

BAGGAGE COMPARTMENT LINING - REPAIR

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to repair the baggage compartment lining.
- B. If a tear, a hole or other type of damage to the lining occurs, it must be repaired to agree with the safety condition of the flame resistance test.
- C. There are two different materials of baggage compartment linings: the Fiberglass/Phenolic Resin liner and the Fiberglass/Epoxy Resin liner. Refer to table 801 to identify them.

Table 801 - FIBERGLASS/PHENOLIC RESIN LINING X FIBERGLASS/EPOXY RESIN LINING

MATERIAL OF BAGGAGE COMPARTMENT LINING	NON-DECOR SURFACE COLOR
Fiberglass/Phenolic Resin	yellow to brown
Fiberglass/Epoxy Resin	off-white

- D. 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
25-51-01-300-801-A	BAGGAGE COMPARTMENT LINING - PATCH REPAIR	ALL
25-51-01-300-802-A	BAGGAGE COMPARTMENT LINING - OLD LINER REPAIR	ALL
25-51-01-300-803-A	BAGGAGE COMPARTMENT LINING - WET LAY-UP REPAIR	ALL
25-51-01-300-804-A	BAGGAGE COMPARTMENT LINING - WET LAY-UP WITH DOUBLER PLATES AND REPAIR-TAPE REPAIR	ALL
25-51-01-300-805-A	BAGGAGE COMPARTMENT LINING - RE-INFORCEMENT	ALL

TASK 25-51-01-300-801-A

EFFECTIVITY: ALL

2. BAGGAGE COMPARTMENT LINING - PATCH REPAIR

A. General

- (1) This task gives the instructions to repair the baggage-compartment lining with patches.

NOTE: There are two approved patches for this repair: AKRO Fireguard Speed Patch, AF 800 Series, and Permaglass Cargo Lining Repair Patch, 100 Series.

- (2) For these patch repairs, no set-up or cure time is necessary. The aircraft can be put back into service immediately.
- (3) The patch repair method was tested and approved for use on the front side of the panel.
- (4) The minimum distance between two patch repairs must be 38 millimeters (1.5 inches).
- (5) The maximum repairable damage is limited by the combination of patch repair with the material of the baggage compartment lining where it will be applied. Refer to table 802 and [Figure 801](#), [Figure 802](#) and [Figure 803](#) for the maximum damage and types of damage that can be repaired in each case.

Table 802 - PATCH REPAIR X MAXIMUM DAMAGE AND TYPES OF DAMAGE

MATERIAL OF BAGGAGE COMPARTMENT LINING	PATCH REPAIR	QUANTITY OF PIECES	TYPE OF DAMAGE	MAXIMUM DAMAGE length x width mm (in)
Fiberglass/ Phenolic Resin	PERMALI	one	square-shaped and L-shaped tears	101 x 101 (4 x 4)
			U-shaped tear	101 x 101 (4 x 4)
Fiberglass/ Epoxy Resin	PERMALI	one	Any type of damage (hole in liner) ^[1]	127 x 127 (5 x 5)
Fiberglass/ Phenolic Resin or Ep- oxy Resin	AKRO AF 844	one		25 x 25 (1 x 1)
	AKRO AF 848			127 x 25 (5 x 1)
	AKRO AF 888			127 x 127 (5 x 5)
Fiberglass/ Phenolic Resin or Ep- oxy Resin	AKRO AF 844	two ^[2]		127 x 50 (5 x 2)
	AKRO AF 848			330 x 50 (13 x 2)
	AKRO AF 888			330 x 152 (13 x 6)

[1] Straight slits are not approved for repair with patches. Cut/Notch straight slits into "U" section.

[2] The minimum patch-to-patch overlap must be 25 millimeters (1.0 inch).

- NOTE:**
- For use of one piece of patch material, the minimum distance between the damage and the patch repairs must be 38 millimeters (1.5 inches).
 - For use of two pieces of patch material, the minimum distance between the damage and the patch repair must be 25 millimeters (1.0 inch).

- (6) If these requirements cannot be obeyed, the damaged baggage compartment lining must be replaced.
- (7) The baggage compartment lining that has other type of damage than that specified in table 802 (or with damage larger than the dimensions in table 802) must be replaced.

B. References

REFERENCE	DESIGNATION
AMM TASK 25-51-01-000-801-A/400	BAGGAGE COMPARTMENT LINING - REMOVAL
AMM TASK 25-51-01-200-801-A/600	BAGGAGE COMPARTMENT LINING - VISUAL INSPECTION
AMM TASK 25-51-01-400-801-A/400	BAGGAGE COMPARTMENT LINING - INSTALLATION

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Rubber gloves	Hand protection	1
Commercially available	Safety goggles	Eye protection	1
Commercially available	Spatula	To strip the tapestry	1
Commercially available	Sandpaper, 320-400 grit	To remove the paint	AR

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
Commercially available	Rhodiasolve E-23 - Commercial grade	AR
TT-I-735	Isopropyl Alcohol - Commercial grade	AR
O-E-760	Ethanol - Commercial grade	AR
Commercially available	AKRO Fireguard Speed Patch Repair, AF 800 Series (AF 844, AF 848 and AF 888)	AR
Commercially available	PERMALI Gloucester Permaglass Patch Repair, 100 Series	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Baggage compartment

I. Patch Repair ([Figure 801](#)) ([Figure 802](#)) ([Figure 803](#)) ([Figure 804](#))

SUBTASK 340-002-A

- (1) Do these steps for all types of baggage-compartment damaged lining.

NOTE: These steps are not applicable when the damage is a scratch.

- Remove the baggage-compartment damaged lining ([AMM TASK 25-51-01-000-801-A/400](#)).
- Make an inspection on the systems installed in the area that the removed baggage-compartment damaged lining covered ([AMM TASK 25-51-01-200-801-A/600](#)).

WARNING: WEAR GLOVES AND GOGGLES AND PREVENT CONTACT WITH SOLVENT VAPORS DURING THE CLEANING.

- (2) Clean the baggage compartment lining with Rhodiasolve E-23, ethanol or isopropyl alcohol to remove dirt, oil, and debris.
- (3) Mask off the surface to keep the original paint intact outside the patch repair and on the adjacent border.
- (4) With a 320-400 grit sanding paper, fully remove the paint, primer and filler from the area where you will install the patch repair.

- NOTE:**
- Remove a minimum of 38 millimeters (1.5 inches) of paint on the border adjacent to the damage where you will install the patch.
 - Be careful not to go through the first layer when you sand the area.
 - Make sure that all filler or primers are also removed and the bare glass surface is exposed.

- (5) Wipe the surface after you sand it, with a clean, shop wipe soaked in Rhodiasolve E-23, ethanol or isopropyl alcohol.

- NOTE:**
- Dry the surface with a clean dry shop wipe. Do not let the solvent evaporate from the part and make sure that there is no remaining contamination on it.
 - The part will be clean when you pass a clean, dry shop wipe on the surface and the shop wipe shows no indications of dirt, oil, or debris.
 - Do not touch the cleaned surfaces.

- (6) Find the patch that correctly agrees with the damage and periphery area (see table 802) ([Figure 801](#), [Figure 802](#) and [Figure 803](#)).

- NOTE:
- For repairs with one piece of patch, make sure that there is a border of liner material with 38 millimeters (1.5 inches) between the damage and the outer edge of the patch repair.
 - For repairs with two pieces of patches, make sure that there is a border of liner material with 25 millimeters (1.0 inch) between the damage and the outer edge of the patch repair.
 - Make sure that there is a minimum of 25 millimeters (1.0 inch) in overlapping patches.
 - These materials can be trimmed as necessary.
 - To mark the periphery of the damage, you can use a compass if you think it will make your job easier.

- (7) Remove the protective liner from one corner of the patch and bond it to the panel periphery ([Figure 804](#)).

- NOTE:
- Be careful not to contaminate the adhesive side of the patch.
 - Apply firm, positive pressure and smooth as necessary to prevent entrapped air.
 - Work the patch down over all the area.

- (8) Use a straightedge or rule to make sure that the edges of the patch are correctly bonded to the panel.

- NOTE:
- The patch is not correctly bonded if the scale or straightedge can be placed below the patch and between the patch and liner more than 1.6 millimeters (1/16th inch).
 - Push the edges down until the scale cannot slip between the liner and the patch.

- (9) If the adhesion is not sufficient, remove the patch and discard it.

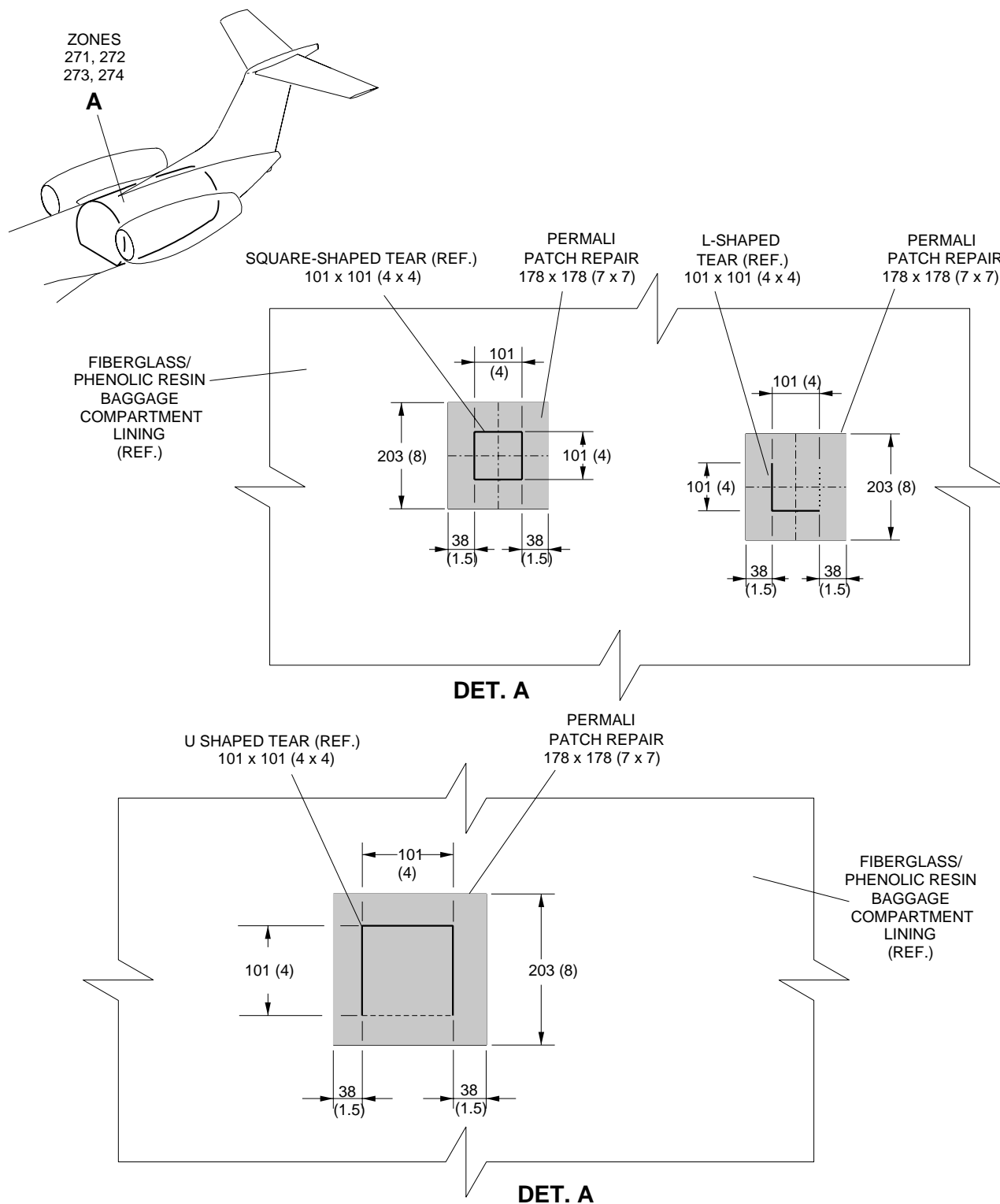
- NOTE:
- Clean the panel surface again, install a new patch, and do an inspection.
 - Obey these procedures to do the cleaning, the installation, and the inspection.

- (10) Install the baggage-compartment damaged lining back ([AMM TASK 25-51-01-400-801-A/400](#)).

EFFECTIVITY: ALL

Fiberglass/Phenolic Resin Baggage Compartment Lining - Permali Patch Repair Maximum Damage

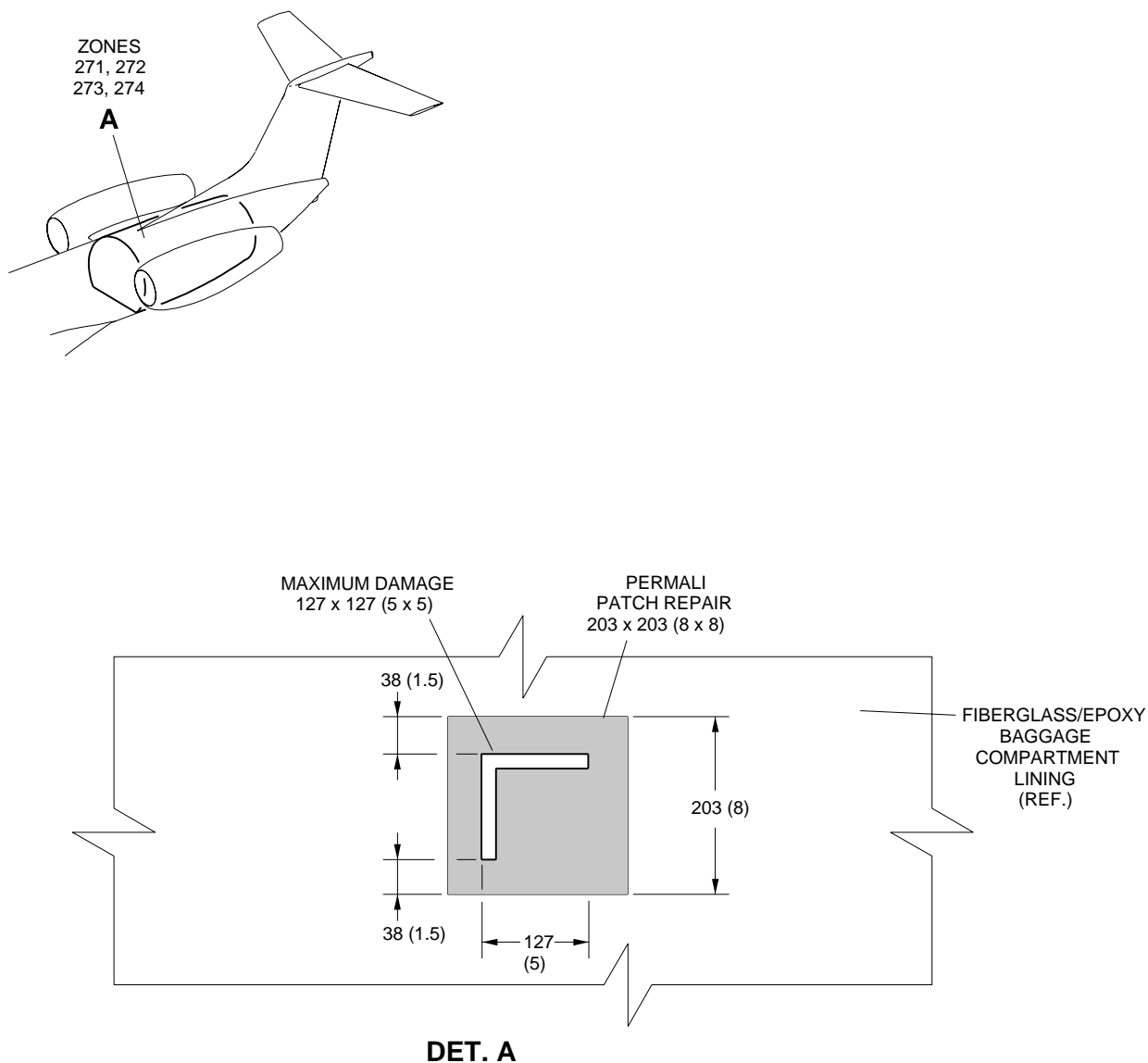
Figure 801



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EFFECTIVITY: ALL

Fiberglass/Epoxy Resin Baggage Compartment Lining - Permal Patch Repair Maximum Damage
Figure 802



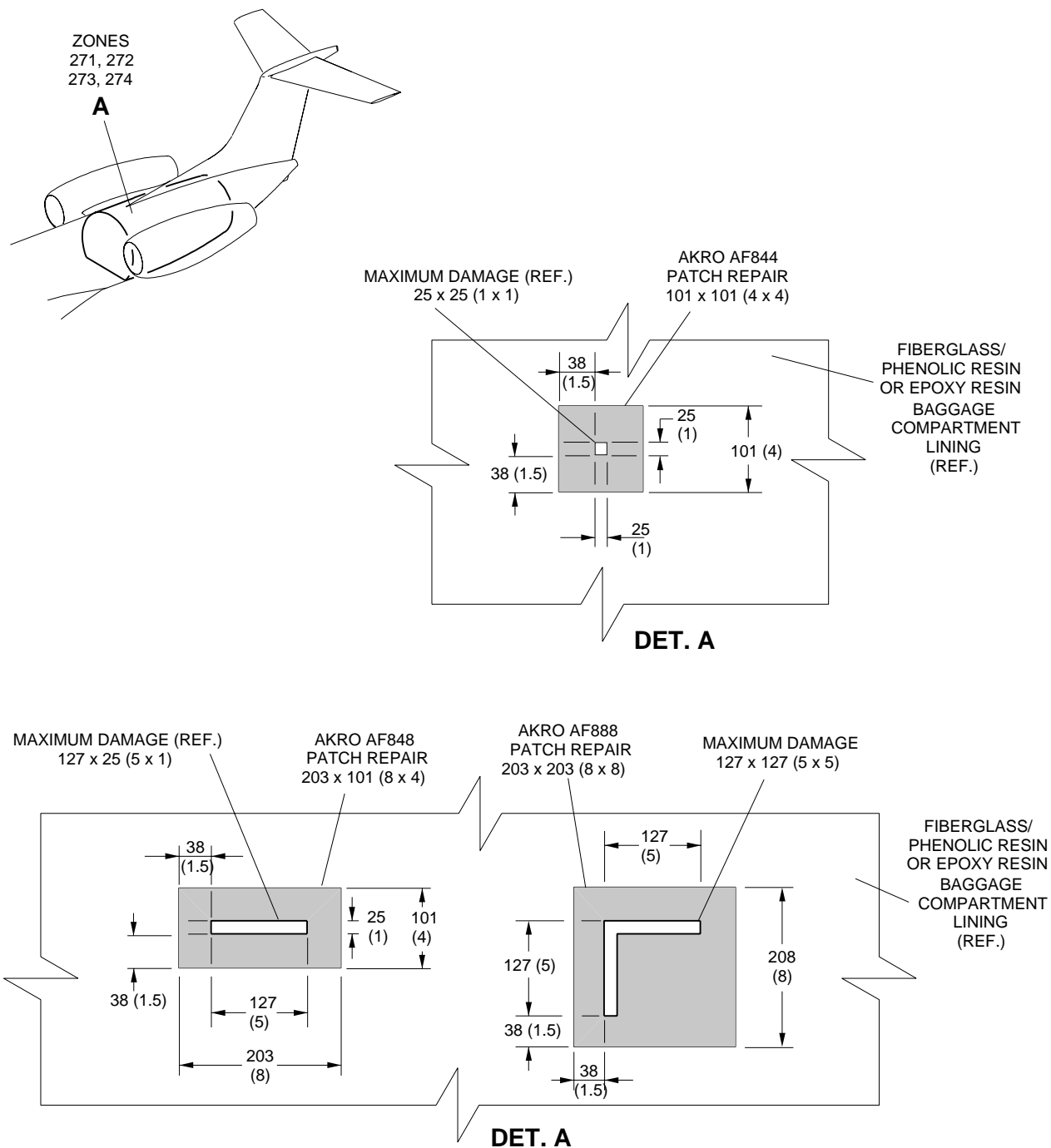
DIMENSIONS ARE IN MILLIMETERS WITH INCH
CONVERSIONS IN PARENTHESES.

