



AIRCRAFT MAINTENANCE MANUAL

ELEVATOR TIPS - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the elevator tips.
- 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
55-20-01-000-801-A	ELEVATOR TIPS - REMOVAL	ALL
55-20-01-400-801-A	ELEVATOR TIPS - INSTALLATION	ALL

TASK 55-20-01-000-801-A
EFFECTIVITY: ALL
2. ELEVATOR TIPS - REMOVAL
A. General

- (1) This procedure gives the instructions to remove the elevator tips.

B. References

<i>REFERENCE</i>	<i>DESIGNATION</i>
SRM 51-20-01-PR	-

C. Zones and Accesses

<i>ZONE</i>	<i>PANEL/DOOR</i>	<i>LOCATION</i>
335		Elevator - LH
336		Elevator - RH

D. Tools and Equipment

<i>ITEM</i>	<i>DESCRIPTION</i>	<i>PURPOSE</i>	<i>QTY</i>
Commercially available	Workstand	To get access to the work area	
Commercially available	Torque wrench	To remove the screws	
Commercially available	Acrylic spatula	To remove old sealant	

E. Auxiliary Items

<i>ITEM</i>	<i>DESCRIPTION</i>	<i>PURPOSE</i>	<i>QTY</i>
Commercially available	Protective Gloves	For protection of technician's hands	1
Commercially available	Safety Goggles	For protection of technician's eyes	1

F. Consumable Materials

<i>SPECIFICATION (BRAND)</i>	<i>DESCRIPTION</i>	<i>QTY</i>
ASTM-D-740	Methyl Ethyl Ketone - MEK	AR

G. Expandable Parts

Not Applicable



AIRCRAFT
MAINTENANCE MANUAL

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Elevator tips

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

SUBTASK 020-002-A

- (1) Remove the screws (1) that attach the elevator tip (2) to its frame. Refer to [Figure 401](#); DET. B.
- (2) Remove the elevator tip (2). Refer to [Figure 401](#); DET. B.
- (3) Remove the old aerodynamic sealant and prepare the surface. Refer to SRM 51-20-01-PR.

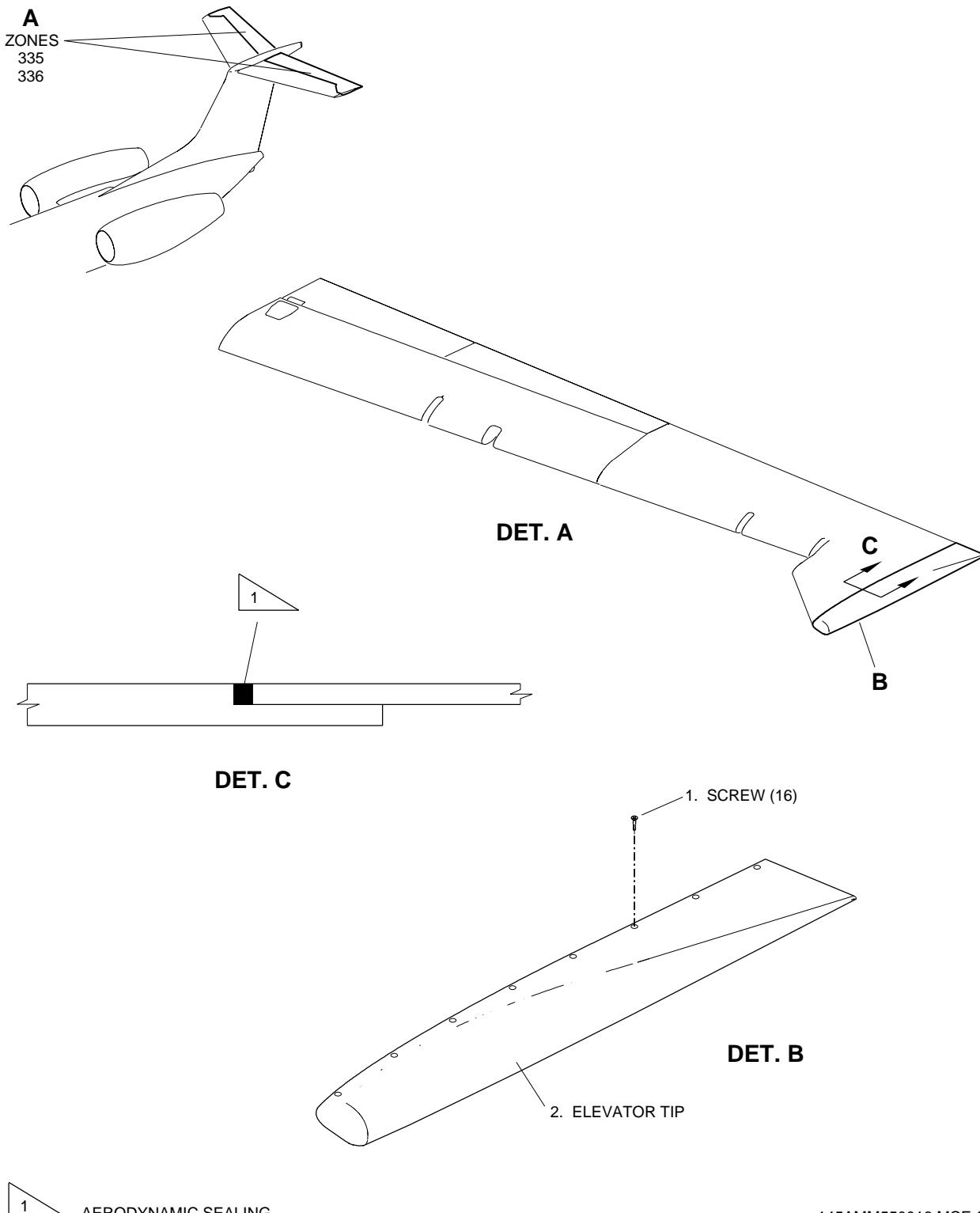
WARNING: BE CAREFUL WHEN YOU USE SOLVENTS BECAUSE THEY ARE A HEALTH AND FIRE HAZARD. USE SAFETY GOGGLES AND PROTECTIVE CLOTHING WHEN YOU HANDLE THEM. DO NOT BREATHE THEIR GASES AND WORK IN A WELL VENTILATED AREA.

