



AIRCRAFT
MAINTENANCE MANUAL

HORIZONTAL-STABILIZER LEADING EDGE - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the horizontal-stabilizer leading edge.
- 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
55-15-00-000-801-A	HORIZONTAL-STABILIZER LEADING EDGE - REMOVAL	ALL
55-15-00-400-801-A	HORIZONTAL-STABILIZER LEADING EDGE - INSTALLATION	ALL



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TASK 55-15-00-000-801-A

EFFECTIVITY: ALL

2. HORIZONTAL-STABILIZER LEADING EDGE - REMOVAL

A. General

(1) This procedure gives the instructions to remove the horizontal-stabilizer leading edge.

B. References

REFERENCE	DESIGNATION
AMM TASK 30-12-06-000-801-A/400	PICCOLO TUBE - REMOVAL
AMM TASK 55-13-00-000-801-A/400	HORIZONTAL-STABILIZER LEADING-EDGE ROOT FAIRINGS - REMOVAL
AMM TASK 55-13-02-000-801-A/400	HORIZONTAL STABILIZER TIPS - REMOVAL
AMM TASK 55-36-00-000-801-A/400	TAIL BOOM - REMOVAL
SRM 51-20-01	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
331		Leading edge - LH
332		Leading edge - RH

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Ladder		To get access to the horizontal stabilizer	1

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Horizontal-stabilizer leading edge

I. Preparation

SUBTASK 841-002-A

(1) Remove the front fixed fairing ([AMM TASK 55-36-00-000-801-A/400](#)).



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- (2) Remove the horizontal-stabilizer leading-edge root fairings (LH and RH) ([AMM TASK 55-13-00-000-801-A/400](#)).
- (3) Remove the horizontal stabilizer tips (LH and RH) ([AMM TASK 55-13-02-000-801-A/400](#)).

J. Removal

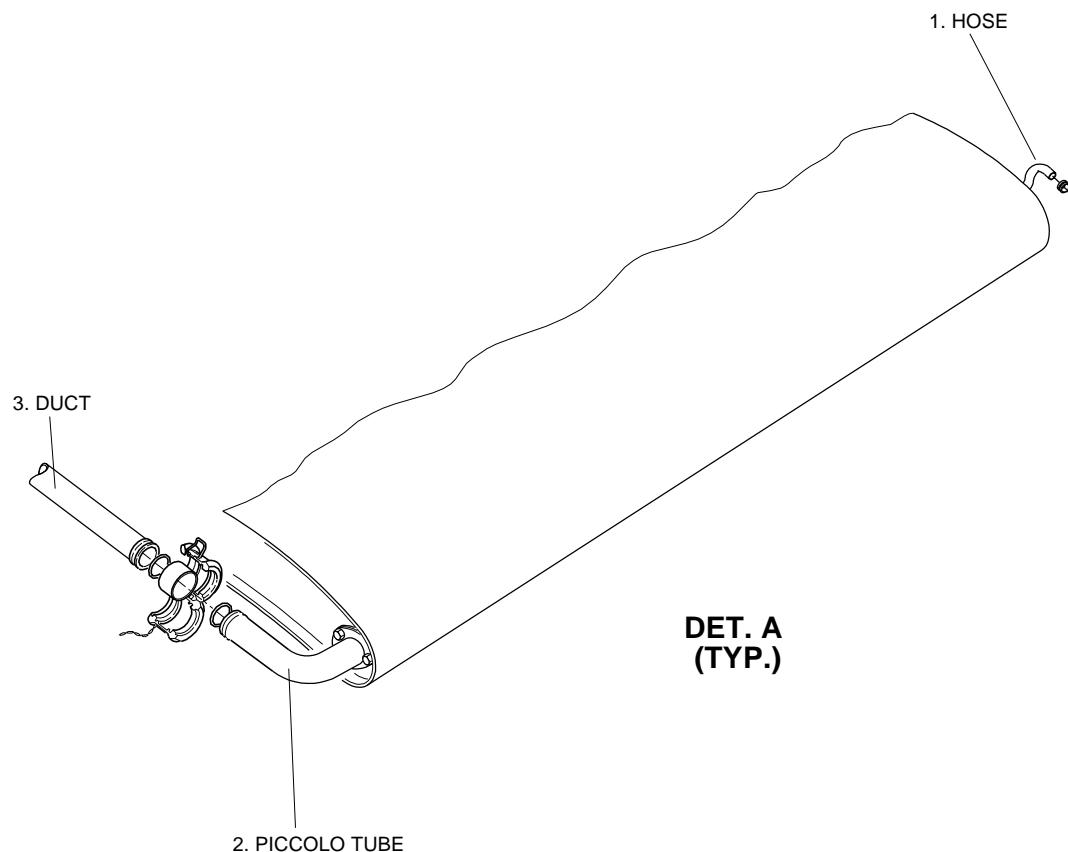
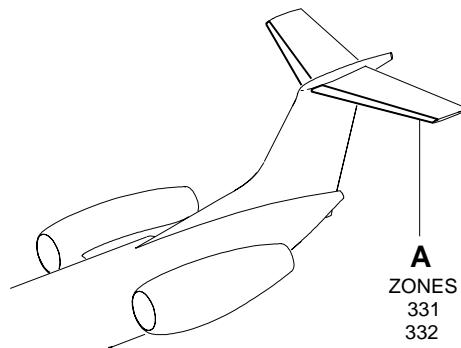
SUBTASK 020-002-A

