhibiting compound corrosion inhibiting compound, G00009, to wet areas (doorways, galleys and lavatories) of the main cabin (Figure 203).
- (9) Refer to CORROSION PREVENTION, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

**B. References**

<b>Reference</b>	<b>Title</b>
51-00	CORROSION PREVENTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
51-41-11-350-801	Area Around the Aircraft Drains (Leveling with Compound) Repair (P/B 801)
53-21-00 P/B 401	PASSENGER CABIN FLOORS - REMOVAL/INSTALLATION
SRM 737-678	Structural Repair Manual

**C. Consumable Materials**

<b>Reference</b>	<b>Description</b>	<b>Specification</b>
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

EFFECTIVITY  
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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

**D. Location Zones**

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

**E. Corrosion Prevention**

SUBTASK 53-11-37-610-020

- (1) Periodically examine galley and lavatory areas to detect early stages of corrosion. Skin bulges, missing fasteners or white powdery deposits are evidences of the existence of corrosion which should alert operators that some corrective action is required. A corrosion prevention program should be initiated to prevent the accumulation of moisture in order to minimize the occurrence of corrosion.

SUBTASK 53-11-37-610-021

- (2) Where extensive corrosion exists (noticeable skin bulges, missing fasteners, or large amounts of white deposits) refer to SRM 737-678 for details of corrosion removal.

SUBTASK 53-11-37-610-022



**WARNING**  
DO NOT APPLY THE CORROSION-INHIBITING COMPOUNDS IN THE AREAS THAT HAVE OXYGEN SYSTEM COMPONENTS. THE MIXTURE OF CORROSION-INHIBITING COMPOUNDS, AND OXYGEN CAN CAUSE AN EXPLOSION. AN EXPLOSION CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.



**CAUTION**  
DO NOT INSTALL THE INSULATION BLANKETS THAT ARE SOAKED WITH CORROSION INHIBITING COMPOUNDS. INSULATION BLANKETS INADVERTENTLY SPATTERED WITH THE CORROSION INHIBITING COMPOUNDS SHOULD BE ALLOWED TO DRY BEFORE INSTALLATION. SOAKED INSULATION BLANKETS ARE POTENTIAL FIRE HAZARDS. THEY CAN CAUSE DAMAGE TO THE AIRPLANE.

- (3) For details of application of corrosion inhibiting compound, G00009, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-11-37-610-023

- (4) For minor corrosion to minimize the down time of the airplane, the corrosion products should be cleared off, followed by an application of a corrosion inhibiting compound into the affected area to retard the corrosion process. The finish system should be restored at the next maintenance opportunity (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59).

NOTE: The treatment of the internal structure described above should be made at the first opportunity the area is exposed. Location of the area should be noted and monitored from the outside every 3 months for visual indication of corrosion progression. Any noticeable skin bulges would require scheduling corrosion removal outlined in Structural Repair Manual.



**53-11-37**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-11-37-610-024

- (5) The treatment of seat tracks in the galleys and lavatories should be accomplished per Figure 203.

SUBTASK 53-11-37-610-025

- (6) Prevention treatment.

- (a) At first opportunity when scheduled maintenance work allows access to the structure, corrosion prevention treatment should be accomplished.

NOTE: Preferred access to the floor structure is from the lower lobe.

- (b) Remove sidewall lining and insulation blankets to expose frames, stringers, doublers and skin.

- (c) Remove floor panels to gain access to bilge areas.

- (d) Remove insulation blankets and liners (if any) from bulkheads in the immediate area below galleys or lavatories.

- (e) Remove ceiling lining for access to main deck floor beams and intercostals.

- (f) Open plugged drains, if any.

- (g) Clear all drain paths.

- (h) Refinish broken or damaged finishes. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems. Use interior finish system with polyurethane enamel topcoat.

- (i) Replace or repair broken or damaged leveling compounds used for drainage (TASK 51-41-11-350-801).

- (j) Apply sealant, A00247, class F, chromate-loaded sealant to the inboard flanges and to portions of the frames that come in contact with insulation blankets. Allow to cure for 48 hours. Note condition of the sealant and reapply as necessary.

- (k) Apply corrosion inhibiting compound, G00009, water displacing corrosion inhibiting compound to all structures under galleys and lavatories. Exposed structure of bulkheads should also be included. Special efforts should be made to apply the corrosion inhibitor to the top of the floor support structure where moisture may be trapped between the floor panel and floor support. The use of spray equipment with nozzle directed into faying surfaces is recommended. Do not apply excessively.

NOTE: To reduce the possibility of moisture entrapment between insulation blankets and airplane skins in the bilge area, supports for the insulation blankets were provided. These supports consist of nylon twine and brackets. Silicone rubber used on earlier installations may deteriorate due to exposure to hydrocarbons present in corrosion inhibiting compound and should be replaced with nylon twine.

- (l) Allow solvent in the corrosion inhibitor to evaporate before reinstalling insulation blankets.

- (m) Install blankets so they are taut and so that the outboard surfaces of lower blanket overlap the lower blanket.

- (n) Install liners and floor panels. Install the floor panel fasteners with grease, D00633.

SUBTASK 53-11-37-610-026

- (7) Frequency of application.

- (a) It is recommended that corrosion inhibiting compound, G00009, water displacing corrosion inhibiting compound be applied to the lower lobe structure whenever the area is made accessible, at intervals not to exceed the "D" check.

EFFECTIVITY  
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**53-11-37**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-11-37-610-062

- (8) For corrosion prevention on the hardpoint fittings in the wet area of the forward and aft lavatories, refer to applicable steps in PASSENGER CABIN FLOORS - REMOVAL/INSTALLATION, PAGEBLOCK 53-21-00/401.

NOTE: The wet area is between STA 270 and STA 380 and between STA 887 and STA 1016.

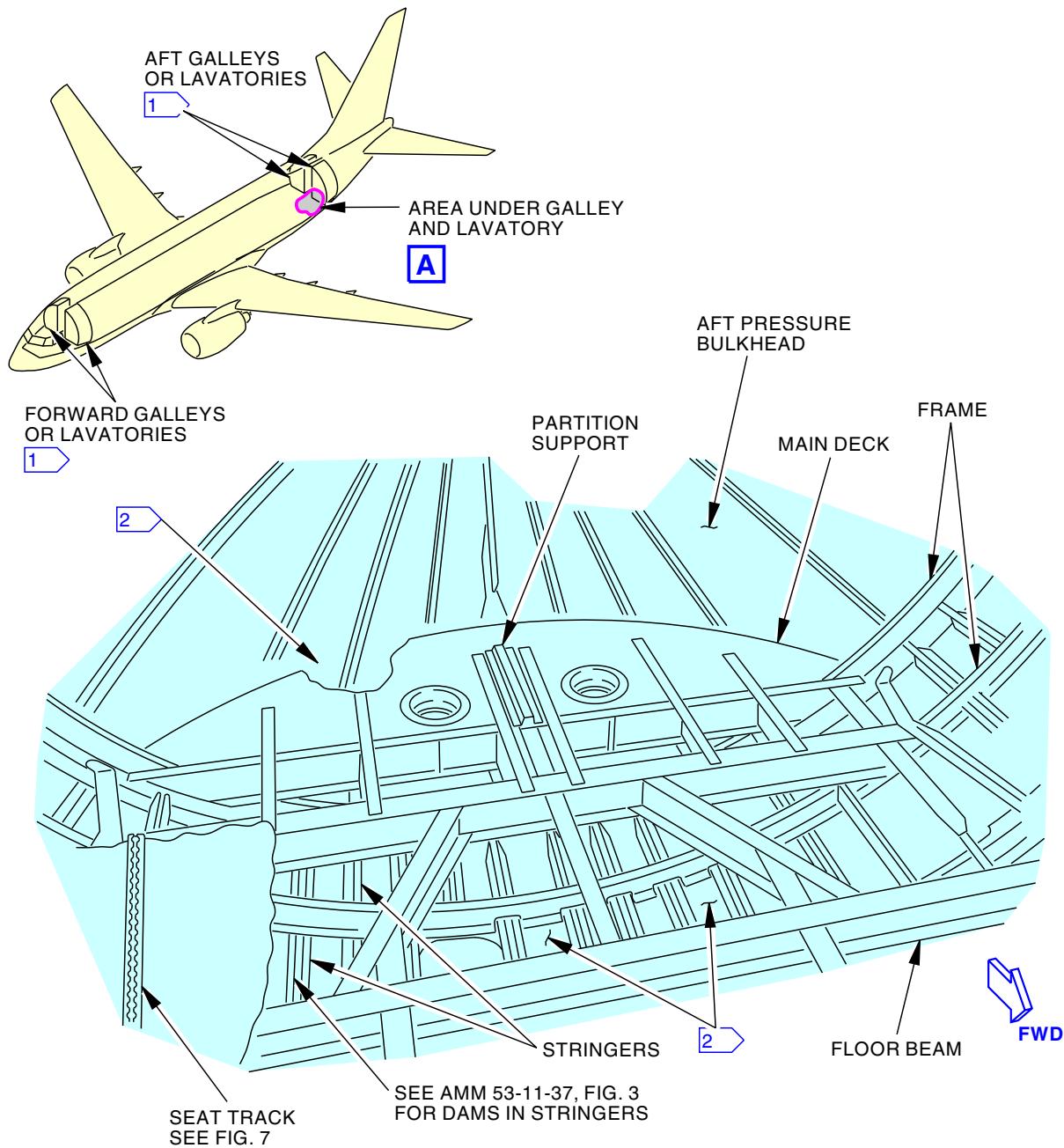
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**53-11-37**

Page 217  
Feb 15/2023

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**Galley and Lavatory Areas**  
**Figure 203/53-11-37-990-804 (Sheet 1 of 3)**

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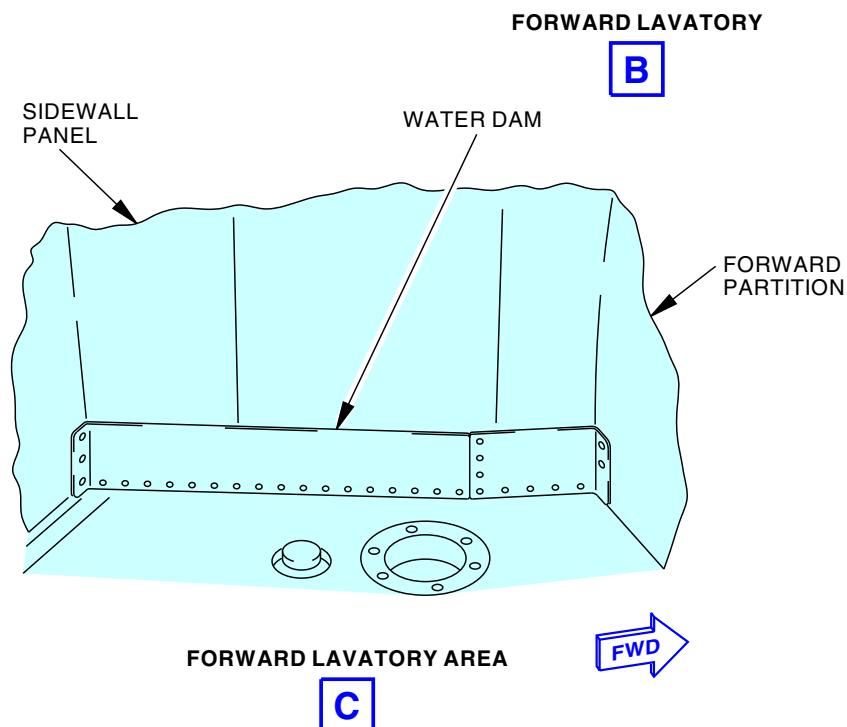
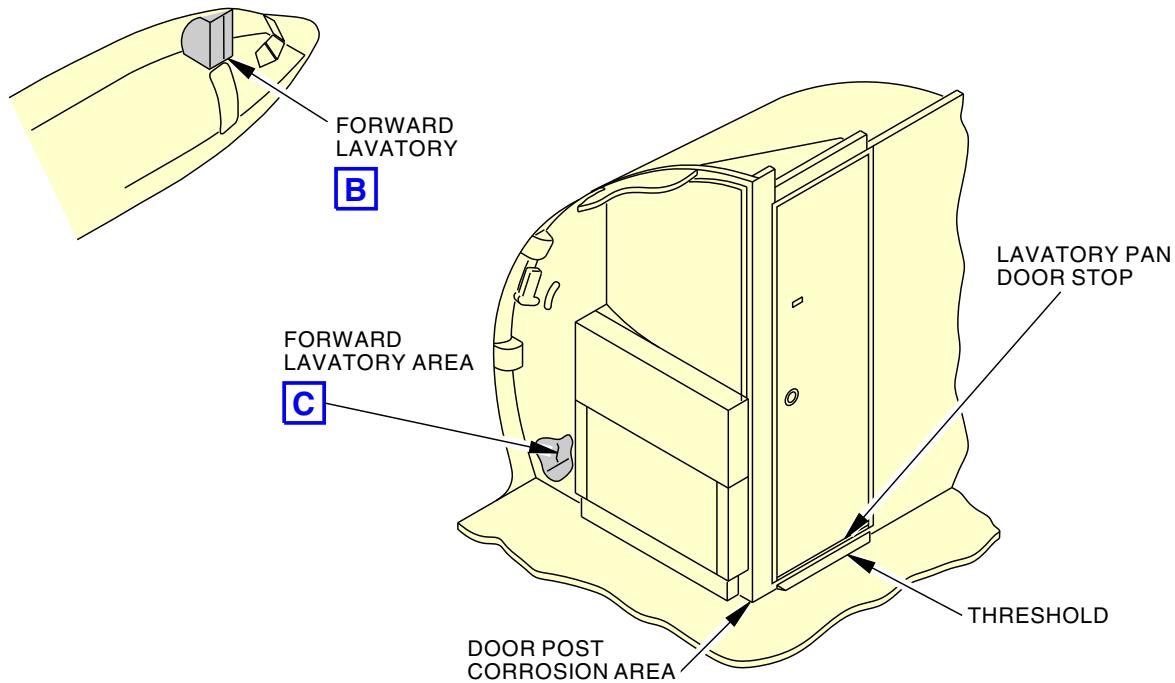
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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Galley and Lavatory Areas  
Figure 203/53-11-37-990-804 (Sheet 2 of 3)

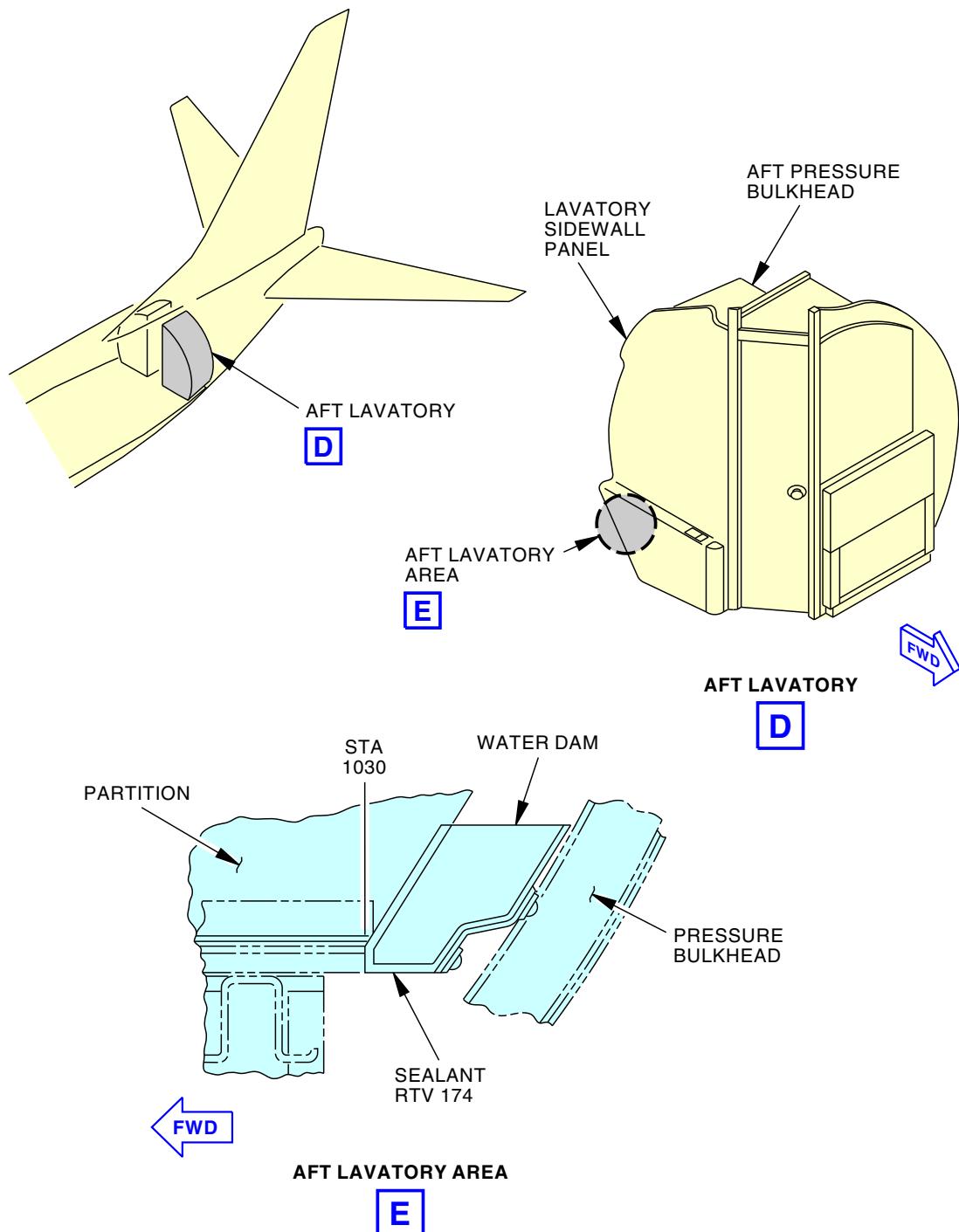
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**53-11-37**

Page 219  
Feb 15/2023



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**Galley and Lavatory Areas**  
**Figure 203/53-11-37-990-804 (Sheet 3 of 3)**

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D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-11-37**

 Page 220  
 Feb 15/2023



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-11-37-600-805**

**5. Main Gear Wheel Well and Keel Beam - Corrosion Prevention**

(Figure 204)

**A. General**

- (1) The main gear wheel well is in the fuselage section aft of the bulkhead at the rear spar of the wing center section. The floor is formed by the wing to body fairing with an opening provided to fit the tire, with the outboard tire providing the closure for the cavity. A keel beam carries the longitudinal stress loads across the cavity. The wheel well in the fuselage extends into the inboard end of the wing trailing edge structure. The wing wheel well houses the greater portion of the landing gear components.
- (2) The surfaces inside the fuselage are exposed to air contaminants and runway splash and are subject to corrosion.
- (3) The wing wheel well should be treated at the same time as the trunnion attach fittings, the landing gear support beam and forward trunnion support structure.
- (4) Stress corrosion cracking has been reported in the horizontal integral ribs of the BS 685 and 706 frames. Cracks occurred at WL192, 202 and 208 on Sta 685 frames and at WL202 on STA 706 frames on both sides of airplanes. Cracks originated at, or passed through holes for fasteners used to attach shear webs to frame ribs. Cracks occurred in frames made from 7079 material.
- (5) Stress corrosion cracks have occurred in the keel beam left and right lower tee chord. They initiated under the splice near the ends of the 7178-T6511 aluminum chords at STA 743. Corrosion has also occurred between the tee chord and skin.
- (6) Corrosion has been reported on the keel beam lower chord surfaces between STA 520 and STA 540 and aft of STA 727. Stress corrosion cracks have also been reported on the keel beam lower chord at STA 590 and between STA 530 and STA 536.
- (7) Stress corrosion cracking has been reported in the horizontal flange of the forward and aft frame fitting at STA 695. The cracks ran along the line of fasteners common to the stringer S-18A shear beam Figure 204 (Sheet 2).
- (8) Stress corrosion cracks has been reported in both left and right inboard splice tees of the keel beam at the main wheel well aft bulkhead Figure 204 (Sheet 3).
- (9) Refer to CORROSION PREVENTION, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

**B. References**

<b>Reference</b>	<b>Title</b>
29	HYDRAULIC POWER
51-00	CORROSION PREVENTION
51-00-51	INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES

**C. Consumable Materials**

<b>Reference</b>	<b>Description</b>	<b>Specification</b>
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23





**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**D. Location Zones**

<b>Zone</b>	<b>Area</b>
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right

**E. Corrosion Prevention**

SUBTASK 53-11-37-610-027

(1) General philosophy.

- (a) The basic corrosion prevention philosophy is to make the periodic inspection described in INSPECTION AND DETECTION, SUBJECT 51-00-51 to preclude or detect the early stages of corrosion. Missing fasteners, white powdery or discolored deposits are evidences of the existence of corrosion which should alert operators that some corrective action is required. A corrosion prevention program should be initiated to prevent the accumulation of moisture or corrosive products in order to minimize the occurrence of corrosion.

SUBTASK 53-11-37-610-028

(2) Corrosion inspection/removal.

- (a) Following cleaning of suspected areas, a visual inspection utilizing bright lighting and mirror is effective for identifying the existence of corrosion. In specific localized areas where inspection by visual means is impossible or where extent of corrosion has to be determined after visual detection, INSPECTION AND DETECTION, SUBJECT 51-00-51 for applicable method.
- (b) Where corrosion exists (noticeable bulges of the skin or white deposits of corrosion products at fastener heads of joint edges), refer to Structural Repair Manual for details of corrosion removal.
- (c) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by the application of a corrosion inhibiting compound into the affected area to retard the corrosion process (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59). The finish system should be restored at the next maintenance opportunity.

SUBTASK 53-11-37-610-029

(3) Application of corrosion inhibitors.

- (a) For details of application of water displacing corrosion inhibiting compound, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.
- (b) Hydraulic tubing, tubing supports and fittings are to be treated per HYDRAULIC POWER, CHAPTER 29.

SUBTASK 53-11-37-610-030

(4) Prevention treatment.

(a) Maintenance prevention.

- 1) At first opportunity consistent with scheduled maintenance activity, corrosion prevention treatment should be accomplished in the wheel well and on the aft keel beam.
- 2) Treatment of the wheel well at the same time as the main gear is recommended.
- 3) Remove runway debris and generally clean the entire wheel well area.
- 4) Replace damaged or broken finishes if at all possible. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems.

EFFECTIVITY  
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**53-11-37**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 5) Apply corrosion inhibiting compound to all exposed wheel well structure. Special effort should be made to apply corrosion inhibitor along doubler edges, along faying surfaces and on fastener heads. The use of spray equipment with nozzle directed into faying surface is recommended.
- 6) Apply water displacing corrosion inhibiting compound to the frames at BS 685 and 706, WL 193 to 208.
- 7) Regrease all grease fittings in the treatment area.
- 8) In cases where the wheel well is cleaned with steam or high pressure water and detergent, reapplication of corrosion inhibiting compound is recommended.

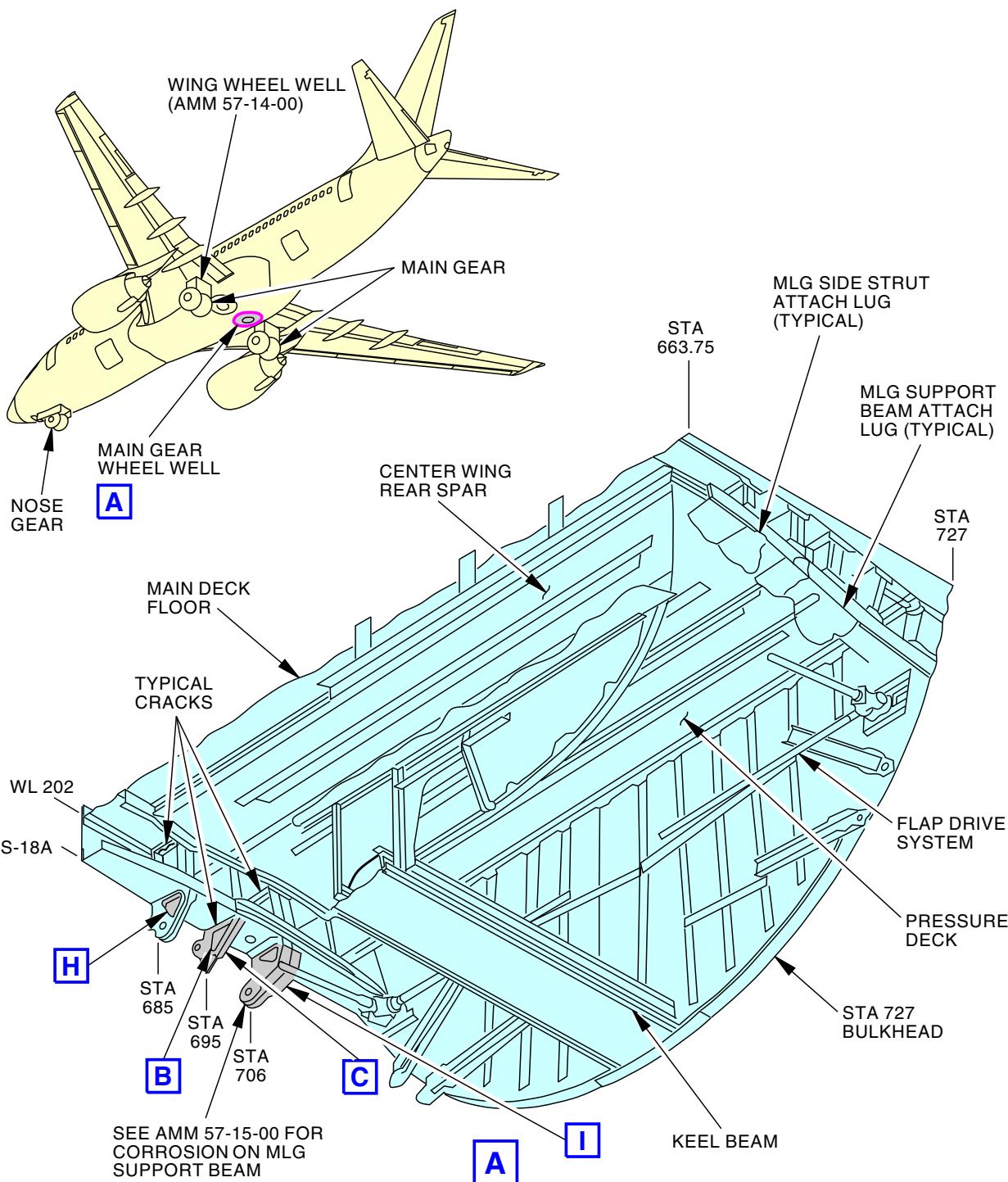
SUBTASK 53-11-37-610-031

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

———— END OF TASK ———

EFFECTIVITY  
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**53-11-37**



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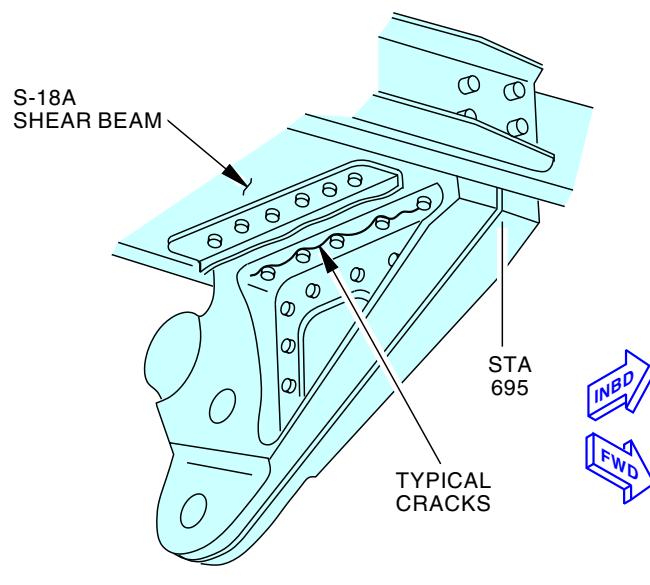
**Main Gear Wheel and Keel Beam**  
**Figure 204/53-11-37-990-805 (Sheet 1 of 5)**

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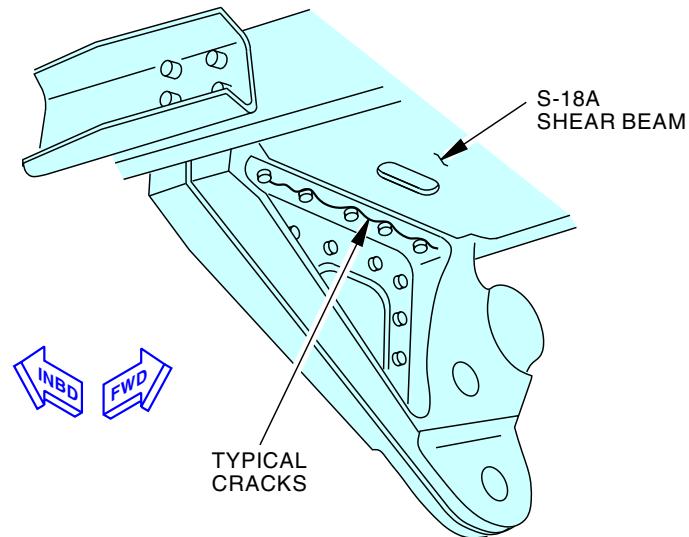
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737-600/700/800/900  
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Main Gear Wheel and Keel Beam  
Figure 204/53-11-37-990-805 (Sheet 2 of 5)

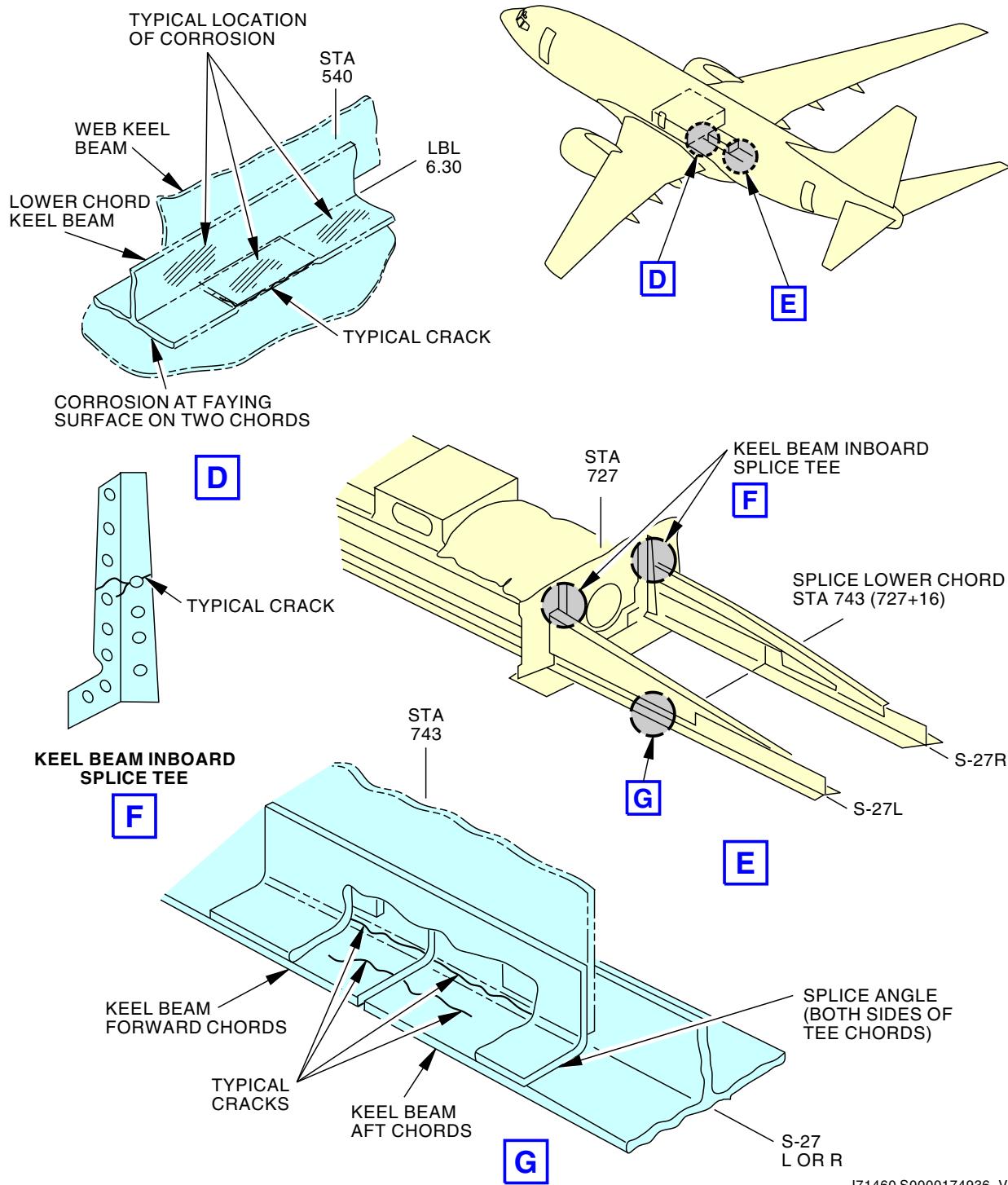
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Page 225  
Feb 15/2023



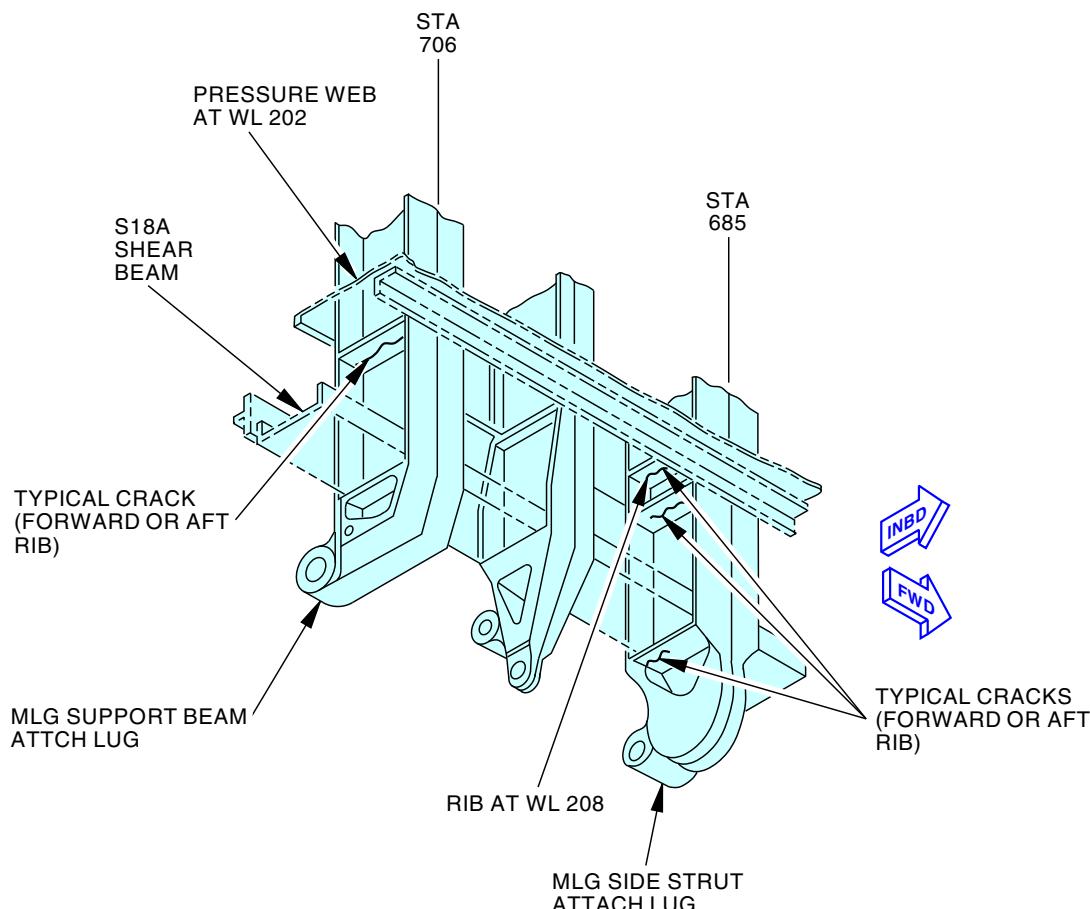
**Main Gear Wheel and Keel Beam**  
**Figure 204/53-11-37-990-805 (Sheet 3 of 5)**

EFFECTIVITY  
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**53-11-37**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Main Gear Wheel and Keel Beam  
Figure 204/53-11-37-990-805 (Sheet 4 of 5)

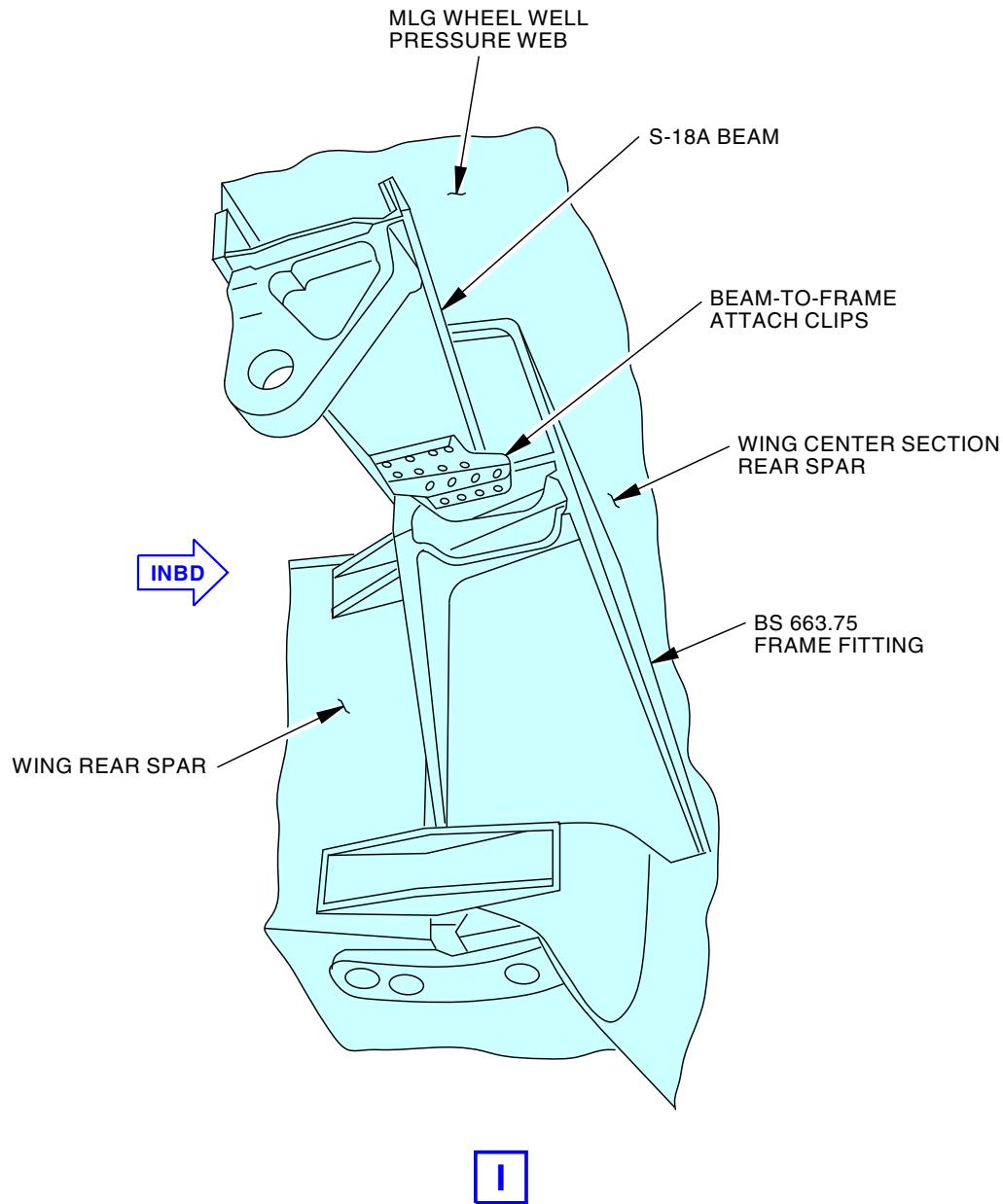
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**53-11-37**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 227  
Feb 15/2023



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Main Gear Wheel and Keel Beam  
Figure 204/53-11-37-990-805 (Sheet 5 of 5)

EFFECTIVITY  
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53-11-37

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-600/700/800/900  
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**TASK 53-11-37-600-806**

**6. Nose Gear Wheel Well - Corrosion Prevention**

(Figure 205)

**A. General**

- (1) The nose gear wheel well is a rigid box structure consisting of a ceiling, two sidewalls, a forward and an aft wall and is located in the forward fuselage. The nose gear attachment fittings are located in the wheel well.
- (2) The surfaces inside the box structure are exposed to air contaminants and runway splash and are subject to corrosion. The nose gear attachment fittings are also found to be susceptible to corrosion.
- (3) Stress corrosion cracking of the aluminum alloy actuator support fitting has been reported. Cracks occurred in the vertical leg midway between the rows of fastener holes. In another instance cracking and failure of the bearing retaining lug was reported.
- (4) Corrosion has been reported on the exterior surfaces of the box, on webs, stiffeners and chords. Cracking of the upper panel web BS 277 stiffener has also been reported.
- (5) Stress corrosion cracks have been reported on the LH and RH lock support fitting to which the strap is riveted. One of the cracks was between the two attach rivet holes and the other extended into the upper flange radius. It was determined that the strap induced clamp-up stresses in the fitting during strap installation. The strap was removed as a crack preventive measure.
- (6) Refer to CORROSION PREVENTION, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

**B. References**

Reference	Title
51-00	CORROSION PREVENTION
51-00-51	INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES

**C. Consumable Materials**

Reference	Description	Specification
C00755	Compound - Organic Corrosion Inhibiting, Heavy Duty	BMS3-26
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

**D. Location Zones**

Zone	Area
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right





**737-600/700/800/900**  
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## **E. Corrosion Prevention**

SUBTASK 53-11-37-610-032

- (1) Make the periodic inspection described in INSPECTION AND DETECTION, SUBJECT 51-00-51 to preclude or detect the early stages of corrosion. Missing fasteners, white powdery or any discolored deposits are evidences of the existence of corrosion which should alert operators that some corrective action is required. A corrosion prevention program should be initiated to prevent the accumulation of corrosive products in order to minimize the occurrence of corrosion.

SUBTASK 53-11-37-610-033

- (2) Corrosion inspection/removal.
- (a) Following cleaning of suspected areas, a visual inspection utilizing bright lighting and mirror is effective for identifying the existence of corrosion. In specific localized areas where inspection by visual means is impossible or where extent of corrosion has to be determined after visual detection, INSPECTION AND DETECTION, SUBJECT 51-00-51 for applicable method.
  - (b) Where corrosion exists (noticeable bulges of the skin or white deposits of corrosion products at fastener heads or joint edges), refer to Structural Repair Manual for details of corrosion removal.
  - (c) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by the application of a corrosion inhibiting compound into the affected area to retard the corrosion process (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59). The finish system should be restored at the next maintenance opportunity.

SUBTASK 53-11-37-610-034

- (3) Application of corrosion inhibitors.
- (a) For details of application of water displacing corrosion inhibiting compound, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-11-37-610-035

- (4) Prevention treatment.
- (a) At the next maintenance opportunity, corrosion prevention treatment should be accomplished in the wheel well.
  - (b) Treatment of the wheel well at the same time as the nose gear is recommended.
  - (c) Remove runway debris and generally clean the entire wheel well. Make sure that all drain paths are clear in structural areas at the nose gear wheel well.
  - (d) Replace damaged or broken finishes if at all possible. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems.
  - (e) Apply water displacing corrosion inhibiting compound to all exposed wheel well structure. Special effort should be made to apply the corrosion inhibitor along doubler edges, along faying surfaces and on fastener heads. The use of spray equipment with nozzle directed into faying surfaces is recommended.  
**NOTE:** The manual extension release mechanism on the nose landing gear must be protected from corrosion inhibiting compound contamination.
  - (f) Apply water displacing corrosion inhibiting compound to nose gear actuator attachment fitting, nose gear trunnion support fittings and miscellaneous other fittings. Ensure that all lugs and lug faces are treated.

EFFECTIVITY  
LOM ALL

**53-11-37**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (g) Regrease all grease fittings in the treatment area.
- (h) In cases where the wheel well is cleaned with steam or high pressure water and detergent, reapplication of corrosion inhibiting compound is recommended.

SUBTASK 53-11-37-610-036

(5) Frequency of application.

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

SUBTASK 53-11-37-610-037

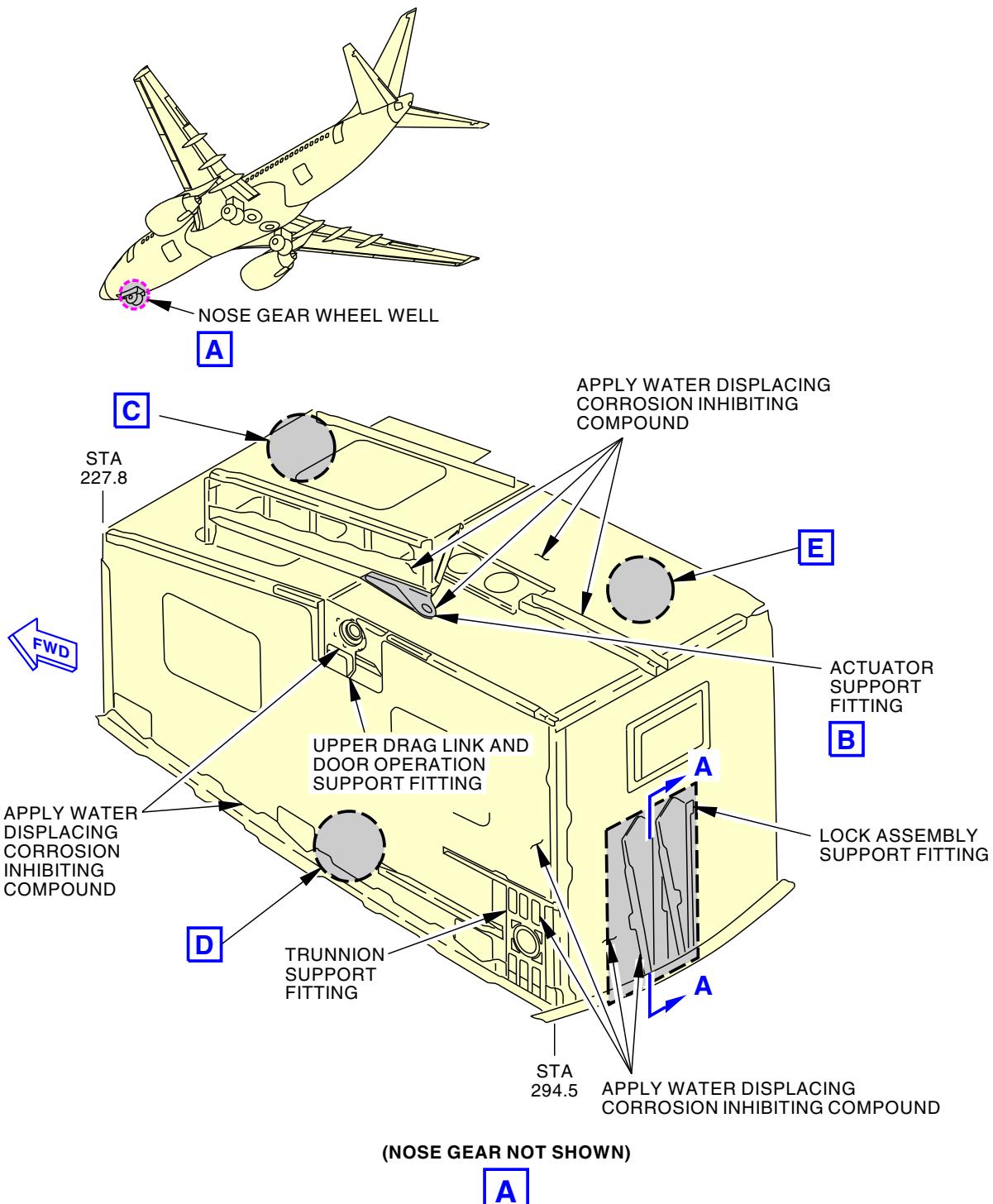
(6) Improved corrosion protection.

- (a) A layer of corrosion preventive compound, C00755, was added on the corrosion inhibiting compound, G00009, in some areas.

———— END OF TASK ————

EFFECTIVITY  
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**53-11-37**



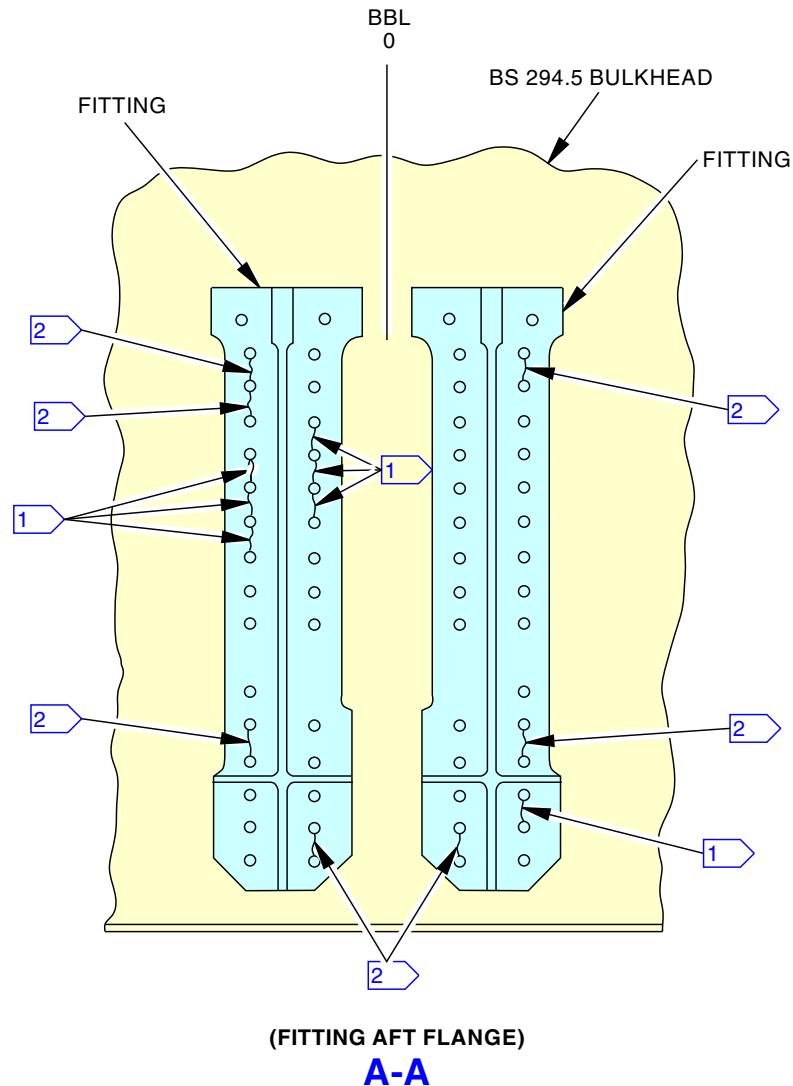
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**Nose Gear Wheel Well**  
Figure 205/53-11-37-990-806 (Sheet 1 of 3)

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**53-11-37**Page 232  
Feb 15/2023



CRACK LOCATION ON AIRPLANE WITH 5567 FLIGHT HOURS  
 CRACK LOCATION ON AIRPLANE WITH 5648 FLIGHT HOURS

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**Nose Gear Wheel Well**  
**Figure 205/53-11-37-990-806 (Sheet 2 of 3)**

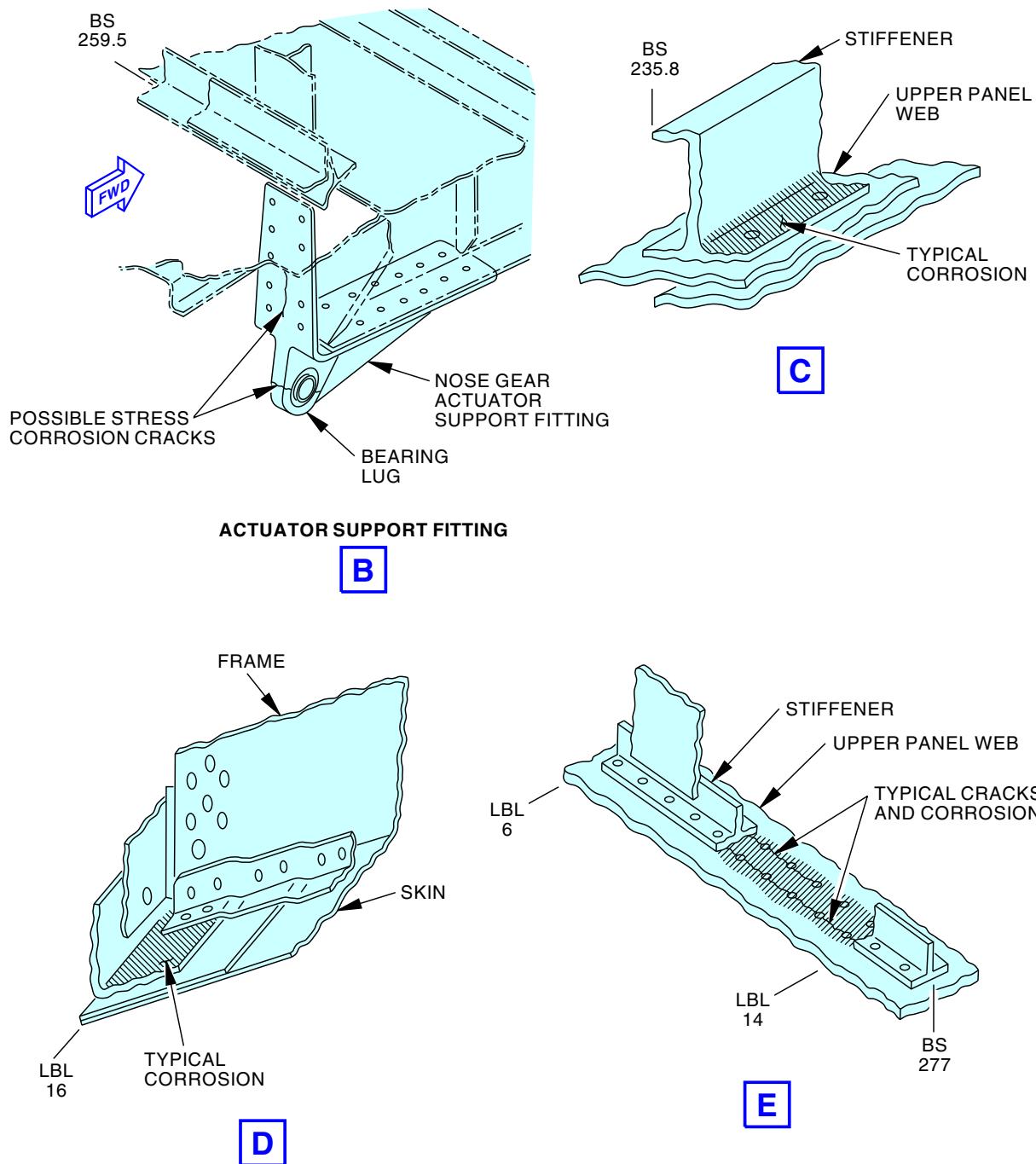
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**53-11-37**

Page 233  
Feb 15/2023



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**Nose Gear Wheel Well**  
**Figure 205/53-11-37-990-806 (Sheet 3 of 3)**

EFFECTIVITY  
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**53-11-37**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-11-37-600-808**

**7. Door Openings - Corrosion Prevention**

(Figure 206)

**A. General**

- (1) The door openings and surrounding structure in the fuselage section are made up of frames, doublers, fittings, stiffeners and intercostals. In addition, the passenger and/or crew entry doors have reveals and scuff plates.
- (2) The primary corrosion area is under the door sill, floor panels and floor beams. Contaminants are tracked in by passenger, crew members, cargo and service personnel or by driven rain/snow when door is opened. Specific problems have been reported under the corrosion resistant steel plates at the cargo doors.
- (3) Insulation blankets are provided on cabin interiors for passenger comfort and to minimize the condensation of warm cabin air on cold skins and stringers. Corrosion has been experienced in areas where the blankets are not installed taut and wrap around stringers or lay on the skins. Reports of water soaked blankets have been common in these instances.
- (4) Stress corrosion can cause cracks in the frame at Station 360.
- (5) Some skins and doublers came apart, pulled through the rivets, and tore the skin at the aft edge of the cutout for the aft cargo door. The damage was caused by the water from the main landing gear tires when the runway was wet.
- (6) Refer to the CORROSION PREVENTION, SECTION 51-00 for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

**B. References**

Reference	Title
51-00	CORROSION PREVENTION
51-00-51	INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
51-41-11-350-801	Area Around the Aircraft Drains (Leveling with Compound) Repair (P/B 801)

**C. Consumable Materials**

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
D00633	Grease - Aircraft General Purpose	BMS3-33
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

**D. Location Zones**

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

EFFECTIVITY
LOM ALL

**53-11-37**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**E. Corrosion Prevention**

SUBTASK 53-11-37-610-041

- (1) Make the regular inspection of INSPECTION AND DETECTION, SUBJECT 51-00-51 to stop or find the start of corrosion. Missing fasteners, white powdery or any discolored deposits are signs of corrosion.

SUBTASK 53-11-37-610-042

- (2) If you find corrosion (web bulges, missing fasteners or large amounts of discolored deposits at fastener heads or faying surfaces), refer to Structural Repair Manual for details of corrosion removal.

SUBTASK 53-11-37-610-043

- (3) For small amounts of corrosion, to decrease the downtime of the airplane, clean off the corrosion products. Apply a corrosion inhibiting compound into the affected area to stop the corrosion process Ref (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59). Repair the finish system at the next maintenance opportunity.

SUBTASK 53-11-37-610-044

- (4) Prevention treatment.
  - (a) At first opportunity consistent with scheduled maintenance activity, corrosion prevention treatment should be accomplished in the door opening area.
  - (b) Treatment of the door at the same time as the door opening is recommended.
  - (c) Remove traffic debris and generally clean the entire door opening area. Remove reveal and scuff plate where applicable.
  - (d) Remove sidewall lining and insulation blankets to expose frames, stringers, doublers and skin.
  - (e) Remove door reveal, scuff plates and thresholds.
  - (f) Remove floor panels to gain access to floor beams and intercostals near the door opening.
  - (g) Open plugged drains.
  - (h) Make sure that all drain paths are clear at the equipment access doorway, fwd and aft galley and entry doorways and cargo doorway.
  - (i) Replace damaged or broken finishes. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish system.
  - (j) Apply a coat of epoxy primer, C00259, to the inboard flange surfaces of stringers and allow to dry thoroughly.
  - (k) Apply sealant, A00247, class F, chromate-loaded sealant to the inboard flanges and to portions of the frames that come in contact with insulation blankets. Allow to cure for 48 hours. Note condition of the sealant and reapply as necessary.
  - (l) Apply corrosion inhibiting compound to all immediate structure. Special efforts should be made to apply the corrosion inhibitor along doubler edges, along faying surfaces and on fastener heads. The use of spray equipment with nozzle directed into faying surfaces is recommended. Special attention should be given to flanges of floor beams, doorsills and floor beam to fuselage frame splices.
  - (m) Replace or repair broken or damaged leveling compounds used for drainage (TASK 51-41-11-350-801).
  - (n) Allow solvent in corrosion inhibiting compound to evaporate before reinstalling insulation blankets.

EFFECTIVITY  
LOM ALL

**53-11-37**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (o) Install blankets so they are tight and so that the outboard surfaces of the upper blanket overlap the lower blanket.
- (p) Lubricate all the lube points again per standard servicing procedures.
- (q) Install liners and floor panels. Install the floor panel fasteners with grease, D00633.

SUBTASK 53-11-37-610-045

- (5) Frequency of application.
  - (a) Regular inspection is required in areas that can get corrosion and should agree with the schedules in the Maintenance Planning Document. Operators must know of problems and areas.
  - (b) Regular application of corrosion inhibiting compound, G00009, compound is necessary on areas identified and should agree with the schedule in the Maintenance Planning Document.

SUBTASK 53-11-37-610-046

- (6) Improved corrosion protection.
  - (a) On all entry and galley doorway scuff plate support structures, add sealant, A00247, fay surface seals between the scuff plate and support structure and installed the screws through the scuff plate with sealant, A00247.
  - (b) A production change applied sealant, A00247, class F, chromate-loaded sealant to inboard flanges of stringers and to the areas of the frames that touch the insulation blankets.
  - (c) Drain holes with drain tubes were added at the forward entry doorway, but the drain tubes can become clogged with dirt and carpet debris. To make it easier to clean the drain lines, a production change added cutouts in the floor mat retainer plate.

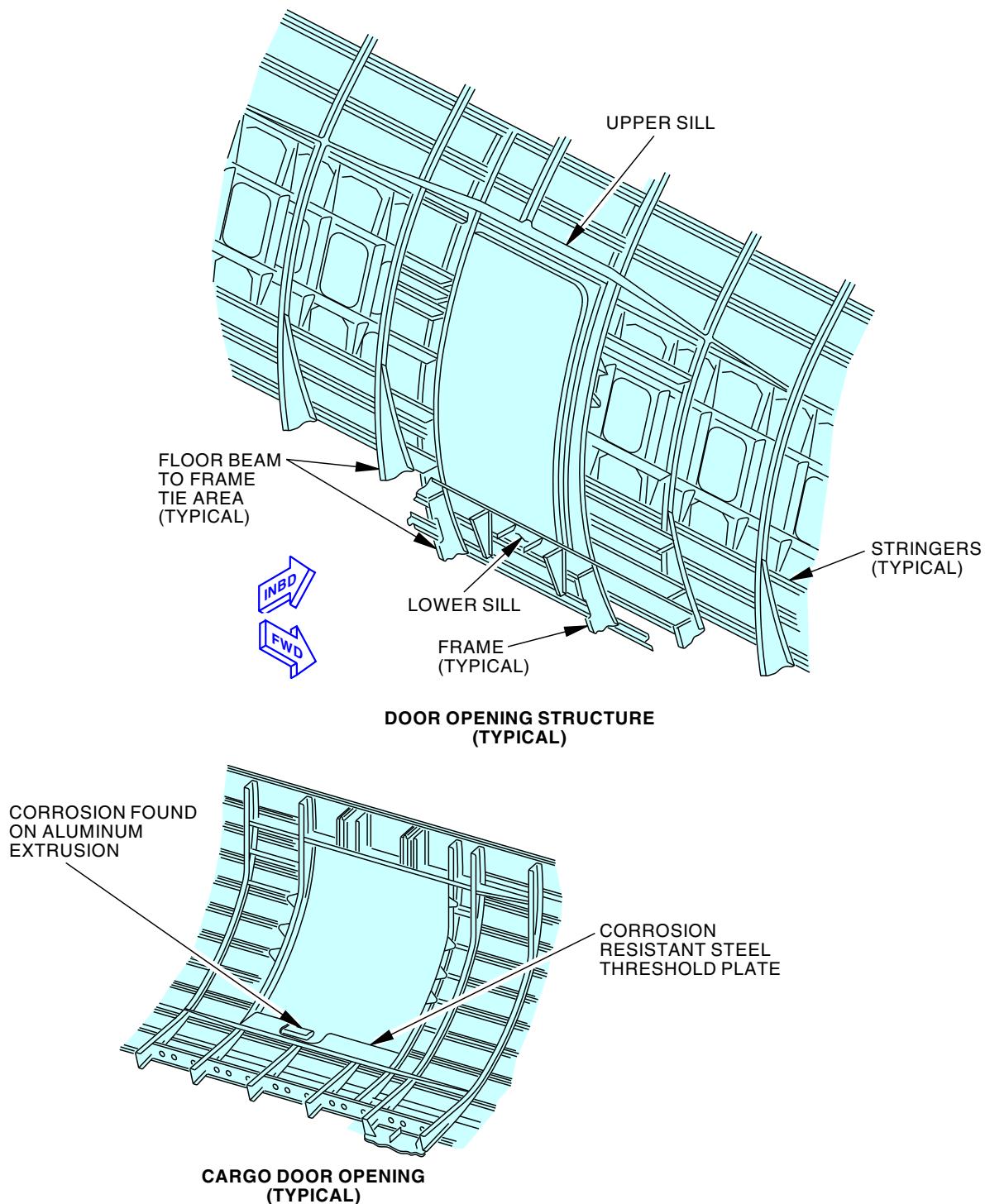
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**53-11-37**



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Door Openings  
Figure 206/53-11-37-990-808 (Sheet 1 of 4)

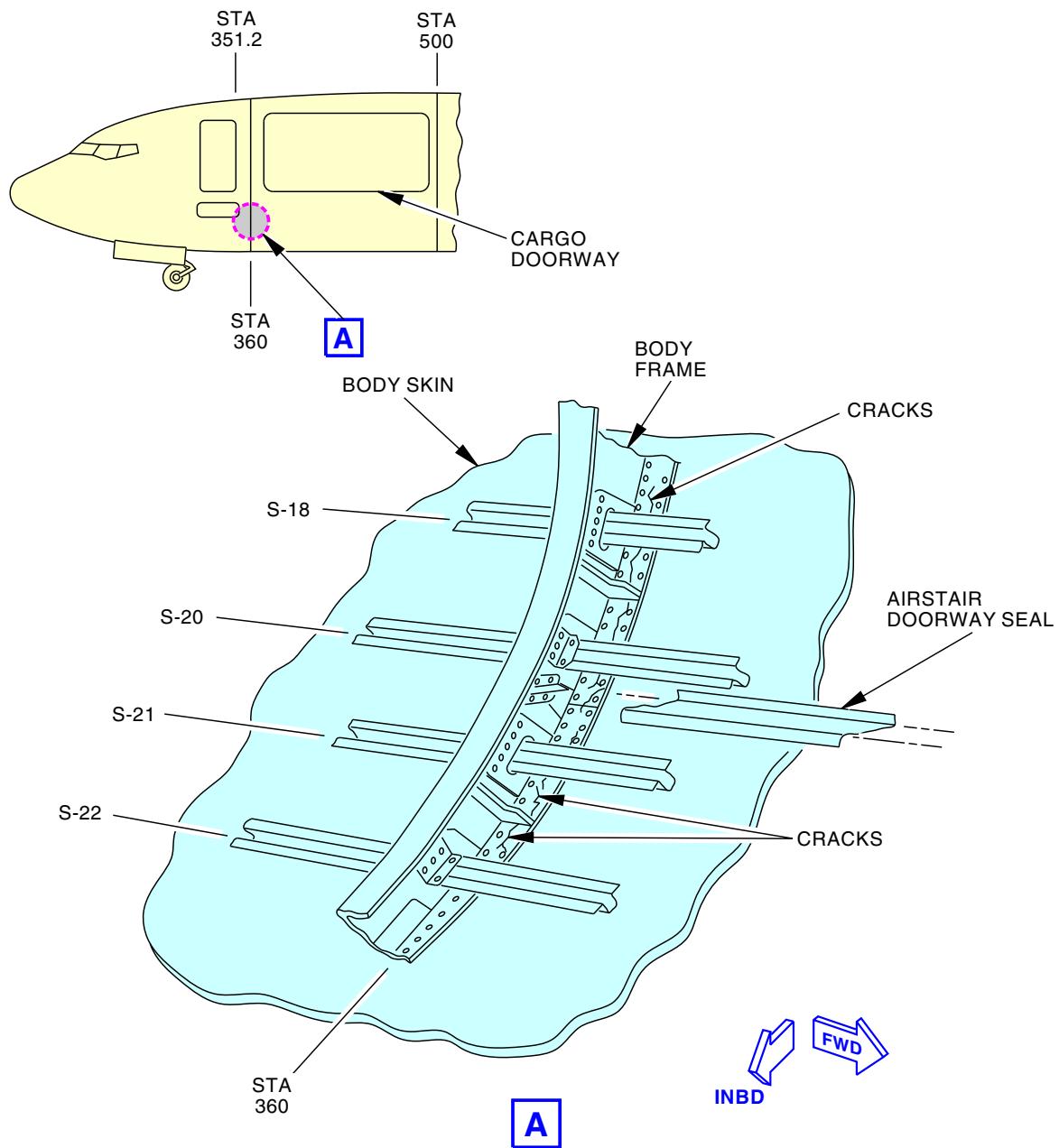
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**53-11-37**

Page 238  
Feb 15/2023

**737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL**

**737 CARGO AIRPLANES**

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**Door Openings**  
**Figure 206/53-11-37-990-808 (Sheet 2 of 4)**

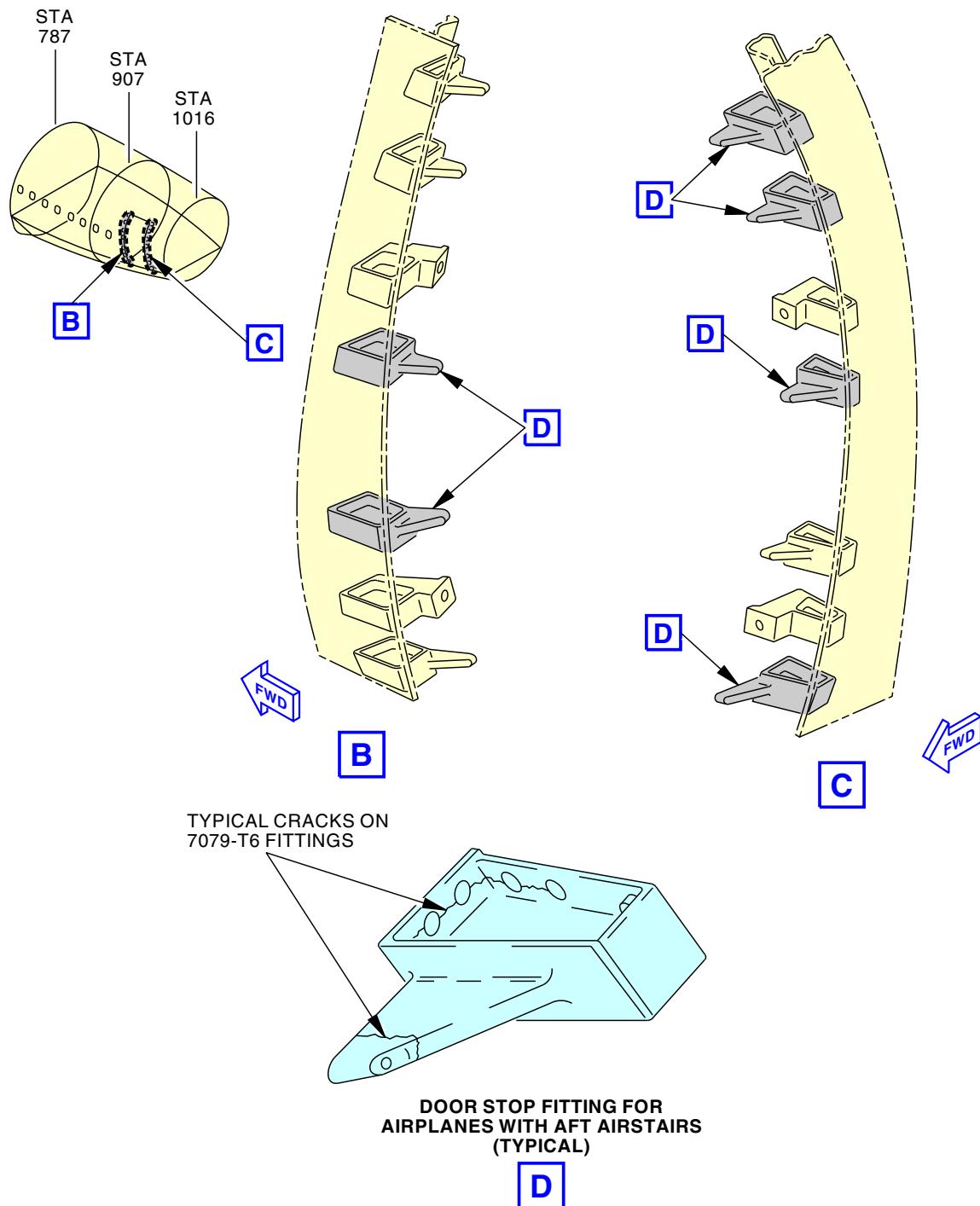
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Door Openings  
Figure 206/53-11-37-990-808 (Sheet 3 of 4)

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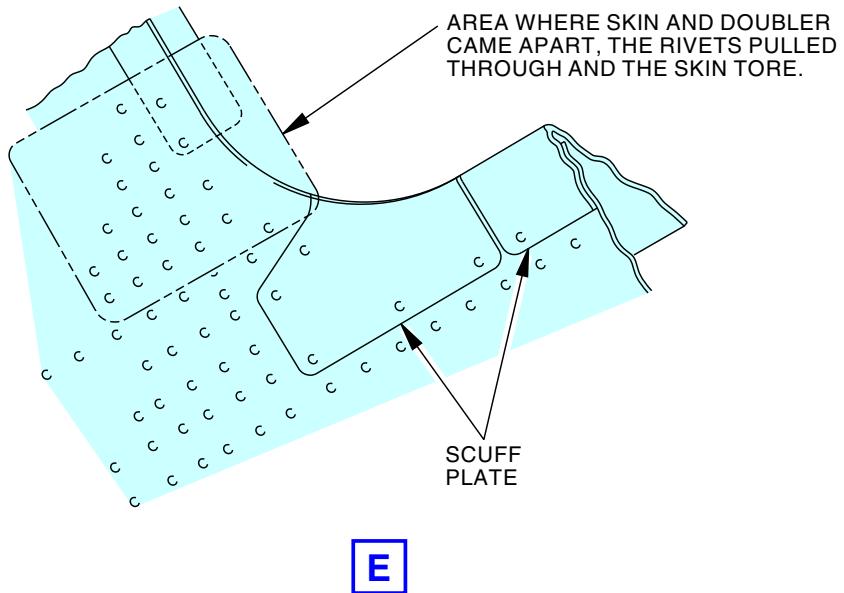
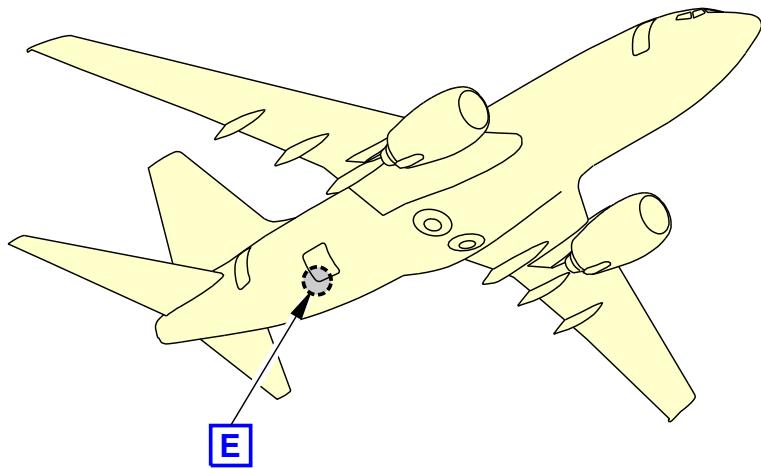
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**53-11-37**

Page 240  
Feb 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Door Openings  
Figure 206/53-11-37-990-808 (Sheet 4 of 4)

EFFECTIVITY  
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D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-11-37**

Page 241  
Feb 15/2023



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-11-37-600-810**

**8. Upper Lobe Frames, Stringers and Skin - Corrosion Prevention**  
(Figure 207)

**A. General**

- (1) The fuselage is of semi-monocoque construction which uses aluminum skins, circumferential frames and longitudinal hat section stringers. The fuselage skin is installed with circumferential butt joints and longitudinal lap joints that are usually flush riveted. Skins should be treated at the same time with the fuselage structure.
- (2) Cracks were found in the areas where the skin and doubler come apart. Cracks come from the fastener holes in the double rivet row in Stringer 17L and 17R between BS 422 to 500A, and BS 727A to BS 747.
- (3) Broken attach bolts were found in the vertical-fin-aft-spar-terminal support fitting at the upper center part of BS 1088 bulkhead. The attach bolts are made from H-11 steel alloy which are susceptible to cracks caused by stress corrosion.
- (4) The main compartment sidewall insulation have pillow blankets installed just inboard of the airplane skin and insulation blankets installed inboard of the pillow blankets. It was found that the pillow catches the moisture against the airplane skin which can add to possible corrosion of the adjacent structure.
- (5) Refer to CORROSION PREVENTION, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

**B. References**

Reference	Title
51-00	CORROSION PREVENTION
51-00-51	INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES

**C. Consumable Materials**

Reference	Description	Specification
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I

**D. Location Zones**

Zone	Area
200	Upper Half of Fuselage

**E. Corrosion Prevention**

SUBTASK 53-11-37-610-055

- (1) The basic corrosion prevention philosophy is to make the periodic inspection described in INSPECTION AND DETECTION, SUBJECT 51-00-51 to preclude or detect the early stages of corrosion. Skin bulges, missing fasteners or white powdery deposits are evidences of the existence of corrosion which should alert operators that some corrective action is required. A corrosion prevention program should be initiated to prevent the accumulation of moisture or corrosive compounds in order to minimize the occurrence of corrosion.

SUBTASK 53-11-37-610-056

- (2) Where extensive corrosion exists (very noticeable skin bulges, missing fasteners, or large amounts of white deposits at the fastener heads or faying surfaces), refer to Structural Repair Manual for details of corrosion removal.

EFFECTIVITY
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**53-11-37**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-11-37-610-057



**WARNING**

DO NOT APPLY THE CORROSION-INHIBITING COMPOUNDS IN THE AREAS THAT HAVE OXYGEN SYSTEM COMPONENTS. THE MIXTURE OF CORROSION-INHIBITING COMPOUNDS, AND OXYGEN CAN CAUSE AN EXPLOSION. AN EXPLOSION CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.



**CAUTION**

DO NOT INSTALL THE INSULATION BLANKETS THAT ARE SOAKED WITH CORROSION INHIBITING COMPOUNDS. INSULATION BLANKETS INADVERTENTLY SPATTERED WITH THE CORROSION INHIBITING COMPOUNDS SHOULD BE ALLOWED TO DRY BEFORE INSTALLATION. SOAKED INSULATION BLANKETS ARE POTENTIAL FIRE HAZARDS. THEY CAN CAUSE DAMAGE TO THE AIRPLANE.

- (3) For details of application of water displacing corrosion inhibiting compound, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-11-37-610-058

- (4) For minor corrosion detected during the periodic inspections and to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by an application of a corrosion inhibiting compound into the affected area to retard the corrosion process.

SUBTASK 53-11-37-610-059

- (5) Prevention treatment.

- (a) At first opportunity when schedule maintenance work allows access to the structure, corrosion prevention treatment should be accomplished.
- (b) Remove insulation blankets to expose frame, stringer and skin. Dry blankets thoroughly if found wet.
- (c) Replace broken or damaged finishes. Refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 for protective finish systems.
- (d) Apply a coat of epoxy primer, C00259, to the inboard flange surfaces of stringer and allow to dry thoroughly.
- (e) Apply water displacing corrosion inhibiting compound to all exposed structure. The use of spray equipment with nozzle directed into faying surfaces is recommended.
- (f) Allow solvent to evaporate before reinstalling insulation blankets.
- (g) Reinstall blankets so they are taut and so that the outboard surface of the upper blanket overlaps the lower blanket.
- (h) Reinstall liner and restore airplane to normal.

SUBTASK 53-11-37-610-060

- (6) Improved corrosion protection.

- (a) A production change replaced the H-11 attach bolts used in the vertical-fin-aft-spar-terminal support fitting at BS 1088 bulkhead with Inconel 718 bolts. The Inconel 718 bolt is less susceptible to cracks caused by stress corrosion.

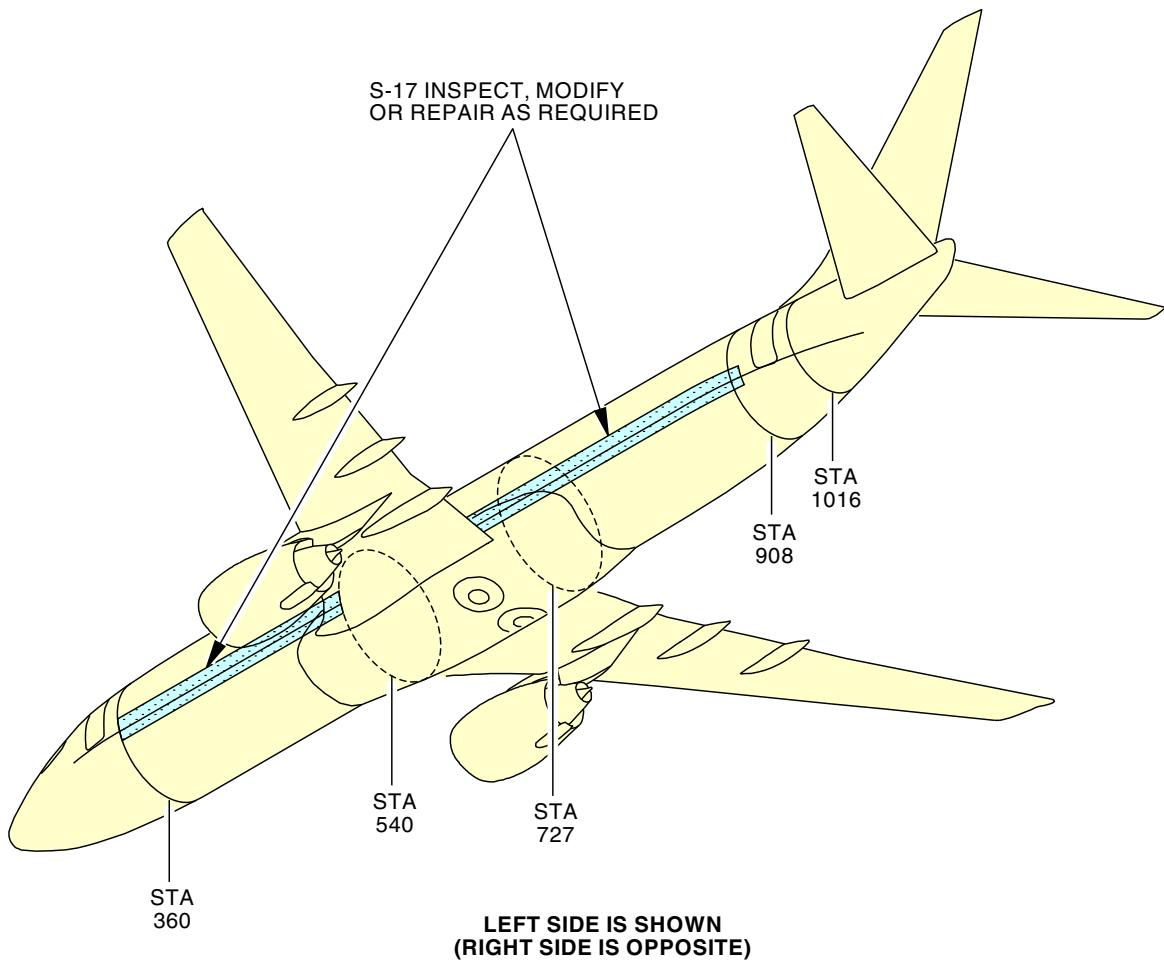
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**53-11-37**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Upper Lobe Frames, Stringers and Skin  
Figure 207/53-11-37-990-810 (Sheet 1 of 3)

EFFECTIVITY  
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**53-11-37**

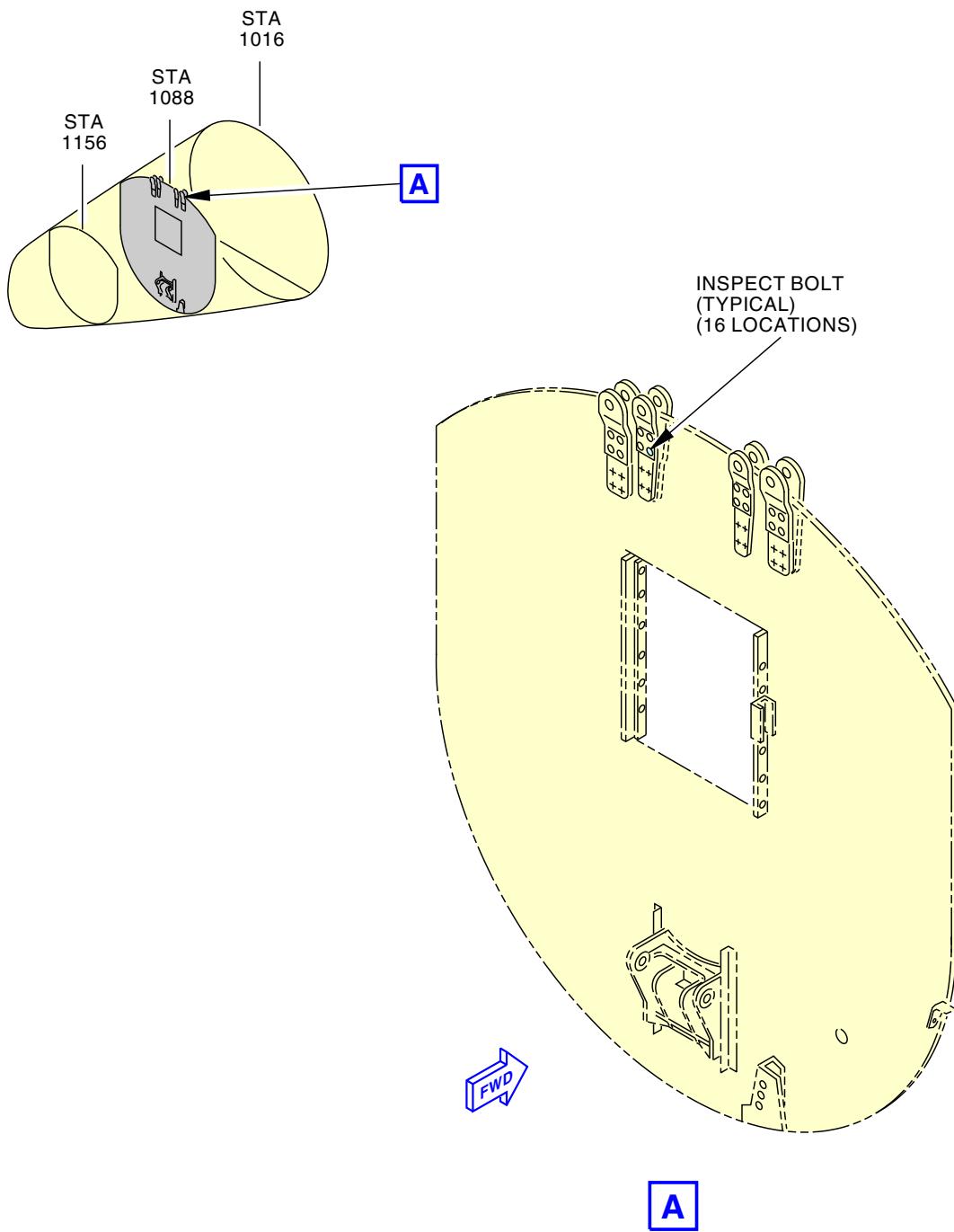
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Page 244  
Feb 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



J71680 S0000174997\_V2

Upper Lobe Frames, Stringers and Skin  
Figure 207/53-11-37-990-810 (Sheet 2 of 3)

EFFECTIVITY  
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**53-11-37**

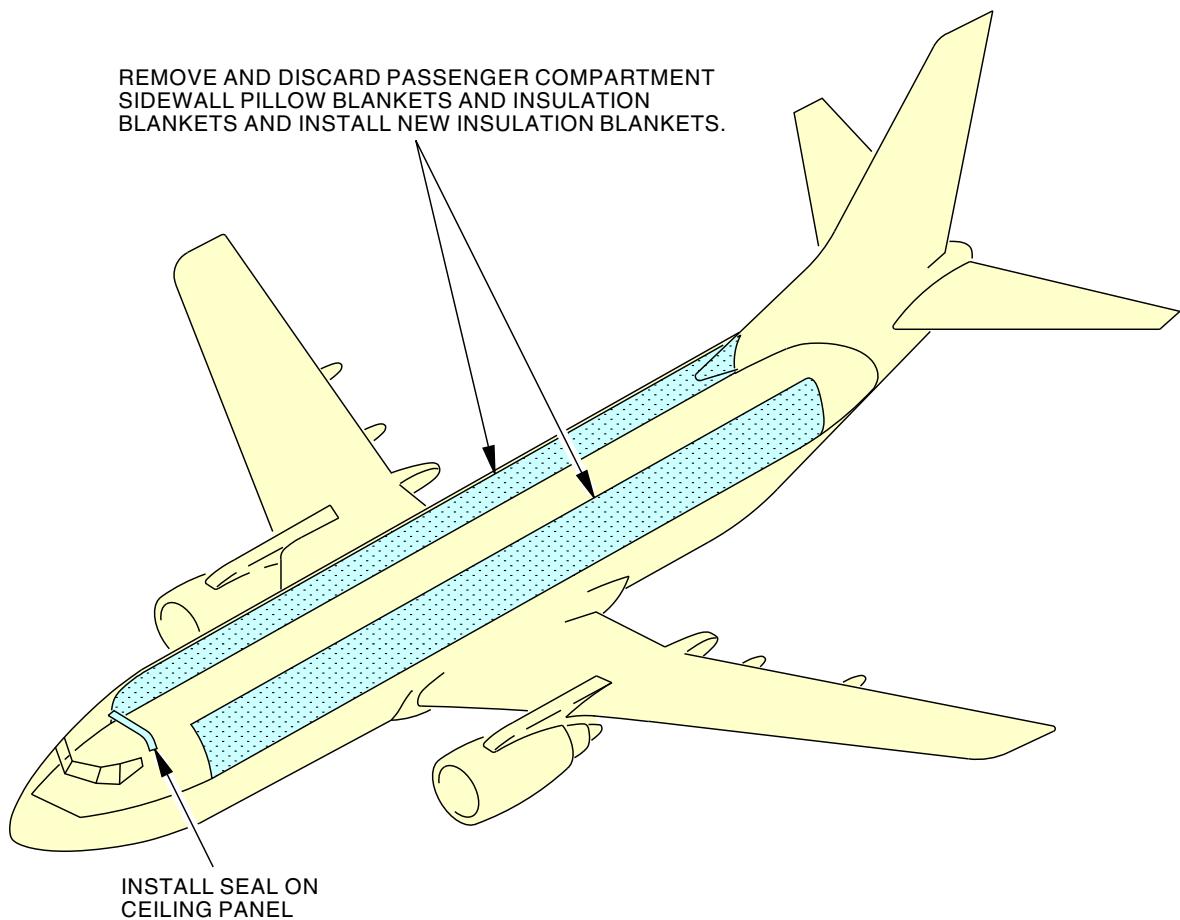
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 245  
Feb 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Upper Lobe Frames, Stringers and Skin  
Figure 207/53-11-37-990-810 (Sheet 3 of 3)

EFFECTIVITY  
LOM ALL

**53-11-37**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 246  
Feb 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

STRINGER BEAM LINKS - REMOVAL/INSTALLATION

**1. General**

- A. There are two tasks in this procedure.
  - (1) Stinger beam link removal.
  - (2) Stringer beam link installation.

**TASK 53-12-12-000-801**

**2. Stringer Beam Link Removal**

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

**A. General**

- (1) This task includes the steps to remove the S18A beam links found at STA 663.75, L/RBL 66, WL 199.

**B. References**

Reference	Title
25-21-46-000-801	Sidewall Panel - Removal (P/B 401)
25-22-00-000-801	Passenger Seat - Removal (P/B 401)
29-11-81-000-801	EDP Supply Shutoff Valve Removal (P/B 401)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
53-21-00-000-801	Passenger Cabin Floor Panel - Removal (P/B 401)
SRM 51-40-02-0G-0	Lockbolts and Hex-Drive Bolts

**C. Location Zones**

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
230	Subzone - Passenger Compartment - Body Station 360.00 to 663.75

**D. Prepare for the Removal**

SUBTASK 53-12-12-480-001



**WARNING**

OBEY THE PROCEDURE FOR THE INSTALLATION OF THE DOWNLOCK PINS. IF YOU MOVE THE CONTROL LEVER FOR THE LANDING GEAR TO THE UP POSITION, THE LANDING GEAR CAN RETRACT. THIS CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (1) Install the downlock pins for the main landing gear (TASK 32-00-01-480-801.)

SUBTASK 53-12-12-010-001

- (2) Remove the applicable passenger seats aft of the overwing emergency exit (TASK 25-22-00-000-801).

