ANTI-BLOCKAGE BARRIER - REPAIR

EFFECTIVITY: ALL

1. General

   A. This section gives the procedures to repair the baggage-compartment anti-blockage barrier.

   B. The anti-blockage barrier is installed in the baggage compartment at zones 271/272.

   C. 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*
25-50-01-300-801-A	ANTI-BLOCKAGE BARRIER (OVERLAP) - REPAIR	ALL
25-50-01-300-802-A	ANTI-BLOCKAGE BARRIER (SPLICE AND ATTACHMENTS) - REPAIR	ALL

TASK 25-50-01-300-801-A
EFFECTIVITY: ALL

2. ANTI-BLOCKAGE BARRIER (OVERLAP) - REPAIR

A. General

(1) This task gives the instructions to repair the anti-blockage barrier. The conditions below must be obeyed:

(a) The repairs are limited to cosmetic vinyl-laminated fabric (1).

(b) Items with damaged metallic fittings or nylon webbing (2) must be replaced.

(c) The total area for overlap section must be less than 0.37 m² (4.0 square feet).

B. References

REFERENCE	*DESIGNATION*
AMM TASK 25-50-01-000-801-A/400	BAGGAGE-COMPARTMENT ANTI-BLOCKAGE BARRIER - REMOVAL
AMM TASK 25-50-01-400-801-A/400	BAGGAGE-COMPARTMENT ANTI-BLOCKAGE BARRIER - INSTALLATION

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*
TT-I-735	Isopropyl Alcohol	AR
RTV 1201 (Translucent)	Sealant	AR
RTV 5249 (Gray)	Sealant	AR
FED V-T-295	Nylon Tread - Type II, Class A, Size 3 (color: olive drab S-1)	AR
VLP - 1306	Vinyl-laminated Fabric 13oz/lyd, (color: grey)	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	*FUNCTION*	*PLACE*
1	Does the task	Baggage compartment

I. Overlap Repair (Figure 801)

SUBTASK 350-002-A

(1) Remove the anti-blockage barrier (AMM TASK 25-50-01-000-801-A/400).

(2) Clean up the anti-blockage barrier surface with solvent.

NOTE:
- Make sure that no oil, cutting grease, wax, etc. touch the repaired area. They must be fully removed with 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.
- Do not touch the cleaned surfaces.

(3) Examine the anti-blockage barrier and identify the damaged vinyl-laminated fabric (1) section(s). Refer to block 1, Figure 801.

(4) With a pair of scissors, carefully cut away the torn or damaged section along the perimeter of the nylon web border (2). Refer to block 2, Figure 801.

NOTE: Remove only the sections on the inside of the web.

(5) Apply a small bead of sealant along the vinyl-laminated fabric (1) border between the seam and the trimmed edge. Refer to block 3, step 1, Figure 801.

NOTE:
- Push the sealant and the vinyl-laminated fabric (1) border down onto the nylon web (2). Refer to block 3, step 2, Figure 801.
- Add 3.2 millimeters to 1.6 millimeters (0.13 inches to 0.06 inches) of the sealant along the outside edge of the vinyl-laminated fabric (1). Refer to block 3, step 3, Figure 801.
- Let it cure for 6 hours.

(6) Put a new section of vinyl-laminated fabric on the area and mark with a pencil or wax-type fabric marking pen.

NOTE:
- Vinyl-laminated fabric (1) is supplied by:
  MARUITZON
  3939 BELDEN AVE.
  Chicago, IL. 60647
  PHONE: (800) 621-4352
  FAX: (773) 235-1479

- The section must be larger than the removed piece, and it must extend to the full width of the nylon web (2).

(7) Sew the new vinyl-laminated fabric (1) in the original place. Refer to block 4, step 4, Figure 801.

NOTE:
- Use nylon thread.
- Nylon thread is supplied by:
  EDDINGTON THREAD
  3222 KNIGHTS ROAD
  PA. 19020
  PHONE: (800) 220 8901
- After the sewing, examine the patch repair for collateral damage and make sure that there is no other damage.

