

AIRSTAIRS MAIN DOOR GUIDES - REMOVAL/INSTALLATION

EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS MAIN DOOR

1. General

- A. This section gives the procedures to remove and install the airstairs main door guides.
- 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
53-21-05-000-801-A	AIRSTAIRS MAIN DOOR GUIDES - REMOVAL	AIRCRAFT WITH AIRSTAIRS MAIN DOOR
53-21-05-400-801-A	AIRSTAIRS MAIN DOOR GUIDES - INSTALLATION	AIRCRAFT WITH AIRSTAIRS MAIN DOOR

TASK 53-21-05-000-801-A

EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS MAIN DOOR

2. AIRSTAIRS MAIN DOOR GUIDES - REMOVAL

A. General

(1) This task gives the procedure to remove the airstairs main door guides.

B. References

REFERENCE

DESIGNATION

[AMM SDS 52-10-00/1](#)

C. Zones and Accesses

ZONE

PANEL/DOOR

LOCATION

811

Main door

D. Tools and Equipment

ITEM

DESCRIPTION

PURPOSE

QTY

Commercially
available

No. 8 screwdriver bits for torq-set
screws

To remove the screws

E. Auxiliary Items

Not Applicable

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY

FUNCTION

PLACE

1

Does the task

At the main door frames

I. Preparation

SUBTASK 841-002-A

(1) Open the main door ([AMM SDS 52-10-00/1](#)).

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

SUBTASK 020-002-A

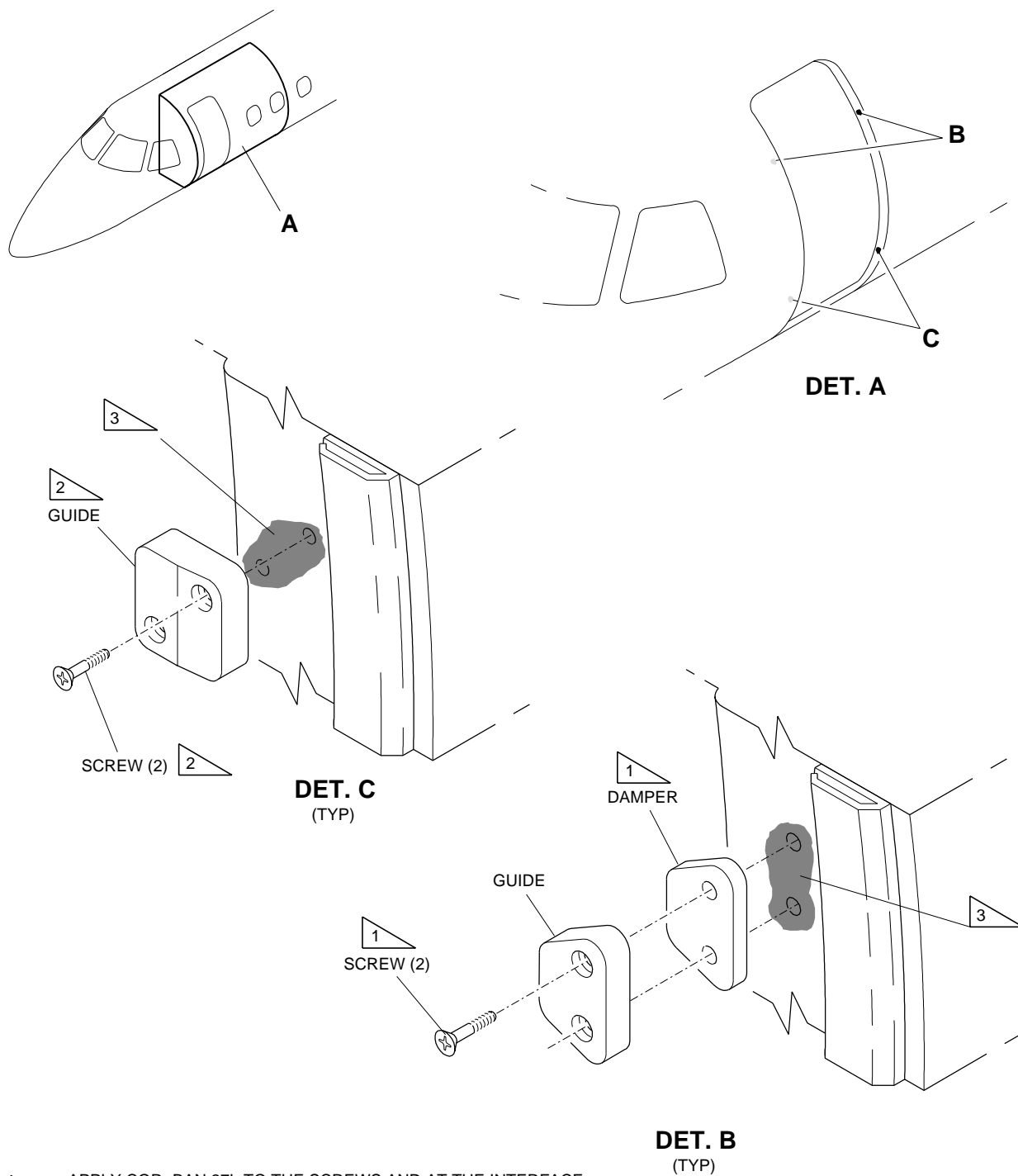
(1) Remove the screws from the airstairs main door guide. Refer to [Figure 401](#).

