

## PASSENGER-CABIN ESCAPE HATCH RUBBER TRIM SEAL - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

### 1. General

- A. This section gives the procedure for removal and installation of the passenger-cabin escape-hatch rubber trim seal.
- 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
52-21-01-000-801-A	PASSENGER-CABIN ESCAPE-HATCH RUBBER TRIM SEAL - REMOVAL	ALL
52-21-01-400-801-A	PASSENGER-CABIN ESCAPE-HATCH RUBBER TRIM SEAL - INSTALLATION	ALL

TASK 52-21-01-000-801-A

EFFECTIVITY: ALL

## 2. PASSENGER-CABIN ESCAPE-HATCH RUBBER TRIM SEAL - REMOVAL

### A. General

- (1) This task gives the instructions to remove the passenger-cabin escape-hatch rubber trim seal.

### B. References

REFERENCE	DESIGNATION
<a href="#">AMM TASK 52-21-00-000-801-A/400</a>	PASSENGER-CABIN ESCAPE HATCHES - REMOVAL

### C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
812		Passenger cabin - LH
822		Passenger cabin - RH

### D. Tools and Equipment

Not Applicable

### E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Acrylic Spatula	To remove the sealant	1
Commercially available	Cutter	To remove the rubber seal	1

### F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
TT-M-261	Methyl-ethyl-ketone (MEK)	AR

### G. Expandable Parts

Not Applicable

### H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Maintenance shop

### I. Preparation

SUBTASK 841-003-A

- (1) Remove the passenger-cabin escape hatch ( [AMM TASK 52-21-00-000-801-A/400](#) ).

- (2) Put the cockpit emergency exits on a safe surface to prevent scratches to the hatch.

J. Removal (Figure 401)

*SUBTASK 020-003-A*

**CAUTION:** SEALANTS OR SOLVENTS MUST BE USED ONLY IN AREAS WITH A GOOD FLOW OF AIR. DO NOT BREATHE THEIR VAPORS AND DO NOT LET YOUR SKIN TOUCH THESE PRODUCTS FOR A LONG TIME.

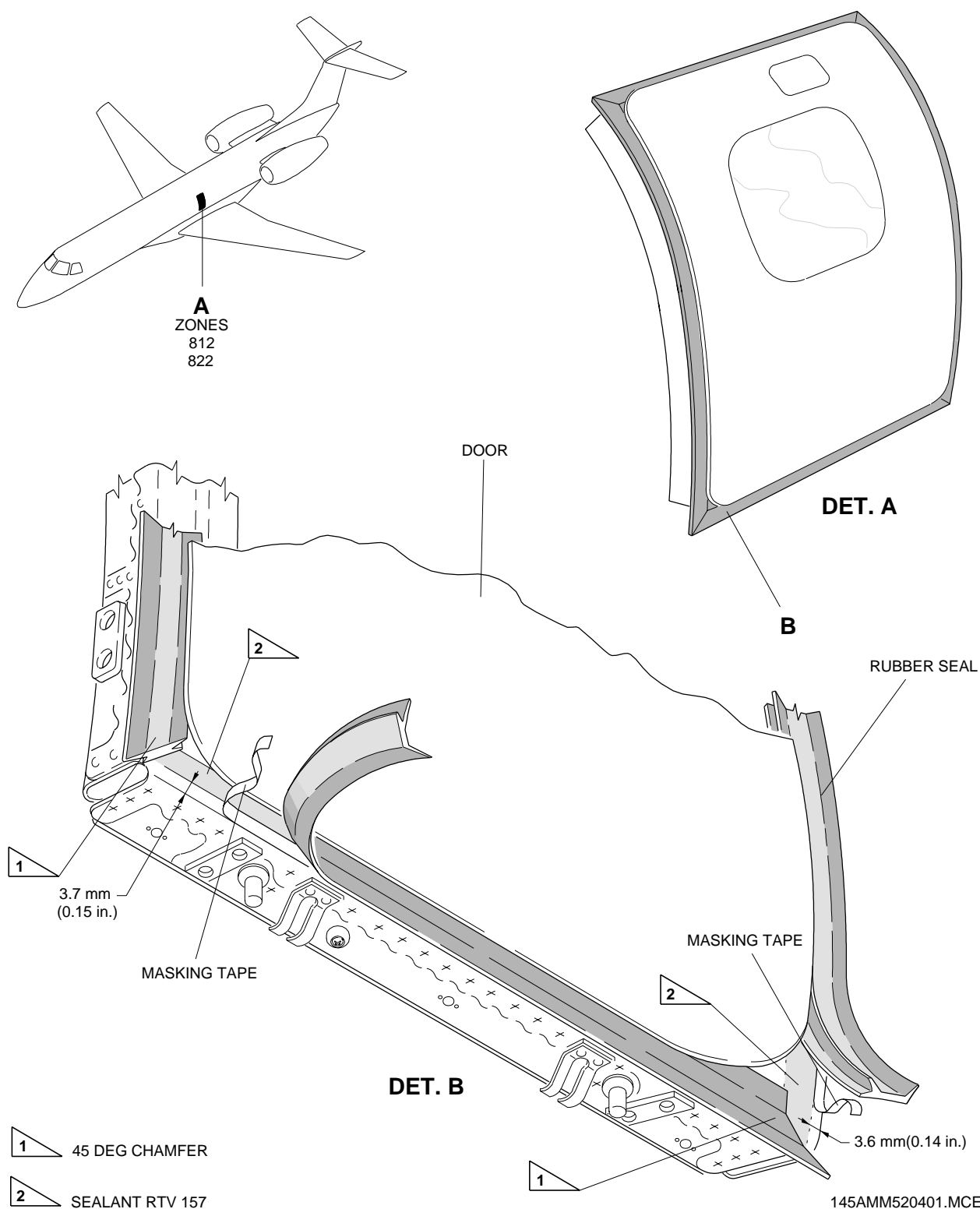
- (1) With a cutter, remove the sealant to lift the rubber seal end.
- (2) Slowly release the rubber seal with a cutter until the rubber seal is fully removed.
- (3) Remove from the door the old sealant with an acrylic spatula.
- (4) With a cloth soaked in MEK, clean the surface.

