



## AIRCRAFT MAINTENANCE MANUAL

### MAIN-DOOR RUBBER TRIM SEAL - REMOVAL/INSTALLATION

EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS DOOR

#### 1. General

- A. This section gives the procedures to remove and install the rubber trim seal of 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
52-10-04-000-801-A	MAIN-DOOR RUBBER TRIM SEAL - REMOVAL	AIRCRAFT WITH AIR-STAIRS DOOR
52-10-04-400-801-A	MAIN-DOOR RUBBER TRIM SEAL - INSTALLATION	AIRCRAFT WITH AIR-STAIRS DOOR



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TASK 52-10-04-000-801-A

EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS DOOR

2. MAIN-DOOR RUBBER TRIM SEAL - REMOVAL

A. General

- (1) This procedure gives the instructions to remove the rubber trim seal of the main door.

B. References

REFERENCE	DESIGNATION
AMM SDS 52-10-00/1	
AMM TASK 52-00-00-910-801-A/200	MAIN-DOOR - SUPPORTING
AMM TASK 52-00-01-300-801-A/800	FILLER STRIP - REPAIR / REPLACEMENT
AMM TASK 52-00-04-300-801-A/800	RUBBER TRIM SEAL - REPAIR
AMM TASK 52-11-04-400-801-A/400	MAIN-DOOR FOLDING FLAP - INSTALLATION

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

Not Applicable

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
TT-M-261	Methyl Ethyl Ketone (MEK)	AR
TT-I-735	Isopropyl Alcohol	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Airstairs door
1	Helps the other technician	Airstairs door

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

SUBTASK 841-002-A

- (1) Open the main door ([AMM SDS 52-10-00/1](#)).
- (2) The door must be held and the mechanism must be in the closed position. For this, do as in ([AMM TASK 52-00-00-910-801-A/200](#)).



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- (3) Remove bolts (4) (21 positions), washers (2) (21 positions) and nuts (1) (21 positions) to release the folding flap edge (3).

NOTE: If it is necessary to replace the folding flap edge with a new edge, do as in ([AMM TASK 52-11-04-400-801-A/400](#)).

J. Removal ([Figure 402](#))

SUBTASK 020-002-A

**CAUTION:** DO NOT USE SHARP-EDGED TOOLS, TO PREVENT DAMAGE TO THE RUBBER TRIM SEAL OR TO THE METALLIC SURFACES OF THE DOOR FRAME.

- (1) Remove the rubber trim seal (1) as follows:

- (a) Slowly pull the rubber trim seal from the door channel.

NOTE: The rubber trim seal has two link points near the articulation of the folding flap refer to ([Figure 402](#); DET. D):

- To prevent damage to the rubber trim seal, cut these two link points very carefully.
- Observe the sealant position. This will help you on installation procedure.

- (b) Remove the rubber trim seal (1).

