

SERVICE DOOR - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the service door.
- 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 |
|--------------------|-----------------------------|-------------|
| 52-43-00-000-801-A | SERVICE DOOR - REMOVAL | ALL |
| 52-43-00-400-801-A | SERVICE DOOR - INSTALLATION | ALL |

TASK 52-43-00-000-801-A

EFFECTIVITY: ALL

2. SERVICE DOOR - REMOVAL

A. General

(1) This procedure gives the instructions to remove the service door.

B. References

| REFERENCE | DESIGNATION |
|---|--------------------------------------|
| AMM 52-43-00/101 | - |
| AMM TASK 25-23-05-000-801-A/400 | SERVICE DOOR LINING PANELS - REMOVAL |

C. Zones and Accesses

| ZONE | PANEL/DOOR | LOCATION |
|------|------------|--------------|
| 821 | | Service door |

D. Tools and Equipment

| ITEM | DESCRIPTION | PURPOSE | QTY |
|------------------------|---------------|--------------------------------|-----|
| Commercially available | Workstand | To get access to the work area | |
| Commercially available | Torque wrench | To remove bolts | |

E. Auxiliary Items

| ITEM | DESCRIPTION | PURPOSE | QTY |
|------------------------|-------------------|--------------------------------------|-----|
| Commercially available | Protective Gloves | For protection of technician's hands | 1 |
| Commercially available | Safety Goggles | For protection of technician's eyes | 1 |

F. Consumable Materials

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

G. Expandable Parts

Not Applicable

H. Persons Recommended

| QTY | FUNCTION | PLACE |
|-----|----------------------------|--------------|
| 1 | Does the task | Service door |
| 1 | Helps the other technician | Service door |

I. Preparation

SUBTASK 841-002-A

- (1) Open the service door (AMM 52-43-00/101).
- (2) Remove the lining panel 821BW of the service door, according to [AMM TASK 25-23-05-000-801-A/400](#).
- (3) Remove the lining panel of the passenger cabin along the contour of the service-door frame, at the link point of its arm.

