

MAIN DOOR - REMOVAL/INSTALLATION

EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS DOOR

1. General

- A. This section gives the procedures to remove and install the Main 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 |
|--------------------|--------------------------|-------------------------------|
| 52-10-01-000-801-A | MAIN DOOR - REMOVAL | AIRCRAFT WITH AIR-STAIRS DOOR |
| 52-10-01-400-801-A | MAIN DOOR - INSTALLATION | AIRCRAFT WITH AIR-STAIRS DOOR |

TASK 52-10-01-000-801-A

EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS DOOR

2. MAIN DOOR - REMOVAL

A. General

(1) This task gives the procedures to remove the Main Door.

B. References

| REFERENCE | DESIGNATION |
|------------------------------------|-------------|
| AMM MPP 06-41-02/100 | - |
| AMM SDS 52-10-00/1 | |

C. Zones and Accesses

| ZONE | PANEL/DOOR | LOCATION |
|------|------------|---------------------|
| 231 | | Passenger cabin, LH |
| 811 | | Main door |

D. Tools and Equipment

| ITEM | DESCRIPTION | PURPOSE | QTY |
|-------------------------|----------------|----------------------------------|-----|
| GSE 142 | Special Wrench | Removal of the door rotating arm | |
| GSE 143 | Special Wrench | Removal of the door rotating arm | |

E. Auxiliary Items

Not Applicable

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

| QTY | FUNCTION | PLACE |
|-----|---------------|------------------|
| 1 | Does the task | On the main door |

I. Preparation

SUBTASK 841-002-A

- (1) Open the main door ([AMM SDS 52-10-00/1](#)).
- (2) Put the door on the correct stand.
- (3) Remove floor panel 231CF (AMM MPP 06-41-02/100).

