



AIRCRAFT MAINTENANCE MANUAL

SIDE-HINGED MAIN-DOOR FOLDING FLAP - REMOVAL/INSTALLATION

EFFECTIVITY: AIRCRAFT WITH SIDE-HINGED MAIN DOOR

1. General

- A. This section gives the procedures to remove and install the folding flap of the side-hinged 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
52-18-03-000-801-A	SIDE-HINGED MAIN-DOOR FOLDING FLAP - REMOVAL	AIRCRAFT WITH SIDE-HINGED MAIN DOOR
52-18-03-400-801-A	SIDE-HINGED MAIN-DOOR FOLDING FLAP - INSTALLATION	AIRCRAFT WITH SIDE-HINGED MAIN DOOR



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TASK 52-18-03-000-801-A

EFFECTIVITY: AIRCRAFT WITH SIDE-HINGED MAIN DOOR

2. SIDE-HINGED MAIN-DOOR FOLDING FLAP - REMOVAL

A. General

- (1) This procedure gives the instructions to remove the folding flap of the side-hinged main door.

B. References

REFERENCE	DESIGNATION
AMM TASK 25-23-04-000-801-A/400	MAIN-DOOR LINING PANEL - REMOVAL
AMM TASK 52-18-04-000-801-A/400	SIDE-HINGED MAIN-DOOR RUBBER TRIM SEAL - REMOVAL

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
811		Side-hinged main door

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the side-hinged main door	

E. Auxiliary Items

Not Applicable

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Side-hinged main door
1	Helps the other technician	Side-hinged main door

I. Preparation

SUBTASK 841-002-A

- (1) Open the side-hinged main door.
- (2) Remove the trim cover of the side-hinged main door ([AMM TASK 25-23-04-000-801-A/400](#)).



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- (3) Remove the rubber-trim seal from the contour of the folding flap (AMM TASK 52-18-04-000-801-A/400).

J. Removal (Figure 401)

SUBTASK 020-002-A

- (1) The internal actuating handle of the main door must be in the open position.

CAUTION: DO NOT CHANGE THE ADJUSTMENT OF THE RODS (13) AND (10) WHILE YOU DO THIS TASK.

- (2) Remove the cotter pin (16), nut (15), washer (14), and bolt (12) to disconnect the rod (13) end from the support (19) at the folding flap (1).

- (3) Remove the cotter pin (7), nut (8), washer (9), and bolt (11) to disconnect the rod (10) end from the support at the folding flap (1).

- (4) Remove the nuts (6), washers (5), and screws (2) (16 positions) that attach the folding flap (1) to the door.

- (5) Remove the plate (18).

CAUTION: BE CAREFUL TO PREVENT DAMAGE TO THE RUBBER-TRIM SEAL DURING THE FOLDING FLAP REMOVAL.

- (6) Pull the rubber trim (17) to get access to the pin (4) of the hinge (3).

- (7) Remove the pin (4).

- (8) Remove the folding flap (1).

- (9) If necessary, remove the folding flap edging (20) as follows:

