

STABILIZERS - ACCESS DOOR/PANELS - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the stabilizer access doors/panels.
- B. The procedures in this section are given in the sequence below.
- 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).

<i>TASK NUMBER</i>	<i>DESCRIPTION</i>	<i>EFFECTIVITY</i>
52-40-04-000-801-A	TAIL CONE ACCESS DOOR - REMOVAL	ALL
52-40-04-400-801-A	TAIL CONE ACCESS DOOR - INSTALLATION	ALL
52-40-04-000-802-A	TAIL CONE ACCESS PANELS - REMOVAL	ALL
52-40-04-400-802-A	TAIL CONE ACCESS PANELS - INSTALLATION	ALL
52-40-04-000-803-A	TAIL CONE APU AIR ACCESS PANEL - REMOVAL	ALL
52-40-04-400-803-A	TAIL CONE APU AIR ACCESS PANEL - INSTALLATION	ALL
52-40-04-000-804-A	TAIL CONE APU COMPARTMENT ACCESS PANEL - REMOVAL	ALL
52-40-04-400-804-A	TAIL CONE APU COMPARTMENT ACCESS PANEL - INSTALLATION	ALL
52-40-04-000-805-A	TAIL CONE FAIRING - REMOVAL	ALL
52-40-04-400-805-A	TAIL CONE FAIRING - INSTALLATION	ALL
52-40-04-000-806-A	VERTICAL STABILIZER AND RUDDER ACCESS DOORS AND PANELS - REMOVAL	ALL
52-40-04-400-806-A	VERTICAL STABILIZER AND RUDDER ACCESS DOORS AND PANELS - INSTALLATION	ALL
52-40-04-000-807-A	HORIZONTAL STABILIZER AND ELEVATOR ACCESS DOORS AND PANELS - REMOVAL	ALL
52-40-04-400-807-A	HORIZONTAL STABILIZER AND ELEVATOR ACCESS DOORS AND PANELS - INSTALLATION	ALL

TASK 52-40-04-000-801-A

EFFECTIVITY: ALL

2. TAIL CONE ACCESS DOOR - REMOVAL

A. General

(1) This procedure gives the instructions to remove the tail cone access door.

B. References

REFERENCE	DESIGNATION
AMM MPP 06-42-00/100	-
SRM 51-40-07	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
312	312AR	Tail cone

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	1

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Tail cone

I. Preparation

SUBTASK 841-002-A

- (1) Make sure that the aircraft is safe for maintenance.
- (2) Put the workstand in the work area.
- (3) Identify the tail cone access door 312AR. Refer to AMM MPP 06-42-00/100.

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

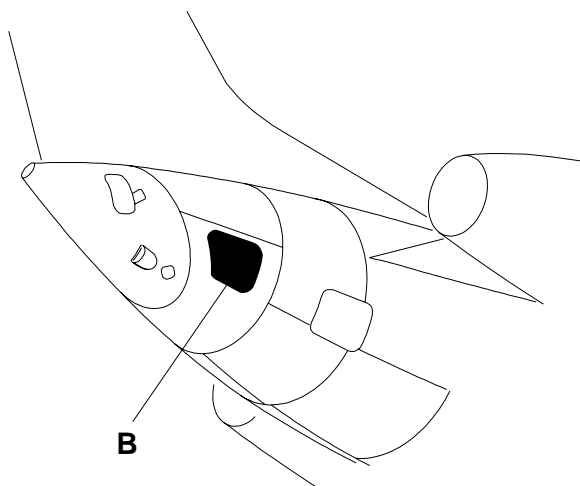
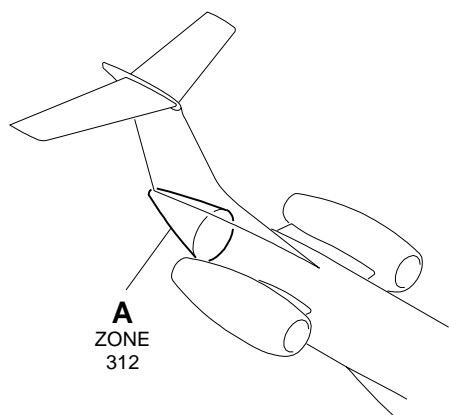
SUBTASK 020-002-A

- (1) Release the fasteners (2) to open the access door (1).
- (2) Remove the cotter pin (3) and pin (4).
- (3) Remove the nut (5) and washer (6).
- (4) Release the bonding strap (7).
- (5) Remove the screw (9) and washer (8).
- (6) Remove the rivets (10) that attach the access door (1) on tail cone. Refer to SRM 51-40-07.
- (7) Remove the access door (1).

