

PYLON - LOWER SURFACE - COVER ASSY - JOINT RETAINER - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the joint retainer of the cover assy in the lower surface of the pylon.
- 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
54-51-02-000-801-A	JOINT RETAINER - REMOVAL	ALL
54-51-02-400-801-A	JOINT RETAINER - INSTALLATION	ALL

TASK 54-51-02-000-801-A

EFFECTIVITY: ALL

2. JOINT RETAINER - REMOVAL

A. General

- (1) This procedure gives the instructions to remove the joint retainer of the cover assy in the lower surface of the pylon.

B. References

REFERENCE	DESIGNATION
AMM MPP 06-43-00/100	- COMPONENT LOCATION
AMM MPP 78-30-00/200	- MAINTENANCE PRACTICES
AMM TASK 20-40-02-910-801-A/200	STATIC GROUNDING - STANDARD PRACTICES

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
410	414CB (LH side)	Pylon
420	424CB (RH side)	Pylon

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	1
Commercially available	Acrylic Spatula	To clean the surface and release the adhesive	1
Commercially available	Cutter	To remove the joint retainer	1
Commercially available	Protective Gloves	For protection of technician's hands	1
Commercially available	Safety Goggles	For protection of technician's eyes	1

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
ASTM D-740	Methyl-Ethyl-Ketone (MEK)	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Do the task	Pylon

I. Preparation

SUBTASK 841-002-A

WARNING: MAKE SURE THAT THE AIRCRAFT IS IN A SAFE CONDITION BEFORE YOU DO THE MAINTENANCE PROCEDURES. THIS IS TO PREVENT INJURY TO PERSONS AND/OR DAMAGE TO THE EQUIPMENT.

WARNING: BEFORE YOU DO THE TASK, OBEY THE SAFETY PRECAUTIONS GIVEN IN [AMM MPP 78-30-00/200](#) TO PREVENT INJURY TO PERSONS AND DAMAGE TO MATERIAL.

- (1) Do the procedure to make the aircraft safe for maintenance ([AMM TASK 20-40-02-910-801-A/200](#)).
- (2) On the circuit breaker panel, open the circuit breakers below and attach a DO-NOT-CLOSE tag to them:
 - START 1 (location tip: POWERPLANT/THRUST REVERSER 1).
 - START 2 (location tip: POWERPLANT/THRUST REVERSER 2).
- (3) Put a DO-NOT-OPERATE-THE-THRUST-REVERSERS sign on the instrument panel, in the cockpit.
- (4) Put the workstand into position and get access to the lower surface of the pylon.
- (5) Remove the access panels 414CB (LH side) and 424CB (RH side) ([AMM MPP 06-43-00/100](#)).

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

SUBTASK 020-002-A

WARNING: BE CAREFUL WHEN YOU USE A CUTTER AND DO NOT MAKE SCRATCHES ON THE LOWER SURFACE OF THE PYLON.

- (1) With a cutter, remove the adhesive to lift the joint retainer (2).
- (2) Slowly release the joint retainer (2) with a cutter until the joint retainer (2) is fully removed.
- (3) Remove the old adhesive with an acrylic spatula.

WARNING: BE CAREFUL WHEN YOU USE THE METHYL-ETHYL-KETONE (MEK). PUT ON SAFETY GOGGLES, PROTECTIVE GLOVES AND CLOTHING. DO NOT BREATHE THE GAS. DO THE WORK IN AN AREA WHICH HAS A GOOD FLOW OF AIR. MEK IS POISONOUS AND HIGHLY FLAMMABLE.