SUBTASK 53-12-12-010-002

- (3) Remove the applicable floor panels (TASK 53-21-00-000-801).

SUBTASK 53-12-12-010-003

- (4) If necessary, remove the applicable sidewall panels (Sidewall Panel - Removal, TASK 25-21-46-000-801).

EFFECTIVITY  
LOM ALL

**53-12-12**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-12-12-010-004

- (5) If necessary, remove the EDP shutoff valve (TASK 29-11-81-000-801).

SUBTASK 53-12-12-010-005

- (6) If necessary, remove the hydraulic fuses and other equipment for access to the aft links in the MLG wheel well.

**E. Forward Link Removal**

SUBTASK 53-12-12-020-001

- (1) From the passenger compartment, remove the bolt [2], bolt [3], washers [4], bushing [5], bushing [6], washers [7] and nuts [8] that attach the link [1] to the fitting [14] and fitting [15].  
(a) Remove the link [1].

**F. Aft Link Removal**

SUBTASK 53-12-12-020-002

- (1) From the MLG wheel well, remove the bolt [2], bolt [3], washers [4], bushing [5], bushing [6], washers [7] and nuts [8] that attach the link [1] to the fitting [13] and stringer [17].  
(a) Remove the link [1].  
1) If necessary, do the next step.

SUBTASK 53-12-12-020-003

- (2) If necessary, remove the bolts [9], bolts [10], bolts [11] and collars [12] that attach the fitting [13] to the spar frame [16], fitting [14] and fitting [15] (SRM 51-40-02-0G-0).

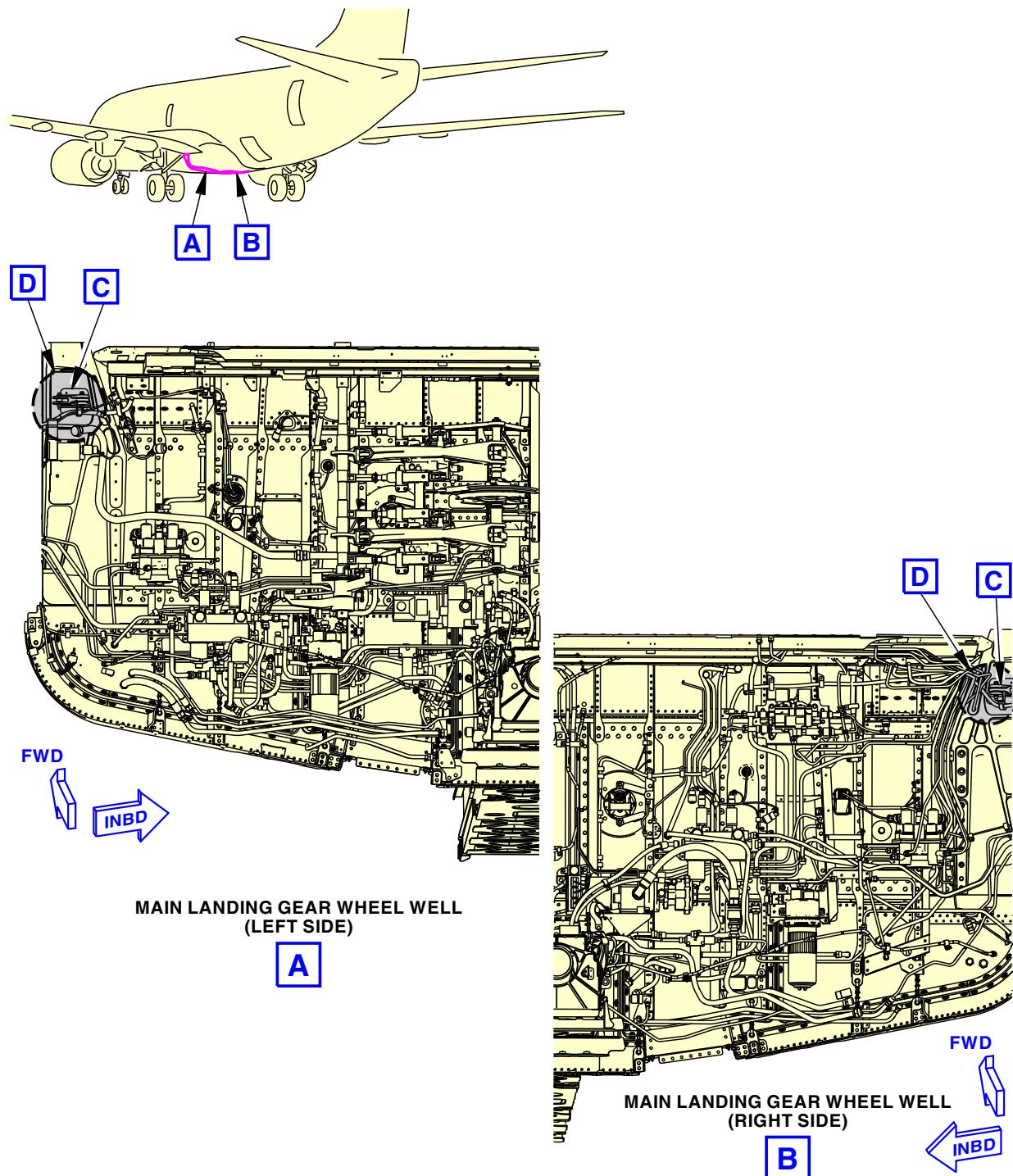
NOTE: Make a record of the fastener positions for installation.

- (a) Remove the fitting [13].  
(b) Remove the link [1].

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-12-12**



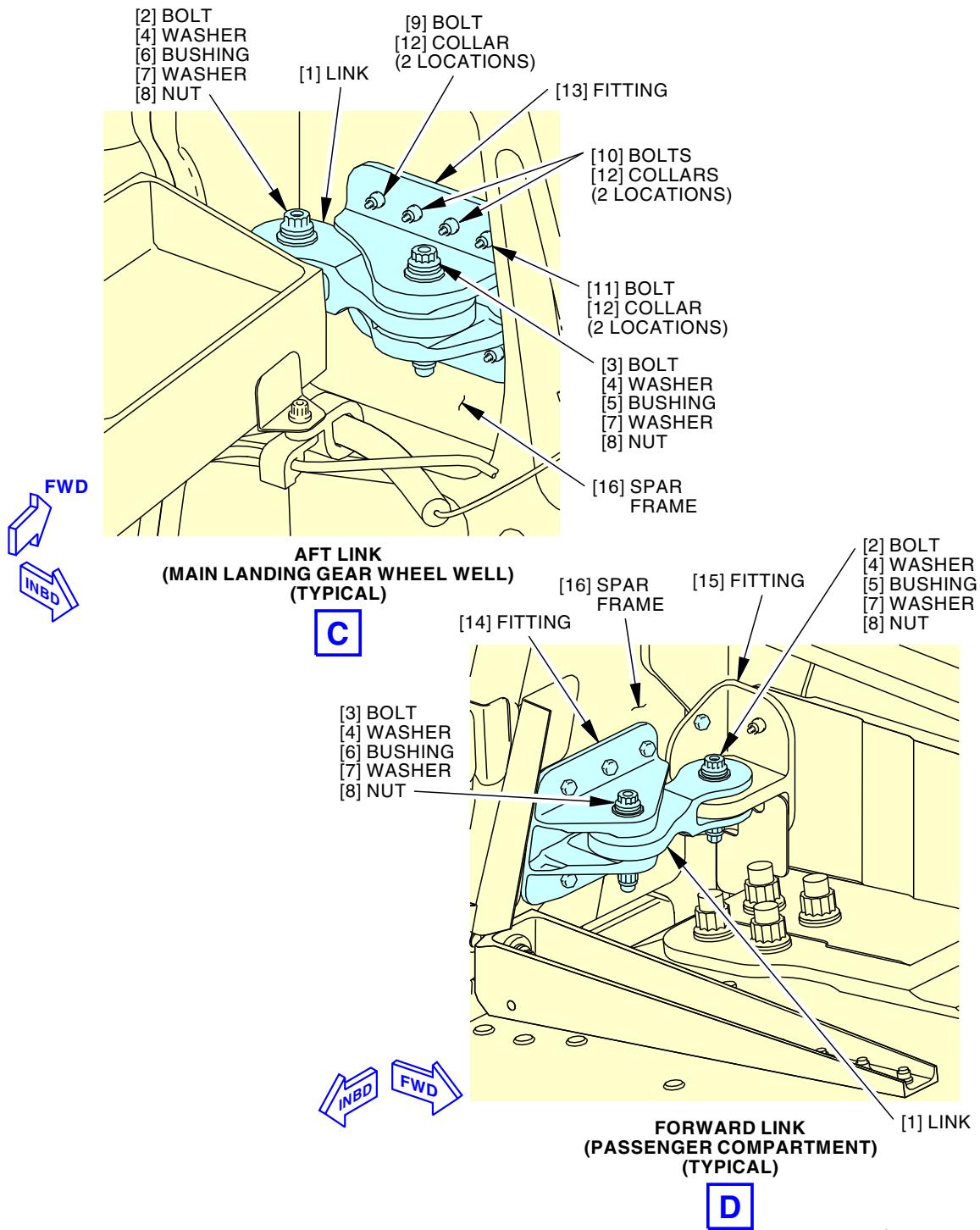
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**STRINGER BEAM LINK INSTALLATION**  
**Figure 401/53-12-12-990-801 (Sheet 1 of 2)**

EFFECTIVITY  
 LOM ALL

**53-12-12**

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**STRINGER BEAM LINK INSTALLATION**  
**Figure 401/53-12-12-990-801 (Sheet 2 of 2)**

 EFFECTIVITY  
 LOM ALL

**53-12-12**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-12-12-400-801**

**3. Stringer Beam Link Installation**

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

**A. General**

- (1) This task includes the steps to install the S18A beam links found at STA 663.75, L/RBL 66, WL 199.

**B. References**

Reference	Title
25-21-46-400-801	Sidewall Panel - Installation (P/B 401)
25-22-00-400-802	Passenger Seat - Installation (P/B 401)
29-11-81-400-801	EDP Supply Shutoff Valve Installation (P/B 401)
53-21-00-400-801	Passenger Cabin Floor Panel - Installation (P/B 401)
SRM 51-40-02-0G-0	Lockbolts and Hex-Drive Bolts

**C. Consumable Materials**

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
B00065	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002 (Supersedes O-A-396)
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

**D. Location Zones**

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
230	Subzone - Passenger Compartment - Body Station 360.00 to 663.75

**E. Prepare for the Installation**

**SUBTASK 53-12-12-100-001**

- (1) Do these steps if the aft fitting [13] was removed:
- Clean the mating surfaces of the fitting [13] and the spar frame [16] with a cotton wiper, G00034, wet with alcohol, B00065.
  - Dry the surfaces with a clean, dry cotton wiper, G00034 before the solvent dries.

**F. Forward Link Installation**

**SUBTASK 53-12-12-420-001**

- (1) From the passenger compartment, put the link [1] in its position on the fittings.
- Install the bolt [2], bolt [3], washers [4], bushing [5], bushing [6], washers [7] and nuts [8] that attach the link [1] to the fitting [14] and fitting [15].
  - Torque the fasteners  $400 \pm 100$  in-lb ( $45 \pm 11$  N·m)
    - May torque from the head side.
    - When torqued from the head side, use a torque setpoint of 500 in-lb (56 N·m).

EFFECTIVITY
LOM ALL

**53-12-12**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**G. Aft Link Installation**

SUBTASK 53-12-12-420-002

- (1) Do these steps to install the aft fitting [13]:
  - (a) Apply a fay surface bond between the fitting [13] and spar frame [16] with sealant, A00247.
  - (b) Put the link [1] on the fitting [13].
  - (c) Install the fitting [13] to the spar frame [16].
    - 1) Position the link [1] onto the stringer [17].
  - (d) Install the bolts [9], bolts [10] and bolts [11] that attach the fitting [13] to the spar frame [16], fitting [14] and fitting [15].
    - 1) Install the collars [12] onto the bolts [9], bolts [10] and bolts [11] (SRM 51-40-02-0G-0).

SUBTASK 53-12-12-420-003

- (2) Put the link [1] in its position on the fitting and stringer.
  - (a) Install the bolt [2], bolt [3], washers [4], bushing [5], bushing [6], washers [7] and nuts [8] that attach the link [1] to the fitting [13] and stringer [17].
  - (b) Torque the fasteners  $400 \pm 100$  in-lb ( $45 \pm 11$  N·m)
    - 1) May torque from the head side.
    - 2) When torqued from the head side, use a torque setpoint of 500 in-lb (56 N·m).

SUBTASK 53-12-12-370-001

- (3) Apply finishes removed during the removal procedure.

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

SUBTASK 53-12-12-410-001

- (1) If necessary, install the hydraulic fuses and other equipment.

SUBTASK 53-12-12-410-002

- (2) If necessary, install the EDP shutoff valve (TASK 29-11-81-400-801).

SUBTASK 53-12-12-410-003

- (3) If necessary, install the applicable sidewall panels (Sidewall Panel - Installation, TASK 25-21-46-400-801).

SUBTASK 53-12-12-410-004

- (4) Install the applicable floor panels (TASK 53-21-00-400-801).

SUBTASK 53-12-12-410-005

- (5) Install the applicable passenger seats aft of the overwing emergency exit (TASK 25-22-00-400-802).

———— END OF TASK ————

EFFECTIVITY
LOM ALL

**53-12-12**

Page 406  
Oct 15/2021



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

NOSE WHEEL WELL ACCESS PANELS - REMOVAL/INSTALLATION

**1. General**

- A. This procedure contains these tasks:
  - (1) The removal of the Nose Wheel Well Access panels.
  - (2) The installation of the Nose Wheel Well Access panels.

**TASK 53-14-01-020-801**

**2. Nose Wheel Well Access Panels - Removal**

(Figure 401)

**A. General**

- (1) This task gives the instructions to remove the nose wheel well access panels.
- (2) The nose wheel well access panel is referred to as the access panel in this task.

**B. References**

Reference	Title
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)

**C. Location Zones**

Zone	Area
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right

**D. Prepare for the Removal**

SUBTASK 53-14-01-010-001



**WARNING**

MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED IN ALL OF THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT AND CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (1) If the downlock pins are not installed in the nose and main landing gear, do this task: Landing Gear Downlock Pins Installation, TASK 32-00-01-480-801.

**E. Forward Side Access Panel Removal**

SUBTASK 53-14-01-020-002

- (1) Remove the forward access panels [15].
  - (a) Remove the bolts [14].
  - (b) Remove the washers [2].
  - (c) Remove the O-ring seal washers [3].
    - 1) Discard the O-ring seal washers [3].

SUBTASK 53-14-01-020-005

- (2) Remove the forward access panel [15].

**F. Aft Side Access Panel Removal**

SUBTASK 53-14-01-020-006

- (1) Remove the aft access panels [18].
  - (a) Remove bolts [17].
  - (b) Remove the washers [2].

EFFECTIVITY  
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**53-14-01**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (c) Remove the O-ring seal washers [3].
  - 1) Discard the O-ring seal washers [3].

SUBTASK 53-14-01-020-008

- (2) Remove the aft access panel [18].

**G. Top Access Panels Removal**

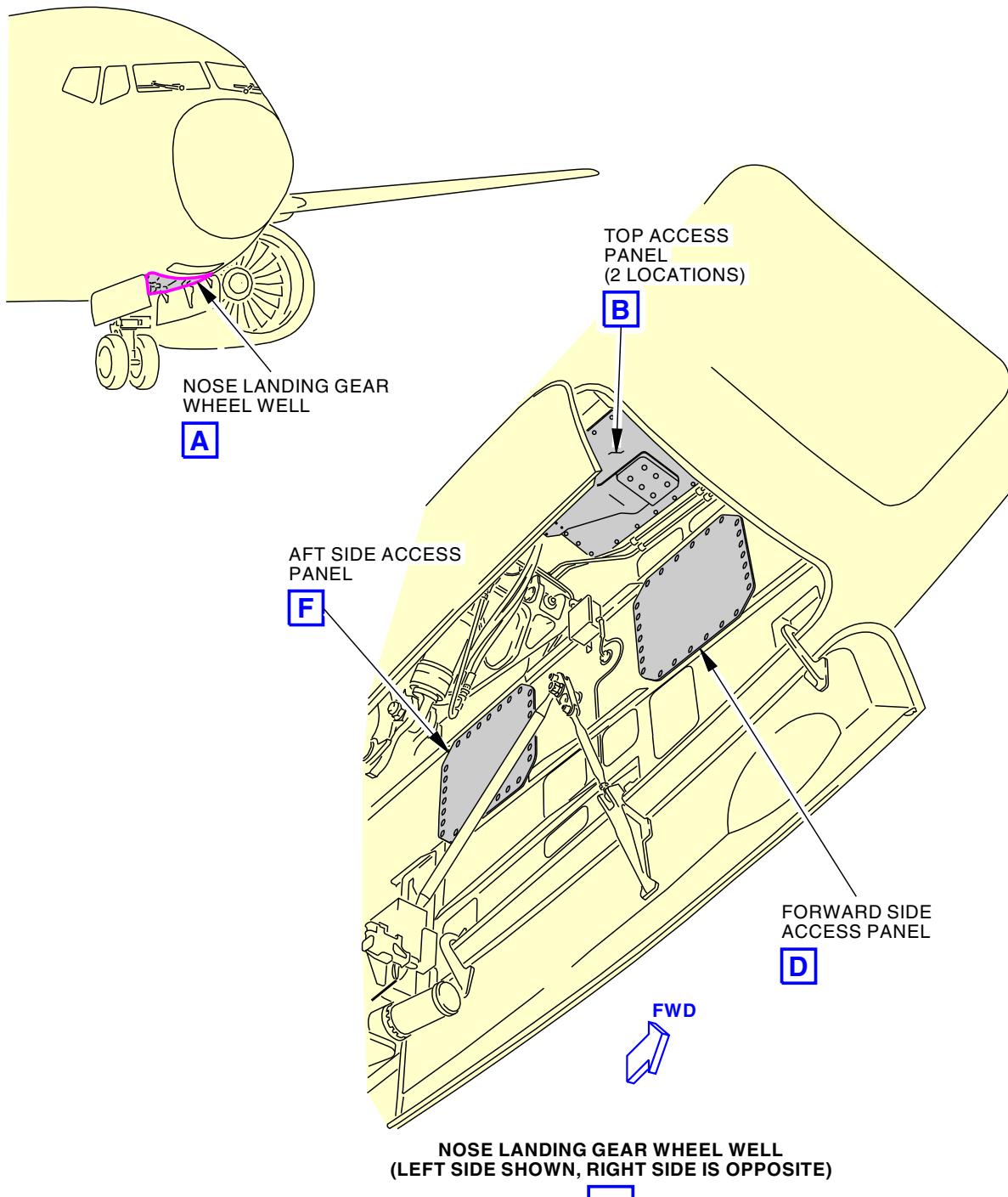
SUBTASK 53-14-01-020-001

- (1) Remove the top access panels [4] and spring assemblies [20].
  - (a) Remove the bolts [1], bolts [5] and bolts [6].
  - (b) Remove the O-ring seal washers [3] and washers [2].
    - 1) Discard the O-ring seal washers [3].
  - (c) Remove the top access panel [4] and spring assembly [20].
  - (d) If necessary, remove the spring assembly [20].
    - 1) Remove the bolts [8], the washers [9] and nuts [10] from the spring assembly [20] and top access panel [4].
    - 2) Remove the spring [7], the filler [12] and plate [13].

———— END OF TASK ————

EFFECTIVITY  
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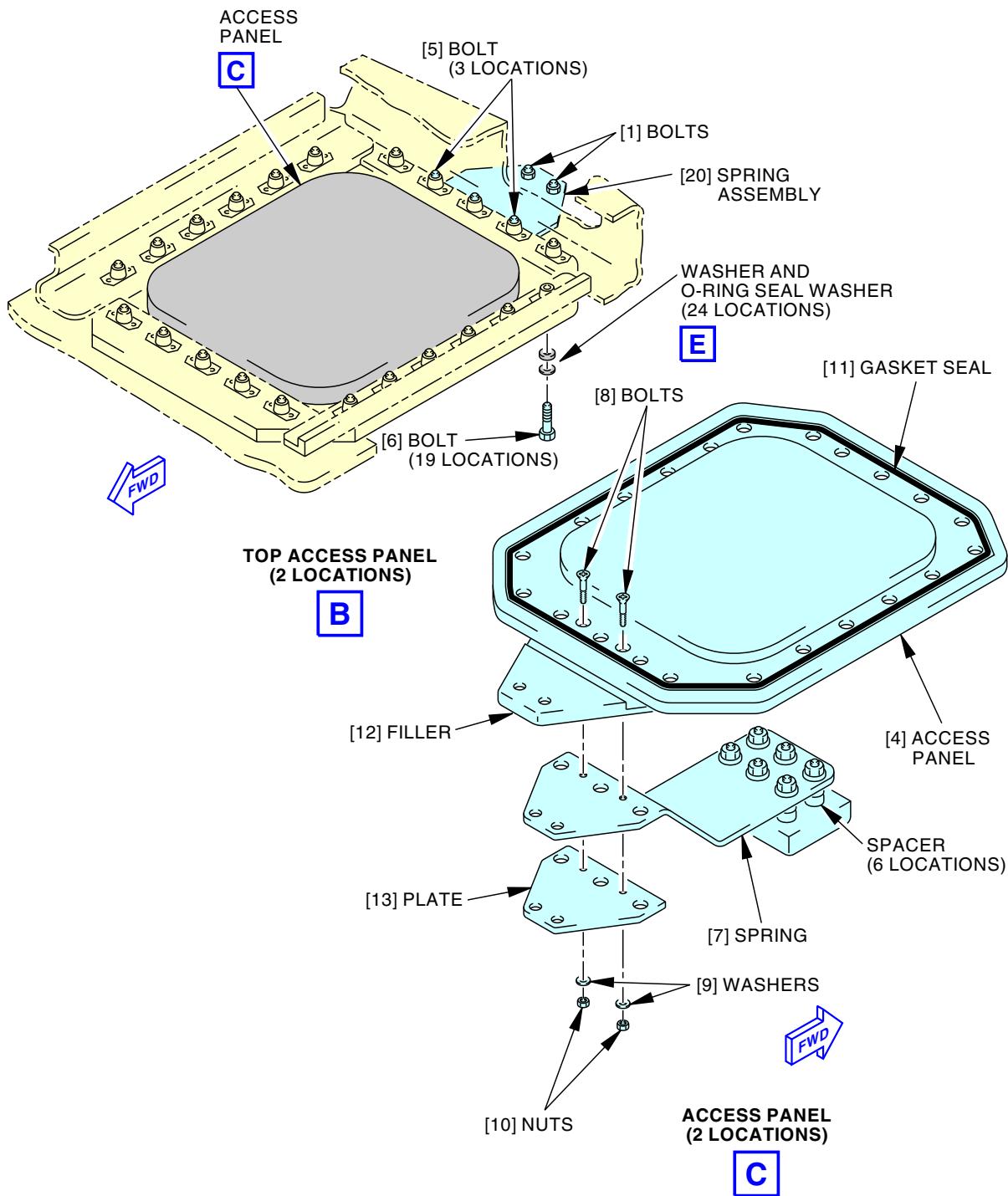
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**Nose Wheel Well Access Panels Removal/Installation**  
Figure 401/53-14-01-990-802 (Sheet 1 of 4)EFFECTIVITY  
LOM ALL**53-14-01**

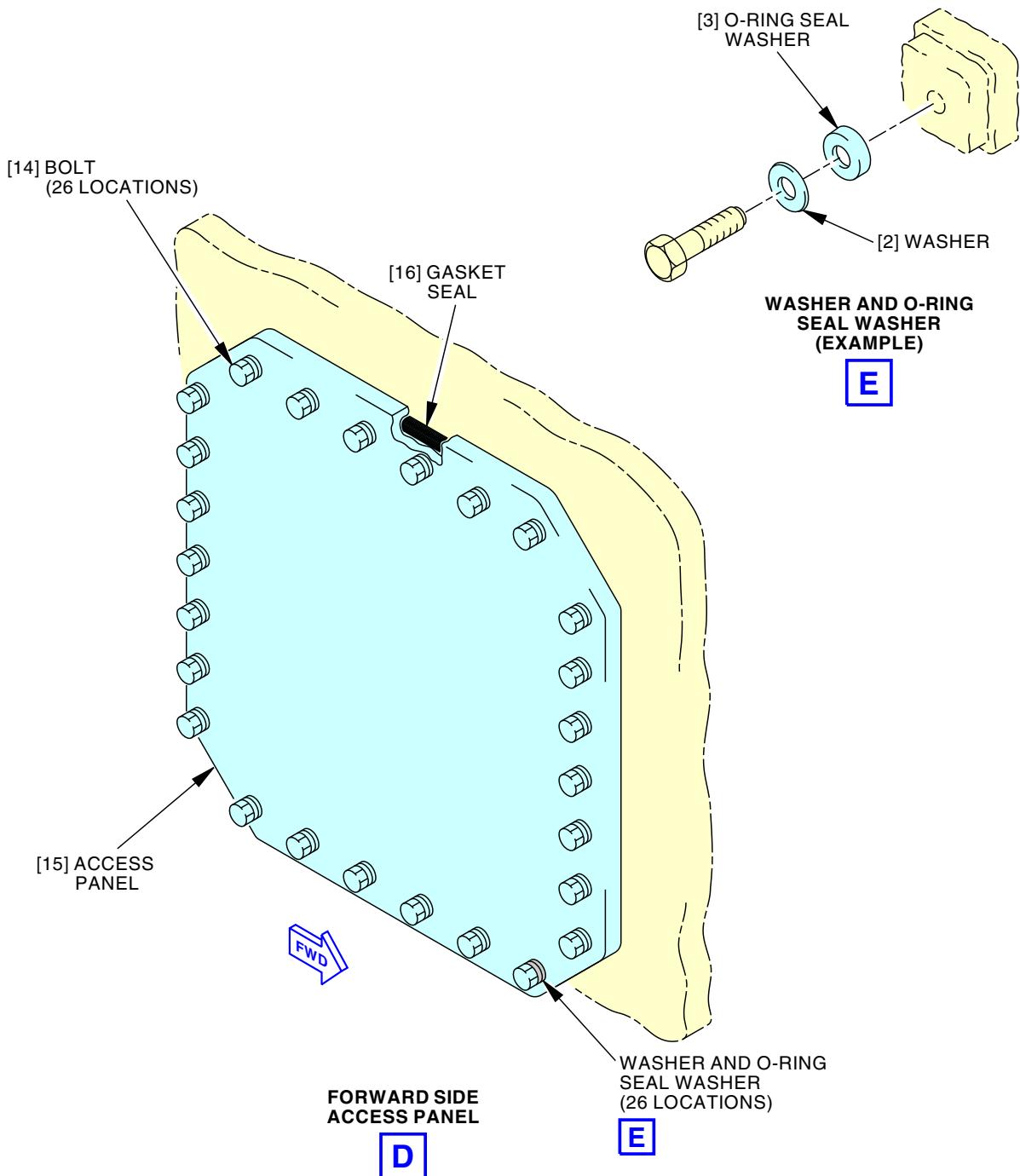
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**737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL**


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**Nose Wheel Well Access Panels Removal/Installation**  
**Figure 401/53-14-01-990-802 (Sheet 2 of 4)**

**53-14-01**



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**Nose Wheel Well Access Panels Removal/Installation  
Figure 401/53-14-01-990-802 (Sheet 3 of 4)**

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 LOM ALL

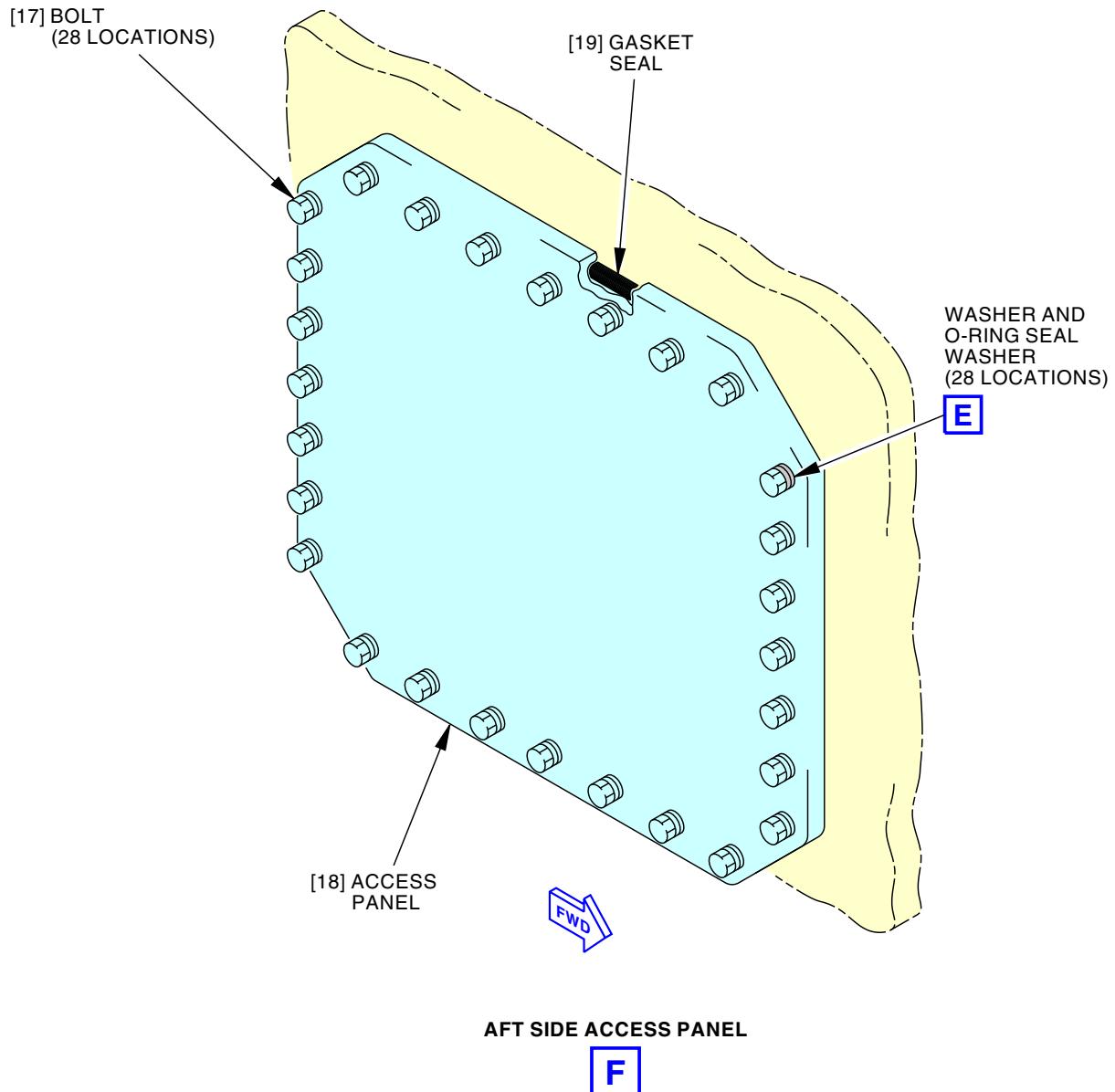
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**53-14-01**

 Page 405  
 Feb 15/2019

**BOEING**  
737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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**Nose Wheel Well Access Panels Removal/Installation**  
Figure 401/53-14-01-990-802 (Sheet 4 of 4)

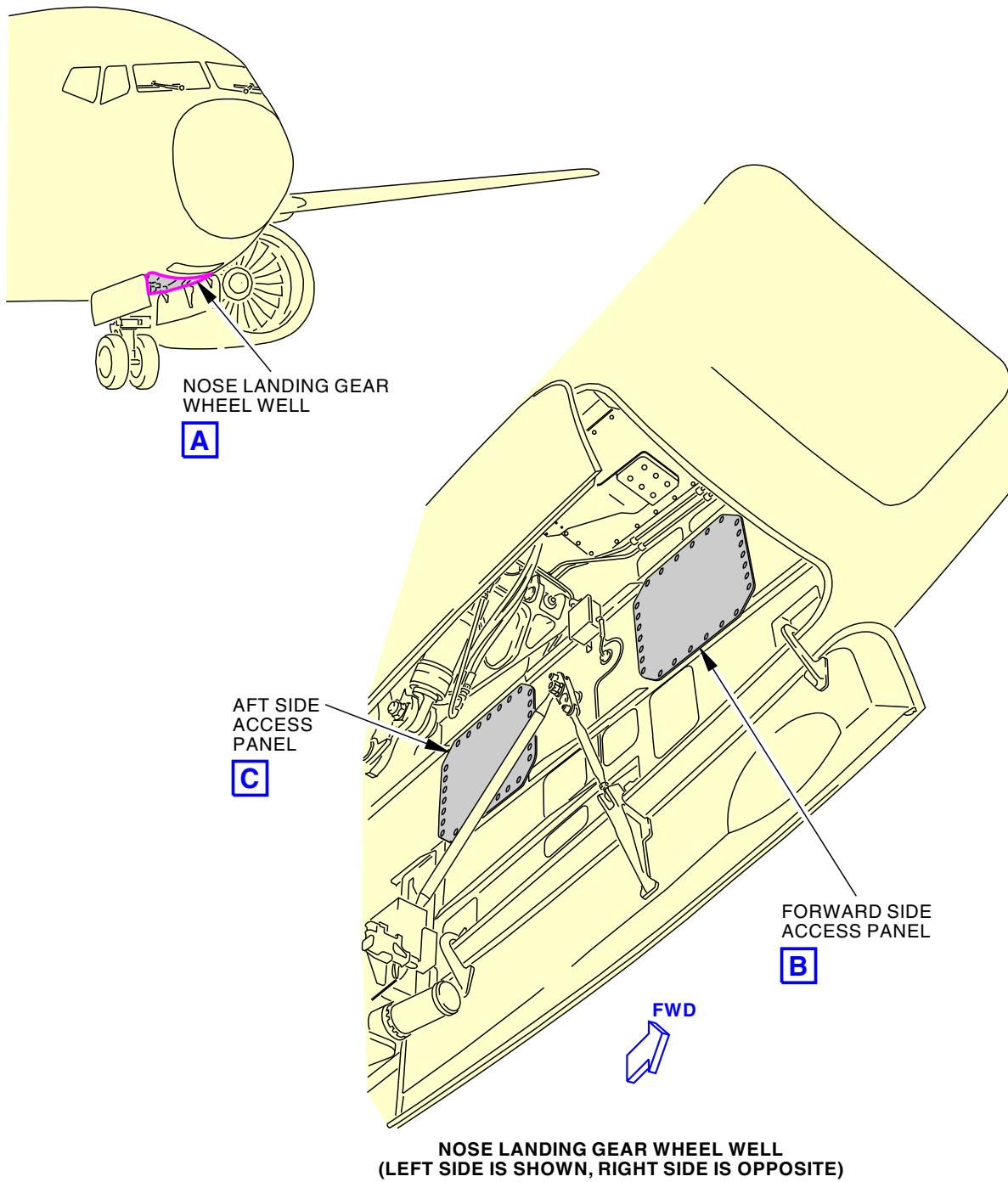
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 406  
Feb 15/2019



2977976 S0000756271\_V1

**Nose Wheel Well Access Panel Sealant Inspection**  
Figure 402/53-14-01-990-803 (Sheet 1 of 3)

EFFECTIVITY  
LOM ALL

**53-14-01**

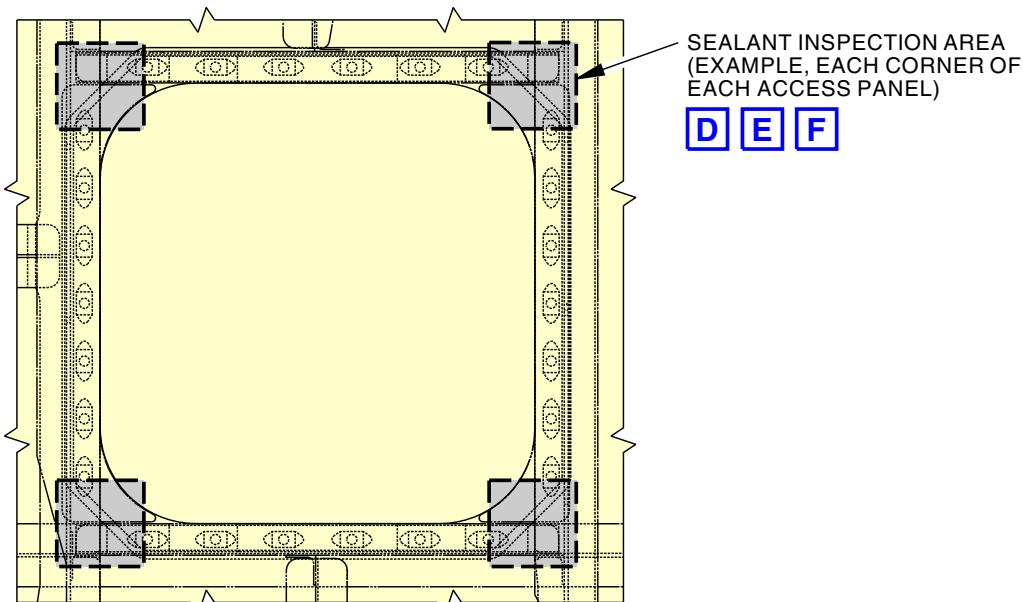
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 407  
Oct 15/2021

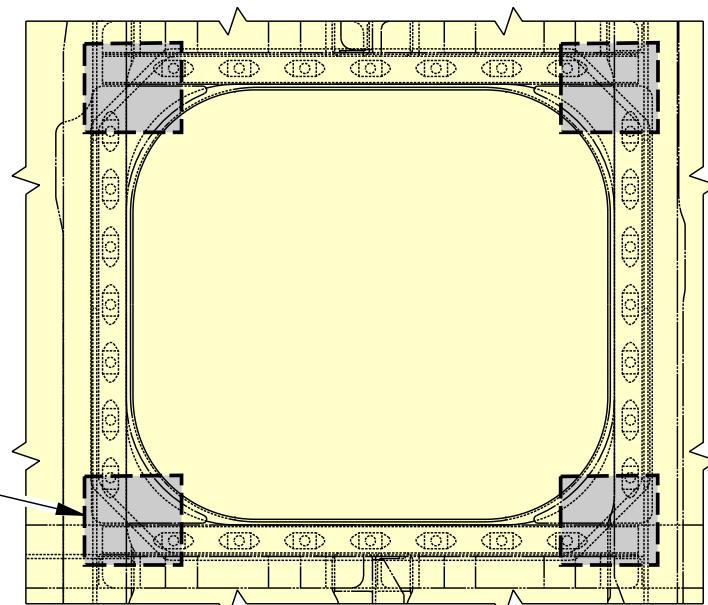


737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



FORWARD SIDE ACCESS PANEL  
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

B



AFT SIDE ACCESS PANEL  
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

C

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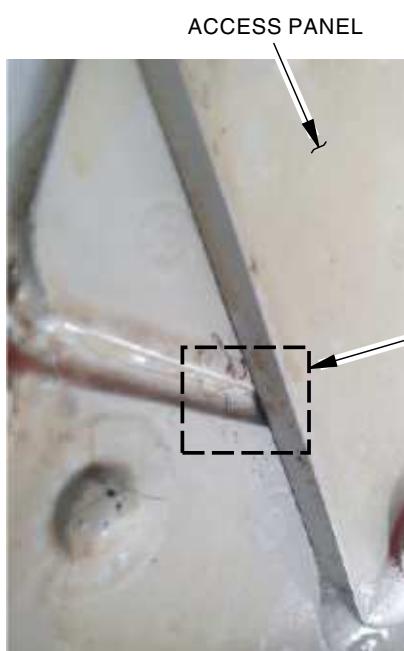
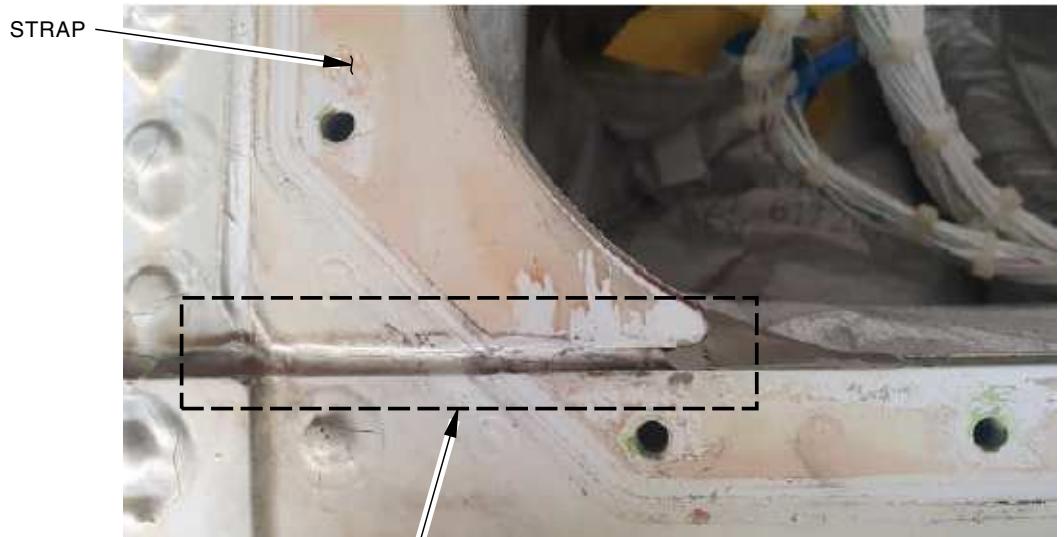
Nose Wheel Well Access Panel Sealant Inspection  
Figure 402/53-14-01-990-803 (Sheet 2 of 3)

EFFECTIVITY  
LOM ALL

53-14-01



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



E

D



F

SEALANT INSPECTION AREA

(ACCESS PANEL IS REMOVED)

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Nose Wheel Well Access Panel Sealant Inspection  
Figure 402/53-14-01-990-803 (Sheet 3 of 3)

EFFECTIVITY  
LOM ALL

53-14-01

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 409  
Oct 15/2021



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-14-01-420-801**

**3. Nose Wheel Well Access Panels - Installation**

(Figure 401 and Figure 402)

**A. General**

- (1) This task gives the instructions to install the nose wheel well access panels.
- (2) The nose wheel well access panel is referred to as the access panel in this task.

**B. References**

Reference	Title
05-51-91-790-801	Cabin Pressure Leak Test (P/B 201)
51-31-00-390-803	Hole and Slot Seal Application (P/B 201)

**C. Consumable Materials**

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
G00268	Brush - Soft Bristle, Paint	

**D. Expendables/Parts**

AMM Item	Description	AIPC Reference	AIPC Effectivity
3	O-ring seal washer	32-22-11-02-030	LOM ALL
4	Top access panel	32-22-11-02-035	LOM ALL
15	Forward access panel	32-22-11-02-110	LOM ALL
18	Aft access panel	32-22-11-02-135	LOM ALL

**E. Location Zones**

Zone	Area
115	Nose Landing Gear Wheel Well - Left
116	Nose Landing Gear Wheel Well - Right

**F. Prepare for the Installation**

**SUBTASK 53-14-01-210-001**

- (1) Examine the sealant areas for the forward and aft side access panels 113AW, 113BW, 114AW, and 114BW as shown in Figure 402.
  - (a) Make sure that the sealant is not damaged.
  - (b) Make sure that the sealant is not missing.
  - (c) Make sure that there are no gaps between the access panels and the airplane structure.
  - (d) Make sure that there are no signs of cabin pressure leak.
  - (e) If there are signs of damage or missing sealant, remove the access panels.
    - 1) Apply sealant, A00247 (TASK 51-31-00-390-803).
    - 2) Install the access panels.

**G. Forward Side Access Panels Installation**

**SUBTASK 53-14-01-420-002**

- (1) Install the forward access panels [15].
  - (a) Examine the gasket seal [16] for its condition.
    - 1) Replace the forward access panel [15] if the gasket seal [16] is damaged.

EFFECTIVITY LOM ALL

**53-14-01**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (b) Install the forward access panel [15] in its location.
- (c) Install the washers [2], bolts [14] and new O-ring seal washers [3].

SUBTASK 53-14-01-420-004

- (2) Tighten the bolts [14] to  $60 \pm 10$  in-lb ( $7 \pm 1$  N·m).

SUBTASK 53-14-01-200-001

- (3) Make sure that there are no air leaks (TASK 05-51-91-790-801).

## H. Aft Side Access Panels Installation

SUBTASK 53-14-01-400-001

- (1) Install the aft access panels [18].
  - (a) Examine the gasket seal [19] for its condition.
    - 1) Replace the aft access panel [18] if the gasket seal [19] is damaged.
  - (b) Install the aft access panel [18] in its location.
  - (c) Install the washers [2], bolts [17] and new O-ring seal washers [3].

SUBTASK 53-14-01-420-005

- (2) Tighten the bolts [17] to  $60 \pm 10$  in-lb ( $7 \pm 1$  N·m).

SUBTASK 53-14-01-790-001

- (3) Make sure that there are no air leaks (TASK 05-51-91-790-801).

## I. Top Access Panels Installation

SUBTASK 53-14-01-400-002

- (1) Install the top access panels [4] and spring assemblies [20].
    - (a) Install the spring assembly [20].
      - 1) Apply a layer of sealant, A00247, on the plate [13].
      - 2) Put the plate [13] on the bottom of the spring [7].
      - 3) Apply a layer of sealant, A00247, on the spring [7].
      - 4) Put the filler [12] on the top of the spring [7].
      - 5) Apply a layer of sealant, A00247, on the top access panel [4].
      - 6) Put the top access panel [4] above the spring assembly [20].
      - 7) With a brush, G00268, apply sealant, A00247, to the access panel holes before you install the bolts [8].
      - 8) Install the bolts [8].
      - 9) Install the washers [9] and nuts [10].
      - 10) Tighten the nuts [10] to  $35 \pm 1$  in-lb ( $4 \pm 0$  N·m).
    - (b) Examine the gasket seal [11] for its condition.
      - 1) Replace the top access panel [4] if the gasket seal [11] is damaged.
    - (c) Install the top access panel [4] with the spring assembly [20] in its location.
    - (d) Install the washers [2], bolts [6], bolts [5], bolts [1] and new O-ring seal washers [3].
- SUBTASK 53-14-01-420-006
- (2) Tighten the bolts [6], bolts [5], and bolts [1] to  $60 \pm 10$  in-lb ( $7 \pm 1$  N·m).

EFFECTIVITY
LOM ALL

**53-14-01**

Page 411  
Feb 15/2024

D633A101-LOM



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-14-01-790-002

- (3) Make sure that there are no air leaks (TASK 05-51-91-790-801).

———— END OF TASK ————

— EFFECTIVITY —  
**LOM ALL**

**53-14-01**

Page 412  
Feb 15/2024

D633A101-LOM



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

PASSENGER CABIN FLOORS - REMOVAL/INSTALLATION

**1. General**

- A. This procedure contains two tasks:
- (1) The removal of the passenger cabin floor panels.
  - (2) The installation of the passenger cabin floor panels.

**TASK 53-21-00-000-801**

**2. Passenger Cabin Floor Panel - Removal**

(Figure 401)

**A. General**

- (1) This task has one or more steps which are a means to satisfy Critical Design Configuration Control Limitation (CDCCL) requirements. A CDCCL note will follow the step to which it applies. Any step or sub-step that precedes or follows a CDCCL identified step is not subject to the CDCCL requirement.
  - (a) For important information on CDCCL requirements, refer to this task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801.

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

**B. References**

Reference	Title
25-27-21-000-801	Entry and Service Area Floor Covering - Removal (P/B 401)
28-11-00-211-801	External Wires Over the Center Fuel Tank Inspection (P/B 601)
53-00-00-912-801	Airworthiness Limitation Precautions (P/B 201)
53-21-11-300-801	Vinyl Water Barrier Repair (P/B 801)

**C. Tools/Equipment**

Reference	Description
STD-1064	Scraper - Phenolic, Hard Resin

**D. Location Zones**

Zone	Area
200	Upper Half of Fuselage

**E. Passenger Cabin Floor Panel Removal**

**SUBTASK 53-21-00-010-001**

- (1) Break the panel seals.
  - (a) If the water barrier is installed, get access to the panel fasteners.
    - 1) Do this task: Vinyl Water Barrier Repair, TASK 53-21-11-300-801.
  - (b) If the entry and service area floor covering is installed, get access to the panel fasteners.
    - 1) Do this task: Entry and Service Area Floor Covering - Removal, TASK 25-27-21-000-801.
  - (c) Break the seals with a hard resin phenolic scraper, STD-1064, or a sealant removal tool.

**SUBTASK 53-21-00-020-001**

- (2) Remove the fasteners.

**SUBTASK 53-21-00-020-002**

- (3) Remove the panel.

EFFECTIVITY  
LOM ALL

**53-21-00**



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AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-21-00-010-002

- (4) If you removed the panels over the center fuel tank and do maintenance in the area above the center fuel tank, do these steps:

**28-AWL-02: CDCCL**

- (a) Make sure you do not change the routing and clamping of the wires over the center fuel tank.

NOTE: CDCCL- Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important Information on CDCCL.

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

**28-AWL-02: CDCCL**

- (b) Before you install the panels over the center tank, do this task only for the areas over the center tank where you removed the panels: External Wires Over the Center Fuel Tank Inspection, TASK 28-11-00-211-801

NOTE: CDCCL- Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important Information on CDCCL.

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

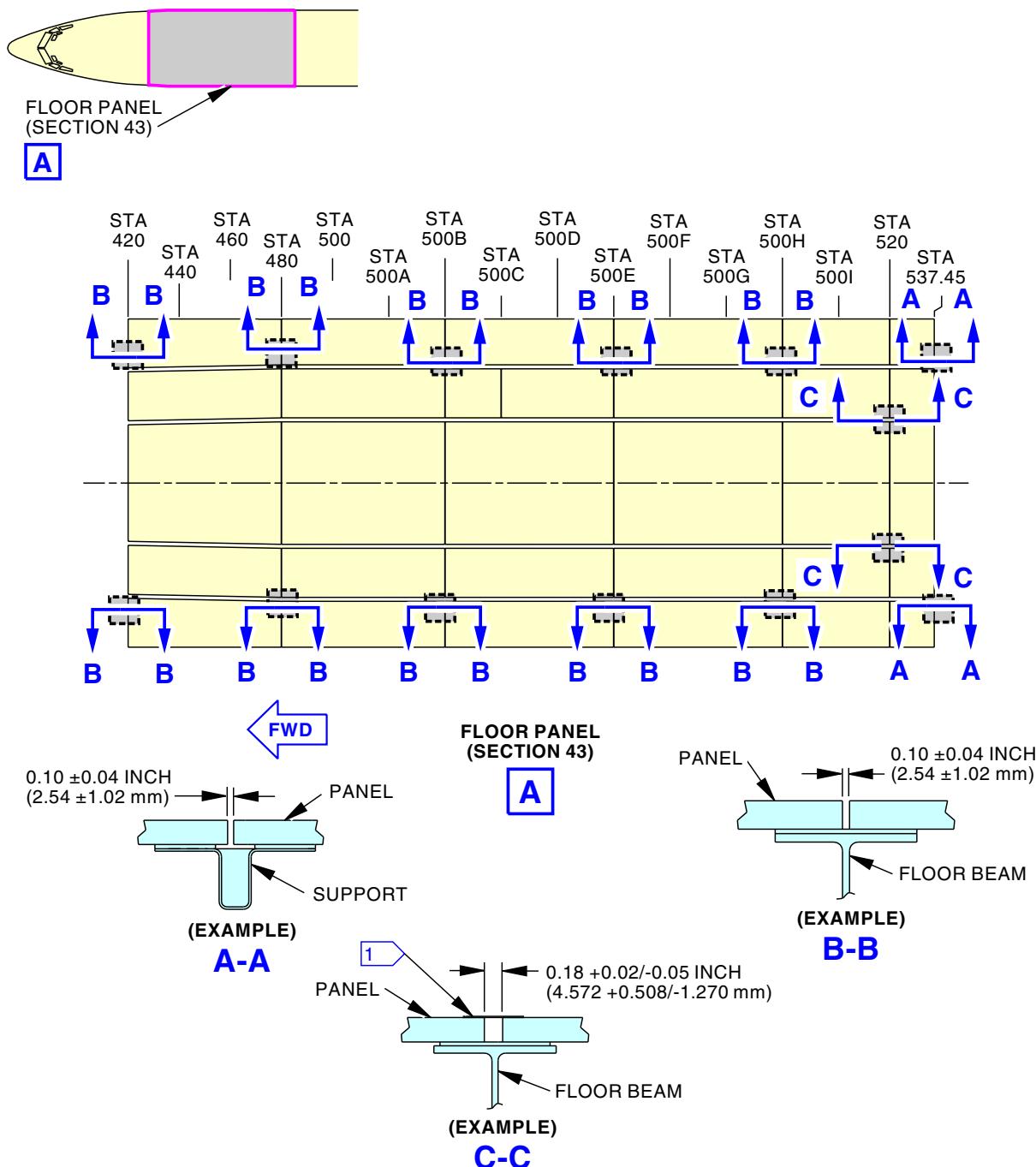
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-21-00**



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- 1 IF CLEARANCE IS MORE THAN 0.20 INCH (5.08 mm).  
INSTALL BACS40R010U190 BETWEEN THE SEATRACKS,  
AND INSTALL THE CLEARANCE COVER SHIM  
BACS40R010U477 IN AISLE.

2105077 S0000449048\_V5

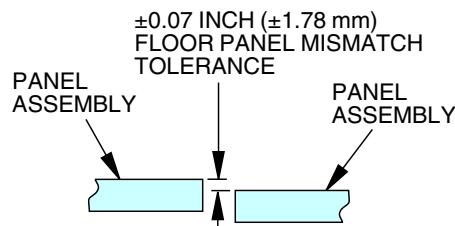
Floor Panel Installation and Sealing  
Figure 401/53-21-00-990-806 (Sheet 1 of 2)

EFFECTIVITY  
LOM ALL

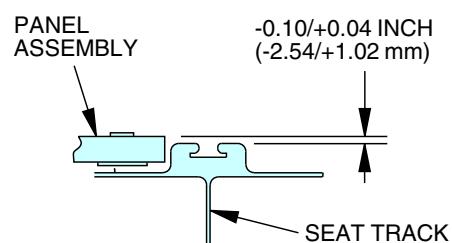
53-21-00



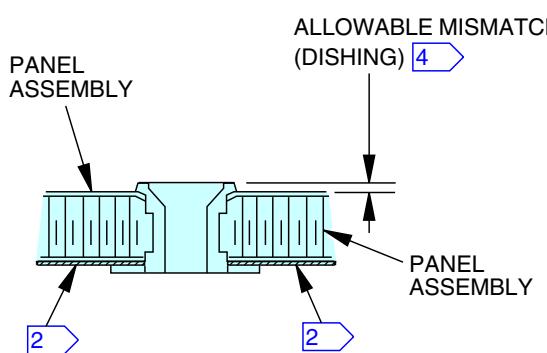
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AIRCRAFT MAINTENANCE MANUAL



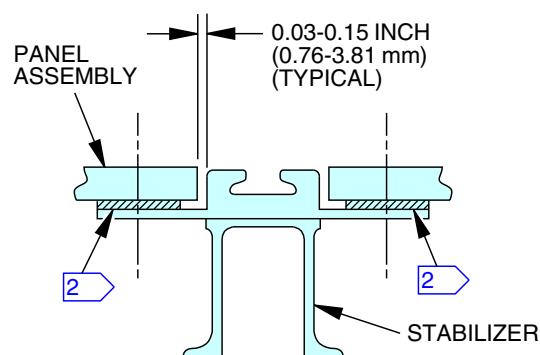
TYPICAL MISMATCH DIMENSION  
FOR FLOOR PANEL INSTALLATION



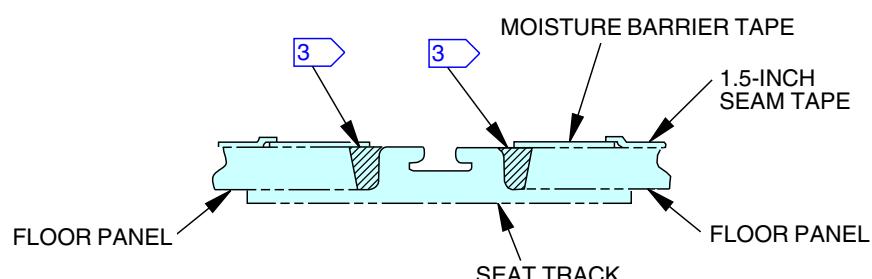
TYPICAL MISMATCH DIMENSION  
FOR FLOOR PANEL INSTALLATION



TYPICAL MISMATCH DIMENSION  
FOR FLOOR PANEL INSTALLATION



TYPICAL MISMATCH DIMENSION  
FOR FLOOR PANEL INSTALLATION



TYPICAL FLOOR PANEL  
SEALING AT SEAT TRACKS

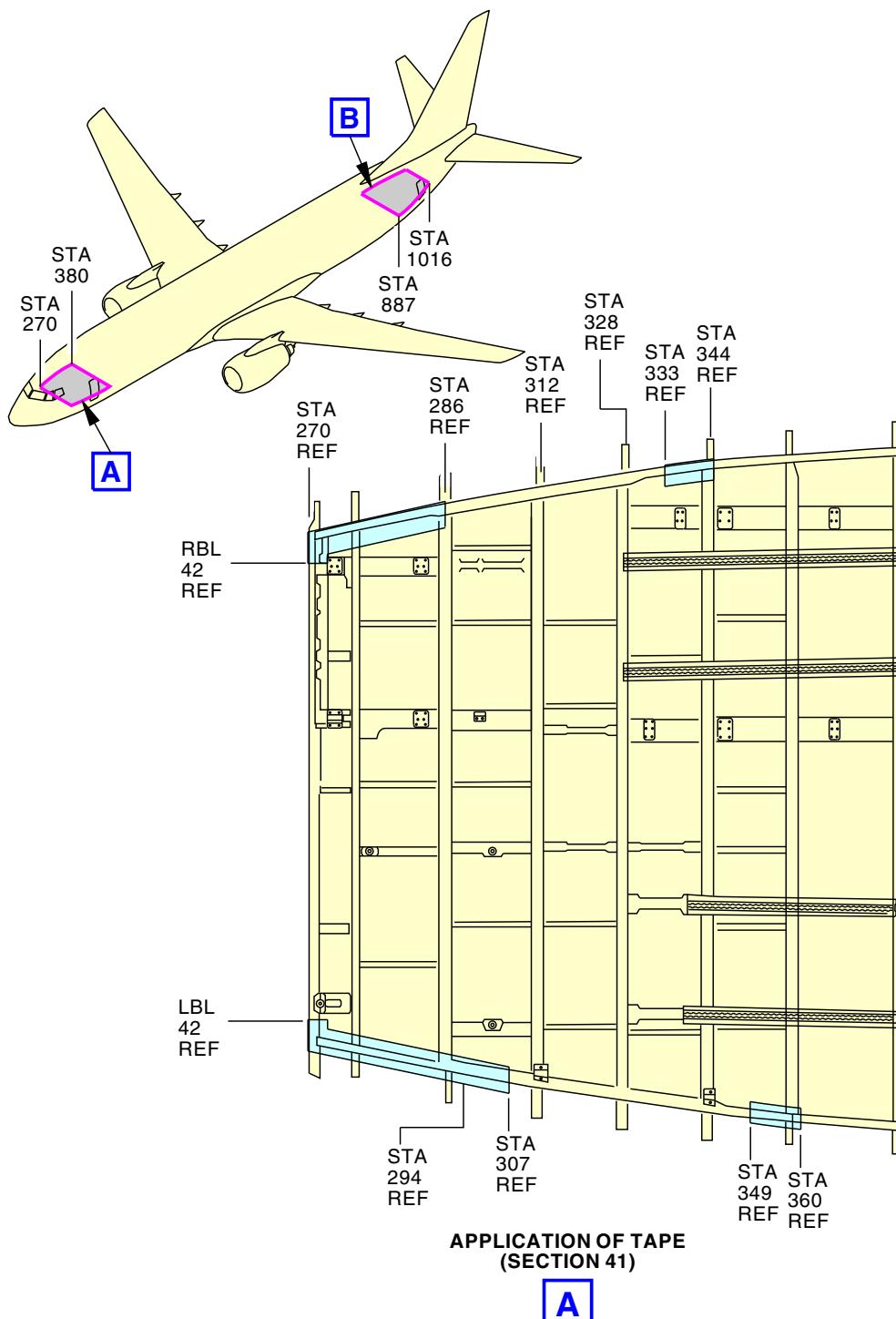
- [2] HI-TAK TAPE
- [3] SEALANT
- [4] ONE PIECE INSERT - -0.005/+0.030 INCH (-0.13/+0.76 mm)  
TWO PIECE INSERT - -0.030/+0.030 INCH (-0.76/+0.76 mm)

U63204 S0000210324\_V5

Floor Panel Installation and Sealing  
Figure 401/53-21-00-990-806 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

**53-21-00**



2568220 S0000613585\_V5

**Floor Panel Sealing**  
Figure 402/53-21-00-990-808 (Sheet 1 of 5)

EFFECTIVITY  
LOM ALL

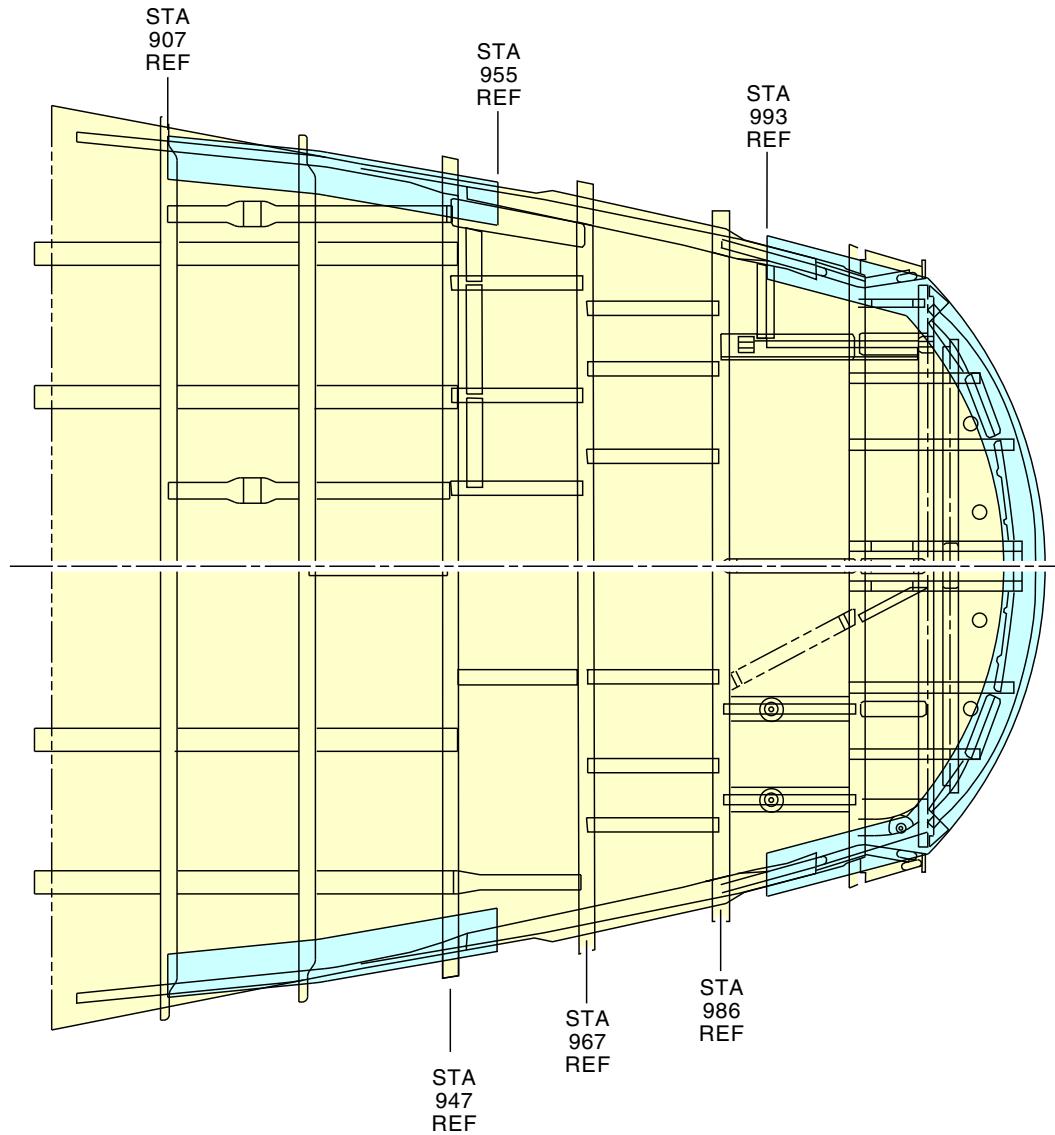
**53-21-00**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details



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AIRCRAFT MAINTENANCE MANUAL



APPLICATION OF TAPE  
(SECTION 47)

B

2568221 S0000613586\_V4

Floor Panel Sealing  
Figure 402/53-21-00-990-808 (Sheet 2 of 5)

EFFECTIVITY  
LOM ALL

**53-21-00**

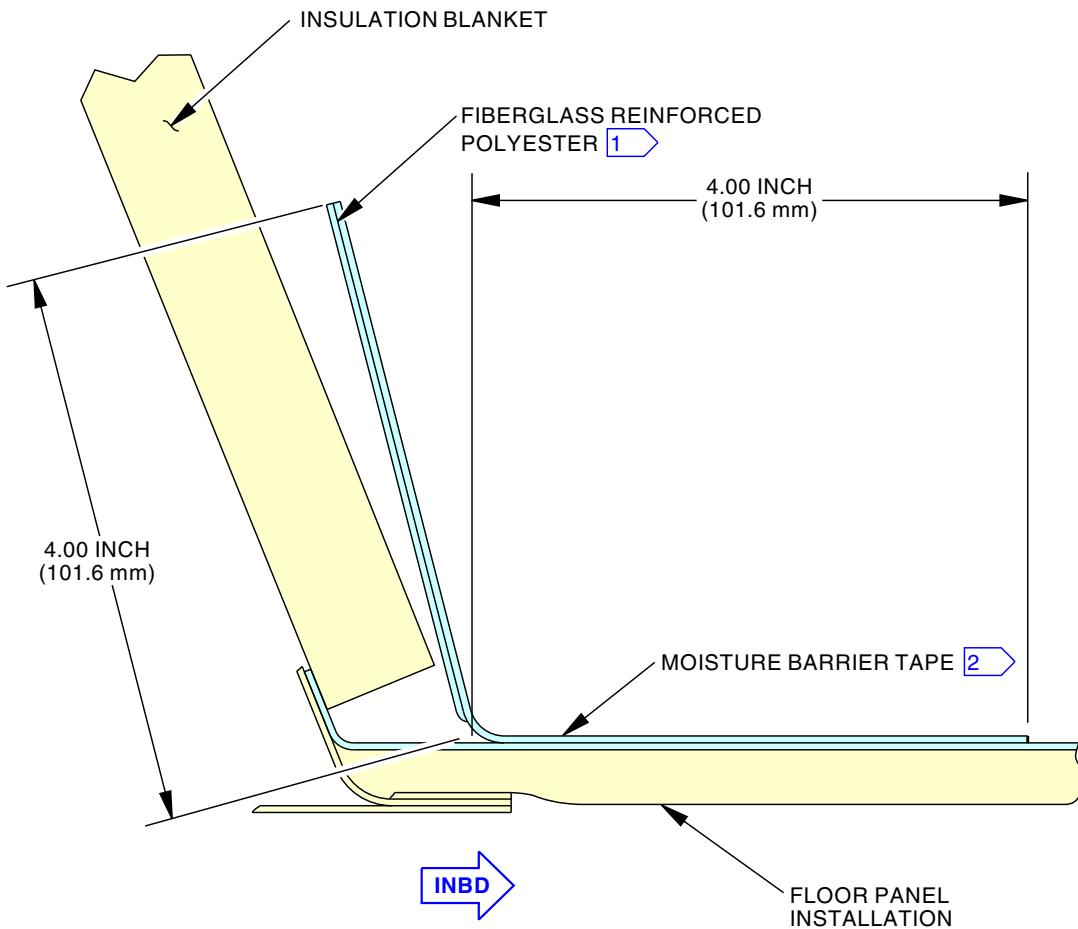
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 406  
Feb 15/2020



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



- [1] PER BMS 8-2 CLASS 1 GRADE A TYPE 13  
[2] PER BMS 8-346 CLASS 4 GRADE A TYPE II

2786064 S0000632176\_V2

Floor Panel Sealing  
Figure 402/53-21-00-990-808 (Sheet 3 of 5)

EFFECTIVITY  
LOM ALL

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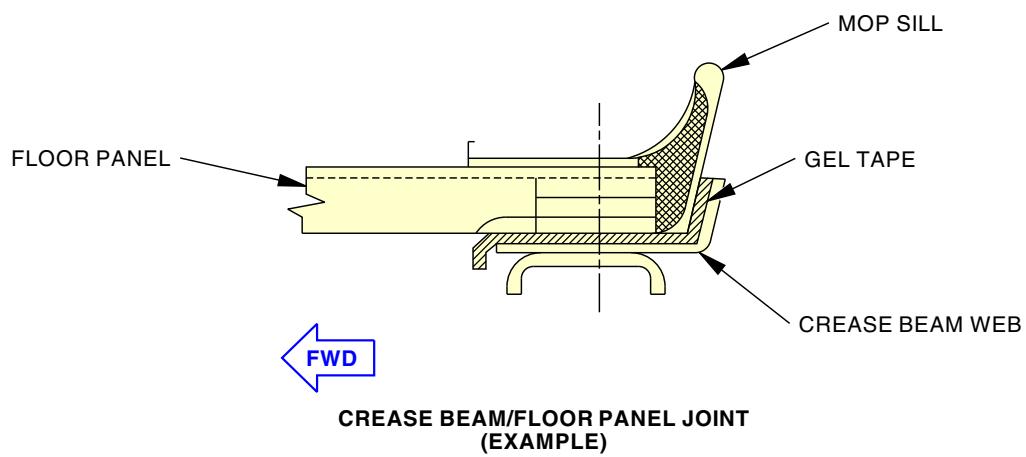
ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-21-00**

Page 407  
Feb 15/2020



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



2840497 S0000662851\_V3

Floor Panel Sealing  
Figure 402/53-21-00-990-808 (Sheet 4 of 5)

EFFECTIVITY  
LOM ALL

**53-21-00**

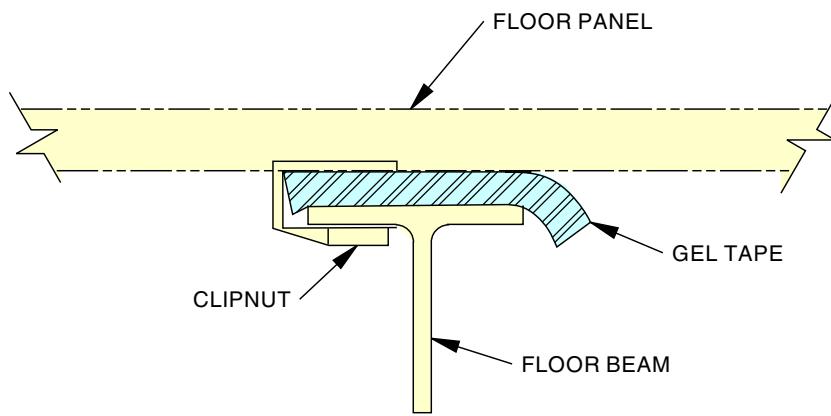
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 408  
Feb 15/2020



737-600/700/800/900  
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GEL TAPE INSTALLATION ON PASSENGER CABIN FLOOR PANEL SUPPORT  
STRUCTURE AND CREEASE BEAMS  
(EXAMPLE)

2909003 S0000697045\_V1

Floor Panel Sealing  
Figure 402/53-21-00-990-808 (Sheet 5 of 5)

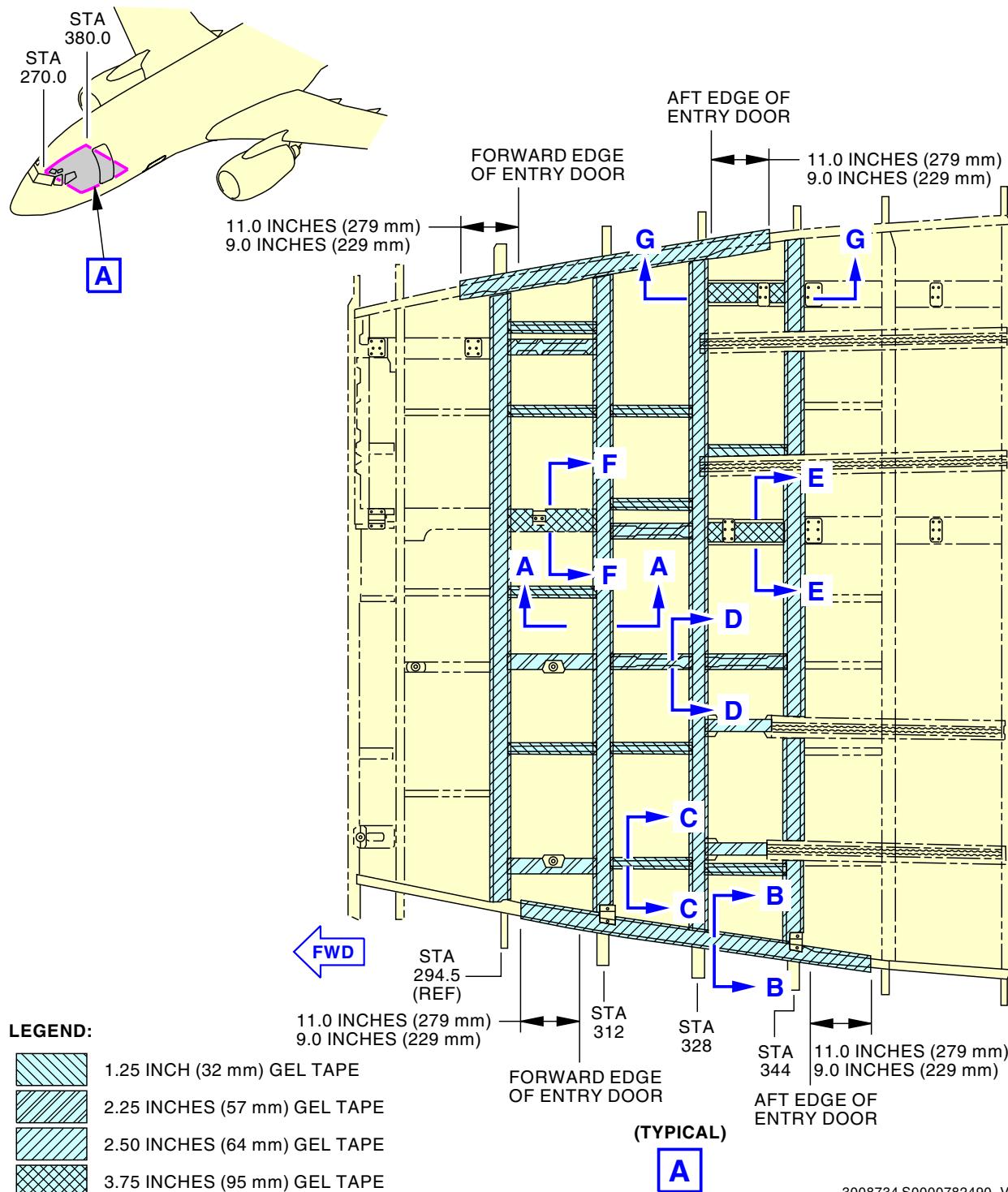
EFFECTIVITY  
LOM ALL

**53-21-00**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 409  
Feb 15/2020



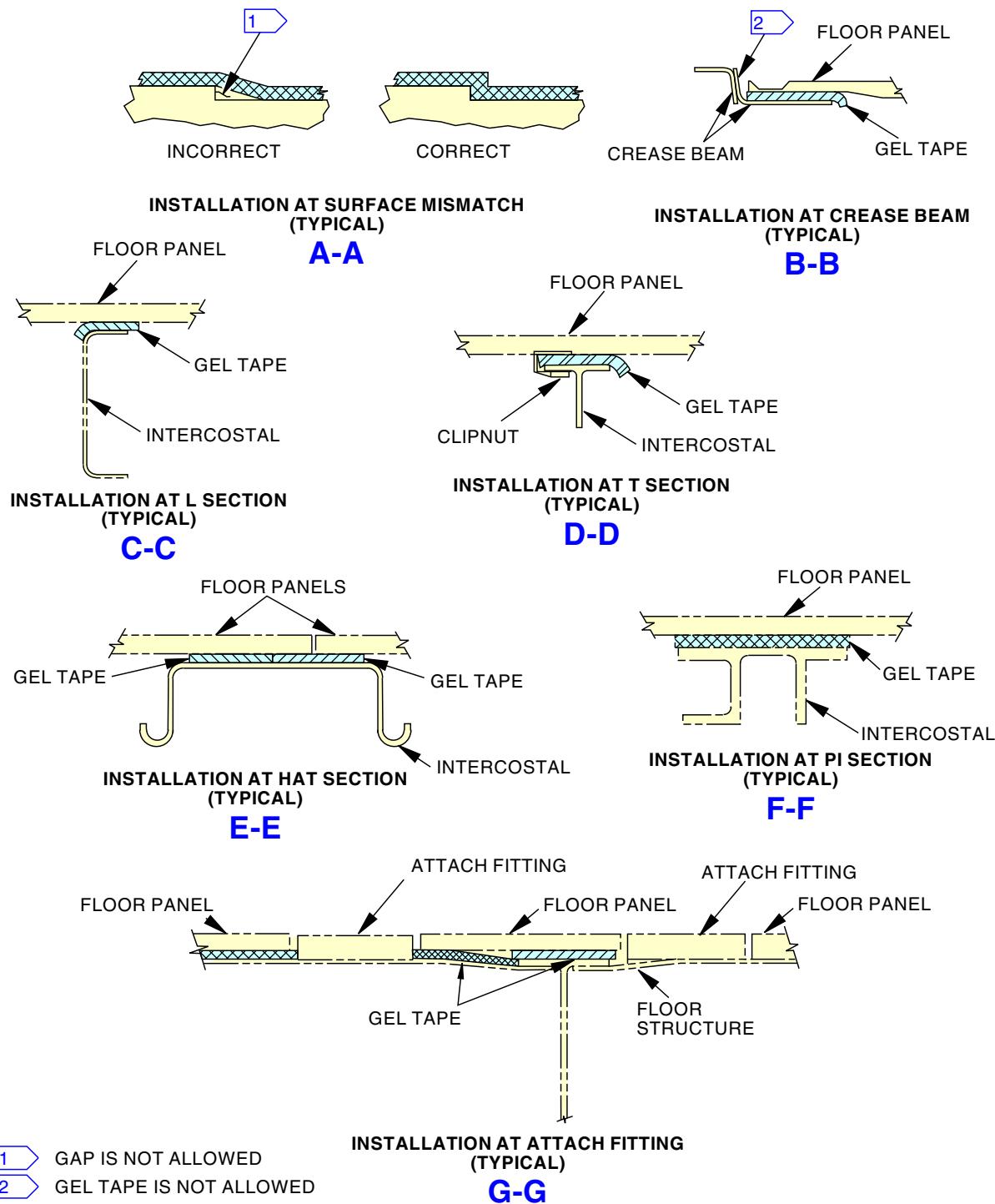
Gel Tape (Section 41) Installation  
Figure 403/53-21-00-990-813 (Sheet 1 of 2)

EFFECTIVITY  
LOM 402, 406, 416, 420, 422-434, 437-447, 450-999;  
LOM 404, 407, 411, 412, 415 POST SB 737-53-1285

**53-21-00**



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AIRCRAFT MAINTENANCE MANUAL



3008736 S0000782491\_V1

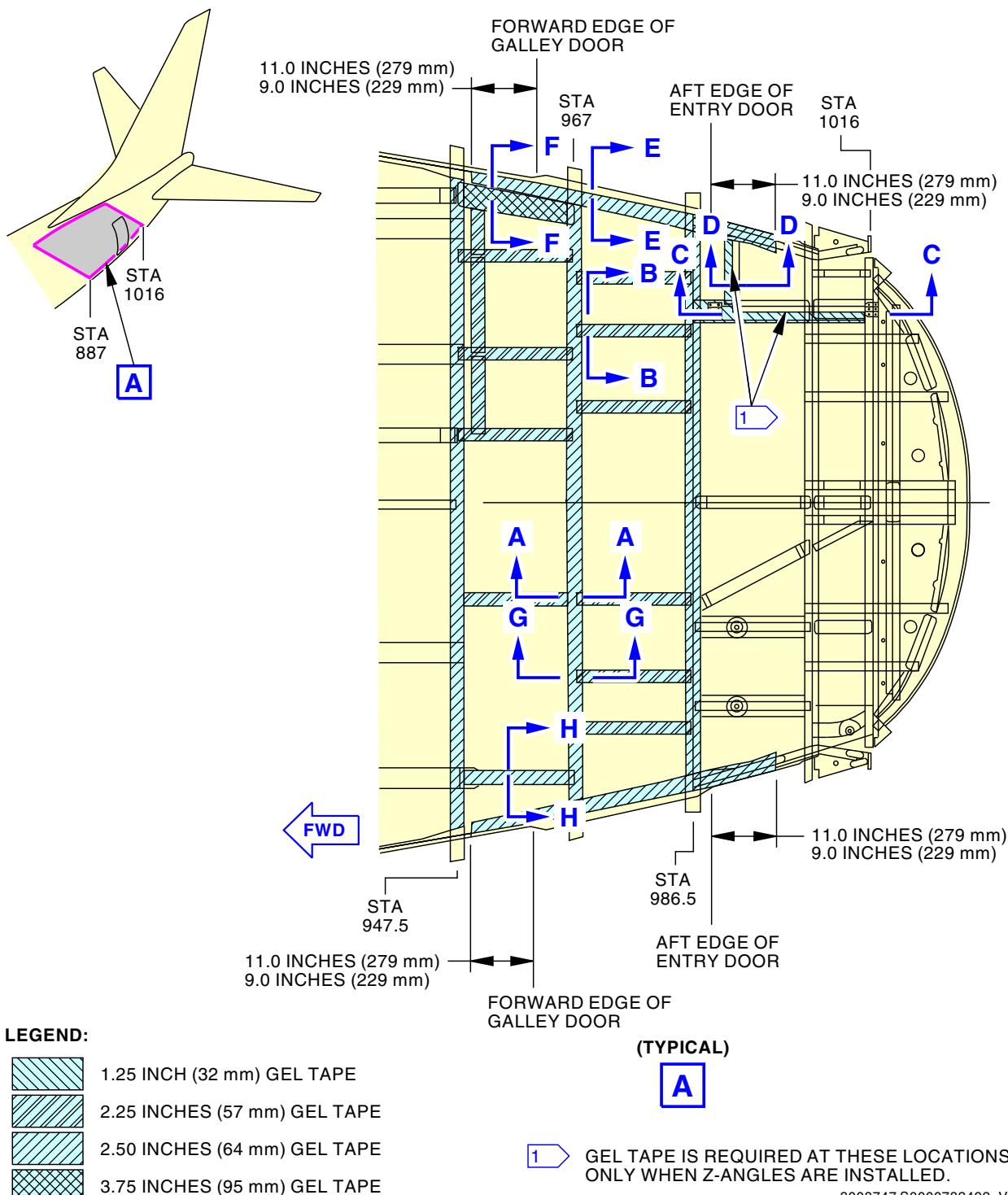
Gel Tape (Section 41) Installation  
Figure 403/53-21-00-990-813 (Sheet 2 of 2)

EFFECTIVITY  
LOM 402, 406, 416, 420, 422-434, 437-447, 450-999;  
LOM 404, 407, 411, 412, 415 POST SB 737-53-1285

**53-21-00**

Page 411  
Oct 15/2024

D633A101-LOM

**737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL**


**Gel Tape (Section 47) Installation**  
**Figure 404/53-21-00-990-814 (Sheet 1 of 3)**

EFFECTIVITY  
LOM 402, 406, 416, 420, 422-434, 437-447, 450-999;  
LOM 404, 407, 411, 412, 415 POST SB 737-53-1285

**53-21-00**

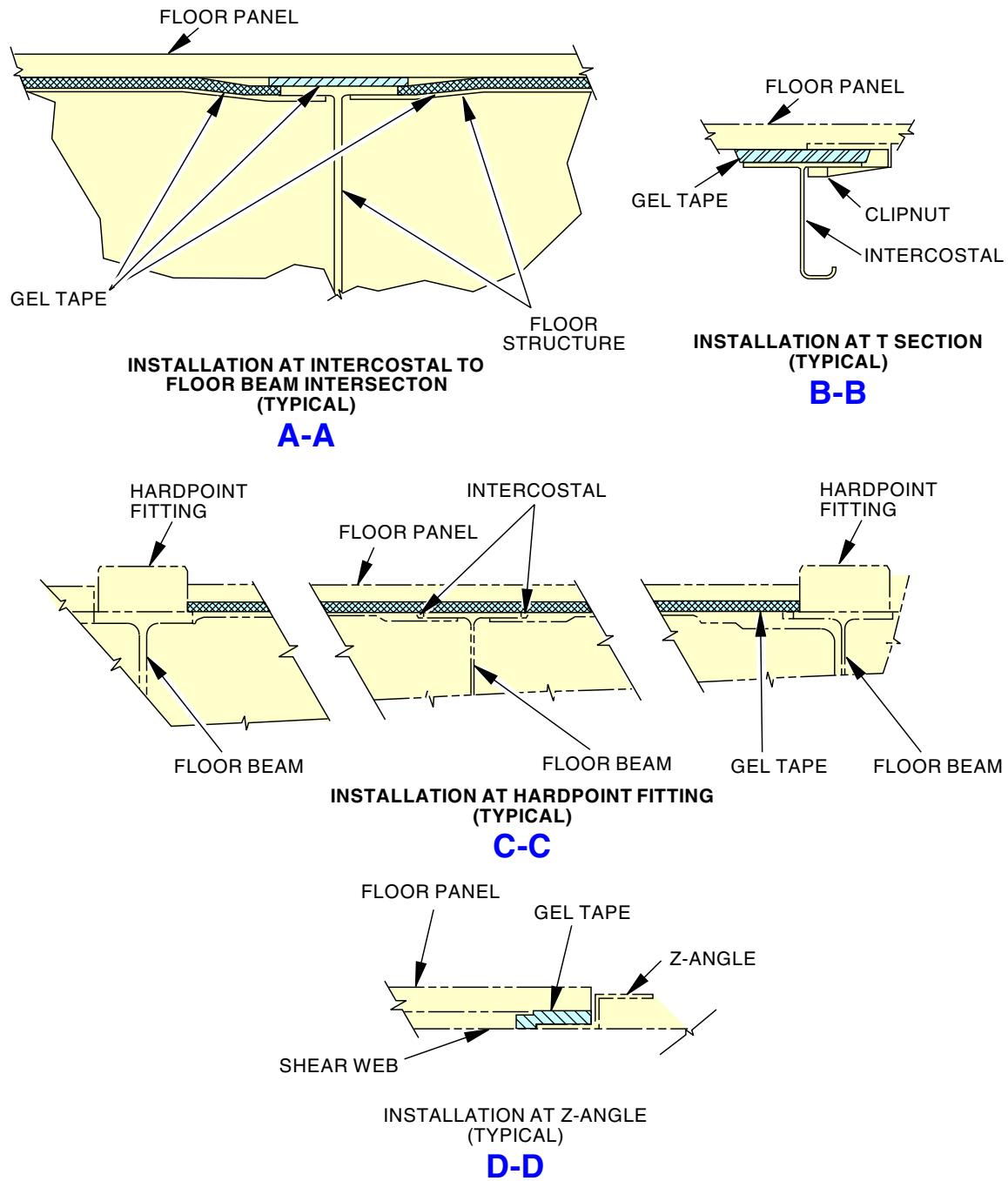
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 412  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3008750 S0000782493\_V1

Gel Tape (Section 47) Installation  
Figure 404/53-21-00-990-814 (Sheet 2 of 3)

EFFECTIVITY  
LOM 402, 406, 416, 420, 422-434, 437-447, 450-999;  
LOM 404, 407, 411, 412, 415 POST SB 737-53-1285

**53-21-00**

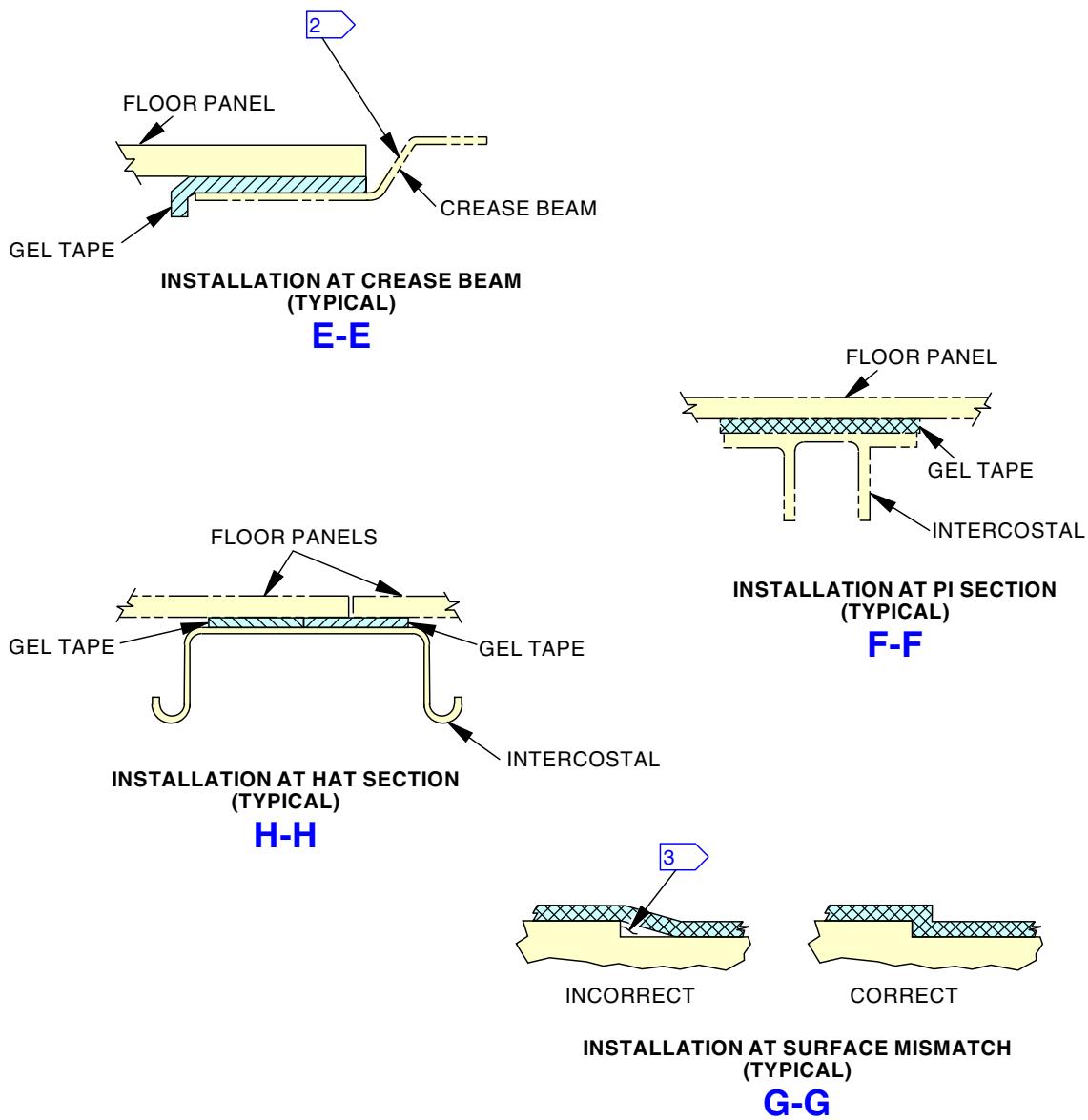
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 413  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



- [2] GEL TAPE INSTALLATION ON VERTICAL FLANGE OF CREASE BEAM IS NOT ALLOWED  
[3] GAP IS NOT ALLOWED

3008751 S0000782494\_V1

**Gel Tape (Section 47) Installation**  
Figure 404/53-21-00-990-814 (Sheet 3 of 3)

EFFECTIVITY  
LOM 402, 406, 416, 420, 422-434, 437-447, 450-999;  
LOM 404, 407, 411, 412, 415 POST SB 737-53-1285

**53-21-00**

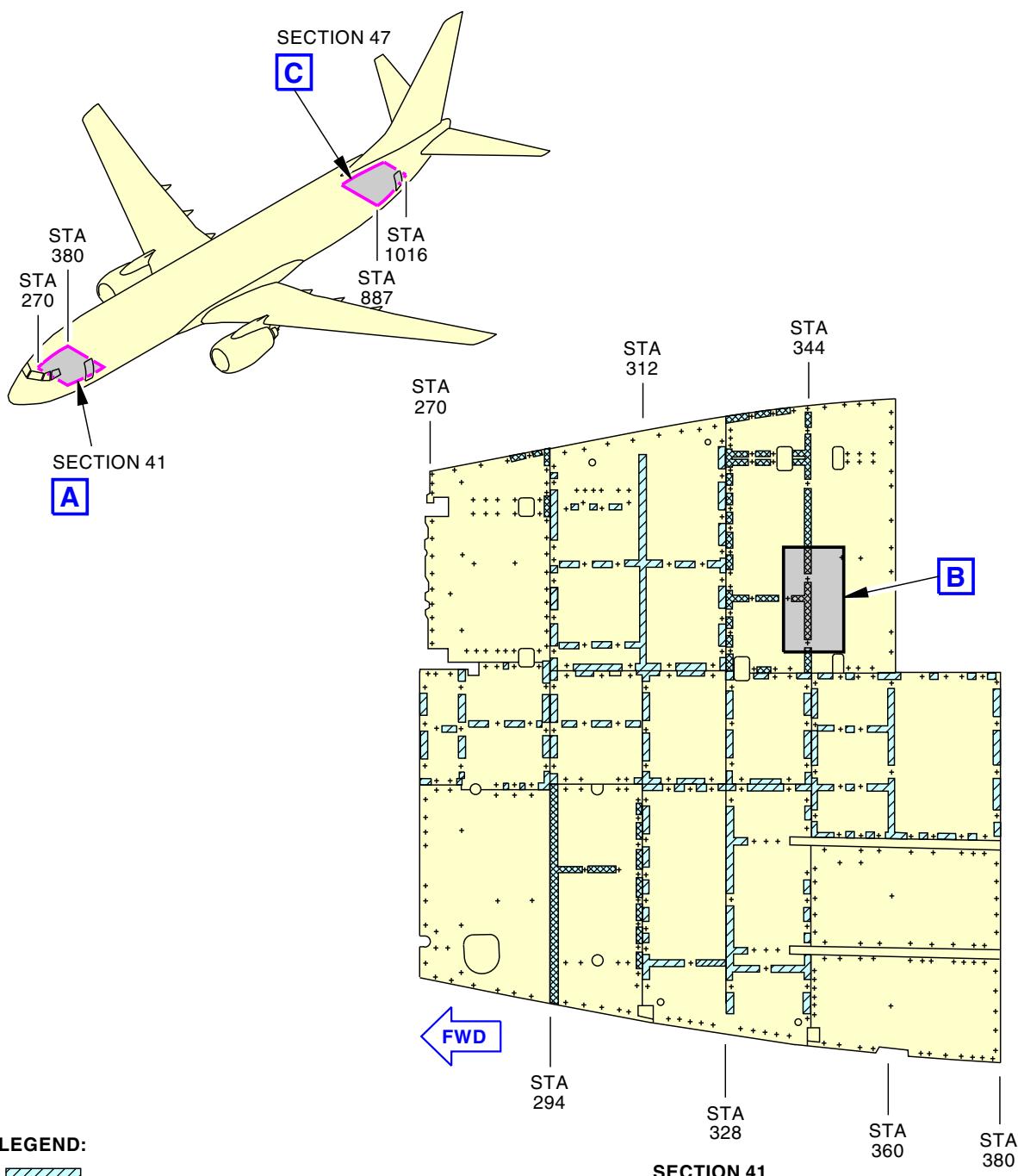
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 414  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



3008691 S0000782340\_V1

Skyflex Tape Installation  
Figure 405/53-21-00-990-812 (Sheet 1 of 4)

EFFECTIVITY  
LOM 402, 406, 416, 420, 422-434, 437-447, 450-999;  
LOM 404, 407, 411, 412, 415 POST SB 737-53-1285

**53-21-00**

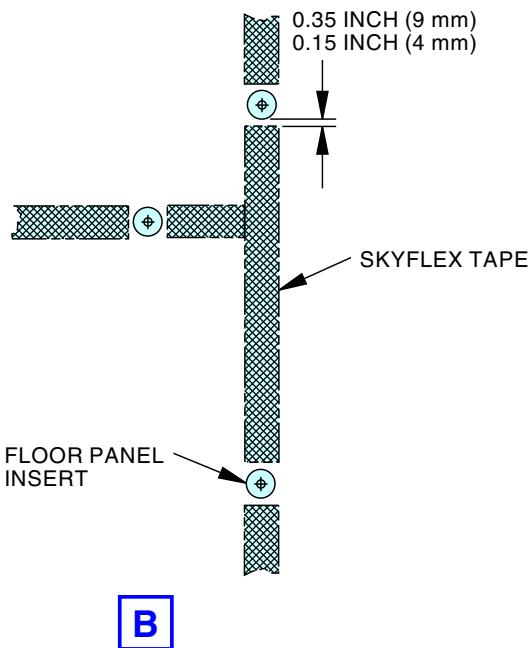
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 415  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



**LEGEND:**



SKYFLEX TAPE APPLIED BY THIS INSTALLATION

+ FLOOR PANEL INSERT LOCATION

3008692 S0000782341\_V1

**Skyflex Tape Installation**  
**Figure 405/53-21-00-990-812 (Sheet 2 of 4)**

EFFECTIVITY  
LOM 402, 406, 416, 420, 422-434, 437-447, 450-999;  
LOM 404, 407, 411, 412, 415 POST SB 737-53-1285

**53-21-00**

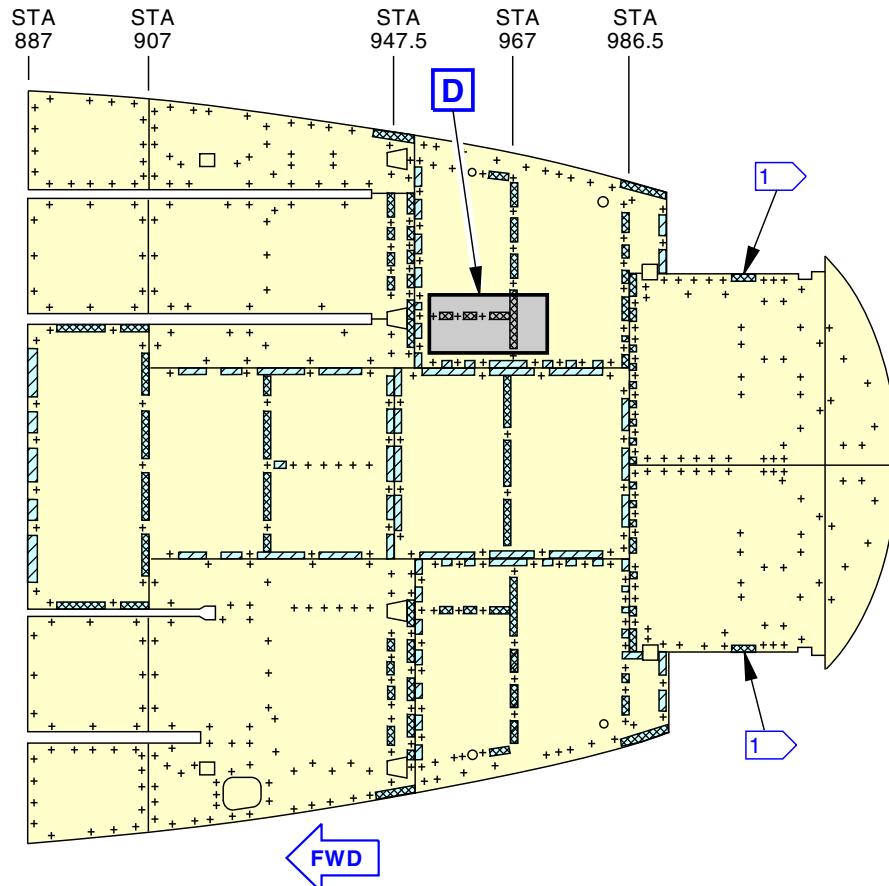
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 416  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



SECTION 47

C

1 GEL TAPE IS REQUIRED AT THESE LOCATIONS  
ONLY WHEN Z-ANGLES ARE INSTALLED.

LEGEND:



EXISTING SKYFLEX TAPE



SKYFLEX TAPE APPLIED BY THIS INSTALLATION

+ FLOOR PANEL INSERT LOCATION

3008716 S0000782342\_V1

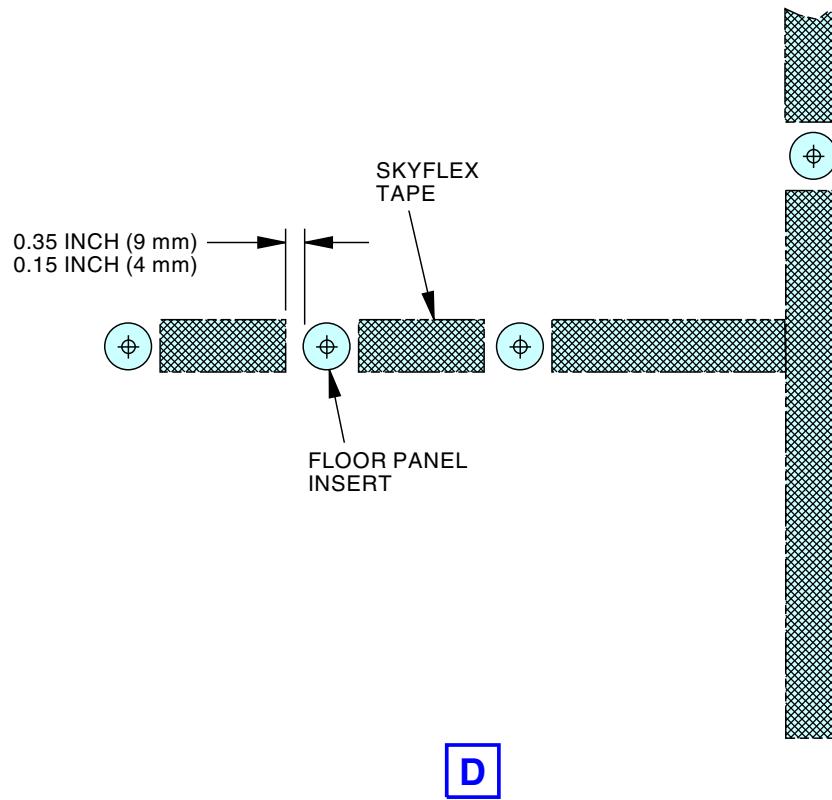
Skyflex Tape Installation  
Figure 405/53-21-00-990-812 (Sheet 3 of 4)

EFFECTIVITY  
LOM 402, 406, 416, 420, 422-434, 437-447, 450-999;  
LOM 404, 407, 411, 412, 415 POST SB 737-53-1285

53-21-00



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



**LEGEND:**



SKYFLEX TAPE APPLIED BY THIS INSTALLATION

+ FLOOR PANEL INSERT LOCATION

3008726 S0000782344\_V1

**Skyflex Tape Installation**  
**Figure 405/53-21-00-990-812 (Sheet 4 of 4)**

EFFECTIVITY  
LOM 402, 406, 416, 420, 422-434, 437-447, 450-999;  
LOM 404, 407, 411, 412, 415 POST SB 737-53-1285

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-21-00**

Page 418  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-21-00-400-801**

**3. Passenger Cabin Floor Panel - Installation**

(Figure 401 and Figure 402)

**A. General**

- (1) This task has one or more steps which are a means to satisfy Critical Design Configuration Control Limitation (CDCCL) requirements. A CDCCL note will follow the step to which it applies. Any step or sub-step that precedes or follows a CDCCL identified step is not subject to the CDCCL requirement.
- (a) For important information on CDCCL requirements, refer to this task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801.