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

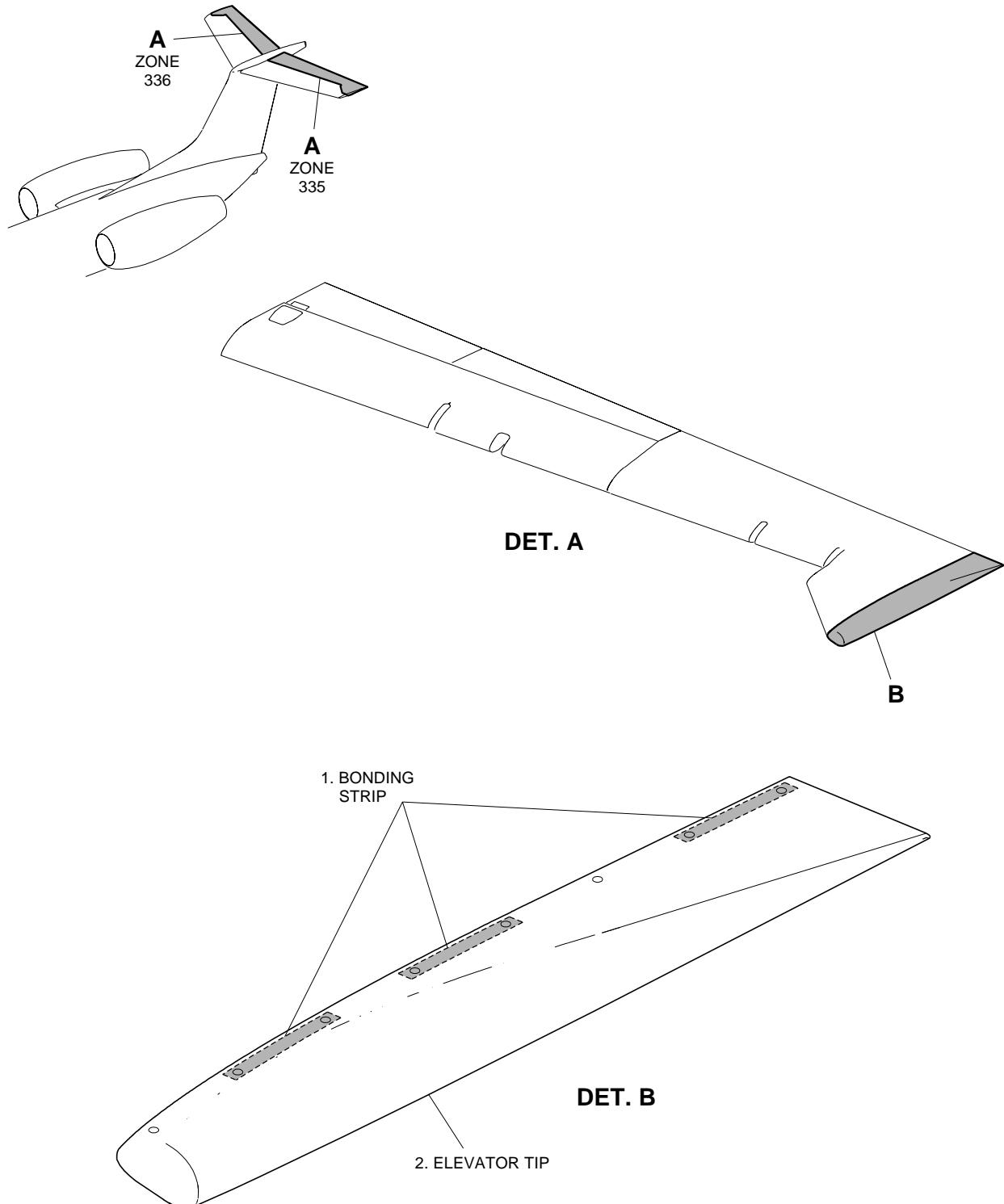
EFFECTIVITY: ALL

Elevator Tips - Removal/Installation

Figure 401



EFFECTIVITY: ALL
 Bonding Strip
 Figure 402



EM145AMM550113B.DGN



EMB145 - EMB135

AIRCRAFT
MAINTENANCE MANUAL

TASK 55-20-01-400-801-A

EFFECTIVITY: ALL

3. ELEVATOR TIPS - INSTALLATION

A. General

- (1) This procedure gives the instructions to install the elevator tips.

B. References

REFERENCE	DESIGNATION
AMM MPP 20-10-01/200	- MAINTENANCE PRACTICES
AMM TASK 20-13-21-700-801-A/200	ELECTRICAL BONDING TEST - STANDARD PROCEDURES
SRM 51-20-01-PR	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
335		Elevator - LH
336		Elevator - RH

D. Tools and Equipment

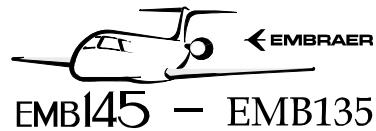
ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	
Commercially available	Torque wrench	To tighten/remove the screws	

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Protective Gloves	For protection of technician's hands	1
Commercially available	Safety Goggles	For protection of technician's eyes	1

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
MEP 09-083	Sealant, PR 2050 B-1/2	AR
Commercially available	Adhesive Tape	AR
Commercially available	Aluminum Tape (AL Tape 425)	AR
Commercially available	Polyethylene Film	AR
ASTM-D-740	Methyl Ethyl Ketone - MEK	AR



AIRCRAFT MAINTENANCE MANUAL

(Continued)

SPECIFICATION (BRAND)	DESCRIPTION	QTY
Commercially available	Scotch Brite Sponge	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Elevator tips

I. Installation (Figure 401)

SUBTASK 420-002-A

- (1) Install the elevator tip (2). Refer to (Figure 401); DET. B.