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EFFECTIVITY: ALL

Fiberglass/Phenolic or Epoxy Baggage Compartment Lining - Akro Patch Repair Maximum Damage

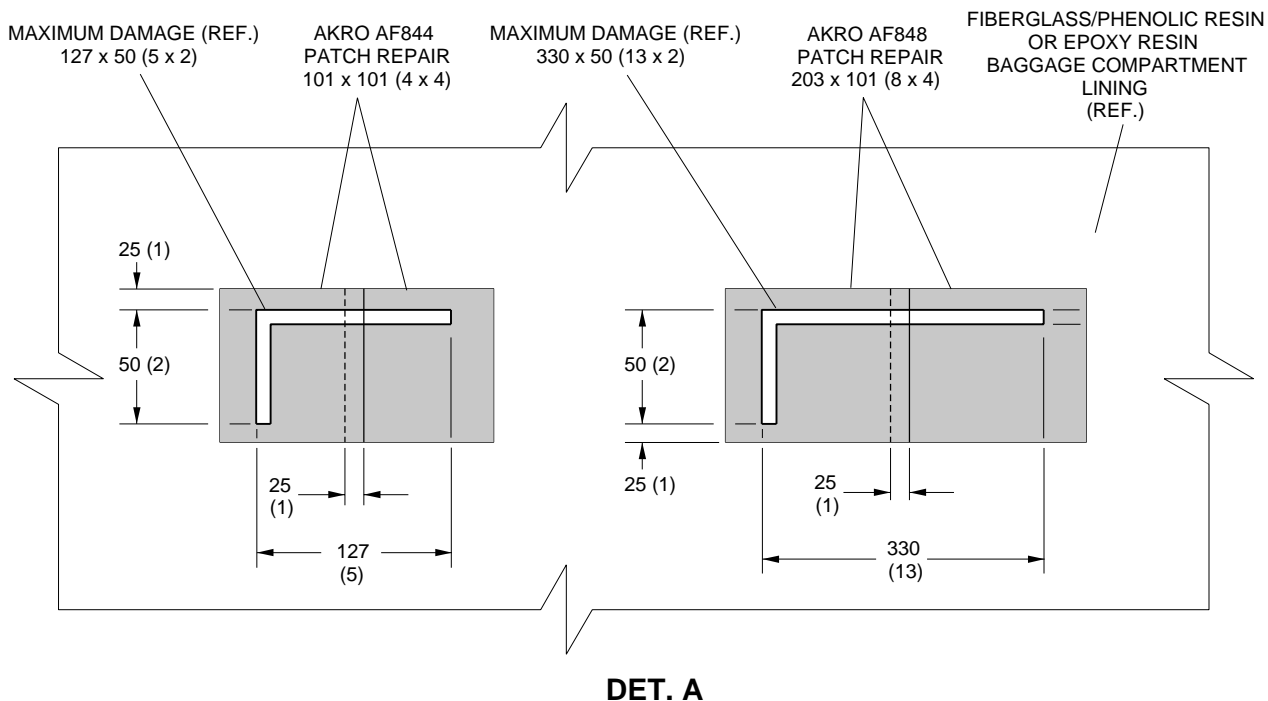
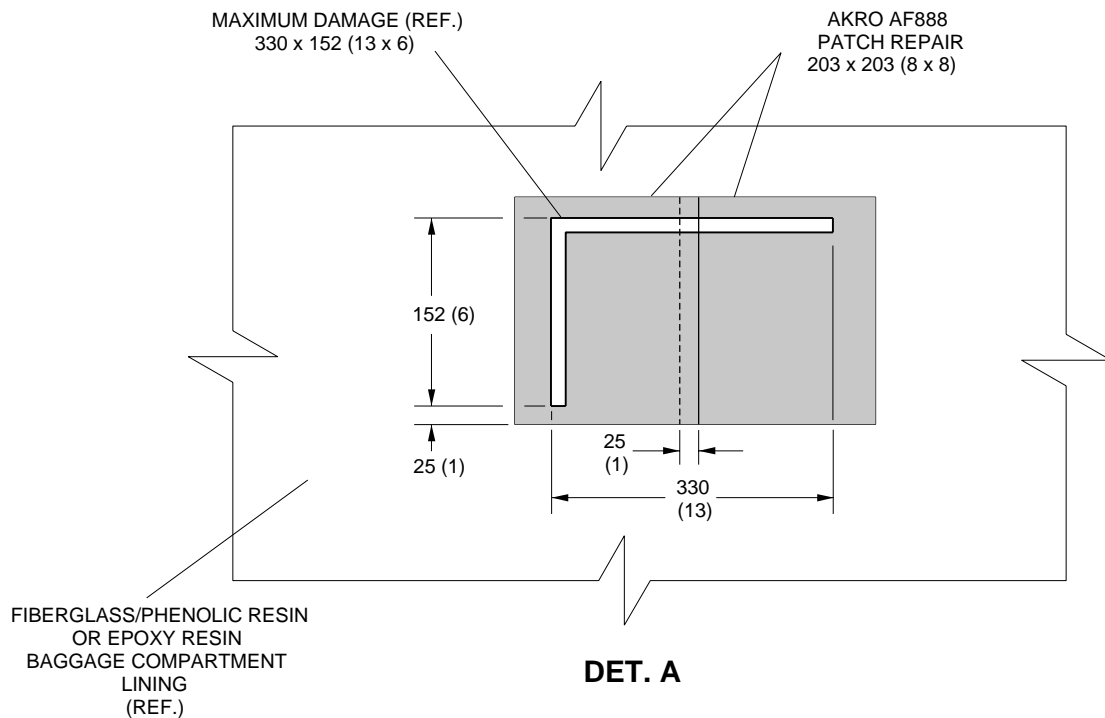
Figure 803 - Sheet 1



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EFFECTIVITY: ALL

Fiberglass/Phenolic or Epoxy Baggage Compartment Lining - Akro Patch Repair Maximum Damage
Figure 803 - Sheet 2

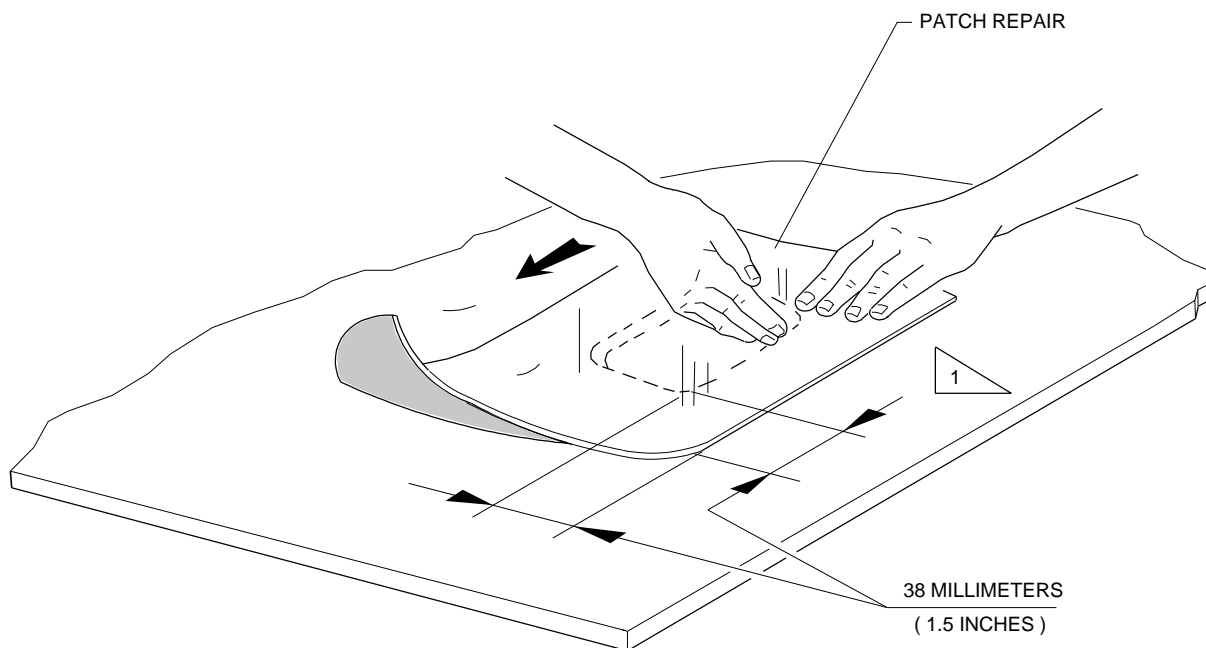


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EFFECTIVITY: ALL

Baggage Compartment Lining - Patch Repair Procedure

Figure 804



1 APPLY THE PATCH FIRMLY AND SMOOTH AS NECESSARY TO PREVENT ENTRAPPED AIR.

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TASK 25-51-01-300-802-A
EFFECTIVITY: ALL

3. BAGGAGE COMPARTMENT LINING - OLD LINER REPAIR

A. General

(1) This task gives the instructions to repair the baggage compartment lining with old liners.

B. References

REFERENCE	DESIGNATION
AMM TASK 25-51-01-000-801-A/400	BAGGAGE COMPARTMENT LINING - REMOVAL
AMM TASK 25-51-01-200-801-A/600	BAGGAGE COMPARTMENT LINING - VISUAL INSPECTION
AMM TASK 25-51-01-400-801-A/400	BAGGAGE COMPARTMENT LINING - INSTALLATION
IPC 25-51-01	BAGGAGE COMPARTMENT LINING

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
1	Rubber gloves	Chemical protection	
1	Safety goggles	Eye protection	

E. Auxiliary Items

Not Applicable

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
MIL-PRF-680	Cleaning Solvent	AR
Commercially available	Rhodiasolve E-23 - Commercial grade	AR
TT-I-735	Isopropyl Alcohol	AR
Commercially available	Foam seal (0.50 wdt X 0.06 thk) SNS512AF0625010 - Vendor: C&D	AR

G. Expendable Parts

ITEM	IPC REFERENCE (VENDOR REFERENCE)	QTY
Nutplate	IPC 25-51-01	AR
Screw	IPC 25-51-01	AR
Washer	IPC 25-51-01	AR

H. Persons Recommended

QTY	FUNCTION	PLACE
1	A - Does the task	Baggage compartment
1	B - Helps technician A	Baggage compartment

I. Old Liner Repair ([Figure 805](#))

SUBTASK 340-003-A

WARNING: THE BAGGAGE COMPARTMENT LININGS ARE FRAGILE , LARGE AND DIFFICULT TO MOVE. ASK FOR HELP TO MOVE THE LINERS AND BE CAREFUL TO PREVENT INJURY TO PERSONS AND DAMAGE TO THE PARTS.

- (1) Remove the baggage-compartment lining ([AMM TASK 25-51-01-000-801-A/400](#)).

NOTE: To agree with the safety condition of the flame resistance test, you must use the expendable parts listed in item G. to repair the baggage compartment linings.

- (2) Make an inspection on the systems installed in the area that the removed baggage-compartment damaged lining covered ([AMM TASK 25-51-01-200-801-A/600](#)).

NOTE: These steps are not applicable when the damage is a scratch.

- (3) Clean up the damaged surface with solvent and remove all loose fragments.

NOTE:

- Make sure that no oil, cutting grease, wax, etc. touch the repaired area. They must be fully removed with Rhodiasolve E-23 or isopropyl alcohol.
- Wear gloves and goggles and prevent solvent vapors during the cleaning.
- Clean the surface with a clean dry cloth and make sure that there is no remaining contamination on it.

- (4) Trim the patch. Cut a baggage-compartment old lining to the correct size to fully cover the damaged area. Refer to [Figure 805](#), sheet 2, DET. C and DET. D.

NOTE: Make sure that there is a border of liner material with 76.2 millimeters (3 inches) minimum between the damage and the outer edge of the patch repair.

- (5) Put the patch repair in the correct position and drill the two linings together all around the patch repair to install the fasteners. Refer to [Figure 805](#), sheet 2, DET. C.

NOTE: Make sure that there is a distance of 127 millimeters (5 inches) maximum between the holes of the fasteners.

- (6) Install the nutplates (1) on the patch repair. Refer to [Figure 805](#), sheet 2, DET. D.

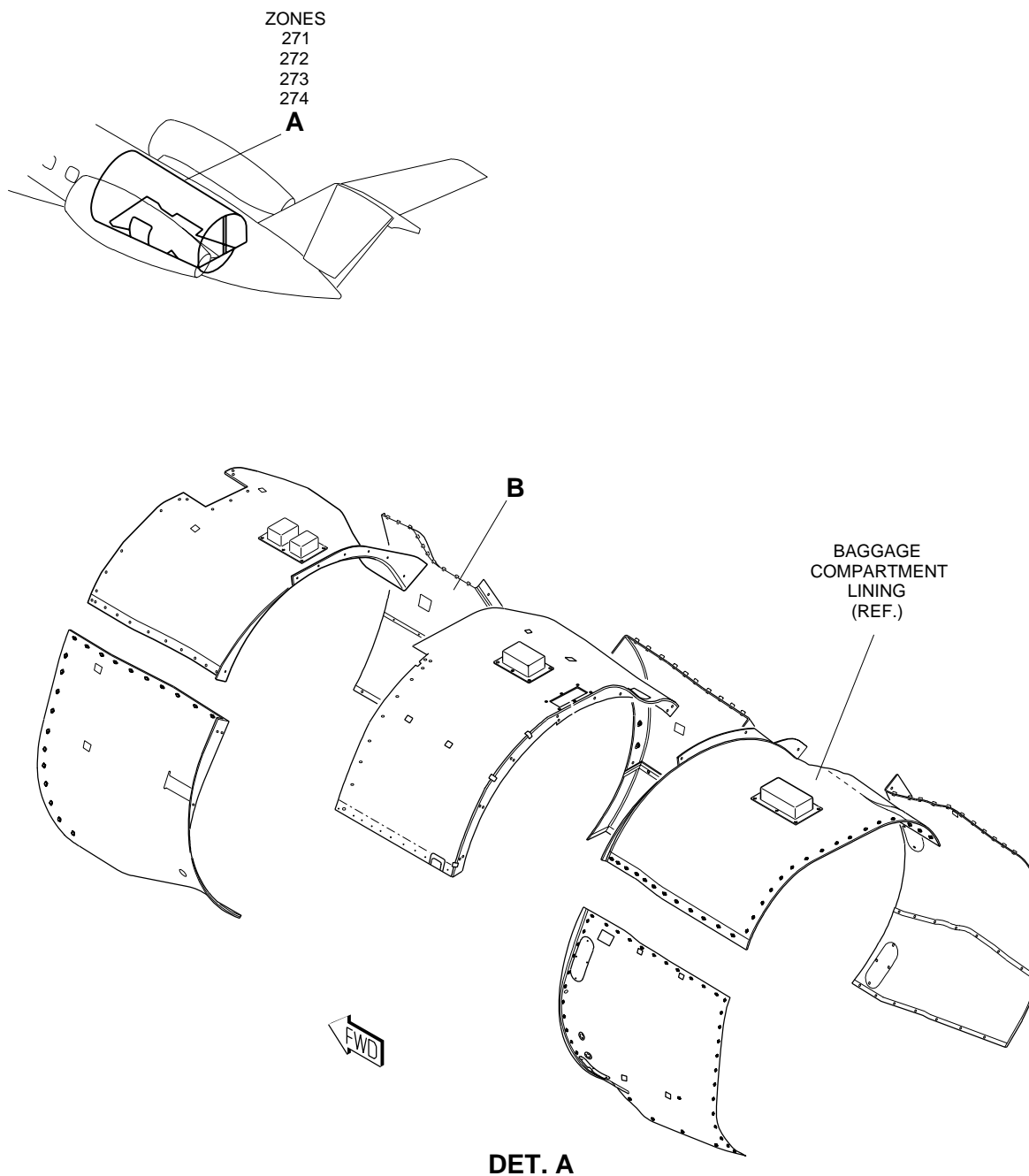
- (7) Apply the foam seal (2) all around the contour of the patch repair. Refer to [Figure 805](#), sheet 2, DET. D.

- (8) Attach the patch repair to the baggage compartment lining with the screws (4) and the washers (3). Refer to [Figure 805](#), sheet 2, DET. D.
- (9) Install the baggage compartment lining back ([AMM TASK 25-51-01-400-801-A/400](#)).

EFFECTIVITY: ALL

Baggage Compartment Lining - Old Liner Repair

Figure 805 - Sheet 1

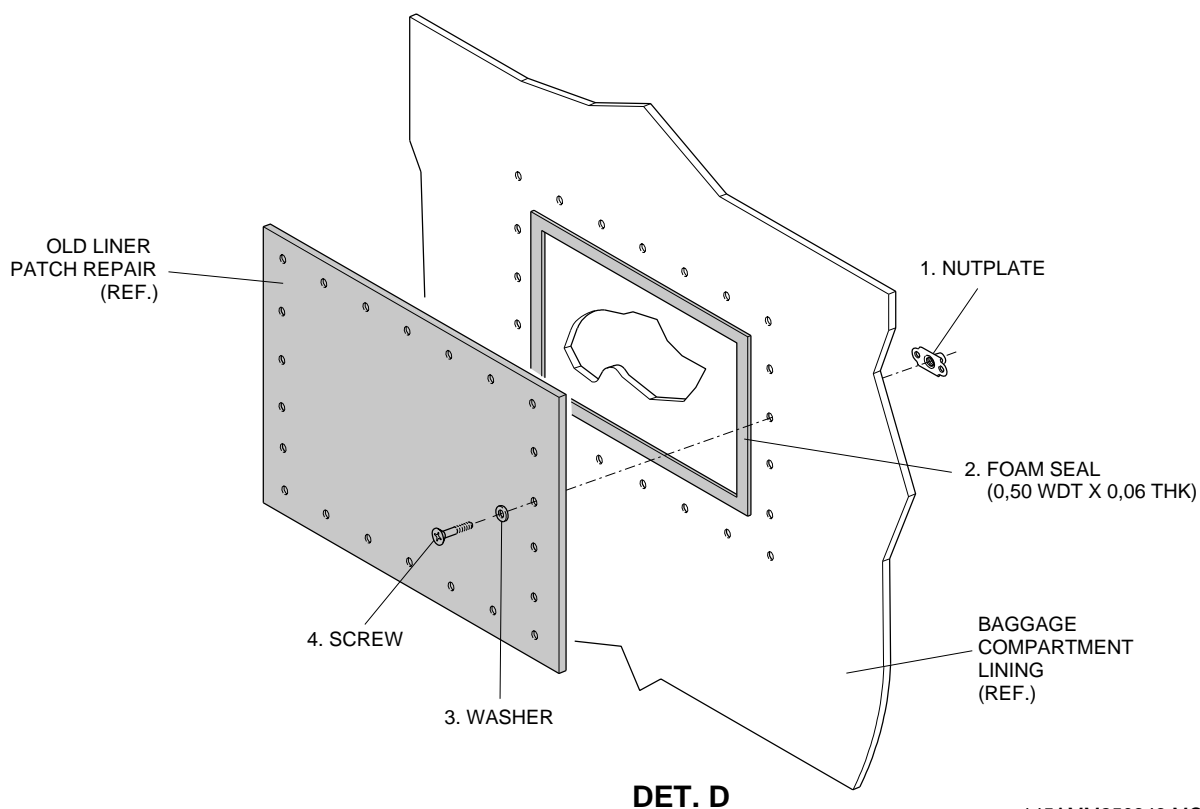
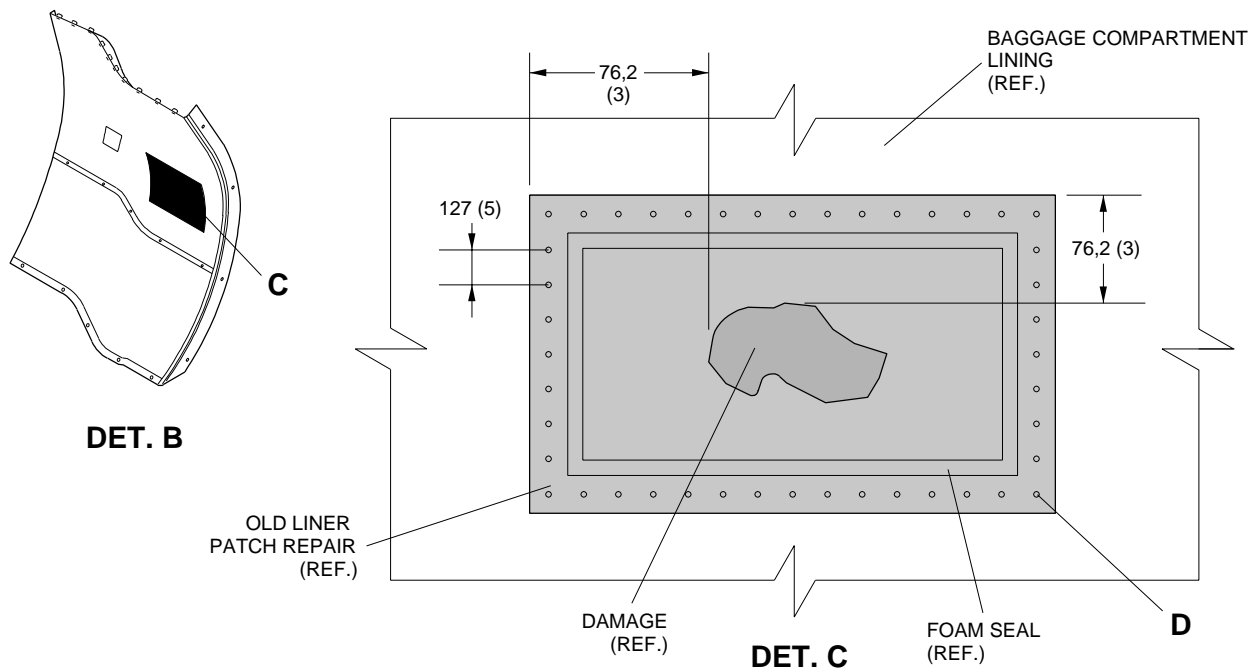


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EFFECTIVITY: ALL

Baggage Compartment Lining - Old Liner Repair

Figure 805 - Sheet 2



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TASK 25-51-01-300-803-A

EFFECTIVITY: ALL

4. BAGGAGE COMPARTMENT LINING - WET LAY-UP REPAIR

A. General

- (1) Apply this repair method:
 - (a) To the same damage, on the front side or the backside of the panel for fiberglass/phenolic resin baggage-compartment lining;
 - (b) To the same damage, on the front side and the backside of the panel for fiberglass/epoxy resin baggage-compartment lining.
- (2) On the panel for fiberglass/phenolic baggage-compartment lining, use the plies of repair fiberglass as follows:
 - (a) Front side (paint side): 3 plies of 7781 fiberglass or;
 - (b) Backside: 3 plies of 7781 fiberglass.
- (3) On the panel for fiberglass/epoxy baggage-compartment lining, use the plies of repair fiberglass as follows:
 - (a) Front side (paint side): 2 plies of 7781 fiberglass and;
 - (b) Backside: 3 plies of 7781 fiberglass.
- (4) The maximum repairable damage is related to the material of the baggage compartment lining that you will repair. Refer to table 803 for the maximum damage and types of damage that you can repair in each case.

Table 803 - PATCH REPAIR X MAXIMUM DAMAGE AND TYPES OF DAMAGE

MATERIAL OF BAGGAGE COMPARTMENT LINING	TYPE OF DAMAGE	MAXIMUM DAMAGE length x width mm (in)
Fiberglass/ Phenolic Resin	square-shaped	101 x 101 (4 x 4)
	U-shaped slit	127 x 127 (5 x 5)
Fiberglass/ Epoxy Resin	Any type of damage (hole in liner)	127 x127 (5 x 5)

- (5) If you cannot obey the requirements in table 803, the damaged baggage-compartment lining must be replaced.
- (6) Replace the baggage compartment lining that has damage larger than the referred-to dimension.

