



AIRCRAFT  
MAINTENANCE MANUAL

RUBBER TRIM SEAL FILLER STRIP - REPAIR

EFFECTIVITY: ALL

1. General

- A. This section gives the procedure to repair or replace the filler strip of the door rubber trim seal.
- 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
52-00-01-300-801-A	FILLER STRIP - REPAIR / REPLACEMENT	ALL



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TASK 52-00-01-300-801-A

EFFECTIVITY: ALL

2. FILLER STRIP - REPAIR / REPLACEMENT

A. General

- (1) This procedure gives the instructions to repair or replace the filler strip of the rubber trim seal of the main door and service door.

B. References

REFERENCE	DESIGNATION
AMM SDS 52-10-00/1	
AMM SDS 52-18-00/1	
AMM SDS 52-43-00/1	
AMM TASK 52-00-00-910-801-A/200	MAIN-DOOR - SUPPORTING
IPC 52-18-10	SIDE-HINGED MAIN DOOR
IPC 52-43-10	SERVICE DOOR INSTL
SRM 51-20-01-PR	-

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Plastic spatula	To remove the sealant from the rubber trim seal	

E. Auxiliary Items

Not Applicable

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
ASTM-D-740	Methyl Ethyl Ketone (MEK)	AR
TT-I-735	Isopropyl Alcohol	AR
MIL-F-38249, TYPE I	Sealant RTV-157	AR
Commercially available	Adhesive tape	AR
Commercially available	Detergent	AR

G. Expendable Parts

ITEM	IPC REFERENCE (VENDOR REFERENCE)	QTY
Rubber Trim Seal Angle - Main Door	IPC 52-18-10	AR



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(Continued)

ITEM	IPC REFERENCE (VENDOR REFERENCE)	QTY
Rubber Trim Seal Angle - Service Door	IPC 52-43-10	AR

## H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	At the door

## I. Preparation

### SUBTASK 841-002-A

- (1) Open the door ([AMM SDS 52-10-00/1](#), or [AMM SDS 52-18-00/1](#), or [AMM SDS 52-43-00/1](#), as applicable).
- (2) On aircraft with airstairs door installed, the door must be held and the mechanism must be in the closed position. For this, do as in [AMM TASK 52-00-00-910-801-A/200](#).

## J. Filler Strip - Repair / Replacement ([Figure 801](#)) ([Figure 802](#)) ([Figure 803](#))

### SUBTASK 350-002-A

**WARNING: USE SEALANT OR SOLVENT IN WELL VENTILATED AREAS. AVOID VAPOR INHALATION AND LONG SKIN CONTACT WITH THESE PRODUCTS.**

**CAUTION: DO NOT USE SHARP-EDGED TOOLS TO PREVENT DAMAGE TO THE RUBBER TRIM SEAL.**

- (1) Prepare the filler strip and the rubber trim seal as follows:

- (a) With Isopropyl Alcohol or Methyl Ethyl Ketone (MEK), clean the loose surface of the filler strip, or the new filler strip, and the rubber trim seal.

**NOTE:** Make sure that there is no remaining sealant.

Make sure that there is no damage in the rubber trim seal bonding area.

- (2) Bond the filler strip to the rubber trim seal as follows:

- (a) While you apply RTV157 sealant to the narrower side of the filler strip, which has interface with the rubber trim seal ( DET. A and DET. B in [Figure 801](#)), you must put the filler strip on the rubber trim seal.

- (b) Put tapes to keep the filler strips bonded to the rubber trim seal during the sealant curing time (DET. A and DET. B in [Figure 801](#)).

- (c) After the sealant is tack-free, remove the tapes.

**NOTE:** The sealant tack-free time changes with the environmental conditions.  
Refer to SRM 51-20-01-PR.

- (d) Apply a sealant fillet around the filler strip edge ([Figure 802](#), DET. B).

- (e) Apply sealant to each angle of the filler strip end ([Figure 802](#), DET. C).



