

AIRCRAFT MAINTENANCE MANUAL

COCKPIT EMERGENCY EXIT FRAME SEAL - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures for removal and installation of the cockpit emergency-exit frame 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
56-11-03-000-801-A	COCKPIT EMERGENCY-EXIT FRAME SEAL - REMOVAL	WITHOUT STRIP AND FILLER
56-11-03-400-801-A	COCKPIT EMERGENCY-EXIT FRAME SEAL - INSTALLATION	WITHOUT STRIP AND FILLER
56-11-03-000-802-A	COCKPIT EMERGENCY-EXIT FRAME SEAL STRIP AND FRAME FILLER - REMOVAL	WITH STRIP AND FILLER
56-11-03-400-802-A	COCKPIT EMERGENCY-EXIT FRAME SEAL STRIP AND FRAME FILLER - INSTALLATION	WITH STRIP AND FILLER



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TASK 56-11-03-000-801-A

EFFECTIVITY: WITHOUT STRIP AND FILLER

2. COCKPIT EMERGENCY-EXIT FRAME SEAL - REMOVAL

A. General

(1) This task gives the procedures to remove the cockpit emergency-exit frame seal.

B. References

REFERENCE	DESIGNATION
AMM TASK 25-12-09-000-801-A/400	LH/RH COCKPIT LINING - REMOVAL
AMM TASK 56-11-01-000-801-A/400	COCKPIT EMERGENCY EXIT - REMOVAL

C. Zones and Accesses

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

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Acrylic Spatula	To remove the sealant	
Commercially available	Sandpaper No. 400	To make the surface rough	

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
ASTM D740	Methyl Ethyl Ketone - (MEK)	AR

G. Expandable Parts

Not Applicable



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H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Maintenance shop

I. Preparation

SUBTASK 841-002-A

EFFECTIVITY: WITHOUT STRIP AND FILLER

- (1) Remove the cockpit emergency exits ([AMM TASK 56-11-01-000-801-A/400](#))
- (2) Put the cockpit emergency exits on a safe surface to prevent scratches to the acrylic panel.
- (3) Remove the LH/RH cockpit lining ([AMM TASK 25-12-09-000-801-A/400](#)).

