

ELEVATOR TIPS - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the elevator 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).

TASK NUMBER	DESCRIPTION	EFFECTIVITY
55-20-01-000-801-A	ELEVATOR TIPS - REMOVAL	ALL
55-20-01-400-801-A	ELEVATOR TIPS - INSTALLATION	ALL

TASK 55-20-01-000-801-A

EFFECTIVITY: ALL

2. ELEVATOR TIPS - REMOVAL

A. General

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

B. References

REFERENCE	DESIGNATION
SRM 51-20-01-PR	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
335		Elevator - LH
336		Elevator - RH

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 old 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

SPECIFICATION (BRAND)	DESCRIPTION	QTY
ASTM-D-740	Methyl Ethyl Ketone - MEK	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Elevator tips

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

SUBTASK 020-002-A

- (1) Remove the screws (1) that attach the elevator tip (2) to its frame. Refer to [Figure 401](#); DET. B.
- (2) Remove the elevator tip (2). Refer to [Figure 401](#); DET. B.
- (3) Remove the old aerodynamic sealant and prepare the surface. Refer to SRM 51-20-01-PR.

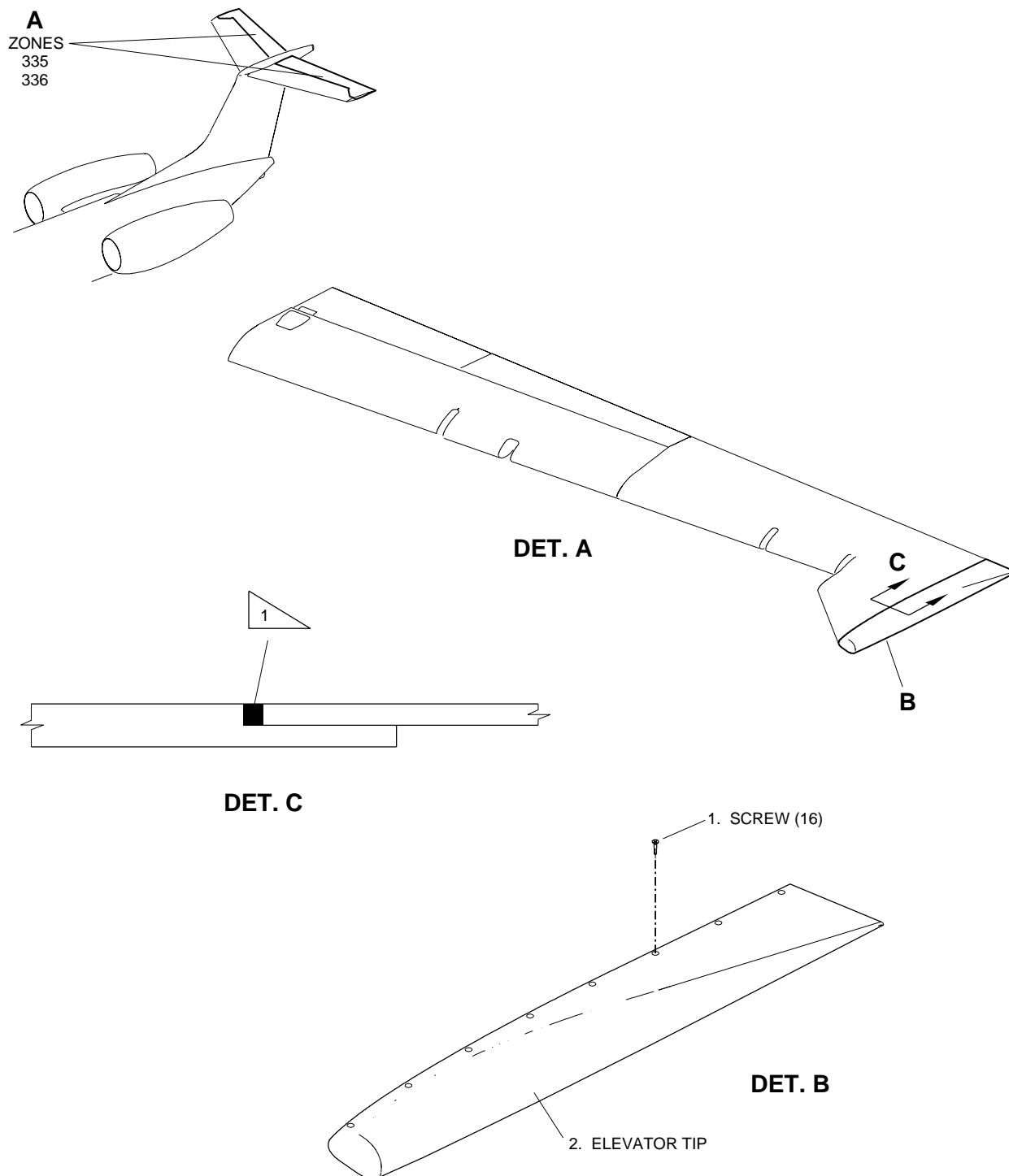
WARNING: BE CAREFUL WHEN YOU USE SOLVENTS BECAUSE THEY ARE A HEALTH AND FIRE HAZARD. USE SAFETY GOGGLES AND PROTECTIVE CLOTHING WHEN YOU HANDLE THEM. DO NOT BREATHE THEIR GASES AND WORK IN A WELL VENTILATED AREA.

- (4) With a cloth soaked in MEK, clean the surface.

