

FORWARD BAGGAGE COMPARTMENT PARTITION - REPAIR

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to repair the forward baggage compartment partition.
- B. The forward baggage compartment partition is located in the forward section of the baggage compartment.
- C. If a tear, a hole, or other type of damage to the partition occurs, it must be repaired to agree with the safety condition of the flame resistance test.
- 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
25-27-02-300-801-A	FORWARD BAGGAGE COMPARTMENT PARTITION - PATCH REPAIR	ALL
25-27-02-300-802-A	FORWARD BAGGAGE COMPARTMENT PARTITION - RIGID PATCH REPAIR	ALL
25-27-02-300-803-A	FORWARD BAGGAGE COMPARTMENT PARTITION - FIREBLOCK BLANKET RE-WORK	ALL

TASK 25-27-02-300-801-A

EFFECTIVITY: ALL

2. FORWARD BAGGAGE COMPARTMENT PARTITION - PATCH REPAIR

A. General

- (1) This task gives the procedures to repair the forward baggage compartment partition with patches:

NOTE: There are two patches certified 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 minimum distance between two patch repairs must be 38 millimeters (1.5 inches).
- (4) Refer to table 801 and [Figure 801](#) for the maximum and types of damage that can be repaired.

Table 801 - PATCH REPAIR X MAXIMUM AND TYPES OF DAMAGE

PATCH REPAIR	QUANTITY OF PIECES	TYPE OF DAMAGE	MAXIMUM DAMAGE length x width mm (in)
PERMALI	one	square-shaped and L-shaped tears	101 x 101 (4 x 4)
		U-shaped tear	101 x 101 (4 x 4)
AKRO AF 844	one	Any type of damage (hole in liner) ^[1]	25 x 25 (1 x 1)
AKRO AF 848			127 x 25 (5 x 1)
AKRO AF 888			127 x 127 (5 x 5)
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).

- (5) If these requirements cannot be obeyed, the damaged forward baggage compartment partition must be replaced.
- (6) The forward baggage compartment partition that has other type of damage than that specified in table 801 (or with damage larger than the dimensions in table 801) must be replaced.

B. Zones and Accesses

Not Applicable

C. Tools and Equipment

Not Applicable

D. Auxiliary Items

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

E. 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 800 Series (AF 844, AF 848 and AF 888)	AR
Commercially available	PERMALI Gloucester Permaglass Patch Repair 100 Series	AR

F. Expandable Parts

Not Applicable

G. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Baggage compartment

H. Patch Repair (Figure 801) (Figure 802)

SUBTASK 340-002-A

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

- (1) Clean the forward baggage compartment partition with ethanol or isopropyl alcohol to remove dirt, oil, and debris.
- (2) Mask off the surface to keep the original chemical treatment intact outside the patch repair and on the adjacent border.
- (3) With a 320-400 grit sanding paper, fully remove the chemical treatment from the area where you will install the patch repair.

NOTE: Remove the chemical treatment at least 38 millimeters (1.5 inches) on the adjacent border of the damage where you will install the patch.

- (4) Wipe the surface after you sand it, with a clean, shop wipe soaked with ethanol or isopropyl alcohol.

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

- The part will be clean when a clean, dry shop wipe can be passed over the surface and show no indications of dirt, oil, or debris.
- Do not touch the cleaned surfaces.

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

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.

- (6) Remove the protective liner from one corner of the patch and bond it to the partition periphery ([Figure 802](#)).

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 all over the area.

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

- 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.