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

SUBTASK 020-002-A

EFFECTIVITY: WITHOUT STRIP AND FILLER

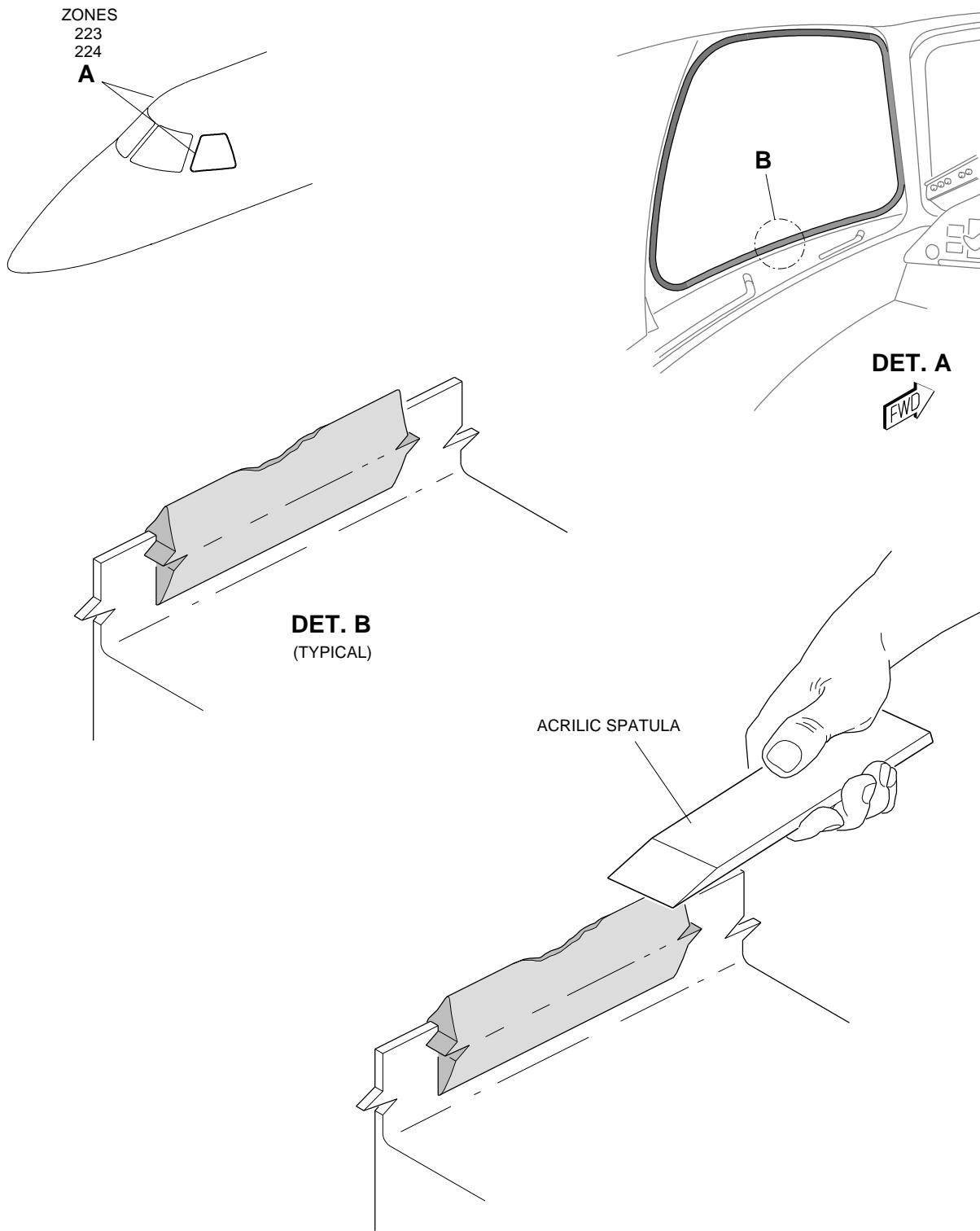
- (1) With an acrylic spatula, remove the sealant from the cockpit emergency-exit frame. Refer to ([Figure 401](#)).
- (2) If necessary, with a sandpaper, sand the fuselage frame to remove the remaining sealant.

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.

- (3) Clean the surface with a cloth wet with MEK.

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

EFFECTIVITY: WITHOUT STRIP AND FILLER
Cockpit Emergency-Exit Frame Seal - Removal/Installation
Figure 401



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TASK 56-11-03-400-801-A

EFFECTIVITY: WITHOUT STRIP AND FILLER

3. COCKPIT EMERGENCY-EXIT FRAME SEAL - INSTALLATION

A. General

(1) This task gives the procedures to install the cockpit emergency-exit frame seal.

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 56-11-00-820-801-A/500	COCKPIT EMERGENCY EXIT - ALIGNMENT
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		Cockpit emergency exit, LH
224		Cockpit emergency exit, RH

D. Tools and Equipment

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

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-S-8802, TYPE II, Class B1/2	Sealant PR-1422 B1/2	AR
Commercially available	Adhesive tape	AR
ASTM D740	Methyl Ethyl Ketone - (MEK)	AR



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(Continued)

SPECIFICATION (BRAND)	DESCRIPTION	QTY
Commercially available	Detergent	AR

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Maintenance shop

I. Installation (Figure 401)

SUBTASK 420-002-A

EFFECTIVITY: WITHOUT STRIP AND FILLER

- (1) From outside the aircraft, limit the application area of the sealant. For this, use masking tape to protect the fuselage.

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.

- (2) Clean all surfaces to be bonded with MEK.
- (3) Apply grease to the area of the cockpit emergency exit, which will be in touch with the sealant on the cockpit emergency exit frame.