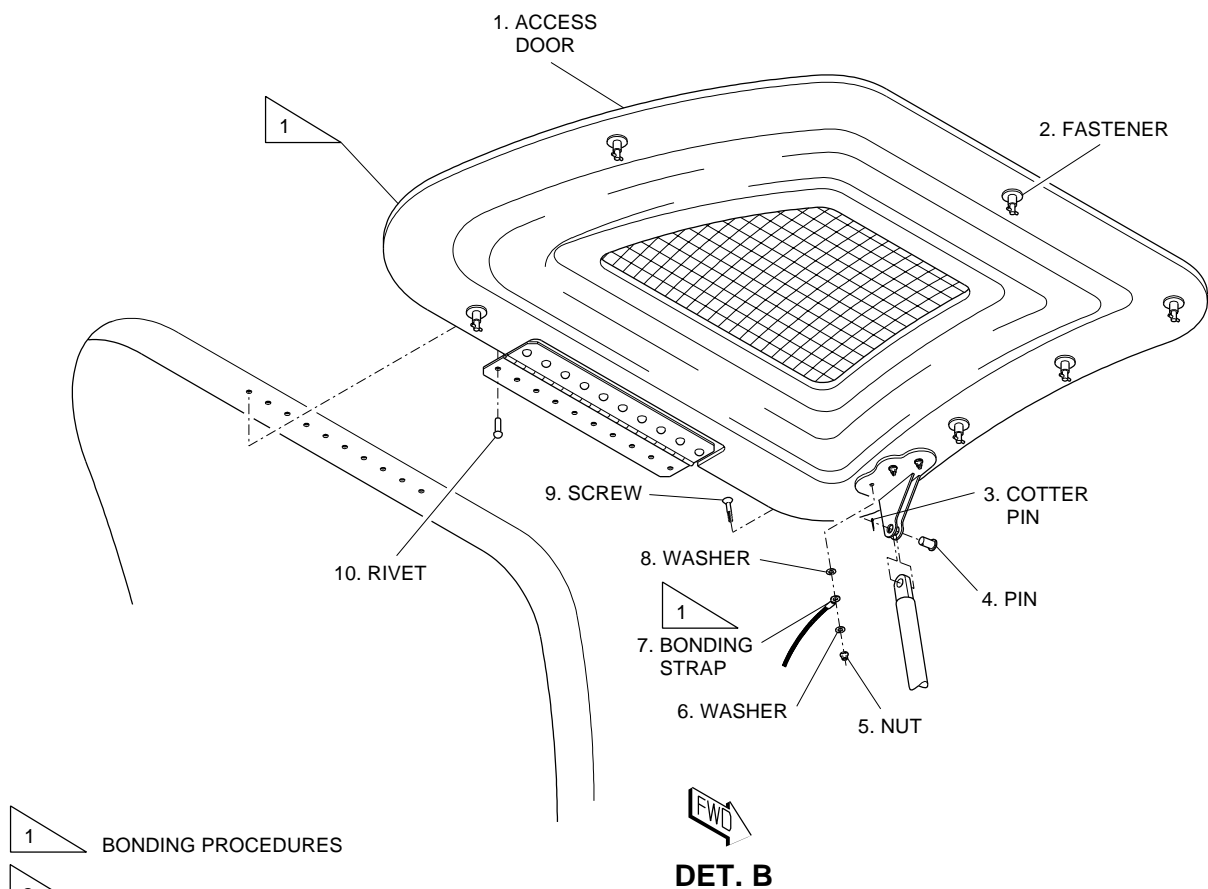
EFFECTIVITY: ALL

Tail Cone Access Door - Removal/Installation

Figure 401



DET. A



145AMM520596.MCE

TASK 52-40-04-400-801-A
EFFECTIVITY: ALL

3. TAIL CONE ACCESS DOOR - INSTALLATION

A. General

(1) This procedure gives the instructions to install the tail cone access doors.

B. References

REFERENCE	DESIGNATION
AMM MPP 20-10-01/200	- MAINTENANCE PRACTICES
AMM MPP 20-13-21/200	- MAINTENANCE PRACTICES
SRM 51-10-01	-
SRM 51-40-07	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
312	312AR	Tail cone

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Torque wrench	To tighten the attachment nuts	

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	1

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Tail cone

I. Installation (Figure 401)

SUBTASK 420-002-A

(1) Install the access door (1) with the rivets (10) on tail cone. Refer to SRM 51-40-07.

(2) Install the washer (8) and screw (9).

- (3) Install the bonding strap (7), washer (6), and nut (5) applying the correct torque. Refer to [AMM MPP 20-10-01/200](#).
- (4) Do the bonding procedures. Refer to [AMM MPP 20-13-21/200](#).
- (5) Install the pin (4) and cotter pin (3).
- (6) Close the fasteners (2).

J. Follow-on

SUBTASK 842-002-A

- (1) Do the bonding procedures test. Refer to [AMM MPP 20-13-21/200](#).
- (2) Check the Aerodynamic Limits. Refer to SRM 51-10-01.
- (3) Remove the workstand from the work area.

TASK 52-40-04-000-802-A

EFFECTIVITY: ALL

4. TAIL CONE ACCESS PANELS - REMOVAL

A. General

(1) This procedure gives the instructions to remove the tail cone access panels.

B. References

REFERENCE	DESIGNATION
AMM MPP 06-42-00/100	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
313	313AL	Tail cone
313	313BL	Tail cone
313	313DR	Tail cone
313	313GR	Tail cone

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	1

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Tail cone

I. Preparation

SUBTASK 841-003-A

- (1) Make sure that the aircraft is safe for maintenance.
- (2) Put the workstand in the work area.
- (3) Identify the access panels 313AL, 313BL, 313DR, and 313GR. Refer to AMM MPP 06-42-00/100.

