

SERVICE-DOOR FRAME STOP - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedure to remove and install the service-door frame stop.
- 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).

<i>TASK NUMBER</i>	<i>DESCRIPTION</i>	<i>EFFECTIVITY</i>
53-21-04-000-801-A	REMOVAL	ALL
53-21-04-400-801-A	INSTALLATION	ALL

TASK 53-21-04-000-801-A

EFFECTIVITY: ALL

2. REMOVAL

A. General

(1) This task gives the instructions to remove the service-door frame stop.

B. References

REFERENCE	DESIGNATION
AMM SDS 52-43-00/1	
AMM TASK 25-23-07-000-801-A/400	-
AMM TASK 25-27-08-000-801-A/400	-
AMM TASK 25-30-01-000-801-A/400	-
AMM TASK 25-30-02-000-801-A/400	-

C. Zones and Accesses

Not Applicable

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	Center fuselage I - on the right side

I. Preparation

SUBTASK 841-002-A

- (1) Open the service door ([AMM SDS 52-43-00/1](#)).
- (2) Remove the service-door trim shroud assembly (AMM TASK 25-23-07-000-801-A/400).
- (3) For the EMB-135() models, remove the RH windscreen (AMM TASK 25-27-08-000-801-A/400) or the forward galley assembly (AMM TASK 25-30-01-000-801-A/400), as applicable.

- (4) For the EMB-145() models, remove the forward galley assembly (AMM TASK 25-30-01-000-801-A/400) or the aft galley assembly (AMM TASK 25-30-02-000-801-A/400), as applicable.

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

SUBTASK 020-002-A

- (1) Remove the screws (1) and (2), nuts (4) and (5), and washers (3) and (6) from the stop. Discard the nuts.

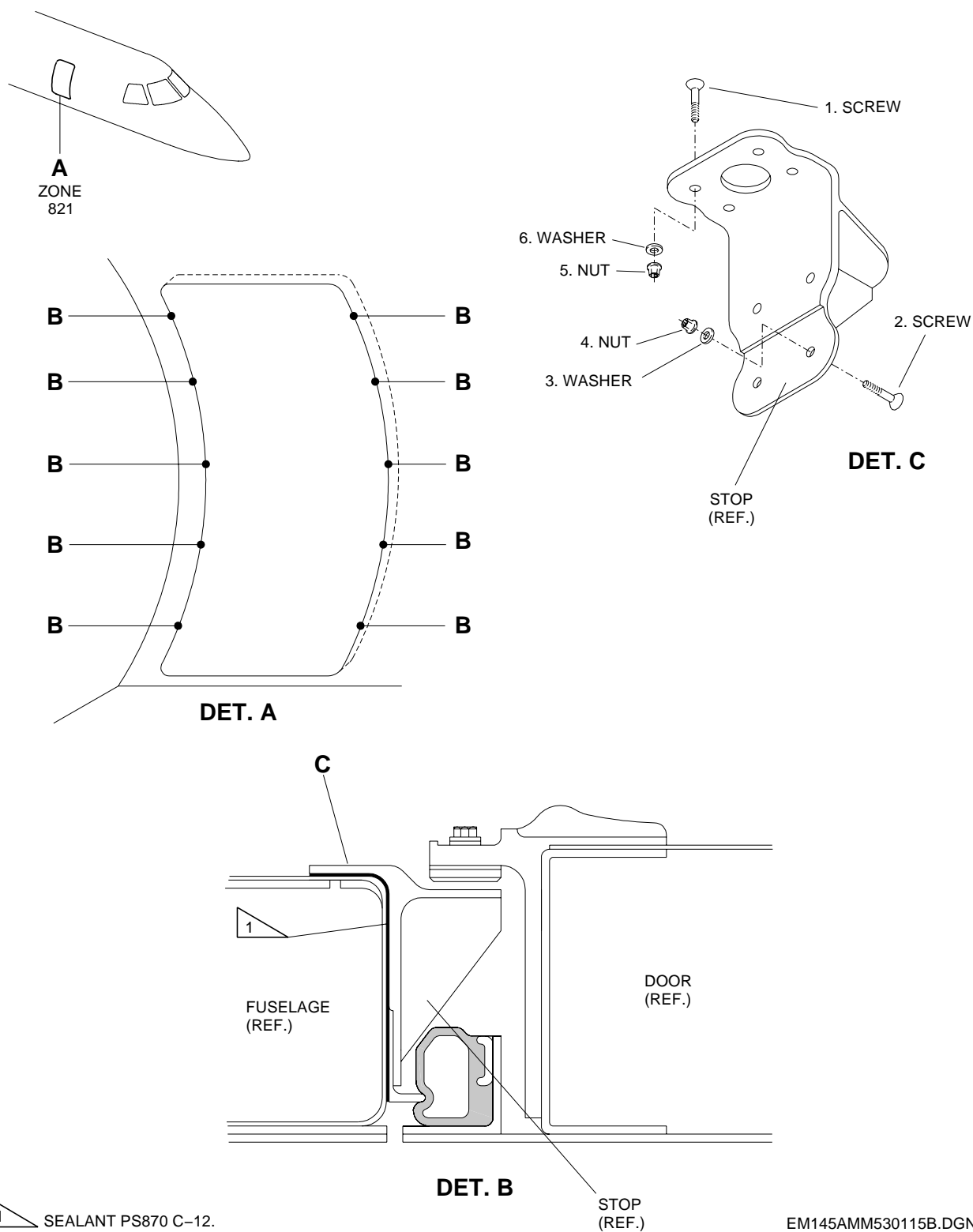
NOTE: Screws are different in size. Write down their positions.

