



AIRCRAFT  
MAINTENANCE MANUAL

**SERVICE-DOOR RUBBER-TRIM SEAL - REMOVAL/INSTALLATION**

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the rubber-trim seal of the service 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
52-43-04-000-801-A	SERVICE-DOOR RUBBER-TRIM SEAL - REMOVAL	ALL
52-43-04-400-801-A	SERVICE-DOOR RUBBER-TRIM SEAL - INSTALLATION	ALL



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TASK 52-43-04-000-801-A

EFFECTIVITY: ALL

2. SERVICE-DOOR RUBBER-TRIM SEAL - REMOVAL

A. General

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

B. References

REFERENCE	DESIGNATION
AMM SDS 52-43-00/1	
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 52-43-03-000-801-A/400	SERVICE DOOR FOLDING FLAP - REMOVAL

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
821		Service door

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the service door	

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
ASTM-D-740	Methyl Ethyl Ketone - MEK	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Service door



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(Continued)

QTY	FUNCTION	PLACE
1	Helps the other technician	Service door

## I. Preparation

### SUBTASK 841-002-A

- (1) Open the service door [AMM SDS 52-43-00/1](#).
- (2) Have the cams controlled to the intermediate position. You can do this by hands and put the internal handle on its closed position.

## J. Removal ([Figure 401](#)) ([Figure 402](#))

### SUBTASK 020-002-A

- (1) Remove the bolt (1) (20 positions), washer (3) (20 positions) and nut (4) (20 positions) to remove the folding flap edging (2). Refer to [Figure 401](#); DET. C.

NOTE: If it is necessary to replace the folding flap edging with a new edging, according to [AMM TASK 52-43-03-000-801-A/400](#).

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

- (2) Remove the rubber-trim seal (1). Refer to [Figure 402](#); DET. B:

- (a) Slowly pull the rubber-trim seal (1) from the door groove.

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

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

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

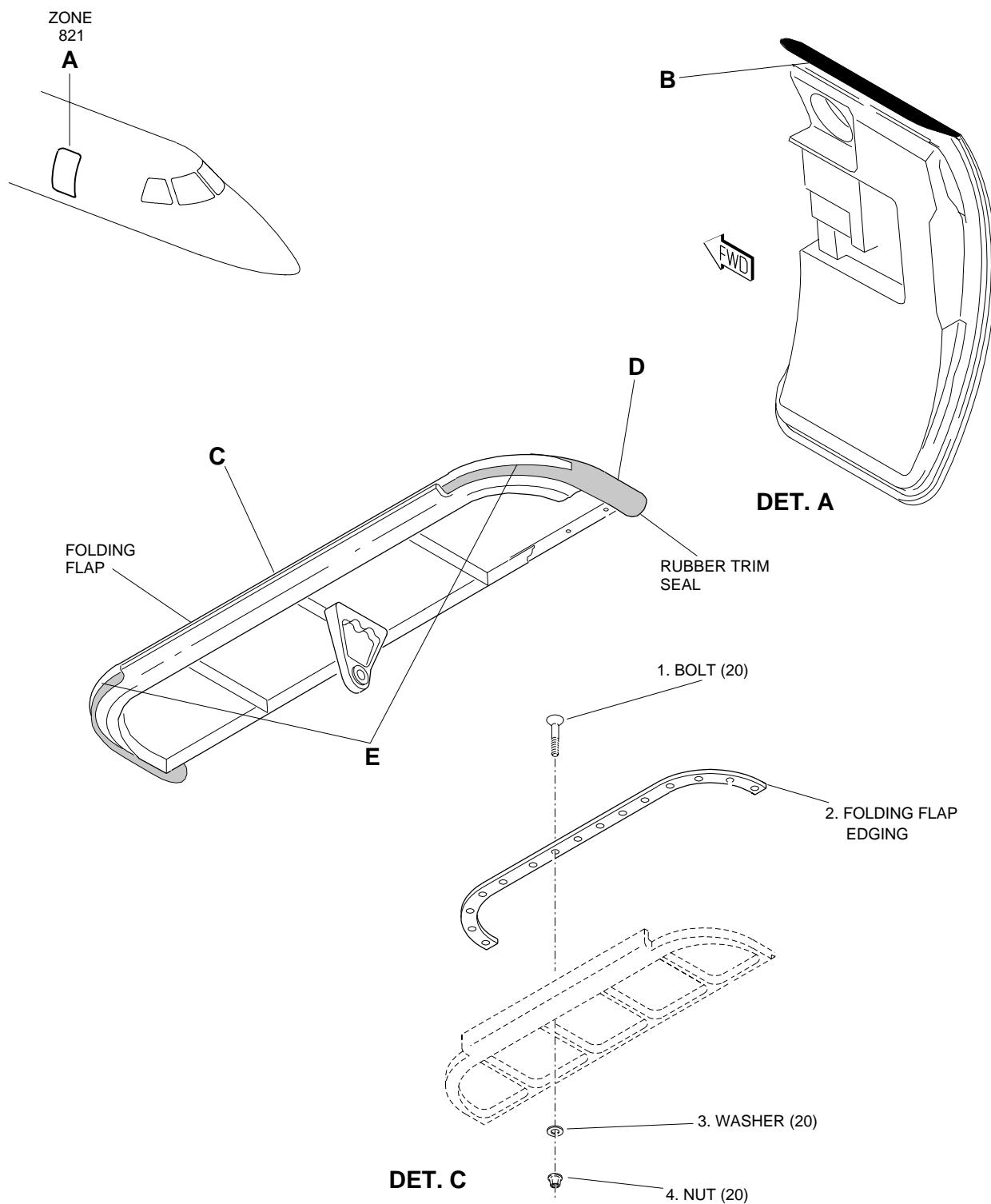
**WARNING: BE CAREFUL WHEN YOU USE SOLVENTS BECAUSE THEY ARE A HEALTH AND FIRE HAZARD. USE SAFETY GOGGLES AND PROTECTIVE CLOTHING WHEN YOU HANDLE THEM. DO NOT BREATHE THEIR GASES AND WORK IN A WELL VENTILATED AREA.**