J. Removal ([Figure 402](#))

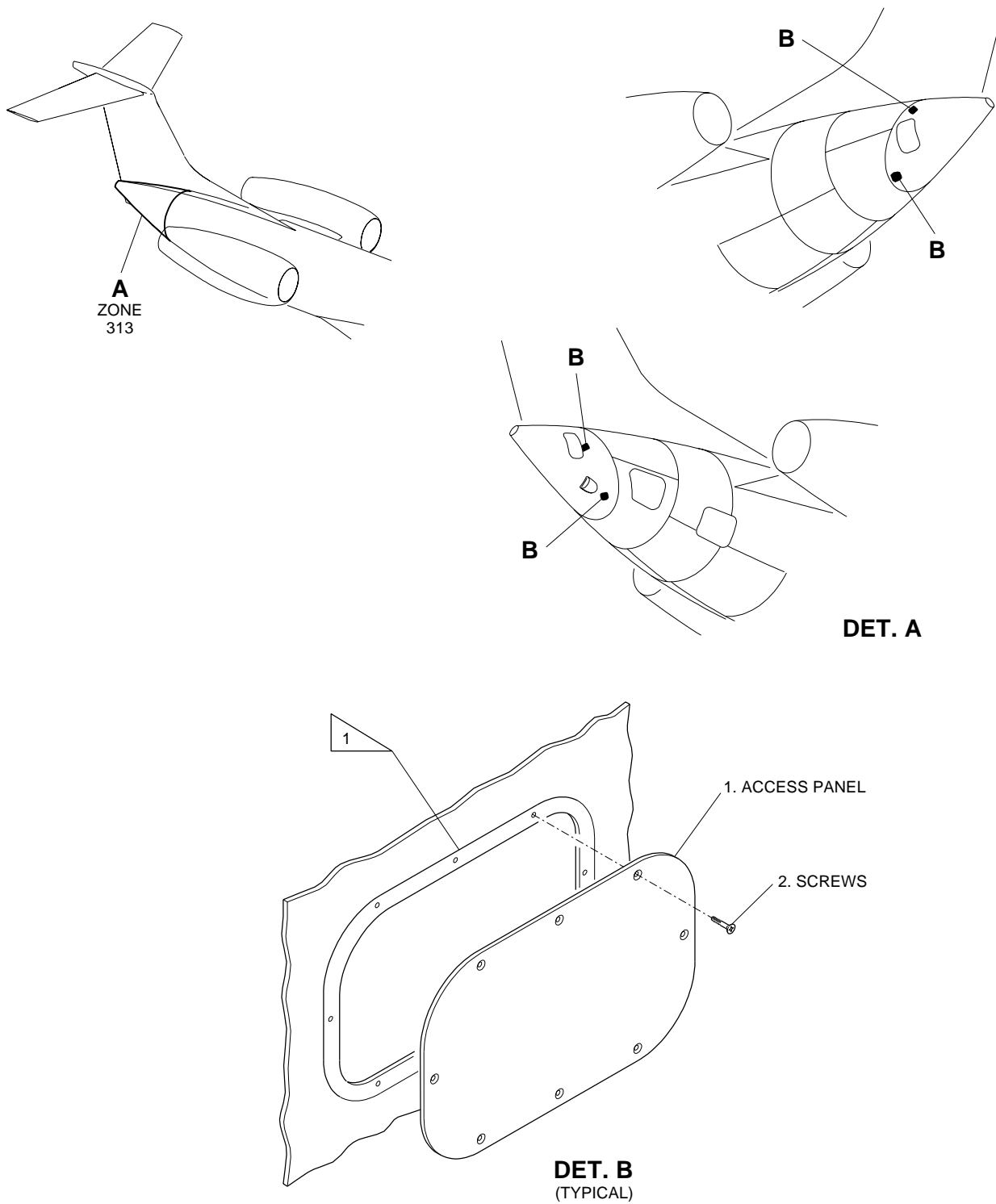
SUBTASK 020-003-A

- (1) Remove the screws (2) that attach access panel (1).
- (2) Remove the access panel (1).

EFFECTIVITY: ALL

Tail Cone Access Panels - Removal/Installation

Figure 402



1 AERODYNAMIC LIMITS

145AMM520597.MCE

TASK 52-40-04-400-802-A

EFFECTIVITY: ALL

5. TAIL CONE ACCESS PANELS - INSTALLATION

A. General

(1) This procedure gives the instructions to install the tail cone access panels.

B. References

REFERENCE	DESIGNATION
AMM MPP 20-10-01/200	- MAINTENANCE PRACTICES
SRM 51-10-01	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
313	313AL	Tail cone
313	313BL	Tail cone
313	313DR	Tail cone
313	313GR	Tail cone

D. Tools and Equipment

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

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	1

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Tail cone

I. Installation (Figure 402)

SUBTASK 420-003-A

(1) Install the access panel (1).

- (2) Install the screws (2) that attach the access panel (1) applying the correct torque. Refer to [AMM MPP 20-10-01/200](#).

J. Follow-on

SUBTASK 842-003-A

- (1) Check the Aerodynamic Limits. Refer to SRM 51-10-01.
- (2) Remove the workstand from the work area.

TASK 52-40-04-000-803-A

EFFECTIVITY: ALL

6. TAIL CONE APU AIR ACCESS PANEL - REMOVAL

A. General

(1) This procedure gives the instructions to remove the tail cone apu air access panels.

B. References

REFERENCE	DESIGNATION
AMM MPP 06-42-00/100	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
313	313ER	Tail cone

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	1

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Tail cone

I. Preparation

SUBTASK 841-004-A

- (1) Make sure that the aircraft is safe for maintenance.
- (2) Put the workstand in the work area.
- (3) Identify the apu air access panel 313ER. Refer to AMM MPP 06-42-00/100.

J. Removal ([Figure 403](#))

SUBTASK 020-004-A

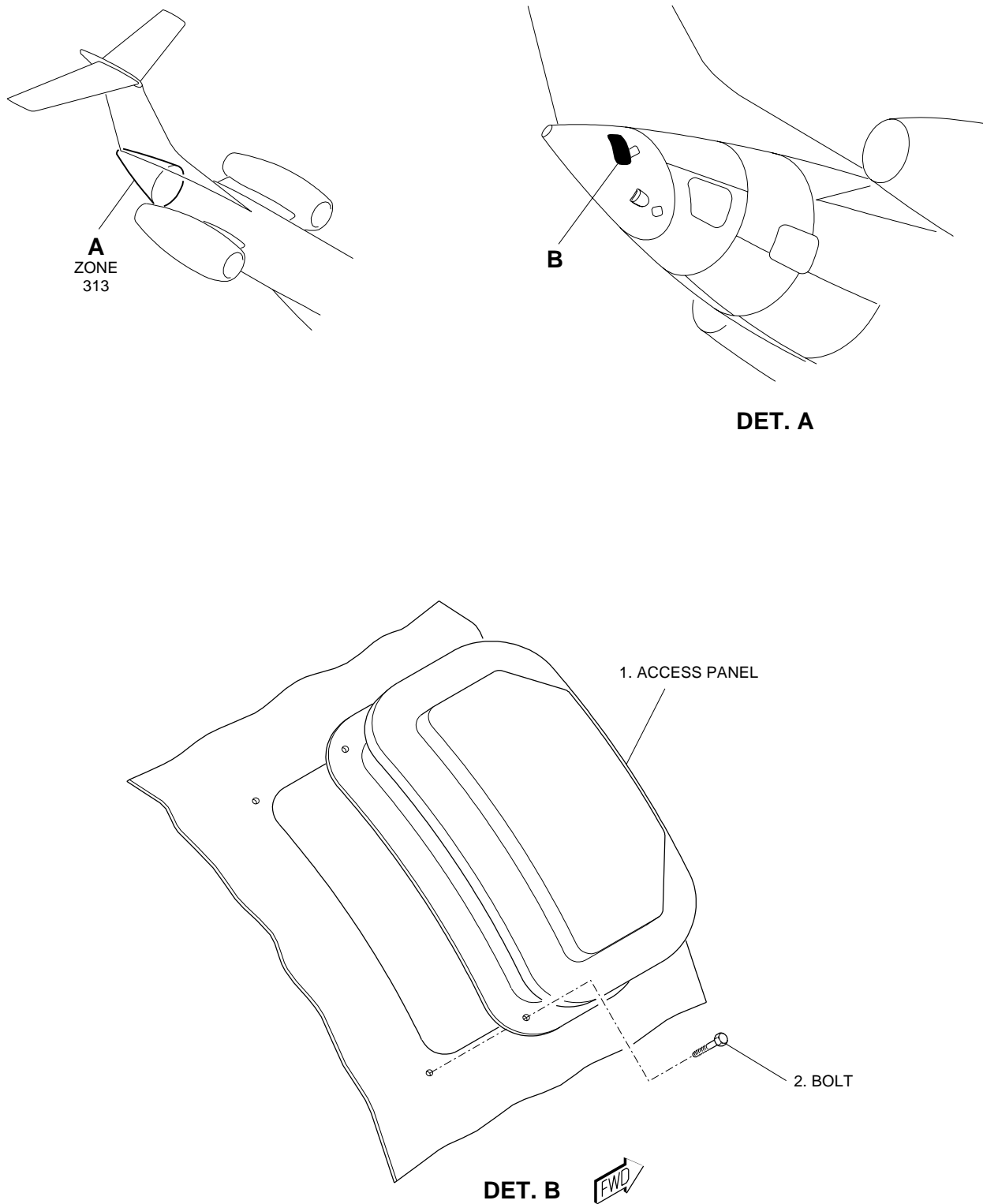
- (1) Remove the bolts (2) that attach apu air access panel (1).

