



AIRCRAFT MAINTENANCE MANUAL

COCKPIT EMERGENCY EXIT RUBBER TRIM SEAL - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures for removal and installation of the cockpit emergency-exit 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
56-11-02-000-801-A	COCKPIT EMERGENCY-EXIT RUBBER TRIM SEAL - REMOVAL	ALL
56-11-02-400-801-A	COCKPIT EMERGENCY-EXIT RUBBER TRIM SEAL - INSTALLATION	ALL



EMB145 – EMB135

AIRCRAFT
MAINTENANCE MANUAL

TASK 56-11-02-000-801-A

EFFECTIVITY: ALL

2. COCKPIT EMERGENCY-EXIT RUBBER TRIM SEAL - REMOVAL

A. General

(1) This task gives the procedures to remove the cockpit emergency-exit rubber trim seal.

B. References

REFERENCE	DESIGNATION
AMM TASK 56-11-01-000-801-A/400	COCKPIT EMERGENCY EXIT - REMOVAL

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
223		Cockpit emergency exit, LH
224		Cockpit emergency exit, RH

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Acrylic spatula	To remove the sealant	

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Protective Gloves	For protection of technicians hands	1
Commercially available	Safety Goggles	For protection of technicians eyes	1

F. Consumable Materials

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

G. Expandable Parts

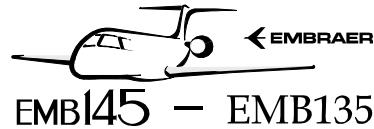
Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Maintenance shop

I. Preparation

SUBTASK 841-002-A



AIRCRAFT
MAINTENANCE MANUAL

- (1) Remove the cockpit emergency exit ([AMM TASK 56-11-01-000-801-A/400](#)).
- (2) Put the cockpit emergency exit on a safe surface to prevent scratches to the acrylic panel.

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

SUBTASK 020-002-A

- (1) With a acrylic spatula, remove the sealant to lift the rubber trim seal end.
- (2) Slowly release the rubber trim seal with a cutter until the rubber trim seal is fully removed.
- (3) Remove from the door the old sealant with an acrylic spatula.

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.

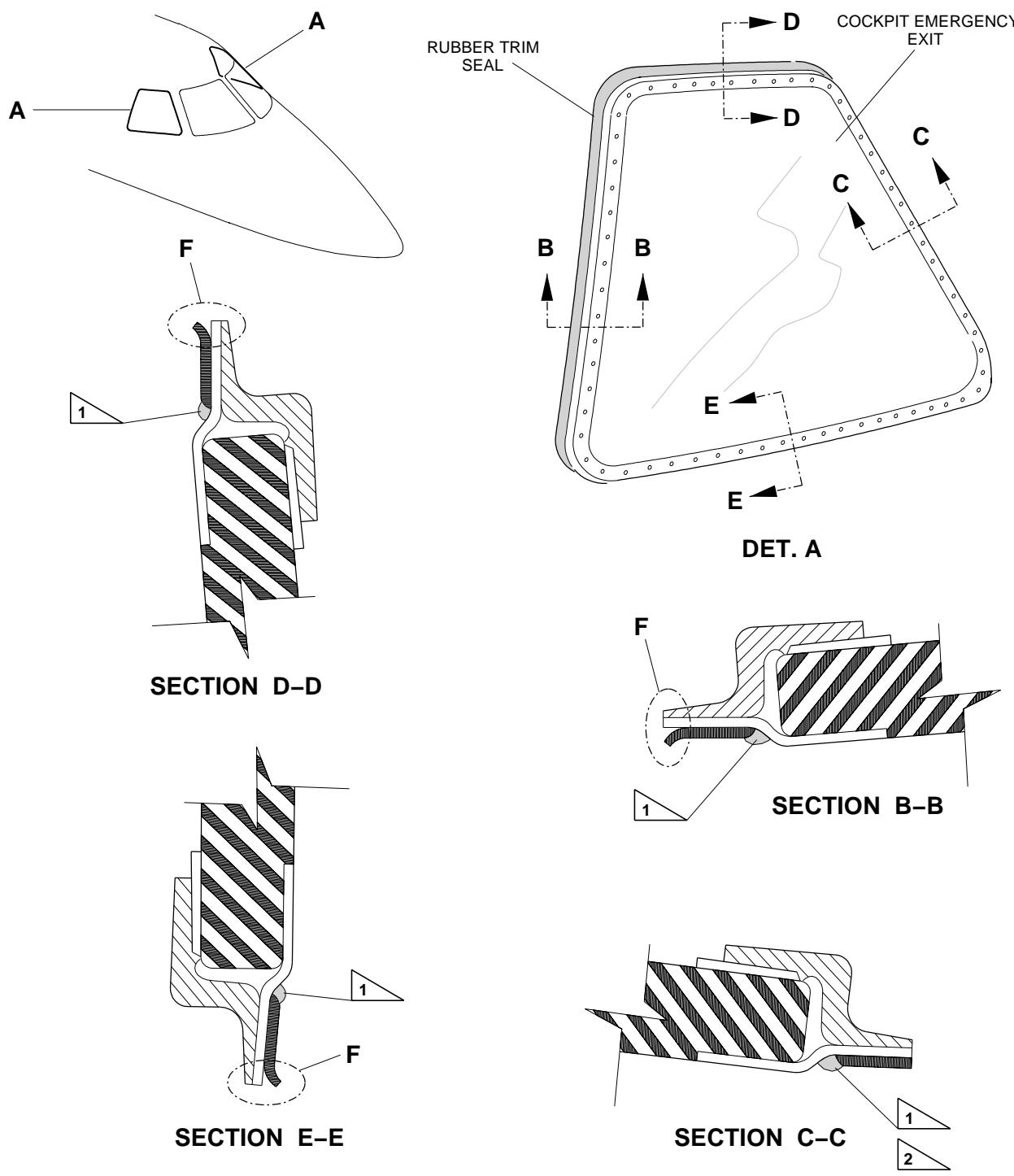
- (4) With a cloth soaked in MEK, clean the surface.

