

## TAIL CONE - REMOVAL/INSTALLATION

*EFFECTIVITY: ALL*

1. General

- A. This section gives the procedures to remove and install the tail cone.
- 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 |
|--------------------|--------------------------|-------------|
| 53-32-00-000-801-A | TAIL CONE - REMOVAL      | ALL         |
| 53-32-00-400-801-A | TAIL CONE - INSTALLATION | ALL         |

TASK 53-32-00-000-801-A

EFFECTIVITY: ALL

## 2. TAIL CONE - REMOVAL

### A. General

(1) This task gives the instructions to remove the tail cone.

### B. References

| REFERENCE                                       | DESIGNATION  |
|---|--|
| AMM MPP 06-42-00/100                            | -  |
| <a href="#">AMM TASK 49-11-00-000-801-A/400</a> | APU COWLING - REMOVAL  |
| <a href="#">AMM TASK 49-15-00-000-801-A/400</a> | APU COWLING - REMOVAL  |
| <a href="#">AMM TASK 53-32-10-200-801-A/600</a> | PERMITTED LIMITS FOR DAMAGE TO RESONATOR<br>- INSPECTION/CHECK |
| SRM 53-32-22/01                                 | -  |

### C. Zones and Accesses

| ZONE | PANEL/DOOR | LOCATION  |
|------|------------|---|
| 313  |            | Tail cone fairing                                   |
| 312  | Door 312AR | Structural area aft of rear pressure bulk-head - RH |

### D. Tools and Equipment

| ITEM                   | DESCRIPTION | PURPOSE                        | QTY |
|------------------------|-------------|--------------------------------|-----|
| Commercially available | Workstand   | To get access to the work area |     |

### 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              | Tail cone fairing |
| 1   | Helps the other technician | Tail cone fairing |

I. Preparation

*SUBTASK 841-002-A*

- (1) On the Overhead Circuit Breaker Panel, open the Rudder 1 circuit breaker (Location tip: essential dc bus 2/rudder 1) and Rudder 2 circuit breaker (Location tip: essential dc bus 1/rudder 2) and attach a DO-NOT-CLOSE tag to them.
- (2) Make sure that the GPU pushbutton, on the electrical panel installed on the overhead panel, is set at OFF. Attach a DO-NOT-SET-TO-ON tag to it.
- (3) Make sure that the BATT 1 and BATT 2 switches, on the electrical panel installed on the overhead panel, are set at OFF. Attach DO-NOT-SET-TO-ON tags to them.
- (4) Set the BACKUP pushbutton, on the electrical panel installed on the overhead panel, to OFF. Make sure that the striped bar on the pushbutton comes on.
- (5) Attach a DO-NOT-SET-TO-AUTO tag to the BACKUP pushbutton.
- (6) Put the workstand in the work area.
- (7) Open access door 312AR (AMM MPP 06-42-00/100).
- (8) Manually move the rudder fully to the right side.

J. Removal ([Figure 401](#)) ([Figure 402](#)) ([Figure 403](#)) ([Figure 404](#))

*SUBTASK 000-002-A*

- (1) Hold up the tail cone and remove the screws (2).

**CAUTION:** BE CAREFUL WHEN YOU REMOVE THE TAIL CONE TO PREVENT DAMAGE TO THE RUDDER.

- (2) Remove the tail cone (3).

