
HORIZONTAL STABILIZER TIPS - REMOVAL/INSTALLATION*EFFECTIVITY: ALL*1. General

- A. This section gives the procedures to remove and install the horizontal stabilizer tips.
- 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>
55-13-02-000-801-A	HORIZONTAL STABILIZER TIPS - REMOVAL	ALL
55-13-02-400-801-A	HORIZONTAL STABILIZER TIPS - INSTALLATION	ALL

TASK 55-13-02-000-801-A

EFFECTIVITY: ALL

2. HORIZONTAL STABILIZER TIPS - REMOVAL

A. General

(1) This procedure gives the instructions to remove the horizontal stabilizer tips.

B. References

REFERENCE	DESIGNATION
SRM 51-20-01-PR	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
331		LH Horizontal-Stabilizer Leading Edge
332		RH Horizontal-Stabilizer Leading Edge

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	
Commercially available	Torque wrench	To remove the screws	
Commercially available	Acrylic spatula	To remove sealant	

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
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

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Horizontal stabilizer tips

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

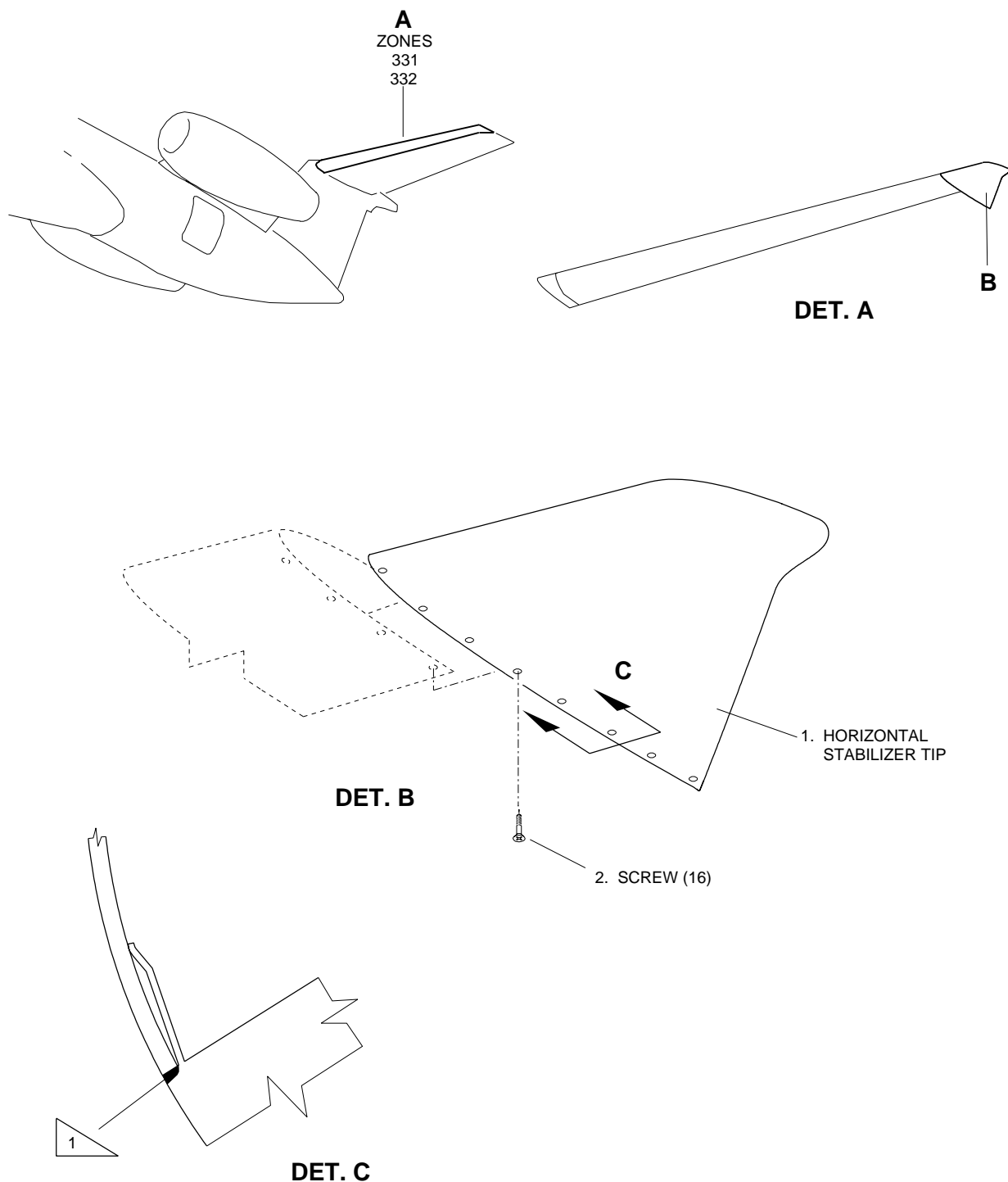
SUBTASK 020-002-A

- (1) Remove the screws (2) that attach the horizontal stabilizer tip (1) to its frame.
- (2) Remove the horizontal stabilizer tip (1).
- (3) With an acrylic spatula, remove the old aerodynamic sealant and prepare the surface (SRM 51-20-01-PR).

EFFECTIVITY: ALL

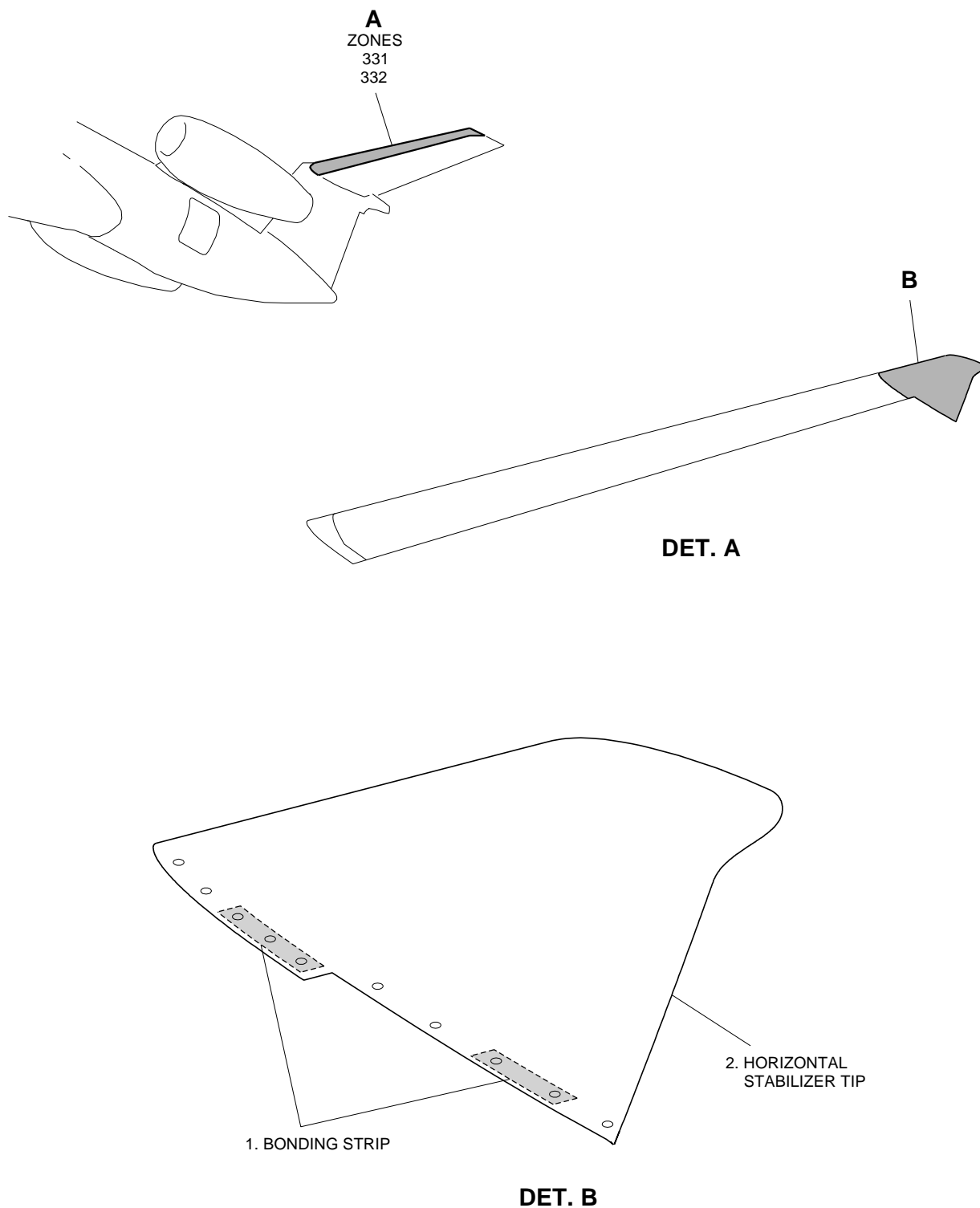
Horizontal Stabilizer Tips - Removal/Installation