NOTE: Make sure that the surface of the door frame where the rubber trim seal will be installed is clean and without residues of sealant, rubber, or oil.

EFFECTIVITY: FLAT SECTION SEAL

Cockpit Emergency-Exit Rubber Trim Seal - Removal/Installation

Figure 401 - Sheet 1

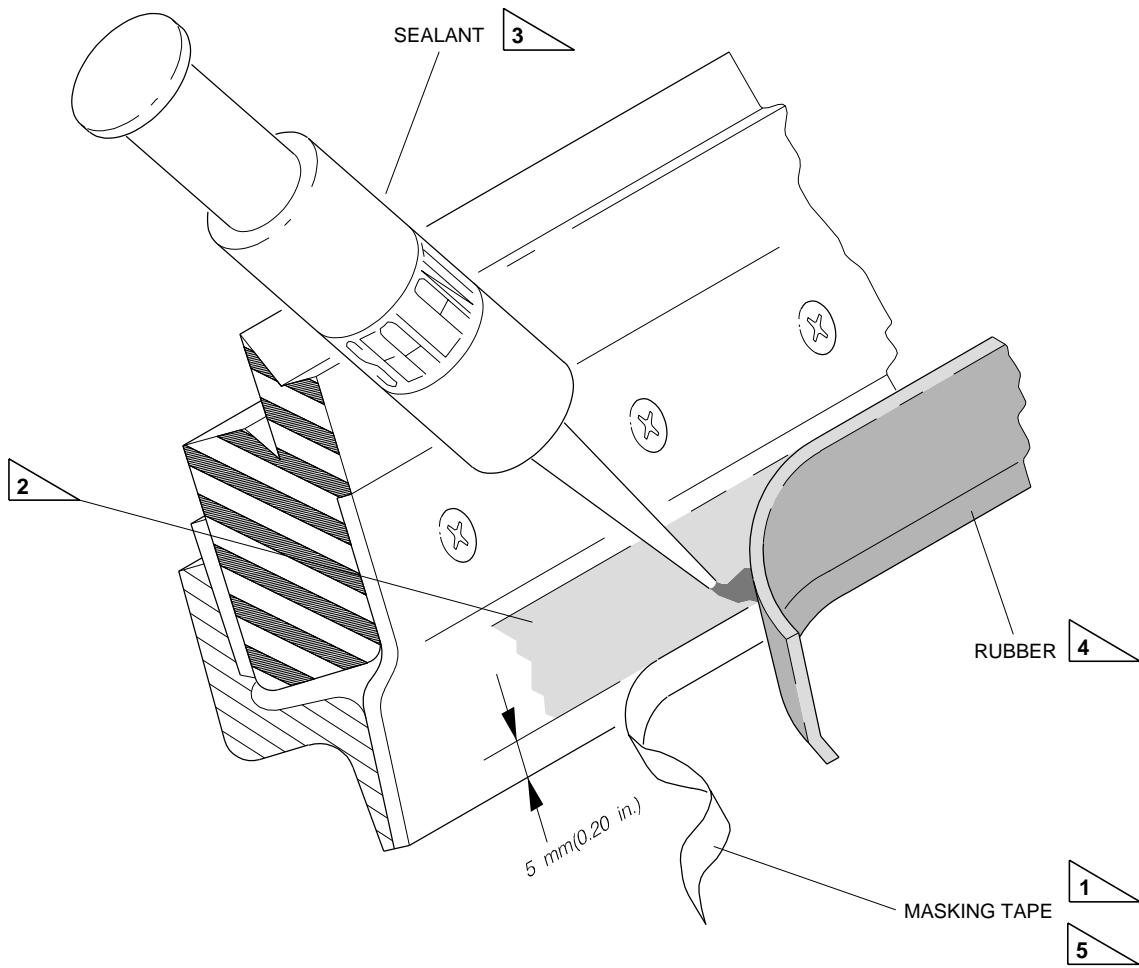


EM145AMM520403B.DGN

EFFECTIVITY: FLAT SECTION SEAL

Cockpit Emergency-Exit Rubber Trim Seal - Removal/Installation

Figure 401 - Sheet 2



