

## COCKPIT EMERGENCY EXIT FRAME SEALANT - REPAIR

*EFFECTIVITY: THIS TASK IS APPLICABLE TO AIRCRAFT S/N UP TO 884*

### 1. General

- A. This section gives the procedures to repair the frame sealant of the cockpit emergency.
- 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
56-11-04-300-801-A	FUSELAGE FRAME SEALANT - REPAIR	THIS TASK IS APPLICABLE TO AIRCRAFT S/N UP TO 884

TASK 56-11-04-300-801-A

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## 2. FUSELAGE FRAME SEALANT - REPAIR

### A. General

(1) This task gives the instructions to repair the frame sealant of the cockpit emergency exit.

### B. References

REFERENCE	DESIGNATION
AMM TASK 21-31-00-860-801-A/200	PROCEDURE TO PRESSURIZE THE AIRCRAFT FOR MAINTENANCE
AMM TASK 21-31-00-860-802-A/200	PROCEDURE TO DEPRESSURIZE THE AIRCRAFT FOR MAINTENANCE
AMM TASK 56-11-01-000-801-A/400	COCKPIT EMERGENCY EXIT - REMOVAL
AMM TASK 56-11-01-400-801-A/400	COCKPIT EMERGENCY EXIT - INSTALLATION
SRM 51-20-01-PR	-

### C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
223		LH - Cockpit emergency exit
224		RH - Cockpit emergency exit

### D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Acrylic spatula	To remove the damaged sealant	
Commercially available	Soft lint-free cloth	To clean the repair area	
Commercially available	Sandpaper 120 grit	To sand the fuselage frame	

### E. Auxiliary Items

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

### F. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
MIL-PRF-81733, TYPE II, Class B	Sealant PR-2050 B-1/2	AR

(Continued)

<i>SPECIFICATION (BRAND)</i>	<i>DESCRIPTION</i>	<i>QTY</i>
ASTM D740	Methyl Ethyl Ketone - (MEK)	AR
Commercially available	Adhesive tape	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

<i>QTY</i>	<i>FUNCTION</i>	<i>PLACE</i>
1	Does the task	In the LH or RH cockpit emergency exit

I. Preparation

*SUBTASK 841-002-A*

- (1) Remove the cockpit emergency exit ([AMM TASK 56-11-01-000-801-A/400](#)).
- (2) Put the window on a safe surface to prevent damage.

J. Frame sealant - Repair ([Figure 801](#))

*SUBTASK 350-002-A*

- (1) Identify the regions where the sealant is damaged.
- (2) Using an acrylic spatula, remove the damaged portion of the fuselage frame sealant.
- (3) Sand the fuselage frame, in the region of the damaged sealant, to ensure that all the old sealant has been removed.

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

- (4) Clean all surfaces to be bonded with MEK.
- (5) Limit the application area of the sealant, in the internal side of the fuselage frame, with masking tape to protect the fuselage.
- (6) Install the cockpit emergency exit ([AMM TASK 56-11-01-400-801-A/400](#)), and close it.
- (7) Mask the region of the cockpit emergency exit and the fuselage frame, according to [Figure 801](#).
- (8) Apply sealant PR-2050 B-1/2 in the repair region. Refer to SRM 51-20-01-PR
- (9) Remove the sealant excess and the masking tapes.

**NOTE:** • During the cure time, the cockpit emergency exit shall remain closed.

- The sealant cure time changes as a function of the environmental conditions. Refer to SRM 51-20-01-PR.

(10) Remove the cockpit emergency exit ([AMM TASK 56-11-01-000-801-A/400](#)).

(11) Remove the internal mask tape.