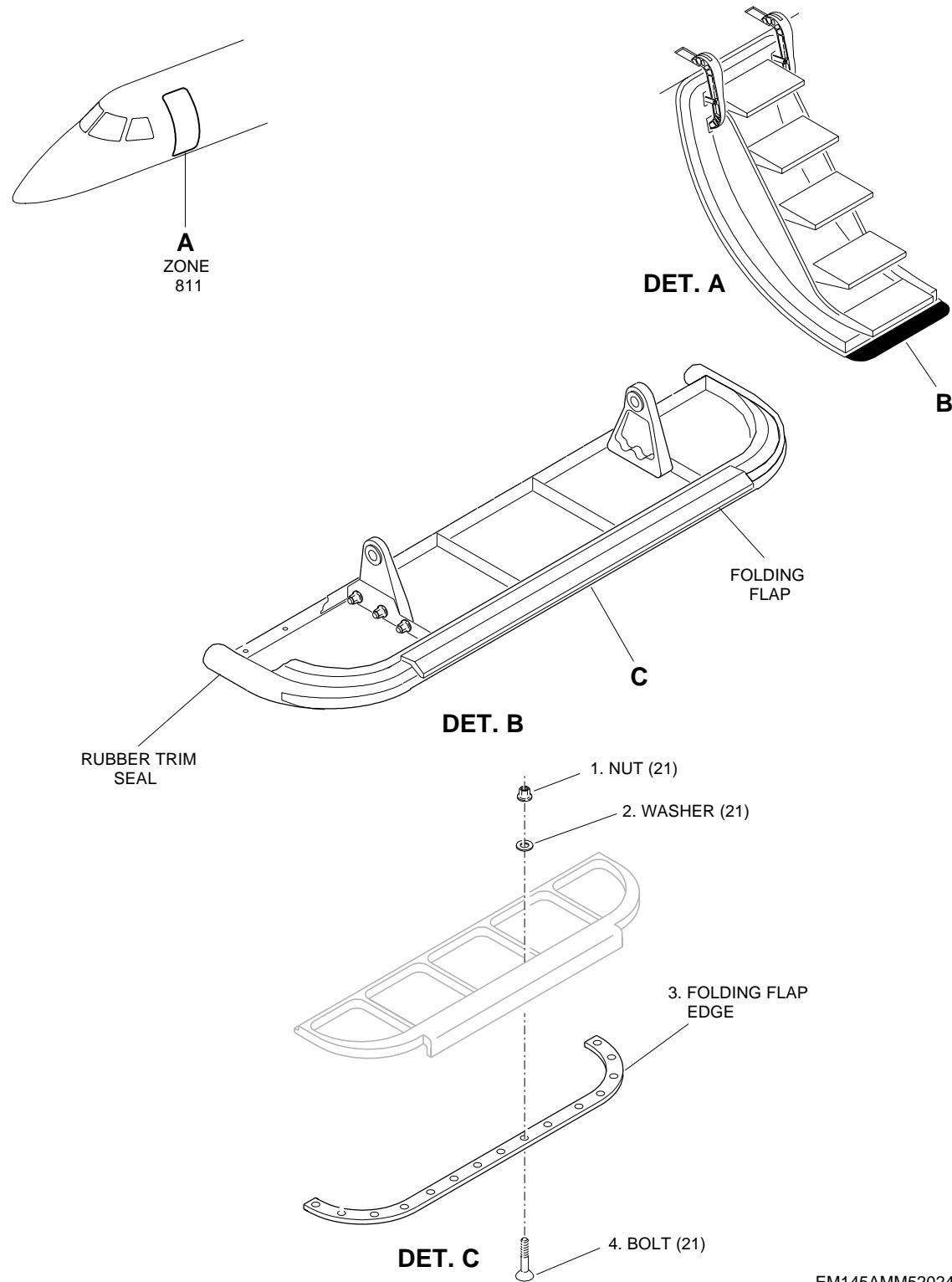
**WARNING:** USE SEALANT OR SOLVENT IN WELL VENTILATED AREAS. PREVENT VAPOR INHALATION AND LONG SKIN CONTACT WITH THESE PRODUCTS.

- (c) Clean the area of the door frame near the link point of the rubber trim seal (2 positions) with Isopropyl Alcohol or Methyl Ethyl Ketone to remove the remaining sealant.
- (d) If necessary, do a repair of the rubber trim seal ([AMM TASK 52-00-04-300-801-A/800](#)).
- (e) If necessary, replace the top or bottom filler strips ([AMM TASK 52-00-01-300-801-A/800](#)).

**EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS DOOR**

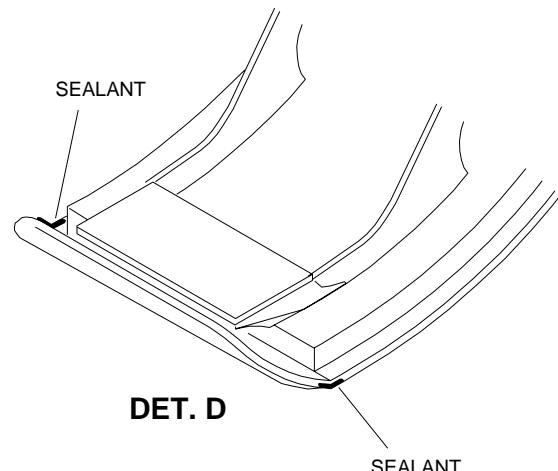
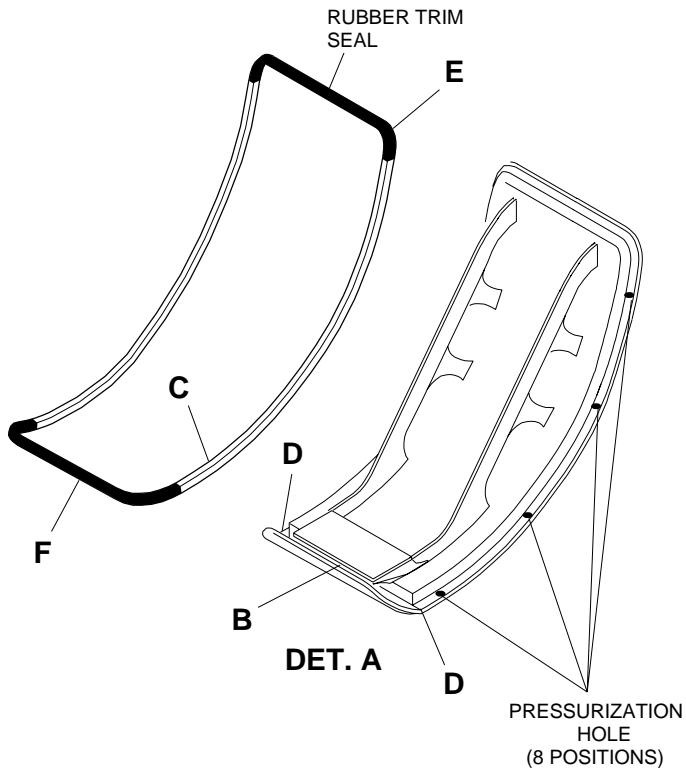
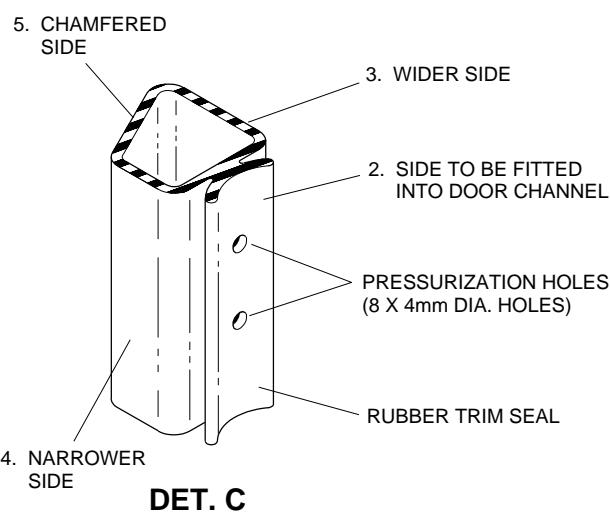
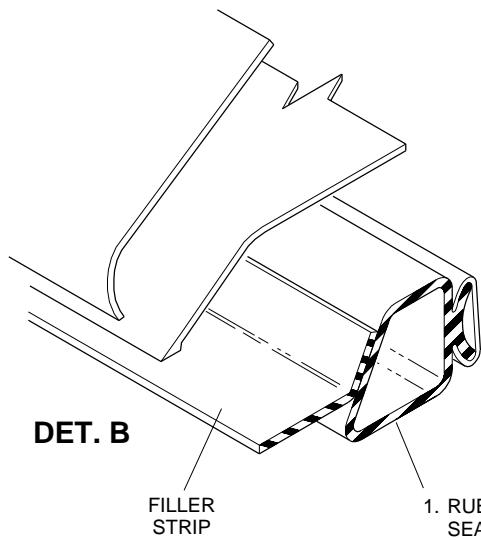
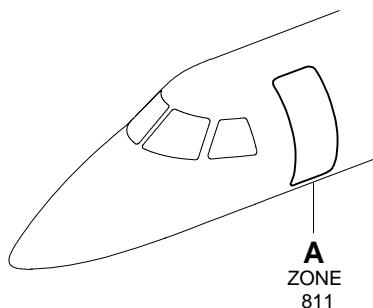
Folding Flap Edge - Removal/Installation

Figure 401



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**EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS DOOR**  
**Rubber Trim Seal - Removal/Installation**  
**Figure 402 - Sheet 1**