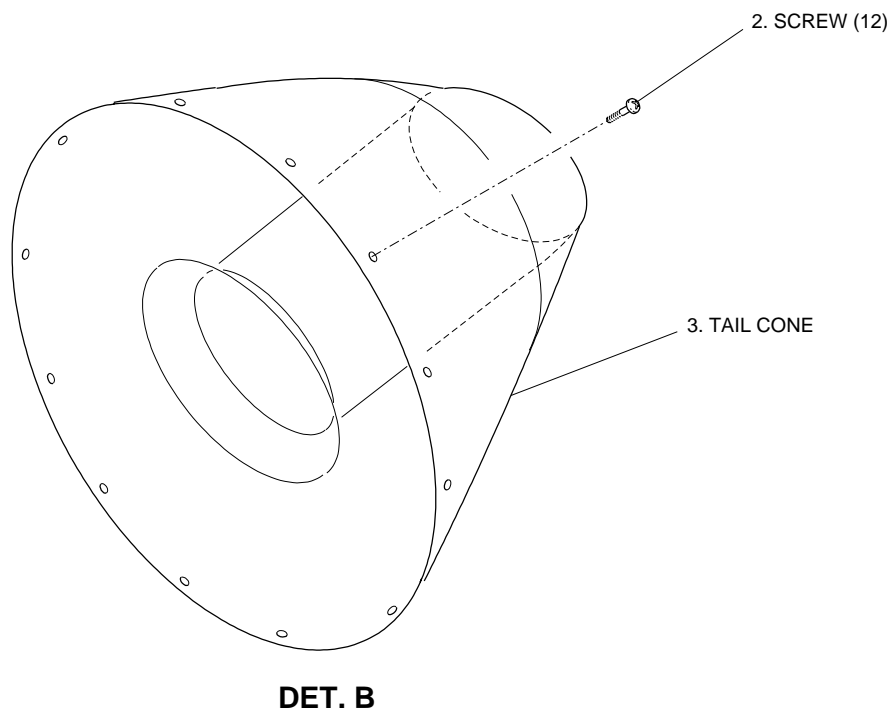
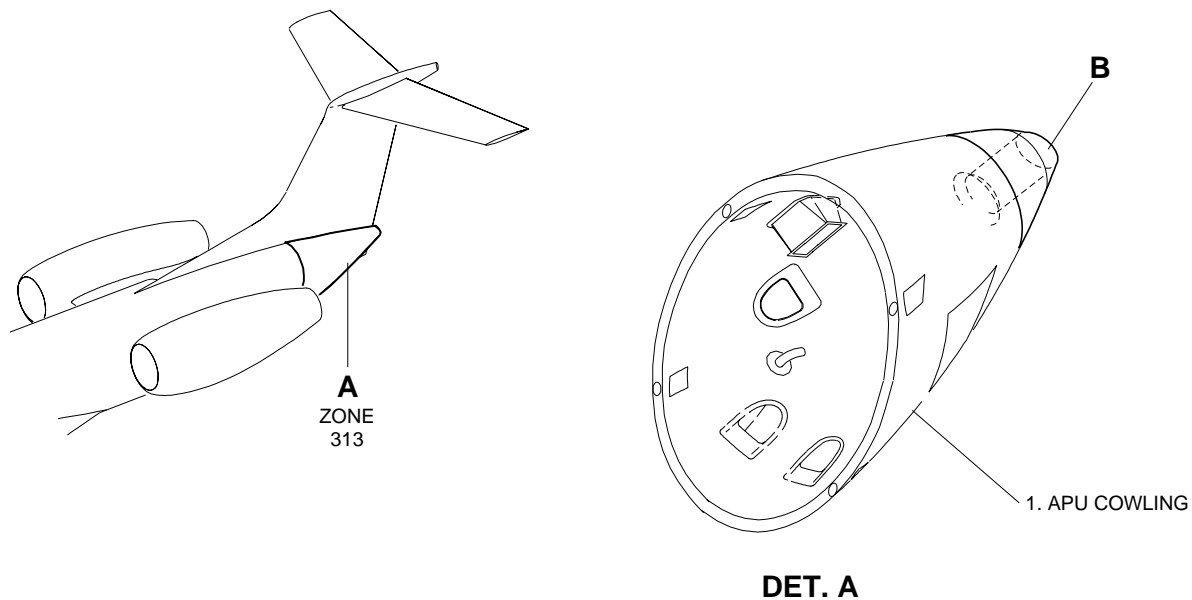
**NOTE:** The rudder must be out of its neutral position.

- (3) For aircraft with APU Exhaust Silencer, make a detailed inspection on the resonator for damage ([AMM TASK 53-32-10-200-801-A/600](#)).
- (4) For aircraft with APU Exhaust Silencer, make an inspection on the silencer for damage. If there are signs of damage, refer to the SRM 53-32-22/01 to find specific information applicable to your case.
- (5) Remove the APU cowling (1) ( [AMM TASK 49-11-00-000-801-A/400](#) or [AMM TASK 49-15-00-000-801-A/400](#), as applicable), when it is necessary to install a new tail cone.

