



AIRCRAFT
MAINTENANCE MANUAL

HORIZONTAL STABILIZER-TO-ELEVATOR HINGE FITTINGS - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the horizontal stabilizer-to-elevator hinge fittings.
- B. The procedures in this section are given in the sequence below. The tasks identified with (♦) are part of the Scheduled Maintenance Requirements Document (SMRD).

TASK NUMBER	DESCRIPTION	EFFECTIVITY
55-20-03-000-801-A	HORIZONTAL STABILIZER-TO-ELEVATOR HINGE FITTINGS - REMOVAL	ALL
55-20-03-400-801-A	HORIZONTAL STABILIZER-TO-ELEVATOR HINGE FITTINGS - INSTALLATION	ALL



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TASK 55-20-03-000-801-A

EFFECTIVITY: ALL

2. HORIZONTAL STABILIZER-TO-ELEVATOR HINGE FITTINGS - REMOVAL

A. General

- (1) This procedure gives the instructions to remove the horizontal stabilizer-to-elevator hinge fittings.

B. References

REFERENCE	DESIGNATION
AMM TASK 27-30-00-000-801-A/400	ELEVATOR - REMOVAL

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
333		Horizontal Stabilizer
334		Horizontal Stabilizer

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

Not Applicable

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Horizontal Stabilizer

I. Preparation

SUBTASK 841-002-A

- (1) Remove the elevator. Refer to [AMM TASK 27-30-00-000-801-A/400](#).

J. Removal ([Figure 401](#))

SUBTASK 020-002-A

- (1) Remove the fitting (6) as follows:
- (2) Remove the cotter pin, locknut (5), and washers (4).
- (3) Hold the fitting (6) and remove the bolt (1), washer (2), and bushing (3).
- (4) Remove the fitting (6).



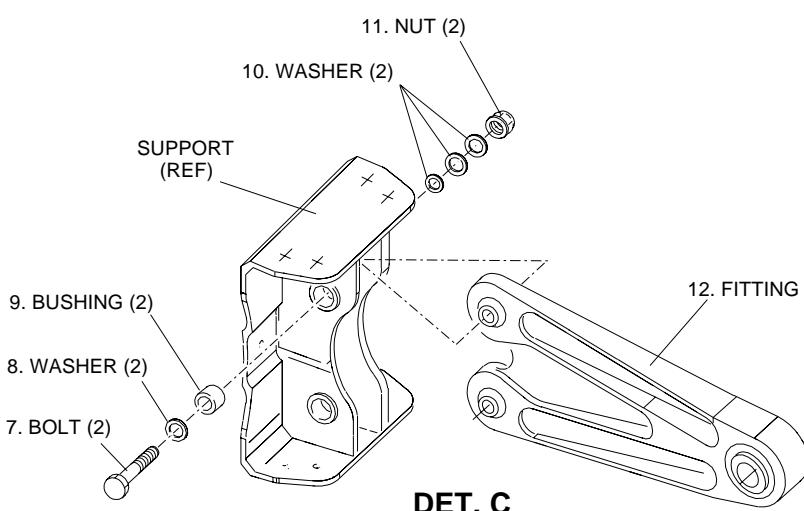
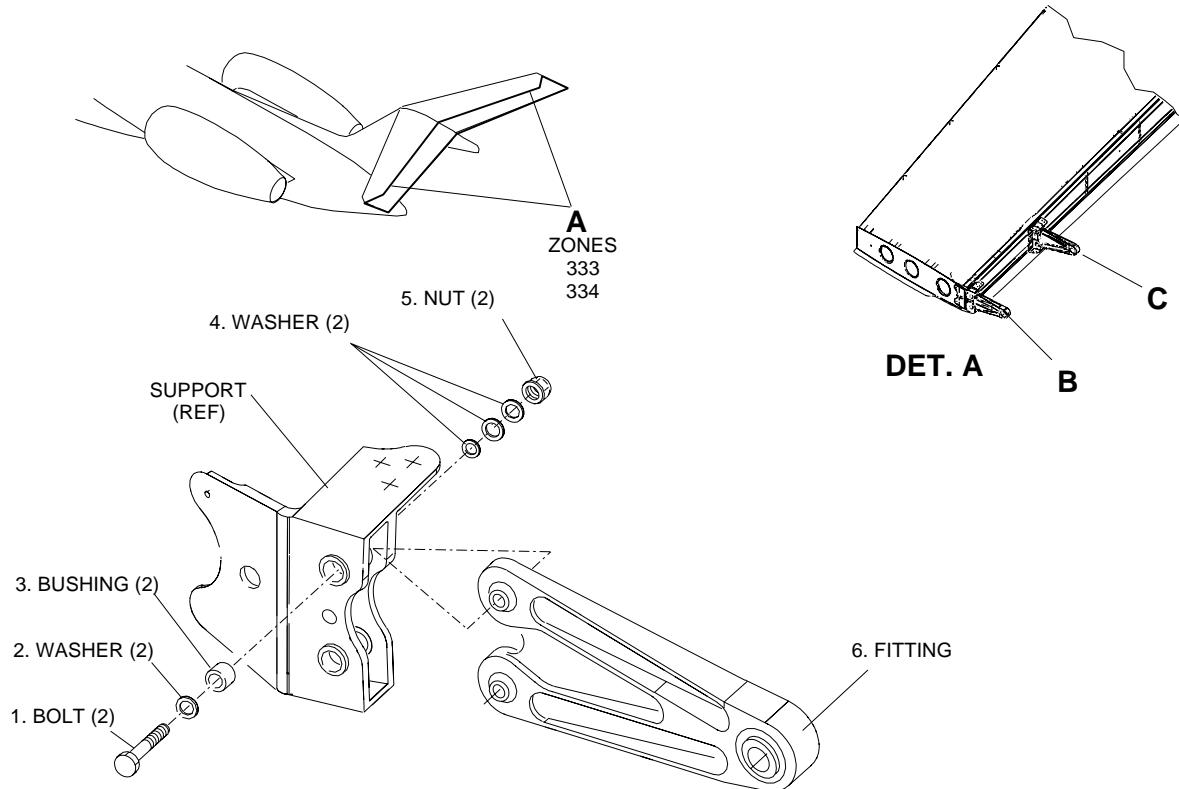
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- (5) Remove the fitting (12) as follows:
- (6) Remove the cotter pin, locknut (11), and washers (10).
- (7) Hold the fitting (12) and remove the bolt (7), washer (8), and bushing (9).
- (8) Remove the fitting (12).