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

**B. References**

Reference	Title
25-27-21-400-801	Entry and Service Area Floor Covering - Installation (P/B 401)
28-11-00-211-801	External Wires Over the Center Fuel Tank Inspection (P/B 601)
51-21-41-370-802	Bonderite M-CR 600 Aero, Bonderite M-CR Alcrm 1200 Aero or Bonderite M-CR 1200S Aero Application Process (P/B 701)
53-00-00-912-801	Airworthiness Limitation Precautions (P/B 201)
53-21-00-300-801	Repair the Polyurethane Waterseal (P/B 801)
SOPM 20-30-03	General Cleaning Procedures

**C. Tools/Equipment**

Reference	Description
STD-449	Gun - Sealant
STD-745	Roller - Hard Rubber
STD-810	Spatula - Fillet Smoothing, Hardwood or Plastic

**D. Consumable Materials**

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A00306	Resin - Urethane - Flexane-80	
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
B00666	Solvent - Methyl Propyl Ketone	BMS11-9
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
C00953	Primer - Devcon Flexane FL-20	
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23
G00270	Tape - Scotch Flatback Masking 250	ASTM D6123 (Supersedes A-A-883)
G02424	Tape - Skyflex Noise Reduction - GUA1057-1, GUA1059-1, GUA1057-144	

EFFECTIVITY  
LOM ALL

**53-21-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

(Continued)

Reference	Description	Specification
G50019	Tape - Flexible Foam Sound Damping And Sealing Tape	BMS8-283 Type I
G50029	Sleeving - Expandable, Braided (Polyester, Tight Weave)	BMS13-52 Type V
G50738	Tape - Flame Retardant Hi-Tak TufSeal, (Av-DEC - HI-TAK HT3000FR-XXX)	
G51339	Fabric, General Purpose, Rigid, Fire Retarded, Glass Fabric Reinforced Plastic Sheeting	BMS8-2 Type 13, Class 1, Grade A
G51340	Tape - Moisture Barrier, Adhesive One-side	BMS8-346 Type II Class 4
G51561	Tape - Vinyl Foam, 1 Inch (25.40 mm) Wide - 3M 4508	

**E. Location Zones**

Zone	Area
200	Upper Half of Fuselage

**F. Passenger Cabin Floor Panel Installation**

SUBTASK 53-21-00-210-001

- (1) If you removed the panels over the center fuel tank and do maintenance in the area above the center fuel tank, do these steps:

**► 28-AWL-02: CDCCL**

- (a) Make sure that you do not change the routing and clamping of the wires over the center fuel tank.

NOTE: CDCCL- Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important Information on Critical Design Configuration Control Limitations (CDCCLs).

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

**► 28-AWL-02: CDCCL**

- (b) Before you install the panels over the center tank, do this task only for the areas over the center tank where you removed the panels: External Wires Over the Center Fuel Tank Inspection, TASK 28-11-00-211-801.

NOTE: CDCCL- Refer to the task: Airworthiness Limitation Precautions, TASK 53-00-00-912-801, for important Information on Critical Design Configuration Control Limitations (CDCCLs).

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

SUBTASK 53-21-00-390-002

- (2) Prepare the fastener holes for the floor panel in the wet areas of the structure as follows:

NOTE: The wet area is between STA 270 and STA 380 and between STA 887 and STA 1016.

- (a) Clean and apply chemical conversion coating to the bare aluminum surface on the floor support structure (TASK 51-21-41-370-802).

- (b) Apply one layer of primer, C00259, to the floor support structure.

NOTE: After application, allow the primer, C00259, to dry off.

- (c) Apply compound, C00528 (Corrosion Preventive Compound), to the holes.

EFFECTIVITY  
LOM ALL

**53-21-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (d) If it is necessary, do the following for the top surfaces of the mop sill and crease beam that do not have tape:



**WARNING**

DO NOT GET THE CORROSION-INHIBITING COMPOUND ON YOUR SKIN, IN YOUR EYES, OR ON YOUR CLOTHES. THE COMPOUND IS POISONOUS AND FLAMMABLE. USE APPROVED GLOVES, AND EYE PROTECTION. MAKE SURE THAT THERE IS GOOD AIRFLOW IN THE WORK AREA. KEEP THE COMPOUND AWAY FROM SPARKS AND FLAMES. THE COMPOUND CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- 1) Apply corrosion inhibiting compound, G00009, to the top surfaces.

**LOM 404, 407, 411, 412, 415 PRE SB 737-53-1285**

SUBTASK 53-21-00-400-003

- (3) Apply Hi-Tak TufSeal Tape, G50738 (preferred), or GUA1057-1, GUA1059-1, GUA1057-144 tape, G02424 (alternate), on the floor support structure.
- (a) Splices between strips of Hi-Tak TufSeal Tape, G50738 (preferred), or GUA1057-1, GUA1059-1, GUA1057-144 tape, G02424 (alternate), must overlap by 1 in. (25 mm).

NOTE: A minimum of 20 psi (138 kPa) pressure is needed to make a waterproof joint on the tape splices.

**LOM 402, 406, 416, 420, 422-434, 437-447, 450-999; LOM 404, 407, 411, 412, 415 POST SB 737-53-1285**

SUBTASK 53-21-00-390-003

- (4) Before you install the floor panels in the wet area, examine the condition of Hi-Tak TufSeal Tape, G50738, on the floor structure and GUA1057-1, GUA1059-1, GUA1057-144 tape, G02424, on the floor panels (Figure 403, Figure 404, and Figure 405).
- (5) Do these steps to replace damaged tape:

NOTE: The wet area is between STA 270 and STA 380 and between STA 887 and STA 1016.

- (a) Remove the damaged tape from the panel or the floor support structure.



**CAUTION**

BE CAREFUL WHEN REMOVING ADHESIVES FROM PRIMARY STRUCTURE. HARSH SCRAPING OR USE OF IMPROPER TOOLS MAY CAUSE SCRIBE DAMAGE TO THE AIRCRAFT, WHICH CAN RESULT IN FATIGUE CRACKING. CONTACT ENGINEERING IF NICKS, SCRATCHES, OR SCRIBE MARKS ARE EVIDENT ON PRIMARY STRUCTURE.

- (b) Clean scuff plates, floor panels, and floor panel support structure with an approved plastic scraper and solvent, B00184, or solvent, B00666 (SOPM 20-30-03).



**WARNING**

DO NOT GET THE CORROSION-INHIBITING COMPOUND ON YOUR SKIN, IN YOUR EYES, OR ON YOUR CLOTHES. THE COMPOUND IS POISONOUS AND FLAMMABLE. USE APPROVED GLOVES, AND EYE PROTECTION. MAKE SURE THAT THERE IS GOOD AIRFLOW IN THE WORK AREA. KEEP THE COMPOUND AWAY FROM SPARKS AND FLAMES. THE COMPOUND CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (c) Apply corrosion inhibiting compound, G00009, to the floor panel support structure.

EFFECTIVITY  
LOM ALL

**53-21-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**LOM 402, 406, 416, 420, 422-434, 437-447, 450-999; LOM 404, 407, 411, 412, 415 POST SB 737-53-1285**  
**(Continued)**

- (d) Apply Hi-Tak TufSeal Tape, G50738, on the floor support structure and crease beams (Figure 403 and Figure 404).
  - 1) Make sure that there are no protective backing on the panel side of the Hi-Tak TufSeal Tape, G50738, before installation.  
NOTE: Use Hi-Tak TufSeal Tape, G50738, widths that will give 1/16 in. (1.6 mm) - 1/8 in. (3.2 mm) of excess on each side of the mop sills and crease beams. Excesses more than 1/8 in. (3.2 mm) are permitted.
  - 2) Make sure that the air bubbles are smaller than 0.38 in. (9.65 mm).
  - 3) Make sure that the Hi-Tak TufSeal Tape, G50738, overlaps structure by 0.063 in. (2 mm) - 0.125 in. (3 mm).
- (e) Apply GUA1057-1, GUA1059-1, GUA1057-144 tape, G02424, to the floor panels (Figure 405).

**LOM ALL**

SUBTASK 53-21-00-400-002

- (6) Before you install floor panels in the dry area, examine tape, G50019, or 3M 4508 tape, G51561.  
NOTE: The dry area is between section 41 and section 47, and more than 20 in. (51 cm) from a galley, lavatory or entry/service door.  
NOTE: For the three section 44 aisle panels (STA 537 to STA 727B) 3M 4508 tape, G51561, may be used instead of tape, G50019.
- (a) If it is necessary, remove the damaged tape from the panel or the floor support structure.



**BE CAREFUL WHEN YOU REMOVE ADHESIVE FROM THE FLOOR PANEL SURFACES. DAMAGE TO THE FLOOR PANEL CAN OCCUR.**

- (b) Clean the floor panels with an approved plastic scraper and solvent, B00184, or solvent, B00666.
- (c) Apply tape, G50019, or 3M 4508 tape, G51561, on the floor panel.  
NOTE: Additional layers of tape, G50019, or 3M 4508 tape, G51561, can be applied under low panels, to meet panel mismatch tolerances. The total thickness of compressed tape, G50019, must be 0.07 in. (1.78 mm) or less.  
NOTE: Do not apply other tapes over 3M 4508 tape, G51561.
- (d) Use a hard rubber roller, STD-745, or hand to apply pressure on the 3M 4508 tape, G51561, to make sure that the 3M 4508 tape, G51561, is firmly installed.

SUBTASK 53-21-00-420-007

- (7) If the clipnuts were removed, install the new clipnuts as follows:
  - (a) Apply compound, C00528, to the floor support structure at the clipnut locations.
  - (b) Install new composite torlon clipnuts everywhere on the floor structure at the floor panel attachment locations (preferred BACN11AL, optional BACN10YDG) to improve corrosion resistance.  
NOTE: Be careful when you install the clipnuts to prevent scratches on the floor support structure.

EFFECTIVITY  
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**53-21-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (c) Install clipnuts over gel tapes to provide better corrosion resistance (Figure 402).
- (d) Turn the clipnuts clockwise against the floor support structure.

SUBTASK 53-21-00-350-001

- (8) If a replacement floor panel is to be installed:
  - (a) Make sure that the new floor panel has the same contour and dimensions as the removed floor panel.

SUBTASK 53-21-00-420-004

- (9) Align the floor panel with the holes in the floor support structure.

SUBTASK 53-21-00-420-002

- (10) Install the screws with wet compound, C00528, until they are smooth with the floor panel.

NOTE: Do not tighten the screws.

SUBTASK 53-21-00-820-001

- (11) Do these steps to tighten the floor panel screws:

NOTE: Do a check of the torque before you install the floor covering.

- (a) Torque the screws on the panels with the one-piece insert to  $32.5 \pm 2.5$  in-lb ( $3.7 \pm 0.3$  N·m).
  - 1) The panel can dish at the fastener by a maximum of 0.005 in. (0.127 mm) below the panel top surface.
- (b) Torque the screws on the panels with the two-piece insert to  $22.5 \pm 2.5$  in-lb ( $2.5 \pm 0.3$  N·m).
  - 1) The panel can dish at the fastener by a maximum of 0.030 in. (0.762 mm) below the panel top surface.

SUBTASK 53-21-00-220-001

- (12) Examine the floor panel clearances.

SUBTASK 53-21-00-390-005

- (13) Apply one layer of Scotch Flatback Masking Tape 250, G00270, to the edge of the joints that are adjacent to and along the full length of the clearance at the edges of the panels.

SUBTASK 53-21-00-420-003

- (14) Apply sealant, A00247, or sealant, A02315 (preferred), as follows:

- (a) Apply sealant, A00247, or sealant, A02315, in the clearance between the floor panel and the crease beam in the wet area that follows:
  - 1) From STA 344 to STA 380.
- (b) Apply sealant, A00247, or sealant, A02315, to the remaining wet areas and the dry areas that follow to prevent corrosion:
  - 1) The remaining openings between the floor panels
  - 2) The seat tracks
  - 3) The bulkheads
  - 4) The mounting hard points
  - 5) The door drain gutter
  - 6) The mop sill.

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LOM ALL

**53-21-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-21-00-390-006



**CAUTION**

DO NOT CAUSE A BLOCKAGE WHEN YOU APPLY SEALANT NEAR OR AROUND THE FUSELAGE DRAIN HOLES, TUBES, OR PATHS. THE FUNCTION OF THE DRAIN HOLES IS TO DRAIN CONDENSATION AND FLUIDS OVERBOARD. IF YOU CAUSE A BLOCKAGE, FLUIDS WILL COLLECT IN THE AIRPLANE. THE FLUIDS CAN CAUSE DAMAGE TO THE STRUCTURE OR A FIRE IF THE FLUIDS ARE FLAMMABLE.

- (15) If you apply Flexane-80 resin, A00306, do these steps:
- Install sleeve, G50029, around the edges of the panel.
  - Apply Devcon Flexane FL-20 primer, C00953.
  - Apply Flexane-80 resin, A00306 (alternate), with a sealant gun, STD-449, or hardwood or plastic fillet smoothing spatula, STD-810.
  - Make sure that there are no air bubbles when you apply the sealant.
  - Use a hardwood or plastic fillet smoothing spatula, STD-810, to make the seal smooth with Scotch Flatback Masking Tape 250, G00270.

SUBTASK 53-21-00-390-007

- (16) Make the edges of the seal smooth.
- Remove all of the unwanted compound with hardwood or plastic fillet smoothing spatula, STD-810.
  - Remove Scotch Flatback Masking Tape 250, G00270, after the seal is smooth or let Scotch Flatback Masking Tape 250, G00270, stay during the curing time.
  - Install the moisture barrier if it is applicable, do this task: Repair the Polyurethane Waterseal, TASK 53-21-00-300-801.

SUBTASK 53-21-00-400-004

- (17) If the entry and service area floor covering was removed, do this task: Entry and Service Area Floor Covering - Installation, TASK 25-27-21-400-801.

SUBTASK 53-21-00-390-013

- (18) Apply moisture barrier tape, G51340, and fabric, G51339, to the moisture barrier tape, G51340, covered floor panels (Figure 402).

NOTE: You can use other widths of moisture barrier tape, G51340, but you must get a minimum total tape width of 36 in. (91 cm). If necessary, to get this width, use a tape overlap of  $4 \pm 1$  in. (102  $\pm$ 25 mm) at all the tape joints.

- Make sure that you remove the protective backing on the panel side of the moisture barrier tape, G51340, before installation.
- Make sure that you trim the moisture barrier tape, G51340, as required to fit around the gutter, seat tracks, galley chiller cutouts, and monument fittings.

NOTE: Slit, notch, or cut moisture barrier tape, G51340, as required to fit airframe structure contours.

- Make sure that the moisture barrier tape, G51340, does not adhere to insulation blankets.
- Make sure that you trim the fiberglass reinforced polyester to fit around monument plumbing lines and fittings.

NOTE: Crease, fold, bend, or score fiberglass reinforced polyester to fit airframe structure contours.

— END OF TASK —

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**53-21-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

POLYURETHANE WATERSEAL - REPAIRS

**1. General**

- A. This procedure contains the task to repair polyurethane waterseal on passenger floors in wet areas of the aircraft, which are defined as that part of the floor that is local to doorways, galleys and lavatories.
- B. The waterseal installation is intended to reduce corrosion of floor structure by preventing liquids spilled in wet areas from traveling below floor level.

**TASK 53-21-00-300-801**

**2. Repair the Polyurethane Waterseal**

Figure 801

**A. Consumable Materials**

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
G02423	Tape - Moisture Barrier - 3 Feet Wide - 3M 8663	
G02500	Tape - Moisture Barrier - 4 inch Wide - 3M 8663DL	
G50179	Tape - Moisture Barrier, Adhesive One-side, Clear Polyurethane	BMS8-346 Type I
G51340	Tape - Moisture Barrier, Adhesive One-side	BMS8-346 Type II Class 4

**B. Location Zones**

Zone	Area
200	Upper Half of Fuselage

**C. Procedure**

SUBTASK 53-21-00-420-001

- (1) If the tape shows deterioration or damage because of the floor panel removal, install the new polyurethane tape.

SUBTASK 53-21-00-420-005

- (2) Do these steps to install the moisture barrier:

- (a) Make sure the floor panels and the seat tracks are clean according to BAC5750 before you install the moisture barrier.
  - (b) Install the polyurethane moisture barrier in the wet areas of the floor structure as follows:

NOTE: The moisture barrier must be, as much as possible, one continuous piece. Do not try to fit the moisture barrier below lavatories or galleys where removal of these fixtures is necessary.

The maximum permitted overlap between two pieces of the moisture barrier is 4 in. (102 mm).

- 1) Center the moisture barrier tape, G50179 on floor panel joint to cover sealant and fasteners/inserts.

NOTE: The moisture barrier tape, G50179 is applied only to joints between two floor panels and not to other structure including seat track, gutters, lavatory and galley mounts, crease beams and partition walls.

EFFECTIVITY  
LOM ALL

**53-21-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- a) Apply the tape against the floor while removing the backing.
- b) If air bubbles trapped under the tape, re-apply by pulling the tape back off the floor panel and re-smooth it down.
- c) Make sure the tape overlap by a minimum of 0.5 in. (12.7 mm) where you have a splice.
- d) Cut the tape approximately 1.5 in. (38.1 mm) from the edge of seat tracks, entryway gutters, and lavatory/gallery mounts.
- 2) Position a section of 3M 8663 tape, G02423 or moisture barrier tape, G51340 (optional) with backing still in place, on the entire wet area laying the tape in forward/aft direction.
  - a) Mark the tape approximately 1.5 in. (38.1 mm) from the edge of seat tracks, entryway gutters, and lavatory/gallery mounts.



**DO NOT CUT THE WATER SEAL TAPE AGAINST THE FLOOR PANEL, OR OTHER STRUCTURE. DAMAGE TO THE STRUCTURE, OR FINISHES ON THE STRUCTURE WILL OCCUR.**

- b) Trim the tape at marked locations.
- c) Remove the backing from the adhesive side and put the tape on the floor. Cover any flush lavatory/galley mounts or girt bar attach fittings.

NOTE: Be careful not to stretch the tape while smoothing it down.
- d) If air bubbles trapped under the tape, re-apply by pulling the tape back off the floor panel and re-smoothing it down.
- e) Remove the backing from the non adhesive side of the tape.
- 3) Install the adjacent sections of 3M 8663 tape, G02423 or moisture barrier tape, G51340 (optional), overlap onto the existing water seal tape by 1 in. (25 mm) to 3 in. (76 mm).

NOTE: An overlap of 2 in. (51 mm) will cause the edge of the waterseal tape splice and the edge of the seam tape to align. This may show through the galley/entryway mat.
- 4) If a section of 3M 8663 tape, G02423 or moisture barrier tape, G51340 (optional) must be spliced longitudinally for some reason, do these steps:
  - a) Put down the first section of tape.
  - b) Apply a bead of sealant, A00247 per BAC5000 to the edge of the waterseal tape that will be covered by the second section. This fillet will prevent water from being able to travel under the tape through the small gap left at the edge of the underlying section of waterseal tape.
  - c) Apply the second section of 3M 8663 tape, G02423 or moisture barrier tape, G51340 (optional), overlap the first by 1 in. (25 mm) to 3 in. (76 mm).

NOTE: Too many splices or splices located in the wrong place may cause excessive tape build up that will show through floor coverings
- 5) Apply 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) to all of the 3M 8663 tape, G02423 or moisture barrier tape, G51340 (optional) splices. The tape must be centered on the overlapping edge of the waterseal tape and shall be continuous, not spliced at any point.

EFFECTIVITY  
LOM ALL

**53-21-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (3) Do these steps to seal the seat tracks (open track, no filler):
- (a) Apply fillet sealant, A00247 to all waterseal edges where it cut back from the seat track.
  - (b) Put a strip of 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) down on each side of the seat track with one edge overlapped onto the existing waterseal and one edge on the sealant between the seat track and floor panel.
    - 1) Extend the tape a minimum of 2 in. (51 mm) past the end of the seat track cutout.
    - 2) Push the tape down firmly to smooth out the sealant bead.
    - 3) Make sure the seam tape strips is continuous with no splices.
    - 4) Apply fillet sealant, A00247 to the edge of the previous applied seam tape.
  - (c) Put a small strip of 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) at the end of the seat track with one edge overlapped onto the existing waterseal and one edge on the sealant between the seat track and floor panel.
    - 1) Extend the seam tape to overlap onto previous applied seam tape a minimum of 1 in. (25 mm).
    - 2) Push the tape down firmly to smooth out the sealant bead.
- (4) Do these steps to seal seat tracks with no filler (open track): (Alternative methods)
- (a) Method 1
    - 1) Cut a patch of 3M 8663 tape, G02423 or 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) to fit over the seat track and overlap onto the existing waterseal tape a minimum of 1 in. (25 mm).
    - 2) The edge of the patch at the end of the seat track must extend a minimum of 2 in. (51 mm) past the end of the seat track cutout.
    - 3) Apply fillet sealant, A00247 to all waterseal edges where it has been cut back from the seat track.
    - 4) Remove the backing from the adhesive side of the tape and push the tape down firmly to smooth out the sealant bead.
    - 5) Remove the backing from the nonadhesive side of the tape.
  - (b) Method 2
    - 1) Install the 3M 8663 tape, G02423 or moisture barrier tape, G51340 (optional) to the floor panel except the seat track.
    - 2) Apply a bead of sealant, A00247 to the edge of the waterseal around the perimeter of the seat track.
  - (c) Method 3
    - 1) Put a strip of 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) down each side of the seat track with one edge along the edge of the seat track crown.
      - a) The edge of the patch at the end of the seat track must extend a minimum of 2 in. (51 mm) past the end of the seat track cutout.
      - b) Make sure the seam tape strips is continuous with no splices.
      - c) Apply a bead of sealant, A00247 to the perimeter of the seam tape except the edge next to the seat track.
    - 2) Install the 3M 8663 tape, G02423 or moisture barrier tape, G51340 (optional), overlap the seam tape.

EFFECTIVITY  
LOM ALL

**53-21-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- a) Push the tape down firmly to smooth out the sealant bead.
- (5) Do these steps to seal seat tracks with filler:
  - (a) Apply fillet sealant, A00247 to all waterseal edges where it has been cut back from the seat track.
  - (b) Put a strip of 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) down on each side of the seat track with one edge overlapped onto the existing waterseal and one edge on the sealant between the seat track and floor panel.
    - 1) Extend the tape a minimum of 2 in. (51 mm) past the end of the seat track cutout.
    - 2) Push the tape down firmly to smooth out the sealant bead.
    - 3) Make sure the seam tape strips is continuous with no splices.
  - (c) Center a strip of 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) over the seat track and filler, overlap the previous applied seam tape.
    - 1) Extend the tape a minimum of 2 in. (51 mm) past the end of the seat track cutout.
    - 2) Make sure the seam tape strips is continuous with no splices.
- (6) Do these steps to seal seat tracks with filler: (Alternative methods)
  - (a) Method 1
    - 1) Cut a patch of 3M 8663 tape, G02423 or 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) to fit over the seat track and overlap onto the existing waterseal tape a minimum of 1 in. (25 mm).
    - 2) The edge of the patch at the end of the seat track must extend a minimum of 2 in. (51 mm) past the end of the seat track cutout.
    - 3) Apply fillet sealant, A00247 to all waterseal edges where it has been cut back from the seat track.
    - 4) Remove the backing from the adhesive side of the tape and push the tape down firmly to smooth out the sealant bead.
    - 5) Remove the backing from the nonadhesive side of the tape.
  - (b) Method 2
    - 1) Install the 3M 8663 tape, G02423 or moisture barrier tape, G51340 (optional) directly over the seat track without trimming it back around the perimeter.
    - 2) Apply a bead of sealant, A00247 to the edge of the waterseal around the perimeter of the seat track.
- (c) Method 3
  - 1) Put a strip of 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) down each side of the seat track with one edge along the edge of the seat track crown.
    - a) The edge of the patch at the end of the seat track must extend a minimum of 2 in. (51 mm) past the end of the seat track cutout.
    - b) Make sure the seam tape strips is continuous with no splices.
    - c) Apply a bead of sealant, A00247 to the perimeter of the seam tape except the edge next to the seat track.
  - 2) Install the 3M 8663 tape, G02423 or moisture barrier tape, G51340 (optional), overlap the seam tape.

EFFECTIVITY  
LOM ALL

**53-21-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- a) Push the tape down firmly to smooth out the sealant bead.
  - b) Trim the waterseal tape to the edge of the seat track crown.
  - 3) Center a strip of 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) on the seat track and filler, overlap the previous applied waterseal tape.
    - a) Extend the tape a minimum of 2 in. (51 mm) past the end of the seat track cutout.
    - b) Make sure the seam tape strips is continuous with no splices.
- (7) Do these steps to seal lavatory and galley mounts:
- (a) Cut a patch of 3M 8663 tape, G02423 or 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) to either cover flush mounts or to extend into the radius of protruding mounts.
  - (b) Extend the tape to overlap onto the existing waterseal tape a minimum of 1 in. (25 mm).
  - (c) Apply fillet sealant, A00247 to all tape edges where it cut back from the edges of the mounts.
  - (d) Apply fillet sealant, A00247 to the edges of any protruding mounts.
  - (e) Remove the backing from the adhesive side of the tape and push the tape down firmly to smooth out the sealant bead.
  - (f) Remove the backing from the non-adhesive side of the tape.
- (8) Do these steps to seal lavatory and galley mounts: (Alternative methods)
- (a) Method 1
    - 1) Apply fillet sealant, A00247 to the edges of any protruding mounts.
    - 2) Apply the 3M 8663 tape, G02423 or moisture barrier tape, G51340 (optional) to either cover flush mounts or to the radius of protruding mounts.
    - 3) Remove the backing from the non-adhesive side of the tape.
    - 4) Cut a patch of 3M 8663 tape, G02423 or 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) to either cover flush mounts or to extend into the radius of protruding mounts.
    - 5) Extend the tape a minimum of 1 in. (25 mm) beyond the edge of the mount.
    - 6) Remove the backing from the non-adhesive side of the tape.
    - 7) Apply fillet sealant, A00247 to the edges of any protruding mounts.
  - (b) Method 2
    - 1) Cut a patch of 3M 8663 tape, G02423 or 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) to either cover flush mounts or to extend into the radius of protruding mounts.
      - a) Extend the tape a minimum of 1 in. (25 mm) beyond the edge of the mount.
      - b) Remove the backing from the non-adhesive side of the tape.
      - c) Apply sealant to the outer edges of the patch.
    - 2) Apply the 3M 8663 tape, G02423 or moisture barrier tape, G51340 (optional) to overlap the patch.
      - a) Remove the backing from the non-adhesive side of the tape.
      - b) Apply sealant, A00247 to the inner edges of the tape.

EFFECTIVITY  
LOM ALL

**53-21-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 3) Cut a patch of 3M 8663 tape, G02423 or 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) to either cover flush mounts or to extend into the radius of protruding mounts.
  - a) Extend the tape to overlap the previous installed tape by a minimum of 1 in. (25 mm).
  - b) Remove the backing from the non-adhesive side of the tape.
  - c) Apply fillet sealant, A00247 to the edges of any protruding mounts.
- (9) Do these steps to seal the door gutters:
  - (a) Cut a patch of 3M 8663 tape, G02423 or 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) to fit over the gutter and girt bar fitting for forward entry door.
  - (b) Extend the tape a minimum of 1 in. (25 mm) onto the existing waterseal tape.
  - (c) Trim the tape at the edge of the gutter.
  - (d) The forward and aft ends of the patch must extend a minimum of 2 in. (51 mm) past the door edge frames.
  - (e) Apply sealant, A00247 to all waterseal tape edges where it cut back from the edge of the gutter.
  - (f) Apply a bead of sealant, A00247 to the existing sealant at the edge of the gutter and along the side of body crease beam chord.
  - (g) Remove the backing from the adhesive side of the tape and push the tape down firmly to smooth out the sealant bead.
  - (h) Remove the backing from the non-adhesive side of the tape.
- (10) Do these steps to seal the floor panel edges at side of body crease beam:
  - (a) Trim the 3M 8663 tape, G02423 or moisture barrier tape, G51340 (optional) to the edge of the floor panels at the side of body.
    - 1) Apply a bead of sealant, A00247 to the existing sealant at the side of body crease beam and fair it smooth.
    - 2) Apply sealant, A00247 to the edge of door gutter patch.
  - (b) Apply the 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) on the sealant at the side of body to extend a minimum of 1 in. (25 mm) onto the existing waterseal tape and above the top edge of the side of body crease beam chord.
    - 1) Extend the tape to overlap onto the door gutter patch a minimum of 1 in. (25 mm).
    - 2) Push the seam tape until it touch and stick to the faired sealant.
    - 3) Trim the seam tape to the top edge of the side of body crease beam chord.
- (11) Do these steps to seal the floor panel edges at side of body crease beam: (Alternative method)
  - (a) Apply a bead of sealant, A00247 to the existing sealant at the side of body crease beam and fair it smooth.
  - (b) Apply 3M 8663 tape, G02423 or moisture barrier tape, G51340 (optional) on the sealant at the side of body to extend above the top edge of the side of body crease beam chord.
  - (c) Push the waterseal tape until it touch and stick to the faired sealant.
  - (d) Trim the waterseal tape to the top edge of the side of body crease beam chord.
- (12) Do these steps to seal the floor panel edges adjacent to bulkheads:
  - (a) Trim the 3M 8663 tape, G02423 or moisture barrier tape, G51340 (optional) to the edge of the floor panels or the bulkhead base at the flight deck partition.

EFFECTIVITY  
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**53-21-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 1) Apply a bead of sealant, A00247 to the existing sealant or bulkhead base at the flight deck partition and fair it smooth.
  - (b) Apply 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) on the sealant at the flight deck partition to extend a minimum of 1 in. (25 mm) onto the existing waterseal tape and wrap up the flight deck partition a minimum of 2 in. (51 mm).
    - 1) Push the seam tape until it touch and stick to the faired sealant.
- (13) Do these steps to seal the floor panel edges adjacent to flight deck transition:
- (a) Trim the 3M 8663 tape, G02423 or moisture barrier tape, G51340 (optional) to the edge of the floor panels adjacent to the flight deck.
  - (b) Apply 3M 8663DL tape, G02500 or moisture barrier tape, G51340 (optional) on the edge of the waterseal tape extending over the lip and onto the vertical surface adjacent to the flight deck.

SUBTASK 53-21-00-300-001

- (14) Do these steps to repair cuts or air bubbles trapped under moisture barrier tape:

NOTE: Any air bubble must be less than 0.5 in. (12.7 mm) square inches in total area. In the walkway area, bubble must be less than 0.05 in. (1.27 mm) in height and less than 0.1 in. (2.5 mm) in height elsewhere.

NOTE: Air bubbles greater than 0.1 in. (2.5 mm) square inches in area must be limited in number to 10 or less in any 1 ft (305 mm) diameter area.

- (a) To repair the air bubble, use a sharp blade to cut the tape over the bubble and squeeze the air out. Be careful not to damage the underlying floor panel or structure.
- (b) Apply a small bead of sealant, A00247 on the cut.
- (c) Apply new tape and push down firmly to smooth out the sealant bead.
- (d) Make sure the repair tape overlap the cut by a minimum of 2 in. (51 mm).

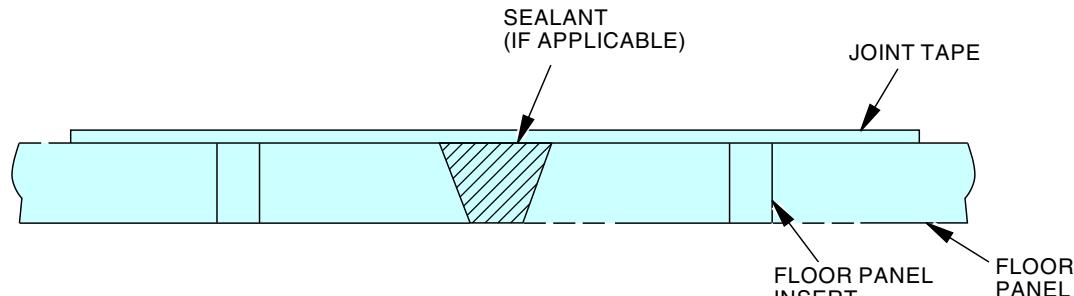
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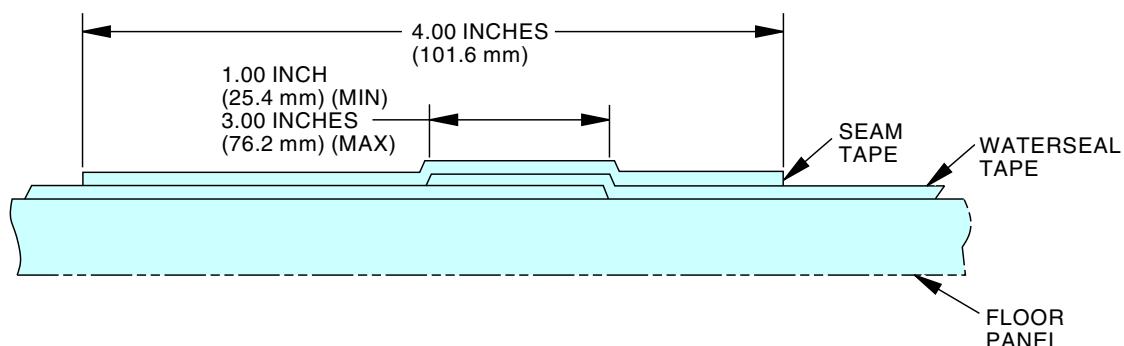
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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



JOINT TAPE INSTALLATION  
(EXAMPLE)



WATERSEAL SPLICE  
(EXAMPLE)

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Water Seal Tape Application  
Figure 801/53-21-00-990-802 (Sheet 1 of 7)

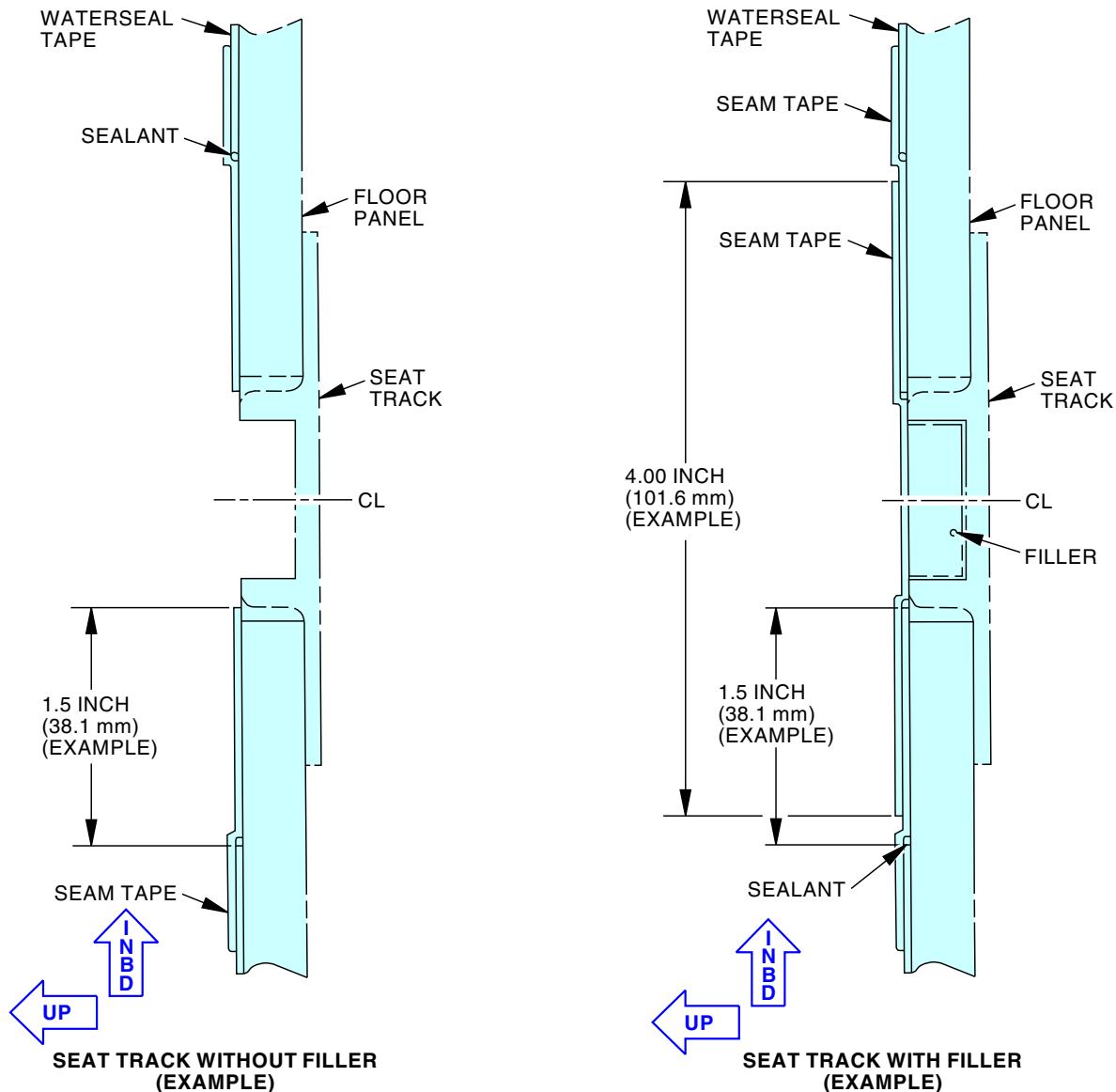
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 808  
Oct 15/2015



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**Water Seal Tape Application**  
**Figure 801/53-21-00-990-802 (Sheet 2 of 7)**

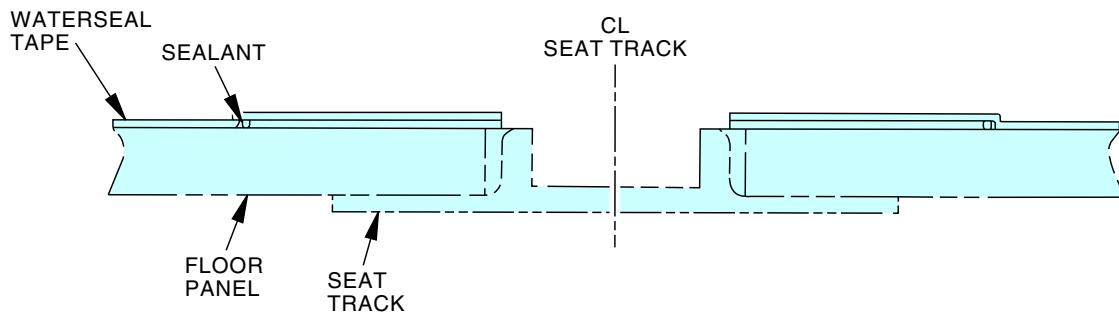
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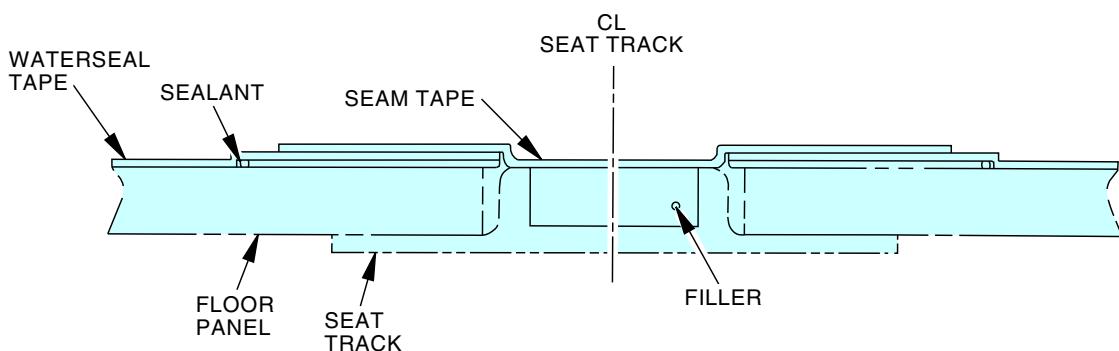
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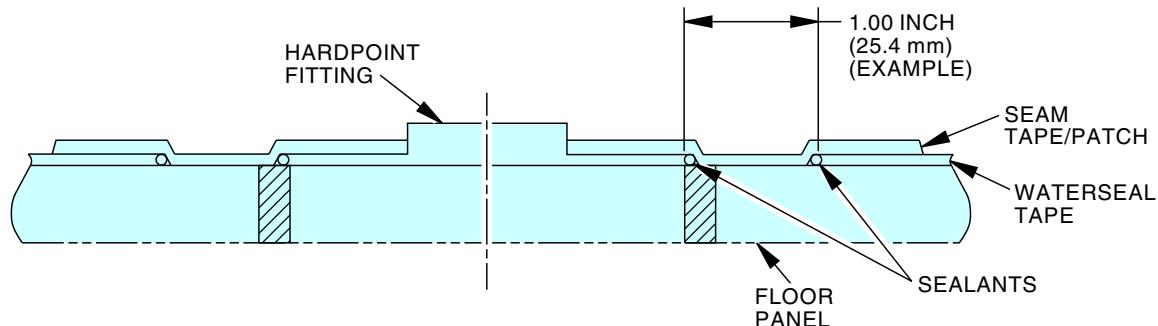
737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



SEAT TRACK WITHOUT FILLER  
(OPTIONAL METHOD 3)



SEAT TRACK WITH FILLER  
(OPTIONAL METHOD 3)



LAVATORY AND GALLEY HARDPOINT FITTINGS  
(EXAMPLE)

2179827 S0000481179\_V2

Water Seal Tape Application  
Figure 801/53-21-00-990-802 (Sheet 3 of 7)

EFFECTIVITY  
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**53-21-00**

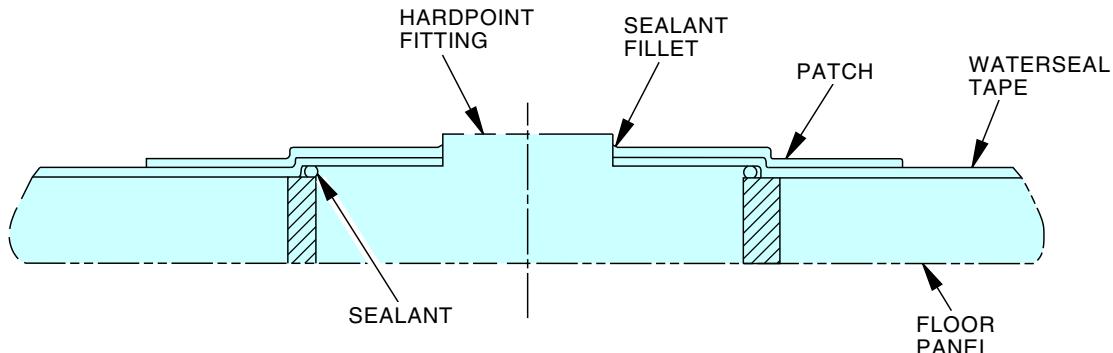
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

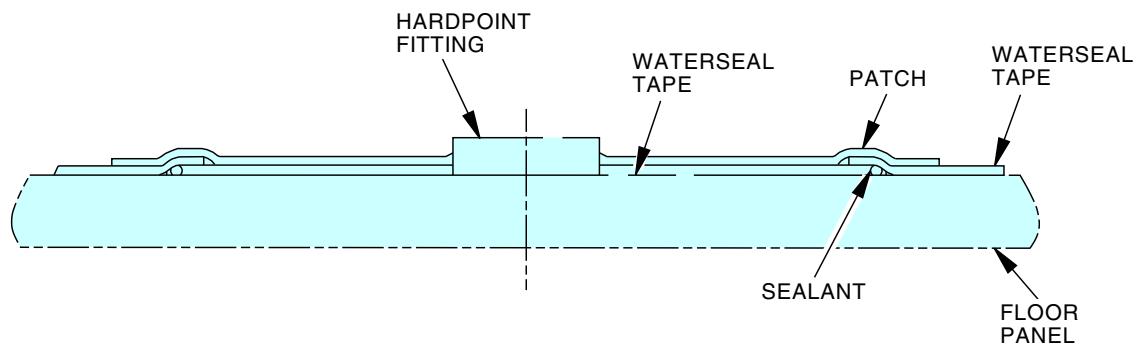
Page 810  
Oct 15/2015



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



LAVATORY AND GALLEY HARPOINTER FITTINGS  
(OPTIONAL METHOD 1)



LAVATORY AND GALLEY HARPOINTER FITTINGS  
(OPTIONAL METHOD 2)

2180025 S0000481180\_V2

Water Seal Tape Application  
Figure 801/53-21-00-990-802 (Sheet 4 of 7)

EFFECTIVITY  
LOM ALL

**53-21-00**

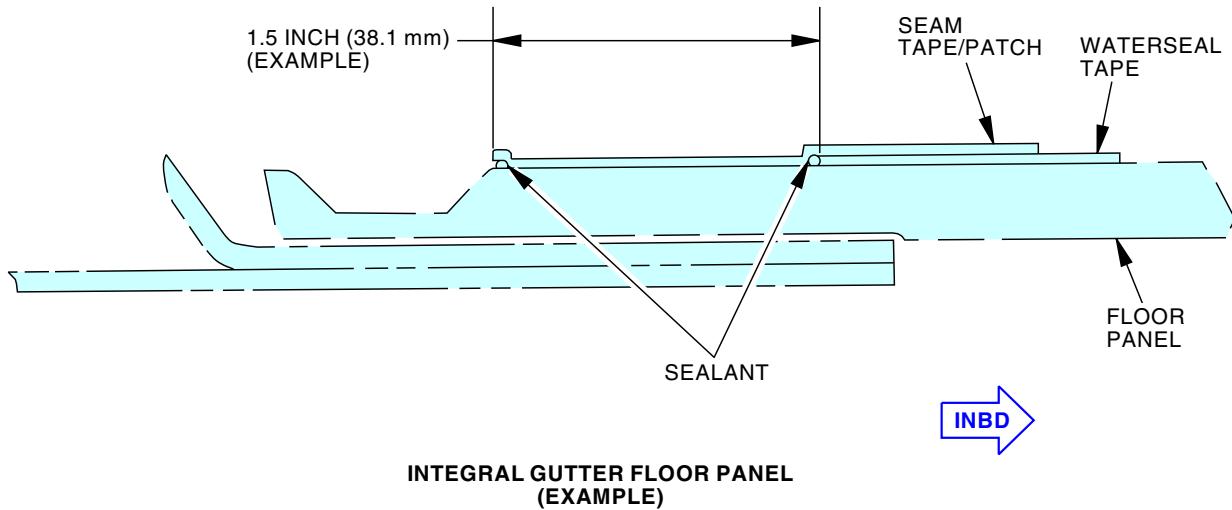
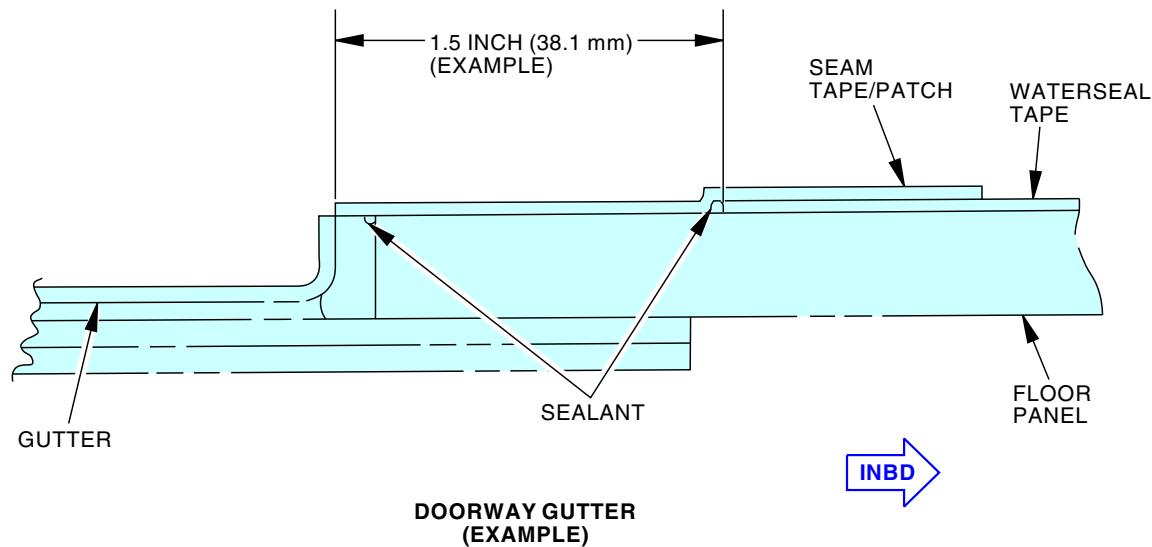
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Page 811  
Oct 15/2015



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



2180161 S0000481181\_V2

**Water Seal Tape Application**  
Figure 801/53-21-00-990-802 (Sheet 5 of 7)

EFFECTIVITY  
LOM ALL

**53-21-00**

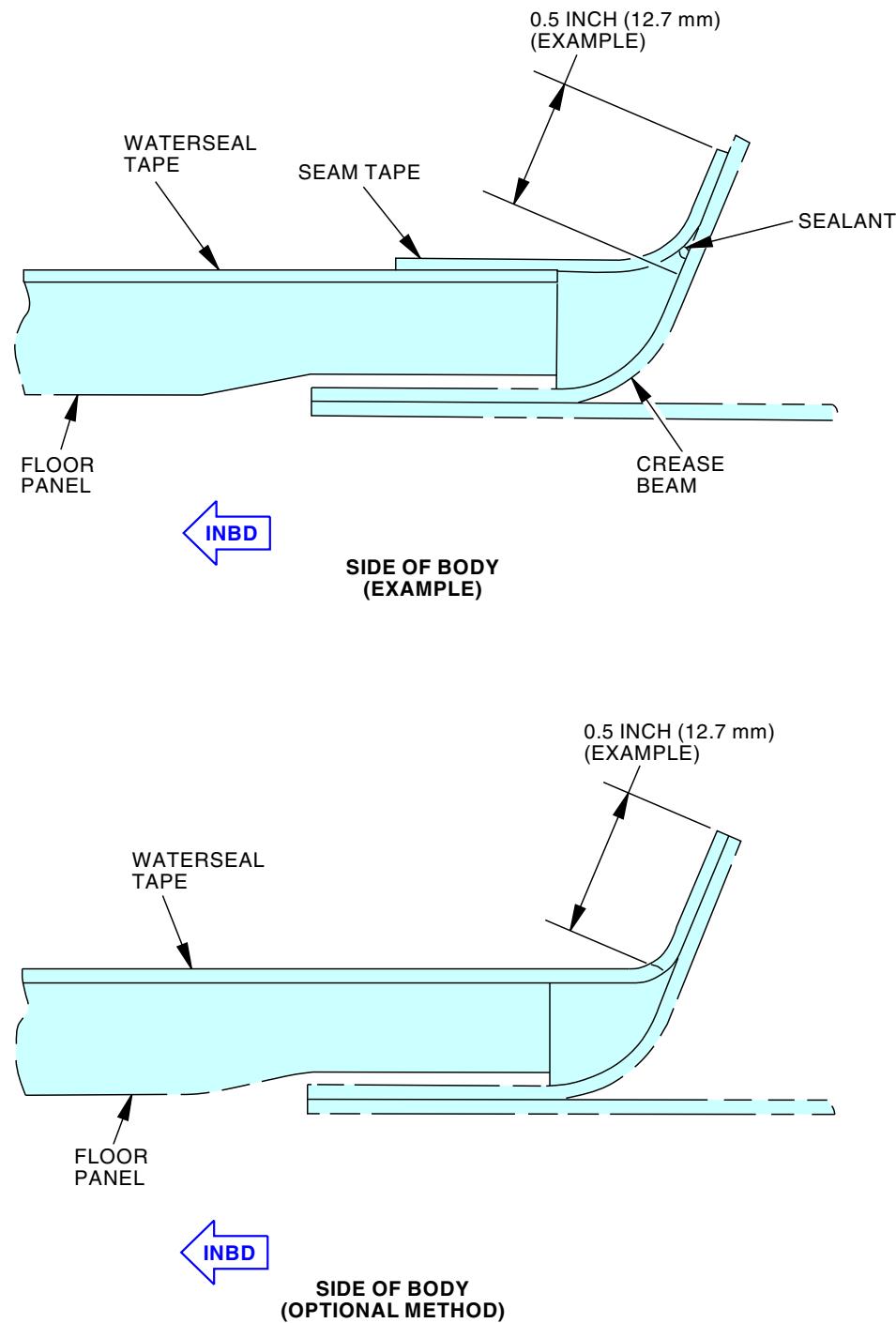
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 812  
Oct 15/2015



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



2180193 S0000481182\_V2

Water Seal Tape Application  
Figure 801/53-21-00-990-802 (Sheet 6 of 7)

EFFECTIVITY  
LOM ALL

**53-21-00**

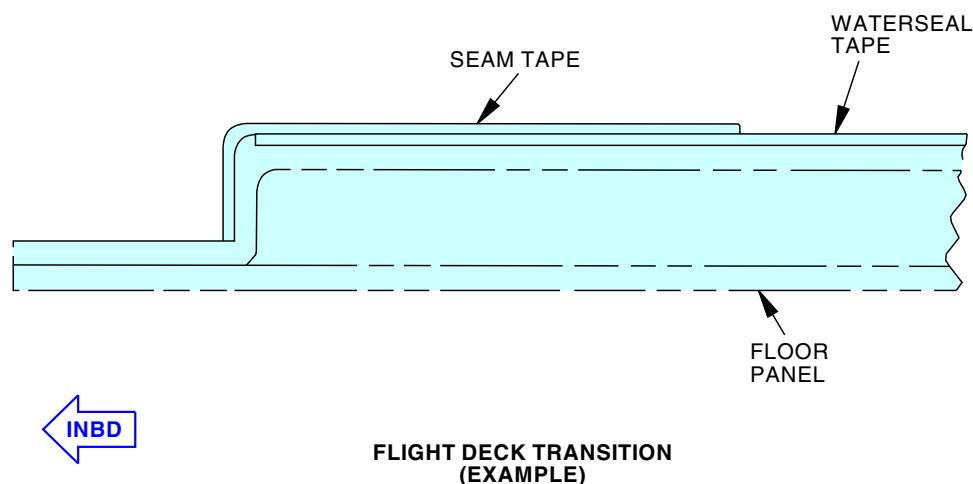
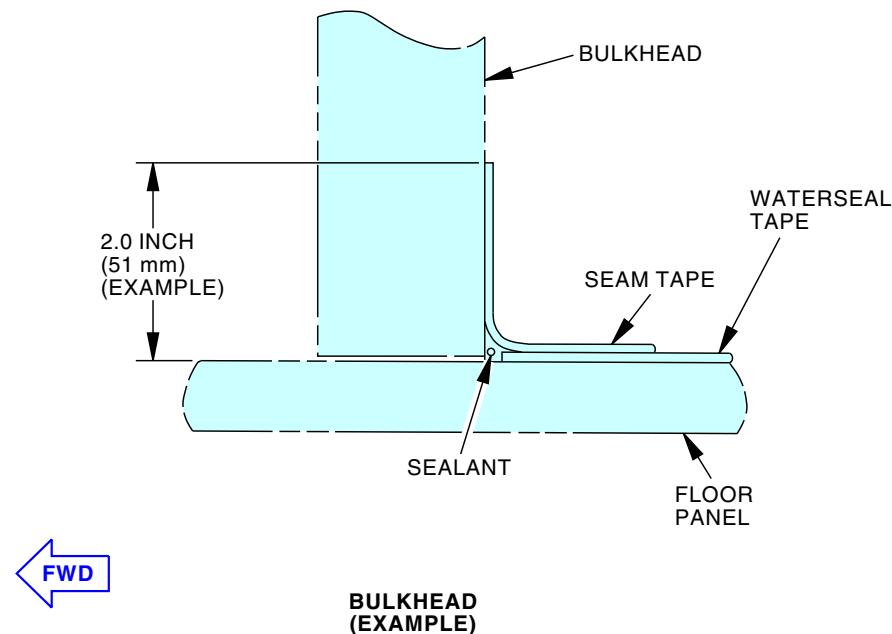
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 813  
Oct 15/2015



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



2180203 S0000481183\_V2

Water Seal Tape Application  
Figure 801/53-21-00-990-802 (Sheet 7 of 7)

EFFECTIVITY  
LOM ALL

**53-21-00**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 814  
Oct 15/2015



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

WATER BARRIER - REPAIRS

**1. General**

- A. This procedure contains two tasks. The first task is the repair of the vinyl part of the water barrier. The second task is the repair of the mylar part of the water barrier.
- B. The water barrier has mylar sheets (transparent), vinyl sheets (nontransparent) or 18 in. (457 mm) wide strips of tape bonded to the floor panels. This procedure gives instructions on how to cut the water barrier for the removal of a floor panel. It also gives instructions on how to repair the water barrier with the floor panel installed.
- C. The vinyl tape at right angles to the seat tracks with a 1.00 in. (25.40 mm) overlap is the preferred replacement of the water barrier.
- D. Cut through the water barrier around the edges of the floor panel to remove the floor panel. Pull back the vinyl to get to the fasteners for the floor panels. If mylar is on the floor panel fasteners, cut a circular patch for each fastener.

**TASK 53-21-11-300-801**

**2. Vinyl Water Barrier Repair**

**A. Consumable Materials**

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A50464	Tape - Vinyl, Adhesive Coated	BMS5-179
G00157	Tape - Nitto P-306L (use until stock depleted)	

**B. Location Zones**

Zone	Area
200	Upper Half of Fuselage

**C. Procedure**

SUBTASK 53-21-11-350-001

- (1) Apply the Nitto P-306L tape, G00157 or tape, A50464 vinyl tape at right angles to the seat tracks with a minimum of a 1.00 in. (25.40 mm) overlap.

SUBTASK 53-21-11-390-001

- (2) Apply a sealant, A00247 to the tape overlap.

NOTE: You can use 3.00 in. (76.20 mm) wide tape on the edge of the overlap as an alternative to the sealant.

———— END OF TASK ————

**TASK 53-21-11-300-802**

**3. Mylar Water Barrier Repair**

**A. References**

Reference	Title
53-21-00-400-801	Passenger Cabin Floor Panel - Installation (P/B 401)

**B. Consumable Materials**

Reference	Description	Specification
A00156	Adhesive - For Bonding Mylar And Nylon, 2 Part, RT Cure	BMS5-31

EFFECTIVITY  
LOM ALL

**53-21-11**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)
G00111	Sheet - Mylar	

**C. Location Zones**

Zone	Area
200	Upper Half of Fuselage

**D. Prepare for the Repair of the Mylar Water Barrier**

SUBTASK 53-21-11-410-001

- (1) Do this task: Passenger Cabin Floor Panel - Installation, TASK 53-21-00-400-801.

SUBTASK 53-21-11-350-002

- (2) Cut strips of mylar sheet, G00111 to make a splice with the edges of the floor panel.

NOTE: The splice must make a 0.75-inch (19 mm) overlap with the fastener line and adjacent floor panel 3/4 inch (19 mm).

SUBTASK 53-21-11-140-001

- (3) Clean the mating surfaces with solvent, B00083.

SUBTASK 53-21-11-350-003

- (4) Mix 100 parts by weight of the adhesive, A00156 Pro-Seal 501 with 30 parts by weight of the Pro-Seal 501-A accelerator. Mix for approximately 5 minutes with a spatula or an equivalent tool. If you mix the adhesive in the original can, cut off the rim of the can to make it easier.

NOTE: Apply the adhesive as soon as it is possible. The heat of the material in a container decreases the work life. The Work life is 20 minutes at 77°F (25°C). Use 50 ( $\pm 5$ ) grams for each square foot of the surface that you cover.

**E. Repair Procedure**

SUBTASK 53-21-11-390-002

- (1) Apply a layer of adhesive to the mating surface of the splice.

SUBTASK 53-21-11-390-003

- (2) Bond the splice to the water barrier.

SUBTASK 53-21-11-140-002

- (3) Remove the unwanted adhesive with a clean cotton wiper, G00034 moist with solvent, B00083.

SUBTASK 53-21-11-350-004

- (4) Put a weight or tape on the edges that show signs of delamination until the adhesive dries.

SUBTASK 53-21-11-860-001

- (5) Let the adhesive dry for a minimum of 2 hours.

NOTE: A minimum of 12 hours is necessary for the adhesive to fully dry.

— END OF TASK —

— EFFECTIVITY —  
**LOM ALL**

**53-21-11**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

NOSE VORTEX GENERATORS - REMOVAL/INSTALLATION

**1. General**

- A. This procedure contains two tasks.
  - (1) The first task is the removal of the nose vortex generators.
  - (2) The second task is the installation of the nose vortex generators.

**TASK 53-31-11-000-801**

**2. Remove the Nose Vortex Generators**

(Figure 401)

**A. Tools/Equipment**

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

Reference	Description
COM-2481	Sealant Removal Tool (Meets BSS7384 Requirements) Part #: 1-6390-A Supplier: 63318 Part #: 10810 Supplier: \$0855 Part #: 10811 Supplier: \$0855 Part #: 10812 Supplier: \$0855 Part #: 234350 Supplier: 5HCF1 Part #: 235072 Supplier: 5HCF1 Part #: 235073 Supplier: 5HCF1 Part #: 235074 Supplier: 5HCF1 Part #: 235075 Supplier: 5HCF1 Part #: 235076 Supplier: 5HCF1 Part #: 311/03 Supplier: F6892 Part #: 311/14 Supplier: F6892 Part #: 311/25 Supplier: F6892 Part #: 311/37 Supplier: F6892 Part #: AS1 Supplier: \$1351 Part #: AS2 Supplier: \$1351 Part #: AS3 Supplier: \$1351 Part #: DAD5013 Supplier: 7RKH2 Part #: DFD5019 Supplier: 7RKH2 Part #: JNT411B60 Supplier: 3DN12 Part #: JNT411B90 Supplier: 3DN12 Part #: PT6529-S Supplier: 81205 Part #: SCD5019 Supplier: 7RKH2 Part #: ST982LF-9 Supplier: 81205 Part #: TS1275-4 Supplier: 22975

**B. Location Zones**

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

**C. Procedure - Remove the Nose Vortex Generators**

SUBTASK 53-31-11-020-001

- (1) Remove the loose vortex generator [1] with sealant removal tool, COM-2481.

———— END OF TASK ————

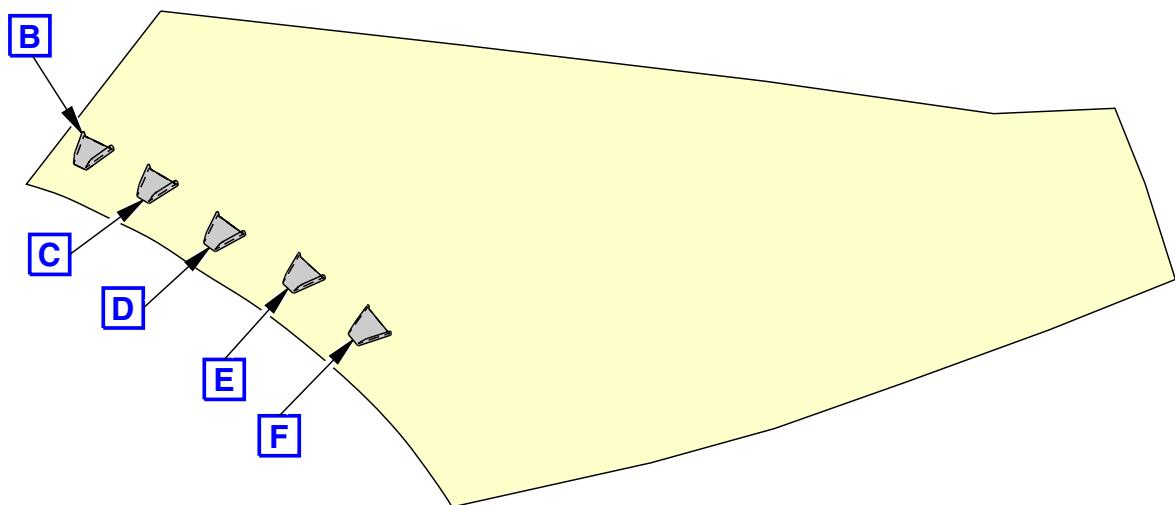
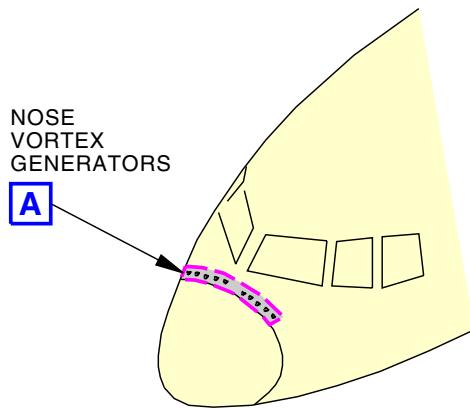
EFFECTIVITY  
LOM 404, 406, 407, 411, 412, 415, 416, 420, 422-434,  
437-447, 450-999; LOM 402 POST SB 737-25-1543

**53-31-11**

Page 401  
Feb 15/2025

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**BOEING**  
737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



NOSE VORTEX GENERATORS



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Nose Vortex Generators  
Figure 401/53-31-11-990-801 (Sheet 1 of 3)

EFFECTIVITY  
LOM 404, 406, 407, 411, 412, 415, 416, 420, 422-434,  
437-447, 450-999; LOM 402 POST SB 737-25-1543

**53-31-11**

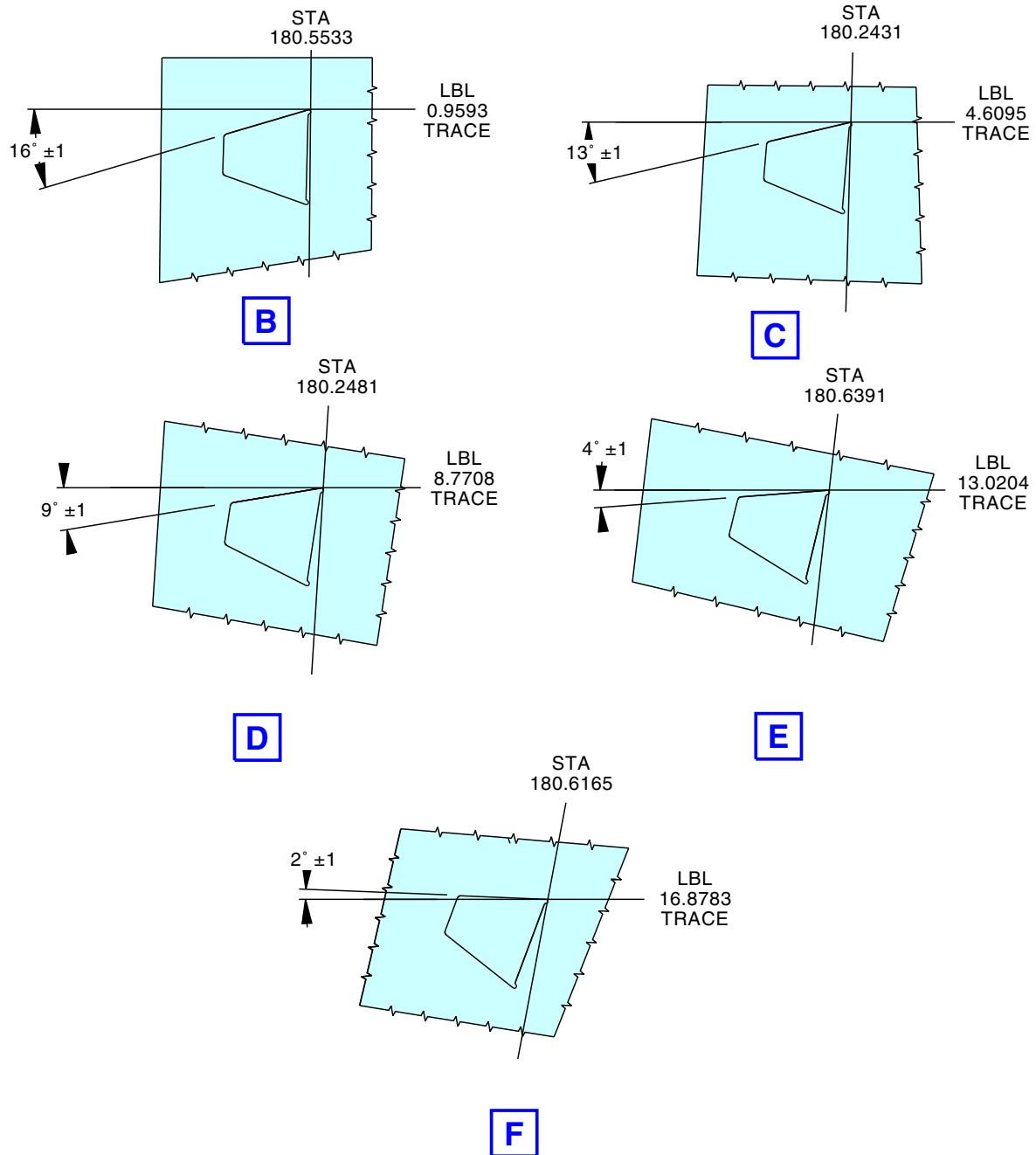
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Page 402  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



U64116 S0000210836\_V2

Nose Vortex Generators  
Figure 401/53-31-11-990-801 (Sheet 2 of 3)

EFFECTIVITY  
LOM 404, 406

**53-31-11**

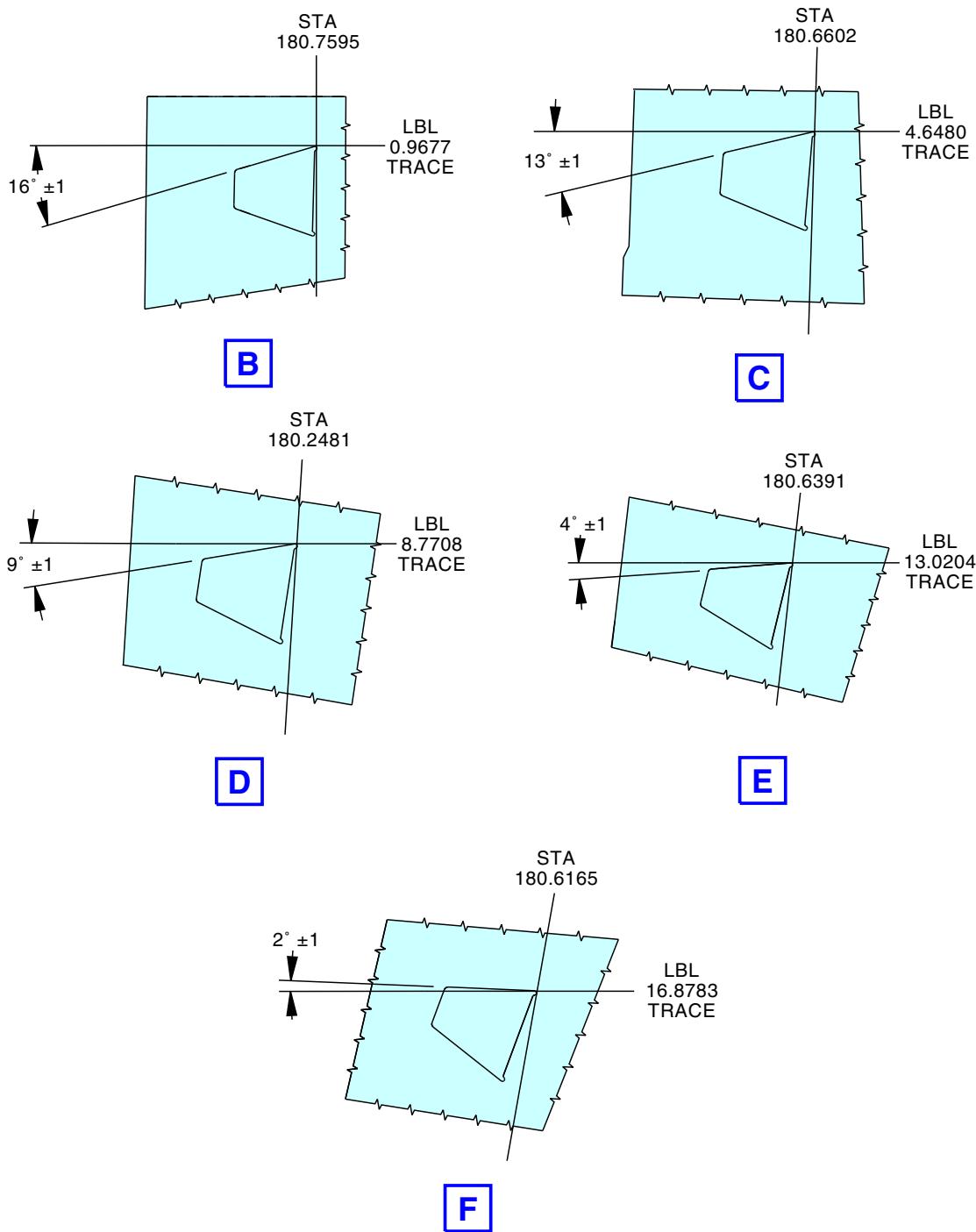
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Page 403  
Jun 15/2020



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



U63849 S0000210837\_V2

Nose Vortex Generators  
Figure 401/53-31-11-990-801 (Sheet 3 of 3)

EFFECTIVITY  
LOM 407, 411, 412, 415, 416, 420, 422-434, 437-447,  
450-999; LOM 402 POST SB 737-25-1543

**53-31-11**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-31-11-400-801**

**3. Install the Nose Vortex Generators**

(Figure 401)

**A. References**

Reference	Title
51-31-00-160-801	Prepare For Sealing (P/B 201)
57-32-00-993-802	Table: Cure Time For BMS 5-44 (Class B), BMS 5-45 (Class B) and PR-1828 (Class B) (P/B 401)

**B. Consumable Materials**

Reference	Description	Specification
A00436	Sealant - Fuel Tank	BMS5-45 (Supersedes BMS5-26)
A00551	Sealant - Fuel Tank	BAC5010 Type 44 (BMS5-44, BMS5-45)

**C. Location Zones**

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

**D. Procedure - Install the Nose Vortex Generator**

SUBTASK 53-31-11-150-001

- (1) Clean the mating surface, do this task: Prepare For Sealing, TASK 51-31-00-160-801

SUBTASK 53-31-11-410-001

- (2) Put the vortex generator [1] in the correct position.

SUBTASK 53-31-11-410-002

- (3) Do the steps that follow to bond the vortex generator to the fuselage skin surface:



DO NOT GET THE SEALANT ON YOUR SKIN OR IN YOUR EYES. PUT ON PROTECTIVE CLOTHING, GOGGLES AND A FACE MASK. USE IN A WELL VENTILATED AREA. DO NOT BREATHE THE GAS. IF YOU GET THE SEALANT ON YOUR SKIN OR IN YOUR EYES, WIPE IT AWAY. GET MEDICAL AID IF YOUR SKIN OR EYES BECOME IRRITATED.

- (a) Mix the base compound for the sealant, A00551 with the activator.

NOTE: Refer to the manufacturer's instructions for the details.

- 1) Do not thin the sealant.

- (b) Apply a thin, constant layer of the adhesive mixture to each mating surface.

- (c) Put the vortex generator on the nose section surface immediately, with sufficient pressure.

NOTE: Make sure that the surfaces are sealed together fully. Make sure that a continuous bead of extruded adhesive is around the edge of the vortex generator. This seals the surfaces together and shows a correct seal.

- (d) Remove the unwanted adhesive around the edges of the vortex generator.

SUBTASK 53-31-11-410-003

- (4) Fillet seal around the vortex generator.

EFFECTIVITY  
LOM 404, 406, 407, 411, 412, 415, 416, 420, 422-434,  
437-447, 450-999; LOM 402 POST SB 737-25-1543

**53-31-11**

Page 405  
Oct 15/2024



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (a) Make the fillet seal to 0.03 in. (0.76 mm) by 0.03 in. (0.76 mm).

NOTE: If more sealant is necessary for the fillet seal, use sealant, A00436 Class B.

SUBTASK 53-31-11-410-004

- (5) After the adhesive dries, (Table 57-32-00-993-802), apply paint to the nose section surface if it is necessary.

**Table 401/53-31-11-993-801 Cure Time For BMS 5-44 (Class B) and BMS 5-45 (Class B)**

Adhesive	Cure Time
BMS 5-44 Class B-1/2	24 hours at standard conditions
BMS 5-44 Class B-2	48 hours at standard conditions
BMS 5-45 Class B-1/2	12 hours at standard conditions
BMS 5-45 Class B-2	24 hours at standard conditions

———— END OF TASK ————

— EFFECTIVITY —  
LOM 404, 406, 407, 411, 412, 415, 416, 420, 422-434,  
437-447, 450-999; LOM 402 POST SB 737-25-1543

**53-31-11**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 406  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

VORTEX GENERATOR ASSEMBLY - REMOVAL/INSTALLATION

**1. General**

- A. This procedure contains two tasks:
  - (1) The removal of the vortex generator assembly.
  - (2) The installation of the vortex generator assembly.
- B. The vortex generator assembly is installed on the left and right side of the fuselage above the horizontal stabilizer. The function of the vortex generators are to increase the efficiency of the airflow over the flying surface.

**TASK 53-31-21-000-801**

**2. Vortex Generator Assembly Removal**

(Figure 401)

**A. Tools/Equipment**

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

Reference	Description
SPL-1672	Lock Assembly - Stabilizer Trim Part #: F71336-501 Supplier: 81205
STD-1064	Scraper - Phenolic, Hard Resin

**B. Location Zones**

Zone	Area
300	Empennage

**C. Access Panels**

Number	Name/Location
311BL	Stabilizer Trim Access Door

**D. Prepare for the Removal**

SUBTASK 53-31-21-010-001



**WARNING** MAKE SURE THAT ALL PERSONNEL, AND EQUIPMENT ARE AWAY FROM THE HORIZONTAL STABILIZER. THE MOVEMENT OF THE HORIZONTAL STABILIZER DURING MAINTENANCE CAN CAUSE INJURY TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (1) Use the switches on the control wheel to set the leading edge of the horizontal stabilizer to the full down (airplane nose up) position.

SUBTASK 53-31-21-860-001

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

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

Row	Col	Number	Name
C	2	C00849	AFCS STABILIZER TRIM

EFFECTIVITY  
LOM ALL

**53-31-21**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**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 53-31-21-860-002

- (3) Install the lock assembly, SPL-1672 on the stabilizer trim wheel at the control stand, (Figure 402).
  - (a) Adjust the height of the trim lock to put the trim wheel handle correctly on the yoke.
  - (b) Install the pin through the yoke.
  - (c) Install the safety pin.

SUBTASK 53-31-21-010-002

- (4) Open this access panel:

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

SUBTASK 53-31-21-010-003

- (5) Get access to the vortex generator fasteners from inside the fuselage.

NOTE: The leading edge of the horizontal stabilizer may be moved farther down by turning the handwheel by hand if needed.

- (a) Go on the horizontal stabilizer torque box to reach the fasteners.

**E. Removal Procedure**

SUBTASK 53-31-21-010-004

- (1) Remove the 13 bolts [2] which hold the vortex generator assembly [1] to the fuselage, (Figure 401).

SUBTASK 53-31-21-020-001

- (2) Remove the generator assembly [1] with a hardwood hard resin phenolic scraper, STD-1064.

———— END OF TASK ————

**TASK 53-31-21-400-801**

**3. Vortex Generator Installation**

(Figure 401)

**A. Tools/Equipment**

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

<u>Reference</u>	<u>Description</u>
SPL-1672	Lock Assembly - Stabilizer Trim Part #: F71336-501 Supplier: 81205
STD-1064	Scraper - Phenolic, Hard Resin

**B. Consumable Materials**

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95



**53-31-21**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III

**C. Location Zones**

Zone	Area
300	Empennage

**D. Access Panels**

Number	Name/Location
311BL	Stabilizer Trim Access Door

**E. Prepare for the Installation**

SUBTASK 53-31-21-140-001

- (1) If there is bonding material on the fuselage skin, remove the bonding material with a hardwood hard resin phenolic scraper, STD-1064.

SUBTASK 53-31-21-110-001

- (2) Use solvent, B00083 to clean the mating surfaces.

**F. Installation Procedure**

SUBTASK 53-31-21-420-001

- (1) Bond the vortex generator assembly [1] to the fuselage surface.
  - (a) Apply a thin, constant layer of sealant, A00247 to each mating surface.  
NOTE: Make sure the sealant will cover all of the mating surfaces.
  - (b) Align the vortex generator assembly [1] to the fuselage (Figure 401).
  - (c) Make a 0.05 inch by 0.05 inch (1.27mm by 1.27 mm) fillet seal around the edge of the assembly.

SUBTASK 53-31-21-420-002

- (2) Attach the vortex generator assembly [1] to the empennage with 13 bolts [2] in the applicable locations.