EFFECTIVITY: AIRCRAFT WITH APU T-62T-40C11 WITHOUT EXHAUST SILENCER

Tail Cone - Removal/Installation

Figure 401

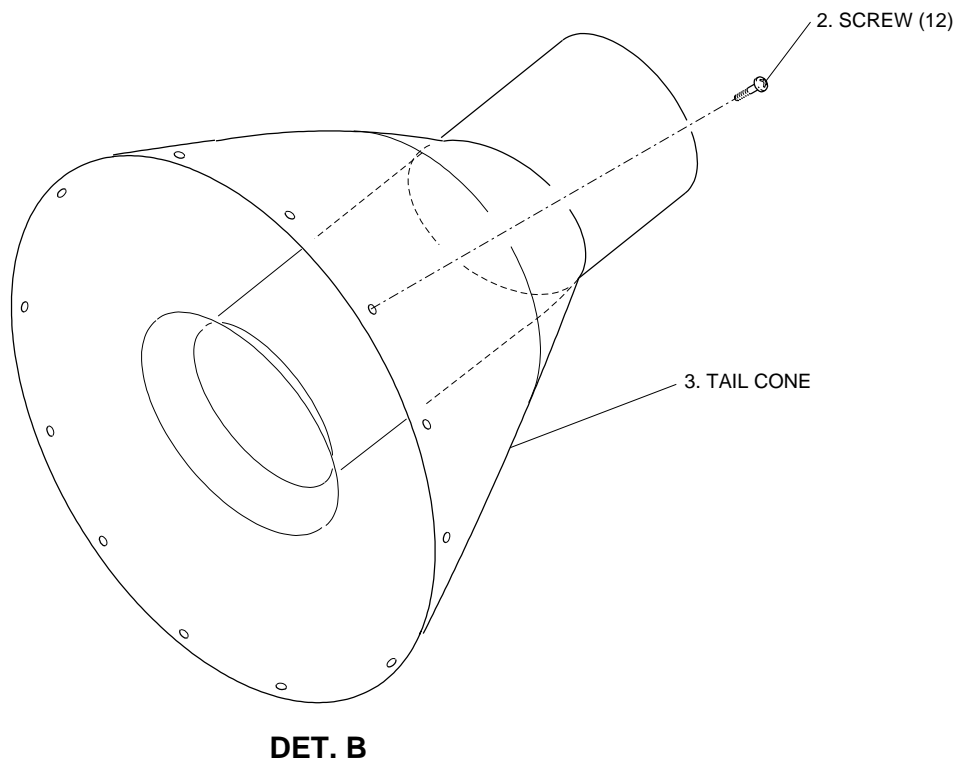
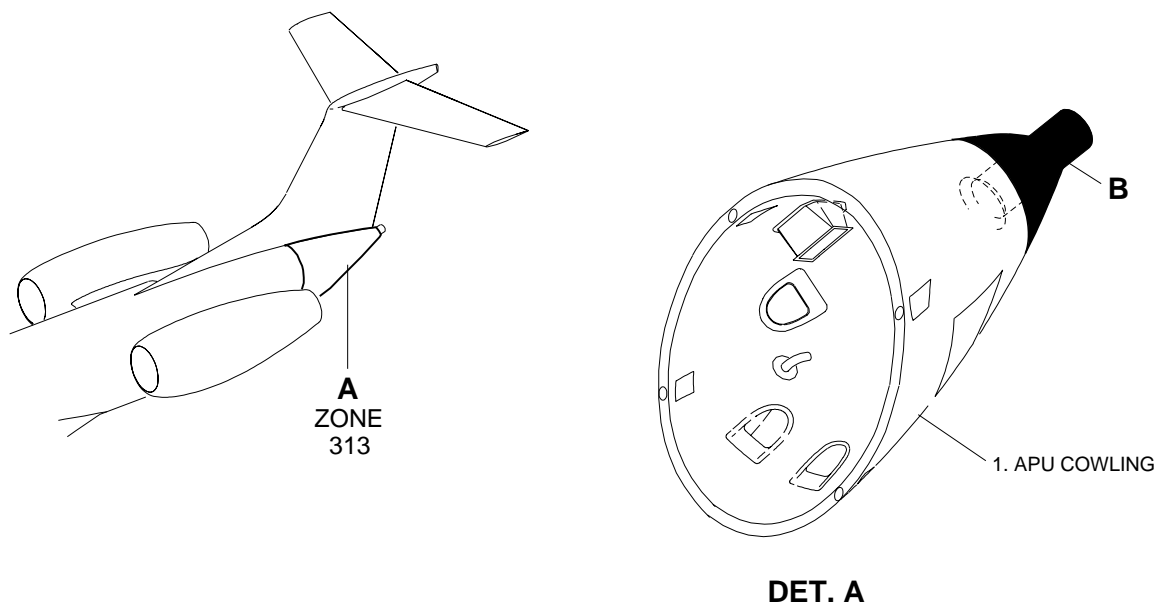