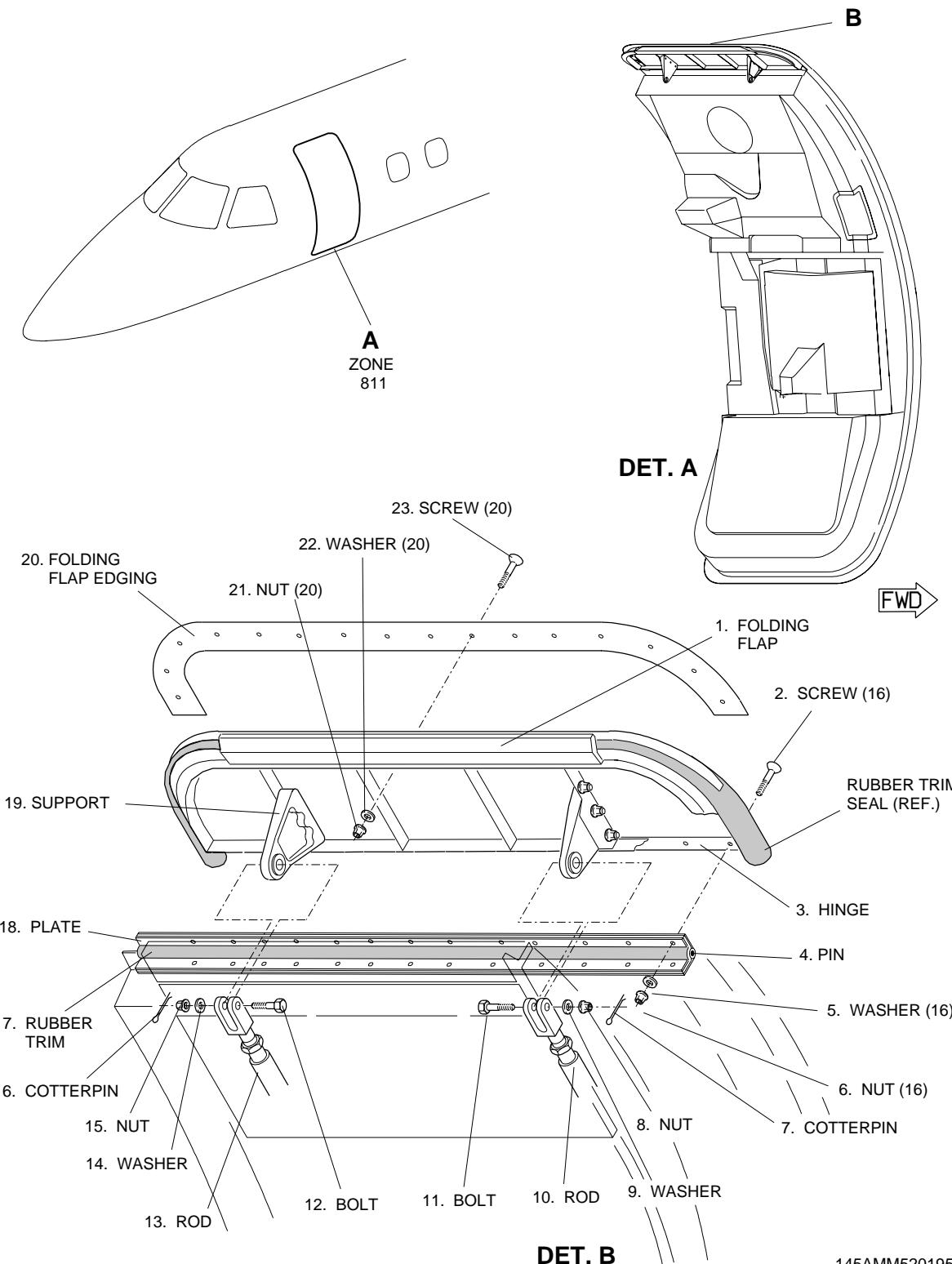
- (a) Support the folding flap (1) on a bench.

- (b) Remove the nuts (21), washers (22), and screws (23) (20 positions) that attach the folding flap edging (20) to the folding flap (1).