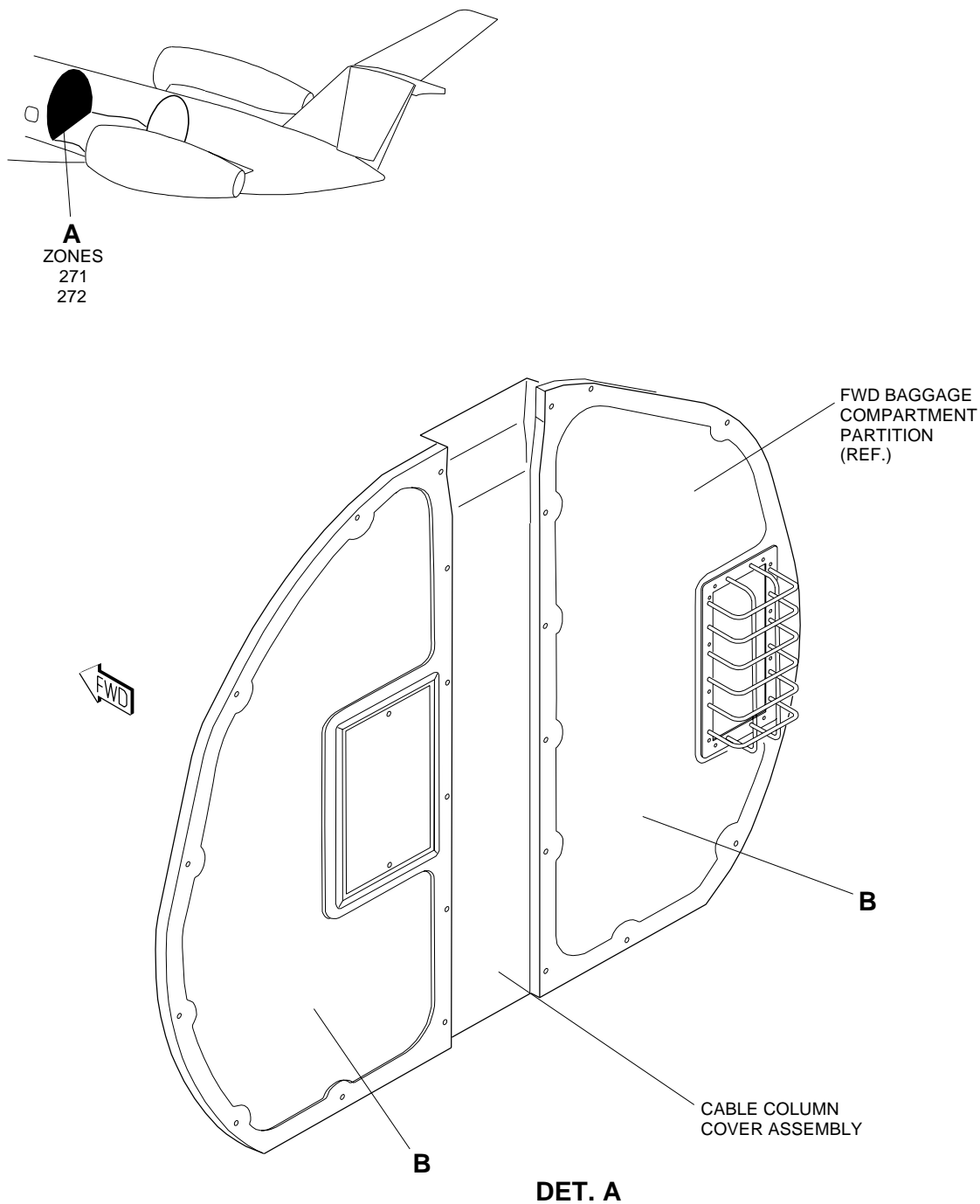
(8) If the adhesion is not sufficient, remove the patch and discard it.