NOTE: The installation of permanent fasteners will hold the vortex generator assembly in position. You do not have to wait for the full cure of the sealant before you return the airplane to service.

**G. Put the Airplane Back to its Usual Condition**

SUBTASK 53-31-21-860-003

- (1) Remove the lock assembly, SPL-1672 on the stabilizer trim wheel at the control stand, (Figure 402).

SUBTASK 53-31-21-860-004

- (2) 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

EFFECTIVITY  
LOM ALL

**53-31-21**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

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

Row    Col    Number    Name

D      10      C00840      FLIGHT CONTROL STAB TRIM ACTUATOR

SUBTASK 53-31-21-010-005

- (3) Close this access panel:

Number    Name/Location

311BL      Stabilizer Trim Access Door

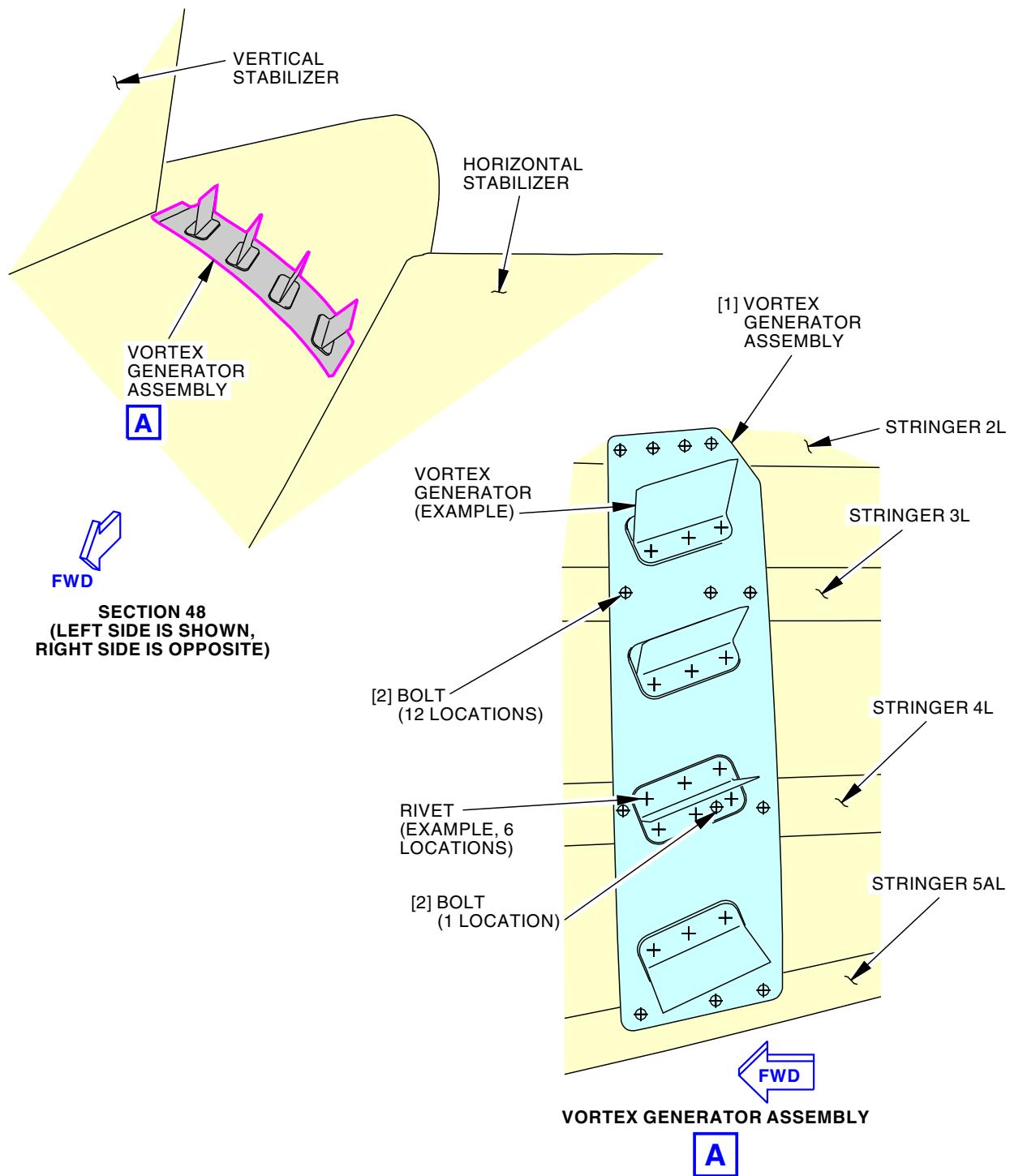
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EFFECTIVITY  
LOM ALL

**53-31-21**

Page 404  
Feb 15/2025

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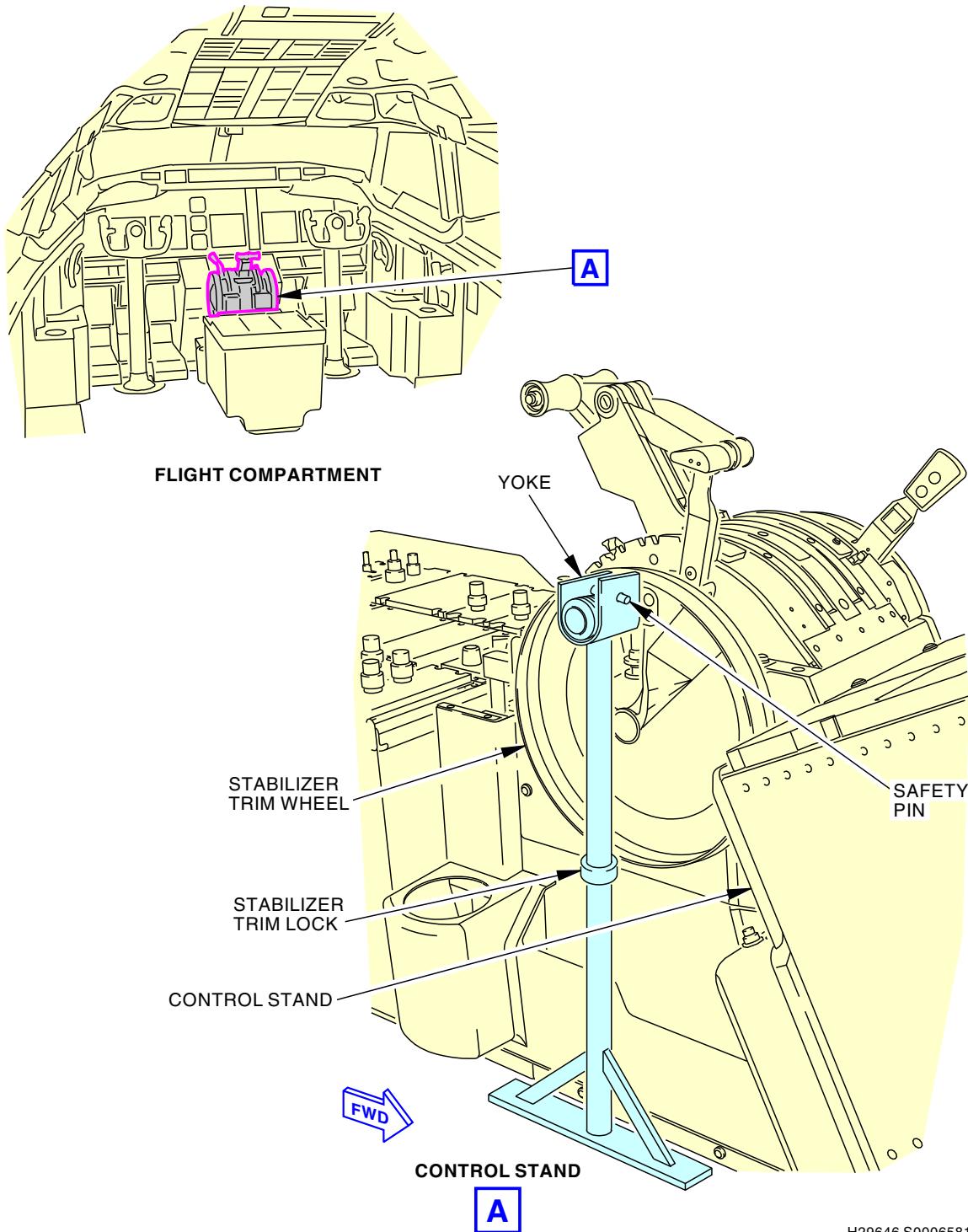


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**Fuselage Vortex Generator Installation**  
**Figure 401/53-31-21-990-801**

EFFECTIVITY  
**LOM ALL**

**53-31-21**



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**Stabilizer Trim Lock Installation**  
**Figure 402/53-31-21-990-802**

 EFFECTIVITY  
 LOM ALL

**53-31-21**

D633A101-LOM



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

STABILIZER TO BODY FRONT SPAR SLIDING SEAL - REMOVAL/INSTALLATION

**1. General**

- A. This procedure contains four tasks:
  - (1) The removal of the stabilizer-to-body upper front spar sliding seal.
  - (2) The installation of the stabilizer-to-body upper front spar sliding seal (referred to as the sliding seal).
  - (3) The removal of the stabilizer-to-body lower front spar sliding seal.
  - (4) The installation of the stabilizer-to-body lower front spar sliding seal (referred to as the sliding seal).
- B. The sliding seal closes the opening where the attach fitting of the forward stabilizer moves. The approved repair of the seal can be done when the seal plates has been removed and this task has been done: Apply The Abrasion-Resistant Teflon Finish, BMS 10-86 Type I, TASK 51-21-81-370-801.

**TASK 53-31-31-000-802**

**2. Stabilizer-to-Body Upper Front Spar Sliding Seal Removal**

(Figure 401)

**A. References**

Reference	Title
27-31-00-800-802	Remove Pressure from the Elevator Hydraulic Systems A and B (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 53-31-31-860-027-002

- (1) Do this task: Remove Pressure from the Elevator Hydraulic Systems A and B, TASK 27-31-00-800-802.

SUBTASK 53-31-31-860-028-002

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

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



ECCN 9E991 BOEING PROPRIETARY - See title page for details

D633A101-LOM

**53-31-31**

Config 2

Page 401

Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-31-31-860-029-002

- (3) 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

**CAPT Electrical System Panel, P18-2**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	8	C00544	FLIGHT RECORDER POSITION SENSOR

**CAPT Electrical System Panel, P18-3**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	15	C00644	EXTERIOR LIGHTING LOGO ILLUM

**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 53-31-31-860-026-002

- (4) If necessary, use the stabilizer trim wheel on the control stand to set the horizontal stabilizer at zero degrees (4 units of trim).

SUBTASK 53-31-31-480-007-002

- | (5) Install the lock assembly, SPL-1672, on the stabilizer trim wheel at the control stand (Figure 402):
- 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.

**F. Stabilizer-to-Body Upper Front Spar Sliding Seal Removal**

NOTE: The use of safety lockwire is optional to secure the two links together.

SUBTASK 53-31-31-010-001-002

- (1) To get access to the nuts [11], open this access panel:

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

SUBTASK 53-31-31-020-013

- (2) Remove the upper center track strips [3].
- Remove the nuts [11], washers [10], and bolts [9].

SUBTASK 53-31-31-020-014

- (3) Make sure that the stabilizer is at 4.0 degrees leading edge down to remove the upper seal plate [1].

SUBTASK 53-31-31-020-015

- (4) Remove the pins [4] that connect the link assemblies [7] to the pedestal [6].
- If the pin [4] heads point to the lugs, the pedestal [6] can be removed to get access for the removal of the pins.



ECCN 9E991 BOEING PROPRIETARY - See title page for details

D633A101-LOM

**53-31-31**

Config 2

Page 402

Feb 15/2025



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

(b) Keep the pedestal [6] for the installation.

SUBTASK 53-31-31-020-016

(5) Pull out the upper seal plate [1].

SUBTASK 53-31-31-020-017

(6) Remove all the hardware from the upper seal plate [1].

NOTE: Keep the link assembly and the corner plates for installation.

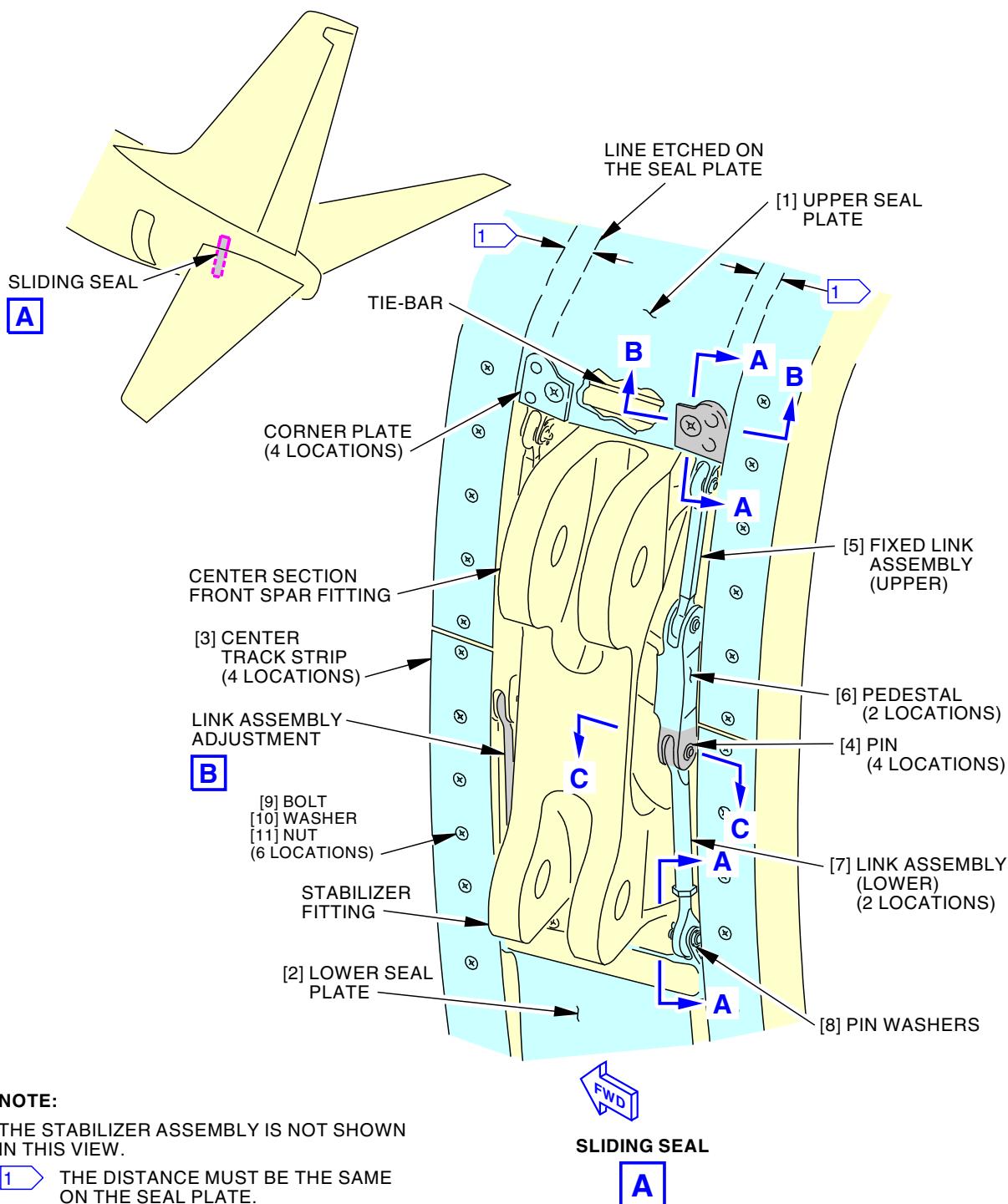
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

ECCN 9E991 BOEING PROPRIETARY - See title page for details

D633A101-LOM

**53-31-31**  
Config 2  
Page 403  
Oct 15/2023



368381 S0000133242\_V5

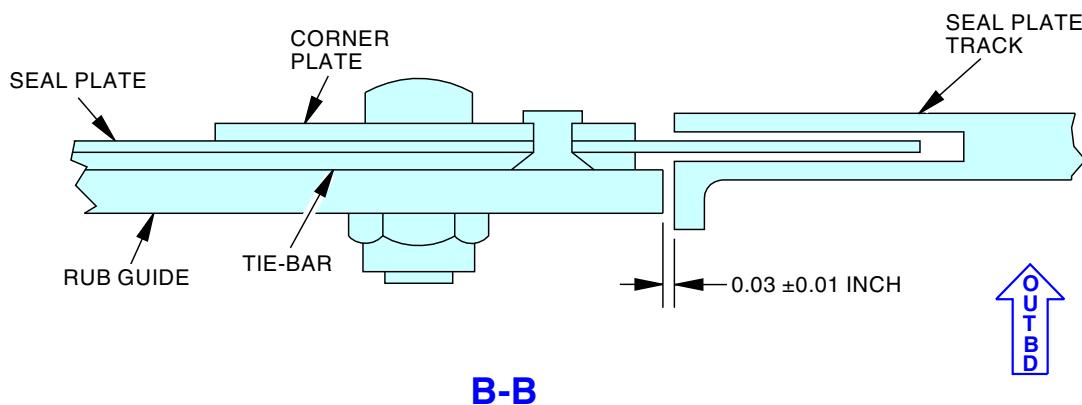
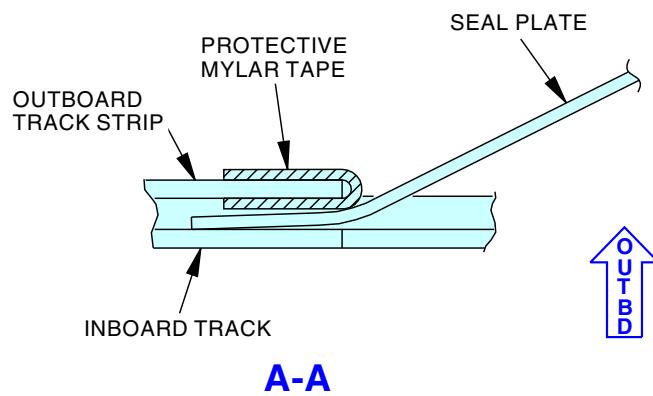
**Front Spar Sliding Seal Installation**  
**Figure 401/53-31-31-990-807-002 (Sheet 1 of 3)**

EFFECTIVITY  
LOM ALL

D633A101-LOM



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



H20834 S0006581035\_V2

Front Spar Sliding Seal Installation  
Figure 401/53-31-31-990-807-002 (Sheet 2 of 3)

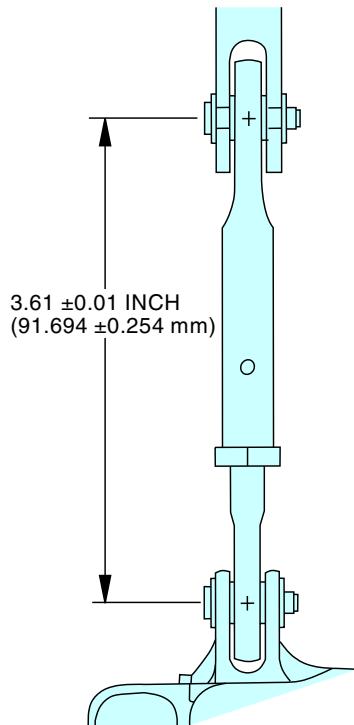
EFFECTIVITY  
LOM ALL

ECCN 9E991 BOEING PROPRIETARY - See title page for details

D633A101-LOM

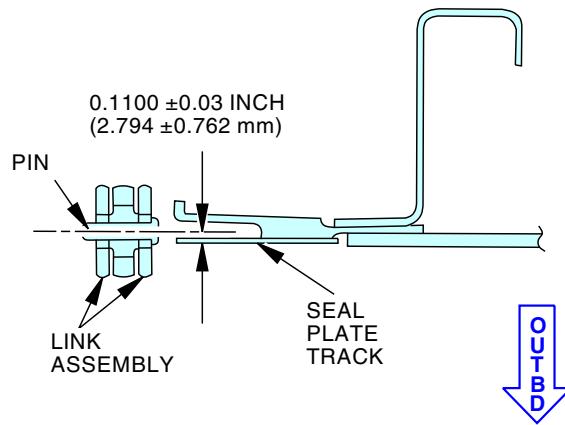
**53-31-31**  
Config 2  
Page 405  
Oct 15/2023

**BOEING**  
**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**



**LINK ASSEMBLY ADJUSTMENT**

**B**



**C-C**

370546 S0000133247\_V2

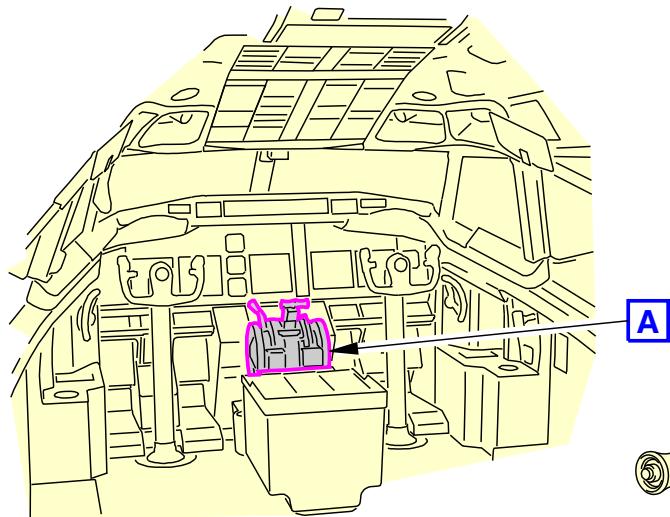
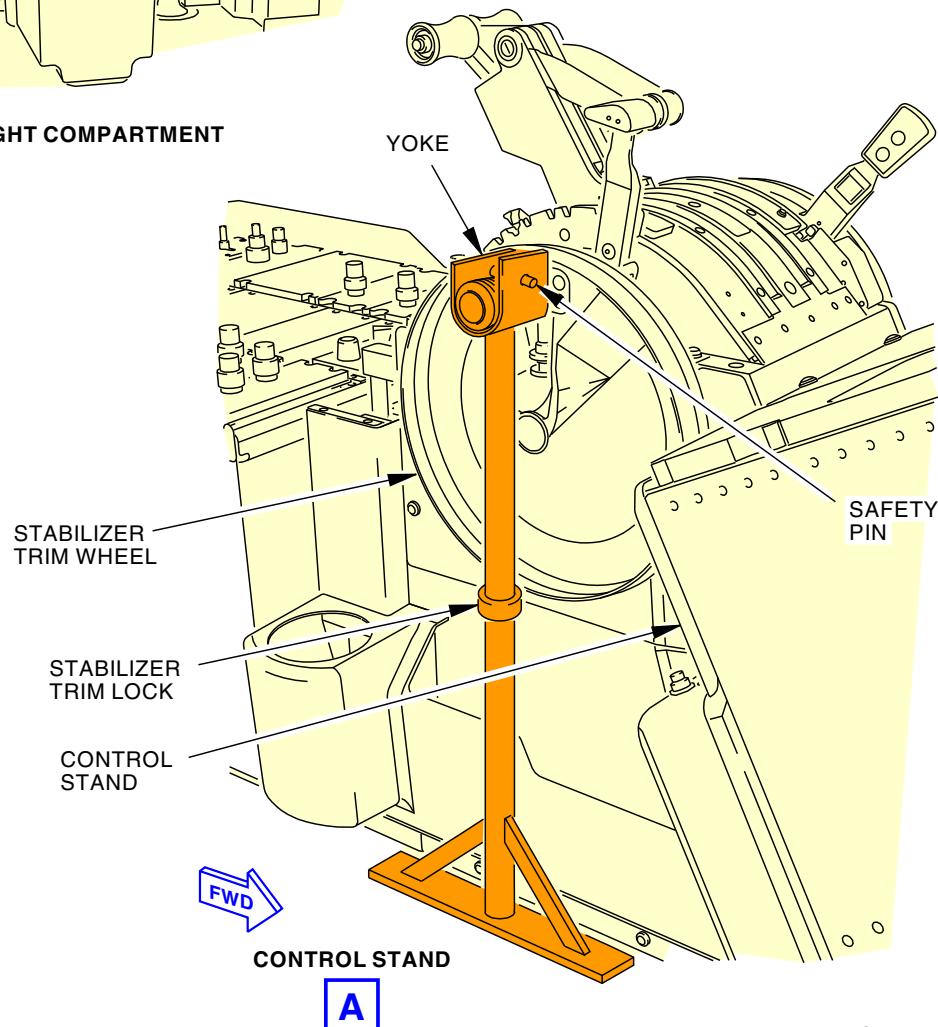
**Front Spar Sliding Seal Installation**  
**Figure 401/53-31-31-990-807-002 (Sheet 3 of 3)**

EFFECTIVITY  
**LOM ALL**

ECCN 9E991 BOEING PROPRIETARY - See title page for details

D633A101-LOM

**53-31-31**  
 Config 2  
 Page 406  
 Oct 15/2023


**FLIGHT COMPARTMENT**

**CONTROL STAND**
**A**

F74053 S0006569721\_V2

**Stabilizer Trim lock Installation**  
**Figure 402/53-31-31-990-808-002**

 EFFECTIVITY  
 LOM ALL

ECCN 9E991 BOEING PROPRIETARY - See title page for details

D633A101-LOM

**53-31-31**  
 Config 2  
 Page 407  
 Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-31-31-400-802**

3. **Stabilizer-to-Body Upper Front Spar Sliding Seal Installation**  
(Figure 401)

**A. References**

Reference	Title
27-31-00-840-802	Put the Elevator Systems A and B Back to the Condition Before the Pressure 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
STD-3729	Fastener - Spring Loaded, Sheet Metal, 3/16 Cleco

**C. Consumable Materials**

Reference	Description	Specification
G01925	Tape - 3M Polyester Film Tape 850 (Formerly 3M No. 850 Tape)	
G02480	Tape - Mylar, Clear, 3.5 mils, Maximum 16.5" Width - Permacel P-255	
G51272	Tape - High Temperature, Polyester Pressure Sensitive - Flashbreaker 2R	
G51458	Tape - Polyester, Adhesive - Nitto No. 315	

**D. Expendables/Parts**

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Seal plate	53-31-31-03-105	LOM ALL
		53-31-31-03-110	LOM ALL

**E. Location Zones**

Zone	Area
300	Empennage

**F. Access Panels**

Number	Name/Location
311BL	Stabilizer Trim Access Door

**G. Stabilizer-to-Body Upper Front Spar Sliding Seal Installation**

SUBTASK 53-31-31-860-047-002

- (1) Make sure that the stabilizer position is at 4.0 degrees leading edge down.

SUBTASK 53-31-31-420-020

- (2) Put the link assembly [5] in its position at the center of the replacement seal plate [1].

SUBTASK 53-31-31-210-005

- (3) Make sure that the tie-bar lugs are clear of the seal plate [1] edges and that the edge distances will be satisfactory.

EFFECTIVITY  
**LOM ALL**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-31-31**

Config 2

Page 408

Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-31-31-210-006

- (4) Make an index mark of the location of the tie-bar on the seal plate [1] with a pencil for reference.

SUBTASK 53-31-31-160-004

- (5) Remove any contamination or unwanted materials from the track area.

SUBTASK 53-31-31-410-001-002

- (6) If it is necessary, install the pedestal [6].

SUBTASK 53-31-31-420-021

- (7) Temporarily attach the link assembly [5] to the pedestal [6].

NOTE: Do not install the cotter pins.

SUBTASK 53-31-31-420-022

- (8) Apply protective 3M 850 tape, G01925, or Flashbreaker 2R tape, G51272, around the end of the track strip to prevent the seal plate from damage during the installation (Figure 401).

SUBTASK 53-31-31-420-023

- (9) Put the seal plate [1] into the tracks.

SUBTASK 53-31-31-420-024

- (10) Use the index mark to align the seal plate [1] on the link assembly [5].

SUBTASK 53-31-31-420-025

- (11) Lightly attach the seal plate [1] to the tie-bar with a clamp.

SUBTASK 53-31-31-420-026

- (12) If it is necessary, move the seal plate [1] in a longitudinal direction to get equal dimensions.

NOTE: The dimensions are between the etched line on the seal plate and the edges of the track strip along the full length of the visible track.

SUBTASK 53-31-31-950-002



**CAUTION**

DO THIS STEP CAREFULLY. IF THE PARTICLES GO INTO THE TRACKS, IT CAN CAUSE DAMAGE TO THE TEFLON COATING ON THE SEAL.

- (13) Apply Permacel P-255 tape, G02480, or Nitto No. 315 tape, G51458, (alternate) to all the track openings to prevent that the drilled chips go into the track.

SUBTASK 53-31-31-420-027

- (14) Tighten the clamps.

SUBTASK 53-31-31-420-028

- (15) Back drill a minimum of two locations through the holes in the tie-bar into the seal plate [1].

SUBTASK 53-31-31-420-029

- (16) Install the temporary spring loaded fastener, STD-3729, in the holes.

SUBTASK 53-31-31-020-018

- (17) Remove the pins [4] that attach the link assembly [5] to the pedestal [6].

SUBTASK 53-31-31-020-019

- (18) Remove the seal plate [1] with the attached link assembly [5].

SUBTASK 53-31-31-420-030

- (19) At the bench, assemble the seal plate [1], link assembly [5], and corner plates.

NOTE: Use the holes that are in the tie-bar for the locations to drill.

EFFECTIVITY  
LOM ALL



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-31-31-210-007

- (20) Make sure that the protective Permacel P-255 tape, G02480, or Nitto No. 315 tape, G51458, (alternate) stays around the end of the strip.

SUBTASK 53-31-31-420-031

- (21) Put the seal plate [1] assembly into the tracks.

SUBTASK 53-31-31-420-032

- (22) Move the seal plate [2] up and down.

- (a) The force to move the seal plate [2] must not be more than 20 lb (9 kg) and the seal plate [2] must move freely.

SUBTASK 53-31-31-220-003-002

- (23) Make sure that the distance between the center line of each pin [4] and the inside of the outer track strip is  $0.11 \pm 0.03$  in. ( $2.79 \pm 0.76$  mm) (Figure 401).

- (a) If adjustment is needed, loosen the four bolts on the pedestals [6].

- (b) Move the pedestal [6] assembly along the serrations on the serrated plate inboard or outboard.

- (c) Tighten the four bolts and nuts.

SUBTASK 53-31-31-420-033

- (24) Attach the link assembly [5] to the pedestal [6] with the pins [4].

SUBTASK 53-31-31-420-034

- (25) Install the cotter pins.

SUBTASK 53-31-31-420-035

- (26) Install the rub guide.

SUBTASK 53-31-31-420-038

- (27) Adjust and trim the ends of the rub guide.

- (a) It is necessary to keep  $0.03 \pm 0.01$  in. ( $0.76 \pm 0.25$  mm) clearance between each end of the rub guide and the track.

SUBTASK 53-31-31-420-037

- (28) Manually put the leading edge of the stabilizer to the full up position.

SUBTASK 53-31-31-210-008

- (29) Make sure that the double flush rivet at the uppermost corner of the seal plates is not out more than 0.003 in. (0.076 mm).

- (a) If the rivet touches the body structure, cut the driven head until it does not touch the body structure.

## H. Put the Airplane Back to Its Usual Condition

SUBTASK 53-31-31-020-021

- (1) Remove all the protective tapes and covers.

SUBTASK 53-31-31-160-002

- (2) Clean the area.

SUBTASK 53-31-31-420-036

- (3) Install the upper center track strips [3].

- (a) Install the bolts [9], washers [10], and nuts [11].





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-31-31-410-002-002

- (4) Close this access panel:

Number    Name/Location

311BL      Stabilizer Trim Access Door

SUBTASK 53-31-31-080-003-002

- (5) Remove the lock assembly, SPL-1672, from the stabilizer trim wheel at the control stand.

SUBTASK 53-31-31-860-035-002

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

SUBTASK 53-31-31-860-034-002

- (7) 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

**CAPT Electrical System Panel, P18-2**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	8	C00544	FLIGHT RECORDER POSITION SENSOR

**CAPT Electrical System Panel, P18-3**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	15	C00644	EXTERIOR LIGHTING LOGO ILLUM

**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 53-31-31-730-001-002

- (8) Do this task: Put the Elevator Systems A and B Back to the Condition Before the Pressure Removal, TASK 27-31-00-840-802.

———— END OF TASK ————

**TASK 53-31-31-000-803**

**4. Stabilizer-to-Body Lower Front Spar Sliding Seal Removal**

(Figure 401)

**A. References**

<u>Reference</u>	<u>Title</u>
27-31-00-800-802	Remove Pressure from the Elevator Hydraulic Systems A and B (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.



ECCN 9E991 BOEING PROPRIETARY - See title page for details

D633A101-LOM

**53-31-31**

Config 2

Page 411

Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

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 53-31-31-860-030-002

- (1) Do this task: Remove Pressure from the Elevator Hydraulic Systems A and B, TASK 27-31-00-800-802.

SUBTASK 53-31-31-860-031-002

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

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

SUBTASK 53-31-31-860-032-002

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

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

Row	Col	Number	Name
C	2	C00849	AFCS STABILIZER TRIM

**CAPT Electrical System Panel, P18-2**

Row	Col	Number	Name
C	8	C00544	FLIGHT RECORDER POSITION SENSOR

**CAPT Electrical System Panel, P18-3**

Row	Col	Number	Name
A	15	C00644	EXTERIOR LIGHTING LOGO ILLUM

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

Row	Col	Number	Name
B	10	C00207	FLIGHT CONTROL STAB TRIM CONT
D	10	C00840	FLIGHT CONTROL STAB TRIM ACTUATOR

SUBTASK 53-31-31-860-033-002

- (4) If necessary, use the stabilizer trim wheel on the control stand to set the horizontal stabilizer at zero degrees (4 units of trim).

SUBTASK 53-31-31-480-008-002

- (5) Install the lock assembly, SPL-1672, on the stabilizer trim wheel at the control stand (Figure 402):

- (a) Turn the trim wheel to put the handle at the top of the wheel.
- (b) Adjust the height of the trim lock to put the trim wheel handle correctly on the yoke.
- (c) Install the pin through the yoke.
- (d) Install the safety pin.

EFFECTIVITY  
LOM ALL



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**F. Stabilizer-to-Body Lower Front Spar Sliding Seal Removal**

NOTE: The use of safety lockwire is optional to secure the two links together.

SUBTASK 53-31-31-010-002-002

- (1) To get access to the nuts [11], open this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

SUBTASK 53-31-31-020-002

- (2) Remove the lower center track strip [3].
  - (a) Remove the nuts [11], washers [10], and bolts [9].

SUBTASK 53-31-31-080-008-002

- (3) Remove the lock assembly, SPL-1672, from the stabilizer trim wheel at the control stand.

SUBTASK 53-31-31-020-023

- (4) Move the stabilizer to the full up position to remove the lower sliding seal plate.

SUBTASK 53-31-31-480-011-002

- (5) Install the lock assembly, SPL-1672, on the stabilizer trim wheel at the control stand (Figure 402):

- (a) Turn the trim wheel to put the handle at the top of the wheel.
  - (b) Adjust the height of the trim lock to put the trim wheel handle correctly on the yoke.
  - (c) Install the pin through the yoke.
  - (d) Install the safety pin.

SUBTASK 53-31-31-020-024

- (6) Remove the pins [4] that connect the link assemblies [7] to the pedestal [6].

SUBTASK 53-31-31-020-025

- (7) Pull out the lower sliding seal plate [2].

SUBTASK 53-31-31-020-026

- (8) Remove the link assemblies [7] and attaching hardware.

NOTE: Keep the link assembly and attaching hardware for installation.

————— END OF TASK ————

**TASK 53-31-31-400-803**

**5. Stabilizer-to-Body Lower Front Spar Sliding Seal Installation**

(Figure 401)

**A. References**

Reference	Title
27-31-00-840-802	Put the Elevator Systems A and B Back to the Condition Before the Pressure 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.



ECCN 9E991 BOEING PROPRIETARY - See title page for details

D633A101-LOM

**53-31-31**

Config 2

Page 413

Feb 15/2025



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

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

**C. Consumable Materials**

Reference	Description	Specification
G02480	Tape - Mylar, Clear, 3.5 mils, Maximum 16.5" Width - Permacel P-255	

**D. Expendables/Parts**

AMM Item	Description	AIPC Reference	AIPC Effectivity
2	Seal plate	53-31-31-02A-100	LOM ALL
		53-31-31-02A-105	LOM ALL

**E. Location Zones**

Zone	Area
300	Empennage

**F. Access Panels**

Number	Name/Location
311BL	Stabilizer Trim Access Door

**G. Stabilizer-to-Body Lower Front Spar Sliding Seal Installation**

SUBTASK 53-31-31-860-046-002

- (1) Make sure that the stabilizer is in the full up position.

SUBTASK 53-31-31-160-003

- (2) Remove any contamination or unwanted materials from the track area.

SUBTASK 53-31-31-420-039

- (3) Apply protective Permacel P-255 tape, G02480, around the end of the track strip to prevent the seal plate from damage during the installation (Figure 401).

SUBTASK 53-31-31-420-040

- (4) Put the seal plate [2] into the tracks.

SUBTASK 53-31-31-420-041

- (5) Move the seal plate [2] up and down.

- (a) The force to move the seal plate [2] must not be more than 20 lb (9 kg) and the seal plate [2] must move freely.

SUBTASK 53-31-31-220-001

- (6) Make sure that the distance between the center line of each pin [4] and the inside of the outer track strip is  $0.11 \pm 0.03$  in. ( $2.79 \pm 0.76$  mm) (Figure 401).

- (a) If adjustment is needed, loosen the four bolts on the pedestals.
  - (b) Move the pedestal assembly along serrations on the serrated plate inboard or outboard.
  - (c) Tighten the four bolts and nuts.

SUBTASK 53-31-31-420-042

- (7) Attach the link assembly [7] to the pedestal [6] with the pins [4].

SUBTASK 53-31-31-420-043

- (8) Install the cotter pins.

EFFECTIVITY	
LOM ALL	

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-31-31**

Config 2

Page 414

Feb 15/2025



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-31-31-420-044

- (9) Attach the seal plate [2] to the link assemblies [7] with the pins [8].

SUBTASK 53-31-31-220-002

- (10) Adjust the forward link assembly [7] length to  $3.61 \pm 0.01$  in. ( $91.69 \pm 0.25$  mm) (View B, Figure 401).  
(a) Tighten the nuts of the link assembly [7] to 20 in-lb (2.26 N·m) - 30 in-lb (3.39 N·m).  
(b) Install the cotter pins.

SUBTASK 53-31-31-210-010

- (11) Adjust the aft link assembly [7] length in half turn increments to achieve an equal gap between the rub guide and seal tracks.

## H. Put the Airplane Back to Its Usual Condition

SUBTASK 53-31-31-020-027

- (1) Remove all the protective tapes and covers.

SUBTASK 53-31-31-160-005

- (2) Clean up the area.

SUBTASK 53-31-31-420-046

- (3) Install the lower center track strips [3].  
(a) Install the bolts [9], washers [10], and nuts [11].

SUBTASK 53-31-31-410-003-002

- (4) Close this access panel:

**Number      Name/Location**

311BL      Stabilizer Trim Access Door

SUBTASK 53-31-31-080-004-002

- (5) Remove the lock assembly, SPL-1672, from the stabilizer trim wheel at the control stand.

SUBTASK 53-31-31-860-036-002

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

SUBTASK 53-31-31-860-037-002

- (7) 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

**CAPT Electrical System Panel, P18-2**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
C	8	C00544	FLIGHT RECORDER POSITION SENSOR

**CAPT Electrical System Panel, P18-3**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
A	15	C00644	EXTERIOR LIGHTING LOGO ILLUM

**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

EFFECTIVITY  
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**53-31-31**

Config 2

Page 415

Feb 15/2025

D633A101-LOM



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

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

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
------------	------------	---------------	-------------

D	10	C00840	FLIGHT CONTROL STAB TRIM ACTUATOR
---	----	--------	-----------------------------------

SUBTASK 53-31-31-730-002-002

- (8) Do this task: Put the Elevator Systems A and B Back to the Condition Before the Pressure Removal, TASK 27-31-00-840-802.

———— END OF TASK ————

EFFECTIVITY  
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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

PASSENGER CABIN AND CARGO COMPARTMENT TRACKS - CLEANING/PAINTING

**1. General**

- A. This procedure contains one task. The task is to clean the passenger cabin and cargo compartment tracks.
- B. A minimum quantity of maintenance is necessary for the passenger cabin and cargo compartment tracks if you keep them clean and free of moisture. Use the task that follows when you find corrosion.

**TASK 53-42-11-100-801**

**2. Clean the Passenger Cabin and Cargo Compartment Track**

**A. References**

Reference	Title
SRM 51-20-01	Structural Repair Manual

**B. Tools/Equipment**

Reference	Description
STD-123	Brush - Soft Bristle

**C. Consumable Materials**

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
B00102	Abrasive - Aluminum Oxide Coated Cloth	
C00064	Coating - Aluminum Chemical Conversion	BAC5719 Type II Class A (MIL-DTL-5541 Class 1A)
C00755	Compound - Organic Corrosion Inhibiting, Heavy Duty	BMS3-26

**D. Location Zones**

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

**E. Procedure**

**SUBTASK 53-42-11-140-001**

- (1) Manually clean the track with solvent, B00083.

**SUBTASK 53-42-11-210-001**

- (2) Make sure you remove oil or grease.

**SUBTASK 53-42-11-140-002**

- (3) Rub the track with abrasive cloth, B00102 paper to remove the corrosion.

**SUBTASK 53-42-11-140-003**

- (4) Remove the residue with a soft bristle brush, STD-123.

**SUBTASK 53-42-11-140-004**

- (5) Clean the surface again with solvent, B00083.

EFFECTIVITY
LOM ALL

**53-42-11**

Page 701  
Feb 15/2017



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-42-11-110-001



**WARNING**

DO NOT TOUCH YOUR SKIN WITH THE CHEMICAL CONVERSION COATING. IT CONTAINS CHROMIC ACID AND CAN CAUSE INJURY TO PERSONS.



**CAUTION**

PUT A COVER ON THE CARPETS WHILE YOU APPLY THE CHEMICAL CONVERSION COATING. IT CAN CAUSE A STAIN ON SOME FABRICS.

- (6) Apply a layer of the chemical conversion coating, C00064 to the surface.

SUBTASK 53-42-11-370-001

- (7) Apply a finish if it is necessary.

SUBTASK 53-42-11-390-001

- (8) Below the galleys, apply a corrosion preventive compound, C00755 in the seat tracks (SRM 51-20-01).

———— END OF TASK ————

EFFECTIVITY  
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**53-42-11**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

FRONT SPAR TO REAR SPAR UNDERWING PANEL - INSPECTION/REPAIR

**1. General**

- A. This procedure contains two tasks. The first task is to examine the countersunk of the fastener holes of the front spar to rear spar underwing panel. The second task is the repair the holes if cracks are found.

**TASK 53-51-00-200-801**

**2. Front Spar to Rear Spar Underwing Panel Inspection**

Figure 201

**A. Location Zones**

Zone	Area
100	Lower Half of Fuselage

**B. Procedure**

SUBTASK 53-51-00-010-001

- (1) Remove the sixteen 0.25 in. (6.35 mm) attach fasteners from the outboard edge of the aft and forward panels on the left and right sides (Figure 201).

SUBTASK 53-51-00-210-001

- (2) Do a visual inspection with a 10X magnifying glass of the countersunk and adjacent area of the hole.

SUBTASK 53-51-00-300-001

- (3) If you find cracks in or adjacent to the countersunk area, do this task: Front Spar to Rear Spar Underwing Panel Repair, TASK 53-51-00-300-801.

SUBTASK 53-51-00-420-002

- (4) If you do not find cracks, or you have made repairs to cracks, install the bolts and washers:
- Measure and record the nutplate for the self-locking torque. The torque should be 3.5 in-lb (0.4 N·m) to 30 in-lb (3 N·m).
  - Add the self-locking torque (5 in-lb (1 N·m) to 10 in-lb (1 N·m)) to calculate the installation torque.
  - Tighten the bolts to the midrange of this torque range.

———— END OF TASK ————

**TASK 53-51-00-300-801**

**3. Front Spar to Rear Spar Underwing Panel Repair**

**A. References**

Reference	Title
SRM 51-70-04	Repair of Damage to the Edgeband of a Honeycomb Panel
SRM 51-70-05	Structural Repair Manual

**B. Consumable Materials**

Reference	Description	Specification
G50400	Resin - Fiberglass Layup, Short Worklife, Non-Brominated	BMS8-201 Type IV (Supersedes BMS8-201 Type II)

EFFECTIVITY  
LOM ALL

**53-51-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

C. Location Zones

Zone	Area
100	Lower Half of Fuselage

D. Procedure

SUBTASK 53-51-00-340-003

- (1) If you find cracks only in the countersunk area:
  - (a) Fill the crack with resin, G50400.

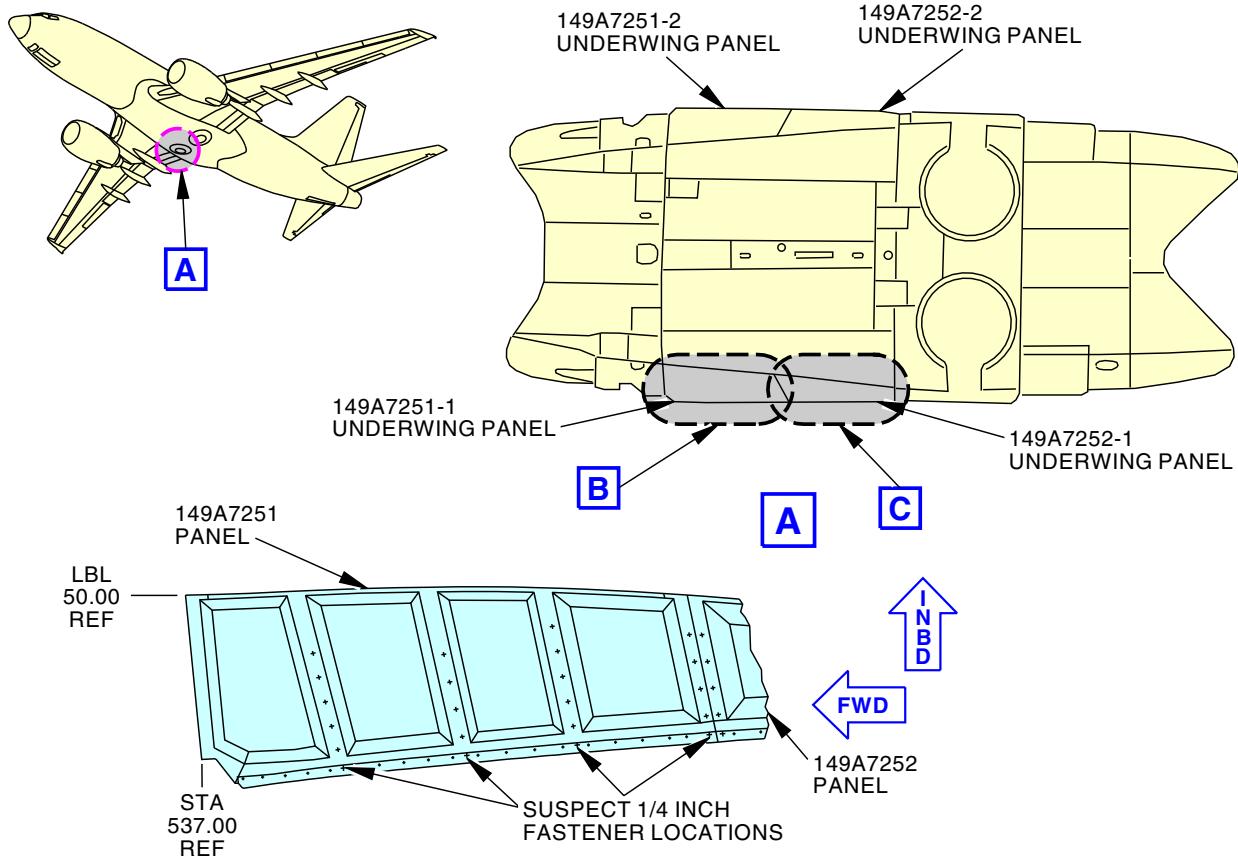
SUBTASK 53-51-00-340-001

- (2) If you find cracks that extend more than the countersunk area, do one of the repair procedures that follow:
  - (a) SRM 51-70-04, Repair 6
  - (b) SRM 51-70-05, Repair 6.

———— END OF TASK ————

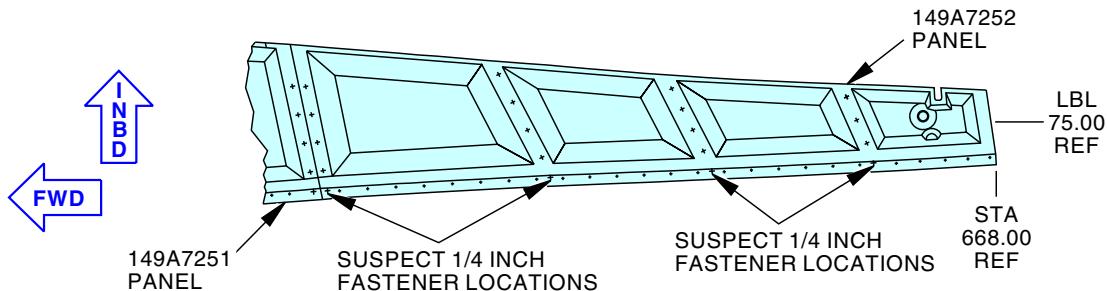
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**53-51-00**

**737-600/700/800/900  
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**FORWARD UNDERWING PANEL, 149A7251, FASTENER LOCATIONS  
(LEFT PANEL IS SHOWN, RIGHT PANEL IS OPPOSITE)**

**B**



**AFT UNDERWING PANEL, 149A7252, FASTENER LOCATIONS  
(LEFT PANEL IS SHOWN, RIGHT PANEL IS OPPOSITE)**

**C**

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**Front Spar to Rear Spar Underwing Panel Attachment Fasteners**  
**Figure 201/53-51-00-990-801**

EFFECTIVITY  
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D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-51-00**

Page 203  
Oct 15/2015





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

WING-TO-BODY FAIRING - INSPECTION/CHECK

**1. General**

- A. This procedure has one task. The task gives instructions to check the electrical resistance of a wing-to-body fairing panel.

**TASK 53-51-01-765-801**

**2. Wing-to-Body Fairing Electrical Resistance Check**

**A. References**

Reference	Title
53-51-21 P/B 401	WING-TO-BODY FAIRING PANELS - REMOVAL/INSTALLATION

**B. Tools/Equipment**

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

Reference	Description
COM-1793	Multimeter - Digital/Analog (or equivalent meter meets task requirements) Part #: 117 Supplier: 89536 Part #: 260-8XPI Supplier: 55026 Part #: 287 Supplier: 89536 Part #: 289 Supplier: 89536 Part #: 87V Supplier: 89536 Part #: FLUKE 27 II Supplier: 89536 Part #: FLUKE-77-4 Supplier: 89536 Opt Part #: 187 Supplier: 89536 Opt Part #: 189 Supplier: 89536 Opt Part #: 21 Supplier: 89536 Opt Part #: 27 Supplier: 89536 Opt Part #: 77 SERIES III Supplier: 89536 Opt Part #: 87 Supplier: 89536 Opt Part #: FLUKE 27 Supplier: 89536 Opt Part #: MODEL 27 Supplier: 89536

**C. Consumable Materials**

Reference	Description	Specification
C00767	Coating - Anti-Static Coating	BMS10-21 Type III
C00862	Coating - Chemical Conversion - Bonderite M-CR 600 Aero (Formerly Alodine 600)	BAC5719 Class A, C or D, MIL-DTL-81706 Type I Class 1A or 3

**D. Location Zones**

Zone	Area
190	Subzone - Wing-to-Body Fairing
191	Lower Wing-To-Body Fairing - Forward of Wing Box
192	Lower Wing-To-Body Fairing - Under Wing Box
193	Lower Wing-To-Body Fairing - Wheel Well
194	Lower Wing-To-Body Fairing - Aft of Wheel Well
195	Above Wing, Wing-To-Body Fairing - Left

EFFECTIVITY  
LOM ALL

**53-51-01**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

**Zone      Area**

196	Above Wing, Wing-To-Body Fairing - Right
-----	--

**E. Prepare for the Electrical Resistance Check**

SUBTASK 53-51-01-200-001

- (1) Identify the fastener locations on each panel that an electrical bond is necessary:

NOTE: There are usually four fasteners per panel with electrical bonds. It is recommended to examine the panel at the corners first. Usually the locations are at or near the corners of the panel. Panel repairs can change the locations of the electrical bonds. It is necessary to examine all the fastener holes to identify locations with an electrical bond.

- (a) Examine the area around each fastener hole:

- 1) Locations that have an electrical bond have an abraded area in the panel that surrounds the fastener hole Figure 601.

SUBTASK 53-51-01-211-001

- (2) Do these steps if the electrical bond locations are not identified after the visual inspection:

- (a) Remove one fastener and one dimpled washer if installed, from the panel.

NOTE: There are usually four fasteners per panel with electrical bonds. It is recommended to examine the panel at the corners first. Usually the locations are at or near the corners of the panel. Panel repairs can change the locations of the electrical bonds. It is necessary to examine all the fastener holes to identify locations with an electrical bond.

- (b) Examine the area around the fastener hole:

- 1) Locations that have an electrical bond have an abraded area in the panel that surrounds the fastener hole Figure 601.

- (c) Examine the countersunk area of the fastener hole:

- 1) Examine the countersunk area of the panel below the dimpled washer if installed.  
2) The countersunk area for each electrically bonded fastener hole will have a coating, C00767 or Bonderite M-CR 600 Aero coating, C00862.

NOTE: Non-electrical bonding locations do not have coatings in the countersunk hole.

- (d) Examine the countersunk mating surface between the dimpled washer if installed, and the panel: Figure 601.

- 1) Make sure that the surfaces without an electrical bond between the dimpled washer and the panel are free from contamination.  
2) Make sure that the surfaces with an electrical bond between the dimpled washer and the panel are free from contamination, primer, or paint.

- (e) Re-install the fastener and dimpled washer if the location is a designated electrical bond.

- (f) Do not re-install the dimpled washer if the location is not a designated electrical bond.

- (g) Do the steps again to find all the designated bond locations.

SUBTASK 53-51-01-000-001

- (3) If installed, remove the fasteners and dimpled washers that are in a designated electrical bond location.

EFFECTIVITY  
LOM ALL

**53-51-01**



# 737-600/700/800/900 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-51-01-100-001

- (4) Make sure that the mating surface between the panel conductive surface and the dimpled washer if installed, is clean.

SUBTASK 53-51-01-100-002

- (5) Make sure that the fasteners and the area around the fastener holes are clean.

## F. Check the Electrical Resistance of the Designated Bonds

SUBTASK 53-51-01-400-001

- (1) Install one fastener, and one dimpled washer in a designated bond location in the panel.

SUBTASK 53-51-01-765-001

- (2) Put a dimpled washer only in an adjacent (empty) designated bonded fastener location.

SUBTASK 53-51-01-765-002

- (3) Put one probe of a digital/analog multimeter, COM-1793 on the installed designated bonded fastener head.

SUBTASK 53-51-01-765-003

- (4) Put the second probe on a dimpled washer in the adjacent (empty) designated bonded fastener location.

NOTE: The dimpled washer if installed, completes an electrical bond between the panel conductive surface and the probe.

SUBTASK 53-51-01-765-004

- (5) Make sure that the resistance is not more than in the Table 601.

**Table 601/53-51-01-993-801 Panel Conductive Surface Maximum Resistance**

Conductive Surface Type	Maximum Resistance (Ohm) <sup>*[1]</sup>
Anti-Static Coating	300,000
Aluminum Coated Fiber	10
Expanded Aluminum Foil <sup>*[2]</sup>	0.5
Flamespray	0.5

\*[1] Some panels will be installed with bonding jumpers. The dimension of the bonding jumper can change the maximum resistance. Refer to the installation procedure for the maximum resistance of panels with bonding jumpers (PAGEBLOCK 53-51-21/401).

\*[2] Some panels with the expanded aluminum foil surface can have different maximum resistances. Refer to the installation procedure for panels with different maximum resistances than in this table (PAGEBLOCK 53-51-21/401).

SUBTASK 53-51-01-765-005

- (6) Make sure that the dimpled washer if installed, does not move:
  - (a) Remove the probe.
  - (b) Install the fastener.

## G. Repeat the Check

SUBTASK 53-51-01-765-006

- (1) Repeat the Check of the Electrical Resistance of the Designated Bonds
  - (a) Do the check with each subsequently installed designated bond fastener as the start point until all fasteners are installed.

NOTE: It is not necessary to remove or do the resistance check again for the very first fastener installed.

EFFECTIVITY  
LOM ALL

**53-51-01**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 1) If the panel does not pass the electrical resistance test:
  - a) Do the steps again that apply the electrical coating to the panel and do the resistance test again, or replace the panel.

**H. Restore the Fairing to Normal**

SUBTASK 53-51-01-390-001

- (1) Apply finish to fairing panel:
  - (a) Apply finish to the fastener heads.
  - (b) Apply finish to areas adjacent to the fasteners on the panel if necessary.

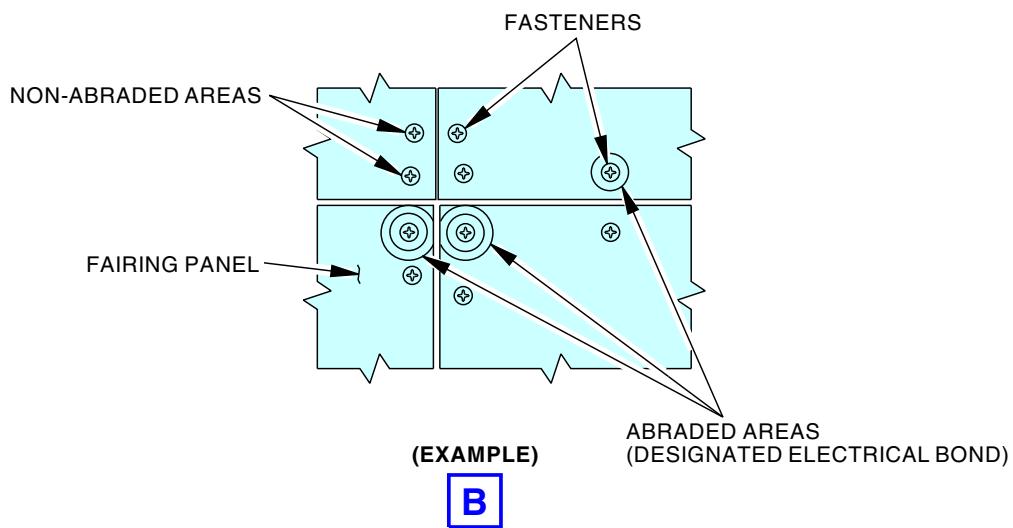
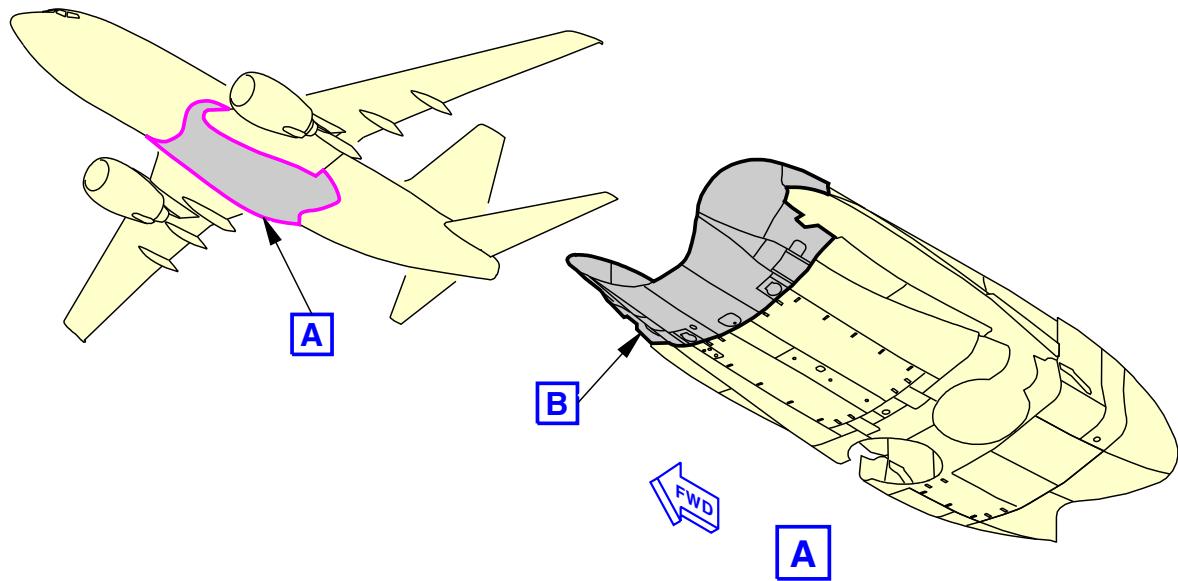
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-51-01**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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**Wing-to-Body Fairing**  
**Figure 601/53-51-01-990-801**

EFFECTIVITY	LOM ALL
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**53-51-01**

Page 605  
Oct 15/2015





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

WING-TO-BODY FAIRING BLOWOUT PANEL - REMOVAL/INSTALLATION

**1. General**

- A. This procedure contains two tasks. The first task is the removal of the blowout panel for the wing-to-body fairing. The second task is the installation of the blowout panel for the wing-to-body fairing.
- B. The blowout panels have a hinge on one side. The rivets that go through the clips on the other side hold the blowout panels closed.

**TASK 53-51-11-000-801**

**2. Blowout Panel for the Wing-to-Body Fairing Removal**

**A. Location Zones**

Zone	Area
200	Upper Half of Fuselage

**B. Procedure**

SUBTASK 53-51-11-010-001

- (1) If the panel blows out, open the underwing fairing and remove the rivets.

———— END OF TASK ————

**TASK 53-51-11-400-801**

**3. Blowout Panel for the Wing-to-Body Fairing Installation**

**A. References**

Reference	Title
51-21-81 P/B 701	ABRASION-RESISTANT TEFLON FINISH - CLEANING/PAINTING
51-31-00-390-801	Non-Removable Faying (Mated) Surface Seal Application (P/B 201)

**B. Tools/Equipment**

Reference	Description
STD-810	Spatula - Fillet Smoothing, Hardwood or Plastic

**C. Location Zones**

Zone	Area
200	Upper Half of Fuselage

**D. Procedure**

SUBTASK 53-51-11-210-001

- (1) Examine the attach clips for damage.

SUBTASK 53-51-11-140-003

- (2) Use a hardwood or plastic fillet smoothing spatula, STD-810 to clean the sealant from the mating surfaces.

SUBTASK 53-51-11-120-002

- (3) Apply an abrasion resistant finish and parting agent to the outer face of the fairing lip (ABRASION-RESISTANT TEFLON FINISH - CLEANING/PAINTING, PAGEBLOCK 51-21-81/701).

SUBTASK 53-51-11-140-004

- (4) Remove the sealant from the clearance between the blowout panel and panel cutout.

EFFECTIVITY  
LOM ALL

**53-51-11**



737-600/700/800/900  
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SUBTASK 53-51-11-390-002



**CAUTION**

BE CAREFUL WHEN YOU APPLY HAND PRESSURE TO PUT THE BLOWOUT PANEL IN THE CORRECT POSITION. TOO MUCH PRESSURE CAN CAUSE DISTORTION OF THE BLOWOUT PANEL.

- (5) Before you install the blowout panel, apply a bead of sealant to the inner face of the panel lip (Non-Removable Faying (Mated) Surface Seal Application, TASK 51-31-00-390-801).

SUBTASK 53-51-11-420-001

- (6) Install the blowout panels with one rivet, 3/32 in. (2.4 mm) diameter, in the aft outboard location and one rivet, 1/8 in. (3.2 mm) diameter, in the forward outboard location.

SUBTASK 53-51-11-860-003

- (7) After the sealant dries, open and close the blowout panel to make sure it does not bond.

SUBTASK 53-51-11-860-002

- (8) Close and latch the blowout panel.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-51-11**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

WING-TO-BODY FAIRING PANELS - REMOVAL/INSTALLATION

**1. General**

- A. This procedure has these tasks:
- (1) A removal of the Forward Wing-To-Body fairings panels
  - (2) An installation of the Forward Wing-To-Body fairings panels
  - (3) A removal of the Center Wing-To-Body fairings panels
    - (a) This includes the Wing-To-Body fairing panels above the wings
  - (4) An installation of the Center Wing-To-Body fairings panels
    - (a) This includes the Wing-To-Body fairing panels above the wings
  - (5) A removal of the Aft Wing-To-Body fairings panels
  - (6) An installation of the Aft Wing-To-Body fairings panels.

**TASK 53-51-21-000-803**

**2. Forward Wing-To-Body Fairing Panel Removal**

(Figure 401, Figure 402)

**A. References**

Reference	Title
21-51	PACK FLOW CONTROL AND PACK COOLING SYSTEM
33-44	ANTI-COLLISION LIGHTS

**B. Location Zones**

Zone	Area
191	Lower Wing-To-Body Fairing - Forward of Wing Box

**C. Access Panels**

Number	Name/Location
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper
191BL	Forward Wing To Body Fairing Panel, Ram Air Inlet
191BR	Forward Wing To Body Fairing Panel, Ram Air Inlet
191CL	Forward Wing To Body Fairing Panel - Middle
191CR	Forward Wing To Body Fairing Panel - Middle
191D	Forward Wing To Body Fairing Panel - Lower
191E	Access Door - Forward Fairing
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191GL	Ram Air Actuator Panel - Forward
191GR	Ram Air Actuator Panel - Forward
191HL	Ram Air Inlet Lip Panel - Forward
191HR	Ram Air Inlet Lip Panel - Forward

**D. Prepare for Forward Wing-To-Body Fairing Panels Removal**

SUBTASK 53-51-21-020-002

- (1) If necessary, remove or disconnect the equipment that is attached to the fairing.
  - (a) Ram Air Intake (SECTION 21-51)



**53-51-21**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

(b) Lights (SECTION 33-44).

**E. Forward Wing-To-Body Fairing Panels Removal**

SUBTASK 53-51-21-010-001

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

SUBTASK 53-51-21-020-003

- (2) Do these steps to remove the applicable fairing panels:

NOTE: Hold the fairing panel until all the fasteners have been removed.

NOTE: Identify the fasteners to install them in the same locations.

- (a) Zone 191:

- 1) Remove the fasteners for access panel [7]:

**Number      Name/Location**

191AL      Forward Wing To Body Fairing Panel - Upper

- 2) Remove the fasteners for access panel [1]:

**Number      Name/Location**

191AR      Forward Wing To Body Fairing Panel - Upper

- 3) Remove the fasteners for access panel [6]:

**Number      Name/Location**

191BL      Forward Wing To Body Fairing Panel, Ram Air Inlet

- 4) Remove the fasteners for access panel [2]:

**Number      Name/Location**

191BR      Forward Wing To Body Fairing Panel, Ram Air Inlet

- 5) Remove the fasteners for access panel [5]:

**Number      Name/Location**

191CL      Forward Wing To Body Fairing Panel - Middle

- 6) Remove the fasteners for access panel [3]:

**Number      Name/Location**

191CR      Forward Wing To Body Fairing Panel - Middle

- 7) Remove the fasteners for access panel [4]:

**Number      Name/Location**

191D      Forward Wing To Body Fairing Panel - Lower

- 8) Remove the fasteners for access panel [11]:

**Number      Name/Location**

191E      Access Door - Forward Fairing

EFFECTIVITY  
LOM ALL

**53-51-21**

Page 402  
Oct 15/2021



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



**CAUTION**

MAKE SURE THAT YOU REMOVE ALL THE FASTENERS AND THE PANEL FROM THE STRUCTURE. IF YOU DO NOT, DAMAGE TO THE PANEL AND STRUCTURE CAN OCCUR AT THE LEADING EDGE DURING THE FLAP/SLAT EXTENSION.

- 9) Remove the fasteners for access panel [9]:

**Number      Name/Location**

191FL      Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet



**CAUTION**

MAKE SURE THAT YOU REMOVE ALL THE FASTENERS AND THE PANEL FROM THE STRUCTURE. IF YOU DO NOT, DAMAGE TO THE PANEL AND STRUCTURE CAN OCCUR AT THE LEADING EDGE DURING THE FLAP/SLAT EXTENSION.

- 10) Remove the fasteners for access panel [13]:

**Number      Name/Location**

191FR      Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

- 11) Remove the fasteners for access panel [8]:

**Number      Name/Location**

191GL      Ram Air Actuator Panel - Forward

- 12) Remove the fasteners for access panel [14]:

**Number      Name/Location**

191GR      Ram Air Actuator Panel - Forward

- 13) Remove the fasteners for access panel [10]:

**Number      Name/Location**

191HL      Ram Air Inlet Lip Panel - Forward

- 14) Remove the fasteners for access panel [12]:

**Number      Name/Location**

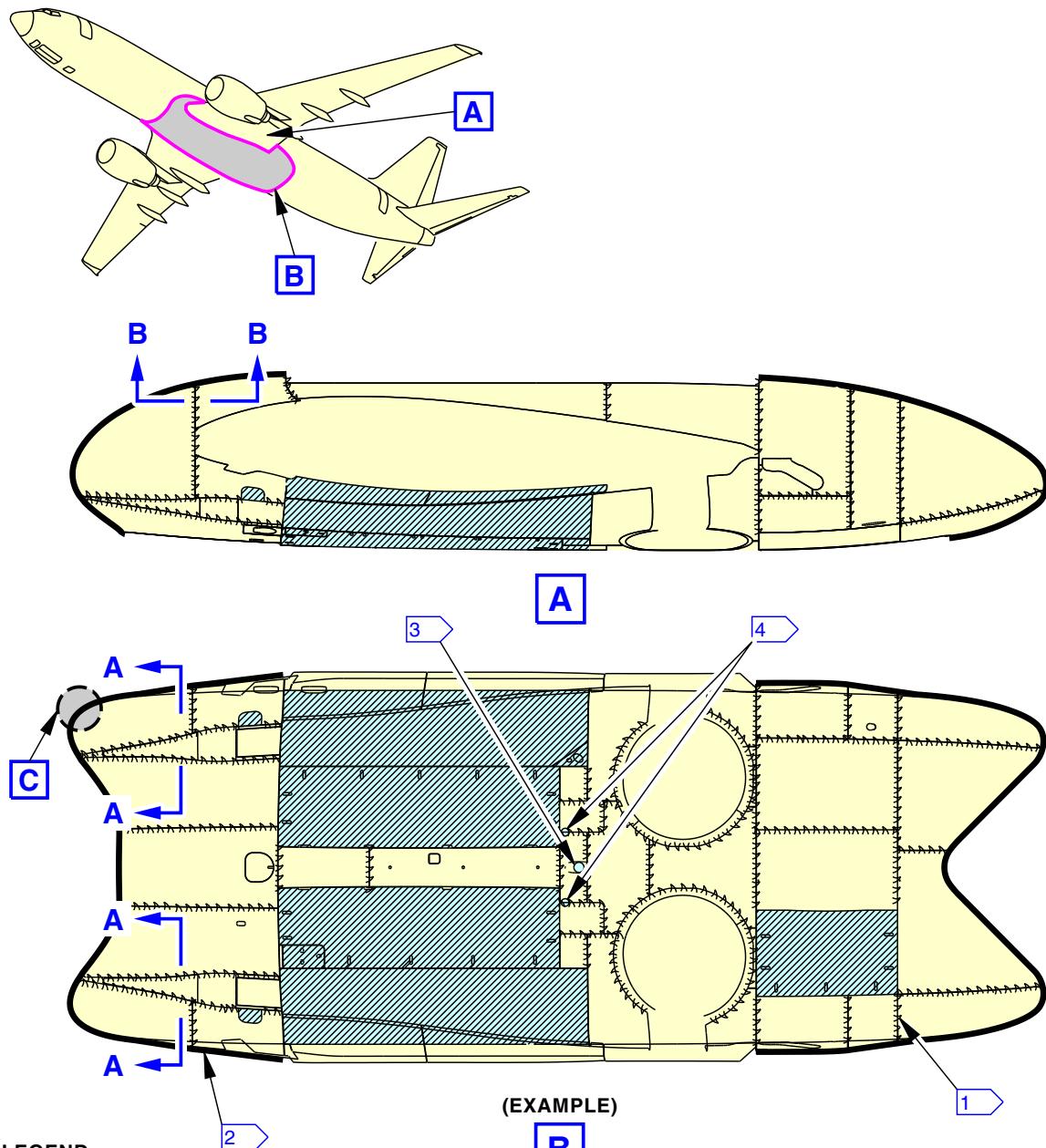
191HR      Ram Air Inlet Lip Panel - Forward

- (b) Remove the fairing panel from the airplane.

———— END OF TASK ————

EFFECTIVITY  
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**53-51-21**



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**Wing-to-Body Fairing Seal Requirements**  
**Figure 401/53-51-21-990-805 (Sheet 1 of 4)**

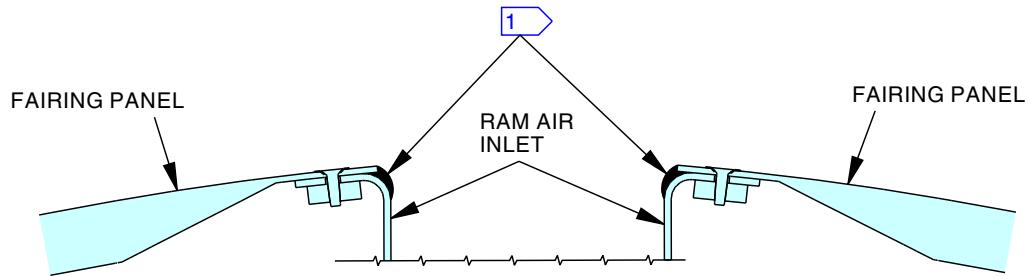
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**53-51-21**

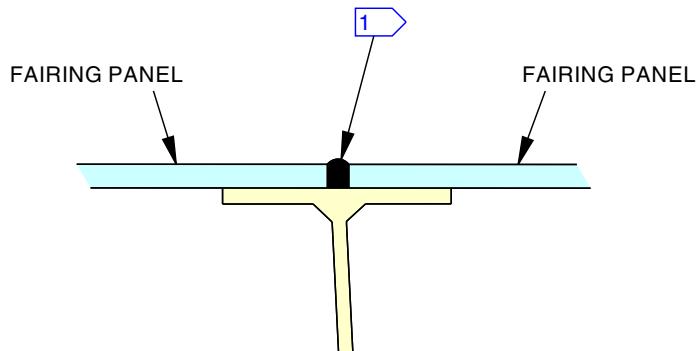
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

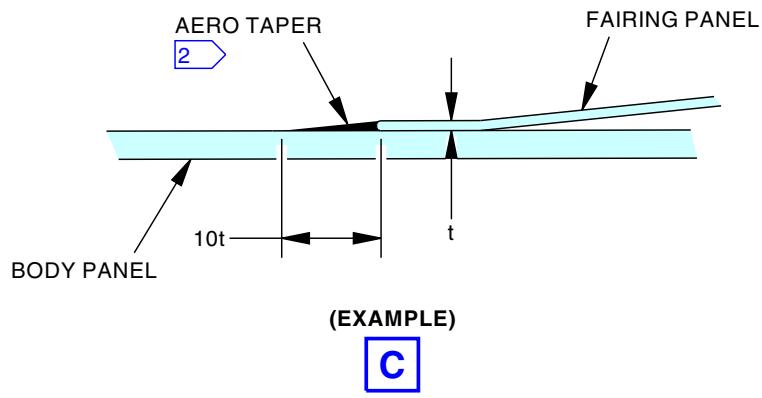
**BOEING**  
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**AIRCRAFT MAINTENANCE MANUAL**



**A-A**



(EXAMPLE)  
**B-B**



(EXAMPLE)

**C**

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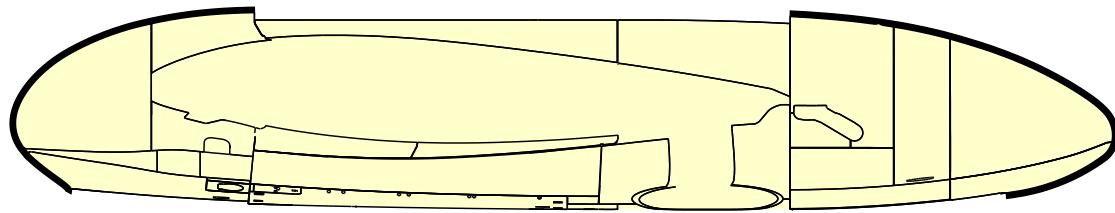
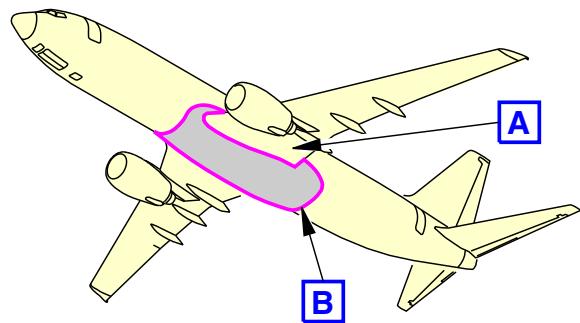
**Wing-to-Body Fairing Seal Requirements**  
**Figure 401/53-51-21-990-805 (Sheet 2 of 4)**

EFFECTIVITY  
**LOM 431-434, 437-447, 450-464**

**53-51-21**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



A

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**Wing-to-Body Fairing Seal Requirements**  
**Figure 401/53-51-21-990-805 (Sheet 3 of 4)**

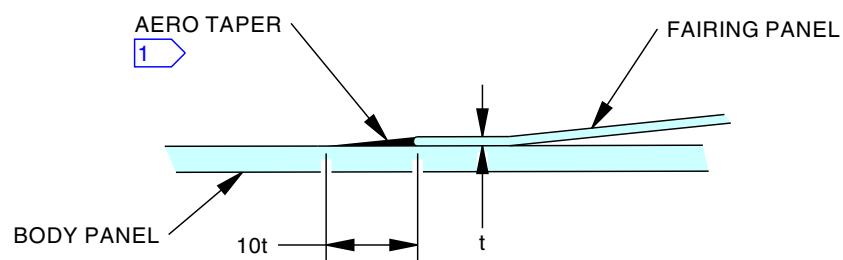
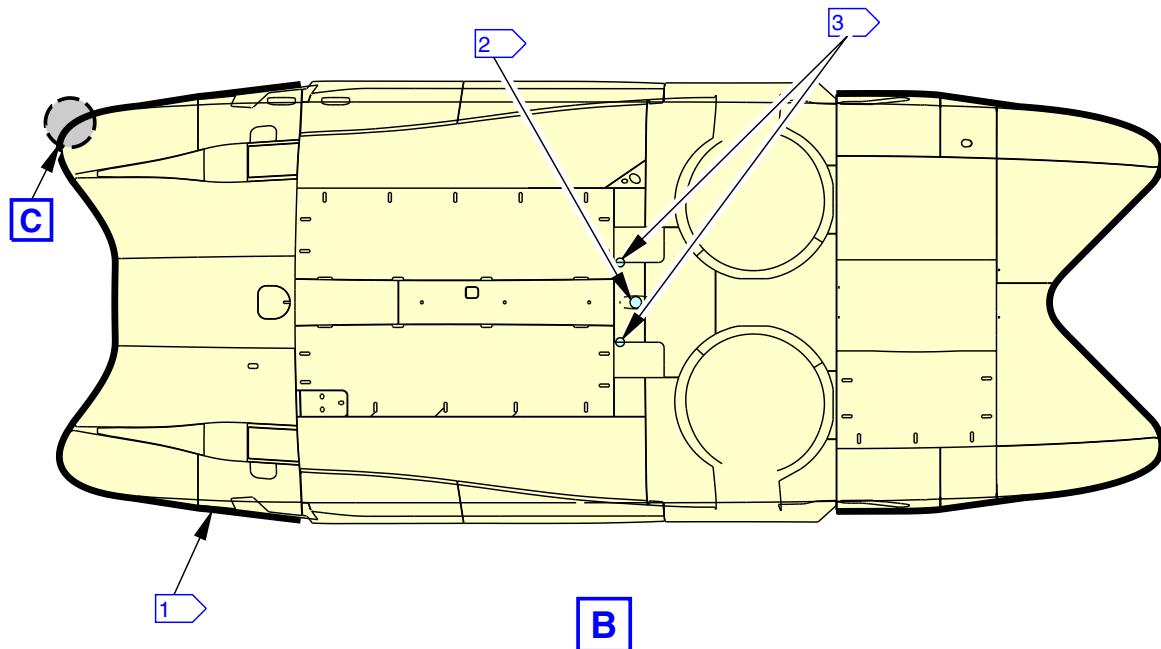
EFFECTIVITY  
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,  
422-430, 465-999

**53-51-21**

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Page 406  
Oct 15/2024



(EXAMPLE)



**NOTE:**

- 1** APPLY BMS 5-95.
- 2** NO SEAL REQUIRED UNDER LIGHT ASSEMBLY.
- 3** DO NOT APPLY SEALANT OVER THE DRAIN PATH GAP.

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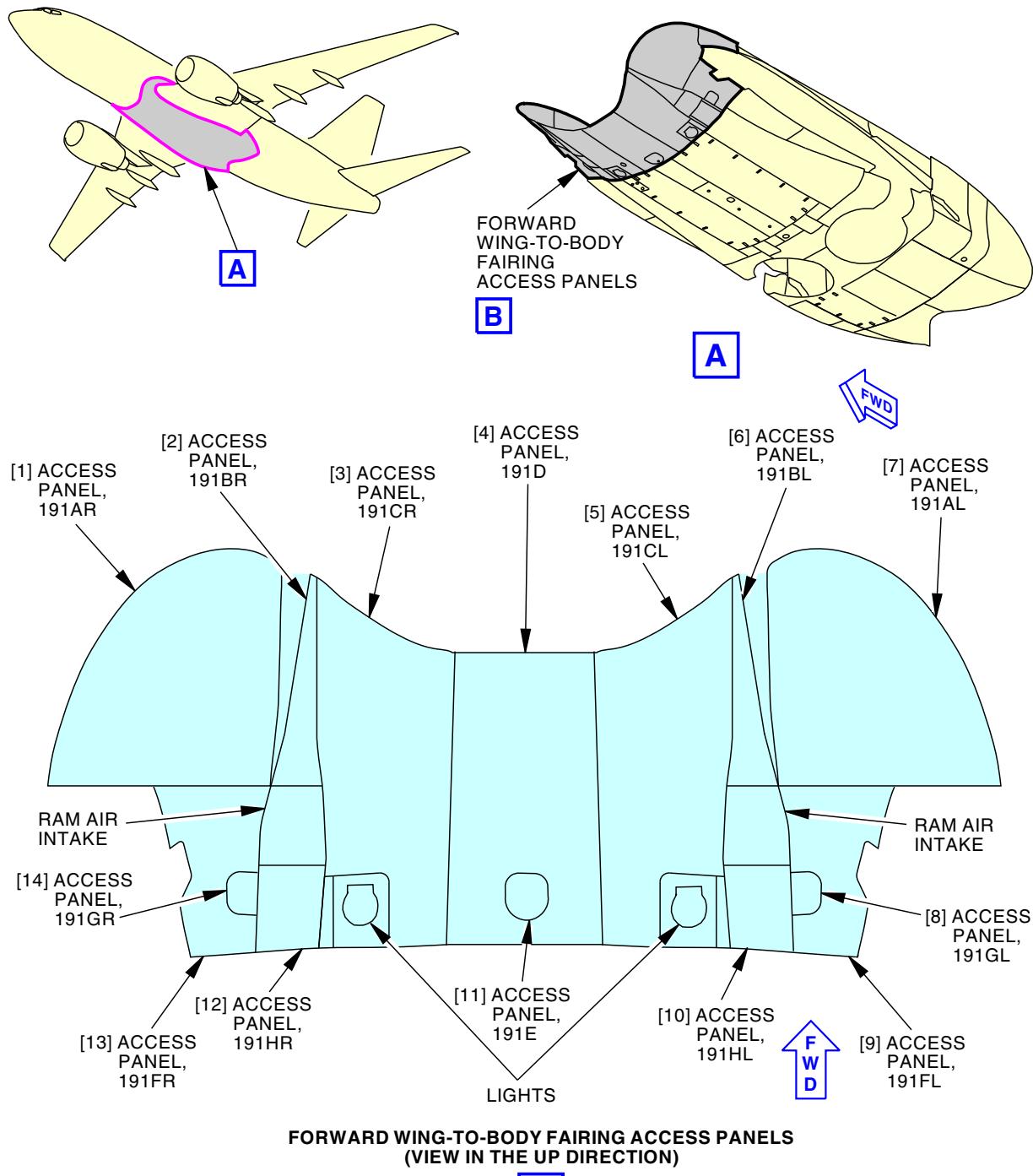
**Wing-to-Body Fairing Seal Requirements**  
**Figure 401/53-51-21-990-805 (Sheet 4 of 4)**

EFFECTIVITY  
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,  
422-430, 465-999

**53-51-21**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



FORWARD WING-TO-BODY FAIRING ACCESS PANELS  
(VIEW IN THE UP DIRECTION)

B

1644769 S0000301401\_V5

**Forward Wing-to-Body Fairing Access Panels Installation**  
**Figure 402/53-51-21-990-807**

EFFECTIVITY  
LOM ALL

**53-51-21**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-51-21-400-803**

**3. Forward Wing-To-Body Fairing Panel Installation**

(Figure 402)

**A. References**

Reference	Title
21-51	PACK FLOW CONTROL AND PACK COOLING SYSTEM
33-44	ANTI-COLLISION LIGHTS
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
51-21-81 P/B 701	ABRASION-RESISTANT TEFLON FINISH - CLEANING/PAINTING
53-51-21-211-801	Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection (P/B 601)
53-51-21-760-801	Wing-To-Body Fairing Panel Maximum Electrical Resistance Check (P/B 601)

**B. Consumable Materials**

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A50231	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class B
A50359	Sealant - Low Density, Non-Chromate Type	BMS5-142 Type II Class B
C00175	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79 Type III
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00304	Coating - Teflon Filled, Non Decorative, Sprayable Material	BMS10-86 Type I
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
C50149	Coating - Teflon Filled, Non Decorative, Brushable or Sprayable Material	BMS10-86 Type II
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

**C. Location Zones**

Zone	Area
191	Lower Wing-To-Body Fairing - Forward of Wing Box

**D. Access Panels**

Number	Name/Location
191AL	Forward Wing To Body Fairing Panel - Upper
191AR	Forward Wing To Body Fairing Panel - Upper
191BL	Forward Wing To Body Fairing Panel, Ram Air Inlet
191BR	Forward Wing To Body Fairing Panel, Ram Air Inlet
191CL	Forward Wing To Body Fairing Panel - Middle
191CR	Forward Wing To Body Fairing Panel - Middle
191D	Forward Wing To Body Fairing Panel - Lower

EFFECTIVITY  
LOM ALL

**53-51-21**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Number	Name/Location
191E	Access Door - Forward Fairing
191FL	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191GL	Ram Air Actuator Panel - Forward
191GR	Ram Air Actuator Panel - Forward
191HL	Ram Air Inlet Lip Panel - Forward
191HR	Ram Air Inlet Lip Panel - Forward

**E. Prepare for Forward Wing-To-Body Fairing Panel Installation**

SUBTASK 53-51-21-210-006

- (1) Make sure that the mating surfaces between the panel and the structure are free from contamination.

**NOTE:** Teflon is applied on the mating structure surface. The Teflon is not contamination. It is not necessary to remove the Teflon.

SUBTASK 53-51-21-160-003

- (2) Make sure that the Teflon mating structure surface is in a good condition.
  - (a) If necessary, repair the Teflon coating.
    - 1) Apply coating, C00304 or coating, C50149 (PAGEBLOCK 51-21-81/701).
    - 2) Do not get Teflon in nutplate threads.

SUBTASK 53-51-21-210-005

- (3) Make sure that the designated electrical bonds for the panel are identified.
  - (a) Refer to this task: Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection, TASK 53-51-21-211-801.

SUBTASK 53-51-21-390-010



**CAUTION**

DO NOT APPLY CORROSION-PREVENTATIVE COMPOUND TO THE BOND-BOLTS AND THEIR HOLES. THE COMPOUND PREVENTS CORRECT INSTALLATION OF THE BONDING BOLT. IF YOU DO NOT INSTALL THE BONDING BOLT CORRECTLY, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (4) Apply the corrosion preventive compound, C00308, to the flanges on the fairing that touches the structure.

SUBTASK 53-51-21-390-008

- (5) Apply the corrosion inhibiting compound, G00009, to the area on the structure and the body skin that touches the fairing.
  - (a) If necessary, refer to the STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

**F. Forward Wing-To-Body Fairing Panels Installation**

SUBTASK 53-51-21-400-007

- (1) Install the fasteners that do not have a designated electrical bond on the applicable panel.
  - (a) Apply primer, C00259, to the hole areas of all fasteners in the structure when necessary.
  - (b) Let the primer dry.
  - (c) Put the panel into its position.



**53-51-21**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 1) Install the non-designated electrical bond fasteners for this access panel [7]:

**Number**    **Name/Location**

191AL      Forward Wing To Body Fairing Panel - Upper

- 2) Install the non-designated electrical bond fasteners for this access panel [1]:

**Number**    **Name/Location**

191AR      Forward Wing To Body Fairing Panel - Upper

- 3) Install the non-designated electrical bond fasteners for this access panel [6]:

**Number**    **Name/Location**

191BL      Forward Wing To Body Fairing Panel, Ram Air Inlet

- 4) Install the non-designated electrical bond fasteners for this access panel [2]:

**Number**    **Name/Location**

191BR      Forward Wing To Body Fairing Panel, Ram Air Inlet

- 5) Install the non-designated electrical bond fasteners for this access panel [5]:

**Number**    **Name/Location**

191CL      Forward Wing To Body Fairing Panel - Middle

- 6) Install the non-designated electrical bond fasteners for this access panel [3]:

**Number**    **Name/Location**

191CR      Forward Wing To Body Fairing Panel - Middle

- 7) Install the non-designated electrical bond fasteners for this access panel [4]:

**Number**    **Name/Location**

191D      Forward Wing To Body Fairing Panel - Lower

- 8) Install the non-designated electrical bond fasteners for this access panel [11]:

**Number**    **Name/Location**

191E      Access Door - Forward Fairing

- 9) Install the non-designated electrical bond fasteners for this access panel [9]:

**Number**    **Name/Location**

191FL      Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

- 10) Install the non-designated electrical bond fasteners for this access panel [13]:

**Number**    **Name/Location**

191FR      Forward Wing To Body Fairing Panel - Mid Fairing, Above Ram Air Inlet

- 11) Install the non-designated electrical bond fasteners for this access panel [8]:

**Number**    **Name/Location**

191GL      Ram Air Actuator Panel - Forward

- 12) Install the non-designated electrical bond fasteners for this access panel [14]:

**Number**    **Name/Location**

191GR      Ram Air Actuator Panel - Forward

EFFECTIVITY  
LOM ALL

**53-51-21**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 13) Install the non-designated electrical bond fasteners for this access panel [10]:

**Number**    **Name/Location**

191HL      Ram Air Inlet Lip Panel - Forward

- 14) Install the non-designated electrical bond fasteners for this access panel [12]:

**Number**    **Name/Location**

191HR      Ram Air Inlet Lip Panel - Forward

**SUBTASK 53-51-21-400-006**

- (2) Install the bonding fasteners for the applicable panel:

- (a) Measure the maximum electrical resistance for each bonding fastener.

- 1) Refer to this task: Wing-To-Body Fairing Panel Maximum Electrical Resistance Check, TASK 53-51-21-760-801.

- a) Make sure that the resistance for each bonding fastener is not more than 300,000 ohms for these access panels:

- In Zone 191: 191AL, 191AR, 191BL, 191BR, 191FL, 191FR, 191GL, 191GR, 191HL, 191HR.

- b) Make sure that the resistance for each bonding fastener is not more than 10 ohms for these access panels:

- In Zone 191: 191CL, 191CR, 191D.

- c) Make sure that the resistance for each bonding jumper is not more than 0.5 ohms for this access panel:

- In Zone 191: 191E.

- (b) After you install the bonding fasteners, apply one layer of primer, C00175, to the bonding fasteners only.

**SUBTASK 53-51-21-220-003**

- (3) Make sure that the distance between panels is in tolerance.

- (a) Measure the misfair between the fairing panels.

- 1) If you install access panel, 191BL [6] or access panel, 191BR [2], make sure that there is no misfair between the panels and the adjacent panels.

NOTE: These panels make a recess for the Ram Air inlet.

