



AIRCRAFT
MAINTENANCE MANUAL

SERVICE DOOR FRAME TRIM RUBBER SEAL - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the Service-Door Frame Rubber Seal.
- 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
53-21-11-000-801-A	SERVICE-DOOR FRAME RUBBER SEAL - ALL REMOVAL	
53-21-11-400-801-A	SERVICE-DOOR FRAME RUBBER SEAL - ALL INSTALLATION	



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TASK 53-21-11-000-801-A

EFFECTIVITY: ALL

2. SERVICE-DOOR FRAME RUBBER SEAL - REMOVAL

A. General

- (1) This procedure gives the instructions to remove the Service-Door Frame Rubber Seal.

B. References

REFERENCE	DESIGNATION
AMM TASK 25-23-07-000-801-A/400	-
AMM TASK 52-00-04-300-801-A/800	RUBBER TRIM SEAL - REPAIR

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Acrylic Spatula	To remove the sealant	1
Commercially available	Cutter	To remove the rubber seal	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	In the forward fuselage, on the RH side

I. Preparation

SUBTASK 841-002-A

- (1) Remove the service-door upper, forward, and aft corner trim shrouds (AMM TASK 25-23-07-000-801-A/400).



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

SUBTASK 020-002-A

- (1) Remove the service door frame rubber seal (2).
- (2) **NOTE:** If a damage to the rubber seal occurs and a repair is necessary, do the same procedure as for the Rubber Trim Seal Repair ([AMM TASK 52-00-04-300-801-A/800](#)).

With a acrylic spatula, remove the sealant to lift the rubber seal end.

- (3) Slowly release the rubber seal with a cutter until the rubber seal is fully removed.
- (4) Remove the old sealant with an acrylic spatula.

WARNING: BE CAREFUL WHEN YOU USE SOLVENTS BECAUSE THEY ARE A HEALTH AND FIRE HAZARD. USE SAFETY GOGGLES AND PROTECTIVE CLOTHING WHEN YOU HANDLE THEM. DO NOT BREATHE THEIR GASES AND WORK IN A WELL VENTILATED AREA.