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NOTE: For a better finish of the sealant, you can soak your fingers in a water-and-soap solution and pass them on the sealant that is applied.

- (f) Wait the sealant curing time.

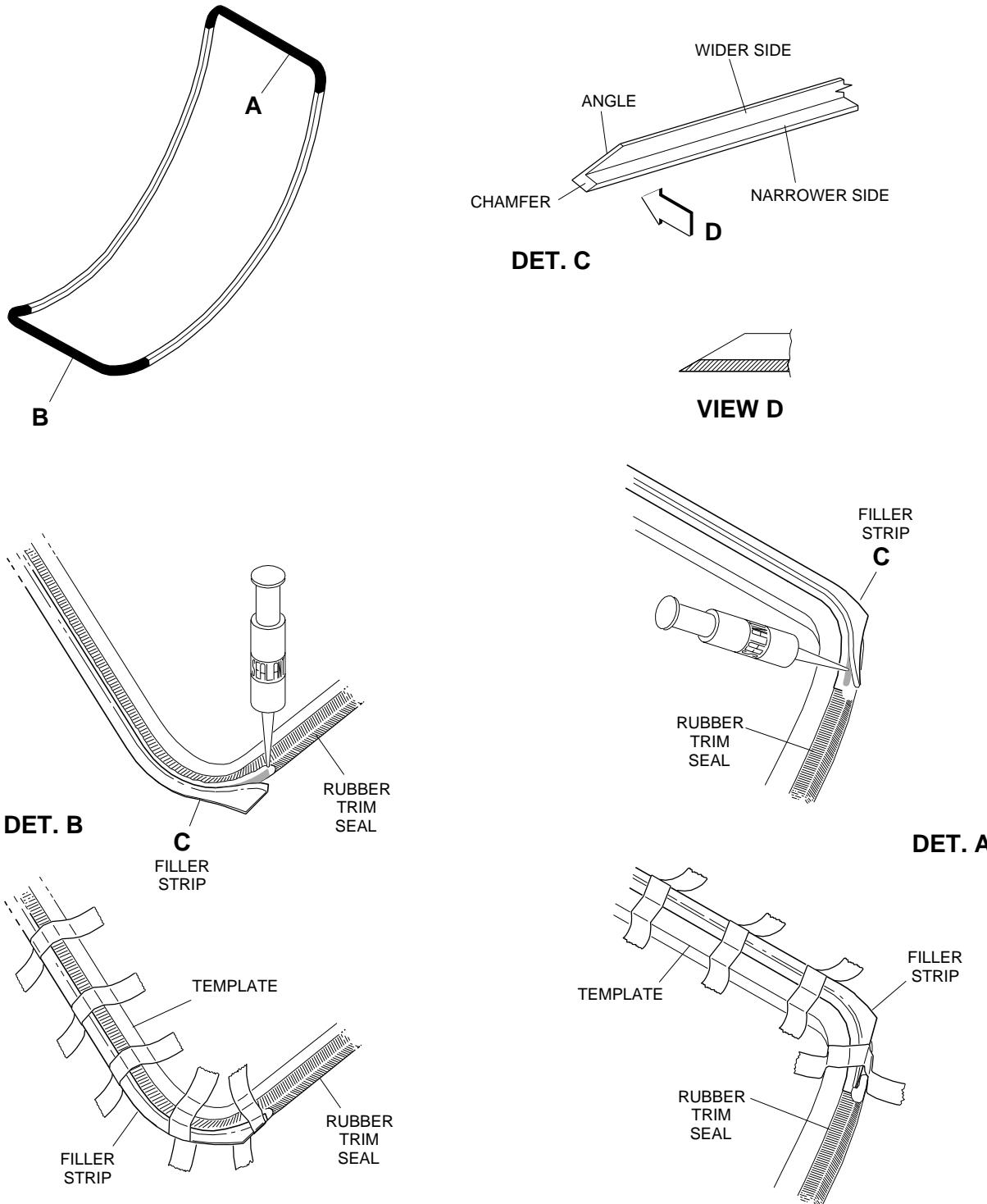
NOTE: The sealant curing time changes with the environmental conditions. Refer to SRM 51-20-01-PR.