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EFFECTIVITY: AIRCRAFT WITH APU EXHAUST SILENCER

Tail Cone - Removal/Installation

Figure 402

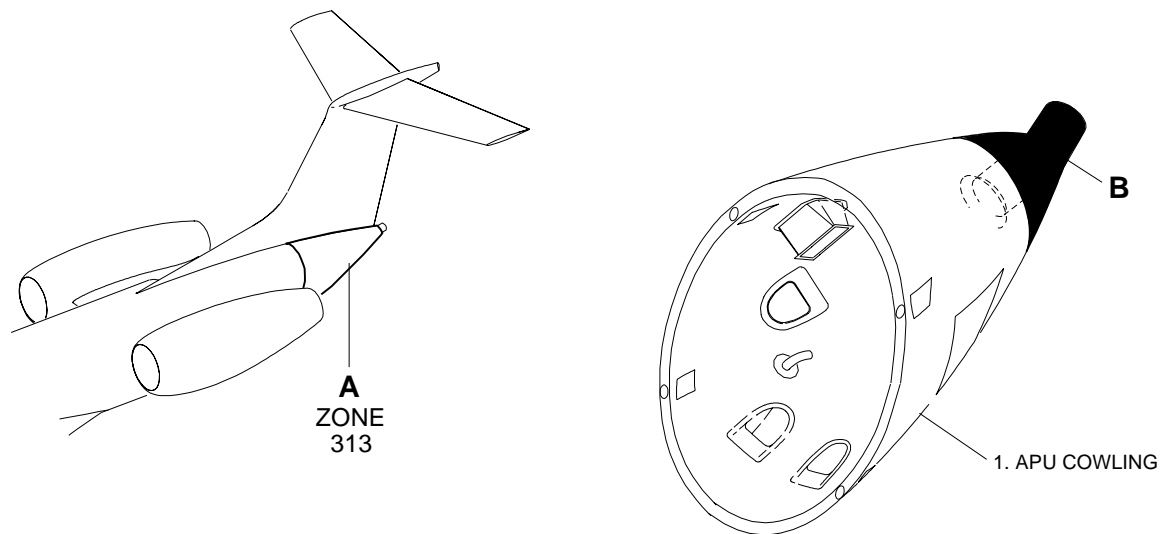


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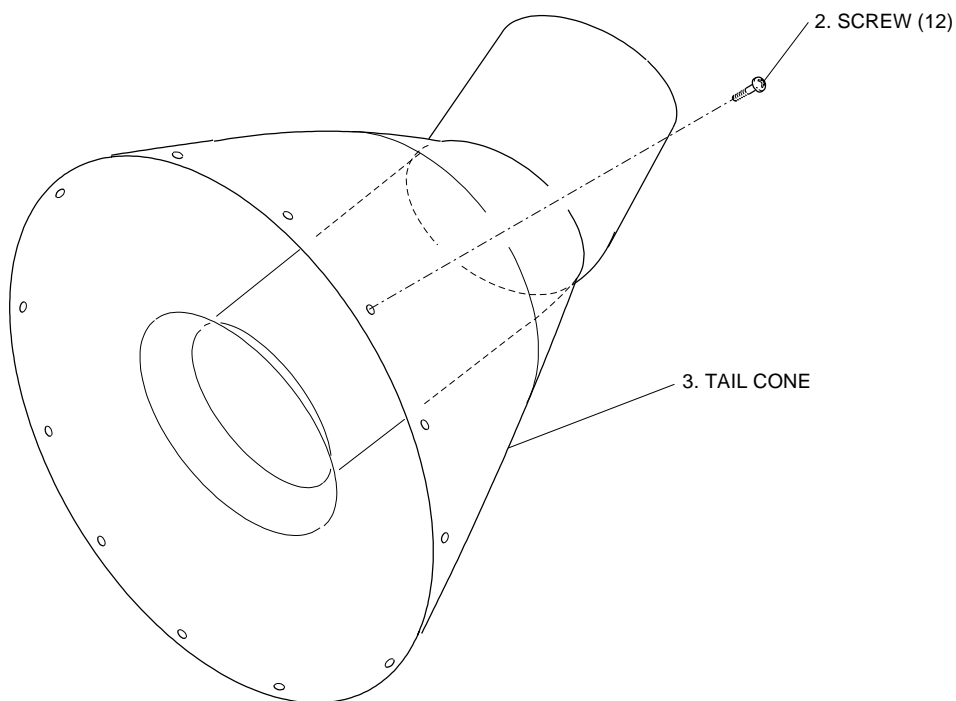
EFFECTIVITY: AIRCRAFT WITH APU T-62T-40C14 WITHOUT EXHAUST SILENCER