- (1) Disconnect the piccolo tube (2) from the duct (3), and the hose (1) from the end of the piccolo tube at the leading edge. Refer to [Figure 401](#) and [AMM TASK 30-12-06-000-801-A/400](#).
- (2) Remove the screws (1) that attach the horizontal-stabilizer leading edge (2) to the horizontal stabilizer. Refer to [Figure 402](#).
- (3) Remove the horizontal-stabilizer leading edge (2) from the horizontal stabilizer. Refer to [Figure 402](#).
- (4) Remove the old aerodynamic sealant and prepare the surface. Refer to SRM 51-20-01.

EFFECTIVITY: ALL

Horizontal-Stabilizer Leading Edge - Removal/Installation

Figure 401

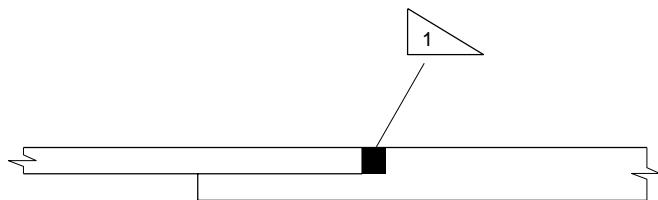
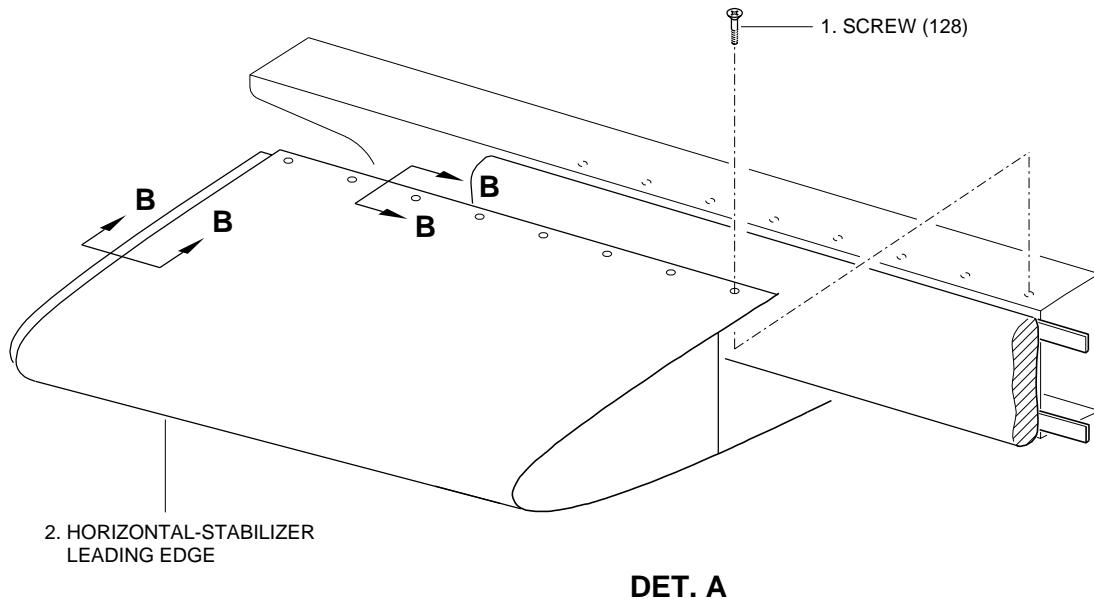
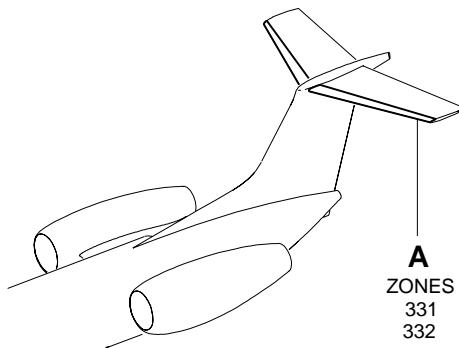