K. Follow-on ([Figure 804](#))

SUBTASK 842-002-A

- (1) Make two 4-mm (5/32-in) dia. holes in the bottom of the rubber trim seal (SECTION C-C of [Figure 803](#) and [Figure 804](#)).
- (2) Close the door ([AMM SDS 52-10-00/1](#), or [AMM SDS 52-18-00/1](#), or [AMM SDS 52-43-00/1](#), as applicable).

**EFFECTIVITY: ALL**  
 Filler Strip - Repair / Replacement  
 Figure 801

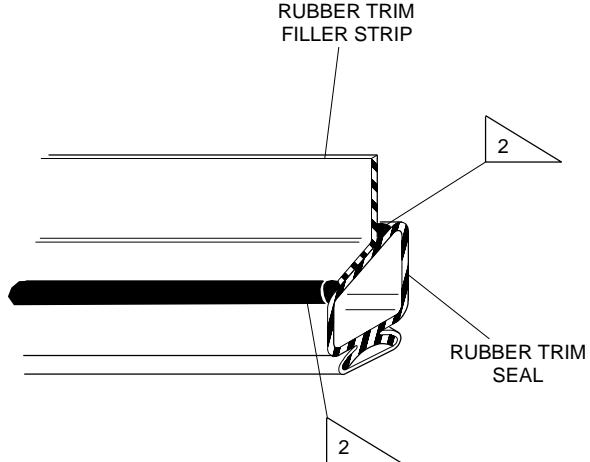
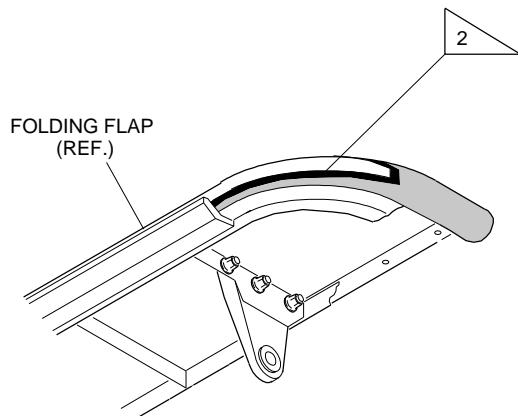
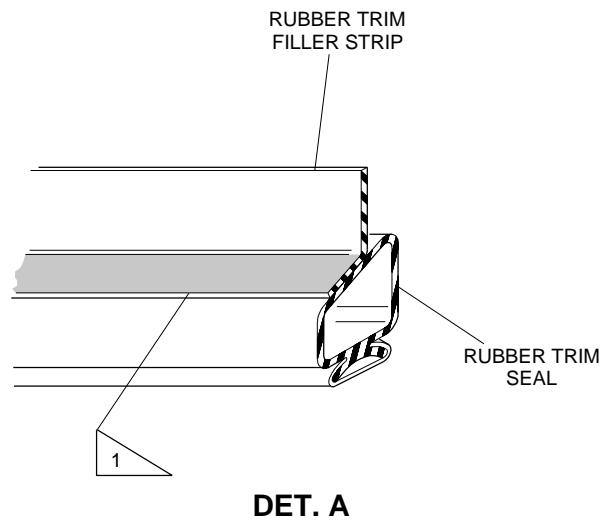