DET. F
(TYP.)
OF FIGURE 401
SHEET - 1

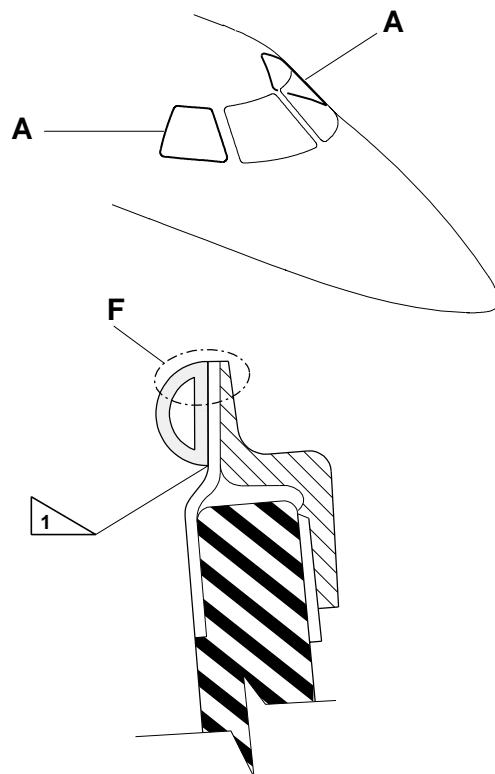
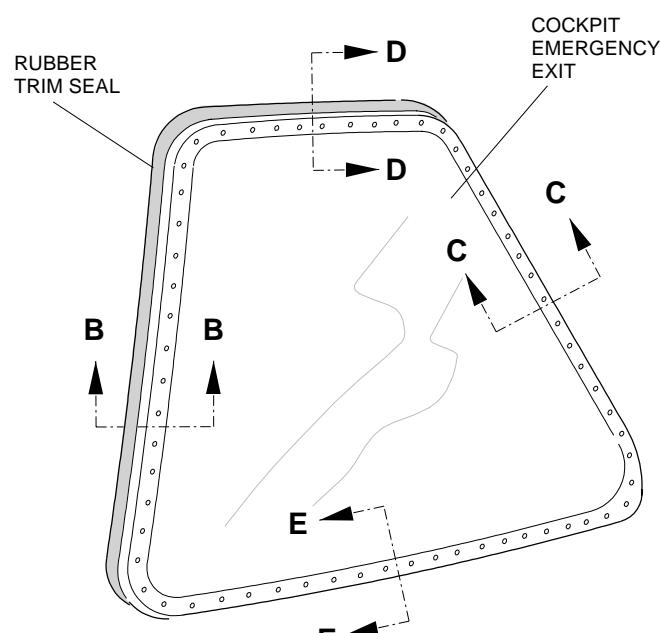
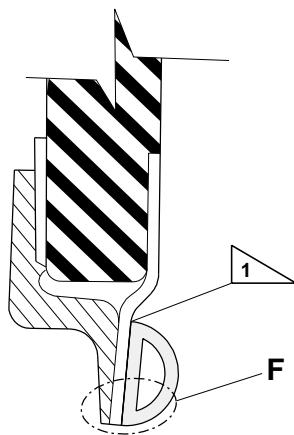
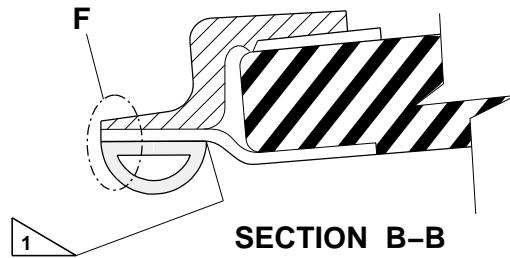
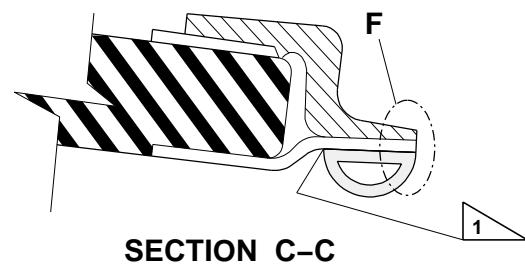
- 1** APPLY THE ADHESIVE TAPE TO THE WINDOW
- 2** SAND THE PARTS WHERE THE SEALANT WILL BE APPLIED.
- 3** APPLY SEALANT RTV 157.
- 4** INSTALL THE RUBBER TRIM SEAL.
- 5** REMOVE THE ADHESIVE TAPE FROM THE WINDOW.