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

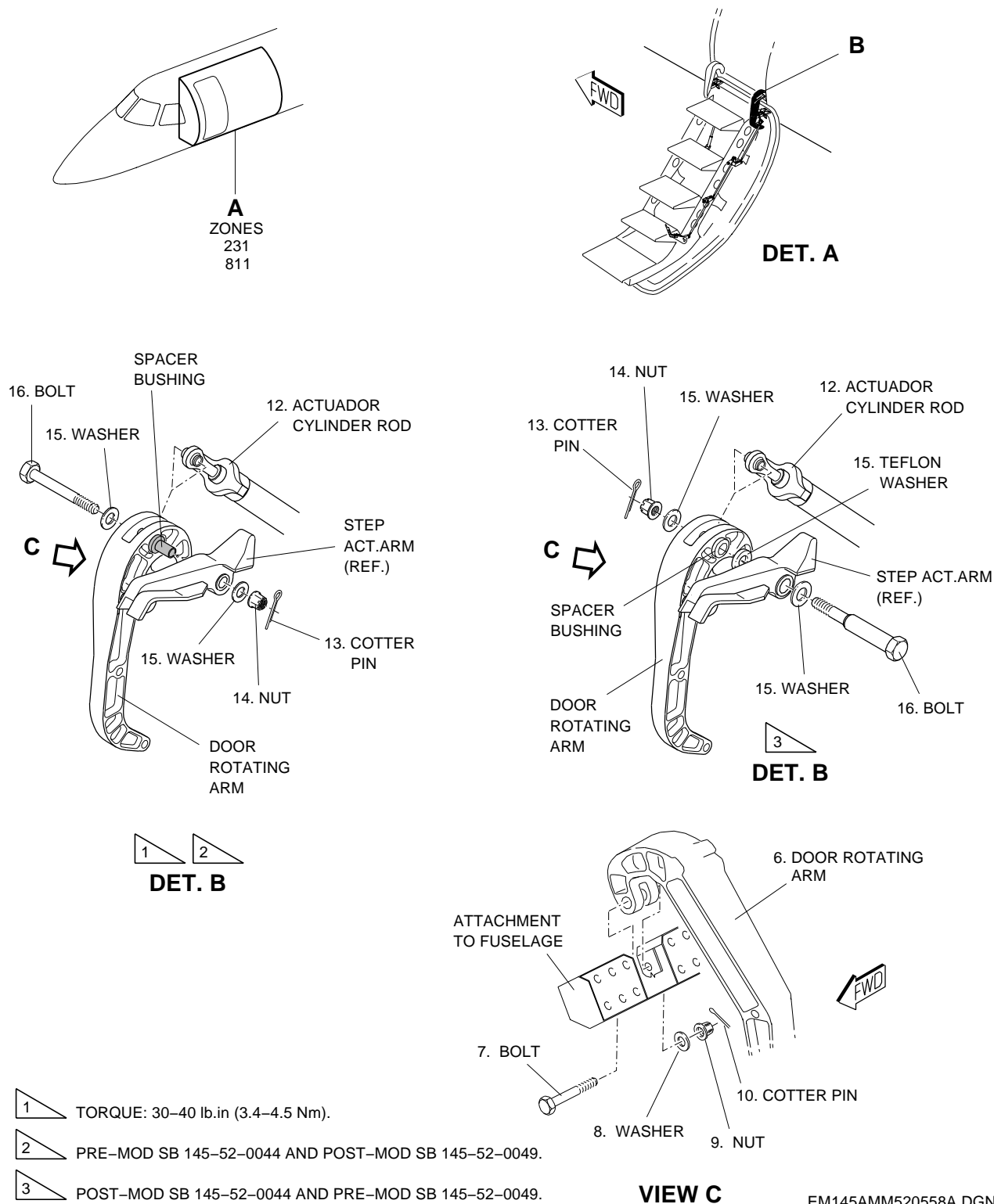
SUBTASK 020-002-A

- (1) Remove the cotter pin (13), nut (14), washers (15), and bolt (16) which attach the rod of each actuating cylinder.
- (2) Remove the cotter pin (2), nut (1), washers (4), and bolt (3) which attach each handrail link arm to the fuselage.
- (3) Remove the handrail link arm (5).
- (4) Release the main door electrical connection (11) at the front actuator. See the wire identifications.
- (5) Remove the bonding jumper (17) installed at the fuselage and rotating arm.
- (6) Remove the cotter pin (10), nut (9), washer (8), and bolt (7) from each door rotating arm at the fuselage. Use special wrenches GSE 142 and GSE 143.

EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS DOOR

Main Door - Removal/Installation

Figure 401 - Sheet 1

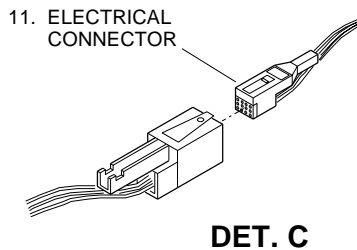
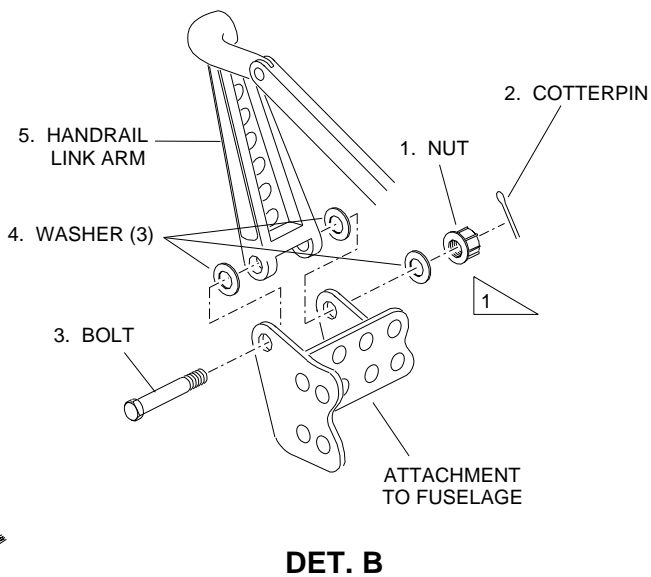
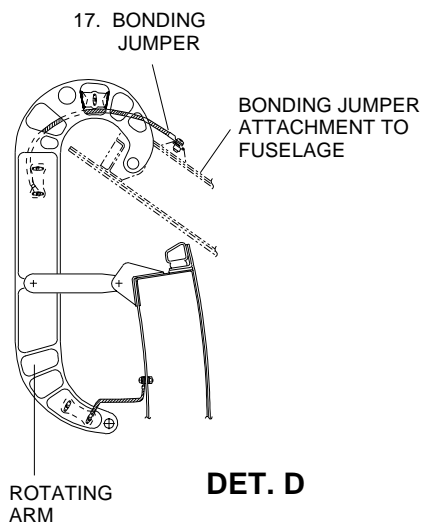
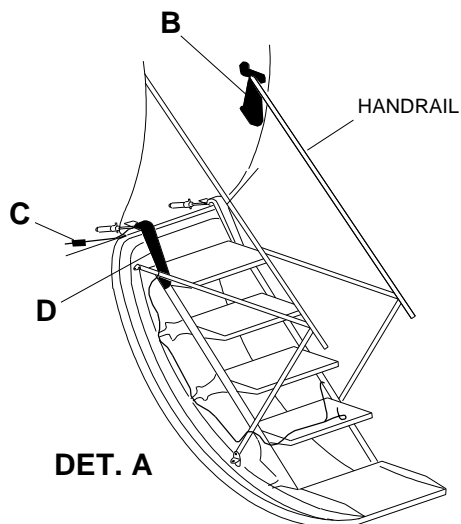
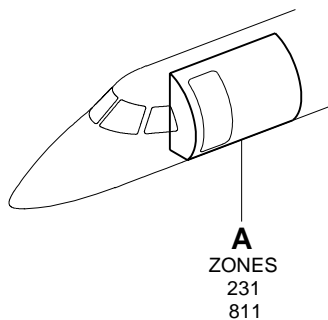


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EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS DOOR

Main Door - Removal/Installation

Figure 401 - Sheet 2



TORQUE: 60–85 lb.in (6.8–9.6 N.m)

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TASK 52-10-01-400-801-A

EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS DOOR

3. MAIN DOOR - INSTALLATION

A. General

(1) This task gives the procedures to install the Main Door.

B. References

| REFERENCE | DESIGNATION |
|---------------------------------|---|
| 52-10-00 | - |
| AMM MPP 06-41-02/100 | - |
| AMM SDS 52-10-00/1 | |
| AMM TASK 52-10-01-820-801-A/500 | MAIN DOOR INTERNAL ACTUATING HANDLE - TEST |
| AMM TASK 52-10-01-820-802-A/500 | MAIN-DOOR STEP ACTUATING MECHANISM - ADJUSTMENT |
| AMM TASK 52-10-01-820-803-A/500 | MAIN-DOOR INTERCONNECTING RODS - ADJUSTMENT |
| AMM TASK 52-10-01-820-804-A/500 | MAIN-DOOR LOCKING-MECHANISM CAMS - TEST |
| AMM TASK 52-10-01-820-805-A/500 | MAIN DOOR CABLES - ADJUSTMENT |
| AMM TASK 52-10-01-820-807-A/500 | MAIN DOOR-TO-FUSELAGE SKIN GAP - ADJUSTMENT |
| AMM TASK 52-10-01-820-808-A/500 | MAIN DOOR-TO-FUSELAGE SKIN STEP - ADJUSTMENT |
| AMM TASK 52-10-01-820-809-A/500 | MAIN DOOR STOPS - ADJUSTMENT |
| AMM TASK 52-10-01-820-810-A/500 | MAIN-DOOR FOLDING FLAP EDGE - ADJUSTMENT |
| AMM TASK 52-10-01-820-811-A/500 | MAIN-DOOR FOLDING FLAP - ADJUSTMENT |
| AMM TASK 52-73-01-700-801-A/500 | AIRSTAIRS MAIN-DOOR WARNING MICROSWITCHES - FUNCTIONAL TEST |
| TASK 52-10-01-700-806-A | - |

