



EMB145 - EMB135

AIRCRAFT
MAINTENANCE MANUAL

COCKPIT SEAT TRACKS - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the Cockpit Seat Tracks.
- B. Make sure that GSE 364 is in a good condition.
- C. Use the two handles to vertically remove/install GSE 364 from/to the cockpit seat tracks.
- D. 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
53-01-05-000-801-A	COCKPIT SEAT TRACKS - REMOVAL	ALL
53-01-05-400-801-A	COCKPIT SEAT TRACKS - INSTALLATION	ALL



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TASK 53-01-05-000-801-A

EFFECTIVITY: ALL

2. COCKPIT SEAT TRACKS - REMOVAL

A. General

- (1) This procedure gives the instructions to remove the Cockpit Seat Tracks.

B. References

REFERENCE	DESIGNATION
AMM TASK 25-11-01-000-801-A/400	PILOT SEAT - REMOVAL
AMM TASK 53-01-01-000-801-A/400	COCKPIT FLOOR PANELS - REMOVAL

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	In the cockpit, RH/LH

I. Preparation

SUBTASK 841-002-A

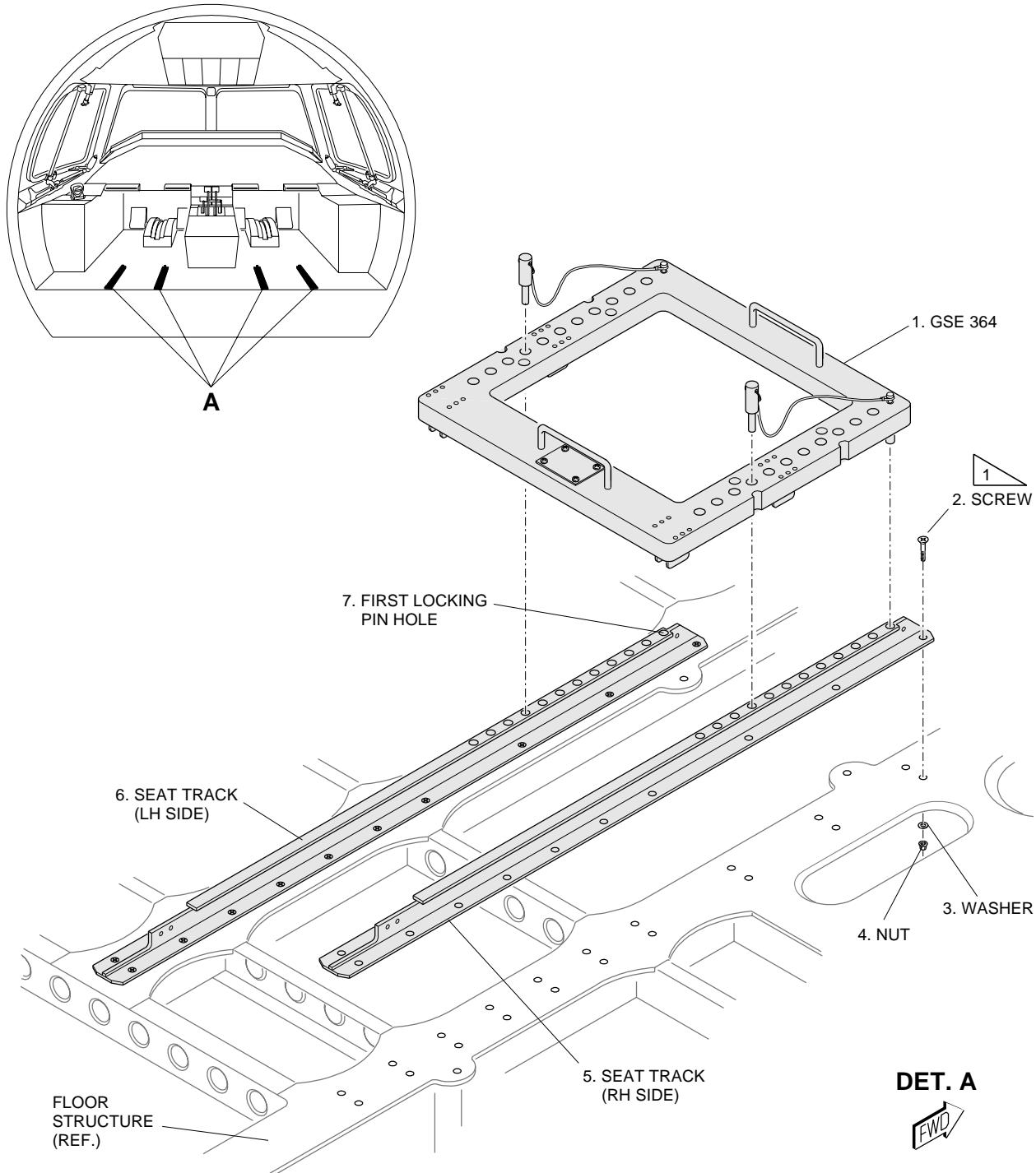
- (1) Remove the pilot/copilot seats ([AMM TASK 25-11-01-000-801-A/400](#)).
- (2) Remove cockpit floor panels 221CF, 221EF, 221FF, 221GF, 222BF, 222CF, and 222FF. Refer to [AMM TASK 53-01-01-000-801-A/400](#).