(8) Bond edges of vinyl-laminated fabric (1) overlap in place with sealant. Refer to block 4, step 5, Figure 801.

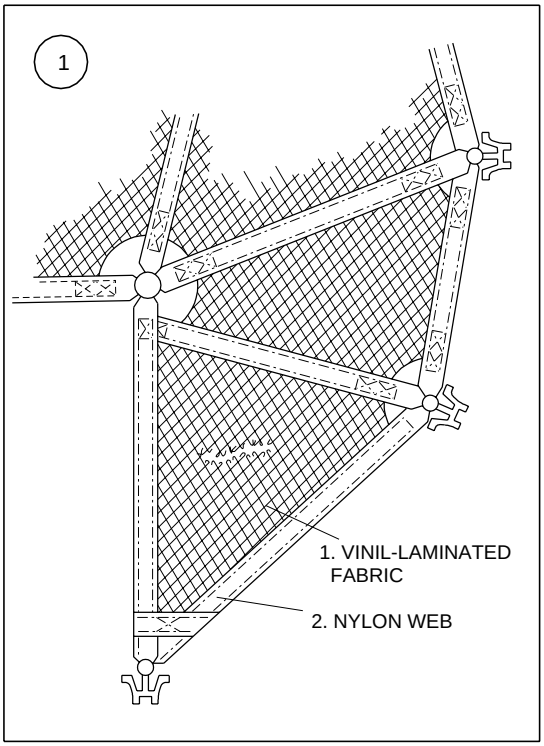
NOTE:
- Add 3.2 millimeters to 1.6 millimeters (0.13 inches to 0.06 inches) of the sealant between the nylon seam and the edge of vinyl-laminated fabric (1). Refer to block 4, step 6, Figure 801.
- Let it cure for 6 hours.

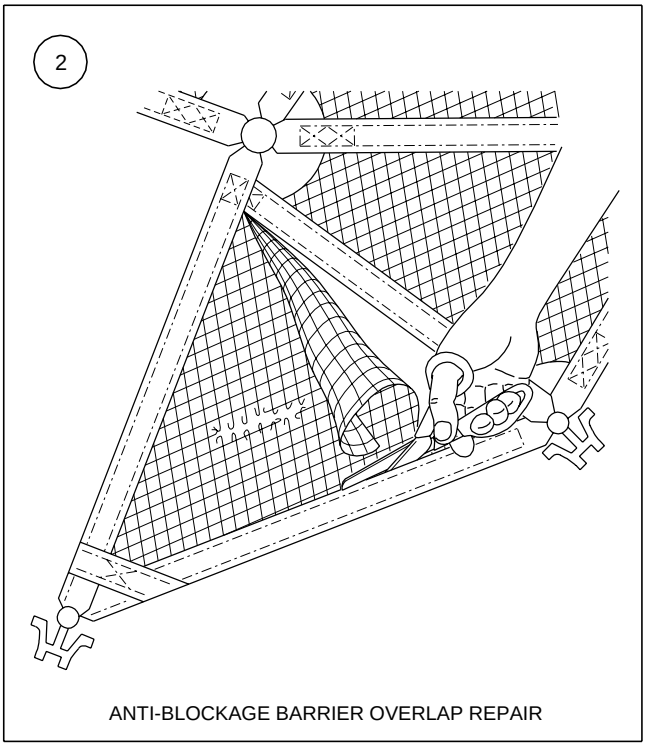
(9) Make sure that the new vinyl-laminated fabric (1) is edge-sealed in place and that the sewn seams stitches/inch are correct and tacked through the nylon web (2) and the original vinyl-laminated fabric (1).

(10) Install the anti-blockage barrier (AMM TASK 25-50-01-400-801-A/400).

