



## AIRCRAFT MAINTENANCE MANUAL

### 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



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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	-
<a href="#">AMM SDS 52-10-00/1</a>	

C. Zones and Accesses

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

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
<a href="#">GSE 142</a>	Special Wrench	Removal of the door rotating arm	
<a href="#">GSE 143</a>	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).



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

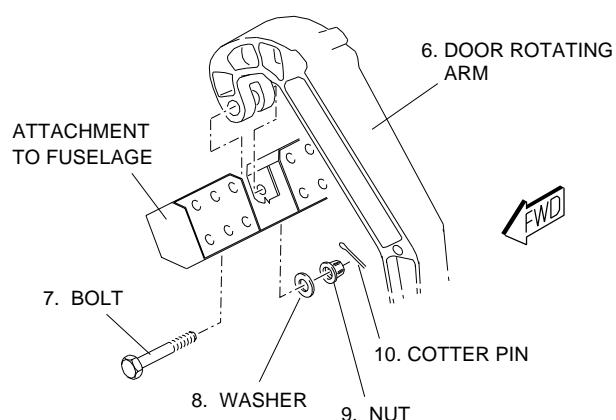
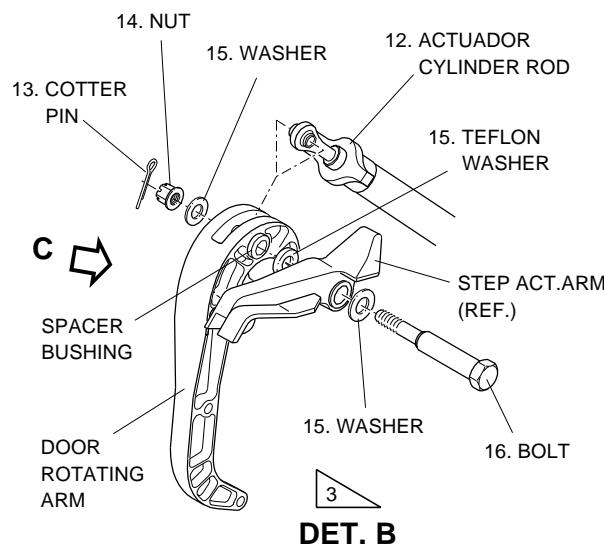
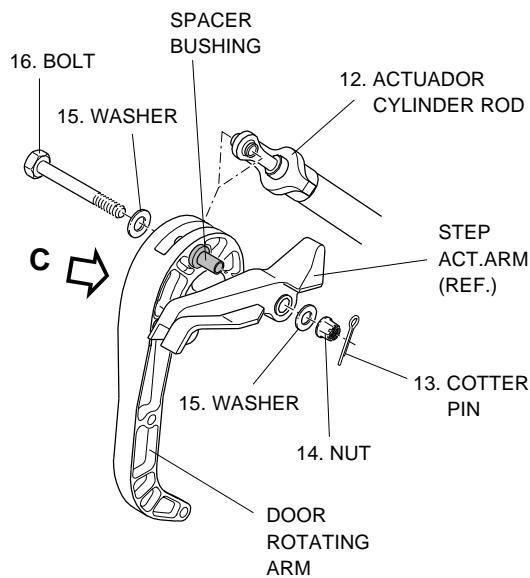
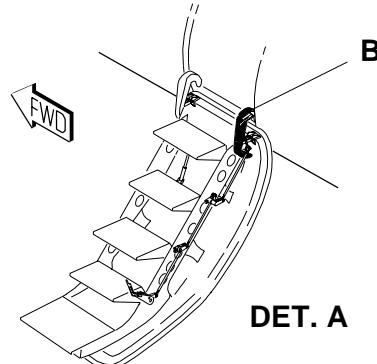
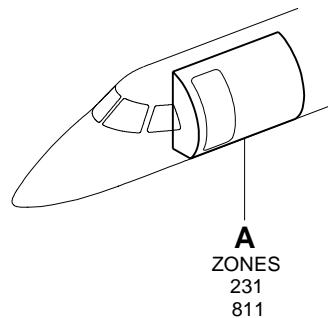
SUBTASK 020-002-A

- (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



 TORQUE: 30–40 lb.in (3.4–4.5 Nm).