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

EFFECTIVITY: ALL

Forward Baggage Compartment Partition - Maximum Damage

Figure 801 - Sheet 1

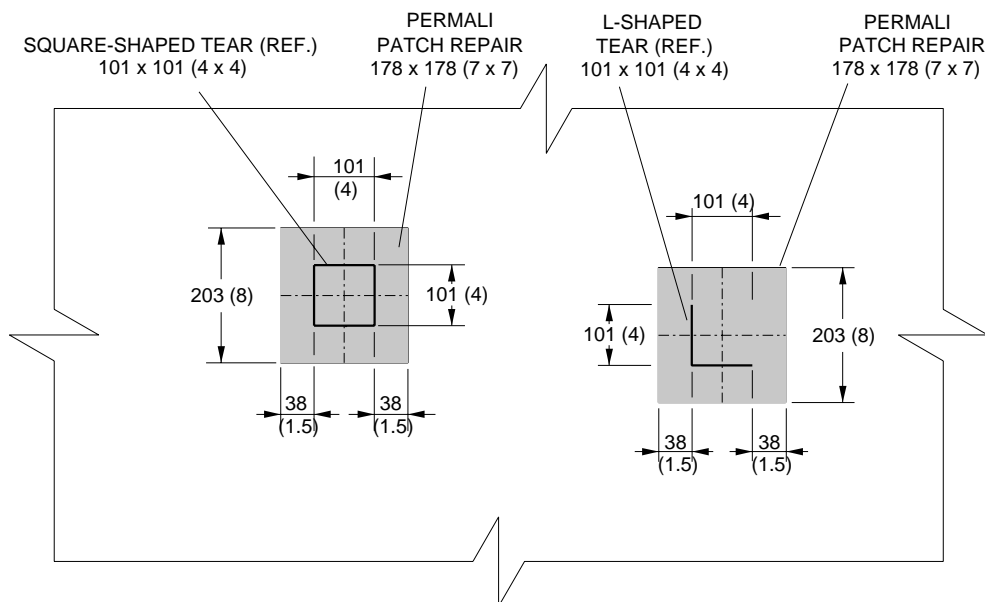


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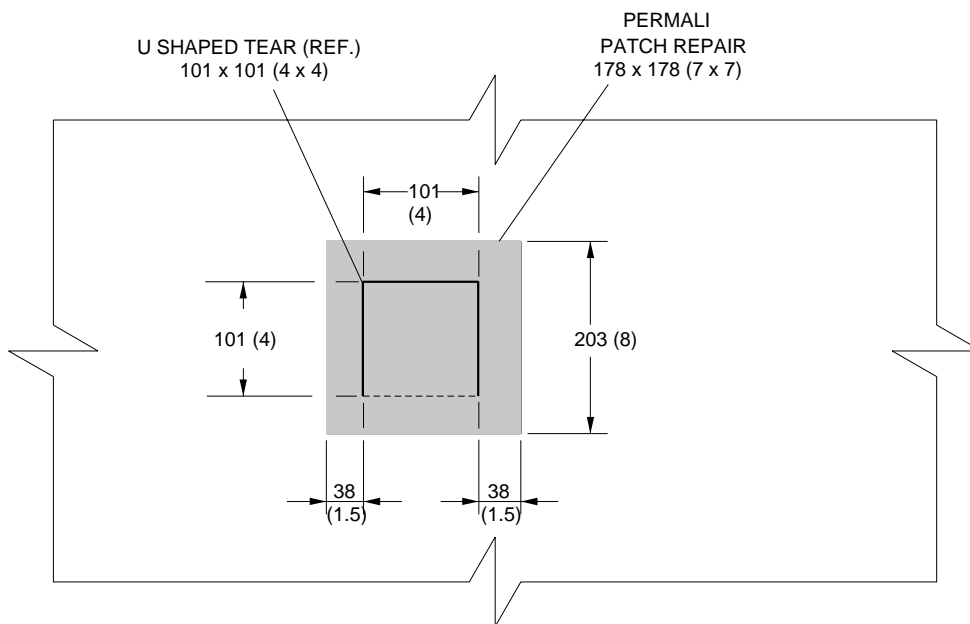
EFFECTIVITY: ALL

Forward Baggage Compartment Partition - Maximum Damage

Figure 801 - Sheet 2



DET. B



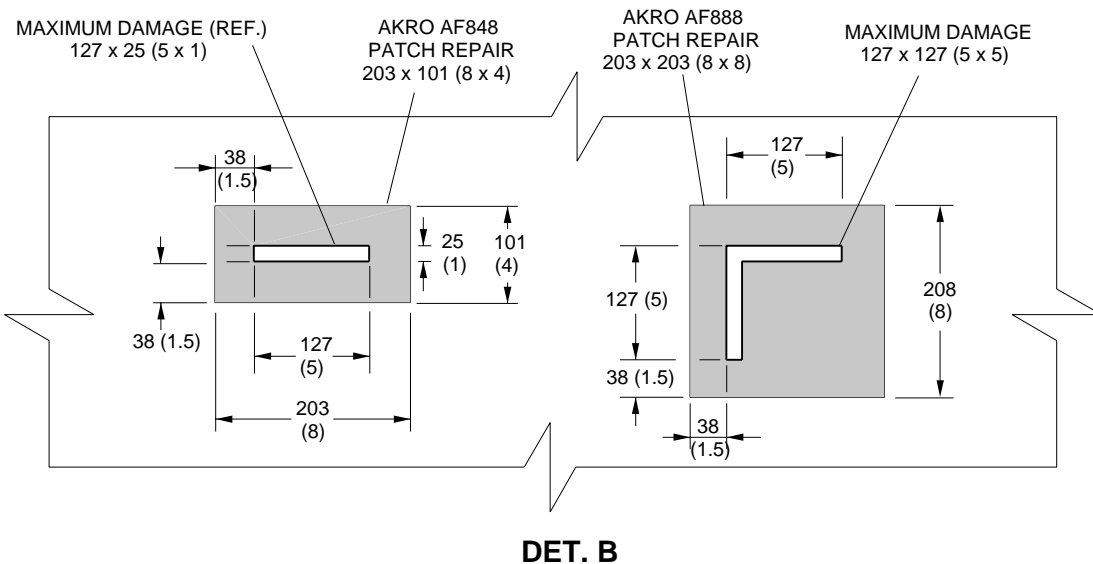
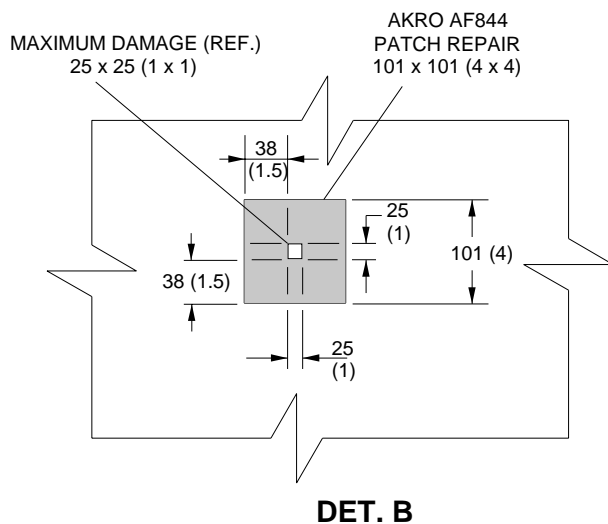
DET. B