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

**EFFECTIVITY: ALL**

Folding Flap Edging - Removal/Installation

Figure 401

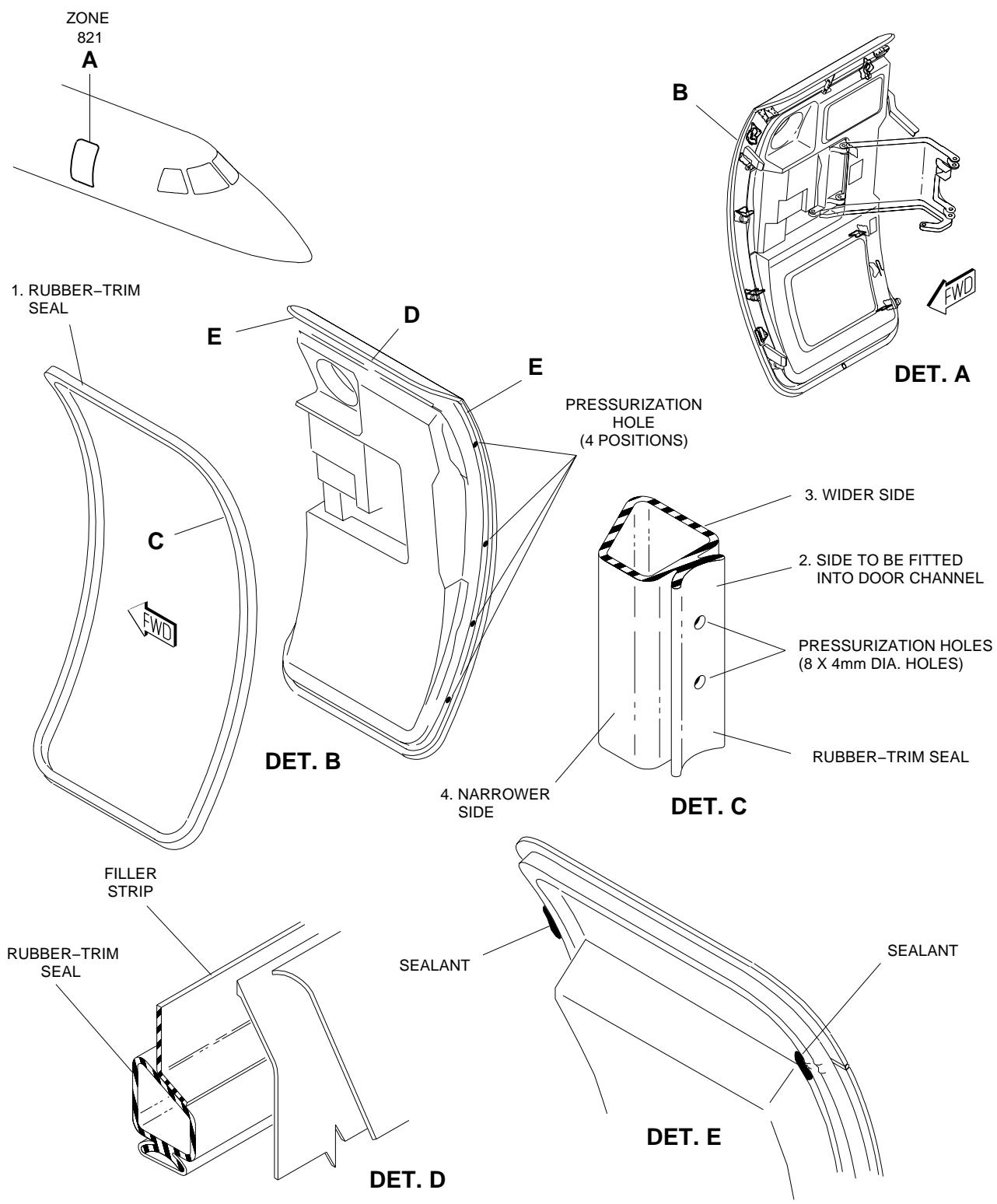


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**EFFECTIVITY: ALL**

Rubber-Trim Seal - Removal/Installation