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**EFFECTIVITY: ALL**

Filler Strip - Repair / Replacement

Figure 802

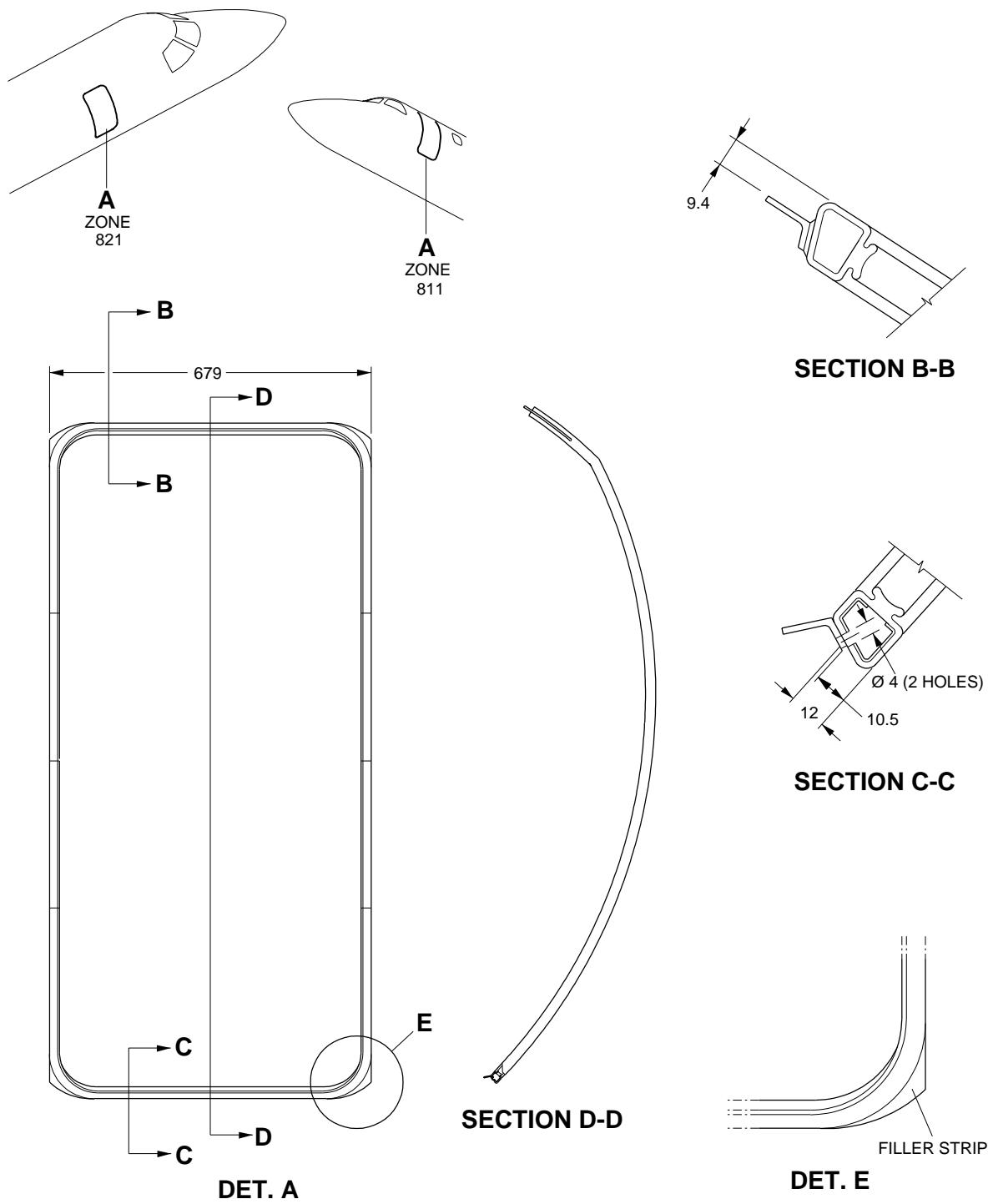


**1** APPLY RTV-157 AT  
INTERFACE RUBBER TRIM SEAL/  
RUBBER TRIM FILLER STRIP

**2** APPLY RTV-157 SEALANT FILLET

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**EFFECTIVITY: ALL**  
 Filler Strip - Repair / Replacement  
 Figure 803