EFFECTIVITY: ALL

Horizontal Stabilizer-to-Elevator Hinge Fittings - Removal/Installation

Figure 401



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TASK 55-20-03-400-801-A

EFFECTIVITY: ALL

3. HORIZONTAL STABILIZER-TO-ELEVATOR HINGE FITTINGS - INSTALLATION

A. General

- (1) This procedure gives the instructions to install the horizontal stabilizer-to-elevator hinge fittings.

B. References

REFERENCE	DESIGNATION
AMM TASK 27-30-00-400-801-A/400	ELEVATOR - INSTALLATION

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
333		Horizontal Stabilizer
334		Horizontal Stabilizer

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially Available	Dial-Type Wrench - Torque 0 - 8.5 N.m (0 - 75 lb.in)	To measure the locking torque value	
Commercially Available	Click-Type Wrench - Torque 3.4 - 16.9 N.m (30 - 150 lb.in)	To apply the final torque to the locknuts	

E. Auxiliary Items

Not Applicable

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Horizontal Stabilizer

I. Installation (Figure 401)

SUBTASK 420-002-A

- (1) Install the fitting (6) as follows:
- (2) Install the washer (2) to the bolt (1).
- (3) Put the fitting (6) in position and install the bushing (3) and bolt (1).

- (4) Install the washers (4).
- (5) Install the locknut (5).
- (6) Make sure that the threads of the locknut (5) and bolt (1) fully engage. The base of the locknut (5) must not touch the surface.
- (7) Turn the locknut (5) and measure the locking torque with a dial-type wrench.
- (8) Make sure that the locking torque value is 0.4 - 3.4 N.m (3.5 - 30 lb.in).
NOTE: If you find a locknut that is not in the correct range, replace it and do the procedure again from step (5).
- (9) Add the locking torque value measured in step (7) to the standard torque of 5.6 - 6.8 N.m (50 - 60 lb.in) to get the final torque.
- (10) Apply the final torque to the locknuts (5) with a click-type wrench.
- (11) Install the cotter pin.
- (12) Install the fitting (12) as follows:
 - (13) Install the washer (8) to the bolt (7).
 - (14) Put the fitting (12) in position and install the bushing (9) and bolt (7).
 - (15) Install the washers (10).
 - (16) Install the locknut (11).
- (17) Make sure that the threads of the locknut (11) and bolt (7) fully engage. The base of the locknut (11) must not touch the surface.
- (18) Turn the locknut (11) and measure the locking torque with a dial-type wrench.
- (19) Make sure that the locking torque value is 0.4 - 3.4 N.m (3.5 - 30 lb.in).
NOTE: If you find a locknut that is not in the correct range, replace it and do the procedure again from step (16).
- (20) Add the locking torque value measured in step (18) to the standard torque of 5.6 - 6.8 N.m (50 - 60 lb.in) to get the final torque.
- (21) Apply the final torque to the locknuts (11) with a click-type wrench.
- (22) Install the cotter pin.

J. Follow-on

SUBTASK 842-002-A

- (1) Install the elevator. Refer to [AMM TASK 27-30-00-400-801-A/400](#).