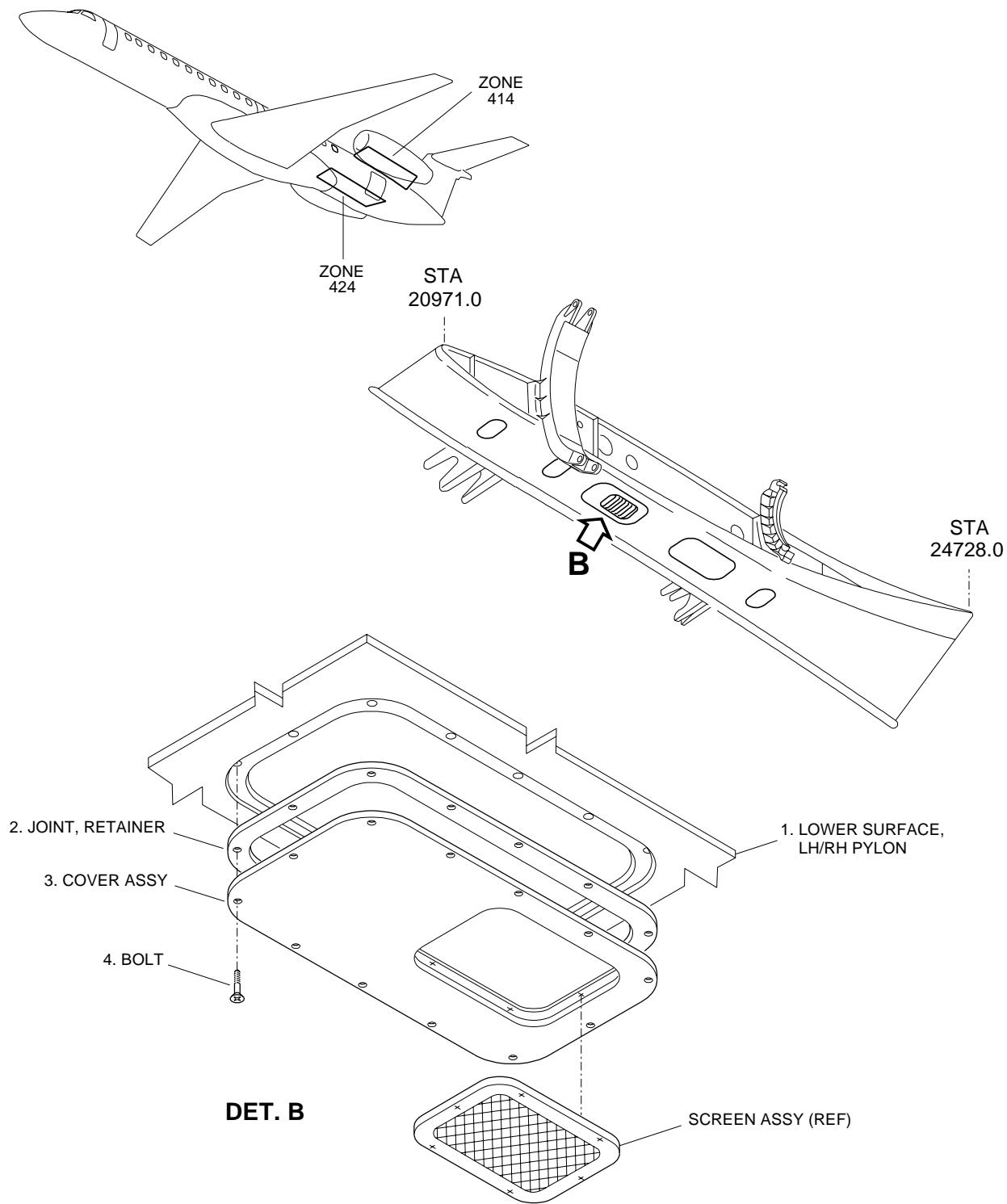
- (4) With a cloth soaked in MEK, clean the lower surface of the pylon (1).

NOTE: Make sure that the lower surface of the pylon (1) where the joint retainer (2) will be installed is clean and with no residues of adhesive, rubber, or oil.

EFFECTIVITY: ALL

Joint Retainer - Removal and Installation

Figure 401



EM145AMM540035A.DGN

TASK 54-51-02-400-801-A

EFFECTIVITY: ALL

3. JOINT RETAINER - INSTALLATION

A. General

- (1) This procedure gives the instructions to install the joint retainer of the cover assy in the lower surface of the pylon.

B. References

REFERENCE	DESIGNATION
AMM MPP 06-43-00/100	- COMPONENT LOCATION
AMM TASK 20-40-02-910-801-A/200	STATIC GROUNDING - STANDARD PRACTICES

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
410	414CB (LH side)	Pylon
420	424CB (RH side)	Pylon

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	1
Commercially available	Acrylic Spatula	To clean the surface and release the adhesive	1
Commercially available	Cutter	To remove the joint retainer	1
Commercially available	Protective Gloves	For protection of technician's hands	1
Commercially available	Safety Goggles	For protection of technician's eyes	1

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
ASTM D-740	Methyl-Ethyl-Ketone (MEK)	AR
TT-I-735	Isopropyl Alcohol	AR
AV138	Araldite adhesive	AR
Commercially available	Adhesive tape	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Do the task	Pylon

I. Installation (Figure 401)

SUBTASK 420-002-A

- (1) Bond the joint retainer (2) with the lower surface of the pylon (1) as follows:

WARNING: BE CAREFUL WHEN YOU USE SOLVENTS BECAUSE THEY ARE A HEALTH AND FIRE HAZARD. USE SAFETY GOGGLES AND PROTECTIVE CLOTHING WHEN YOU HANDLE THEM. DO NOT BREATHE THEIR GASES AND WORK IN A WELL VENTILATED AREA.

- (a) Clean the pylon recess with a clean cloth soaked with solvent.
- (b) Mix the adhesive component A and B and apply it in the pylon recess (1).
- (c) Position the joint retainer (2) in the pylon recess (1) let the sealing compound cure within the time established by the manufacturer.

NOTE: Obey the manufacturer's instructions to prepare the area.

- (d) With masking tape, keep the joint retainer (2) in position until the adhesive polymerization is completed.

- (2) After cure time remove the tape.

J. Follow-on

SUBTASK 842-002-A

- (1) Install the access panels 414CB (LH side) and 424CB (RH side) ([AMM MPP 06-43-00/100](#)).
- (2) Remove all tools, equipment and unwanted materials from the work area.
- (3) Remove the workstand from the work area.
- (4) On the circuit breaker panel, close the circuit breakers below and remove the DO-NOT-CLOSE tag from them:
 - START 1 (location tip: POWERPLANT/THRUST REVERSER 1).
 - START 2 (location tip: POWERPLANT/THRUST REVERSER 2).
- (5) Remove the DO-NOT-OPERATE-THE-THRUST-REVERSERS sign from the instrument panel, in the cockpit.
- (6) Put the aircraft back to its dispatch condition ([AMM TASK 20-40-02-910-801-A/200](#)).