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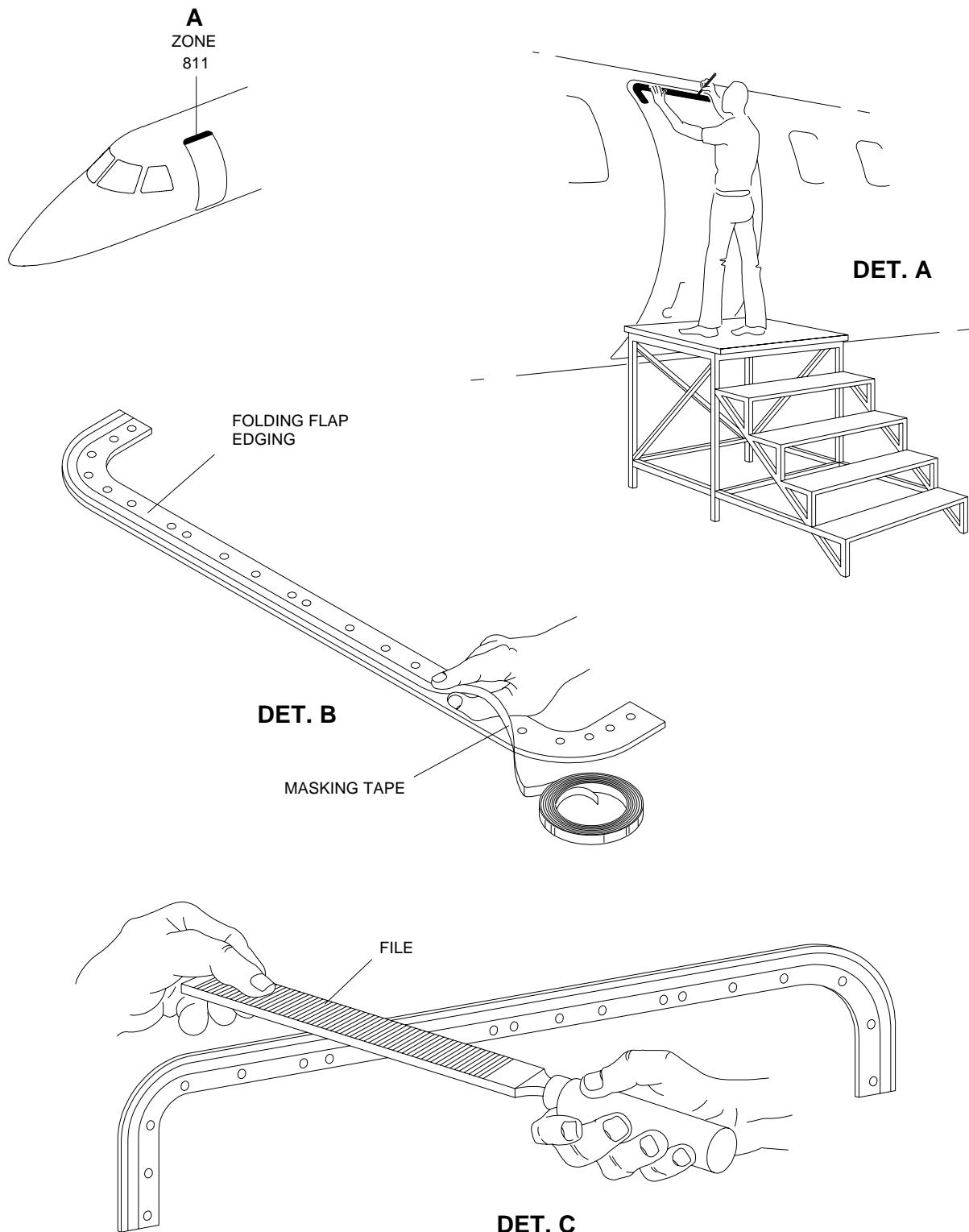
Folding Flap - Removal/Installation