145AMM520404.MCE A

EFFECTIVITY: SEMI-CIRCULAR SECTION SEAL

Cockpit Emergency-Exit Rubber Trim Seal - Removal/Installation

Figure 402 - Sheet 1


SECTION D-D

DET. A

SECTION E-E

SECTION B-B

SECTION C-C

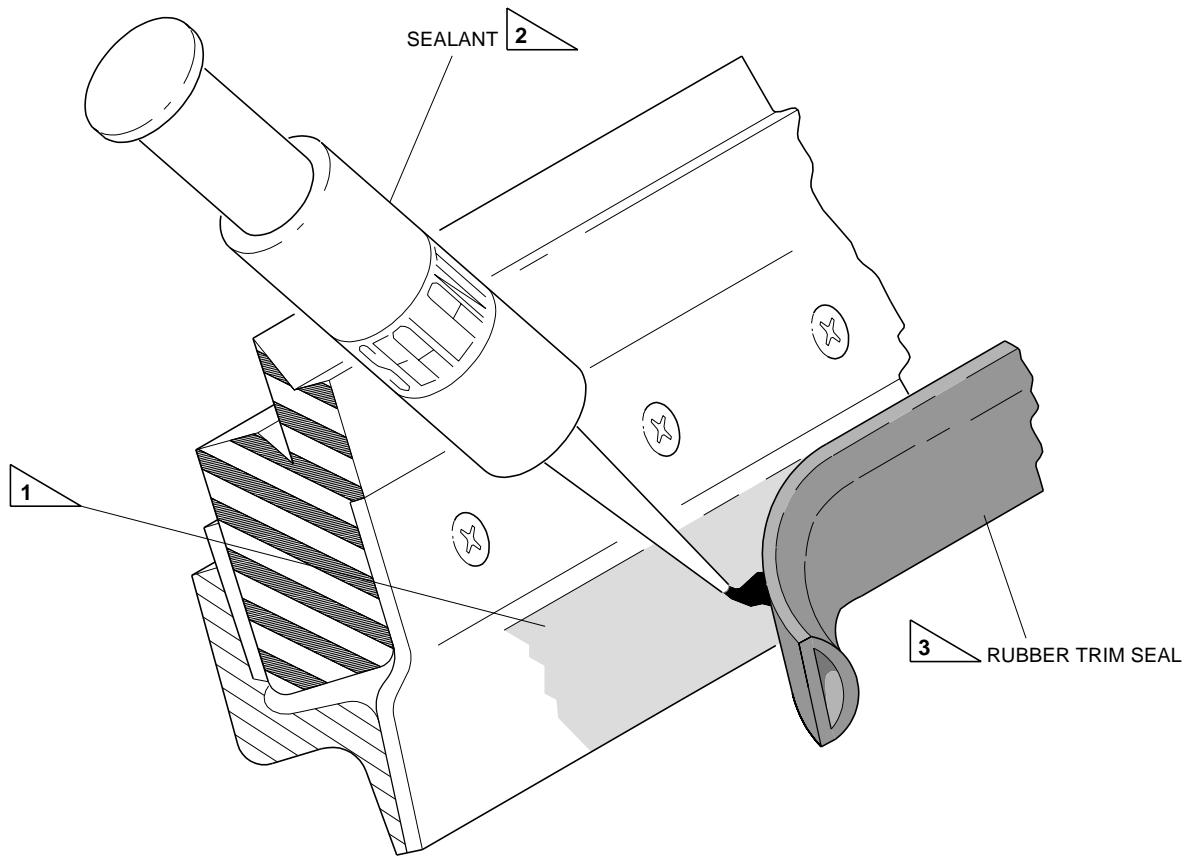
 TO INSTALL THE NEW SEAL, USE THE END OF THE RADIUS OF THE WINDOW FRAME AS A REFERENCE.