- (2) Remove the apu air access panel (1).

EFFECTIVITY: ALL

Tail Cone APU Air Access Panel - Removal/Installation

Figure 403



TASK 52-40-04-400-803-A

EFFECTIVITY: ALL

7. TAIL CONE APU AIR ACCESS PANEL - INSTALLATION

A. General

(1) This procedure gives the instructions to install the tail cone apu air access panel.

B. References

REFERENCE	DESIGNATION
AMM MPP 20-10-01/200	- MAINTENANCE PRACTICES
SRM 51-10-01	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
313	313ER	Tail cone

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Torque wrench	To tighten the attachment bolts	

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	1

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Tail cone

I. Installation (Figure 403)

SUBTASK 420-004-A

- (1) Install the apu air access panel (1).
- (2) Install the bolts (2) that attach the apu air access panel (1) applying the correct torque. Refer to [AMM MPP 20-10-01/200](#).

J. Follow-on

SUBTASK 842-004-A

- (1) Check the Aerodynamic Limits. Refer to SRM 51-10-01.
- (2) Remove the workstand from the work area.

TASK 52-40-04-000-804-A
EFFECTIVITY: ALL

8. TAIL CONE APU COMPARTMENT ACCESS PANEL - REMOVAL

A. General

- (1) This procedure gives the instructions to remove the tail cone apu compartment access panel.

B. References

REFERENCE	DESIGNATION
AMM MPP 06-42-00/100	-
SRM 51-40-07	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
313	313CL	Tail cone

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	1

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Tail cone

I. Preparation

SUBTASK 841-005-A

- (1) Make sure that the aircraft is safe for maintenance.
- (2) Put the workstand in the work area.
- (3) Open the apu compartment access panel 313CL. Refer to AMM MPP 06-42-00/100.

J. Removal ([Figure 404](#))

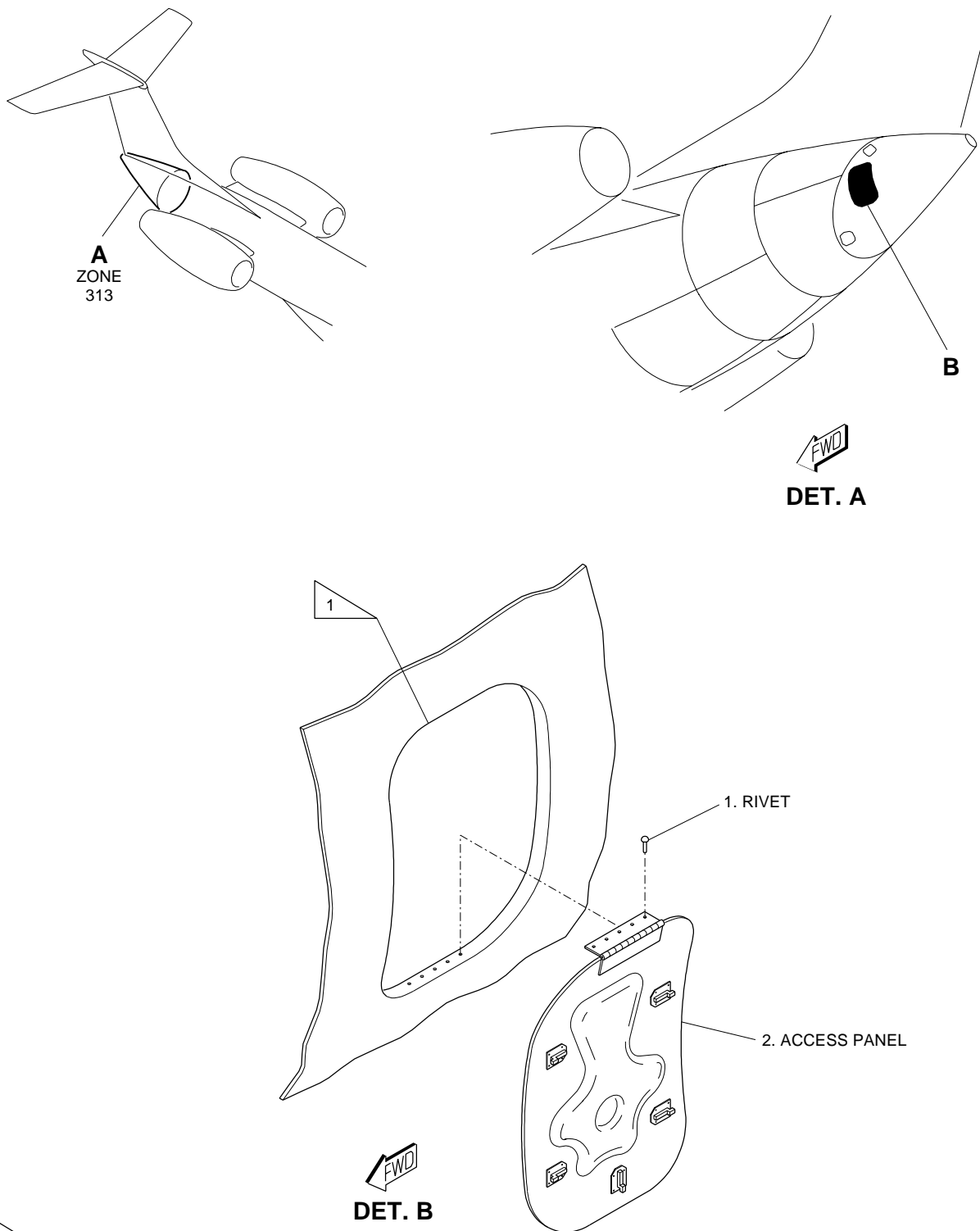
SUBTASK 020-005-A

- (1) Remove the rivets (1) that attach apu compartment access panel (2). Refer to SRM 51-40-07.
- (2) Remove the apu compartment access panel (2).

EFFECTIVITY: ALL

Tail Cone APU Compartment Access Panel - Removal/Installation

Figure 404



1 AERODYNAMIC LIMITS

145AMM520599.MCE

TASK 52-40-04-400-804-A

EFFECTIVITY: ALL

9. TAIL CONE APU COMPARTMENT ACCESS PANEL - INSTALLATION

A. General

(1) This procedure gives the instructions to install the tail cone apu compartment access panel.