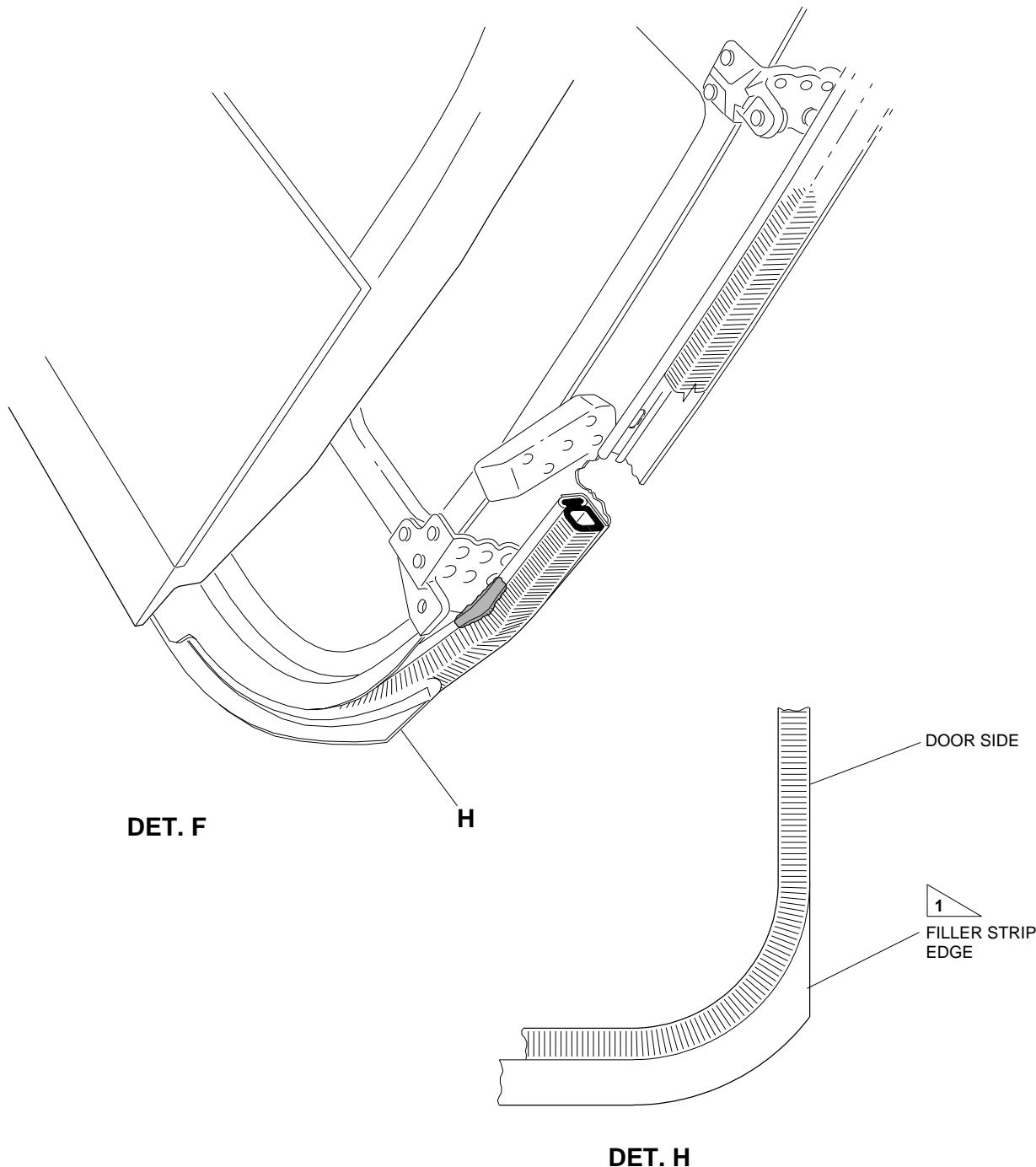


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**EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS DOOR**