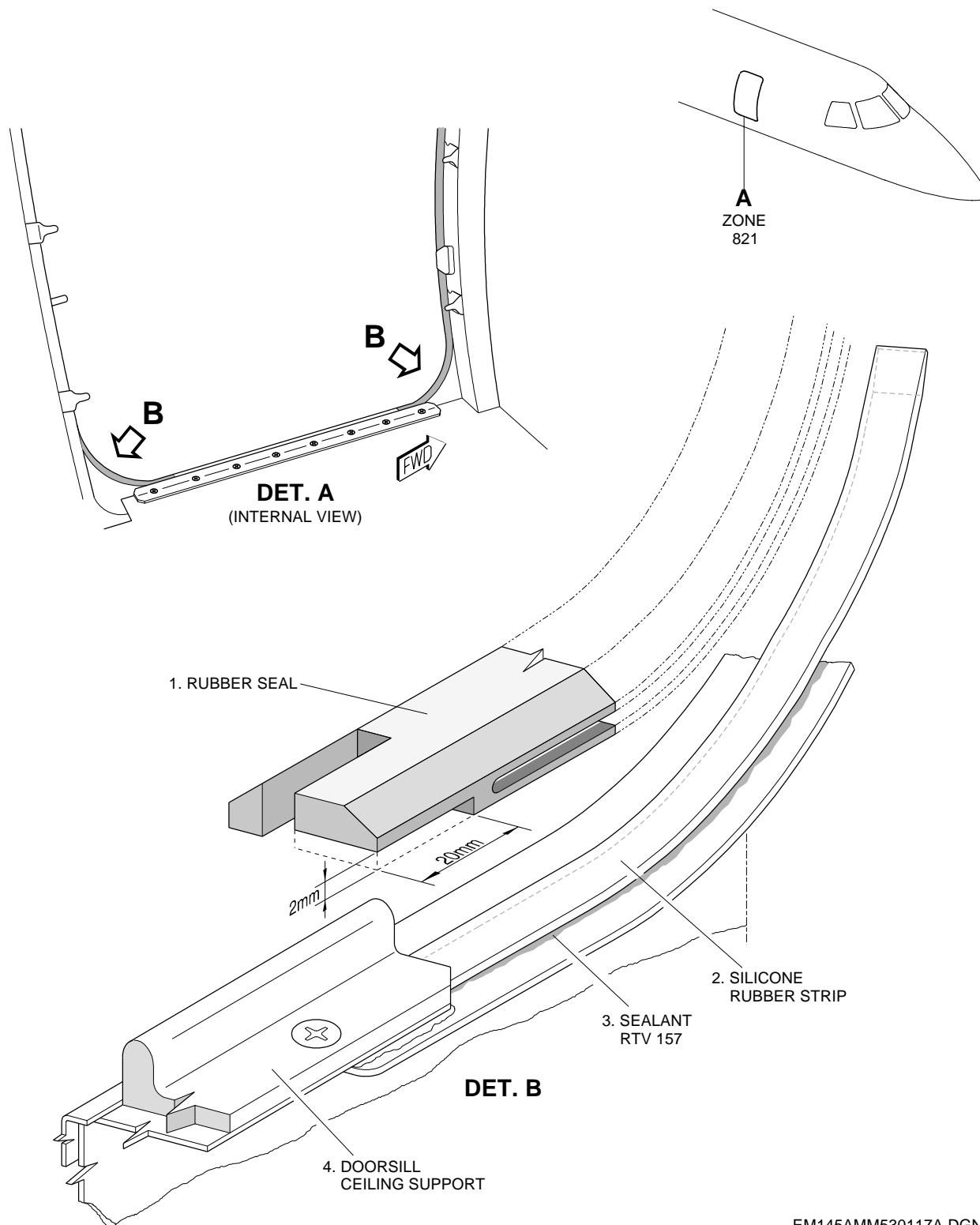
- (5) With a cloth soaked in MEK, clean the surface.

NOTE: Make sure that the surface of the door frame where the rubber seal will be installed is clean and without residues of sealant, rubber, or oil.

