

## PIVOT DOOR BEARING - INSPECTION/CHECK

*EFFECTIVITY: ALL*

1. General

- A. This section gives the procedures to do the inspection and check of the pivot door bearing.
- B. These procedures are applicable to the Upper and Lower doors.
- 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
78-31-06-200-801-A	PIVOT DOOR BEARING - INSPECTION/ CHECK	AIRCRAFT WITH PIV- OT DOOR BEARING P/N RBF12DAT
78-31-06-200-802-A	PIVOT DOOR BEARING BORE - INSPEC- TION/CHECK	ALL

TASK 78-31-06-200-801-A

*EFFECTIVITY: AIRCRAFT WITH PIVOT DOOR BEARING P/N RBF12DAT*

2. PIVOT DOOR BEARING - INSPECTION/CHECK

A. General

(1) Obey the instructions below to do the inspection and check of the pivot door bearing.

B. References

REFERENCE	DESIGNATION
AMM MPP 78-30-00/200	- MAINTENANCE PRACTICES
AMM TASK 78-31-02-000-801-A/400	THRUST-REVERSER UPPER DOOR - REMOVAL
AMM TASK 78-31-02-400-801-A/400	THRUST-REVERSER UPPER DOOR - INSTALLATION
AMM TASK 78-31-03-000-801-A/400	THRUST-REVERSER LOWER DOOR - REMOVAL
AMM TASK 78-31-03-400-801-A/400	THRUST-REVERSER LOWER DOOR - INSTALLATION
AMM TASK 78-33-01-980-801-A/200	ISOLATION CONTROL UNIT - INHIBITION PROCEDURES

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the engine nacelle	
GSE 341	TR Bearing Holder	To use in the axial play measurement	

E. Auxiliary Items

Not Applicable

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
ASTM-D-740	Solvent (Methyl Ethyl Ketone)	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Examines the pivot door bearing	Thrust reverser door

I. Preparation

*SUBTASK 841-002-A*

**WARNING:** • REFER TO THE GROUND SAFETY PRECAUTIONS GIVEN IN [AMM MPP 78-30-00/200](#) WHEN YOU DO THE THRUST REVERSER MAINTENANCE PROCEDURES.

- MAKE SURE THAT THE THRUST REVERSERS ARE DEENERGIZED. ENERGIZED CIRCUITS CAN CAUSE INJURY TO PERSONS.
- MAKE SURE THAT THE HYDRAULIC TEST STAND IS NOT CONNECTED.

**CAUTION:** MAKE SURE THAT ALL THE HYDRAULIC LINES ARE CONNECTED NOT TO PERMIT THE HYDRAULIC OIL TO FALL OUT.

- (1) Make sure that the aircraft is safe for maintenance.
- (2) Put the workstand under the engine thrust reverser.
- (3) On the circuit breaker panel, open these circuit breakers and attach a DO-NOT-CLOSE tag to them:
  - THRUST REVERSER 1/2.
  - HYD. ELEC. PUMP 1/2.
- (4) Put a DO-NOT-OPERATE-THE-THRUST-REVERSERS sign on the instrument panel, in the cockpit.
- (5) Inhibit the ICU ([AMM TASK 78-33-01-980-801-A/200](#)).
- (6) Remove the upper door ( [AMM TASK 78-31-02-000-801-A/400](#)) or lower door ( [AMM TASK 78-31-03-000-801-A/400](#)), as applicable.

J. Inspection/Check

*SUBTASK 211-002-A*

**WARNING:** DO NOT APPLY HYDRAULIC POWER TO THE AIRCRAFT, AND DO NOT OPERATE THE THRUST REVERSER WHILE THE MAINTENANCE PERSONS ARE AT WORK.

**WARNING:** METHYL-ETHYL-KETONE (MEK) IS IRRITANT AND HIGHLY FLAMMABLE. THIS CHEMICAL PRODUCT CAN CAUSE INJURIES. TO USE IT, OBEY THE MANUFACTURER'S INSTRUCTIONS.

- (1) Clean the thrust-reverser pivot bearing with a dry lint-free cloth with methyl-ethyl-ketone (MEK) or similar.

- NOTE:** • Let the solvent dry before you turn the ball to make sure that the lubricant applied to the inner surface of the bearing case is not removed.
- Try to remove all metallic unwanted material from the ball.

- (2) Use GSE 341 to prevent the tilting movement of the pivot-door bearing ball and permit the bearing axial play measurement. The axial play must be less than or equal to 1.5 mm.
- (3) There can be grooves on the ball surface. They are permitted if the axial play is within the value specified in step (2).

K. Follow-on

*SUBTASK 842-002-A*

**CAUTION:** EXAMINE ALL THE WORK AREAS TO MAKE SURE YOU DID NOT LET TOOLS OR OTHER EQUIPMENT STAY BEHIND.

- (1) Install the upper door ( [AMM TASK 78-31-02-400-801-A/400](#)) or lower door ( [AMM TASK 78-31-03-400-801-A/400](#)), as applicable.
- (2) Deinhbit the ICU ([AMM TASK 78-33-01-980-801-A/200](#)).
- (3) On the circuit breaker panel, close these circuit breakers and remove the DO-NOT-CLOSE tag from them:
  - THRUST REVERSER 1/2.
  - HYD. ELEC. PUMP 1/2.
- (4) Remove the DO-NOT-OPERATE-THE-THRUST-REVERSERS sign from the instrument panel, in the cockpit.
- (5) Remove the workstand from the work area.