NOTE: Apply the grease to the rubber seal and between the rubber loose edge and the cockpit exit.

WARNING: BE CAREFUL WHEN YOU USE SEALANTS. FOR HAZARDOUSNESS, PROTECTION AND HANDLING OF THE MATERIAL, REFER TO ITS MATERIAL SAFETY DATA SHEET.

- (4) Apply PR-1422 B1/2 sealant to the cockpit emergency exit frame.

NOTE: For alternative sealant, refer to SRM 51-20-01-PR.

- (5) Slowly install the cockpit emergency exit ([AMM TASK 56-11-01-400-801-A/400](#)).
- (6) From outside the aircraft, remove the excess sealant and the masking tapes.
- (7) Wait for the sealant to cure and remove the cockpit emergency exit ([AMM TASK 56-11-01-000-801-A/400](#)).

NOTE: The sealant cure time changes with the environmental conditions. Refer to SRM 51-20-01-PR.

- (8) Remove the excess sealant.



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- (9) Install the cockpit emergency exit ([AMM TASK 56-11-01-400-801-A/400](#)), do a check for water penetration through the cockpit emergency exit.
- (10) Pressurize the aircraft ([AMM TASK 21-31-00-860-801-A/200](#)).
- (11) Make sure that there is no air leakage through the cockpit emergency exit.
- (12) Depressurize the aircraft ([AMM TASK 21-31-00-860-802-A/200](#)).

J. Follow-on

SUBTASK 842-002-A

EFFECTIVITY: WITHOUT STRIP AND FILLER

- (1) If necessary, adjust the cockpit emergency exit locking mechanism ([AMM TASK 56-11-00-820-801-A/500](#)).



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TASK 56-11-03-000-802-A

EFFECTIVITY: WITH STRIP AND FILLER

4. COCKPIT EMERGENCY-EXIT FRAME SEAL STRIP AND FRAME FILLER -REMOVAL

A. General

- (1) This task gives the procedures to remove the cockpit emergency-exit frame seal strip and frame filler.

B. References

REFERENCE	DESIGNATION
AMM TASK 25-12-09-000-801-A/400	LH/RH COCKPIT LINING - REMOVAL
AMM TASK 56-11-01-000-801-A/400	COCKPIT EMERGENCY EXIT - REMOVAL

C. Zones and Accesses

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

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Acrylic Spatula	To remove the sealant	

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
ASTM D740	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

EFFECTIVITY: WITH STRIP AND FILLER

- (1) Remove the cockpit emergency exits ([AMM TASK 56-11-01-000-801-A/400](#))
- (2) Put the cockpit emergency exits on a safe surface to prevent scratches to the acrylic panel.
- (3) Remove the LH/RH cockpit lining ([AMM TASK 25-12-09-000-801-A/400](#)).

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

SUBTASK 020-003-A

EFFECTIVITY: WITH STRIP AND FILLER

- (1) Slowly release the frame seal strip with a cutter until the frame seal strip is fully removed.

NOTE: Be careful to prevent damage to the cockpit emergency-exit frame.

- (2) With an acrylic spatula, remove the sealant from the cockpit emergency-exit frame.

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.

- (3) Clean the surface with a cloth wet with MEK.

