

## BAGGAGE DOOR SKIN PROTECTION - REMOVAL/INSTALLATION

*EFFECTIVITY: AIRCRAFT WITH DOOR LOCK*

### 1. General

- A. This section gives the procedures for removal and installation of the baggage-door skin protection.
- 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
52-31-04-000-801-A	BAGGAGE-DOOR SKIN PROTECTION - REMOVAL	AIRCRAFT WITH DOOR LOCK
52-31-04-400-801-A	BAGGAGE-DOOR SKIN PROTECTION - INSTALLATION	AIRCRAFT WITH DOOR LOCK

TASK 52-31-04-000-801-A

*EFFECTIVITY: AIRCRAFT WITH DOOR LOCK*

## 2. BAGGAGE-DOOR SKIN PROTECTION - REMOVAL

### A. General

(1) This task gives the procedures to remove the baggage-door skin protection.

### B. References

REFERENCE	DESIGNATION
AMM SDS 52-31-00/1	
AMM TASK 52-31-00-000-801-A/400	BAGGAGE-DOOR ACTUATING AND LOCKING MECHANISM - REMOVAL

### C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
813		Baggage door

### D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Acrylic spatula	To remove adhesive epoxy	
Commercially available	Heat Gun	To remove skin guard	
Commercially available	Thermometer -40 to +100 °C (-40 to +212 °F) Minimum Range	To apply hot air	
Commercially available	Pair of pliers	To remove skin guard	

### E. Auxiliary Items

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Protective Gloves	For protection of technician's hands	1
Commercially available	Safety Goggles	For protection of technician's eyes	1

### F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
ASTM D-740	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 841-002-A*

- (1) Make sure that the aircraft is safe for maintenance.
- (2) Open the baggage door ([AMM SDS 52-31-00/1](#)).
- (3) Remove the actuating handle ( [AMM TASK 52-31-00-000-801-A/400](#)).

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

*SUBTASK 020-002-A*

- (1) With a pair of pliers, bend the tab. Refer to [Figure 401](#), View C.

**WARNING: OBEY THE SAFETY PRECAUTIONS WHEN YOU DO TASKS WITH A HEATING GUN. IF YOU USE AN INCORRECT HEAT GUN NEAR FLAMMABLE MATERIAL OR FUEL VENT, EXPLOSION CAN OCCUR.**

- (2) With a heat gun, apply hot air to the skin guard.
- (3) With a thermometer, control the temperature. Refer to [Figure 401](#), DET. B.

**NOTE:** The temperature must not be higher than 92°C (197.6°F).

- (4) Remove and discard the skin guard.
- (5) With an acrylic spatula, remove the old adhesive epoxy.

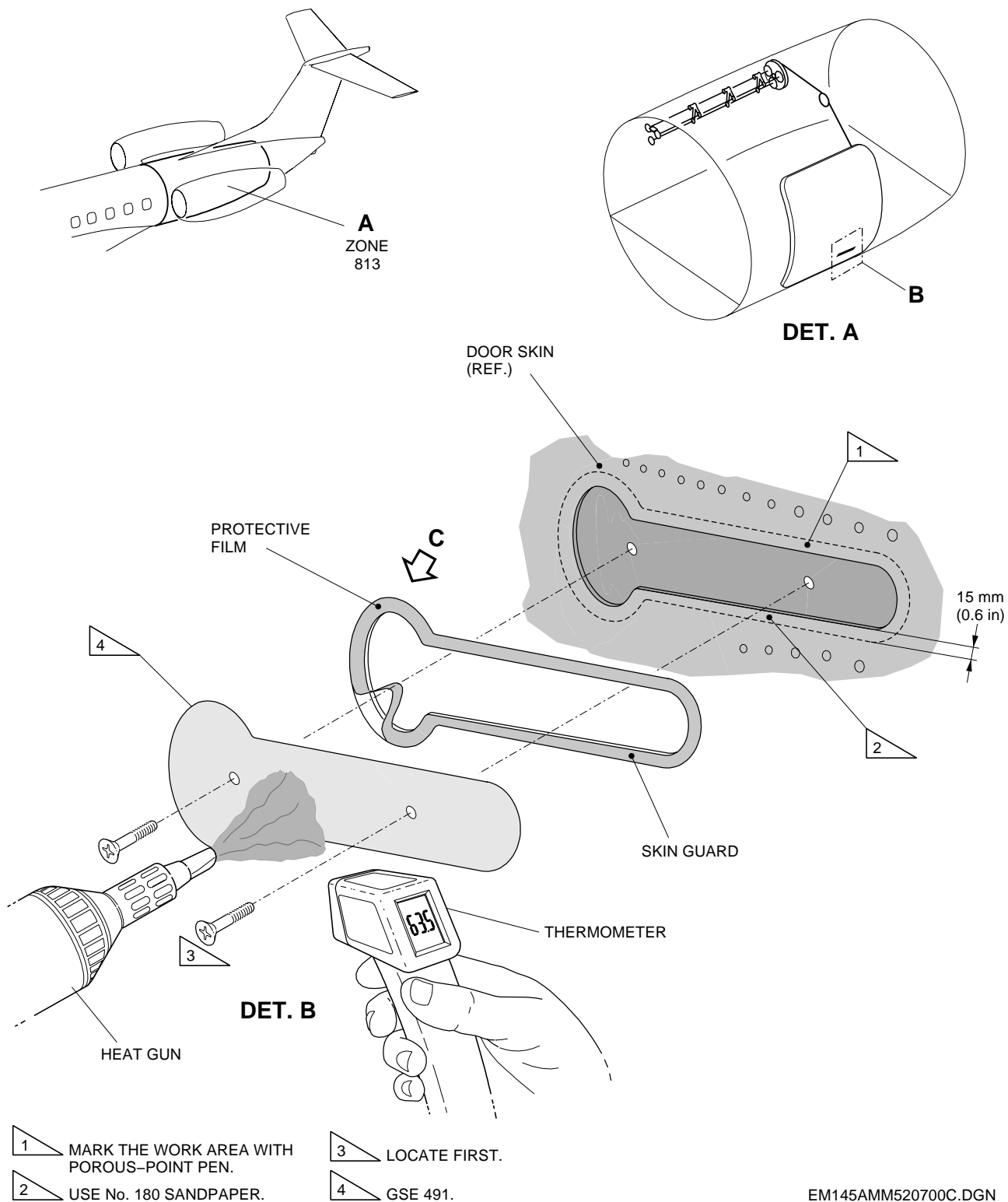
**WARNING: BE CAREFUL WHEN YOU USE SOLVENTS BECAUSE THEY ARE A HEALTH AND FIRE HAZARD. USE SAFETY GOGGLES AND PROTECTIVE CLOTHING WHEN YOU HANDLE THEM. DO NOT BREATHE THEIR GASES AND WORK IN A WELL VENTILATED AREA.**