TASK 78-31-06-200-802-A  
EFFECTIVITY: ALL

3. PIVOT DOOR BEARING BORE - INSPECTION/CHECK

A. General

(1) Obey the instructions below to do the inspection and check of the pivot door bearing bore.

B. References

REFERENCE	DESIGNATION
AMM MPP 78-30-00/200	- MAINTENANCE PRACTICES
AMM TASK 78-31-02-000-801-A/400	THRUST-REVERSER UPPER DOOR - REMOVAL
AMM TASK 78-31-02-400-801-A/400	THRUST-REVERSER UPPER DOOR - INSTALLATION
AMM TASK 78-31-03-000-801-A/400	THRUST-REVERSER LOWER DOOR - REMOVAL
AMM TASK 78-31-03-400-801-A/400	THRUST-REVERSER LOWER DOOR - INSTALLATION
AMM TASK 78-31-06-000-801-A/400	PIVOT DOOR BEARING- REMOVAL
AMM TASK 78-31-06-400-801-A/400	PIVOT DOOR BEARING - INSTALLATION
AMM TASK 78-33-01-980-801-A/200	ISOLATION CONTROL UNIT - INHIBITION PROCEDURES
CPM 51-14-00	-
SRM 54-30-02/201	-

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the engine nacelle	
Commercially available	Three-point self-centering micrometer	To measure the pivot fitting bore	
Commercially available	Micrometer	To measure the thickness of the pivot fitting	

E. Auxiliary Items

Not Applicable

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
ASTM-D-740	Solvent (Methyl Ethyl Ketone)	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Examines/Measures the pivot door bearing bore	Thrust reverser door

I. Preparation

SUBTASK 841-003-A

**WARNING:** • REFER TO THE GROUND SAFETY PRECAUTIONS GIVEN IN [AMM MPP 78-30-00/200](#) WHEN YOU DO THE THRUST REVERSER MAINTENANCE PROCEDURES.

- MAKE SURE THAT THE THRUST REVERSERS ARE DEENERGIZED. ENERGIZED CIRCUITS CAN CAUSE INJURY TO PERSONS.
- MAKE SURE THAT THE HYDRAULIC TEST STAND IS NOT CONNECTED.

**CAUTION:** MAKE SURE THAT ALL THE HYDRAULIC LINES ARE CONNECTED NOT TO PERMIT THE HYDRAULIC OIL TO FALL OUT.

- (1) Make sure that the aircraft is safe for maintenance.
- (2) Put the workstand under the engine thrust reverser.
- (3) On the circuit breaker panel, open these circuit breakers and attach a DO-NOT-CLOSE tag to them:
  - THRUST REVERSER 1/2.
  - HYD. ELEC. PUMP 1/2.
- (4) Put a DO-NOT-OPERATE-THE-THRUST-REVERSERS sign on the instrument panel, in the cockpit.
- (5) Inhibit the ICU ([AMM TASK 78-33-01-980-801-A/200](#)).
- (6) Remove the upper door ( [AMM TASK 78-31-02-000-801-A/400](#)) or lower door ( [AMM TASK 78-31-03-000-801-A/400](#)), as applicable.
- (7) Remove the pivot door bearing ( [AMM TASK 78-31-06-000-801-A/400](#)).

J. Inspection/Check ([Figure 601](#))

SUBTASK 211-003-A

**WARNING:** METHYL-ETHYL-KETONE (MEK) IS IRRITANT AND HIGHLY FLAMMABLE. THIS CHEMICAL PRODUCT CAN CAUSE INJURIES. TO USE IT, OBEY THE MANUFACTURER'S INSTRUCTIONS.

- (1) Clean the area to be examined with a dry lint-free cloth with methyl-ethyl-ketone (MEK). Make sure that the surface is clean, dry and free of oil, grease and sealant.
- (2) Inspect the pivot fitting structure for cracks and corrosion. Remove all corrosion (CPM 51-14-00).

- (3) Measure the inside diameter of the hole in the pivot fitting in which the ball bearing nut will be installed. With a three-point self-centering micrometer, measure around all the perimeter of the hole in the pivot fitting. Record the largest dimension. Refer to DET. C, SECTION D-D of [Figure 601](#).
- (4) Measure the thickness of the pivot fitting in which the ball bearing nut will be installed. Use a micrometer to measure around the entire perimeter of the bore in the pivot fitting. Record the smallest dimension. Refer to DET. C, SECTION D-D of [Figure 601](#).
- (5) The diameter dimension got in step (3) must be less than or equal to 41.335 mm (1.627"). Refer to SRM 54-30-02/201 to repair the hole, if necessary.
- (6) The thickness dimension got in step (4) must be greater than or equal to 5.30 mm (0.21").