B. References

REFERENCE	DESIGNATION
SRM 51-10-01	-
SRM 51-40-07	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
313	313CL	Tail cone

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	1

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Tail cone

I. Installation (Figure 404)

SUBTASK 420-005-A

(1) Install the apu compartment access panel (2) with the rivets (1). Refer to SRM 51-40-07.

J. Follow-on

SUBTASK 842-005-A

(1) Check the Aerodynamic Limits. Refer to SRM 51-10-01.

(2) Remove the workstand from the work area.

TASK 52-40-04-000-805-A

EFFECTIVITY: ALL

10. TAIL CONE FAIRING - REMOVAL

A. General

(1) This procedure gives the instructions to remove the tail cone fairing.

B. References

REFERENCE	DESIGNATION
AMM MPP 06-42-00/100	-
AMM TASK 49-11-00-000-801-A/400	APU COWLING - REMOVAL

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
313	313FR	Tail cone

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	1

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Tail cone

I. Preparation

SUBTASK 841-006-A

- (1) Make sure that the aircraft is safe for maintenance.
- (2) Put the workstand in the work area.
- (3) Identify the fairing 313FR. Refer to AMM MPP 06-42-00/100.
- (4) Remove the apu cowling ([AMM TASK 49-11-00-000-801-A/400](#)).

J. Removal ([Figure 405](#))

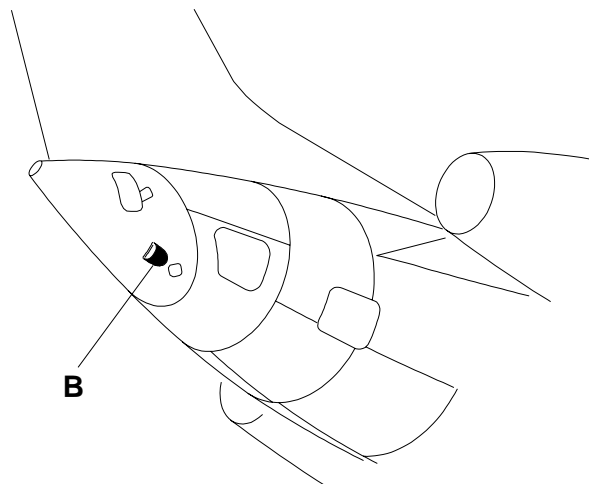
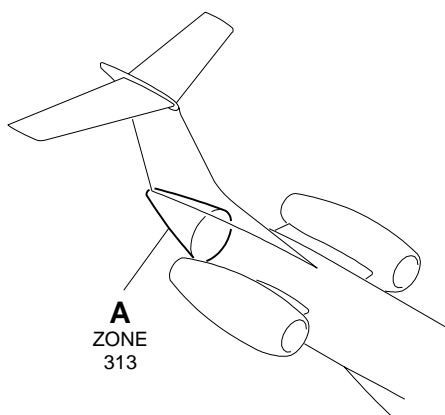
SUBTASK 020-006-A

- (1) Remove the screws (2) that attach the fairing (1) on apu cowling.
- (2) Remove the fairing (1).

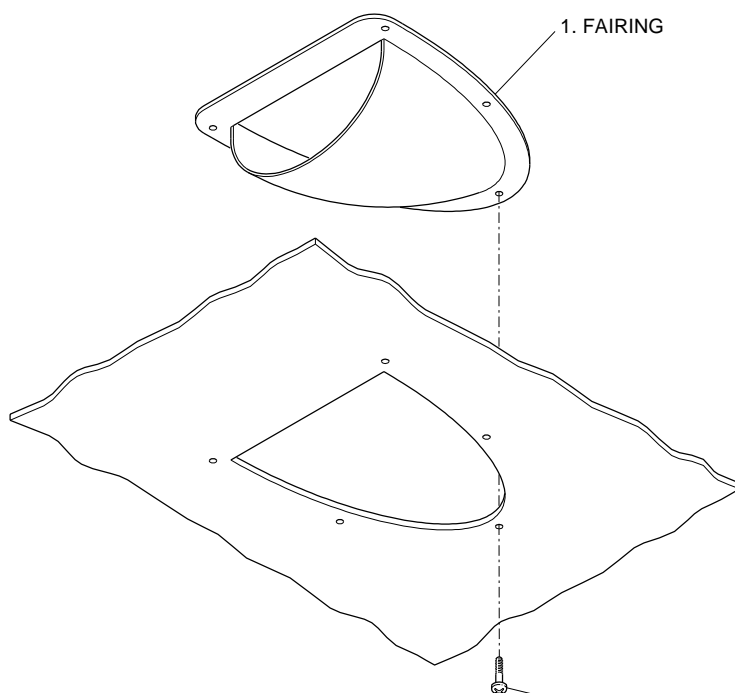
EFFECTIVITY: ALL

Tail Cone Fairing - Removal/Installation

Figure 405



DET. A



DET. B

145AMM520601.MCE

TASK 52-40-04-400-805-A

EFFECTIVITY: ALL

11. TAIL CONE FAIRING - INSTALLATION

A. General

(1) This procedure gives the instructions to install the tail cone fairing.

B. References

REFERENCE	DESIGNATION
AMM MPP 20-10-01/200	- MAINTENANCE PRACTICES
AMM TASK 49-11-00-400-801-A/400	APU COWLING - INSTALLATION

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
313	313FR	Tail cone

D. Tools and Equipment

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

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	1

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Tail cone

I. Installation (Figure 405)

SUBTASK 420-006-A

- (1) Install the fairing (1) with screws (2) applying the correct torque. Refer to [AMM MPP 20-10-01/200](#).

J. Follow-on

SUBTASK 842-006-A

- (1) Install the apu cowling ([AMM TASK 49-11-00-400-801-A/400](#)).
- (2) Remove the workstand from the work area.

TASK 52-40-04-000-806-A

EFFECTIVITY: ALL

12. VERTICAL STABILIZER AND RUDDER ACCESS DOORS AND PANELS - REMOVAL

A. General

- (1) This procedure gives the instructions to remove the vertical stabilizer and rudder access doors and panels.

