



AIRCRAFT MAINTENANCE MANUAL

ENGINE MOUNTS - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove/install the engine mounts.
- B. With the engine installed on the aircraft, remove/install one mount at a time.
- C. 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
71-20-00-000-801-A	ENGINE MOUNTS - REMOVAL	ALL
71-20-00-400-801-A	ENGINE MOUNTS - INSTALLATION	ALL



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TASK 71-20-00-000-801-A

EFFECTIVITY: ALL

2. ENGINE MOUNTS - REMOVAL

A. General

(1) This task is applicable to the LH and RH engines.

B. References

REFERENCE	DESIGNATION
AMM MPP 71-00-00/200	- MAINTENANCE PRACTICES
AMM TASK 71-11-01-000-801-A/400	ENGINE UPPER COWLING - REMOVAL
AMM TASK 78-31-01-980-801-A/200	LOCK/UNLOCK THE TR EXHAUST DOOR - STOWED POSITION
AMM TASK 78-33-01-980-801-A/200	ISOLATION CONTROL UNIT - INHIBITION PROCEDURES

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
412		LH Engine Upper Cowling
422		RH Engine Upper Cowling
413		LH Engine Lower Cowling
423		RH Engine Lower Cowling

D. Tools and Equipment

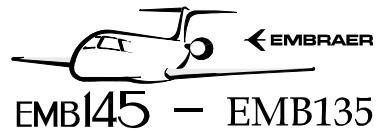
ITEM	DESCRIPTION	PURPOSE	QTY
GSE 164	Engine-Assembly Lifting Adapter	To lift the engine	
GSE 169	Aft Engine Lifting Adapter	To lift the engine	
GSE 180	Hydraulic crane	To lift the engine	
GSE 262	Forward Lifting Adapter	To lift the engine	

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the engine	1
Commercially available	Soft lint-free cloth	To clean the mounts	1

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
Fed. Spec. TT-I-735	Isopropyl alcohol	AR



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(Continued)

SPECIFICATION (BRAND)	DESCRIPTION	QTY
Fed. Spec. O-M-232	Methyl alcohol	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Engine

I. Preparation

SUBTASK 841-002-A

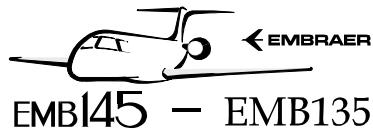
WARNING: BEFORE YOU DO THE TASK, OBEY THE SAFETY PRECAUTIONS GIVEN IN AMM MPP 71-00-00/200 TO PREVENT INJURY TO PERSONS AND DAMAGE TO MATERIAL.

- (1) On the circuit breaker panel, open the circuit breakers below and attach a DO-NOT-CLOSE tag to them.
 - START 1/2.
 - ENG AIR INLET 1/2.
 - THRUST REVERSER 1/2.
 - FADEC 1A/2A.
 - FADEC 1B/2B.
- (2) Lock the thrust reverser doors, if applicable ([AMM TASK 78-31-01-980-801-A/200](#)).
- (3) Isolate the ICU, if applicable ([AMM TASK 78-33-01-980-801-A/200](#)).
- (4) Put the workstand in the work area.
- (5) Remove the upper cowling ([AMM TASK 71-11-01-000-801-A/400](#)) to get access to the engine mounts.

