



AIRCRAFT MAINTENANCE MANUAL

FLAP ROLLERS - INSPECTION/CHECK

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to do a detailed inspection on the flap rollers for structural integrity.
- 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
27-51-15-200-801-A ♦	FLAP ROLLERS FOR STRUCTURAL INTEGRITY - DETAILED VISUAL INSPECTION	ALL



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TASK 27-51-15-200-801-A

EFFECTIVITY: ALL

2. FLAP ROLLERS FOR STRUCTURAL INTEGRITY - DETAILED VISUAL INSPECTION

A. General

- (1) This task gives the procedure to do a detailed inspection on the flap rollers for structural integrity.
- (2) You must do this inspection over the rollers on the flaps and on the structural wing. There are eight rollers on each wing, [Figure 601](#) shows the flap and wing rollers location.

B. References

REFERENCE	DESIGNATION
AMM TASK 20-13-21-910-801-A/200	TYPES OF ELECTRICAL BONDING AND SURFACE PREPARATION - STANDARD PROCEDURES
AMM TASK 27-50-00-000-801-A/400	INBOARD FLAP - REMOVAL
AMM TASK 27-50-00-000-802-A/400	OUTBOARD FLAP - REMOVAL
AMM TASK 27-50-00-400-801-A/400	INBOARD FLAP - INSTALLATION
AMM TASK 27-50-00-400-802-A/400	OUTBOARD FLAP - INSTALLATION
AMM TASK 27-51-15-000-801-A/400	ROLLERS - REMOVAL
AMM TASK 57-50-01-000-801-A/400	TORQUE BOX FAIRINGS - REMOVAL
AMM TASK 57-50-01-400-801-A/400	TORQUE BOX FAIRINGS - INSTALLATION
SRM 51-20-01/1	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
5711		Left wing
5721		Left wing
6711		Right wing
6721		Right wing

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

Not Applicable

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
ASTM D-740	Methyl-Ethyl-Ketone (MEK)	AR
MIL-S-8802 Type II, Class A	PR1440A2 654 SEMKIT	AR
AMS-S-8802	PR1422 B-2 654 SEMKIT	AR



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G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Wing

I. Preparation ([Figure 601](#))

SUBTASK 841-002-A

- (1) Make sure that the aircraft is safe for maintenance.
- (2) Do not do other tasks on the flap system.
- (3) Remove the inboard flap ([AMM TASK 27-50-00-000-801-A/400](#)) and outboard flap ([AMM TASK 27-50-00-000-802-A/400](#)).
- (4) Remove the torque box I fairing, the torque box II cover and the torque box III fairing ([AMM TASK 57-50-01-000-801-A/400](#)).
- (5) Remove the fairing attachment shape (1) from the torque box I. For this, remove the bolts (3) and washers (2).

J. Inspect (Detailed Inspection) Flap Rollers for Structural Integrity ([Figure 602](#))

SUBTASK 220-002-A

- (1) Remove the thrust washer (retaining ring) to release the spring and the internal pin.
- (2) Clean the surface with a clean cloth wet with solvent MEK (Methyl-Ethyl-Ketone - Spec. ASTM-D-740), or similar.
NOTE: You can find dark marks on the flap roller surface because of solid lubricant superficial deposit.
- (3) Do an inspection on the internal pin and spring for mechanical damage.
NOTE: If you find signs of mechanical damage, replace the roller assy ([AMM TASK 27-51-15-000-801-A/400](#)).
- (4) Install the spring in the internal pin.
- (5) Put the internal pin in the flap roller and install the thrust washer (retaining ring).

K. Follow-on

SUBTASK 842-002-A

- (1) Install the torque box II cover and the torque box III fairing ([AMM TASK 57-50-01-000-801-A/400](#)).
- (2) Install the fairing attachment shape (1) to the torque box I as follows:
 - (a) Do the bonding procedure, method 3 ([AMM TASK 20-13-21-910-801-A/200](#)) to install the fairing attachment shape (1) to the torque box I.