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

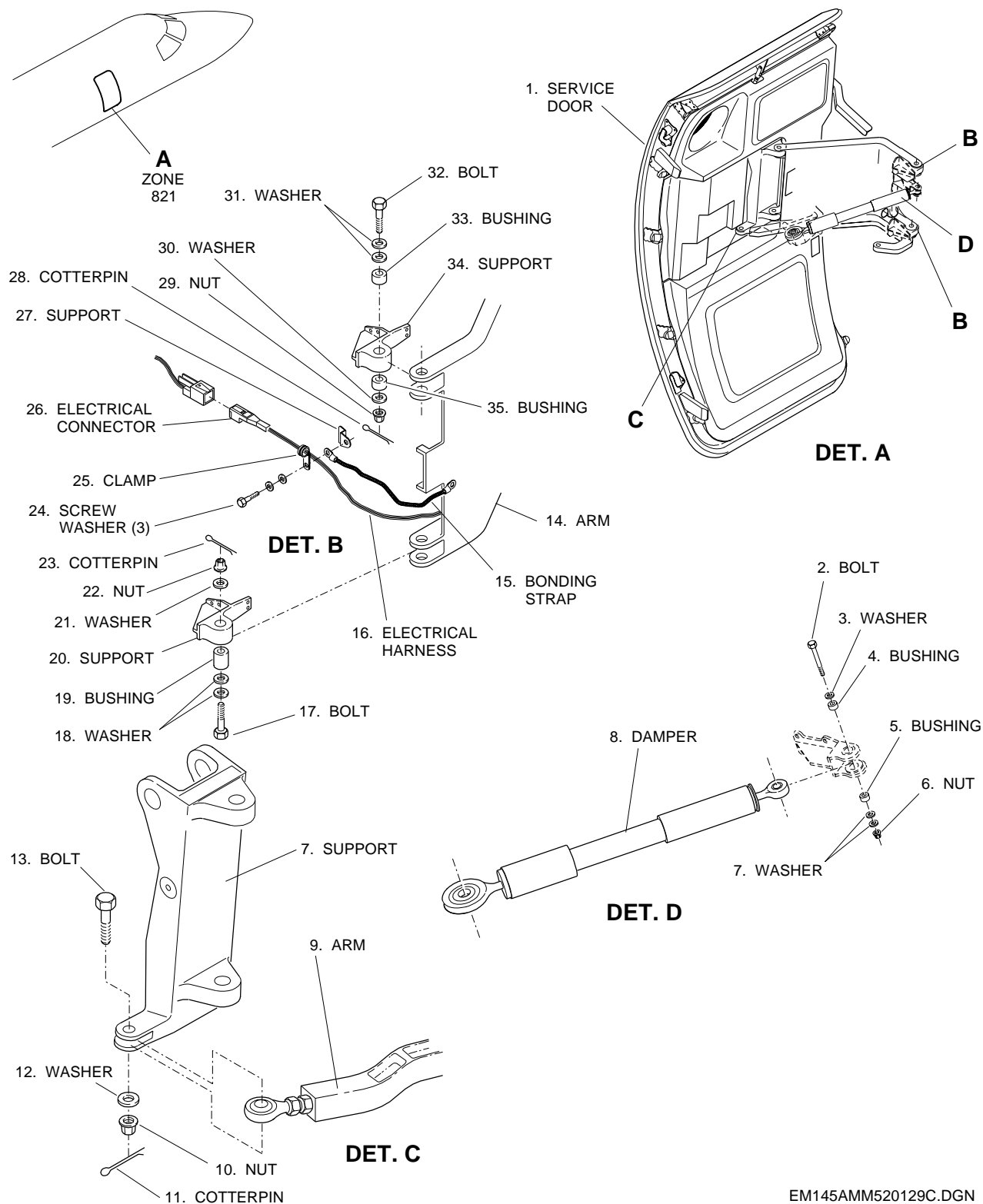
SUBTASK 020-002-A

- (1) Disconnect the end of the damper (8) from the arm (14). For this, remove the nut (6), washers (7), bushing (5) and (4), washer (3), and bolt (2).
- (2) Disconnect the arm (9) from the support (7) at the service door. For this, remove the cotter pin (11), nut (10), washer (12), and bolt (13).
- (3) Disconnect the electrical connector (26).
- (4) Release the electrical harness (16) and the end of the bonding strap (15) from the support (27) at the fuselage structure as follows:
 - (a) Remove the screw and three washers (24) and release the end of the bonding strap (15) and the clamp (25).
- (5) Hold the service door (1).
- (6) Remove the cotter pin (23), nut (22), washer (21), bolt (17), washers (18), and bushing (19) to release the lower link-point of the arm (14) from the support (20) at the fuselage.
- (7) Remove the cotter pin (28), nut (29), washer (30), bushing (35), bolt (32), bushing (33), and washers (31) to release the upper link-point of the arm (14) from the support (34) at the fuselage.
- (8) Remove the service door (1).

EFFECTIVITY: ALL

Service Door - Removal/Installation

Figure 401



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TASK 52-43-00-400-801-A
EFFECTIVITY: ALL

3. SERVICE DOOR - INSTALLATION

A. General

(1) This procedure gives the instructions to install the service door.

B. References

| REFERENCE | DESIGNATION |
|---|---|
| 52-43-00 | - |
| AMM 52-43-00/101 | - |
| AMM TASK 20-13-21-910-801-A/200 | TYPES OF ELECTRICAL BONDING AND SURFACE PREPARATION - STANDARD PROCEDURES |
| AMM TASK 25-23-05-400-801-A/400 | SERVICE DOOR LINING PANELS - INSTALLATION |
| AMM TASK 52-43-06-700-801-A/500 | SERVICE-DOOR ACTUATING AND LOCKING MECHANISM - FUNCTIONAL CHECK |

C. Zones and Accesses

| ZONE | PANEL/DOOR | LOCATION |
|------|------------|--------------|
| 821 | | Service door |

D. Tools and Equipment

| ITEM | DESCRIPTION | PURPOSE | QTY |
|------------------------|---------------|--------------------------------|-----|
| Commercially available | Workstand | To get access to the work area | |
| Commercially available | Torque wrench | To install the bolts | |

E. Auxiliary Items

| ITEM | DESCRIPTION | PURPOSE | QTY |
|------------------------|-------------------|--------------------------------------|-----|
| Commercially available | Protective Gloves | For protection of technician's hands | 1 |
| Commercially available | Safety Goggles | For protection of technician's eyes | 1 |

F. Consumable Materials

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

G. Expendable Parts

| ITEM | IPC REFERENCE (VENDOR REFERENCE) | QTY |
|------------|-------------------------------------|-----|
| Cotter pin | 52-43-00 | 2 |

H. Persons Recommended

| QTY | FUNCTION | PLACE |
|-----|----------------------------|--------------|
| 1 | Does the task | Service door |
| 1 | Helps the other technician | Service door |

I. Installation (Figure 401)

SUBTASK 420-002-A

- (1) Put the service door (1) in its frame at the fuselage.
- (2) Put the arm (14) in the supports (20) and (34) at the fuselage structure.
- (3) Install the bushing (33), bolt (32), washers (31), bushing (35), washer (30), nut (29), and cotter pin (28) to connect the upper link-point of the arm (14) to the support (34).
- (4) Install the bolt (17), washer (18), bushing (19), washer (21), nut (22), and cotter pin (23) to connect the lower link-point of the arm (14) to the support (20).
- (5) Put the clamp (25) on the electrical harness (16).
- (6) Connect the electrical connector (26).
- (7) Connect the end of the bonding strap (15) and attach the clamp (25) to the support (27) at the fuselage as follows:
 - (a) Make sure that the support (27) is correctly prepared for bonding. Refer to [AMM TASK 20-13-21-910-801-A/200](#).
 - (b) Put the end of the bonding strap (15) and the clamp (25) on the support (27).
 - (c) Make sure that the length of the electrical harness (16) is sufficient to permit the free movement of the service door (1).
 - (d) Install the screw and three washers (24) to attach the clamp (25) and the end of the bonding strap (15). Refer to [AMM TASK 20-13-21-910-801-A/200](#).
- (8) Connect the arm (9) to the support (7) at the service door as follows:
 - (a) Put the end of the arm (9) in the support (7).
 - (b) Install the bolt (13), washer (12), nut (10), and cotter pin (11).
- (9) Connect the damper (8) to the arm (14) as follows:
 - (a) Put the end of the damper (8) in the arm (14).
 - (b) Install the bolt (2), bushing (4), washer (3), bushing (5), washers (7), and nut (6).

J. Follow-on

SUBTASK 842-002-A

- (1) Do an operational check of the service door.

NOTE: The operating load for the door handle should not exceed 220 N (50 lbf).

- (2) If necessary, adjust the actuation and locking mechanism of the service door, according to [AMM TASK 52-43-06-700-801-A/500](#).
- (3) Install the lining panel 821BW of the service door, according to [AMM TASK 25-23-05-400-801-A/400](#).
- (4) Install the lining panel of the passenger cabin along the contour of the service-door frame, at the link point of its arm.
- (5) Close the service door (AMM 52-43-00/101).