B. References

<i>REFERENCE</i>	<i>DESIGNATION</i>
AMM TASK 25-51-01-000-801-A/400	BAGGAGE COMPARTMENT LINING - REMOVAL
AMM TASK 25-51-01-200-801-A/600	BAGGAGE COMPARTMENT LINING - VISUAL INSPECTION

(Continued)

REFERENCE	DESIGNATION
AMM TASK 25-51-01-400-801-A/400	BAGGAGE COMPARTMENT LINING - INSTALLATION

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Balance with precision in grams ± 1.0 gram	To weigh the fiberglass plies	
Commercially available	Heat gun	To smooth the surfaces	

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Rubber gloves	Hand protection	1
Commercially available	Safety goggles	Eye protection	1
Commercially available	Paint brush	To apply the resins	AR
Commercially available	Sandpaper 320-400 grit	To remove the paint	AR
Commercially available	Shop Wipes	For cleaning	AR
Commercially available	Spatula	To apply the resins	1

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
Commercially available	Rhodiasolve E-23 - Commercial grade	AR
TT-I-735	Isopropyl Alcohol - Commercial grade	AR
O-E-760	Ethanol - Commercial grade	AR
MIL-C-9084	E - glass, Style 7781 - Dry fiberglass	AR
Commercially available	Shell resin 828 with Epicure 3223 catalyst	AR
Commercially available	Georgia Pacific GP677D60 resin with GP4840 catalyst	AR
Commercially available	EPIBOND 1559-1 A/B	AR
Commercially available	Hysol EA 956 Part A resin with Part B catalyst	AR
WLS P/N 412-109	WLS Paint	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	A - Does the task	Baggage compartment
1	B - Helps technician A	Baggage compartment

I. Wet Lay-up Repair (Figure 806) (Figure 807)

SUBTASK 340-004-A

EFFECTIVITY: APPLICABLE TO FIBERGLASS/PHENOLIC BAGGAGE-COMPARTMENT LINING

WARNING: THE BAGGAGE COMPARTMENT LININGS ARE FRAGILE, LARGE AND DIFFICULT TO MOVE. ASK FOR HELP TO MOVE THE LINERS AND BE CAREFUL TO PREVENT INJURY TO PERSONS AND DAMAGE TO THE PARTS.

- (1) Remove the baggage-compartment damaged lining ([AMM TASK 25-51-01-000-801-A/400](#)).
- (2) Make an inspection on the systems installed in the area that the removed baggage-compartment damaged lining covered ([AMM TASK 25-51-01-200-801-A/600](#)).

NOTE: These steps are not applicable when the damage is a scratch.

- (3) Find the damage size and make the decision on which side of the panel (front side or backside) you will repair.

WARNING: WEAR GLOVES AND GOGGLES AND AVOID CONTACT WITH SOLVENT VAPORS DURING THE CLEANING.

- (4) Clean the baggage compartment lining with Rhodiasolve E-23, ethanol or isopropyl alcohol to remove dirt, oil, and debris.
- (5) **NOTE:** The step that follows is applicable only to wet lay-up repair of the front side of the panel.

With a 320-400 grit sandpaper, fully remove the paint from the area where you will install the repair.

- NOTE:**
- Mask off the surface to keep the original paint intact outside the repair and the adjacent border.
 - Remove a minimum of 25 millimeters (1.0 inch) of paint on the border adjacent to the damage that you will repair.
 - Be careful not to go through the first layer when you sand the area.
 - Make sure that all filler or primers are also removed and the bare glass surface is exposed.

- (6) Wipe the surface with a clean shop wipe soaked in Rhodiasolve E-23, ethanol or isopropyl alcohol.

- NOTE:**
- Dry the surface with a clean dry shop wipe. Do not let the solvent evaporate from the part and make sure that there is no remaining contamination on it.
 - The part will be clean when you pass a clean, dry shop wipe on the surface and the shop wipe shows no indications of dirt, oil, or debris.
 - Do not touch the cleaned surfaces.

- (7) Trim 3 plies of 7781 fiberglass to cover the damaged area and extend a minimum of 25 millimeters (1.0 inch) past on all sides.

NOTE: Put the fiberglass pieces on a table with release paper to prevent contamination of the resin on the shop benches.

- (8) Weigh the fiberglass plies. Use this figure as a start weight for the resin that you will mix for repair (Table 804).

Table 804 - LAMINATING RESIN/CATALYST

Laminating Resin : Catalyst (by weight)
100:10

- (9) Mix Shell Resin 828 (laminating resin) and Epicure 3223 (catalyst). Resin mixture must cause a complete saturation of the glass to occur.
- (10) With a paint brush, apply a small quantity of the resin on the 25-millimeter (1.0-inch) border past the panel damage.
- (11) With a paint brush, apply a small quantity of resin on the first fiberglass ply. Use of a roller pin or dowel will help distribute the resin equally on the fiberglass ply.
- (12) Install the first fiberglass ply with resin on the damaged panel. Make sure that the patch extends a minimum 25 millimeters (1.0 inch) past the damage.
- (13) Use the resin and brush to distribute the resin and smooth the panel surface as necessary.
- (14) Install the second ply on the first ply.
- (15) Apply more resin on the surface of the panel. Make sure that the panel is fully soaked in the resin solution.
- (16) Install the third ply on the repair and apply more resin on the surface, as necessary to have a complete saturation.
- (17) You can use a nylon or Teflon paddle to help seat the plies onto the panel.
- NOTE:** Apply pressure from one corner of the repair and work outward to prevent air bubbles.
- (18) Let the repair cure for a minimum of 6 hours.
- (19) Brush-apply, to the two sides of the panel, GP677D60 resin with GP4840 catalyst mixed 1:1 by weight.

NOTE: • Try to make a uniform coat with a minimum thickness of 0.08 millimeters (0.003 inches).

- Additional resin does not affect performance.

(20) Before you finish, let the resin cure for 8 hours.

NOTE: • You can return the panel to service or paint it.

- Do not remove the GP677D60 resin if you apply a finish.

(21) **NOTE:** The step that follows is applicable only to wet lay-up repair on the front side of the panel.

Sand the area softly and paint with WLS P/N 412-109 to finish the repair, if applicable.

(22) Install the baggage compartment lining back ([AMM TASK 25-51-01-400-801-A/400](#)).

J. Wet Lay-up Repair ([Figure 806](#)) ([Figure 808](#))

SUBTASK 340-005-A

EFFECTIVITY: APPLICABLE TO FIBERGLASS/EPOXY BAGGAGE-COMPARTMENT LINING

WARNING: THE BAGGAGE COMPARTMENT LININGS ARE FRAGILE, LARGE AND DIFFICULT TO MOVE. ASK FOR HELP TO MOVE THE LINERS AND BE CAREFUL TO PREVENT INJURY TO PERSONS AND DAMAGE TO THE PARTS.

- (1) Remove the baggage-compartment damaged lining ([AMM TASK 25-51-01-000-801-A/400](#)).
- (2) Make an inspection on the systems installed in the area that the removed baggage-compartment damaged lining covered ([AMM TASK 25-51-01-200-801-A/600](#)).

NOTE: This step is not applicable when the damage is a scratch.

- (3) Find the damaged size and make the repair on the front side and backside of the panel.

WARNING: WEAR GLOVES AND GOGGLES AND AVOID CONTACT WITH SOLVENT VAPORS DURING THE CLEANING.

- (4) Clean the baggage compartment lining with Rhodiasolve E-23, ethanol or isopropyl alcohol to remove dirt, oil, and debris.
- (5) **NOTE:** The step that follows is applicable only to wet lay-up repair of the front side of the panel.

With a 320-400 grit sandpaper, fully remove the paint from the area where you will install the repair.

NOTE: • Mask off the surface to keep the original paint intact outside the repair and the adjacent border.

- Remove a minimum of 76.2 millimeters (3.0 inches) of paint on the border adjacent to the damage where you will make the repair.

- Be careful not to go through the first layer when you sand the area.
- Make sure that all filler or primers are also removed and the bare glass surface is exposed.

(6) Wipe the front side and backside surface with a clean, shop wipe soaked in Rhodiasolve E-23, ethanol or isopropyl alcohol.

NOTE: • Dry the surface with a clean dry shop wipe. Do not let the solvent evaporate from the part and make sure that there is no remaining contamination on it.

- The part will be clean when you pass a clean, dry shop wipe on the surface and the shop wipe shows no indications of dirt, oil, or debris.
- Do not touch the cleaned surfaces.

(7) Trim 5 plies of 7781 fiberglass to cover the damaged area and extend a minimum of 76.2 millimeters (3.0 inches) past on all sides.

NOTE: Put the fiberglass pieces on a table with release paper to prevent contamination of the resin on the shop benches.

(8) Weigh the fiberglass plies. Use this figure as a start weight for the resin that you will mix for repair (Table 805).

Table 805 - LAMINATING RESIN/CATALYST

Laminating Resin : Catalyst (by weight)
100:58

(9) Mix EA 956 Part A (laminating resin epoxy) and EA 956 Part B (catalyst). Resin mixture must cause a complete saturation of the glass to occur.

(10) With a paint brush, apply a small quantity of the resin on the 76.2 millimeters (3.0 inches) border past the panel damage.

(11) With a paint brush, apply a small quantity of resin on the first fiberglass ply. Use of a roller pin or dowel will help distribute the resin equally on the fiberglass ply.

(12) On the front side, install the first fiberglass ply with resin on the damaged panel. Make sure that the patch extends a minimum 76.2 millimeters (3.0 inches) past the damage.

(13) Use the resin and brush to distribute the resin and smooth the panel surface as necessary.

(14) Install the second ply on the first ply.

(15) Apply more resin on the surface of the panel. Make sure that the panel is fully soaked in the resin solution.

(16) You can use a nylon or Teflon paddle to help seat the plies onto the panel.

NOTE: Apply pressure from one corner of the repair and work outward to prevent air bubbles.

- (17) Before you install the plies on the backside, heat the front surface of the panel with a heat gun held at distance of 150 millimeters (6 inches) to accelerate the cure time.

NOTE: You must use heat guns moderately, at low setting, 65°C (150°F).

- (18) On the backside, install the first ply on the repair and apply more resin on the surface.
- (19) Install the second ply on the repair and apply more resin on the surface, as necessary to have a complete saturation.
- (20) Install the third ply on the repair and apply more resin on the surface, as necessary to have a complete saturation.
- (21) The use of a nylon or Teflon paddle to help seat the plies onto the panel is recommended.

NOTE: Apply pressure from one corner of the repair and work outward to prevent air bubbles.

- (22) Heat the back surface of the panel with a heat gun held 150 millimeters (6 inches) to accelerate the cure time.

NOTE: You must use heat guns moderately, at low setting, 48°C (120°F) for one hour and increase the temperature to 93°C (200°F) for one hour to complete cure.

- (23) After the curing time, use a spatula to apply, to the front side of the panel, EPIBOND 1559-1 A/B part A resin adhesive with Part B catalyst mixed 1:1 by volume or weight.

NOTE:

- Try to make a uniform coat with a minimum thickness of 3.2 millimeters (0.125 inches).
- Sand the area softly to get a minimum of 0.127 millimeter (0.005 inch) thickness of adhesive to have an intumescent barrier.
- Additional resin does not affect performance.

- (24) Before you finish, let the resin cure for 1 hour at room temperature.

NOTE: You can return the panel to service or paint it.

- (25) NOTE: The step that follows is applicable only to wet lay-up repair on the front side of the panel.

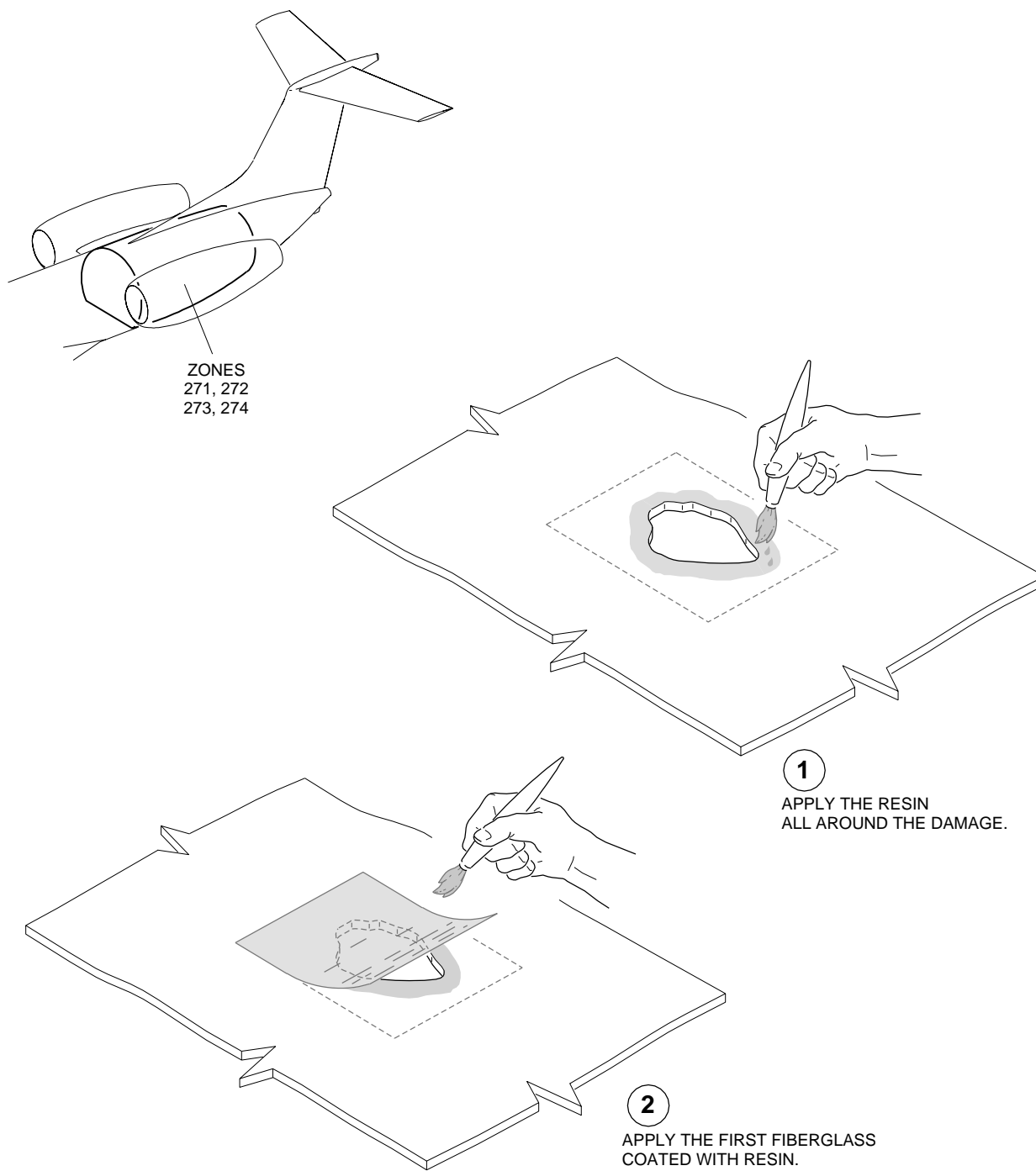
Sand the area softly and paint with WLS P/N 412-109 to finish the repair, if applicable.

- (26) Install the baggage compartment lining back ([AMM TASK 25-51-01-400-801-A/400](#)).

EFFECTIVITY: ALL

Baggage Compartment Lining - Wet Lay-up Repair

Figure 806

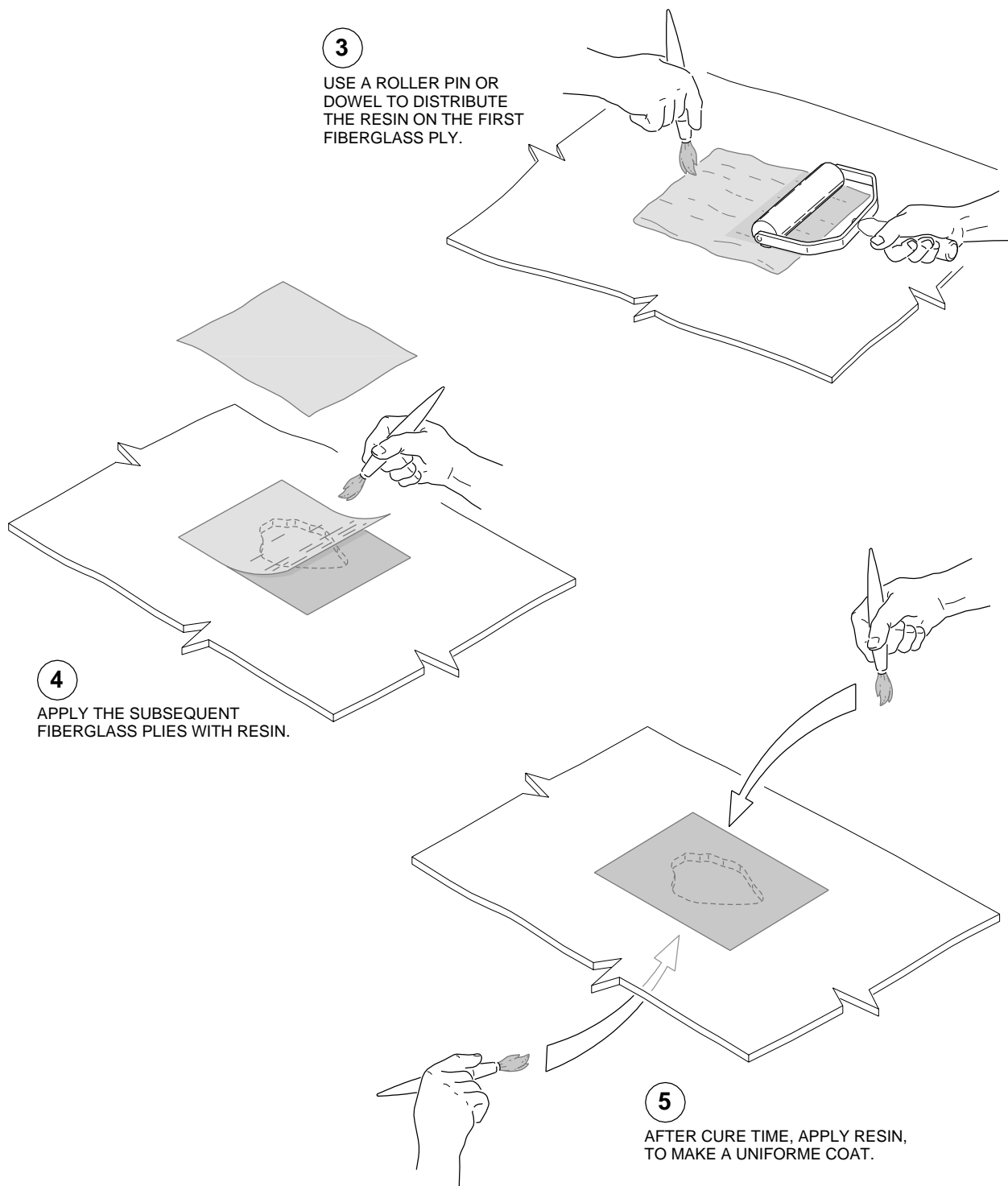


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EFFECTIVITY: APPLICABLE TO FIBERGLASS/PHENOLIC BAGGAGE-COMPARTMENT LINING

Fiberglass/Phenolic Baggage Compartment Lining - Wet Lay-up Repair

Figure 807

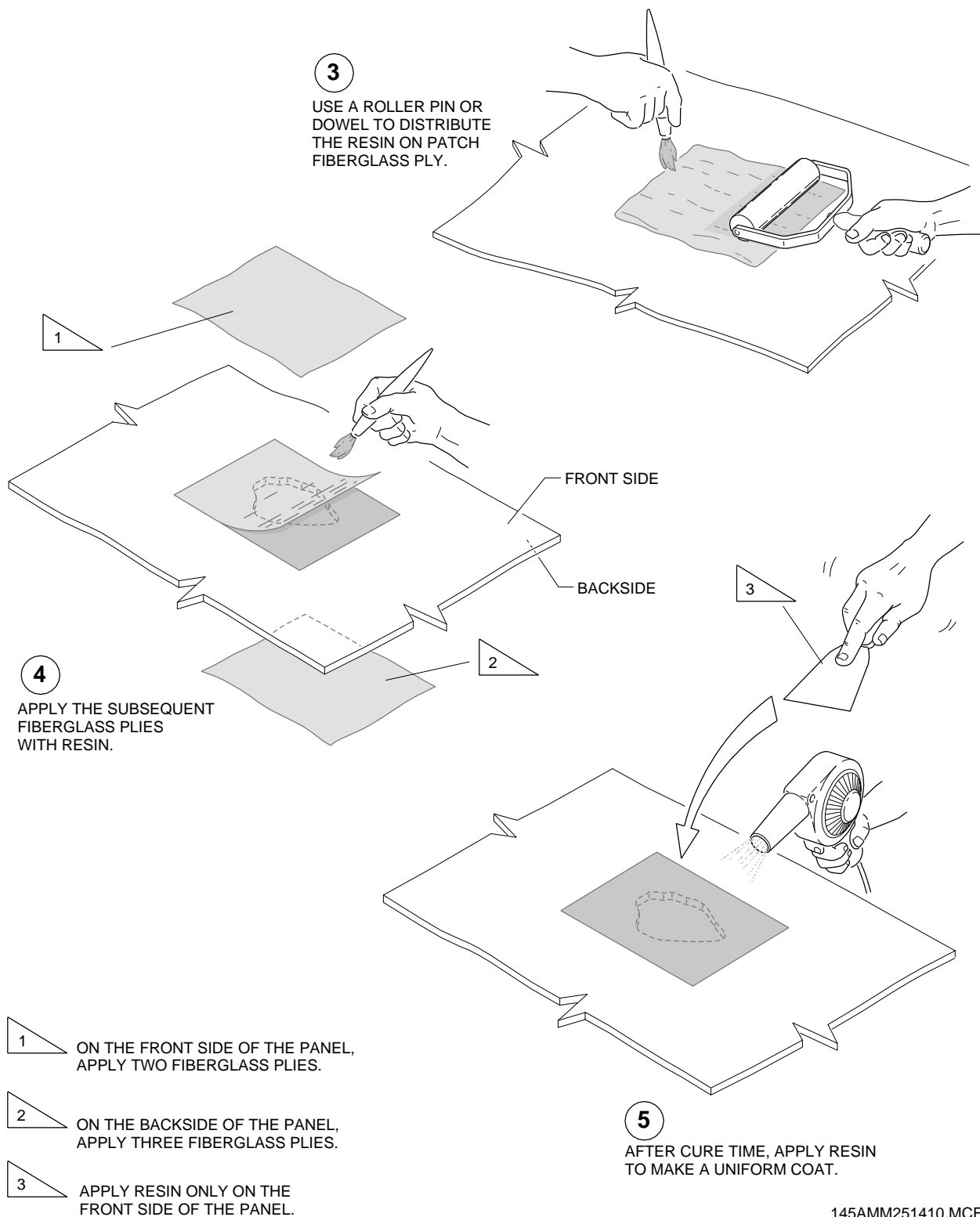


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EFFECTIVITY: APPLICABLE TO FIBERGLASS/EPOXY BAGGAGE-COMPARTMENT LINING

Fiberglass/Epoxy Baggage Compartment Lining - Wet Lay-up Repair

Figure 808



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TASK 25-51-01-300-804-A

EFFECTIVITY: ALL

5. BAGGAGE COMPARTMENT LINING - WET LAY-UP WITH DOUBLER PLATES AND REPAIR-TAPE REPAIR

A. General

(1) The repair method was tested and approved for use:

- (a) To all types and dimension of damage;
- (b) On the front side of the baggage-compartment lining.

