

HORIZONTAL-STABILIZER-TIP POLYURETHANE FILM - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and apply the horizontal-stabilizer-tip polyurethane film.
- 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
55-14-01-000-801-A	HORIZONTAL-STABILIZER-TIP POLYURETHANE FILM - REMOVAL	ALL
55-14-01-400-801-A	HORIZONTAL-STABILIZER-TIP POLYURETHANE FILM - INSTALLATION	ALL

TASK 55-14-01-000-801-A

EFFECTIVITY: ALL

2. HORIZONTAL-STABILIZER-TIP POLYURETHANE FILM - REMOVAL

A. General

- (1) This procedure gives the instructions to remove the horizontal-stabilizer-tip polyurethane film.

B. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
333		Horizontal stabilizer
334		Horizontal stabilizer

C. Tools and Equipment

Not Applicable

D. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Spatula	To remove the old film	1

E. Consumable Materials

Not Applicable

F. Expandable Parts

Not Applicable

G. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Horizontal stabilizer tips

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

SUBTASK 020-002-A

- (1) Prepare the new film with the old film as a template. Mark the contour to cut the excess material of the new film to the correct size. Refer to steps A and B.

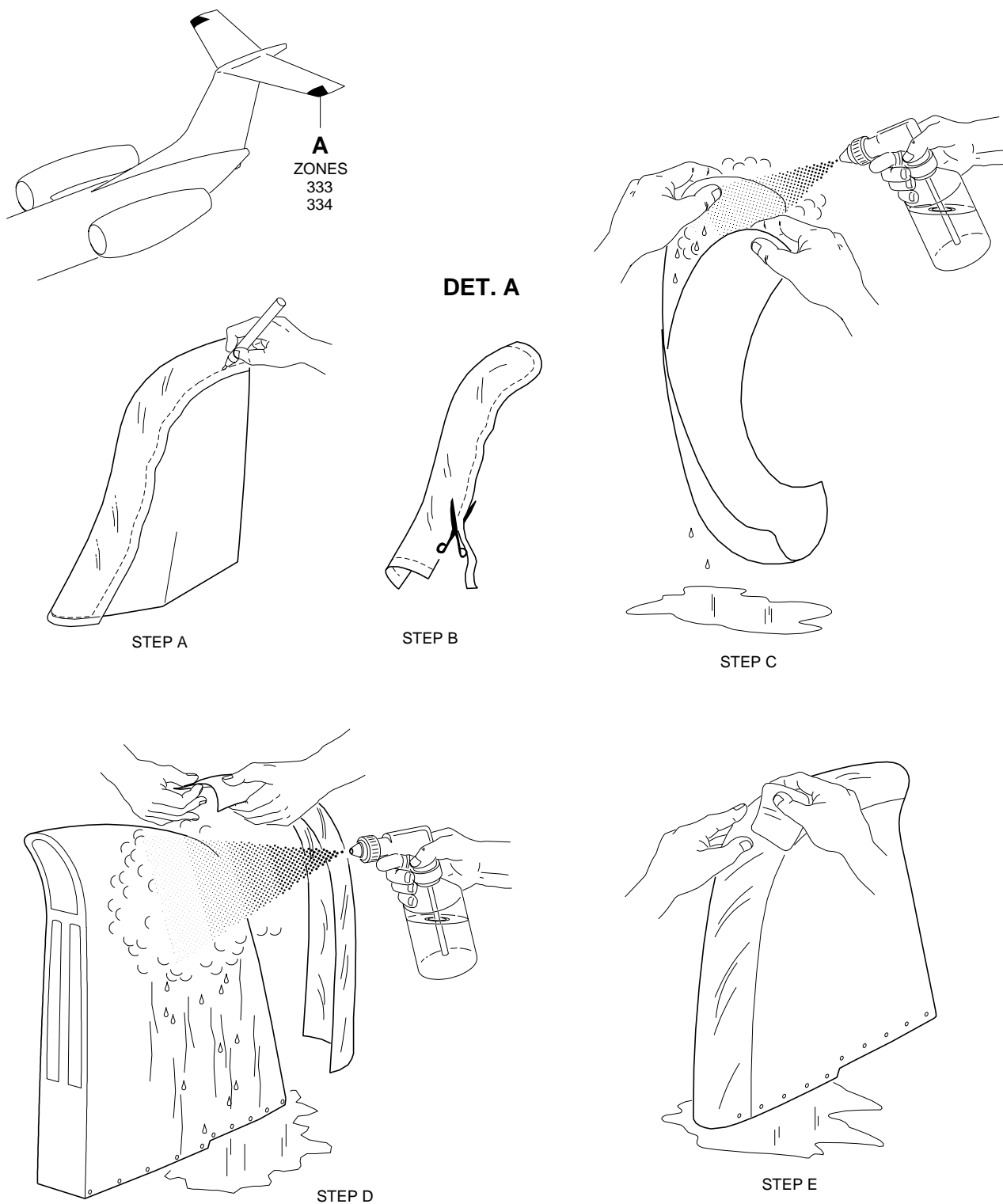
CAUTION: BE CAREFUL WHEN YOU REMOVE THE OLD FILM TO PREVENT DAMAGE TO THE TIP SURFACE.

