

SIDE-HINGED MAIN DOOR GUIDES - REMOVAL/INSTALLATION

EFFECTIVITY: AIRCRAFT WITH SIDE-HINGED MAIN DOOR

1. General

- A. This section gives the procedures to remove and install the side-hinged main door guides.
- 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
53-21-06-000-801-A	SIDE-HINGED MAIN DOOR GUIDES - REMOVAL	AIRCRAFT WITH SIDE-HINGED MAIN DOOR
53-21-06-400-801-A	SIDE-HINGED MAIN DOOR GUIDES - INSTALLATION	AIRCRAFT WITH SIDE-HINGED MAIN DOOR

TASK 53-21-06-000-801-A

EFFECTIVITY: AIRCRAFT WITH SIDE-HINGED MAIN DOOR

2. SIDE-HINGED MAIN DOOR GUIDES - REMOVAL

A. General

(1) This task gives the procedure to remove the side-hinged main door guides.

B. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
811		Main door

C. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	No. 8 screwdriver bits for torq-set screws	To remove the screws	

D. Auxiliary Items

Not Applicable

E. Consumable Materials

Not Applicable

F. Expandable Parts

Not Applicable

G. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	At the main door frames

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

SUBTASK 020-002-A

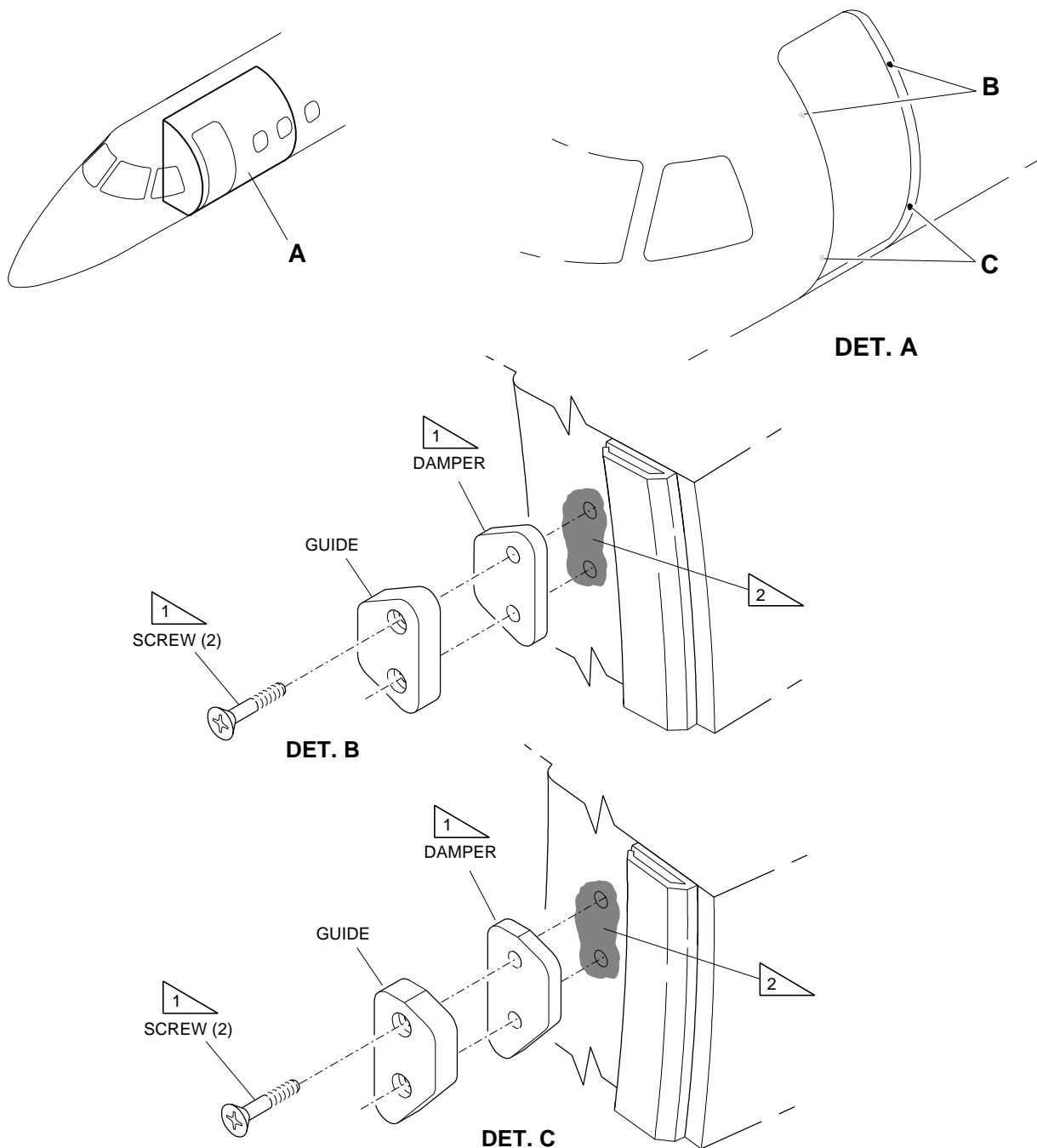
(1) Remove the screws from the side-hinged main door guide. Refer to [Figure 401](#).