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

SUBTASK 020-002-A

- (1) Remove the screws (2), washers (3), and nuts (4) that attach the seat tracks (5) and (6) to the cockpit floor structure.
- (2) Remove the seat tracks (5) and (6).

EFFECTIVITY: ALL
Cockpit Seat Tracks - Installation
Figure 401



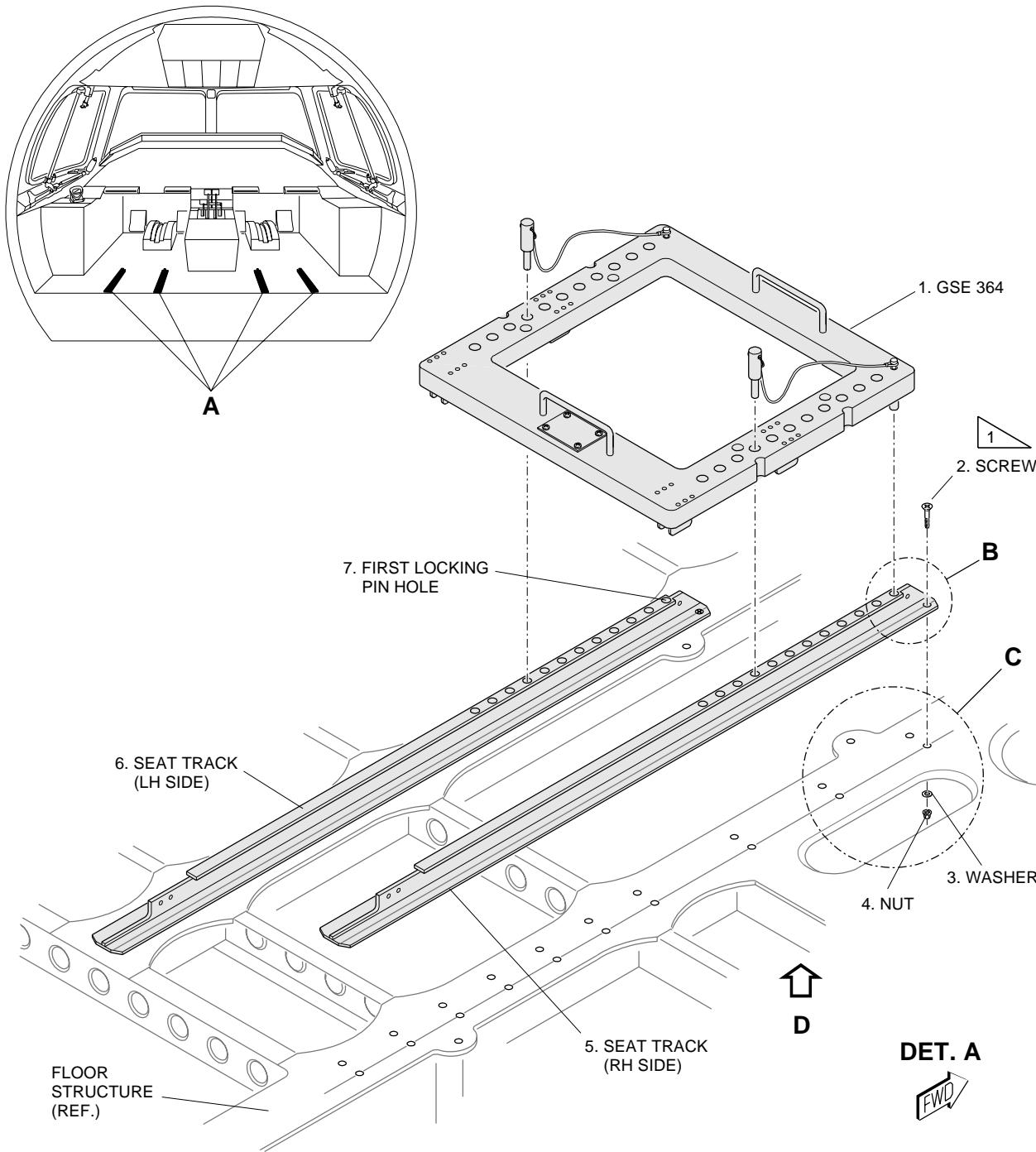
 **TORQUE:** 1.7 TO 2.3N.m (15 TO 20 lb.in) PLUS DRAG TORQUE.