Tail Cone - Removal/Installation

Figure 403



DET. A



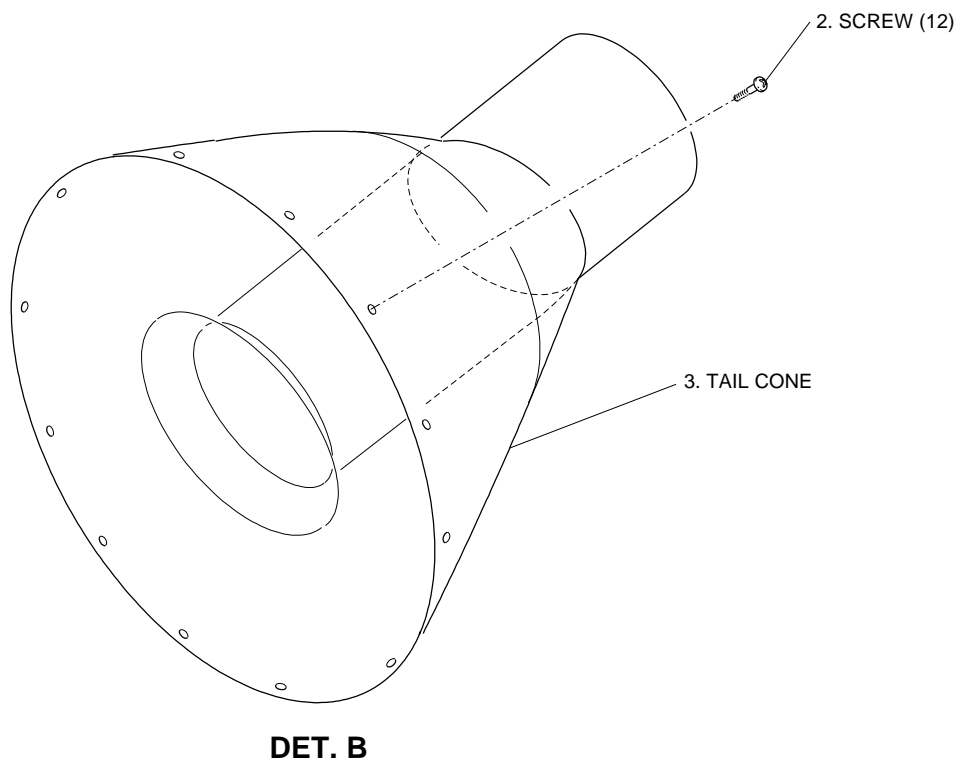
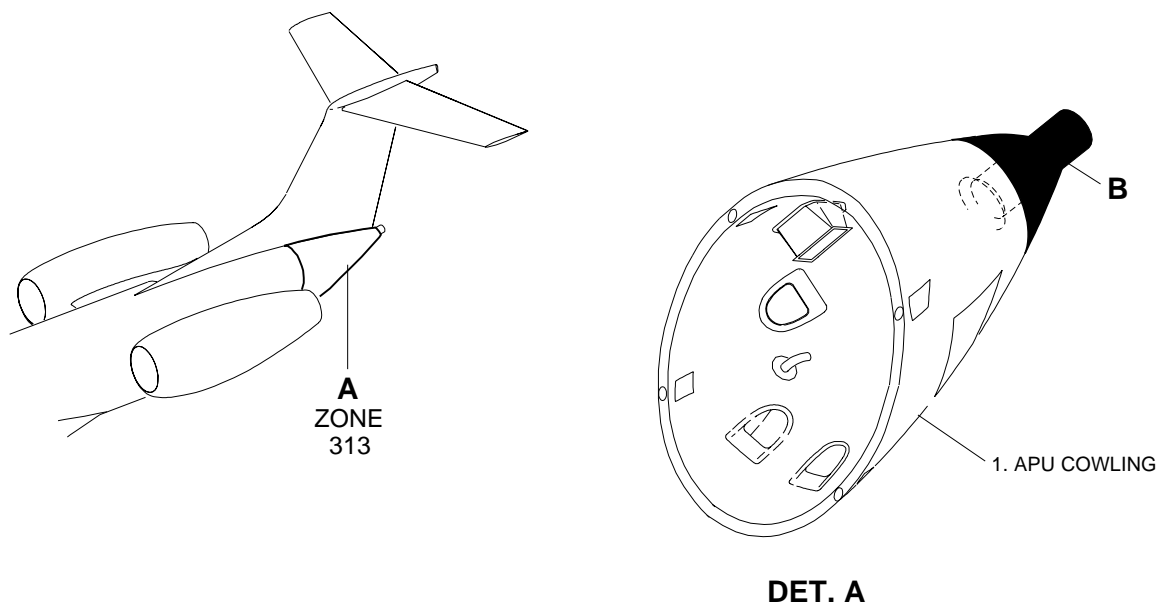
DET. B