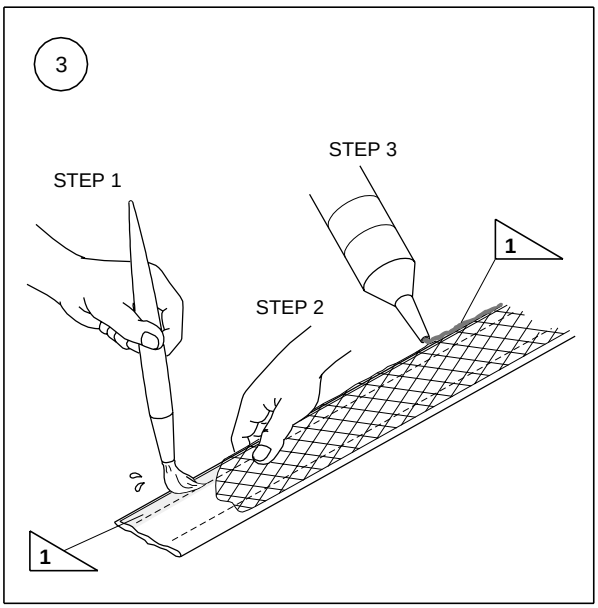
EFFECTIVITY: ALL

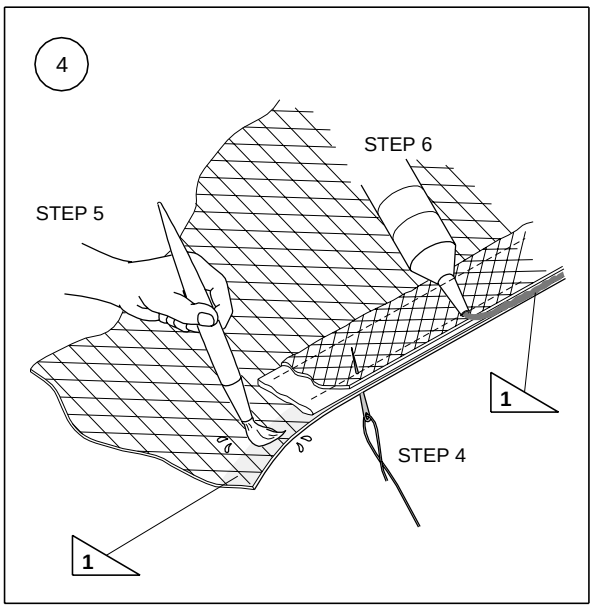
Anti-Blockage Barrier (Overlap) - Repair
Figure 801





ANTI-BLOCKAGE BARRIER OVERLAP REPAIR





1 SEALANT P/N RTV 1201 OR 5249.

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TASK 25-50-01-300-802-A
EFFECTIVITY: ALL

3. ANTI-BLOCKAGE BARRIER (SPLICE AND ATTACHMENTS) - REPAIR

A. General

(1) This task gives the instructions to repair the nylon webbing and to replace the attachment anchor plates and buckles of the anti-blockage barrier net.

(2) The repair must be done when damage to the anti-blockage barrier net is suspected.

(3) Do an inspection of the anti blockage barrier net as follows:

NOTE: The conditions below must be obeyed to replace the nylon webbing.

(a) Replace the webbing as follows:

1 If there are more than two longitudinal fibers broken.

2 If two or more transversal fibers regardless of extent are broken or missing.

3 If there are abrasion marks which cause rupture of fibers or nap sufficient to obscure the identity of fiber with more than 0.10 in width or 2.54 cm (1 inch) in length.

4 If there are abrasion marks which cause difference in stiffness or thickness of webbing and go for more than 0.635 cm (1/4 inch) in the length direction.

5 Replace the web if you find a cut, hole or tear.

6 Replace the web if it has knots.

7 Replace the web if it has a twist or distortion.

8 If there are two or more yarns per shed.

(4) It is not necessary to replace the webbing when the wear is considered an acceptable damage as follows:

(a) Fibers are not cut, discontinuous or broken.

NOTE: This kind of abrasion reduces the diameter of exterior web fibers, but does not reduce performance or safety margins.

(b) If there are flat abrasions and worn fibers which causes no longer than 30% of the thickness of the fibers and 10% of the webbing width.

(c) Broken Fibers: if there are visible on one or two ends within the same length and no longer than 22,86 cm (9 inches).

