



AIRCRAFT  
MAINTENANCE MANUAL

TAIL CONE - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the tail cone.
- 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
53-32-00-000-801-A	TAIL CONE - REMOVAL	ALL
53-32-00-400-801-A	TAIL CONE - INSTALLATION	ALL



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TASK 53-32-00-000-801-A

EFFECTIVITY: ALL

2. TAIL CONE - REMOVAL

A. General

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

B. References

REFERENCE	DESIGNATION
AMM MPP 06-42-00/100	-
AMM TASK 49-11-00-000-801-A/400	APU COWLING - REMOVAL
AMM TASK 49-15-00-000-801-A/400	APU COWLING - REMOVAL
AMM TASK 53-32-10-200-801-A/600	PERMITTED LIMITS FOR DAMAGE TO RESONATOR - INSPECTION/CHECK
SRM 53-32-22/01	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
313		Tail cone fairing
312	Door 312AR	Structural area aft of rear pressure bulkhead - RH

D. Tools and Equipment

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

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	Tail cone fairing
1	Helps the other technician	Tail cone fairing



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I. Preparation

SUBTASK 841-002-A

- (1) On the Overhead Circuit Breaker Panel, open the Rudder 1 circuit breaker (Location tip: essential dc bus 2/rudder 1) and Rudder 2 circuit breaker (Location tip: essential dc bus 1/rudder 2) and attach a DO-NOT-CLOSE tag to them.
- (2) Make sure that the GPU pushbutton, on the electrical panel installed on the overhead panel, is set at OFF. Attach a DO-NOT-SET-TO-ON tag to it.
- (3) Make sure that the BATT 1 and BATT 2 switches, on the electrical panel installed on the overhead panel, are set at OFF. Attach DO-NOT-SET-TO-ON tags to them.
- (4) Set the BACKUP pushbutton, on the electrical panel installed on the overhead panel, to OFF. Make sure that the striped bar on the pushbutton comes on.
- (5) Attach a DO-NOT-SET-TO-AUTO tag to the BACKUP pushbutton.
- (6) Put the workstand in the work area.
- (7) Open access door 312AR (AMM MPP 06-42-00/100).
- (8) Manually move the rudder fully to the right side.

J. Removal ([Figure 401](#)) ([Figure 402](#)) ([Figure 403](#)) ([Figure 404](#))

SUBTASK 000-002-A

- (1) Hold up the tail cone and remove the screws (2).

**CAUTION: BE CAREFUL WHEN YOU REMOVE THE TAIL CONE TO PREVENT DAMAGE TO THE RUDDER.**

- (2) Remove the tail cone (3).