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

SUBTASK 020-002-A

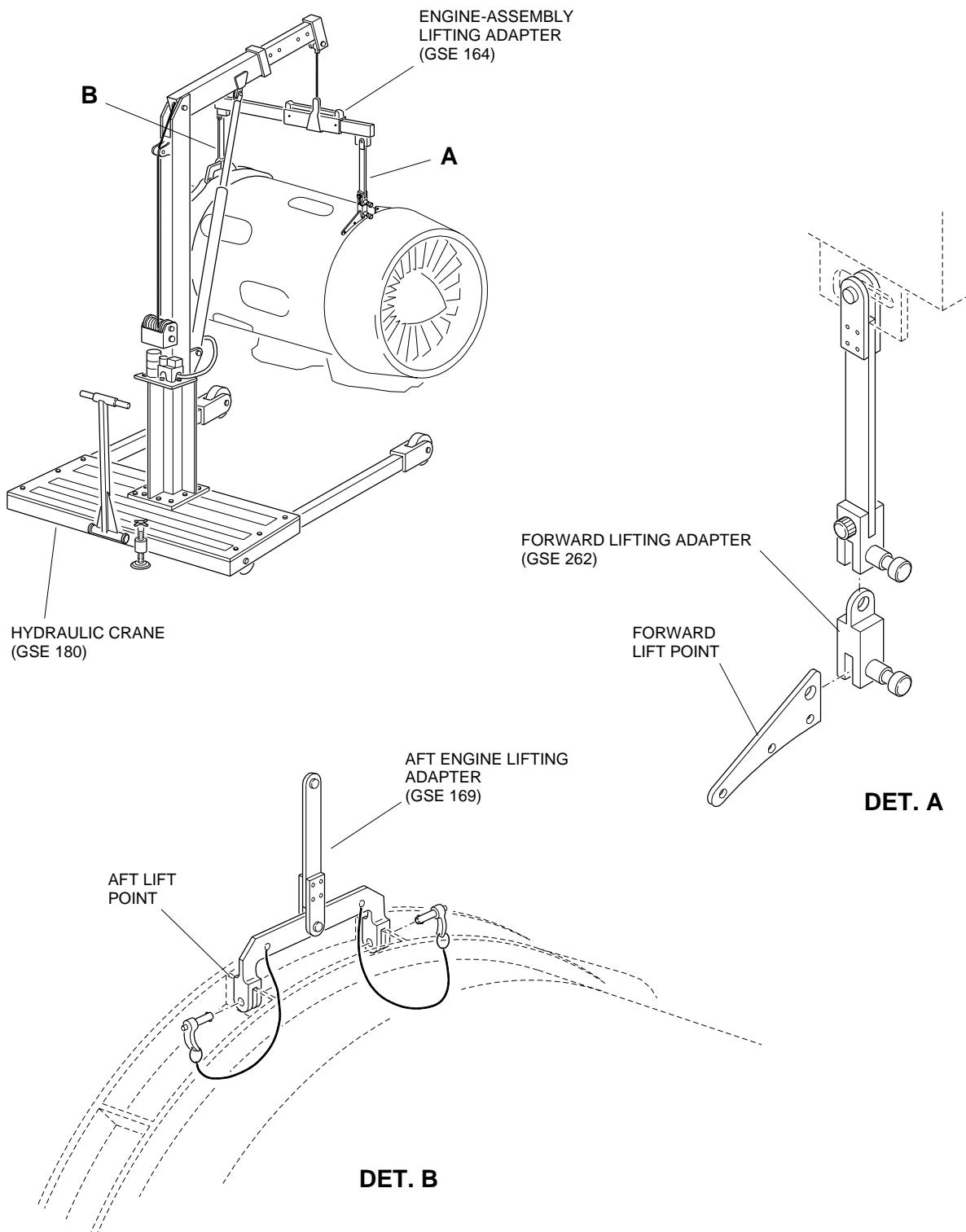
- (1) Remove the forward mounts as follows:
 - (a) Install the engine-assembly lifting adapter (GSE 164) at the hydraulic crane (GSE 180).
 - (b) Install the forward lifting adapter (GSE 262) at the forward lift point and at the engine-assembly lifting adapter (GSE 164).
 - (c) Install the aft engine lifting adapter (GSE 169) at the aft lift point and at the engine-assembly lifting adapter (GSE 164).