- (6) With a cloth soaked in MEK, clean the surface.

**EFFECTIVITY: AIRCRAFT WITH DOOR LOCK**

Baggage-Door Skin Protection - Removal/Installation

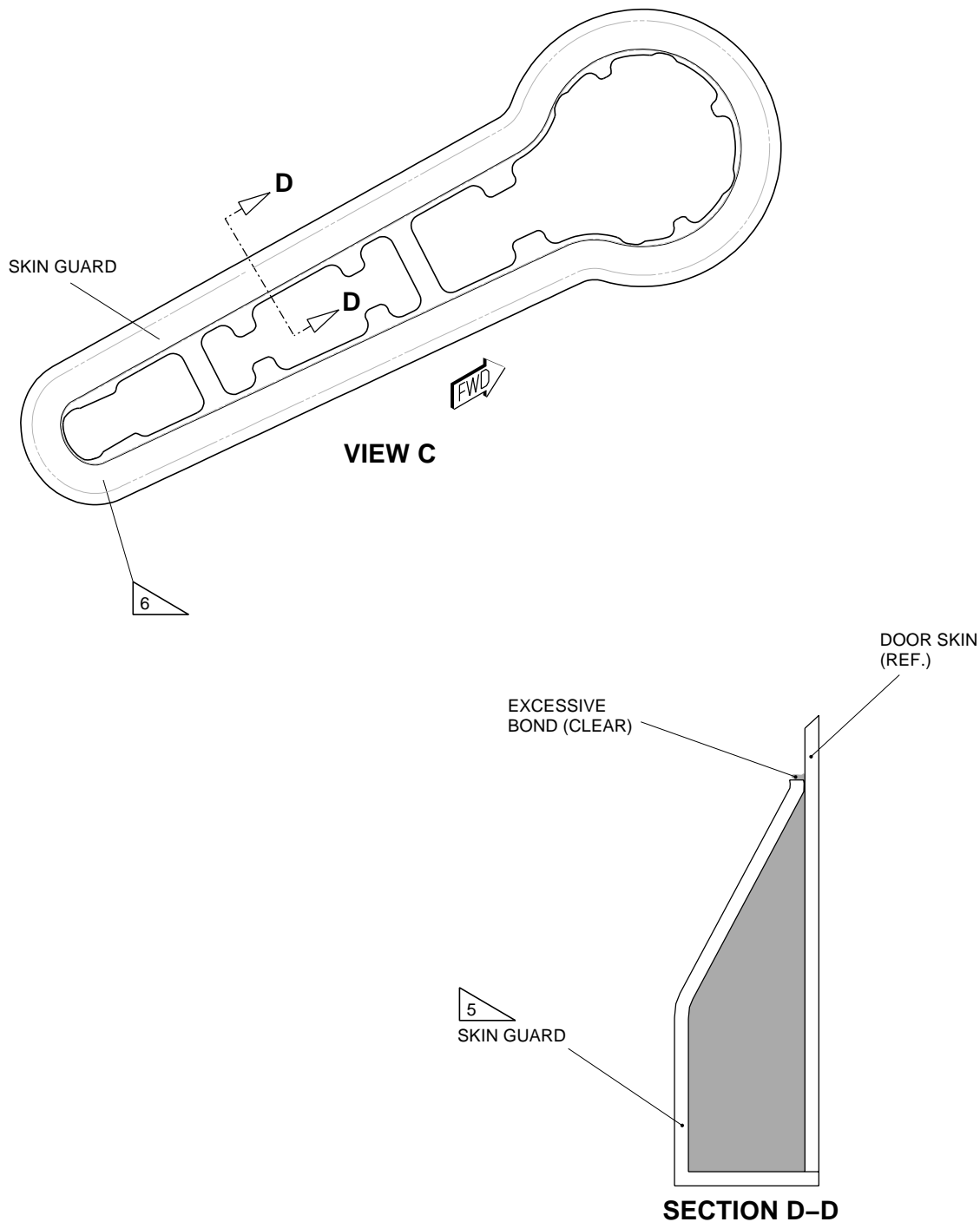
Figure 401 - Sheet 1



EFFECTIVITY: AIRCRAFT WITH DOOR LOCK

Baggage-Door Skin Protection - Removal/Installation

Figure 401 - Sheet 2



5 COMPLETELY FILL WITH ADHESIVE EPOXY.

6 USE No. 180 SANDPAPER.

EM145AMM520701F.DGN

**TASK 52-31-04-400-801-A**

**EFFECTIVITY: AIRCRAFT WITH DOOR LOCK**

**3. BAGGAGE-DOOR SKIN PROTECTION - INSTALLATION**

**A. General**

(1) This task gives the procedures to install the baggage-door skin protection.

**B. References**

REFERENCE	DESIGNATION
AMM SDS 52-31-00/1	
AMM TASK 52-31-00-400-801-A/400	BAGGAGE-DOOR ACTUATING AND LOCKING MECHANISM - INSTALLATION
IPC 52-31-00	BAGGAGE DOOR - ACTUATING LOCKING SYSTEM
SRM 51-10-02-PR	-
SRM 51-10-03-PR	-
SRM 51-20-01-PR	-

**C. Zones and Accesses**

ZONE	PANEL/DOOR	LOCATION
813		Baggage door

**D. Tools and Equipment**

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Acrylic spatula	To install the sealant	
GSE 491		To install the skin guard	
Commercially available	Heat Gun	To install skin guard	
Commercially available	Thermometer -40 to +100 °C (-40 to +212 °F) Minimum Range	To apply hot air	
Commercially available	Pair of pliers	To install skin guard	

**E. Auxiliary Items**

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Protective Gloves	For protection of technician's hands	1
Commercially available	Safety Goggles	For protection of technician's eyes	1
Commercially available	Porous-point pen mark	To make marks on the skin	1

F. Consumable Materials

<i>SPECIFICATION (BRAND)</i>	<i>DESCRIPTION</i>	<i>QTY</i>
EA9320NA	Epoxy Adhesive Type II - (MEP 09-066)	AR
Commercially available	Adhesive tape	AR
Commercially available	Sandpaper No. 350	AR

G. Expendable Parts

<i>ITEM</i>	<i>IPC REFERENCE (VENDOR REFERENCE)</i>	<i>QTY</i>