- (2) Remove the old polyurethane film. For this, use a spatula and pull the film.

EFFECTIVITY: ALL

Horizontal-Stabilizer-Tip Polyurethane Film - Removal/Installation

Figure 401



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TASK 55-14-01-400-801-A

EFFECTIVITY: ALL

3. HORIZONTAL-STABILIZER-TIP POLYURETHANE FILM - INSTALLATION

A. General

(1) This procedure gives the instructions to apply the horizontal-stabilizer-tip polyurethane film.

B. References

REFERENCE	DESIGNATION
AMM TASK 55-14-01-000-801-A/400	HORIZONTAL-STABILIZER-TIP POLYURETHANE FILM - REMOVAL
IPC 11-21-05	EXTERIOR DECAL, CORROSION PROTECTION

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
333		Horizontal stabilizer
334		Horizontal stabilizer

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Spatula	To squeegee unapplied film and eliminate air bubbles	1

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
MEP 21-012	Neutral Liquid Detergent	AR
FED. SPEC. TT-I-735	Isopropyl Alcohol	AR

G. Expendable Parts

ITEM	IPC REFERENCE (VENDOR REFERENCE)	QTY
Polyurethane film	IPC 11-21-05	AR

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Horizontal stabilizer tip
1	Helps the other technician	Horizontal stabilizer tip

I. Preparation (Figure 401)

SUBTASK 841-002-A

- (1) Fully mix neutral liquid detergent with isopropyl alcohol and water. The solution must contain approximately 2.5% of liquid detergent, 24.5% of isopropyl alcohol, and 73% of water.

J. Installation (Figure 401)

SUBTASK 420-002-A

- (1) Use the old film as a reference to cut the new film to the correct size. Refer to steps A and B ([\(AMM TASK 55-14-01-000-801-A/400\)](#)).

- (2) Clean the tip surface and the polyurethane film with a cloth wet with isopropyl alcohol.

CAUTION: DO NOT PERMIT THE ADHESIVE SIDE OF THE FILM TO BE TOUCHED TO PREVENT FINGERPRINTS AND LOSS OF ADHESIVENESS.

- (3) Separate the liner from the film and spray the detergent solution on the adhesive surface at the same time. Refer to step C.

- (4) Wet the tip surface with detergent solution.

- (5) Align the film and press on edge to surface with fingers. Refer to step D.

CAUTION: IF AIR BUBBLE OCCURS, DO NOT MAKE A HOLE IN THE FILM TO ELIMINATE THE AIR BUBBLE.

- (6) Squeeze the water out from the tip with the spatula. Refer to step E.

NOTE: If an air bubble occurs, pull the film back until you get to the location of the air bubble, spray with detergent solution, and apply the film again.

- (7) After one hour, the tip with the film is ready for service.