- (2) Remove the stop.

EFFECTIVITY: ALL

Service-Door Frame Stop - Removal/Installation

Figure 401



EM145AMM530115B.DGN

TASK 53-21-04-400-801-A
EFFECTIVITY: ALL

3. INSTALLATION

A. General

(1) This task gives the instructions to install the service-door frame stop.

B. References

REFERENCE	DESIGNATION
AMM SDS 52-43-00/1	
AMM TASK 25-23-07-400-801-A/400	-
AMM TASK 25-27-08-400-801-A/400	-
AMM TASK 25-30-01-400-801-A/400	-
AMM TASK 25-30-02-400-801-A/400	-
IPC 53-21-00	CENTRAL I
SRM 51-20-01/1	-

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

Not Applicable

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
TT-M-261	Methyl ethyl ketone	AR
MIL-PRF-81733	Sealant PS870 C-12	AR

G. Expendable Parts

ITEM	IPC REFERENCE (VENDOR REFERENCE)	QTY
Nut	IPC 53-21-00	80

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Center fuselage I - on the right side

I. Installation (Figure 401)

SUBTASK 400-002-A

- (1) Clean the stop and the installation area with methyl ethyl ketone.
- (2) Apply interface sealant PS870 C-12 (SRM 51-20-01/1) between the stop and the fuselage installation area. Seal the nut holes to prevent damage to the electrical bonding area caused by the sealant (Figure 401).
- (3) Install the stop.
- (4) Install the screws (1) and (2), nuts (4) and (5), and washers (3) and (6) to attach the stop.

NOTE: Screws are different in size. Make sure that they are installed in the correct positions.

- (5) Remove the excess protective coat.

J. Follow-on

SUBTASK 842-002-A

- (1) For the EMB-135() models, install the RH windscreen (AMM TASK 25-27-08-400-801-A/400) or the forward galley assembly (AMM TASK 25-30-01-400-801-A/400), as applicable.
- (2) For the EMB-145() models, install the forward galley assembly (AMM TASK 25-30-01-400-801-A/400) or the aft galley assembly (AMM TASK 25-30-02-400-801-A/400), as applicable.
- (3) Install the service-door trim shroud assembly (AMM TASK 25-23-07-400-801-A/400).
- (4) Close the service door ([AMM SDS 52-43-00/1](#)).