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

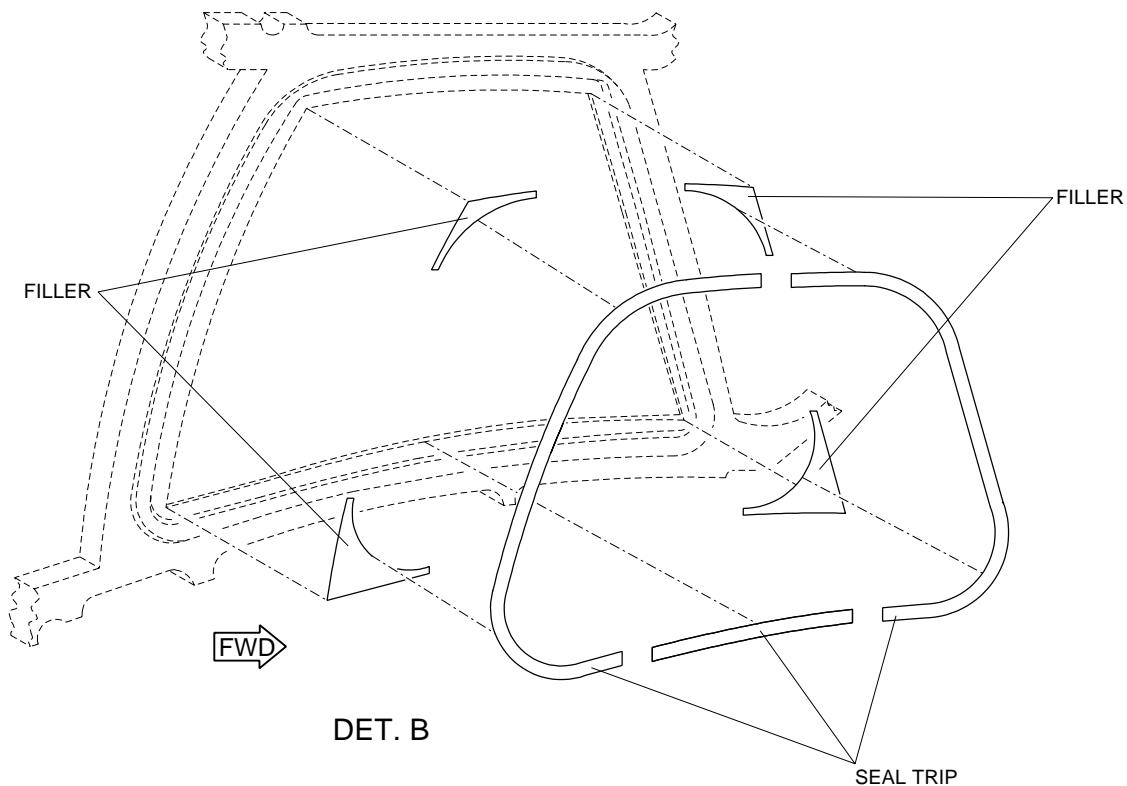
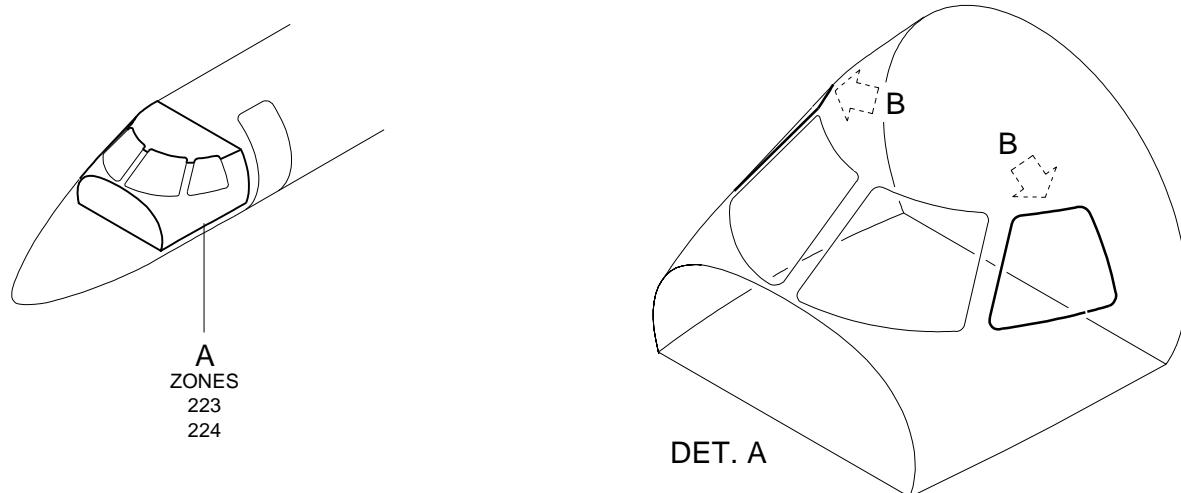
- (4) If filler will be damaged remove it as follows:

- (a) With an acrylic spatula, remove the gaps sealant (RTV157) that fill the fillers/structure.
- (b) Remove and discard the damaged filler with an acrylic spatula.
- (c) Clean all surfaces with MEK.
- (d) If necessary, touch up the paint of the cockpit emergency-exit frame with Polyurethane Coating, were the old sealant has been removed from.

EFFECTIVITY: WITH STRIP AND FILLER

Cockpit Emergency-Exit Frame Seal - Removal/Installation

Figure 402

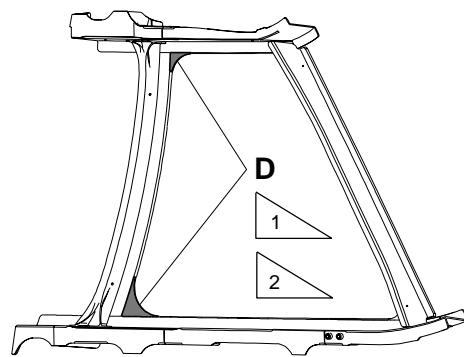
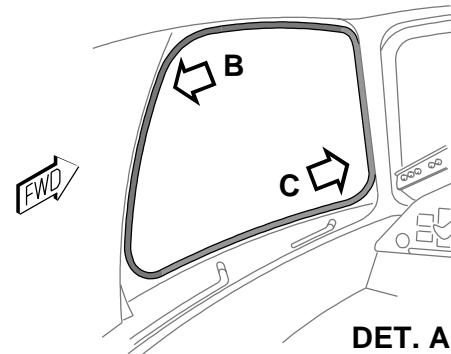
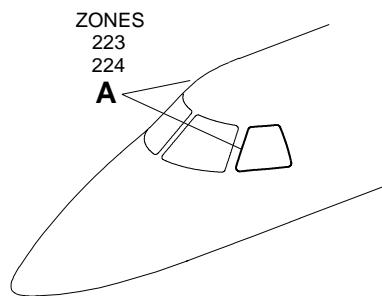


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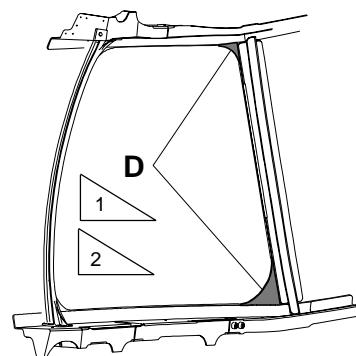
EFFECTIVITY: WITH STRIP AND FILLER

Cockpit Emergency-Exit Frame Filler - Removal/Installation

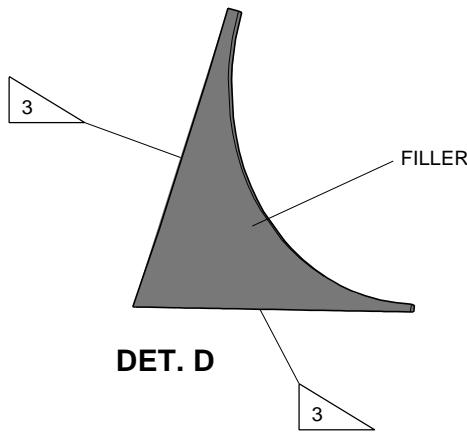
Figure 403



DET. B
(AFT VIEW)



DET. C
(FWD VIEW)