145AMM530012D.MCE

EFFECTIVITY: POST-MOD. S.B. 145-53-0027

Cockpit Seat Tracks - Installation

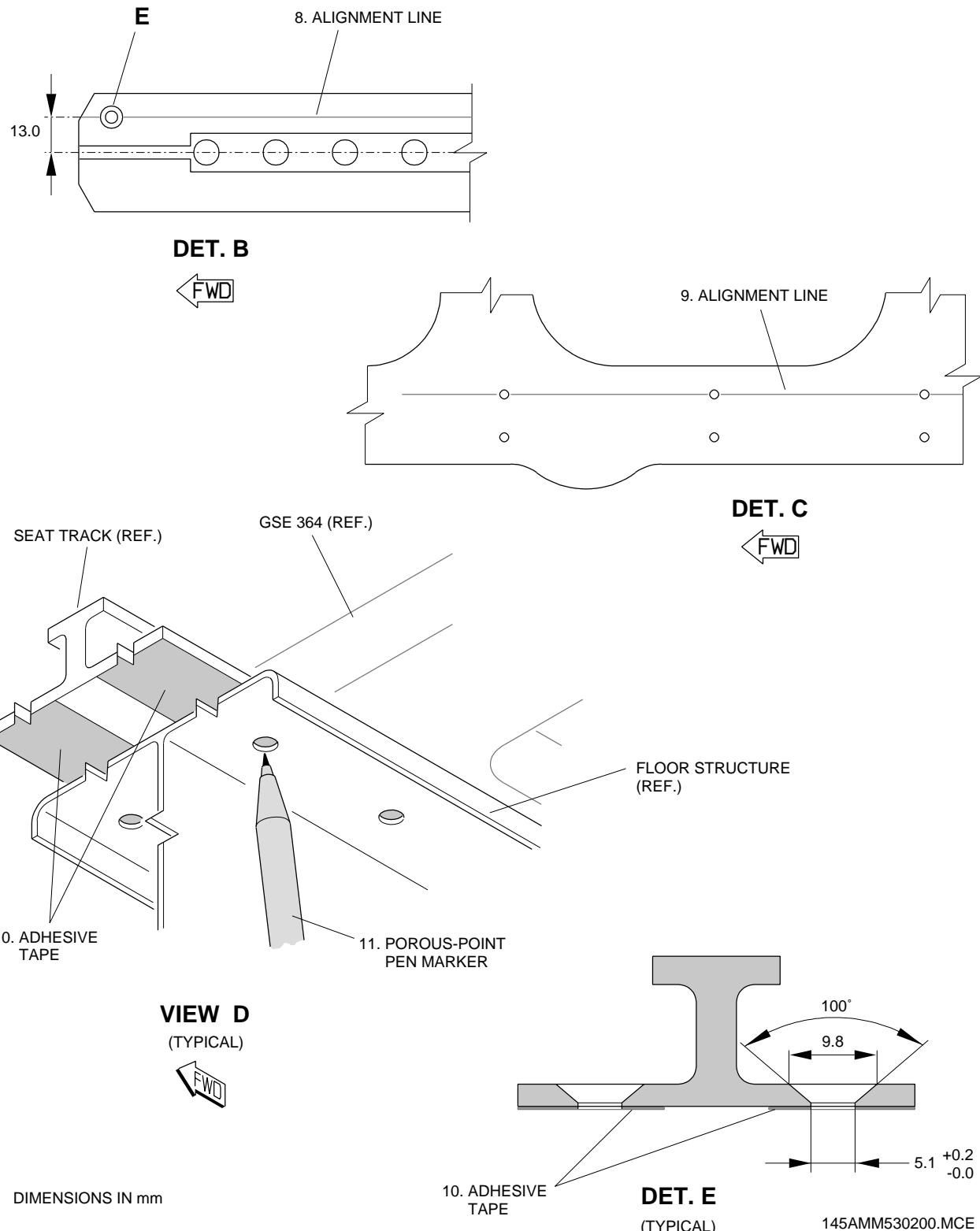
Figure 402 - Sheet 1



 TORQUE: 1.7 TO 2.3N.m (15 TO 20 lb.in) PLUS DRAG TORQUE.