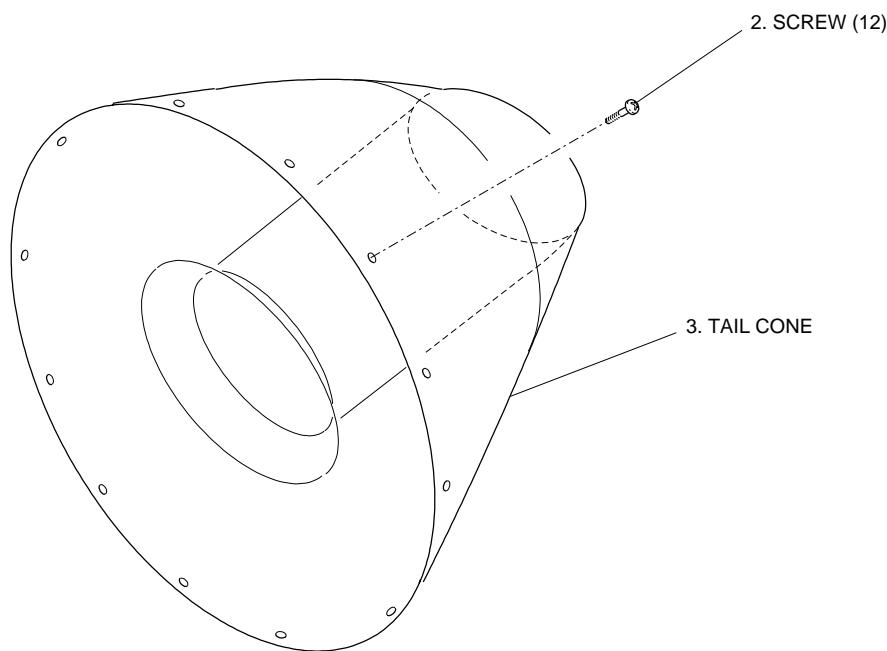
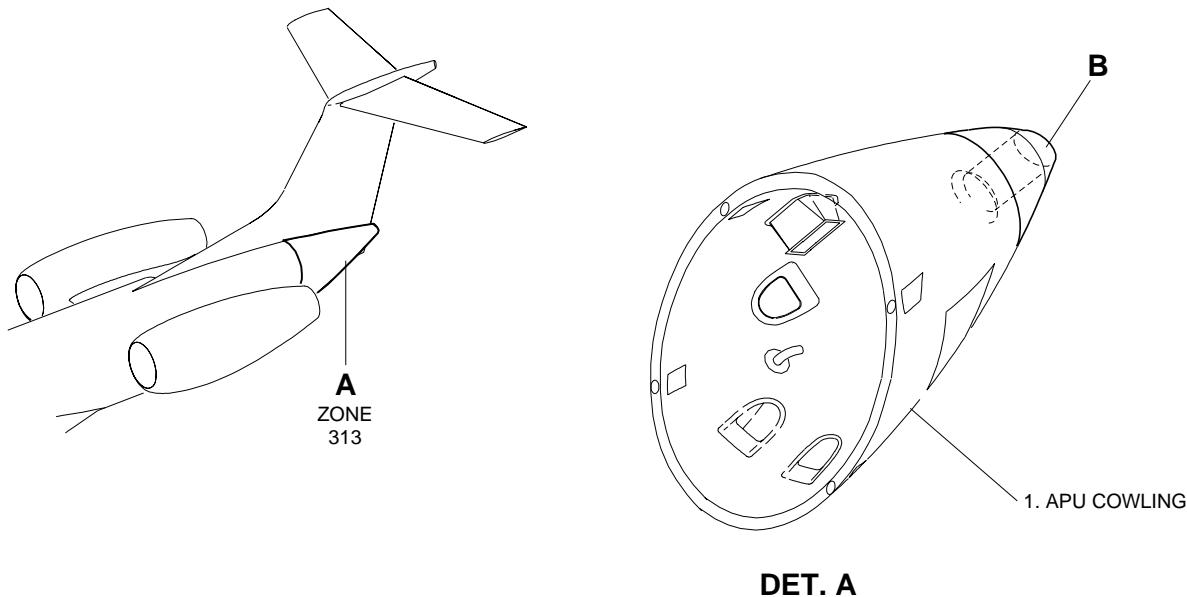
**NOTE:** The rudder must be out of its neutral position.

- (3) For aircraft with APU Exhaust Silencer, make a detailed inspection on the resonator for damage ([AMM TASK 53-32-10-200-801-A/600](#)).
- (4) For aircraft with APU Exhaust Silencer, make an inspection on the silencer for damage. If there are signs of damage, refer to the SRM 53-32-22/01 to find specific information applicable to your case.
- (5) Remove the APU cowling (1) ([AMM TASK 49-11-00-000-801-A/400](#) or [AMM TASK 49-15-00-000-801-A/400](#), as applicable), when it is necessary to install a new tail cone.

