



AIRCRAFT  
MAINTENANCE MANUAL

PYLON - LOWER SURFACE - COVER ASSY - JOINT RETAINER - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the joint retainer of the cover assy in the lower surface of the pylon.
- 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
54-51-02-000-801-A	JOINT RETAINER - REMOVAL	ALL
54-51-02-400-801-A	JOINT RETAINER - INSTALLATION	ALL



# AIRCRAFT MAINTENANCE MANUAL

TASK 54-51-02-000-801-A

EFFECTIVITY: ALL

## 2. JOINT RETAINER - REMOVAL

### A. General

- (1) This procedure gives the instructions to remove the joint retainer of the cover assy in the lower surface of the pylon.

### B. References

REFERENCE	DESIGNATION
AMM MPP 06-43-00/100	- COMPONENT LOCATION
AMM MPP 78-30-00/200	- MAINTENANCE PRACTICES
AMM TASK 20-40-02-910-801-A/200	STATIC GROUNDING - STANDARD PRACTICES

### C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
410	414CB (LH side)	Pylon
420	424CB (RH side)	Pylon

### D. Tools and Equipment

Not Applicable

### E. Auxiliary Items

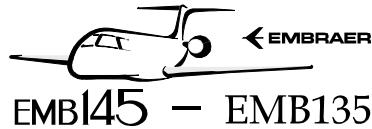
ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	1
Commercially available	Acrylic Spatula	To clean the surface and release the adhesive	1
Commercially available	Cutter	To remove the joint retainer	1
Commercially available	Protective Gloves	For protection of 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



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## H. Persons Recommended

QTY	FUNCTION	PLACE
1	Do the task	Pylon

## I. Preparation

## SUBTASK 841-002-A

**WARNING:** MAKE SURE THAT THE AIRCRAFT IS IN A SAFE CONDITION BEFORE YOU DO THE MAINTENANCE PROCEDURES. THIS IS TO PREVENT INJURY TO PERSONS AND/OR DAMAGE TO THE EQUIPMENT.

**WARNING:** BEFORE YOU DO THE TASK, OBEY THE SAFETY PRECAUTIONS GIVEN IN **AMM MPP 78-30-00/200** TO PREVENT INJURY TO PERSONS AND DAMAGE TO MATERIAL.

- (1) Do the procedure to make the aircraft safe for maintenance ([AMM TASK 20-40-02-910-801-A/200](#)).
- (2) On the circuit breaker panel, open the circuit breakers below and attach a DO-NOT-CLOSE tag to them:
  - START 1 (location tip: POWERPLANT/THRUST REVERSER 1).
  - START 2 (location tip: POWERPLANT/THRUST REVERSER 2).
- (3) Put a DO-NOT-OPERATE-THE-THRUST-REVERSERS sign on the instrument panel, in the cockpit.
- (4) Put the workstand into position and get access to the lower surface of the pylon.
- (5) Remove the access panels 414CB (LH side) and 424CB (RH side) ([AMM MPP 06-43-00/100](#)).

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

## SUBTASK 020-002-A

**WARNING:** BE CAREFUL WHEN YOU USE A CUTTER AND DO NOT MAKE SCRATCHES ON THE LOWER SURFACE OF THE PYLON.

- (1) With a cutter, remove the adhesive to lift the joint retainer (2).
- (2) Slowly release the joint retainer (2) with a cutter until the joint retainer (2) is fully removed.
- (3) Remove the old adhesive with an acrylic spatula.

**WARNING:** BE CAREFUL WHEN YOU USE THE METHYL-ETHYL-KETONE (MEK). PUT ON SAFETY GOGGLES, PROTECTIVE GLOVES AND CLOTHING. DO NOT BREATHE THE GAS. DO THE WORK IN AN AREA WHICH HAS A GOOD FLOW OF AIR. MEK IS POISONOUS AND HIGHLY FLAMMABLE.

- (4) With a cloth soaked in MEK, clean the lower surface of the pylon (1).