EM145AMM520531A.DGN

EFFECTIVITY: SEMI-CIRCULAR SECTION SEAL

Cockpit Emergency-Exit Rubber Trim Seal - Removal/Installation

Figure 402 - Sheet 2

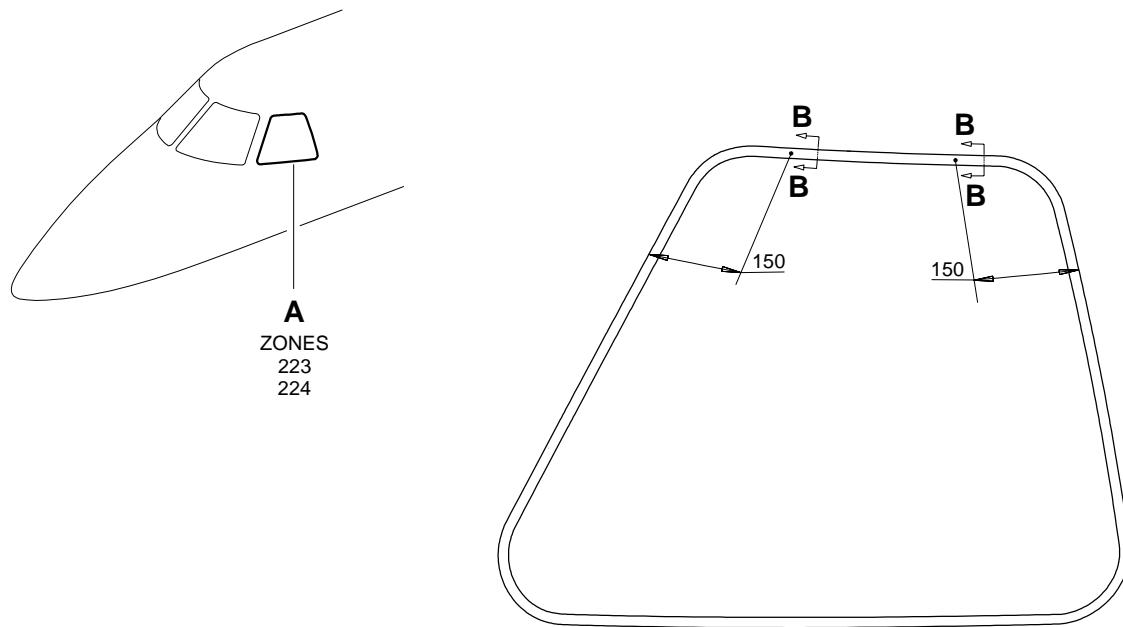


DET. F
(TYPICAL)

