VERTICAL-STABILIZER LEADING EDGE - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

A. This section gives the procedures to remove and install the vertical-stabilizer leading edge.

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*
55-35-00-000-801-A	VERTICAL-STABILIZER LEADING EDGE - REMOVAL	ALL
55-35-00-400-801-A	VERTICAL-STABILIZER LEADING EDGE - INSTALLATION	ALL

TASK 55-35-00-000-801-A
EFFECTIVITY: ALL

2. VERTICAL-STABILIZER LEADING EDGE - REMOVAL

A. General

(1) This procedure gives the instructions to remove the vertical-stabilizer leading edge.

B. References

REFERENCE	*DESIGNATION*
SRM 51-20-01-PR	-

C. Zones and Accesses

ZONE	*PANEL/DOOR*	*LOCATION*
323		Vertical-stabilizer leading edge

D. Tools and Equipment

ITEM	*DESCRIPTION*	*PURPOSE*	*QTY*
Commercially available	Workstand	To get access to the work area	
Commercially available	Torque wrench	To remove the screws	
Commercially available	Acrylic spatula	To remove sealant	

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	Vertical-stabilizer leading edge

I. Removal (Figure 401) (Figure 402)

SUBTASK 020-002-A

(1) Remove the screws (1) that attach the vertical-stabilizer leading edge (2) to the vertical stabilizer.

(2) Remove the vertical-stabilizer leading edge (2).

(3) Remove the old aerodynamic sealant and prepare the surface, according 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.

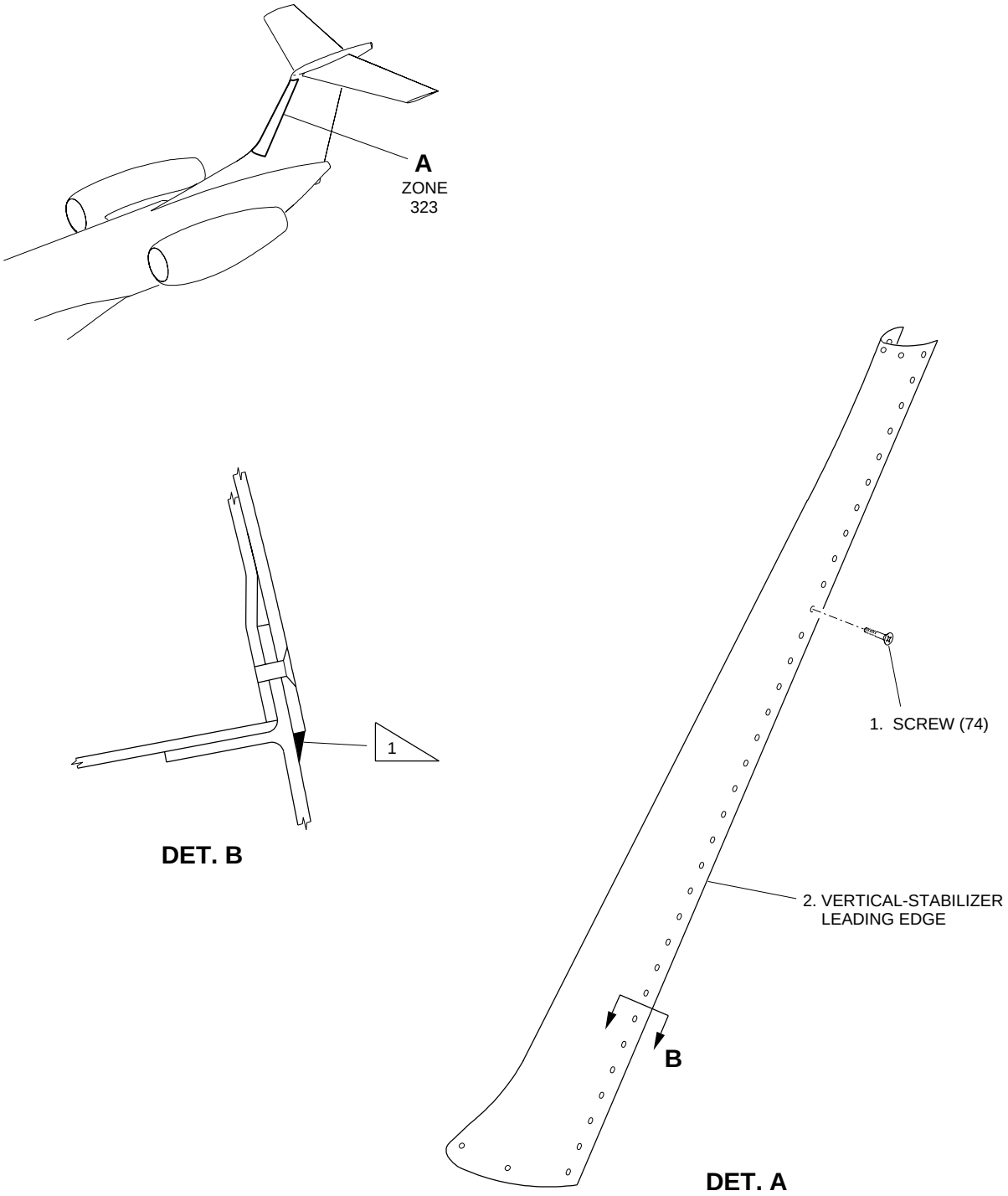
(4) With a cloth soaked in MEK, clean the surface.