EFFECTIVITY: ALL

Elevator Tips - Removal/Installation

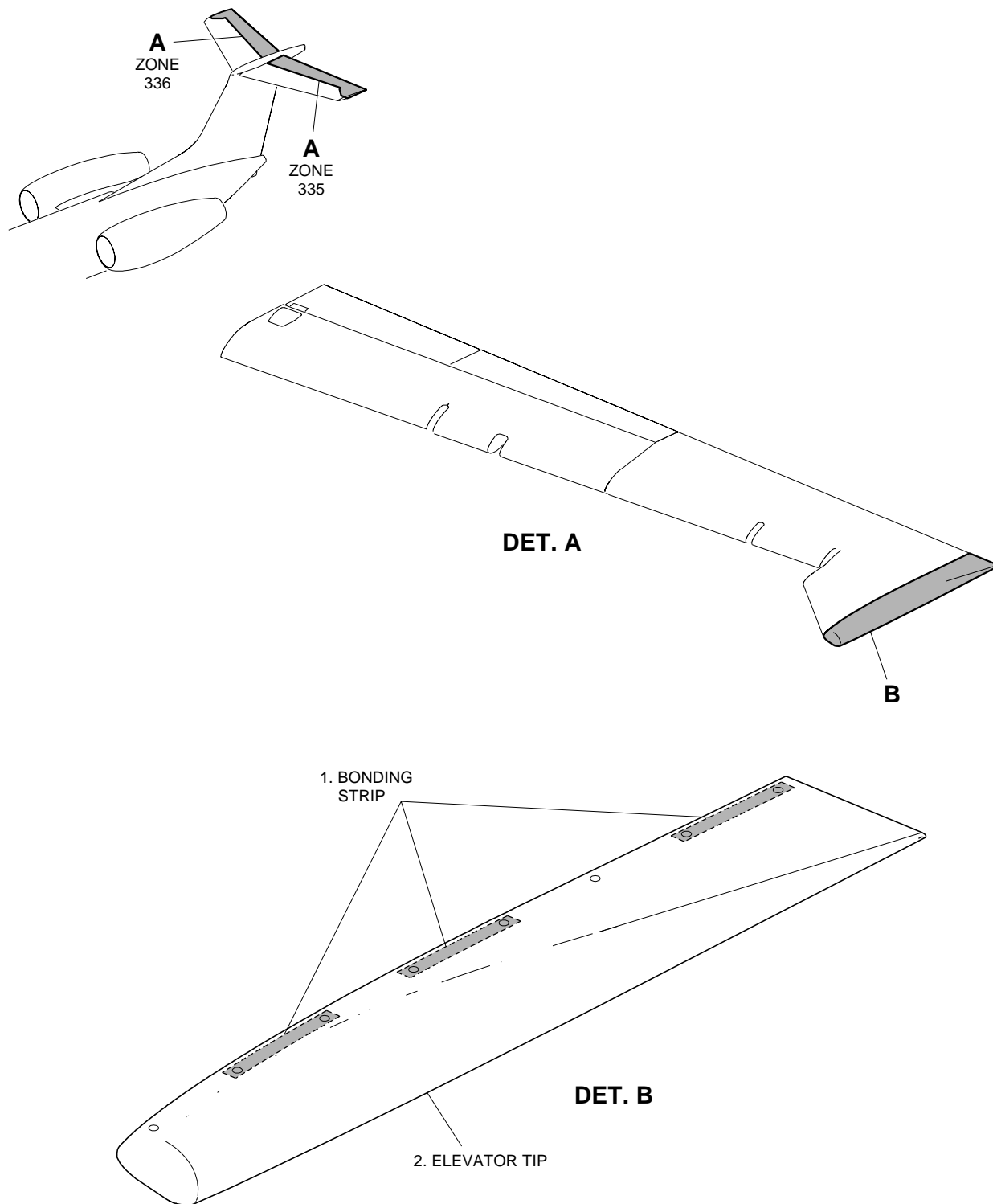
Figure 401



1 AERODYNAMIC SEALING

145AMM550016.MCE C

EFFECTIVITY: ALL
Bonding Strip
Figure 402



EM145AMM550113B.DGN

TASK 55-20-01-400-801-A

EFFECTIVITY: ALL

3. ELEVATOR TIPS - INSTALLATION

A. General

(1) This procedure gives the instructions to install the elevator 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
335		Elevator - LH
336		Elevator - RH

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	
Commercially available	Torque wrench	To tighten/remove 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
MEP 09-083	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

(Continued)

<i>SPECIFICATION (BRAND)</i>	<i>DESCRIPTION</i>	<i>QTY</i>
Commercially available	Scotch Brite Sponge	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

<i>QTY</i>	<i>FUNCTION</i>	<i>PLACE</i>
1	Does the task	Elevator tips

I. Installation (Figure 401)

SUBTASK 420-002-A

- (1) Install the elevator tip (2). Refer to (Figure 401); DET. B.

CAUTION: IT IS NOT NECESSARY TO DO THE STATIC BALANCING OF THE ELEVATORS WHEN AN OLD ELEVATOR TIP FAIRING IS REPLACED BY A NEW ONE.

- (2) Install the screws (1) that attach the elevator tip (2) to its frame. Refer to (Figure 401); DET. B.

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

- (3) There are different methods to do the aerodynamic sealing between the elevator tip (2) and its frame. Use the applicable procedure as necessary.

- (a) Full sealant-curing time:

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

NOTE: The sealant curing time will change with the environmental 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: The sealant curing time will change with the environmental 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 fast 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 After the 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).