Figure 401



145AMM550013.MCE C

EFFECTIVITY: ALL
Bonding Strip
Figure 402



EM145AMM550122B.DGN

TASK 55-13-02-400-801-A

EFFECTIVITY: ALL

3. HORIZONTAL STABILIZER TIPS - INSTALLATION

A. General

(1) This procedure gives the instructions to install the horizontal stabilizer tips.

B. References

REFERENCE	DESIGNATION
AMM MPP 20-10-01/200	- MAINTENANCE PRACTICES
AMM TASK 20-13-21-700-801-A/200	ELECTRICAL BONDING TEST - STANDARD PROCEDURES
SRM 51-20-01-PR	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
331		LH Horizontal-Stabilizer Leading Edge
332		RH Horizontal-Stabilizer Leading Edge

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	
Commercially available	Torque wrench	To tighten the screws	

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
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
MIL-PRF-81733 TYPE II - CLASS B	Sealant, PR-2050 B-1/2	AR
Commercially available	Adhesive Tape	AR
Commercially available	Aluminum Tape (AL Tape 425)	AR
Commercially available	Polyethylene Film	AR
ASTM-D-740	Methyl Ethyl Ketone - MEK	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Horizontal stabilizer tips

I. Installation (Figure 401)

SUBTASK 420-002-A

(1) Install the horizontal stabilizer tip (1).

(2) Install the screws (2) that attach the horizontal stabilizer tip (1) to the frame.

NOTE: For the torque, refer to [AMM MPP 20-10-01/200](#).

(3) There are different methods to do the aerodynamic sealing between the horizontal stabilizer tip (1) and the frame. Use the applicable procedure as necessary.

(a) Full sealant-curing time:

1 Apply sealant PR-2050 B-1/2.

NOTE: Sealant curing time will change with environment conditions. Refer to SRM 51-20-01-PR.

(b) Acceleration of sealant curing time with heating:

1 Apply sealant PR-2050 B-1/2.

2 Wait for one hour after the sealant is applied.

CAUTION: THE TEMPERATURE MUST NOT BE HIGHER THAN 55°C (131°F).

3 Heat the area which received the sealant.

NOTE: Sealant curing time will change with environment conditions. Refer to SRM 51-20-01-PR.

(c) Application of aluminum tape after the tack-free time.

NOTE: This procedure must only be done when a faster aircraft clearance is necessary.

1 Apply sealant PR-2050 B-1/2.

2 You can accelerate the sealant curing time as given in paragraph (b).

3 When sealant is tack-free, apply aluminum tape.

NOTE: You can operate the aircraft immediately after the aluminum tape application.

4 Remove the aluminum tape after 150 hours.

(d) Application of polyethylene film and aluminum tape.

- 1 Apply sealant PR-2050 B-1/2.
- 2 Apply a polyethylene film on the sealant.
- 3 Apply the aluminum tape.

NOTE: You can operate the aircraft immediately after the aluminum tape application.

- 4 Remove the aluminum tape after 10 days.

J. Follow-on (Figure 402)

SUBTASK 842-002-A

- (1) Do the electrical-bonding test procedure as given in [AMM TASK 20-13-21-700-801-A/200](#). Refer to (Figure 402) for bonding strip location.