Skin guard	IPC 52-31-00	1

H. Persons Recommended

<i>QTY</i>	<i>FUNCTION</i>	<i>PLACE</i>
1	Does the task	Maintenance shop

I. Installation (Figure 401)

**SUBTASK 420-002-A**

- (1) With a felt-tip pen, draw the area where the skin guard will be bonded, 15 mm (0.6 in) offset all along the handle contour. Refer to (Figure 401), DET. B.
- (2) With masking tape, protect the door skin around the area defined.
- (3) With sandpaper No. 350, sand the area defined on the door skin where the skin guard will be bonded and the surface of the skin guard, on the side that will be in contact with door skin. Rework the affected area. Refer to SRM 51-10-02-PR and SRM 51-10-03-PR.

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- (4) With a cloth soaked in MEK, clean the surface.
- (5) Remove the protective surface film from the skin guard and discard the film.

**CAUTION: BONDING OPERATION MUST BE DONE IMMEDIATELY AFTER THE SURFACES ARE SANDED/CLEANED, PROVIDED THE TWO SURFACES ARE DRY.**

Apply epoxy adhesive to the surface of the skin guard, on the side that will be in contact with the door skin. Refer to (Figure 401); View C.

- (6) **NOTE:** The bond must fully fill the space between the skin guard and the door skin. Refer to SRM 51-20-01-PR.
- (7) Install the skin guard.

- (8) Use GSE 491 to adjust the position of the skin guard. Refer to (Figure 401); DET. B.

NOTE: The epoxy-adhesive curing time changes with the environmental conditions. If necessary, with a heat gun, apply hot air and control the temperature.

- (9) Remove excess epoxy adhesive. Refer to (Figure 401); SECTION D-D.

NOTE: Use an acrylic spatula.

- (10) Remove GSE 491. Refer to (Figure 401); DET. B.

- (11) With a pair of pliers, bend the tab. Refer to (Figure 401), View C.

J. Follow-on

*SUBTASK 842-002-A*

- (1) Install the actuating handle ( [AMM TASK 52-31-00-400-801-A/400](#) ).
- (2) Close the baggage door ([AMM SDS 52-31-00/1](#)).