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EFFECTIVITY: ALL

Forward Baggage Compartment Partition - Maximum Damage

Figure 801 - Sheet 3

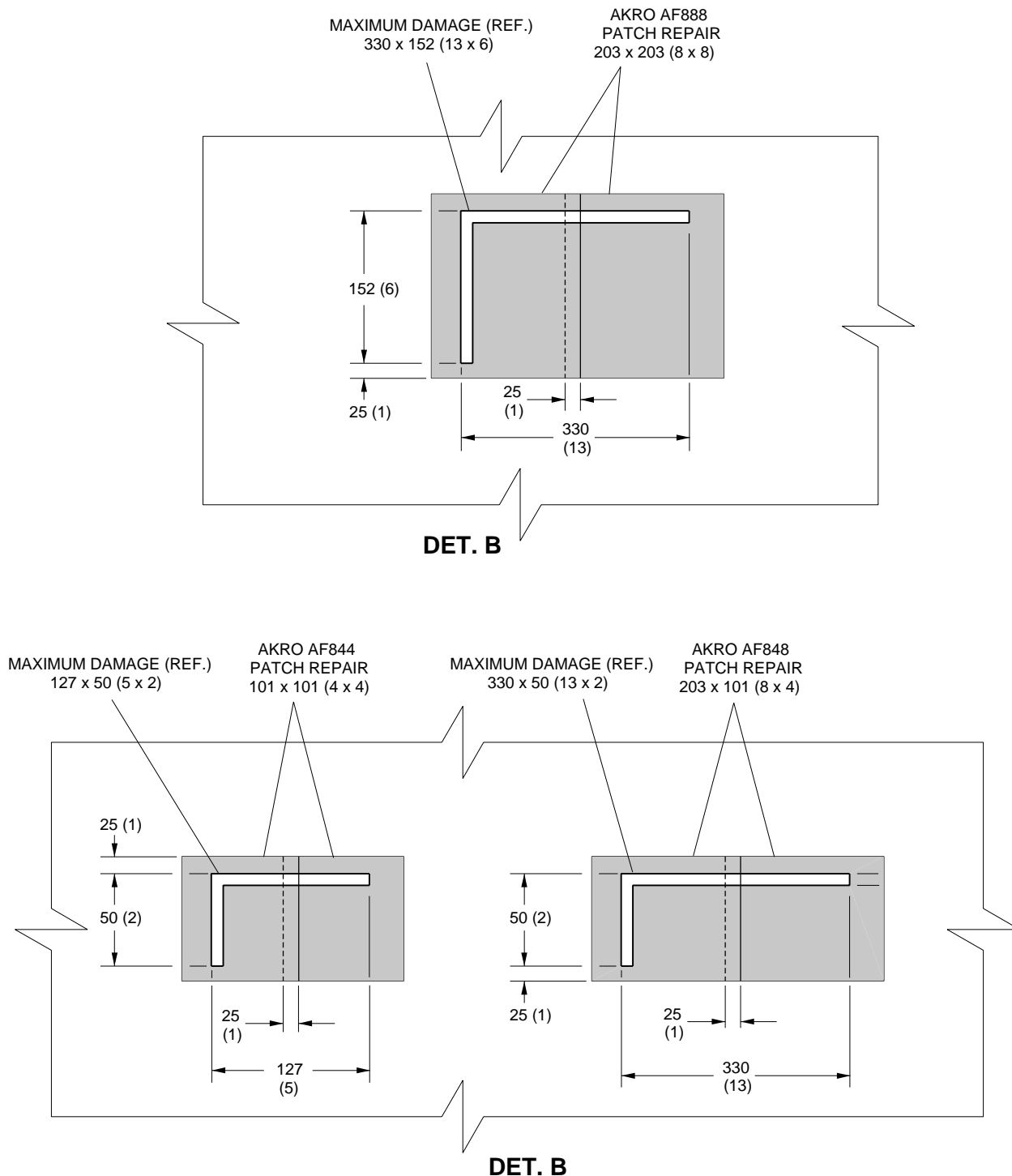


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EFFECTIVITY: ALL

Forward Baggage Compartment Partition - Maximum Damage

Figure 801 - Sheet 4

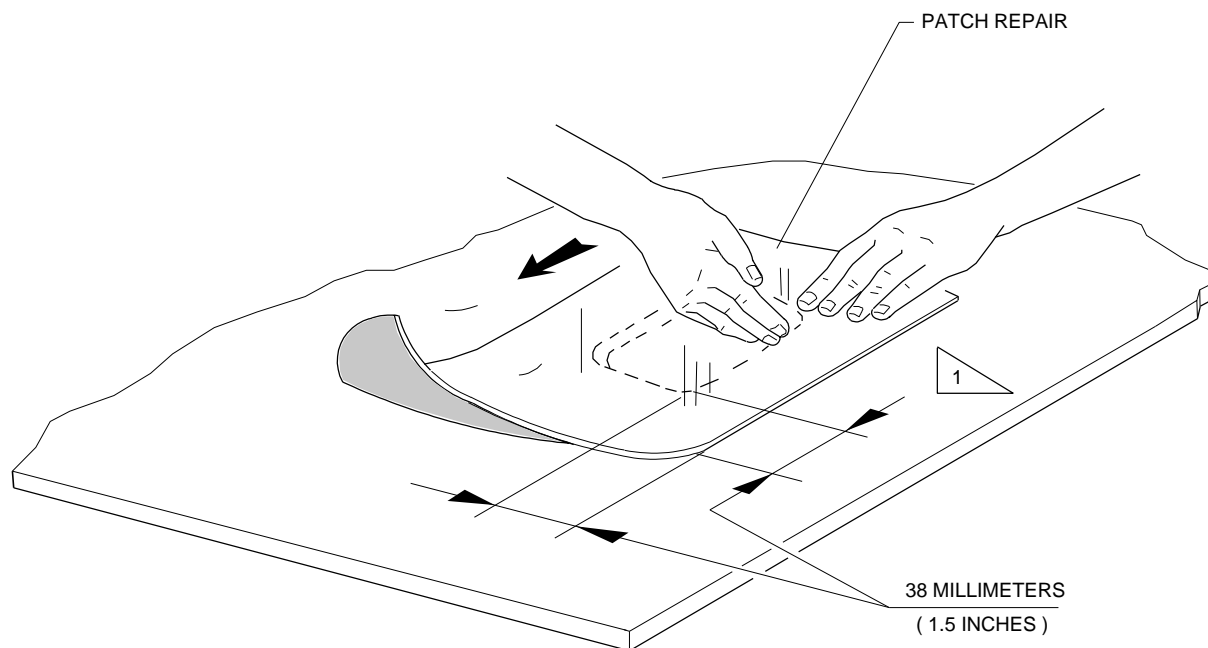


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EFFECTIVITY: ALL

Forward Baggage Compartment Partition - Patch Repair Procedure

Figure 802



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

145AMM250730.MCE A

TASK 25-27-02-300-802-A

EFFECTIVITY: ALL

3. FORWARD BAGGAGE COMPARTMENT PARTITION - RIGID PATCH REPAIR

A. General

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

NOTE: For this repair, you can use two kinds of rigid patches: Stainless steel or Aluminum 2024 T-3 or 7075 T-3.

- (2) For these patch repairs, set-up or cure time is necessary. See manufacturer's instructions.

- (3) The patch repair method was tested and approved for use only on the aft skin, at the baggage compartment side.

- (4) To repair the surfaces, you must obey the conditions given below:

- (a) To apply patch repairs bonded without rivets the damage can not be larger than 12,7 x 12,7 mm (1/2 x 1/2 in) square in size.

NOTE: Multiple patches of 12,7 x 12,7 mm (1/2 x 1/2 in) square in size can be done.

- (b) To apply patch repairs with hard rivets the damage can not be larger than 103 cm² (16 in²).

NOTE: Multiple patches of 103 cm² (16 in²) can be done.

- (5) The steel material must be 0.508 mm (0.020 in) thick 300 series stainless or better.

- (6) The Aluminum 2024 T-3 or 7075 T-3 must be 0.84 mm (0.032 in) thick or better.