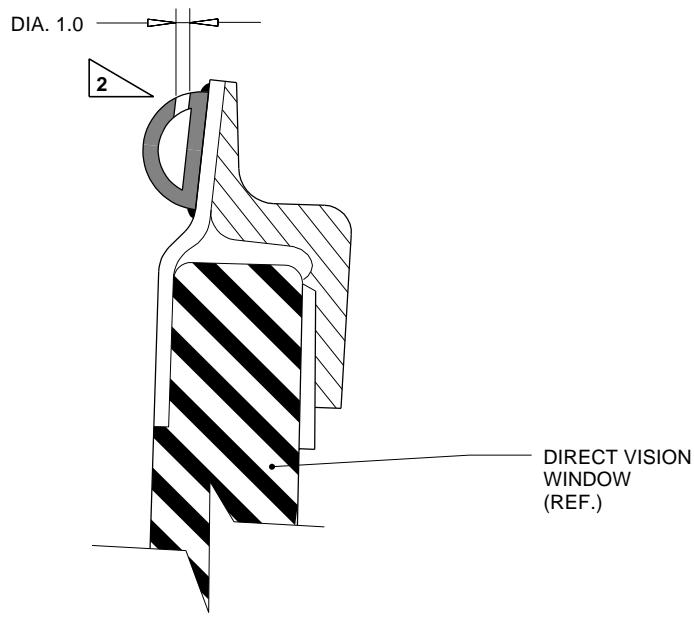
- 1 SAND THE PARTS WHERE THE SEALANT WILL BE APPLIED.
- 2 APPLY SEALANT RTV 157.
- 3 INSTALL THE RUBBER TRIM SEAL.

EM145AMM520698A.DGN

EFFECTIVITY: SEMI-CIRCULAR SECTION SEAL
 Cockpit Emergency-Exit Rubber Trim Seal - Holes
 Figure 403

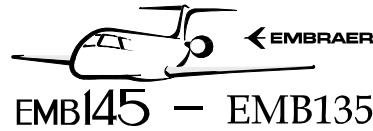


DET. A



DIMENSIONS IN mm.

2 MAKE THE HOLES ON THE OUTSIDE OF THE SEAL.



EMB145 - EMB135

AIRCRAFT
MAINTENANCE MANUAL

TASK 56-11-02-400-801-A

EFFECTIVITY: ALL

3. COCKPIT EMERGENCY-EXIT RUBBER TRIM SEAL - INSTALLATION

A. General

(1) This task gives the procedures to install the cockpit emergency-exit rubber trim seal.

B. References

REFERENCE	DESIGNATION
AMM TASK 21-31-00-860-801-A/200	PROCEDURE TO PRESSURIZE THE AIRCRAFT FOR MAINTENANCE
AMM TASK 21-31-00-860-802-A/200	PROCEDURE TO DEPRESSURIZE THE AIRCRAFT FOR MAINTENANCE
AMM TASK 56-11-00-820-801-A/500	COCKPIT EMERGENCY EXIT - ALIGNMENT
AMM TASK 56-11-01-000-801-A/400	COCKPIT EMERGENCY EXIT - REMOVAL
AMM TASK 56-11-01-400-801-A/400	COCKPIT EMERGENCY EXIT - INSTALLATION
IPC 56-11-00	DIRECT VISION
SRM 51-20-01-PR	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
223		Cockpit emergency exit, LH
224		Cockpit emergency exit, RH

D. Tools and Equipment

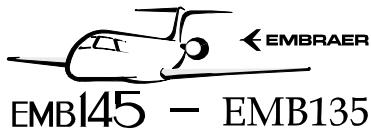
ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Acrylic spatula	To remove the sealant	
Commercially available	Cutter	To remove the rubber seal	

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Protective Gloves	For protection of technicians hands	1
Commercially available	Safety Goggles	For protection of technicians eyes	1

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
	Silicone sealant - RTV 157 (Gray)	AR



EMB145 - EMB135

AIRCRAFT
MAINTENANCE MANUAL

(Continued)