K. Follow-on

*SUBTASK 842-003-A*

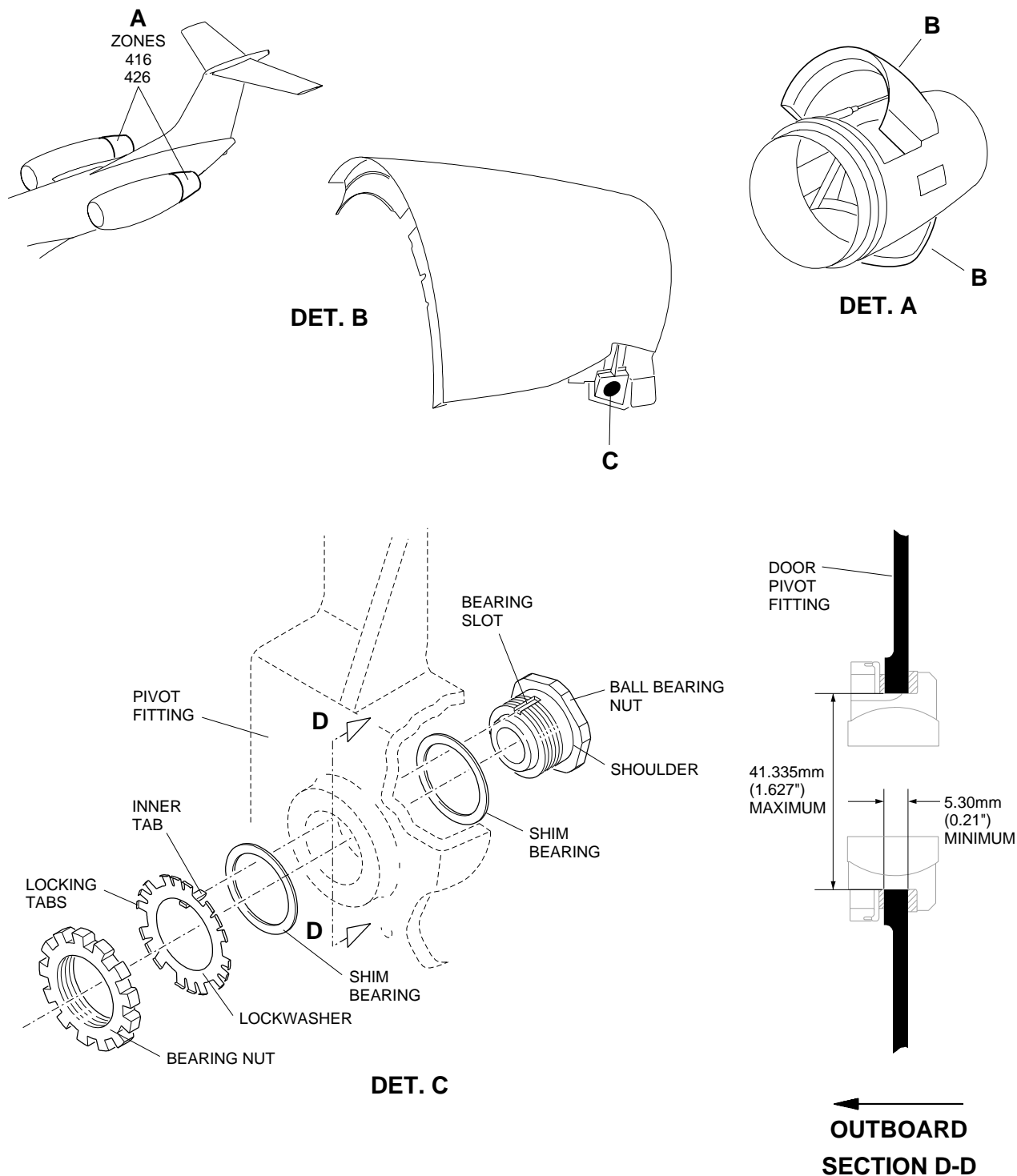
**CAUTION:** EXAMINE ALL THE WORK AREAS TO MAKE SURE YOU DID NOT LET TOOLS OR OTHER EQUIPMENT STAY BEHIND.

- (1) Install the pivot door bearing ( [AMM TASK 78-31-06-400-801-A/400](#)).
- (2) Install the upper door ( [AMM TASK 78-31-02-400-801-A/400](#)) or lower door ( [AMM TASK 78-31-03-400-801-A/400](#)), as applicable.
- (3) Deinhbit the ICU ([AMM TASK 78-33-01-980-801-A/200](#)).
- (4) On the circuit breaker panel, close these circuit breakers and remove the DO-NOT-CLOSE tag from them:
  - THRUST REVERSER 1/2.
  - HYD. ELEC. PUMP 1/2.
- (5) Remove the DO-NOT-OPERATE-THE-THRUST-REVERSERS sign from the instrument panel, in the cockpit.
- (6) Remove the workstand from the work area.

EFFECTIVITY: ALL

Pivot Door Bearing Bore - Inspection/Check

Figure 601



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