(d) If there are abrasion marks which cause difference in stiffness or thickness of webbing and go for less than 0.635 cm (1/4 inch) in the length direction.

B. References

REFERENCE	*DESIGNATION*
AMM TASK 25-50-01-000-801-A/400	BAGGAGE-COMPARTMENT ANTI-BLOCKAGE BARRIER - REMOVAL
AMM TASK 25-50-01-400-801-A/400	BAGGAGE-COMPARTMENT ANTI-BLOCKAGE BARRIER - INSTALLATION

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

ITEM	*DESCRIPTION*	*PURPOSE*	*QTY*
Commercially available	Soldering bolt	to burn straps ends	AR

F. Consumable Materials

SPECIFICATION (BRAND)	*DESCRIPTION*	*QTY*
MIL-W-4088-T25 Class 2/MIL-W-27265 Class R	Nylon webbing, Class 2 (Color original olive drab 7)	AR
FED STD SPEC V-T-295	Nylon Tread - Class A, Size 3 (color: olive drab S-1)	AR
TT-I-735	Isopropyl Alcohol	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	*FUNCTION*	*PLACE*
1	Does the task	Baggage compartment

I. Splice Repair (Figure 802)

SUBTASK 350-003-A

(1) Remove the anti-blockage barrier (AMM TASK 25-50-01-000-801-A/400).

(2) Clean up the anti-blockage barrier surface with solvent.

NOTE: • Make sure that no oil, cutting grease, wax, etc. touch the repaired area. They must be fully removed with 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.
- Do not touch the cleaned surfaces.

(3) Measure the length of the wear or abrasion damage and plus 76.2 mm (3 inches).

NOTE: The splice webbing must be 2.54 cm (1 inch) in width.

(4) Overlap the webbing at least 3.81 cm (1½ inch) on each side of the "good" webbing. Refer to DET. D, sheet 2.

(5) Make an overlap of 3.81cm (1½ inch) onto the worn webbing at each end.

(6) NOTE: Apply tacking or adhesives dots to accommodate the sewing.

Sew a minimum of 7-9 stitches per 2.54 cm (1 inch) the length of the splice, along the lengthwise edges.

(7) Sew a double stitch and complete the ends as DET. D, sheet 2.

(8) After the sewing, examine the repair for collateral damage and make sure that there is no other damage.

(9) Install the anti-blockage barrier (AMM TASK 25-50-01-400-801-A/400).

J. Attachment Anchor and Buckle - Replacement (Figure 802)

SUBTASK 350-004-A

(1) Remove the anti-blockage barrier (AMM TASK 25-50-01-000-801-A/400).

(2) Clean up the anti-blockage barrier surface with solvent.

NOTE:
- Make sure that no oil, cutting grease, wax, etc. touch the repaired area. They must be fully removed with 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.
- Do not touch the cleaned surfaces.

(3) To remove the damage buckle or anchor, cut the loop neatly in the center.

NOTE: Do not allow the webbing to fray.

(4) Immediately use a soldering bolt to burn straps ends.

NOTE: This step prevent the webbing to fray.

(5) Use a piece of nylon webbing with a minimum loop length of 12.7-22.86 cm (5-9 inches).

(6) Sew over the new buckle or attachment anchor.

(7) Size the splice as follows:

(a) Add an additional 3.81 cm (1½ inch) from the end of the loop sewing.

NOTE: On anchors that are double stitched this can be much as 22.86 cm (9 inches).

(b) To hold floor anchors and buckles allow 2.54 cm (1 inch) of loop.

(8) Position the new buckle or anchor in the center of the loop.

(9) NOTE: Apply tacking or adhesives dots to accommodate the sewing.

Sew a minimum of 7-9 stitches per 2.54 cm (1 inch) the length of the splice, along the lengthwise edges.