NOTE: Straight slits are not an approved repair method. Cut/Notch straight slits into "U" section.

B. References

REFERENCE	DESIGNATION
AMM TASK 25-51-01-000-801-A/400	BAGGAGE COMPARTMENT LINING - REMOVAL
AMM TASK 25-51-01-200-801-A/600	BAGGAGE COMPARTMENT LINING - VISUAL INSPECTION
AMM TASK 25-51-01-400-801-A/400	BAGGAGE COMPARTMENT LINING - INSTALLATION

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Balance with precision in grams ± 1.0 gram	To weigh the fiberglass plies	

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Rubber gloves	Hand protection	1
Commercially available	Safety goggles	Eye protection	1
Commercially available	Paint brush	To apply the resins	AR
Commercially available	Sandpaper 320-400 grit	To remove the paint	AR
Commercially available	Shop Wipes	For cleaning	AR

F. Consumable Materials

<i>SPECIFICATION (BRAND)</i>	<i>DESCRIPTION</i>	<i>QTY</i>
Commercially available	Rhodiasolve E-23 - Commercial grade	AR
TT-I-735	Isopropyl Alcohol - Commercial grade	AR
O-E-760	Ethanol - Commercial grade	AR
MIL-C-9084	E - glass, Style 7781 - Dry fiberglass	AR
Commercially available	Shell resin 828 with Epicure 3223 catalyst	AR
Commercially available	Doubler Plates, CRES, Type 302 (0.020 thk), 25.4 millimeters (1 inch) wide	AR
Commercially available	Pan-head Rivets, Blind, PN/SD42BS - Vendor: Meg Tech	AR
Commercially available	Fiberglass Reinforced Adhesive Tape, PN/397FR - Vendor: 3M	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

<i>QTY</i>	<i>FUNCTION</i>	<i>PLACE</i>
1	Does the task	Baggage compartment
1	B - Helps technician A	Baggage compartment

I. Wet Lay-up with Doubler Plates and Repair Tape Repair ([Figure 809](#))

SUBTASK 340-006-A

WARNING: THE BAGGAGE COMPARTMENT LININGS ARE FRAGILE, LARGE AND DIFFICULT TO MOVE. ASK FOR HELP TO MOVE THE LINERS AND BE CAREFUL TO PREVENT INJURY TO PERSONS AND DAMAGE TO THE PARTS.

- (1) Remove the damaged baggage-compartment lining ([AMM TASK 25-51-01-000-801-A/400](#)).
- (2) Make an inspection on the systems installed in the area that the removed baggage-compartment damaged lining covered ([AMM TASK 25-51-01-200-801-A/600](#)).

NOTE: These steps are not applicable when the damage is a scratch.

- (3) Find the damage size.

NOTE: The wet lay-up with doubler plates must make a minimum overlap of 76.2 millimeters (3.0 inch) around the damage area to make sure that there is sufficient bond strength.

WARNING: WEAR GLOVES AND GOGGLES AND PREVENT CONTACT WITH SOLVENT VAPORS DURING THE CLEANING.

- (4) Clean the baggage compartment lining with Rhodiasolve E-23, ethanol or isopropyl alcohol to remove dirt, oil, and debris.

- (5) With a 320-400 grit sandpaper, fully remove the paint from the area where the repair will be installed.

NOTE:

- Mask off the surface to keep the original paint intact outside the repair and the adjacent border.
- Remove a minimum of 76.2 millimeters (3.0 inch) of paint on the border adjacent to the damage where the repair will be done.
- Be careful not to go through the first layer when you sand the area.
- Make sure that all filler or primers are also removed and the bare glass surface is exposed.

- (6) Wipe the surface with a clean, shop wipe soaked in Rhodiasolve E-23, ethanol or isopropyl alcohol.

NOTE:

- Dry the surface with a clean dry shop wipe. Do not let the solvent evaporate from the part and make sure that there is no remaining contamination on it.
- The part will be clean when you pass a clean, dry shop wipe on the surface and the shop wipe shows no indications of dirt, oil, or debris.
- Do not touch the cleaned surfaces.

- (7) Trim 3 plies of 7781 fiberglass to cover the damaged area:

- (a) 1 ply at 50.8 millimeters (2.0 inches) from the periphery of the damage area;
- (b) 1 ply at 63.5 millimeters (2.5 inches) from the periphery of the damage area;
- (c) 1 ply at 76.2 millimeters (3.0 inches) from the periphery of the damage area.

NOTE: Put the fiberglass pieces on a table with release paper to prevent contamination of the resin on the shop benches.

- (8) Weigh the fiberglass plies. Use this figure as start weight for resin to be mixed for repair (Table 806).

Table 806 - LAMINATING RESIN/CATALYST

Laminating Resin : Catalyst (by weight)
100:10

- (9) Mix Shell Resin 828 (laminating resin) and Epicure 3223 (catalyst). Resin mixture must cause a complete saturation of the glass to occur.
- (10) With a paint brush, apply a small quantity of the resin on the 50.8 millimeter (2.0-inch) border past the panel damage.
- (11) With a paint brush, apply a small quantity of resin on the first fiberglass ply. The use of a roller pin or dowel will help distribute the resin equally on the fiberglass ply.
- (12) Install the first fiberglass ply with resin on the damaged panel. Make sure that the patch extends a minimum 50.8 millimeters (2.0 inch) past the damage.

- (13) Use the resin and brush to distribute the resin and smooth the panel surface as necessary.
- (14) Install the second ply on the first ply. This ply must extend 12.5 millimeters (0.5 inch) past the first ply.
- (15) Apply more resin on the surface of the panel. Make sure that the panel is fully soaked in the resin solution.
- (16) Install the third ply on the repair. This ply must extend 25.4 millimeters (1.00 inch) past the first ply.
- (17) Apply more resin on the surface, as necessary to have a complete saturation.
- (18) The use of a nylon or Teflon paddle to help seat the plies onto the panel is recommended.

NOTE: Apply pressure from one corner of the repair and work outward to prevent air bubbles.

- (19) Let the repair cure for a minimum of 8 hours.
- (20) Apply the doubler plates around the damage on the front and back sides of the liner to be repaired and install the rivets.

NOTE:

- Make sure that the doubler plates are at the position of 50.8 millimeters (2.0 inches) from the damage to the plate edge.
- Make sure that the rivets are on the centerline of the doubler plates, 25.4 millimeters (1.0 inch) from each end, and with a maximum spacing of 50.8-millimeters (2.0-inches).

- (21) Apply repair-tape strips to the doubler plates to prevent damage to the baggage-compartment lining and framework.

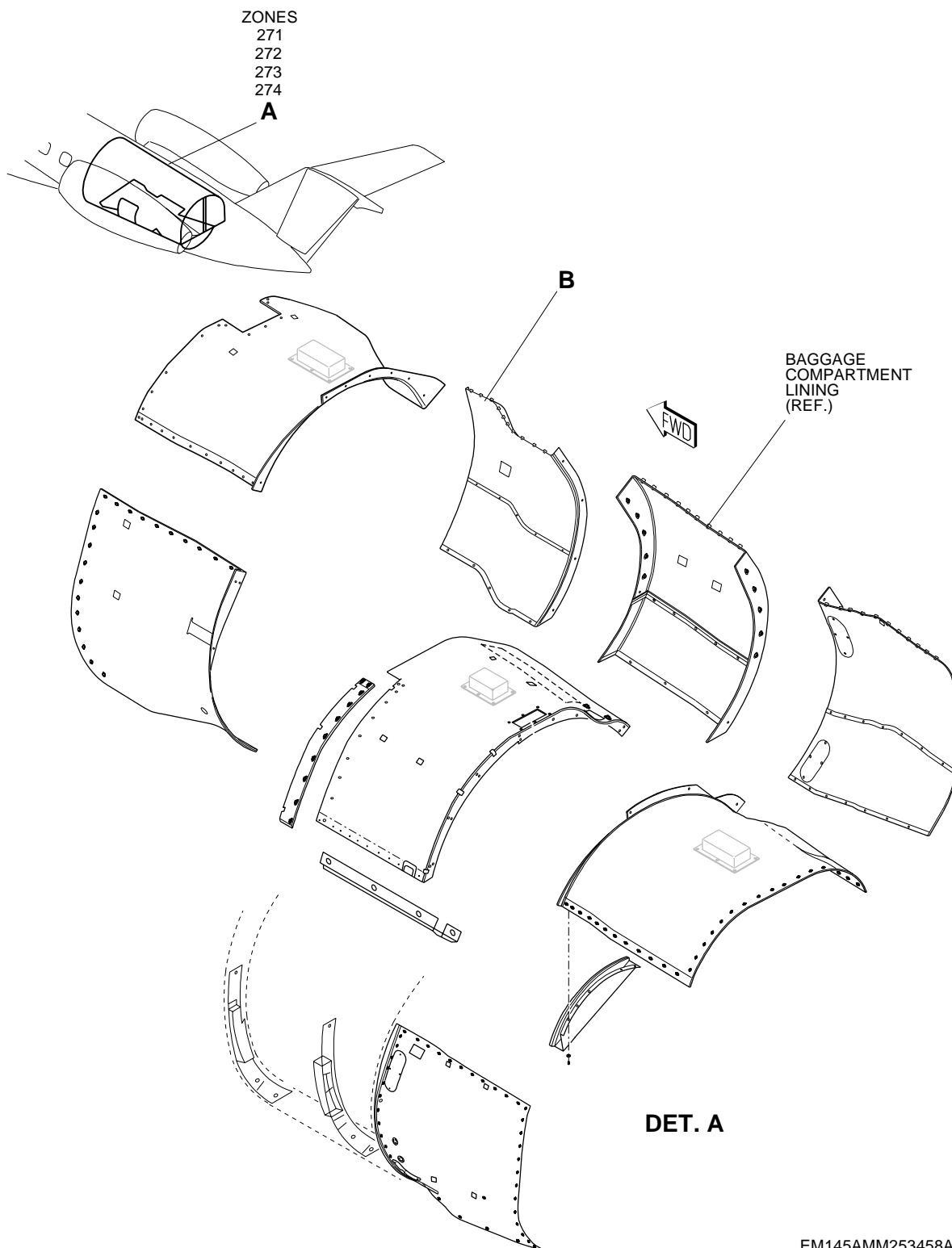
NOTE: Make sure that each repair-tape strips overlaps the liner 25.4 millimeters (1.0 inch) from the edge of the doubler plates, and 12.7 millimeters (0.50 inch) the adjacent tape strips.

- (22) Install the baggage compartment lining back ([AMM TASK 25-51-01-400-801-A/400](#)).

EFFECTIVITY: ALL

Baggage Compartment Lining - Wet Lay-up with Doubler Plates and Repair Tape Repair

Figure 809 - Sheet 1

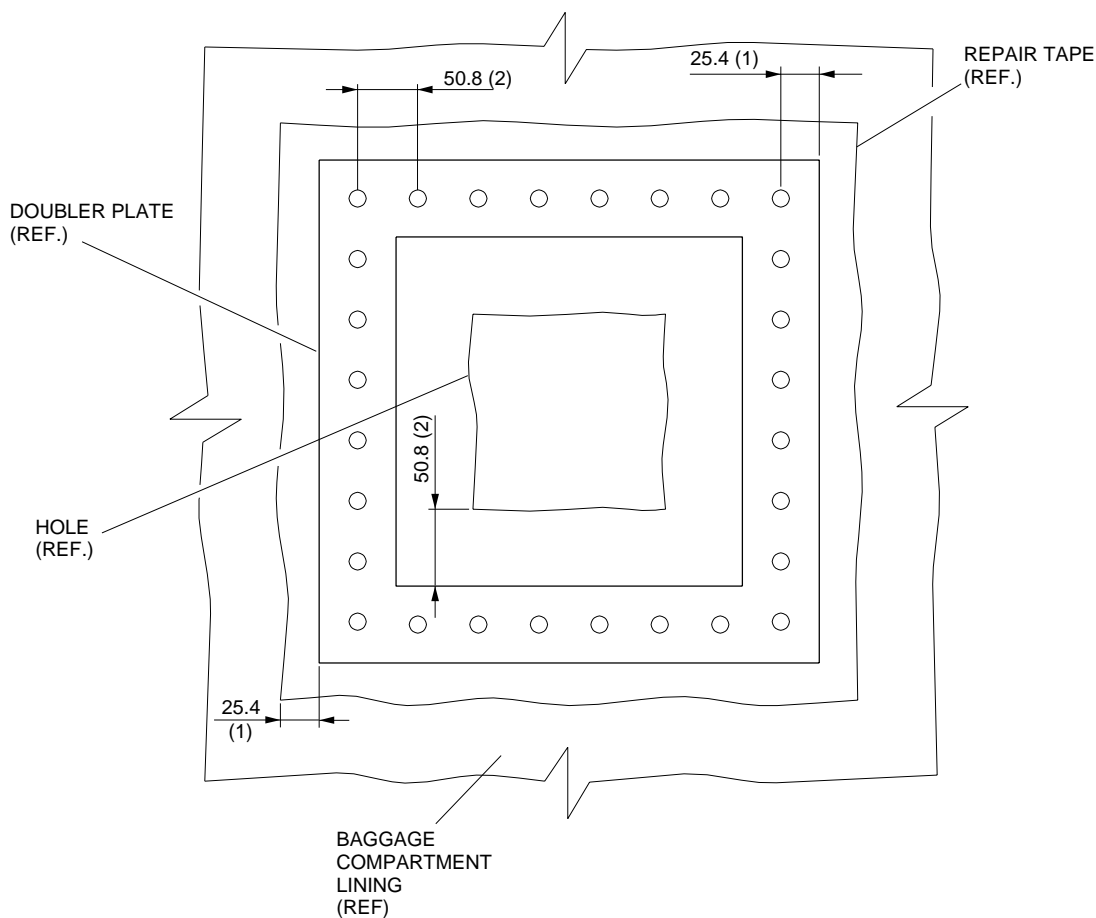


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EFFECTIVITY: ALL

Baggage Compartment Lining - Wet Lay-up with Doubler Plates and Repair Tape Repair

Figure 809 - Sheet 2



DET. B

- DIMENSIONS ARE IN mm
- CONVERSIONS IN PARENTHESES

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TASK 25-51-01-300-805-A

EFFECTIVITY: ALL

6. BAGGAGE COMPARTMENT LINING - REINFORCEMENT

A. General

CAUTION: IS NECESSARY TO APPLY THESE PROCEDURES BELOW FOR THE BAGGAGE COMPARTMENT COMPRISES BAGGAGE COMPARTMENT LININGS REINFORCED.

- (1) This task gives the instructions to reinforce the baggage-compartment lining with plates and polyethylene adhesive.

B. References

REFERENCE	DESIGNATION
AMM TASK 25-51-01-000-801-A/400	BAGGAGE COMPARTMENT LINING - REMOVAL
AMM TASK 25-51-01-400-801-A/400	BAGGAGE COMPARTMENT LINING - INSTALLATION
IPC 25-51-01	BAGGAGE COMPARTMENT LINING

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Razor-blade scraper	To cut a piece of the carpet	
Commercially available	Drill	To do small holes on the linings	

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Rubber gloves	Hand protection	1
Commercially available	Safety goggles	Eye protection	1
Commercially available	Paint brush	To apply the resins	AR
Commercially available	Sandpaper 180 grit	To sand the surface	AR
Commercially available	Shop Wipes	For cleaning	AR
Commercially available	Spatula	To apply the adhesives	1

F. Consumable Materials

<i>SPECIFICATION (BRAND)</i>	<i>DESCRIPTION</i>	<i>QTY</i>
Commercially available	Rhodiasolve E-23 - Commercial grade	AR
MEP09-022	Adhesive Epoxy AV138, component A	AR
MEP09-022	HV998 Catalyst-Adhesive AV138, component B	AR
MEP18-030	5423-50 Polyethylene Adhesive Tape	AR

G. Expendable Parts

<i>ITEM</i>	<i>IPC REFERENCE (VENDOR REFERENCE)</i>	<i>QTY</i>
Reinforcement Plate	IPC 25-51-01	AR

H. Persons Recommended

<i>QTY</i>	<i>FUNCTION</i>	<i>PLACE</i>
1	A - Does the task	Baggage compartment
1	B - Helps technician A	Baggage compartment

I. Baggage Lining - Reinforcement (Figure 810) (Figure 811)

SUBTASK 340-007-A

CAUTION: TO BE A BAGGAGE COMPARTMENT LINING REINFORCED, THESE PROCEDURES MUST BE APPLIED TO ALL OF THE BAGGAGE COMPARTMENT LININGS.

- (1) Reinforce the LH AFT baggage compartment lining as follow (refer to Figure 810, DET. B, sheet 2):

WARNING: THE BAGGAGE COMPARTMENT LININGS ARE FRAGILE, LARGE AND DIFFICULT TO MOVE. ASK FOR HELP TO MOVE THE LINERS AND BE CAREFUL TO PREVENT INJURY TO PERSONS AND DAMAGE TO THE PARTS.

- (a) Remove the LH AFT baggage-compartment lining ([AMM TASK 25-51-01-000-801-A/400](#)).

WARNING: WEAR GLOVES AND GOGGLES AND AVOID CONTACT WITH SOLVENT VAPORS DURING THE CLEANING.

- (b) Clean the LH AFT baggage-compartment lining with Rhodiasolve E-23 to remove dirt, oil, and debris.
- (c) With a 180 grit sandpaper, to fully remove the paint from the area where you will install the reinforcement plates.

NOTE: Be careful not to go through the first layer when you sand the area.

- (d) Clean the baggage compartment lining with Rhodiasolve E-23.

CAUTION: BONDING OPERATION MUST BE DONE IMMEDIATELY AFTER THE REINFORCED PLATE IS SANDED/CLEANED.

- (e) On the outside surface, position the reinforcement plates (1) over the lining panel. Refer to Figure 810, DET. P, sheet 10.

NOTE:

- Make sure that the alignment of the holes in the reinforcement plates (1) and in the lining are correct.
- Make sure that the reinforcement plates (1) do not go more than the lining borders.

CAUTION: WHEN USING THE BLANK REINFORCEMENT, THE MINIMUM DISTANCE ALLOWED BETWEEN THE CENTER OF THE NEW HOLE AND THE REINFORCEMENT EDGE IS 9 MM (0.35 IN).

- (f) If the reinforcement plates (1) go more than the lining borders, use a blank reinforcement plate. Refer to Figure 810, DET. R, sheet 10.

NOTE: Drill the hole according to the one existing in the lining.

WARNING: ADHESIVES ARE CLASSIFIED AS HAZARDOUS MATERIALS WHICH MAY CAUSE INJURY OR ILLNESS IF NOT PROPERLY USED. THESE PRODUCTS SHOULD BE USED ONLY IN ACCORDANCE WITH THE MANUFACTOR'S SPECIFIC SAFETY AND HEALTH RECOMMENDATIONS. PRIOR TO THE USE OF THESE PRODUCTS, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

- (g) Use the adhesive AV138 and the catalyst HV998 to bond the reinforcement plates (1).
- (h) Use the cure time according manufacturer's instructions.
- (i) Apply adhesive polyethylene tape (2) over the reinforcement plates (1). Refer to Figure 810, DET. B, sheet 2 and DET. P, sheet 10.
- (j) Use the same instructions to apply the reinforcement plates (3) to the inside surface. Refer to Figure 810, DET. L, sheet 10.

NOTE: On the inside surface the adhesive polyethylene tape is not applied.

CAUTION: TO BE A BAGGAGE COMPARTMENT LINING REINFORCED, THESE PROCEDURES MUST BE APPLIED TO ALL OF THE BAGGAGE COMPARTMENT LININGS.

- (2) Reinforce the upper aft baggage compartment lining as follow (refer to Figure 810, DET. C, sheet 3):

WARNING: THE BAGGAGE COMPARTMENT LININGS ARE FRAGILE, LARGE AND DIFFICULT TO MOVE. ASK FOR HELP TO MOVE THE LINERS AND BE CAREFUL TO PREVENT INJURY TO PERSONS AND DAMAGE TO THE PARTS.

- (a) Remove the upper aft baggage compartment lining ([AMM TASK 25-51-01-000-801-A/400](#)).

WARNING: WEAR GLOVES AND GOGGLES AND AVOID CONTACT WITH SOLVENT VAPORS DURING THE CLEANING.

- (b) Clean the upper aft baggage compartment lining with Rhodiasolve E-23 to remove dirt, oil, and debris.
- (c) With a 180 grit sandpaper, to fully remove the paint from the area where you will install the reinforcement plates.

NOTE: Be careful not to go through the first layer when you sand the area.

- (d) Clean the upper aft baggage compartment lining with Rhodiasolve E-23.

CAUTION: BONDING OPERATION MUST BE DONE IMMEDIATELY AFTER THE REINFORCED PLATE IS SANDED/CLEANED.

- (e) On the outside surface, position the reinforcement plates (5) over the lining panel. Refer to Figure 810, DET. P, sheet 10.

NOTE:

- Make sure that the alignment of the holes in the reinforcement plates (5) and in the lining are correct.
- Make sure that the reinforcement plates (5) do not go more than the lining borders.

CAUTION: WHEN USING THE BLANK REINFORCEMENT, THE MINIMUM DISTANCE ALLOWED BETWEEN THE CENTER OF THE NEW HOLE AND THE REINFORCEMENT EDGE IS 9 MM (0.35 IN).

- (f) If the reinforcement plates (5) go more than the lining borders, use a blank reinforcement plate. Refer to Figure 810, DET. R, sheet 10.

NOTE: Drill the hole according to the one existing in the lining.

WARNING: ADHESIVES ARE CLASSIFIED AS HAZARDOUS MATERIALS WHICH MAY CAUSE INJURY OR ILLNESS IF NOT PROPERLY USED. THESE PRODUCTS SHOULD BE USED ONLY IN ACCORDANCE WITH THE MANUFACTOR'S SPECIFIC SAFETY AND HEALTH RECOMMENDATIONS. PRIOR TO THE USE OF THESE PRODUCTS, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

- (g) Use the adhesive AV138 and the catalyst HV998 to bond the reinforcement plates (5).
- (h) Use the cure time according manufactor's instructions.
- (i) Apply adhesive polyethylene tape (6) over the reinforcement plates (5). Refer to Figure 810, DET. C, sheet 3 and DET. P, sheet 10.
- (j) Use the same instructions to apply the reinforcement plates (4) to the inside surface. Refer to Figure 810, DET. L, sheet 10.

NOTE: On the inside surface the adhesive polyethylene tape is not applied.