- (7) The adhesive P/S 870 is available in three types:

- (a) Type A: Low viscosity version. Work best on surface with no penetration damage, can be applied with a brush.
- (b) Type B: Higher viscosity version of the same adhesive. IT requires plastic spreader, trowels, putty knife, or similar edge tool to distribute the adhesive over the panel surfaces.
- (c) Type C: It moves and distributes with either spatula or stiff brush. Moves and flows on part surfaces.

B. References

REFERENCE	DESIGNATION
AMM TASK 25-27-02-000-801-A/400	-
AMM TASK 25-27-02-400-801-A/400	-
TASK 25-00-00-340-801-A	-

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	Medium/fine Sandpaper, 180 grit	To remove exterior dirt	AR
Commercially available	Drill	To mix the putty	AR

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
Commercially available	Rhodiasolve E-23 - Commercial grade	AR
TT-I-735	Isopropyl Alcohol - Commercial grade	AR
Commercially available	Stainless Steel 300 series	AR
Commercially available	Aluminum 2024 T-3 or 7075 T-3	AR
MIL-PRF-81733	P/S 870 Courtaulds Metal Bonding Sealant/Adhesives	AR
CR3523	Cherry Rivets CR3523-4-1	AR
Commercially available	Flashbreaker Polyester Pressure Sensitive Adhesive	AR
Commercially available	GE RTV 100 series Adhesives	AR
Commercially available	Dow Corning RTV 730 series or 730 FS Adhesives	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Baggage compartment

I. Rigid Patch Repair (Figure 802)

SUBTASK 340-003-A

- (1) At the lavatory side make sure that the skin of the forward baggage partition remains intact without damage.

NOTE: These procedures are not applicable when damage occurs to both side.

- (2) If necessary, remove the forward baggage compartment partition (AMM TASK 25-27-02-000-801-A/400).

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

- (3) Clean the forward baggage compartment lining with Rhodiasolve E-23 or isopropyl alcohol to remove dirt, oil, and debris.
- (4) Use polyester tape to mask off the surface to keep the original paint intact outside the patch repair and on the adjacent border.
- (5) With a 180 grit sanding paper or finer, fully remove the debris from the area where you will install the patch repair.
- (6) Wipe the surface after you sand it, with a clean, shop wipe soaked in Rhodiasolve E-23, 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) Define the size of the damaged area and develop a template or tracing, to size and cut the metal patch.
- (8) Obey the conditions given below to cut the metal skin in right size.
- (a) Make sure that there is a border of liner material with 25,4 millimeters (1.0 inch) between the damage and the outer edge of the patch repair.
- (b) To mark the periphery of the damage, you can use a compass if you think it will make your job easier.

- (9) Fill and fairing the patch, if necessary (TASK 25-00-00-340-801-A).

NOTE: They may be filled with metal skin-bonding P/S 870 Type B.

- (10) Obey the conditions below to drill holes in patch for rivet locations.
- (a) Match drill through the partition skin for blind rivets.
- (b) Make sure that on each patch, the center of rivet holes has a minimum of 6,35 mm (0.25 in) from all edges.
- (c) Make sure that there is on each patch, a minimum of 1 rivet every 127 mm (5 in) of length.
- (11) On a mixing tray, container or cardboard palette, put some P/S 870 courtaulds adhesive.
- (12) Mix with a large spatula or knife.

(13) Use adhesive spreaders to distribute the material over the patch and damage surface.

- NOTE:
- Be careful not to contaminate the adhesive side.
 - Both surfaces must be given a uniform coat of adhesive.

(14) Apply the the metal patch over the damage surface.

- NOTE:
- Start work the patch at one corner.
 - If necessary, have a second technician to help hold the panel off-set of the bonding. surface
 - Carefully work the patch down, apply firm, positive pressure and smooth as necessary to prevent entrapped air.

(15) Use Rhodiasolve E-23 or isopropyl alcohol to remove any excess of adhesive from the metal surface.

(16) Install the rivets on the forward baggage partition repair to apply pressure.

(17) Allow 12 hours to consolidate the surfaces.

- NOTE:
- The repair is complete in a total of 24 hours.
 - The adhesive P/S870 is available in various cure rates and times. See manufacturer's instructions.