Rubber Trim Seal - Removal/Installation

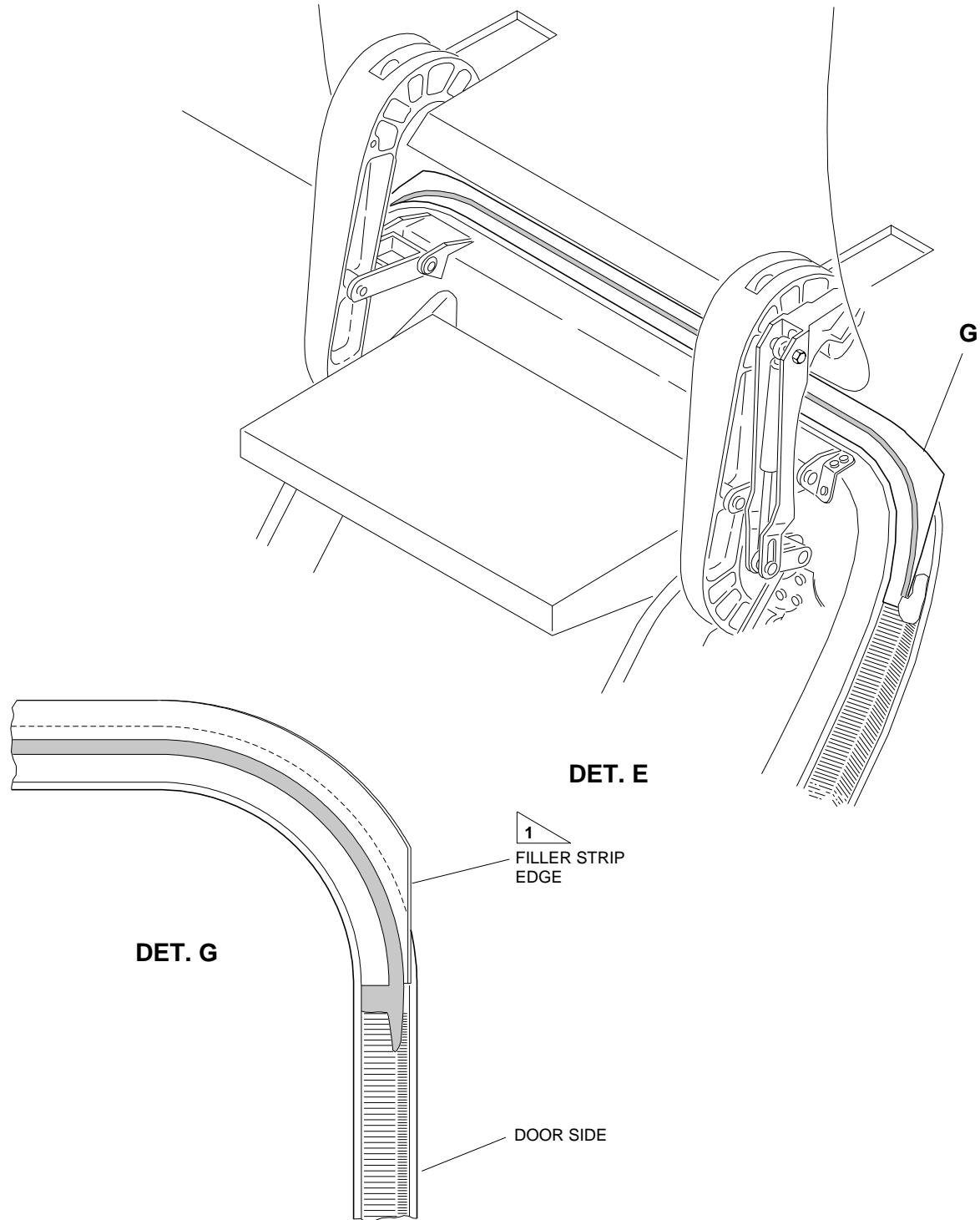
Figure 402 - Sheet 2



 **1** THE FILLER STRIP EDGE MUST BE IN THE SAME PLANE AS THE DOOR SIDE

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**EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS DOOR**  
**Rubber Trim Seal - Removal/Installation**  
**Figure 402 - Sheet 3**