C. Zones and Accesses

| ZONE | PANEL/DOOR | LOCATION |
|------|------------|--------------------|
| 231 | | Passenger cabin LH |
| 811 | | Main door |

D. Tools and Equipment

| ITEM | DESCRIPTION | PURPOSE | QTY |
|---------|----------------|---------------------------------------|-----|
| GSE 142 | Special Wrench | Installation of the door rotating arm | |
| GSE 143 | Special Wrench | Installation of the door rotating arm | |

E. Auxiliary Items

Not Applicable

F. Consumable Materials

Not Applicable

G. Expendable Parts

| ITEM | IPC REFERENCE (VENDOR REFERENCE) | QTY |
|------------|-------------------------------------|-----|
| Cotter pin | 52-10-00 | 6 |

H. Persons Recommended

| QTY | FUNCTION | PLACE |
|-----|---------------|------------------|
| 1 | Does the task | On the main door |

I. Installation (Figure 401)

SUBTASK 420-002-A

- (1) With the main door held, put the rotating arms (6) at their hinging points in the fuselage brackets.
- (2) Install the bolt (7), washers (8), nut (9), and a new cotter pin (10) to the door rotating arm at the fuselage. Use special wrenches GSE 142 and GSE 143.
- (3) Make the main door electrical connection (11) at the front actuator. See the wire identifications.
- (4) Install the bonding jumper (17) installed between the fuselage and the rotating arm.
- (5) Put the handrail link arm (5) in position.
- (6) Install the bolt (3), washers (4), nut (1), and a new cotter pin (2) to attach each handrail link arm to the fuselage.
- (7) Put each actuating cylinder rod (12) on the related door rotating arm.
- (8) Install the bolt (16), washers (15), nut (14), and a new cotter pin (13) to attach each actuating cylinder rod (12).

J. Follow-on

SUBTASK 842-002-A

- (1) If the main door is the same:
 - (a) Main door step actuating mechanism - adjustment/test ([AMM TASK 52-10-01-820-802-A/500](#)).
 - (b) Main door-to-fuselage skin gap - adjustment/test ([AMM TASK 52-10-01-820-807-A/500](#)).
 - (c) Main door-to-fuselage skin step - adjustment/test ([AMM TASK 52-10-01-820-808-A/500](#)).
 - (d) Main-door Warning Microswitches - functional test ([AMM TASK 52-73-01-700-801-A/500](#)).

- (2) If the main door is new or different from that removed, adjust as follow:
 - (a) Main door internal actuating handle - test ([AMM TASK 52-10-01-820-801-A/500](#)).
 - (b) Main-door step actuating mechanism - adjustment/test ([AMM TASK 52-10-01-820-802-A/500](#)).
 - (c) Main-door interconnecting rods - adjustment/test ([AMM TASK 52-10-01-820-803-A/500](#)).
 - (d) Main-door locking mechanism cams - adjustment/test ([AMM TASK 52-10-01-820-804-A/500](#)).
 - (e) Main door cables - adjustment/test ([AMM TASK 52-10-01-820-805-A/500](#)).
 - (f) Main door rollers - adjustment/test (TASK 52-10-01-700-806-A).
 - (g) Main door-to-fuselage skin gap - adjustment/test ([AMM TASK 52-10-01-820-807-A/500](#)).
 - (h) Main door-to-fuselage skin step - adjustment/test ([AMM TASK 52-10-01-820-808-A/500](#)).
 - (i) Main door stops - adjustment/test ([AMM TASK 52-10-01-820-809-A/500](#)).
 - (j) Main-door folding flap edge - adjustment/test ([AMM TASK 52-10-01-820-810-A/500](#)).
 - (k) Main-door folding flap - adjustment/test ([AMM TASK 52-10-01-820-811-A/500](#)).
- (3) Install floor panel 231CF (AMM MPP 06-41-02/100).
- (4) Close the main door ([AMM SDS 52-10-00/1](#)) .