(5) Examine the bonding metallic plate for general condition. Replace it if necessary. Refer to Figure 402.

NOTE: If it is necessary to replace the bonding metallic plate, use a wooden tool as a wedge for the separation of the bonding metallic plate from the surface of the electric contacts.

EFFECTIVITY: ALL

Vertical-Stabilizer Leading Edge - Removal/Installation
Figure 401



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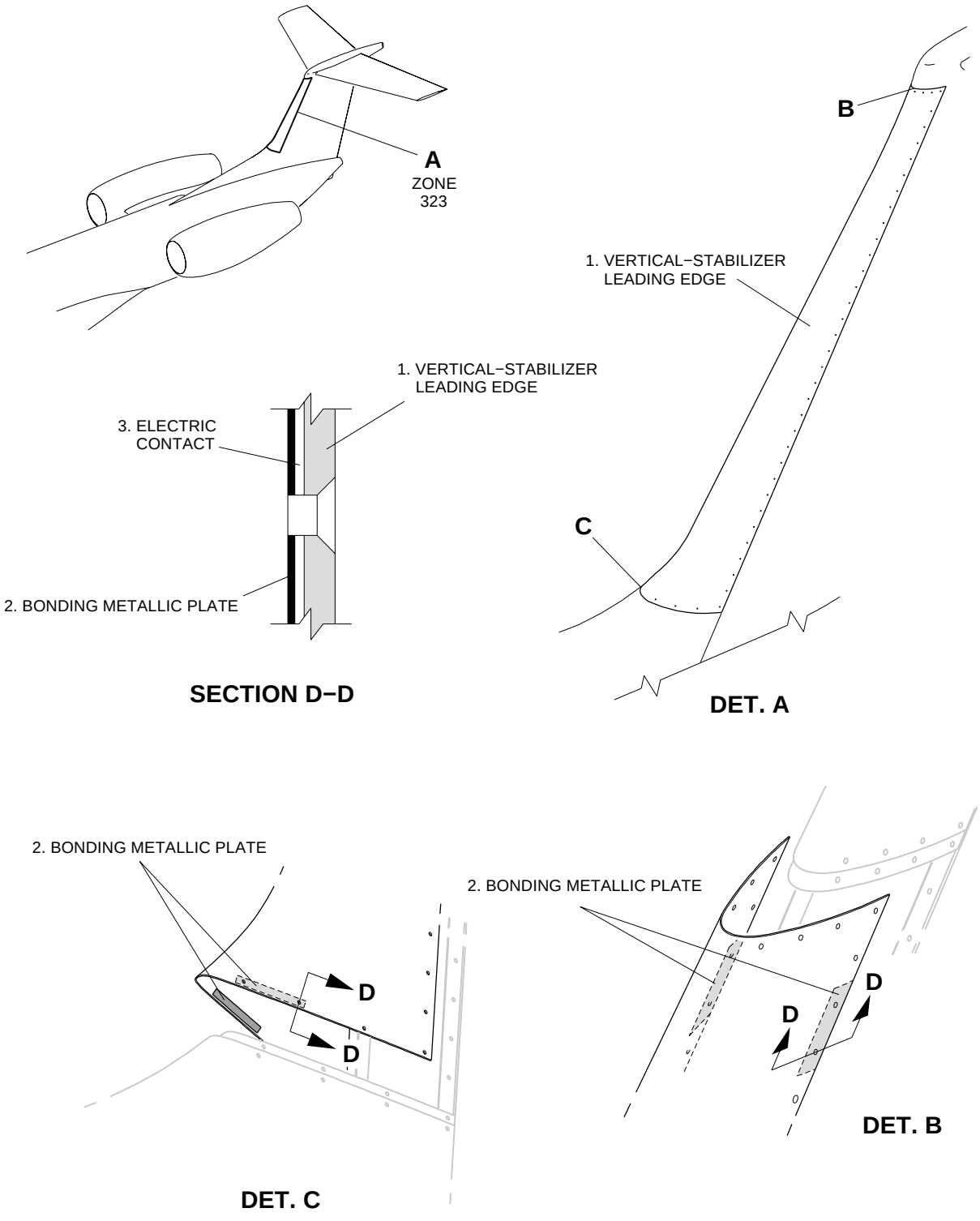
EFFECTIVITY: ALL
Bonding Metallic Plate
Figure 402