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- (d) Slowly and carefully operate the hydraulic crane (GSE 180) to keep the engine tightly held by the sling; however, do not lift its weight.
 - (e) Remove the bolts (1), washers (2) and the lockplates (3).
 - (f) Remove the cotter pin (5), nut (6), washers (4), bushing (7) and bolt (9). Discard the cotter pin.
 - (g) Cut the lockwire and remove the bolts (10) and washers (11).
 - (h) Remove the forward engine mount.
- (2) Remove the aft mounts as follows:
- (a) Remove the cotter pin (17), nut (18), washers (13), bushings (14) and bolt (12). Discard the cotter pin.
 - (b) Cut the lockwire and remove the bolts (15) and washers (16).
 - (c) Remove the aft engine mount.
- WARNING: DO NOT BREATHE METHYL OR ISOPROPYL ALCOHOL VAPORS. ALWAYS PUT ON GOGGLES, GLOVES AND A RESPIRATOR WHEN YOU USE METHYL OR ISOPROPYL ALCOHOL. DO THE WORK IN AN AREA THAT HAS A GOOD AIRFLOW, FAR FROM SPARKS, FLAMES, AND HOT SURFACES. METHYL AND ISOPROPYL ALCOHOL ARE TOXIC AND FLAMMABLE AND CAN CAUSE EYE, SKIN OR RESPIRATORY PROBLEMS. IF IT GETS ON YOUR SKIN, FLUSH IT WITH SOAP AND WATER. IF IT GETS IN YOUR EYES, FLUSH THEM WITH WATER AND GET MEDICAL AID IMMEDIATELY.**
- (3) To remove the CA-1000 product from the bolts and/or mounts, clean the parts with a cloth soaked in methyl or isopropyl alcohol. Let the parts to air-dry.

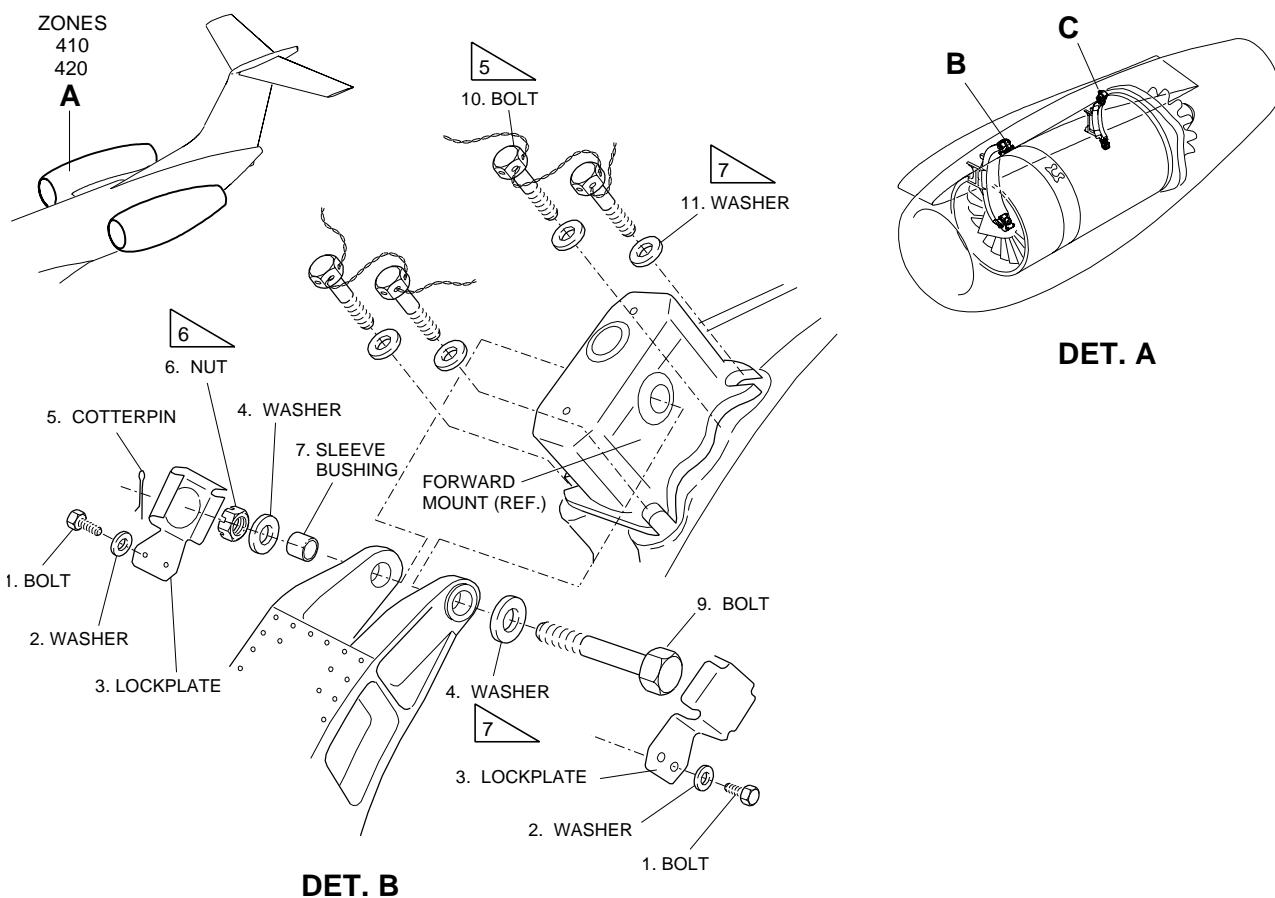
EFFECTIVITY: ALL
Engine Mounts - Removal/Installation
Figure 401 - Sheet 1