CAUTION: IT IS NOT NECESSARY TO DO THE STATIC BALANCING OF THE ELEVATORS WHEN AN OLD ELEVATOR TIP FAIRING IS REPLACED BY A NEW ONE.

- (2) Install the screws (1) that attach the elevator tip (2) to its frame. Refer to (Figure 401); DET. B.

NOTE: For the torque, refer to [AMM MPP 20-10-01/200](#).

- (3) There are different methods to do the aerodynamic sealing between the elevator tip (2) and its frame. Use the applicable procedure as necessary.

(a) Full sealant-curing time:

- 1 Apply sealant PR 2050 B-1/2.

NOTE: The sealant curing time will change with the environmental conditions. Refer to SRM 51-20-01-PR.

(b) Acceleration of sealant curing time with heating:

- 1 Apply sealant PR 2050 B-1/2.

- 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: The sealant curing time will change with the environmental conditions. Refer to SRM 51-20-01-PR.

(c) Application of aluminum tape after the tack-free time.

NOTE: This procedure must only be done when a fast aircraft clearance is necessary.

- 1 Apply sealant PR 2050 B-1/2.
 - 2 You can accelerate the sealant curing time as given in paragraph (b).
 - 3 After the sealant is tack-free, apply aluminum tape.
NOTE: You can operate the aircraft immediately after the aluminum tape application.
 - 4 Remove the aluminum tape after 150 hours.
- (d) Application of polyethylene film and aluminum tape.
- 1 Apply sealant PR 2050 B-1/2.
 - 2 Apply a polyethylene film on 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.

J. Follow-on (Figure 402)

SUBTASK 842-002-A

- (1) Do the electrical-bonding test procedure as given in [AMM TASK 20-13-21-700-801-A/200](#). Refer to (Figure 402).