



AIRCRAFT  
MAINTENANCE MANUAL

SERVICE DOOR WINDOW - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the window of the service door.
- 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
52-43-08-000-801-A	SERVICE DOOR WINDOW - REMOVAL	ALL
52-43-08-400-801-A	SERVICE DOOR WINDOW - INSTALLA- TION	ALL



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TASK 52-43-08-000-801-A

EFFECTIVITY: ALL

2. SERVICE DOOR WINDOW - REMOVAL

A. General

- (1) This procedure gives the instructions to remove the window of the service door.

B. References

REFERENCE	DESIGNATION
AMM MPP 06-45-00/100	- COMPONENT LOCATION

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Work stand	To get access to the service door	

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	Service door
1	Helps the other technician	Service door

I. Preparation

*SUBTASK 841-002-A*

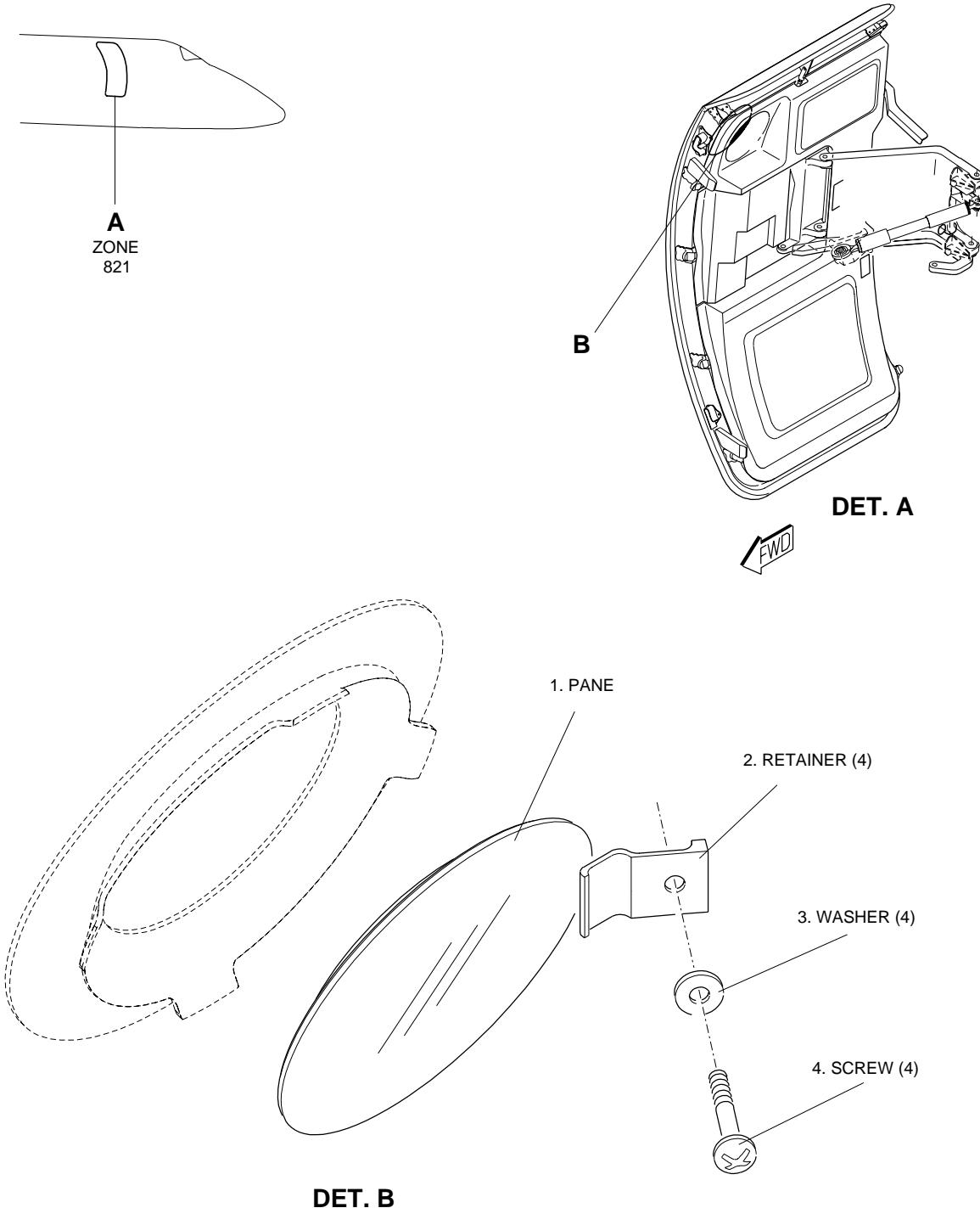
- (1) Open the service door.
- (2) Remove lining panels of the service door. Refer to [AMM MPP 06-45-00/100](#).

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

*SUBTASK 020-002-A*

- (1) Remove the screws (4) (4 positions) and washers (3) (4 positions).
- (2) Remove the retainer (2) (4 positions).
- (3) Remove the pane (1).

**EFFECTIVITY: ALL**  
 Window - Removal/Installation  
 Figure 401



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TASK 52-43-08-400-801-A

EFFECTIVITY: ALL

3. SERVICE DOOR WINDOW - INSTALLATION

A. General

- (1) This procedure gives the instructions to install the window of the service door.

B. References

REFERENCE	DESIGNATION
AMM MPP 06-45-00/100	- COMPONENT LOCATION
SRM 51-20-01	-

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the service door	

E. Auxiliary Items

Not Applicable

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
MIL-S-81733 Type II-2	Sealant P/S 870B-2	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Service door
1	Helps the other technician	Service door

I. Installation (Figure 401)

SUBTASK 420-002-A

- (1) Remove all the old aerodynamic sealant and prepare the surface (SRM 51-20-01). Use a plastic spatula for this.
- (2) Put the pane (1) in its frame in the door.
- (3) Install the screws (4) (4 positions), and washers (3) (4 positions) and put the retainer (2) (4 positions) in position to attach the pane (1).



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J. Follow-on

SUBTASK 842-002-A

- (1) Apply new aerodynamic sealant (SRM 51-20-01).
- (2) Install the lining panels of the service door ([AMM MPP 06-45-00/100](#)).
- (3) Close the service door.