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EFFECTIVITY: ALL

Engine Mounts - Removal/Installation

Figure 401 - Sheet 2



1 TORQUE: 54.23 Nm TO 65.53 Nm (480 TO 580 lb.in).
FOR MOUNTS P/N LM-223-SA6.

2 TORQUE: 33.9 Nm TO 50.8 Nm (300 TO 450 lb.in).
FOR MOUNTS P/N LM-223-SA7.

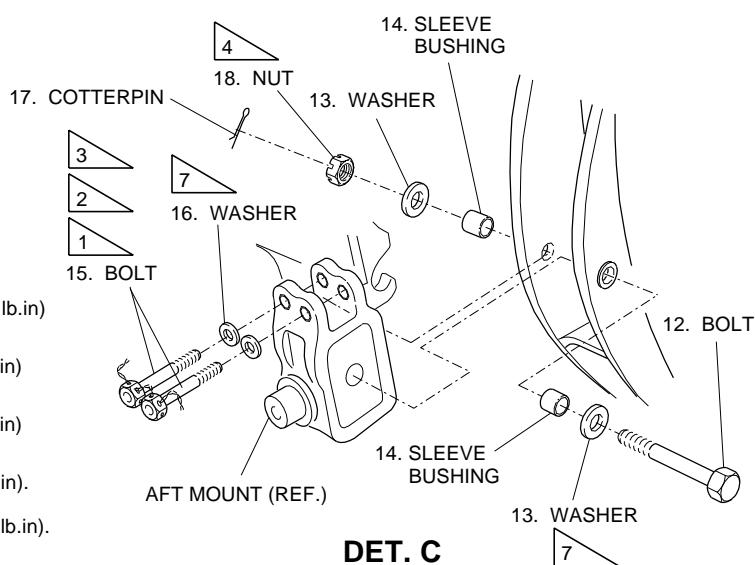
3 TORQUE: 19.8 Nm TO 25.4 Nm (175 TO 225 lb.in).
FOR MOUNTS P/N LM-223-SA8.

4 TORQUE: 33.9 Nm TO 50.8 Nm (300 TO 450 lb.in).

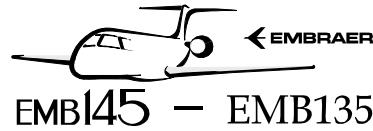
5 TORQUE: 54.24 Nm TO 62.15 Nm (480 TO 550 lb.in).

6 TORQUE: 45.19 Nm TO 56.49 Nm (400 TO 500 lb.in).

7 THE CHAMFER OF THE WASHER SHALL BE INSTALLED TO BOLT HEAD SIDE.



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TASK 71-20-00-400-801-A

EFFECTIVITY: ALL

3. ENGINE MOUNTS - INSTALLATION

A. General

(1) This task is applicable to the LH and RH engines.