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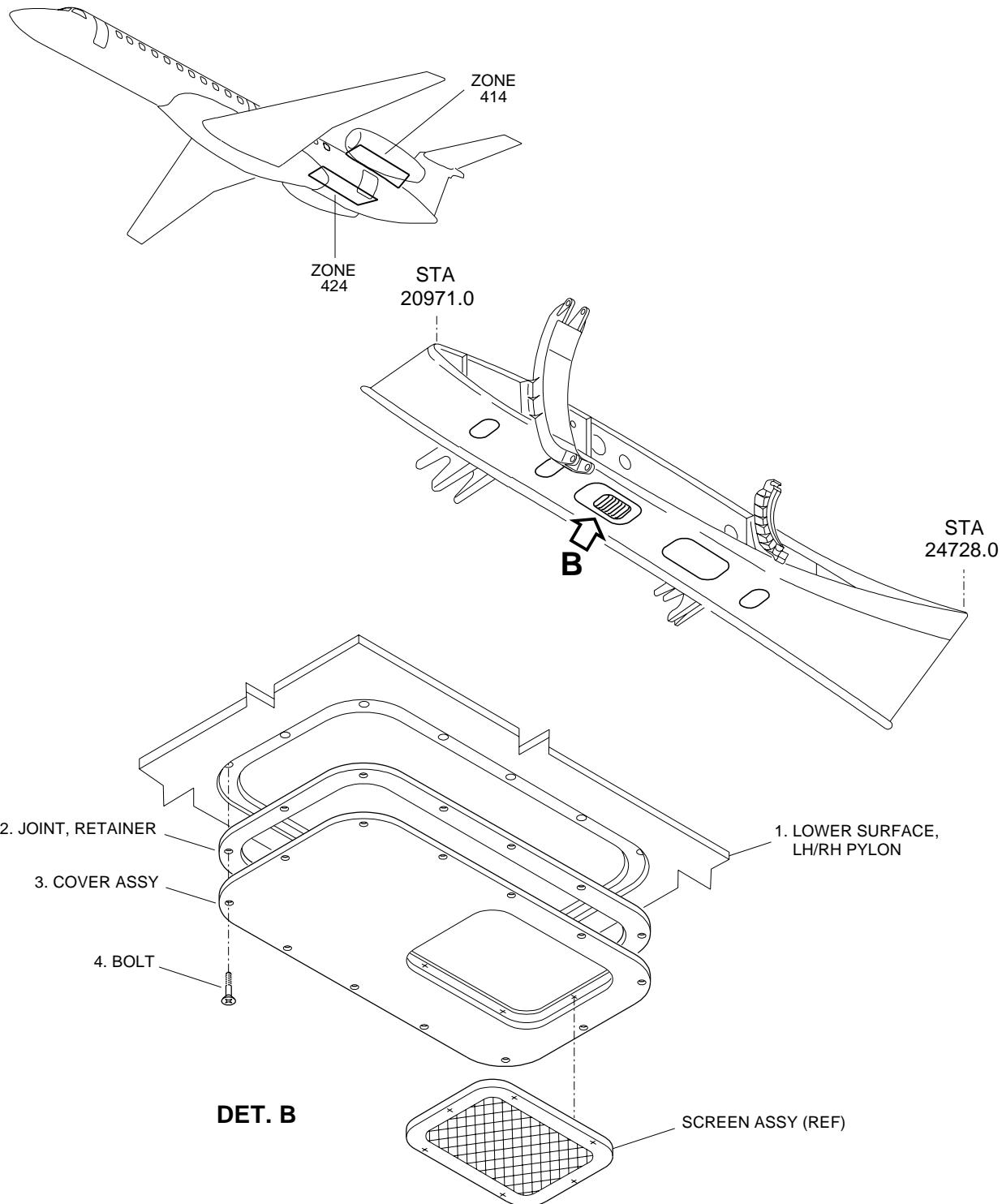
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**NOTE:** Make sure that the lower surface of the pylon (1) where the joint retainer (2) will be installed is clean and with no residues of adhesive, rubber, or oil.

**EFFECTIVITY: ALL**

Joint Retainer - Removal and Installation

Figure 401



EM145AMM540035A.DGN



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TASK 54-51-02-400-801-A

EFFECTIVITY: ALL

## 3. JOINT RETAINER - INSTALLATION

### A. General

- (1) This procedure gives the instructions to install the joint retainer of the cover assy in the lower surface of the pylon.

### B. References

REFERENCE	DESIGNATION
AMM MPP 06-43-00/100	- COMPONENT LOCATION
AMM TASK 20-40-02-910-801-A/200	STATIC GROUNDING - STANDARD PRACTICES

### C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
410	414CB (LH side)	Pylon
420	424CB (RH side)	Pylon

### D. Tools and Equipment

Not Applicable

### E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	1
Commercially available	Acrylic Spatula	To clean the surface and release the adhesive	1
Commercially available	Cutter	To remove the joint retainer	1
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
TT-I-735	Isopropyl Alcohol	AR
AV138	Araldite adhesive	AR
Commercially available	Adhesive tape	AR

**G. Expandable Parts**

Not Applicable

**H. Persons Recommended**

<i>QTY</i>	<i>FUNCTION</i>	<i>PLACE</i>
1	Do the task	Pylon

**I. Installation (Figure 401)**
**SUBTASK 420-002-A**

- (1) Bond the joint retainer (2) with the lower surface of the pylon (1) as follows:

**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.**

- (a) Clean the pylon recess with a clean cloth soaked with solvent.
  - (b) Mix the adhesive component A and B and apply it in the pylon recess (1).
  - (c) Position the joint retainer (2) in the pylon recess (1) let the sealing compound cure within the time established by the manufacturer.
- NOTE:** Obey the manufacturer's instructions to prepare the area.
- (d) With masking tape, keep the joint retainer (2) in position until the adhesive polymerization is completed.

- (2) After cure time remove the tape.

**J. Follow-on**
**SUBTASK 842-002-A**

- (1) Install the access panels 414CB (LH side) and 424CB (RH side) ( [AMM MPP 06-43-00/100](#)).
- (2) Remove all tools, equipment and unwanted materials from the work area.
- (3) Remove the workstand from the work area.
- (4) On the circuit breaker panel, close the circuit breakers below and remove the DO-NOT-CLOSE tag from them:
  - START 1 (location tip: POWERPLANT/THRUST REVERSER 1).
  - START 2 (location tip: POWERPLANT/THRUST REVERSER 2).
- (5) Remove the DO-NOT-OPERATE-THE-THRUST-REVERSERS sign from the instrument panel, in the cockpit.
- (6) Put the aircraft back to its dispatch condition ( [AMM TASK 20-40-02-910-801-A/200](#)).