B. References

REFERENCE	DESIGNATION
AMM MPP 06-42-00/100	-
AMM TASK 55-38-00-000-801-A/400	RUDDER I ACCESS PANELS - REMOVAL

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
322	322AL	Vertical stabilizer
322	322BR	Vertical stabilizer
324	324AL	Vertical stabilizer
324	324BL	Vertical stabilizer
324	324CL	Vertical stabilizer
324	324DL	Vertical stabilizer
324	324EL	Vertical stabilizer
324	324FR	Vertical stabilizer
325	325AL	Vertical stabilizer
325	325BL	Vertical stabilizer
325	325CL	Vertical stabilizer
325	325DL	Vertical stabilizer
325	325EL	Vertical stabilizer
325	325FL	Vertical stabilizer
325	325FR	Vertical stabilizer
325	325GR	Vertical stabilizer
325	325HR	Vertical stabilizer
325	325JR	Vertical stabilizer
325	325KR	Vertical stabilizer
325	325LR	Vertical stabilizer
326	326AL	Vertical stabilizer
326	326BL	Vertical stabilizer
326	326CL	Vertical stabilizer
326	326DL	Vertical stabilizer
326	326EL	Vertical stabilizer
326	326FL	Vertical stabilizer

(Continued)

<i>ZONE</i>	<i>PANEL/DOOR</i>	<i>LOCATION</i>
326	326GL	Vertical stabilizer
326	326HL	Vertical stabilizer
327	327AL	Vertical stabilizer
327	327BL	Vertical stabilizer
327	327CL	Vertical stabilizer
327	327DL	Vertical stabilizer
327	327ER	Vertical stabilizer
327	327FR	Vertical stabilizer
327	327GR	Vertical stabilizer
327	327HR	Vertical stabilizer

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

<i>ITEM</i>	<i>DESCRIPTION</i>	<i>PURPOSE</i>	<i>QTY</i>
Commercially available	Workstand	To get access to the work area	1

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

<i>QTY</i>	<i>FUNCTION</i>	<i>PLACE</i>
1	Does the task	Vertical stabilizer

I. Preparation

SUBTASK 841-007-A

- (1) Make sure that the aircraft is safe for maintenance.
- (2) Put the workstand in the work area.
- (3) Identify vertical stabilizer access panels 322AL, 322BR, 324AL, 324BL, 324CL, 324DL, 324EL, 324FR, 325AL, 325BL, 325CL, 325DL, 325EL, 325FL, 325FR, 325GR, 325HR, 325JR, 325KR, 325LR, 326AL, 326BL, 326CL, 326DL, 326EL, 326FL, 326GL, 326HL, 327AL, 327BL, 327CL, 327DL, 327ER, 327FR, 327GR, and 327HR. Refer to AMM MPP 06-42-00/100.

J. Removal ([Figure 406](#))

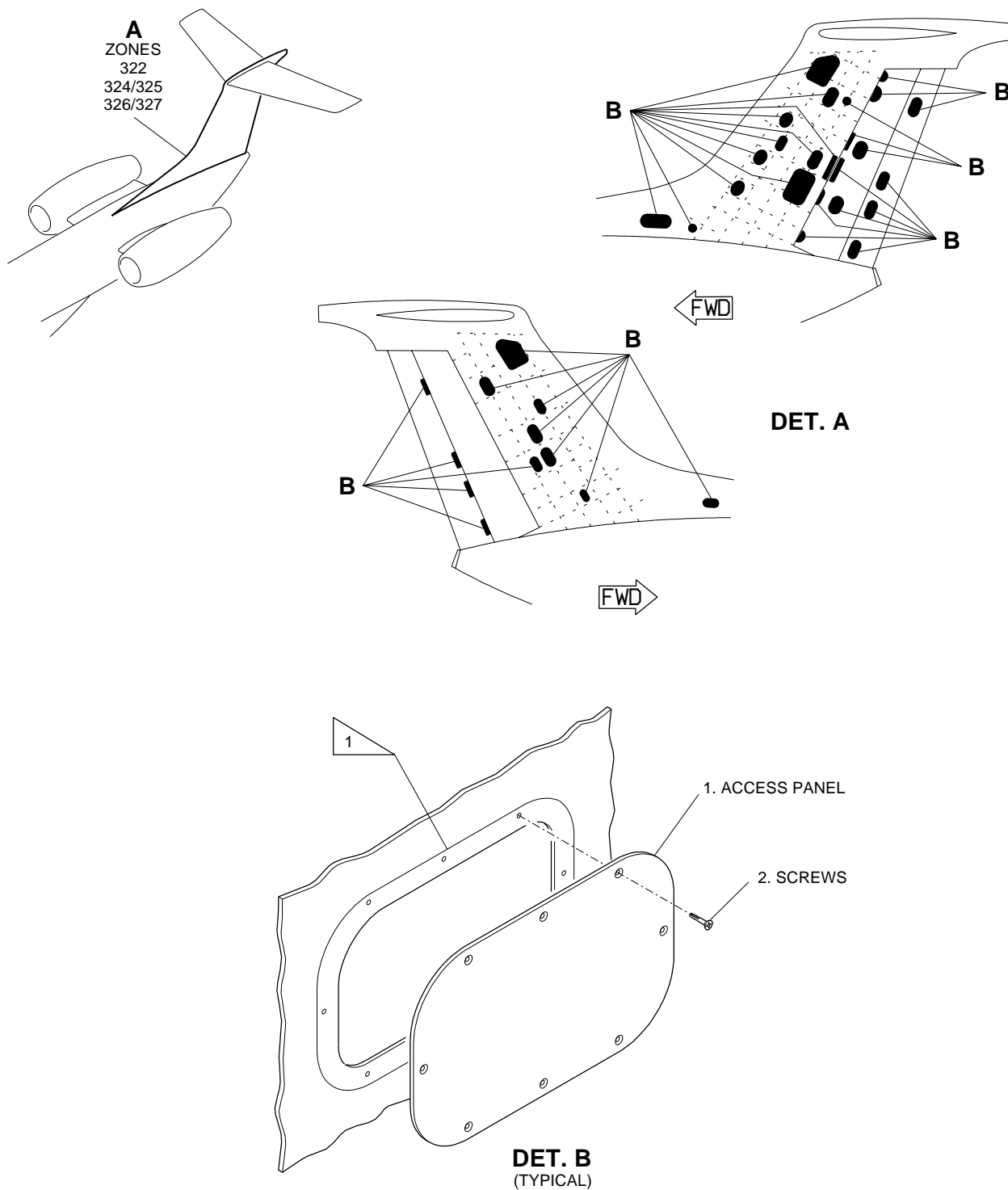
SUBTASK 020-007-A

- (1) Remove these access panels. Refer to [AMM TASK 55-38-00-000-801-A/400](#):
 - 326AL
 - 326BL
 - 326DL
 - 326EL
 - 326GL
 - 326HL
- (2) Remove the remaining vertical-stabilizer access panels as follows:
 - (a) Remove the screws (2) that attach the access panel (1).
 - (b) Remove the access panel (1).