B. References

REFERENCE	DESIGNATION
AMM TASK 71-11-01-400-801-A/400	ENGINE UPPER COWLING - INSTALLATION
AMM TASK 78-31-01-980-801-A/200	LOCK/UNLOCK THE TR EXHAUST DOOR - STOWED POSITION
AMM TASK 78-33-01-980-801-A/200	ISOLATION CONTROL UNIT - INHIBITION PROCEDURES
IPC 71-20-00	ENGINE MOUNTS

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
412		LH Engine Upper Cowling
422		RH Engine Upper Cowling
413		LH Engine Lower Cowling
423		RH Engine Lower Cowling

D. Tools and Equipment

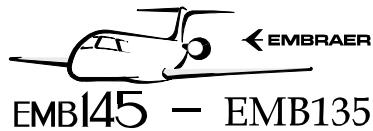
ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Torque wrench (For its torque range, refer to figure 401)	To apply torque	

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the engine mounts	1

F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
MS20995-C32	Lockwire	AR
	CA-1000 Corrosion - Inhibiting Compound	AR
AMS-2518	Molykote 321	AR



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G. Expendable Parts

ITEM	IPC REFERENCE (VENDOR REFERENCE)	QTY
Cotter pin	IPC 71-20-00	01/LRU

H. Persons Recommended

QTY	FUNCTION	PLACE
2	Do the task	Engine

I. Installation (Figure 401)

SUBTASK 420-002-A

- (1) Install the engine forward mount as follows:

- (a) In the pylon and in the engine, clean the pads which attach the engine forward mount.
- (b) Install the engine forward mount to the engine and attach it with bolts (10) and washers (11). Apply torque to the bolts (Refer to Figure 401).
- (c) Safety the bolts (10).

WARNING: CA-1000 CORROSION-INHIBITING COMPOUND IS TOXIC TO SKIN, EYES AND RESPIRATORY TRACT. USE PVC GLOVES AND EYE PROTECTION. USE ONLY IN WELL VENTILATED AREAS. OBEY THE MANUFACTURERS' HEALTH AND SAFETY INSTRUCTIONS.

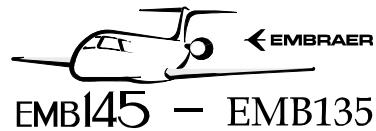
- (d) Apply Molykote 321 lubricant over the bushings (7). Apply CA-1000 corrosion-inhibiting compound to the engine mount attaching bolt (9) and install it to the pylon with the related bushing (7), washers (4) and nut (6). Torque the bolt (Refer to Figure 401).
- (e) Safety the nut (6) with the cotter pin.
- (f) Install the lock plates (3) and attach them with bolt (1) and washers (2).

- (2) Install the engine aft mounts as follows:

- (a) Install the engine aft mounts to the pylon and attach them with bolts (15) and washers (16). Torque the bolts (Refer to Figure 401).
- (b) Safety the bolts (15).

WARNING: CA-1000 CORROSION-INHIBITING COMPOUND IS TOXIC TO SKIN, EYES AND RESPIRATORY TRACT. USE PVC GLOVES AND EYE PROTECTION. USE ONLY IN WELL VENTILATED AREAS. OBEY THE MANUFACTURERS' HEALTH AND SAFETY INSTRUCTIONS.

- (c) Apply CA-1000 corrosion-inhibiting compound to the engine mount attaching bolt (12) and install it to the engine with the related bushings (14), washers (13), and nut (18). Torque the bolt (Refer to Figure 401).



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- (d) Safety the nut (18) with the cotter pin.
- (e) Remove the forward lifting adapter (GSE 262) from the forward lift point and the aft engine lifting adapter (GSE 169) from the aft lift points.

J. Follow-on

SUBTASK 842-002-A

- (1) Install the upper cowling ([AMM TASK 71-11-01-400-801-A/400](#)).
- (2) Release the thrust reverser doors, if applicable ([AMM TASK 78-31-01-980-801-A/200](#)).
- (3) Put the ICU back to its usual condition, if applicable ([AMM TASK 78-33-01-980-801-A/200](#)).
- (4) Remove the workstand.
- (5) On the circuit breaker panel, close the circuit breakers below and remove the DO-NOT-CLOSE tag from them.
 - START 1/2.
 - ENG AIR INLET 1/2.
 - THRUST REVERSER.
 - FADEC 1A/2A.
 - FADEC 1B/2B.