Figure 401



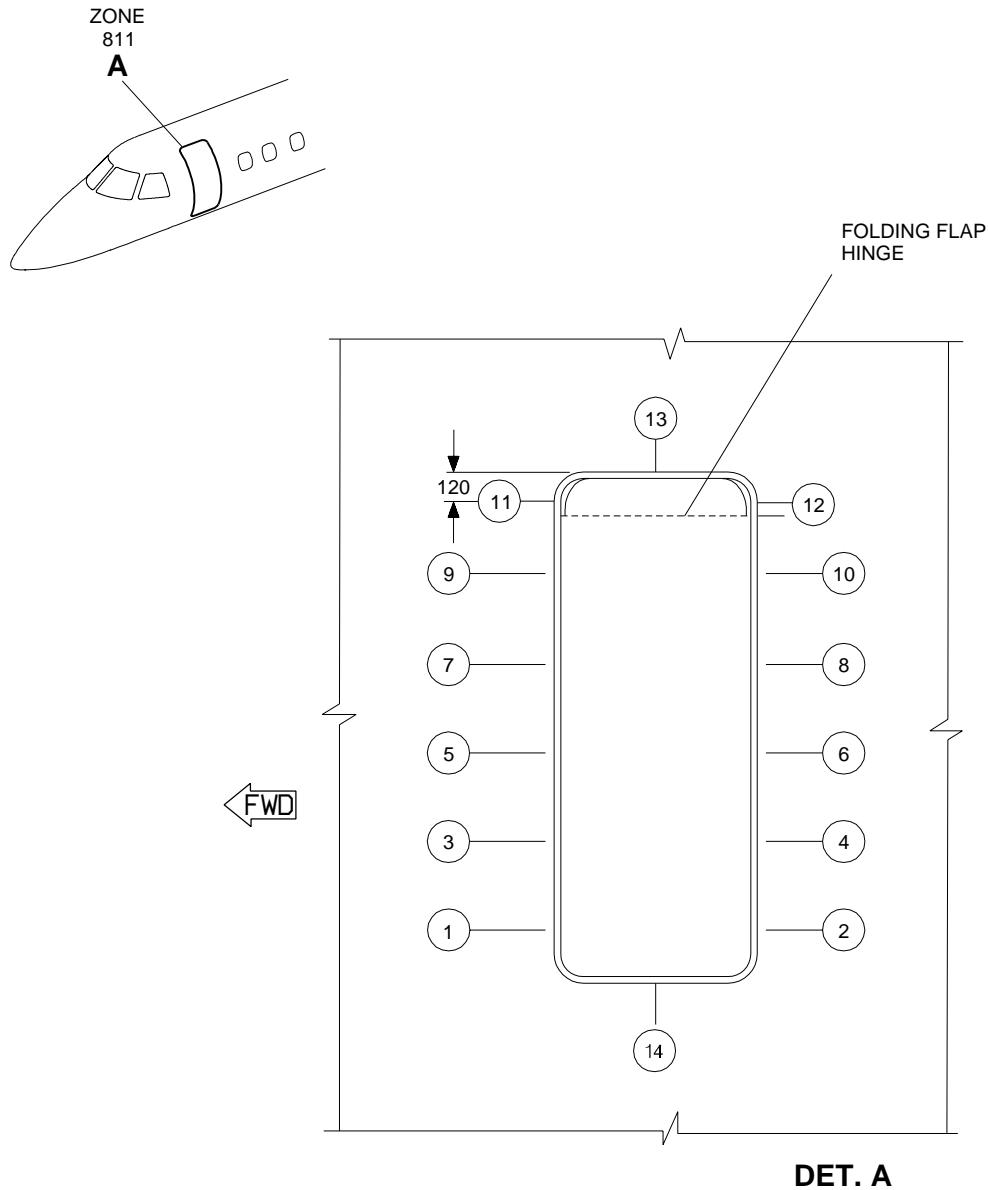
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EFFECTIVITY: AIRCRAFT WITH SIDE-HINGED MAIN DOOR
Folding Flap Edging - Installation
Figure 402



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EFFECTIVITY: AIRCRAFT WITH SIDE-HINGED MAIN DOOR
 Gaps Between Side-Hinged Main-Door Frame and Folding Flap
 Figure 403



AIRCRAFT DISCHARGED		
REFRENCE POINTS	GAP (mm)	
	MAX	MIN
01 UNTIL 10 13 AND 14	5.0	1.0
11 AND 12	7.0	4.0

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TASK 52-18-03-400-801-A

EFFECTIVITY: AIRCRAFT WITH SIDE-HINGED MAIN DOOR

3. SIDE-HINGED MAIN-DOOR FOLDING FLAP - INSTALLATION

A. General

(1) This procedure gives the instructions to install the folding flap of the side-hinged main door.