DIMENSION IN mm

145AMM520390.MCE

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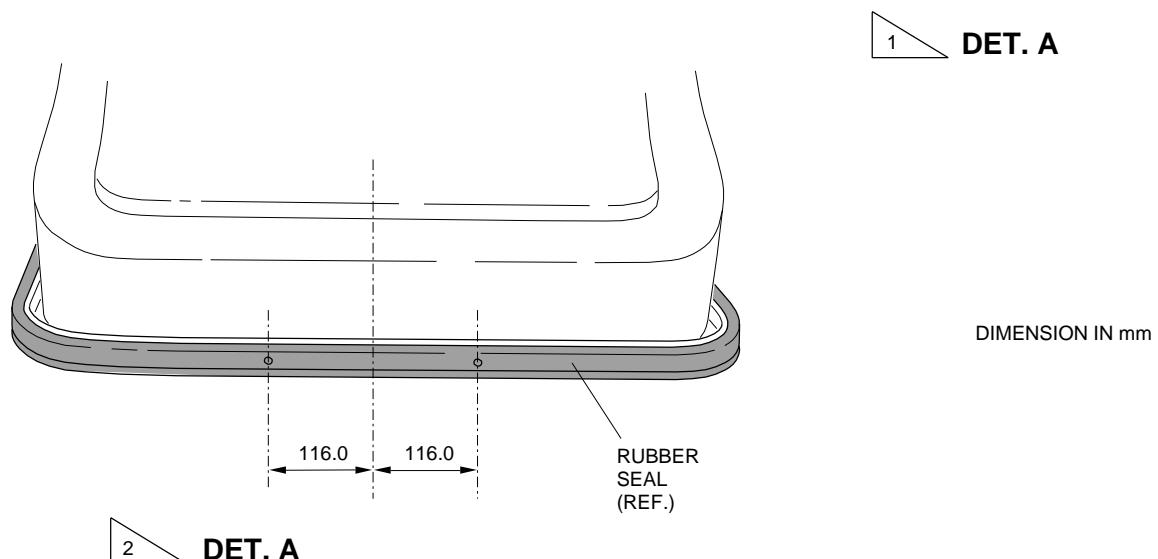
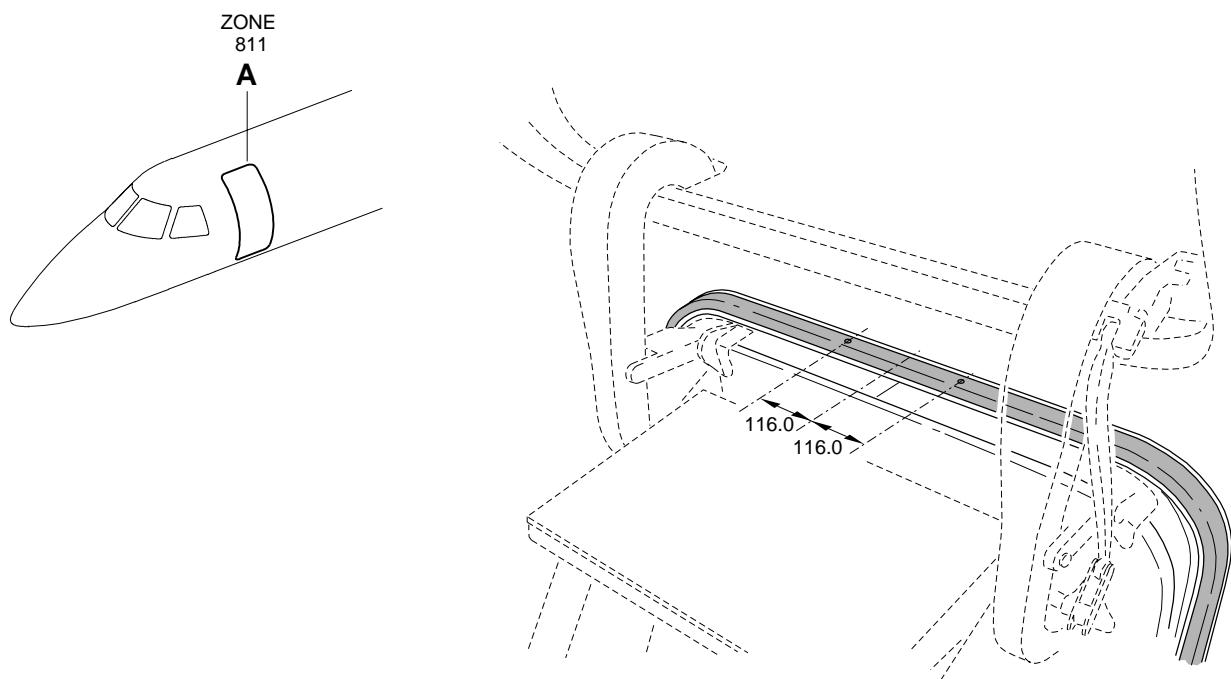
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**EFFECTIVITY: ALL**