145AMM530199B.MCE

EFFECTIVITY: POST-MOD. S.B. 145-53-0027
Cockpit Seat Tracks - Installation
Figure 402 - Sheet 2





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TASK 53-01-05-400-801-A

EFFECTIVITY: ALL

3. COCKPIT SEAT TRACKS - INSTALLATION

A. General

(1) This procedure gives the instructions to install the Cockpit Seat Tracks.

B. References

REFERENCE	DESIGNATION
AMM TASK 25-11-01-200-801-A/600	COCKPIT SEATS - DETAILED INSPECTION
AMM TASK 53-01-01-400-801-A/400	COCKPIT FLOOR PANELS - INSTALLATION
CPM 51-21-04	-
S.B.145-53-0027	-
SRM 51-20-03	-

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
GSE 364	Jig-Drilling, Pilot Seat Track Instl	To assemble the seat tracks correctly	
Commercially available	Torque Wrench	To torque the screws that attach the seat tracks	

E. Auxiliary Items

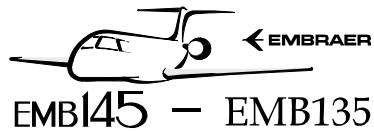
ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Rubber gloves	Protection for the hands	AR
Commercially available	Goggles	Protection for the eyes	AR
Commercially available	Porous-point pen marker	To transfer holes from the cockpit floor structure to the seat tracks	1

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
JAN-P-127	Adhesive Tape	AR
MEP 13-073	Rhodiasolve E-23	AR
MEP 09-060	CA 1000	AR

G. Expandable Parts

Not Applicable



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H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	In the cockpit, RH/LH

I. Installation (Figure 401) (Figure 402)

SUBTASK 420-002-A

WARNING: MAKE SURE THAT GSE 364 IS IN GOOD CONDITION. IT MUST BE USED IN BOTH SITUATION, WHETHER THE SEAT TRACK IS DRILLED OR NOT.

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

- (1) With a clean cloth soaked in rhodiasolve E-23, clean the seat track holes, seat tracks surface, cockpit floor structure holes, and the cockpit floor structure surface.
- (2) Do steps (a) through (y) when the installation of the new cockpit seat tracks POST-MOD. [S.B.145-53-0027](#) part II is necessary. (Refer to (Figure 402):
 - (a) Apply adhesive tape (10) to the lower side of the tracks, as shown in DET. D and DET. E.
 - (b) Use a porous-point pen marker (11) to draw a alignment line (8) on the under and upper surface of the seat track (5) (RH side), as shown in DET. B and keep the mark.
 - (c) Use a porous-point pen marker (11) to draw a alignment line on the cockpit floor structure which goes through the existing hole centers (RH and side), as shown in DET. A and DET. C. Keep the mark.
 - (d) Position the new seat tracks on the floor structure, as shown in DET. A.
 - (e) Install the screws (2), washers (3), and nuts (4) that attach the seat tracks (5) and (6) (RH and LH sides) to the cockpit floor structure.
 - (f) Align the track (5) (RH side) with the centerline of the cockpit floor structure and use a C-clamp to attach the seat track (RH side) to the cockpit floor structure.
 - (g) Install GSE 364 (1) to the first locking pin hole (7).
 - (h) Use GSE 364 (1) to make sure that the locking pin engages correctly at each hole.
 - (i) Use a C-clamp to attach the seat track (6) (LH side) to the cockpit floor structure.
 - (j) Use GSE 364 (1) to make sure that the locking pin engages correctly at each hole.

NOTE: If there is interference between locking pin holes and GSE 364 (1) or seat tracks (5) and (6) (LH and RH sides) to GSE 364 (1), remove the C-clamp (LH side) and go to step (f).

- (k) Transfer GSE 364 (1) to the twelfth locking pin hole.

NOTE: If there is interference between locking pin holes and GSE 364 (1) or seat tracks (5) and (6) (LH and RH sides) to GSE 364 (1), remove the C-clamp (LH side) and go to step (f).

- (l) Use a porous-point pen marker (11) to transfer to the extremity of the seat tracks (5) and (6) (LH and RH sides) the holes in the cockpit floor structure (3 position), as shown in DET. D.