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EFFECTIVITY: AIRCRAFT WITH APU T-62T-40C14 WITHOUT EXHAUST SILENCER

Tail Cone - Removal/Installation

Figure 404



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TASK 53-32-00-400-801-A

EFFECTIVITY: ALL

### 3. TAIL CONE - INSTALLATION

#### A. General

(1) This task gives the instructions to install the tail cone.

#### B. References

| REFERENCE                                       | DESIGNATION                |
|---|----------------------------|
| AMM MPP 06-42-00/100                            | -                          |
| <a href="#">AMM TASK 49-11-00-400-801-A/400</a> | APU COWLING - INSTALLATION |
| <a href="#">AMM TASK 49-15-00-400-801-A/400</a> | APU COWLING - INSTALLATION |
| SRM 51-40-00                                    | -                          |

#### C. Zones and Accesses

| ZONE | PANEL/DOOR | LOCATION  |
|------|------------|---|
| 313  |            | Tail cone fairing                                   |
| 312  | Door 312AR | Structural area aft of rear pressure bulk-head - RH |

#### D. Tools and Equipment

| ITEM                   | DESCRIPTION | PURPOSE                        | QTY |
|------------------------|-------------|--------------------------------|-----|
| Commercially available | Workstand   | To get access to the work area |     |

#### 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              | Tail cone fairing |
| 1   | Helps the other technician | Tail cone fairing |

#### I. Installation (Figure 401) (Figure 402) (Figure 403) (Figure 404)

##### SUBTASK 400-002-A

(1) Do steps (a) through (n) when the installation of the new tail cone is necessary:

(a) Put the APU cowling on the workbench.



- (b) Remove the rivets that attach the nut plates (SRM 51-40-00).
- (c) Remove the nut plates that attach the tail cone to the APU cowling.
- (d) Connect the new tail cone to the APU cowling.
- (e) Transfer the hole from the APU cowling to the tail cone.
- (f) Drill 3/16 in.-diameter holes in the tail cone.
- (g) Remove the burrs.
- (h) Alodize the reworked areas and apply epoxy primer. Refer to Corrosion Prevention Manual - Chapter 51.
- (i) Install rig pins to the holes.

**CAUTION:** THE ASSEMBLY TOLERANCE BETWEEN THE TAIL CONE AND THE APU COWLING IS  $1.0 \pm 0.8$  MM ON THE CONTOUR.

- (j) Mark the contour of the new tail cone to get the adjustment.
  - (k) Cut the excess material with snips and make sure that the adjustment is correct.
  - (l) If necessary, do steps (j) through (l) again to get the assembly tolerance.
  - (m) Remove the rig pins.
  - (n) Install the APU cowling (1) ( [AMM TASK 49-11-00-400-801-A/400](#) or [AMM TASK 49-15-00-400-801-A/400](#), as applicable).
- (2) Install the tail cone (3).
  - (3) Install the screws (2).

J. Follow-on

**SUBTASK 842-002-A**

- (1) Close access door 312AR (AMM MPP 06-42-00/100).
- (2) On the Overhead Circuit Breaker Panel, close the Rudder 1 circuit breaker (Location tip: essential dc bus 2/rudder 1) and Rudder 2 circuit breaker (Location tip: essential dc bus 1/rudder 2) and remove the DO-NOT-CLOSE tag from them.
- (3) Set the BACKUP pushbutton, on the electrical panel, on the overhead panel, to AUTO. Remove the DO-NOT-SET-TO-AUTO tag from the BACKUP pushbutton.
- (4) Remove the DO-NOT-SET-TO-AUTO tags from the BATT 1 AND BATT 2 switches.
- (5) Remove the DO-NOT-SET-TO-ON tag from the GPU pushbutton.