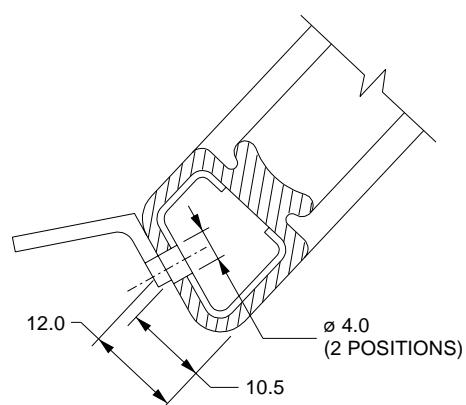
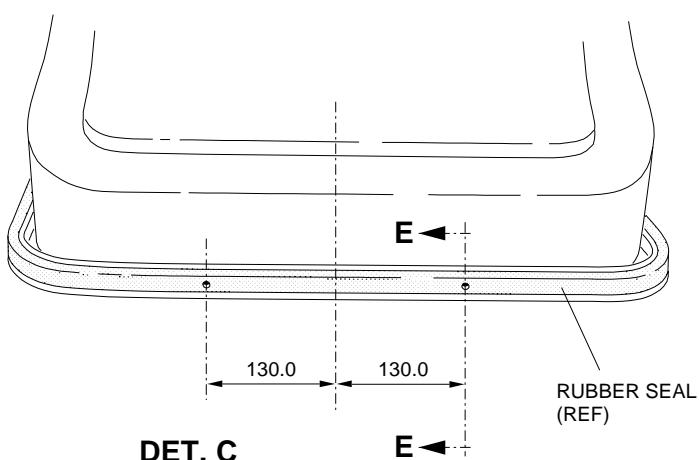
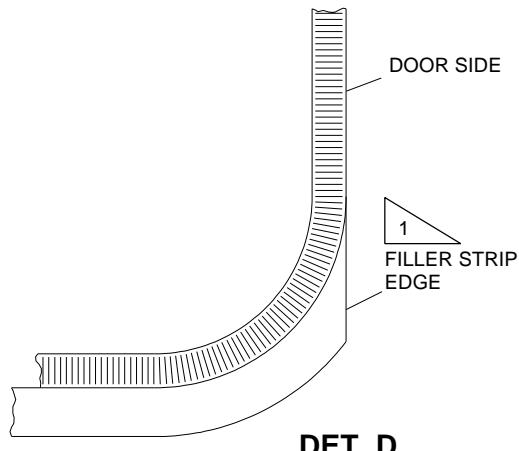
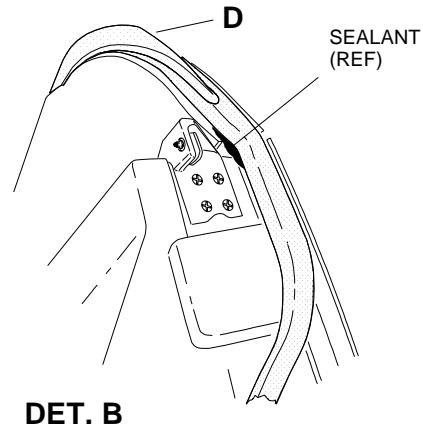
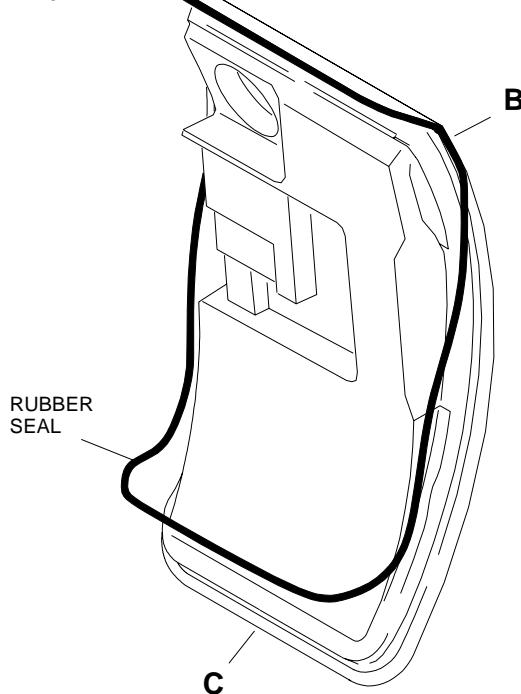
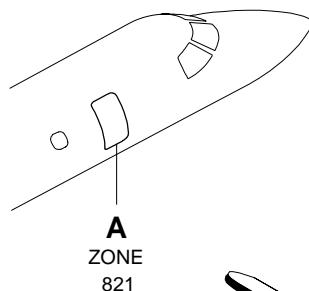
Figure 402