SPECIFICATION (BRAND)	DESCRIPTION	QTY
MIL-S-8802, TYPE II, Class B1/2	Sealant PR-1422 B1/2	AR
Commercially available	Adhesive tape	AR
Commercially available	Detergent	AR

G. Expendable Parts

ITEM	IPC REFERENCE (VENDOR REFERENCE)	QTY
Profile seal	IPC 56-11-00	AR

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Maintenance shop

I. Installation (Figure 401)

SUBTASK 420-002-A

EFFECTIVITY: FLAT SECTION SEAL

- (1) There are two different conditions for the installation of the cockpit emergency-exit rubber trim seal.
 - (a) Installation of the same cockpit emergency-exit rubber trim seal. Do steps (2) to (15).
 - (b) Installation of a new cockpit emergency-exit rubber trim seal. Do steps (3) to (15).
- (2) Remove the sealant from the cockpit emergency-exit rubber trim seal.
- (3) Mask off all the acrylic surface.
- (4) On the upper, lower, and back sides of the cockpit emergency exit, apply a 5 mm (0,20 in) wide tape to the cockpit emergency exit edge as a protection for the part that will not receive the sealant (Figure 401); Sheet 2.
- (5) Sand the parts of the cockpit emergency exit to which sealant RTV-157 (Figure 401); Sheet 2 will be applied, the cockpit emergency exit front side included.
- (6) Apply a thin coat of sealant RTV 157 to the area to which the rubber trim seal will be attached (Figure 401); Sheet 2.

NOTE: If necessary, use the acrylic spatula to apply the sealant.

- (7) Install the rubber trim seal all around the cockpit emergency exit, with the free (unbounded) edge outboard on the upper, lower, and back sides of the cockpit emergency exit (Figure 401); Sheet 2.

NOTE: • Make sure that the end of the rubber trim seal is aligned with the cockpit emergency exit edge.

- Clean the excess sealant.
- (8) Remove the adhesive tape from the cockpit emergency exit (Figure 401); Sheet 2).
- (9) On the front side of the cockpit emergency exit, make sure that the flange of the rubber trim seal is bonded to the cockpit emergency exit with sealant RTV 157 (Figure 401); SECTION C-C).
- NOTE:**
- Attach the flange of the rubber trim seal only on the front side of the cockpit emergency exit.
 - To prevent free edges in the front part of the cockpit emergency exit, push on the rubber trim seal until it is fully attached to the cockpit emergency exit. Use tape if necessary.
- (10) Apply sealant RTV157 between the rubber back end and the cockpit emergency exit (Figure 401); Sheet 1).
- NOTE:** Wet the finger in a water-detergent solution and mold the sealant around the rubber.
- (11) When the sealant is cured, the aircraft can be dispatched.
- NOTE:** The sealant curing time changes with the environmental conditions. Refer to SRM 51-20-01-PR.
- (12) Cut off the excess sealant edges.
- (13) Install the cockpit emergency exit ([AMM TASK 56-11-01-400-801-A/400](#)).
- (14) Do a check for water penetration through the cockpit emergency exit.
- (a) If there is no water penetration, do step (15).
 - (b) If there is water penetration:
 - 1 Align the cockpit emergency exit ([AMM TASK 56-11-00-820-801-A/500](#)).
 - 2 Do other check for water penetration through the cockpit emergency exit. If the water penetration continues, do step (15).
- (15) Pressurize the aircraft ([AMM TASK 21-31-00-860-801-A/200](#)).
- (16) Make sure that there is no air leakage through the cockpit emergency exit. If there is, replace the fuselage frame sealant, according to the instructions below.
- (17) Depressurize the aircraft ([AMM TASK 21-31-00-860-802-A/200](#)).
- (18) Replace the fuselage frame sealant as follows:
- (a) Remove the cockpit emergency exit ([AMM TASK 56-11-01-000-801-A/400](#)).
 - (b) To remove the fuselage frame sealant, do as follows:
 - 1 Pull the sealant from the fuselage frame.

- 2 Remove the sealant remaining on the fuselage frame with an acrylic spatula.

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 NO BREATHE THEIR GASES AND WORK IN A WELL VENTILATED AREA.

- 3 With a cloth soaked in MEK, clean the surface.