- 2) If you install access panel, 191AL [7] or access panel, 191AR [1], make sure that the misfair for the trailing edge is between 0.07 in. (1.78 mm) and -0.03 in. (-0.76 mm).

NOTE: The trailing edge will be against panel 195AL or 195AR.

- 3) For all other access panels, make sure that the misfair is less than or equal to 0.04 in. (1.02 mm).

- 4) If necessary, install shims to the forward panels at fastener locations, no more than 0.040 in. (1.016 mm), bonded to the structure with sealant, A00247.

NOTE: Reducing the positive step will reduce erosion of the access panels.

- (b) Measure the clearance between the fairing panels.

- 1) Make sure that the clearance between the panels is 0.14 in. (3.56 mm) $\pm$ 0.060 in. (1.524 mm).

- (c) Measure the flushness between the fasteners and the fairing panels.

EFFECTIVITY  
LOM ALL

**53-51-21**



## 737-600/700/800/900 AIRCRAFT MAINTENANCE MANUAL

- 1) Make sure that the distance between the fasteners and panels is between 0.005 in. (0.127 mm) and -0.010 in. (-0.254 mm).

SUBTASK 53-51-21-390-007

- (4) Apply sealant to make an aerodynamic seal as follows (Figure 401):

NOTE: This makes an aerodynamic and weather seal.

- (a) Apply sealant, A00247 or sealant, A50231 where the panels touch the airplane skin.

### LOM 431-434, 437-447, 450-464

- (b) Apply sealant, A50359 between the panels.

NOTE: Application of this sealant is optional.

### LOM ALL

- (c) Do not apply sealant on the access doors.

## G. Put the Airplane in Its Usual Condition

SUBTASK 53-51-21-410-005

- (1) Connect or install the equipment to the fairing.

SUBTASK 53-51-21-410-003

- (2) Do an operational test for the disconnected or removed equipment.
  - (a) Ram Air Intake (SECTION 21-51)
  - (b) Lights (SECTION 33-44).

————— END OF TASK ————

## TASK 53-51-21-000-802

### 4. Center Wing-To-Body Fairing Panel Removal

(Figure 403)

#### A. References

Reference	Title
33-44-02-960-802	Lower Anti-Collision Light - Light Assembly Replacement (P/B 201)
34-32-11 P/B 401	MARKER BEACON ANTENNA - REMOVAL/INSTALLATION
34-55-11 P/B 401	DME ANTENNA - REMOVAL/INSTALLATION
52-48-42-000-801	Environmental Control Systems (ECS) Access Doors - Removal (P/B 401)
SRM 51-40-02	Structural Repair Manual

#### B. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box
193	Lower Wing-To-Body Fairing - Wheel Well
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

#### C. Access Panels

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
192AR	Underwing Bolt Cover - Forward

EFFECTIVITY  
LOM ALL

**53-51-21**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Number	Name/Location
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
192G	Sump Drain Access Door
192HL	Underwing Bolt Cover - Aft
192HR	Underwing Bolt Cover - Aft
192JL	Air Conditioning Panel - Aft
192JR	Air Conditioning Panel - Aft
192K	Air Conditioning Under Keel Panel - Aft
193AL	Wheel Well Panel - Forward Outboard
193AR	Wheel Well Panel - Forward Outboard
193B	Wheel Well Panel - Forward Inboard
193CL	Wheel Well Panel - Aft Outboard
193CR	Wheel Well Panel - Aft Outboard
193D	Wheel Well Panel - Aft Inboard
193EL	Access Panel - Aft Wheel Well
193ER	Access Panel - Aft Wheel Well
195AL	Wing To Body Fairing - Left Side
195AR	Wing To Body Fairing - Right Side
195BL	Wing To Body Fairing - Left Side
195BR	Wing To Body Fairing - Right Side
195CL	Wing To Body Fairing - Left Side
195CR	Wing To Body Fairings - Right Side

**D. Prepare for Center Wing-To-Body Fairing Panels Removal**

SUBTASK 53-51-21-020-004

- (1) Remove or disconnect the equipment that is attached to the fairing.  
**NOTE:** This should be done before the removal of the screws on the center wing-to-body fairing panel.
  - (a) Distance Measuring Equipment (DME) Antennas (PAGEBLOCK 34-55-11/401).
  - (b) Marker Beacon (MB) Antenna (PAGEBLOCK 34-32-11/401).
  - (c) Remove the wheel well service interphone jacks.
    - 1) Remove the lockwasher and nut that attach the service interphone jack to the access panel.

**E. Center Wing-To-Body Fairing Panels Removal**

SUBTASK 53-51-21-010-002

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

SUBTASK 53-51-21-020-005

- (2) If you remove access panel, 192CL [46], or access panel, 192CR [44], do this task:  
Environmental Control Systems (ECS) Access Doors - Removal, TASK 52-48-42-000-801.





**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**LOM ALL; AIRPLANES WITHOUT AERODYNAMIC SHAPED LIGHT**

SUBTASK 53-51-21-020-011

- (3) If you remove the access panel, 192K [36], remove the lower anti-collision light assembly (TASK 33-44-02-960-802).

**LOM ALL; AIRPLANES WITH AERODYNAMIC SHAPED LIGHT**

SUBTASK 53-51-21-020-012

- (4) If you remove the access panel, 192K [36], or access panel, 193B [34], remove the lower anti-collision light assembly (TASK 33-44-02-960-802).

**LOM ALL**

SUBTASK 53-51-21-020-006

- (5) Do these steps to remove the applicable fairing panels:

NOTE: Hold the fairing panel until all the fasteners have been removed.

NOTE: Identify the fasteners to install them in the same locations.

- (a) Zone 192:

- 1) Remove the fasteners for this access panel [27]:

**Number      Name/Location**

192AL      Underwing Bolt Cover - Forward

- 2) Remove the fasteners for this access panel [41]:

**Number      Name/Location**

192AR      Underwing Bolt Cover - Forward

- 3) Remove the fasteners for this access panel [30]:

**Number      Name/Location**

192BL      ECS Ram Air Inlet Mixing Duct Panel - Forward

- 4) Remove the fasteners for this access panel [42]:

**Number      Name/Location**

192BR      ECS Ram Air Inlet Mixing Duct Panel - Forward

- 5) Remove the fasteners for this access panel [45]:

**Number      Name/Location**

192E      ECS Under Keel Panel - Forward

- 6) Remove the fasteners for this access panel [28]:

**Number      Name/Location**

192F      ECS Under Keel Panel - Middle

- 7) Remove the fasteners for this access panel [26]:

**Number      Name/Location**

192G      Sump Drain Access Door

- 8) Remove the fasteners for this access panel [29]:

**Number      Name/Location**

192HL      Underwing Bolt Cover - Aft

EFFECTIVITY  
LOM ALL

**53-51-21**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 9) Remove the fasteners for this access panel [40]:

**Number**    **Name/Location**

192HR      Underwing Bolt Cover - Aft

- 10) Remove the fasteners for this access panel [33]:

**Number**    **Name/Location**

192JL      Air Conditioning Panel - Aft

- 11) Remove the fasteners for this access panel [39]:

**Number**    **Name/Location**

192JR      Air Conditioning Panel - Aft

- 12) Remove the fasteners for this access panel [36]:

**Number**    **Name/Location**

192K      Air Conditioning Under Keel Panel - Aft

- (b) Zone 193:

- 1) Remove the fasteners for this access panel [31]:

**Number**    **Name/Location**

193AL      Wheel Well Panel - Forward Outboard

- 2) Remove the fasteners for this access panel [38]:

**Number**    **Name/Location**

193AR      Wheel Well Panel - Forward Outboard

- 3) Remove the fasteners for this access panel [34]:

**Number**    **Name/Location**

193B      Wheel Well Panel - Forward Inboard

- 4) Remove the fasteners for this access panel [32]:

**Number**    **Name/Location**

193CL      Wheel Well Panel - Aft Outboard

- 5) Remove the fasteners for this access panel [37]:

**Number**    **Name/Location**

193CR      Wheel Well Panel - Aft Outboard

- 6) Remove the fasteners for this access panel [35]:

**Number**    **Name/Location**

193D      Wheel Well Panel - Aft Inboard

- 7) Open access panel, 193EL [47], do these steps (View A-A, Figure 403):

- a) Remove the rivets [67] (SRM 51-40-02).

- b) Remove the bolts [68], washers [69], bonding bolts [70], bolts [71], washers [72], and nuts [73].

- c) Open this access panel:

**Number**    **Name/Location**

193EL      Access Panel - Aft Wheel Well

- 8) Open access panel, 193ER [48], do these steps (View A-A, Figure 403):

- a) Remove the rivets [67] (SRM 51-40-02).

EFFECTIVITY  
LOM ALL

**53-51-21**

Page 416  
Oct 15/2022



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- b) Remove the bolts [68], washers [69], bonding bolts [70], bolts [71], washers [72], and nuts [73].

- c) Open this access panel:

<b><u>Number</u></b>	<b><u>Name/Location</u></b>
193ER	Access Panel - Aft Wheel Well

- (c) Zone 195:

- 1) Remove the fasteners for this access panel [20]:

<b><u>Number</u></b>	<b><u>Name/Location</u></b>
195AL	Wing To Body Fairing - Left Side

- 2) Remove the fasteners for this access panel [21]:

<b><u>Number</u></b>	<b><u>Name/Location</u></b>
195BL	Wing To Body Fairing - Left Side

- 3) Remove the fasteners for this access panel [22]:

<b><u>Number</u></b>	<b><u>Name/Location</u></b>
195CL	Wing To Body Fairing - Left Side

- (d) Zone 196:

- 1) Remove the fasteners for this access panel [23]:

<b><u>Number</u></b>	<b><u>Name/Location</u></b>
195AR	Wing To Body Fairing - Right Side

- 2) Remove the fasteners for this access panel [24]:

<b><u>Number</u></b>	<b><u>Name/Location</u></b>
195BR	Wing To Body Fairing - Right Side

- 3) Remove the fasteners for this access panel [25]:

<b><u>Number</u></b>	<b><u>Name/Location</u></b>
195CR	Wing To Body Fairings - Right Side

- (e) Remove the fairing panel from the airplane.

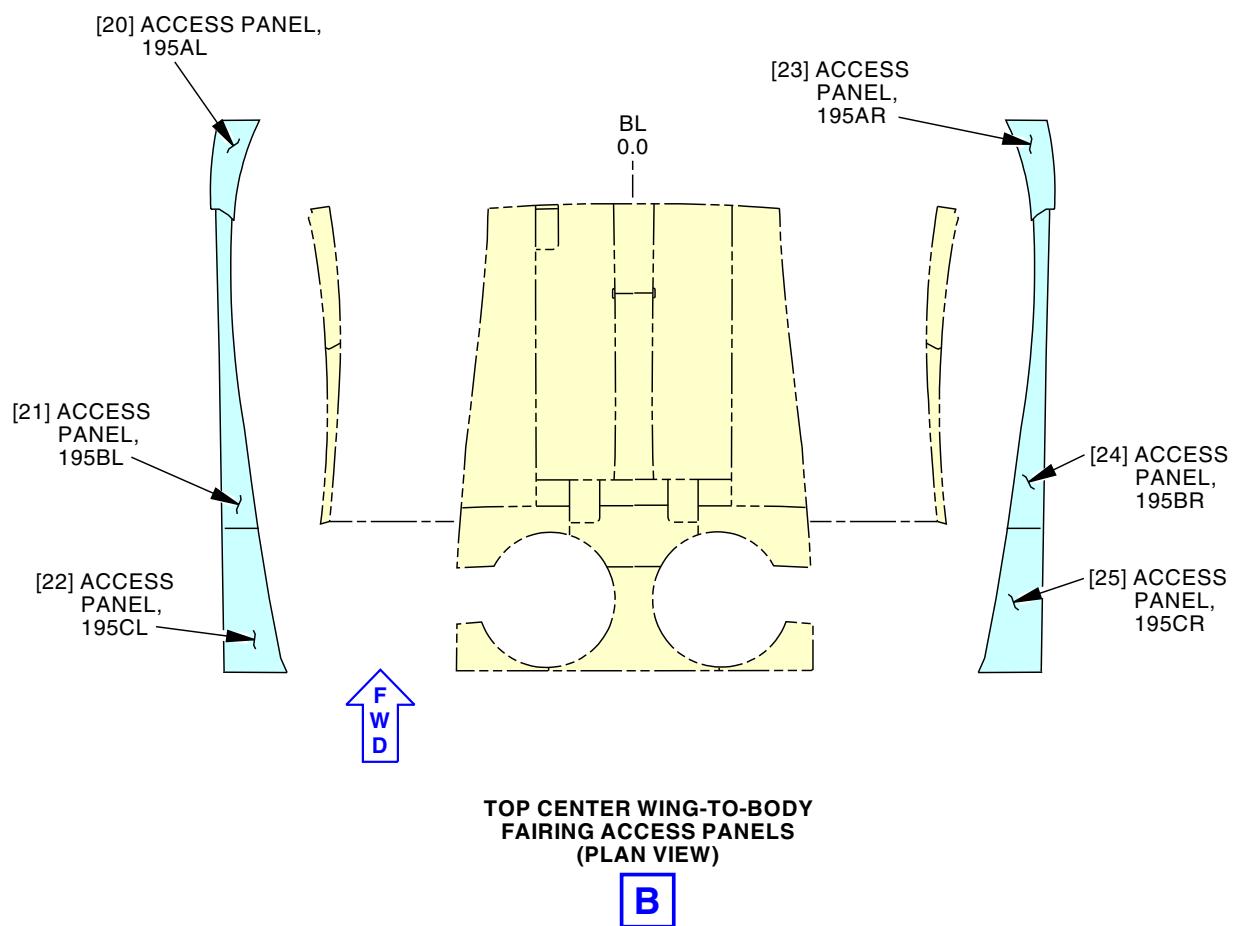
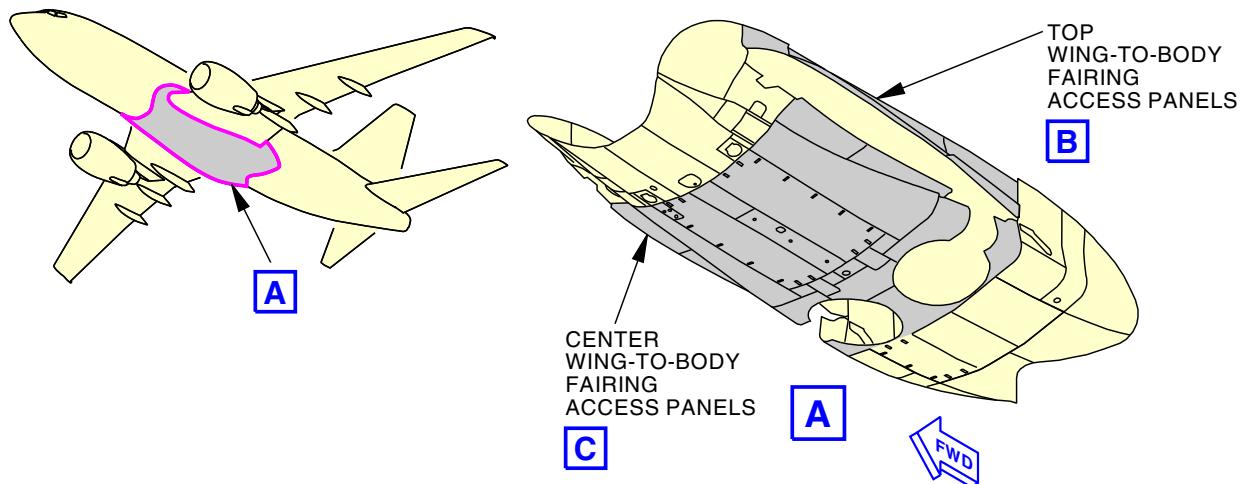
———— END OF TASK ————

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**53-51-21**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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**Center Wing-To-Body Fairing Panels Installation**  
**Figure 403/53-51-21-990-808 (Sheet 1 of 3)**

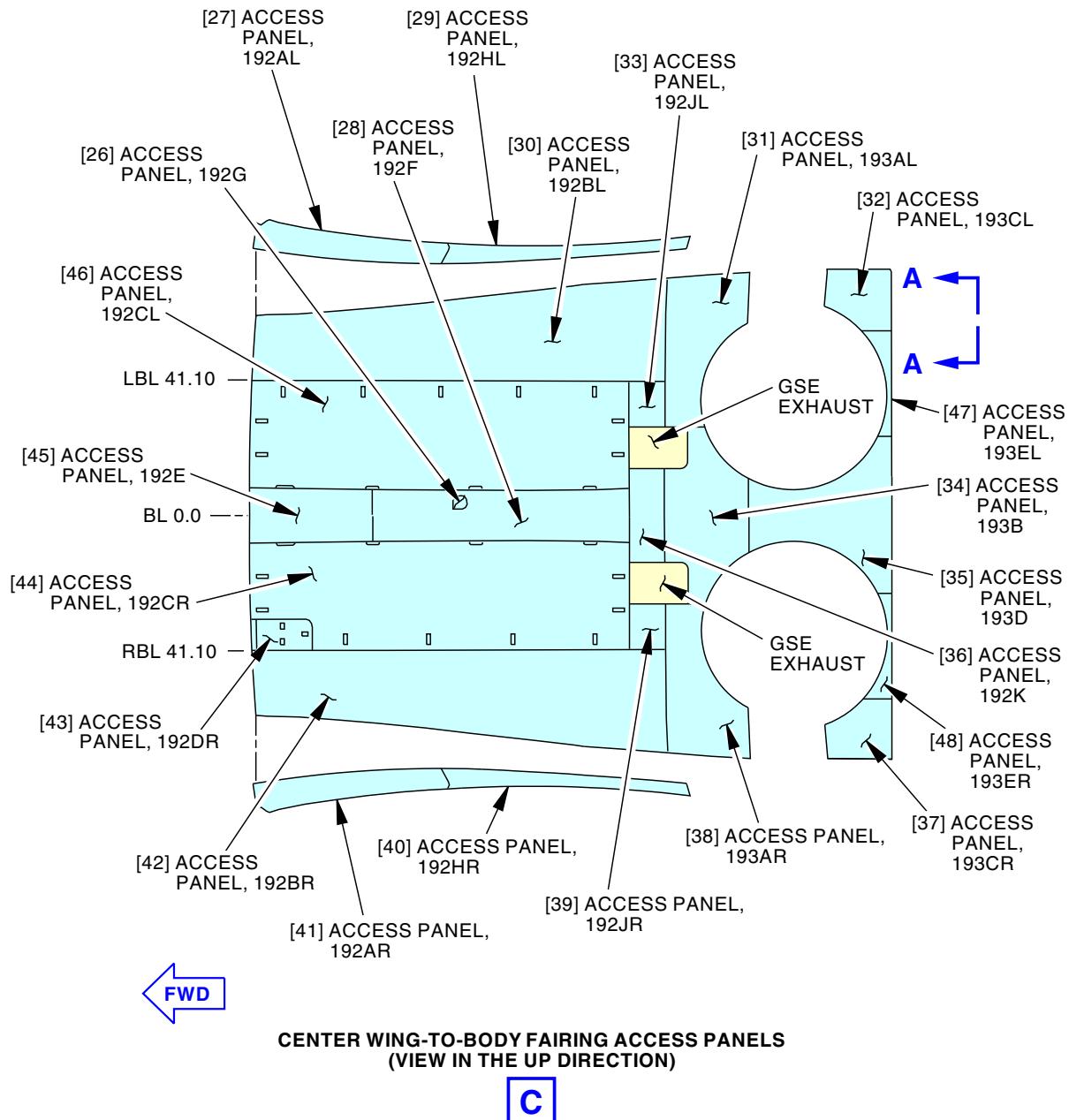
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-51-21**

Page 418  
Jun 15/2023



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**Center Wing-To-Body Fairing Panels Installation**  
**Figure 403/53-51-21-990-808 (Sheet 2 of 3)**

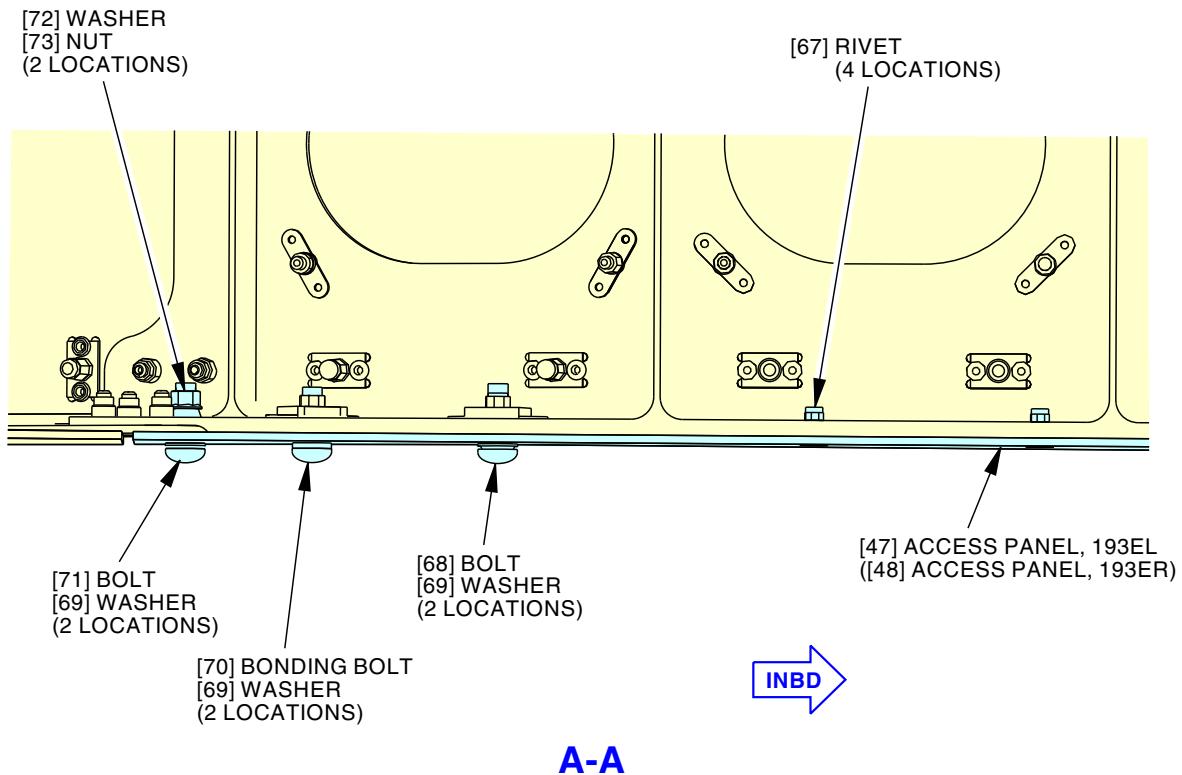
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 LOM ALL

**53-51-21**

D633A101-LOM



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Center Wing-To-Body Fairing Panels Installation  
Figure 403/53-51-21-990-808 (Sheet 3 of 3)

EFFECTIVITY  
LOM ALL

**53-51-21**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-51-21-400-802**

**5. Center Wing-To-Body Fairing Panel Installation**

(Figure 403)

**A. General**

- (1) This task includes the steps to install access panels.

**B. References**

Reference	Title
33-44-02-960-802	Lower Anti-Collision Light - Light Assembly Replacement (P/B 201)
34-32-11 P/B 401	MARKER BEACON ANTENNA - REMOVAL/INSTALLATION
34-55-11 P/B 401	DME ANTENNA - REMOVAL/INSTALLATION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
51-21-81 P/B 701	ABRASION-RESISTANT TEFLON FINISH - CLEANING/PAINTING
52-48-42-400-801	Environmental Control Systems (ECS) Access Door - Installation (P/B 401)
53-51-21-211-801	Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection (P/B 601)
53-51-21-760-801	Wing-To-Body Fairing Panel Maximum Electrical Resistance Check (P/B 601)
SRM 51-40-02	Structural Repair Manual

**C. Tools/Equipment**

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

Reference	Description
COM-1793	Multimeter - Digital/Analog (or equivalent meter meets task requirements) Part #: 117 Supplier: 89536 Part #: 260-8XPI Supplier: 55026 Part #: 287 Supplier: 89536 Part #: 289 Supplier: 89536 Part #: 87V Supplier: 89536 Part #: FLUKE 27 II Supplier: 89536 Part #: FLUKE-77-4 Supplier: 89536 Opt Part #: 187 Supplier: 89536 Opt Part #: 189 Supplier: 89536 Opt Part #: 21 Supplier: 89536 Opt Part #: 27 Supplier: 89536 Opt Part #: 77 SERIES III Supplier: 89536 Opt Part #: 87 Supplier: 89536 Opt Part #: FLUKE 27 Supplier: 89536 Opt Part #: MODEL 27 Supplier: 89536

**D. Consumable Materials**

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

EFFECTIVITY  
LOM ALL

**53-51-21**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

(Continued)

<b>Reference</b>	<b>Description</b>	<b>Specification</b>
A50231	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class B
A50359	Sealant - Low Density, Non-Chromate Type	BMS5-142 Type II Class B
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00304	Coating - Teflon Filled, Non Decorative, Sprayable Material	BMS10-86 Type I
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
C00767	Coating - Anti-Static Coating	BMS10-21 Type III
C50149	Coating - Teflon Filled, Non Decorative, Brushable or Sprayable Material	BMS10-86 Type II
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38

**E. Location Zones**

<b>Zone</b>	<b>Area</b>
192	Lower Wing-To-Body Fairing - Under Wing Box
193	Lower Wing-To-Body Fairing - Wheel Well
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

**F. Access Panels**

<b>Number</b>	<b>Name/Location</b>
192AL	Underwing Bolt Cover - Forward
192AR	Underwing Bolt Cover - Forward
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
192G	Sump Drain Access Door
192HL	Underwing Bolt Cover - Aft
192HR	Underwing Bolt Cover - Aft
192JL	Air Conditioning Panel - Aft
192JR	Air Conditioning Panel - Aft
192K	Air Conditioning Under Keel Panel - Aft
193AL	Wheel Well Panel - Forward Outboard
193AR	Wheel Well Panel - Forward Outboard
193B	Wheel Well Panel - Forward Inboard
193CL	Wheel Well Panel - Aft Outboard
193CR	Wheel Well Panel - Aft Outboard
193D	Wheel Well Panel - Aft Inboard
193EL	Access Panel - Aft Wheel Well

EFFECTIVITY LOM ALL
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**53-51-21**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Number	Name/Location
193ER	Access Panel - Aft Wheel Well
195AL	Wing To Body Fairing - Left Side
195AR	Wing To Body Fairing - Right Side
195BL	Wing To Body Fairing - Left Side
195BR	Wing To Body Fairing - Right Side
195CL	Wing To Body Fairing - Left Side
195CR	Wing To Body Fairings - Right Side

## G. Prepare for the Center Wing-To-Body Fairing Panel Installation

SUBTASK 53-51-21-210-003

- (1) Make sure that the mating surfaces between the panel and the structure are free from contamination.

NOTE: Teflon is applied in the mating structure surface. The Teflon is not contamination. It is not necessary to remove the Teflon.

SUBTASK 53-51-21-160-002

- (2) Make sure that the Teflon mating structure surface is in a good condition.
  - (a) If it is necessary, repair the Teflon coating.
    - 1) Apply coating, C00304 or coating, C50149 (PAGEBLOCK 51-21-81/701).
    - 2) Do not get Teflon in nutplate threads.

SUBTASK 53-51-21-210-004



**CAUTION** DO NOT APPLY CORROSION-PREVENTATIVE COMPOUND TO THE BOND-BOLTS AND THEIR HOLES. THE COMPOUND PREVENTS CORRECT INSTALLATION OF THE BONDING BOLT. IF YOU DO NOT INSTALL THE BONDING BOLT CORRECTLY, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (4) Apply corrosion preventive compound, C00308, to the flanges on the fairing that touches the structure.

SUBTASK 53-51-21-390-004

- (5) Apply corrosion inhibiting compound, G00009, to the area on the structure and the body skin that touches the fairing (SUBJECT 51-00-59).

## H. Center Wing-To-Body Fairing Panels Installation

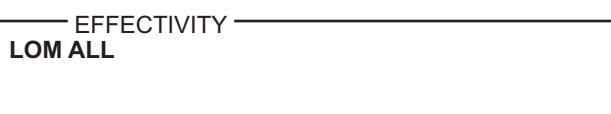
SUBTASK 53-51-21-400-003

- (1) If you install access panels 192CL, 192CR, or 192DR, do this task: Environmental Control Systems (ECS) Access Door - Installation, TASK 52-48-42-400-801.

SUBTASK 53-51-21-400-004

- (2) Install the fasteners that do not have a designated electrical bond on the applicable panel.
  - (a) If it is necessary, apply primer, C00259, to the hole areas of all fasteners in the structure.

NOTE: Do not apply primer on fastener holes with designated electrical bonding.
  - (b) Let the primer dry.



**53-51-21**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (c) Apply corrosion inhibiting material, G50136, to all areas of the holes and immediately install the bolts.
- (d) Put the applicable panel into its position.
  - 1) Zone 192:
    - a) Install the non-designated electrical bond fasteners for this access panel [27]:

<u>Number</u>	<u>Name/Location</u>
192AL	Underwing Bolt Cover - Forward
    - b) Install the non-designated electrical bond fasteners for this access panel [41]:

<u>Number</u>	<u>Name/Location</u>
192AR	Underwing Bolt Cover - Forward
    - c) Install the non-designated electrical bond fasteners for this access panel [30]:

<u>Number</u>	<u>Name/Location</u>
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
    - d) Install the non-designated electrical bond fasteners for this access panel [42]:

<u>Number</u>	<u>Name/Location</u>
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
    - e) Install the non-designated electrical bond fasteners for this access panel [45]:

<u>Number</u>	<u>Name/Location</u>
192E	ECS Under Keel Panel - Forward
    - f) Install the non-designated electrical bond fasteners for this access panel [28]:

<u>Number</u>	<u>Name/Location</u>
192F	ECS Under Keel Panel - Middle
    - g) Install the non-designated electrical bond fasteners for this access panel [26]:

<u>Number</u>	<u>Name/Location</u>
192G	Sump Drain Access Door
    - h) Install the non-designated electrical bond fasteners for this access panel [29]:

<u>Number</u>	<u>Name/Location</u>
192HL	Underwing Bolt Cover - Aft
    - i) Install the non-designated electrical bond fasteners for this access panel [40]:

<u>Number</u>	<u>Name/Location</u>
192HR	Underwing Bolt Cover - Aft
    - j) Install the non-designated electrical bond fasteners for this access panel [33]:

<u>Number</u>	<u>Name/Location</u>
192JL	Air Conditioning Panel - Aft
    - k) Install the non-designated electrical bond fasteners for this access panel [39]:

<u>Number</u>	<u>Name/Location</u>
192JR	Air Conditioning Panel - Aft
    - l) Install the non-designated electrical bond fasteners for this access panel [36]:

<u>Number</u>	<u>Name/Location</u>
192K	Air Conditioning Under Keel Panel - Aft

EFFECTIVITY  
LOM ALL

**53-51-21**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

2) Zone 193:

- a) Install the non-designated electrical bond fasteners for this access panel [31]:

**Number**    **Name/Location**

193AL      Wheel Well Panel - Forward Outboard

- b) Install the non-designated electrical bond fasteners for this access panel [38]:

**Number**    **Name/Location**

193AR      Wheel Well Panel - Forward Outboard

- c) Install the non-designated electrical bond fasteners for this access panel [34]:

**Number**    **Name/Location**

193B      Wheel Well Panel - Forward Inboard

- d) Install the non-designated electrical bond fasteners for this access panel [32]:

**Number**    **Name/Location**

193CL      Wheel Well Panel - Aft Outboard

- e) Install the non-designated electrical bond fasteners for this access panel [37]:

**Number**    **Name/Location**

193CR      Wheel Well Panel - Aft Outboard

- f) Install the non-designated electrical bond fasteners for this access panel [35]:

**Number**    **Name/Location**

193D      Wheel Well Panel - Aft Inboard

- g) Close access panel, 193EL [47], do these steps (View A-A, Figure 403):

<1> Install the bolts [68], washers [69], bolts [71], washers [72], and nuts [73].

<2> Close this access panel:

**Number**    **Name/Location**

193EL      Access Panel - Aft Wheel Well

- h) Close access panel, 193ER [48], do these steps (View A-A, Figure 403):

<1> Install the bolts [68], washers [69], bolts [71], washers [72], and nuts [73].

<2> Close this access panel:

**Number**    **Name/Location**

193ER      Access Panel - Aft Wheel Well

3) Zone 195:

- a) Install the non-designated electrical bond fasteners for this access panel [20]:

**Number**    **Name/Location**

195AL      Wing To Body Fairing - Left Side

- b) Install the non-designated electrical bond fasteners for this access panel [21]:

**Number**    **Name/Location**

195BL      Wing To Body Fairing - Left Side

EFFECTIVITY  
LOM ALL

**53-51-21**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- c) Install the non-designated electrical bond fasteners for this access panel [22]:

**Number      Name/Location**

195CL      Wing To Body Fairing - Left Side

- 4) Zone 196:

- a) Install the non-designated electrical bond fasteners for this access panel [23]:

**Number      Name/Location**

195AR      Wing To Body Fairing - Right Side

- b) Install the non-designated electrical bond fasteners for this access panel [24]:

**Number      Name/Location**

195BR      Wing To Body Fairing - Right Side

- c) Install the non-designated electrical bond fasteners for this access panel [25]:

**Number      Name/Location**

195CR      Wing To Body Fairings - Right Side

SUBTASK 53-51-21-400-005

- (3) Install the bonding bolts to the designated bonding fastener holes.

- (a) Apply anti-static coating, C00767, in the designated bonding fastener holes.

- (b) For the access panel, 193EL [47], and access panel, 193ER [48]:

- 1) Install the bonding bolts [70] and washers [69].

- (c) Measure the maximum electrical resistance for each bonding fastener, do this task:  
Wing-To-Body Fairing Panel Maximum Electrical Resistance Check,  
TASK 53-51-21-760-801.

- 1) Make sure that the maximum resistance for each bonding fastener is not more than  
300,000 ohms for these access panels:

- In Zone 192: 192AL, 192AR, 192HL, 192HR
- In Zone 193: 193AR, 193B, 193CL, 193CR, 193D
- In Zone 195: 195AL, 195BL, 195CL
- In Zone 196: 195AR, 195BR, 195CR.

- 2) Make sure that the maximum resistance for each bonding jumper is not more than  
100 ohms for these access panels:

- In Zone 192: 192CL, 192CR.

- 3) Make sure that the maximum resistance for each bonding fastener is not more than  
10 ohms for these access panels:

- In Zone 193: 193AL.

- 4) Make sure that the maximum resistance for each bonding fastener is not more than  
0.5 ohms for these access panels:

- In Zone 192: 192BL, 192BR, 192E, 192F, 192JL, 192JR, 192K.

- 5) Make sure that the maximum resistance for each bonding fastener is not more than  
0.001 ohms for this access panel:

- In Zone 192: 192G.

EFFECTIVITY  
LOM ALL

**53-51-21**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-51-21-760-001

- (4) Measure the electrical bonding resistance for each bonding bolt [70] and washer [69] at the next hole locating on the fairing panel with a digital/analog multimeter, COM-1793, (TASK 53-51-21-760-801).
  - (a) Make sure that the bonding resistance for each bonding bolt [70] is 300,000 ohms or less for these access panels:
    - In Zone 193: 193EL, 193ER.

SUBTASK 53-51-21-420-001

- (5) Install the rivets [67] for the access panel, 193EL [47] and access panel, 193ER [48] (SRM 51-40-02).

SUBTASK 53-51-21-220-002

- (6) Make sure that the distance between panels is in tolerance.
  - (a) Measure the misfair between the fairing panels.
    - 1) If you install access panels 192CL or 192CR, make sure that the misfair is less than 0.010 in. (0.254 mm).
    - 2) If you install access panel 192DR, make sure that there the misfair is  $0.00 \pm 0.06$  in. ( $0.000 \pm 1.524$  mm).
    - 3) If you install access panels 193AL (193AR) or 192BL (192BR), make sure that the misfair between these panels is  $0.0505 +0.0400 / -0.0900$  in. (1.283 +1.016 / -2.286 mm).
    - 4) If you install access panels 193AL (193AR) or 192JL (192JR), make sure that the misfair between these panels is  $0.000 \pm 0.060$  in. ( $0.00 \pm 1.52$  mm).
    - 5) If you install access panels 195AL or 195AR, make sure that the misfair for the leading edge is between 0.07 in. (1.78 mm) and -0.03 in. (-0.76 mm).  
NOTE: The leading edge will be against panel 191AL or 191AR.
    - 6) For all other access panels, make sure that the misfair is less than or equal to 0.04 in. (1.02 mm).
    - 7) If it is necessary, install shims to the forward panels at fastener locations, no more than 0.040 in. (1.016 mm), bonded to the structure with sealant, A00247.  
NOTE: Reducing the positive step will reduce erosion of the access panels.
  - (b) Measure the clearance between the fairing panels.
    - 1) Make sure that the clearance between the panels is  $0.14$  in. ( $3.56$  mm) $\pm 0.060$  in. (1.524 mm).
    - 2) If you install access panels 192CL or 192CR, make sure that the clearance between the two sides of each hinge is less than 0.088 in. (2.235 mm).
    - 3) If you install access panel 192DR, make sure that the clearance is less than 0.10 in. (2.54 mm).
  - (c) Measure the flushness between the fasteners and the fairing panels.
    - 1) Make sure that the distance between the fasteners and panels is between 0.005 in. (0.127 mm) and -0.010 in. (-0.254 mm).

**LOM ALL; AIRPLANES WITHOUT AERODYNAMIC SHAPED LIGHT**

SUBTASK 53-51-21-420-004

- (7) If you install the access panel, 192K [36], install the lower anti-collision light assembly (TASK 33-44-02-960-802).

EFFECTIVITY  
LOM ALL

**53-51-21**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**LOM ALL; AIRPLANES WITH AERODYNAMIC SHAPED LIGHT**

SUBTASK 53-51-21-420-005

- (8) If you install the access panel, 192K [36], or access panel, 193B [34], install the lower anti-collision light assembly (TASK 33-44-02-960-802).

**LOM ALL**

SUBTASK 53-51-21-910-004

- (9) Apply sealant to make an aerodynamic seal as follows (Figure 401):

NOTE: This makes an aerodynamic and weather seal.

- (a) Apply sealant, A50231, or sealant, A00247, where the panels touch the airplane skin.

**LOM 431-434, 437-447, 450-464**

- (b) Apply sealant, A50359, between the panels.

NOTE: Application of this sealant is optional.

**LOM ALL**

- (c) Do not apply sealant on the access doors.

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

SUBTASK 53-51-21-410-004

- (1) Connect or install the equipment to the fairing.

SUBTASK 53-51-21-410-002

- (2) Do an operational test for the disconnected or removed equipment.
- (a) Distance Measuring Equipment (DME) Antennas (PAGEBLOCK 34-55-11/401).
  - (b) Marker Beacon Antenna (PAGEBLOCK 34-32-11/401).
  - (c) Install the wheel well service interphone jacks.
    - 1) Install the lockwasher and nut.
      - a) Torque the nut to  $15 \pm 1$  in-lb ( $1.69 \pm 0.11$  N·m).
      - b) Bend up one washer tap most normal to flat side of nut.
    - 2) Fill the cavity between skin cutout and interphone jask with sealant, A50359.

————— END OF TASK ————

**TASK 53-51-21-000-801**

**6. Aft Wing-To-Body Fairing Panel Removal**

(Figure 404)

**A. References**

Reference	Title
27-51-00-860-803	Extend the Trailing Edge Flaps (P/B 201)
27-51-00-860-804	Retract the Trailing Edge Flaps (P/B 201)
27-51-11-820-801	Inboard Trailing Edge Flap Adjustment (P/B 501)
28-25-07-020-801	APU Fuel Feed Line Shroud Drain Mast Removal (P/B 401)
34-32-11-000-801	Marker Beacon Antenna Removal (P/B 401)
34-32-11-000-802	Marker Beacon Antenna with Gasket - Removal (P/B 401)

————— EFFECTIVITY ————  
**LOM ALL**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**B. Location Zones**

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

**C. Access Panels**

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft
194CL	Aft Wing To Body Fairing Panel
194CR	Aft Wing To Body Fairing Panel
194DL	Aft Wing To Body Fairing Panel
194DR	Aft Wing To Body Fairing Panel
194E	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel
194HL	Aft Wing To Body Fairing Panel
194HR	Aft Wing To Body Fairing Panel

**D. Prepare for Aft Wing-To-Body Fairing Panels Removal**

SUBTASK 53-51-21-020-007

- (1) If necessary, remove or disconnect the equipment that is attached to the fairing.
  - (a) For the marker beacon antenna, do this task: Marker Beacon Antenna Removal, TASK 34-32-11-000-801.

**LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-431, 433, 434, 437-447, 450-999**

- LOM  
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- (b) For the marker beacon antenna, do this task: Marker Beacon Antenna with Gasket - Removal, TASK 34-32-11-000-802

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**LOM ALL**

- (c) For the Auxiliary Power Unit (APU) Drain Mast, do this task: APU Fuel Feed Line Shroud Drain Mast Removal, TASK 28-25-07-020-801.

**E. Aft Wing-To-Body Fairing Panels Removal**

SUBTASK 53-51-21-020-001

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

SUBTASK 53-51-21-020-008

- (2) Do these steps to remove the applicable fairing panels:



**CAUTION** MAKE SURE THAT THERE IS CLEARANCE BETWEEN THE COVERPLATE AND FAIRING BEFORE YOU OPERATE THE TRAILING EDGE FLAPS. IF THERE IS NOT SUFFICIENT CLEARANCE, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (a) Measure the clearance between the coverplate on the trailing edge flap and the wing-to-body fairing panel (TASK 27-51-11-820-801).
- (b) Make sure you hold the fairing panel until all the fasteners are removed.

EFFECTIVITY  
**LOM ALL**

**53-51-21**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (c) Make sure that you identify the fasteners to install them in the same locations
- (d) Zone 194:

- 1) Remove the fasteners for access panel [57]:

**Number**    **Name/Location**

194AL      Aft Wing To Body Fairing Panel

- 2) Remove the fasteners for access panel [50]:

**Number**    **Name/Location**

194AR      Aft Wing To Body Fairing Panel

- 3) Do these steps to remove the fasteners for access panel [56]:

**Number**    **Name/Location**

194BL      Flap Track Lubrication Panel - Aft

- a) Do this task: Extend the Trailing Edge Flaps, TASK 27-51-00-860-803.
  - b) Remove the visible fasteners for access panel, 194BL [56] which are blocked by the Trailing Edge (TE) flaps when they are retracted.
  - c) Do this task: Retract the Trailing Edge Flaps, TASK 27-51-00-860-804.
  - d) Remove the remaining fasteners for access panel, 194BL [56].
- 4) Do these steps to remove the fasteners for access panel [51]:

**Number**    **Name/Location**

194BR      Flap Track Lubrication Panel - Aft

- a) Do this task: Extend the Trailing Edge Flaps, TASK 27-51-00-860-803.
  - b) Remove the visible fasteners for access panel, 194BR [51] which are blocked by the TE flaps when they are retracted.
  - c) Do this task: Retract the Trailing Edge Flaps, TASK 27-51-00-860-804.
  - d) Remove the remaining fasteners for access panel, 194BR [51].
- 5) Remove the fasteners for access panel [64]:

**Number**    **Name/Location**

194CL      Aft Wing To Body Fairing Panel

- 6) Remove the fasteners for access panel [52]:

**Number**    **Name/Location**

194CR      Aft Wing To Body Fairing Panel

- 7) Remove the fasteners for access panel [55]:

**Number**    **Name/Location**

194DL      Aft Wing To Body Fairing Panel

- 8) Remove the fasteners for access panel [53]:

**Number**    **Name/Location**

194DR      Aft Wing To Body Fairing Panel

- 9) Remove the fasteners for access panel [54]:

**Number**    **Name/Location**

194E      Aft Wing To Body Fairing Panel

EFFECTIVITY  
LOM ALL

**53-51-21**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 10) Remove the fasteners for access panel [58]:

**Number      Name/Location**

194FL      Aft Wing To Body Fairing Panel

a) If required, remove the APU drain mast (TASK 28-25-07-020-801).

- 11) Remove the fasteners for access panel [62]:

**Number      Name/Location**

194FR      Aft Wing To Body Fairing Panel

- 12) Remove the fasteners for access panel [59]:

**Number      Name/Location**

194GL      Aft Wing To Body Fairing Panel

- 13) Remove the fasteners for access panel [63]:

**Number      Name/Location**

194GR      Aft Wing To Body Fairing Panel

- 14) Remove the fasteners for access panel [60]:

**Number      Name/Location**

194HL      Aft Wing To Body Fairing Panel

- 15) Remove the fasteners for access panel [61]:

**Number      Name/Location**

194HR      Aft Wing To Body Fairing Panel

- (e) Remove the fairing panel from the airplane.

———— END OF TASK ————

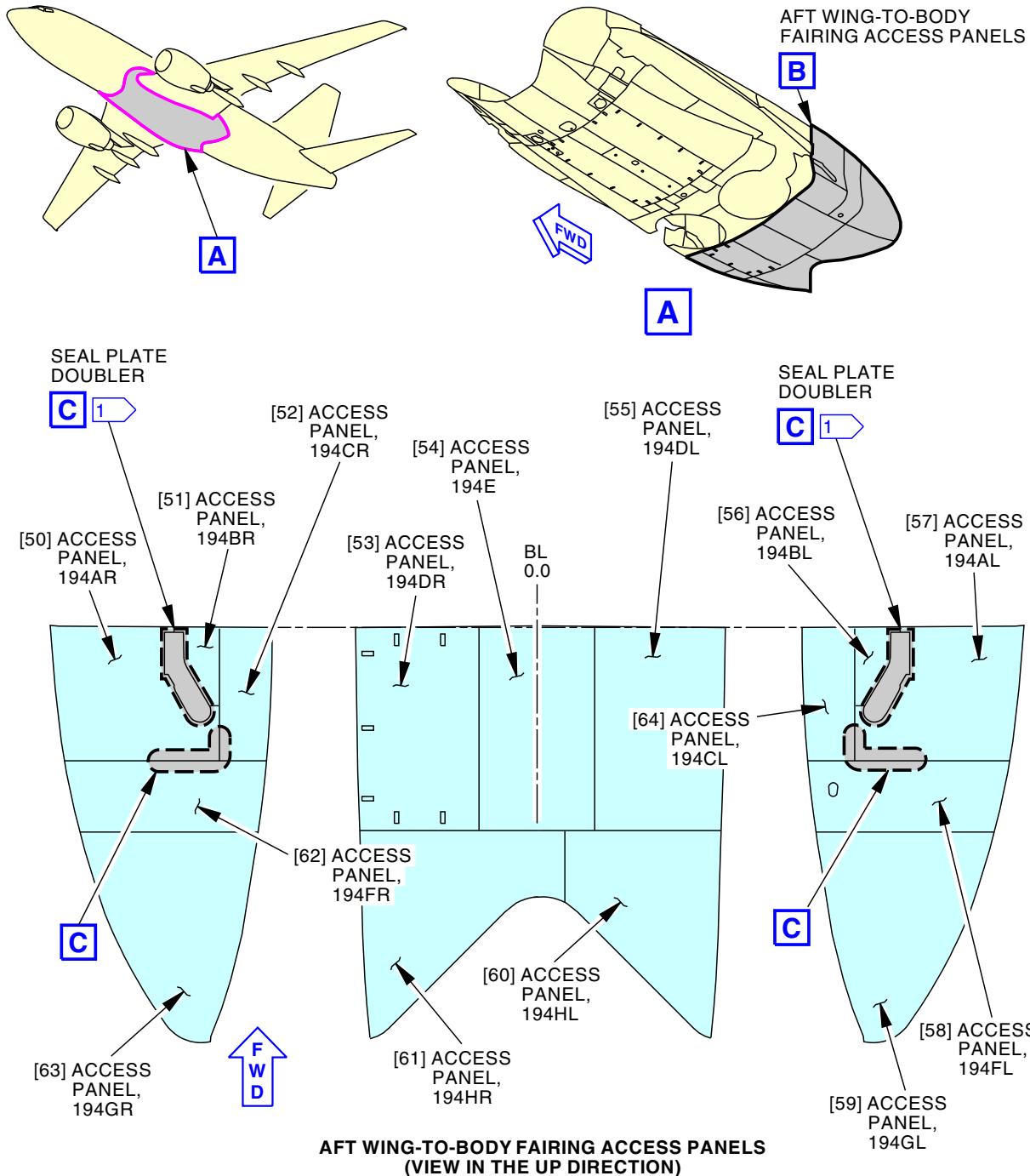
EFFECTIVITY  
LOM ALL

**53-51-21**



# **737-600/700/800/900**

## **AIRCRAFT MAINTENANCE MANUAL**



**1** SEAL PLATE DOUBLERS ARE NOT INSTALLED ON ALL AIRPLANES.

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**Aft Wing-To-Body Fairing Access Panels Installation  
Figure 404/53-51-21-990-806 (Sheet 1 of 2)**

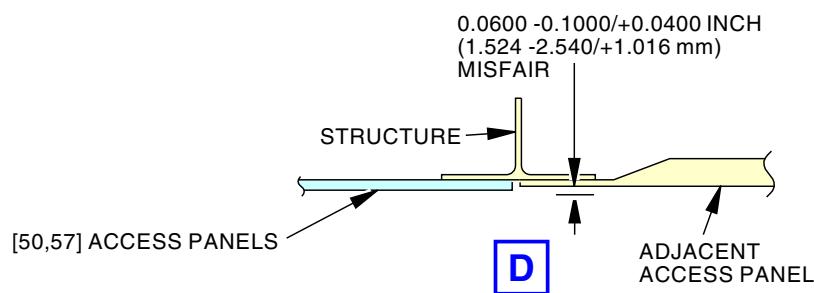
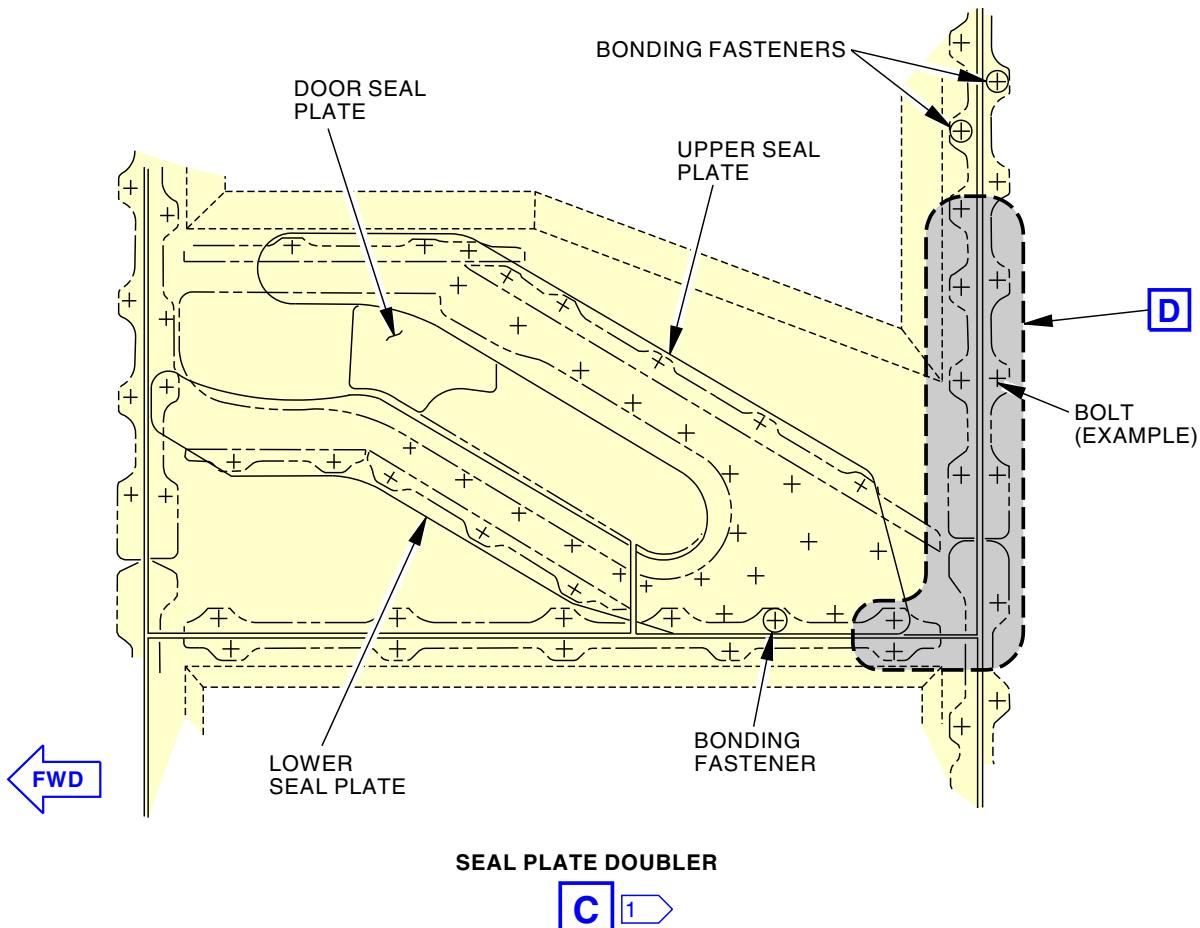
EFFECTIVITY  
LOM ALL

53-51-21

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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Aft Wing-To-Body Fairing Access Panels Installation  
Figure 404/53-51-21-990-806 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

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**53-51-21**

Page 433  
Jun 15/2022



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-51-21-400-801**

**7. Aft Wing-To-Body Fairing Panel Installation**

(Figure 404)

**A. General**

- (1) This task includes the steps to install access panels:

**B. References**

Reference	Title
27-51-00-820-801	Trailing Edge Flap Control System Adjustment and Test (P/B 501)
27-51-00-860-803	Extend the Trailing Edge Flaps (P/B 201)
27-51-00-860-804	Retract the Trailing Edge Flaps (P/B 201)
28-25-07-420-801	APU Fuel Feed Line Shroud Drain Mast Installation (P/B 401)
34-32-11-400-801	Marker Beacon Antenna Installation (P/B 401)
34-32-11-400-802	Marker Beacon Antenna with Gasket - Installation (P/B 401)
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
51-21-81 P/B 701	ABRASION-RESISTANT TEFILON FINISH - CLEANING/PAINTING
53-51-21-211-801	Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection (P/B 601)
53-51-21-760-801	Wing-To-Body Fairing Panel Maximum Electrical Resistance Check (P/B 601)

**C. 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
A50231	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class B
A50359	Sealant - Low Density, Non-Chromate Type	BMS5-142 Type II Class B
C00175	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79 Type III
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00304	Coating - Teflon Filled, Non Decorative, Sprayable Material	BMS10-86 Type I
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
C50149	Coating - Teflon Filled, Non Decorative, Brushable or Sprayable Material	BMS10-86 Type II
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

**D. Location Zones**

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

EFFECTIVITY  
LOM ALL

**53-51-21**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**E. Access Panels**

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft
194CL	Aft Wing To Body Fairing Panel
194CR	Aft Wing To Body Fairing Panel
194DL	Aft Wing To Body Fairing Panel
194DR	Aft Wing To Body Fairing Panel
194E	Aft Wing To Body Fairing Panel
194FL	Aft Wing To Body Fairing Panel
194FR	Aft Wing To Body Fairing Panel
194GL	Aft Wing To Body Fairing Panel
194GR	Aft Wing To Body Fairing Panel
194HL	Aft Wing To Body Fairing Panel
194HR	Aft Wing To Body Fairing Panel

**F. Prepare for Aft Wing-To-Body Fairing Panel Installation**

SUBTASK 53-51-21-210-001

- (1) Make sure that the mating surfaces between the panel and structure are free from contamination.

NOTE: Teflon is applied on the mating structure surface. The Teflon is not contamination. It is not necessary to remove the Teflon.

SUBTASK 53-51-21-160-001

- (2) Make sure that the Teflon mating structure surface is in a good condition.
  - (a) If necessary, repair the Teflon coating.
    - 1) Apply coating, C00304 or coating, C50149 (PAGEBLOCK 51-21-81/701).
    - 2) Do not get Teflon in nutplate threads.

SUBTASK 53-51-21-210-002

- (3) Make sure that the designated electrical bonds for the panel can be identified (TASK 53-51-21-211-801).

SUBTASK 53-51-21-390-001



**CAUTION**  
DO NOT APPLY CORROSION-PREVENTATIVE COMPOUND TO THE BOND-BOLTS AND THEIR HOLES. THE COMPOUND PREVENTS CORRECT INSTALLATION OF THE BONDING BOLT. IF YOU DO NOT INSTALL THE BONDING BOLT CORRECTLY, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (4) Apply the corrosion preventive compound, C00308, to the flanges on the fairing that touches the structure.

SUBTASK 53-51-21-390-003

- (5) Apply the corrosion inhibiting compound, G00009, to the area on the structure and body skin that touches the fairing.
  - (a) If necessary, refer to the STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

EFFECTIVITY  
LOM ALL

**53-51-21**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

G. Aft Wing-To-Body Fairing Panels Installation

SUBTASK 53-51-21-400-001

- (1) Install the fasteners that do not have a designated electrical bond on the applicable panel.



**CAUTION**

DO NOT APPLY CORROSION-PREVENTATIVE COMPOUND TO THE BOND-BOLTS AND THEIR HOLES. THE COMPOUND PREVENTS CORRECT INSTALLATION OF THE BONDING BOLT. IF YOU DO NOT INSTALL THE BONDING BOLT CORRECTLY, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (a) Apply primer, C00259, to the hole of all non-designated electrical bond fasteners in the structure as necessary.

- (b) Let the primer dry.

- (c) Put the panel into its position.

- 1) Install the non-designated electrical bond fasteners for this access panel [57]:

**Number      Name/Location**

194AL      Aft Wing To Body Fairing Panel

- 2) Install the non-designated electrical bond fasteners for this access panel [50]:

**Number      Name/Location**

194AR      Aft Wing To Body Fairing Panel

- 3) Do these steps to install the non-designated electrical bond access fasteners for this panel [56]:

**Number      Name/Location**

194BL      Flap Track Lubrication Panel - Aft

- a) Install all the non-designated electrical bond fasteners that you have access to for access panel, 194BL [56].

- b) Do this task: Extend the Trailing Edge Flaps, TASK 27-51-00-860-803.

- c) Install the remaining non-designated electrical bond fasteners for access panel, 194BL [56] which are blocked by the Trailing Edge (TE) flaps when they are retracted.

- d) Do this task: Retract the Trailing Edge Flaps, TASK 27-51-00-860-804.

- 4) Do these steps to install the non-designated electrical bond fasteners for this access panel [51]:

**Number      Name/Location**

194BR      Flap Track Lubrication Panel - Aft

- a) Install all the non-designated electrical bond fasteners that you have access to for access panel, 194BR [51].

- b) Do this task: Extend the Trailing Edge Flaps, TASK 27-51-00-860-803.

- c) Install the remaining non-designated electrical bond fasteners for access panel, 194BR [51] which are blocked by the TE flaps when they are retracted.

- d) Do this task: Retract the Trailing Edge Flaps, TASK 27-51-00-860-804.

- 5) Install the non-designated electrical bond fasteners for this access panel [64]:

**Number      Name/Location**

194CL      Aft Wing To Body Fairing Panel

EFFECTIVITY  
LOM ALL

**53-51-21**

Page 436  
Oct 15/2023



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 6) Install the non-designated electrical bond fasteners for this access panel [52]:

**Number**    **Name/Location**

194CR      Aft Wing To Body Fairing Panel

- 7) Install the non-designated electrical bond fasteners for this access panel [55]:

**Number**    **Name/Location**

194DL      Aft Wing To Body Fairing Panel

- a) If required, install the Auxiliary Power Unit (APU) drain mast  
(TASK 28-25-07-420-801).

NOTE: Keep access panel 194DL open to install the drain mast.

- 8) Install the non-designated electrical bond fasteners for this access panel [53]:

**Number**    **Name/Location**

194DR      Aft Wing To Body Fairing Panel

- 9) Install the non-designated electrical bond fasteners for this access panel [54]:

**Number**    **Name/Location**

194E      Aft Wing To Body Fairing Panel

- 10) Install the non-designated electrical bond fasteners for this access panel [58]:

**Number**    **Name/Location**

194FL      Aft Wing To Body Fairing Panel

- a) If required, install the APU drain mast (TASK 28-25-07-420-801).

- 11) Install the non-designated electrical bond fasteners for this access panel [62]:

**Number**    **Name/Location**

194FR      Aft Wing To Body Fairing Panel

- 12) Install the non-designated electrical bond fasteners for this access panel [59]:

**Number**    **Name/Location**

194GL      Aft Wing To Body Fairing Panel

- 13) Install the non-designated electrical bond fasteners for this access panel [63]:

**Number**    **Name/Location**

194GR      Aft Wing To Body Fairing Panel

- 14) Install the non-designated electrical bond fasteners for this access panel [60]:

**Number**    **Name/Location**

194HL      Aft Wing To Body Fairing Panel

- 15) Install the non-designated electrical bond fasteners for this access panel [61]:

**Number**    **Name/Location**

194HR      Aft Wing To Body Fairing Panel

EFFECTIVITY  
LOM ALL

**53-51-21**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



IF YOU REPLACE A PANEL THAT HAS A DOUBLER (194AL, 194BL, 194AR, 194BR), YOU MUST INSTALL A NEW PANEL WITH A NEW DOUBLER. MAKE SURE THAT YOU INSTALL IT CORRECTLY. IF YOU INSTALL THE DOUBLERS INCORRECTLY, DAMAGE TO THE EQUIPMENT CAN OCCUR.

- (d) If access panels 194AL, 194AR, 194BL, or 194BR are replaced and have a doubler, do the following:

NOTE: The same thickness doubler and nylon liner should be used and edges sealed with sealant. This makes an aerodynamic and a weather seal.

- 1) Install a new doubler and nylon at STA 727.
- 2) Fay seal doubler to fairing panel.
- 3) Make sure that the seal compression is within limits of operation and trailing edge flaps are within limits (TASK 27-51-00-820-801).
- 4) Apply sealant, A02315, to make a fillet seal around edge of doubler.

SUBTASK 53-51-21-400-002



CAUTION

INSTALL THE BONDING BOLTS IN THE SAME FASTENER HOLES THAT YOU REMOVED THEM FROM. BONDING BOLTS CAN HELP TO PREVENT LIGHTNING DAMAGE. LIGHTNING CAN CAUSE DAMAGE TO THE AIRPLANE.



CAUTION

DO NOT APPLY CORROSION-PREVENTATIVE COMPOUND TO THE BOND-BOLTS AND THEIR HOLES. THE COMPOUND PREVENTS CORRECT INSTALLATION OF THE BONDING BOLT. IF YOU DO NOT INSTALL THE BONDING BOLT CORRECTLY, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (2) Install the designated bonding fasteners for the applicable panel.

- (a) Measure the maximum electrical resistance for each bonding fastener (TASK 53-51-21-760-801).
  - 1) Make sure that the resistance for each bonding fastener is not more than 300,000 ohms for these access panels:
    - In Zone 194: 194AL, 194AR, 194BL, 194BR, 194CL, 194FL, 194FR, 194GL, 194GR.
  - 2) Make sure that the resistance for each bonding fastener is not more than 0.5 ohms for these access panels:
    - In Zone 194: 194CR, 194DL, 194DR, 194E, 194HL, 194HR.
- (b) After you install the bonding fasteners, apply one coat of primer, C00175, as needed to the bonding fasteners only.

SUBTASK 53-51-21-220-001

- (3) Make sure that the distance between panels is in tolerance.

- (a) Measure the misfair between the panels.
  - 1) If you install access panels 194AL, 194AR, 194CL, 194CR, 194FL, or 194FR, make sure that the joint misfair is within the range of 0.0600 in. (1.524 mm) +0.0400 in. (1.016 mm) or -0.1000 in. (-2.5400 mm).
  - 2) For all other access panel joints, make sure that the joint misfair is less than or equal to 0.0400 in. (1.016 mm).

EFFECTIVITY  
LOM ALL

53-51-21



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 3) If necessary, install shims to the forward panels at fastener locations, no more than 0.040 in. (1.016 mm), bonded to the structure with sealant, A00247.

NOTE: Reducing the positive step will reduce erosion of the access panels.

- (b) Measure the gap between the fairing panels.
- 1) Make sure that the gap between the access panels is 0.1400 in. (3.556 mm)  $\pm 0.0600$  in. (1.524 mm).
- (c) Measure the flushness between the fasteners and fairing panels.
- 1) Make sure that the fasteners are flush to the fairing panel between 0.005 in. (0.127 mm) and -0.010 in. (-0.254 mm).

SUBTASK 53-51-21-910-003

- (4) Apply sealant to make an aerodynamic seal as follows (Figure 401):

NOTE: This makes an aerodynamic and weather seal.

- (a) Apply sealant, A50231, or sealant, A00247, where the panels touch the airplane skin.

**LOM 431-434, 437-447, 450-464**

- (b) Apply sealant, A50359, between the panels.

NOTE: Application of this sealant is optional.

**LOM ALL**

- (c) Do not apply sealant on the access doors.

**H. Put the Airplane in Its Usual Condition**

SUBTASK 53-51-21-410-001

- (1) Connect or install the equipment to the fairing and do an operational test if the equipment was disconnected or removed:
- (a) For the marker beacon antenna, do this task: Marker Beacon Antenna Installation, TASK 34-32-11-400-801.

**LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-431, 433, 434, 437-447, 450-999**

- LOM**
- LOM**
- (b) For the marker beacon antenna, do this task: Marker Beacon Antenna with Gasket - Installation, TASK 34-32-11-400-802

**LOM**

**LOM ALL**

- (c) For the APU drain mast, do this task: APU Fuel Feed Line Shroud Drain Mast Installation, TASK 28-25-07-420-801.

———— END OF TASK ————



**53-51-21**

Page 439  
Oct 15/2024





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

WING-TO-BODY FAIRING PANELS - INSPECTION/CHECK

**1. General**

- A. This procedure has these tasks:
  - (1) Wing-To-Body Fairing Panel maximum electrical resistance check.
  - (2) Wing-To-Body Fairing Panel designated electrical bond visual inspection.
- B. This task is not specified to a zone or panel. It applies to all panels in the Forward, Center, and Aft sections of the fillet fairings.

**TASK 53-51-21-760-801**

**2. Wing-To-Body Fairing Panel Maximum Electrical Resistance Check**

(Figure 601)

**A. General**

- (1) This task covers the maximum electrical resistance checks for all designated bonds for panels located in the Wing-To-Body Fairing section.

**B. References**

Reference	Title
53-51-21 P/B 401	WING-TO-BODY FAIRING PANELS - REMOVAL/INSTALLATION
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES

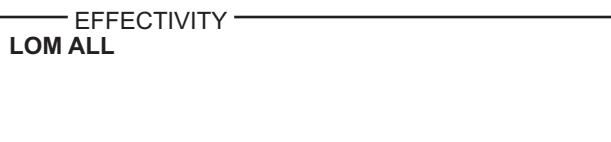
**C. Tools/Equipment**

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

Reference	Description
COM-1793	Multimeter - Digital/Analog (or equivalent meter meets task requirements) <ul style="list-style-type: none"><li>Part #: 117 Supplier: 89536</li><li>Part #: 260-8XPI Supplier: 55026</li><li>Part #: 287 Supplier: 89536</li><li>Part #: 289 Supplier: 89536</li><li>Part #: 87V Supplier: 89536</li><li>Part #: FLUKE 27 II Supplier: 89536</li><li>Part #: FLUKE-77-4 Supplier: 89536</li><li>Opt Part #: 187 Supplier: 89536</li><li>Opt Part #: 189 Supplier: 89536</li><li>Opt Part #: 21 Supplier: 89536</li><li>Opt Part #: 27 Supplier: 89536</li><li>Opt Part #: 77 SERIES III Supplier: 89536</li><li>Opt Part #: 87 Supplier: 89536</li><li>Opt Part #: FLUKE 27 Supplier: 89536</li><li>Opt Part #: MODEL 27 Supplier: 89536</li></ul>

**D. Consumable Materials**

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79 Type III





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Reference	Description	Specification
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
C00767	Coating - Anti-Static Coating	BMS10-21 Type III
C00862	Coating - Chemical Conversion - Bonderite M-CR 600 Aero (Formerly Alodine 600)	BAC5719 Class A, C or D, MIL-DTL-81706 Type I Class 1A or 3

**E. Location Zones**

Zone	Area
190	Subzone - Wing-to-Body Fairing
191	Lower Wing-To-Body Fairing - Forward of Wing Box
192	Lower Wing-To-Body Fairing - Under Wing Box
193	Lower Wing-To-Body Fairing - Wheel Well
194	Lower Wing-To-Body Fairing - Aft of Wheel Well
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

**F. Prepare for the Maximum Electrical Resistance Check**

SUBTASK 53-51-21-211-002

- (1) Make sure that the fastener locations for the designated bonds are identified.
  - (a) Refer to this task: Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection, TASK 53-51-21-211-801.

**G. Check the Maximum Electrical Resistance of the Designated Bonds**

SUBTASK 53-51-21-910-005

- (1) Make sure that one fastener and one dimpled washer (if installed) is installed in a designated bond location in the panel.
  - (a) Refer to SWPM 20-20-00, Electrical Bonding of Fasteners To Conductive Finishes on Composites.
  - (b) Make sure that the flushness for the fastener and the panel is  $0.000 \pm 0.003$  in.  
 $(0.0000 \pm 0.0762$  mm).

SUBTASK 53-51-21-800-001

- (2) Put a dimpled washer (if necessary) in an adjacent designated bonded fastener location.
  - (a) Do not install the fastener at the adjacent designated bonded fastener location.

SUBTASK 53-51-21-200-001

- (3) Connect the digital/analog multimeter, COM-1793, to examine the electrical resistance:
  - (a) Put one probe of a digital/analog multimeter, COM-1793, on the installed designated bonded fastener head.
  - (b) If the dimpled washer is installed, put the second probe on a dimpled washer in the adjacent designated bonded fastener location.

NOTE: The dimpled washer completes an electrical bond between the panel conductive surface and the probe. There must not be a fastener at this location.

- (c) If the dimpled washer is not installed, put the second probe on a bonding surface.



**53-51-21**

Page 602  
Jun 15/2023



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-51-21-200-002

- (4) Make sure that the resistance is not more than in the Table 601.

**Table 601/53-51-21-993-801 Panel Conductive Surface Maximum Resistance**

Conductive Surface Type	Maximum Resistance (Ohm) <sup>*[1]</sup>
Anti-Static Coating	300,000
Aluminum Coated Fiber	10
Expanded Aluminum Foil <sup>*[2]</sup>	0.5
Flamespray	0.5

\*[1] Some panels will be installed with bonding jumpers. The dimension of the bonding jumper can change the maximum resistance. Refer to the installation procedure for the maximum resistance of panels with bonding jumpers(PAGEBLOCK 53-51-21/401).

\*[2] Some panels with the expanded aluminum foil surface can have different maximum resistances. Refer to the installation procedure for panels with different maximum resistances than in this table (PAGEBLOCK 53-51-21/401).

**NOTE:** The maximum resistance data for each panel can be found in the installation procedures (PAGEBLOCK 53-51-21/401).

- (a) If the designated electrical bond is not in the limits, do these steps:
  - 1) Apply a layer of coating on the countersunk area of the panel.
    - a) Use coating, C00767, on panels with an anti-static coating conductive surface type.
    - b) Use Bonderite M-CR 600 Aero coating, C00862, on panels with an aluminum conductive surface type.
  - 2) Measure the maximum resistance again.

SUBTASK 53-51-21-400-008

- (5) If the maximum resistance is in the limits, make sure that the dimpled washer (if installed) does not move as follows:
  - (a) Remove the probe.
  - (b) Install the fastener.
    - 1) Refer to SWPM 20-20-00, Electrical Bonding of Fasteners To Conductive Finishes on Composites.

## H. Repeat the Electrical Resistance of the Designated Bonds Check

SUBTASK 53-51-21-200-003

- (1) Do the "Check of the Electrical Resistance of the Designated Bonds" steps again until all designated bonds are examined.

- (a) Do the check with each subsequently installed designated bond fastener as the start point until all fasteners are installed.

**NOTE:** It is not necessary to remove or do the resistance check again for the first fastener installed.

- 1) If the designated electrical bond is not in the limits, do these steps:
  - a) Apply a layer of coating on the countersunk area of the panel.
    - <1> Use coating, C00767, on panels with an anti-static coating conductive surface type.

EFFECTIVITY  
LOM ALL

**53-51-21**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

<2> Use Bonderite M-CR 600 Aero coating, C00862, on panels with an aluminum conductive surface type.

- b) Measure the maximum resistance for the fastener again.

**I. Restore the Fairing Panel to Its Usual Condition**

SUBTASK 53-51-21-390-011

- (1) Apply finish to the fairing panel after all the fasteners have been examined and installed.
  - (a) Apply one layer of primer, C00175, as necessary to the bonding fasteners only.
  - (b) Apply compound, C00528, to all the fasteners for non-designated bonds and their holes.
  - (c) Apply primer, C00259, as necessary to all the fasteners for non-designated bonds and their holes.

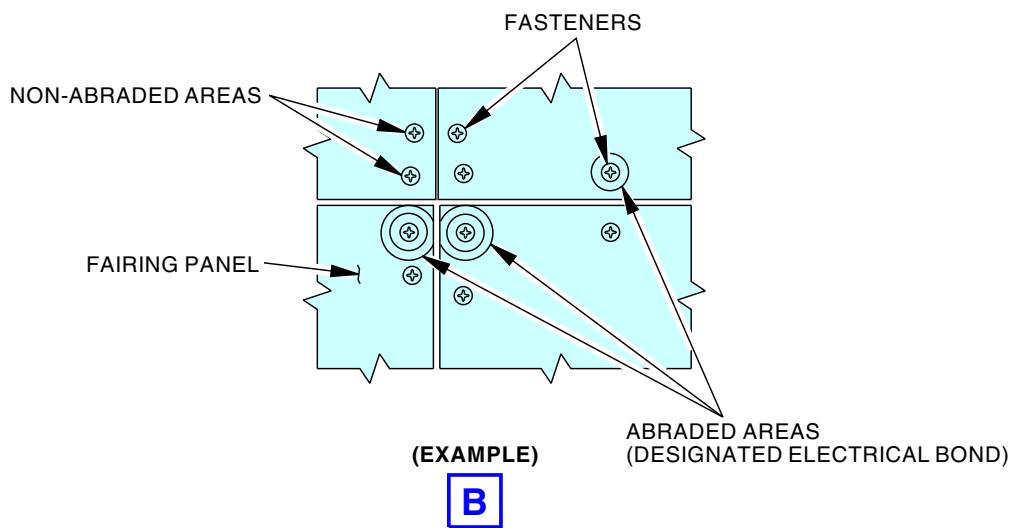
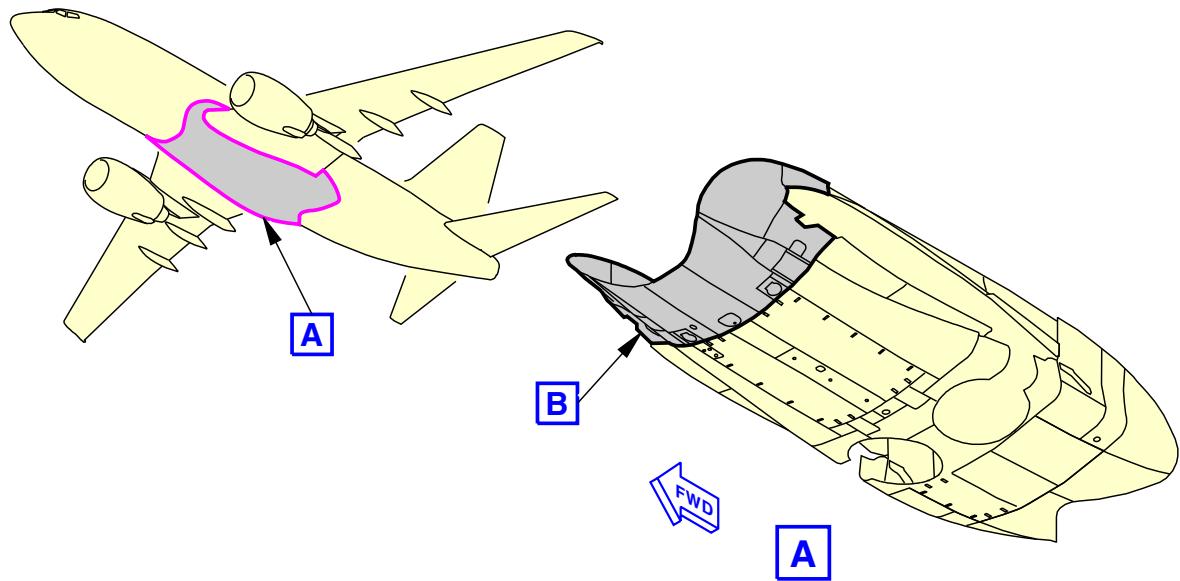
———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-51-21**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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**Wing-to-Body Fairing Inspection**  
Figure 601/53-51-21-990-804

EFFECTIVITY  
LOM ALL

**53-51-21**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 605  
Oct 15/2015



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

TASK 53-51-21-211-801

3. **Wing-To-Body Fairing Panel Designated Electrical Bond Visual Inspection**

(Figure 601)

**A. General**

- (1) This task covers the visual inspection of the designated electrical bonds for the panels located in the Wing-To-Body Fairing section.

**B. Consumable Materials**

Reference	Description	Specification
C00767	Coating - Anti-Static Coating	BMS10-21 Type III
C00862	Coating - Chemical Conversion - Bonderite M-CR 600 Aero (Formerly Alodine 600)	BAC5719 Class A, C or D, MIL-DTL-81706 Type I Class 1A or 3

**C. Location Zones**

Zone	Area
190	Subzone - Wing-to-Body Fairing
191	Lower Wing-To-Body Fairing - Forward of Wing Box
192	Lower Wing-To-Body Fairing - Under Wing Box
193	Lower Wing-To-Body Fairing - Wheel Well
194	Lower Wing-To-Body Fairing - Aft of Wheel Well
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

**D. Visually Examine the Designated Electrical Bonds on the Wing-To-Body Fairing Panels**

SUBTASK 53-51-21-211-001

- (1) Identify the fastener locations on each panel that an electrical bond is necessary to identify fastener locations for electrical bonds:

NOTE: There are usually four fasteners per panel with electrical bonds.

- (a) Examine the area around each fastener hole to identify electrical bond locations.
  - 1) Locations that have an electrical bond have an abraded area in the panel around the fastener hole (Figure 601).
  - 2) It is recommended to examine the panel at the corners first. Usually, the locations are at or near the panel corners, but panel repairs can change the locations of the electrical bonds.
  - 3) It is necessary to examine all the fastener holes to identify locations with an electrical bond.

SUBTASK 53-51-21-300-001

- (2) Do these steps if the electrical bond locations are not identified after the visual inspection:

- (a) Remove one fastener and one dimpled washer, if installed, from the panel.

NOTE: There are usually four fasteners per panel with dimpled washers.

- (b) Examine the area around the fastener hole:
  - 1) Locations that have an electrical bond have an abraded area in the panel around the fastener hole (Figure 601).
  - 2) It is recommended to examine the panel at the corners first. Usually, the locations are at or near the panel corners, but panel repairs can change the locations of the electrical bonds.

EFFECTIVITY  
LOM ALL

**53-51-21**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 3) It is necessary to examine all the fastener holes to identify locations with an electrical bond.
- (c) Examine the countersunk area of the fastener hole:  
NOTE: The countersunk area of the panel will be below the dimpled washer, if installed.
  - 1) The countersunk area for each electrically bonded fastener hole will have a coating, C00767 or an Bonderite M-CR 600 Aero coating, C00862.  
NOTE: Non-electrical bonding locations do not have coatings in the countersunk hole.
- (d) Examine the countersunk mating surface between the dimpled washer (if installed) and the panel (Figure 601).
  - 1) Make sure that the surfaces without an electrical bond between the dimpled washer and the panel are free from contamination.
  - 2) Make sure that the surfaces with an electrical bond between the dimpled washer and the panel are free from contamination, primer, or paint.
- (e) If necessary, install the fastener if the location is not a designated electrical bond.  
NOTE: It is not necessary to do this step if the removal and installation procedure is being done until it is necessary in the installation procedure.
  - 1) Do not install the dimpled washer if the location is not a designated electrical bond.
- (f) Do the steps again to find all the designated bond locations.  
NOTE: The only fasteners not installed will be fasteners for a designated electrical bond.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-51-21**





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

FILLET FAIRINGS CORROSION - MAINTENANCE PRACTICES

**1. General**

- A. This procedure contains 1 task:
- (1) Corrosion Prevention of the Wing to Body Fairing Cavity.

**TASK 53-51-37-600-801**

**2. Wing to Body Fairing Cavity - Corrosion Prevention**

Figure 201

**A. General**

- (1) The upper wing-to-body fairing is attached to the upper wing surface and fuselage skin along the wing to fuselage joints. The lower lobe fairing houses the ambient air inlets to the ram air system during pack cooling fan operation. The lower lobe fuselage skin under the fairing extends to the bulkhead below the front spar of the center wing section. The cavity formed by the lower lobe fairing and fuselage skin is the area of concern and is the subject of this figure. Aft of this area the fairing covers the center wing section.
- (2) Service experience has shown the revised finish system has been effective in controlling the corrosion problem. Corrosion damage is due to the accumulation of moisture from the ambient air as it enters the cavity during pack cooling fan operation.
- (3) Corrosion was reported on the fuselage skin and the external doubler on the wing upper surface under the wing to body fairing. The body surfaces under the fairing is treated with a water displacing corrosion inhibiting compound in production.
- (4) Refer to CORROSION PREVENTION, SECTION 51-00 of this manual for a discussion of the Aging Airplane Corrosion Prevention and Control Program and related documentation. Structural items within this section are subject to the unique requirements of the mandatory Corrosion Prevention and Control Program.

**B. References**

Reference	Title
51-00	CORROSION PREVENTION
51-00-51	INSPECTION AND DETECTION
51-00-59	STANDARD PREVENTIVE MAINTENANCE PROCEDURES
SRM 737-678	Structural Repair Manual

**C. Consumable Materials**

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

**D. Location Zones**

Zone	Area
100	Lower Half of Fuselage

**E. Corrosion Prevention**

SUBTASK 53-51-37-610-001

- (1) Make the periodic inspection described in INSPECTION AND DETECTION, SUBJECT 51-00-51 to ensure that the protective finishes provided at manufacture remain intact. Access for inspections can be made through service doors and access panels in the fairing. A corrosion prevention program should be initiated to prevent the accumulation of corrosive products in order to minimize the occurrence of corrosion.

EFFECTIVITY
LOM ALL

**53-51-37**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-51-37-610-002



**CAUTION**

DO NOT APPLY THE CORROSION-INHIBITING COMPOUND TO SILICONE RUBBER, RUBBER SEALS, OR RUBBER CUSHIONS. THE CORROSION-INHIBITING COMPOUND CAN CAUSE SEALS, AND CUSHIONS TO BECOME LARGER, AND CAN CAUSE THE DETERIORATION OF THEM.

- (2) Use corrosion inhibiting compound, G00009 where extensive corrosion exists (noticeable skin bulges, missing fasteners or large amounts of discolored deposits of fastener heads or faying surfaces), refer to SRM 737-678 for details of corrosion removal.

SUBTASK 53-51-37-610-003

- (3) Where corrosion is not evident, apply corrosion inhibiting compound in all metallic areas of the cavity.

NOTE: For details of water displacing corrosion inhibiting compound, corrosion inhibiting compound, G00009, refer to STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59.

SUBTASK 53-51-37-610-004

- (4) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by an application of corrosion inhibiting compound on the affected area to retard the corrosion process and into the entire cavity area noted in part C. The finish system should be restored at the next maintenance opportunity (STANDARD PREVENTIVE MAINTENANCE PROCEDURES, SUBJECT 51-00-59 and SRM 737-678).

SUBTASK 53-51-37-610-005

- (5) Frequency of Application

- (a) Inspect the area at regular maintenance intervals and reapply corrosion inhibitor as necessary.

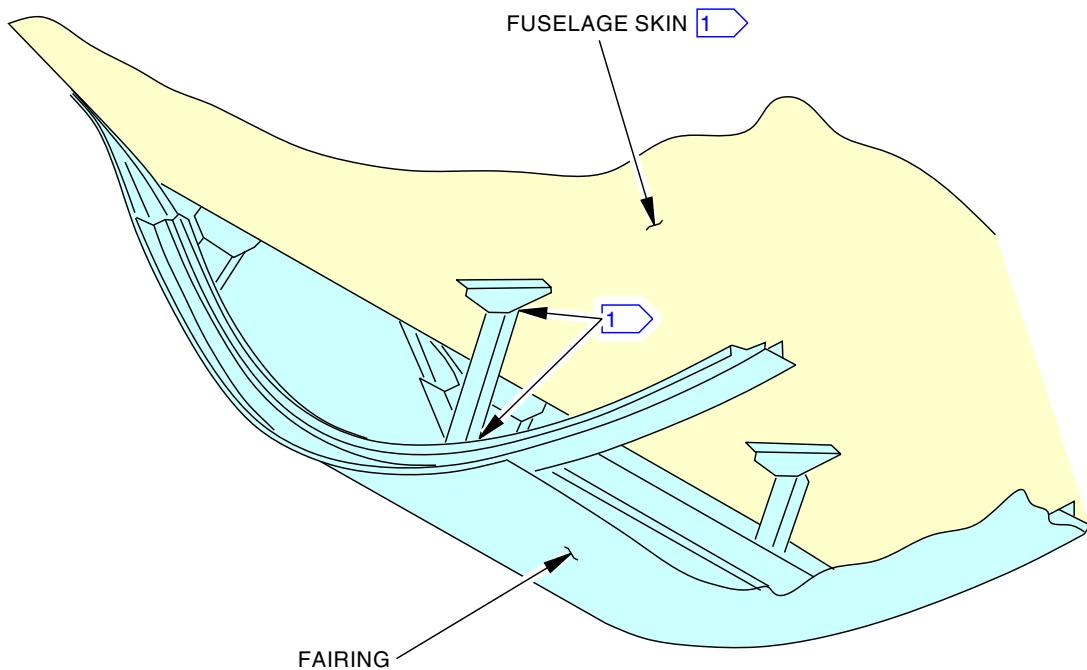
— END OF TASK —

EFFECTIVITY  
LOM ALL

**53-51-37**



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TYPICAL FAIRING CAVITY STRUCTURE

NOTE:

APPLY BMS 3-23 CORROSION INHIBITOR

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Wing to Body Fairing Cavity  
Figure 201/53-51-37-990-801

EFFECTIVITY  
LOM ALL

**53-51-37**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 203  
Oct 15/2015





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

NOSE RADOME - MAINTENANCE PRACTICES

**1. General**

- A. This section contains these tasks:
- (1) A task to open the nose radome.
  - (2) A task to close the nose radome.
  - (3) The removal of the nose radome protective boot.
  - (4) The installation of the nose radome protective boot.

**TASK 53-52-00-010-802**

**2. Nose Radome - Open**

**A. General**

- (1) This task has the steps to open the Nose Radome.

**B. Location Zones**

Zone	Area
111	Radome

**C. Prepare to Open the Nose Radome**

SUBTASK 53-52-00-040-001

- (1) Open this circuit breaker and install safety tag:

**F/O Electrical System Panel, P6-1**

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

**D. Open the Nose Radome**

SUBTASK 53-52-00-010-002

**LOM 422, 425, 429-431, 433, 434, 440, 442-444, 451-453; LOM 420, 428, 445, 454, 457 POST SB 737-23-1605**



USE CAUTION WHEN YOU OPEN THE NOSE RADOME COMPARTMENT. IF THERE IS A BATTERY FAILURE, A DANGEROUS GAS CAN EMIT. DO THE CORRECT EMERGENCY PROCEDURES IF YOU SMELL AN UNUSUAL ODOR AT THE RADOME AREA.

**LOM ALL**

- (1) Remove the screws that attach the aft edge of the radome to the clips on the fuselage bulkhead.

SUBTASK 53-52-00-010-003



**WARNING**

DO NOT OPEN THE NOSE RADOME IF THE WIND IS MORE THAN 15 KNOTS. IF YOU OPEN THE NOSE RADOME IN A WIND, THE RADOME CAN MOVE QUICKLY. THIS CAN CAUSE INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.

EFFECTIVITY  
**LOM ALL**

**53-52-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(WARNING PRECEDES)



**CAUTION**

DO NOT OPEN THE RADOME IN THE RAINY CONDITION. THE WATER ON THE FLAT PLATE MAY CAUSE A NEGATIVE AFFECT TO THE RADAR PERFORMANCE. WIPE OFF THE WATER COMPLETELY BEFORE RADOME IS CLOSED.



**CAUTION**

DO NOT LET THE WORKSTANDS OR EQUIPMENT HIT OR TOUCH THE WEATHER RADAR ANTENNA. THIS CAN CAUSE DAMAGE TO THE WEATHER RADAR ANTENNA.

- (2) Open the radome.
  - (a) Hold the radome in the open position.

SUBTASK 53-52-00-020-012

- (3) Remove the radome support rods [1] from the stowed position.

