TAIL BOOM LENS - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

   A. This section gives the procedures to remove and install the tail-boom light lens.

   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*
55-36-01-000-801-A	TAIL-BOOM LIGHT LENS - REMOVAL	ALL
55-36-01-400-801-A	TAIL-BOOM LIGHT LENS - INSTALLATION	ALL

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TASK 55-36-01-000-801-A
EFFECTIVITY: ALL

2. TAIL-BOOM LIGHT LENS - REMOVAL

A. General

(1) This task gives the instructions to remove the tail-boom light lens.

B. References

REFERENCE	*DESIGNATION*
SRM 51-20-01	-

C. Zones and Accesses

ZONE	*PANEL/DOOR*	*LOCATION*
321	Tail Boom	Horizontal Stabilizer

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

ITEM	*DESCRIPTION*	*PURPOSE*	*QTY*
Commercially available	Workstand	To get access to the work area	1

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	*FUNCTION*	*PLACE*
1	Does the task	On the horizontal stabilizer

I. Preparation

SUBTASK 841-002-A

(1) On the circuit breaker panel, open the PITCH TRIM 1 and 2 circuit breakers and attach a DO-NOT-CLOSE tag to them.

(2) On the left electrical power control/distribution box, open the PITCH TRIM 1 circuit breaker and attach a DO-NOT-CLOSE tag to it.

(3) On the right electrical power control/distribution box, open the PITCH TRIM 2 circuit breaker and attach a DO-NOT-CLOSE tag to it.

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(4) Put a DO-NOT-OPERATE-THE-HORIZONTAL-STABILIZER sign on the pitch trim panel.

(5) Put the workstand in the work area.

J. Removal (Figure 401)

SUBTASK 020-002-A

(1) Remove the screws (1) from the tail-boom light lens (2).

(2) Remove the tail-boom light lens (2).

NOTE: Make sure that the interface sealant is not damaged. If necessary, apply sealant again. Refer to SRM 51-20-01.

(3) Remove all the old aerodynamic sealant, if applicable, and prepare the surface (SRM 51-20-01) between the tail boom fairing and the tail-boom light lens (2).

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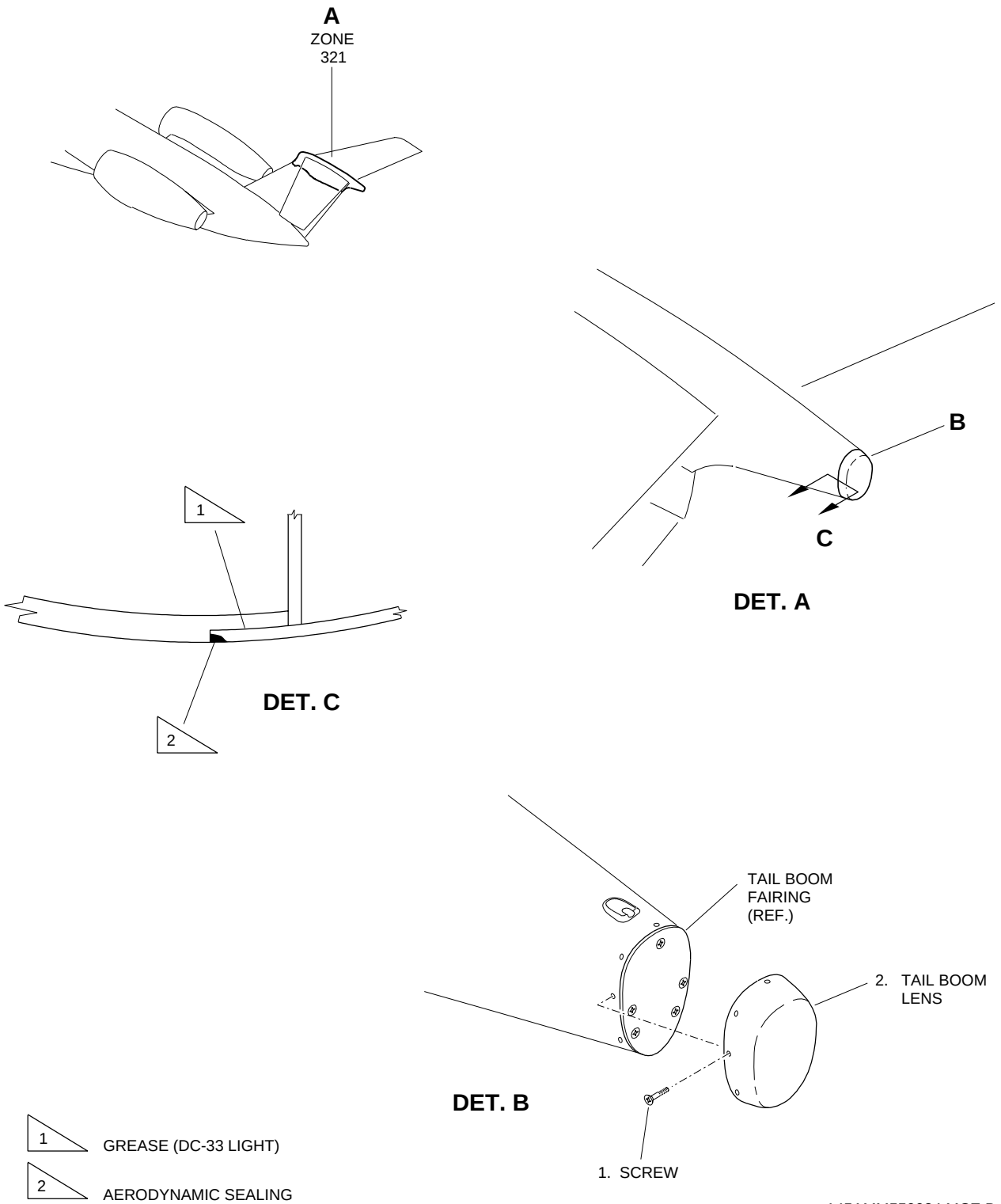
EFFECTIVITY: ALL