EFFECTIVITY: ALL

Vertical Stabilizer and Rudder Access Doors and Panels - Removal/Installation

Figure 406



1 AERODYNAMIC LIMITS

145AMM520605.MCE

TASK 52-40-04-400-806-A

EFFECTIVITY: ALL

13. VERTICAL STABILIZER AND RUDDER ACCESS DOORS AND PANELS - INSTALLATION

A. General

- (1) This procedure gives the instructions to install the vertical stabilizer and rudder access doors and panels.

B. References

REFERENCE	DESIGNATION
AMM MPP 20-10-01/200	- MAINTENANCE PRACTICES
AMM TASK 55-38-00-400-801-A/400	RUDDER I ACCESS PANELS - INSTALLATION
SRM 51-10-01	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
322	322AL	Vertical stabilizer
322	322BR	Vertical stabilizer
324	324AL	Vertical stabilizer
324	324BL	Vertical stabilizer
324	324CL	Vertical stabilizer
324	324DL	Vertical stabilizer
324	324EL	Vertical stabilizer
324	324FR	Vertical stabilizer
325	325AL	Vertical stabilizer
325	325BL	Vertical stabilizer
325	325CL	Vertical stabilizer
325	325DL	Vertical stabilizer
325	325EL	Vertical stabilizer
325	325FL	Vertical stabilizer
325	325FR	Vertical stabilizer
325	325GR	Vertical stabilizer
325	325HR	Vertical stabilizer
325	325JR	Vertical stabilizer
325	325KR	Vertical stabilizer
325	325LR	Vertical stabilizer
326	326AL	Vertical stabilizer
326	326BL	Vertical stabilizer
326	326CL	Vertical stabilizer
326	326DL	Vertical stabilizer
326	326EL	Vertical stabilizer

(Continued)

ZONE	PANEL/DOOR	LOCATION
326	326FL	Vertical stabilizer
326	326GL	Vertical stabilizer
326	326HL	Vertical stabilizer
327	327AL	Vertical stabilizer
327	327BL	Vertical stabilizer
327	327CL	Vertical stabilizer
327	327DL	Vertical stabilizer
327	327ER	Vertical stabilizer
327	327FR	Vertical stabilizer
327	327GR	Vertical stabilizer
327	327HR	Vertical stabilizer

D. Tools and Equipment

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

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	1

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Vertical Stabilizer

I. Installation (Figure 406)

SUBTASK 420-007-A

(1) Install these access panels. Refer to [AMM TASK 55-38-00-400-801-A/400](#):

- 326AL
- 326BL
- 326DL

- 326EL
- 326GL
- 326HL

(2) Install the remaining vertical-stabilizer access panels as follows:

- (a) Install the access panel (1).
- (b) Install and correctly torque the screws (2) that attach the access panel (1). Refer to [AMM MPP 20-10-01/200](#).

J. Follow-on

SUBTASK 842-007-A

- (1) Check the aerodynamic limits. Refer to SRM 51-10-01.
- (2) Remove the workstand from the work area.

TASK 52-40-04-000-807-A

EFFECTIVITY: ALL

14. HORIZONTAL STABILIZER AND ELEVATOR ACCESS DOORS AND PANELS - REMOVAL

A. General

- (1) This procedure gives the instructions to remove the horizontal stabilizer and elevator access doors and panels.

B. References

REFERENCE	DESIGNATION
AMM MPP 06-42-00/100	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
333	333AB	Horizontal stabilizer
333	333BB	Horizontal stabilizer
333	333CB	Horizontal stabilizer
334	334AB	Horizontal stabilizer
334	334BB	Horizontal stabilizer
334	334CB	Horizontal stabilizer
335	335AB	Horizontal stabilizer
335	335BB	Horizontal stabilizer
335	335CB	Horizontal stabilizer
335	335DB	Horizontal stabilizer
335	335EB	Horizontal stabilizer
335	335FB	Horizontal stabilizer
335	335GB	Horizontal stabilizer
335	335HB	Horizontal stabilizer
336	336AB	Horizontal stabilizer
336	336BB	Horizontal stabilizer
336	336CB	Horizontal stabilizer
336	336DB	Horizontal stabilizer
336	336EB	Horizontal stabilizer
336	336FB	Horizontal stabilizer
336	336GB	Horizontal stabilizer
336	336HB	Horizontal stabilizer
337	337DL	Horizontal stabilizer

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Workstand	To get access to the work area	1

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Horizontal stabilizer

I. Preparation

SUBTASK 841-008-A

- (1) Make sure that the aircraft is safe for maintenance.
- (2) Put the workstand in the work area.
- (3) Identify the Horizontal Stabilizer and Elevator access doors and panels 333AB, 333BB, 333CB, 334AB, 334BB, 334CB, 335AB, 335BB, 335CB, 335DB, 335EB, 335FB, 335GB, 335HB, 336AB, 336BB, 336CB, 336DB, 336EB, 336FB, 336GB, 336HB, and 337DL. Refer to (AMM MPP 06-42-00/100).