- (m) Remove GSE 364 (1).

- (n) Remove the seat tracks and drill 5.1 mm (0.201 in.) -diameter holes and countersink them (Refer to SRM 51-20-03), as shown in DET. E.

- (o) Position the seat tracks (5) and (6) (LH and RH sides) on the floor structure again.

- (p) Install the screws (2), washers (3), and nuts (4) that attach the seat tracks (5) and (6) (LH and RH sides) to the cockpit floor structure.

- (q) Install GSE 364 (1) in the first locking pin hole (7).

- (r) Use GSE 364 (1) to make sure that the locking pin is engages correctly at each hole.

NOTE: If there is interference between locking pin holes and GSE 364 (1) or seat tracks (5) and (6) to GSE 364 (1), remove the screws (2), washers (3), and nuts (4) and remove the seat tracks (5) and (6) (LH and RH sides) and go to step (o).

- (s) Transfer GSE 364 (1) to the twelfth locking pin hole.

NOTE: If there is interference between locking pin holes and GSE 364 (1) or seat tracks (5) and (6) to GSE 364 (1), remove the screws (2), washers (3), and nuts (4) and remove the seat tracks (5) and (6) (LH and RH sides) and go to step (o).

- (t) Use a porous-point pen marker (11) to transfer to the seat tracks the holes in the cockpit floor structure, as shown in DET. D.

- (u) Remove GSE 364 (1).

- (v) Remove the seat tracks (5) and (6) (LH and RH sides) and drill 5.1 mm (0.201 in.) -diameter holes and countersink them (Refer to SRM 51-20-03), as shown in DET. E.

- (w) Remove the adhesive tape (10).

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

- (x) With a clean cloth soaked in rhodiasolve E-23, clean the seat track holes, seat tracks surface, cockpit floor-structure holes, and the cockpit floor-structure surface.
- (y) Apply alodine to the drilled holes according to CPM 51-21-04.
- (3) Position the seat tracks (5) and (6) (LH and RH sides) on the floor structure. Refer to (Figure 401).
- (4) Install GSE 364 (1) in the first locking pin hole (7).
- (5) Before you install the screw (2) and nut (4) to the assembly, measure the drag torque as follows:
 - (a) Make sure the threads of the nut (4) and screw (2) fully engage.
 - (b) With an applicable torque wrench, turn the screw (2) and measure the drag torque. Make sure that the torque value is 0.23 to 2.0 N.m (2 - 18 lb.in).

NOTE: If you find that the nut is not in the correct range, you must replace it and do the drag torque check again.

WARNING: CA-1000 CORROSION-INHIBITING COMPOUND IS TOXIC TO SKIN, EYES AND RESPIRATORY TRACT. USE GOGGLES AND PROTECTIVE GLOVES. USE ONLY IN WELL VENTILATED AREAS. OBEY THE MANUFACTURER'S HEALTH AND SAFETY INSTRUCTIONS.

- (6) Install the screw (2), washer (3), and nut (4) that attach the seat tracks (5) and (6) (LH and RH sides) to the cockpit floor structure. The screw must be wet with CA-1000.
- (7) Add the drag torque value measured in step (5) to the standard torque of 1.7 to 2.3 N.m (15 to 20 lb.in) to get the final torque.
- (8) Apply the final torque to the screw (2).
- (9) After 15 min. (which is the time necessary for unwanted sealant to extrude) apply the final torque to the screw (2) again.
- (10) Use GSE 364 (1) to make sure that the locking pin engages correctly at each hole.

NOTE: If there is interference between locking pin holes and GSE 364 (1) or seat tracks (5) and (6) (LH and RH sides) to GSE 364 (1), remove the screws (2), washers (3), and nuts (4) and go to step (3).

- (11) Transfer GSE 364 (1) to the twelfth locking pin hole.

NOTE: If there is interference between locking pin holes and GSE 364 (1) or seat tracks (5) and (6) (LH and RH sides) to GSE 364 (1), remove the screws (2), washers (3), and nuts (4) and go to step (3).

- (12) Remove GSE 364 (1).



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J. Follow-on

SUBTASK 842-002-A

- (1) Install the cockpit floor panels 221CF, 221EF, 221FF, 221GF, 222BF, 222CF, and 222FF. Refer to [AMM TASK 53-01-01-400-801-A/400](#).
- (2) Do the inspection/check of the pilot seats - ([AMM TASK 25-11-01-200-801-A/600](#)).