**EFFECTIVITY: ALL**

Rubber-Trim Seal - Removal/Installation

Figure 403



DIMENSION IN mm



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

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TASK 52-43-04-400-801-A

EFFECTIVITY: ALL

3. SERVICE-DOOR RUBBER-TRIM SEAL - INSTALLATION

A. General

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

B. References

REFERENCE	DESIGNATION
AMM SDS 52-43-00/1	
AMM TASK 21-31-00-700-805-A/500	-
AMM TASK 21-31-00-700-808-A/500	-
SRM 51-20-01-PR	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
821		Service door

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the service door	
Commercially available	Acrylic spatula	To install the rubber trim seal to the door channel	

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
ASTM-D-740	Methyl Ethyl Ketone - MEK	AR
MIL-F-38249, TYPE I	Sealant RTV-157	AR
Commercially available	Neutral liquid detergent	AR

G. Expandable Parts

Not Applicable

**H. Persons Recommended**

<i>QTY</i>	<i>FUNCTION</i>	<i>PLACE</i>
1	Does the task	Service door
1	Helps the other technician	Service door

**I. Installation (Figure 401) (Figure 402) (Figure 403)**
**SUBTASK 420-002-A**

**NOTE:** The rubber trim seal has four different sides. Refer to(Figure 402); 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 parallel to the side (2) fitted into the door channel. The filler strip is bonded to the chamfered side.

- (1) Put the rubber-trim seal (1) on the door frame.

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

- (2) Make sure that the chamfered side of the rubber-trim seal (1) is turned up.
- (3) Make sure that the filler strip of the rubber-trim seal (1) is parallel to the folding flap side. Refer to (Figure 403); DET. D.

**WARNING: BE CAREFUL WHEN YOU USE SEALANTS. FOR HAZARD, PROTECTION, AND HANDLING OF MATERIAL, REFER TO ITS MATERIAL SAFETY DATA SHEET.**

- (4) Apply RTV-157 sealant to the rubber trim seal surfaces.

**NOTE:** The sealant curing time changes with the environmental conditions. Refer to (SRM 51-20-01-PR).

- (5) Use an acrylic spatula for the finish of the RTV-157 sealant.

**NOTE:** For a better finish of the sealant, wet the fingers in a water-detergent solution and mold the sealant that is applied.

- (6) Manually install the middle point of the side to be fitted into the channel of the lower, upper, left, and right door sides.
- (7) With a acrylic spatula, first install the rubber trim seal into the door channel from the lower and upper sides of the door structure.
- (8) With a acrylic 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.

- (9) On the left and right door sides, find the eight holes in the door channel and make a mark on the rubber trim seal (1). The marks must agree with the center of the identified holes and stay on the side to be fitted into the door channel.
- (10) Remove from the door channel the part of the rubber trim seal in which the marks of the hole positions are.
- (11) Drill eight 4-mm (5/32-in) dia. holes in the rubber trim seal (1).
- (12) Put the part of the rubber trim seal in which the holes are on position back.
- (13) With a pressure applicator fill the link point of the rubber trim seal with sealant (2 positions), near the folding-flap articulation area. Stop the application when the sealant comes into view on the other side of the trim seal, like it was before the removal. Refer to (Figure 402); 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 apply.

(14) Use an acrylic spatula to remove the sealant excess.

- (15) After the sealant tack-free time, install the bolt (1) (20 positions), washer (3) (20 positions), and nut (4) (20 positions) to install the folding flap edging (2). Refer to (Figure 401).

**NOTE:** • The aircraft can be dispatched 6 hours after the sealant application.  
• If the sealant is tack-free before 6 hours, the aircraft can be operated.  
• The tack-free time changes as a function of environmental conditions.

**J. Follow-on**

**SUBTASK 842-002-A**

- (1) Put the internal handle in its opened position and have the cams controlled to the locked position. You can do this by hands.

**CAUTION:** MAKE SURE THAT THE INTERNAL HANDLE IS IN THE OPEN POSITION AND THE CAMS ARE IN THE LOCKED POSITION.

- (2) Close the service door [AMM SDS 52-43-00/1](#).
- (3) 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.