J. Removal [\(Figure 407\)](#)

SUBTASK 020-008-A

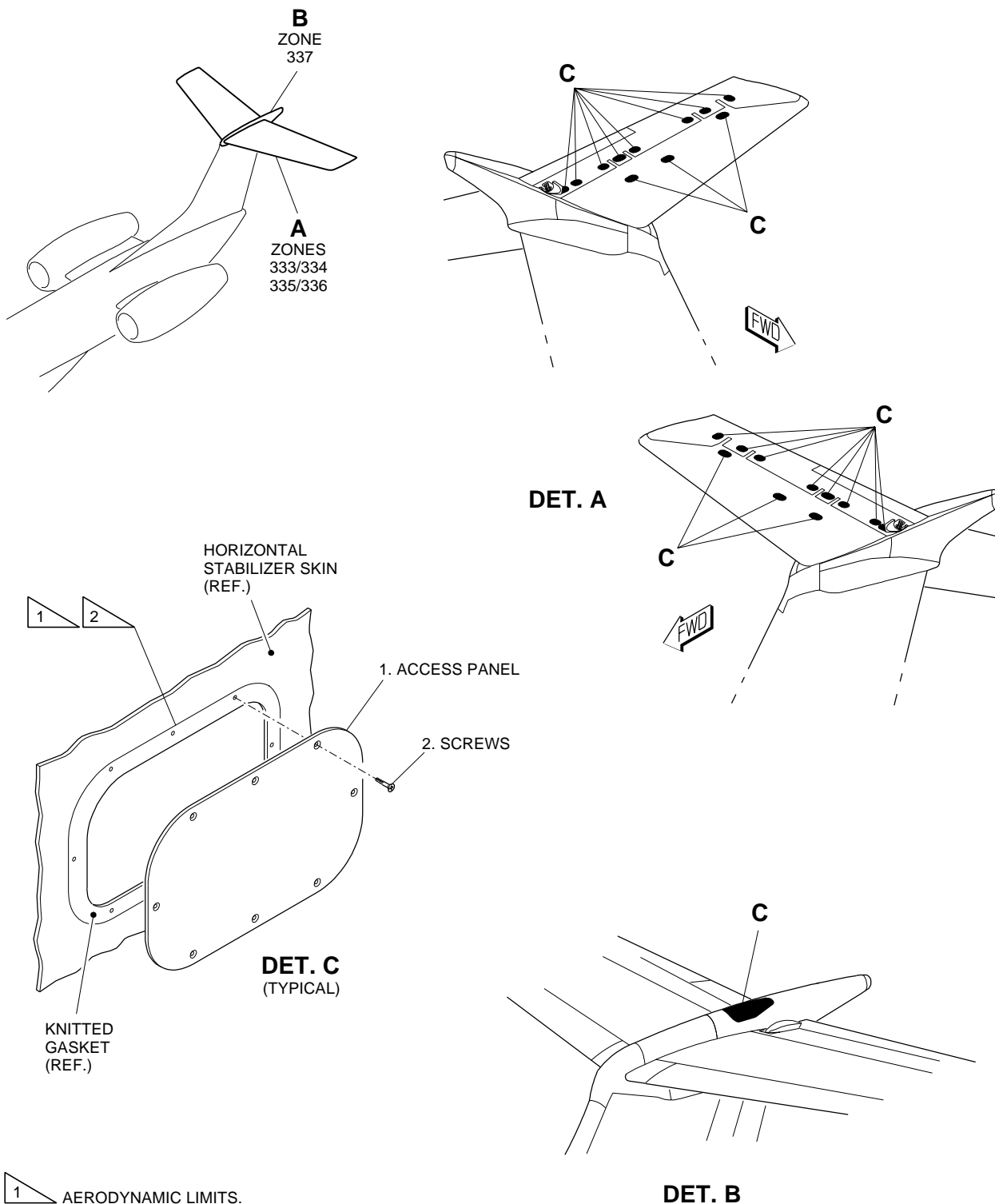
CAUTION: DURING THE REMOVAL AND INSTALLATION PROCEDURES, BE CAREFUL NOT TO DAMAGE THE KNITTED GASKET.

- (1) Remove the screws (2) that attach access panel (1).
- (2) Remove the access panel (1).

EFFECTIVITY: ALL

Horizontal Stabilizer and Elevator Access Doors and Panels - Removal/Installation

Figure 407



EM145AMM520600A.DGN

TASK 52-40-04-400-807-A

EFFECTIVITY: ALL

15. HORIZONTAL STABILIZER AND ELEVATOR ACCESS DOORS AND PANELS - INSTALLATION

A. General

- (1) This procedure gives the instructions to install the horizontal stabilizer and elevator access doors and panels.

B. References

REFERENCE	DESIGNATION
AMM MPP 20-10-01/200	- MAINTENANCE PRACTICES
AMM TASK 52-40-04-000-807-A/400	HORIZONTAL STABILIZER AND ELEVATOR ACCESS DOORS AND PANELS - REMOVAL
SRM 51-10-01	-
SRM 51-20-01	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
333	333AB	Horizontal stabilizer
333	333BB	Horizontal stabilizer
333	333CB	Horizontal stabilizer
334	334AB	Horizontal stabilizer
334	334BB	Horizontal stabilizer
334	334CB	Horizontal stabilizer
335	335AB	Horizontal stabilizer
335	335BB	Horizontal stabilizer
335	335CB	Horizontal stabilizer
335	335DB	Horizontal stabilizer
335	335EB	Horizontal stabilizer
335	335FB	Horizontal stabilizer
335	335GB	Horizontal stabilizer
335	335HB	Horizontal stabilizer
336	336AB	Horizontal stabilizer
336	336BB	Horizontal stabilizer
336	336CB	Horizontal stabilizer
336	336DB	Horizontal stabilizer
336	336EB	Horizontal stabilizer
336	336FB	Horizontal stabilizer
336	336GB	Horizontal stabilizer
336	336HB	Horizontal stabilizer
337	337DL	Horizontal stabilizer

D. Tools and Equipment

<i>ITEM</i>	<i>DESCRIPTION</i>	<i>PURPOSE</i>	<i>QTY</i>
Commercially available	Torque wrench	To tighten the attachment screws	

E. Auxiliary Items

<i>ITEM</i>	<i>DESCRIPTION</i>	<i>PURPOSE</i>	<i>QTY</i>
Commercially available	Workstand	To get access to the work area	1

F. Consumable Materials

<i>SPECIFICATION (BRAND)</i>	<i>DESCRIPTION</i>	<i>QTY</i>
MEP 09-083	Sealant, PR 2050 B-1/2	AR
MILPRF- 81733 Type II, Class 1/2	Sealant, P/S 870 B-1/2	AR
SAE AMS-S-8802 Type II Class B2	Sealant, PR-1440 B2	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

<i>QTY</i>	<i>FUNCTION</i>	<i>PLACE</i>
1	Does the task	Horizontal Stabilizer

I. Preparation
SUBTASK 841-009-A

- (1) Make sure that the aircraft is in the same configuration as it was at the end of the removal task. Refer to [AMM TASK 52-40-04-000-807-A/400](#).
- (2) Check if the gasket sealants are damaged before installing the access doors or panels. If they are, remove the old sealant and re-apply PR-1440 B2. Refer to SRM 51-20-01.

J. Installation (Figure 407)
SUBTASK 420-008-A

- (1) Install the access panel (1).
- (2) Install the screws (2) that attach the access panel (1) applying the correct torque. Refer to [AMM MPP 20-10-01/200](#).

K. Follow-on
SUBTASK 842-008-A

- (1) Check the Aerodynamic Limits. Refer to SRM 51-10-01.



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- (2) Do the aerodynamic sealing of the access doors or panels contours with P/S 870 B1/2 or PR 2050 B1/2. Refer to SRM 51-20-01).
 - (3) Remove the workstand from the work area.