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TASK 55-35-00-400-801-A
EFFECTIVITY: ALL

3. VERTICAL-STABILIZER LEADING EDGE - INSTALLATION

A. General

(1) This procedure gives the instructions to install the vertical-stabilizer leading edge.

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
IPC 55-35-00	LEADING EDGE - FIN
SRM 51-20-01-PR	-

C. Zones and Accesses

ZONE	*PANEL/DOOR*	*LOCATION*
323		Vertical-stabilizer leading edge

D. Tools and Equipment

ITEM	*DESCRIPTION*	*PURPOSE*	*QTY*
Commercially available	Workstand	To get access to the work area	
Commercially available	Torque wrench	To tighten 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*
MIL-PRF-81733 TYPE II-2	Sealant, P/S 870 - B 2	AR
MIL-PRF-81733 TYPE II-1/2	Sealant, P/S 870 - 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

(Continued)

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

G. Expendable Parts

ITEM	*IPC REFERENCE (VENDOR REFERENCE)*	*QTY*
Bonding Metallic Plate	IPC 55-35-00	AR

H. Persons Recommended

QTY	*FUNCTION*	*PLACE*
1	Does the task	Vertical-stabilizer leading edge

I. Installation (Figure 401) (Figure 402)

SUBTASK 420-002-A

(1) Install the bonding metallic plate. Refer to (Figure 402):

(a) With a Scotch Brite sponge, sand the surface of the electric contacts where the bonding metallic plate will be bonded.

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.

(b) With a cloth soaked in MEK, clean the area of the electric contacts where the bonding metallic plate will be bonded.

(c) Remove the release film from the bonding metallic plate.

NOTE: Do not warp or twist the bonding metallic plate.

(d) Install the bonding metallic plate on the electric contacts.

(2) Install the vertical-stabilizer leading edge (2).

(3) Install the screws (1) that attach the vertical-stabilizer leading edge (2) to the vertical stabilizer.

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

(4) There are different methods to do the aerodynamic sealing between the vertical-stabilizer leading edge (2) and the vertical stabilizer itself. Use the applicable procedure as necessary.

(a) Full sealant-curing time:

1 Apply sealant P/S 870 - B 1/2 or P/S 870 - B 2.

NOTE: Sealant curing time will vary according to environmental conditions. Refer to SRM 51-20-01-PR.

(b) Acceleration of sealant curing time with heating:

1 Apply sealant P/S 870 - B 1/2 or P/S 870 - B 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: Sealant curing time will vary according to environmental conditions. Refer to SRM 51-20-01-PR.

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

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

1 Apply sealant P/S 870 - B 1/2 or P/S 870 - B 2.

2 You can accelerate the sealant curing time as indicated in paragraph (b).

3 After 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 P/S 870 - B 1/2 or P/S 870 - B 2.

2 Apply a polyethylene film over 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

SUBTASK 842-002-A

(1) Do the electrical-bonding test procedure as given in AMM TASK 20-13-21-700-801-A/200.