Filler Strip - Repair / Replacement

Figure 804 - Sheet 1

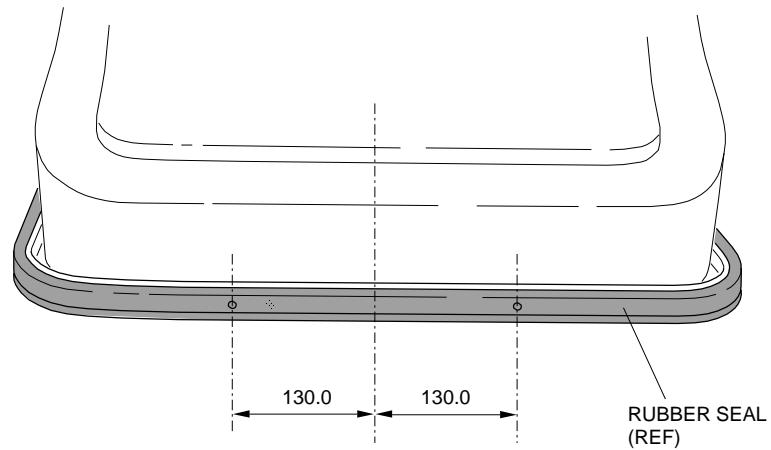
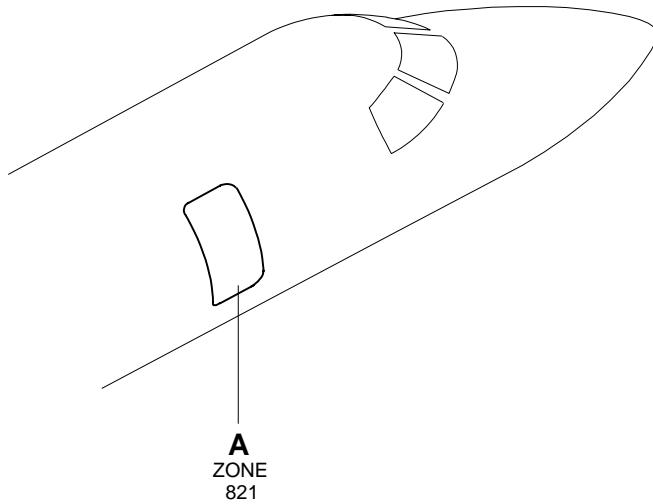


 1 APPLICABLE TO AIRSTAIRS DOOR.

 2 APPLICABLE TO SIDE-HINGED MAIN DOOR.

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EFFECTIVITY: ALL  
Filler Strip - Repair / Replacement  
Figure 804 - Sheet 2



DIMENSION IN mm

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