CAUTION: TO BE A BAGGAGE COMPARTMENT LINING REINFORCED, THESE PROCEDURES MUST BE APPLIED TO ALL OF THE BAGGAGE COMPARTMENT LININGS.

- (3) Reinforce the RH aft baggage compartment lining as follow (refer to Figure 810, DET. D, sheet 4):

WARNING: THE BAGGAGE COMPARTMENT LININGS ARE FRAGILE, LARGE AND DIFFICULT TO MOVE. ASK FOR HELP TO MOVE THE LINERS AND BE CAREFUL TO PREVENT INJURY TO PERSONS AND DAMAGE TO THE PARTS.

- (a) Remove the RH aft baggage compartment lining ([AMM TASK 25-51-01-000-801-A/400](#)).

WARNING: WEAR GLOVES AND GOGGLES AND AVOID CONTACT WITH SOLVENT VAPORS DURING THE CLEANING.

- (b) Clean the RH aft baggage compartment lining with Rhodiasolve E-23 to remove dirt, oil, and debris.
- (c) With a 180 grit sandpaper, to fully remove the paint from the area where you will install the reinforcement plate.

NOTE: Be careful not to go through the first layer when you sand the area.

- (d) Clean the RH aft baggage compartment lining with Rhodiasolve E-23.

CAUTION: BONDING OPERATION MUST BE DONE IMMEDIATELY AFTER THE REINFORCED PLATE IS SANDED/CLEANED.

- (e) On the outside surface, position the reinforcement plates (7) over the lining panel. Refer to Figure 810, DET. P, sheet 10.

NOTE:

- Make sure that the alignment of the holes in the reinforcement plates (7) and in the lining are correct.
- Make sure that the reinforcement plates (7) do not go more than the lining borders.

CAUTION: WHEN USING THE BLANK REINFORCEMENT, THE MINIMUM DISTANCE ALLOWED BETWEEN THE CENTER OF THE NEW HOLE AND THE REINFORCEMENT EDGE IS 9 MM (0.35 IN).

- (f) If the reinforcement plates (7) go more than the lining borders, use a blank reinforcement plate. Refer to Figure 810, DET. R, sheet 10.

NOTE: Drill the hole according to the one existing in the lining.

WARNING: ADHESIVES ARE CLASSIFIED AS HAZARDOUS MATERIALS WHICH MAY CAUSE INJURY OR ILLNESS IF NOT PROPERLY USED. THESE PRODUCTS SHOULD BE USED ONLY IN ACCORDANCE WITH THE MANUFACTOR'S SPECIFIC SAFETY AND HEALTH RECOMMENDATIONS. PRIOR TO THE USE OF THESE PRODUCTS, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

- (g) Use the adhesive AV138 and the catalyst HV998 to bond the reinforcement plates (7).
- (h) Use the cure time according manufacturer's instructions.
- (i) Apply adhesive polyethylene tape (8) over the reinforcement plates (7). Refer to Figure 810, DET. D, sheet 4 and DET. P, sheet 10.
- (j) Use the same instructions to apply the reinforcement plates (9) to the inside surface. Refer to Figure 810, DET. L, sheet 10.

NOTE: On the inside surface the adhesive polyethylene tape is not applied.

CAUTION: TO BE A BAGGAGE COMPARTMENT LINING REINFORCED, THESE PROCEDURES MUST BE APPLIED TO ALL OF THE BAGGAGE COMPARTMENT LININGS.

- (4) Reinforce the upper middle baggage compartment lining as follow (refer to Figure 810, DET. E, sheet 5):

WARNING: THE BAGGAGE COMPARTMENT LININGS ARE FRAGILE, LARGE AND DIFFICULT TO MOVE. ASK FOR HELP TO MOVE THE LINERS AND BE CAREFUL TO PREVENT INJURY TO PERSONS AND DAMAGE TO THE PARTS.

- (a) Remove the upper middle baggage compartment lining ([AMM TASK 25-51-01-000-801-A/400](#)).

WARNING: WEAR GLOVES AND GOGGLES AND AVOID CONTACT WITH SOLVENT VAPORS DURING THE CLEANING.

- (b) Clean the upper middle baggage compartment lining with Rhodiasolve E-23 to remove dirt, oil, and debris.
- (c) With a 180 grit sandpaper, to fully remove the paint from the area where you will install the reinforcement plate.

NOTE: Be careful not to go through the first layer when you sand the area.

- (d) Clean the upper middle baggage compartment lining with Rhodiasolve E-23.

CAUTION: BONDING OPERATION MUST BE DONE IMMEDIATELY AFTER THE REINFORCED PLATE IS SANDED/CLEANED.

- (e) On the inside surface, position the reinforcement plates (10), (11) and (12) over the lining panel. Refer to Figure 810, DET. L, sheet 10.

- NOTE:**
- Make sure that the alignment of the holes in the reinforcement plates (10), (11) and (12) and in the lining are correct. Refer to Figure 810, DET. L, sheet 10.
 - Make sure that the reinforcement plates (10), (11) and (12) do not go more than the lining borders.

CAUTION: WHEN USING THE BLANK REINFORCEMENT, THE MINIMUM DISTANCE ALLOWED BETWEEN THE CENTER OF THE NEW HOLE AND THE REINFORCEMENT EDGE IS 9 MM (0.35 IN).

- (f) If the reinforcement plates (10), (11) and (12) go more than the lining borders, use a blank reinforcement plate. Refer to Figure 810, DET. R, sheet 10.

NOTE: Drill the hole according to the one existing in the lining.

WARNING: ADHESIVES ARE CLASSIFIED AS HAZARDOUS MATERIALS WHICH MAY CAUSE INJURY OR ILLNESS IF NOT PROPERLY USED. THESE PRODUCTS SHOULD BE USED ONLY IN ACCORDANCE WITH THE MANUFACTURER'S SPECIFIC SAFETY AND HEALTH RECOMMENDATIONS. PRIOR TO THE USE OF THESE PRODUCTS, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

- (g) Use the adhesive AV138 and the catalyst HV998 to bond the reinforcement plates (10), (11) and (12).
- (h) Use the cure time according manufacturer's instructions.

CAUTION: TO BE A BAGGAGE COMPARTMENT LINING REINFORCED, THESE PROCEDURES MUST BE APPLIED TO ALL OF THE BAGGAGE COMPARTMENT LININGS.

- (5) Reinforce the RH middle baggage compartment lining as follow (refer to Figure 810, DET. F, sheet 6):

WARNING: THE BAGGAGE COMPARTMENT LININGS ARE FRAGILE, LARGE AND DIFFICULT TO MOVE. ASK FOR HELP TO MOVE THE LINERS AND BE CAREFUL TO PREVENT INJURY TO PERSONS AND DAMAGE TO THE PARTS.

- (a) Remove the RH middle baggage compartment lining ([AMM TASK 25-51-01-000-801-A/400](#)).

WARNING: WEAR GLOVES AND GOGGLES AND AVOID CONTACT WITH SOLVENT VAPORS DURING THE CLEANING.

- (b) Clean the RH middle baggage compartment lining with Rhodiasolve E-23 to remove dirt, oil, and debris.
- (c) Use a razor to cut a piece of the carpet (refer to Figure 810, DET. Q, sheet 10).
- (d) With a 180 grit sandpaper, to fully remove the paint from the area where you will install the reinforcement plate.

NOTE: Be careful not to go through the first layer when you sand the area.

- (e) Clean the RH middle baggage compartment lining with Rhodiasolve E-23.

CAUTION: BONDING OPERATION MUST BE DONE IMMEDIATELY AFTER THE REINFORCED PLATE IS SANDED/CLEANED.

- (f) On the inside surface, position the reinforcement plates (13) and (14) over the lining panel. Refer to Figure 810, DET. L, sheet 10.

- NOTE:
- Make sure that the alignment of the holes in the reinforcement plates (13) and (14) and in the lining are correct. Refer to Figure 810, DET. L, sheet 10.
 - Make sure that the reinforcement plates (13) and (14) do not go more than the lining borders.

CAUTION: WHEN USING THE BLANK REINFORCEMENT, THE MINIMUM DISTANCE ALLOWED BETWEEN THE CENTER OF THE NEW HOLE AND THE REINFORCEMENT EDGE IS 9 MM (0.35 IN).

- (g) If the reinforcement plates (13) and (14) go more than the lining borders, use a blank reinforcement plate. Refer to Figure 810, DET. R, sheet 10.

NOTE: Drill the hole according to the one existing in the lining.

WARNING: ADHESIVES ARE CLASSIFIED AS HAZARDOUS MATERIALS WHICH MAY CAUSE INJURY OR ILLNESS IF NOT PROPERLY USED. THESE PRODUCTS SHOULD BE USED ONLY IN ACCORDANCE WITH THE MANUFACTURER'S SPECIFIC SAFETY AND HEALTH RECOMMENDATIONS. PRIOR TO THE USE OF THESE PRODUCTS, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

- (h) Use the adhesive AV138 and the catalyst HV998 to bond the reinforcement plates (13) and (14).
- (i) Use the cure time according manufacturer's instructions.

CAUTION: TO BE A BAGGAGE COMPARTMENT LINING REINFORCED, THESE PROCEDURES MUST BE APPLIED TO ALL OF THE BAGGAGE COMPARTMENT LININGS.

- (6) Reinforce the LH forward baggage compartment lining as follow (refer to Figure 810, DET. G, sheet 7):

WARNING: THE BAGGAGE COMPARTMENT LININGS ARE FRAGILE, LARGE AND DIFFICULT TO MOVE. ASK FOR HELP TO MOVE THE LINERS AND BE CAREFUL TO PREVENT INJURY TO PERSONS AND DAMAGE TO THE PARTS.

- (a) Remove the LH forward baggage compartment lining ([AMM TASK 25-51-01-000-801-A/400](#)).

WARNING: WEAR GLOVES AND GOGGLES AND AVOID CONTACT WITH SOLVENT VAPORS DURING THE CLEANING.

- (b) Clean the LH forward baggage compartment lining with Rhodiasolve E-23 to remove dirt, oil, and debris.
- (c) With a 180 grit sandpaper, to fully remove the paint from the area where you will install the reinforcement plate.

NOTE: Be careful not to go through the first layer when you sand the area.

- (d) Clean the LH forward baggage compartment lining with Rhodiasolve E-23.

CAUTION: BONDING OPERATION MUST BE DONE IMMEDIATELY AFTER THE REINFORCED PLATE IS SANDED/CLEANED.

- (e) On the outside surface, position the reinforcement plates (15) and (17) over the lining panel. Refer to Figure 810, DET. P, sheet 10.

NOTE:

- Make sure that the alignment of the holes in the reinforcement plates (15) and (17) in the lining are correct.
- Make sure that the reinforcement plates (15) and (17) do not go more than the lining borders.

CAUTION: WHEN USING THE BLANK REINFORCEMENT, THE MINIMUM DISTANCE ALLOWED BETWEEN THE CENTER OF THE NEW HOLE AND THE REINFORCEMENT EDGE IS 9 MM (0.35 IN).

- (f) If the reinforcement plates (15) and (17) go more than the lining borders, use a blank reinforcement plate. Refer to Figure 810, DET. R, sheet 10.

NOTE: Drill the hole according to the one existing in the lining.

WARNING: ADHESIVES ARE CLASSIFIED AS HAZARDOUS MATERIALS WHICH MAY CAUSE INJURY OR ILLNESS IF NOT PROPERLY USED. THESE PRODUCTS SHOULD BE USED ONLY IN ACCORDANCE WITH THE MANUFACTOR'S SPECIFIC SAFETY AND HEALTH RECOMMENDATIONS. PRIOR TO THE USE OF THESE PRODUCTS, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

- (g) Use the adhesive AV138 and the catalyst HV998 to bond the reinforcement plates (15) and (17).
- (h) Use the cure time according manufactor's instructions.
- (i) Apply adhesive polyethylene tape (16) and (18) over the reinforcement plates (15) and (17). Refer to Figure 810, DET. G, sheet 7 and DET. P, sheet 10.
- (j) Use the same instructions to apply the reinforcement plates (19) and (20) to the inside surface. Refer to Figure 810, DET. G, sheet 7 and DET. L and DET. M, sheet 10.

- NOTE:**
- Make sure that the reinforcement plates (19) and (20) do not go more than the radius of the lining.
 - On the inside surface the adhesive polyethylene tape is not applied.

CAUTION: TO BE A BAGGAGE COMPARTMENT LINING REINFORCED, THESE PROCEDURES MUST BE APPLIED TO ALL OF THE BAGGAGE COMPARTMENT LININGS.

- (7) Reinforce the RH forward baggage compartment lining as follow (refer to Figure 810, DET. J, sheet 8):

WARNING: THE BAGGAGE COMPARTMENT LININGS ARE FRAGILE, LARGE AND DIFFICULT TO MOVE. ASK FOR HELP TO MOVE THE LINERS AND BE CAREFUL TO PREVENT INJURY TO PERSONS AND DAMAGE TO THE PARTS.

- (a) Remove RH forward baggage compartment lining ([AMM TASK 25-51-01-000-801-A/400](#)).

WARNING: WEAR GLOVES AND GOGGLES AND AVOID CONTACT WITH SOLVENT VAPORS DURING THE CLEANING.

- (b) Clean the RH forward baggage compartment lining with Rhodiasolve E-23 to remove dirt, oil, and debris.
- (c) With a 180 grit sandpaper, to fully remove the paint from the area where you will install the reinforcement plates.

NOTE: Be careful not to go through the first layer when you sand the area.

- (d) Clean the RH forward baggage compartment lining with Rhodiasolve E-23.

CAUTION: BONDING OPERATION MUST BE DONE IMMEDIATELY AFTER THE REINFORCED PLATE IS SANDED/CLEANED.

- (e) On the outside surface, position the reinforcement plates (21) over the lining panel.

- NOTE:**
- Make sure that the alignment of the holes in the reinforcement plates (21) and in the lining are correct.
 - Make sure that the reinforcement plates (21) do not go more than the lining borders.

CAUTION: WHEN USING THE BLANK REINFORCEMENT, THE MINIMUM DISTANCE ALLOWED BETWEEN THE CENTER OF THE NEW HOLE AND THE REINFORCEMENT EDGE IS 9 MM (0.35 IN).

- (f) If the reinforcement plates (21) go more than the lining borders, use a blank reinforcement plate. Refer to Figure 810, DET. R, sheet 10.

NOTE: Drill the hole according to the one existing in the lining.

WARNING: ADHESIVES ARE CLASSIFIED AS HAZARDOUS MATERIALS WHICH MAY CAUSE INJURY OR ILLNESS IF NOT PROPERLY USED. THESE PRODUCTS SHOULD BE USED ONLY IN ACCORDANCE WITH THE MANUFACTOR'S SPECIFIC SAFETY AND HEALTH RECOMMENDATIONS. PRIOR TO THE USE OF THESE PRODUCTS, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

- (g) Use the adhesive AV138 and the catalyst HV998 to bond the reinforcement plates (21).
- (h) Use the cure time according manufacturer's instructions.
- (i) Apply adhesive polyethylene tape (22) over the reinforcement plates (21). Refer to Figure 810, DET. J, sheet 8 and DET. P, sheet 10.
- (j) Use the same instructions to apply the reinforcement plates (23) to the inside surface. Refer to Figure 810, DET. J, sheet 8 and DET. L, sheet 10.

NOTE: On the inside surface the adhesive polyethylene tape is not applied.

CAUTION: TO BE A BAGGAGE COMPARTMENT LINING REINFORCED, THESE PROCEDURES MUST BE APPLIED TO ALL OF THE BAGGAGE COMPARTMENT LININGS.

- (8) Reinforce the upper forward baggage compartment lining as follow (refer to Figure 810, DET. H, sheet 9):

WARNING: THE BAGGAGE COMPARTMENT LININGS ARE FRAGILE, LARGE AND DIFFICULT TO MOVE. ASK FOR HELP TO MOVE THE LINERS AND BE CAREFUL TO PREVENT INJURY TO PERSONS AND DAMAGE TO THE PARTS.

- (a) Remove upper forward baggage compartment lining ([AMM TASK 25-51-01-000-801-A/400](#)).

WARNING: WEAR GLOVES AND GOGGLES AND AVOID CONTACT WITH SOLVENT VAPORS DURING THE CLEANING.

- (b) Clean the upper forward baggage compartment lining with Rhodiasolve E-23 to remove dirt, oil, and debris.
- (c) With a 180 grit sandpaper, to fully remove the paint from the area where you will install the reinforcement plates.

NOTE: Be careful not to go through the first layer when you sand the area.

- (d) Clean the upper forward baggage compartment lining with Rhodiasolve E-23.

CAUTION: BONDING OPERATION MUST BE DONE IMMEDIATELY AFTER THE REINFORCED PLATE IS SANDED/CLEANED.

- (e) On the outside surface, position the reinforcement plates (25) over the lining panel. Refer to Figure 810, DET. P, sheet 10.

- NOTE:**
- Make sure that the alignment of the holes in the reinforcement plates (25) and in the lining are correct.
 - Make sure that the reinforcement plates (25) do not go more than the lining borders.

CAUTION: WHEN USING THE BLANK REINFORCEMENT, THE MINIMUM DISTANCE ALLOWED BETWEEN THE CENTER OF THE NEW HOLE AND THE REINFORCEMENT EDGE IS 9 MM (0.35 IN).

- (f) If the reinforcement plates (25) go more than the lining borders, use a blank reinforcement plate. Refer to Figure 810, DET. R, sheet 10.

NOTE: Drill the hole according to the one existing in the lining.

WARNING: ADHESIVES ARE CLASSIFIED AS HAZARDOUS MATERIALS WHICH MAY CAUSE INJURY OR ILLNESS IF NOT PROPERLY USED. THESE PRODUCTS SHOULD BE USED ONLY IN ACCORDANCE WITH THE MANUFACTOR'S SPECIFIC SAFETY AND HEALTH RECOMMENDATIONS. PRIOR TO THE USE OF THESE PRODUCTS, CAREFULLY READ THE APPLICABLE "MATERIAL SAFETY DATA SHEET" AND FOLLOW ALL LISTED SAFETY AND HEALTH PRECAUTIONS.

- (g) Use the adhesive AV138 and the catalyst HV998 to bond the reinforcement plates (25).
- (h) Use the cure time according manufactor's instructions.
- (i) Apply adhesive polyethylene tape (26) over the reinforcement plates (25). Refer to Figure 810, DET. H, sheet 9 and DET. P, sheet 10.
- (j) Use the same instructions to apply the reinforcement plates (24) to the inside surface. Refer to Figure 810, DET. H, sheet 9 and DET. L, sheet 10.

NOTE: On the inside surface the adhesive polyethylene tape is not applied.

- (9) After all the baggage linings are reinforced, at the fuselage apply the a fuselage frames protection as follows (refer to Figure 811):
- (a) Identify the frames with points to be protected with polyethylene adhesive tape. Refer to DET. B, sheet 2.

WARNING: WEAR GLOVES AND GOGGLES AND AVOID CONTACT WITH SOLVENT VAPORS DURING THE CLEANING.

- (b) Clean the frame 61 with Rhodiasolve E-23 to remove dirt, oil, and debris. Refer to VIEW C-C, sheet 3.
- (c) At the fuselage frame 61, identify the points that must be protected. Refer to VIEW C-C, sheet 3.
- (d) Apply adhesive polyethylene tape (1). Refer DET. G and DET. H, sheet 8.

WARNING: WEAR GLOVES AND GOGGLES AND AVOID CONTACT WITH SOLVENT VAPORS DURING THE CLEANING.

- (e) Clean the frame 65 with Rhodiasolve E-23 to remove dirt, oil, and debris. Refer to VIEW D-D, sheet 4.
- (f) At the fuselage frame 65, identify the points that must be protected. Refer to VIEW D-D, sheet 4.
- (g) Apply adhesive polyethylene tape (2). Refer DET. L and DET. G, sheet 7 and sheet 8.

WARNING: WEAR GLOVES AND GOGGLES AND AVOID CONTACT WITH SOLVENT VAPORS DURING THE CLEANING.

- (h) Clean the frame 68 with Rhodiasolve E-23 to remove dirt, oil, and debris. Refer to VIEW E-E, sheet 5.
- (i) At the fuselage frame 68, identify the points that must be protected. Refer to VIEW E-E, sheet 5.
- (j) Apply adhesive polyethylene tape (3). Refer DET. M and DET. G, sheet 7 and sheet 8.

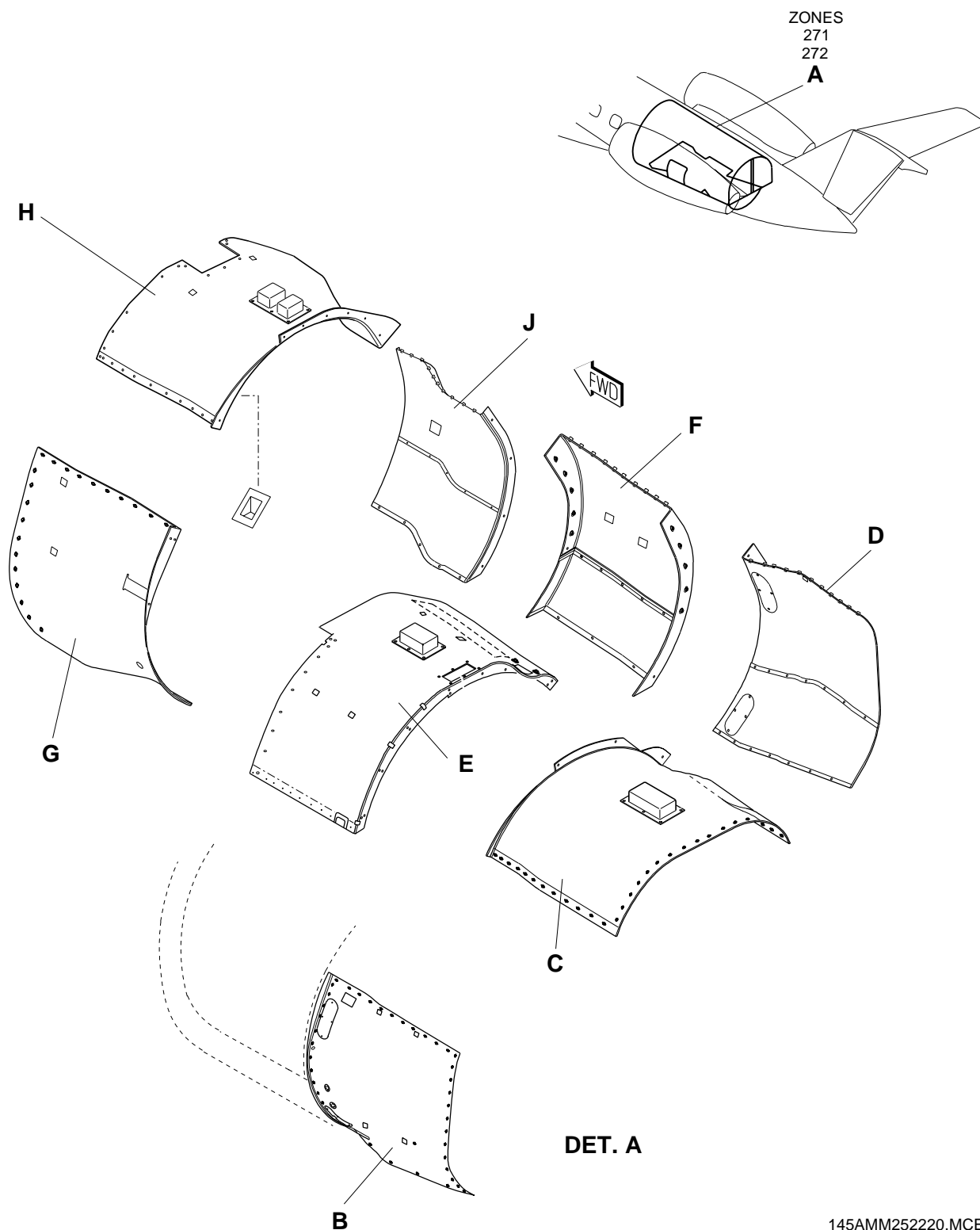
WARNING: WEAR GLOVES AND GOGGLES AND AVOID CONTACT WITH SOLVENT VAPORS DURING THE CLEANING.