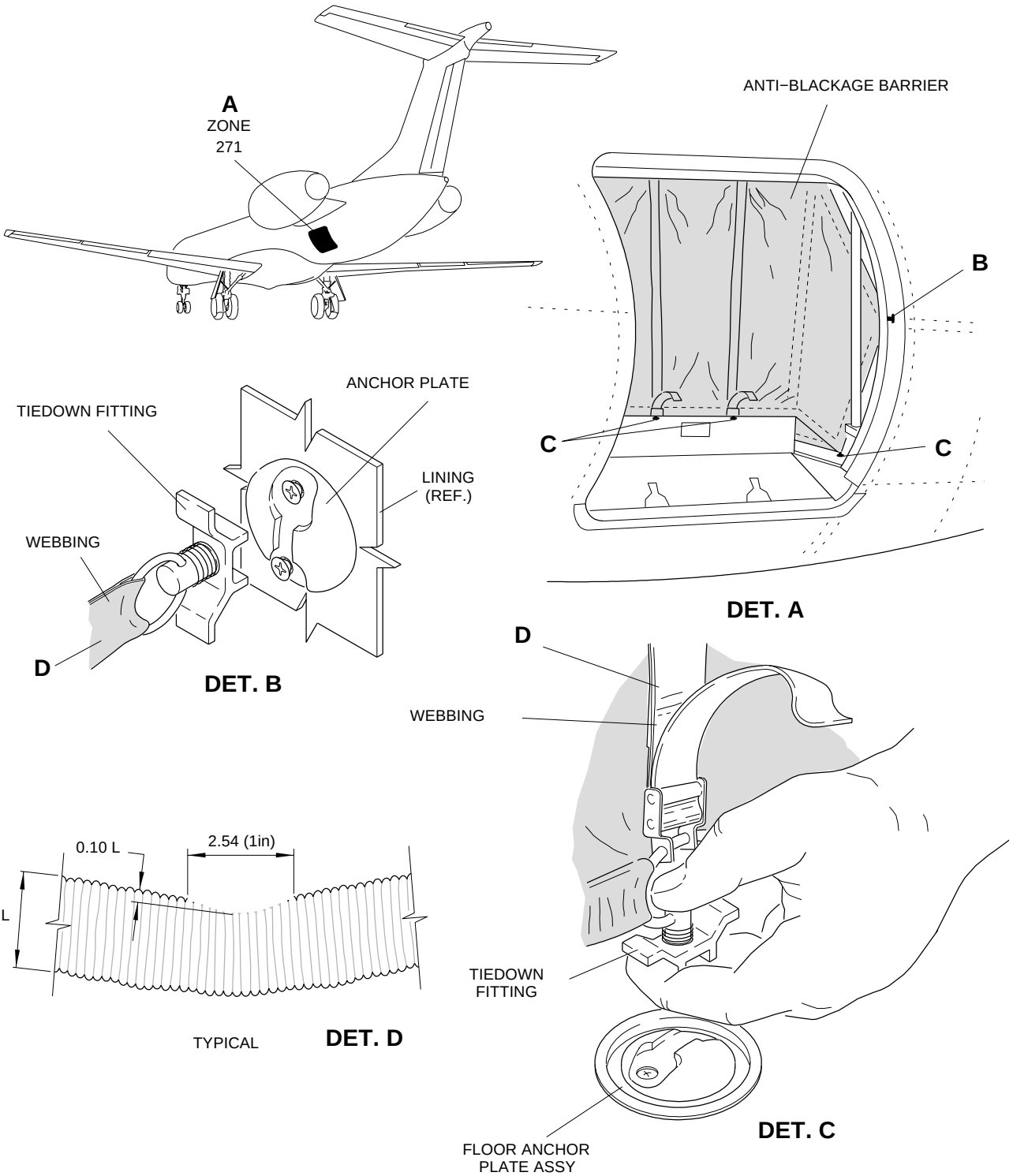
(10) Sew a double stitch and complete the ends as DET. D, sheet 2.

(11) After the sewing, examine the repair for collateral damage and make sure that there is no other damage.

(12) Install the anti-blockage barrier (AMM TASK 25-50-01-400-801-A/400).