*EFFECTIVITY: AIRCRAFT WITH APU T-62T-40C11 WITHOUT EXHAUST SILENCER*

Tail Cone - Removal/Installation

Figure 401



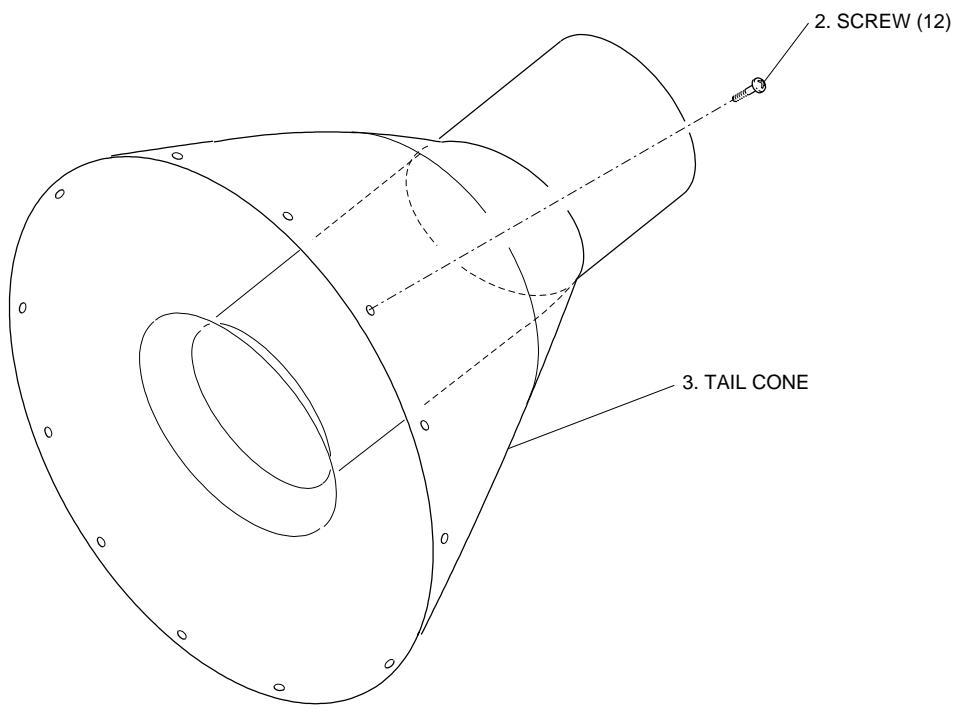
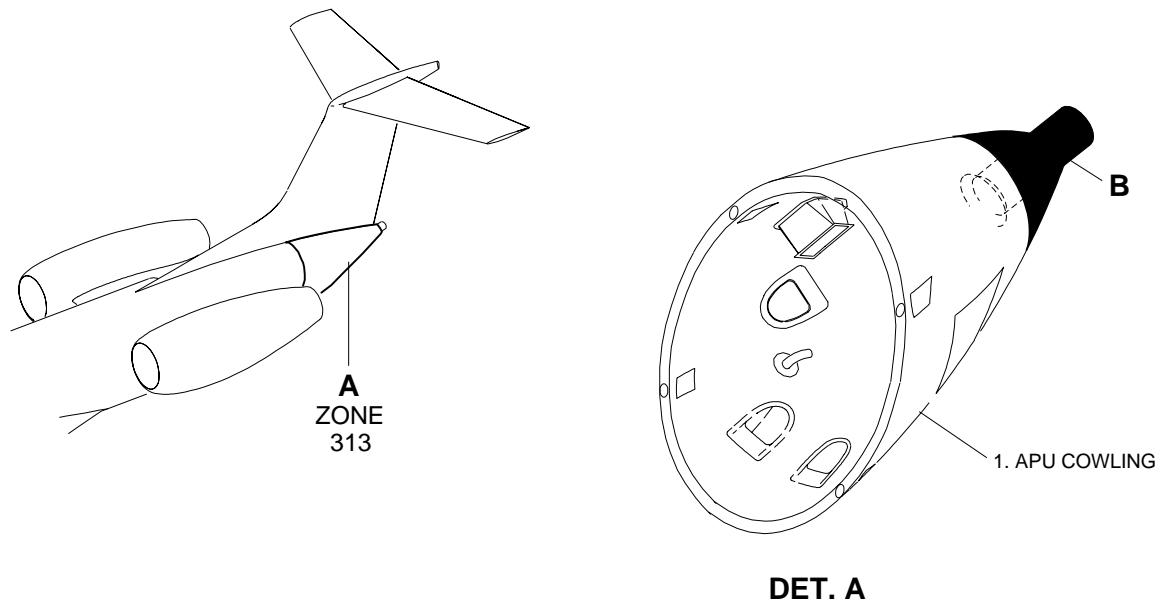
**DET. B**