SUBTASK 53-52-00-420-010

- (4) Install the radome support rods [1] on the studs [3] to hold the radome in the open position.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-52-00**

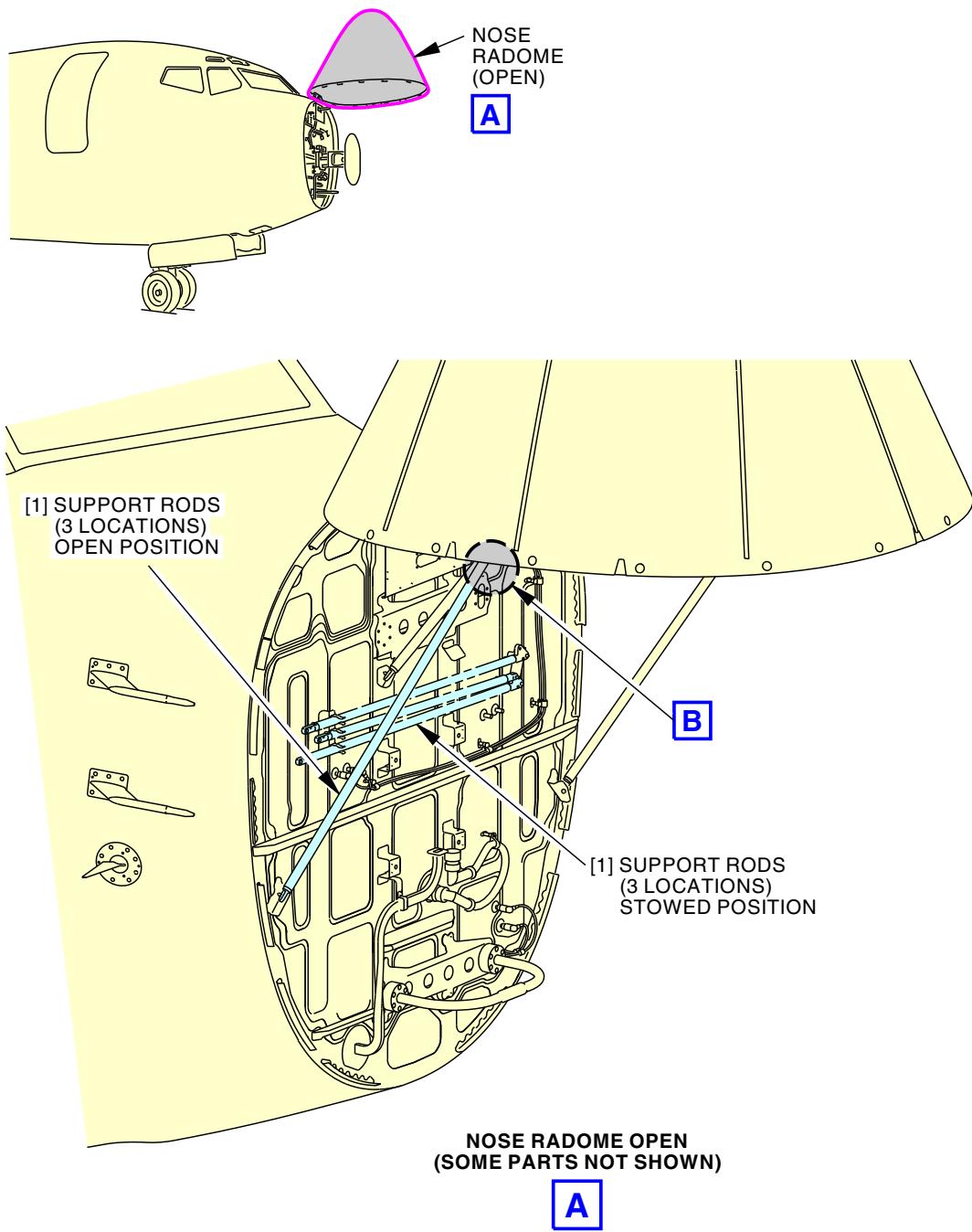
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Page 202  
Feb 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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**Nose Radome Open/Close Procedure**  
Figure 201/53-52-00-990-806 (Sheet 1 of 2)

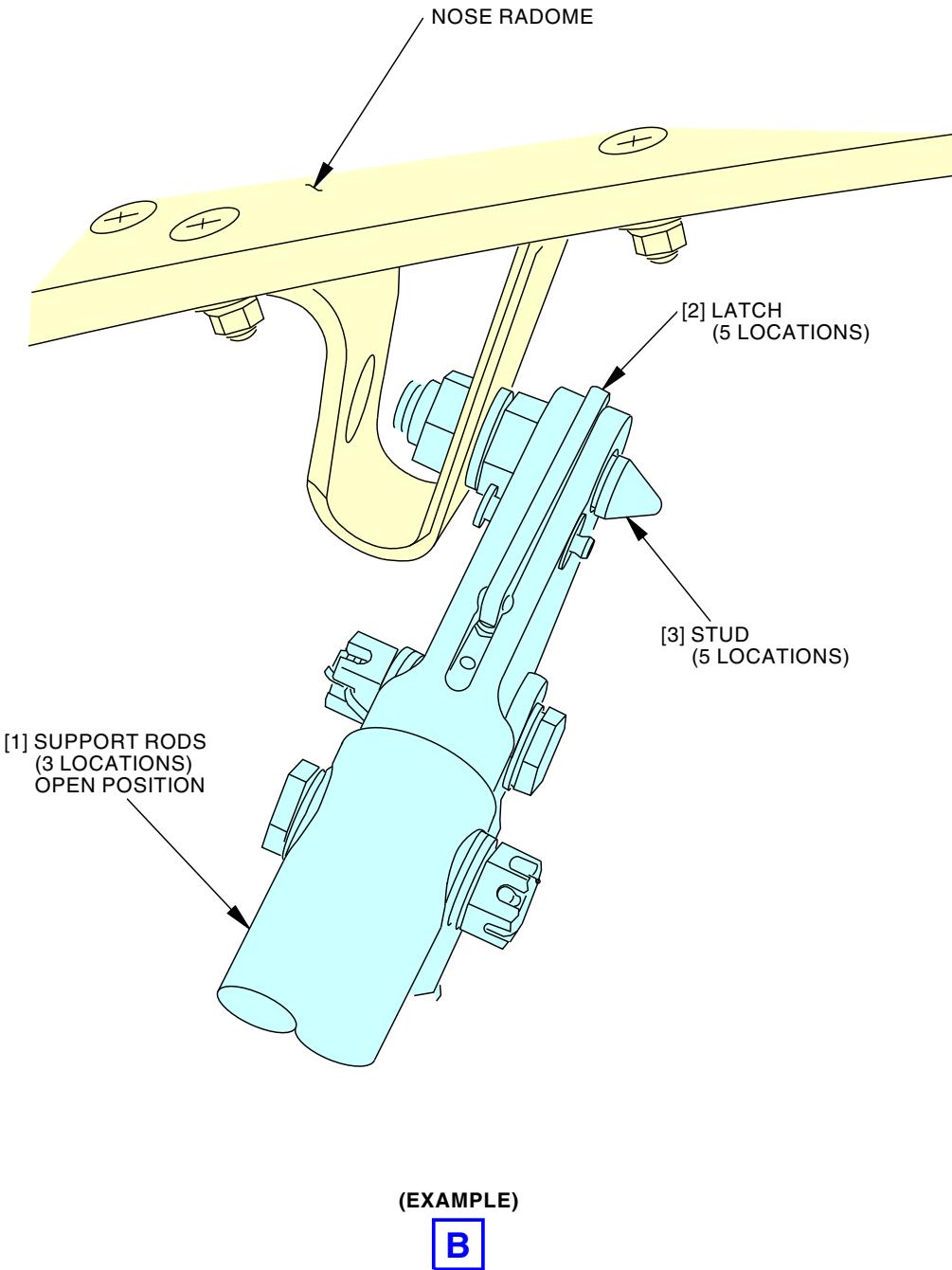
EFFECTIVITY  
LOM ALL

**53-52-00**

Page 203  
Feb 15/2020

D633A101-LOM

**BOEING**  
737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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**Nose Radome Open/Close Procedure**  
Figure 201/53-52-00-990-806 (Sheet 2 of 2)

EFFECTIVITY  
LOM ALL

**53-52-00**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 204  
Feb 15/2020



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-52-00-410-802**

**3. Nose Radome - Close**

(Figure 201)

**A. General**

- (1) This task has the steps to close the nose radome.

**B. Consumable Materials**

Reference	Description	Specification
D50004	Compound - Antiseize	BMS3-28

**C. Location Zones**

Zone	Area
111	Radome

**D. Prepare to Close the Nose Radome**

SUBTASK 53-52-00-040-002

- (1) Make sure that this circuit breaker is open and has safety tag:

**F/O Electrical System Panel, P6-1**

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

**E. Close the Nose Radome**

SUBTASK 53-52-00-410-004

- (1) Hold the radome while you remove the radome support rods [1].

SUBTASK 53-52-00-410-005

- (2) Remove the radome support rods [1].

- (a) Lift the latches [2] to remove the radome support rods [1] from the studs [3].

SUBTASK 53-52-00-410-006

- (3) Install the radome support rods [1] in the stowed position.

SUBTASK 53-52-00-410-007

- (4) Lower the radome.

SUBTASK 53-52-00-410-008

- (5) Install the screws with compound, D50004 in the aft edge of the radome.

- (a) Torque screws to 120 in-lb (13.6 N·m) - 150 in-lb (16.9 N·m).

SUBTASK 53-52-00-210-017

- (6) Make sure that the seal engages correctly.

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

SUBTASK 53-52-00-440-001

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

**F/O Electrical System Panel, P6-1**

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

— END OF TASK —

EFFECTIVITY  
LOM ALL

**53-52-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-52-00-000-802**

**4. Nose Radome Protective Boot Removal**

**A. References**

Reference	Title
53-52-00-370-801	Nose Radome - Cleaning/Painting (P/B 701)

**B. Location Zones**

Zone	Area
111	Radome

**C. Procedure**

SUBTASK 53-52-00-000-002



USE CARE WHEN USING KNIFE TO PREVENT DAMAGE TO LAMINATIONS OF RADOME.

**CAUTION**

- (1) Lightly cut the radome boot into 4 pieces with a knife or a razor blade.

SUBTASK 53-52-00-000-003

- (2) Remove the 4 radome boot pieces:

- (a) Lift an edge slowly.
- (b) Remove the radome boot piece slowly at an angle of 90° to 180°.

NOTE: When removing the radome boot pieces, the speed and angle may affect how much adhesive residue is left and how much paint is removed from the nose radome. Remove the radome boot pieces slowly to avoid adhesive residue and removed paint.

- (c) Do the procedure again until all 4 pieces are removed.

SUBTASK 53-52-00-000-004

- (3) Remove the adhesive residue.

SUBTASK 53-52-00-100-004

- (4) Clean the radome boot area.

SUBTASK 53-52-00-300-001

- (5) Repair areas of removed paint:

- (a) Do this task: Nose Radome - Cleaning/Painting, TASK 53-52-00-370-801.

— END OF TASK —

**TASK 53-52-00-400-802**

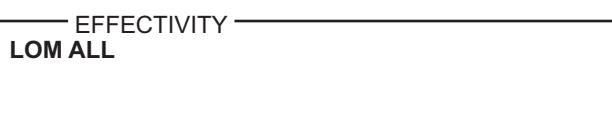
**5. Nose Radome Protective Boot Installation**

**A. References**

Reference	Title
51-21-99-300-801	Decorative Exterior Paint System Application (P/B 701)
51-21-99-370-801	Basecoat/Clearcoat Paint System - Repair (P/B 701)

**B. Tools/Equipment**

Reference	Description
STD-821	Squeegee - Plastic



**53-52-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

C. Consumable Materials

Reference	Description	Specification
B50073	Alcohol - Isopropyl	ASTM D 770
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)
G02219	Tape - Yellow Vinyl Adhesive, Scotch Brand No.471, 1.5 Inches (38.1 mm) Wide	
G50220	Pad - Abrasive, Scotch- Brite 7447	

D. Location Zones

Zone	Area
111	Radome

E. Procedure

SUBTASK 53-52-00-100-005

- (1) Clean the nose radome area for the radome boot installation.

NOTE: Use a clean cloth to clean the area to keep from contamination.

SUBTASK 53-52-00-400-001

- (2) Cut the radome boot 0.25 in. (0.64 cm) above the cut line. The cut line (end line) is at STA 138.6.

NOTE: Make the cuts as smooth as possible and avoid jagged edges.

SUBTASK 53-52-00-400-002

- (3) Put the radome boot on the nose radome.

- (a) Align the radome boot to the center of the nose radome.

SUBTASK 53-52-00-400-003

- (4) Apply Scotch Brand No.471 tape, G02219 at 3 locations on the nose radome and the radome boot (Figure 202).

NOTE: The markings will be used to align the radome boot to the same location after the protective lining is removed.

SUBTASK 53-52-00-400-004

- (5) Apply the wet solution to the radome boot.

NOTE: The wet solution is made from 25% isopropyl alcohol, 75% water, and 1 teaspoon of a dishwashing liquid per 1 gallon (3.8 liters).

NOTE: The wet solution prevents the adhesive from sticking to itself.

SUBTASK 53-52-00-400-005

- (6) Turn the inner surface of the radome boot out.

SUBTASK 53-52-00-000-005

- (7) Remove the protective lining:

- (a) Slowly and carefully remove the protective lining.

- (b) Apply the wet solution to the nose radome adhesive during the lining removal.

NOTE: The wet solution is made from 25% isopropyl alcohol, 75% water, and 1 teaspoon of a dishwashing liquid per 1 gallon (3.8 liters).

NOTE: The wet solution prevents the adhesive from sticking to itself.

EFFECTIVITY  
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-52-00-400-007

- (8) Turn the inner surface of the radome boot out again.

NOTE: The adhesive side of the radome boot should be facing the nose radome.

SUBTASK 53-52-00-400-008

- (9) Align the 3 marks on the radome boot to the 3 correct locations on the nose radome.

SUBTASK 53-52-00-400-009

- (10) Apply the wet solution to the adhesive side of the radome boot.

SUBTASK 53-52-00-400-006

- (11) Put the radome boot back on the nose radome.

SUBTASK 53-52-00-400-010

- (12) Use the plastic squeegee, STD-821 to make the radome boot smooth.

(a) Start at the center of the radome boot.

(b) Slowly remove the trapped air bubbles and the wet solution with the plastic squeegee, STD-821.

SUBTASK 53-52-00-400-011

- (13) If there are trapped air bubbles:

NOTE: Small bubbles less than 0.125 in. (0.318 cm) will evaporate by themselves in less than one week.

(a) Slowly and carefully remove the radome boot.

(b) Apply the wet solution to the area.

(c) Slowly remove the trapped air bubbles and the wet solution with the plastic squeegee, STD-821.

SUBTASK 53-52-00-400-012

- (14) Dry the surface of the radome boot.

(a) Allow the radome boot to dry for one hour at 70°F (21°C).

SUBTASK 53-52-00-400-013

- (15) Paint the nose radome boot if applicable:

(a) Scuff the boot lightly with very fine abrasive Scotch-Brite 7447 pad, G50220.

(b) Solvent clean using isopropyl alcohol, B50073, by doing the following:

1) Dispense solvent from the container onto a very fine abrasive Scotch-Brite 7447 pad, G50220, or BMS15-5, Class A cotton wiper, G00034.

2) Wipe the surface with the solvent soaked abrasive pad and/or wiper, as applicable.



DO NOT LET THE SOLVENT DRY WHEN YOU CLEAN. IF YOU DO,  
IT WILL NOT REMOVE ALL CONTAMINATION.

**CAUTION**

3) Immediately wipe the surface dry with a clean, dry cotton wiper, G00034, before the applied solvent completely evaporates.

(c) Application of BMS10-127, Type 1, Grade F chemical reactivator over the protective boot is optional, do this task: TASK 51-21-99-370-801, Paragraph Q.

EFFECTIVITY  
LOM ALL

**53-52-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



**CAUTION**  
DO NOT APPLY PRIMER ON THE POLYURETHANE BOOT. IF YOU  
APPLY THE PRIMER ON THE POLYURETHANE BOOT, IT CAN CAUSE A  
DEFECTIVE BOND OF THE SUBSEQUENT TOP LAYER.

- (d) Paint the nose radome with exterior decorative coating, do this task: Decorative Exterior Paint System Application, TASK 51-21-99-300-801.

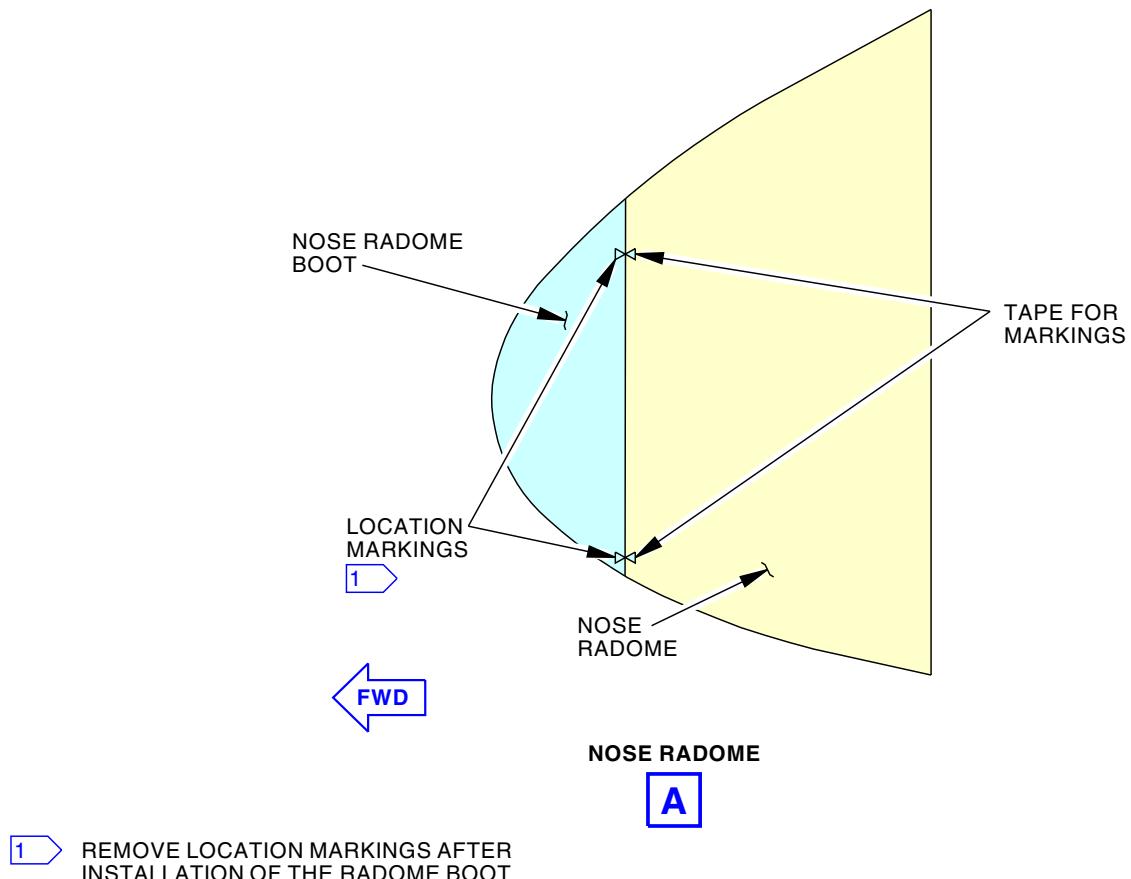
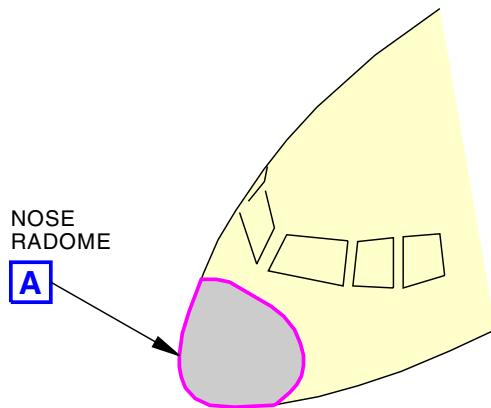
———— END OF TASK ————

— EFFECTIVITY —  
**LOM ALL**

**53-52-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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**Radome Boot Installation**  
**Figure 202/53-52-00-990-804**

EFFECTIVITY  
LOM ALL

**53-52-00**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 210  
Feb 15/2020



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL  
NOSE RADOME - REMOVAL/INSTALLATION

**1. General**

- A. This procedure contains two tasks:
- (1) A removal of the nose radome
  - (2) An installation of the nose radome.

**TASK 53-52-00-000-801**

**2. Nose Radome Removal**

(Figure 401)

**A. General**

- (1) Two mechanics are necessary to do this task.

**B. Location Zones**

Zone	Area
111	Radome

**C. Nose Radome Removal**

SUBTASK 53-52-00-860-001

- (1) Open this circuit breaker and install safety tag:

**F/O Electrical System Panel, P6-1**

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

SUBTASK 53-52-00-020-001

- (2) Remove the bolts [14] that attach the aft edge of the nose radome [15] to the clips [13] on the fuselage bulkhead.

SUBTASK 53-52-00-010-001



**WARNING**

DO NOT OPEN THE NOSE RADOME IF THE WIND IS MORE THAN 15 KNOTS. IF YOU OPEN THE NOSE RADOME IN A WIND, THE RADOME CAN MOVE QUICKLY. THIS CAN CAUSE INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.

- (3) Open the radome and hold it in the open position by the installation of the support rods on each side.

SUBTASK 53-52-00-020-002

- (4) Disconnect the end of the radome assembly bonding jumper that is connected to the clips [13] on the fuselage bulkhead.

SUBTASK 53-52-00-020-003



**WARNING**

GET SUFFICIENT AID FROM OTHER PERSONNEL AND EQUIPMENT TO HOLD THE COMPONENT DURING THE REMOVAL, AND INSTALLATION. THE COMPONENT IS HEAVY. THIS WILL PREVENT INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (5) Remove the bolts [9], washers [10] and nuts [11] that attach the hinge arms [7] to the hinge brackets [1] on the nose radome [15].

- (a) Remove the nose radome [15] from the fuselage.

EFFECTIVITY  
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

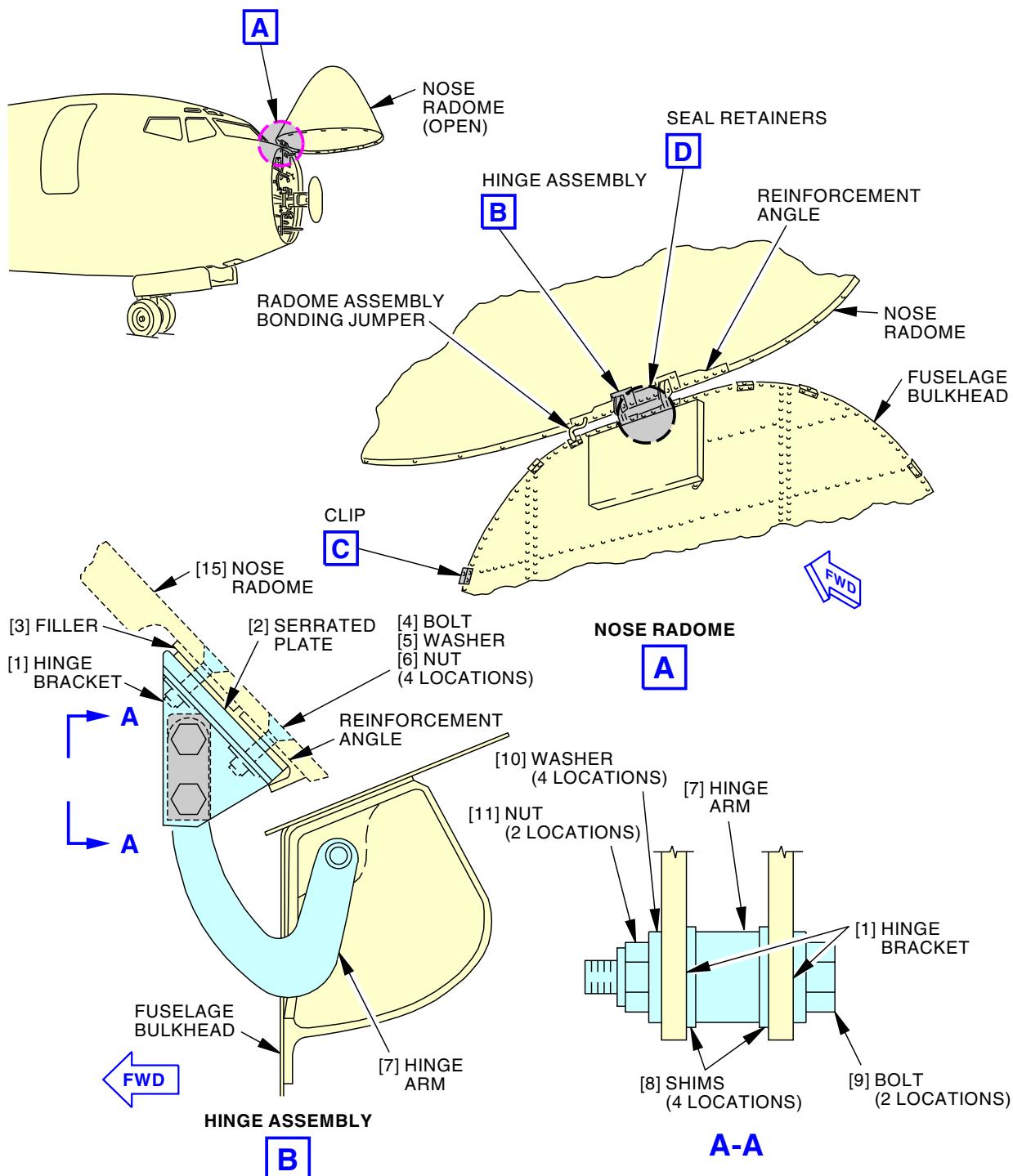
- (b) When you remove the bolts [9], prepare to catch the shims [8] that are installed between the hinge arms [7] and the hinge brackets [1].
- (c) Make a record of the installed positions of the shims [8].

NOTE: Shims should be installed on the same positions during nose radome installation.

———— END OF TASK ————

— EFFECTIVITY —  
**LOM ALL**

**53-52-00**

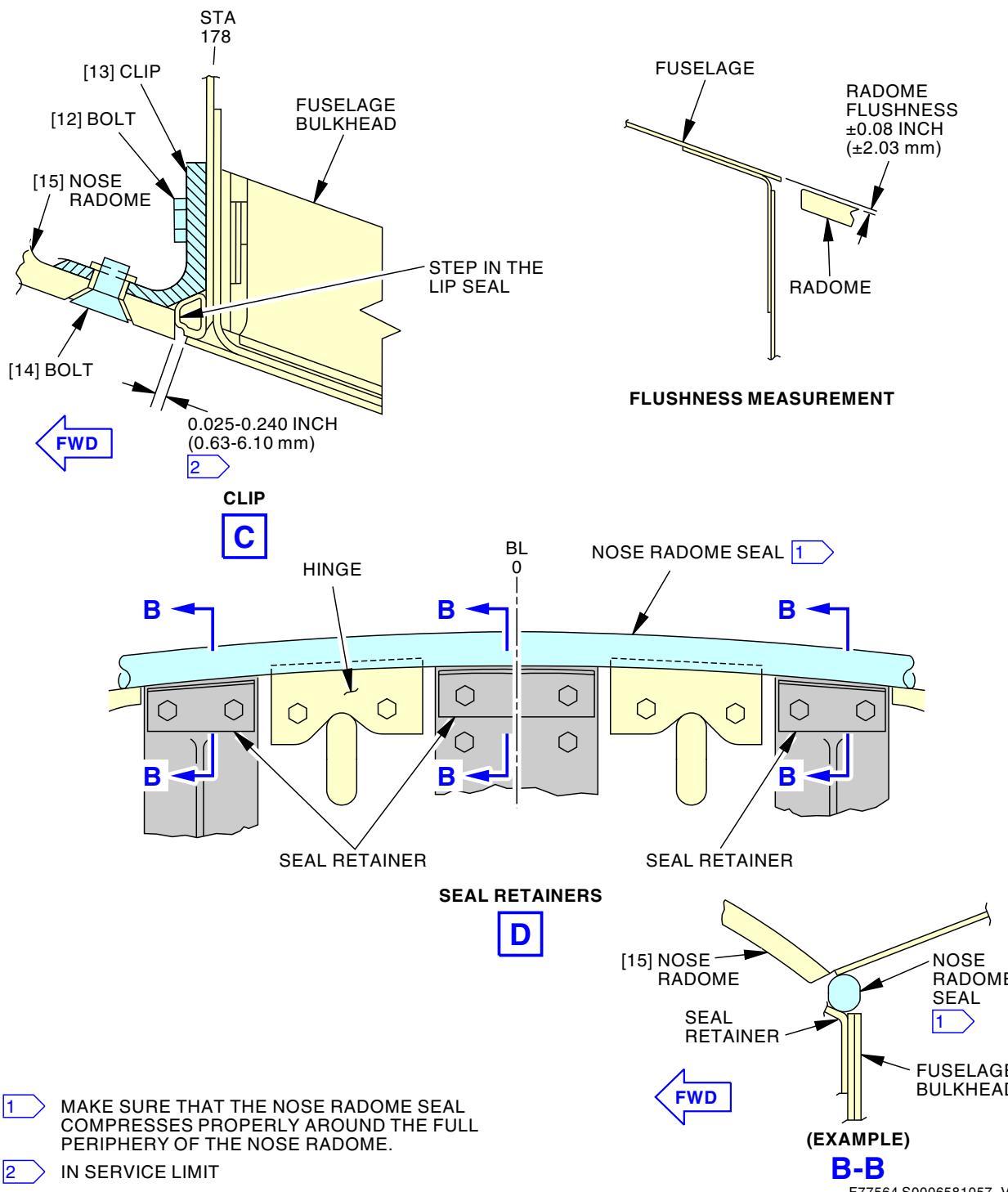


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**Nose Radome Installation**  
**Figure 401/53-52-00-990-816 (Sheet 1 of 3)**

EFFECTIVITY  
LOM ALL

**53-52-00**

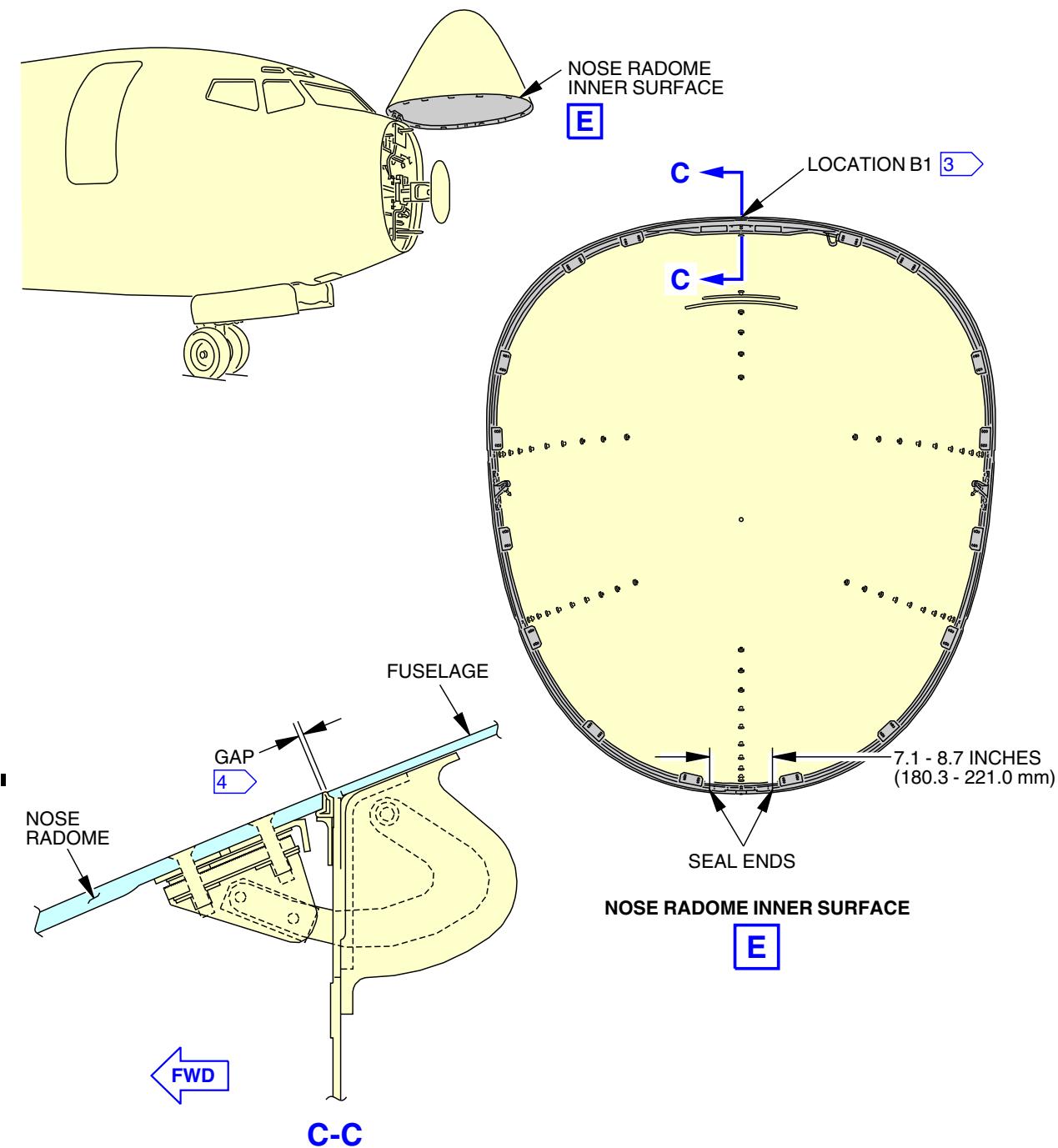


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Nose Radome Installation  
Figure 401/53-52-00-990-816 (Sheet 2 of 3)

EFFECTIVITY  
LOM ALL

**53-52-00**



- 3** GAP AT LOCATION B1 IS 0.046 TO 0.216 INCH (1.17 TO 5.49 mm)
- 4** ONLY MEASURE THE GAP WHEN NOSE RADOME IS FULLY CLOSED.

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**Nose Radome Installation**  
Figure 401/53-52-00-990-816 (Sheet 3 of 3)

EFFECTIVITY	
LOM ALL	

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-52-00-400-801**

**3. Nose Radome Installation**

(Figure 401)

**A. General**

- (1) Two mechanics are necessary to do this task.

**B. References**

Reference	Title
20-30-89-910-801	Final Cleaning of Solvent Sensitive Organic Coatings Prior to Non-structural Bonding (Series 89) (P/B 201)

**C. Tools/Equipment**

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

Reference	Description
COM-614	Bonding Meters - Non-Intrinsically Safe (For use in outside Class I, Divisions I & II non-hazardous locations. For hazardous locations, use COM-1550). Part #: 247000 Supplier: 00426 Part #: 620LK Supplier: 1CRL2 Part #: BLR-0003-XX Supplier: KC432 Part #: BT51 Supplier: 00426 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659 Opt Part #: 247001 Supplier: 00426
COM-1550	Bonding Meter - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659

**D. Consumable Materials**

Reference	Description	Specification
A00281	Adhesive - Dow Corning 3145 RTV	MIL-A-46146 (BAC5010 Type 79)
A00335	Adhesive - Silicone Rubber, 2 Part, RTV	BAC5010 Type 68
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B01009	Solvent - Final Cleaning Of All Organic Ctgs Before Non-Structural Bonding (AMM 20-30-89) - Series 89	
D50004	Compound - Antiseize	BMS3-28

**E. Expendables/Parts**

AMM Item	Description	AIPC Reference	AIPC Effectivity
15	Nose radome	53-52-00-03A-204	LOM ALL

EFFECTIVITY  
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

(Continued)

<b>AMM Item</b>	<b>Description</b>	<b>AIPC Reference</b>	<b>AIPC Effectivity</b>
15 (cont.)		53-52-00-03A-230	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999

**F. Location Zones**

<b>Zone</b>	<b>Area</b>
111	Radome

**G. Prepare for the Installation**

SUBTASK 53-52-00-110-001

- (1) Install the erosion protection and the lightning diverter strips where it is necessary.

SUBTASK 53-52-00-420-008

- (2) Install the hinge brackets [1], serrated plates [2], and fillers [3] on the nose radome [15] with the bolts [4], washers [5] and nuts [6].

NOTE: For new nose radome only.

NOTE: These brackets can push on the flange of the reinforcement angle.

SUBTASK 53-52-00-420-009

- (3) Torque the bolts [4] to 65 in-lb (7.3 N·m) - 70 in-lb (7.9 N·m).

SUBTASK 53-52-00-210-016

- (4) Make sure that this circuit breaker is open and has safety tag:

**F/O Electrical System Panel, P6-1**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
D	13	C00120	WEATHER RADAR RT

SUBTASK 53-52-00-820-002



**WARNING**

GET SUFFICIENT AID FROM OTHER PERSONNEL AND EQUIPMENT TO HOLD THE COMPONENT DURING THE REMOVAL, AND INSTALLATION. THE COMPONENT IS HEAVY. THIS WILL PREVENT INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (5) Hold the radome adjacent to the fuselage bulkhead until the hinge brackets [1] can be engaged with the hinge arms [7] on the bulkhead.

SUBTASK 53-52-00-420-003

- (6) Install the shims [8], where it is necessary, between the hinge brackets [1] and the hinge arms [7], and install the bolts [9].
  - (a) Use a record made during nose radome removal procedure.

**H. Nose Radome Installation**

SUBTASK 53-52-00-410-001



**CAUTION**

YOU MUST BE CAREFUL WHEN YOU LOWER THE RADOME TO THE CLOSED POSITION AFTER THE INSTALLATION OF THE HINGE. IF YOU ARE NOT CAREFUL WHEN YOU LOWER THE RADOME, THE TOP AFT EDGE OF THE RADOME CAN HIT THE FUSELAGE SKIN AND CAUSE DAMAGE.

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**53-52-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(CAUTION PRECEDES)



**CAUTION**

DO NOT PUT A COVER ON THE DRAIN OPENING WITH A TAPE. THE RADOME CAN COLLAPSE BECAUSE THE OPENING DRAINS THE RADOME AND EQUALIZES EXTERNAL AND INTERNAL RADOME PRESSURE. IF YOU DO NOT OBEY THESE INSTRUCTIONS, DAMAGE TO EQUIPMENT CAN OCCUR.

- (1) Remove the radome support rods, if used.

SUBTASK 53-52-00-420-012

- (2) Install the support rods in their storage clips on the forward pressure bulkhead.

SUBTASK 53-52-00-410-010

- (3) Lower the radome carefully to the closed position.

SUBTASK 53-52-00-210-007

- (4) Make sure that the top aft edge does not hit the fuselage skin.

SUBTASK 53-52-00-210-018



**CAUTION**

MAKE SURE THAT THE SEAL ENDS DO NOT TOUCH AT THE BOTTOM OF THE BULKHEAD. THERE MUST BE AN OPENING OF 7.1 INCH (18.0 CM) AT THE BOTTOM OF THE BULKHEAD TO LET THE RADOME DRAIN. IF YOU DO NOT OBEY THESE INSTRUCTIONS, DAMAGE TO EQUIPMENT CAN OCCUR.

- (5) Make sure that the seal ends do not touch at the bottom of the bulkhead.

- (a) Make sure that there is an opening of 7.1 in. (18.0 cm) to 8.7 in. (22.1 cm) at the bottom of the bulkhead.

SUBTASK 53-52-00-020-005

- (6) If you find an interference, do these steps:

- (a) Lift and hold the radome in an open position.
  - (b) Loosen the bolts [4] of the hinge bracket [1].
  - (c) Move the nose radome forward to remove the interference and tighten the bolts [4].

SUBTASK 53-52-00-210-008

- (7) Examine the nose radome seal for rough and damaged areas.

SUBTASK 53-52-00-210-009

- (8) Make sure that the seal is bonded to the bulkhead along its entire length.

SUBTASK 53-52-00-020-007

- (9) If it is necessary, replace the seal as follows:



**WARNING**

DO NOT GET SOLVENTS IN YOUR MOUTH, YOUR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. SOLVENTS ARE DANGEROUS MATERIALS. SOLVENTS CAN BE FLAMMABLE. OBEY THE MATERIAL SAFETY DATA SHEETS (MSDS) FOR SOLVENTS. OBEY LOCAL REGULATIONS FOR THE CORRECT PROCEDURES TO USE OR DISCARD SOLVENTS. SOLVENTS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (a) Clean the mating surfaces on the bulkhead with solvent, B00148, or Series 89 solvent, B01009 (TASK 20-30-89-910-801).

EFFECTIVITY  
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (b) Fill the 1 in. (25 mm) to 1.25 in. (32 mm) ends of the seal with adhesive, A00335.  
NOTE: It is permitted to use Dow Corning 3145 RTV adhesive, A00281 (BAC5010, TYPE 79), as an alternative adhesive.
- (c) Bond the seal to the bulkhead with adhesive, A00335, along the entire length of the seal.  
NOTE: It is permitted to use Dow Corning 3145 RTV adhesive, A00281 (BAC5010, TYPE 79), as an alternative adhesive.



**CAUTION**

MAKE SURE THAT THE SEAL ENDS DO NOT TOUCH AT THE BOTTOM OF THE BULKHEAD. THERE MUST BE AN OPENING OF 7.1 INCH (18.0 CM) AT THE BOTTOM OF THE BULKHEAD TO LET THE RADOME DRAIN. IF YOU DO NOT OBEY THESE INSTRUCTIONS, DAMAGE TO EQUIPMENT CAN OCCUR.

- 1) Make sure that the seal ends do not touch at the bottom of the bulkhead.
  - a) Make sure that there is an opening of 7.1 in. (18.0 cm) to 8.7 in. (22.1 cm) at the bottom of the bulkhead (View E, Figure 401 (Sheet 3)).
- (d) Let the adhesive, A00335, or Dow Corning 3145 RTV adhesive, A00281, dry for 24 hours.

**SUBTASK 53-52-00-210-012**

- (10) Examine the clips [13] on the fuselage bulkhead as follows:
- (a) Carefully examine the areas adjacent to the hinges for binding on the radome when you move the radome to the closed position.
  - (b) If binding was noted, the clips [13] need to be adjusted.

**SUBTASK 53-52-00-020-008**

- (11) If an adjustment is necessary at clips [13], do these steps:
- (a) Loosen the fuselage bulkhead bolts [12] on the applicable clip [13] where binding was noted and move the clips inboard.
    - 1) Move the clips [13] inboard just enough so that the nose radome no longer binds when it is lowered into position.



**CAUTION**

WHEN LOWERING RADOME, BULB SEAL MAY BECOME PINCHED BETWEEN RADOME AND FUSELAGE SKIN CAUSING THE BULB SEAL TO TEAR OR BE PULLED OUT OF POSITION. WHILE THE RADOME IS BEING LOWERED, CAREFULLY WORK THE BULB SEAL INTO PROPER POSITION USING A FLAT NON-METALLIC SPATULA.

- (b) Lower the radome to the closed position.
- (c) Apply compound, D50004, to the threads of the countersunk bolt [14] and install the bolt [14].
- (d) Tighten the countersunk bolt [14] sufficiently to pull the clip into contact with the inner face of the radome.
- (e) Remove the bolt [14].
- (f) Open the radome carefully to prevent movement of the adjusted clip [13].
- (g) Torque the bolts [12] that attach the clip [13] to the fuselage bulkhead to 100 in-lb (11.3 N·m) - 125 in-lb (14.1 N·m).

EFFECTIVITY  
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-52-00-760-004

- (12) Measure the electrical bonding resistance between the clip [13] and airplane structure with an intrinsically safe approved bonding meter, COM-1550, or non-intrinsically safe bonding meter, COM-614.

NOTE: It is necessary where the radome clip contacts to the radome conductor strap.

- (a) Make sure that the electrical resistance is 0.01 ohm (10 milliohms) or less.

SUBTASK 53-52-00-100-007

- (13) Make sure that the mating surfaces of the bonding jumper and clip [13] are clean and bright.

SUBTASK 53-52-00-420-015

- (14) Connect the bonding jumper to the clip [13] on the fuselage bulkhead.

SUBTASK 53-52-00-760-005

- (15) Measure the electrical bonding resistance between the bonding jumper and radome clip with an intrinsically safe approved bonding meter, COM-1550, or non-intrinsically safe bonding meter, COM-614.

- (a) Make sure that the electrical resistance is 0.001 ohm (1 milliohm) or less.

SUBTASK 53-52-00-210-014

- (16) With the radome in a closed position, make sure that the screw holes of the radome attachment are aligned with the holes in the attachment clips.

SUBTASK 53-52-00-420-005



**CAUTION**

DO NOT USE TOO MUCH FORCE TO ALIGN THE HOLES. YOU CAN CAUSE DAMAGE TO THE CLIPS AND THE RADOME.

- (17) If the adjustment is necessary, use manual force to adjust the radome position to align the screw holes.

SUBTASK 53-52-00-420-006

- (18) Install the countersunk bolts [14] with the compound, D50004, in the aft edge of the radome.

SUBTASK 53-52-00-420-014

- (19) Torque the bolts [14] to 120 in-lb (13.6 N·m) - 150 in-lb (16.9 N·m).

SUBTASK 53-52-00-210-015

- (20) Make sure that the seal engages correctly and the radome clearances are correct.

SUBTASK 53-52-00-860-004

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

**F/O Electrical System Panel, P6-1**

<b>Row</b>	<b>Col</b>	<b>Number</b>	<b>Name</b>
D	13	C00120	WEATHER RADAR RT

———— END OF TASK ————

EFFECTIVITY  
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**53-52-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

NOSE RADOME - INSPECTION/CHECK

**1. General**

- A. This procedure contains one task. This task is the check of the nose radome.

**TASK 53-52-00-200-801**

**2. Nose Radome - Inspection**

(Figure 601)

**A. References**

Reference	Title
05-51-19-210-804	Phase I Examination (P/B 201)
05-51-19-210-805	Phase II Inspection (P/B 201)
53-52-00-010-802	Nose Radome - Open (P/B 201)
53-52-00-410-802	Nose Radome - Close (P/B 201)
53-52-03-000-801	Remove the Lightning Diverter Strips (P/B 201)
53-52-03-000-802	Remove the Conductor Straps (P/B 401)
53-52-03-300-801	Lightning Diverter Strip Temporary Repair (P/B 801)
53-52-03-400-801	Install the Lightning Diverter Strip (P/B 201)
53-52-03-400-802	Install the Conductor Straps (P/B 401)
53-52-31-000-801	Glide Slope Director Bar Removal (P/B 401)
53-52-31-400-801	Glide Slope Director Bar Installation (P/B 401)
737 NDT Part 9, 51-00-01	Inspection for Water or Ice in Honeycomb Parts
SRM 51-00-01	Fuselage- Repair Nose Radome
SRM 53-10-72	Repair General - Nose Radome
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES

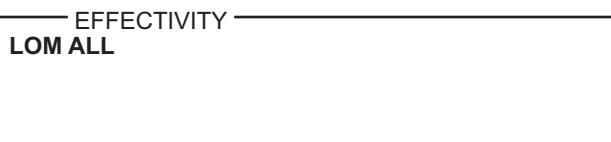
**B. Tools/Equipment**

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
COM-2010	Equipment - Moisture Indicator/Register, RADOME  Part #: MRC005574 Supplier: OCT97 Part #: MRC006507 Supplier: OCT97

**C. Location Zones**

Zone	Area
111	Radome



**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**D. Nose Radome Inspection**

SUBTASK 53-52-00-210-001

- (1) You must do a check of the nose radome to see if there are lightning strikes (Phase I Examination, TASK 05-51-19-210-804 and Phase II Inspection, TASK 05-51-19-210-805).

SUBTASK 53-52-00-210-002

- (2) Do a check for damage such as holes, scuffs, cracks, blisters, and delamination.

NOTE: You can locate the delamination if you lightly hit the radome skin with a small metal object such as a short socket extension and listen for changes in the sound.

SUBTASK 53-52-00-280-001

- (3) Do a check for moisture.

- (a) Moisture that enters the honeycomb cells of a radome can cause the radar transmission to decrease. Periodic radome inspection is necessary to ensure sufficient radar transmission. Water that is entrapped in the honeycomb cells can be detected with the three methods that follow.
  - (b) There are three radome moisture inspection methods. The recommended method 1 is the moisture meter inspection method. Two alternative methods are electronic thermography inspection method and liquid crystal sheets method. (737 NDT Part 9, 51-00-01 and SRM 51-00-01).

- (4) Use the moisture indicator/register RADOME equipment, COM-2010, to do a check for moisture as follows:

NOTE: The moisture indicator/register RADOME equipment, COM-2010, indicates pockets in aircraft radomes by measuring the radio frequency dielectric power loss of the material in contact with the moisture indicator/register RADOME equipment, COM-2010, gun. The radio frequency depth of penetration is approximately 2.5 in. (6.4 cm). Any conductive materials such as water, aluminum, or metallic fasteners within 3 in. (7.6 cm) from the gun will cause the meter to read high. It is important that all metallic parts be removed from the area on the radome that is being tested for moisture content.

- (a) Hold the gun part of the moisture indicator/register RADOME equipment, COM-2010, a minimum of 3 in. (7.6 cm) from each part.
  - (b) Push the ON-OFF switch, on the case, to the ON position.
  - (c) Put the sensor head on the inner surface of the radome.
    - 1) Make sure that all the electrodes contact the radome surface.
    - 2) If it is necessary, apply light force to make sure that the sensor head contacts the radome surface.

- (d) Move the sensor head over all of the inner surface of the radome.

NOTE: The sensor head must touch the full inner surface of the radome. To perform an adequate inspection, the sensor must be indexed at an interval of 1 in. (25 mm) or less.

- (e) In areas that cause a meter reading of 20 or greater, put the sensor head away from the center of the indication (in an adjacent area with a reading of less than 20) Monitor the meter reading as you move the sensor head toward the of the area.
  - (f) To identify the area of entrapped water, make marks on the radome at the position of the electrodes closest to the entrapped water when the meter reading increases to 20.
  - (g) You must dry and then seal all of the areas where you find moisture.

EFFECTIVITY  
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**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 1) Do these steps until the boundary of the entrapped water is marked.
- (h) If there is moisture, dry the radome and refer to SRM 53-10-72 to remove the moisture and seal it.

**Table 601/53-52-00-993-802 RADOME CONDITION NUMERICAL SCALE**

RADOME CONDITION	COLOR	NUMERICAL SCALE	ALLOWABLE SURFACE AREA of WATER
Good	Green	0 to 5	4 in. (102 mm) diameter or equivalent area
Fair	Yellow	5 to 10	
Poor	Orange	10 to 20	

NOTE: Unlimited 1-inch (25.4 mm) diameter areas of water are allowed if they are spaced more than 10 inches (254.0 mm) apart.

- (5) Electronic Thermography (alternative) Inspection Method
  - (a) Refer to the 737 NDT Part 9, 51-00-01 for equipment, calibration and inspection instructions.
 

NOTE: The inspection can be performed from either side of the radome.
  - (b) Examine the entire surface of the radome.
 

NOTE: Areas that contain entrapped water will appear cold.
  - (c) Monitor the surface of the radome with the infrared camera while you use a marker to put a mark at the boundary of the entrapped water.
  - (d) If the area that you marked is greater than the allowable area shown in Table 602, remove the moisture in the marked area and seal it (SRM 53-10-72).
- (6) Liquid Crystal (alternative) Inspection Method
  - (a) Refer to the 737 NDT Part 9, 51-00-01 for equipment, calibration and inspection instructions.
 

NOTE: The inspection can be performed from either side of the radome.
  - (b) Examine the entire surface of the radome.
 

NOTE: Areas that contain entrapped water will appear cold.
  - (c) Monitor the surface of the radome with the liquid crystal sheets while you use a marker to put a mark at the boundary layer of the entrapped water on the transparent template.
  - (d) If the area that you marked is greater than the allowable area shown in Table 602, remove the moisture in the marked area and seal it (SRM 53-10-72).

**Table 602/53-52-00-993-803 RADAR CONDITION MOISTURE ACCEPTANCE CRITERIA**

Moisture Meter Reject Level	Allowable Surface Area of Water
20	(4 in. (102 mm) diameter or equivalent area

NOTE: Unlimited 1-inch (25.4 mm) diameter areas of water are allowed if they are spaced more than 10 inches (254.0 mm) apart.

#### E. Inspection of the Conductor Straps and Diverter Strips

SUBTASK 53-52-00-010-004

- (1) Open the radome (TASK 53-52-00-010-802).

EFFECTIVITY LOM ALL
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**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-52-00-210-003

- (2) Do the visual check that follows:

- Examine the conductor straps for tears, loose areas, burned areas, and general deterioration.
- Examine the aluminum diverter strips for loose fasteners, burned areas, and corrosion.

NOTE: Sharp corners, or points on the conductive strip can cause radio interference.

SUBTASK 53-52-00-280-002

- (3) Measure the electrical bonding resistance between the ends of the diverter strips (SWPM 20-20-00).

- Use an intrinsically safe approved bonding meter, COM-1550.

NOTE: Use a test probe with a sharp point to go through the paint or epoxy on the strip.

- Make sure that the electrical bonding resistance is 0.01 ohms or less.

SUBTASK 53-52-00-280-003

- (4) Measure the electrical bonding resistance between the conductor strap and diverter strip in Figure 601 (SWPM 20-20-00).

- Use an intrinsically safe approved bonding meter, COM-1550.

- Make sure that the electrical bonding resistance is 0.01 ohms or less.

SUBTASK 53-52-00-280-005

- (5) Measure the electrical bonding resistance between the radome clips and airframe bulkhead (SWPM 20-20-00).

NOTE: Required only where the radome clip contacts the radome conductor strap.

- Use an intrinsically safe approved bonding meter, COM-1550.

- Make sure that the electrical bonding resistance is 0.01 ohms or less.

SUBTASK 53-52-00-410-009

- (6) Close the radome (TASK 53-52-00-410-802).

SUBTASK 53-52-00-280-004

- (7) Measure the electrical bonding resistance between the conductor straps on the radome and body structure skin (SWPM 20-20-00).

NOTE: Required only where the radome clip contacts the radome conductor strap.

- Use an intrinsically safe approved bonding meter, COM-1550.

- Make sure that the electrical bonding resistance is 0.03 ohms or less.

SUBTASK 53-52-00-210-004

- (8) If there is damage, repair or replace the conductor straps and diverter strips .

- Lightning Diverter Strip Temporary Repair, TASK 53-52-03-300-801
- Remove the Lightning Diverter Strips, TASK 53-52-03-000-801
- Install the Lightning Diverter Strip, TASK 53-52-03-400-801
- Remove the Conductor Straps, TASK 53-52-03-000-802
- Install the Conductor Straps, TASK 53-52-03-400-802.

EFFECTIVITY  
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**F. Inspection of the Director Bar for the Glide Slope Antenna**

SUBTASK 53-52-00-210-005

- (1) Do a check for damage of the director bar for the glide slope antenna.

NOTE: The antenna director bar is a 13 in. (33 cm) continuous strip of aluminum foil tape. The strip is installed horizontally across the centerline on the inner surface of the nose radome.

SUBTASK 53-52-00-210-006

- (2) Make sure that the attachment of the director bar is satisfactory.

SUBTASK 53-52-00-960-001

- (3) If you find damage or an unsatisfactory bond of the director bar for the glide slope antenna replace the director bar.
  - (a) Do this task: Glide Slope Director Bar Removal, TASK 53-52-31-000-801.
  - (b) Do this task: Glide Slope Director Bar Installation, TASK 53-52-31-400-801.

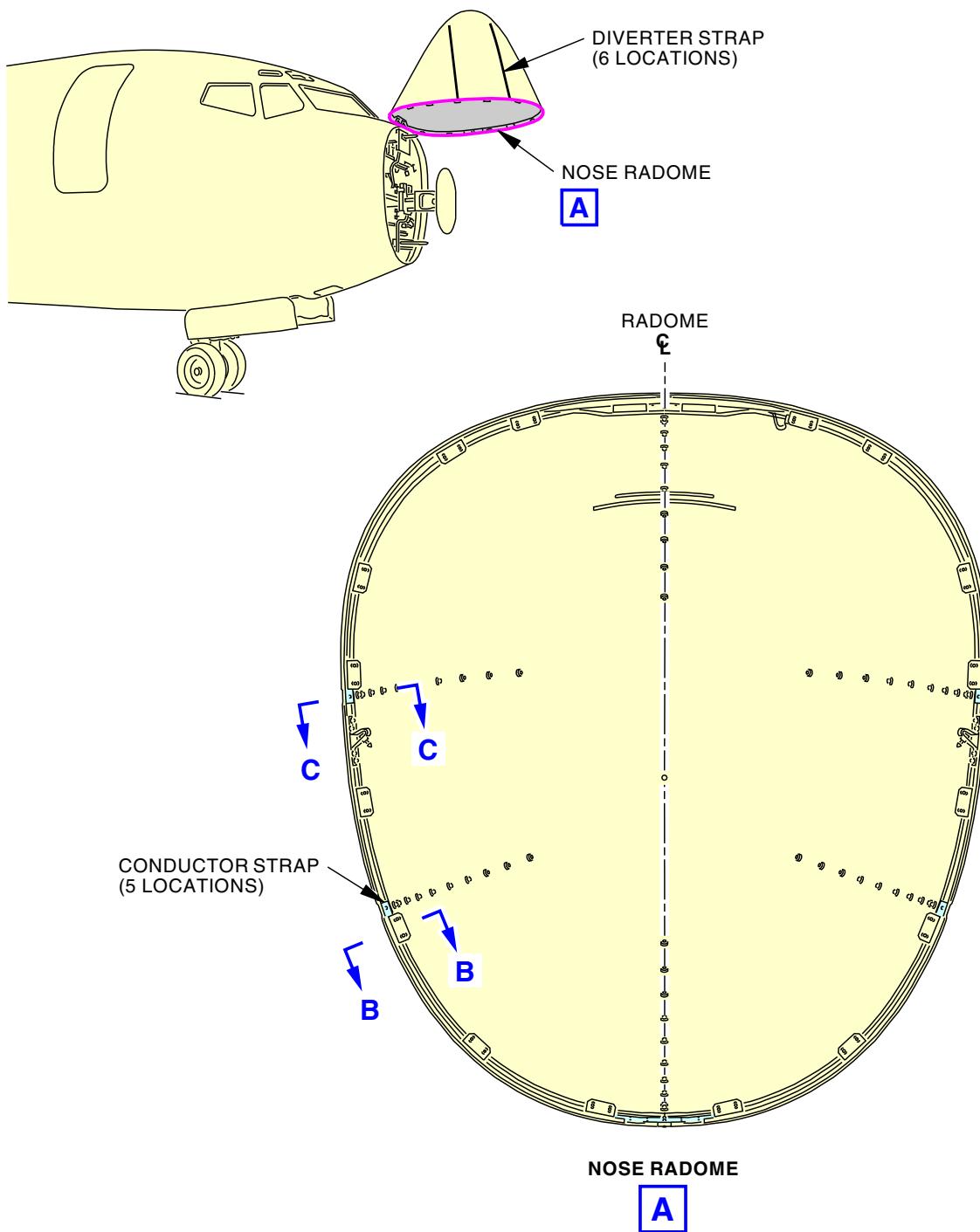
———— END OF TASK ————

EFFECTIVITY  
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**53-52-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Nose Radome Check  
Figure 601/53-52-00-990-813 (Sheet 1 of 2)

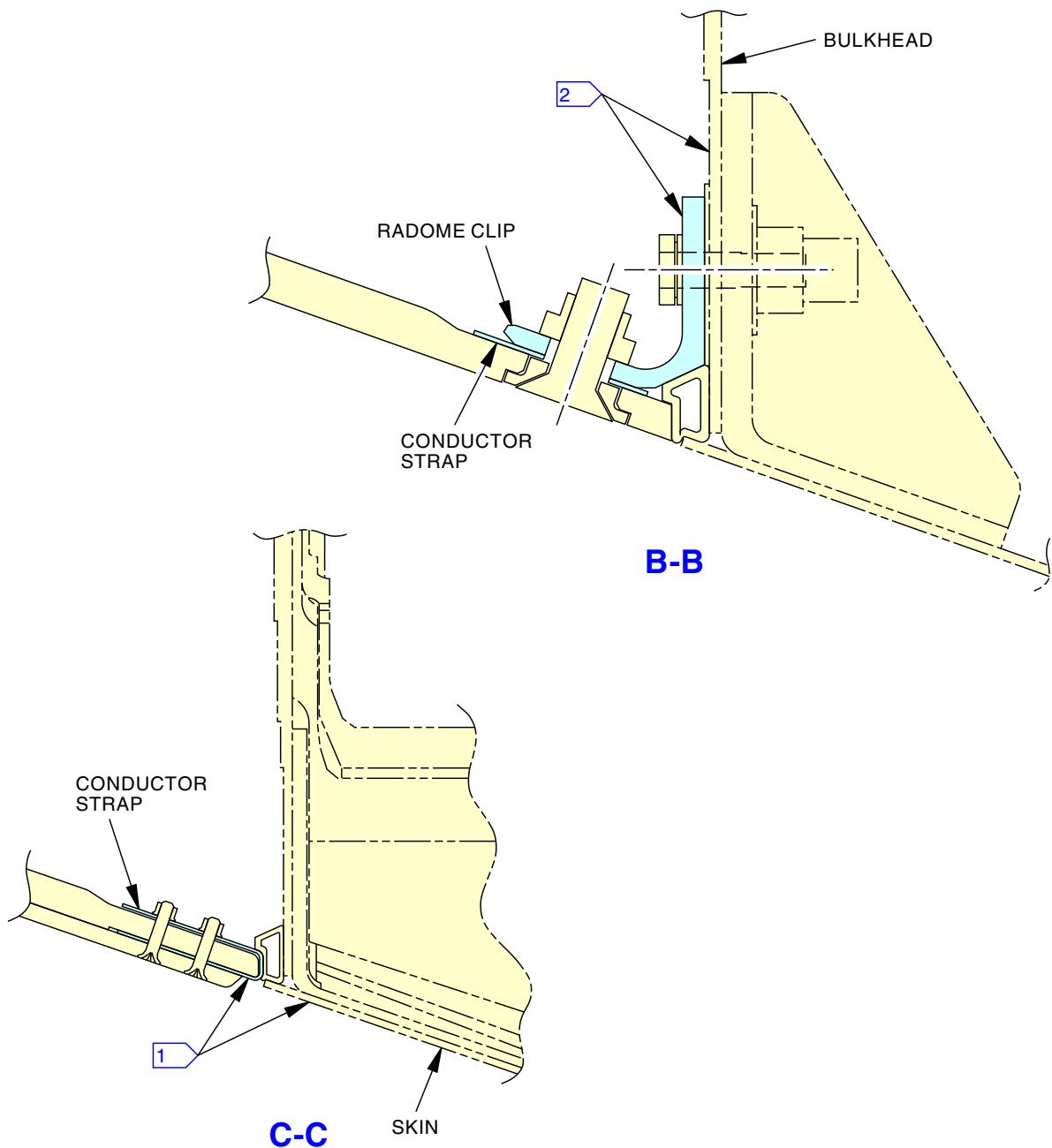
EFFECTIVITY  
LOM ALL

**53-52-00**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 606  
Feb 15/2023



- [1] >** ELECTRICAL RESISTANCE BETWEEN THESE SURFACES MUST NOT EXCEED 0.03 OHMS.
- [2] >** ELECTRICAL RESISTANCE BETWEEN THESE SURFACES MUST NOT EXCEED 0.01 OHMS.

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**Nose Radome Check**  
**Figure 601/53-52-00-990-813 (Sheet 2 of 2)**

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

**53-52-00**

 Page 607  
 Feb 15/2023





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

NOSE RADOME - CLEANING/PAINTING

**1. General**

A. This procedure contains these tasks:

- (1) Nose Radome Cleaning/Painting.

NOTE: A nose radome protective boot can be used in place of the BMS 10-60, Type II, enamel coating, C50075. The finish sequence prior to applying the protective boot can be found in TASK 53-52-00-370-801, Paragraph G. If a protective boot is not being installed, finish the radome per TASK 53-52-00-370-801, Paragraph F.

**TASK 53-52-00-370-801**

**2. Nose Radome - Cleaning/Painting**

**A. References**

Reference	Title
51-21-11 P/B 701	PAINT STRIPPING - CLEANING/PAINTING
51-21-21-100-802	Cleaning and Preparation of Internal and External Plastic Surfaces (P/B 701)
51-21-71-370-803	Apply BMS 10-21 Type IV Conductive Coating To Specified External Surfaces (P/B 701)
51-21-72-370-802	BMS10-103, Type 1, Primer - Application (P/B 701)
51-21-73-370-803	BMS10-60 Topcoat Application (P/B 701)
51-21-99-300-801	Decorative Exterior Paint System Application (P/B 701)
53-52-00-400-802	Nose Radome Protective Boot Installation (P/B 201)
53-52-03-000-801	Remove the Lightning Diverter Strips (P/B 201)
53-52-03-400-801	Install the Lightning Diverter Strip (P/B 201)
SRM 53-10-72-2R-0	REPAIR GENERAL - Nose Radome

**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-1793	Multimeter - Digital/Analog (or equivalent meter meets task requirements) Part #: 117 Supplier: 89536 Part #: 260-8XPI Supplier: 55026 Part #: 287 Supplier: 89536 Part #: 289 Supplier: 89536 Part #: 87V Supplier: 89536 Part #: FLUKE 27 II Supplier: 89536 Part #: FLUKE-77-4 Supplier: 89536 Opt Part #: 187 Supplier: 89536 Opt Part #: 189 Supplier: 89536 Opt Part #: 21 Supplier: 89536 Opt Part #: 27 Supplier: 89536 Opt Part #: 77 SERIES III Supplier: 89536 Opt Part #: 87 Supplier: 89536 Opt Part #: FLUKE 27 Supplier: 89536 Opt Part #: MODEL 27 Supplier: 89536

EFFECTIVITY
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

(Continued)

<b>Reference</b>	<b>Description</b>
SPL-7885	Probe - Surface Resistivity Measurement Part #: ST895A-3-1 Supplier: 81205
SPL-10361	Probe - Film Resistance Measure Part #: F70328-1 Supplier: 81205 Opt Part #: ST895A-1 Supplier: 81205

**C. Consumable Materials**

<b>Reference</b>	<b>Description</b>	<b>Specification</b>
B50073	Alcohol - Isopropyl	ASTM D 770
C00766	Primer - Nonchromated Primer For Composites	BMS10-103 Type I
C00921	Coating - Exterior Decorative Paint	BMS10-72
C50075	Coating - Protective Enamel (BAC 707 Gray Color)	BMS10-60 Type II
C50219	Coating - Anti-Static Coating	BMS10-21 Type IV
C50316	Coating - Exterior Decorative Paint	AMS3095
G02219	Tape - Yellow Vinyl Adhesive, Scotch Brand No.471, 1.5 Inches (38.1 mm) Wide	
G50123	Rag - Epoxy Coated Tack Rag - C-60	
G50220	Pad - Abrasive, Scotch- Brite 7447	
G50509	Tape - Masking (3M Scotch Fine Line Tape 218)	AMS-T-21595
G50630	Tape - Copper Foil With Conductive Adhesive (3M 1181 Tape)	

**D. Location Zones**

<b>Zone</b>	<b>Area</b>
111	Radome

**E. Prepare to Paint the Nose Radome**

**SUBTASK 53-52-00-000-006**

- (1) Remove the lightning diverter strips from the radome (TASK 53-52-03-000-801).
  - (a) Identify the lightning diverter strips for re-installation.

**SUBTASK 53-52-00-370-032**

- (2) Use Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, to mask-off the conductor straps and holes from the removed lightning diverter strips on the radome.
  - (a) Make sure that coating, C50219, does not enter the conductor straps and holes from the removed lightning diverter strips on the radome.

**SUBTASK 53-52-00-150-001**

- (3) Remove the existing paint (PAGEBLOCK 51-21-11/701).

NOTE: This step is to make sure that the paint thicknesses are minimized.

**SUBTASK 53-52-00-100-002**

- (4) Clean and prepare the surface of the nose radome (TASK 51-21-21-100-802).

EFFECTIVITY
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**F. Paint the Nose Radome**

NOTE: These instructions are for the finishes of a radome without a boot.

NOTE: Thicknesses of paint which are more than 0.01 in. (0.254 mm) can decrease the necessary radome electrical transmission efficiency. A radome wall that has been repainted should be put back to its initial thickness, including paint thickness. If this is not done, radome transmission efficiency will be decreased (SRM 53-10-72-2R-0).

**SUBTASK 53-52-00-370-004**

- (1) Apply coating, C50219, to the entire nose radome surface (Figure 702, Figure 703).
  - (a) To apply coating, C50219, do this task: Apply BMS 10-21 Type IV Conductive Coating To Specified External Surfaces, TASK 51-21-71-370-803.
  - (b) If the anti-static coating is not overcoated within 24 hours, do the following before painting the next layer:
    - 1) Solvent clean using alcohol, B50073.
    - 2) Lightly abrade with very fine abrasive pad, Scotch-Brite 7447 pad, G50220.
    - 3) Solvent clean using alcohol, B50073.
    - 4) If necessary, use tack rag, G50123, to remove particulate contamination.
    - 5) Visually examine the anti-static coating surface to make sure that the coating is continuous (no bare areas).

**SUBTASK 53-52-00-860-013**

- (2) Determine the surface resistivity of the coating, C50219, using one of the following methods:
  - (a) To determine the surface resistivity using the square method, do the steps that follow:
    - 1) Cut two pieces of flexible bare 3M 1181 copper foil tape, G50630, with conductive adhesive each of length "L".
    - 2) Place the two pieces of tape at a distance of " $0.1L \pm 5$  percent" and parallel to each other.
    - 3) Press the two pieces of tape firmly against the anti-static coating.
    - 4) Connect the Ohmmeter probes to the tape.
    - 5) Read the number for resistance.
    - 6) Multiply the number for resistance by 10.
  - NOTE: The result is the resistivity of the anti-static coating.
  - 7) Make sure that the resistivity is between 1 and 100 megohms per square (square of any dimension).
    - a) If the surface resistivity of the coating, C50219, is less than 1 megohm per square, do the steps that follow (refer to the relevant section within this task):
      - <1> Remove the coating, C50219, anti-static paint.
      - <2> Clean and prepare the surface.
      - <3> Re-apply the coating, C50219, anti-static paint.
      - <4> Determine the resistivity again.
      - <5> Repeat once if necessary.
      - <a> Contact Liaison engineering if resistivity requirements are not met after second processing.

EFFECTIVITY  
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- b) If the surface resistivity of the coating, C50219, is more than 100 megohms per square, do the steps that follow:
    - <1> Cure at 140°F (60°C) to 160°F (71°C) for 60 to 70 minutes.
    - <2> Determine the resistivity again.
    - <3> If the resistivity is not between 1 and 100 megohms repeat the resolution steps.
  - 8) Remove copper tape after completion of the measurement.
- (b) To determine the surface resistivity of the coating, C50219, using a surface resistivity measurement probe, SPL-7885, do the steps that follow:
- 1) Connect the digital/analog multimeter, COM-1793, to the surface resistivity measurement probe, SPL-7885 (Figure 707).
  - 2) Place surface resistivity measurement probe, SPL-7885, on the conductive coating.
  - 3) Read the number for the resistance.
  - 4) Multiply the number for resistance by 10.

NOTE: The result is the resistivity of the anti-static coating.
  - 5) Make sure that the resistivity is between 1 and 100 megohms per square.
    - a) If the surface resistivity of the coating, C50219, is less than 1 megohm per square, do the steps that follow (refer to the relevant section within this task):
      - <1> Remove the coating, C50219, anti-static paint.
      - <2> Clean and prepare the surface.
      - <3> Re-apply the coating, C50219, anti-static paint.
      - <4> Determine the resistivity again.
      - <5> Repeat once if necessary.
        - <a> Contact Liaison engineering if resistivity requirements are not met after second processing.
    - b) If the surface resistivity of the coating, C50219, is more than 100 megohms, do the steps that follow:
      - <1> Cure at 140°F (60°C) to 160°F (71°C) for 60 to 70 minutes.
      - <2> Determine the resistivity again.
      - <3> If the resistivity is not between 1 and 100 megohms repeat the resolution steps.
  - (c) To determine the surface resistivity of the coating, C50219, using the Fastener-to-Conductive Surface Test Method, do the steps that follow:

NOTE: The resistivity of the conductive coating after it is cured must be between 1 and 100 megohms per square.

NOTE: Let the conductive coat cure for the specified time before you measure the conductivity (Figure 708).

    - 1) If the bonding surface and the head of the fastener are covered with a finish, do the steps as follows (Figure 709):
      - a) Remove a sufficient quantity of the outer coating or paint to let the probes touch the conductive finish.

NOTE: If it is necessary, the probes can be pushed through the outer coating.

EFFECTIVITY  
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- b) Put the digital/analog multimeter, COM-1793, with the film resistance measure probe, SPL-10361, in direct contact with the bonding fastener and the conductive finish.
    - <1> Put the film resistance measure probe, SPL-10361, 1.00  $\pm$ 0.25 in. (25.40  $\pm$ 6.35 mm) apart (Figure 709).
  - c) Record the value of the resistivity shown on the multimeter.
    - <1> The minimum allowable resistivity is 1 megohm per square.
    - <2> The maximum allowable resistivity is 100 megohm per square.
- (d) To determine the surface resistivity of the coating, C50219, using the Fastener-to-Fastener Test Method, do the steps that follow:
- NOTE: The resistivity of the conductive coating after it is cured must be between 1 and 100 megohms per square.
- 1) Make sure that the conductive coating shows in the fastener location.
  - 2) Clean the area with alcohol, B50073.
  - 3) Install one temporary fastener at each fastener location to be measured (Figure 709).
- NOTE: This procedure can be used for measuring electrical resistivity of panels with covered (painted) conductive coatings when the ground fastener locations show.
- 4) Connect the digital/analog multimeter, COM-1793, probes at the two fastener locations (Figure 709).
  - 5) Record the value of the resistivity with the digital/analog multimeter, COM-1793.
    - a) The minimum allowable resistivity is 1 megohm per square.
    - b) The maximum allowable resistivity is 100 megohm per square.
  - 6) Remove the temporary fasteners from the surface.

SUBTASK 53-52-00-840-004

- (3) Install the six lightning diverter strips (TASK 53-52-03-400-801).

SUBTASK 53-52-00-950-011

- (4) Use Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, to mask-off the exterior surface of the radome, except for a 5 in. (127 mm) vertical band from STA. 138.6 to STA. 143.6 (Figure 701).

SUBTASK 53-52-00-370-035

- (5) Apply a second coat of coating, C50219, to the exposed vertical band area (Figure 703).
- (a) To apply coating, C50219, do this task: Apply BMS 10-21 Type IV Conductive Coating To Specified External Surfaces, TASK 51-21-71-370-803.
  - (b) If the anti-static coating is not overcoated within 24 hours, do the following before painting the next layer:
    - 1) Solvent clean using alcohol, B50073.
    - 2) Lightly abrade with very fine abrasive pad, Scotch-Brite 7447 pad, G50220.
    - 3) Solvent clean using alcohol, B50073.
    - 4) If necessary, use tack rag, G50123, to remove particulate contamination.
    - 5) Visually examine the anti-static coating surface to make sure that the coating is continuous (no bare areas).

EFFECTIVITY  
LOM ALL

**53-52-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-52-00-860-014

- (6) Determine the surface resistivity of the coating, C50219, using one of the following methods:
- (a) To determine the surface resistivity using the square method, do the steps that follow:
- 1) Cut two pieces of flexible bare 3M 1181 copper foil tape, G50630, with conductive adhesive each of length "L" (Figure 706).
  - 2) Place the two pieces of tape at a distance of " $0.1L \pm 5$  percent" and parallel to each other (Figure 706).
  - 3) Press the two pieces of tape firmly against the anti-static coating.
  - 4) Connect the Ohmmeter probes to the tape (Figure 706).
  - 5) Read the number for resistance.
  - 6) Multiply the number for resistance by 10.
- NOTE: The result is the resistivity of the anti-static coating.
- 7) Make sure that the resistivity is between 1 and 100 megohms.
    - a) If the surface resistivity of the coating, C50219, is less than 1 megohm per square (square of any dimension), do the steps that follow (refer to the relevant section within this task):
      - <1> Remove the coating, C50219, anti-static paint.
      - <2> Clean and prepare the surface.
      - <3> Re-apply the coating, C50219, anti-static paint.
      - <4> Determine the resistivity again.
      - <5> Repeat once if necessary.
        - <a> Contact Liaison engineering if resistivity requirements are not met after second processing.
    - b) If the surface resistivity of the coating, C50219, is more than 100 megohms, do the steps that follow:
      - <1> Cure at  $140^{\circ}\text{F}$  ( $60^{\circ}\text{C}$ ) to  $160^{\circ}\text{F}$  ( $71^{\circ}\text{C}$ ) for 60 to 70 minutes.
      - <2> Determine the resistivity again.
      - <3> If the resistivity is not between 1 and 100 megohms repeat the resolution steps.
  - 8) Remove copper tape after completion of the measurement.
- (b) To determine the surface resistivity of the coating, C50219, using a surface resistivity measurement probe, SPL-7885, do the steps that follow:
- 1) Connect the digital/analog multimeter, COM-1793, to the surface resistivity measurement probe, SPL-7885 (Figure 707).
  - 2) Place surface resistivity measurement probe, SPL-7885, on the conductive coating.
  - 3) Read the number for the resistance.
  - 4) Multiply the number for resistance by 10.
- NOTE: The result is the resistivity of the anti-static coating.
- 5) Make sure that the resistivity is between 1 and 100 megohms.
    - a) If the surface resistivity of the coating, C50219, is less than 1 megohm per square (square of any dimension), do the steps that follow (refer to the relevant section within this task):

EFFECTIVITY  
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- <1> Remove the coating, C50219, anti-static paint.
- <2> Clean and prepare the surface.
- <3> Re-apply the coating, C50219, anti-static paint.
- <4> Determine the resistivity again.
- <5> Repeat once if necessary.
  - <a> Contact Liaison engineering if resistivity requirements are not met after second processing.
- b) If the surface resistivity of the coating, C50219, is more than 100 megohms, do the steps that follow:
  - <1> Cure at 140°F (60°C) to 160°F (71°C) for 60 to 70 minutes.
  - <2> Determine the resistivity again.
  - <3> If the resistivity is not between 1 and 100 megohms repeat the resolution steps.
- (c) To determine the surface resistivity of the coating, C50219, using the Fastener-to-Conductive Surface Test Method, do the steps that follow:

NOTE: The resistivity of the conductive coating after it is cured must be between 1 and 100 megohms per square.

NOTE: Let the conductive coat cure for the specified time before you measure the conductivity (Figure 708).

  - 1) If the bonding surface and the head of the fastener are covered with a finish, do the steps as follows (Figure 709):
    - a) Remove a sufficient quantity of the outer coating or paint to let the probes touch the conductive finish.

NOTE: If it is necessary, the probes can be pushed through the outer coating.
    - b) Put the digital/analog multimeter, COM-1793, with the film resistance measure probe, SPL-10361, in direct contact with the bonding fastener and the conductive finish.
      - <1> Put the film resistance measure probe, SPL-10361, 1.00 ±0.25 in. (25.40 ±6.35 mm) apart (Figure 709).
    - c) Record the value of the resistivity shown on the multimeter.
      - <1> The minimum allowable resistivity is 1 megohm per square.
      - <2> The maximum allowable resistivity is 100 megohm per square.
- (d) To determine the surface resistivity of the coating, C50219, using the Fastener-to-Fastener Test Method, do the steps that follow:

NOTE: The resistivity of the conductive coating after it is cured must be between 1 and 100 megohms per square.

  - 1) Make sure that the conductive coating shows in the fastener location.
  - 2) Clean the area with alcohol, B50073.
  - 3) Install one temporary fastener at each fastener location to be measured (Figure 709).

NOTE: This procedure can be used for measuring electrical resistivity of panels with covered (painted) conductive coatings when the ground fastener locations show.

EFFECTIVITY  
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 4) Connect the digital/analog multimeter, COM-1793, probes at the two fastener locations (Figure 709).
- 5) Record the value of the resistivity with the digital/analog multimeter, COM-1793.
  - a) The minimum allowable resistivity is 1 megohm per square.
  - b) The maximum allowable resistivity is 100 megohm per square.
- 6) Remove the temporary fasteners from the surface.

SUBTASK 53-52-00-370-034

- (7) Remove the Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219.

SUBTASK 53-52-00-950-001

- (8) Use Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, to mask-off a 5 in. (127 mm) vertical band from STA 138.6 to STA 143.6 (Figure 701).

SUBTASK 53-52-00-370-029

- (9) Apply 0.3 mil (0.0076 mm) - 0.8 mil (0.0203 mm) of primer, C00766, from the radome tip to STA 138.6 and from STA 143.6 to the aft edge of the radome (Figure 702).
  - (a) To apply the primer, C00766, do this task: BMS10-103, Type 1, Primer - Application, TASK 51-21-72-370-802.

SUBTASK 53-52-00-370-030

NOTE: If coating, C00921, or coating, C50316, is applied to the nose radome, either coating can be applied in lieu of coating, C50075, in an effort to minimize total paint thickness on the nose radome.

- (10) Use Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, to mask-off the radome tip to STA 138.6 (Figure 701).
- (11) Apply 1.4 mils (0.0356 mm) - 2.4 mils (0.0610 mm) of coating, C50075, from STA 143.6 to the aft edge of the radome (Figure 702).
  - (a) To apply the coating, C50075, do this task: BMS10-60 Topcoat Application, TASK 51-21-73-370-803.
- (12) Remove the Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, from the radome tip to STA 138.6.

NOTE: Do not remove Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, from STA 138.6 to STA 143.6.

SUBTASK 53-52-00-950-012

- (13) Use Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, to mask-off the area from STA 143.6 to the aft edge of the radome (Figure 701).

SUBTASK 53-52-00-370-031

- (14) Apply 8 mils (0.2032 mm) - 10 mils (0.2540 mm) of coating, C50075, from the radome tip to STA 138.6 (Figure 702).

NOTE: If coating, C00921, or coating, C50316, is applied to the nose radome, either coating can be applied in lieu of coating, C50075, in an effort to minimize total paint thickness on the nose radome.

NOTE: A nose radome protective boot can be used in place of the coating, C50075.

- (a) To apply the coating, C50075, do this task: BMS10-60 Topcoat Application, TASK 51-21-73-370-803.

EFFECTIVITY  
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**SUBTASK 53-52-00-950-013**

- (15) Remove the Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219 from the 5 in. (127 mm) vertical band from STA 138.6 to STA 143.6.
- (16) Use Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, to mask-off the radome tip to STA 138.6 (Figure 701).

**SUBTASK 53-52-00-370-036**

- (17) Apply decorative primer on 5 in. (127 mm) vertical band from STA 138.6 to STA 143.6 (TASK 51-21-99-300-801).
- (18) Remove all the Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219.

**SUBTASK 53-52-00-370-019**

- (19) Apply decorative paint to the entire surface of the radome (TASK 51-21-99-300-801).

NOTE: Refer to your livery drawing requirements.

**G. Paint the Nose Radome before Installation of a Protective Boot**

**SUBTASK 53-52-00-370-037**

NOTE: Thicknesses of paint which are more than 0.01 in. (0.254 mm) can decrease the necessary radome electrical transmission efficiency. A radome wall that has been repainted should be put back to its initial thickness, including paint thickness. If this is not done, radome transmission efficiency will be decreased (SRM 53-10-72-2R-0).

- (1) Apply coating, C50219, to the entire nose radome surface (Figure 701, Figure 704, Figure 705).
  - (a) To apply coating, C50219, do this task: Apply BMS 10-21 Type IV Conductive Coating To Specified External Surfaces, TASK 51-21-71-370-803.
  - (b) If the anti-static coating is not overcoated within 24 hours do the following:
    - 1) Solvent clean using alcohol, B50073.
    - 2) Lightly abrade with a very fine abrasive pad, Scotch-Brite 7447 pad, G50220.
    - 3) Solvent clean using alcohol, B50073.
    - 4) If necessary, use a tack rag, G50123, to remove particulate contamination.
    - 5) Visually examine the anti-static coating surface to make sure that the coating is continuous (no bare areas).

**SUBTASK 53-52-00-860-015**

- (2) Determine the surface resistivity of the coating, C50219, using one of the following methods:
  - (a) To determine the surface resistivity using the square method, do the steps that follow:
    - 1) Cut two pieces of flexible bare 3M 1181 copper foil tape, G50630, with conductive adhesive each of length "L" (Figure 706).
    - 2) Place the two pieces of tape at a distance of " $0.1L \pm 5$  percent" and parallel to each other (Figure 706).
    - 3) Press the two pieces of tape firmly against the anti-static coating.
    - 4) Connect the Ohmmeter probes to the tape (Figure 706).
    - 5) Read the number for resistance.
    - 6) Multiply the number for resistance by 10.
  - NOTE: The result is the resistivity of the anti-static coating.
  - 7) Make sure that the resistivity is between 1 and 100 megohms per square (square of any dimension).

EFFECTIVITY  
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- a) If the surface resistivity of the coating, C50219, is less than 1 megohm per square, do the steps that follow (refer to the relevant section within this task):
    - <1> Remove the coating, C50219, anti-static paint.
    - <2> Clean and prepare the surface.
    - <3> Re-apply the coating, C50219, anti-static paint.
    - <4> Determine the resistivity again.
    - <5> Repeat once if necessary.
      - <a> Contact Liaison engineering if resistivity requirements are not met after second processing.
  - b) If the surface resistivity of the coating, C50219, is more than 100 megohms per square, do the steps that follow:
    - <1> Cure at 140°F (60°C) to 160°F (71°C) for 60 to 70 minutes.
    - <2> Determine the resistivity again.
    - <3> If the resistivity is not between 1 and 100 megohms repeat the resolution steps.
- 8) Remove copper tape after completion of the measurement.
- (b) To determine the surface resistivity of the coating, C50219, using a surface resistivity measurement probe, SPL-7885, do the steps that follow:
- 1) Connect the digital/analog multimeter, COM-1793, to the surface resistivity measurement probe, SPL-7885 (Figure 707).
  - 2) Place surface resistivity measurement probe, SPL-7885, on the conductive coating.
  - 3) Read the number for the resistance.
  - 4) Multiply the number for resistance by 10.
- NOTE: The result is the resistivity of the anti-static coating.
- 5) Make sure that the resistivity is between 1 and 100 megohms per square.
    - a) If the surface resistivity of the coating, C50219, is less than 1 megohm per square, do the steps that follow (refer to the relevant section within this task):
      - <1> Remove the coating, C50219, anti-static paint.
      - <2> Clean and prepare the surface.
      - <3> Re-apply the coating, C50219, anti-static paint.
      - <4> Determine the resistivity again.
      - <5> Repeat once if necessary.
        - <a> Contact Liaison engineering if resistivity requirements are not met after second processing.
    - b) If the surface resistivity of the coating, C50219, is more than 100 megohms, do the steps that follow:
      - <1> Cure at 140°F (60°C) to 160°F (71°C) for 60 to 70 minutes.
      - <2> Determine the resistivity again.
      - <3> If the resistivity is not between 1 and 100 megohms repeat the resolution steps.

EFFECTIVITY  
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (c) To determine the surface resistivity of the coating, C50219, using the Fastener-to-Conductive Surface Test Method, do the steps that follow:

NOTE: The resistivity of the conductive coating after it is cured must be between 1 and 100 megohms per square.

NOTE: Let the conductive coat cure for the specified time before you measure the conductivity (Figure 708).

- 1) If the bonding surface and the head of the fastener are covered with a finish, do the steps as follows (Figure 709):

- a) Remove a sufficient quantity of the outer coating or paint to let the probes touch the conductive finish.

NOTE: If it is necessary, the probes can be pushed through the outer coating.

- b) Put the digital/analog multimeter, COM-1793, with the film resistance measure probe, SPL-10361, in direct contact with the bonding fastener and the conductive finish.

<1> Put the film resistance measure probe, SPL-10361, 1.00 ±0.25 in. (25.40 ±6.35 mm) apart (Figure 709).

- c) Record the value of the resistivity shown on the multimeter.

<1> The minimum allowable resistivity is 1 megohm per square.

<2> The maximum allowable resistivity is 100 megohm per square.

- (d) To determine the surface resistivity of the coating, C50219, using the Fastener-to-Fastener Test Method, do the steps that follow:

NOTE: The resistivity of the conductive coating after it is cured must be between 1 and 100 megohms per square.

- 1) Make sure that the conductive coating shows in the fastener location.

- 2) Clean the area with alcohol, B50073.

- 3) Install one temporary fastener at each fastener location to be measured (Figure 709).

NOTE: This procedure can be used for measuring electrical resistivity of panels with covered (painted) conductive coatings when the ground fastener locations show.

- 4) Connect the digital/analog multimeter, COM-1793, probes at the two fastener locations (Figure 709).

- 5) Record the value of the resistivity with the digital/analog multimeter, COM-1793.

- a) The minimum allowable resistivity is 1 megohm per square.

- b) The maximum allowable resistivity is 100 megohm per square.

- 6) Remove the temporary fasteners from the surface.

SUBTASK 53-52-00-840-005

- (3) Install the six lightning diverter strips (TASK 53-52-03-400-801).

SUBTASK 53-52-00-950-014

- (4) Use Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219, to mask-off the exterior surface of the radome, except for a 5 in. (127 mm) vertical band from STA 138.6 to STA 143.6 (Figure 701).

EFFECTIVITY  
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-52-00-370-038

- (5) Apply a second coat of coating, C50219, to the exposed vertical band area (Figure 705).
  - (a) To apply coating, C50219, do this task: Apply BMS 10-21 Type IV Conductive Coating To Specified External Surfaces, TASK 51-21-71-370-803.
  - (b) If the anti-static coating is not overcoated within 24 hours do the following:
    - 1) Solvent clean using alcohol, B50073.
    - 2) Lightly abrade with very fine abrasive pad, Scotch-Brite 7447 pad, G50220.
    - 3) Solvent clean using alcohol, B50073.
    - 4) If necessary, use a tack rag, G50123, to remove particulate contamination.
    - 5) Visually examine the anti-static coating surface to make sure that the coating is continuous (no bare areas).

SUBTASK 53-52-00-860-016

- (6) Determine the surface resistivity of the coating, C50219, using one of the following methods:
  - (a) To determine the surface resistivity using the square method, do the steps that follow:
    - 1) Cut two pieces of flexible bare 3M 1181 copper foil tape, G50630, with conductive adhesive each of length "L" (Figure 706).
    - 2) Place the two pieces of tape at a distance of " $0.1L \pm 5$  percent" and parallel to each other (Figure 706).
    - 3) Press the two pieces of tape firmly against the anti-static coating.
    - 4) Connect the Ohmmeter probes to the tape (Figure 706).
    - 5) Read the number for resistance.
    - 6) Multiply the number for resistance by 10.  
NOTE: The result is the resistivity of the anti-static coating.
  - (b) If the surface resistivity of the coating, C50219, is less than 1 megohm per square (square of any dimension), do the steps that follow (refer to the relevant section within this task):
    - <1> Remove the coating, C50219, anti-static paint.
    - <2> Clean and prepare the surface.
    - <3> Re-apply the coating, C50219, anti-static paint.
    - <4> Determine the resistivity again.
    - <5> Repeat once if necessary.  
<a> Contact Liaison engineering if resistivity requirements are not met after second processing.
  - (c) If the surface resistivity of the coating, C50219, is more than 100 megohms, do the steps that follow:
    - <1> Cure at 140°F (60°C) to 160°F (71°C) for 60 to 70 minutes.
    - <2> Determine the resistivity again.
    - <3> If the resistivity is not between 1 and 100 megohms repeat the resolution steps.
- 8) Remove copper tape after completion of the measurement.

EFFECTIVITY  
LOM ALL

**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (b) To determine the surface resistivity of the coating, C50219, using a surface resistivity measurement probe, SPL-7885, do the steps that follow:
- 1) Connect the digital/analog multimeter, COM-1793, to the surface resistivity measurement probe, SPL-7885 (Figure 707).
  - 2) Place surface resistivity measurement probe, SPL-7885, on the conductive coating.
  - 3) Read the number for the resistance.
  - 4) Multiply the number for resistance by 10.  
NOTE: The result is the resistivity of the anti-static coating.
  - 5) Make sure that the resistivity is between 1 and 100 megohms.
    - a) If the surface resistivity of the coating, C50219, is less than 1 megohm per square (square of any dimension), do the steps that follow (refer to the relevant section within this task):
      - <1> Remove the coating, C50219, anti-static paint.
      - <2> Clean and prepare the surface.
      - <3> Re-apply the coating, C50219, anti-static paint.
      - <4> Determine the resistivity again.
      - <5> Repeat once if necessary.  
<a> Contact Liaison engineering if resistivity requirements are not met after second processing.
    - b) If the surface resistivity of the coating, C50219, is more than 100 megohms, do the steps that follow:
      - <1> Cure at 140°F (60°C) to 160°F (71°C) for 60 to 70 minutes.
      - <2> Determine the resistivity again.
      - <3> If the resistivity is not between 1 and 100 megohms repeat the resolution steps.
- (c) To determine the surface resistivity of the coating, C50219, using the Fastener-to-Conductive Surface Test Method, do the steps that follow:
- NOTE: The resistivity of the conductive coating after it is cured must be between 1 and 100 megohms per square.
- NOTE: Let the conductive coat cure for the specified time before you measure the conductivity (Figure 708).
- 1) If the bonding surface and the head of the fastener are covered with a finish, do the steps as follows (Figure 709):
    - a) Remove a sufficient quantity of the outer coating or paint to let the probes touch the conductive finish.  
NOTE: If it is necessary, the probes can be pushed through the outer coating.
    - b) Put the digital/analog multimeter, COM-1793, with the film resistance measure probe, SPL-10361 in direct contact with the bonding fastener and the conductive finish.
      - <1> Put the film resistance measure probe, SPL-10361,  $1.00 \pm 0.25$  in. ( $25.40 \pm 6.35$  mm) apart (Figure 709).
    - c) Record the value of the resistivity shown on the multimeter.
      - <1> The minimum allowable resistivity is 1 megohm per square.

EFFECTIVITY  
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**53-52-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

<2> The maximum allowable resistivity is 100 megohm per square.

- (d) To determine the surface resistivity of the coating, C50219, using the Fastener-to-Fastener Test Method, do the steps that follow:

NOTE: The resistivity of the conductive coating after it is cured must be between 1 and 100 megohms per square.

- 1) Make sure that the conductive coating shows in the fastener location.
- 2) Clean the area with alcohol, B50073.
- 3) Install one temporary fastener at each fastener location to be measured (Figure 709).

NOTE: This procedure can be used for measuring electrical resistivity of panels with covered (painted) conductive coatings when the ground fastener locations show.

- 4) Connect the digital/analog multimeter, COM-1793, probes at the two fastener locations (Figure 709).
- 5) Record the value of the resistivity with the digital/analog multimeter, COM-1793.
  - a) The minimum allowable resistivity is 1 megohm per square.
  - b) The maximum allowable resistivity is 100 megohm per square.
- 6) Remove the temporary fasteners from the surface.

**SUBTASK 53-52-00-000-010**

- (7) Remove the Tape - Masking, G50509, or Scotch Brand No.471 tape, G02219.

**SUBTASK 53-52-00-370-039**

- (8) Apply 0.3 mil (0.0076 mm) - 0.8 mil (0.0203 mm) of primer, C00766, to the entire radome (Figure 704).
  - (a) To apply the primer, C00766, do this task: BMS10-103, Type 1, Primer - Application, TASK 51-21-72-370-802.

**SUBTASK 53-52-00-370-040**

- (9) Apply 1.4 mils (0.0356 mm) - 2.4 mils (0.0610 mm) of coating, C50075, to the entire radome (Figure 704, Figure 705).
  - (a) To apply the coating, C50075, do this task: BMS10-60 Topcoat Application, TASK 51-21-73-370-803.