EFFECTIVITY: ALL

Anti-Blockage Barrier (Splice and Attachments) - Repair
Figure 802 - Sheet 1



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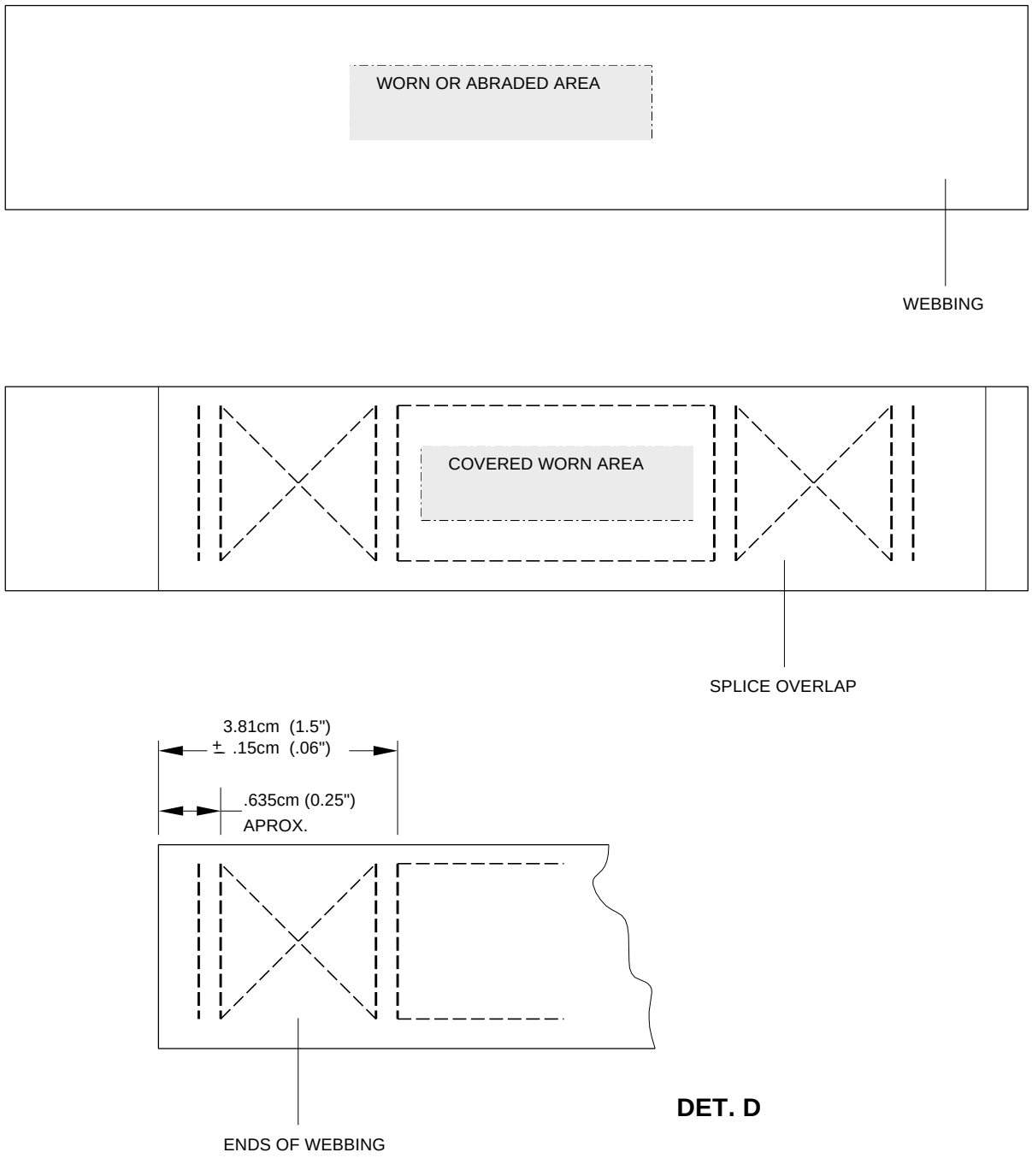
EFFECTIVITY: ALL

Anti-Blockage Barrier (Splice and Attachments) - Repair
Figure 802 - Sheet 2



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