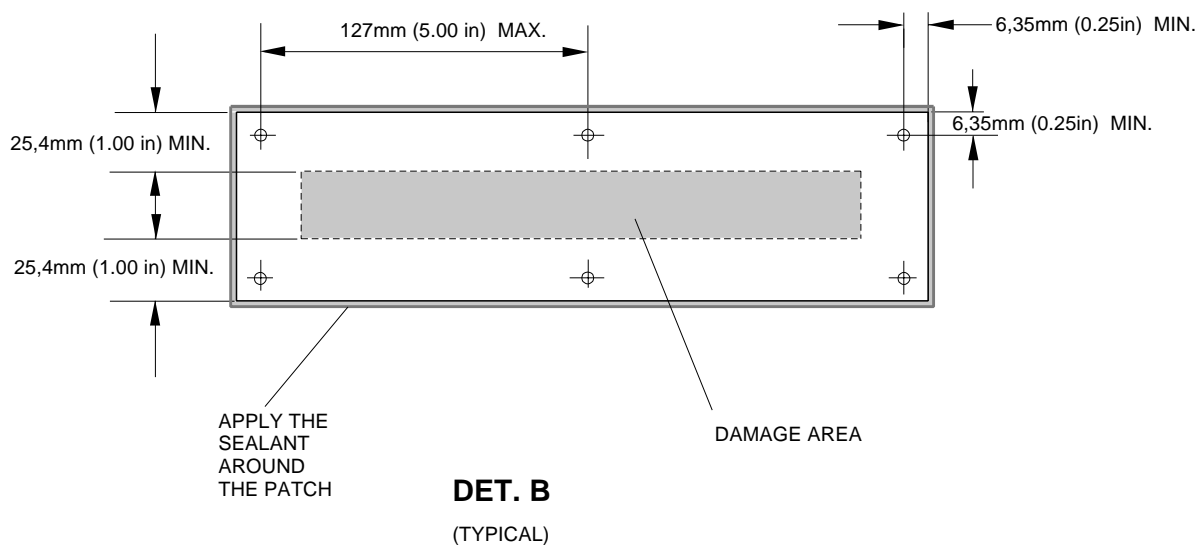
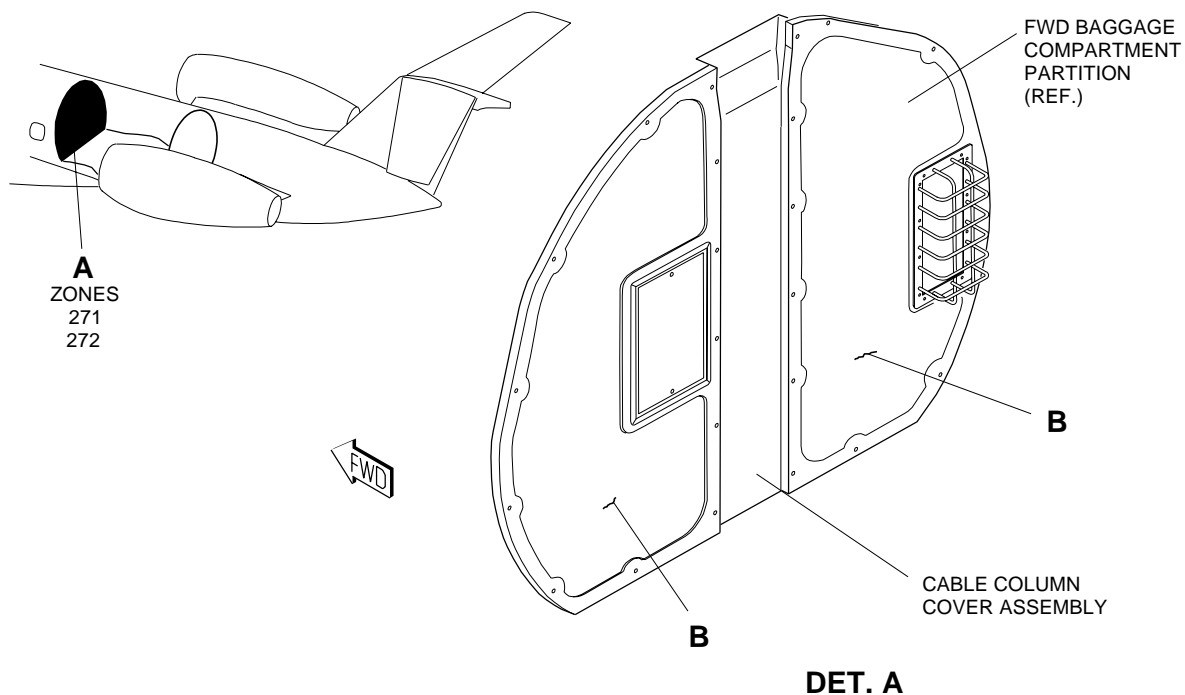
(18) Apply the adhesive GE RTV 100 series to the edges of the repair.

- NOTE: As an alternative, you can apply to the edges, the adhesive Dow Corning RTV 730 series or the adhesive 730 FS or the adhesive P/S 870.

(19) Remove the tape.