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**EFFECTIVITY: AIRCRAFT WITH APU EXHAUST SILENCER**

Tail Cone - Removal/Installation

Figure 402

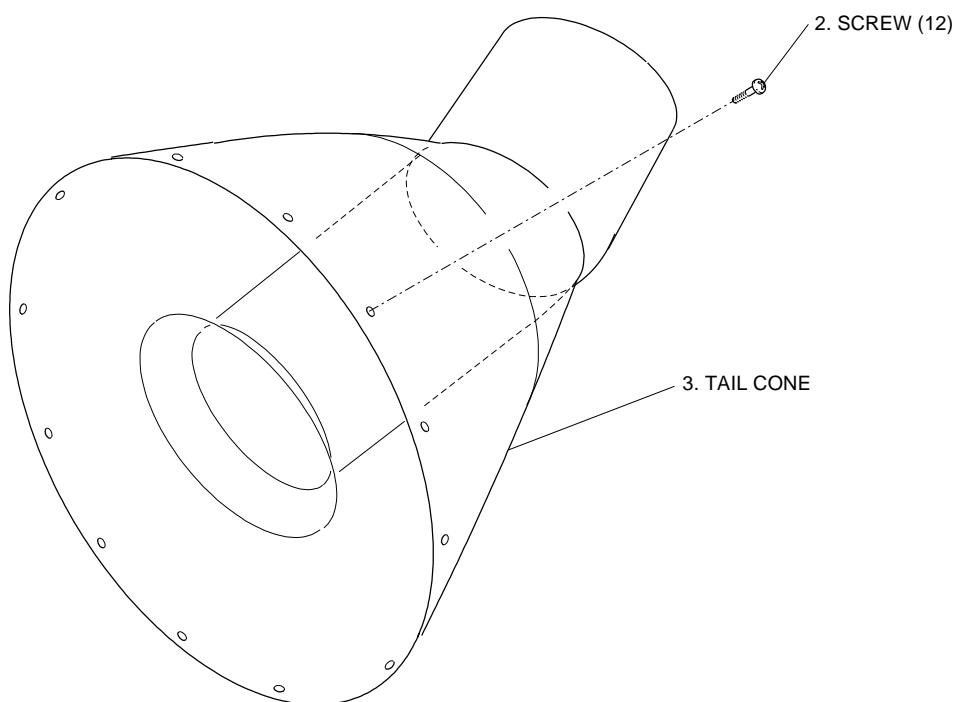
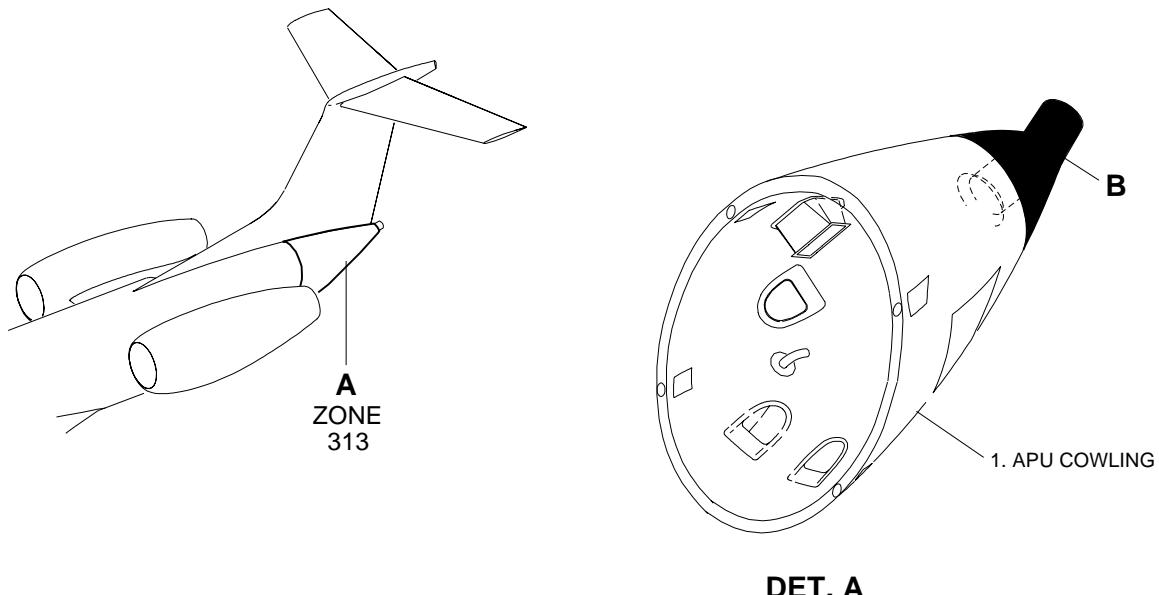