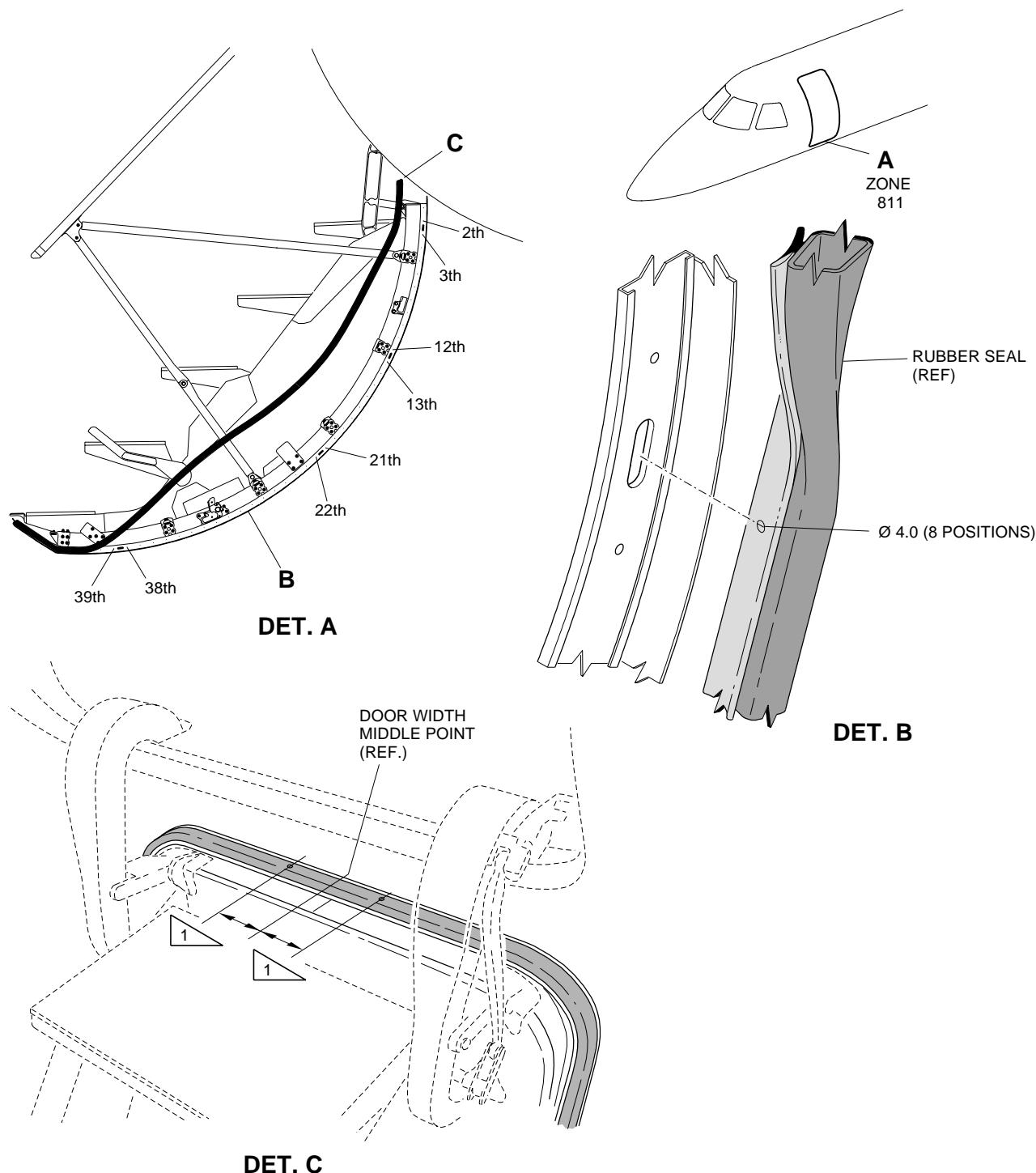
**1** THE FILLER STRIP EDGE MUST BE IN THE SAME PLANE AS THE DOOR SIDE

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**EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS DOOR**

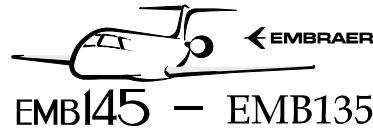
Rubber Trim Seal - Removal/Installation

Figure 403



 THE DISTANCE BETWEEN THE MIDDLE OF THE DOOR WIDTH AND THE HOLE OF EACH SIDE MUST BE THE SAME.

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TASK 52-10-04-400-801-A

EFFECTIVITY: AIRCRAFT WITH AIRSTAIRS DOOR

3. MAIN-DOOR RUBBER TRIM SEAL - INSTALLATION

A. General

(1) This procedure gives the instructions to install the rubber trim seal of the main door.

B. References

REFERENCE	DESIGNATION
AMM SDS 52-10-00/1	
AMM TASK 21-31-00-700-805-A/500	-
AMM TASK 21-31-00-700-808-A/500	-
AMM TASK 52-00-00-910-801-A/200	MAIN-DOOR - SUPPORTING
AMM TASK 52-11-04-400-801-A/400	MAIN-DOOR FOLDING FLAP - INSTALLATION

C. Zones and Accesses

Not Applicable

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Plastic spatula	To install the rubber trim seal to the door channel	