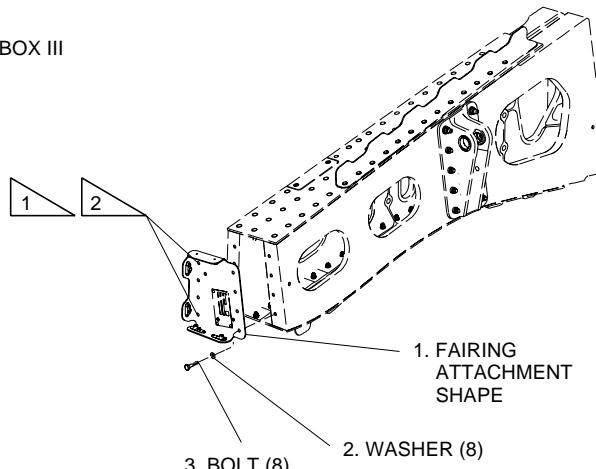
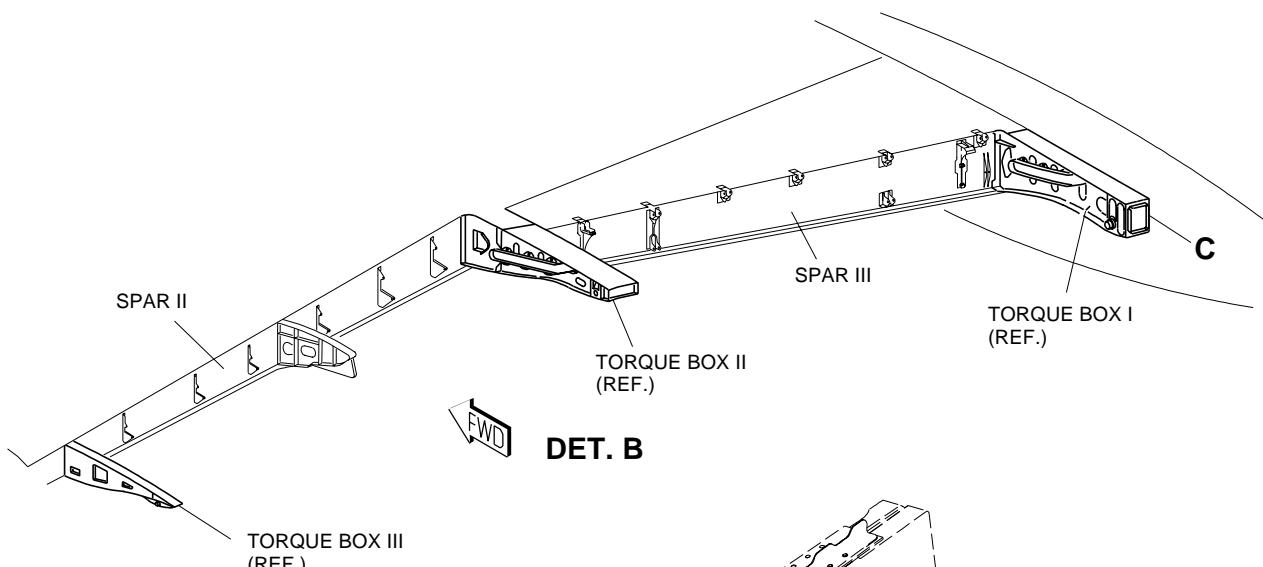
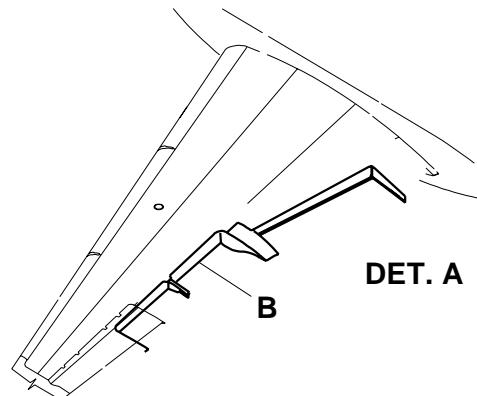
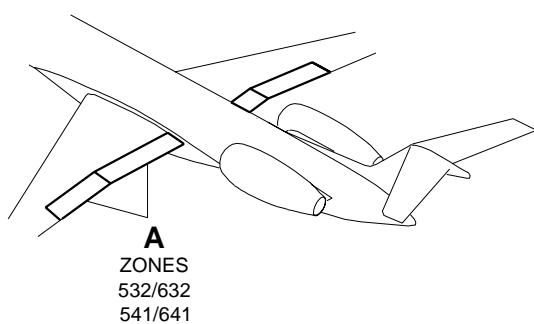
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- (b) Install the fairing attachment shape (1) to the torque box I with bolts (3) and washers (2).
 - (c) Apply sealant PR1440A2 654 SEMKIT to the two indicated bolts (3).
 - (d) Apply a fillet of sealant PR1422 B-2 654 SEMKIT along the contour of the fairing attachment shape (1) (SRM 51-20-01/1).
- (3) Install the torque box I fairing ([AMM TASK 57-50-01-400-801-A/400](#)).
- (4) Install the inboard flap ([AMM TASK 27-50-00-400-801-A/400](#)) and outboard flap ([AMM TASK 27-50-00-400-802-A/400](#)).