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*EFFECTIVITY: AIRCRAFT WITH APU T-62T-40C14 WITHOUT EXHAUST SILENCER*

Tail Cone - Removal/Installation

Figure 403



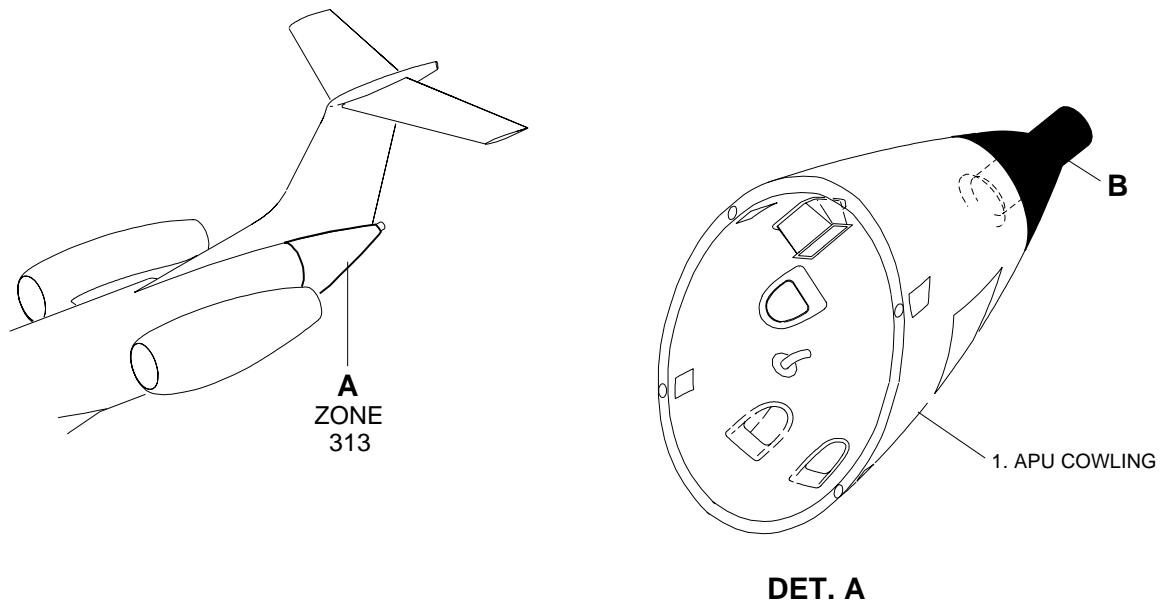
**DET. B**

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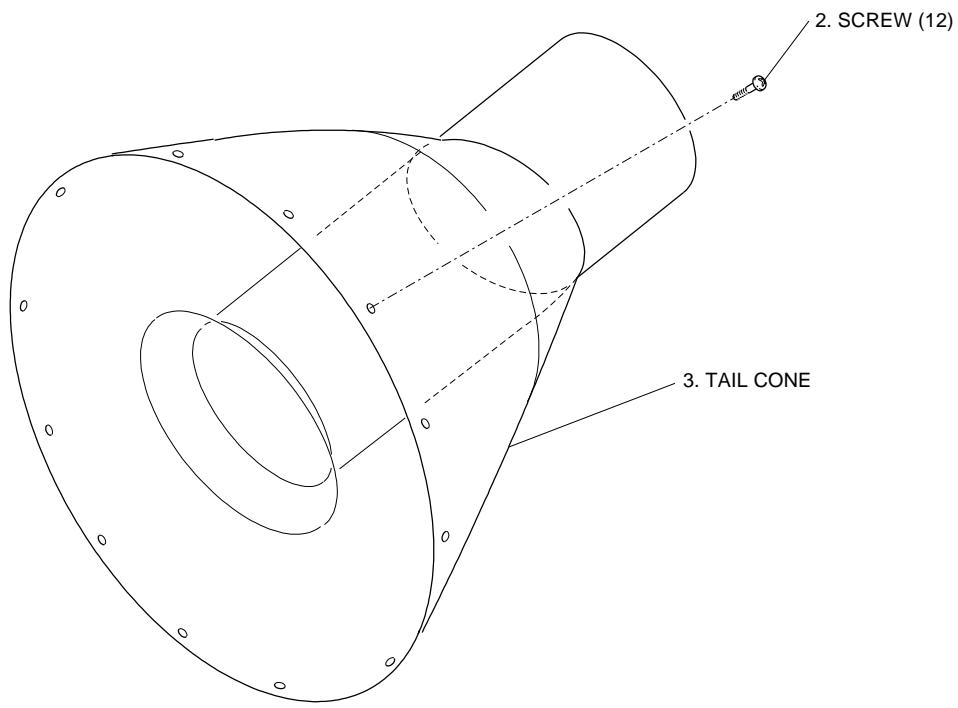
**EFFECTIVITY: AIRCRAFT WITH APU T-62T-40C14 WITHOUT EXHAUST SILENCER**