EFFECTIVITY: ALL

Service-Door Frame Rubber Seal - Installation

Figure 401 - Sheet 1

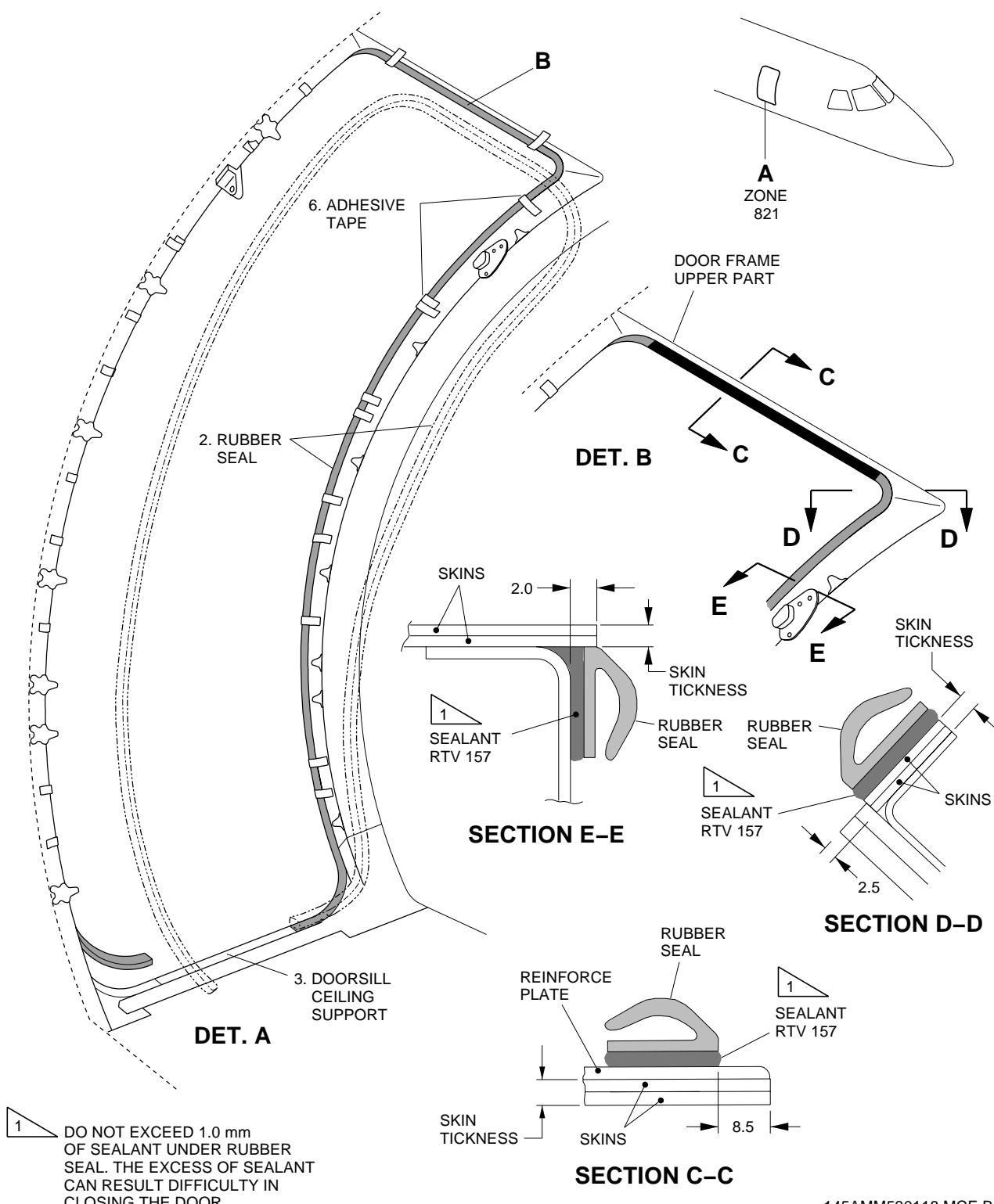


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EFFECTIVITY: ALL

Service-Door Frame Rubber Seal - Installation

Figure 401 - Sheet 2

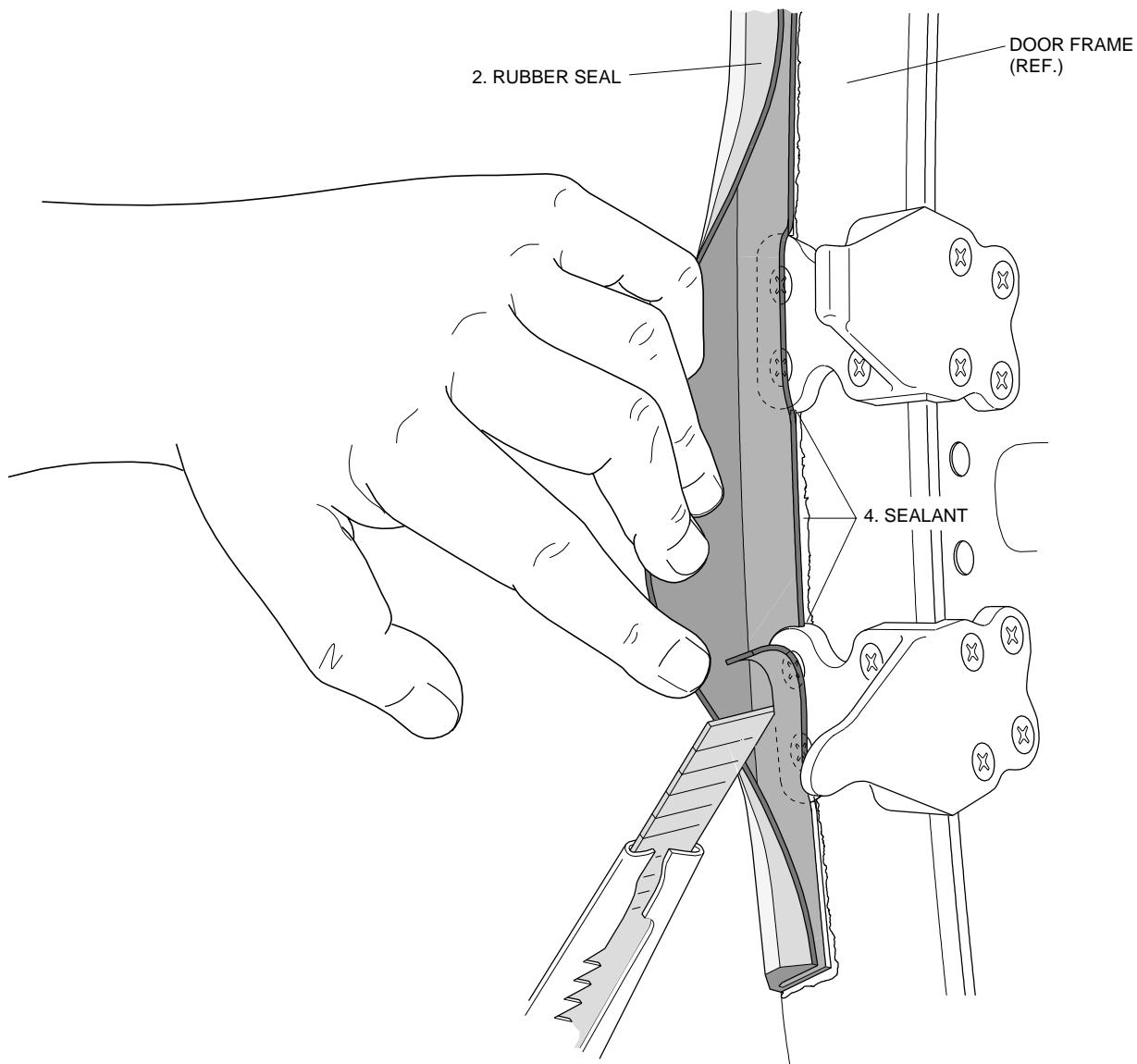


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EFFECTIVITY: ALL

Service-Door Frame Rubber Seal - Installation

Figure 401 - Sheet 3

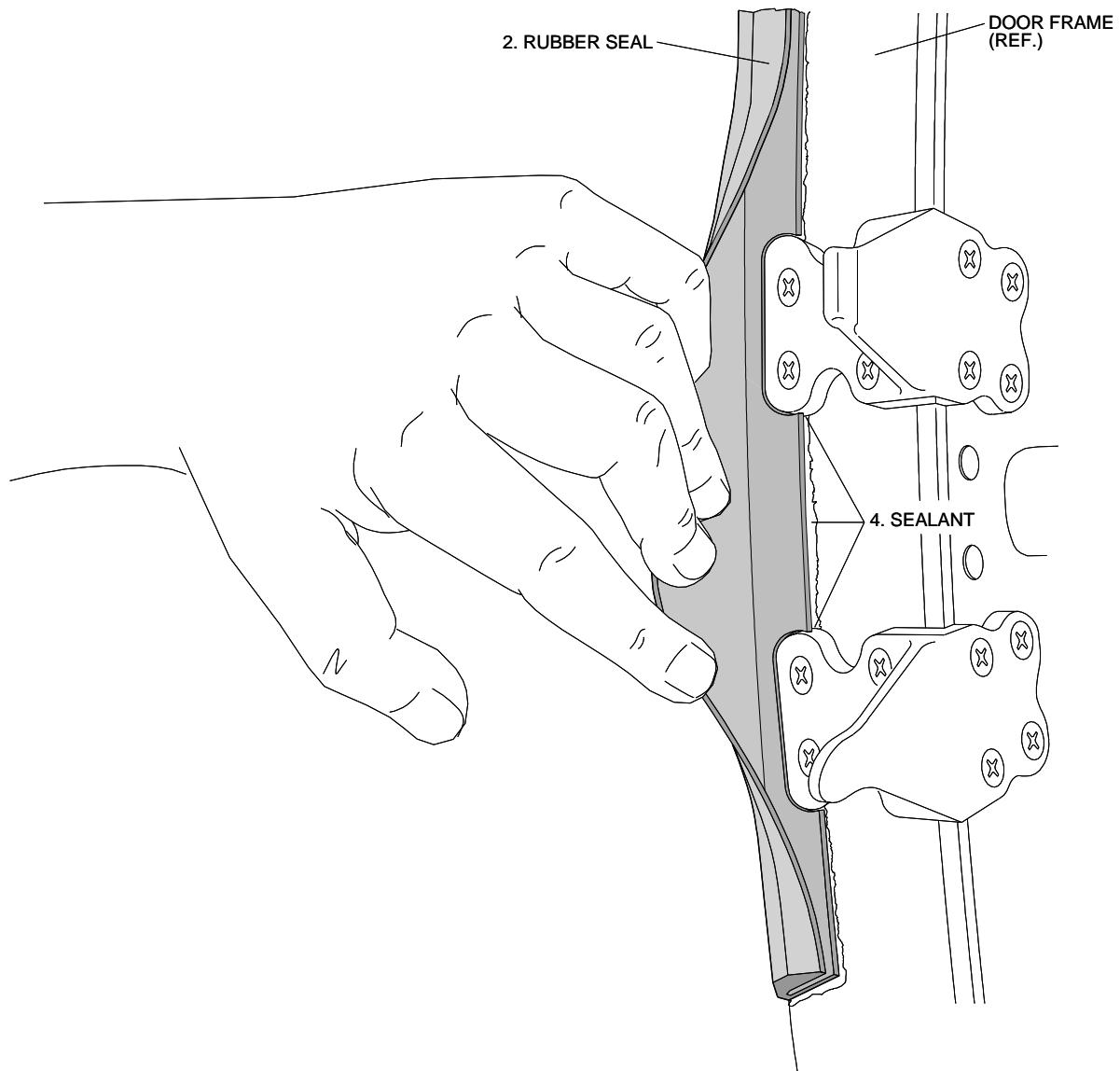


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EFFECTIVITY: ALL