- (k) Clean the frame 73 with Rhodiasolve E-23 to remove dirt, oil, and debris. Refer to VIEW F-F, sheet 6.
 - (l) At the fuselage frame 73, identify the points that must be protected. Refer to VIEW F-F, sheet 5.
 - (m) Apply adhesive polyethylene tape (4). Refer DET. G and DET. H, sheet 8.
- (10) Install all the baggage compartment linings ([AMM TASK 25-51-01-400-801-A/400](#)).

EFFECTIVITY: ALL

Baggage Compartment Lining - Reinforcement

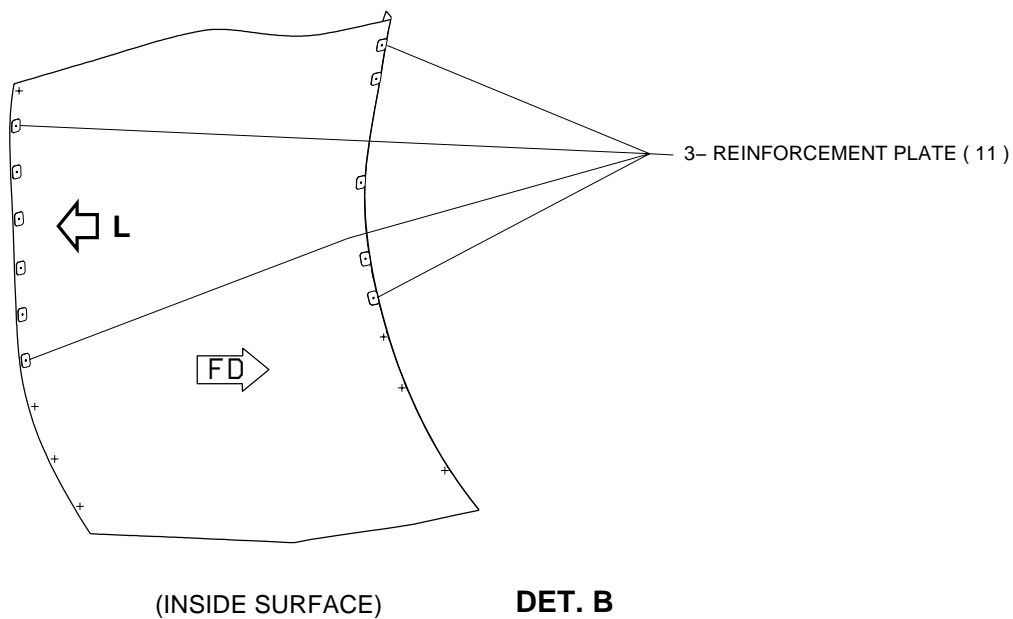
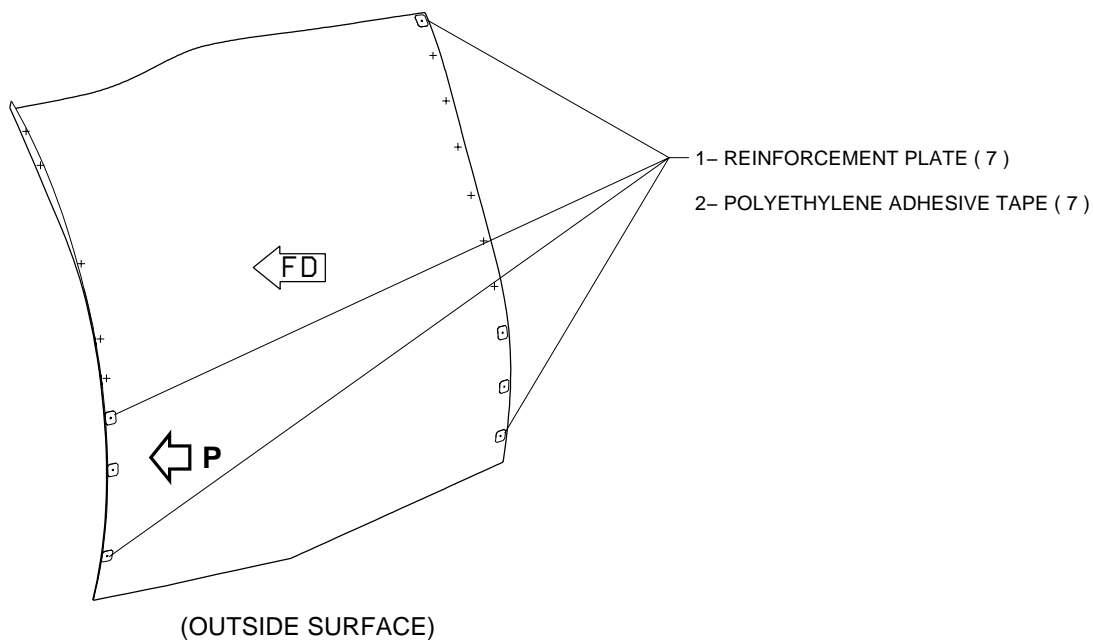
Figure 810 - Sheet 1