(2) Remove the airstairs main door guide and, if applicable, the damper.

EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS MAIN DOOR

Airstairs Main Door Guides - Removal/Installation

Figure 401



- 1 APPLY COR-BAN 27L TO THE SCREWS AND AT THE INTERFACE BETWEEN THE DOOR FRAME AND THE DAMPER.
- 2 APPLY COR-BAN 27L TO THE SCREWS AND AT THE INTERFACE BETWEEN THE DOOR FRAME AND THE GUIDE.
- 3 FOR AIRCRAFT POST-MOD SB145-53-0040 OR SB145-53-0088 APPLY ALODINE 1200S AND EPOXY PRIMER.

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TASK 53-21-05-400-801-A

EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS MAIN DOOR

3. AIRSTAIRS MAIN DOOR GUIDES - INSTALLATION

A. General

(1) This task gives the procedure to install the airstairs main door guides.

B. References

REFERENCE	DESIGNATION
AMM SDS 52-10-00/1	
AMM TASK 52-10-01-820-807-A/500	MAIN DOOR-TO-FUSELAGE SKIN GAP - ADJUSTMENT
S.B.145-53-0040	-
S.B.145-53-0088	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
811		Main door

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	No. 8 screwdriver bits for torq-set screws	To install the screws	

E. Auxiliary Items

Not Applicable

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
MEP 09-075	Corrosion-Inhibiting Compound (COR-BAN 27L)	AR
MIL-C-5541	Alodine 1200S	AR
MEP 10-059	Epoxy Primer	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	At the main door frames

I. Installation (Figure 401)

SUBTASK 420-002-A

NOTE: Make sure that the door frame area where the door guide is installed does not show signs of corrosion. If it does, contact the EMBRAER Technical Support Department.

- (1) For aircraft POST-MOD. [S.B.145-53-0040](#) or [S.B.145-53-0088](#), do a chemical conversion touch-up of all bare metal surface in the holes with Alodine 1200S (Spec MIL-C-5541) and then apply Epoxy primer (Spec. MEP10-059). Refer to (Figure 401).

WARNING: THE COR-BAN 27L CORROSION-INHIBITING COMPOUND IS TOXIC TO SKIN, EYES, AND RESPIRATORY TRACT. USE GOGGLES AND PROTECTIVE GLOVES. USE ONLY IN WELL VENTILATED AREAS. OBEY THE MANUFACTURER'S HEALTH AND SAFETY INSTRUCTIONS.

- (2) Apply COR-BAN 27L at the interface between the door frame and the damper or guide, as applicable, at the guide position.
- (3) Install the airstairs main door guide with the screws soaked in COR-BAN 27L.
- (4) Adjust the gap between the guides installed at the fuselage and at the door ([AMM TASK 52-10-01-820-807-A/500](#)).

J. Follow-on

SUBTASK 842-002-A

- (1) Close the main door ([AMM SDS 52-10-00/1](#)).