1 CYANOACRYLATE ADHESIVE SB496 OR LOCTITE 496

2 SAND THE SURFACES OF THE FILLER (BOTH SIDES)

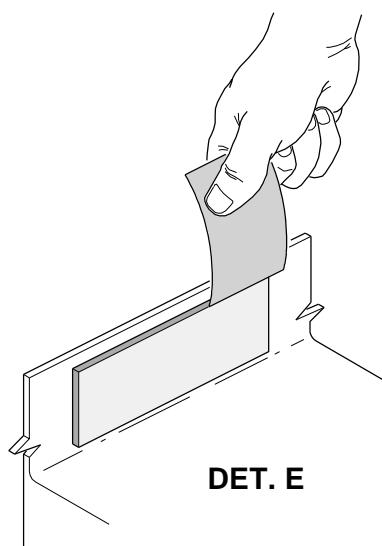
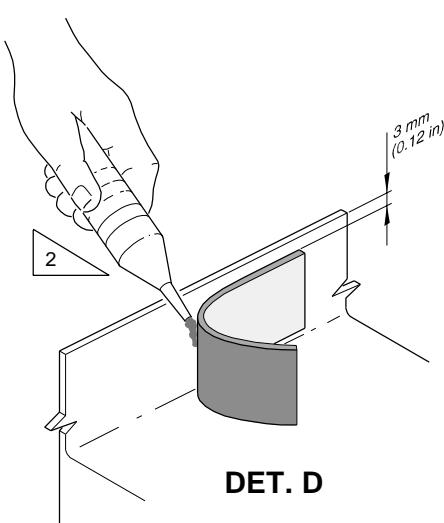
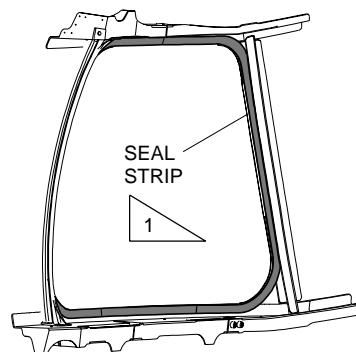
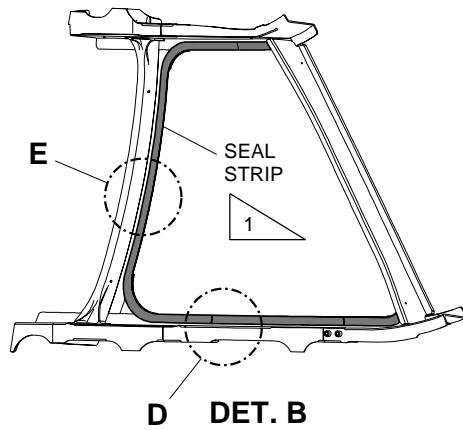
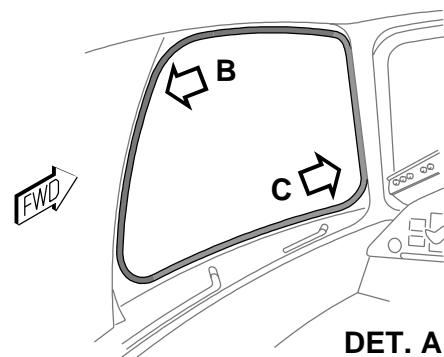
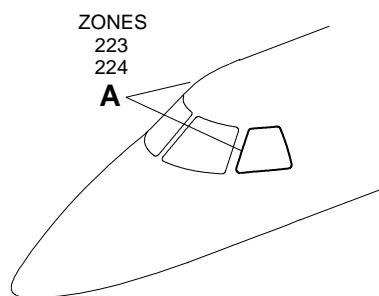
3 SEALANT RTV157

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EFFECTIVITY: WITH STRIP AND FILLER

Cockpit Emergency-Exit Frame Seal Strip - Removal/Installation

Figure 404



1 BONDED THE WITHOUT POLYESTER SIDE

2 SEALANT RTV157

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TASK 56-11-03-400-802-A
EFFECTIVITY: WITH STRIP AND FILLER
5. COCKPIT EMERGENCY-EXIT FRAME SEAL STRIP AND FRAME FILLER -INSTALLATION
A. General

- (1) This task gives the procedures to install the cockpit emergency-exit frame seal strip and frame filler.