**NOTE:** Make sure that the surface of the door frame where the rubber seal will be installed is clean and without residues of sealant, rubber or oil.

EFFECTIVITY: ALL

Passenger-Cabin Escape-Hatch Rubber Trim Seal - Removal/Installation

Figure 401



TASK 52-21-01-400-801-A  
EFFECTIVITY: ALL

### 3. PASSENGER-CABIN ESCAPE-HATCH RUBBER TRIM SEAL - INSTALLATION

#### A. General

(1) This task gives the instructions to install the passenger-cabin escape-hatch rubber trim seal.

#### B. References

REFERENCE	DESIGNATION
AMM TASK 52-21-00-400-801-A/400	PASSENGER-CABIN ESCAPE HATCHES - INSTALLATION
AMM TASK 52-21-00-820-801-A/500	PASSENGER-CABIN ESCAPE-HATCH SUPPORT PINS - ADJUSTMENT
IPC 52-21-00	EMERGENCY HATCH

#### C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
812		Passenger cabin - LH
822		Passenger cabin - RH

#### D. Tools and Equipment

Not Applicable

#### E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Acrylic Spatula	To apply the sealant	1

#### F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
	Silicone sealant - RTV 157 (Gray)	AR
Commercially available	Masking tape	AR
Commercially available	Detergent	AR

#### G. Expendable Parts

ITEM	IPC REFERENCE (VENDOR REFERENCE)	QTY
Seal profile	IPC 52-21-00	AR

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Maintenance shop

I. Installation (Figure 401)

**SUBTASK 420-003-A**

- (1) There are two different conditions in which the installation of the passenger-cabin escape-hatch rubber trim seal can be done.
  - (a) Installation of the same passenger-cabin escape-hatch rubber trim seal. Do steps (2) to (12).
  - (b) Installation of a new passenger-cabin escape-hatch rubber trim seal. Do steps (3) to (12).
- (2) Remove the sealant from the passenger-cabin escape-hatch rubber trim seal.
- (3) To the upper and lower side of the passenger-cabin escape hatch, apply the masking tape 3.7 mm (0.15 in) from the passenger-cabin escape hatch edge to protect the part that will not receive the sealant (Det. B on (Figure 401).
- (4) To the left and right side of the passenger-cabin escape hatch, apply the masking tape 3.6 mm (0.14 in) from the passenger-cabin escape-hatch edge to protect the part that will not receive the sealant (Det. B on (Figure 401).
- (5) Sand the parts of the passenger-cabin escape hatch to which sealant RTV-157 will be applied.
- (6) Apply a thin coat of sealant RTV 157 to the area to which the rubber trim seal will be attached (Det. B on (Figure 401).
 

**NOTE:** If necessary, use the acrylic spatula to apply the sealant.
- (7) Apply sealant between the rubbers on the 45 degrees chamfer (note 1 on Det. B on (Figure 401).
- (8) Install the rubber trim seal to the passenger-cabin escape hatch (Figure 401).
 

**NOTE:** Clean the sealant excess.
- (9) Remove the masking tape from the cockpit emergency exit (Figure 401).
- (10) Wet the finger in a water-detergent solution and mold the sealant between the 45 degrees chamfer.
 

**NOTE:** If necessary, apply more sealant to the chamfer top to mold the sealant.
- (11) Wait 6 hours for the sealant to cure.
 

**NOTE:**

  - If the sealant is tack-free before 6 hours, the aircraft can be flown.
  - The tack-free time changes as a function of environmental conditions.

(12) Cut off the excess sealant edges.

J. Follow-on

*SUBTASK 842-003-A*

- (1) Install the passenger-cabin escape hatch ( [AMM TASK 52-21-00-400-801-A/400](#)).
- (2) If necessary, adjust the passenger cabin escape hatch ( [AMM TASK 52-21-00-820-801-A/500](#)).