Tail Cone - Removal/Installation

Figure 404



**DET. A**



**DET. B**

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TASK 53-32-00-400-801-A

EFFECTIVITY: ALL

3. TAIL CONE - INSTALLATION

A. General

- (1) This task gives the instructions to install the tail cone.

B. References

REFERENCE	DESIGNATION
AMM MPP 06-42-00/100	-
<a href="#">AMM TASK 49-11-00-400-801-A/400</a>	APU COWLING - INSTALLATION
<a href="#">AMM TASK 49-15-00-400-801-A/400</a>	APU COWLING - INSTALLATION
SRM 51-40-00	-

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
313		Tail cone fairing
312	Door 312AR	Structural area aft of rear pressure bulkhead - RH

D. Tools and Equipment

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

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	Tail cone fairing
1	Helps the other technician	Tail cone fairing

I. Installation (Figure 401) (Figure 402) (Figure 403) (Figure 404)

SUBTASK 400-002-A

- (1) Do steps (a) through (n) when the installation of the new tail cone is necessary:

- (a) Put the APU cowling on the workbench.

- (b) Remove the rivets that attach the nut plates (SRM 51-40-00).
- (c) Remove the nut plates that attach the tail cone to the APU cowling.
- (d) Connect the new tail cone to the APU cowling.
- (e) Transfer the hole from the APU cowling to the tail cone.
- (f) Drill 3/16 in.-diameter holes in the tail cone.
- (g) Remove the burrs.
- (h) Alodize the reworked areas and apply epoxy primer. Refer to Corrosion Prevention Manual - Chapter 51.
- (i) Install rig pins to the holes.

**CAUTION: THE ASSEMBLY TOLERANCE BETWEEN THE TAIL CONE AND THE APU COWLING IS  $1.0 \pm 0.8$  MM ON THE CONTOUR.**

- (j) Mark the contour of the new tail cone to get the adjustment.
  - (k) Cut the excess material with snips and make sure that the adjustment is correct.
  - (l) If necessary, do steps (j) through (l) again to get the assembly tolerance.
  - (m) Remove the rig pins.
  - (n) Install the APU cowling (1) ( [AMM TASK 49-11-00-400-801-A/400](#) or [AMM TASK 49-15-00-400-801-A/400](#), as applicable).
- (2) Install the tail cone (3).
  - (3) Install the screws (2).

**J. Follow-on**

**SUBTASK 842-002-A**

- (1) Close access door 312AR (AMM MPP 06-42-00/100).
- (2) On the Overhead Circuit Breaker Panel, close the Rudder 1 circuit breaker (Location tip: essential dc bus 2/rudder 1) and Rudder 2 circuit breaker (Location tip: essential dc bus 1/rudder 2) and remove the DO-NOT-CLOSE tag from them.
- (3) Set the BACKUP pushbutton, on the electrical panel, on the overhead panel, to AUTO. Remove the DO-NOT-SET-TO-AUTO tag from the BACKUP pushbutton.
- (4) Remove the DO-NOT-SET-TO-AUTO tags from the BATT 1 AND BATT 2 switches.
- (5) Remove the DO-NOT-SET-TO-ON tag from the GPU pushbutton.