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 56-11-00-820-801-A/500	COCKPIT EMERGENCY EXIT - ALIGNMENT
AMM TASK 56-11-01-400-801-A/400	COCKPIT EMERGENCY EXIT - INSTALLATION
IPC 56-11-00	DIRECT VISION
SRM 51-20-01-PR	-

C. Zones and Accesses

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

D. Tools and Equipment

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

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
Commercially available	Silicone sealant - RTV 157 (Gray)	AR
Commercially available	Adhesive tape	AR
ASTM D740	Methyl Ethyl Ketone - (MEK)	AR

(Continued)

<i>SPECIFICATION (BRAND)</i>	<i>DESCRIPTION</i>	<i>QTY</i>
Commercially available	Detergent	AR

G. Expendable Parts

<i>ITEM</i>	<i>IPC REFERENCE (VENDOR REFERENCE)</i>	<i>QTY</i>
Profile seal	IPC 56-11-00	AR

H. Persons Recommended

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

I. Installation (Figure 402) (Figure 403) (Figure 404)
SUBTASK 420-003-A
EFFECTIVITY: WITH STRIP AND FILLER

- (1) To Install the cockpit Emergency-Exit Frame Filler (Figure 403), do as follows:

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.

- (a) Clean all surfaces with MEK.
- (b) Sand the surfaces (both sides) of the filler in order to get a good sealant adhesion.
- (c) If necessary, trim the filler so that it fits flush with adjacent structure.
- (d) Position and bond the filler on the cockpit emergency-exit frame corners using cyanoacrylate adhesive.

WARNING: BE CAREFUL WHEN YOU USE SEALANTS. FOR HAZARDOUSNESS, PROTECTION AND HANDLING OF THE MATERIAL, REFER TO ITS MATERIAL SAFETY DATA SHEET.

- (e) Fill the fillers/structure gaps with sealant RTV157.

NOTE: The sealant cure time changes with the environmental conditions. Refer to SRM 51-20-01-PR.

- (f) Install the emergency-exit frame seal strip as required.

- (2) To Install the cockpit Emergency-Exit Frame seal strip (Figure 404), do as follows:

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.

- (a) Clean all surfaces with MEK.

WARNING: BE CAREFUL WHEN YOU USE SEALANTS. FOR HAZARDOUSNESS, PROTECTION AND HANDLING OF THE MATERIAL, REFER TO ITS MATERIAL SAFETY DATA SHEET.

- (b) With an acrylic spatula, apply a thin coat of silicone sealant RTV-157 to the area to which the seal strip will be bonded in order to have a uniform coat.

NOTE: The sealant cure time changes with the environmental conditions. Refer to SRM 51-20-01-PR.

- (c) Bond seal strips, according to (Figure 404).

NOTE: • The seal strip side without polyester must be bonded on the direct-vision window frame.
• Make sure that there are no waves formed on the seal strips.

- (d) Use an acrylic spatula to remove the excess sealant.

- (e) Wait for the sealant curing time.

NOTE: The sealant curing time changes with the environmental conditions. Refer to SRM 51-20-01-PR.

- (f) Install the cockpit emergency exit ([AMM TASK 56-11-01-400-801-A/400](#)), do a check for water penetration through the cockpit emergency exit.

- (g) Pressurize the aircraft ([AMM TASK 21-31-00-860-801-A/200](#)).

- (h) Make sure that there is no air leakage through the cockpit emergency exit.

- (i) Depressurize the aircraft ([AMM TASK 21-31-00-860-802-A/200](#)).

J. Follow-on

SUBTASK 842-003-A

- (1) If necessary, adjust the cockpit emergency exit locking mechanism ([AMM TASK 56-11-00-820-801-A/500](#)).