EFFECTIVITY: ALL

Flap Rollers Access Panels - Location
Figure 601



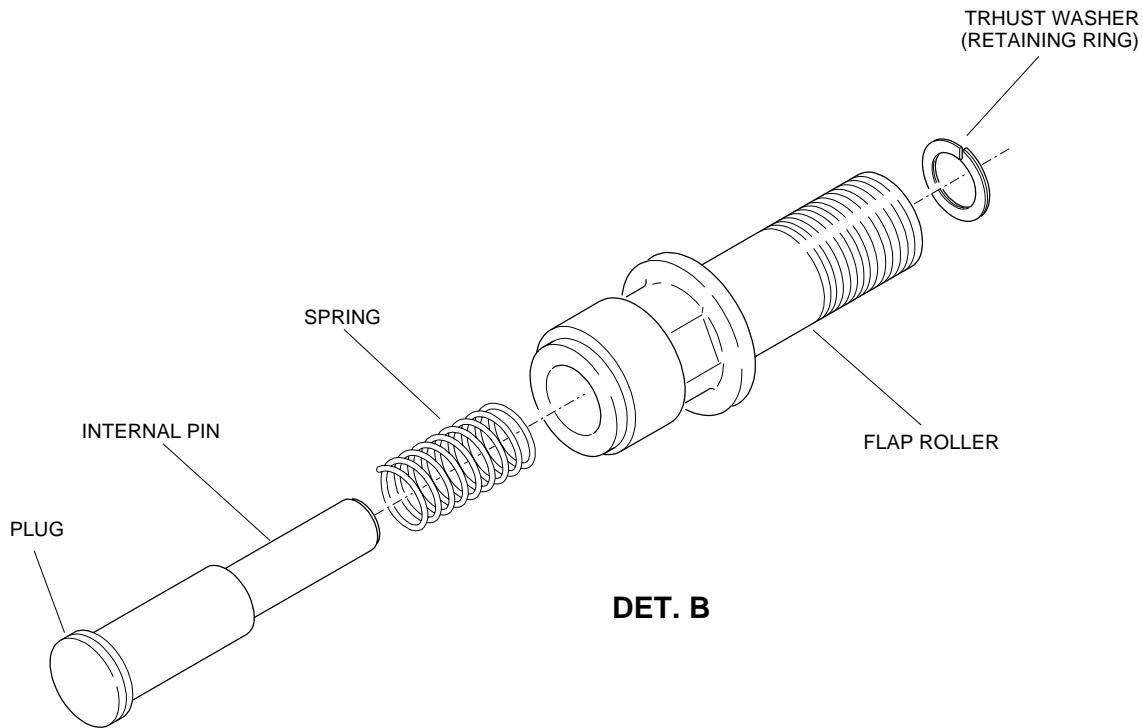
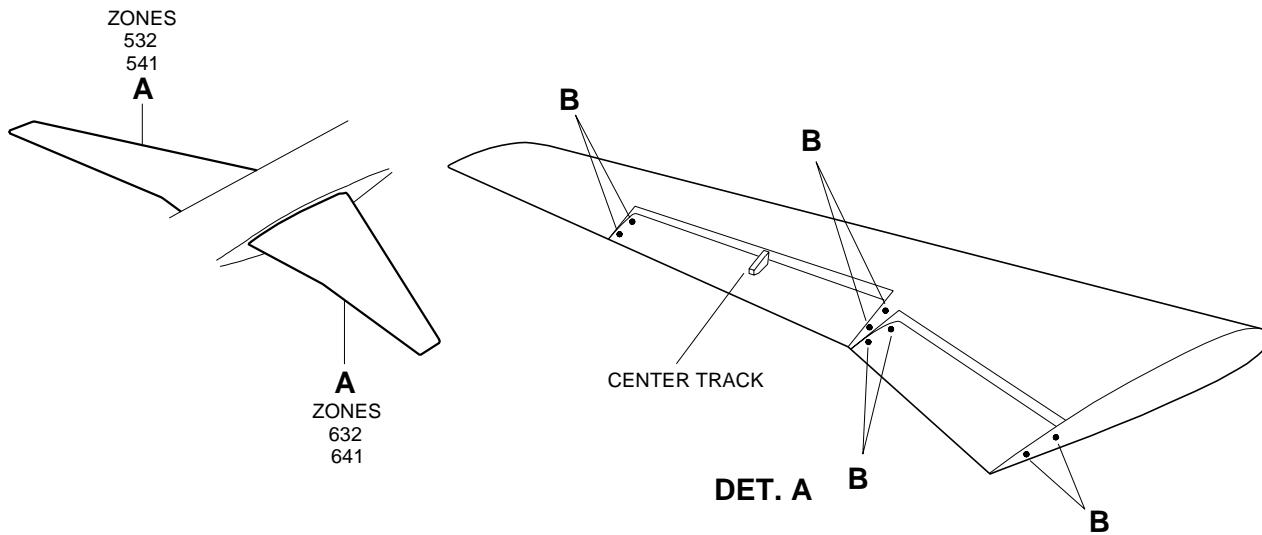
1 ELECTRICAL BONDING, METHOD 3.

2 SEALANT PR1440A2 654 SEMKIT.

DET. C **FWD**

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EFFECTIVITY: ALL
Flap Rollers - Inspection
Figure 602



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