E. Auxiliary Items

Not Applicable

F. Consumable Materials

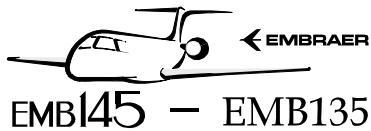
SPECIFICATION (BRAND)	DESCRIPTION	QTY
RTV-157	Sealant	AR
TT-M-261	Methyl Ethyl Ketone (MEK)	AR
TT-I-735	Isopropyl Alcohol	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Airstairs door
1	Helps the other technician	Airstairs door



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I. Installation (Figure 402) (Figure 403)

SUBTASK 420-002-A

NOTE: The rubber trim seal has four different sides refer to (Figure 402); sheet 1, DET. C):

1. The side (2) which is fitted into the door channel has the pressurization holes.
2. The wider side (3) is in contact with the door frame when the rubber trim is installed.
3. The narrower side (4) keeps its face upwards.
4. The chamfered side (5) is opposite to the side (2) fitted into the door channel. The filler strip is bonded to the chamfered side.

(1) Install the rubber trim seal (1) to the door frame as follows:

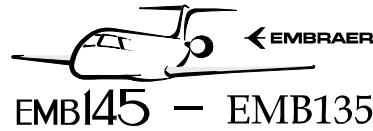
- (a) Put the rubber trim seal on the door frame.

NOTE: The rubber trim seal has a slope that must to be installed on the folding flap area.

- (b) Make sure that the narrower side of the rubber trim seal is turned up and the wider side is in contact with the door frame.
- (c) Make sure that the filler strip edge is in the same plane as the door side (Figure 402); sheet 2, DET. H) and (Figure 402); sheet 3, DET. G).
- (d) Manually install the middle point of the side to be fitted into the channel of the lower, upper, left, and right door sides.
- (e) With a plastic spatula, first install the rubber trim seal into the door channel from the lower and upper sides of the door structure.
- (f) With a plastic spatula install the left and the right sides of the rubber trim seal into the door channel.

NOTE: When the rubber trim seal is installed, make sure that there is no different tensions along the rubber trim seal contour.

- (g) On the left and right door sides, find the eight holes in the door channel and make a mark on the rubber trim seal (Figure 403); DET. A). The marks must agree with the center of the identified holes and stay on the side to be fitted into the door channel (Figure 403); DET. B).
- (h) Remove from the door channel the part of the rubber trim seal in which the marks of the hole positions are.
- (i) Drill eight 4-mm (5/32-in) dia. holes in the rubber trim seal (1) (Figure 403); DET. B).
- (j) Put the part of the rubber trim seal in which the holes are on position back.
- (k) With a pressure applicator fill the link point of the rubber trim seal with sealant (2 positions) (Figure 402); sheet 1, DET. D), near the folding-flap articulation area. Stop the application when the sealant comes into view on the other side of the



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trim seal, like it was before the removal (Figure 402); sheet 2, DET. F) and (Figure 402); sheet 3, DET. E).

NOTE: For a better finish of the sealant, you can soak your fingers in water-and-soap solution and pass them on the sealant that is applied.

J. Follow-on (Figure 401)

SUBTASK 842-002-A

NOTE: The aircraft can be dispatched 6 hours after the sealant application.

- (1) After 06 (six) hours, install the bolt (4) (21 positions), washer (2) (21 positions), and nut (1) (21 positions) to install the folding flap edge (3).

NOTE: If it is necessary to replace the folding flap edge with a new edge, do as in (AMM TASK 52-11-04-400-801-A/400).

- (2) Connect the fold-out rod as in item M (1) of (AMM TASK 52-00-00-910-801-A/200).
- (3) Put the internal handle in its opened position and have the cams controlled to the locked position (intermediate position). You can do this by hands refer to (Figure 202; sheet 2, DET. C) (b) of (AMM TASK 52-00-00-910-801-A/200).

CAUTION: MAKE SURE THAT THE STEPS ARE UNFOLDED, THE INTERNAL HANDLE IS IN THE OPEN POSITION, THE FOLD-OUT ROD IS INSTALLED, AND THE CAMS ARE IN THE LOCKED POSITION.

- (4) Hold the door while you remove the bench and get down the door, slowly.
- (5) Close the main door (AMM SDS 52-10-00/1).
- (6) Do a functional test for cabin leakage (AMM TASK 21-31-00-700-805-A/500) or (AMM TASK 21-31-00-700-808-A/500). If the leakage values are permitted, you can operate the aircraft.