**SUBTASK 53-52-00-400-016**

- (10) Apply the nose radome protective boot (TASK 53-52-00-400-802).

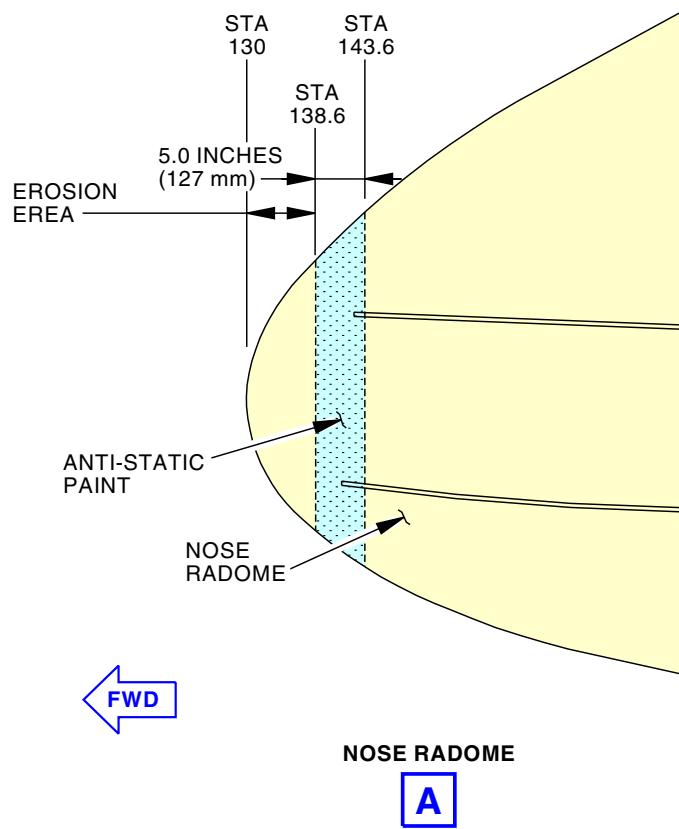
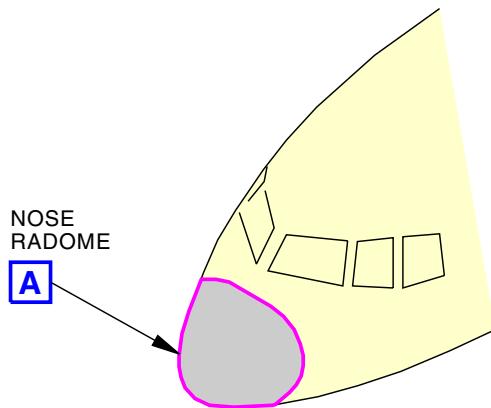
———— END OF TASK ———

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**53-52-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



U30485 S0000190355\_V3

Nose Radome Anti-Static Band  
Figure 701/53-52-00-990-803



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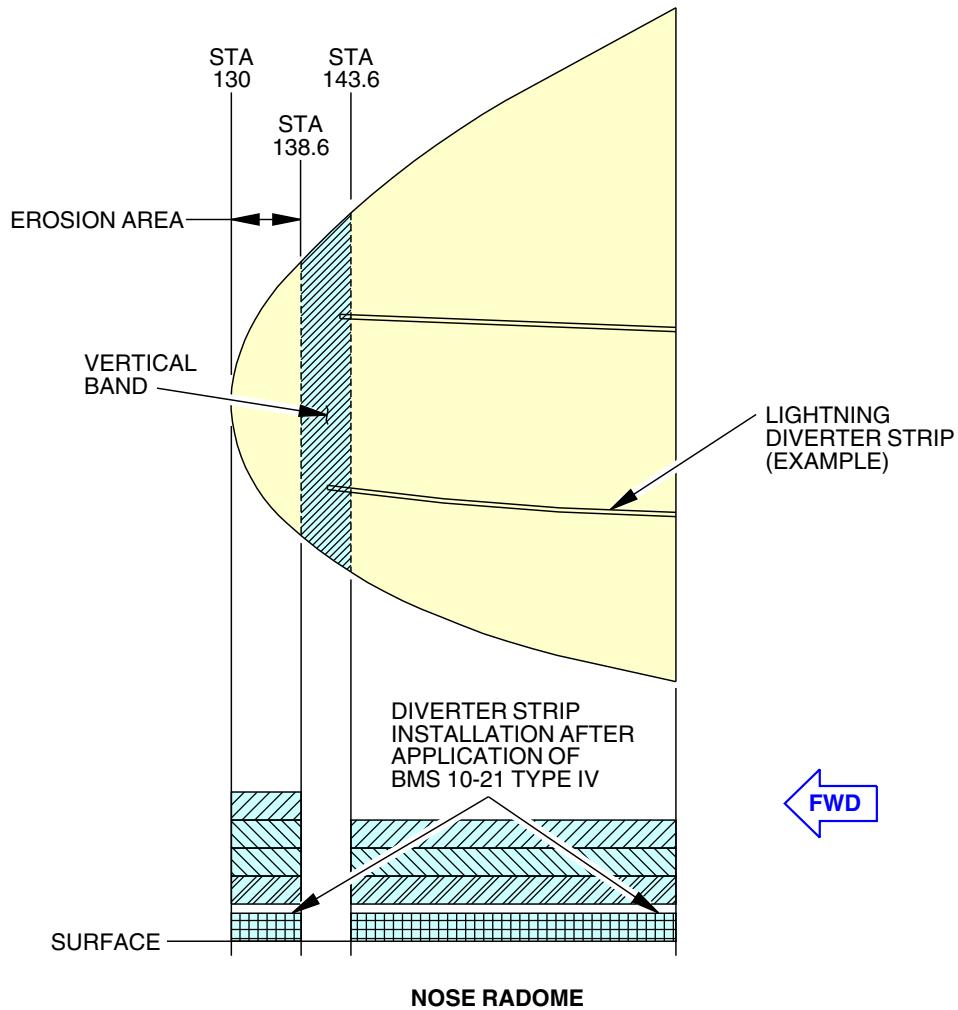
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**53-52-00**

Page 715  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



**LEGEND:**

- BMS 10-72 DECORATIVE COATING (TOPCOAT) OR AMS3095 EXTERIOR GLOSS PAINT
- BMS 10-60 TYPE II ENAMEL COATING
- BMS 10-103 TYPE I PRIMER
- BMS 10-21 TYPE IV ANTI-STATIC COATING

2245834 S0000503249\_V7

Nose Radome Painting - Nose Tip to STA 138.6 and STA 143.6 to Aft Edge  
Figure 702/53-52-00-990-807

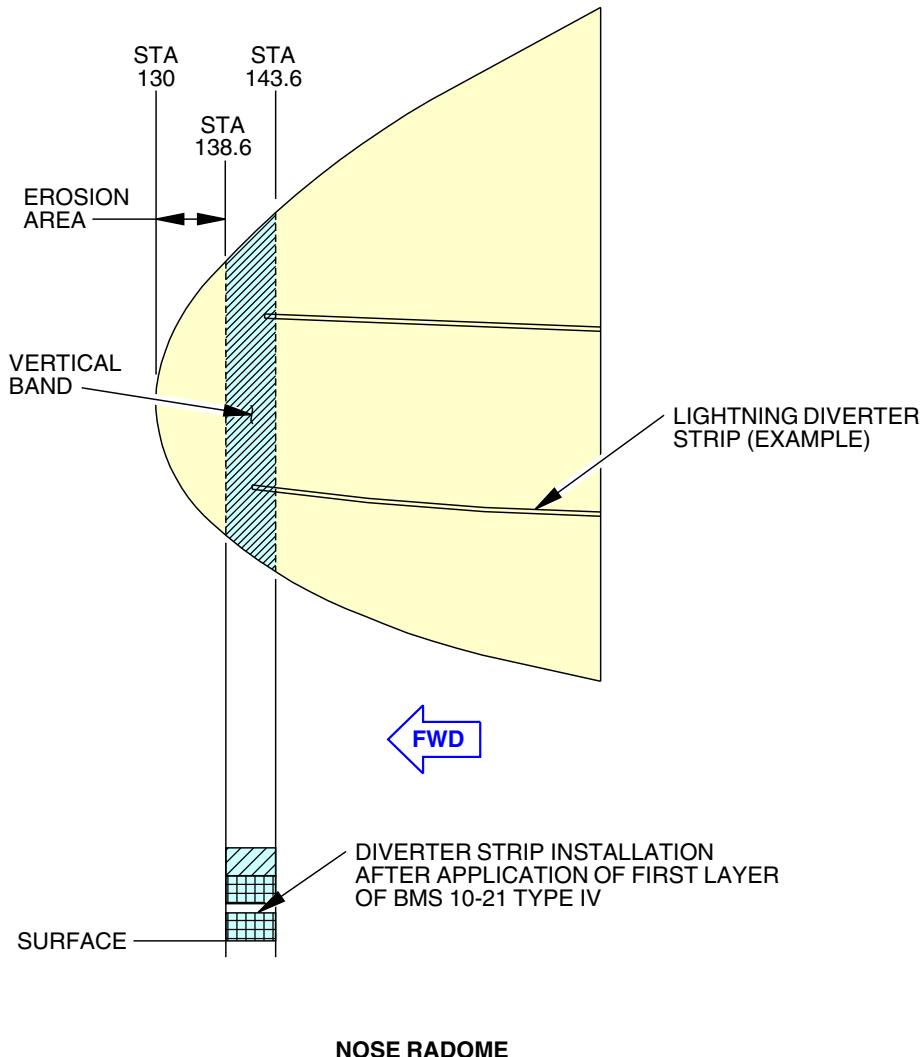
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**53-52-00**

Page 716  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



**LEGEND:**



BMS 10-72 DECORATIVE COATING (PRIMER AND TOPCOAT) OR AMS3095 EXTERIOR GLOSS PAINT



BMS 10-21 TYPE IV ANTI-STATIC COATING

2246034 S0000503251\_V6

**Nose Radome Painting - STA 138.6 to STA 143.6**  
**Figure 703/53-52-00-990-808**

EFFECTIVITY	LOM ALL
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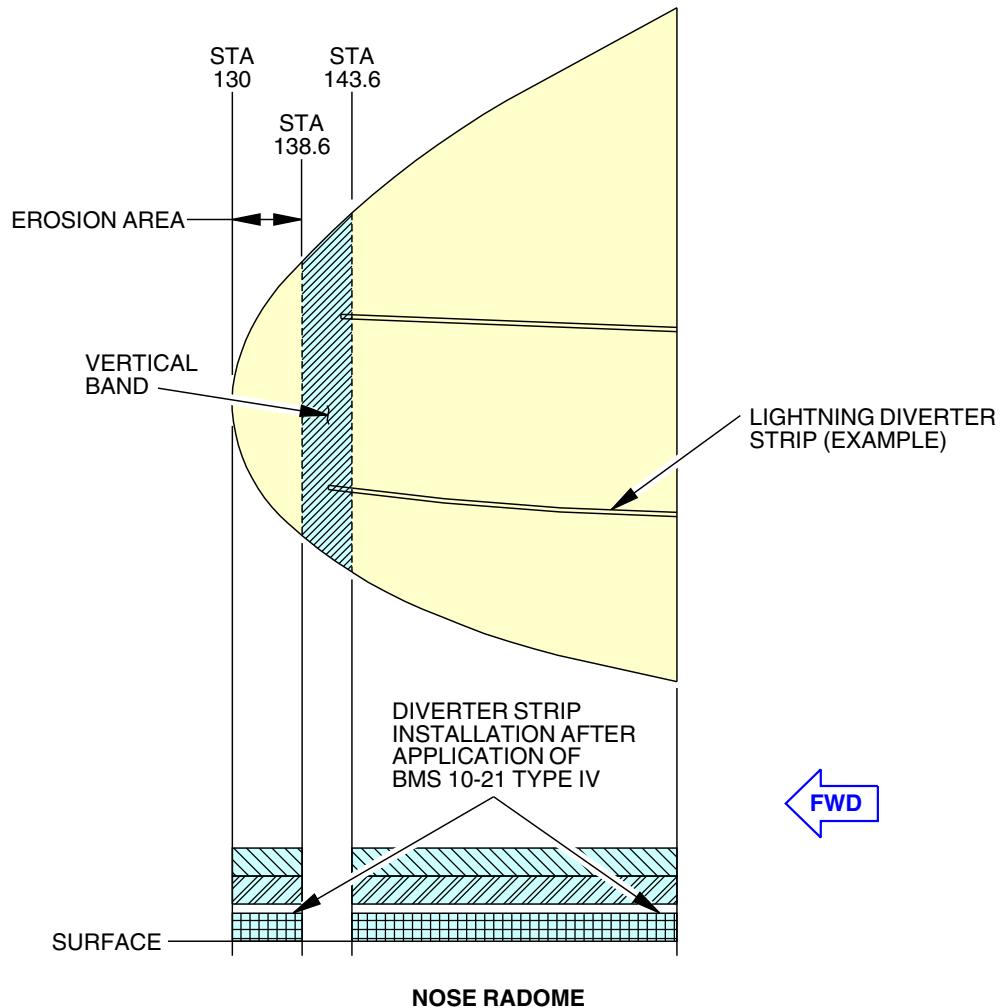
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**53-52-00**

Page 717  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



**LEGEND:**

- BMS 10-60 TYPE II ENAMEL COATING
- BMS 10-103 TYPE I PRIMER
- BMS 10-21 TYPE IV ANTI-STATIC COATING

2830089 S0000656457\_V3

Nose Radome Painting - Nose Tip to STA 138.6 and STA 143.6 to Aft Edge - With Protective Boot  
Figure 704/53-52-00-990-814

EFFECTIVITY  
LOM ALL

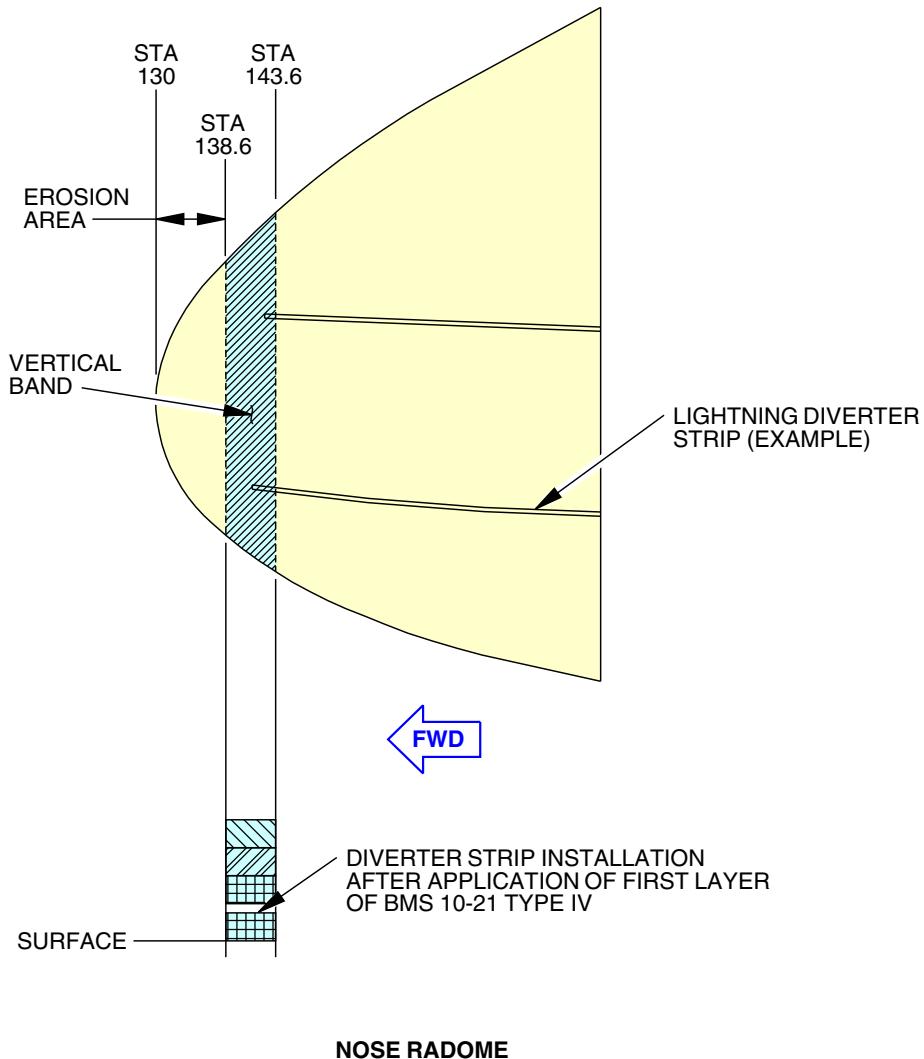
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**53-52-00**

Page 718  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



NOSE RADOME

**LEGEND:**

- BMS 10-60 TYPE II ENAMEL COATING
- BMS 10-103 TYPE I PRIMER
- BMS 10-21 TYPE IV ANTI-STATIC COATING

2830114 S0000656458\_V3

Nose Radome Painting - STA 138.6 to STA 143.6 - With Protective Boot  
Figure 705/53-52-00-990-815

EFFECTIVITY	LOM ALL
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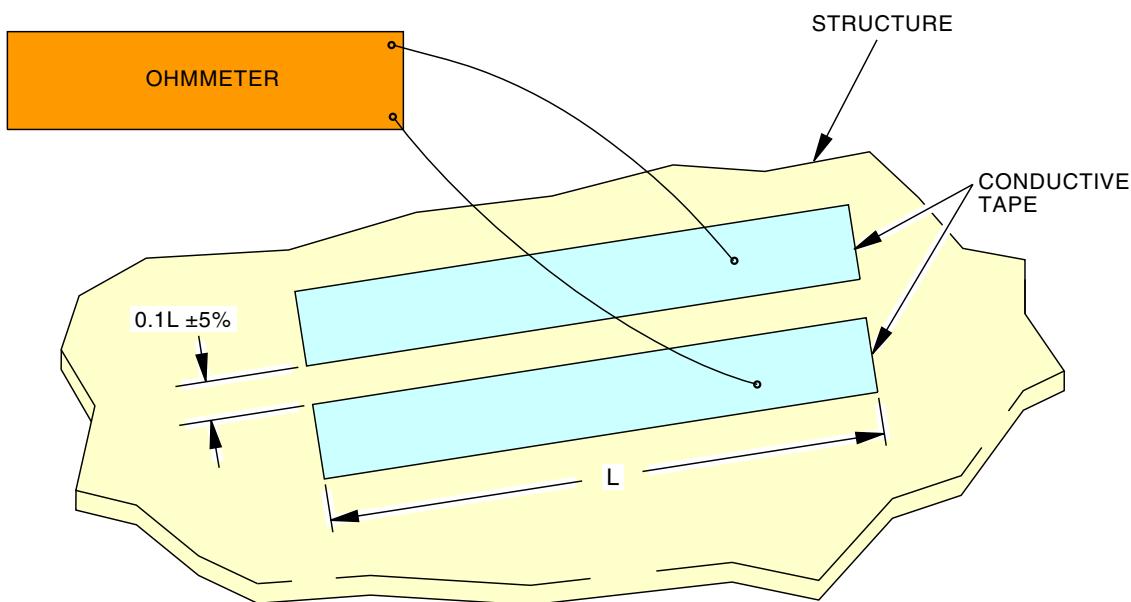
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**53-52-00**

Page 719  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



2337201 S0000532390\_V2

**Resistance Measurement Using Square Method**  
**Figure 706/53-52-00-990-809**

EFFECTIVITY  
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**53-52-00**

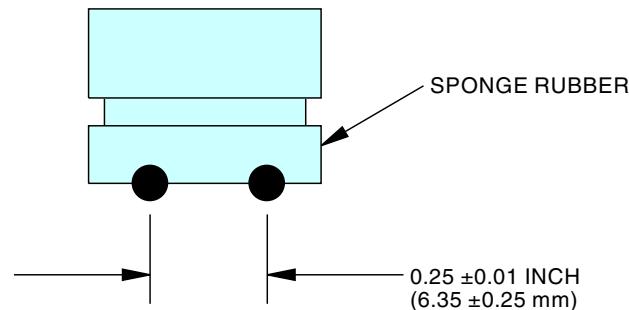
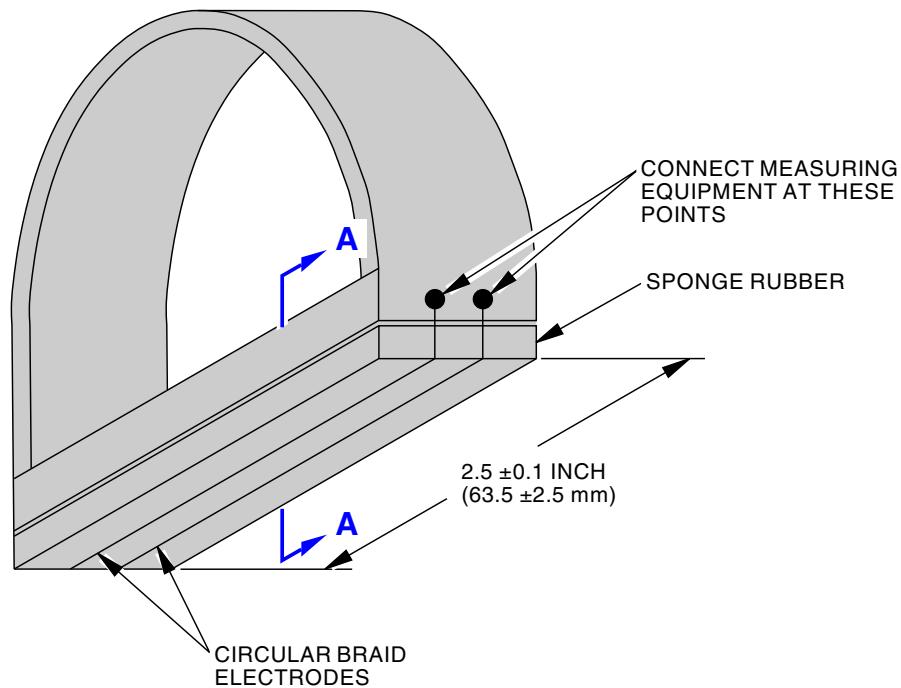
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 720  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



PROBE CROSS SECTION  
**A-A**

2337246 S0000532389\_V2

**ST895A-3 Resistivity Probe**  
Figure 707/53-52-00-990-810

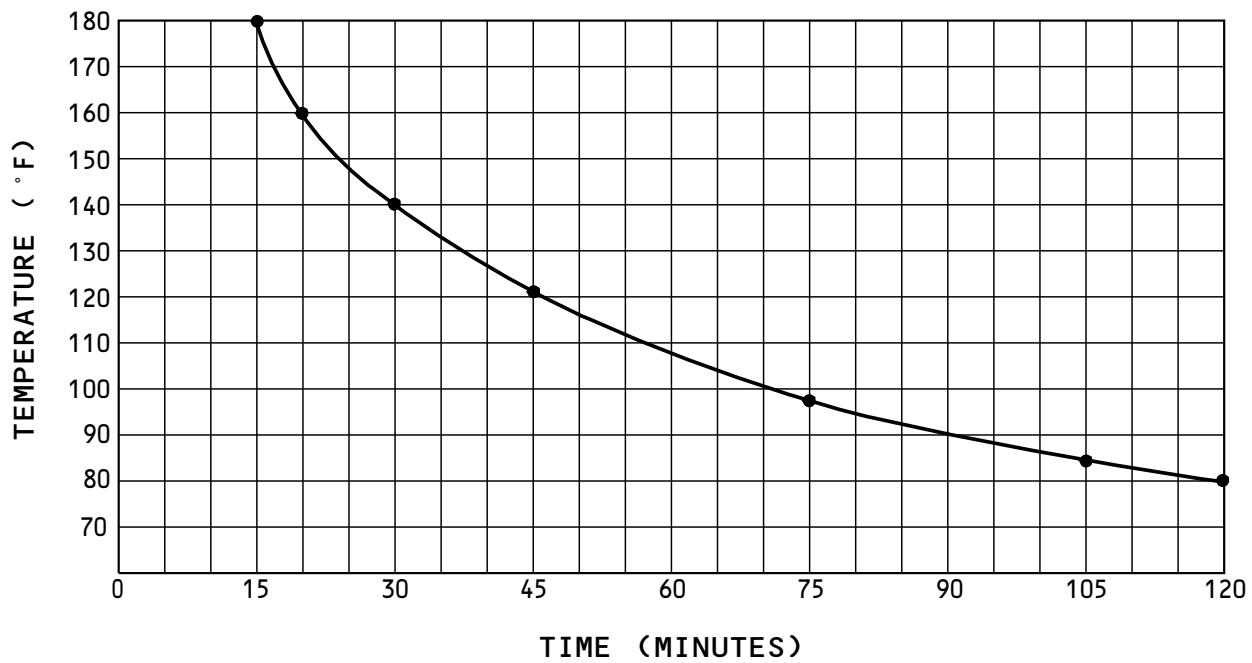
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-52-00**

Page 721  
Oct 15/2024

**BOEING**  
737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



F34247 S0006579527\_V1

**Conductive Coating Increased Cure Times**  
Figure 708/53-52-00-990-811



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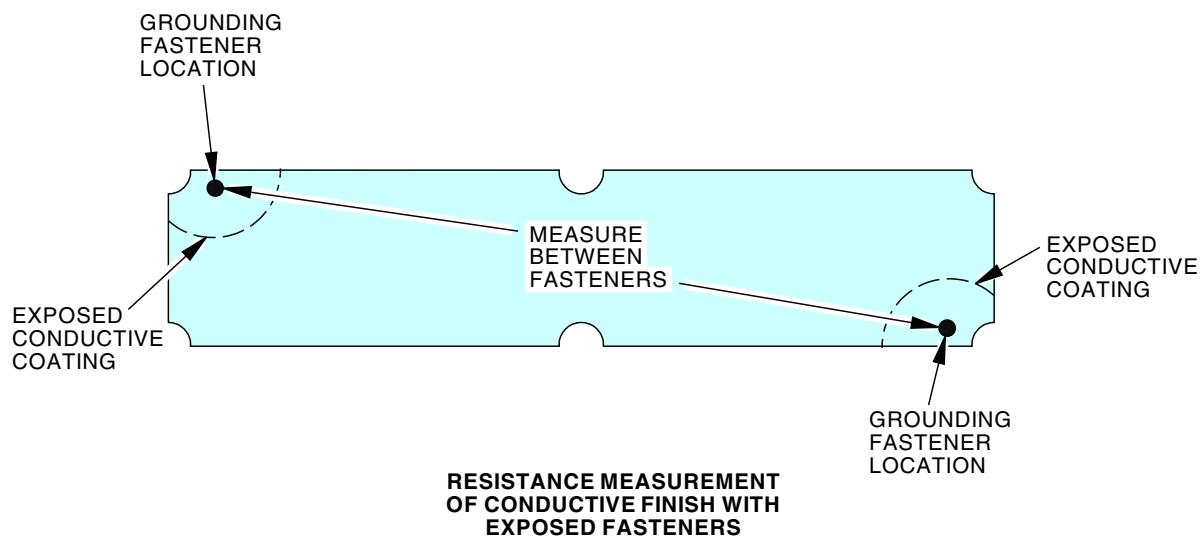
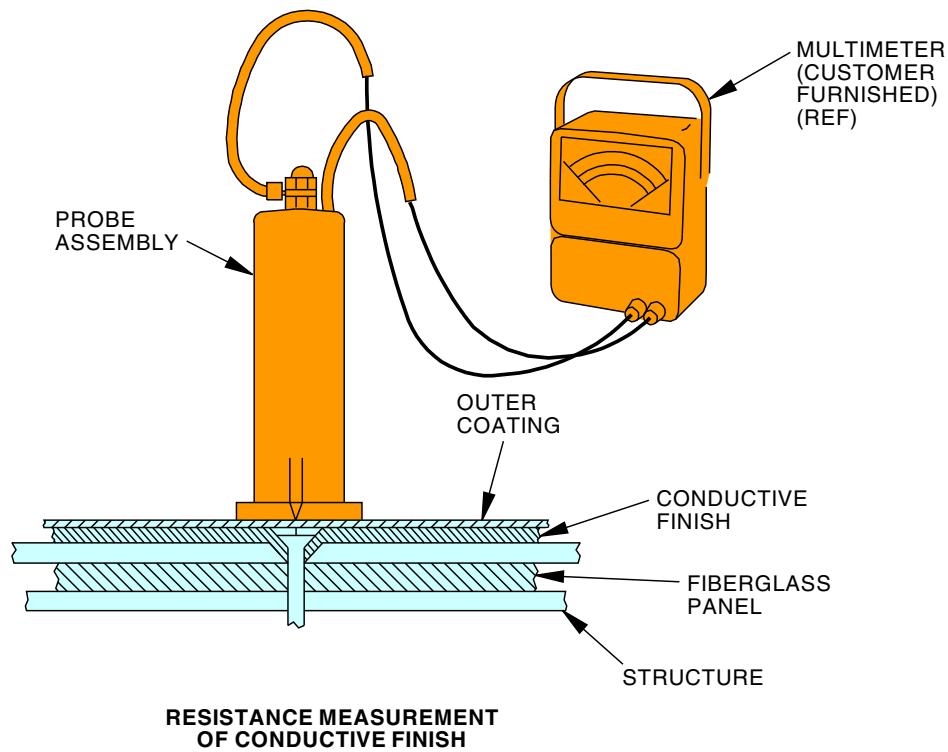
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**53-52-00**

Page 722  
Oct 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



F34237 S0006579528\_V4

**Resistivity Measurement of Conductive Finish**  
**Figure 709/53-52-00-990-812**

EFFECTIVITY  
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D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-52-00**

Page 723  
Oct 15/2024





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

LIGHTNING DIVERTER STRIPS - MAINTENANCE PRACTICES

**1. General**

- A. This procedure contains three tasks:
  - (1) The first task is the removal of the lightning diverter strips.
  - (2) The second task is the installation of the lightning diverter strips.
  - (3) The third task is the adjustment/test of the lightning diverter strips.
- B. You must repair the damaged radome surface before you install the new lightning diverter strips.

**TASK 53-52-03-000-801**

**2. Remove the Lightning Diverter Strips**

(Figure 201)

**A. References**

Reference	Title
53-52-00-010-802	Nose Radome - Open (P/B 201)

**B. Consumable Materials**

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

**C. Location Zones**

Zone	Area
111	Radome

**D. Lightning Diverter Strips Removal**

**SUBTASK 53-52-03-010-001**

- (1) Do this task: Nose Radome - Open, TASK 53-52-00-010-802.

**SUBTASK 53-52-03-020-001**

- (2) Remove the screws that attach the applicable diverter strip [3] to the nose radome [1] (Figure 202).

**SUBTASK 53-52-03-020-002**

- (3) Remove the diverter strip [3] from the nose radome [1].

**SUBTASK 53-52-03-100-001**

- (4) Remove all unwanted material from the nose radome [1] surface.

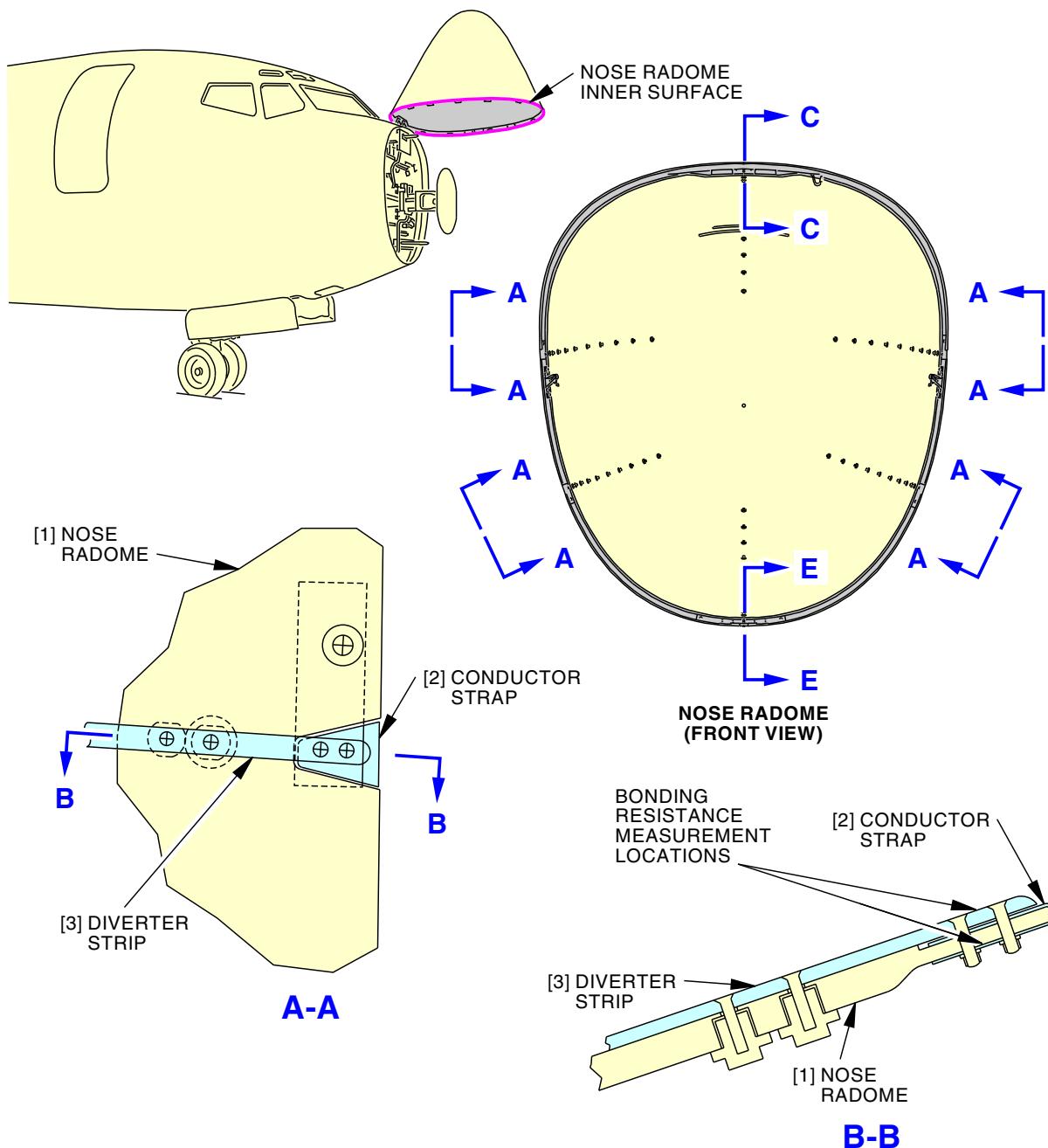
**SUBTASK 53-52-03-100-002**

- (5) Clean the nose radome [1] surface with a cotton wiper, G00034, that is moist with solvent, B00083.

— END OF TASK —

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**53-52-03**



2789822 S0000634411\_V2

**Diverter Strip Installation**  
**Figure 201/53-52-03-990-804 (Sheet 1 of 3)**

EFFECTIVITY  
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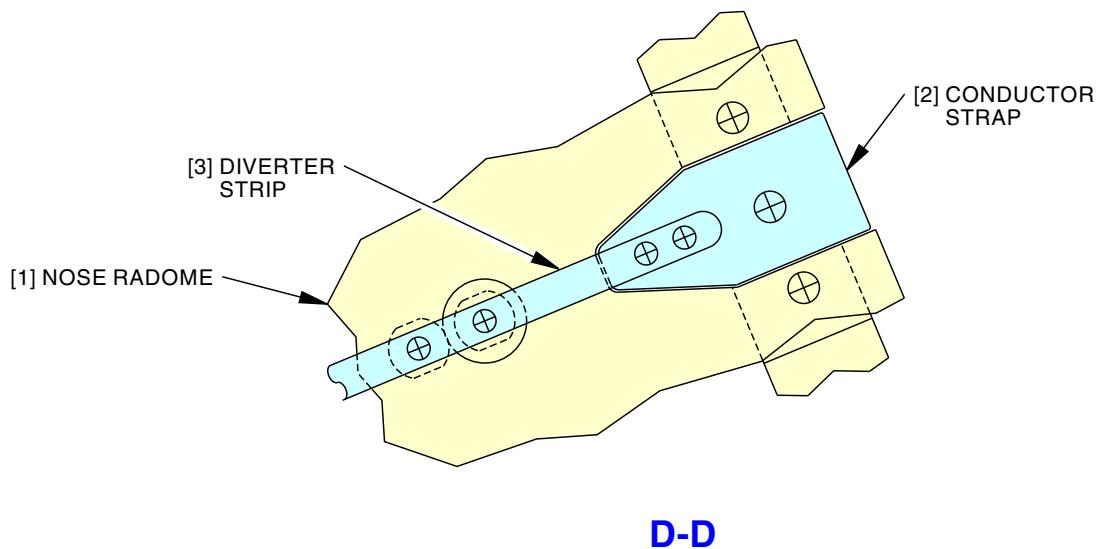
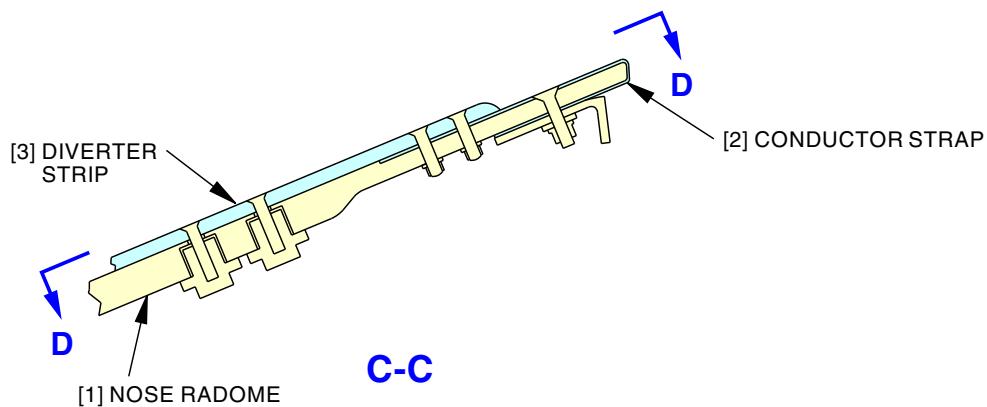
**53-52-03**

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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



2789842 S0000634412\_V1

Diverter Strip Installation  
Figure 201/53-52-03-990-804 (Sheet 2 of 3)

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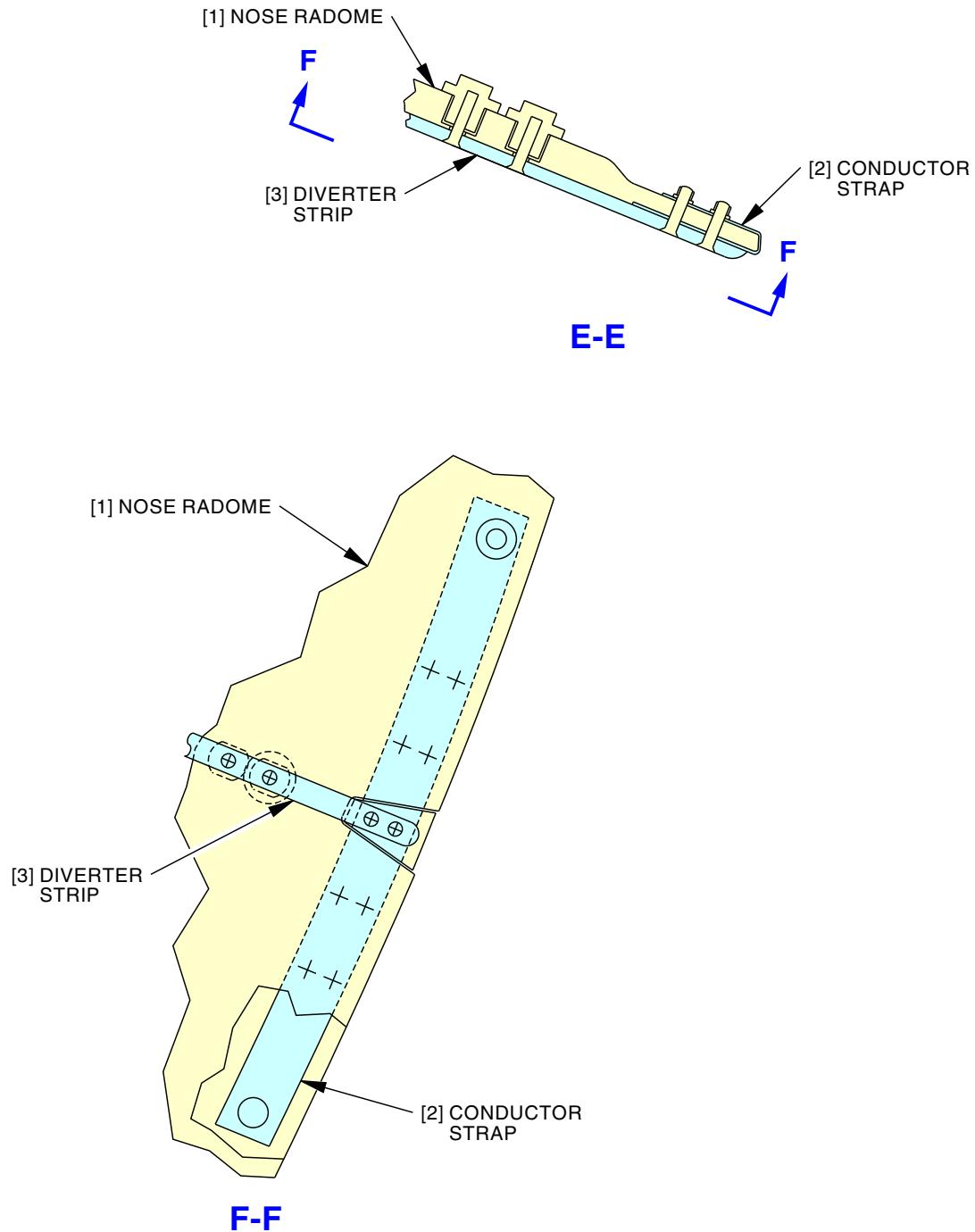
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

**53-52-03**

Page 203  
Feb 15/2018

**BOEING**  
**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**



2790013 S0000634413\_V1

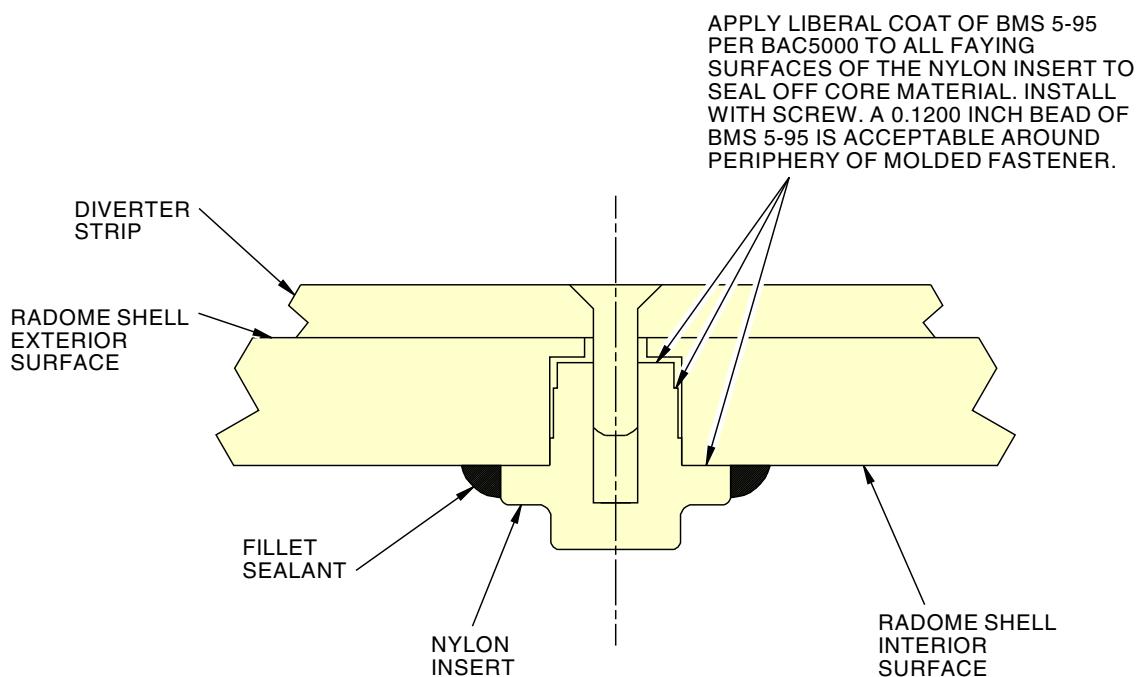
**Diverter Strip Installation**  
**Figure 201/53-52-03-990-804 (Sheet 3 of 3)**

EFFECTIVITY	LOM ALL
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**53-52-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



L13925 S0006581070\_V2

Insert/Sealant Installation  
Figure 202/53-52-03-990-805

EFFECTIVITY  
LOM ALL

**53-52-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 205  
Feb 15/2018



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-52-03-400-801**

**3. Install the Lightning Diverter Strip**

(Figure 201)

**A. References**

Reference	Title
51-21-99-300-802	Decorative Exterior Paint System Repair (P/B 701)

**B. Consumable Materials**

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A50250	Sealant - P/S 870 Class B-1/2 Corrosion Inhibitive Sealant	BMS5-95 Class B-1/2
A50479	Sealant - P/S 870 Class B-2 Corrosion Inhibitive Sealant	BMS5-95 Class B-2
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III

**C. Location Zones**

Zone	Area
111	Radome

**D. Procedure**

**SUBTASK 53-52-03-370-001**

- (1) Repair the nose radome [1] surface if the protective finish is damaged, do this task: (Decorative Exterior Paint System Repair, TASK 51-21-99-300-802).

**SUBTASK 53-52-03-100-003**

- (2) Clean the mating surfaces of the applicable diverter plate and the applicable diverter strip [3] for a satisfactory electrical bond.

**SUBTASK 53-52-03-390-001**

- (3) Seal the diverter strip [3] attach inserts.
  - (a) Clean insert surface with a rag moistened with solvent, B00083 and let dry.
  - (b) Clean the nose radome [1] surface around insert hole with a rag moistened with solvent, B00083 and let dry.
  - (c) Apply sealant, A00247 on and around the insert hole in the nose radome [1] and the mating surface of the insert. Completely coat the honeycomb core cells with sealant (Figure 202).
  - (d) Install the insert immediately before the sealant has a chance to set-up.
  - (e) Make sure there is squeeze out of the sealant all round the insert on both surfaces of the nose radome [1]. The sealant squeeze out on the aerodynamic surface of the nose radome [1] needs to be flush with the surface. This is to accommodate the fit-up of the diverter strip [3].
  - (f) Apply a 0.12 inch fillet seal of sealant, A00247 around the flange of the diverter strip [3] insert that is exposed to the interior side of the nose radome [1].

**NOTE:** It is important to make sure that the diverter strip [3] attach inserts are completely sealed to prevent moisture from entering into the nose radome [1] honeycomb core.

EFFECTIVITY
LOM ALL

**53-52-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-52-03-420-001

- (4) Install the diverter strip [3], do these steps:

(a) Apply a bead of sealant P/S 870 Class B-1/2 sealant, A50250 or P/S 870 Class B-2 sealant, A50479 on the nose radome [1] outer surface where the diverter strip [3] will be installed.

(b) Push the diverter strip [3] tightly against the nose radome [1].

(c) Align the diverter strip [3] holes with the correct nose radome [1] fastener holes.

(d) Install the screws, except the diverter strip [3] grounding or terminating fasteners with sealant, A00247.

NOTE: Grounding or terminating fasteners are not to be installed wet with sealant.

(e) Remove excess sealant.

NOTE: If used, do not let alcohol or acetone dry on the nose radome [1] surface.

Wipe/dry the solvents from the surface using a dry, clean lint free cloth.

(f) At the grounding or terminating fasteners, over coat the fastener tail side and nut with sealant, A00247.

(g) Install a bead of sealant, A00247 over the heads of each of the diverter strip [3] fasteners to prevent moisture ingestion.

SUBTASK 53-52-03-410-001

- (5) Install the nose radome [1] if it was removed.

SUBTASK 53-52-03-210-001

- (6) Make sure there are no clearances between the diverter strip [3] and the nose radome [1].

SUBTASK 53-52-03-860-001

- (7) Do this task: Lightning Diverter Strips - Test, TASK 53-52-03-820-801.

————— END OF TASK ————

**TASK 53-52-03-820-801**

**4. Lightning Diverter Strips - Test**

(Figure 201)

**A. General**

- (1) This procedure gives the instructions to do a dc continuity test for all parts that are related to the diverter strips [3]. You must do this test after you install the new diverter strips [3] or when the inspection shows deterioration. The deterioration of the diverter strips [3] can cause radio noise interference.

**B. References**

Reference	Title
53-52-00-010-802	Nose Radome - Open (P/B 201)
53-52-00-410-802	Nose Radome - Close (P/B 201)

**C. Tools/Equipment**

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

EFFECTIVITY  
LOM ALL

**53-52-03**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

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

**D. Location Zones**

<b>Zone</b>	<b>Area</b>
111	Radome

**E. Procedure**

SUBTASK 53-52-03-010-002

- (1) Do this task: Nose Radome - Open, TASK 53-52-00-010-802.

SUBTASK 53-52-03-210-002

- (2) Measure the electrical resistance between the points shown with an intrinsically safe approved bonding meter, COM-1550 and make sure the resistance does not exceed 0.01 ohms for diverter strips [3] that have been in service. The maximum resistance for new diverter strips [3] is 0.001 ohms.

SUBTASK 53-52-03-410-003

- (3) If you are not doing this task as part of the conductor strap [2] installation. Do this task: Nose Radome - Close, TASK 53-52-00-410-802.

SUBTASK 53-52-03-210-003

- (4) Measure the electrical resistance between the applicable diverter strip [3] and the airframe with an intrinsically safe approved bonding meter, COM-1550, and make sure the resistance is less than 30 milliohms.

———— END OF TASK ————





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

LIGHTNING DIVERTER STRIPS - REPAIRS

**1. General**

- A. This procedure has one task:
- (1) A temporary repair of the lightning diverter strips.



DO NOT OPERATE THE AIRPLANE FOR LONG PERIODS OF TIME WITH MISSING, OR DAMAGED DIVERTER STRIPS. REPAIR THE DIVERTER STRIPS QUICKLY. THE RISK OF DAMAGE TO THE RADOME, AND OTHER EQUIPMENT FROM LIGHTNING STRIKES INCREASES WHILE THERE ARE MISSING, OR DAMAGED STRIPS.

- B. A temporary repair should be replaced by a permanent repair before reaching 400 flight hours.
- C. Because of the possible effects on the ILS antenna pattern, the number of missing or damaged strips must be at a minimum and missing/removed in a symmetrical pattern. It is possible to remove strips on BL 0 independently.
- D. The number of diverter strips missing/damaged must not be more than 40% of the total number of diverter strips. (For example, on radomes with 6 diverter strips, there must be no more than 2 diverter strips in symmetrical pairs missing or damaged at one time. Radomes with 10 diverter strips there must be no more than 4 diverter strips in symmetrical pairs missing or damaged.)
- E. Sections of diverter strips not connected to the grounding plate can cause interference with communications equipment.

**TASK 53-52-03-300-801**

**2. Lightning Diverter Strip Temporary Repair**

**A. References**

Reference	Title
53-52-03-000-801	Remove the Lightning Diverter Strips (P/B 201)

**B. Consumable Materials**

Reference	Description	Specification
G50012 [P05-278]	Tape - Protective Polyurethane - 3M 8672	
G50361	Tape - Mylar, Permacel P-280	
G50362	Tape - 3M Polyester Tape 853 (Formerly Scotch No. 853 Tape)	

**C. Location Zones**

Zone	Area
111	Radome

**D. Lightning Diverter Strip Temporary Repair**

SUBTASK 53-52-03-350-001

- (1) For damaged diverter strips:
- (a) Remove all loose pieces of the lightning diverter strip (TASK 53-52-03-000-801).
- (b) Make sure that the remaining section of the damaged strip is safely held.
- (c) Make sure that the ground plate is not damaged.
- (d) Make sure that there is a continuous connection with the remaining section of the damaged strip and the ground plate.

EFFECTIVITY  
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**53-52-03**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-52-03-350-002

- (2) For missing or removed diverter strips:
- (a) Seal openings from missing bolts with non-metallic tape (3M 853 tape, G50362, Permacel P-280 tape, G50361, 3M 8672 tape, G50012 [P05-278], or equivalent).
  - (b) Make sure that all tape edges are flush with the surface of the radome.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-52-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

CONDUCTOR STRAPS - REMOVAL/INSTALLATION

**1. General**

- A. This procedure contains two tasks:
- (1) The first task is for the removal of the conductor straps [2].
  - (2) The second task is for the installation of the conductor straps [2].

**TASK 53-52-03-000-802**

**2. Remove the Conductor Straps**

(Figure 401)

**A. General**

- (1) This task includes the steps to remove the conductor straps [2] from the nose radome [1].

**B. References**

Reference	Title
53-52-03-000-801	Remove the Lightning Diverter Strips (P/B 201)
SRM 51-00-10	GENERAL SEALANT REMOVAL PRECAUTIONS

**C. Consumable Materials**

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III

**D. Location Zones**

Zone	Area
111	Radome

**E. Procedure**

**SUBTASK 53-52-03-010-003**

- (1) Remove the applicable diverter strips [3], do this task: Remove the Lightning Diverter Strips, TASK 53-52-03-000-801.
- (2) Remove the applicable conductor straps [2], refer to SRM 51-00-10.

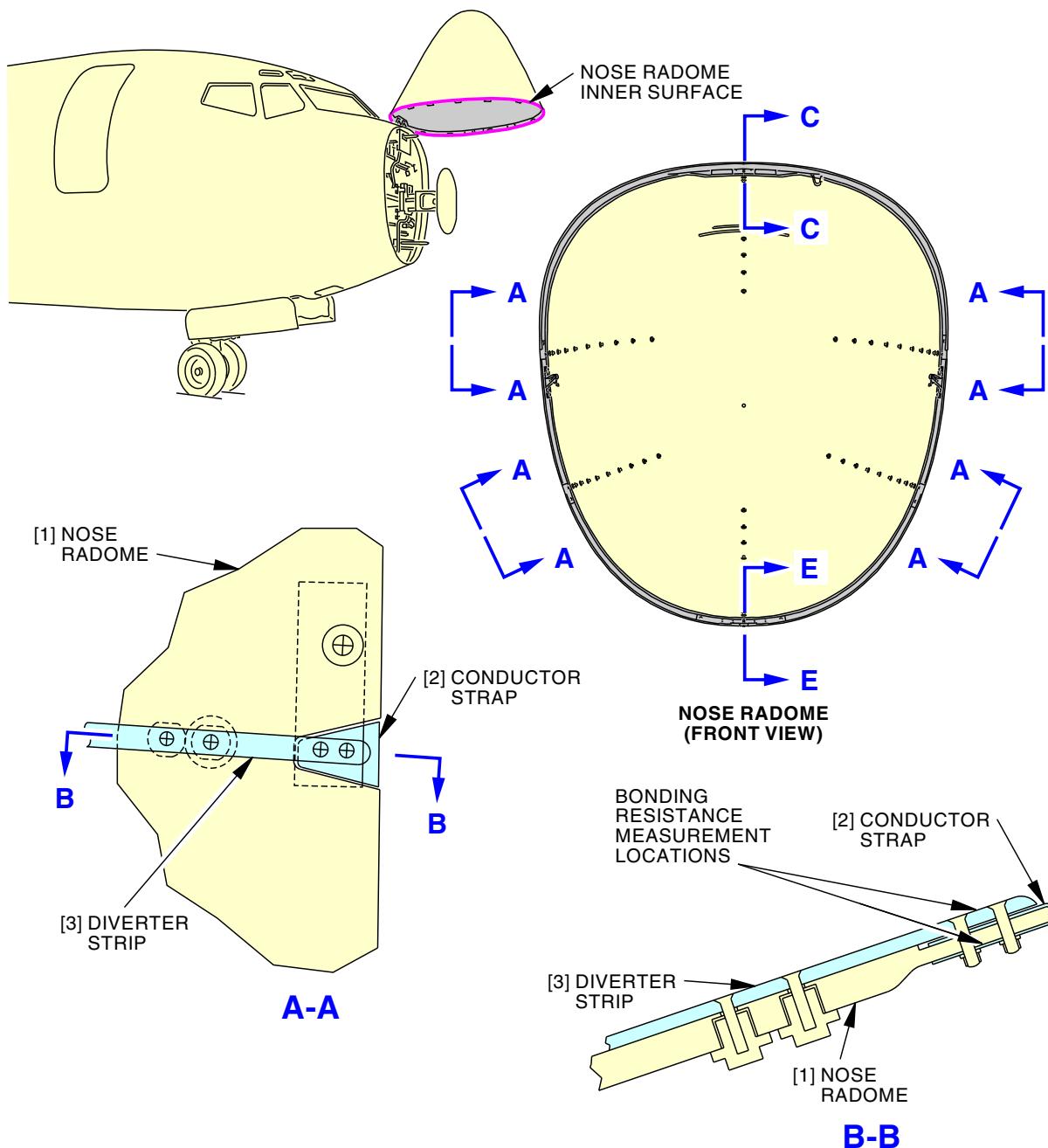
**SUBTASK 53-52-03-100-004**

- (3) Clean nose radome [1] surface around insert hole with a rag moistened with solvent, B00083 and let dry.

———— END OF TASK ————



**53-52-03**



2789822 S0000634411\_V2

**Conductor Strap Installation**  
**Figure 401/53-52-03-990-806 (Sheet 1 of 3)**

EFFECTIVITY  
LOM ALL

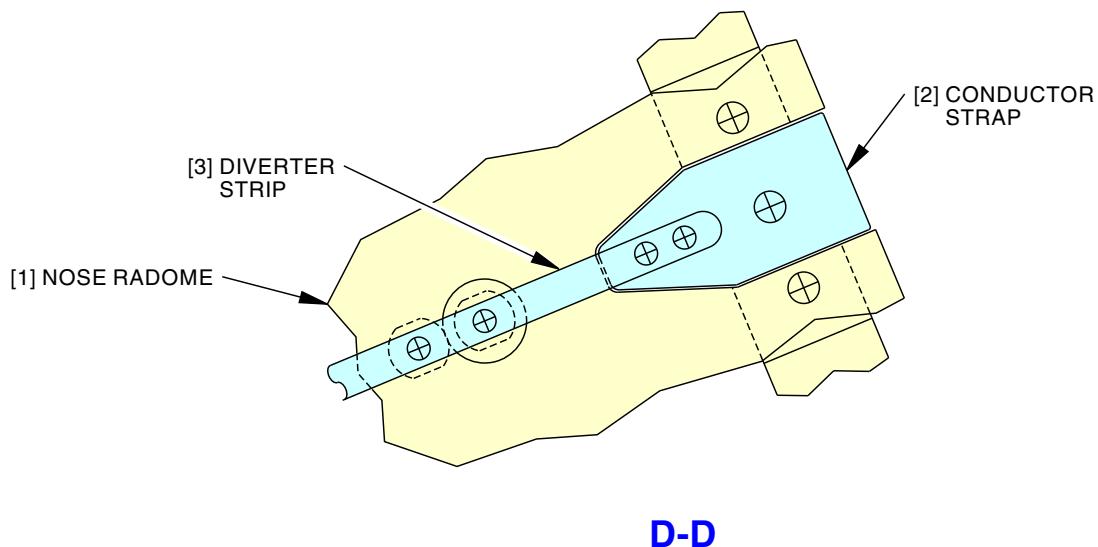
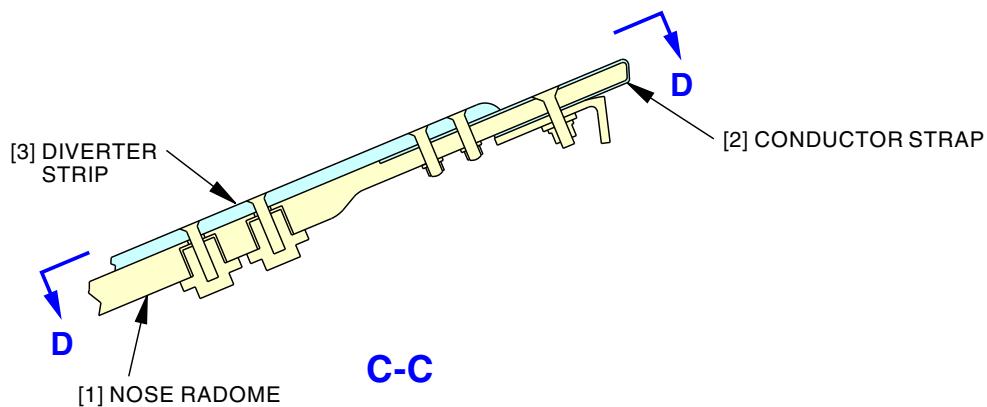
**53-52-03**

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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



2789842 S0000634412\_V1

Conductor Strap Installation  
Figure 401/53-52-03-990-806 (Sheet 2 of 3)

EFFECTIVITY  
LOM ALL

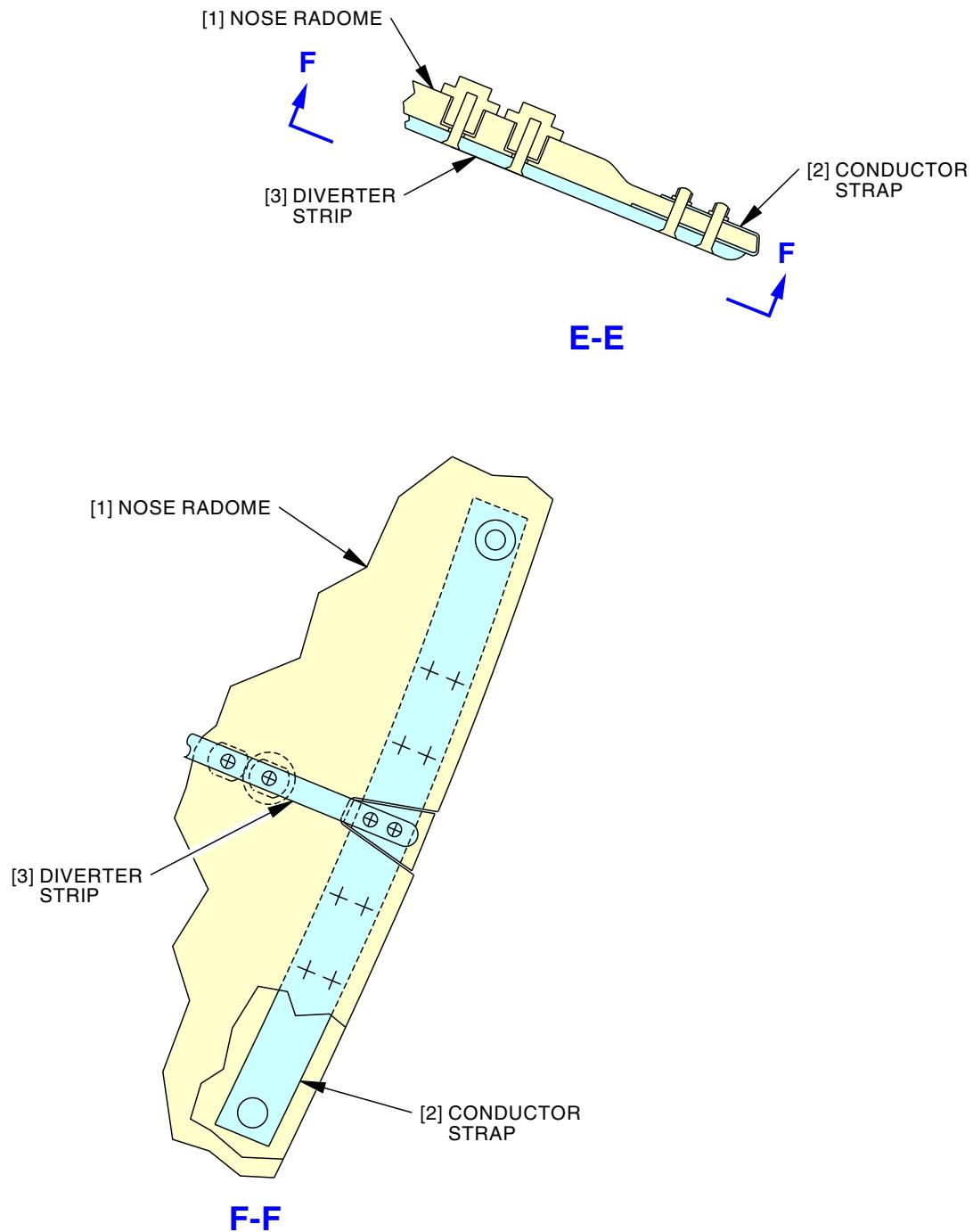
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Page 403  
Feb 15/2018

**BOEING**  
**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**



2790013 S0000634413\_V1

**Conductor Strap Installation**  
**Figure 401/53-52-03-990-806 (Sheet 3 of 3)**

EFFECTIVITY	LOM ALL
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**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-52-03-400-802**

**3. Install the Conductor Straps**

(Figure 401)

**A. General**

- (1) This task includes the steps to install the conductor straps [2] to the nose radome [1].

**B. References**

Reference	Title
53-52-00-410-802	Nose Radome - Close (P/B 201)
53-52-03-400-801	Install the Lightning Diverter Strip (P/B 201)

**C. Tools/Equipment**

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

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

**D. Consumable Materials**

Reference	Description	Specification
A00273	Adhesive - Epoxy Polyamide, 2 Part, Natural Colored	BMS5-126 Type II Class 1
A00435	Adhesive - Epoxy Polyamide, 2 Component, Natural Color	BMS5-126 Type III Class 1
A50081	Adhesive - Modified Epoxy For General Purpose Use	BMS5-92 Type I
A50231	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class B
A50355	Adhesive - Epoxy Polyamide, 2 Component	BMS5-126 Type IV Class 1
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

**E. Expendables/Parts**

AMM Item	Description	AIPC Reference	AIPC Effectivity
2	Conductor strap	53-52-00-03A-285	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999

EFFECTIVITY  
LOM ALL

**53-52-03**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

AMM Item	Description	AIPC Reference	AIPC Effectivity
2 (cont.)		53-52-00-03A-290	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		53-52-00-03A-295	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		53-52-00-03A-300	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		53-52-03-01-030	LOM ALL
		53-52-03-01-035	LOM ALL
		53-52-03-01-040	LOM ALL
		53-52-03-01-045	LOM ALL

**F. Location Zones**

Zone	Area
111	Radome

**G. Procedure**

SUBTASK 53-52-03-100-006

- (1) Clean the mating surfaces of the nose radome [1] and the applicable conductor straps [2] with solvent, B00083.

SUBTASK 53-52-03-420-002

- (2) Install applicable conductor straps [2] using adhesive, A00273, adhesive, A00435, adhesive, A50355 or adhesive, A50081:

- (a) To prepare the adhesive, do the following:

- 1) adhesive, A00273, before use, stir the individual components. Mix equal parts by weight of components A and B.

NOTE: The pot life of adhesive, A00273 is approximately 2 hours below 80°F (27°C). Prepare adhesive before use to maximize time for application.

- 2) adhesive, A00435, before use, stir the individual components. Mix equal parts by weight of components A and B.

NOTE: The pot life of adhesive, A00435 is approximately 2 hours below 80°F (27°C). Prepare adhesive before use to maximize time for application.

- 3) adhesive, A50355, before use, stir the individual components. Mix components in accordance with the manufacturers instructions.

- 4) adhesive, A50081, before use, stir the individual components. Mix components in accordance with the manufacturers instructions.





**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (b) Apply a thin continuous coat of blended adhesive to the faying surface of the conductor straps [2] and nose radome [1].  
NOTE: Application of adhesive on one surface is permitted on smooth faying surfaces of less than 12 in<sup>2</sup> (77 cm<sup>2</sup>), if mating surfaces fit intimately and no voids are left in the bond area.
- (c) Align the conductor straps [2] holes with the nose radome [1] aft holes.
- (d) Install the conductor straps [2] on the nose radome [1]:
  - 1) Apply firm pressure to make sure that the faying surfaces are in contact.
  - 2) Clean unwanted adhesive before it has cured, using a cotton wiper, G00034 that is moist with solvent, B00083.  
NOTE: Do not allow solvent to flow into the bondline.
- (e) Cure under constant pressure for 24 hours under 80°F (27°C).
- (f) Fill the gap between the conductor straps [2] and the nose radome [1] with sealant, A50231:
  - 1) Mix components in accordance with the manufacturers instructions.
  - 2) Apply a bead of sealant, A50231 to the gap between the conductor straps [2] and the nose radome [1].
  - 3) Cure for 24 hours at room temperature.
- (3) Install applicable diverter strips [3], do this task: Install the Lightning Diverter Strip, TASK 53-52-03-400-801.

#### H. Installation Test

SUBTASK 53-52-03-700-001

- (1) Measure the electrical resistance between the applicable diverter strip [3] and conductor strap [2] with an intrinsically safe approved bonding meter, COM-1550:
  - (a) Make sure the resistance is not more than 0.001 ohms.
- (2) Do this task: Nose Radome - Close, TASK 53-52-00-410-802.

———— END OF TASK ————

EFFECTIVITY
LOM ALL

**53-52-03**





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

GLIDE SLOPE ANTENNA DIRECTOR BAR - REMOVAL/INSTALLATION

**1. General**

- A. This procedure contains two tasks. The first task is the removal of the director bar for the glide scope antenna. The second task is the installation of the director bar for the glide scope antenna.
- B. The director bar for the glide slope antenna is an aluminum foil pressure-sensitive strip of tape. The director bar is attached to the inner surface of the nose radome. It changes the radiation signals for the glide slope antenna.

**TASK 53-52-31-000-801**

**2. Glide Slope Director Bar Removal**

(Figure 401)

**A. Location Zones**

<u>Zone</u>	<u>Area</u>
111	Radome

**B. Procedure**

SUBTASK 53-52-31-860-001

- (1) Open this circuit breaker and install safety tag:

**F/O Electrical System Panel, P6-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
D	13	C00120	WEATHER RADAR RT

SUBTASK 53-52-31-010-001

- (2) Open the nose radome.

- (a) Remove the screws which attach the radome to the clips on the fuselage.



DO NOT OPEN THE RADOME IF THE WIND SPEED IS MORE THAN 15 KNOTS. THIS CAN CAUSE DAMAGE TO THE RADOME.

- (b) Open the radome.

- (c) Install the support rod to hold the radome open.

SUBTASK 53-52-31-020-001

- (3) Remove the director bar [1].

— END OF TASK —

**TASK 53-52-31-400-801**

**3. Glide Slope Director Bar Installation**

(Figure 401)

**A. References**

<u>Reference</u>	<u>Title</u>
53-52-00-400-801	Nose Radome Installation (P/B 401)

EFFECTIVITY  
LOM ALL

**53-52-31**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**B. Consumable Materials**

Reference	Description	Specification
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
G00291	Tape - Aluminum Foil, 3M 425	AMS-T-23397 / L-T-80

**C. Location Zones**

Zone	Area
111	Radome

**D. Procedure**

SUBTASK 53-52-31-110-001

- (1) Clean the nose radome surface where you will install the director bar with solvent, B00083.

SUBTASK 53-52-31-370-001

- (2) Apply one layer of the primer, C00259 to the surface where you will install the director bar.

SUBTASK 53-52-31-110-002

- (3) Clean the surface with the solvent, B00083.

SUBTASK 53-52-31-420-001

- (4) Do these steps to make and install the director bar.

- (a) Cut a 14 in. (36 cm) long strip of the 3M 425 Aluminum Foil Tape, G00291.

- (b) Install the tape as shown in (Figure 401).

- (c) Push the 3M 425 Aluminum Foil Tape, G00291 correctly into its location.

SUBTASK 53-52-31-420-002

- (5) Install the M1458 decal on the radome as shown in (Figure 401) if it is not installed.

SUBTASK 53-52-31-410-001

- (6) Do this task: (Nose Radome Installation, TASK 53-52-00-400-801).

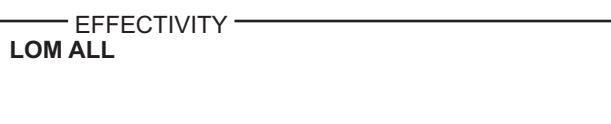
SUBTASK 53-52-31-860-002

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

**F/O Electrical System Panel, P6-1**

Row	Col	Number	Name
D	13	C00120	WEATHER RADAR RT

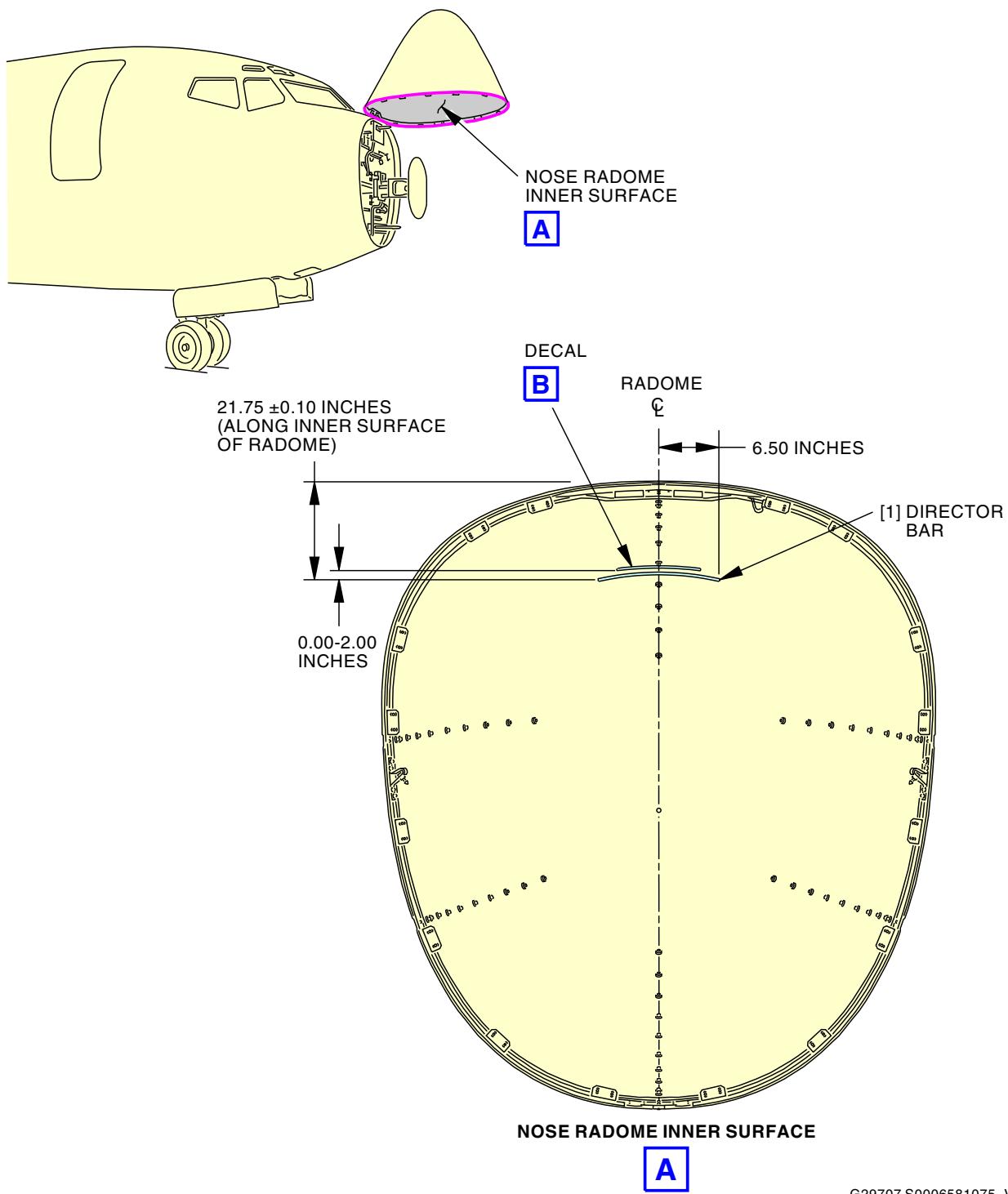
———— END OF TASK ————



**53-52-31**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Director Bar - Glide Slope Antenna Installation  
Figure 401/53-52-31-990-801 (Sheet 1 of 2)

EFFECTIVITY  
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**53-52-31**

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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**GLIDESLOPE ANTENNA DIRECTOR BAR -M1458**

DECAL



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**Director Bar - Glide Slope Antenna Installation  
Figure 401/53-52-31-990-801 (Sheet 2 of 2)**

EFFECTIVITY  
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**53-52-31**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 404  
Oct 15/2015



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

TAILCONE - REMOVAL/INSTALLATION

**1. General**

- A. This procedure contains these tasks:
- (1) A removal of the tailcone
  - (2) An installation of the tailcone.

**TASK 53-53-00-000-801**

**2. Tailcone Removal**

(Figure 401)

**A. General**

- (1) A power-off flight test may be necessary after the installation of the component. Check the requirements in the "General" section at the beginning of the Elevator Power-Off Flight - Test, TASK 27-31-00-710-803.

**B. References**

Reference	Title
27-21-17-000-801	Rudder Index Plate Removal (P/B 401)
27-31-00-710-803	Elevator Power-Off Flight - Test (P/B 501)
27-31-11-000-801	Elevator - Removal (P/B 401)
27-31-81-000-801	Elevator Index Plate Removal (P/B 401)
27-41-00-800-801	Horizontal Stabilizer Trim Control System - Deactivation (P/B 201)
27-41-00-800-802	Horizontal Stabilizer Trim Control System - Activation (P/B 201)
49-91-71-000-801	Eductor Inlet Duct Removal (P/B 401)
55-10-11-000-801	Balance Bay Panels Removal (P/B 401)

**C. Tools/Equipment**

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

Reference	Description
SPL-1672	Lock Assembly - Stabilizer Trim Part #: F71336-501 Supplier: 81205
STD-10684	Plastic Sheet - Protective

**D. Location Zones**

Zone	Area
117	Electrical and Electronics Compartment - Left
315	APU Compartment - Left
316	APU Compartment - Right

**E. Access Panels**

Number	Name/Location
117A	Electronic Equipment Access Door
318BR	Tailcone Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body

EFFECTIVITY  
LOM ALL

**53-53-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
333AZ	Horizontal Stabilizer, Access Panel, Inboard T.E. Closure Rib
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AZ	Horizontal Stabilizer, Access Panel - Inbd T.E. Closure Rib
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

**F. Prepare for the Removal**

SUBTASK 53-53-00-860-005

- (1) Use a non-permanent marker to make alignment marks on the tailcone [1] and fuselage.

SUBTASK 53-53-00-480-001

- (2) Move the stabilizer and elevator to a position that will let the elevator control pushrods be disconnected (TASK 27-31-11-000-801).

SUBTASK 53-53-00-040-001



**WARNING**

MAKE SURE THAT ALL PERSONNEL, AND EQUIPMENT ARE AWAY FROM THE HORIZONTAL STABILIZER. THE MOVEMENT OF THE HORIZONTAL STABILIZER DURING MAINTENANCE CAN CAUSE INJURY TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (3) Deactivate the horizontal stabilizer (TASK 27-41-00-800-801).

SUBTASK 53-53-00-860-007

- (4) 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

**CAPT Electrical System Panel, P18-2**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	8	C00544	FLIGHT RECORDER POSITION SENSOR

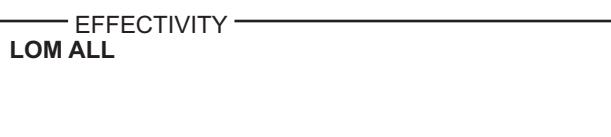
**F/O Electrical System Panel, P6-2**

<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 53-53-00-010-009

- (5) To get access to the P91 panel, open this access panel:

<u>Number</u>	<u>Name/Location</u>
117A	Electronic Equipment Access Door



**53-53-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-53-00-860-008



**WARNING**

WHEN YOU OPEN THE P91 AND P92 PANELS, MAKE SURE THAT THE OUTER DOOR STAYS AS OPEN AS POSSIBLE. IF THE OUTER DOOR TURNS IN, THE ATTACHED DOOR COMPONENTS COULD TOUCH THE INNER DOOR COMPONENTS. THIS CAN CAUSE AN ARC CONDITION WHEN YOU SUPPLY POWER. IF YOU DO NOT OBEY, DAMAGE TO EQUIPMENT AND INJURY TO PERSONNEL CAN OCCUR.



**WARNING**

DO NOT TOUCH THE CONDUCTORS IN THE P91 AND P92 PANELS. BE CAREFUL WHEN YOU GET ACCESS TO THE CIRCUIT BREAKERS ON THE INNER SIDE OF THE P91 AND P92 PANELS (ROW F). IF IT IS POSSIBLE, REMOVE AIRPLANE ELECTRICAL POWER FIRST. THE P91 AND P92 PANELS HAVE HIGH VOLTAGES AND CURRENTS. ELECTRICAL VOLTAGE AND CURRENT CAN KILL YOU OR CAUSE INJURIES.

- (6) Open this circuit breaker and install safety tag:

**Power Distribution Panel Number 1, P91**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	5	C00389	ACCESS COMPT LT

SUBTASK 53-53-00-480-002

- (7) Install the lock assembly, SPL-1672, on the stabilizer trim wheel at the control stand.
- 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 53-53-00-010-005

- (8) Open these access panels:

**Number      Name/Location**

318BR	Tailcone Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AZ	Horizontal Stabilizer, Access Panel, Inboard T.E. Closure Rib
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AZ	Horizontal Stabilizer, Access Panel - Inbd T.E. Closure Rib

SUBTASK 53-53-00-860-006

- (9) Open these access panels:

(TASK 55-10-11-000-801)

**Number      Name/Location**

333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

SUBTASK 53-53-00-010-006

- (10) Remove these parts to get access to the tailcone fasteners (Figure 401):

- Remove the screws [7] that attach the vertical blade seal [10] to the structure.
- To remove the lower track assembly [11], do these steps:

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LOM ALL

**53-53-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 1) Remove the screws [3].
- 2) Remove the lower track assembly [11].
- (c) To remove the upper track assembly [12], do these steps:
  - 1) Remove the screws [9].
  - 2) Remove the upper track assembly [12].

NOTE: The forward fastener can stay installed and the upper track assembly turned up to get access to tailcone fasteners.
- (d) To remove the rub strip [5], do these steps:
  - 1) Remove the screws [4] that hold the rub strip [5] in its position.
  - 2) Remove the rub strip [5].
- (e) Do this task: Eductor Inlet Duct Removal, TASK 49-91-71-000-801.
- (f) Disconnect the electrical connector, D44584P (Station 1166), that attaches the tailcone wire harness to the structure connector.
- (g) Disconnect the electrical connector, D148, from the strobe light.
  - 1) Remove the clamps from the wire harness, W7152, that attach harness to the tailcone.

SUBTASK 53-53-00-420-006

- (11) Install the protective plastic sheet, STD-10684, on the tailcone [1] to prevent damage.

NOTE: When the tailcone is removed, it will touch the horizontal stabilizer.

SUBTASK 53-53-00-010-008

- (12) Remove the tailcone fasteners that are inboard of the horizontal stabilizer.

NOTE: Access is not sufficient to remove all fasteners. When the horizontal stabilizer is moved, these fasteners will have access.

SUBTASK 53-53-00-020-006

- (13) Disconnect the elevator control pushrod from the elevator (TASK 27-31-11-000-801).

SUBTASK 53-53-00-440-002



**WARNING** MAKE SURE THAT ALL PERSONNEL AND EQUIPMENT ARE AWAY FROM THE HORIZONTAL STABILIZER. THE MOVEMENT OF THE HORIZONTAL STABILIZER DURING MAINTENANCE CAN CAUSE INJURY TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (14) Activate the horizontal stabilizer (TASK 27-41-00-800-802).

SUBTASK 53-53-00-860-009

- (15) 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

**CAPT Electrical System Panel, P18-2**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	8	C00544	FLIGHT RECORDER POSITION SENSOR



**53-53-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**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 53-53-00-860-010



**WARNING**

WHEN YOU OPEN THE P91 AND P92 PANELS, MAKE SURE THAT THE OUTER DOOR STAYS AS OPEN AS POSSIBLE. IF THE OUTER DOOR TURNS IN, THE ATTACHED DOOR COMPONENTS COULD TOUCH THE INNER DOOR COMPONENTS. THIS CAN CAUSE AN ARC CONDITION WHEN YOU SUPPLY POWER. IF YOU DO NOT OBEY, DAMAGE TO EQUIPMENT AND INJURY TO PERSONNEL CAN OCCUR.



**WARNING**

DO NOT TOUCH THE CONDUCTORS IN THE P91 AND P92 PANELS. BE CAREFUL WHEN YOU GET ACCESS TO THE CIRCUIT BREAKERS ON THE INNER SIDE OF THE P91 AND P92 PANELS (ROW F). IF IT IS POSSIBLE, REMOVE AIRPLANE ELECTRICAL POWER FIRST. THE P91 AND P92 PANELS HAVE HIGH VOLTAGES AND CURRENTS. ELECTRICAL VOLTAGE AND CURRENT CAN KILL YOU OR CAUSE INJURIES.

- (16) Close this circuit breaker:

**Power Distribution Panel Number 1, P91**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	5	C00389	ACCESS COMPT LT

SUBTASK 53-53-00-840-001

- (17) Set flight control surfaces to remove the tailcone.

- Move the stabilizer trailing edge to the fully up position.
- Move the rudder trailing edge fully left or right.
- Move the elevator trailing edge to the fully up position.
- Make sure that the horizontal stabilizer will not move.

SUBTASK 53-53-00-040-003



**WARNING**

MAKE SURE THAT ALL PERSONNEL AND EQUIPMENT ARE AWAY FROM THE HORIZONTAL STABILIZER. THE MOVEMENT OF THE HORIZONTAL STABILIZER DURING MAINTENANCE CAN CAUSE INJURY TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (18) Deactivate the horizontal stabilizer (TASK 27-41-00-800-801).

**G. Tailcone Removal**

SUBTASK 53-53-00-020-001

- (1) Remove the tailcone.

- Remove the fasteners and washers that attach the tailcone to the structure.

NOTE: Some of the tailcone fasteners do not have washers. If it is necessary, put marks at the locations of the fastener holes that do not have washers.

NOTE: Tailcone fasteners inboard of the horizontal stabilizer can have access. If it is necessary, move the horizontal stabilizer to get access to tailcone fasteners.

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LOM ALL

**53-53-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



**CAUTION**

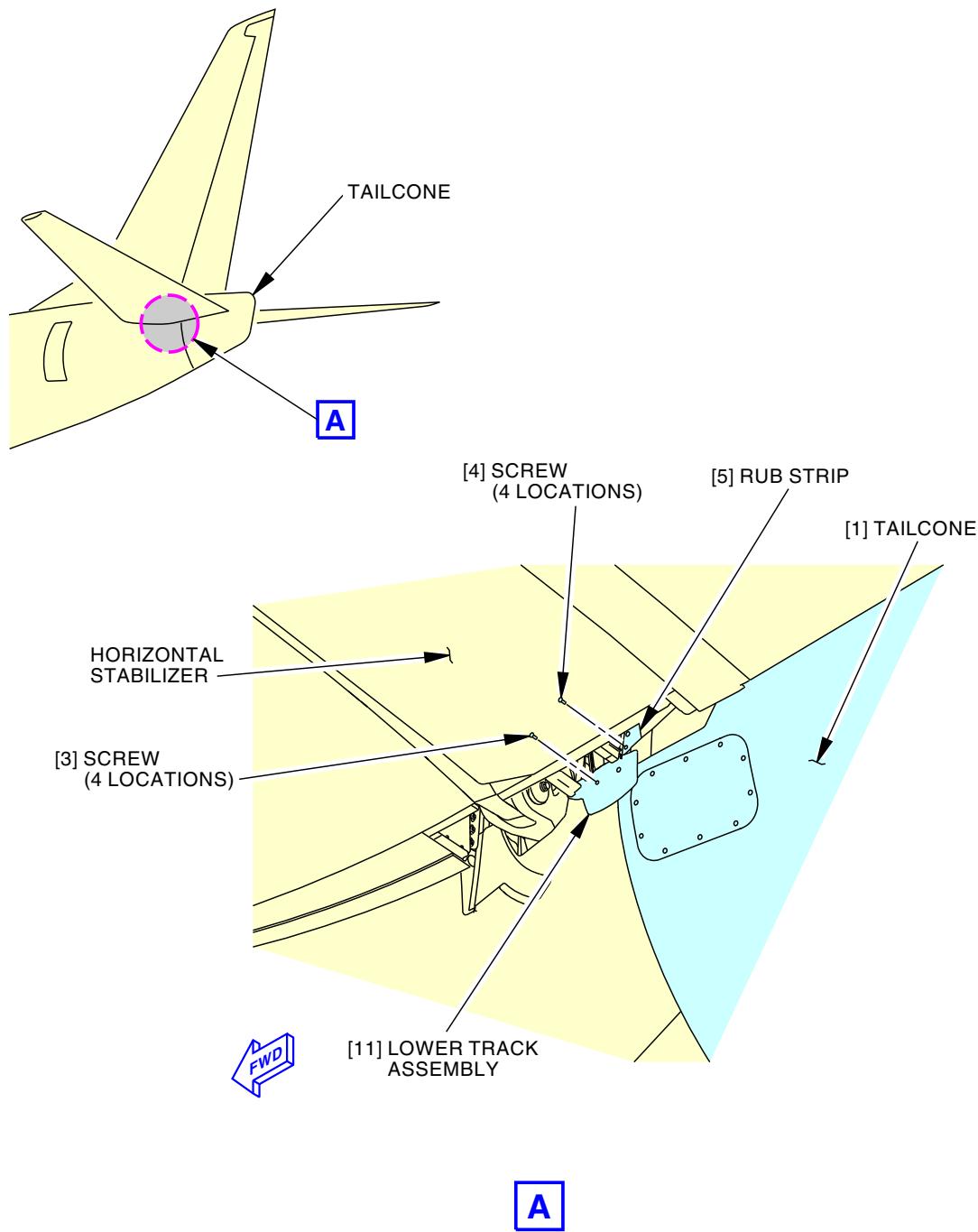
WHEN YOU REMOVE THE TAILCONE, IT CAN TOUCH EQUIPMENT ON THE AFT BULKHEAD. IF YOU APPLY TOO MUCH FORCE TO THE TAILCONE, DAMAGE TO EQUIPMENT ON THE AFT BULKHEAD CAN OCCUR.

- (b) When you remove the tailcone [1], make sure that it does not cause damage to equipment on the aft bulkhead.
- (c) Turn and lower the tailcone [1] away from the aft bulkhead.  
NOTE: The bottom forward edge of the tailcone will be forward of the aft bulkhead for a short time during this step.
- (d) If it is necessary, lightly push the forward end of the tailcone [1] together to clear flight surfaces.
- (e) If you will install a new tailcone or tailcone from a different airplane, do this task: Elevator Index Plate Removal, TASK 27-31-81-000-801.
- (f) If you will install a new tailcone or tailcone from a different airplane, do this task: Rudder Index Plate Removal, TASK 27-21-17-000-801.