- (c) Install the cockpit emergency exit ([AMM TASK 56-11-01-400-801-A/400](#)).
- (d) From outside the aircraft, limit the application area of the sealant. For this, use masking tape to protect the fuselage.
- (e) Remove the cockpit emergency exit ([AMM TASK 56-11-01-000-801-A/400](#)).
- (f) From inside the aircraft, prepare the surface. Refer to SRM 51-20-01-PR.
- (g) Install the cockpit emergency exit ([AMM TASK 56-11-01-400-801-A/400](#)).
- (h) With a felt-tip marker, mark the cockpit emergency exit contour on the fuselage frame.
- (i) Remove the cockpit emergency exit ([AMM TASK 56-11-01-000-801-A/400](#)).
- (j) On the fuselage frame, limit the application area of the sealant. For this, use masking tape.
- (k) Apply sealant PR 1422 B1/2 around the cockpit emergency exit. Refer to SRM 51-20-01-PR.
- (l) Apply sealant PR 1422 B1/2 around the fuselage frame. Refer to SRM 51-20-01-PR.
- (m) Slowly install the cockpit emergency exit.
- (n) From outside the aircraft, remove the excess sealant and the masking tapes.
- (o) When the sealant is cured, remove the cockpit emergency exit ([AMM TASK 56-11-01-000-801-A/400](#)).

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

- (p) Remove the excess sealant.
- (q) Install the cockpit emergency exit ([AMM TASK 56-11-01-400-801-A/400](#)).
- (r) Do a check for water penetration through the cockpit emergency exit, and do a check for air leakage. If there is no leakage, the aircraft can be operated.

J. Installation (Figure 402)

SUBTASK 420-003-A

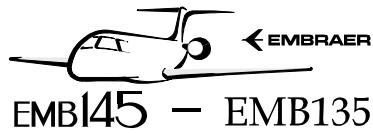
EFFECTIVITY: SEMI-CIRCULAR SECTION SEAL

- (1) There are two different conditions for the installation of the cockpit emergency-exit rubber trim seal.
 - (a) Installation of the same cockpit emergency-exit rubber trim seal. Do steps (2) to (11).
 - (b) Installation of a new cockpit emergency-exit rubber trim seal. Do steps (3) to (11).
- (2) Remove the sealant from the cockpit emergency-exit rubber trim seal.
- (3) Mask off all the acrylic surface.
- (4) Sand the parts of the cockpit emergency exit to which sealant RTV-157 will be applied, the cockpit emergency exit front side included (Figure 402); Sheet 2).
- (5) Apply a thin coat of sealant RTV 157 to the area to which the rubber trim seal will be attached.

NOTE: If necessary, use the acrylic spatula to apply the sealant.
- (6) Install the rubber trim seal all around the cockpit emergency exit.

NOTE: • Make sure that the end of the rubber trim seal is aligned with the cockpit emergency exit edge.
• Clean the excess sealant.
- (7) When the sealant is cured, the aircraft can be dispatched.

NOTE: The sealant curing time changes with the environmental conditions. Refer to SRM 51-20-01-PR.
- (8) Cut off the excess sealant edges.
- (9) For aircraft with seal strip, drill holes according Figure 403.
- (10) Install the cockpit emergency exit ([AMM TASK 56-11-01-400-801-A/400](#)).
- (11) Do a check for water penetration through the cockpit emergency exit.
 - (a) If there is no water penetration, do step (12).
 - (b) If there is water penetration:
 - 1 Align the cockpit emergency exit ([AMM TASK 56-11-00-820-801-A/500](#)) and do other check for water penetration through the cockpit emergency exit.
- (12) Pressurize the aircraft ([AMM TASK 21-31-00-860-801-A/200](#)).
- (13) Make sure that there is no air leakage through the cockpit emergency exit. If there is no leakage, the aircraft can be operated.
- (14) Depressurize the aircraft ([AMM TASK 21-31-00-860-802-A/200](#)).



EMB145 - EMB135

AIRCRAFT
MAINTENANCE MANUAL

K. Follow-on

SUBTASK 842-002-A

- (1) If necessary, adjust the cockpit emergency exit locking mechanism ([AMM TASK 56-11-00-820-801-A/500](#)).