EFFECTIVITY: ALL

Baggage Compartment Lining - Reinforcement

Figure 810 - Sheet 2

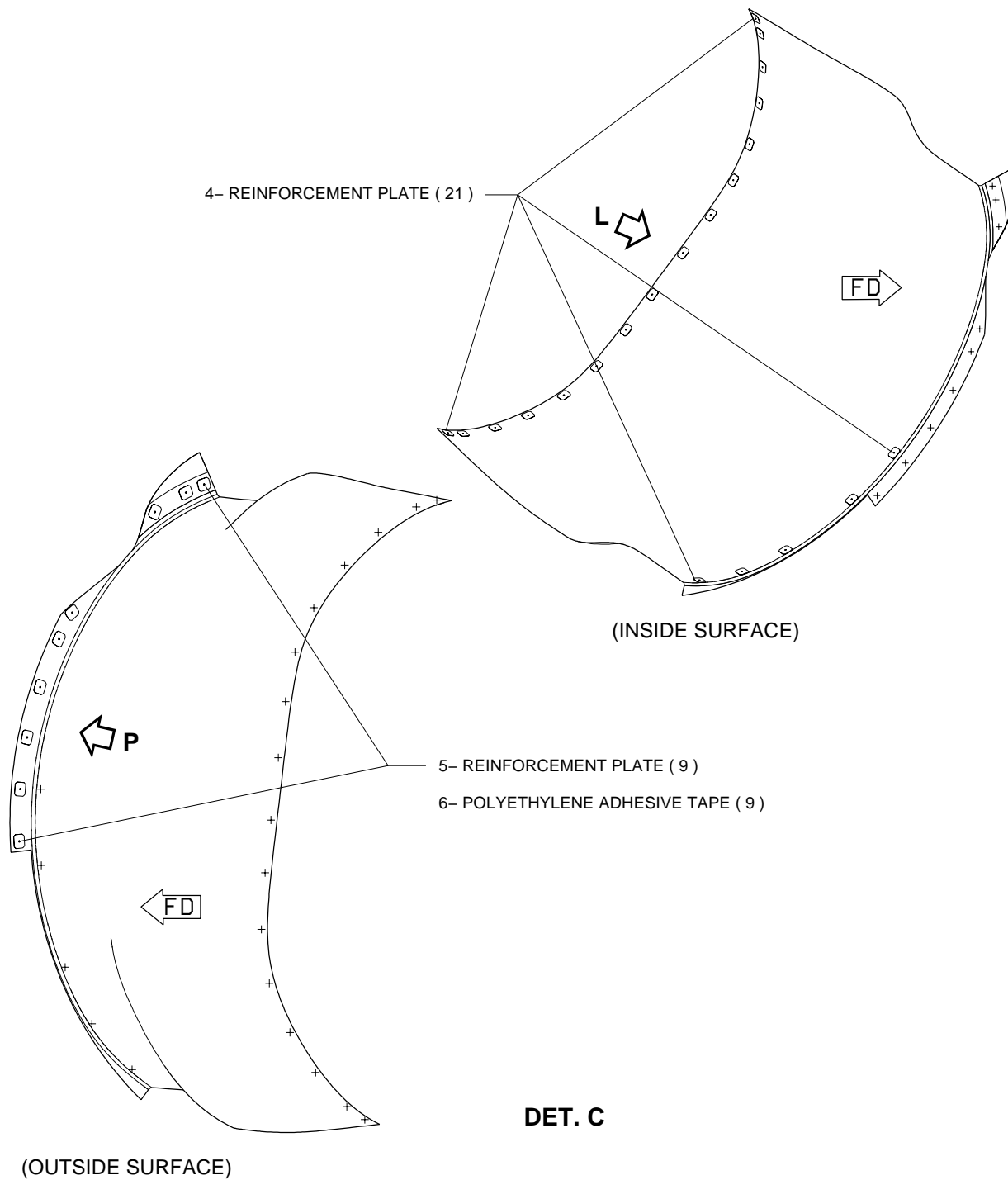


145AMM252221.MCE

EFFECTIVITY: ALL

Baggage Compartment Lining - Reinforcement

Figure 810 - Sheet 3

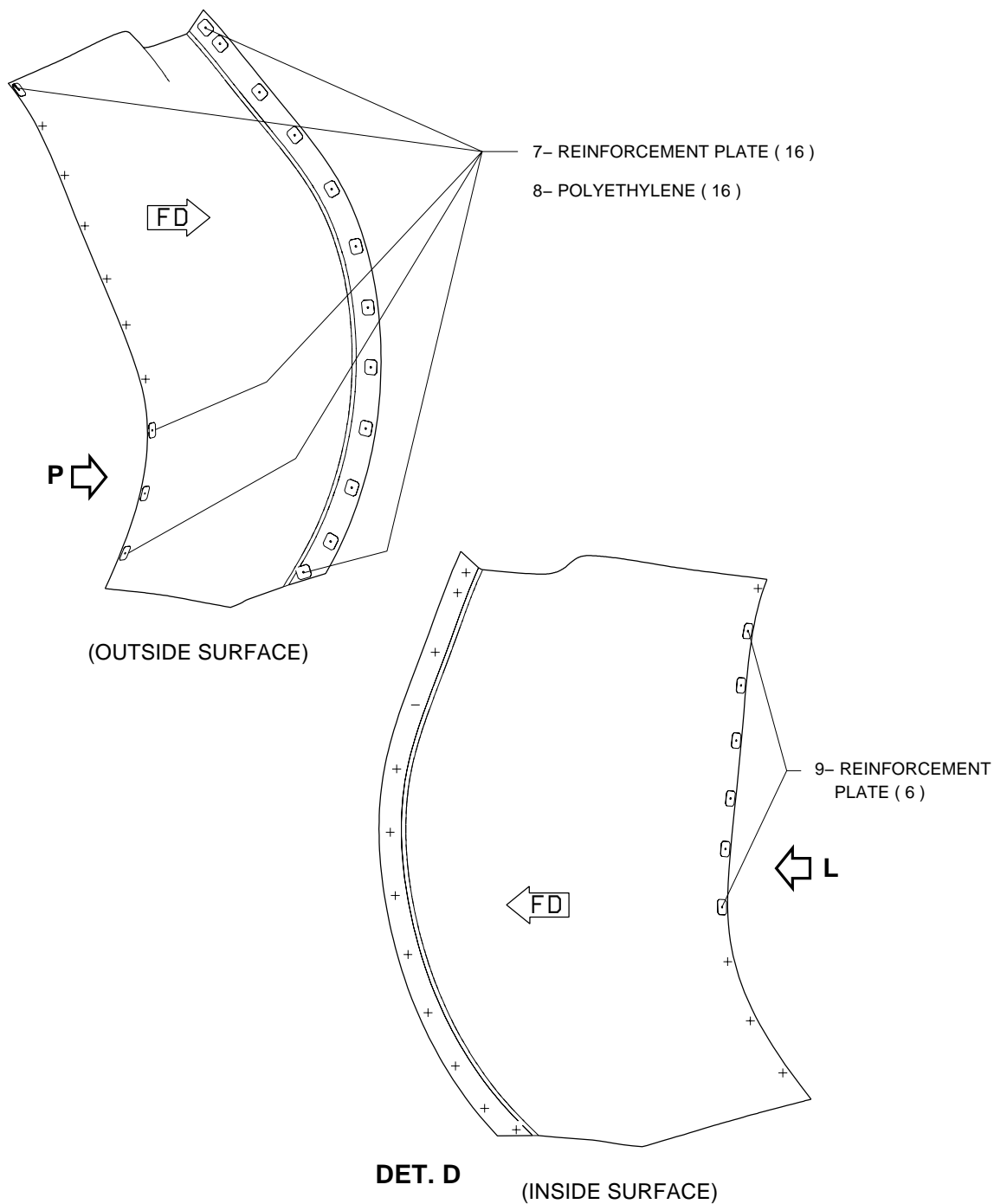


145AMM252222.MCE

EFFECTIVITY: ALL

Baggage Compartment Lining - Reinforcement

Figure 810 - Sheet 4

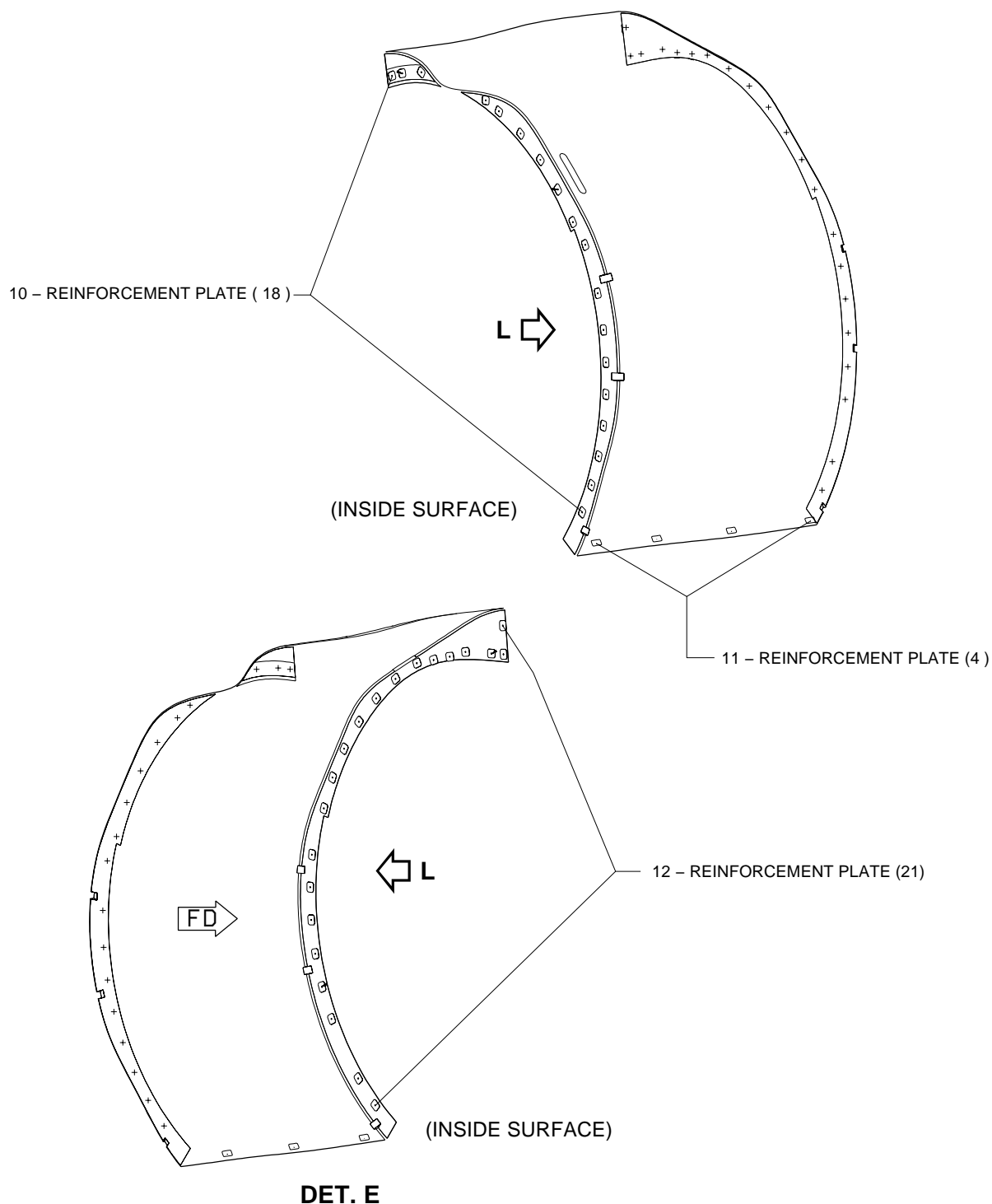


145AMM252223.MCE

EFFECTIVITY: ALL

Baggage Compartment Lining - Reinforcement

Figure 810 - Sheet 5

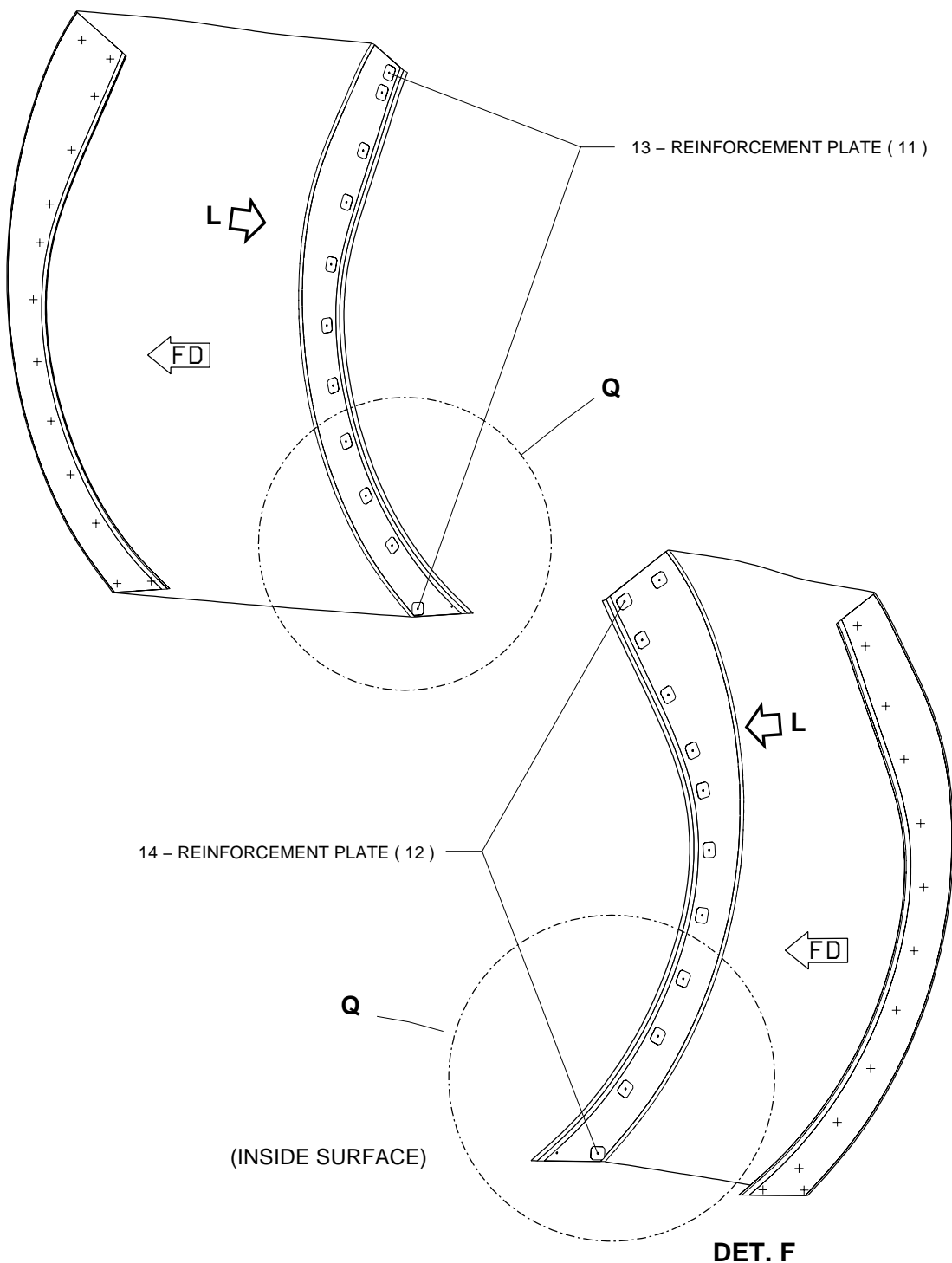


145AMM252224.MCE

EFFECTIVITY: ALL

Baggage Compartment Lining - Reinforcement

Figure 810 - Sheet 6

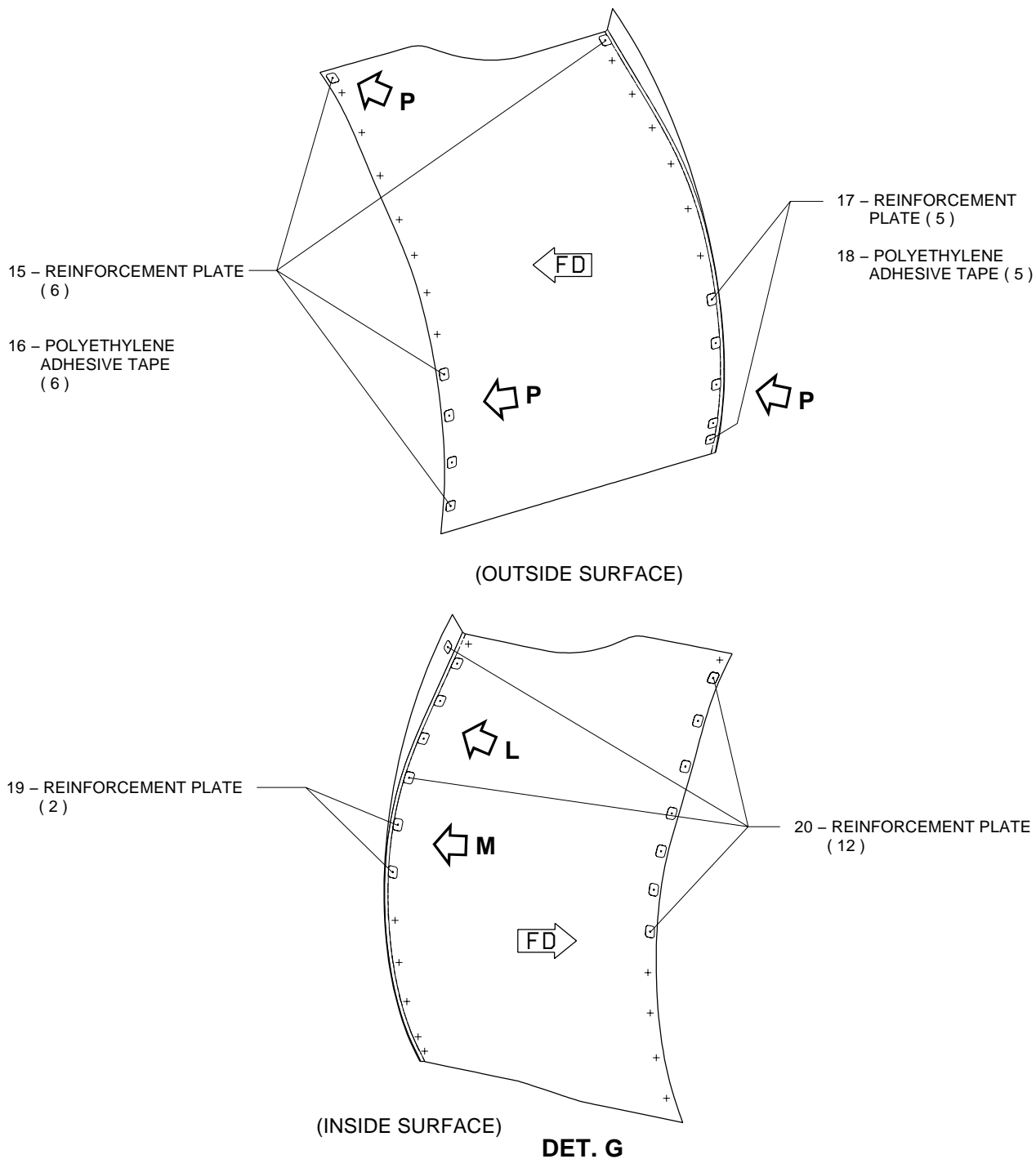


145AMM252225A.MCE

EFFECTIVITY: ALL

Baggage Compartment Lining - Reinforcement

Figure 810 - Sheet 7

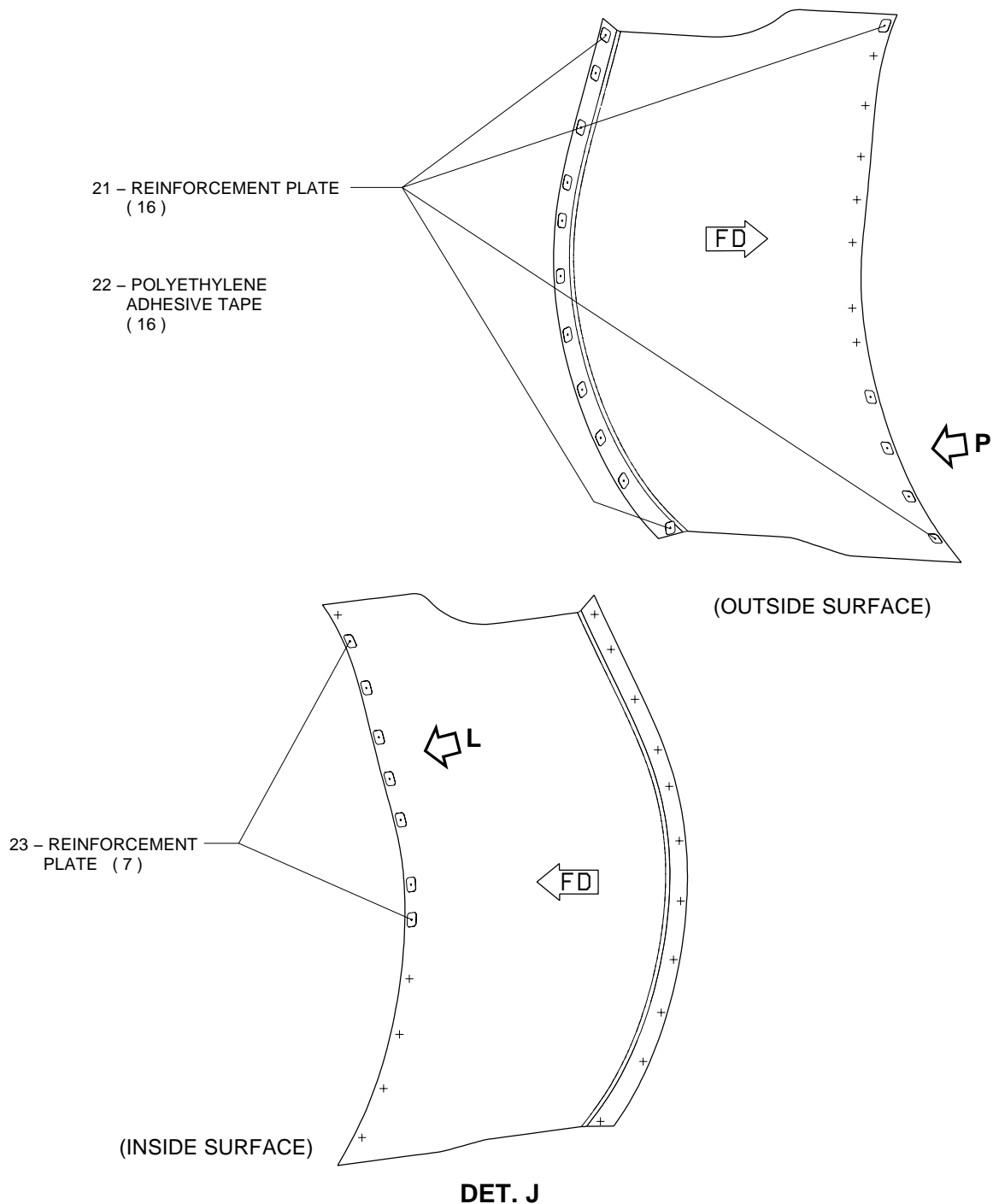


145AMM252226.MCE

EFFECTIVITY: ALL

Baggage Compartment Lining - Reinforcement

Figure 810 - Sheet 8

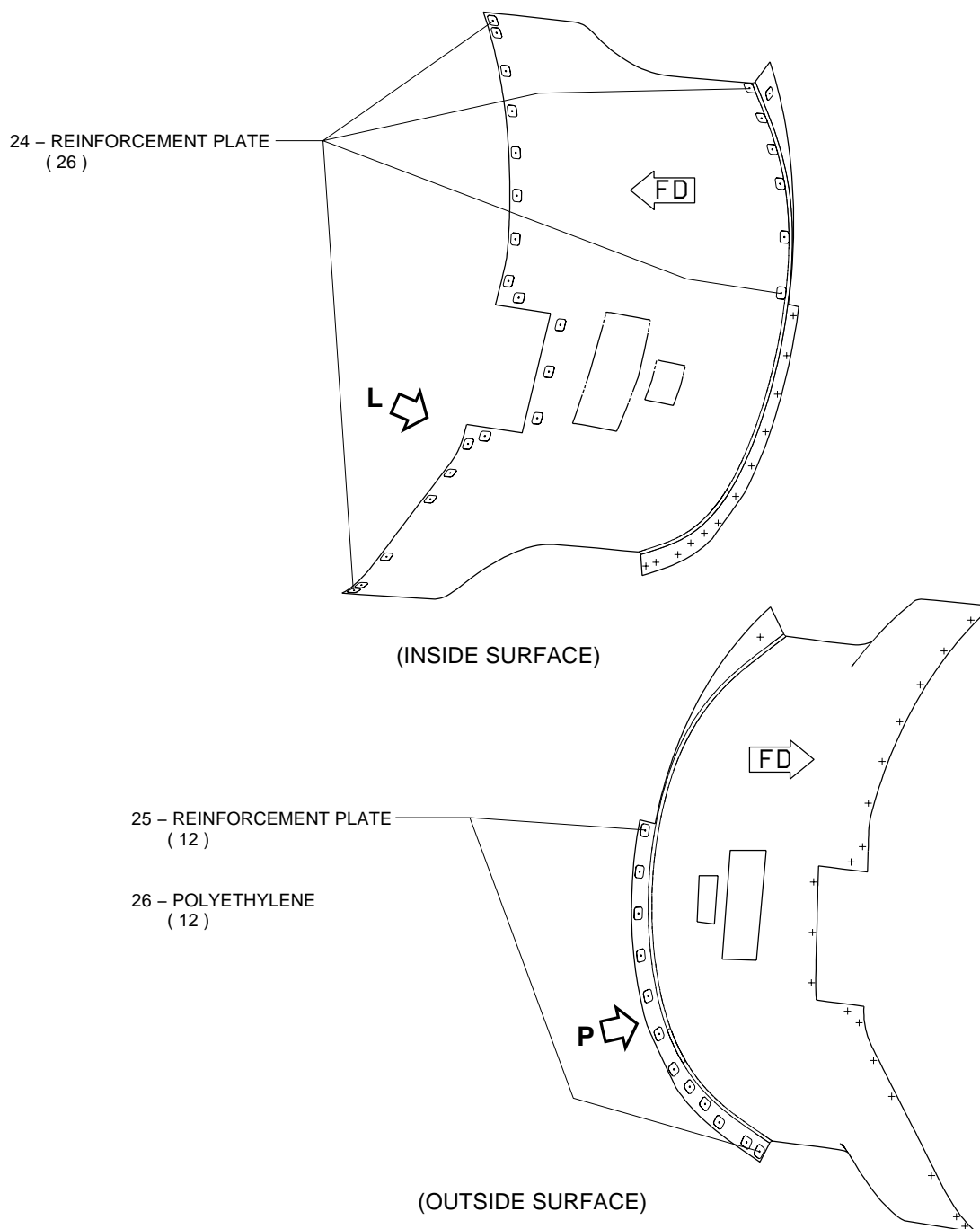


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EFFECTIVITY: ALL

Baggage Compartment Lining - Reinforcement

Figure 810 - Sheet 9



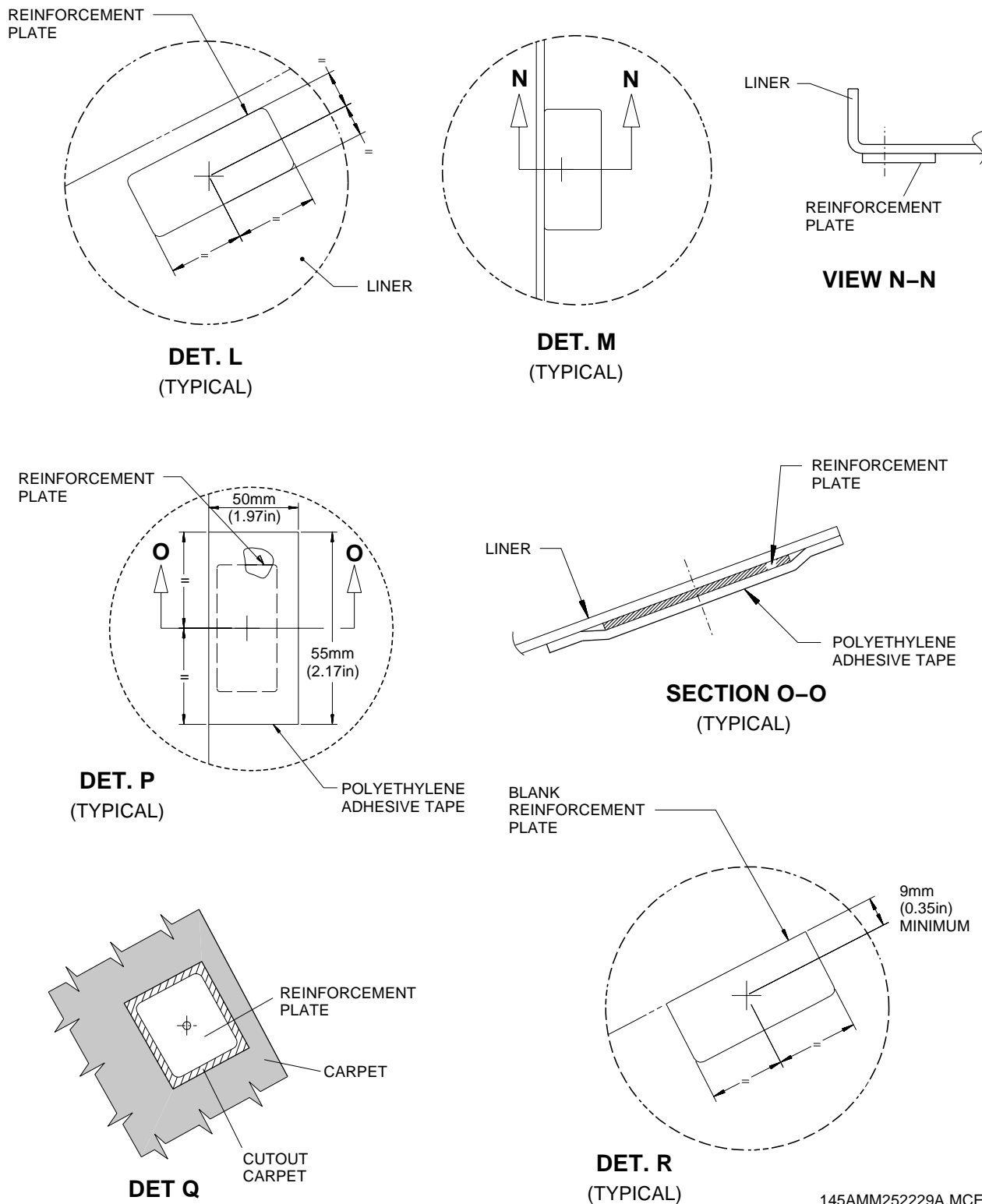
DET. H

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EFFECTIVITY: ALL

Baggage Compartment Lining - Reinforcement

Figure 810 - Sheet 10

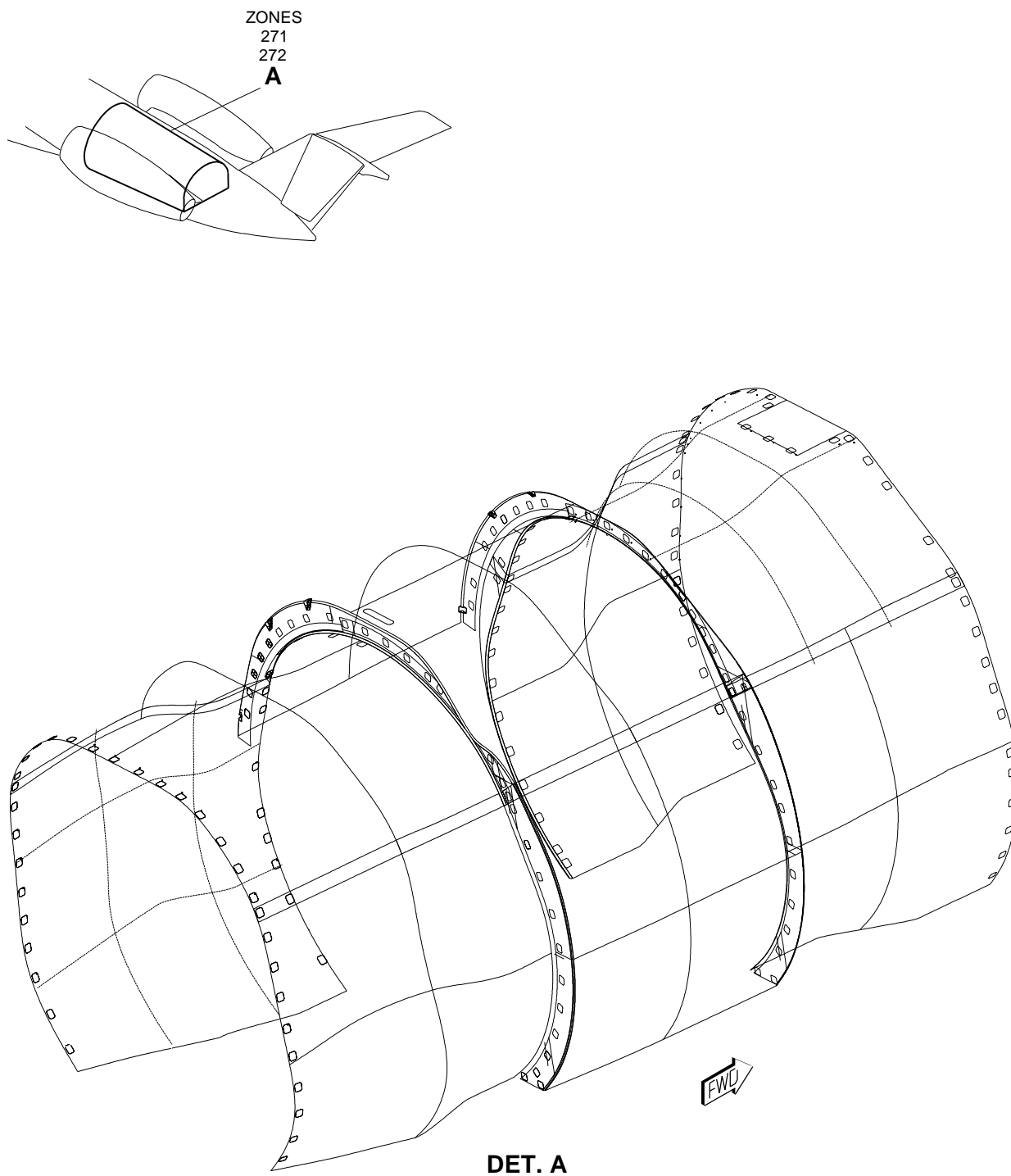


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EFFECTIVITY: ALL

Baggage Compartment Lining - Fuselage Frames Protection

Figure 811 - Sheet 1