(2) Remove the side-hinged main door guide and the damper.

EFFECTIVITY: AIRCRAFT WITH SIDE-HINGED MAIN DOOR

Side-hinged Main Door Guides - Removal/Installation

Figure 401



1 APPLY COR-BAN 27L TO THE SCREWS AND AT THE INTERFACE BETWEEN THE DOOR FRAME AND THE DAMPER.

2 FOR AIRCRAFT POST-MOD SB145-53-0040 OR SB145-53-0088 APPLY ALODINE 1200S AND EPOXY PRIMER.

EM145AMM530291D.DGN

TASK 53-21-06-400-801-A

EFFECTIVITY: AIRCRAFT WITH SIDE-HINGED MAIN DOOR

3. SIDE-HINGED MAIN DOOR GUIDES - INSTALLATION

A. General

(1) This task gives the procedure to install the side-hinged main door guides.

B. References

REFERENCE	DESIGNATION
AMM SDS 52-18-00/1	
AMM TASK 52-18-00-820-801-A/500	MAIN-DOOR INTERNAL ACTUATING HANDLE - TEST
AMM TASK 52-18-00-820-803-A/500	MAIN-DOOR LOCKING-MECHANISM CAMS - TEST
S.B.145-53-0040	-
S.B.145-53-0088	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
811		Main door

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	No. 8 screwdriver bits for torq-set screws	To install the screws	

E. Auxiliary Items

Not Applicable

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
MEP 09-075	Corrosion Inhibiting Compound (COR-BAN 27L)	AR
MIL-C-5541	Alodine 1200S	AR
MEP 10-059	Epoxy Primer	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	At the main door frames

I. Installation (Figure 401)

SUBTASK 420-002-A

NOTE: Make sure that the door frame area where the door guide is installed does not show signs of corrosion. If it does, contact the EMBRAER Technical Support Department.

- (1) For aircraft POST-MOD. [S.B.145-53-0040](#) or [S.B.145-53-0088](#), perform a chemical conversion touch-up of all bare metal surface in the holes using Alodine 1200S (Spec MIL-C-5541) and then apply Epoxy primer (Spec. MEP10-059). Refer to (Figure 401).

WARNING: THE COR-BAN 27L 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.

- (2) Apply COR-BAN 27L at the interface between the door frame and the damper at the guide position.
- (3) Install the side-hinged main door guide with the screws soaked in COR-BAN 27L.

J. Follow-on

SUBTASK 842-002-A

- (1) Do a functional check of the side-hinged main door ([AMM TASK 52-18-00-820-801-A/500](#)).
- (2) If necessary, adjust the actuating and locking mechanism of the side-hinged main door ([AMM TASK 52-18-00-820-803-A/500](#)).
- (3) Close the side-hinged main door ([AMM SDS 52-18-00/1](#)).

