

SERVICE DOOR GUIDES - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the service door guides.
- 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
53-21-07-000-801-A	SERVICE DOOR GUIDES - REMOVAL	ALL
53-21-07-400-801-A	SERVICE DOOR GUIDES - INSTALLATION	ALL

TASK 53-21-07-000-801-A

EFFECTIVITY: ALL

2. SERVICE DOOR GUIDES - REMOVAL

A. General

(1) This task gives the procedure to remove the service door guides.

B. References

REFERENCE	DESIGNATION
AMM SDS 52-43-00/1	

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
821		Service door

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Torque wrench	To tighten the screws	

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Protective Gloves	For protection of technicians hands	1
Commercially available	Safety Goggles	For protection of technicians 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	At the main door frames

I. Preparation

SUBTASK 841-002-A

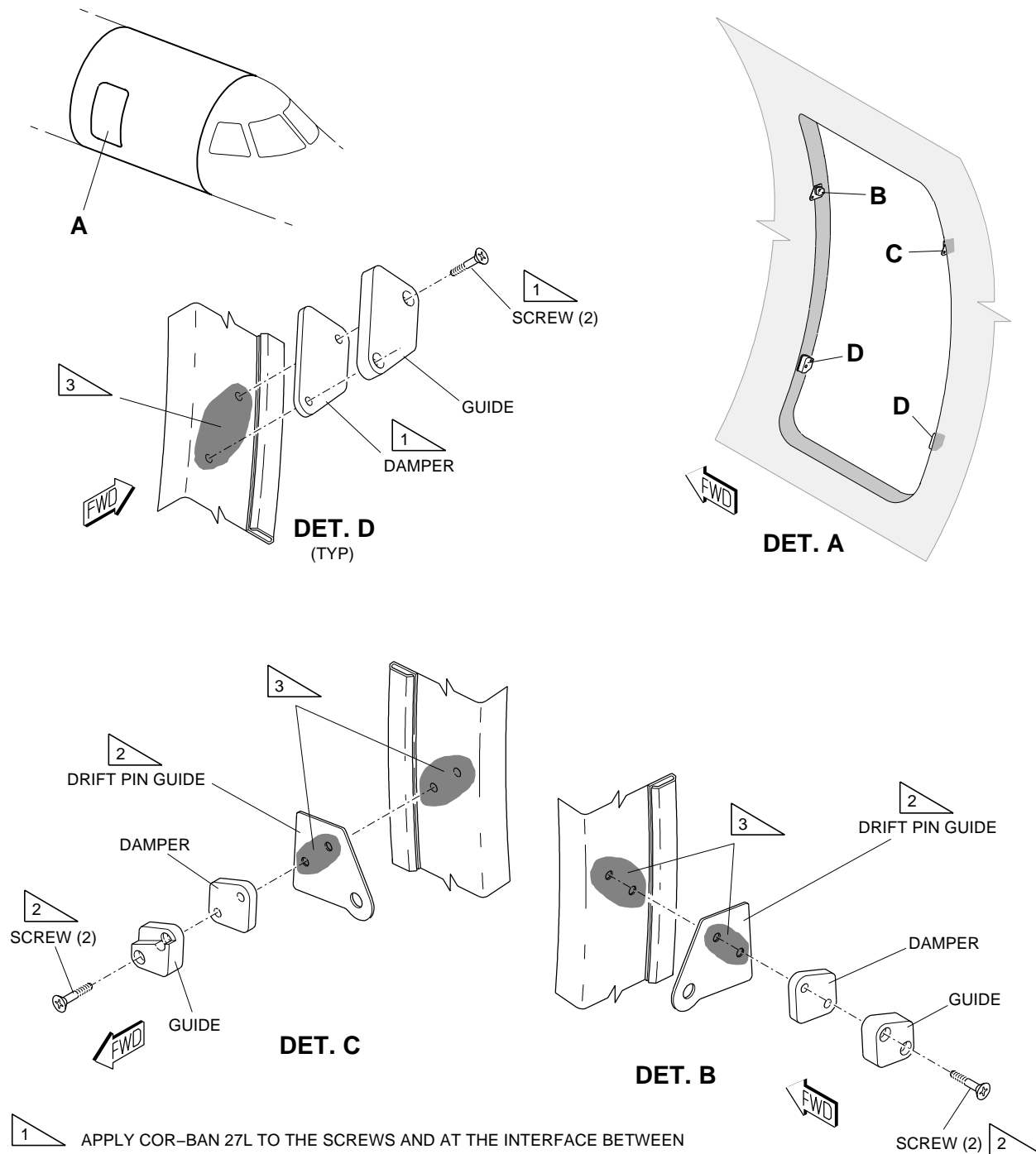
(1) Put the aircraft on safe condition.