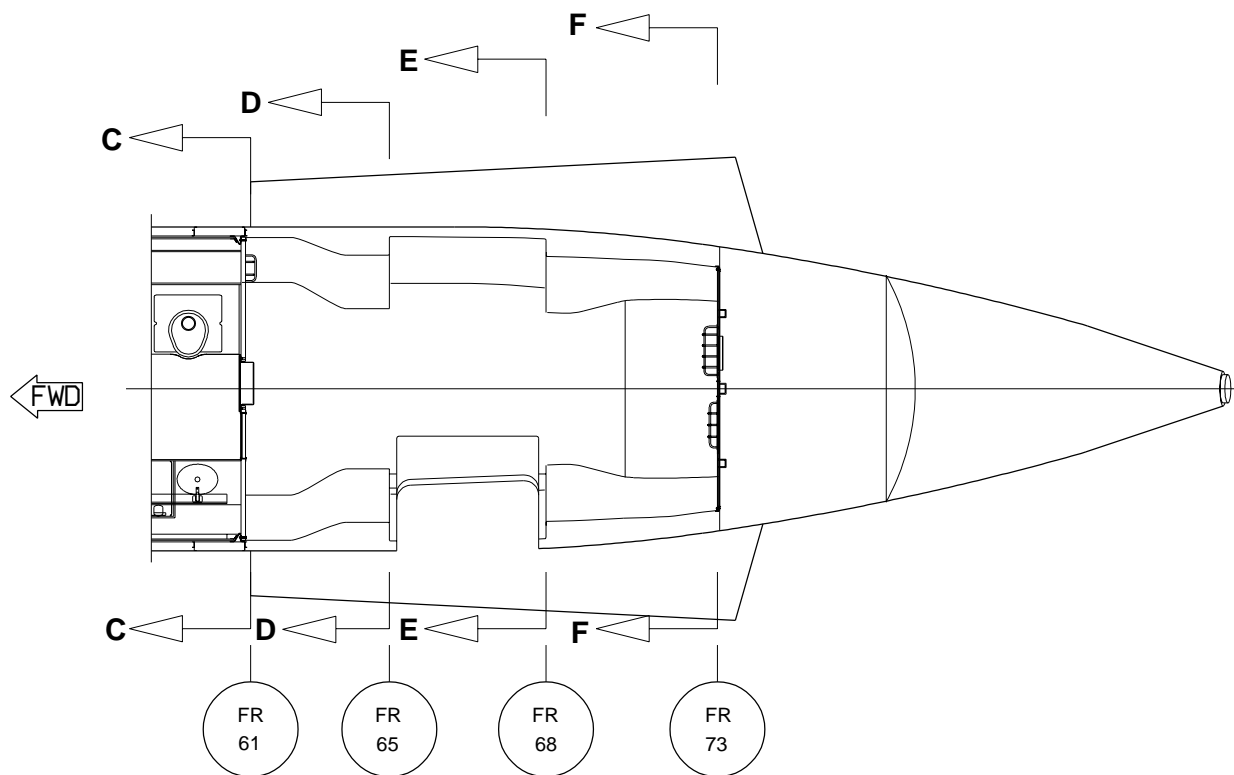


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EFFECTIVITY: ALL

Baggage Compartment Lining - Fuselage Frames Protection

Figure 811 - Sheet 2



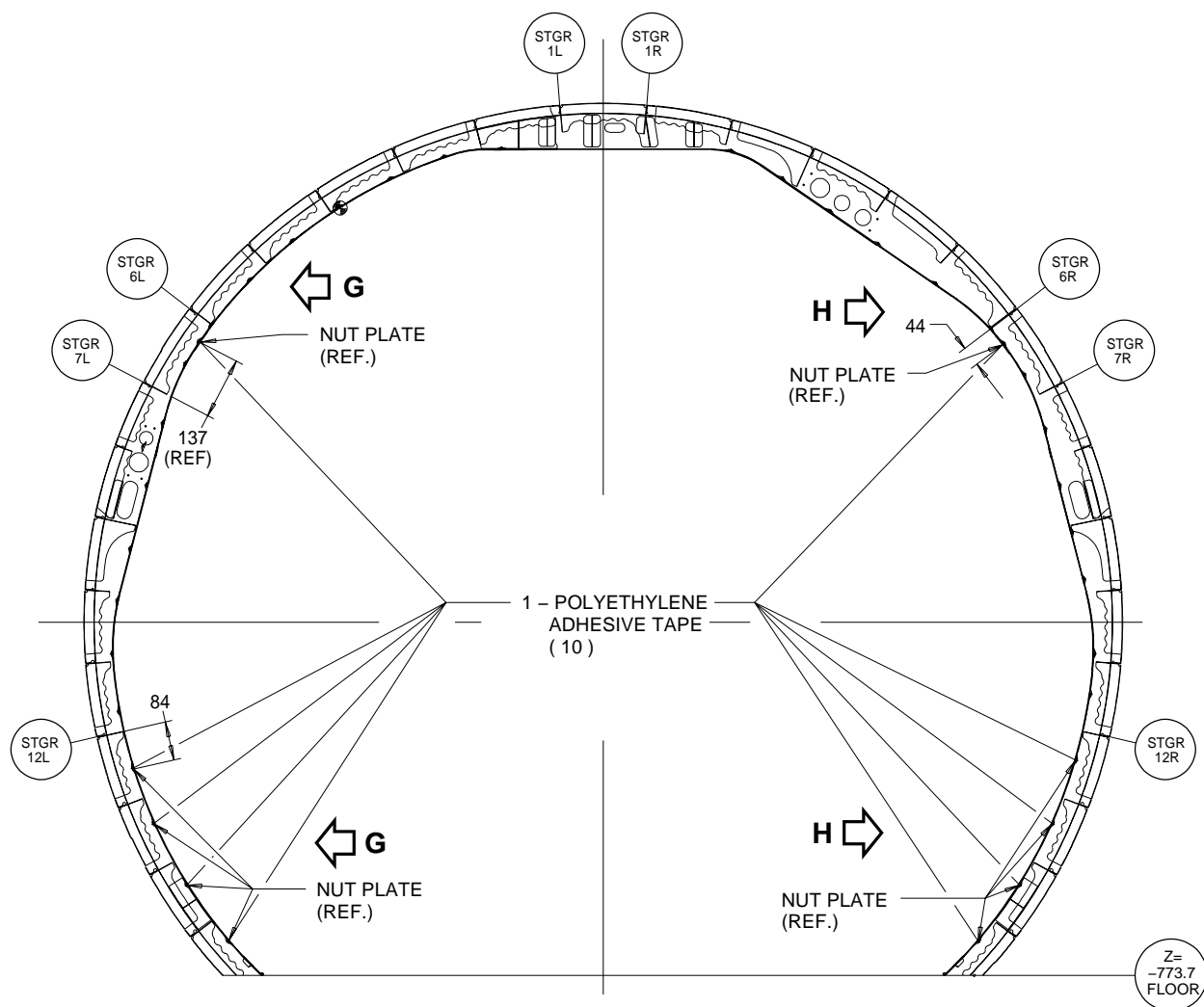
**FUSELAGE FRAMES
(TYPICAL)
DET. B**

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EFFECTIVITY: ALL

Baggage Compartment Lining - Fuselage Frames Protection

Figure 811 - Sheet 3



FRAME 61
VIEW C-C

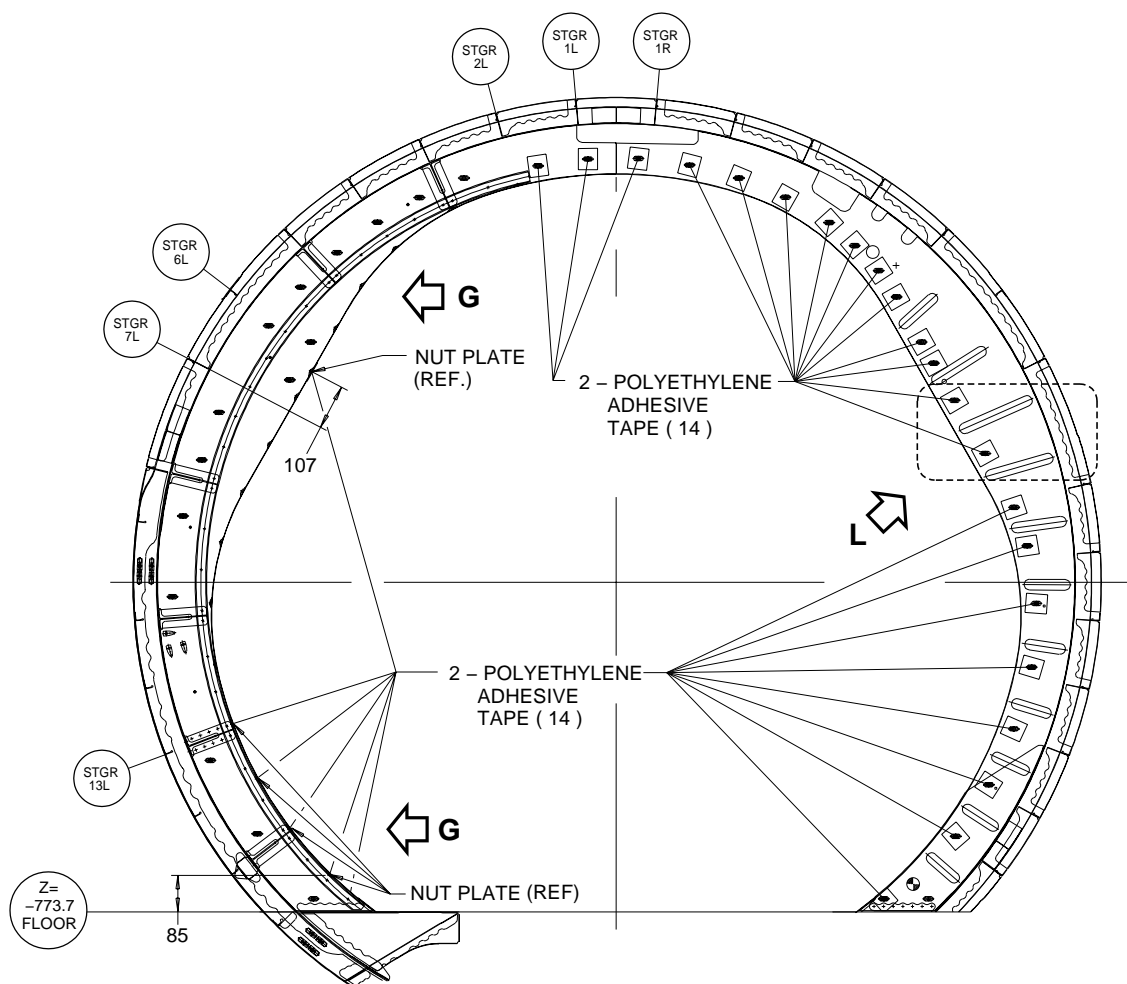
– DIMENSIONS IN mm.

145AMM252232.MCE

EFFECTIVITY: ALL

Baggage Compartment Lining - Fuselage Frames Protection

Figure 811 - Sheet 4



FRAME 65

VIEW D-D

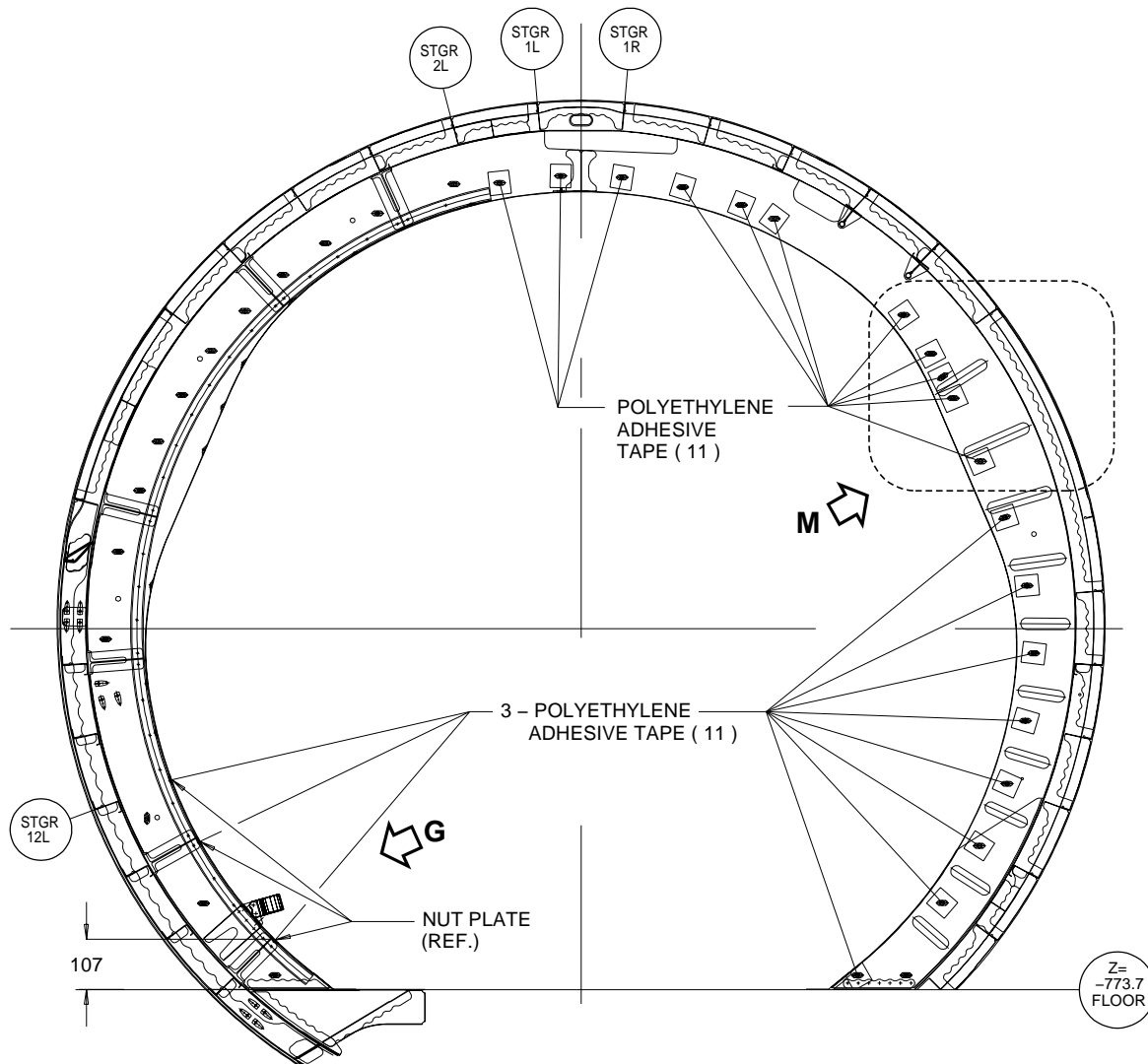
– DIMENSIONS IN mm.

145AMM252233.MCE

EFFECTIVITY: ALL

Baggage Compartment Lining - Fuselage Frames Protection

Figure 811 - Sheet 5



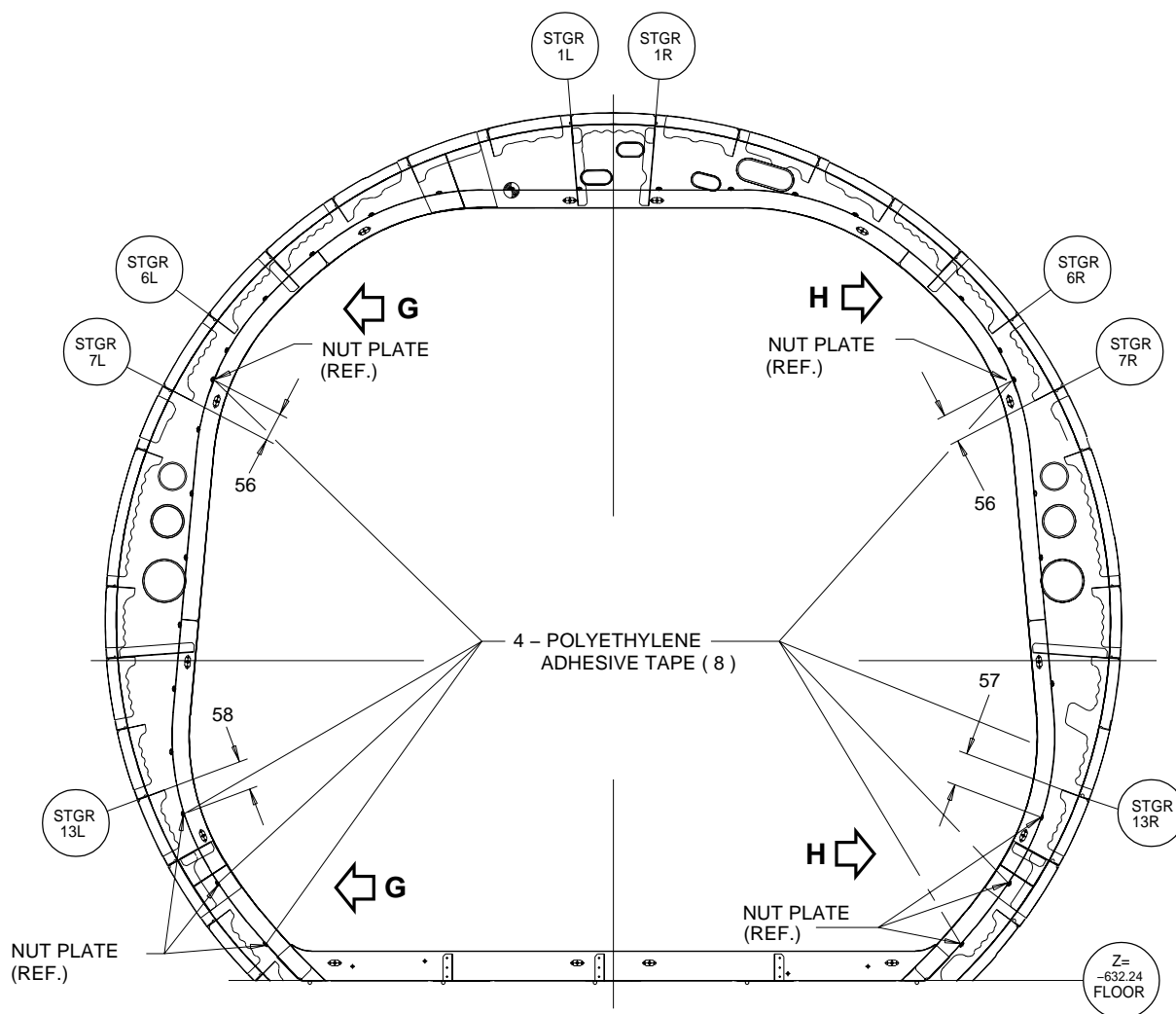
**FRAME 68
VIEW E-E**

145AMM252234A.MCE

EFFECTIVITY: ALL

Baggage Compartment Lining - Fuselage Frames Protection

Figure 811 - Sheet 6



FRAME 73

VIEW F-F

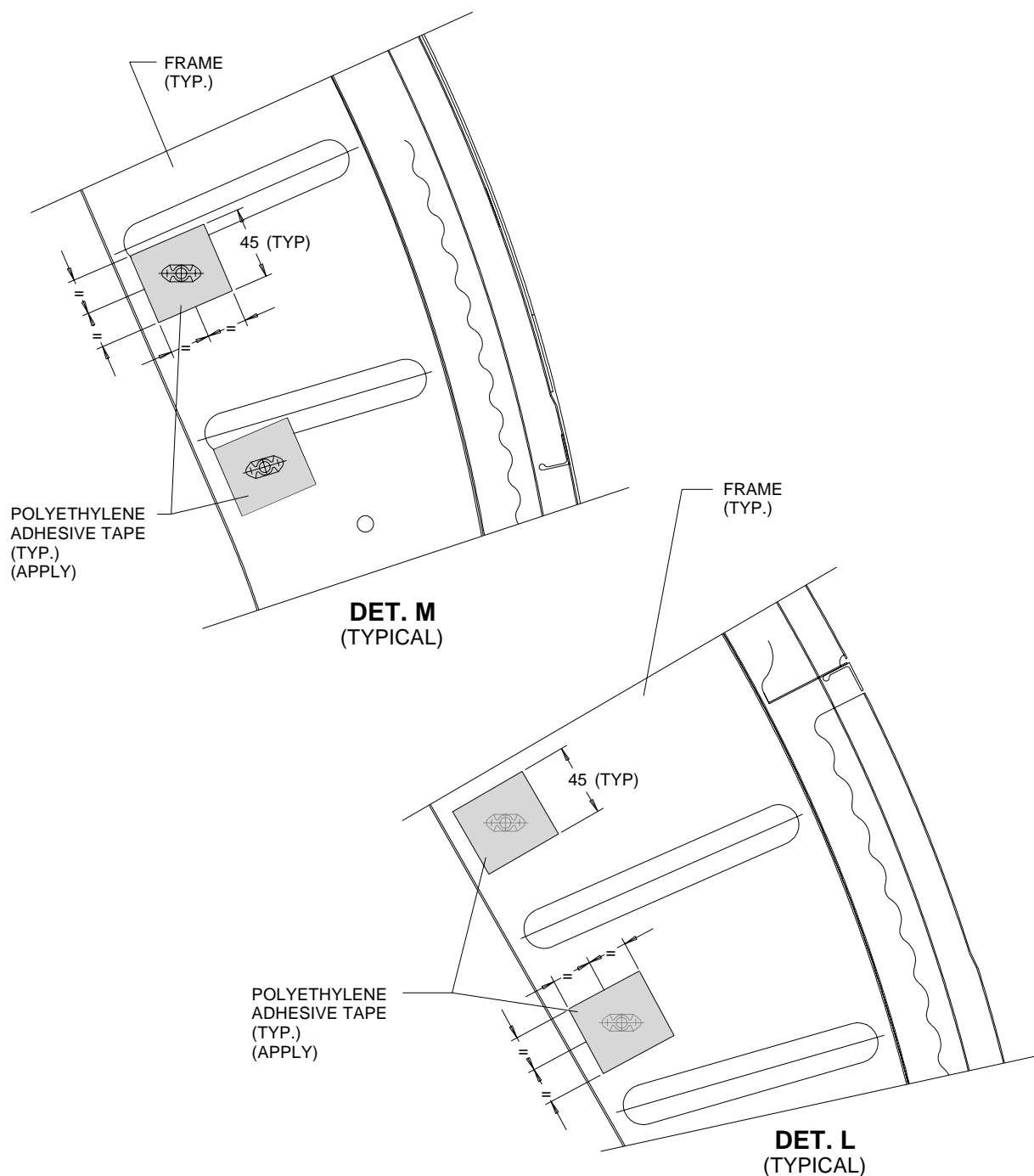
- DIMENSIONS IN mm.

145AMM252235.MCE

EFFECTIVITY: ALL

Baggage Compartment Lining - Fuselage Frames Protection

Figure 811 - Sheet 7

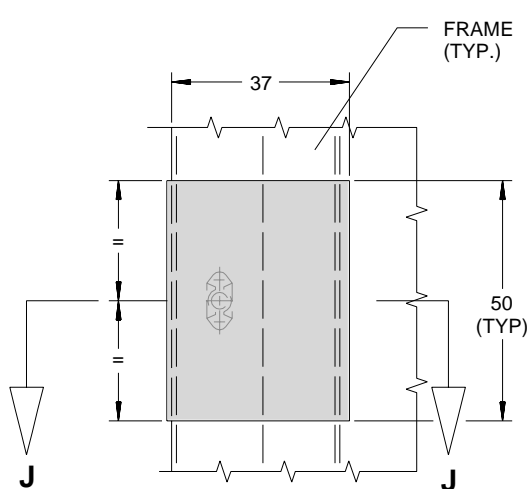


145AMM252236.MCE

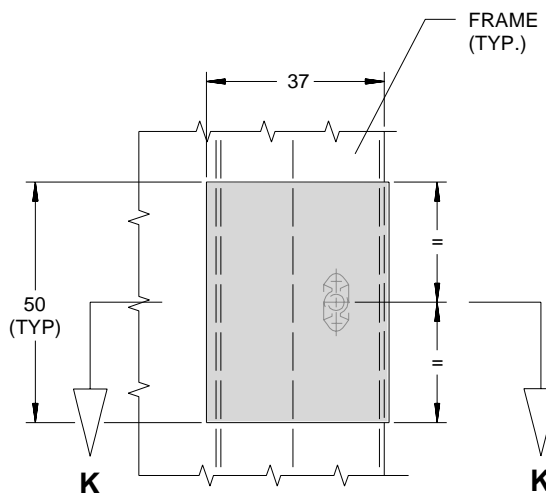
EFFECTIVITY: ALL

Baggage Compartment Lining - Fuselage Frames Protection

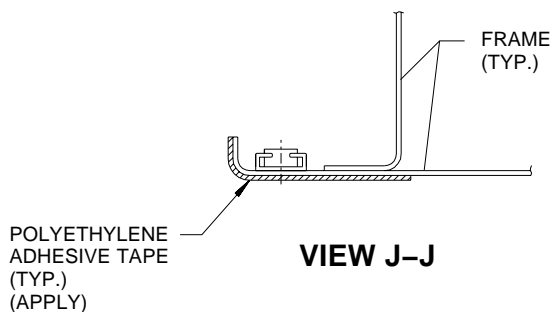
Figure 811 - Sheet 8



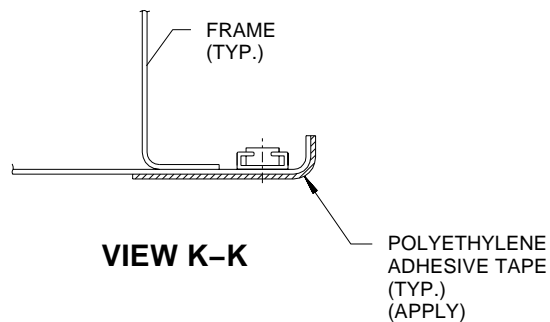
DET. G



DET. H



VIEW J-J



VIEW K-K

145AMM252237.MCE