Service-Door Frame Rubber Seal - Installation

Figure 401 - Sheet 4



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TASK 53-21-11-400-801-A
EFFECTIVITY: ALL
3. SERVICE-DOOR FRAME RUBBER SEAL - INSTALLATION
A. General

- (1) This task gives the instructions to install the service-door frame rubber seal.

B. References

<i>REFERENCE</i>	<i>DESIGNATION</i>
AMM TASK 21-31-00-860-801-A/200	PROCEDURE TO PRESSURIZE THE AIRCRAFT FOR MAINTENANCE
AMM TASK 21-31-00-860-802-A/200	PROCEDURE TO DEPRESSURIZE THE AIRCRAFT FOR MAINTENANCE
AMM TASK 25-23-07-400-801-A/400	-
IPC 53-21-00	CENTRAL I
SRM 51-20-01-PR	-

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

<i>ITEM</i>	<i>DESCRIPTION</i>	<i>PURPOSE</i>	<i>QTY</i>
Commercially available	Acrylic Spatula	To remove the sealant	1

F. Consumable Materials

<i>SPECIFICATION (BRAND)</i>	<i>DESCRIPTION</i>	<i>QTY</i>
	Silicone sealant - RTV 157 (Gray)	AR
Commercially available	Adhesive tape	AR
Commercially available	Silicone rubber strip (lined/reinforced with polyester fabric)	AR
Commercially available	Detergent	AR