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EFFECTIVITY: ALL

Horizontal-Stabilizer Leading Edge - Removal/Installation

Figure 402


 **AERODYNAMIC SEALING**

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TASK 55-15-00-400-801-A

EFFECTIVITY: ALL

3. HORIZONTAL-STABILIZER LEADING EDGE - INSTALLATION

A. General

(1) This procedure gives the instructions to install the horizontal-stabilizer leading edge.

B. References

REFERENCE	DESIGNATION
AMM TASK 30-12-06-400-801-A/400	PICCOLO TUBE - INSTALLATION
AMM TASK 55-13-00-400-801-A/400	HORIZONTAL-STABILIZER LEADING-EDGE ROOT FAIRINGS - INSTALLATION
AMM TASK 55-13-02-400-801-A/400	HORIZONTAL STABILIZER TIPS - INSTALLATION
AMM TASK 55-36-00-400-801-A/400	TAIL BOOM - INSTALLATION
SRM 51-20-01	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
331		Leading edge - LH
332		Leading edge - RH

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Ladder		To get access to the horizontal stabilizer	1

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
MEP 09-083	Sealant, PR 2050 B-1/2	AR
Commercially available	Adhesive Tape	AR
Commercially available	Aluminum Tape (AL Tape 425)	AR
Commercially available	Polyethylene Film	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Horizontal-stabilizer leading edge

I. Installation

SUBTASK 420-002-A

- (1) Install the horizontal-stabilizer leading edge (2) to the horizontal stabilizer. Refer to Figure 402.
- (2) Install the screws (1) that attach the horizontal-stabilizer leading edge (2) to the horizontal stabilizer. Refer to Figure 402.
- (3) Connect the piccolo tube (2) to the duct (3), and the hose (1) to the end of the piccolo tube at the leading edge. Refer to Figure 401 and [AMM TASK 30-12-06-400-801-A/400](#).
- (4) Examine the piccolo tube fittings for leaks and do the functional test given in [AMM TASK 30-12-06-400-801-A/400](#).

J. Follow-on

SUBTASK 842-002-A

- (1) Install the horizontal-stabilizer tips (LH and RH) ([AMM TASK 55-13-02-400-801-A/400](#)).
- (2) Install the horizontal-stabilizer leading-edge root fairings (LH and RH) ([AMM TASK 55-13-00-400-801-A/400](#)).
- (3) Install the front fixed fairing ([AMM TASK 55-36-00-400-801-A/400](#)).
- (4) There are different methods to do the aerodynamic sealing between the horizontal-stabilizer leading-edge and the horizontal stabilizer. Use the applicable procedure as necessary.

(a) Full sealant-curing time:

- 1 Apply sealant PR 2050 B-1/2.

NOTE: Sealant curing time will change with the environment conditions.
Refer to SRM 51-20-01.

(b) Acceleration of sealant curing time with heating:

- 1 Apply sealant PR 2050 B-1/2.

- 2 Wait for one hour after the sealant is applied.

CAUTION: THE TEMPERATURE MUST NOT BE HIGHER THAN 55°C (131°F).

- 3 Heat the area which received the sealant.

NOTE: Sealant curing time versus temperature rate varies as shown in the Sealant Specification Table SRM 51-20-01.

(c) Application of aluminum tape after tack-free time.

NOTE: This procedure must only be done when a fast aircraft clearance is necessary.

- 1 Apply sealant PR 2050 B-1/2.



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- 2 You can accelerate the sealant curing time as given in paragraph (b).
 - 3 When sealant is tack-free, apply aluminum tape.
NOTE: You can operate the aircraft immediately after the aluminum tape application.
 - 4 Remove aluminum tape after 150 hours.
- (d) Application of polyethylene film and aluminum tape.
- 1 Apply sealant PR 2050 B-1/2.
 - 2 Apply a polyethylene film on the sealant.
 - 3 Apply the aluminum tape.
NOTE: You can operate the aircraft immediately after the aluminum tape application.
 - 4 Remove the aluminum tape after 10 days.