(20) If you removed, install the forward baggage-compartment partition back (AMM TASK 25-27-02-400-801-A/400).

EFFECTIVITY: ALL
Rigid Patch Repair
Figure 803



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TASK 25-27-02-300-803-A

EFFECTIVITY: ALL

4. FORWARD BAGGAGE COMPARTMENT PARTITION - FIREBLOCK BLANKET REWORK

A. General

- (1) The fireblock blanket is installed at the forward baggage-compartment partition.
- (2) This task gives the rework instructions to bring the fireblock blanket back to its original configuration.
- (3) The surfaces where the fireblock blanket is installed at the forward baggage-compartment partition are described as follows:
 - (a) Surface A: Aluminum surface;
 - (b) Surface B: Tedlar surface;
 - (c) Surface C: Panel edge.
- (4) To repair the surfaces, you must obey the conditions given below:

CAUTION: YOU MUST NOT APPLY ANY ADHESIVE TO REBOND THE FIREBLOCK BLANKET ON THE ALUMINUM SURFACE (A).

- (a) If the surface A receives any additional adhesive, the certification of the part will be invalidated.
- (b) In case the fireblock blanket on aluminum surface (A) is disbonded, it is necessary to replace fully it.

CAUTION: YOU MUST USE THE SPECIFIC ADHESIVE INDICATED ON THIS TASK.

- (c) In case the fireblock blanket on the tedlar surface (B) and/or panel edge (C) is disbonded, you can rebond it. You can use the old fireblock or replace for a new one.

B. References

REFERENCE	DESIGNATION
AMM TASK 25-27-02-000-801-A/400	-
AMM TASK 25-27-02-400-801-A/400	-
IPC 25-27-02	PARTITION PAX / CARGO

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

(Continued)

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Safety goggles	Eye protection	1
Commercially available	Adhesive spreaders	To spread the adhesive	1

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
Commercially available	Rhodiasolve E-23 - Commercial grade	AR
TT-I-735	Isopropyl Alcohol - Commercial grade	AR
MMM-A-121	Adhesive Scotchgrip 5	AR
MMM-A-121	Adhesive Scotchgrip 10	AR

G. Expendable Parts

ITEM	IPC REFERENCE (VENDOR REFERENCE)	QTY
7141010-11FPC Fireblock Blanket-self adhesive	IPC 25-27-02	AR

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Baggage compartment

I. Repair (Figure 803)

SUBTASK 340-004-A

- (1) If necessary, remove the forward baggage compartment partition (AMM TASK 25-27-02-000-801-A/400).
- (2) For aluminum surface (A), do the procedures as follows:
 - (a) Carefully, remove the fireblock blanket.

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

- (b) Clean the area where the fireblock blanket was removed with a clean, shop wipe soaked with Rhodiasolve E-23 or isopropyl alcohol to remove dirt, oil, and debris.

- 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.

CAUTION: YOU MUST NOT APPLY ANY ADHESIVE TO REBOND THE FIREBLOCK BLANKET ON THE ALUMINUM SURFACE (A). THE FIREBLOCK BLANKET HAS SELF ADHESIVE.

- (c) Install a new one fireblock blanket on the aluminum surface (A).
- (3) For tedlar surface (B) and panel edge (C), do the procedures as follows:
 - (a) Carefully, remove the fireblock blanket.

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

- (b) Clean the area where the fireblock blanket was removed with with a clean, shop wipe soaked with Rhodiasolve E-23 or isopropyl alcohol to remove dirt, oil, and debris.

- 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.

CAUTION: YOU MUST NOT APPLY ADHESIVE TO THE BACK OF THE FIREBLOCK BLANKET.

- (c) Use adhesive spreaders to distribute the adhesive over the tedlar (surface B) or panel edge (surface C).

- NOTE:**
- As an alternative you can use the Scotchgrip 10.
 - For cure time, obey the manufacturer's instructions.

- (d) Install the old fireblock blanket or install a new one.
- (4) Use Rhodiasolve E-23 or isopropyl alcohol to remove any excess of adhesive from the surface.
- (5) If you removed, install the forward baggage-compartment partition back (AMM TASK 25-27-02-400-801-A/400).

A
ZONES
271
272

FWD BAGGAGE COMPARTMENT PARTITION (REF.)

B B B B

FIREBLOCK BLANKET

DET. A

SURFACE A: ALUMINIUM
ADDITIONAL ADHESIVE IS NOT ACCEPTABLE

SURFACE C: PANEL EDGE
ADDITIONAL ADHESIVE IS ACCEPTABLE

SECTION B-B

SURFACE B: TEDLAR
ADDITIONAL ADHESIVE IS ACCEPTABLE