———— END OF TASK ————

EFFECTIVITY  
LOM ALL

**53-53-00**



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**Tailcone Installation**  
Figure 401/53-53-00-990-802 (Sheet 1 of 2)

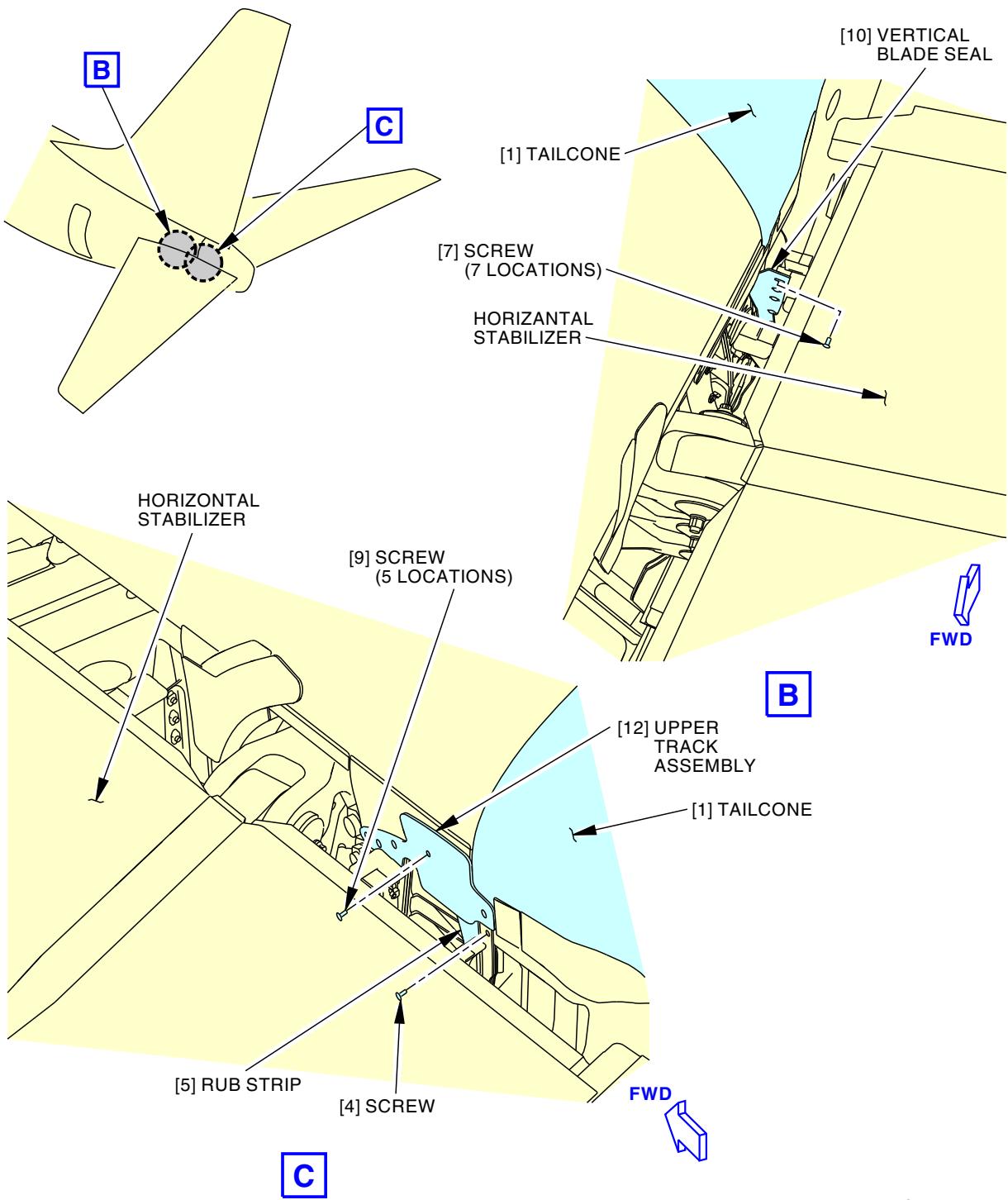
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 407  
Feb 15/2022



414769 S0000136220\_V3

**Tailcone Installation**  
Figure 401/53-53-00-990-802 (Sheet 2 of 2)

EFFECTIVITY  
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**53-53-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-53-00-400-801**

**3. Tailcone Installation**

(Figure 401)

**A. References**

Reference	Title
20-50-11-910-801	Standard Torque Values (P/B 201)
27-21-00-700-819-002	Rudder Trim System Test (P/B 501)
27-21-17-400-801	Rudder Index Plate Installation (P/B 401)
27-31-00-710-801	Elevator and Elevator Trim Control System - Operational Test (P/B 501)
27-31-00-710-803	Elevator Power-Off Flight - Test (P/B 501)
27-31-11-400-801	Elevator - Installation (P/B 401)
27-31-81-400-801	Elevator Index Plate Installation (P/B 401)
27-41-00-800-801	Horizontal Stabilizer Trim Control System - Deactivation (P/B 201)
27-41-00-800-802	Horizontal Stabilizer Trim Control System - Activation (P/B 201)
27-41-11-400-801	Horizontal Stabilizer Installation (P/B 401)
49-91-71-400-801	Eductor Inlet Duct Installation (P/B 401)
51-31-00-160-801	Prepare For Sealing (P/B 201)
51-31-00-390-806	Aerodynamic Smoother Application (P/B 201)
55-10-11-400-801	Balance Bay Panels Installation (P/B 401)

**B. Tools/Equipment**

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

Reference	Description
COM-1550	Bonding Meter - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550).  Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659
STD-10684	Plastic Sheet - Protective

**C. Consumable Materials**

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

**D. Expendables/Parts**

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Tailcone	53-53-00-20-005	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-465



**53-53-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

AMM Item	Description	AIPC Reference	AIPC Effectivity
1 (cont.)		53-53-00-20-580	LOM ALL
		53-53-00-20-585	LOM ALL

**E. Location Zones**

Zone	Area
117	Electrical and Electronics Compartment - Left
315	APU Compartment - Left
316	APU Compartment - Right

**F. Access Panels**

Number	Name/Location
117A	Electronic Equipment Access Door
318BR	Tailcone Access Door
333AB	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AT	Horizontal Stabilizer, Gap Cover, Horizontal Stabilizer to Body
333AZ	Horizontal Stabilizer, Access Panel, Inboard T.E. Closure Rib
333BB	Horizontal Stabilizer, Access Panel, Trailing Edge
343AB	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AT	Horizontal Stabilizer, Gap Cover - H. Stab. to Body
343AZ	Horizontal Stabilizer, Access Panel - Inbd T.E. Closure Rib
343BB	Horizontal Stabilizer, Access Panel - T.E. Area

**G. Prepare for the Installation**

SUBTASK 53-53-00-860-014



**WARNING**

MAKE SURE THAT ALL PERSONNEL, AND EQUIPMENT ARE AWAY FROM THE HORIZONTAL STABILIZER. THE MOVEMENT OF THE HORIZONTAL STABILIZER DURING MAINTENANCE CAN CAUSE INJURY TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (1) Make sure that the horizontal stabilizer will not move (TASK 27-41-00-800-801).

SUBTASK 53-53-00-860-011

- (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

**CAPT Electrical System Panel, P18-2**

Row	Col	Number	Name
C	8	C00544	FLIGHT RECORDER POSITION SENSOR

**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

EFFECTIVITY
LOM ALL

**53-53-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-53-00-860-012



**WARNING**

WHEN YOU OPEN THE P91 AND P92 PANELS, MAKE SURE THAT THE OUTER DOOR STAYS AS OPEN AS POSSIBLE. IF THE OUTER DOOR TURNS IN, THE ATTACHED DOOR COMPONENTS COULD TOUCH THE INNER DOOR COMPONENTS. THIS CAN CAUSE AN ARC CONDITION WHEN YOU SUPPLY POWER. IF YOU DO NOT OBEY, DAMAGE TO EQUIPMENT AND INJURY TO PERSONNEL CAN OCCUR.



**WARNING**

DO NOT TOUCH THE CONDUCTORS IN THE P91 AND P92 PANELS. BE CAREFUL WHEN YOU GET ACCESS TO THE CIRCUIT BREAKERS ON THE INNER SIDE OF THE P91 AND P92 PANELS (ROW F). IF IT IS POSSIBLE, REMOVE AIRPLANE ELECTRICAL POWER FIRST. THE P91 AND P92 PANELS HAVE HIGH VOLTAGES AND CURRENTS. ELECTRICAL VOLTAGE AND CURRENT CAN KILL YOU OR CAUSE INJURIES.

- (3) Make sure that this circuit breaker is open and has safety tag:

**Power Distribution Panel Number 1, P91**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	5	C00389	ACCESS COMPT LT

SUBTASK 53-53-00-100-001

- (4) Remove the aerodynamic sealant and clean the area of aft bulkhead where the tailcone [1] attaches, do this task: Prepare For Sealing, TASK 51-31-00-160-801.

SUBTASK 53-53-00-950-001

- (5) Install a protective plastic sheet, STD-10684, on the tailcone [1] to prevent damage.

## H. Tailcone Installation

SUBTASK 53-53-00-400-002

- (1) Install the tailcone [1].



**CAUTION**

WHEN YOU INSTALL THE TAILCONE, IT CAN TOUCH EQUIPMENT ON THE AFT BULKHEAD. IF YOU APPLY TOO MUCH FORCE TO THE TAILCONE, DAMAGE TO EQUIPMENT ON THE AFT BULKHEAD CAN OCCUR.

- (a) When you install the tailcone [1], make sure that it does not cause damage to equipment on the aft bulkhead.
- (b) Make sure that the elevator control rods are outboard of the tailcone [1].
- (c) Turn and lift the tailcone [1] into its position on the aft bulkhead.
- NOTE: The bottom forward edge of the tailcone will be forward of the aft bulkhead at the beginning of this step.
- (d) If it is necessary, lightly push the forward end of the tailcone [1] together to clear flight surfaces.
- (e) Make sure that the alignment marks are aligned.
- (f) Install but do not tighten the tailcone [1] attachment fasteners.
- (g) Tighten the fasteners.
- 1) Tighten opposite fasteners all around with your hand.

EFFECTIVITY  
LOM ALL

**53-53-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 2) Tighten opposite fasteners all around to the necessary torque  
(TASK 20-50-11-910-801).

NOTE: Some fasteners will not have access. When the horizontal stabilizer is moved, these fasteners will have access.



**WARNING** MAKE SURE THAT ALL PERSONNEL, AND EQUIPMENT ARE AWAY FROM THE HORIZONTAL STABILIZER. THE MOVEMENT OF THE HORIZONTAL STABILIZER DURING MAINTENANCE CAN CAUSE INJURY TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (h) Activate the horizontal stabilizer (TASK 27-41-00-800-802).
- (i) Move the stabilizer and elevator to a position that will let the elevator control pushrods be connected.
- (j) Deactivate the horizontal stabilizer (TASK 27-41-00-800-801).
- (k) Install and tighten remaining tailcone [1] fasteners that are inboard of the horizontal stabilizer.
- (l) Remove the protective plastic sheet, STD-10684.

## I. Put the Airplane Back to Its Usual Condition

### SUBTASK 53-53-00-410-005

- (1) Connect the elevator control pushrods to the elevator (TASK 27-31-11-400-801).

### SUBTASK 53-53-00-420-007

- (2) If you installed a new tailcone [1] or tailcone [1] from a different airplane, do this task: Rudder Index Plate Installation, TASK 27-21-17-400-801.

### SUBTASK 53-53-00-420-008

- (3) If you installed a new tailcone [1] or tailcone [1] from a different airplane, do this task: Elevator Index Plate Installation, TASK 27-31-81-400-801.

### SUBTASK 53-53-00-420-009

- (4) To install the rub strip [5], do these steps:  
(a) Install the rub strip [5].  
(b) Install the screws [4].

### SUBTASK 53-53-00-420-010

- (5) To install the lower track assembly [11], do these steps:  
(a) Install the lower track assembly [11].  
(b) Install the screws [3].

### SUBTASK 53-53-00-420-011

- (6) To install the upper track assembly [12], do these steps:  
(a) Install the upper track assembly [12].  
(b) Install the screws [9].

### SUBTASK 53-53-00-420-012

- (7) Install the screws [7] that attach the vertical blade seal [10] to the structure.

### SUBTASK 53-53-00-420-013

- (8) Connect the electrical connector, D44584P (Station 1166), that attaches the tailcone wire harness to the structure connector.

EFFECTIVITY  
LOM ALL

**53-53-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-53-00-420-014

- (9) Install the clamps to attach wire harness, W7152, to the tailcone [1].
  - (a) Connect the electrical connector, D148, to the strobe light.
  - (b) Measure the electrical bonding resistance between the metal components of the anticolision light housing and Auxiliary Power Unit (APU) eductor fairing surface.
    - 1) Use an intrinsically safe approved bonding meter, COM-1550.
    - 2) Make sure that the electrical bonding resistance 0.001 ohm (1.0 miliohm) or less.

SUBTASK 53-53-00-860-015

- (10) Do this task: Eductor Inlet Duct Installation, TASK 49-91-71-400-801.

SUBTASK 53-53-00-860-020

- (11) 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 53-53-00-860-016

- (12) 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 53-53-00-860-017

- (13) Close these access panels:

**Number      Name/Location**

318BR      Tailcone Access Door

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

333AZ      Horizontal Stabilizer, Access Panel, Inboard T.E. Closure Rib

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

343AZ      Horizontal Stabilizer, Access Panel - Inbd T.E. Closure Rib

SUBTASK 53-53-00-860-018

- (14) Close these access panels:

(TASK 55-10-11-400-801)

**Number      Name/Location**

333BB      Horizontal Stabilizer, Access Panel, Trailing Edge

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

SUBTASK 53-53-00-710-002

- (15) Adjust the stabilizer-to-body seals (TASK 27-41-11-400-801).

SUBTASK 53-53-00-100-002

- (16) Remove the alignment marks.

SUBTASK 53-53-00-390-001

- (17) Apply sealant, A02315, between the tailcone [1] and fuselage skin (TASK 51-31-00-390-806).



**53-53-00**

Page 413  
Feb 15/2024



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-53-00-860-013

- (18) 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

**CAPT Electrical System Panel, P18-2**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	8	C00544	FLIGHT RECORDER POSITION SENSOR

**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 53-53-00-860-019



**WARNING**

WHEN YOU OPEN THE P91 AND P92 PANELS, MAKE SURE THAT THE OUTER DOOR STAYS AS OPEN AS POSSIBLE. IF THE OUTER DOOR TURNS IN, THE ATTACHED DOOR COMPONENTS COULD TOUCH THE INNER DOOR COMPONENTS. THIS CAN CAUSE AN ARC CONDITION WHEN YOU SUPPLY POWER. IF YOU DO NOT OBEY, DAMAGE TO EQUIPMENT AND INJURY TO PERSONNEL CAN OCCUR.



**WARNING**

DO NOT TOUCH THE CONDUCTORS IN THE P91 AND P92 PANELS. BE CAREFUL WHEN YOU GET ACCESS TO THE CIRCUIT BREAKERS ON THE INNER SIDE OF THE P91 AND P92 PANELS (ROW F). IF IT IS POSSIBLE, REMOVE AIRPLANE ELECTRICAL POWER FIRST. THE P91 AND P92 PANELS HAVE HIGH VOLTAGES AND CURRENTS. ELECTRICAL VOLTAGE AND CURRENT CAN KILL YOU OR CAUSE INJURIES.

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

**Power Distribution Panel Number 1, P91**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	5	C00389	ACCESS COMPT LT

SUBTASK 53-53-00-410-007

- (20) Close this access panel:

**Number      Name/Location**

117A      Electronic Equipment Access Door

SUBTASK 53-53-00-440-003

- (21) Activate the horizontal stabilizer (TASK 27-41-00-800-802).

SUBTASK 53-53-00-710-001

- (22) Do this task: Elevator and Elevator Trim Control System - Operational Test, TASK 27-31-00-710-801.

SUBTASK 53-53-00-720-002

- (23) Do this task: Rudder Trim System Test, TASK 27-21-00-700-819-002.



**53-53-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-53-00-720-001

- (24) If it is necessary, do this task: Elevator Power-Off Flight - Test, TASK 27-31-00-710-803.

———— END OF TASK ————

— EFFECTIVITY —  
LOM ALL

**53-53-00**

Page 415  
Feb 15/2024

D633A101-LOM





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

BROADBAND RADOME - REMOVAL/INSTALLATION

**1. General**

- A. This procedure has these tasks:
  - (1) A removal of the broadband radome
  - (2) An installation of the broadband radome
  - (3) A removal of the adapter plate assembly
  - (4) An installation of the adapter plate assembly.
- B. There is one broadband radome. The radome is installed on the antenna adapter plate, that is located on top of the airplane fuselage. The adapter plate and radome are mounted on the airplane center line, between stations 727D and 727J.

**TASK 53-54-00-000-801**

**2. Broadband Radome Removal**

(Figure 401)

**A. General**

- (1) This task has instructions to remove the broadband radome.  
NOTE: The broadband radome weighs approximately 42 lb (19 kg).

**B. Tools/Equipment**

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

Reference	Description
SPL-15116	Removal/Installation Equipment - Broadband Radome Lift Assy C44001-49 (included in C44001-55 Kit) / C44001-59 (included in C44001-58 Kit) Part #: C44001-58 Supplier: 81205 Opt Part #: C44001-55 Supplier: 81205
STD-13571	Screwdriver - Flat Tip

**C. Location Zones**

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

**D. Prepare for the Removal**

SUBTASK 53-54-00-860-002



MAKE SURE THAT THE RADOME IS OFF AND YOU PULL THE CIRCUIT BREAKERS WHEN PERSONNEL ARE NEAR THE RADOME. STAY IN THE RF SAFETY ZONES WHEN THE RADOME IS ON. IF YOU DO NOT OBEY, THE RADIO FREQUENCY (RF) ENERGY CAN CAUSE INJURIES TO PERSONNEL.

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

**F/O Electrical System Panel, P6-1**

Row	Col	Number	Name
A	9	C01956	ANTENNA/WAP PWR DC

EFFECTIVITY  
LOM 466-999

**53-54-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

(Continued)

**F/O Electrical System Panel, P6-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	8	C01957	BROADBAND ANTENNA

SUBTASK 53-54-00-020-001



BE CAREFUL WHEN YOU MOVE THE COMPONENT. THE COMPONENT IS HEAVY. INJURIES TO PERSONS CAN OCCUR.

- (2) Attach the broadband radome removal/installation equipment, C44001-49 or -59, SPL-15116, to the broadband radome [1].
- NOTE: Use two persons and a hoist to lift the broadband radome from the antenna adapter plate.
- (a) Remove the hoist fasteners from the broadband radome [1].
- NOTE: Re-install these hoist fasteners after installation of the broadband radome.
- (b) Attach the hoist fittings [42] and hoist pins [41] to the broadband radome [1].
- 1) Make sure to remove the hoist fasteners.
- (c) Remove the slack from the broadband radome removal/installation equipment, C44001-49 or -59, SPL-15116.
- 1) Make sure that the broadband radome removal/installation equipment, C44001-49 or -59, SPL-15116, is centered over the broadband radome [1].
- (d) Tighten the hoist pins [41] to 30 in-lb (3 N·m).

**E. Broadband Radome Removal**

SUBTASK 53-54-00-010-001

- (1) Get access to the broadband radome blow-out door [6].
- (a) Put a Flat Tip Screwdriver, STD-13571, in the slot on the blow-out door latch.
- (b) Pull the latch in the aft direction.
- (c) Lift the broadband radome blow-out door [6] in the forward direction.

SUBTASK 53-54-00-020-006

- (2) Remove the screws [11] and washers [12] that attach the bonding jumpers [8] to the support structure.

SUBTASK 53-54-00-020-007

- (3) Remove the 67 bolts [3] and 67 washers [4] that attach the broadband radome [1] to the adapter plate assembly [13].

NOTE: Remove the bolts and washers on the left and right side of the broadband radome.

SUBTASK 53-54-00-020-008

- (4) Remove the bolt [5] from the broadband radome [1].

SUBTASK 53-54-00-020-009

- (5) Carefully lift the broadband radome [1] from the airplane.

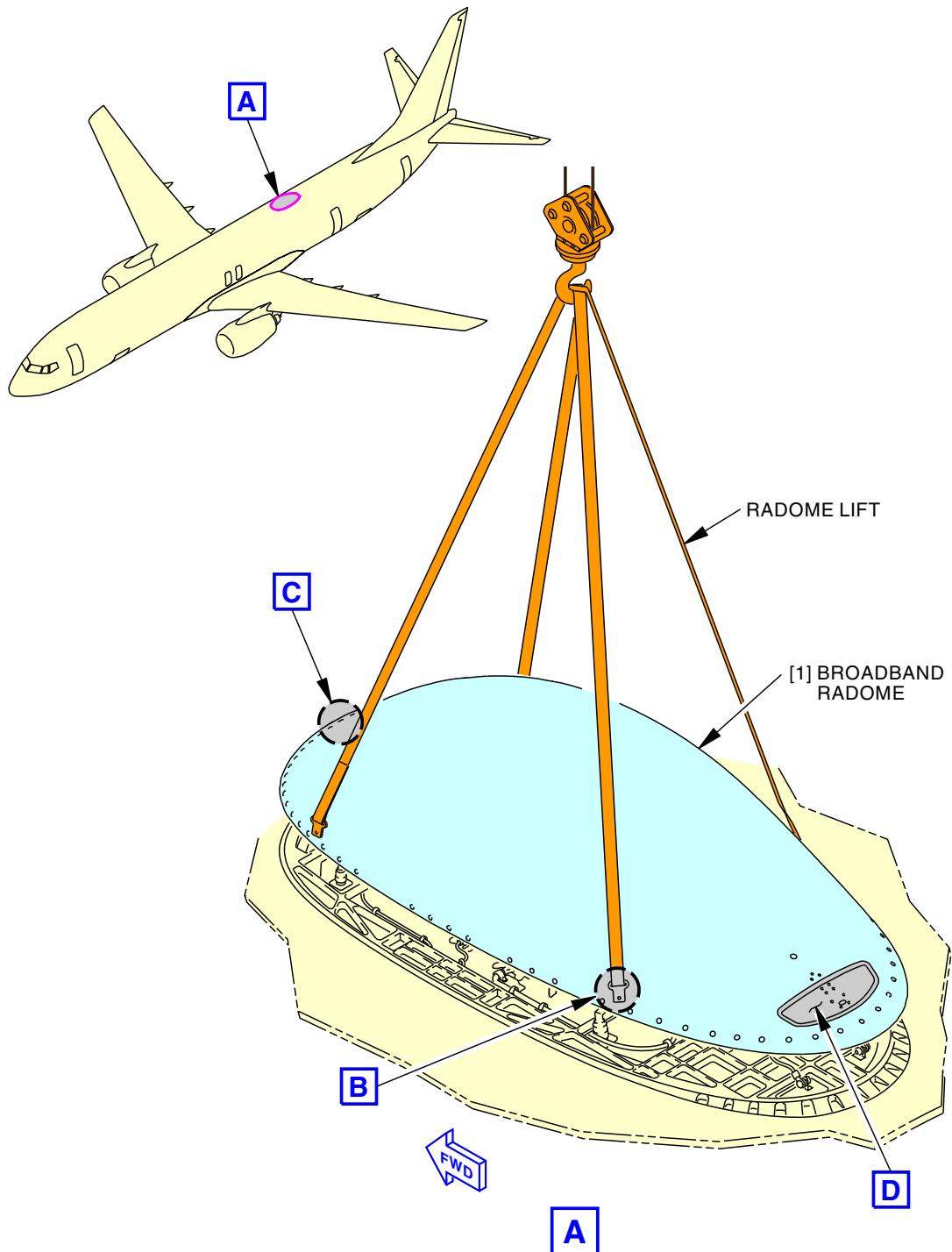
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737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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Broadband Radome Installation  
Figure 401/53-54-00-990-801 (Sheet 1 of 3)

EFFECTIVITY  
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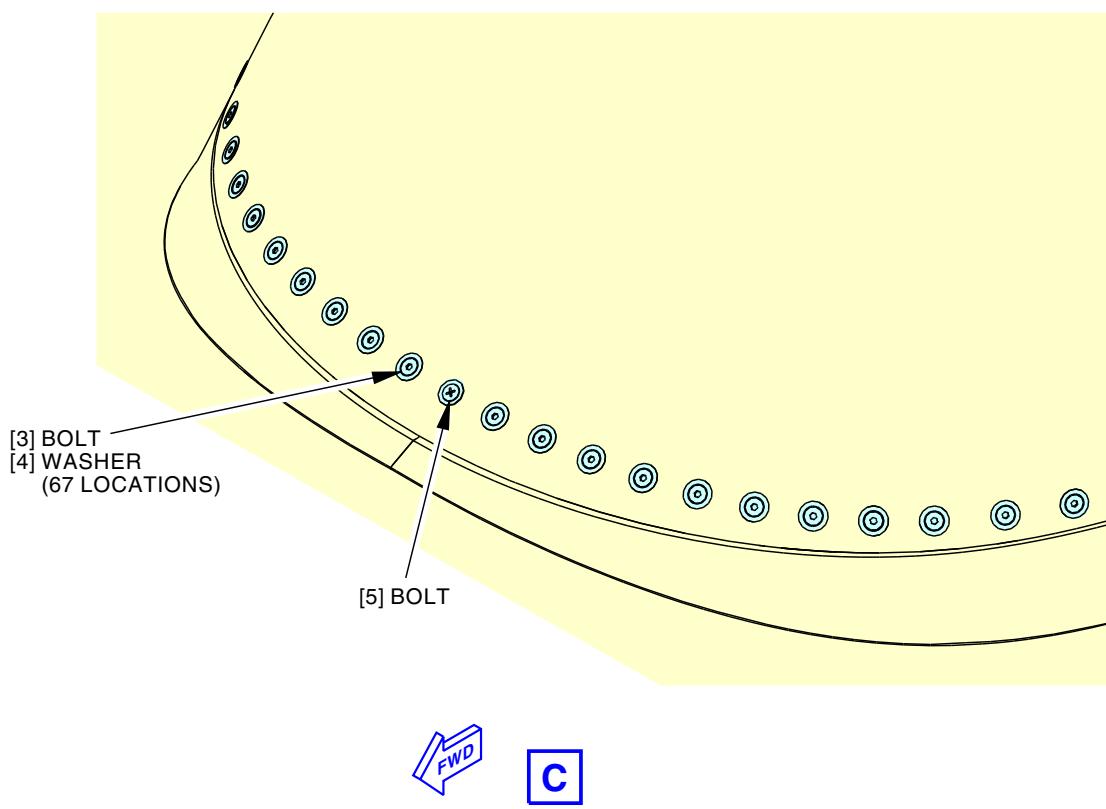
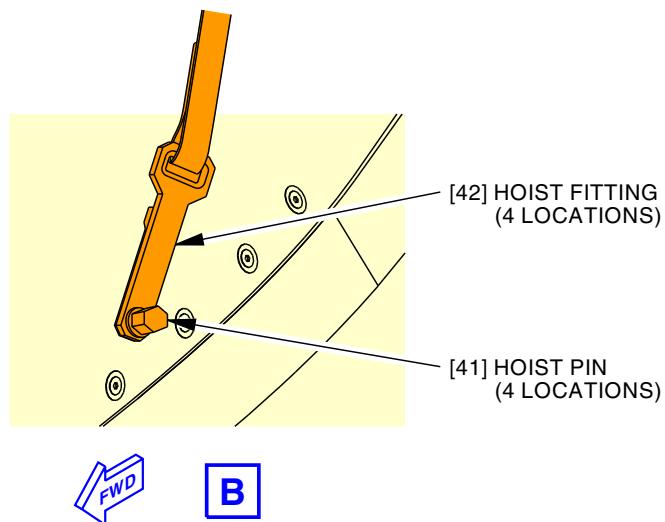
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Page 403  
Jun 15/2018



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

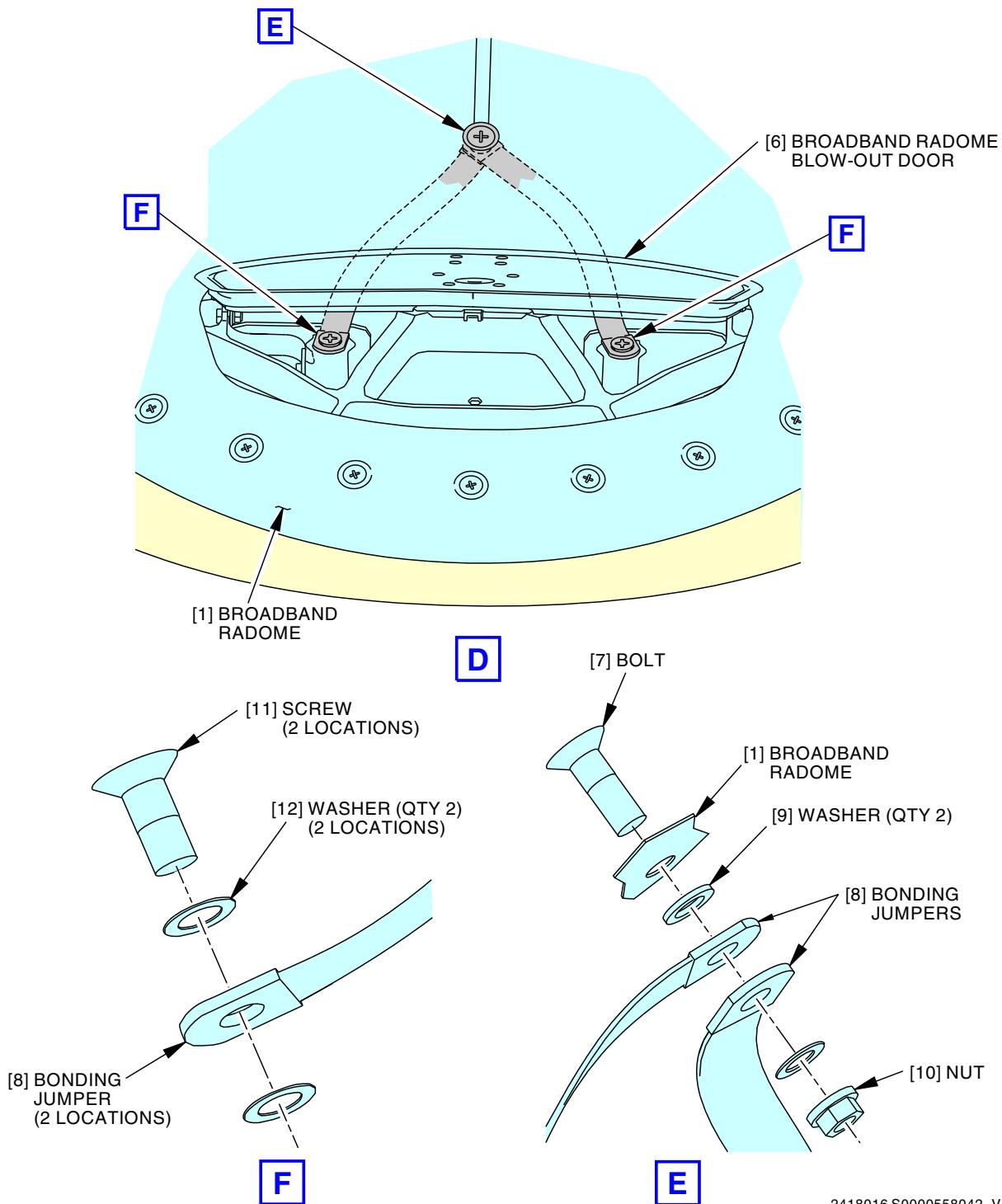


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**Broadband Radome Installation**  
**Figure 401/53-54-00-990-801 (Sheet 2 of 3)**

EFFECTIVITY  
LOM 466-999

**53-54-00**



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**Broadband Radome Installation**  
**Figure 401/53-54-00-990-801 (Sheet 3 of 3)**

EFFECTIVITY  
 LOM 466-999

**53-54-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**TASK 53-54-00-400-801**

**3. Broadband Radome Installation**

(Figure 401)

**A. General**

- (1) This task has instructions to install the broadband radome.

NOTE: The broadband radome weighs approximately 42 lb (19 kg).

**B. References**

<b>Reference</b>	<b>Title</b>
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES
SWPM 20-20-00 Paragraph 21	MAXIMUM PERMITTED RESISTANCE OF ELECTRICAL BONDS
SWPM 20-20-00, Paragraph 2.A.	Cleaning Procedure 1
SWPM 20-20-10 Paragraph 4.F	Category 2 Fay Sealed Direct Ground Stud Installation

**C. Tools/Equipment**

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

<b>Reference</b>	<b>Description</b>
COM-1550	Bonding Meter - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659
SPL-15116	Removal/Installation Equipment - Broadband Radome Lift Assy C44001-49 (included in C44001-55 Kit) / C44001-59 (included in C44001-58 Kit) Part #: C44001-58 Supplier: 81205 Opt Part #: C44001-55 Supplier: 81205
STD-13571	Screwdriver - Flat Tip

**D. Consumable Materials**

<b>Reference</b>	<b>Description</b>	<b>Specification</b>
A01076	Adhesive - Synthetic Rubber	BAC5010 Type 93 (BMS5-95 Class B)
A50110	Sealant - Fuel Tank	BMS5-45 Class B-2
A50155	Sealant - Fuel Tank	BMS5-45 Class C
A50231	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class B
A50296	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class C
B00130	Alcohol - Isopropyl	TT-I-735
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7

EFFECTIVITY  
LOM 466-999

**53-54-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

(Continued)

Reference	Description	Specification
C00064	Coating - Aluminum Chemical Conversion	BAC5719 Type II Class A (MIL-DTL-5541 Class 1A)
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38

#### E. Location Zones

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

#### F. Prepare for the Installation

SUBTASK 53-54-00-860-003



**WARNING**

MAKE SURE THAT THE RADOME IS OFF AND YOU PULL THE CIRCUIT BREAKERS WHEN PERSONNEL ARE NEAR THE RADOME. STAY IN THE RF SAFETY ZONES WHEN THE RADOME IS ON. IF YOU DO NOT OBEY, THE RADIO FREQUENCY (RF) ENERGY CAN CAUSE INJURIES TO PERSONNEL.

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

#### F/O Electrical System Panel, P6-1

Row	Col	Number	Name
A	9	C01956	ANTENNA/WAP PWR DC
B	8	C01957	BROADBAND ANTENNA

SUBTASK 53-54-00-420-001

- (2) Install the adapter plate assembly (TASK 53-54-00-400-802).

SUBTASK 53-54-00-420-002

- (3) Attach the two bonding jumpers [8] to the broadband radome [1]:

(a) Clean the broadband radome [1] and washer [9] with alcohol, B00130.

(b) Install the bolt [7], bonding jumpers [8], washer [9] into the hole above the broadband radome blow-out door [6].

NOTE: The bolt, bonding jumpers, and washer should be installed prior to installation on the aircraft.

(c) Fay seal both sides of the washer [9] and two bonding jumpers [8] with adhesive, A01076.

(d) Put the washer [9] on the bolt [7].

(e) Put the two bonding jumpers [8] on the bolt [7].

(f) Put the remaining washer [9] and the nut [10] on the bolt [7].

(g) Position the unconnected end of the two bonding jumpers [8] 90 degrees to each other.

EFFECTIVITY  
LOM 466-999

**53-54-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (h) Make sure that the two bonding jumpers [8] are aligned on the radome centerline.
- (i) Tighten the bolt [7] to  $200 \pm 20$  in-lb ( $23 \pm 3$  N·m).
- (j) Apply a fillet seal of the bolt [7] and the washer [9] with adhesive, A01076.
- (k) Measure the resistance between the ground strap and the dimpled washer (SWPM 20-20-00 Paragraph 21).
  - 1) Use an intrinsically safe approved bonding meter, COM-1550.
  - 2) Make sure that the resistance is 0.00175 ohm (1.75 milliohms) or less.

SUBTASK 53-54-00-480-001



**WARNING**

BE CAREFUL WHEN YOU MOVE THE COMPONENT. THE COMPONENT IS HEAVY. INJURIES TO PERSONS CAN OCCUR.

- (4) Attach the broadband radome removal/installation equipment, C44001-49 or -59, SPL-15116, to the broadband radome [1].

NOTE: Use two persons and a hoist to lift the radome on to the antenna adapter plate.

  - (a) Remove the hoist fasteners from the broadband radome [1].

NOTE: Re-install these hoist fasteners after installation of the broadband radome.
  - (b) Attach the hoist fittings [42] and hoist pins [41] to the broadband radome [1].
    - 1) Make sure to remove the hoist fasteners.
  - (c) Remove the slack from the broadband radome removal/installation equipment, C44001-49 or -59, SPL-15116.
    - 1) Make sure that the broadband radome removal/installation equipment, C44001-49 or -59, SPL-15116, is centered over the broadband radome [1].
  - (d) Tighten the hoist pins [41] to 30 in-lb (3 N·m).

## G. Broadband Radome Installation

SUBTASK 53-54-00-420-003

- (1) Carefully lift the broadband radome [1] to the top of the airplane.

SUBTASK 53-54-00-420-004

- (2) Align the broadband radome [1] to the adapter plate assembly [13].

SUBTASK 53-54-00-410-001

- (3) Access the broadband radome blow-out door [6].
  - (a) Insert a Flat Tip Screwdriver, STD-13571, into the slot on the blow-out door latch and pull aft.
  - (b) Pull the latch in the aft direction.
  - (c) Lift the broadband radome blow-out door [6] in the forward direction.

SUBTASK 53-54-00-420-005

- (4) Install the screws [11] and washers [12] to connect the bonding jumpers [8] to the support structure, do these steps:
  - (a) Clean the surface of the support structure (SWPM 20-20-00, Paragraph 2.A.).
  - (b) Use cotton wiper, G00034, moist in solvent, B00184, to clean the mating surfaces of the screws [11], washers [12], and bonding jumpers [8].

EFFECTIVITY  
LOM 466-999

**53-54-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (c) Apply sealant, A50110, or sealant, A50155, or sealant, A50231, or sealant, A50296, to the mating surfaces of the screws [11], washers [12], and bonding jumpers [8] (SWPM 20-20-10 Paragraph 4.F).
- (d) Install the screws [11], washers [12], and bonding jumpers [8].
- (e) Tighten the screws [11] to 180 in-lb (20.3 N·m) - 200 in-lb (22.6 N·m).
  - 1) Make sure that there is squeeze out around all the interfaces of each component.
- (f) Measure the electrical resistance between the bonding jumper [8] and airplane structure (SWPM 20-20-00).
  - 1) Use an intrinsically safe approved bonding meter, COM-1550.
  - 2) Make sure that the electrical bonding resistance is 0.001 ohm (1.0 milliohm) or less.
  - 3) Repeat these steps for another bonding jumper [8].
- (g) Manually apply finish with coating, C00064.
  - 1) Apply one coat of primer, C00259.

**SUBTASK 53-54-00-390-001**

- (5) Apply a fillet seal over the screw [11] and washer [12] with adhesive, A01076.

**SUBTASK 53-54-00-760-001**

- (6) Measure the bonding resistance between bolt [7] and the support structure (SWPM 20-20-00 Paragraph 21).
  - (a) Use an intrinsically safe approved bonding meter, COM-1550.
  - (b) Make sure that the resistance is 0.0005 ohm (0.5 milliohms) or less.

**SUBTASK 53-54-00-110-002**

- (7) Clean the 67 washers [4] and the broadband radome [1] with alcohol, B00130.

**SUBTASK 53-54-00-420-006**

- (8) Install the bolt [5] that attach the broadband radome [1] to the adapter plate assembly [13].

**SUBTASK 53-54-00-760-002**

- (9) Measure the bonding resistance between the bolt [5] and airplane structure (SWPM 20-20-00 Paragraph 21).
  - (a) Use an intrinsically safe approved bonding meter, COM-1550.
  - (b) Make sure that the resistance is 0.0007 ohm (0.7 milliohms) or less.

**SUBTASK 53-54-00-390-003**

- (10) Apply corrosion inhibiting material, G50136, to the holes in the broadband radome [1].

**SUBTASK 53-54-00-420-007**

- (11) Immediately install the 67 bolts [3] and 67 washers [4] that attach the broadband radome [1] to the adapter plate assembly [13].
  - (a) Tighten the 67 bolts [3] to  $150 \pm 20$  in-lb ( $17 \pm 2$  N·m).

**NOTE:** Start installation of the bolts and washers on the left and right side of the broadband radome.

EFFECTIVITY  
LOM 466-999

**53-54-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

H. Put the Airplane Back to Its Usual Condition

SUBTASK 53-54-00-080-001



**WARNING**

MAKE SURE THAT THE RADOME IS OFF AND YOU PULL THE CIRCUIT BREAKERS WHEN PERSONNEL ARE NEAR THE RADOME. STAY IN THE RF SAFETY ZONES WHEN THE RADOME IS ON. IF YOU DO NOT OBEY, THE RADIO FREQUENCY (RF) ENERGY CAN CAUSE INJURIES TO PERSONNEL.

- (1) Disconnect the broadband radome removal/installation equipment, C44001-49 or -59, SPL-15116, from the broadband radome [1].
  - (a) Remove the hoist pins [41] and hoist fittings [42] from the broadband radome [1].

SUBTASK 53-54-00-420-008

- (2) Install the hoist fasteners on the broadband radome [1].
  - (a) Tighten each hoist fastener to 29 in-lb (3 N·m) - 31 in-lb (4 N·m).

SUBTASK 53-54-00-440-001

- (3) Activate the satellite communication power.

SUBTASK 53-54-00-860-005

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

**F/O Electrical System Panel, P6-1**

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	9	C01956	ANTENNA/WAP PWR DC
B	8	C01957	BROADBAND ANTENNA

— END OF TASK —

**TASK 53-54-00-000-802**

**4. Adapter Plate Assembly Removal**

Figure 402

**A. General**

- (1) This task has instructions to remove the adapter plate assembly with a seal adapter plate installed.

**B. 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.

<b>Reference</b>	<b>Description</b>
SPL-15115	Removal/Installation Equipment - Adapter Plate Lift Assy, C44001-50 (included in C44001-55 Kit) / C44001-60 (included in C44001-58 Kit) Part #: C44001-58 Supplier: 81205 Opt Part #: C44001-55 Supplier: 81205

**C. Prepare for the Removal**

SUBTASK 53-54-00-020-010

- (1) Remove the broadband radome (Broadband Radome Removal, TASK 53-54-00-000-801).

EFFECTIVITY  
LOM 466-999

**53-54-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-54-00-480-002

- (2) Attach the adapter plate lift assy, C44001-50 or -60, SPL-15115 to the adapter plate assembly [13].

NOTE: Use two persons and a hoist to lift the adapter plate assembly from the airplane.

- (a) Install the four hoist fittings [42] and four hoist pins [41] to the adapter plate assembly [13].
- (b) Remove the slack from the adapter plate lift assy, C44001-50 or -60, SPL-15115.
- 1) Make sure that the adapter plate lift assy, C44001-50 or -60, SPL-15115 is centered over the adapter plate assembly [13].
- (c) Tighten the four hoist pins [41] to 40 in-lb (5 N·m).

**D. Adapter Plate Assembly Removal**

SUBTASK 53-54-00-020-011

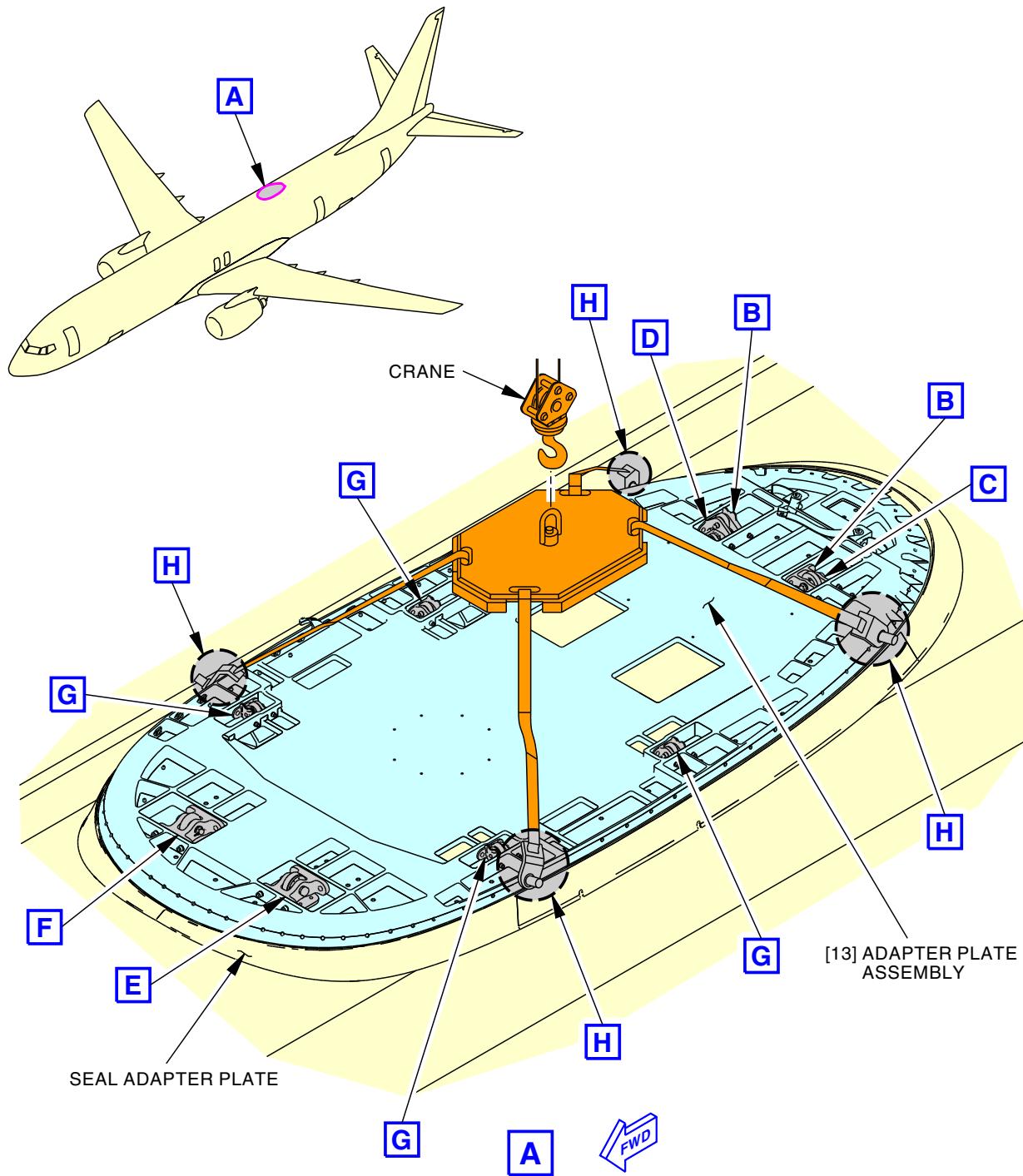
- (1) Remove the adapter plate assembly [13]:

- (a) Remove the bolt [36], three washers [37], nut [39], and cotter pin [40] from the four lug assemblies [38].
- (b) Remove the bolt [31], three washers [32], nut [34], and cotter pin [35] from the lug assembly [33].
- (c) Remove the bolt [27], two washers [28], and nut [30] from the lug assembly [29].
- (d) Remove the bolt [22], three washers [23], nut [25], and cotter pin [26] from the lug assembly [24].
- (e) Remove the bolt [17], three washers [18], nut [20], and cotter pin [21] from the lug assembly [19].
- (f) Remove the four screws [14], four washers [15], and two bonding jumpers [16] that attach to the adapter plate assembly [13] and airplane support structure.
- (g) Remove the adapter plate assembly [13] from lug assembly [19], lug assembly [24], lug assembly [29], lug assembly [33], and four lug assemblies [38] that are attached to the airplane.
- (h) Carefully lift the adapter plate assembly [13] from the airplane.

———— END OF TASK ————

EFFECTIVITY  
LOM 466-999

**53-54-00**

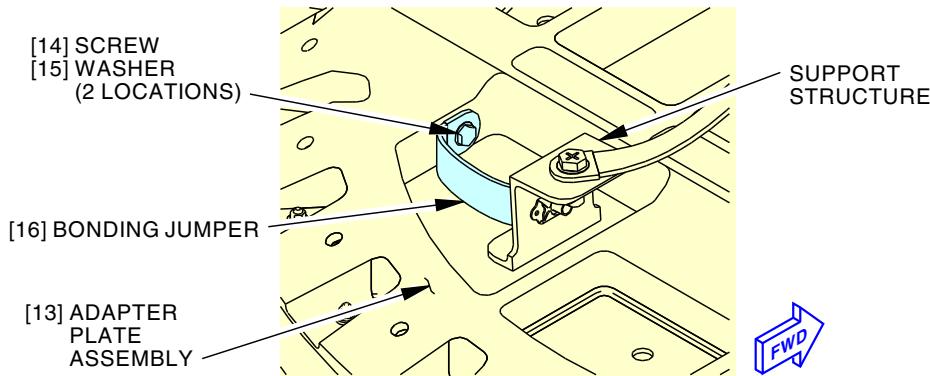
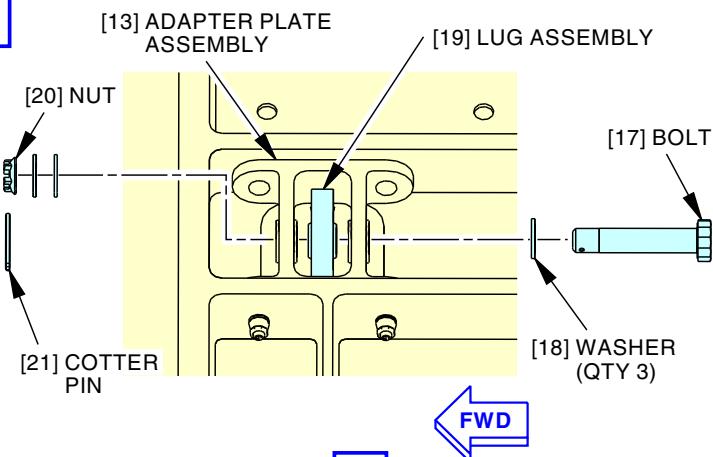
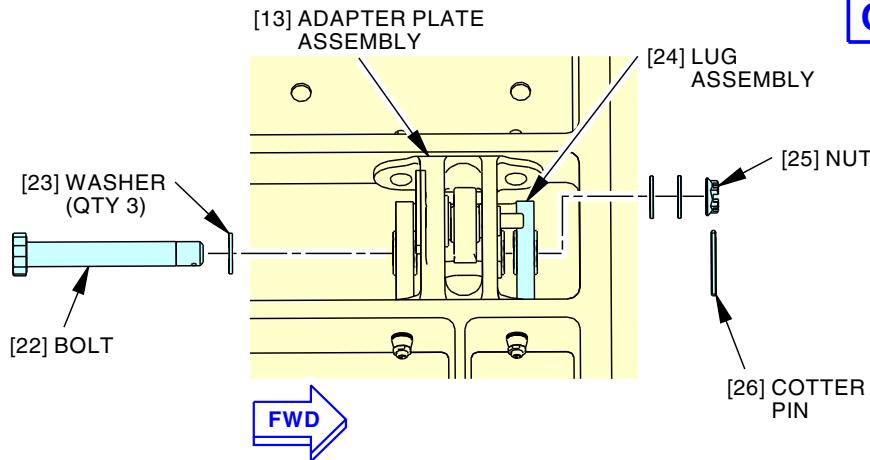


2788242 S0000633339\_V1

**Adapter Plate Assembly Installation**  
Figure 402/53-54-00-990-803 (Sheet 1 of 4)

EFFECTIVITY  
LOM 466-999

**53-54-00**

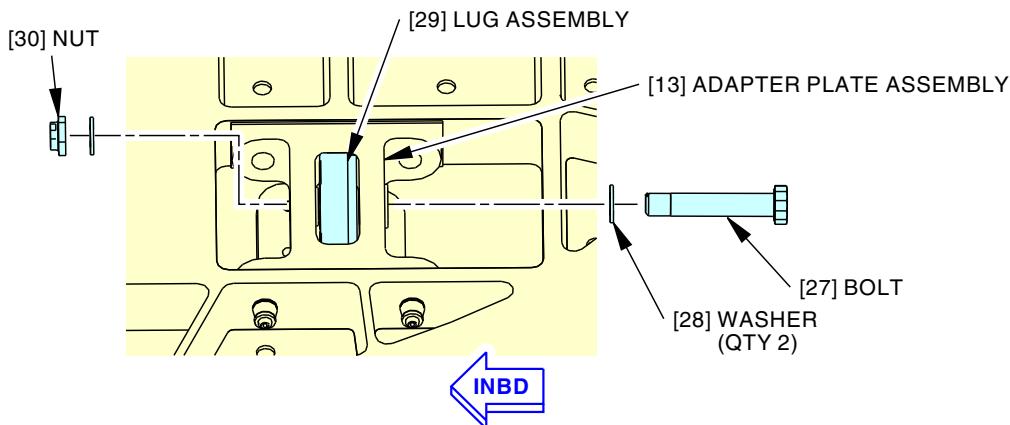
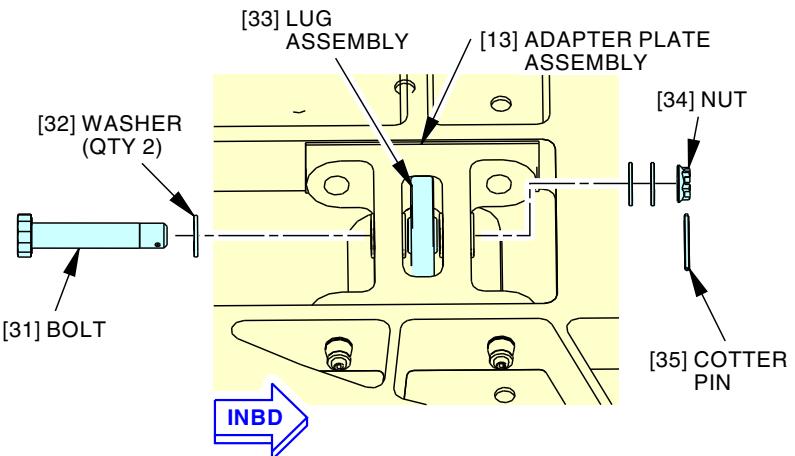
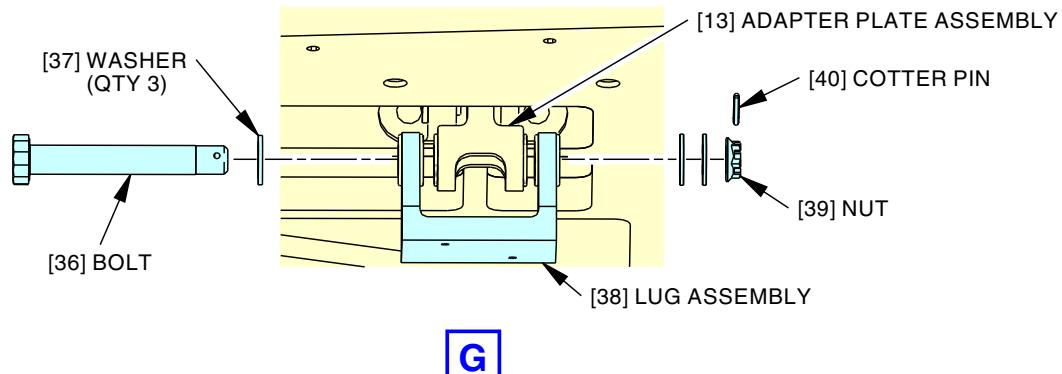

**B**

**C**

**D**

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**Adapter Plate Assembly Installation  
Figure 402/53-54-00-990-803 (Sheet 2 of 4)**

 EFFECTIVITY  
LOM 466-999

**53-54-00**

**E****F****G**

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### Adapter Plate Assembly Installation

Figure 402/53-54-00-990-803 (Sheet 3 of 4)

EFFECTIVITY  
LOM 466-999

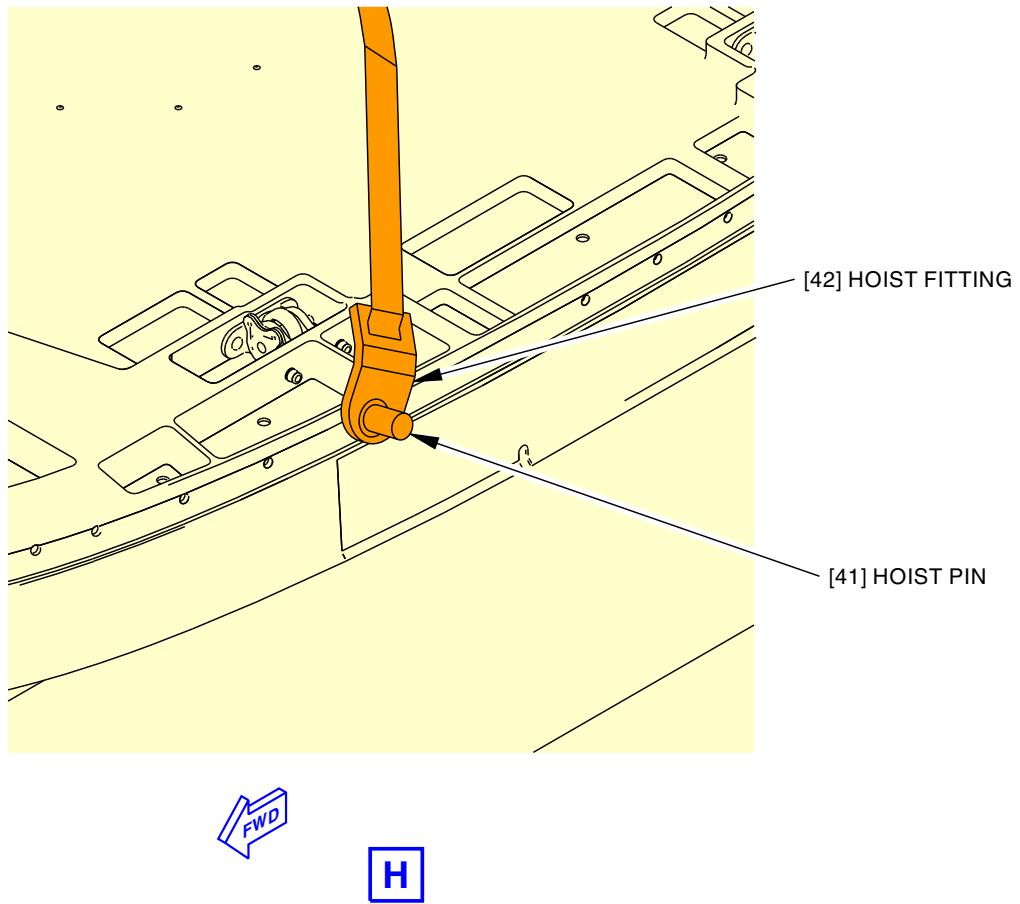
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ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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**Adapter Plate Assembly Installation**  
**Figure 402/53-54-00-990-803 (Sheet 4 of 4)**

EFFECTIVITY  
LOM 466-999

**53-54-00**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 415  
Oct 15/2023



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

**TASK 53-54-00-400-802**

**5. Adapter Plate Assembly Installation**

Figure 402

**A. General**

- (1) This task has instructions to install the adapter plate assembly with a seal adapter plate installed.

**B. Tools/Equipment**

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

Reference	Description
SPL-15115	Removal/Installation Equipment - Adapter Plate Lift Assy, C44001-50 (included in C44001-55 Kit) / C44001-60 (included in C44001-58 Kit) Part #: C44001-58 Supplier: 81205 Opt Part #: C44001-55 Supplier: 81205

**C. Prepare for the Installation**

**SUBTASK 53-54-00-480-003**

- (1) Attach the adapter plate lift assy, C44001-50 or -60, SPL-15115 to the adapter plate assembly [13].

NOTE: Use two persons to hoist and lift the adapter plate assembly on the airplane.

- (a) Attach four hoist fittings [42] and four hoist pins [41] to the adapter plate assembly [13].
- (b) Remove the slack from the adapter plate lift assy, C44001-50 or -60, SPL-15115.
  - 1) Make sure that the adapter plate lift assy, C44001-50 or -60, SPL-15115 is centered over the adapter plate assembly [13].
- (c) Tighten the four hoist pins [41] to 40 in-lb (5 N·m).

**D. Adapter Plate Assembly Installation**

**SUBTASK 53-54-00-420-009**

- (1) Carefully lift the adapter plate assembly [13] to the top of the airplane.
  - (a) Make sure that the adapter plate assembly [13] aligns with the lug assembly [19], lug assembly [24], lug assembly [29], lug assembly [33], and the four lug assemblies [38].
  - (b) Install the four screws [14], four washers [15], and two bonding jumpers [16] that attach to the adapter plate assembly [13] and the airplane support structure.
  - (c) Install the bolt [17], three washers [18], and nut [20] through the lug assembly [19].
    - 1) Make sure to back off the nearest castellation for nut [20].
    - 2) Install a new cotter pin [21].
  - (d) Install the bolt [22], three washers [23], and nut [25] through the lug assembly [24].
    - 1) Make sure to back off the nearest castellation for nut [25].
    - 2) Install a cotter pin [26].
  - (e) Install the bolt [27], two washers [28], and nut [30] through the lug assembly [29].
    - 1) Make sure to back off the nearest castellation for nut [30].
  - (f) Install the bolt [31], three washers [32], and nut [34] through the lug assembly [33].
    - 1) Make sure to back off the nearest castellation for nut [34].

EFFECTIVITY  
LOM 466-999

**53-54-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 2) Install a new cotter pin [35].
- (g) Install the bolt [36], three washers [37], and nut [39] through the lug assembly [38].
  - 1) Make sure to back off the nearest castellation for the nut [39].
  - 2) Install a new cotter pin [40].

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

SUBTASK 53-54-00-080-002

- (1) Disconnect the adapter plate lift assy, C44001-50 or -60, SPL-15115 from the adapter plate assembly [13].
  - (a) Remove the four hoist pins [41] and four hoist fittings [42] from the adapter plate assembly [13].

SUBTASK 53-54-00-420-010

- (2) Install the broadband radome (TASK 53-54-00-400-801).

———— END OF TASK ————

— EFFECTIVITY —  
LOM 466-999

**53-54-00**





737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

BROADBAND RADOME - INSPECTION/CHECK

**1. General**

- A. This procedure has this task:
- (1) Inspection of the broadband radome.

**TASK 53-54-00-211-801**

**2. Broadband Radome Inspection**

**A. References**

Reference	Title
53-54-00-000-801	Broadband Radome Removal (P/B 401)
53-54-00-300-801	Broadband Radome Blow-out Door Hinge Repair (P/B 801)
53-54-00-300-802	Broadband Radome Blow-out Door Latch Repair (P/B 801)
53-54-00-300-803	Broadband Radome Blow-out Door Opening Edge Protector Repair (P/B 801)
53-54-00-300-804	Broadband Radome Blow-out Door Seal Repair (P/B 801)
53-54-00-300-805	Broadband Radome Exterior Coating Repair (P/B 801)
53-54-00-400-801	Broadband Radome Installation (P/B 401)

**B. Procedure**

SUBTASK 53-54-00-211-001

- (1) Exterior Coating Damage:
  - (a) Visually inspect the radome and radome blow-out door assembly exterior for scuffs, cuts, scratches or discolored areas that do not penetrate the coating.
  - (b) Visually inspect the radome and radome blow-out door assembly exterior for scuffs, cuts, scratches or discolored areas that penetrate the coating, but do not expose underlying coating primer or laminate.
  - (c) Visually inspect the radome and door assembly exterior for scuffs, cuts or scratches that penetrate the coating, and expose underlying coating primer and/or laminate.
  - (d) Visually inspect the antistatic topcoat for loss of adhesion to the elastomeric base coat. The indications are loose, bubbled or lost coating.
  - (e) Perform the inspection as required.
  - (f) If the damage does not penetrate the coating, no repair is required.
  - (g) If the coating is penetrated but the primer or laminate is not exposed, no repair is required.
  - (h) If the coating is penetrated and the primer or laminate is exposed, evaluate the damage against the criteria that follows:
    - 1) In the forward-exposed region of the radome, immediately repair individual damaged areas of coating primer or laminate larger than 0.25 square inches.
    - 2) In the forward-exposed region of the radome, no more than five areas of non-repaired damage smaller than 0.25 square inch are allowed. Make sure at least 1 inch of undamaged coating separates the damaged areas from each other.
    - 3) In the non-forward exposed region of the radome, if a damaged area is smaller than 1 square inch, no repair is required.

EFFECTIVITY  
LOM 466-999

**53-54-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 4) In the non-forward exposed region of the radome, no more than five areas of non-repaired damage smaller than 1 square inch are allowed. Make sure at least 1 inch of undamaged coating separates the damaged areas from each other.
  - (i) If the antistatic topcoat exhibits loss of adhesion to the elastomeric base coat, evaluate the damage against the criteria that follows:
    - 1) In the forward-exposed region of the radome, no damage area greater than 4 square inches is allowed.
  - (j) If coating repair is required, do this task: (Broadband Radome Exterior Coating Repair, TASK 53-54-00-300-805).

SUBTASK 53-54-00-211-002

- (2) Radome Shell and Radome Blow-out Door Laminate Damage:
  - (a) Inspect the radome shell and radome blow-out door for lamination damage.
  - (b) Perform the inspection as required.
  - (c) In the forward-exposed region of the radome (Figure 601), no damage of any size is allowed. If lamination damage exists, replace the radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).
  - (d) In the aft attachment region (Figure 601), evaluate the damage against the criteria that follows:
    - 1) Dents that do not cause damage to the quartz fibers are permitted if they are:
      - a) A maximum of 0.50 inches in diameter or across the longest dimension.
      - b) A maximum of 0.008 inches in depth.
      - c) Located above the row of attachment fasteners (as defined by a line connecting fastener centerlines).
      - d) Located a minimum of 1 inch away from any fastener center.
      - e) Located at least 2 times the dent diameter away from any other damage location.
  - (e) In all other areas of the radome (Figure 601), evaluate the damage against the criteria that follows:
    - 1) Dents that do not cause damage to the quartz fibers are permitted if they are:
      - a) A maximum of 0.50 inches in diameter or across the longest dimension.
      - b) A maximum of 0.008 inches in depth.
      - c) Located a minimum of 1 inch away from the blow-out door.
      - d) Located at least 2 times the dent diameter away from any other damage location.
  - (f) If the damage exceeds the criteria above, replace the broadband radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).

SUBTASK 53-54-00-211-003

- (3) Lightning Diverter Strip Damage:
  - (a) Visually inspect the lightning diverter strip for missing lightning diverter strip segments or "buttons".
  - (b) Visually inspect the lightning diverter strip for an unbonded or damaged lightning diverter strip.

EFFECTIVITY  
LOM 466-999

**53-54-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (c) Perform the inspection as required.
- (d) If either condition exists, replace the broadband radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).

**SUBTASK 53-54-00-211-004**

**(4) Hoist Point Hardware Damage:**

- (a) Visually inspect for damage (damaged threads or bent nutplate base) of hoist point hardware (nutplate), that prevents normal removal and installation of hoist point screw.
- (b) Perform the inspection as required.
- (c) If damage exists, replace the broadband radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).

**SUBTASK 53-54-00-211-005**

**(5) Blow-out Door Edge Protector Damage:**

- (a) Visually inspect for damage, including bending and/or disbonding of edge protector, that prevents normal opening and closing of door.
- (b) Perform the inspection as required.
- (c) If the blow-out door edge protector damage does not prevent blow-out door normal operation, repair the blow-out door edge protector. Do this task: (Broadband Radome Blow-out Door Opening Edge Protector Repair, TASK 53-54-00-300-803).
- (d) If blow-out door edge protector damage exists that prevents blow-out door normal operation. replace the radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).

**SUBTASK 53-54-00-211-006**

**(6) Leading Edge Protector Damage:**

- (a) Visually inspect for damage, including bending and/or disbonding of edge protector, that interferes with installation of radome on aircraft.
- (b) Perform the inspection as required.
- (c) If damage exists, replace the radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).

**SUBTASK 53-54-00-211-007**

**(7) Blow-out Door Hinge Damage:**

- (a) Visually inspect for damage, including bending of hinge arm or brackets, that interferes with normal opening and closing of blow-out door.
- (b) Perform the inspection as required.
- (c) If the blow-out door hinge damage does not prevent blow-out door normal operation, repair the blow-out door hinge. Do this task: (Broadband Radome Blow-out Door Hinge Repair, TASK 53-54-00-300-801).
- (d) If blow-out door hinge damage exists that prevents blow-out door normal operation, replace the radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).

EFFECTIVITY  
LOM 466-999

**53-54-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

SUBTASK 53-54-00-211-008

(8) Blow-out Door Latch Damage:

- (a) Visually inspect for damage, including jamming of latch mechanism, that interferes with normal opening and closing of latch of blow-out door.
- (b) Perform the inspection as required.
- (c) If the blow-out door latch damage does not prevent blow-out door normal operation, repair the blow-out door latch. This is the task: (Broadband Radome Blow-out Door Latch Repair, TASK 53-54-00-300-802).
- (d) If blow-out door latch damage exists that prevents blow-out door normal operation, replace the radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).

SUBTASK 53-54-00-211-009

(9) Blow-out Door Seal Damage:

- (a) Visually examine the blow-out door for damage (disbonding, seal tearing) that prevents normal operation of the blow-out door.
- (b) Visually inspect for a torn or missing seal, or section of seal.
- (c) Perform the inspection as required.
- (d) If the blow-out door seal damage does not prevent blow-out door normal operation, repair the blow-out door seal. Do this task: (Broadband Radome Blow-out Door Seal Repair, TASK 53-54-00-300-804).
- (e) If blow-out door seal damage exists that prevents blow-out door normal operation, replace the radome. Do these tasks: (Broadband Radome Removal, TASK 53-54-00-000-801) and (Broadband Radome Installation, TASK 53-54-00-400-801).

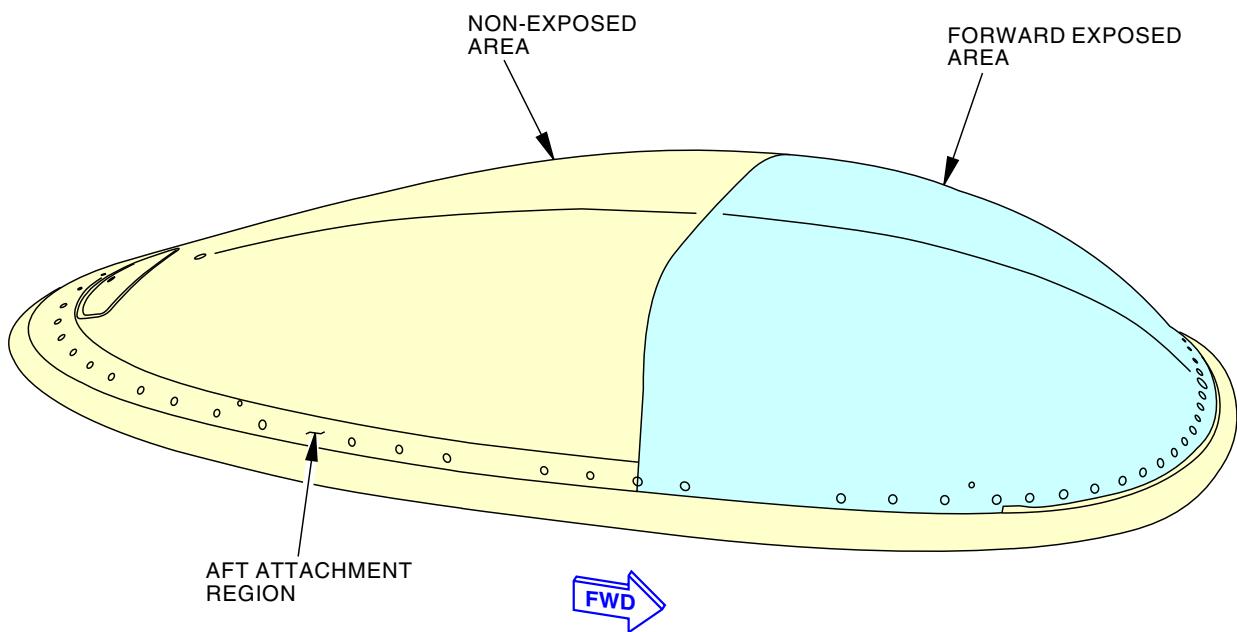
———— END OF TASK ————

EFFECTIVITY  
LOM 466-999

**53-54-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL



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**Radome Area Definition**  
**Figure 601/53-54-00-990-802**

EFFECTIVITY  
LOM 466-999

**53-54-00**

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Page 605  
Jun 15/2018





**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

**BROADBAND RADOME - REPAIRS**

**1. General**

- A. This procedure contains these tasks:
- (1) A repair of the Blow-out Door Hinge
  - (2) A repair of the Blow-out Door Latch
  - (3) A repair of the Blow-out Door Opening Edge Protector
  - (4) A repair of the Blow-out Door Seal
  - (5) A repair of the Hoist Point Nutplate
  - (6) A repair of the Leading Edge Protector
  - (7) A repair of the Lighting Diverter Strip
  - (8) A repair of the Radome Exterior Coating.

**TASK 53-54-00-300-801**

**2. Broadband Radome Blow-out Door Hinge Repair**

**A. General**

- (1) The blow-out door hinge repair consists of replacing the damaged hinge with a new hinge.

**B. Blow-out Door Hinge Repair**

**SUBTASK 53-54-00-300-001**

- (1) To replace a damaged blow-out door hinge, do these steps:
  - (a) Remove all of the fasteners that attach the hinge to the radome and blow-out door:
    - 1) Hold the fasteners using a 5/64" hex wrench.
    - 2) Turn the collar (nut) with grip-type pliers.
  - (b) Remove the damaged hinge.
  - (c) Attach the new hinge to the radome:
    - 1) Use a 5/64" hex wrench to hold the hinge bolts.
    - 2) Turn the collar / nut with a common 5/16" wrench.
  - (d) Attach the hinge to the blow-out door:
    - 1) Use a 5/64" hex wrench to hold the hinge bolts.
    - 2) Turn the collar / nut with a common 5/16" wrench.
- (2) Touch-up the coating on the radome exterior, if required. To touch up the coating, do this task: (Broadband Radome Exterior Coating Repair, TASK 53-54-00-300-805).

———— END OF TASK ————

**TASK 53-54-00-300-802**

**3. Broadband Radome Blow-out Door Latch Repair**

**A. General**

- (1) The blow-out door latch repair consists of replacing the damaged latch with a new latch.

**B. Blow-out Door Latch Repair**

**SUBTASK 53-54-00-300-002**

- (1) To replace a damaged blow-out door latch, do these steps:

———— EFFECTIVITY ————

**LOM 466-999**

**53-54-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (a) Remove all of the fasteners that attach the latch to the radome and blow-out door:
    - 1) Hold the fasteners using a 5/64" hex wrench.
    - 2) Turn the collar (nut) with grip-type pliers.
  - (b) Remove the damaged latch.
  - (c) Put the new latch in position on the blow-out door.
  - (d) Attach the new latch to the blow-out door:
    - 1) Use a 5/64" hex wrench to hold the hinge bolts.
    - 2) Turn the collar (nut) with a common 5/16" wrench.
- (2) Touch-up the coating on the radome exterior, if required. To touch up the coating, do this task:  
(Broadband Radome Exterior Coating Repair, TASK 53-54-00-300-805).

———— END OF TASK ———

**TASK 53-54-00-300-803**

**4. Broadband Radome Blow-out Door Opening Edge Protector Repair**

**A. General**

- (1) The blow-out door opening edge protector repair consists of replacing the damaged edge protector with a new edge protector.
- (2) This repair procedure cannot be done while the radome is installed on the airplane.

**B. References**

<b>Reference</b>	<b>Title</b>
53-54-00-000-801	Broadband Radome Removal (P/B 401)

**C. Tools/Equipment**

<b>Reference</b>	<b>Description</b>
STD-549	Knife - Putty, Broad Blade

**D. Consumable Materials**

<b>Reference</b>	<b>Description</b>	<b>Specification</b>
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A01076	Adhesive - Synthetic Rubber	BAC5010 Type 93 (BMS5-95 Class B)
B00062	Solvent - Acetone (99.5% Grade)	ASTM D 329 (Supersedes O-A-51)
B00130	Alcohol - Isopropyl	TT-I-735
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)
G50260	Sandpaper - Aluminum Oxide, 220 Grit	

**E. Blow-out Door Opening Edge Protector Repair**

**SUBTASK 53-54-00-020-002**

- (1) If the damaged radome is still on the airplane, remove it. To remove the radome, do this task:  
(Broadband Radome Removal, TASK 53-54-00-000-801).

———— EFFECTIVITY ———  
**LOM 466-999**

**53-54-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-54-00-300-003

- (2) To repair the blow-out door opening edge protector, do these steps:
- (a) Open the blow-out door.
  - (b) Mask the coated radome surface surrounding blow-out door edge protector.
  - (c) Use a broad blade putty knife, STD-549 to carefully disbond and remove door opening edge protector.
  - (d) Use sandpaper, G50260 to scuff sand the door opening edge protector bond region.
  - (e) Use a cotton wiper, G00034 moistened with alcohol, B00130 to remove loose particles left by the sanding.
  - (f) Wipe the new edge protector with another cotton wiper, G00034 moistened with alcohol, B00130.
  - (g) Apply adhesive, A01076 or sealant, A00247 to the bond surface of the door opening edge protector.
  - (h) Apply adhesive, A01076 or sealant, A00247 to the door opening edge protector bond surface of the radome.
  - (i) Put the door opening edge protector in the radome door opening and press into position.
  - (j) Use a cotton wiper, G00034 that is moist with solvent, B00062 to remove excess adhesive.
- NOTE: Use only the amount of solvent required to remove excess adhesive.
- (k) Close the radome blow-out door assembly and latch the door in the closed position. This allows the door and door seal to press against door opening edge protector to hold the edge protector in position while the adhesive cures.
  - (l) Let the adhesive cure for 24 hours at 80 ±10°F (27 ±6°C).

— END OF TASK —

**TASK 53-54-00-300-804**

**5. Broadband Radome Blow-out Door Seal Repair**

**A. General**

- (1) The blow-out door seal repair consists of replacing the damaged seal with a new seal.

**B. Tools/Equipment**

Reference	Description
STD-549	Knife - Putty, Broad Blade
STD-761	Scissors

**C. Consumable Materials**

Reference	Description	Specification
A00562	Adhesive - High Strength Silicone Rubber, One-Part - RTV157	
G50260	Sandpaper - Aluminum Oxide, 220 Grit	

**D. Blow-out Door Seal Repair**

SUBTASK 53-54-00-300-004

- (1) To replace a damaged blow-out door seal, do these steps:
- (a) Open the blow-out door.
  - (b) Use a broad blade putty knife, STD-549 to remove the damaged blow-out door seal.

EFFECTIVITY  
LOM 466-999

**53-54-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (c) Use sandpaper, G50260 to scuff sand the outer door flange surface to remove remaining seal adhesive.
- (d) Use sandpaper, G50260 to scuff sand the inner door flange surface to remove remaining seal adhesive.
- (e) Use sandpaper, G50260 to scuff sand the edge of door flange surface to remove remaining seal adhesive.
- (f) Use scissors, STD-761 to cut the seal at the seal centerline on the latch side of the seal.
- (g) Use scissors, STD-761 to cut the seal on the hinge side of the seal, 2" to 3" to either the left or right side of the centerline.
- (h) "Dry fit" the seal to the blow-out door. Trim excess seal length to permit butt joint of seal ends with no gap permitted.
- (i) Apply RTV157 adhesive, A00562 to the bond surface of the door seal halves
- (j) Apply RTV157 adhesive, A00562 to the outer and inner surfaces of the blow-out door flange.
- (k) Install one half (either half) of the door seal onto the blow-out door flange.  
NOTE: The door seal is molded to fit over the flange of the blow-out door flange.
- (l) Install the other half of door seal onto the blow-out door flange.
- (m) Carefully close and latch the door in the closed position to permit seal to be tightly held into position while the door seal adhesive cures.
- (n) Apply RTV157 adhesive, A00562 along the door-to-seal joint line, especially in areas where unfilled gaps between door and seal bulb are visually apparent.

— END OF TASK —

**TASK 53-54-00-300-805**

**6. Broadband Radome Exterior Coating Repair**

**A. General**

- (1) The exterior coating repair consists of the application of coating materials on the damaged area of the radome.

**B. References**

<b>Reference</b>	<b>Title</b>
53-54-00-000-801	Broadband Radome Removal (P/B 401)

**C. Tools/Equipment**

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

<b>Reference</b>	<b>Description</b>
COM-6457	Meter - Insulation (Range: 1-1,000 VDC or equivalent, select meter per test requirements) Part #: 1864-9700 Supplier: 62015 Part #: 1865PLUS Supplier: 62015 Part #: 1865PLUSCE Supplier: 62015 Part #: 2471F Supplier: 21844 Opt Part #: 1865-00-CE Supplier: 62015

— EFFECTIVITY —  
**LOM 466-999**

**53-54-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

D. Consumable Materials

Reference	Description	Specification
B00130	Alcohol - Isopropyl	TT-I-735
C00766	Primer - Nonchromated Primer For Composites	BMS10-103 Type I
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CLA)

E. Radome Exterior Coating Repair

SUBTASK 53-54-00-300-005

- (1) Use 240 grit (or finer) sandpaper to feather the coating around the damaged area for a distance of 1 to 2 inches.
- (2) Use a cotton wiper, G00034 moistened with alcohol, B00130 to remove particles left by the sanding.
- (3) If bare laminate is exposed as a result of the sanding, do these steps:
  - (a) If the radome is still installed on the airplane, remove it. Do this task: (Broadband Radome Removal, TASK 53-54-00-000-801).
  - (b) Mix and apply primer, C00766 to the damaged area.
    - 1) Apply the primer to a thickness of 0.0003" to 0.0008" per Boeing BAC5325.
  - (c) Mix and apply Caapcoat FP-100CM coating system. To apply the coating system, do these steps:

NOTE: If provided in the coating kit, discard the components of the Aeroglaze 9947 wash primer kit. DO NOT apply these components to the radome.

- 1) Add the contents of the polyurethane accelerator container to the polyurethane basecoat/curing agent mixture container and mix well.
- 2) Add the volume of polyurethane thinner to the polyurethane basecoat/curing agent/accelerator mixture necessary to obtain a viscosity of 22 to 28 seconds on a Number 2 Zahn viscosity measuring cup and mix thoroughly.
- 3) Allow the thinned mixture to set at room temperature for 30 minutes or more after mixing.

NOTE: The thinned mixture has a 4 to 6 hour pot life.

- 4) Spray or brush the thinned mixture on the primed area of the radome.
    - a) Apply as many coats as required to achieve a thickness of 0.0085" to 0.010".
    - b) Allow the coating to dry for 5 to 20 minutes between coats.
  - 5) Allow polyurethane basecoat to air dry at room temperature for 15 to 30 minutes before beginning to apply tiecoat.
- (d) Mix and apply the tiecoat. To apply the tiecoat, do these steps:
- 1) Add the contents of the curing agent container to the FE-AS fluoroelastomer tiecoat container and mix well.
- NOTE: The tiecoat mixture has a 6 hour pot life.
- 2) Apply the tiecoat mixture onto the polyurethane coating to a depth of 0.0005" to 0.002" (1-2 coats).

EFFECTIVITY  
LOM 466-999

**53-54-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- 3) Allow 45 to 90 minutes of air drying time prior to the application of the anti-static topcoat.
- (e) Mix and apply the anti-static topcoat. To apply the anti-static topcoat, do these steps:
  - 1) Thoroughly mix the liquid container (Can A) contents.
  - 2) Filter the contents of the liquid container (Can A) into the fibers container (Can B).
  - 3) Add the contents of the curing agent container to the mixture now in the fibers container (Can B) and mix thoroughly.
  - 4) Apply the anti-static topcoat over the previously applied tiecoat to a thickness of 0.001" to 0.002" (1 or 2 coats).
- (4) Let the coating cure for 24 hours at room temperature.
- (5) Use an insulation meter, COM-6457 to test the antistatic topcoat for surface resistance per AMS 3138-6.
  - (a) Make sure that the resistance is between 0.5 and 15 megaohms.
- (6) Test the coating in the repair area and at least one area which includes the repair topcoat bridged to the original radome topcoat.

————— END OF TASK ————

**TASK 53-54-00-300-806**

**7. Broadband Radome Hoist Point Nutplate Repair**

**A. General**

- (1) The radome hoist point nutplate repair consists of replacing the damaged nutplate with a new nutplate.
- (2) This repair procedure cannot be done while the radome is installed on the airplane.

**B. References**

<b>Reference</b>	<b>Title</b>
53-54-00-000-801	Broadband Radome Removal (P/B 401)

**C. Radome Hoist Point Nutplate Repair**

**SUBTASK 53-54-00-020-003**

- (1) If the damaged radome is still on the airplane, remove it. To remove the radome, do this task: (Broadband Radome Removal, TASK 53-54-00-000-801).

**SUBTASK 53-54-00-300-006**

- (2) To replace the radome hoist point nutplate, do these steps:
  - (a) Use a small diameter (1" to 2") disc sander to remove the rivet tail, which attaches the defective hoist point nutplate to the radome.
  - (b) Use a small hammer and a small-diameter (0.070" to 0.090") punch to remove the rivets that attach the hoist point nutplate to the radome.
  - (c) Install new rivets (NAS1200M3-7) into the hoist point nutplate rivet holes from the outer surface of the radome.
  - (d) Put the new hoist point nutplate (BACN11G3A1CD) onto the rivets protruding through radome shell.
  - (e) Position a pneumatic rivet squeezer over the hoist point nutplate rivets.
  - (f) Squeeze the rivets to attach the hoist point nutplate to the radome.

EFFECTIVITY  
LOM 466-999

**53-54-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (3) Touch-up the coating on the radome exterior, if required. To touch up the coating, do this task:  
(Broadband Radome Exterior Coating Repair, TASK 53-54-00-300-805).

— END OF TASK —

**TASK 53-54-00-300-807**

**8. Broadband Radome Leading Edge Protector Repair**

**A. General**

- (1) The radome leading edge protector repair consists of replacing the damaged leading edge protector with a new leading edge protector.  
(2) This repair procedure cannot be done while the radome is installed on the airplane.

**B. References**

<b>Reference</b>	<b>Title</b>
53-54-00-000-801	Broadband Radome Removal (P/B 401)

**C. Tools/Equipment**

<b>Reference</b>	<b>Description</b>
STD-549	Knife - Putty, Broad Blade
STD-3729	Fastener - Spring Loaded, Sheet Metal, 3/16 Cleco

**D. Consumable Materials**

<b>Reference</b>	<b>Description</b>	<b>Specification</b>
A01076	Adhesive - Synthetic Rubber	BAC5010 Type 93 (BMS5-95 Class B)

**E. Radome Leading Edge Protector Repair**

**SUBTASK 53-54-00-020-004**

- (1) If the damaged radome is still on the airplane, remove it. To remove the radome, do this task:  
(Broadband Radome Removal, TASK 53-54-00-000-801).

**SUBTASK 53-54-00-300-007**

- (2) To replace the radome leading edge protector, do these steps:
- Mask the coated radome surface surrounding the leading edge protector.
  - Use a small drill motor and #40 (0.098" diameter) drill bit to remove the countersink heads of the rivets that attach the leading edge protector to the radome.
  - Use a small hammer and small (0.070" to 0.090") diameter punch to remove the rivets.
  - Use a broad blade putty knife, STD-549 to carefully disbond and remove the leading edge protector.
  - Use a small drill motor and a #40 (0.098" diameter) drill bit to enlarge the pilot hole nearest each end of the new leading edge protector to size #40 (0.098").
  - "Dry fit" the new leading edge protector on the radome.
  - Use a spring loaded fastener, STD-3729 to hold the leading edge protector in place.
  - Use a small drill motor and #40 (0.098") drill bit to "back drill" through the existing rivet hole in the radome and through the remaining ("unopened") leading edge protector rivet hole.
  - Repeat steps (g) and (h) on the holes on the other end of the leading edge protector.

— EFFECTIVITY —  
**LOM 466-999**

**53-54-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (j) Use a drill motor and a small microstop with a 100-degree cutter and #40 (0.098" diameter) pilot to countersink the outer surface of the leading edge protector at the edge protector rivet hole locations to accept NAS1200M3-6.5 rivet.
- (k) Remove the spring loaded fastener, STD-3729 and the leading edge protector from the radome.
- (l) Apply adhesive, A01076 to the lower (radome trim) edge of the radome and to the outer surface of the radome in the leading edge protector area.
- (m) Apply adhesive, A01076 to the bond surface of the leading edge protector.
- (n) Put the new leading edge protector in place on the radome.
- (o) Secure each end of the leading edge protector with a spring loaded fastener, STD-3729 while the adhesive cures.
- (p) After the adhesive has cured, install a rivet in the open hole in each end of the leading edge protector.
- (q) Remove the spring loaded fastener, STD-3729 and install a rivet in the other open hole in each end of the leading edge protector.
- (r) Put a pneumatic rivet squeezer into position to squeeze the rivets.
- (s) Squeeze the rivets.

———— END OF TASK ————

**TASK 53-54-00-300-808**

**9. Broadband Radome Lightning Diverter Strip Repair**

**A. General**

- (1) The radome lightning diverter strip repair consists of replacing the damaged lightning diverter strip with a new lightning diverter strip.

**B. References**

<b>Reference</b>	<b>Title</b>
53-54-00-000-801	Broadband Radome Removal (P/B 401)

**C. Consumable Materials**

<b>Reference</b>	<b>Description</b>	<b>Specification</b>
B00130	Alcohol - Isopropyl	TT-I-735
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CLA)
G50073	Promoter - Tape Adhesion - Adhesion Promoter 86A	
G50260	Sandpaper - Aluminum Oxide, 220 Grit	

**D. Radome Lightning Diverter Strip Repair**

**SUBTASK 53-54-00-020-005**

- (1) If the damaged radome is still on the airplane, remove it. To remove the radome, do this task: (Broadband Radome Removal, TASK 53-54-00-000-801).

———— EFFECTIVITY ————  
**LOM 466-999**

**53-54-00**



737-600/700/800/900  
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 53-54-00-300-008

- (2) Apply masking tape and paper along the edge of the lightning diverter strips.

NOTE: The lightning diverter strips are 0.40" wide, and the edge of the lightning diverter strips appears as a "step" in the radome exterior coating in the vicinity of the lightning diverter strips.

- (3) Use a standard putty knife to carefully pry the dimpled washers from the radome surface at the forward and aft terminations of the lightning diverter strips.
- (4) Use a utility or other narrow-blade sharp knife to very carefully cut through the radome coating at the edge of the lightning diverter strips.
- (5) Use a standard putty knife to carefully disbond the lightning diverter strip from the radome outer surface.
- (6) If necessary due to damage, replace the masking materials (tape and paper) in the area surrounding the lightning diverter strip bond region.
- (7) Use sandpaper, G50260 to scuff sand the bond surface of the radome in the area that will receive the new lightning diverter strips.
- (8) Use a cotton wiper, G00034 moistened with solvent to wipe the abraded surface of the radome.
- (9) Use a narrow artist brush to apply Adhesion Promoter 86A, G50073 to the radome surface in the lightning diverter strip bond region.
- (10) Wait 15 to 20 minutes for the Adhesion Promoter 86A, G50073 to air dry on the surface of the radome.
- (11) Carefully peel the protective paper away from the bond side of a new lightning diverter strip.
- (12) Apply the new lightning diverter strip to the radome.
- (a) Work may begin at either the forward termination of the lightning diverter strip, or at the aft termination of the lightning diverter strip.
- (b) Two lightning diverter strips will be applied to the radome.
- (c) The ends of both of these lightning diverter strips shall be positioned 0.060" to 0.100" from the edge of the dimpled washer countersink.
- (13) After one of the lightning diverter strips has been applied along its full length to the radome surface, butt-join a second section of lightning diverter strip to the first section of lightning diverter strip, with no gap between these two sections of lightning diverter.
- (14) Apply the second section of lightning diverter strip to within 1" to 3" of the dimpled washer countersink at the termination of the lightning diverter strip.
- (15) Trim the end of the second section of lightning diverter strip such that the end of the lightning diverter strip is 0.060" to 0.100" from the edge of the dimpled washer countersink.
- (16) Prepare to bond dimpled washers to termination of the lightning diverter strip sections by scuff sanding the radome surface in the region to receive the dimpled washers.
- (17) Apply Loctite / Hysol Company paste adhesive product EA-934NA to the bond surface of the dimpled washer.
- NOTE: This paste adhesive shall not be applied where it will come into contact with the "buttons/segments" of the lightning diverter strip.
- (18) Apply the adhesive-coated dimpled washer to the radome surface.
- (19) Use a cotton wiper, G00034 moistened with solvent to remove excess paste adhesive.
- (20) Use only the minimum amount of solvent (acetone) required to wipe away excess adhesive.

EFFECTIVITY  
LOM 466-999

**53-54-00**



**737-600/700/800/900**  
**AIRCRAFT MAINTENANCE MANUAL**

- (21) Apply a piece of tape over dimpled washers to secure them in place during the adhesive cure period.
- (22) Let the adhesive cure for a period of 24 hours at  $80 \pm 10^{\circ}\text{F}$  ( $27 \pm 6^{\circ}\text{C}$ ).
- (23) Apply narrow masking tape to the lightning diverter strips, centering the masking tape over the buttons/segments of the lightning diverter strips.
- (24) Use 240 (or finer) sandpaper to scuff sand the diverter carrier laminate and the adjacent rain erosion coating in the area that received the new lightning diverter strips.
- (25) Use a cotton wiper, G00034 moistened with alcohol, B00130 to remove particles left by the sanding.
- (26) Apply coating to the exposed surface of the lightning diverter strips. Do this task: (Broadband Radome Exterior Coating Repair, TASK 53-54-00-300-805).
- (27) After the coating has cured, use a utility knife, or similar narrow-blade sharp knife, to very carefully cut the coating along the edge of the masking tape protecting the lightning diverter strip buttons/segments.
- (28) Remove the masking tape.

———— END OF TASK ————

EFFECTIVITY  
LOM 466-999

**53-54-00**