B. References

REFERENCE	DESIGNATION
AMM SDS 52-18-00/1	
AMM TASK 25-23-04-400-801-A/400	MAIN-DOOR LINING PANEL - INSTALLATION
AMM TASK 52-18-00-820-803-A/500	MAIN-DOOR LOCKING-MECHANISM CAMS - TEST
AMM TASK 52-18-00-820-810-A/500	MAIN-DOOR FOLDING FLAP - ADJUSTMENT
AMM TASK 52-18-04-400-801-A/400	SIDE-HINGED MAIN-DOOR RUBBER TRIM SEAL - INSTALLATION
IPC 52-18-11	SIDE-HINGED MAIN DOOR

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
811		Side-hinged main door

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the side-hinged main door	

E. Auxiliary Items

Not Applicable

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
MIL-F-38249, TYPE I	RTV157	AR
ASTM C-920	RTV780	AR

G. Expendable Parts

ITEM	IPC REFERENCE (VENDOR REFERENCE)	QTY
Cotter pin	IPC 52-18-11	2



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H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Side-hinged main door
1	Helps the other technician	Side-hinged main door

I. Installation (Figure 401)

SUBTASK 420-002-A

- (1) The internal actuating handle of the main door must be in the open position.

CAUTION: DO NOT CHANGE THE ADJUSTMENT OF THE RODS (10) AND (13) WHILE YOU DO THIS TASK.

- (2) Put the folding flap (1) at the side-hinged main door.
- (3) Install the pin (4) on the hinge (3).
- (4) Apply RTV157 or RTV780 sealant to the hinge (3) at the folding flap (1).
- (5) Put the rubber trim (17) in position.
- (6) Put the plate (18) in position.
- (7) Install the screws (2), washers (5), and nuts (6) (16 positions) to attach the folding flap (1) to the door.

NOTE: If the folding flap edging was removed, you must not install the last and the first screws.

- (8) Apply RTV157 or RTV780 sealant along the junction between the plate (18) and the folding flap (1), and between the plate (18) and the door.
- (9) Put the rod (13) on the support (19) at the folding flap (1) and install the bolt (12), washer (14), and nut (15).
- (10) Put the rod (10) on the support at the folding flap (1) and install the bolt (11), washer (9), and nut (8).
- (11) Install the cotter pins (7) and (16).

J. Follow-on (Figure 402) (Figure 403)

SUBTASK 842-002-A

- (1) Install the rubber trim seal along the contour of the folding flap ([AMM TASK 52-18-04-400-801-A/400](#)).
- (2) Close and lock the side-hinged main door.
- (3) If it is necessary to replace the folding flap edging, install the new edging as follows:
 - (a) Attach the folding flap edging on the folding flap, with three screws minimum, to hold the folding flap edging in the correct position.

- (b) Draw a line along the folding flap edging contour to let correct gaps stay between the door contour and the frame at points 11, 12, and 13. Refer to Figure 402 (DET. A) and Figure 403.
 - (c) Remove the folding flap edging from the folding flap.
 - (d) Apply narrow masking tape along the contour of the line on the folding flap edging to help you during the filing operation (Figure 402; DET. B).
 - (e) File the folding flap edging to the masking tape (Figure 402; DET. C).
 - (f) Attach the folding flap edging to the folding flap again (item (a) above).
 - (g) Unlock the door and make sure that the folding flap edging is not forced against the seal of the main door frame at the fuselage.
 - 1 If this occurs, lock the door and do items (b) thru (f) again.
 - (h) Remove the masking tape.
 - (i) Refinish the reworked areas as given in Corrosion Prevention Manual - Chapter 51.
 - (j) Install the nuts (8), washers (9), and screws (11) (20 positions).
- (4) Do an operational check of the side-hinged main- door folding flap ([AMM TASK 52-18-00-820-810-A/500](#)).
 - (5) If necessary, adjust the actuating and locking mechanism of the side-hinged main door ([AMM TASK 52-18-00-820-803-A/500](#)).
 - (6) Install the trim cover of the side-hinged main door ([AMM TASK 25-23-04-400-801-A/400](#)).
 - (7) Close the side-hinged main door ([AMM SDS 52-18-00/1](#)).