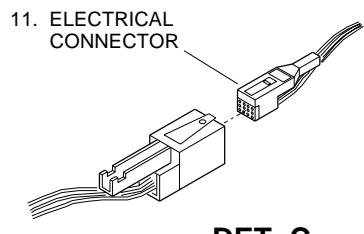
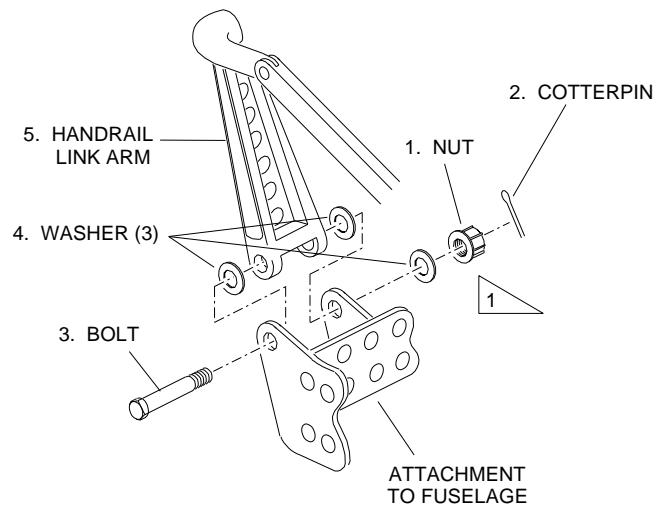
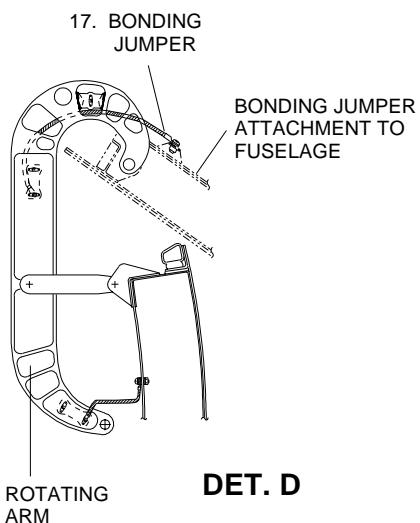
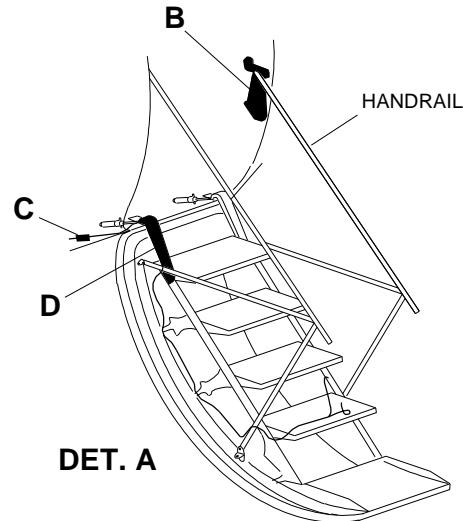
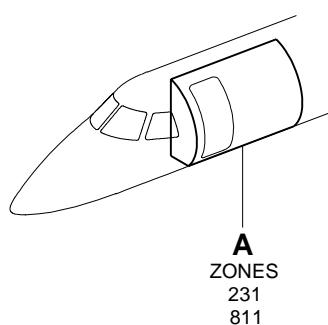
 PRE-MOD SB 145-52-0044 AND POST-MOD SB 145-52-0049.

 POST-MOD SB 145-52-0044 AND PRE-MOD SB 145-52-0049.

**VIEW C**

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**EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS DOOR**  
**Main Door - Removal/Installation**  
**Figure 401 - Sheet 2**



**DET. C**



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

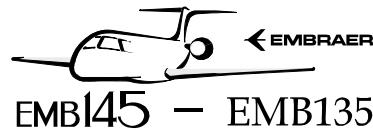
ZONE	PANEL/DOOR	LOCATION
231		Passenger cabin LH
811		Main door

### 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



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## 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](#) ).



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- (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](#)).