G. Expendable Parts

<i>ITEM</i>	<i>IPC REFERENCE (VENDOR REFERENCE)</i>	<i>QTY</i>
Silicone rubber strip	IPC 53-21-00	AR

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	In the forward fuselage, on the RH side

I. Installation (Figure 401)
SUBTASK 420-002-A

WARNING: BE CAREFUL WHEN YOU USE SEALANTS. FOR HAZARD, PROTECTION AND HANDLING OF MATERIAL, REFER TO ITS MATERIAL SAFETY DATA SHEET.

- (1) Install the silicone rubber strips (1) in the bottom corners of the service-door frame shape. Bond them with sealant RTV 157 (4). Refer to (Figure 401); Sheet 1; DET. B)

NOTE: Make sure that the strips are correctly bonded to the frame after 1 hour.

- (2) To correctly adjust the doorsill sealing support (3) and the rubber seal (2). Refer to (Figure 401), Sheet 1; DET. B.

- (3) Install the rubber seal (2) from its bottom end in the doorsill sealing support (3). During the adjustment process, apply adhesive tapes (6) to hold the rubber seal in position. Attach the rubber seal (2) along all the service-door frame contour as far as the other bottom end. Refer to (Figure 401); Sheet 2; DET. A).

NOTE: • Make sure that the rubber seal end is correctly adjusted with the doorsill sealing support. If not, detach this end and adjust the rubber seal rearward.
• Install the parts of the rubber seal in their correct position. Refer to (Figure 401); Sheet 2).

WARNING: BE CAREFUL WHEN YOU USE SEALANTS. FOR HAZARD, PROTECTION AND HANDLING OF MATERIAL, REFER TO ITS MATERIAL SAFETY DATA SHEET.

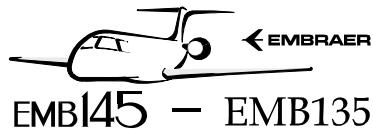
- (4) Bond the rubber seal (2) on the main-door frame structure with sealant RTV 157. Refer to (Figure 401); Sheet 2), for the approximate thickness of the sealant.

- (5) Lift the upper rubber seal (2) flange and use the cutter to cut off the areas of the lower rubber seal flange which interfere with these components: Doorsill sealing support, door stops, rotating arm supports, and frame roller supports. Refer to (Figure 401); Sheet 3).

NOTE: • Be sure to cut only the lower side of the rubber seal section.
• Be careful to cut the lower rubber seal flange to prevent damage to the door frame.

- (6) Fill the gaps and voids between the two sides of the rubber seal and door frame with sealant RTV 157. Refer to (Figure 401); Sheet 4).

- (7) In the upper part of the door frame, bond the flanges of the rubber seal with sealant RTV 157. Refer to (Figure 401); Sheet 2; DET. B).



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- NOTE:
- Wet the finger in a water-detergent solution and mold the sealant around the rubber boundary.
 - When the sealant is cured, the aircraft can be dispatched.
 - The sealant curing time changes with the environmental conditions. Refer to (SRM 51-20-01-PR).

(8) Remove the adhesive tape (6). Refer to (Figure 401); Sheet 2; DET. A).

J. Follow-on

SUBTASK 842-002-A

- (1) Install the service-door upper, forward, and aft corner trim shrouds (AMM TASK 25-23-07-400-801-A/400).
- (2) Pressurize the aircraft ([AMM TASK 21-31-00-860-801-A/200](#)).
- (3) Make sure that there is no air leakage through the service-door contour. If leakage occurs, find its specific location. When the leakage is related to the service-door frame rubber seal, remove and install the rubber seal again in this region to remove the leakage. After this, do the functional test again.
- (4) Depressurize the aircraft ([AMM TASK 21-31-00-860-802-A/200](#)).