K. Follow-on

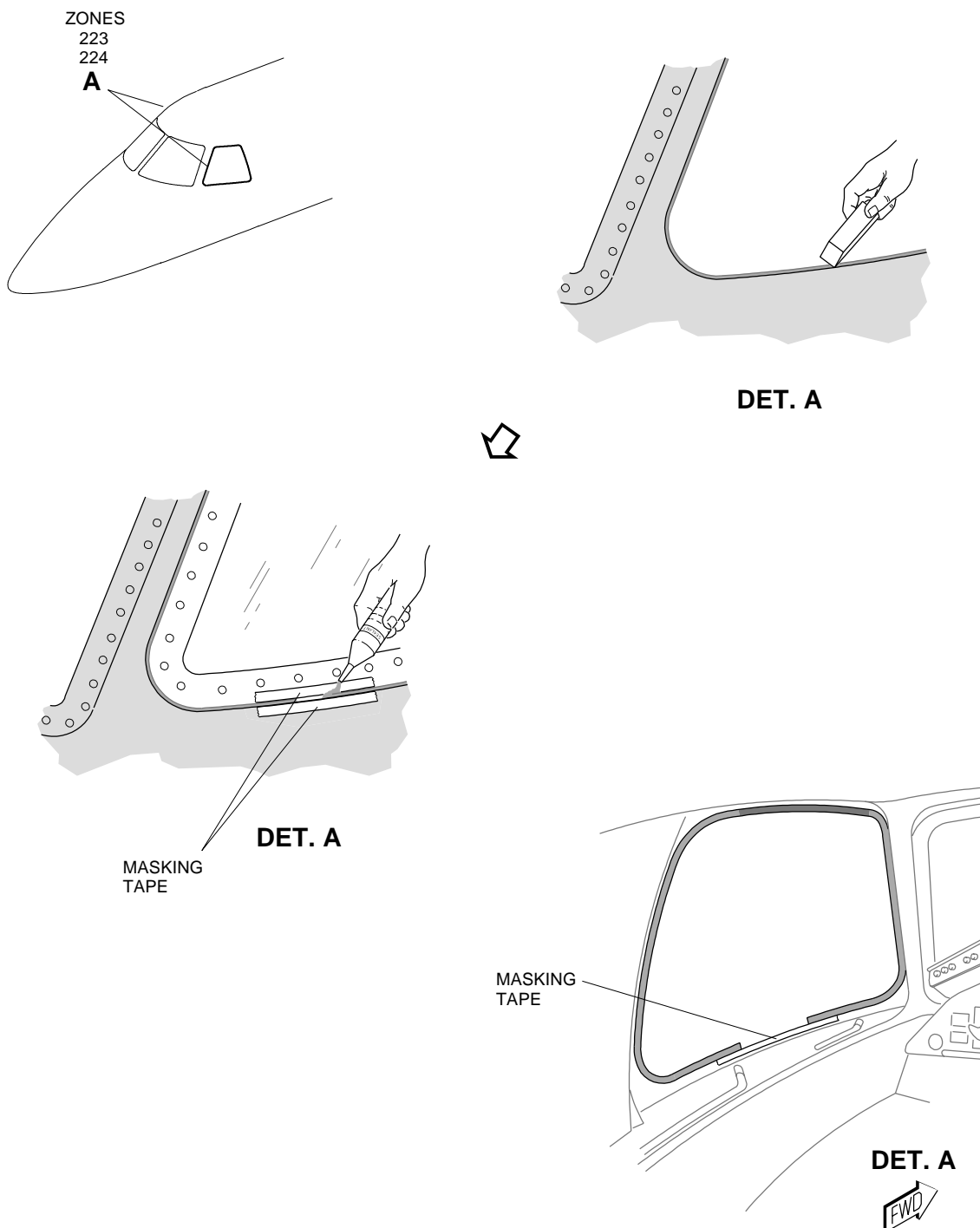
*SUBTASK 842-002-A*

- (1) Install the cockpit emergency-exit ([AMM TASK 56-11-01-400-801-A/400](#)).
- (2) Pressurize the aircraft ( [AMM TASK 21-31-00-860-801-A/200](#)).
- (3) Make sure that there is no air leakage through the cockpit emergency-exit.
- (4) Depressurize the aircraft ( [AMM TASK 21-31-00-860-802-A/200](#)).

**EFFECTIVITY: THIS TASK IS APPLICABLE TO AIRCRAFT S/N UP TO 884**

**Fuselage Frame Sealant - Repair**

**Figure 801**



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