Tail-Boom Light Lens - Removal/Installation
Figure 401



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TASK 55-36-01-400-801-A
EFFECTIVITY: ALL

3. TAIL-BOOM LIGHT LENS - INSTALLATION

A. General

(1) This task gives the instructions to install the tail-boom light lens.

B. References

REFERENCE	*DESIGNATION*
SRM 51-20-01	-

C. Zones and Accesses

ZONE	*PANEL/DOOR*	*LOCATION*
321	Tail Boom	Horizontal Stabilizer

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

ITEM	*DESCRIPTION*	*PURPOSE*	*QTY*
Commercially available	Workstand	To get access to the work area	1
Commercially available	Flannel	To clean the tail-boom light lens	1

F. Consumable Materials

SPECIFICATION (BRAND)	*DESCRIPTION*	*QTY*
MEP 09-083	Sealant, PR2050 B1/2	AR
Commercially available	Adhesive Tape	AR
Commercially available	Aluminum Tape (AL Tape 425)	AR
Commercially available	Polyethylene Film	AR
MIL-G-46886	Grease, Molykote, DC-33, light	AR
TT-N-95	Naphtha	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	*FUNCTION*	*PLACE*
1	Does the task	On the horizontal stabilizer

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I. Installation (Figure 401)

SUBTASK 420-002-A

(1) Clean the inside and the outside of the tail-boom light lens (2) with a flannel soaked with naphtha.

(2) Apply Molykote DC-33 light grease to the faying surface of the tail-boom light lens (2).

(3) Install the tail-boom light lens (2).

(4) Install the screws (1).

J. Follow-on

SUBTASK 842-002-A

(1) There are different methods to do the aerodynamic sealing between the tail boom fairing and the tail-boom light lens (2). Use the applicable procedure as necessary.

(a) Full sealant-curing time:

1 Apply sealant PR2050 B1/2.

NOTE: Sealant curing time will vary according to environment conditions. Refer to SRM 51-20-01.

(b) Acceleration of sealant curing time with heating:

1 Apply sealant PR2050 B1/2.

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 faster aircraft clearance is necessary.

1 Apply sealant PR2050 B1/2.

2 You can accelerate the sealant curing time as indicated in paragraph (b).

3 Once 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 PR2050 B1/2.

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2 Apply a polyethylene film over 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.

(2) Remove the workstand from the work area.

(3) Remove the DO-NOT-OPERATE-THE-HORIZONTAL-STABILIZER sign from the pitch trim panel.

(4) On the circuit breaker panel, close the PITCH TRIM 1 and 2 circuit breakers and remove the DO-NOT-CLOSE tag from them.

(5) On the left electrical power control/distribution box, close the PITCH TRIM 1 circuit breaker and remove the DO-NOT-CLOSE tag from it.

(6) On the right electrical power control/distribution box, close the PITCH TRIM 2 circuit breaker and remove the DO-NOT-CLOSE tag from it.

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