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

EFFECTIVITY: ALL

Service Door Guides - Removal/Installation

Figure 401



- 1 APPLY COR-BAN 27L TO THE SCREWS AND AT THE INTERFACE BETWEEN THE DOOR FRAME AND THE DAMPER.
- 2 APPLY COR-BAN 27L TO THE SCREWS AND AT THE INTERFACE BETWEEN THE DOOR FRAME AND THE DRIFT PIN GUIDE.
- 3 FOR AIRCRAFT POST-MOD SB145-53-0040 OR SB145-53-0088 APPLY ALODINE 1200S AND EPOXY PRIMER.

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TASK 53-21-07-400-801-A
EFFECTIVITY: ALL

3. SERVICE DOOR GUIDES - INSTALLATION

A. General

(1) This task gives the procedure to install the service door guides.

B. References

REFERENCE	DESIGNATION
AMM MPP 20-10-01/200	- MAINTENANCE PRACTICES
AMM TASK 52-43-06-700-801-A/500	SERVICE-DOOR ACTUATING AND LOCKING MECHANISM - FUNCTIONAL CHECK
CPM 51-21-03	-
CPM 51-21-04	-
IPC 53-21-00	CENTRAL I
S.B.145-53-0040	-
S.B.145-53-0088	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
821		Service door

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Torque wrench	To tighten the screws	

E. Auxiliary Items

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

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
MEP 09-075	Corrosion-Inhibiting Compound (COR-BAN 27L)	AR
MIL-C-5541	Alodine 1200S	AR
MEP 10-059	Epoxy Primer	AR

G. Expendable Parts

ITEM	IPC REFERENCE (VENDOR REFERENCE)	QTY
Central I	IPC 53-21-00	AR

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	At the main door frames

I. Installation (Figure 401)

SUBTASK 420-002-A

NOTE: Make sure that the door frame area where the door guide is installed does not show signs of corrosion. If it does, contact the EMBRAER Technical Support Department.

- (1) For aircraft POST-MOD. [S.B.145-53-0040](#) or [S.B.145-53-0088](#), Perform a chemical conversion touch-up of all bare metal surface in the holes using (refer to CPM 51-21-04) and then apply Epoxy primer (refer to CPM 51-21-03).

WARNING: COR-BAN 27L IS TOXIC TO SKIN, EYES, AND RESPIRATORY TRACT. USE PVC GLOVES AND EYE PROTECTION. USE ONLY IN WELL VENTILATED AREAS. OBEY THE MANUFACTURER'S HEALTH AND SAFETY INSTRUCTIONS.

- (2) Apply COR-BAN 27L at the interface between the door frame and the damper or drift pin guide, as applicable, at the guide position.
- (3) Install the service door guide with the screws soaked in COR-BAN 27L.

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

J. Follow-on

SUBTASK 842-002-A

- (1) Do a functional check of the service door ([AMM TASK 52-43-06-700-801-A/500](#)).
- (2) If necessary, adjust the actuating and locking mechanism of the service door ([AMM TASK 52-43-06-700-801-A/500](#)).